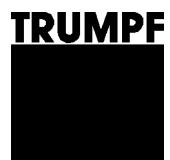


Procedure PR001597en_02

Replacing and cleaning cutting lens KL59

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1. Replacing and cleaning cutting lens KL59

Safety and description

Detailed descriptions of the product can be found in the associated procedures and in the operator's manual. These contain all of the information regarding the safe handling of the product.

Planning information

Service level	2
Number of service engineers needed	1
Estimated task time (hh:mm) (Without referenced procedures)	

Tab. 1

Modification log

Date (yyyy-mm-dd)	Reason for change	Version
2018-08-06	Video Fig. 94663 updated.	02
2018-06-28	Planning information changed.	01
2018-04-20	Operator's manual created.	00

Tab. 2

Conditions

- The power supply to the cutting unit is disconnected.
- Compressed air supply is switched off.
- The cutting unit and the area around it must be clean.
- The nitrogen supply must be open (i.e. the sealing gas must be active).
- The spare parts and additional equipment must be available.

Means, Tools, Materials

- Allen key set.
- Lens cleaning set.
- New lens.

Note

The following work can be performed with the cutting unit either removed or installed.

NOTICE

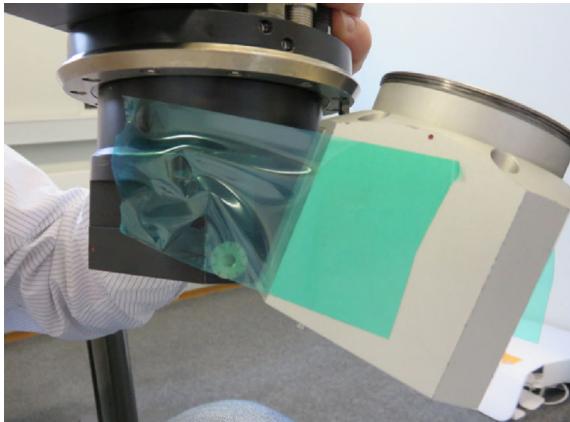
Contamination of the internal optics

Destruction of cutting unit.

- Pay attention to cleanliness in the work area.

Removing the cutting lens

1. Remove the cartridge and protect it, to ensure that it stays clean.
2. Remove four screws from the cutting head.



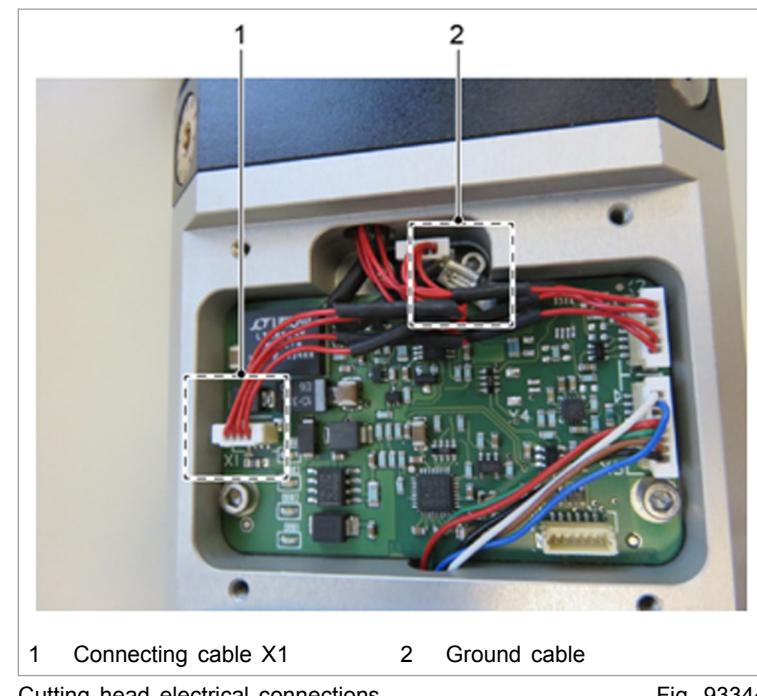
Left: Cutting head fixed with adhesive tape



Right: Cutting head cover

Fig. 93343

3. Either
 - Adhesive tape is used to fix the cutting head onto the cutting unit.
or
➤ Remove cover of cutting head.
➤ Disconnect the electrical connections ([see "Fig. 93344", pg. 4](#)).
➤ Undo the cutting head screws.
➤ Carefully feed the cable through.
➤ Remove the cutting head and protect it, to ensure that it stays clean.



1 Connecting cable X1 2 Ground cable

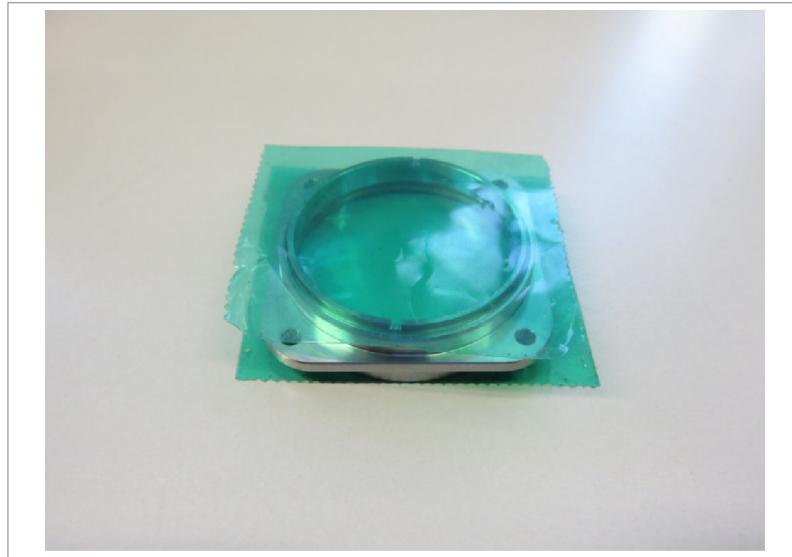
Cutting head electrical connections

Fig. 93344

Notes

- The following work must be done promptly.
 - Should the cutting lens be removed and cleaned, then green adhesive tape from the cleaning set must be used to keep the cutting unit clean.
4. Remove three screws from the lens adapter.
 5. Hold the cutting lens and then undo the fourth screw.
 6. Remove the cutting lens.

Installing the cutting lens

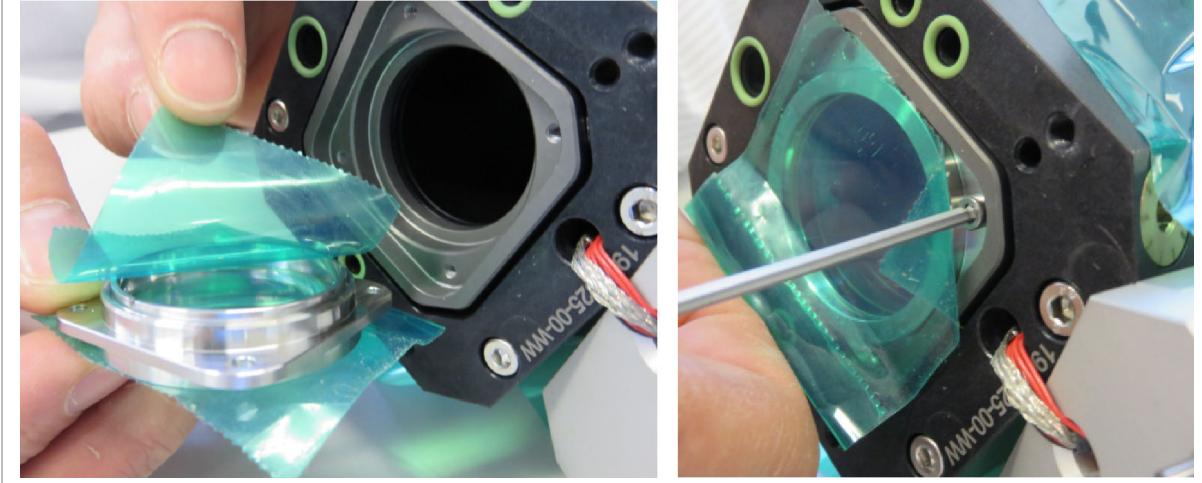


A new lens with its protective film

Fig. 83066

Note

When installing a new lens, only remove the adhesive tape shortly before the actual installation.



Installing the lens

Fig. 83067

7. Remove the protective film from the top of the cutting lens and install the lens.
8. Tighten the four screws for the lens uniformly (to a maximum torque of 1 Nm).

Note

After removing the film, or immediately after checking the lens, install the cutting head.

9. Remove the lower film and check that the lens is clean using the flashlight from the cleaning set.
10. Mounting the cutting head.

NOTICE**Damage to the protective glass possible.**

- Make sure that the protective glass does not collide with the housing of the cutting head.

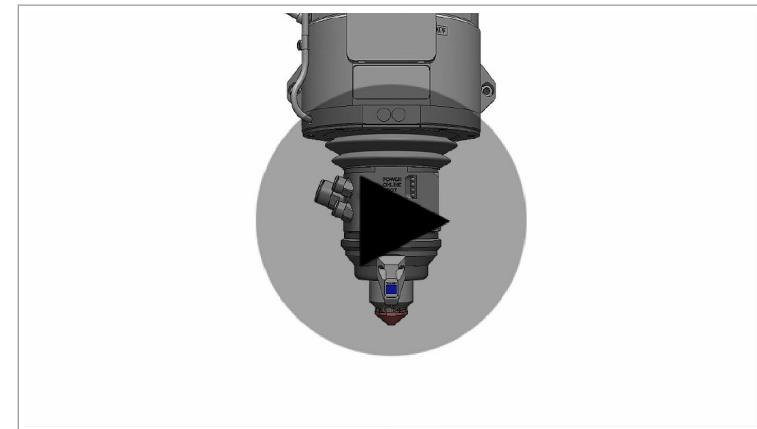


Fig. 94663

11. Check that the protective glass is clean and fit the cartridge.

Complete work

12. Create a spot image in accordance with cutting unit. See [PR001057en.pdf](#).
13. Perform a tapeshot.
14. Determine the focus position in service mode. See [PR001059en.pdf](#).
15. Carry out a variety of test cuts using the "Cutting_Tools.lst" utility program.