

Contents

Prologue.....	1
References.....	8
1 Background to Laser Design and General Applications	11
1.1 Basic Principles of Lasers	11
1.1.1 Stimulated Emission Phenomenon	11
1.1.2 Basic Components of a Laser	12
1.1.3 Physics of the Generation of Laser Light	14
1.1.4 Relationship Between the Einstein Coefficients	17
1.1.5 Lifetime Broadening	18
1.1.6 Transition Rates for Monochromatic Waves	19
1.1.7 Amplification by an Atomic System	20
1.1.8 The Laser: Oscillation and Amplification	23
1.2 Laser Construction Concepts	24
1.2.1 Overall Design	24
1.3 Types of Laser	32
1.3.1 Gas Lasers	32
1.3.2 Solid-state Lasers	41
1.3.3 Dye Lasers	50
1.3.4 Free-electron Lasers	51
1.4 Applications of Lasers	51
1.4.1 Powerful Light	53
1.4.2 Alignment	53
1.4.3 Measurement of Length	54
1.4.4 Velocity Measurement	57
1.4.5 Holography	61
1.4.6 Speckle Interferometry	63
1.4.7 Measurement of Atmospheric Pollution and Dynamics	64
1.4.8 Inspection	66
1.4.9 Analytical Technique	67
1.4.10 Recording	67
1.4.11 Communications	71
1.4.12 Heat Source	71
1.4.13 Medical Uses	72
1.4.14 Printing	72
1.4.15 Isotope Separation	73
1.4.16 Atomic Fusion	73
1.4.17 Stimulated Radioactive Decay?	74

1.5	Market for Laser Applications	74
	References	76
2	Basic Laser Optics	79
2.1	The Nature of Electromagnetic Radiation	79
2.2	Interaction of Electromagnetic Radiation with Matter	81
	2.2.1 Nonlinear Effects	84
2.3	Reflection or Absorption	89
	2.3.1 Effect of Wavelength	90
	2.3.2 Effect of Temperature	91
	2.3.3 Effect of Surface Films	91
	2.3.4 Effect of Angle of Incidence	92
	2.3.5 Effect of Materials and Surface Roughness	93
2.4	Refraction	94
	2.4.1 Scattering	96
2.5	Interference	97
2.6	Diffraction	97
2.7	Laser Beam Characteristics	98
	2.7.1 Wavelength	98
	2.7.2 Coherence	98
	2.7.3 Mode and Beam Diameter	99
	2.7.4 Polarisation	101
2.8	Focusing with a Single Lens	102
	2.8.1 Focused Spot Size	102
	2.8.2 Depth of Focus	114
2.9	Optical Components	115
	2.9.1 Lens Doublets	115
	2.9.2 Depolarisers	116
	2.9.3 Collimators	117
	2.9.4 Metal Optics	119
	2.9.5 Diffractive Optical Elements – Holographic Lenses	120
	2.9.6 Laser Scanning Systems	121
	2.9.7 Fibre Delivery Systems	121
	2.9.8 Liquid Lenses	125
	2.9.9 Graded-index Lenses	127
2.10	Conclusions	127
	References	128
3	Laser Cutting, Drilling and Piercing	131
3.1	Introduction	131
3.2	The Process – How It Is Done	133
3.3	Laser Drilling and Piercing	135
	3.3.1 Introduction	135
	3.3.2 Drilling Process Variations	136
	3.3.3 Percussion and Single- or Double-shot Drilling	136
	3.3.4 Drilling Ceramic-coated Material	149

3.3.5	Trepanning	149
3.3.6	Helical Trepanning	151
3.3.7	Applications of Laser Drilling	152
3.3.8	Monitoring the Drilling Process	155
3.4	Methods of Cutting	156
3.4.1	Vaporisation Cutting/Drilling	156
3.4.2	Fusion Cutting – Melt and Blow	156
3.4.3	Reactive Fusion Cutting	163
3.4.4	Controlled Fracture	164
3.4.5	Scribing	165
3.4.6	Cold Cutting	166
3.4.7	Laser-assisted Oxygen Cutting – the LASOX Process	166
3.5	Theoretical Models of Cutting	168
3.6	Practical Performance	168
3.6.1	Beam Properties	169
3.6.2	Transport Properties	173
3.6.3	Gas Properties	176
3.6.4	Material Properties	180
3.6.5	Practical Tips	182
3.7	Examples of Applications of Laser Cutting	183
3.7.1	Die Board Cutting	183
3.7.2	Cutting of Quartz Tubes	184
3.7.3	Profile Cutting	184
3.7.4	Cloth Cutting	184
3.7.5	Aerospace Materials	184
3.7.6	Cutting Fibre Glass	185
3.7.7	Cutting Kevlar®	185
3.7.8	Prototype Car Production	185
3.7.9	Cutting Alumina and Dielectric Boards	185
3.7.10	Furniture Industry	185
3.7.11	Cutting Paper	187
3.7.12	Flexographic Print Rolls	187
3.7.13	Cutting Radioactive Materials	187
3.7.14	Electronics Applications	187
3.7.15	Scrap Recovery	187
3.7.16	Laser Machining	187
3.7.17	Shipbuilding	188
3.7.18	The Laser Punch Press	188
3.7.19	Manufacture of Bikes and Tubular Structures	188
3.7.20	Cutting and Welding of Railcars	189
3.8	Costed Example	189
3.9	Process Variations	189
3.9.1	Arc-augmented Laser Cutting	189
3.9.2	Hot Machining	190
3.10	Future Developments	191
3.10.1	Higher-powered Lasers	191

	3.10.2 Additional Energy Sources	191
	3.10.3 Improved Coupling	191
	3.10.4 Smaller Spot Size	192
	3.10.5 Increased Drag	192
	3.10.6 Increased Fluidity	192
	3.11 Worked Example of Power Requirement	192
	References	193
4	Laser Welding	199
	4.1 Introduction	199
	4.2 Process Arrangement	202
	4.3 Process Mechanisms – Keyholes and Plasmas	203
	4.4 Operating Characteristics	209
	4.4.1 Power	209
	4.4.2 Spot Size and Mode	213
	4.4.3 Polarisation	214
	4.4.4 Wavelength	215
	4.4.5 Speed	216
	4.4.6 Focal Position	218
	4.4.7 Joint Geometries	219
	4.4.8 Gas Shroud and Gas Pressure	224
	4.4.9 Effect of Gas Pressure – Due to Velocity and Environment	228
	4.4.10 Effect of Material Properties	229
	4.4.11 Gravity	232
	4.5 Process Variations	232
	4.5.1 Arc-augmented Laser Welding	232
	4.5.2 Twin-beam Laser Welding	234
	4.5.3 Walking and Spinning Beams	234
	4.5.4 Laser Welding of Plastics	235
	4.6 Applications for Laser Welding in General	240
	4.7 Costed Example	244
	References	246
5	Theory, Mathematical Modelling and Simulation	251
	5.1 Introduction	251
	5.2 What is a Model?	254
	5.2.1 Derivation of Fourier's Second Law	255
	5.3 Analytical Models with One-dimensional Heat Flow	257
	5.4 Analytical Models for a Stationary Point Source	261
	5.4.1 The Instantaneous Point Source	261
	5.4.2 The Continuous Point Source	262
	5.4.3 Sources Other than Point Sources	262
	5.5 Analytical Models for a Moving Point Source	263
	5.6 Alternative Surface Heating Models	264
	5.6.1 The Ashby–Shercliffe Model: The Moving Hypersurface Line Source	264

5.6.2	The Davis <i>et al.</i> Model: The Moving Gaussian Source	265
5.7	Analytical Keyhole Models – Line Source Solution	266
5.7.1	Line Source on the Axis of the Keyhole	266
5.7.2	Line Source Around the Surface of a Cylinder: One-dimensional Transient Model for Cylindrical Bodies.....	268
5.7.3	Analytical Moving Point–Line Source	269
5.8	Three-dimensional Models	270
5.8.1	Three-dimensional Model for a Semi-infinite Plate	270
5.8.2	Three-dimensional Transient Model for Finite Slabs	271
5.9	Numerical Modelling	272
5.9.1	Three-dimensional Thermal Model	275
5.9.2	Flow Within the Melt Pool – Convection	277
5.9.3	Pool Shape	277
5.9.4	Some Model Results	281
5.9.5	Effect of Flow on Surface Deformation	282
5.9.6	Model for Flow with Vaporisation	283
5.9.7	Mass Additions – Surface Alloying and Cladding.....	283
5.10	Modelling Laser Ablation.....	284
5.11	Semiquantitative Models	286
5.12	Conclusions	288
	References	292
6	Laser Surface Treatment	295
6.1	Introduction	295
6.2	Laser Heat Treatment	297
6.2.1	Heat Flow.....	302
6.2.2	Mass Flow by Diffusion	304
6.2.3	Mechanism of the Transformation Process.....	305
6.2.4	Properties of Transformed Steels.....	307
6.3	Laser Surface Melting	309
6.3.1	Solidification Mechanisms.....	314
6.3.2	Style of Solidification	314
6.4	Laser Surface Alloying	318
6.4.1	Process Variations	318
6.4.2	Applications.....	320
6.5	Laser Cladding	320
6.5.1	Laser Cladding with Preplaced Powder	322
6.5.2	Blown Powder Laser Cladding	323
6.5.3	Applications.....	328
6.6	Particle Injection	329
6.7	Laser-assisted Cold Spray Process	330
6.8	Surface Texturing	330
6.9	Enhanced Electroplating	333
6.10	Laser Chemical Vapour Deposition	334
6.11	Laser Physical Vapour Deposition	335
6.12	Noncontact Bending	335

6.13	Magnetic Domain Control	336
6.14	Laser Cleaning and Paint Stripping	337
6.15	Surface Roughening	337
6.16	Scabbling	337
6.17	Micromachining	338
6.18	Laser Marking	339
6.19	Shock Hardening	340
6.20	Conclusions	342
	References	342
7	Rapid Prototyping and Low-volume Manufacture	349
7.1	Introduction	349
7.2	Range of Processes	350
7.2.1	Styles of Manufacture	350
7.2.2	Classification of Rapid Prototyping Techniques by Material	351
7.3	Computer Aided Design File Manipulation	351
7.4	Layered Manufacturing Issues	353
7.4.1	General	353
7.4.2	Stair Stepping	353
7.4.3	Layer Thickness Selection	354
7.4.4	Accuracy	354
7.4.5	Part Orientation	354
7.4.6	Support Structures	354
7.5	Individual Processes	355
7.5.1	Stereolithography	355
7.5.2	Selective Laser Sintering	358
7.5.3	Laminated-object Manufacture	360
7.5.4	Laser Direct Casting or Direct Metal Deposition (DMD)	362
7.6	Rapid Manufacturing Technologies	365
7.6.1	Silicone Rubber Moulding	365
7.6.2	Investment Casting	365
7.6.3	Sand Casting	366
7.6.4	Laser Direct Casting	366
7.6.5	Rapid Prototyping Tooling	367
7.7	Applications	367
7.8	Conclusions	367
	References	368
8	Laser Ablative Processes – Macro- and Micromachining	371
8.1	Introduction	371
8.2	Basic Mechanisms During Short Radiant Interactions	372
8.2.1	Thermal Models	372
8.2.2	Nonthermal Models	373
8.3	Case 2: Nanosecond Pulse Impact	375
8.4	Case 3: Ultrashort Pulses	378
8.5	Applications	379

8.5.1	Low-energy Pulses (Less than 150 nJ)	379
8.5.2	Medium-energy Pulses (150–500 nJ)	380
8.5.3	High-energy Pulses (More than 500 nJ)	380
8.6	Summary	385
	References	386
9	Laser Bending or Forming	389
9.1	Introduction	389
9.2	The Process Mechanisms	390
9.2.1	The Thermal Gradient Mechanism	390
9.2.2	The Point Source Mechanism	391
9.2.3	The Buckling Mechanism	392
9.2.4	The Upsetting Mechanism	393
9.2.5	Laser-induced Shock Bending	393
9.3	Theoretical Models	394
9.3.1	Models for the Thermal Gradient Mechanism	395
9.3.2	The Buckling Mechanism Model	400
9.3.3	The Upsetting Mechanism Model	402
9.4	Operating Characteristics	403
9.4.1	Effect of Power	404
9.4.2	Effect of Speed – “Line Energy”	404
9.4.3	Effect of Material	405
9.4.4	Effect of Thickness – Thickening at the Bend	406
9.4.5	Effect of Plate Dimensions – Edge Effects	407
9.4.6	Effect of the Number of Passes	407
9.5	Applications	409
9.6	Conclusions	413
	References	414
10	Laser Cleaning	417
10.1	Introduction	417
10.2	Mechanisms of Laser Cleaning	418
10.2.1	Selective Vaporisation	419
10.2.2	Spallation	423
10.2.3	Transient Surface Heating	424
10.2.4	Evaporation Pressure	426
10.2.5	Photon Pressure	429
10.2.6	Ablation (Bond Breaking)	430
10.2.7	Dry and Steam Laser Cleaning	430
10.2.8	Angular Laser Cleaning	433
10.2.9	Laser Shock Cleaning	434
10.3	An Overview of the Laser Cleaning Process	435
10.4	Practical Applications	436
	References	437

11	Biomedical Laser Processes and Equipment	441
11.1	Introduction	441
11.2	Interaction of Laser Radiation with Biological Tissue	442
11.2.1	Optical Properties of Biological Tissue	442
11.2.2	Thermal Properties of Tissue	445
11.2.3	Mechanical Properties of Tissue	447
11.2.4	Tissue Heating Effects – Nonablative Heating	447
11.2.5	Tissue Heating Effects – Ablation	448
11.2.6	Tissue Heating – Nonlinear Interactions with a Laser Beam ...	450
11.3	Medical Applications of Lasers	451
11.3.1	Ophthalmology	451
11.3.2	Surgical Applications	454
11.4	Medical Diagnostics	466
11.4.1	Absorption Techniques	466
11.4.2	Spectral Techniques	466
11.4.3	Visualisation Techniques	467
11.5	Laser Manufacture of Medical Devices	470
11.5.1	Laser Cutting	470
11.5.2	Marking	471
11.5.3	Wire Stripping	471
11.5.4	Laser Welding	472
11.5.5	Nanomedicine	473
11.5.6	Scaffolds for Tissue Engineering	476
11.6	Conclusion	480
	References	482
12	Laser Automation and In-process Sensing	485
12.1	Automation Principles	485
12.2	In-process Monitoring	488
12.2.1	Monitoring Beam Characteristics	488
12.2.2	Monitoring Worktable Characteristics	496
12.2.3	Monitoring Process Characteristics	499
12.3	In-process Control	511
12.3.1	In-process Power Control	511
12.3.2	In-process Temperature Control	512
12.4	“Intelligent” In-process Control	513
12.5	Conclusions	515
	References	516
13	Laser Safety	519
13.1	The Dangers	519
13.2	The Standards	519
13.3	The Safety Limits	520
13.3.1	Damage to the Eye	520
13.3.2	Damage to the Skin	522
13.4	Laser Classification	523

13.5 Typical Class 4 Safety Arrangements	524
13.6 Where Are the Risks in a Properly Set Up Facility?	524
13.7 Electrical Hazards	525
13.8 Fume Hazards	525
13.9 Conclusions	525
References	526
Epilogue	529
14.1 Power Intensity	530
14.2 Power Transmission	530
14.3 Power Shaping	530
14.4 Automation	530
14.5 Beam Coherence	531
14.6 Beam Spectral Purity	531
14.7 Multiphoton Events	531
14.8 Frequency-related Events	531
14.9 Equipment Developments	531
14.10 Unthought-of Concepts	532
Index	535