

# CONTENTS

## PREFACE

xxv

## PART I PRINCIPLES OF INDUSTRIAL LASERS

1

### 1 Laser Generation

3

#### 1.1 Basic Atomic Structure

3

#### 1.2 Atomic Transitions

7

##### 1.2.1 Selection Rules

7

##### 1.2.2 Population Distribution

8

##### 1.2.3 Absorption

8

##### 1.2.4 Spontaneous Emission

9

##### 1.2.5 Stimulated Emission

10

##### 1.2.6 Einstein Coefficients: $A_e, B_{12}, B_{21}$

11

#### 1.3 Lifetime

13

#### 1.4 Optical Absorption

14

#### 1.5 Population Inversion

17

#### 1.6 Threshold Gain

18

#### 1.7 Two-Photon Absorption

21

#### 1.8 Summary

23

#### References

24

#### Appendix 1A

24

#### Problems

25

### 2 Optical Resonators

26

#### 2.1 Standing Waves in a Rectangular Cavity

26

#### 2.2 Planar Resonators

33

##### 2.2.1 Beam Modes

34

##### 2.2.1.1 Longitudinal Modes

35

##### 2.2.1.2 Transverse Modes

36

##### 2.2.2 Line Selection

38

vii



2.2.3	Mode Selection	39
2.2.3.1	Transverse Mode Selection	39
2.2.3.2	Longitudinal Mode Selection	40
2.3	Confocal Resonators	43
2.4	Generalized Spherical Resonators	48
2.5	Concentric Resonators	49
2.6	Stability of Optical Resonators	51
2.7	Summary	56
	Appendix 2A	56
	Problems	57
<b>3</b>	<b>Laser Pumping</b>	<b>63</b>
3.1	Optical Pumping	63
3.1.1	Arc or Flash Lamp Pumping	63
3.1.2	Diode Laser Pumping	65
3.1.2.1	Longitudinal Pumping	65
3.1.2.2	Transverse Pumping	65
3.1.3	Pumping Efficiency	66
3.1.4	Energy Distribution in the Active Medium	66
3.2	Electrical Pumping	68
3.3	Summary	70
<b>4</b>	<b>Rate Equations</b>	<b>71</b>
4.1	Two-Level System	71
4.2	Three-Level System	73
4.3	Four-Level System	76
4.4	Summary	79
	Appendix 4A	80
	Problems	80
<b>5</b>	<b>Broadening Mechanisms</b>	<b>83</b>
5.1	Line-Shape Function	83
5.2	Line-Broadening Mechanisms	84
5.2.1	Homogeneous Broadening	84
5.2.1.1	Natural Broadening	84
5.2.1.2	Collision Broadening	86
5.2.2	Inhomogeneous Broadening	89
5.3	Comparison of Individual Mechanisms	90

5.4 Summary	92
Appendix 5A	93
Problems	93
<b>6 Beam Modification</b>	<b>96</b>
6.1 Quality Factor	96
6.2 Q-Switching	99
6.2.1 Mechanical Shutters	100
6.2.2 Electro-Optic Shutters	101
6.2.3 Acousto-Optic Shutters	103
6.2.4 Passive Shutters	103
6.3 Q-Switching Theory	104
6.4 Mode-Locking	107
6.4.1 Active Mode Locking	111
6.4.2 Passive Mode-Locking	112
6.5 Laser Spiking	113
6.6 Lamb Dip	114
6.7 Summary	115
Appendix 6A	116
Problems	116
<b>7 Beam Characteristics</b>	<b>118</b>
7.1 Beam Divergence	118
7.2 Monochromaticity	121
7.3 Beam Coherence	122
7.3.1 Spatial Coherence	122
7.3.2 Temporal Coherence	125
7.4 Intensity and Brightness	128
7.5 Frequency Stabilization	128
7.6 Beam Size	129
7.7 Focusing	130
7.8 Radiation Pressure	131
7.9 Summary	131
References	132
Appendix 7A	132
Problems	133



<b>8</b>	<b>Types of Lasers</b>	<b>135</b>
8.1	Solid-State Lasers	136
8.1.1	The Ruby Laser	136
8.1.2	Neodymium Lasers	138
8.1.2.1	The Nd:YAG Laser	139
8.1.2.2	The Nd:Glass Laser	139
8.2	Gas Lasers	139
8.2.1	Neutral Atom Lasers	140
8.2.2	Ion Lasers	142
8.2.3	Metal Vapor Lasers	144
8.2.4	Molecular Gas Lasers	146
8.2.4.1	Vibrational–Rotational Lasers	147
8.2.4.2	Vibronic Lasers	155
8.2.4.3	Excimer Lasers	156
8.3	Dye Lasers	158
8.4	Semiconductor (Diode) Lasers	160
8.4.1	Semiconductor Background	161
8.4.2	Semiconductor Lasers	164
8.4.3	Semiconductor Laser Types	170
8.4.3.1	Homojunction Lasers	170
8.4.3.2	Heterojunction Lasers	170
8.4.3.3	Quantum Well Lasers	172
8.4.4	Low-Power Diode Lasers	172
8.4.5	High-Power Diode Lasers	172
8.4.6	Applications of High-Power Diode Lasers	174
8.5	Free Electron Laser	174
8.6	New Developments in Industrial Laser Technology	176
8.6.1	Slab Lasers	176
8.6.2	Disk Lasers	177
8.6.3	Ultrafast (Femtosecond) Lasers	178
8.6.4	Fiber Lasers	180
8.7	Summary	182
	References	183
	Appendix 8A	184
	Appendix 8B	184
	Appendix 8C	185
	Problems	186



<b>9 Beam Delivery</b>	<b>188</b>
9.1 The Electromagnetic Spectrum	188
9.2 Reflection and Refraction	189
9.2.1 Reflection	189
9.2.2 Refraction	190
9.3 Birefringence	191
9.4 Brewster Angle	192
9.5 Polarization	194
9.6 Mirrors and Lenses	200
9.7 Beam Expanders	202
9.8 Beam Splitters	204
9.9 Beam Delivery Systems	205
9.9.1 Conventional Systems	205
9.9.2 Fiber Optic Systems	207
9.9.2.1 Optical Fiber Characteristics	208
9.9.2.2 Waveguide Structure	208
9.9.2.3 Background	209
9.9.2.4 Fiber Types	210
9.9.2.5 Beam Degradation	212
9.9.2.6 Application of Optical Fibers in High-Power Laser Systems	220
9.10 Summary	221
References	222
Appendix 9A	223
Problems	224
 <b>PART II ENGINEERING BACKGROUND</b>	 <b>229</b>
<b>10 Heat And Fluid Flow</b>	<b>231</b>
10.1 Energy Balance During Processing	231
10.2 Heat Flow in The Workpiece	232
10.2.1 Temperature Distribution	232
10.2.1.1 Thick Plate with Point Heat Source (Three Dimensional)	236
10.2.1.2 Thin Plate with Line Heat Source (Two Dimensional)	238



10.2.2	Peak Temperatures	245
10.2.3	Cooling Rates	247
10.2.4	Thermal Cycles	252
10.2.5	Gaussian Heat Source	253
10.2.6	The Two-Temperature Model	255
10.3	Fluid Flow in Molten Pool	259
10.3.1	Continuity Equation	260
10.3.2	Navier–Stokes Equations	261
10.3.3	Surface Tension Effect	262
10.3.4	Free Surface Modeling	265
10.4	Summary	266
	References	267
	Appendix 10A	269
	Appendix 10B Derivation of Equation (10.2A)	270
	Appendix 10C Moving Heat Source	271
	Appendix 10D	272
	Appendix 10E	273
	Appendix 10F	274
	Appendix 10G	275
	Problems	277
<b>11</b>	<b>THE MICROSTRUCTURE</b>	<b>281</b>
11.1	Process Microstructure	281
11.1.1	Fusion Zone	282
11.1.1.1	Initial Solidification	282
11.1.1.2	Microstructure	291
11.1.1.3	Nucleation and Grain Refinement in Molten Pool	299
11.1.1.4	Coring	300
11.1.2	Zone of Partial Melting	302
11.1.3	Heat-Affected Zone	302
11.1.3.1	Pure Metals	303
11.1.3.2	Precipitation-Hardening and Nonferrous Alloys	305
11.1.3.3	Steels	306
11.2	Discontinuities	311
11.2.1	Porosity	312
11.2.2	Cracking	314



11.2.2.1	Hot Cracking	316
11.2.2.2	Liquation Cracking	319
11.2.2.3	Cold Cracking	319
11.2.2.4	Reheat Cracking	324
11.2.2.5	Lamellar Tearing	325
11.2.3	Lack of Fusion	325
11.2.4	Incomplete Penetration	326
11.2.5	Undercut	326
11.3	Summary	327
	References	328
	Appendix 11A	329
	Problems	330
<b>12</b>	<b>Solidification</b>	<b>334</b>
12.1	Solidification Without Flow	334
12.1.1	Solidification of a Pure Metal	334
12.1.2	Solidification of a Binary Alloy	336
12.1.2.1	Temperature and Concentration Variation in a Solidifying Alloy	336
12.1.2.2	Interface Stability Theories	337
12.1.2.3	Mushy Zone	341
12.2	Solidification with Flow	344
12.2.1	Mushy Fluid	346
12.2.2	Columnar Dendritic Structure	348
12.3	Rapid Solidification	349
12.4	Summary	351
	References	352
	Appendix 12A	353
	Appendix 12B Criterion for Solidification of an Alloy	354
	Problems	360
<b>13</b>	<b>Residual Stresses and Distortion</b>	<b>361</b>
13.1	Causes of Residual Stresses	361
13.1.1	Thermal Stresses	361
13.1.2	Nonuniform Plastic Deformation	366
13.2	Basic Stress Analysis	368
13.2.1	Equilibrium Conditions	370
13.2.2	Strain–Displacement Relations	371



13.2.3	Stress–Strain Relations	372
13.2.3.1	Linear Elastic Behavior	372
13.2.3.2	Plastic Flow of Metals	373
13.2.3.3	Elastic–Plastic Conditions	374
13.2.4	Plane Stress and Plane Strain	375
13.2.4.1	Plane Stress	375
13.2.4.2	Plane Strain	375
13.2.4.3	Plane Stress/Plane Strain Equations	377
13.2.4.4	Compatibility Equation	377
13.2.4.5	Stress–Strain Relations for Plane Stress/Plane Strain	378
13.2.5	Solution Methods	378
13.3	Effects of Residual Stresses	379
13.3.1	Apparent Change in Strength	380
13.3.2	Distortion	381
13.4	Measurement of Residual Stresses	383
13.4.1	Stress Relaxation Techniques	383
13.4.1.1	Sectioning Technique	384
13.4.1.2	Drilling Technique	384
13.4.1.3	Strain Analysis	384
13.4.2	X-Ray Diffraction Technique	389
13.4.2.1	Principle of the X-Ray Diffraction Technique	389
13.4.2.2	The Film Technique	391
13.4.2.3	The Diffractometer Technique	392
13.4.3	Neutron Diffraction Technique	392
13.4.4	Residual Stress Equilibrium	394
13.5	Relief of Residual Stresses and Distortion	395
13.5.1	Thermal Treatments	396
13.5.1.1	Preheating	396
13.5.1.2	Postheating	396
13.5.2	Mechanical Treatments	396
13.5.2.1	Peening	397
13.5.2.2	Proof Stressing	397
13.5.2.3	Vibratory Stress Relief	397
13.6	Summary	397



References	398
Appendix 13A	399
Appendix 13B	400
Problems	400
<b>PART III LASER MATERIALS PROCESSING</b>	<b>407</b>
<b>14 Background on Laser Processing</b>	<b>409</b>
14.1 System-Related Parameters	409
14.1.1 Power and Power Density	410
14.1.2 Wavelength and Focusing	410
14.1.2.1 Determining the Focal Position	412
14.1.2.2 Depth of Focus	412
14.1.3 Beam Mode	413
14.1.4 Beam Form	414
14.1.5 Beam Quality	416
14.1.6 Beam Absorption	417
14.1.6.1 Measurement of Absorptivity	420
14.1.6.2 Beam–Plasma Interaction	421
14.1.7 Beam Alignment	422
14.1.8 Motion Unit	424
14.2 Process Efficiency	424
14.3 Disturbances that Affect Process Quality	426
14.4 General Advantages and Disadvantages of Laser Processing	427
14.4.1 Advantages	427
14.4.2 Disadvantages	427
14.5 Summary	428
References	429
Appendix 14A	429
Problems	430
<b>15 Laser Cutting and Drilling</b>	<b>431</b>
15.1 Laser Cutting	432
15.1.1 Forms of Laser Cutting	432
15.1.1.1 Fusion Cutting	432
15.1.1.2 Sublimation Cutting	432
15.1.1.3 Photochemical Ablation	433



15.1.2	Components of a Laser Cutting System	433
15.1.3	Processing Conditions	434
15.1.3.1	Beam Power	435
15.1.3.2	Beam Characteristics	435
15.1.3.3	Traverse Speed	437
15.1.3.4	Assist Gas Functions	438
15.1.3.5	Effect of Focal Position	443
15.1.4	Laser Cutting Principles	443
15.1.4.1	Beam Absorption During Laser Cutting	444
15.1.4.2	Process Modeling	447
15.1.5	Quality of Cut Part	453
15.1.5.1	Striations of the Cut Surface	453
15.1.5.2	Dross Formation	455
15.1.6	Material Considerations	456
15.1.6.1	Metals	457
15.1.6.2	Nonmetals	460
15.1.7	Advantages and Disadvantages of Laser Cutting	464
15.1.7.1	Advantages	464
15.1.7.2	Disadvantages	464
15.1.8	Specific Comparison with Conventional Processes	465
15.1.8.1	Laser, Plasma Arc, and Oxyacetylene (Oxy-Fuel) Cutting	465
15.1.8.2	Laser Cutting and Electrical Discharge Machining	466
15.1.8.3	Laser Cutting and Abrasive Waterjet Machining	466
15.1.8.4	Laser Cutting and Punching/Nibbling	466
15.1.9	Special Techniques	467
15.2	Laser Drilling	468
15.2.1	Forms of Laser Drilling	468
15.2.1.1	Single-Pulse Drilling	468
15.2.1.2	Multipulse Percussion Drilling	469
15.2.1.3	Trepanning	470
15.2.2	Process Parameters	470
15.2.2.1	Beam Characteristics	470
15.2.2.2	Drilling Characteristics	471
15.2.2.3	Process Defects	471



15.2.3	Analysis of Material Removal During Drilling	472
15.2.3.1	Basic Analysis	473
15.2.3.2	Approximate Analysis	478
15.2.4	Advantages and Disadvantages of Laser Drilling	483
15.2.4.1	Advantages	483
15.2.4.2	Disadvantages	483
15.2.5	Applications	484
15.3	New Developments	484
15.3.1	Micromachining	484
15.3.1.1	Transparent Dielectric Materials	485
15.3.1.2	Metals and Semiconductors	486
15.3.2	Laser-Assisted Machining	489
15.4	Summary	492
	References	493
	Appendix 15A	498
	Problems	499
<b>16</b>	<b>Laser Welding</b>	<b>502</b>
16.1	Laser Welding Parameters	502
16.1.1	Beam Power and Traverse Speed	503
16.1.2	Effect of Beam Characteristics	505
16.1.2.1	Beam Mode	505
16.1.2.2	Beam Stability	505
16.1.2.3	Beam Polarization	505
16.1.2.4	Pulsed Beams	505
16.1.3	Plasma Formation, Gas Shielding, and Effect of Ambient Pressure	506
16.1.3.1	Plasma Formation	506
16.1.3.2	Gas Shielding	508
16.1.3.3	Effect of Ambient Pressure	511
16.1.4	Beam Size and Focal Point Location	511
16.1.5	Joint Configuration	512
16.2	Welding Efficiency	514
16.3	Mechanism of Laser Welding	515
16.3.1	Conduction Mode Welding	515
16.3.2	Keyhole Welding	516
16.3.2.1	Power Absorption in the Keyhole	519
16.3.2.2	Keyhole Characteristics	521



16.4	Material Considerations	528
16.4.1	Steels	529
16.4.2	Nonferrous Alloys	529
16.4.3	Ceramic Materials	531
16.4.4	Dissimilar Metals	532
16.5	Weldment Discontinuities	532
16.5.1	Porosity	532
16.5.2	Humping	533
16.5.3	Spiking	533
16.6	Advantages and Disadvantages of Laser Welding	534
16.6.1	Advantages	534
16.6.2	Disadvantages	535
16.7	Special Techniques	535
16.7.1	Multiple-Beam Welding	535
16.7.1.1	Multiple-Beam Preheating and Postweld Heat Treatment	535
16.7.1.2	Multiple-Beam Flow Control	540
16.7.2	Arc-Augmented Laser Welding	545
16.8	Specific Applications	547
16.8.1	Microwelding	547
16.8.2	Laser-Welded Tailored Blanks	547
16.8.2.1	Advantages of Tailored Blank Welding	548
16.8.2.2	Disadvantages of Tailored Blank Welding	549
16.8.2.3	Applications of Laser-Welded Tailored Blanks	550
16.8.2.4	Formability of Tailor-Welded Blanks	551
16.8.2.5	Limiting Thickness or Strength Ratio	556
16.9	Summary	559
	References	560
	Appendix 16A	563
	Problems	565
<b>17</b>	<b>Laser Surface Modification</b>	<b>568</b>
17.1	Laser Surface Heat Treatment	568
17.1.1	Important Criteria	570
17.1.2	Key Process Parameters	570
17.1.2.1	Beam Power, Size, Speed, and Shielding Gas	570



17.1.2.2	Beam Mode	571
17.1.2.3	Beam Absorption	577
17.1.2.4	Initial Workpiece Microstructure	579
17.1.3	Temperature Field	580
17.1.4	Microstructural Changes in Steels	581
17.1.4.1	Pearlite Dissolution	581
17.1.4.2	Austenite Homogenization	585
17.1.4.3	Transformation to Martensite	586
17.1.5	Nonferrous Alloys	588
17.1.5.1	Solution Treatment	589
17.1.5.2	Aging	589
17.1.6	Hardness Variation	589
17.1.7	Residual Stresses	592
17.1.8	Advantages and Disadvantages of Laser Surface Treatment	592
17.1.8.1	Advantages	592
17.1.8.2	Disadvantages	593
17.2	Laser Surface Melting	594
17.3	Laser Direct Metal Deposition	595
17.3.1	Processing Parameters	596
17.3.2	Methods for Applying the Coating Material	596
17.3.3	Dilution	600
17.3.4	Advantages and Disadvantages of Laser Cladding	601
17.3.4.1	Advantages	601
17.3.4.2	Disadvantages	601
17.4	Laser Physical Vapor Deposition (LPVD)	601
17.5	Laser Shock Peening	603
17.5.1	Background Analysis	605
17.5.2	Advantages and Disadvantages of Laser Shock Peening	608
17.5.2.1	Advantages	608
17.5.2.2	Disadvantages	608
17.6	Summary	608
	References	609
	Appendix 17A	612
	Appendix 17B	613
	Problems	614



<b>18 Laser Forming</b>	<b>616</b>
18.1 Principle of Laser Forming	616
18.2 Process Parameters	618
18.3 Laser Forming Mechanisms	619
18.3.1 Temperature Gradient Mechanism	619
18.3.2 Buckling Mechanism	620
18.3.3 Upsetting Mechanism	622
18.3.4 Summary of the Forming Mechanisms	623
18.4 Process Analysis	624
18.5 Advantages and Disadvantages	629
18.5.1 Advantages	629
18.5.2 Disadvantages	629
18.6 Applications	629
18.7 Summary	630
References	630
Appendix 18A	631
Problems	632
<b>19 Rapid Prototyping</b>	<b>633</b>
19.1 Computer-Aided Design	633
19.1.1 Geometric Transformation	634
19.1.1.1 Translation	635
19.1.1.2 Scaling	635
19.1.1.3 Rotation	636
19.1.2 Curve and Surface Design	637
19.1.2.1 Splines	637
19.1.2.2 Bezier Curves	639
19.1.2.3 Surface Representation	640
19.1.3 Solid Modeling	642
19.1.3.1 Constructive Solid Geometry	642
19.1.3.2 Boundary Representation	644
19.1.4 Rapid Prototyping Software Formats	644
19.1.4.1 The STL (Stereolithography) Format	644
19.1.4.2 The IGES Format	646
19.1.5 Supports for Part Building	646
19.1.6 Slicing	647



19.2	Part Building	648
19.2.1	Liquid-Based Systems	649
19.2.1.1	Beam Scanning	650
19.2.1.2	Parallel Processing	654
19.2.2	Powder-Based Systems	655
19.2.2.1	Selective Laser Sintering (SLS)	655
19.2.2.2	3D Printing	657
19.2.2.3	Ballistic Particle Manufacturing	658
19.2.3	Solid-Based Systems	658
19.2.3.1	Fused Deposition Modeling	659
19.2.3.2	Laminated Object Manufacturing	659
19.2.4	Qualitative Comparison of Some Major Systems	661
19.3	Post-Processing	662
19.4	Applications	662
19.4.1	Design	663
19.4.2	Engineering, Analysis, and Planning	663
19.4.3	Manufacturing and Tooling	663
19.5	Summary	664
	References	665
	Appendix 19A	665
	Problems	666
<b>20</b>	<b>Medical and Nanotechnology Applications of Lasers</b>	<b>669</b>
20.1	Medical Applications	669
20.1.1	Medical Devices	670
20.1.2	Therapeutic Applications	672
20.1.2.1	Surgical Procedures	673
20.1.2.2	Ophthalmology	673
20.1.2.3	Dermatology	674
20.1.2.4	Dentistry	674
20.2	Nanotechnology Applications	675
20.2.1	Nanoholes and Grating	676
20.2.2	Nanobumps	677
20.2.3	Two-Photon Polymerization	680
20.2.4	Laser-Assisted Nanoimprint Lithography	686
20.3	Summary	686
	References	687



<b>21</b>	<b>Sensors for Process Monitoring</b>	<b>689</b>
21.1	Laser Beam Monitoring	689
21.1.1	Beam Power	690
21.1.1.1	Pyroelectric or Thermopile Detector	690
21.1.1.2	Beam Dump	690
21.1.2	Beam Mode	691
21.1.2.1	Laser Beam Analyzers	691
21.1.2.2	Plastic Burn Analysis	696
21.1.3	Beam Size	697
21.1.3.1	Kapton Film	697
21.1.3.2	Other Methods	698
21.1.4	Beam Alignment	698
21.2	Process Monitoring	699
21.2.1	Acoustic Emission	699
21.2.1.1	AE Detection	701
21.2.1.2	Background	703
21.2.1.3	AE Transmission	705
21.2.1.4	Traditional AE Signal Analysis	706
21.2.2	Acoustic Mirror	707
21.2.3	Audible Sound Emission	709
21.2.4	Infrared/Ultraviolet (IR/UV) Detection Techniques	711
21.2.4.1	Infrared Detection	711
21.2.4.2	Ultraviolet Detection	718
21.2.5	Optical (Vision) Sensing	719
21.2.5.1	Optical Detectors	719
21.2.5.2	Detector Setup	719
21.2.5.3	Edge Detection Methodology	720
21.3	Summary	724
	References	724
	Appendix 21A	727
	Problems	728
<b>22</b>	<b>Processing of Sensor Outputs</b>	<b>730</b>
22.1	Signal Transformation	730
22.1.1	The Fourier Transform	731
22.1.2	The Discrete Fourier Transform (DFT)	732
22.1.3	Properties of the Discrete Fourier Transform	733
22.1.4	Advantages of Digital Analysis	734



22.1.5	Pitfalls of Digital Analysis	734
22.1.6	The Sampling Theorem	736
22.1.7	Aliasing	736
22.1.8	Leakage	737
22.1.9	Window Functions	739
22.1.9.1	Rectangular Window	739
22.1.9.2	Triangular Window	739
22.1.9.3	Hanning Window	740
22.1.9.4	Hamming Window	741
22.1.10	Picket Fence Effect	741
22.1.11	Segmental Averaging	742
22.2	Data Reduction	742
22.2.1	Optimum Transform for Data Reduction	742
22.2.2	Variance Criterion	747
22.2.3	Class Mean Scatter Criterion	747
22.3	Pattern Classification	749
22.3.1	Pattern Recognition	749
22.3.1.1	Bayes Decision Theory	749
22.3.1.2	Bayes Decision Rule for Minimum Error	750
22.3.1.3	Discriminant Function Analysis	751
22.3.1.4	Minimum-Distance Classifier	752
22.3.1.5	General Linear Discriminant Function	755
22.3.1.6	Quadratic Discriminant Function	756
22.3.1.7	Least-Squares Minimum Distance Classification	756
22.3.1.8	System Training	759
22.3.2	Neural Network Analysis	760
22.3.3	Sensor Fusion	763
22.3.4	Time-Frequency Analysis	764
22.3.4.1	Short-Time Fourier Transform	764
22.3.4.2	Wavelet Transforms	766
22.3.4.3	Time-Frequency Distributions	767
22.3.4.4	Applications in Manufacturing	769
22.4	Summary	770
	References	771
	Appendix 22A	773
	Problems	774



<b>23 Laser Safety</b>	<b>778</b>
23.1 Laser Hazards	778
23.1.1 Radiation-Related Hazards	778
23.1.1.1 Mechanisms of Laser Damage	779
23.1.1.2 Major Hazards	780
23.1.2 Nonbeam Hazards	782
23.1.2.1 Electrical Hazards	783
23.1.2.2 Chemical Hazards	783
23.1.2.3 Environmental Hazards	783
23.1.2.4 Fire Hazards	784
23.1.2.5 Explosion Hazards and Compressed Gases	784
23.1.2.6 Other Hazards	784
23.2 Laser Classification	784
23.3 Preventing Laser Accidents	785
23.3.1 Laser Safety Officer	785
23.3.2 Engineering Controls	785
23.3.3 Administrative and Procedural Controls	786
23.3.4 Protective Equipment	786
23.3.4.1 Protective Eyewear	786
23.3.4.2 Other Protective Equipment	790
23.3.5 Warning Signs and Labels	792
23.4 Summary	793
References	794
Appendix 23A	795
Problem	795
<b>Overall List of Symbols</b>	<b>797</b>
<b>Index</b>	<b>803</b>