LASER WELDER CATALOGUE

MIYACHI

Spirit Of Innovation

LASER WELDER

Advanced Technology That Joins Dreams and the Future

Laser Welder Lineup

We know you'll be satisfied. Miyachi's laser welder series!! A complete line, from 0.25W to 600W


ML-2050A


ML-2350A


ML-2550A


ML-2650B


ML-8050A

Basic Specifications and Performance

Real-time power feedback — The output beam is monitored, comparing it to the set waveform to attain the ideal output waveform.

Variable mirrors — These mirrors eliminate laser power loss and improve branch balance.

Waveform control — Equipped with a "fixed mode" that features three-level waveforms, and a "flex mode" to provide more complex waveforms.

Power monitor — Laser energy (J) and average power (W) are monitored to detect abnormalities.

Color LCD touch panel — The touch panel can be detached from the main unit and operated by hand.

Controller — The controller can also be detached from the main unit and operated by hand.

External communications — Configuration of parameters and monitoring of performance can be carried out from a separate location.

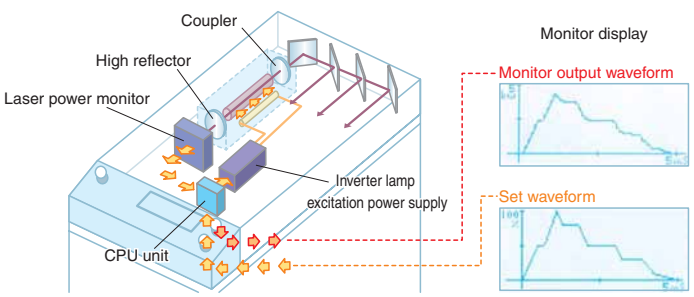
Fade-in/ Fade-out — This feature avoids marks at the end of seam welding and provides a beautiful finish even for overlapping circumference seam welding sections. (See Page 5.)

Forced air cooling — Forced air cooling models are available, eliminating the need for pipes.

Dual-wavelength laser system — By combining various models with the ML-8050A, dual-wavelength laser systems can be provided.

Real-time power feedback control

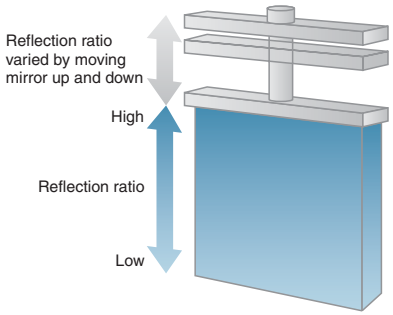
The laser output in the lamp excitation module is monitored in real time. The monitored laser output is compared with the set waveform and power is fed back in real time, varying the energy input to the lamp to reproduce the set waveform and obtain the ideal laser output waveform.



High-efficiency balance among branches

The newly adopted variable mirror eliminates laser power loss and ensures balance among branches, resulting in a significant improvement in the precision of beam splitting.

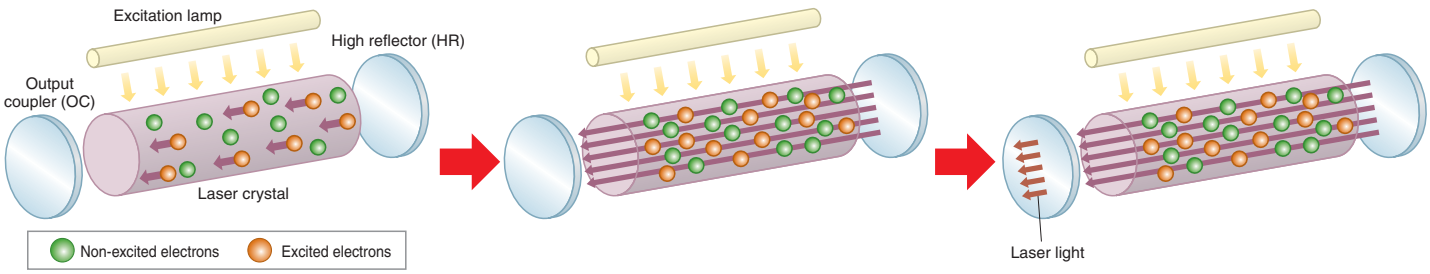
Basic principles behind the variable mirror



YAG Lasers and Nd:YAG

Miyachi laser welders use an Nd:YAG (neodymium:$Y_3Al_5O_{12}$) crystal, adding neodymium doped to a standard YAG (yttrium, aluminum, and garnet) crystal. An Nd:YAG crystal has superior optical characteristics and is one of today's most advanced laser crystals for laser welding. An Nd:YAG laser emits a near-infrared wavelength of 1,064nm, a wavelength that is outside the range of visible light.

Basic principles of Nd:YAG amplification



When the lamp is lit, its light excites the electrons in the YAG crystal.

As the illumination from the lamp continues, the electrons are excited, and the emitted light is oscilated back and forth between the OC and HR, increasing the power of the laser.

Light proportional to the strength of the illumination from the lamp is emitted through the OC to form the laser beam.

Nd:YAG laser welding

With Nd:YAG laser welding, the beam is delivered and concentrated to the work surface by fiber optic systems.

Features

- Using fiber optics makes it is easy to integrate factory automation systems.
- This is non-contact welding, so there is no warping of work pieces.
- Ultra-precise welding is possible.

Oscillation form

Continuous wave (CW)····· 【Output unit】W:Watts
Pulse oscillation (pulsed)····· 【Output unit】J:Joules

Optical fiber delivery

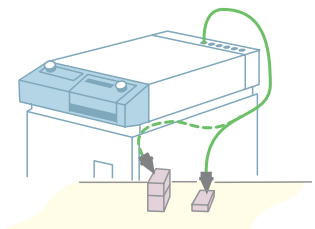
Since the laser beam can be transmitted through optic fibers, welding can be performed in locations separate from the laser welder. This feature makes Miyachi laser welders ideal for use on production and processing lines. Also, a wide variety of applications can be addressed by appropriate selection of the optic fiber and the focus head.
✱ Details are found on Page 3.

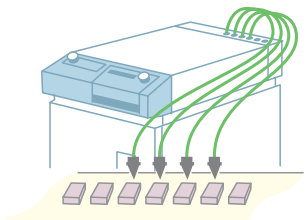

ML-2050A

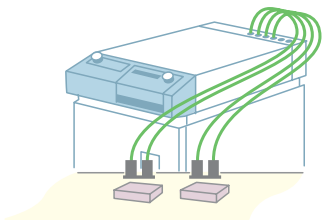

ML-2350A

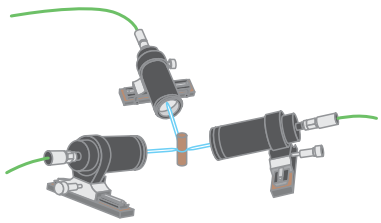
Branch types

Since the branch method can be selected to match the welding work and the number of points to be welded, the ideal configuration of branches can be selected quickly and efficiently. Since the maximum number of branches and the branch method depend on the laser wolder, please consult our nearest sales office to discuss your needs.


Single branch optic system


Four energy share optic system


Two-energy share
two time share optic system

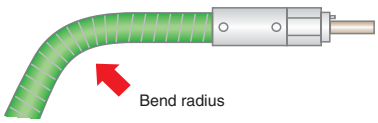

Three energy share optic system

Optic fiber

For most applications we recommend the SI (Step Index) Optic Fiber. Bending the optic fiber less than the permitted bend radius could cause a breakage. Please use it at a larger radius.

Specifications

Optic fiber model	SIH-02CA	SIH-03CA	SIH-04CA	SIH-06CA	SIH-08CA
Core diameter	ϕ0.2mm	ϕ0.3mm	ϕ0.4mm	ϕ0.6mm	ϕ0.8mm
Permitted bend radius	100mm			150mm	200mm
External diameter	ϕ8mm				



A feature that detects breaks in the optic fiber and an optic fiber device diagnostic feature (optional) immediately report problems or abnormalities with an optic fiber.

Focus head assembly

The focus head assembly efficiently collects laser beam coming from the optic fiber. There are various types available, differing by the work distance and the focal distance involved. There is a standard type, and there is also a CCD camera version that allows checks of the work point with a CCD camera during welding operations.

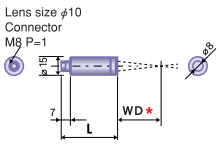
Standard type

			Focal distance (f)	Work distance (WD) *	Length (L)	Weight
FOL-10A	-2040	-STD	40mm	33.4mm	45.6mm	70g
	-2050		50mm	43.8mm		
FOL-10A	-4040	-STD	40mm	33.4mm	64.2mm	80g
	-4050		50mm	43.8mm		
	-4060		60mm	54.0mm		
	-4070		70mm	64.3mm		
FOL-20A	-5050	-STD	50mm	42.6mm	80.8mm	100g
	-5060		60mm	52.9mm		
	-5070		70mm	63.4mm		
	-5080		80mm	73.6mm		
	-50100		100mm	94.2mm		
FOL-30A	-7050	-STD	50mm	39.2mm	107.8mm	140g
	-7070		70mm	60.3mm		
	-7080		80mm	70.7mm		
	-70100		100mm	91.5mm		
	-70120		120mm	112.1mm		
FOL-30A	-10050D	-STD	50mm	36.9mm	139.3mm	160g
FOL-30A	-15050D	-STD	50mm	36.8mm	191.0mm	180g
FOL-30A	-20050D	-STD	50mm	36.7mm	242.4mm	220g
FOL-40A	-7070	-STD	70mm	58.4mm	108.8mm	200g
	-7080		80mm	69.0mm		
	-70100		100mm	90.0mm		
	-70120		120mm	110.8mm		
FOL-40A	-100100	-STD	100mm	90.2mm	136.8mm	230g
FOL-40A	-12060D	-STD	60mm	44.8mm	160.3mm	260g
	-12070		70mm	59.3mm		
	-12080		80mm	69.9mm		
	-120100		100mm	91.0mm		
FOL-50A	-120120	-STD	120mm	105.9mm	178.0mm	1200g

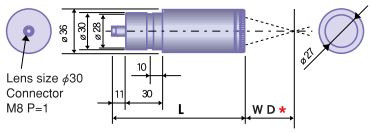
* The distance from the protective glass holder to the work piece.

Focus head

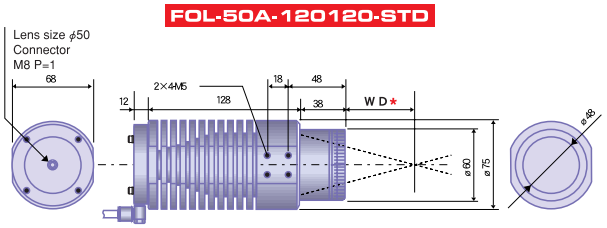
FOL-10A-**-STD**



FOL-30A-**-STD**



FOL-50A-120120-STD



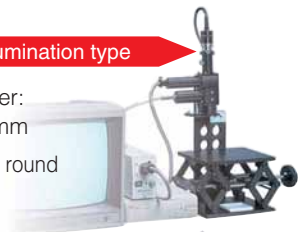
CCD camera unit for use with optical fiber delivery system

There are three types of illumination method. The one that best suits the application can be selected. Also, the most appropriate lens diameter and protective glass shape for each can be selected. Furthermore, a large color monitor has been made standard to improve the ease of viewing.

Standard model — **Epi-illumination type**

Input and output lens diameter:
ϕ30mm, ϕ40mm, ϕ50mm

Protective glass shape: square, round



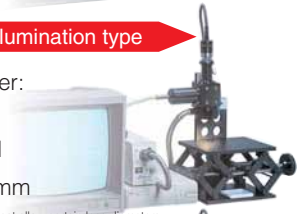
For work with curved surfaces — **Ring illumination type**

Input and output lens diameter:
ϕ30mm, ϕ40mm

Protective glass shape:round

Ring illumination shape: ϕ75mm

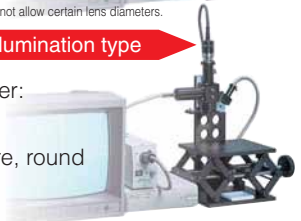
Note: For some models, certain ring illumination sizes do not allow certain lens diameters.



For work with high reflection ratios — **Side illumination type**

Input and output lens diameter:
ϕ30mm, ϕ40mm

Protective glass shape:square, round

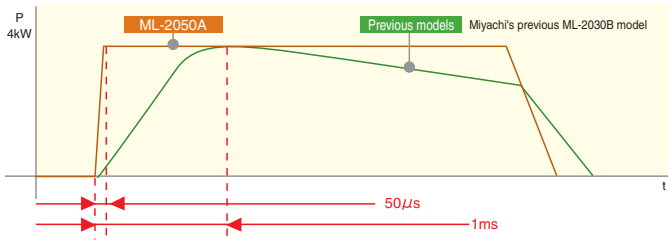


High-efficiency, high-quality welding

A highly power-efficient power supply has been developed that holds down high frequencies to protect the environment. Since single-phase 200/220/240 VAC ±10% is used, power supply requirements are flexible, even when this device is used overseas.

IImproved rise speed and energy efficiency

The laser output startup time has been reduced to about 1/20th of that for previous models. Also, for short-time welding under 5 ms, the pulse width can be set in units of 0.02 ms, five times the precision of previous models.



Optical fiber delivery System

A maximum of three branches are possible, including energy sharing and time sharing.

Pulse repetition rate

Welding and processing have a maximum repetition rate of 30 pps.

ML-2052A

A light condensing diameter of 40μm is achieved the compact, high-brightness laser oscillator. This enables a welding spot diameter of 80μm for stainless steel.

Real-Time Power Feedback Control　YAG Laser Welder

ML-2150A / ML-2050A
ML-2051A / ML-2052A

Basic Specifications and Performance

Real-time power feedback | Variable mirrors | Waveform control | Power monitor | External communi-cations | Forced air cooling | Dual-wavelength laser system

Powerful Air-Cooling Feature That Eliminates Pipes for All Models

25W·15W·7W·0.25W CLASS

Model		ML-2150A	ML-2050A	ML-2051A	ML-2052A
Oscillation wavelength		1,064nm			
Laser output	Maximum rated output	25W	15W	7W	0.25W
	Maximum output energy	25J/P(pulse width 5ms)	15J/P(pulse width 5ms)	7J/P(pulse width 5ms)	0.25J/P(pulse width 0.5ms)
Output control	Pulse width	0.2 to 10.0ms(0.1ms steps), 0.20 to 5.00ms(0.02ms steps) : Setting selectable			0.06 to 0.50ms(0.02ms steps)
	Pulse repetition rate	1 to 30pps			
Number of schedules		32 schedules			
Counter	Total counter	9 digits			
	Good counter	9 digits			
Branch optical system		Optical fiber delivery system　Up to 3 branches ✱			
External communication function		RS-485			
Required power supply		Single-phase 200/220/240VAC +10% -15%　50/60Hz			
Cooling system		Forced air cooling			
Dimensions		310(W)×665(D)×700(H)mm			
Mass		70kg			

✱ Option

Forced air cooling models

Our product line-up also includes forced air cooling models that do not use external cooling water. (ML-2350AF/ML-2351AF)

Pulse repetition rate

Welding and processing can have a maximum repetition rate of 200 pps.

High-quality welding

Power feedback control and waveform control functions ensure high-quality welding for a variety of work.

Optical fiber delivery System

A maximum of six branches are possible, including energy sharing and time sharing. (Optional)

Multiple schedule setting

Up to 32 schedules and waveform control can handle a variety of work.

Space saving, compact design

Compact design combines the laser power supply, oscillator head, and cooler in one piece of equipment. This superior design also makes it possible to handle wiring, filter replacement, etc., easily, from the front of the unit.

Real-Time Power Feedback Control YAG Laser Welder

ML-2450A
ML-2350A·AF
ML-2351A·AF

Basic Specifications and Performance

Real-time power feedback | Variable mirrors | Waveform control | Power monitor | Controller | External communi-cations | Fade-in/ Fade-out | Forced air cooling | Dual-wavelength laser system

Line-up of forced air cooling models

150W·70W·50W CLASS

Model		ML-2450A	ML-2350A	ML-2351A	ML-2350AF	ML-2351AF
Oscillation wavelength		1,064nm				
Laser output	Maximum rated output	150W	70W	50W	70W	50W
	Maximum output energy	70J/P	70J/P	50J/P	70J/P	50J/P
	Pulse width	10ms				
Output control	Pulse width	0.3 to 100.0ms(0.1ms steps)	0.3 to 30.0ms(0.1ms steps)			
		0.25 to 5.00ms(0.05ms steps) : Setting selectable				
	Pulse repetition rate	1 to 200pps				
Number of schedules		32 schedules				
Counter	Total counter	9 digits				
	Good counter	9 digits				
Branch optical system		Optical fiber delivery system Up to 6 branches*				
External communication function		RS-485*				
Required power supply		3-phase 200/380/400VAC ±10% , 3-phase 220VAC +10% -15% 50/60Hz				
Cooling system		Water cooling pressure:294kPa(3kgf/cm²) max Differential pressure:98-294kPa(1-3kgf/cm²)			Forced air cooling	
		Flow:20L/minute at 25˚C(for pure water at 30˚C)	Flow:4L/minute at 25˚C, 18L/minute at 32˚C			
		Water temperature:5-32˚C Hose inner diameter:15mm				
Dimensions		495(W)×995(D)×990(H)mm			530(W)×995(D)×990(H)mm	
Mass		230kg(200/220VAC)	210kg(200/220VAC)		220kg	
		250kg(380/400VAC)	240kg(380/400VAC)			

* Option

High-speed, high-quality welding

High-speed seam welding is possible with high repetition rate of up to 500 pps. Also, power feedback control and waveform control functions enable high-quality welding for a variety of work.

Supports factory automation easily

These devices are equipped with a wealth of input/output terminals (signals), so they can be easily connected to automatic equipment.

Optical fiber delivery system

A maximum of four branches are possible, including energy sharing and time sharing. (Optional)

Operation section controller

The controller can be taken off the main unit and operated by hand.

ML-2552A

This device is for high-speed seam welding with SI type ϕ0.3 optic fiber as standard.

Real-Time Power Feedback Control YAG Laser Welder

ML-2550A / ML-2551A ML-2552A

Basic Specifications and Performance

Real-time power feedback | Variable mirrors | Waveform control | Power monitor | Controller | External communi-cations | Fade-in/ Fade-out

Beautiful Finish with a Full Array of Functions

400W·300W CLASS

Model		ML-2550A	ML-2551A	ML-2552A
Oscillation wavelength		1,064nm		
Laser output	Maximum rated output	400W	300W	300W ✱1
	Maximum output energy	80J/P(pulse width 10ms)	50J/P(pulse width 10ms)	20J/P(pulse width 4ms)
Output control	Pulse width	0.3 to 100.0ms(0.1ms steps), 0.25 to 5.00ms(0.05ms steps) : Setting selectable		
	Pulse repetition rate	1 to 500pps		
Number of schedules		32 schedules		
Counter	Total counter	9 digits		
	Good counter	9 digits		
Branch optical system		Optical fiber delivery system Up to 4 branches ✱2		
External communication function		RS-485		
Required power supply		3-phase 200/380/400VAC ±10%, 3-phase 220VAC +10% -15% 50/60Hz		
Cooling system		Water cooling Pressure : 294kPa(3kgf/cm²)max. Differential pressure : 98-294kPa(1-3kgf/cm²)		
		Water temperature : 5-32˚C Flow : 16L /minute at 30˚C, 25L /minute at 35˚C Connecting hose inner diameter : 15mm		
Dimensions		530(W)×1,350(D)×1,170(H)mm		
Mass		400kg(200/220VAC) 450kg(380/480VAC)		

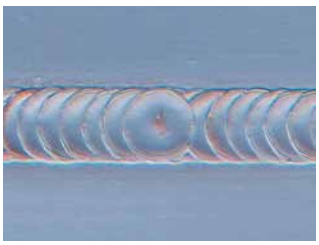
✱1 When the setting range for the width of one pulse is 0.8 - 15.0ms and the peak power is 1.5kW or greater. Outside these ranges, the maximum output is 250W. ✱2 Option

High-speed, high-quality welding

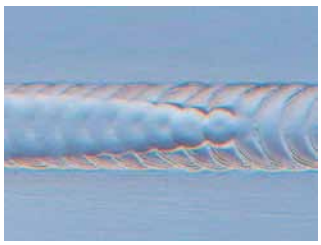
High-speed seam welding is possible with high repetition rates of up to 500 pps. Also, power feedback control and waveform control functions enable high-quality welding for a variety of work.

Fade-in/fade-out function

The laser output is varied gradually to avoid marks at the start and end of seam welding and to provide a beautiful finish, even for overlapping sections of circumferential seam welding.



Without fade-out



With fade-out

Color LCD touch panel

The large, easy-to-view touch panel can be detached from the main unit and operated by hand. (ML-2650B/ML-2651B)

Power monitor

Laser energy (J) and average power (W) can be monitored, and if the set value is not achieved, an abnormality signal is output. Complete quality control is possible.

Optical fiber delivery System

A maximum of four branches are possible, including energy sharing and time sharing. (Optional)

Real-Time Power Feedback Control YAG Laser Welder

ML-2650B / ML-2651B

Basic Specifications and Performance

Real-time power feedback | Variable mirrors | Waveform control | Power monitor | Color LCD touch panel | External communi-cations | Fade-in/ Fade-out

Provides High-Speed, High-Quality Seam Welding

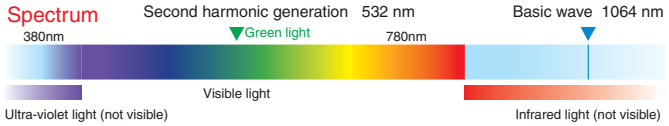
600W·500W CLASS

Model		ML-2650B	ML-2651B(High brightness)
Oscillation wavelength		1,064nm	
Laser output	Maximum rated output	600W	500W
	Maximum output energy	100J/P(pulse width 10ms)	80J/P(pulse width 10ms)
Output control	Pulse width	0.3 to 100.0ms(0.1ms steps), 0.25 to 5.00ms(0.05ms steps) : Setting selectable	
	Pulse repetition rate	1 to 500pps	
Number of schedules		32 schedules	
Counter	Total counter	9 digits	
	Good counter	9 digits	
Branch optical system		Optical fiber delivery system Up to 4 branches*	
External communication function		RS-485	
Required power supply		3-phase 200/380/400VAC ±10%, 3-phase 220VAC +10% -15% 50/60Hz	
Cooling system		Water cooling Pressure : 294kPa(3kgf/cm²) max. Differential pressure : 98-294kPa(1-3kgf/cm²)	
		Water temperature : 5-35˚C Flow : 25L /minute at 25˚C, 55L /minute at 32˚C Connecting hose inner diameter : 19mm	
Dimensions		550(W)×1,780(D)×1,200(H)mm	
Mass		540kg	

* Option

SHG lasers

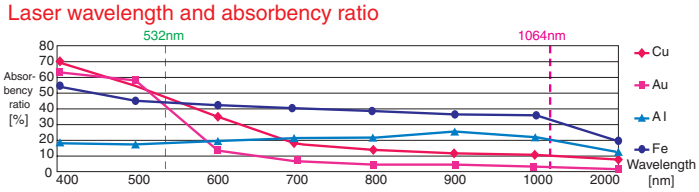
An SHG (second harmonic generation) laser is a green laser that uses non-linear optic elements. It has a wavelength of 532nm, which is in the visible light range and is half that of the basic wave laser (1,064nm).



Why this is suited to copper welding

A YAG SHG laser has a good absorbency ratio for copper and gold, about 4.5 to 20times that of a basic wave laser.

Laser wavelength and absorbency ratio



2-wavelength welding system

By combining the output from a YAG SHG laser and forming a YAG basic wave laser in the Focus head, and then outputting them on the same axis, the welding depth and melting diameter for copper are vastly improved compared to single wavelength welding.

Real-Time Power Feedback Control | YAG SHG Green Pulse Laser Welder

ML-8050A

Basic Specifications and Performance

Real-time power feedback | Variable mirrors | Waveform control | Power monitor | External communi-cations | Forced air cooling | Dual-wavelength laser system

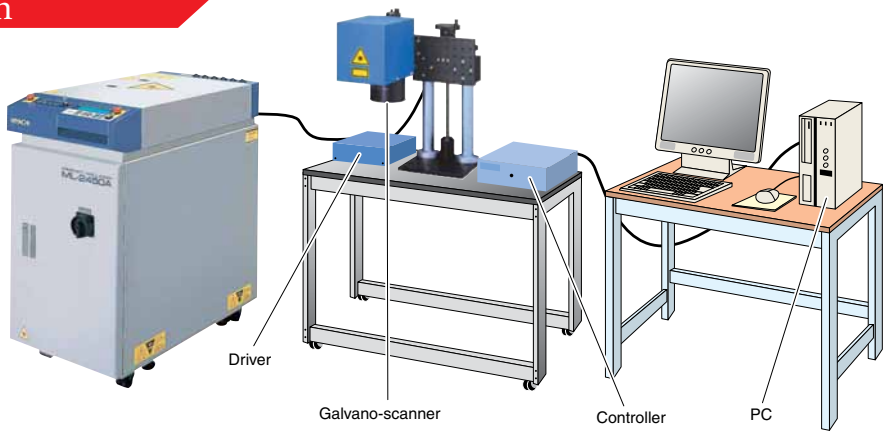
Allows Laser Welding of Copper, Too!

First in the world
From "soldering" to "laser welding"
New copper welding technology!
New solutions! A technology revolution!

Model		ML-8050A
Oscillation wavelength		532nm(YAG SHG)
Laser output	Maximum rated output	2W
	Maximum output energy	2J/P
	Maximum peak power	1.5kW(pulse width 1ms maximum)
Output control	Pulse width	0.20 to 3ms(0.02ms steps)
	Pulse repetition rate	1 to 12pps
Number of schedules		32 schedules
Counter	Total counter	9 digits
	Good counter	9 digits
Available optical fiber		ϕ0.3-0.6mm SI type optical fiber(ϕ0.3mm SI type optical system is recommended)
Branch optical system		Single branch only
External communication function		RS-485
Required power supply		Single-phase 200/220/240VAC +10% -15% 50/60Hz
Cooling system		Forced air cooling
Dimensions		310(W)×802(D)×700(H)mm
Mass		84kg

Scanning laser welding system

Combining a high-speed galvano-scanner and the ML series real-time power feedback device, it is possible to weld multiple spots at high speed within the processing area.



High-speed, multi-point, multi-schedule spot welding

Attains a maximum laser repetition rate of 70 pps. Power feedback enables easy multi-schedule spot welding that can handle different materials and different thicknesses in the same work area.

High-stability, high-precision beam scanning performance

By controlling the galvano-scanner temperature, high stability is attained even with fluctuations in ambient temperature, allowing positioning precision of within 10μm in the ambient temperature range of 20-35℃.

Specifications

Scanning laser welding head		
Model	GWH-10/15/20-35	GWH-10/15/20-60
Processing head section	Scanning head	
Processing area	φ35mm	φ60mm
Power supply	Single-phase 100 to 240VAC 2A 50/60Hz	
Power consumption	200W maximum	
PC	IBM PC/AT compatible	
OS	Windows Xp	
Interface	USB : 1 RS232C : 2	
Dimensions and mass	【Galvano-scanner head】237(W)×440(D)×260(H)mm 10kg	
	【Controller】360(W)×420(D)×122(H)mm 7kg	
	【Driver】180(W)×300(D)×99(H)mm 2kg	

LD DIRECT LASER — Laser plastic welder

ML-5220B

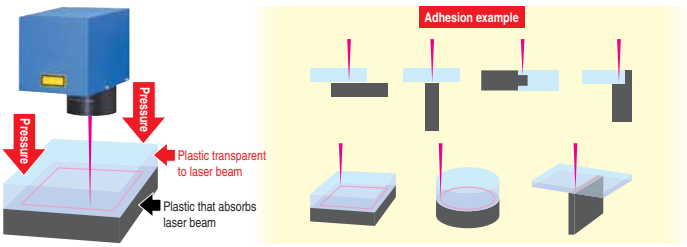
The Compact Galvano-Scanner Head Handles Inline Operation Easily, Too.

Laser Diode (LD) Direct Laser

Laser diode (semi-conductor laser) light is applied directly to thermal processing, without passing it through a YAG or YVO_4 laser crystal.

Plastic welding mechanism

Laser beam striking from the laser transparent plastic side melts the laser-absorbent plastic. By applying pressure and pressing the two plastics together, the transparent plastic is also melted and the two plastics adhere to each other.



Key point: Welding agent not necessary

- Unlike welding with a welding agent, no hardening time is required, so the work time can be greatly reduced, allowing in-line operation.
- Eliminates the need for storage and management of organic solvent and welding agent.
- Eliminates thread pulling and dripping, and improves quality.
- Because laser joining only joins thermally plasticizable materials, recycling is easy.

Specifications

Model	ML-5220B	
Oscillation wavelength	810nm±10nm	
Maximum output	30W	
fθ focal distance	f=100mm	f=150mm
Scanning area	φ30mm	φ60mm
Minimum beam diameter	φ1.4mm	φ2.0mm
Required power supply	Single-phase 90 to 130VAC/180 to 260VAC automatic selectable, 50/60Hz	
Power consumption	0.6kW	
Cooling system	Full air cooling	
Dimensions and mass	【Control section】250(W)×400(D)×450(H)mm 17kg	
	【Scanning head section】203(W)×279(D)×211(H)mm 8kg	

System Sales

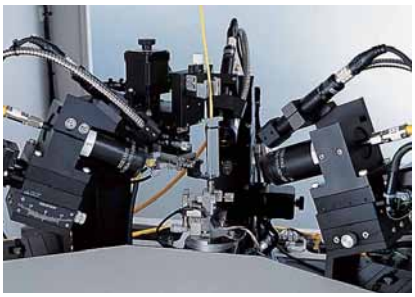
At Miyachi Corp. we also offer hybrid systems.

Green pulse laser welding system

- **Solder-free joining**
  Improves reliability by welding materials directly to each other without the use of solder.
- **High-speed processing point positioning and monitoring**
  The processing point is positioned at high speed using an XYZ stage. The welding points can be monitored on the TV monitor.
- **Laser welding monitor**
  This system has a built-in laser welding monitor that allows real-time evaluation of the weld.

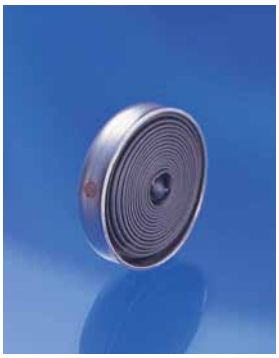
Laser welding system configurations

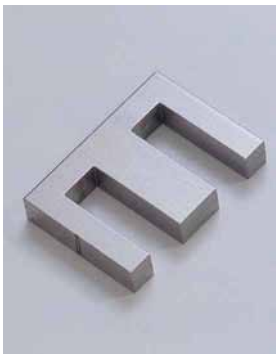
- Simultaneous multi-point welding system
- Precise, high-speed, multi-point welding system
- Sealing welding systems using laser seams
- Spot welding system using image position detection
- Welding system with work rotation mechanisms, etc.

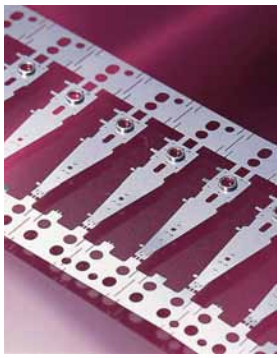


Applications


Motor cores


Cigar lighters


Transformer cores


Gimbals


Optic connectors

Laser beam

1. Miyachi laser devices are Class 4 lasers. Direct light from the laser device or light reflected or dispersed when an object is illuminated is quite dangerous. Be careful not to let any such light get in your eyes.
2. Always wear protective eyeglasses within the area where the laser light may reach. (Protective eyeglasses are included in the accessories.)
3. Do not shine the laser light on your skin. It can cause burns.
4. Do not turn the laser beam in any direction except that of the work area. Cover the light with a stopper (made of a light absorbing/dispersing material that can withstand high temperatures).
5. Keep the laser beam from shining on flammable or combustible materials. Shining laser beam on such materials can cause a fire.

High voltage

1. When replacing the excitation lamp or removing the power supply cover, cut off the power supply and wait at least 5 minutes. Check that the capacitor has discharged before starting any electrical work.
2. Always ground the chassis ground terminal.

Handling of laser devices

1. Designate a laser safety manager.
2. Set and manage laser management areas.
3. Do not alter or change the device.
4. For other details, refer to the following standards, etc.

Miyachi laser products conform to the following standards.

- JIS C 6801
- JIS C 6802, IEC 60825-1
- CE (Some products)

*Please contact us for further details.

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A Wise Choice Begins in Our Laboratory

Miyachi Corporation makes its application development laboratories available to customers at its operational centers in Japan and around the world. Everyone being interested in learning more about laser welders, laser markers and fine spot welders, and/or having trouble meeting their production requirements is invited to make use of the equipment in one of our worldwide application laboratories. You may visit in person or send your parts for a technical analysis and application report. To avoid congestion, please call us prior to your visit to arrange an appointment.

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Please visit MIYACHI website

URL http://www.miyachi.com

This website provides the information on our products and topics.

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