

Fiber Laser Training - ENSIS/LCG AJ

Day	Time	Topic	Contents
1st Day	9:00 ~ 9:15	Introduction	Introduction and Facility orientation
	9:15 ~10:45	Machine & Accessories	Machine explanation, Explanation of Accessories units, Chiller, Dust collector, Purge unit, and Air supply unit
		Break Time	
	11.00 ~12:15	Laser Safety rules	Measures for preventing laser beam hazards, Handling of optical parts
		Heath and Machine Safety	Inhale of Cutting gases, Medical devices failure, High voltage, Eye examination
		Machine Specification	Cutting Speed, Axis Speed, Retract of all axis, Options etc.
		Laser Basics	Brief info. on generation of Laser and Metal cutting Process
	12:15 ~13:00	Material Explanation	Material types of Mild steel, Stainless steel and Auminum
		Assist Gas types and effects	Types of assist gas and its effect on cutting quality.
		Lunch Time	
	14:00 ~ 15:00	Machine Ready	Machine start ON and 3i Control panel buttons explanation Lens and protection glass cleaning, nozzle inspection and Centering
	15:00 ~ 15:30	Sample Cutting	Sample cutting of Oxygen, Nitrogen and Air
		Break Time	
	15.45 ~ 16.30	Practice and Review	Practice of Lense cleaning, Nozzle Centering
	16.30 ~ 17:15		Sample Cutting and machine shutdown, Q & A
2nd Day	9:00 ~ 10:00	Review & Machine Ready	Repeat Make machine Ready procedure Lens Cleaning, Protection glass cleaning
	10:00 ~ 10:45	Types of lenses	190 lens and cutting condition file name explanation
		Types of Nozzles	Eco cut nozzles, clean cut and WACS nozzle
		Break Time	
	11:00 ~ 12 :15	3i Control Panel	AMNC 3i controller explanation, Utility Screen explanation, nozzle change , Focus Adjustment, HS sensing,
	12:15 ~ 13:00	Dimension correction	Dimension correction by Adjust offset
	13:00 ~ 14:00	Lunch Time	
	14:00 ~ 14:30	LST operation	Sheet Loading, shuttle Exchange in Auto and manual mode
	14.30 ~ 15.00	Cutting types	Clean cut, Oxygen cut and Air cut, Cutting Practice
		Break Time	
	15.45 ~ 16.30	Sample Cutting	Sample cutting demonstration and Accuracy check
	16.30 ~ 17:15	Cutting trials	Cutting Practice of various material. Q & A
3rd Day	9:00 ~ 9:30	Review & Machine Ready	Repeat Make machine Ready procedure Lens Cleaning, nozzle centering practise
	9: 30 ~ 11:00	Cut condition files	Cut condition files, Explanation for Oxygen, Nitrogen and Air cutting etc.
		Break Time	
	11 :15 ~ 13:00	Various cuttings	Eco cut, Clean cut, WACS cut, Oil shot
		Sample Cutting	Sample cutting Trial of Eco cut, Clean cut, oxygen cut.
	13:00 ~ 14:00	Lunch Time	
	14:00 ~ 15:30	3i Control Panel	Programme, Schedule, Pre-edit, Switch panel, nozzle changer unit Current Position Panel, Nozzle loading and Registration in
		Break Time	
	15:45~17:15	Cutting Parameter	Cutting parameter explanation and its adjustment Cutting trials Practice by changing Focus, Gas pressure and Speed , Q & A
4th Day	9:00 ~ 9:30	Review	Repeat Make machine Ready procedure
	9:30 ~ 10:45	M and G codes	M codes and G codes explanation and Multiparts Processing
		Break Time	
	11:00 ~ 13:00	Program run	How to modify the program if required and How to Run schedule
	13:00 ~ 14:00	Lunch Time	
	14:00 ~ 15:30	Periodic maintenance.	Periodic Maintenance, Q & A
		Break Time	
	15:45 ~ 17:15	Review, Laser Test and training feedback Test Paper Checking and Certificate Distribution	