High-Efficiency CO₂ LASER with Wide Usage

FANUC
LASER C series
Compact CO$_2$ LASER with High Reliability, High Performance and High Functionality

**FANUC LASER C series**

**C1000i-C/C2000i-C/C3000i-C/C4000i-C/C6000i-C**

FANUC LASER C series i-MODEL C is designed for Series 30i/31i-LB, which is compact, high-performance and highly-reliability carbon-dioxide LASER applicable to cut metallic and non-metallic materials. Newly, C3000i-C optimized for sheet metal cutting was added to the line-up.

**High Efficiency and Economy**

- Superior RF Discharge Excitation
  - High conversion efficiency
  - Stable LASER output
- High-Efficiency Turbo Blower
  - Compact with large blowing capacity by high speed rotation
  - Employment of FANUC Built-in Spindle Motor
- Power Saving Functions
  - Quick Power Saving state
  - Eco Power Saving state
- LASER Gas Saving Function

**Highly Reliable Design**

- RF Discharge Excitation with High Reliability and High Safety
  - All-solid-state LASER power supply
  - Compact and high efficiency by latest MOSFETs
- Easy Maintenance
  - Screen of maintenance information history
  - Power compensation coefficient, run hour/maintenance time of parts etc.
  - Automatic Leakage Check Function
  - Automatic Power Supply Adjustment Function
  - Support Function for Start-Up after Turbo Oil Exchange
- Conformity to Safety Standards
  - EC directive (CE Marking)
  - FDA (U.S.)

**Mach Perfor**

**Minimizing Downtime**

**Tuning for Dedicated**

- Tools for Dedicated Function
  - Nano CNC system
  - C Language Executor
  - Real-Time Custom Ma
  - Personal Computer Fu
- Customization
  - Cutting condition data
High-Speed High-Precision Cutting

- High-Speed Cutting Functions
  - High-Speed High-Precision Cutting Function
- High-Precision Cutting Functions
  - Edge Cutting Function
  - LASER Power Control Function
  - Enhancement of pulse frequency command range
- High-Efficient Cutting Functions
  - Cutting Condition Setting Function
  - Gap Control Function

Superior Control Functions

- Oscillator Control
  - Direct Oscillator Control by CNC
  - LASER Power Feedback Control
  - Minute LASER Output Control and Calibration Function
  - LASER Cutting Condition Control
  - Power Failure Restart Function
System Configuration

FANUC LASER C series is supplied together with FANUC CNC and servo motors, which makes it easy for customers to construct high-performance LASER cutting machines. FANUC LASER C series is compact, high-performance and high-reliability carbon-dioxide LASER. Five models — C1000i-C, C2000i-C, C3000i-C, C4000i-C, and C6000i-C — are available to tailor output to your processing needs. They are specifically developed to cut metallic and non-metallic materials. Pumped at 2MHz with RF discharge using all-solid-state LASER power supply, the LASER oscillator became compact, efficient, and stable. Moreover, the fast axial gas flow produces the optimum beam quality for the cutting process.

FANUC Series 30i/31i-LB realizes high-speed, high-precision LASER cutting with FANUC LASER C series.

FANUC AC SERVO MOTOR αi series, which is the most widely used in the world, also improves stable process together with the most advanced digital servo controlling technology.

System Configuration
High Efficiency and Economy

Superior RF Discharge Excitation and High-Efficiency Turbo Blower

Using RF discharge excitation has brought about improved oscillation efficiency as well as output power stability. It also produces safety of operation due to low discharge voltage and high reliability due to non-contamination of LASER gas which is possible only by adopting the external electrode structure as in FANUC LASER C series. The RF discharge excitation, stable and uniform one by nature, produces excellent pulsing characteristics. The transistorization using high power MOSFET, the first achievement at this power level, has also improved reliability.

![Diagram of LASER excitation and blower](image)

FANUC LASER C series are equipped with high speed rotation Turbo Blower to achieve fast LASER gas circulation. Turbo blower design is optimized by use of FANUC Built-in Spindle Motor. Precise tuning of rotator and strict inspections enabled high speed rotation, and thus realizing the light weight, compact and large capacity Turbo Blower.

Power Saving Functions

During LASER idle time, such as exchanging works, designing layout, and press processing on turret punch press machine, electric power consumption becomes lower by moving into the power saving states, in which LASER power supplies and turbo blowers of LASER oscillator are controlled in power saving conditions.

Two power saving states are available. One is Eco Power Saving state, in which electric power consumption is dramatically saved and the other is Quick Power Saving state, in which LASER cutting can be restarted quickly. Therefore, according to the customers’ choices, electric power consumption will be saved with these power saving functions. Assuming a cutting ratio of 50%, the effect of the power saving is about 20% with Power Saving Functions.
Superior Control Functions

Direct Oscillator Control by CNC

A CNC unit can be connected directly to control the LASER oscillator. The CNC unit constantly checks the status of the LASER oscillator during operation from startup to termination and automatically keeps the oscillator ready with the optimum operating conditions. The CNC unit also automatically controls other parameters that affect beam output, such as LASER gas pressure.

In i-model C, the enhancement of oscillator control sequence enabled to reduce the start-up time and shut down time of oscillator by half to the conventional model. i-model C will contribute to increase the utilization rates of the LASER cutting machine.

Power Failure Restart Function

In case that power failure is detected, CNC stores the operating status of the LASER oscillator. After power recovers, CNC analyses the optimal restart sequence for the LASER oscillator to realize the minimum time restart, according to the operating status just before the power failure occurs. In addition, by using this function together with UPS and retry processing function, it is possible to minimize the downtime caused by power failure, realizing high utilization ratio of LASER machine.

Power Consumption Monitor

CNC always monitors the condition of the LASER oscillator, and outputs estimated power consumption value. Using this power consumption value, the LASER machine can display the total power consumption and the utilization rate of the LASER machine, which will support the users to reduce the power consumption by their programming.

Minute LASER Output Control and Calibration Function

Stable minute LASER output, which is needed for LASER marking, is achieved with enhanced control of LASER power supplies.

In addition, Calibration Function for minute LASER output realizes stable LASER marking process over long periods, not to be affected by change of oscillator condition or exchange of mirrors.

LASER Cutting Condition Control

Full automatic process is provided by programming, including automatic shutter open/close, output beam on/off, assist gas start /stop, output power, and pulse output (frequency and duty).

In addition, the commanded LASER output value, pulse frequency, pulse duty and actual output power value are displayed on the CNC screen.
High-Speed High-Precision Cutting

LASER Power Control Function

LASER output conditions (Peak power, Pulse Frequency, Pulse duty) are weighed corresponding to feed-rate commanded in a part program. Uniform cutting result can be obtained by controlling power, frequency and duty at acceleration and deceleration caused by machine axes. Power control conditions can be switched in 2 stages according to feed-rate. LASER output conditions can be clamped by upper and lower limits. Furthermore, power control conditions can be set separately for acceleration and deceleration.

High-Speed High-Precision Cutting Function

Extreme high-precision synchronization between axis command and beam on/off command is realized. In high speed cutting, deviation between cutting head position and beam on/off command increases. The function minimizes the deviation sufficiently smaller than the beam spot size.

Enhancement of Pulse Frequency

The maximum command frequency of LASER power has been enhanced from 2,000Hz to 32,767Hz. Enhancement of pulse frequency is effective in the improvement of the cut edge quality and decreasing dross.

Edge Cutting Function

On detection of sharp angles in the cut path, automatic acceleration/deceleration is performed with appropriate cutting condition, thus enabling sharp-edge cutting.
Tuning for Dedicated System

Nano CNC System

High-precision cutting Achieved by Coordination between “High-Precision Operation in Nanometers” and “State-of-the-Art Servo Technology” Nano interpolation that computes position commands for the digital servo control unit in nanometers, SERVO HRV Control and SPINDLE HRV Control for which the control cycle is made faster, and FANUC AC SERVO MOTOR ai series with a high-resolution pulse coder are used as standard and make up “Nano CNC System,” which achieves high-speed, high-precision cutting.

C Language Executor

Machine tool builders can create their own operation screens.
- C language is used ANSI functions and CNC and PMC functions for programming.
- High-level tasks to which high execution priority is assigned can monitor signal.

Real-Time Custom Macro

Signals and peripheral axes can be controlled from machining programs.
- A macro statement can be executed in real time in synchronization with a machining program.
- Signals can be input and output by using DI/DO variables.
- Operation that the signal status is used as a trigger can simply be created.
- Macro variables can dynamically be read and written.
- Operation that position information of a system variable is used as a trigger can be created.
- Multiple real-time macro statements can be executed concurrently.
- Peripheral axis control can be written in the same program during machining.

Personal Computer Function

The best combination between a CNC and personal computer is realized by transferring bulk data via an original high-speed interface. Unique dedicated applications can be realized easily by personal computer function, and the machine tools can meet special needs for machine tool customers.

Feature

Various commercially application software and hardware are available

Application

Best fit for flexibility with computer applications, such as tool file management by utilizing database

OS

Windows® Embedded Standard 2009
Windows® Embedded Standard 7
Highly Reliable Design

High Reliability
The thermal deformation of the resonator is suppressed by using low thermal expansion material. The indirect cooling structure exhibits excellent corrosion resistance. The ceramic coating and external electrode structure are adopted to the discharge tubes, in order to protect them mechanically and to decrease the contamination into the LASER gas. The LASER power supply is all-solid-state type using the latest MOSFETs. All these factors contribute to the high reliability.

Easy Maintenance
The history of power compensation coefficient, current/voltage of LASER power supplies, status of LASER, and run hour/maintenance time of fundamental parts are displayed on the CNC screen. The Automatic Leakage Check Function exhausts the resonator chamber to vacuum and displays the change of inside pressure over time. The Automatic Power Supply Adjustment Function automates the adjustment after replacement of LASER power supplies. After the LASER is turned on, decrease of output power is always monitored. When it exceeds a certain preset level, a warning is displayed on the CNC screen to urge mirror cleaning. In addition, newest techniques such as the oil mist decomposition element, dust collection unit and so on, have reduced the frequency of mirror cleaning interval and the high-precision-machined mirror stage has simplified mirror adjustment.

High Safety
FANUC LASER C series products comply with the EC directive (CE Marking) and U.S. standards (FDA) under the LASER radiation control for health and safety that apply to manufactures of LASER products. Warning labels and certification label such as the ones shown down side are affixed permanently on each LASER product. Using RF discharge excitation produces safety of operation due to low discharge voltage and skin effect by RF current.
Utility Plan for the Object

Corresponding to the cutting materials and thicknesses, LASER models can be selected to achieve the best cutting performance. (Cutting performance of the LASER machine might be limited depending on its configuration.)

<table>
<thead>
<tr>
<th></th>
<th>Mild steel</th>
<th>Stainless steel</th>
<th>Aluminum</th>
</tr>
</thead>
<tbody>
<tr>
<td>C1000i-C</td>
<td>800mm/min 9mmthk</td>
<td>1200mm/min 3mmthk</td>
<td>1600mm/min 2mmthk</td>
</tr>
<tr>
<td></td>
<td>1600mm/min 4.5mmthk</td>
<td>2600mm/min 2mmthk</td>
<td>4000mm/min 1mmthk</td>
</tr>
<tr>
<td>C2000i-C</td>
<td>550mm/min 22mmthk</td>
<td>500mm/min 10mmthk</td>
<td>600mm/min 6mmthk</td>
</tr>
<tr>
<td></td>
<td>2400mm/min 6mmthk</td>
<td>1000mm/min 6mmthk</td>
<td>2000mm/min 3mmthk</td>
</tr>
<tr>
<td>C3000i-C</td>
<td>700mm/min 19mmthk</td>
<td>900mm/min 10mmthk</td>
<td>1800mm/min 4mmthk</td>
</tr>
<tr>
<td></td>
<td>3000mm/min 6mmthk</td>
<td>2000mm/min 6mmthk</td>
<td>12000mm/min 1mmthk</td>
</tr>
<tr>
<td></td>
<td>10000mm/min 1mmthk</td>
<td>9600mm/min 1mmthk</td>
<td></td>
</tr>
<tr>
<td>C4000i-C</td>
<td>550mm/min 28mmthk</td>
<td>800mm/min 12mmthk</td>
<td>2000mm/min 6mmthk</td>
</tr>
<tr>
<td></td>
<td>3000mm/min 6mmthk</td>
<td>1800mm/min 6mmthk</td>
<td>3000mm/min 4mmthk</td>
</tr>
<tr>
<td>C6000i-C</td>
<td>550mm/min 32mmthk</td>
<td>600mm/min 16mmthk</td>
<td>1200mm/min 10mmthk</td>
</tr>
<tr>
<td></td>
<td>2400mm/min 12mmthk</td>
<td>1200mm/min 12mmthk</td>
<td>2600mm/min 6mmthk</td>
</tr>
</tbody>
</table>
### Specifications

#### Standard specification of LASER oscillator

<table>
<thead>
<tr>
<th>Items</th>
<th>Contents</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Model</strong></td>
<td><strong>C1000i-C</strong> <strong>C2000i-C</strong> <strong>C3000i-C</strong> <strong>C4000i-C</strong> <strong>C6000i-C</strong></td>
</tr>
<tr>
<td>Optical path length</td>
<td>Short</td>
</tr>
<tr>
<td>System principle</td>
<td>RF discharge excitation fast axial gas flow</td>
</tr>
<tr>
<td>Structure</td>
<td>Integrated type (Note 1) (oscillator and power supply)</td>
</tr>
<tr>
<td>LASER rated output (W)</td>
<td>1000</td>
</tr>
<tr>
<td>LASER maximum output (W)</td>
<td>1000</td>
</tr>
<tr>
<td>Maximum pulse power command (W)</td>
<td>1000</td>
</tr>
<tr>
<td>Output stability</td>
<td>±1% (Note 3)</td>
</tr>
<tr>
<td>LASER wavelength</td>
<td>10.6µm</td>
</tr>
<tr>
<td>Beam mode</td>
<td>Low order mode</td>
</tr>
<tr>
<td>Beam diameter at exit (mm)</td>
<td>&lt;φ20</td>
</tr>
<tr>
<td>Polarization</td>
<td>45° linear</td>
</tr>
<tr>
<td>Beam divergence angle (full angle)</td>
<td>2mrad or less</td>
</tr>
<tr>
<td>Pulse frequency</td>
<td>5 to 5000Hz</td>
</tr>
<tr>
<td>Pulse duty</td>
<td>0 to 100%</td>
</tr>
<tr>
<td>LASER gas (Note 4)</td>
<td>Gas A</td>
</tr>
<tr>
<td>Gas consumption rate (L/Hr)</td>
<td>Approx. 10</td>
</tr>
<tr>
<td><strong>Cooling water</strong></td>
<td>Water rate (L/min)</td>
</tr>
<tr>
<td></td>
<td>Circulated water pressure</td>
</tr>
<tr>
<td></td>
<td>Water temperature/ Water temperature stability</td>
</tr>
<tr>
<td></td>
<td>Recommended cooling capacity (kW)</td>
</tr>
<tr>
<td><strong>Input power supply</strong></td>
<td>AC200V+10%、-15% 50/60Hz±1Hz or AC220V+10%、-15% 60Hz±1Hz or AC230V+5%、-10% 60Hz±1Hz</td>
</tr>
<tr>
<td>Power supply capacity (kVA)</td>
<td>18</td>
</tr>
<tr>
<td>Mass (kg)</td>
<td>350</td>
</tr>
</tbody>
</table>

**Note 1)** In C1000i-C, the vacuum pump is placed outside of the main unit.
**Note 2)** Within limited pulse duty
**Note 3)** At rated power with LASER power feedback during 8 hours.
**Note 4)** Gas A /Premixed gas of CO₂:N₂:He (volume ratio, N₂ balance) 5:55:40% ±5% or less for each composition
Gas B /Premixed gas of CO₂:N₂:He (volume ratio, He balance) 5:35:60% ±5% or less for each composition
Maintenance and Customer Support

Worldwide Customer Service and Support

FANUC operates customer service and support network worldwide through subsidiaries and affiliates. FANUC provides the highest quality service with the prompt response at any location nearest you.

World Wide Support Over 230 Offices

FANUC Training Center

FANUC Training Center operates training courses for daily, periodic, and preventive maintenance including mirror cleaning procedure of CO₂ LASER oscillator.

Inquiries: Yamanakako-mura, Yamanashi, Japan 401-0501
Phone: 81-555-84-6030
Fax: 81-555-84-6540

FANUC CORPORATION

FANUC America Corporation
1800 Lakewood Boulevard,
Hoffman Estates, Illinois 60192, U.S.A
http://www.fanucamerica.com/

FANUC Europe Corporation S.A.
Zone Industrielle, L-6488 Echternach,
Grand-Duché de Luxembourg
http://www.fanuc.eu/

BEIJING-FANUC Mechatronics CO., LTD
No.9 Xinhai Road, Shangdi Information Industry Base,
Haidian District, Beijing CHINA 100085
http://www.bj-fanuc.com.cn/

KOREA FANUC CORPORATION
101, Wanam-ro(st), Seongsan-gu, Changwon-si,
Gyeongsangnam-do, 642-290 Republic of Korea
http://www.fkc.co.kr/

TAIWAN FANUC CORPORATION
No.10, 16th Road, Taichung Industrial Park, Taichung, Taiwan
http://www.fanuctaiwan.com.tw/

FANUC INDIA PRIVATE LIMITED
41-A, Electronics City, Bangalore, 560 100, India
http://www.fanucindia.com/

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