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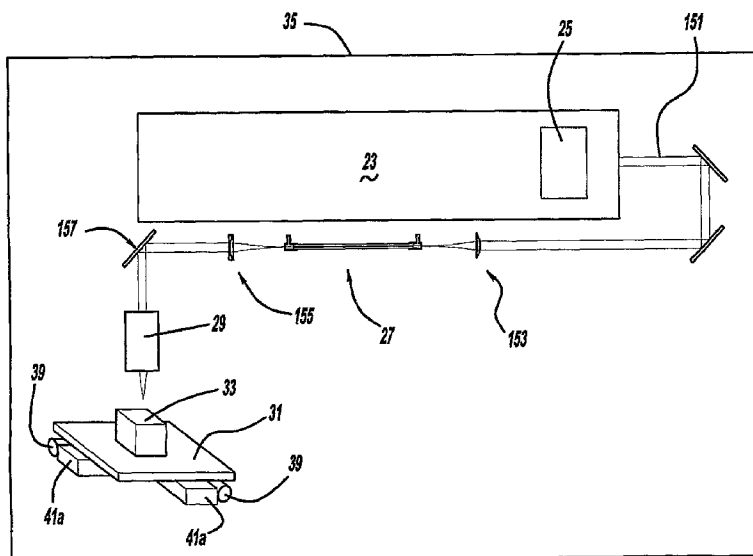
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(54) Title: LASER MATERIAL PROCESSING SYSTEM



(57) Abstract: A laser material processing system and method are provided. A further aspect of the present invention employs a laser for micromachining. In another aspect of the present invention, the system uses a hollow waveguide. In another aspect of the present invention, a laser beam pulse is given broad bandwidth for workpiece modification.

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LASER MATERIAL PROCESSING SYSTEM

CROSS REFERENCE TO RELATED APPLICATION

[0001] This application claims priority to U.S. provisional patent application serial number 60/790,695, filed on April 10, 2006, which is incorporated by reference herein.

STATEMENT OF GOVERNMENT INTEREST

5 **[0002]** A portion of this invention was made with Government support under Contract No. DE-FG02-01ER15143 awarded by the Department of Energy. The Government may have certain rights in this invention.

BACKGROUND AND SUMMARY OF THE INVENTION

10 **[0003]** The present invention generally relates to a material processing system and more particularly to micromachining with a laser.

[0004] It is known to employ femtosecond lasers for micromachining. The use of these ultrafast lasers has significantly improved the machining efficiency by quickly removing the workpiece material due to the instantaneous increase of the material temperature into a plasma regime. Furthermore, ionization of the material reduces splatter and debris during operation. An exemplary conventional device using a 50-200 femtosecond laser for micromachining is disclosed in U.S. Patent No. 6,979,798 entitled "Laser System and Method for Material Processing with Ultra Fast Lasers" which issued to Gu et al. on December 27, 2005, and is incorporated by reference herein. It is noteworthy, however, that a leading publication, P. Bado et al., *Micromachining Handbook*, Clark-MXR, Inc., version 2.3, chapter 14 (2001), discusses that there are "Shortcomings of Femtosecond Lasers" for conventional machining "because the rate of removal of material is dependent on average power, thruput is low. The technology that makes these ultrafast laser pulses does not produce high average power. Additionally, the technology is VERY expensive...."

25 **[0005]** Furthermore, conventional nanosecond laser induced breakdown spectroscopy suffers some limitations due to inefficient coupling of

the laser pulse energy into a sample. The laser creates a plasma, which couples with the bulk (electron-phonon coupling) and supplies the energy for melting, followed by evaporation and excitation of the gas phase atoms. The inefficient coupling requires high energies per pulse, typically in the 10-100 mJ/pulse
5 range, and leaves a scar caused by melting.

[0006] In accordance with the present invention, a laser material processing system and method are provided. A further aspect of the present invention employs a laser for micromachining. In another aspect of the present invention, the system uses a hollow waveguide. In yet another aspect of the
10 present invention, a laser beam pulse is given broad bandwidth for workpiece modification. A further aspect of the present invention allows a single laser beam to simultaneously operate in multiple machining workstations and/or to machine multiple holes in the same workpiece. Additionally, a system includes a laser, pulse shaper and compensation device, and control system, with another
15 aspect of the present invention. In a further aspect of the present invention, a system employs Multiphoton Intrapulse Interference Phase Scan to improve laser pulse performance. A method of operating a laser for micromachining is also provided.

[0007] The present invention is advantageous over conventional
20 constructions since the equipment or the processing throughput used in the system of the present invention is significantly less expensive than traditional equipment. Furthermore, multiple workstations can be simultaneously powered by a single laser, thereby reducing the laser expense per workpiece. The novel waveguide of the present invention system also beneficially increases ps or fs
25 pulse bandwidth so a less expensive, longer pulse lasers can be employed while improving micromachining efficiency. For another exemplary advantage, an inexpensive picosecond laser of the present invention, directly pumped by a flash lamp, is employed in some variations instead of considerably more expensive conventional femtosecond lasers, pumped by green laser sources;
30 nevertheless, the present invention system provides the functional advantages of femtosecond ablation of the workpiece, in part, due to enhancing the laser pulse bandwidth instead of reducing the pulse duration. Multiphoton Intrapulse

Interference Phase Scan and binary pulse shaping are further beneficial in accurately and inexpensively controlling ps or fs laser pulses for micromachining. The present invention advantageously uses laser induced breakdown spectroscopy with shaped pulses and/or MIIPS optimization, and with or without
5 chirped pulses, for feedback and closed loop control of micromachining; the LIBS signal can provide an atomic signature of each workpiece layer when stacked so as to provide sensed feedback when each layer is completely penetrated whereby the controller automatically varies the process accordingly. Additional advantages and features of the present invention will become
10 apparent from the following description and appended claims, taken in conjunction with the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

- [0008] Figure 1 is a perspective view showing a first preferred embodiment of a laser material processing system of the present invention;
- 15 [0009] Figure 2 is a diagrammatic view showing the first preferred embodiment laser material processing system of the present invention;
- [0010] Figure 3 is a diagrammatic view showing the first preferred embodiment of a pulse shaping portion employed with the laser material processing system of the present invention;
- 20 [0011] Figure 4 is a diagrammatic view showing the first preferred embodiment laser material processing system;
- [0012] Figure 5 is an enlarged diagrammatic view showing a portion of the first preferred embodiment laser material processing system of Figure 4;
- [0013] Figure 6 is an enlarged diagrammatic view showing a portion of
25 the first preferred embodiment laser material processing system of Figure 6;
- [0014] Figure 7 is a graph showing expected data of the first preferred embodiment laser material processing system;
- [0015] Figure 8 is a diagrammatic view showing a second preferred embodiment laser material processing system;
- 30 [0016] Figure 9 is a diagrammatic view showing a third preferred embodiment laser material processing system;

[0017] Figure 10 is a diagrammatic view showing the third preferred embodiment laser material processing system;

[0018] Figure 11 is a true view showing a workpiece machined by the third preferred embodiment laser material processing system;

5 [0019] Figure 12 is a diagrammatic view showing a fourth preferred embodiment laser material processing system;

[0020] Figure 13 is a diagrammatic true view of a lens array employed in the fourth preferred embodiment laser material processing system; and

[0021] Figure 14 is a diagrammatic electrical diagram showing a fifth preferred embodiment laser material processing system.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0022] A first preferred embodiment of a laser material processing system 21 of the present invention is generally shown in Figures 1 and 2. System 21 includes a femtosecond laser 23, a pulse shaping and optimization system 25, a waveguide 27, an objective 29, a moveable table or workpiece-support 31, and a workpiece 33, inside a housing or cabinet 35 with an openable door 37. Table 31 is automatically moveable in at least X and Y directions, and optionally in an additional Z and/or rotational direction, by linear slides 41a and connected electric motors 39, controlled by a programmable, microprocessor-based computer controller 41. The present invention system is used for micromachining the workpiece, including drilling holes, cutting slots, polishing and the like.

25 Pulse Shaping and Optimization

[0023] Referring to Figures 3 and 4, pulse shaping and optimization system 25 includes an upstream grating 43, an upstream concave mirror 45, a spatial light modulator 47, a downstream concave mirror 49, a downstream grating 51, a detection device 53, and personal computer 41. More specifically, detection device 53 is a spectrometer. Bursts or pulses of a laser beam 55 are emitted from laser 23, through the optics 43, 45, 49 and 51, as well as through the spatial light modulator 47 for detection and sensing by spectrometer 53 for

further evaluation, analysis, comparison and subsequent control by computer controller 41. The laser is preferably either: (a) a 150 femtosecond laser which can be obtained from Clark-MXR, model CPA 2000; (b) a 500 femtosecond, Ytterbium tungstate (Yb:KGW) laser which can be obtained from Spectra
5 Physics as the Eclipse model; (c) a 110 femtosecond laser which can be obtained from Coherent as the Libra model; (d) the Coherent Legend USP-Elite system, which produces a 3.3 mJ/pulse 26 fs in duration; or (e) an IMRA microJewel FCPA D-400 system, using a Yb-Fiber amplifier. The heart of pulse shaper 29 is automatically moveable flat mirrors or a programmable special light
10 modulator (hereinafter "SLM") that is placed at the Fourier plane. For the applications envisioned herein, the mask must be capable of shifting the phase of individual frequencies. For alternate pulse shapers, a different electronically programmable mask that is capable of controlling phase can be employed such as: a liquid crystal display (hereinafter "LCD"), an acousto-optic modulator
15 (hereinafter "AOM"), a deformable mirror, and a permanently deformed mirror.

[0024] The phase and amplitude masks of the pulse shaper are controlled by the controller wherein the laser pulse shape takes a dynamic role. The microprocessor within controller 41 will then control laser 23, receive an essentially real time feedback input signal from spectrometer 53, and then
20 perform calculations, comparisons and evaluations, and possibly automatic variation of subsequent pulse shapes. Alternately, these automated steps can be substituted with manual user calculations and decisions if desired based on computer outputs.

[0025] Preferably, the phase between photons of different frequencies
25 takes only two values preferably 0 or preferably π to maximize or minimize a given pathway. Any two values whose difference is π work equivalently well. The method is defined as binary phase shaping (hereinafter "BPS"). BPS is used to solve the problem of selective multiphoton excitation with ultrashort laser pulses. The spectral phase of the pulse is tailored using a computer-controlled
30 pulse shaper. The spectral phase of each pulse is corrected using a Multiphoton Intrapulse Interference Phase-Scan (hereinafter "MIIPS") method, which compensates phase distortions to obtain transform-limited (hereinafter "TL")

pulses. The binary phase is introduced as an addition to the compensation phase. The shaped laser pulses, with energy ~ 0.5 nJ per pulse and 87 MHz repetition rate, are focused mildly, to a spot size of ~ 100 microns in diameter, on a 20 micron thin beta barium borate (β BBO) type I SHG crystal. The frequency-doubled light is collected with an optical fiber and dispersed on a compact spectrometer, preferably obtainable from Ocean Optics.

[0026] A preferred MIIPS process for micromachining includes: (1) surface second harmonic emission from the substrate being machined is collected by the spectrometer and its dependence on a number of calibrated phases is used by the programmable computer controller to measure the phase distortions on the pulse; (2) the distortions are then automatically removed by the pulse shaper pursuant to determinations and control of the controller; and thereafter, (3) the pulse shaper automatically introduces a new phase that optimizes the machining process pursuant to determinations and control of the controller. In this MIIPS process, the SHG is obtained from the surface of the workpiece substrate itself, such that a SHG crystal is preferably no longer needed (although use of a SHG crystal still falls within the scope of the present invention, albeit, in a less desired construction). Also note that in some cases a spectrometer may not be needed for MIIPS.

[0027] Multiphoton Intrapulse Interference Phase Scan is capable of both pulse characterization and compensation of subsequent pulses. Within minutes, the pulses are characterized and compensated to yield transform-limited (TL) or user-specified shaped pulses at the substrate being machined. Once the MIIPS system has characterized the pulse and retrieved the phase distortions inherent to the pulses, it can use that information to drive the SLM such that it compensates for the distortions. The first step in compensation is to take the phase determined from the first scan and program it into the SLM with a negative sign so that it subtracts the distortions. The system carries out a new phase scan to determine the remaining spectral phase modulation (usually about 10% of the original). Typically, three such iterations will yield transform-limited pulses. Because the laser is not focused in the pulse shaper, the method can be used with pulses that are relatively high in energy.

[0028] The version of MIIPS illustrated in Figure 4 uses a thin SHG crystal 79, spectrometer 53, a dispersing prism or grating 81, a collimating lens 83, spatial light modulator 47 and the femtosecond laser 23. System 25 further has a redirecting mirror 101, and two quartz cylindrical lenses 103 (200 mm focal length, the upstream one for focusing and the downstream one for collimating). The spatial light modulator has two 128 LCD elements (which can be obtained from CRI Inc. as model number SLM-256). In a variation, self-ultrafast switching can be employed based on pulse phase modulation in the pulse shaper, with the thin SHG crystal causing multiphoton intrapulse interference, and using dispersive optics and a CCD camera detector. The simplicity and accuracy of this method make it practical for the evaluation of laser pulses close to transform limited and for the evaluation of phase distortion from optical elements.

[0029] Another variation of MIIPS used in the present invention system enhances the ultra-fast laser output by placement of a MIIPS box or unit upstream of an amplifier's output. For example, a separate MIIPS unit is placed directly between an ultra-short, femtosecond oscillator and an ultra-short amplifier. The present invention accurately measures output phase distortions using the MIIPS method which then employs the programmable, computer software to correct the distortions at the pulse shaper in the MIIPS box or by directly moving optics such as an amplifier's compressor and/or stretcher gratings. Furthermore, the output is optimized and detected at the downstream, output side of the amplifier or, alternately, at a more distant downstream location such as at the specimen or workpiece using second harmonic emission and detection with wireless communication and the computer controller. The upstream placement of the MIIPS unit is ideally suited for use with the Legend-
USP brand laser, which can be obtained from Coherent, Inc. An electronically integrated system interface includes a MIIPS unit with motorized micrometer actuators that translate gratings and/or mirrors to compensate for changes in the output wavelength of the laser. The actuators are automatically driven by energization signals from the computer controller, in a real-time, closed loop manner based on comparisons of the detected signals from the spectrometer and desired value calculations. When the workpiece is observed through a

microscope objective, MIIPS can compensate for the GVD introduced by specific microscope objectives at the specific wavelength of emission of the tunable laser source. It is also envisioned that the MIIPS unit can be located downstream or after the waveguide, and the MIIPS detection occurs after the microscope objective. Further details of MIIPS and binary pulse shaping can be found in
5 U.S. Patent Application Serial No. 11/177,940, filed on July 8, 2005, invented by M. Dantus et al. and entitled "Control System and Apparatus for use with Ultra-Fast Laser," which is incorporated by reference herein.

10 Laser Micromachining

[0030] Figures 2, 5 and 6 illustrate the preferred material processing system 21 in greater detail. After femtosecond laser source 23 has emitted a series of pulse shaped and optimized laser beam pulses 151, a focusing lens 153 acts to focus each pulse, waveguide 27 serves to increase the bandwidth of
15 each pulse and a subsequent collimating lens 155 acts to collimate each pulse output from waveguide 27. A reflective, microscope objective optical member 29 thereafter focuses and directs each pulse at workpiece 33. Focusing lens 153 can alternately be a curved mirror and while collimating lens 155 is preferably an achromatic lens, it can alternately be a curved mirror as well. Flat mirrors 157
20 are employed to direct and deliver each pulse from laser 23 to objective 29. It is preferred that the workpiece be movable and the laser objective be stationary, however, it is alternately envisioned that objective 29 and various optic members in the pulse path can be mounted to a movable arm with a periscope-type arrangement or other movable transmission and driving actuators in order to
25 affect objective movement relative to a stationary workpiece during processing. Furthermore, one suitable objective 29 can be obtained from the Spectra-Physics division of Newport Corporation, model 50105 or 50102, which is an achromatic, long working distance objective having a wide spectral band.

[0031] Waveguide 27 is generally of the type disclosed in U.S. Patent
30 No. 5,956,173 entitled "Capillary Compressor" which issued to Svelto et al. on September 21, 1999, and is incorporated by reference herein, and N. Nisoli et al., "Generation of high energy 10 fs pulses by a new pulse compression

technique," *Appl. Phys. Lett.* 68 (20), at 2793 (May 13, 1996). Waveguide 27 includes a hollow heavy wall, glass capillary tube 181 which is elongated in a circular-cylindrical shape and filled with an Argon gas to about 100 Torr. In contrast to expensive conventional hollow waveguides, however, the present invention waveguide employs glass caps which are fused directly onto each end of tube 181 after a vacuum is drawn and tube 181 is gas filled. The vacuum is drawn and gas subsequently filled through a T-leg in one cap which is then plugged. The internal passageway within tube 181 of waveguide 27 is preferably smooth and straight from one end to the other. The caps and tube are preferably quartz or glass, and an anti-reflective coating is applied to the caps before fusing. An ultrasonic machine or the like is used to fuse the open section of each cap 183 onto the corresponding end of tube 181 without optically distorting the pulse path through either. Therefore, the direct cap fusing to the tube creates a secure seal with minimal processing and components. Hollow waveguide 27 operably broadens the bandwidth of the laser beam pulse, preferably at least 20 nm and more preferably greater than 30 nm. The use of this large bandwidth is ideally suited for use with 100-500 fs pulses (entering waveguide 27) applied to metal micromachining, and with 10-50 fs TL pulses for nonmetal materials such as glass, polymeric and dielectric workpieces.

[0032] A second preferred embodiment laser material processing system 201 is shown in Figure 8. System 208 is essentially like that described with regard to the first preferred embodiment except that a workpiece supporting table 203 and a workpiece 205 are submerged within a liquid solution 207 in a holding tank 209. Solution 207 is water or machining oil which is circulated past workpiece 205 to remove debris by a pump, filter and piping system (not shown). Oil is ideally suited for index matching between the objective and workpiece. Solution 207 beneficially provides a self-focusing performance that is expected to achieve smaller micromachining hole sizes, in the order of 500 nm or less, due to the index of refraction of the solution. Pulse shaping and MIIPS are additionally used to compensate for pulse dispersion in solution 207.

[0033] Figure 9 shows a third preferred embodiment laser material processing system 221. This exemplary embodiment system 221 can be

employed with either of the prior embodiments. A silicon photo (pin) diode 223 is directly or indirectly (with mirror optics) positioned on an opposite side of a workpiece 225 as compared to pulse 227 emitted from laser 23 and directed through an objective. Diode 223 operably senses and detects pulse 227 when
5 the pulse has completely cut its way through workpiece 225. Diode 223 is connected to computer controller 41 (see Figure 3) which automatically determines the next subsequent desired workpiece-to-pulse placement and automatically moves either the objective or supporting table accordingly, or stops subsequent pulse transmission. This allows for inexpensive and highly accurate,
10 closed loop and real-time feedback control of the laser material processing system.

[0034] Reference should now be made to Figures 10 and 11. A third preferred embodiment laser material processing system 251 employs two or more micromachining workstations 253, 255, 257 and 259 all coupled to a single
15 micromachining laser 23 which emits a set of shaped and compensated laser beam pulses 261. Each pulse is split into multiple subpulses 263, 265, 267 and 269 by one or more splitting optic members 271, 273, 275 and 277 associated with each workstation. The pulse shaping, compensation, waveguide, sensing and controller components of any of the prior embodiments can be also used
20 with the present exemplary embodiment. A focusing objective 281 and/or integrated lens array are employed to direct and focus the pulse upon each workpiece 283 for each workstation. A movable table 285 supports workpiece 283 in each workstation. Additionally, an optional shutter 287 is provided for each workstation to block and prevent a subpulse from being emitted from
25 objective 281, for example if only two of the workpieces are to be machined in the four shown workstations. It is envisioned that up to ten different workstations can be simultaneously used from the single micromachining laser 23.

[0035] Figure 11 shows workpiece 283 which has an orientation reference datum or feature 291. Feature 291 is a series of concentric rings or
30 circles 293, with five shown in the present exemplary embodiment. Rings 293 are preferably created on workpiece 283 before the micromachining, by use of photoetching or evaporating resist processing. A CCD camera 244 (see Figure

1) or other computer controlled, or alternately manually controlled, scanning device coupled to optic 281 (see Figure 10) is used to find the X and Y center of feature 291 to generate a confocal feedback signal for each workpiece. Based on this signal, the workpiece supporting tables or objective can be automatically or manually moved to their correct initialized starting position for subsequent micromachining.

[0036] Referring to Figures 12 and 13, a fourth preferred embodiment laser material processing system 301 has a laser 23, pulse shaper and compensation device, waveguide, sensor and controller like any of the prior embodiments herein. However, a telescope optic, such as a concave mirror or negative lens 303 disperses each laser beam pulse 305 onto a positive collimating lens 307. The collimated pulse is directed to an integrated lens array 309, preferably a two-dimensional SLM phase mask such as the hexagonal array model from Meadowlark Optics Corp. or that sold by Isuzu Glass Corp. or X7500-6510M from Hamamatsu Corp. Fourier optimized masks in the two-dimensional shaper optimize the outcome, such that it can improve the resolution and make patterned holes such as a square or other polygonal shaped hole, by way of example and not limitation. Lens array optic 309 allows each laser beam pulse to create multiple holes or other complex patterns into a single corresponding workpiece 311. This advantageously allows the equipment of the present invention system to be considerably less expensive (on an equipment per emitted beam/machining hole basis) than would otherwise be required while also significantly increasing workpiece processing throughput. The two-dimensional SLM can be used to cause one or more focal spots on the substrate. These focal points need not be static. They can be moved by sending different signals to the SLM and thereby direct the machining process dynamically in one or more locations. It is noteworthy that the two-dimensional shaper of this embodiment is for making patterns and to direct the laser beam pulse focus, but not for use in MIIPS which is preferably performed with a separate one-dimensional shaper.

[0037] Another preferred embodiment laser material processing system 351 is shown in Figure 14. A laser, pulse shaping and compensating

device, waveguide, sensor and controller are essentially the same as any of the prior embodiments. In this exemplary embodiment, an objective 353 includes an elongated, centralized and tapered pin 355 extending from a beam emitting end 357. Pin 355 is electrically connected to an electrical circuit 359 including a power supply 361. A high voltage meter/amp meter 363 is connected in circuit 359 and circuit 359 is also electrically connected in a removable manner, either directly or indirectly, to a conductive workpiece 365. A programmable controller 367 is connected to and operably controls circuit 359. Pin 355 is substantially aligned with a focal point of the laser beam pulse. Thus, when electrical current is flowing through circuit 359 to pin 355, an electrical arc will span to workpiece 365 adjacent the laser beam pulse. The electrical current associated with the arc will vary due to ionization caused by workpiece ablation. For example, the electrical current is expected to be reduced when the laser beam pulse completely cuts through the workpiece. This voltage variation will be sensed by the meter 363 and the associated meter signal will be transmitted to controller 367. The controller will then automatically determine the next processing step such as moving either the workpiece or objective, varying a pulse shape or stopping pulse transmission. Moreover, the laser pulse will also serve to direct and focus the arc discharge toward the desired machining hole thereby improving accuracy and assisting in the machining process.

[0038] Additional alternate variations to the preceding embodiments are also envisioned. For example, the pulse shaper can be automatically switched between different phases, amplitudes or polarizations having different indexes of refractions. An exemplary use is to create a grated, undulated or stepped internal pattern on a hollow waveguide which could change the scattering pattern of light therethrough and could cause higher harmonic generation in an inexpensive manner. In another variation, multiple objectives, each having different characteristics, can be rotated either manually or automatically on a turret or carousel. For example, a first objective can be used to focus the micromachining pulse while a second objective thereafter aligned with the normal beam path can be used to view (by way of display monitor 383, in Figure 1) and detect the accuracy for desired machining path with a CCD

camera or manually. A further alternate variation purges the workpiece area in the machining station with a flowing, compressed Nitrogen or other gas fluid in order to prevent debris build up on the workpiece or objective. Moreover, an alternate version employs a superluminescent laser diode directly providing the
5 desired, expanded bandwidth without a femtosecond laser, for micromachining.

[0039] Another alternate embodiment employs a 200-500 fs ytterbium tungstenate laser (i.e., a picosecond laser) which is directly pumped by flashlamps instead of by a conventional fs green laser source. The bandwidth of this picosecond laser is increased by a hollow waveguide or otherwise pulse
10 shaped and compensated with a MIIPS unit, in order to inexpensively provide micromachining or surgical uses.

Laser Induced Breakdown Spectroscopy

[0040] The effect of femtosecond laser induced breakdown
15 spectroscopy (hereinafter "LIBS") is hereinafter considered. LIBS is influenced by pulse duration, bandwidth, and phase shaping, especially with regard to micromachining of metallic samples. Shorter pulses give a lower threshold. Moreover, different phase functions are expected to produce sample-dependent differences with phase dependence greater near the threshold. For example, it
20 is envisioned that when 30 fs pulses are stretched to 10 ps by linear chirp, little or no effect should be measured on the LIBS signal, seemingly contradicting the advantages reported for femtosecond pulses. Hence, it is believed that the bandwidth of the laser pulses is inversely proportional to the LIBS threshold.

[0041] The ablation process in femtosecond LIBS is very different from
25 conventional nanosecond LIBS. The electric field causes inner ionization of the atoms (1-5 fs), followed by outer ionization within the pulse (~35 fs). This highly unstable multi-ionized system triggers a Coulomb explosion within ~200 fs. Ablation is limited by the optical penetration depth at low fluences. Reduced thermal damage, lower threshold fluences, and less or no material deposition is
30 attributed to the direct transition of material to the vapor or plasma. Only at very high fluences (150 mJ/pulse) is melting observed, as evidenced by crater formation and microsecond emission. The higher efficiency of fs-LIBS results in

higher reliability, making it an efficient method to deliver photons to a sample to produce a reproducible LIBS signal.

[0042] A regeneratively amplified Ti:Sapphire laser and a MIIPS box pulse shaper are used to correct phase distortions, resulting in transform limited (TL) pulses centered at 800 nm (35 fs, ~750 mJ/pulse at 1 kHz). The laser beam is focused with a 100 mm lens and the focal spot diameter is 26 μm as measured from single pulse holes on metal. Laser intensity is varied from 0 to 150 μJ per pulse and the signal is collected at a $\sim 45^\circ$ angle with a fiber coupled high-resolution miniature spectrometer (HR4000-Ocean Optics) and averaged one second. Laser power dependence is measured using a monochromator a photomultiplier and is averaged with a boxcar integrator. A time gate is used to avoid the prompt (first 5 ns) broadband plasma emission. The signal collected corresponds to the atomic emission with characteristic 30-60 ns decay time. Exemplary samples used for this study are 6061 aluminum, copper, and brass disks spun at ~ 4800 rpm. Laser power dependence measurements are carried out by selecting spectral lines from the LIBS spectra (Cu I at 521.820 nm, Al I at 396.152 nm and Zn I at 481.053 nm in brass). For atomic lines, a fast rise is followed by a slow decay characteristic to atomic emission (30-60 ns). Lack of melting can be confirmed by microscopic analysis of clean edged micromachined holes. The threshold values expected to be obtained with TL pulses are in the 3-5 μJ /pulse levels and are very low compared to typical LIBS experiments carried out with 3-5 orders of magnitude higher energy per pulse. The threshold energy density is expected to be 0.6 for aluminum, 0.5 for copper and 0.8 for brass, all in J/cm^2 . Thus, micromachining sub-0.5 mm features can be carried out with single nano-Joule per pulse lasers.

[0043] Furthermore, linear chirp enhances the yield of multiphoton-initiated chemical reactions, and fs-LIBS emission. Measurements from -10,000 to 10,000 fs^2 can be carried out precisely using the MIIPS box pulse shaper at 50 and 150 μJ /pulse. It is expected that chirp will produce a 30% change in the overall LIBS signal for aluminum and a slightly smaller effect for copper. At much greater chirp values, the signal should increase by as much as 40% compared to TL pulses. The signal should still be higher than for TL pulses with a chirp of

130,000 fs² obtained by moving the compressor grating, implying that 35-fs pulses with energy just above threshold produce the same amount of LIBS signal as a pulses that are 10.3 picoseconds long.

[0044] The dependence of femtosecond LIBS on sinusoidal phases inspired by their effect on multiphoton intrapulse interference (MII) and control of multiphoton processes on molecules, proteins, and nonlinear optical crystal is next considered. The measurements can be carried out by introducing phase functions in the frequency (ω) domain defined by $\varphi(\omega) = 3\pi/2\cos(\gamma\omega - \delta)$, where γ is the bandwidth of the pulse ($\sim 1/35$ fs) and δ determines the position of the mask with respect to the spectrum of the pulse. These measurements are obtained with pulse energies 3-5 times above the LIBS threshold. When the intensity is increased to 30 times the LIBS threshold, the effect of the sinusoidal modulation decreases from 20% to less than 10%.

[0045] The effect of binary phase functions (10 bit resolution) on Al and Cu is also explored. Binary phase functions are effective for achieving selective multiphoton excitation in condensed phase and enhancing selective fragmentation in molecular beam experiments. The different patterns in binary phase maps should indicate a fundamental difference in the coupling of the laser energy into the substrate. The pattern to be obtained for copper is expected to indicate TL pulses produce higher LIBS intensity while modulation of the pulse into sub-pulses is best for aluminum.

[0046] TL pulses have very low thresholds for LIBS emission with femtosecond pulses. Positive chirp results in a greater efficiency compared to negative chirp using much more intense fs pulses. Stretching the pulse by a factor of ~ 300 yields signals will be slightly higher than those observed for TL pulses, despite the fact that the laser pulse energy is near threshold. This is in contrast with the expected signal from a two- or three-photon excitation process where the effect of stretching the pulse by such a factor would lead to a signal decrease of 5 or 7 orders of magnitude, respectively. Therefore, the LIBS process is limited by the timescale of electron-phonon coupling and of atoms leaving the bulk. As the pulses are stretched, there is a transition from the fs-

LIBS model, in which the laser energy is confined, to the ns-LIBS model, in which the energy couples to the bulk causing melting.

[0047] The relative insensitivity of LIBS to pulse duration would seem to contradict the better efficiencies and better micromachining characteristics for
5 picosecond and femtosecond laser pulses. Thus, the expected effect of bandwidth by introducing a set of slits in the compressor where the pulse is frequency-dispersed, with the fs-LIBS threshold dependence at multiple bandwidths of the pulse (using full-width at half maximum), is shown in Figure 7; this indicates that the greater the bandwidth, the lower the threshold. In other
10 words, efficient LIBS on metallic surfaces is highly dependent on bandwidth, however, for micromachining purposes, pulse durations below 1 ps are preferred to avoid melting and control depth. Although changes in the bandwidth cause changes in the pulse duration, that pulse duration alone does not affect the LIBS threshold.

[0048] It is also noteworthy that when $\delta=\pi$, the phase function can be approximated by a positive chirp, which yields a higher LIBS signal. When $\delta=0$, the phase function can be approximated by a negative chirp, which yields a lower LIBS signal. At $\delta=\pi/2$, the phase function has, within the FWHM of the
15 pulse, a linear dependence resulting in near-TL excitation. The dependence of LIBS on sinusoidal phase modulation, however, is not as significant as that of multiphoton processes. Furthermore, binary phase functions should provide clear differences between copper and aluminum, by way of example. In copper, TL pulses yield the highest LIBS signal but aluminum requires greater pulse modulation. This is most likely due to the aluminum-oxide layer. Therefore, LIBS
20 efficiency improves with bandwidth well beyond what is available using a traditional picosecond laser. Moreover, phase control of ultrashort (broad bandwidth) pulses will be valuable in laser machining and will improve reproducibility and selectivity in analytical LIBS applications, especially when minimal disturbance of the substrate is required.

[0049] While various embodiments have been disclosed herein, it should be appreciated that other modifications may be made that are covered by the system and methods of the present invention. For example, alternate lasers,
30

workpieces (including silicon wafers and biological specimens), optics, software and controllers can be employed as long as they function as described. Furthermore, a CCD camera or other optical imaging device can be used ahead of or behind the pulse to sense the location of the prospective machining path or
5 to check the machining quality, which then in turn, is usable in a closed loop real-time manner to vary a machining characteristic such as pulse shape, pulse duration or workpiece movement. The description of the invention is merely exemplary in nature and, thus, variations that do not depart from the gist of the invention are intended to be within the scope of the invention. Such variations
10 are not to be regarded as a departure from the spirit and scope of the invention.

CLAIMS

The invention claimed is:

1. A laser material processing system comprising:
5 a laser operable to emit a laser beam pulse;
a shaper operable to shape the pulse;
a hollow waveguide located in the path of the pulse to broaden the
bandwidth of the pulse greater than about 20 nm; and
a workpiece micromachined by the pulse.
- 10 2. The system of Claim 1, wherein the shaper uses multiphoton
intrapulse interference phase scan for pulse characterization and compensation
in a path of the pulse.
3. The system of Claim 1, wherein the waveguide includes an
elongated tube made of at least one of: (a) glass, and (b) quartz; and the pulse
15 has a duration less than about 500 femtoseconds.
4. The system of Claim 1, further comprising a workpiece support
automatically moving the workpiece relative to the laser beam pulse, and a
programmable controller operably controlling the workpiece support, the laser
and the shaper.
- 20 5. The system of Claim 1, further comprising at least one optic device
splitting the laser beam pulse into multiple sub-pulses which simultaneously
micromachine the same workpiece.
6. The system of Claim 1, further comprising at least one optic device
splitting the laser beam pulse into multiple sub-pulses which simultaneously
25 micromachine multiples of the workpiece in multiple machining stations.
7. The system of Claim 1, further comprising a tank containing a
liquid, the workpiece being entirely submerged in the liquid during
micromachining, and the liquid assisting in focusing the laser pulse.
8. The system of Claim 1, further comprising a two-dimensional
30 spatial light modulator operably causing the pulse to create a pattern in the
workpiece.

9. The system of Claim 1, wherein the pulse has a duration of about 100-500 femtoseconds and the workpiece is metal.

10. The system of Claim 1, wherein the pulse is transform limited and has a duration of about 10-50 femtoseconds, and the workpiece is a nonmetallic material.

11. The system of Claim 1, further comprising:
a programmable controller connected to the shaper;
a detector connected to the controller;
wherein a surface of the workpiece creates second harmonic emission of the laser pulse which is detected by the detector to characterize the laser pulses, such that a SHG crystal is not employed.

12. A laser system comprising:
a laser operable to emit a laser beam pulse;
a shaper operable to shape the pulse;
a hollow waveguide located in the path of the pulse to broaden the bandwidth of the pulse;
a programmable controller connected to the shaper; and
a laser pulse detector connected to the controller;
the controller operably receiving a signal from the detector indicative of distortion of the laser pulse and causing the shaper to vary a characteristic of subsequent pulses passing through the shaper to correct the distortion.

13. The system of Claim 12, further comprising micromachining a workpiece with the shaped and bandwidth-broadened laser pulse.

14. The system of Claim 12, wherein the waveguide includes an elongated tube made of at least one of: (a) glass, and (b) quartz; and the pulse has a duration less than about 500 femtoseconds.

15. The system of Claim 12, further comprising a workpiece support automatically moving the workpiece relative to the laser beam pulse, and the controller operably controlling the workpiece support.

16. The system of Claim 12, further comprising at least one optic device splitting the laser beam pulse into multiple sub-pulses which simultaneously micromachine the same workpiece.

5 17. The system of Claim 12, further comprising at least one optic device splitting the laser beam pulse into multiple sub-pulses which simultaneously micromachine workpieces in multiple machining stations.

18. The system of Claim 12, further comprising a tank containing a liquid, a workpiece being entirely submerged in the liquid during use, and the liquid assisting in focusing the laser pulse.

10 19. The system of Claim 12, further comprising a two-dimensional spatial light modulator operably causing the pulse to create a pattern in the workpiece.

20. The system of Claim 12, further comprising a surface of a workpiece operably creating second harmonic emission of the laser pulse which is detected by the detector to monitor the laser performance.

21. A laser material processing system comprising:
a laser operable to emit a laser beam pulse;
a shaper operable to shape the pulse;
a programmable controller connected to the shaper;
20 the controller operably using multiphoton intrapulse interference phase scan programmed instructions to automatically perform pulse characterization and compensation in the pulse; and
a workpiece micromachined by the pulse.

22. The system of Claim 21, further comprising a workpiece support automatically moving the workpiece relative to the laser beam pulse, and a programmable controller operably controlling the workpiece support, the laser and the shaper.

23. The system of Claim 21, further comprising at least one optic device splitting the laser beam pulse into multiple sub-pulses which simultaneously micromachine the same workpiece.

24. The system of Claim 21, further comprising at least one optic device splitting the laser beam pulse into multiple sub-pulses which

simultaneously micromachine multiples of the workpiece in multiple machining stations.

25. The system of Claim 21, further comprising a tank containing a liquid, the workpiece being entirely submerged in the liquid during
5 micromachining, and the liquid assisting in focusing the laser pulse.

26. The system of Claim 21, wherein the shaper is a two-dimensional spatial light modulator.

27. The system of Claim 21, wherein the pulse has a duration of about 100-500 femtoseconds and the workpiece is metal.

10 28. The system of Claim 21, wherein the pulse is transform limited and has a duration of about 10-50 femtoseconds, and the workpiece is a nonmetallic material.

29. The system of Claim 21, further comprising:
a detector connected to the controller;
15 wherein a surface of the workpiece creates second harmonic emission of the laser pulse which is detected by the detector, such that a SHG crystal is not employed.

30. A laser material processing system comprising:
a laser operable to emit a laser beam pulse;
20 a two-dimensional spatial light modulator operable to shape the pulse in space; and
a workpiece micromachined by the shaped pulse.

31. The system of Claim 30, further comprising a programmable controller connected to another spatial light modulator, the controller operably
25 using multiphoton intrapulse interference phase scan programmed instructions to automatically perform pulse characterization and compensation in the pulse.

32. The system of Claim 30, further comprising a hollow waveguide located in the path of the pulse to broaden the bandwidth of the pulse greater than about 20 nm.

30 33. The system of Claim 30, further comprising a workpiece support automatically moving the workpiece relative to the laser beam pulse, and a programmable controller operably controlling the workpiece support.

34. The system of Claim 30, further comprising at least one optic device splitting the laser beam pulse into multiple sub-pulses which simultaneously micromachine the same workpiece.

5 35. The system of Claim 30, further comprising at least one optic device splitting the laser beam pulse into multiple sub-pulses which simultaneously micromachine multiples of the workpiece in multiple machining stations.

10 36. The system of Claim 30, further comprising a tank containing a liquid, the workpiece being entirely submerged in the liquid during micromachining, and the liquid assisting in focusing the laser pulse.

37. The system of Claim 30, wherein the two-dimensional spatial light modulator is an integrated lens array and the two-dimensional spatial light modulator causes at least the pulse to make a polygonal shaped hole in the workpiece.

15 38. The system of Claim 30, wherein the two-dimensional spatial light modulator causes the pulse to create multiple holes into the same workpiece.

39. The system of Claim 30, wherein the two-dimensional spatial light modulator causes the pulse to create a pattern in the workpiece.

20 40. A laser material processing system comprising:
a laser operably emitting at least one laser beam pulse;
an electrical circuit conducting electrical current and supplying an electrical arc adjacent the pulse; and
a controller operably determining changes in the electrical current due to the arc and automatically varying a characteristic of the pulse accordingly.

25 41. The system of Claim 40, further comprising:
a workpiece modified by the pulse;
an objective emitting the pulse; and
a conductor located adjacent the pulse emitting the electrical arc to the workpiece.

30 42. The system of Claim 40, further comprising a sensor and a workpiece, the sensor being substantially located on an opposite side of the workpiece from the objective, the pulse having a duration of less than about 500

femtoseconds, and the controller determining when the pulse has reached a desired position relative to the workpiece by sensing the electrical current.

5 43. The system of Claim 40, further comprising a hollow waveguide located in the path of the pulse to broaden the bandwidth of the pulse greater than about 20 nm.

44. The system of Claim 40, further comprising a pulse shaper operably shaping the pulse, and the controller being connected to the shaper and using multiphoton intrapulse interference phase scan instructions to cause pulse characterization and compensation in a path of the pulse.

10 45. The system of Claim 40, further comprising an objective focusing the pulse, and an elongated and conductive pin connected to the objective, the pin being substantially concentric with the pulse being emitted from the objective.

15 46. The system of Claim 40, wherein the electrical current associated with the arc will vary due to ionization caused by workpiece ablation from the pulse.

47. The system of Claim 40, wherein the controller causes subsequent pulses to have different characteristics based at least in part on a signal associated with the arc.

20 48. The system of Claim 40, wherein the laser pulse operably assists in directing the arc toward the area being modified by the pulse.

49. The system of Claim 40, further comprising machining a workpiece with the pulse.

50. The system of Claim 40, further comprising machining a hole in a workpiece with the pulse.

25 51. The system of Claim 40, wherein the pulse has a duration of no greater than 500 femtoseconds.

52. A laser material processing system comprising:
a laser operably emitting at least one laser beam pulse;
an electrical circuit conducting electrical current and supplying an
30 electrical arc adjacent the pulse; and
a workpiece micromachined by at least the pulse.

53. The system of Claim 52, further comprising:

an objective emitting the pulse; and
a conductor located adjacent the pulse emitting the electrical arc to
the workpiece.

5 54. The system of Claim 52, further comprising a sensor and a
programmable controller, the sensor being substantially located on an opposite
side of the workpiece from the objective, the pulse having a duration of less than
about 500 femtoseconds, and the controller determining when the pulse has
reached a desired position relative to the workpiece by sensing the electrical
current.

10 55. The system of Claim 52, further comprising a hollow waveguide
located in the path of the pulse to broaden the bandwidth of the pulse greater
than about 20 nm.

15 56. The system of Claim 52, further comprising a pulse shaper
operably shaping the pulse, and a programmable controller connected to the
shaper and using multiphoton intrapulse interference phase scan instructions to
cause pulse characterization and compensation in a path of the pulse.

57. The system of Claim 52, further comprising an objective focusing
the pulse, and an elongated and conductive pin connected to the objective, the
pin being substantially concentric with the pulse being emitted from the objective.

20 58. The system of Claim 52, further comprising electrical current
associated with the arc will vary due to ionization caused by workpiece ablation
from the pulse.

25 59. The system of Claim 52, further comprising a programmable
controller operably causing subsequent pulses to have different characteristics
based at least in part on a signal associated with the arc.

60. The system of Claim 52, wherein the laser pulse operably assists
in directing the arc toward the area being machined by the pulse.

61. The system of Claim 52, further comprising machining a hole in the
workpiece with the pulse.

30 62. The system of Claim 52, wherein the pulse has a duration of no
greater than 500 femtoseconds.

63. A micromachining system comprising:

a laser operably emitting a first laser beam pulse;

a workpiece;

a pulse shaper operably shaping the first pulse;

a programmable controller connected to the shaper and operably

5 causing the shaper to vary the pulse shape of one or more subsequent pulses transmitted through the shaper; and

at least one optic member causing multiple focal points on the workpiece for each of the pulses.

64. The system of Claim 63, wherein each of the pulses
10 micromachines multiple holes within the same workpiece, and each of the pulses has a duration less than about 500 femtoseconds.

65. The system of Claim 63, wherein the optic member includes a two-dimensional SLM varied by the controller.

66. The system of Claim 63, further comprising an optical assembly
15 spreading and collimating each of the pulses.

67. The system of Claim 63, wherein the controller operably uses multiphoton intrapulse interference phase scan programmed instructions to automatically perform pulse characterization and compensation in the pulses.

68. The system of Claim 63, further comprising a hollow waveguide
20 located in the path of the pulses to broaden the bandwidth of the pulses greater than about 20 nm.

69. The system of Claim 63, further comprising a workpiece support automatically moving the workpiece relative to the laser pulses, and the programmable controller operably controlling the workpiece support.

70. The system of Claim 63, further comprising a tank containing a
25 liquid, the workpiece being entirely submerged in the liquid during micromachining, and the liquid assisting in focusing the laser pulses.

71. The system of Claim 63, wherein the at least one optic member is a two-dimensional spatial light modulator.

72. A laser micromachining system comprising:
30 a laser beam pulse;
a first micromachining workstation;

a first optic member associated with the first micromachining workstation;

at least a second micromachining workstation; and

at least a second optic member associated with the second
5 micromachining workstation;

wherein the same pulse is simultaneously directed to the first and second micromachining workstations by their respective first and second optic members.

73. The system of Claim 72, further comprising a pulse shaper using
10 multiphoton intrapulse interference phase scan for automatic characterization and compensation of the pulse.

74. The system of Claim 72, further comprising at least one hollow waveguide operably broadening the bandwidth of the pulse.

75. The system of Claim 72, further comprising at least one workpiece
15 support automatically moving a workpiece relative to the laser beam pulse, and a programmable controller operably controlling the workpiece support.

76. The system of Claim 72, further comprising a pulse shaper operably shaping the laser pulse.

77. The system of Claim 72, further comprising:
20 a third micromachining workstation;
a third optic member associated with the third micromachining workstation;

at least a fourth micromachining workstation; and

at least a fourth optic member associated with the fourth
25 micromachining workstation;

wherein the same pulse from a single laser is simultaneously directed to the first, second, third and fourth micromachining workstations by their respective optic members.

78. The system of Claim 72, further comprising a tank containing a
30 liquid, a workpiece being entirely submerged in the liquid during micromachining, and the liquid assisting in focusing the laser pulse.

79. The system of Claim 72, further comprising at least one shutter operably blocking transmission of the split sub-pulse from reaching an associated one of the workstations.

5 80. The system of Claim 72, wherein the pulse has a duration of about 100-500 femtoseconds and a workpiece is metal.

81. The system of Claim 72, wherein the pulse is transform limited and has a duration of about 10-50 femtoseconds, and a workpiece is a nonmetallic material.

10 82. A laser material processing system comprising:
a workpiece;
a laser operably emitting at least one laser beam pulse onto a first side of the workpiece, the workpiece being micromachined by the pulse;
a sensor located on a second and opposite side of the workpiece;
and
15 a programmable controller connected to the sensor and the laser, the controller operably determining when the pulse has reached a desired position relative to the workpiece.

20 83. The system of Claim 82, further comprising a pulse shaper connected to and controlled by the controller, the controller operably using multiphoton intrapulse interference phase scan instructions for pulse characterization and compensation in the pulse.

84. The system of Claim 82, further comprising an elongated and hollow waveguide broadening the bandwidth of the pulse.

25 85. The system of Claim 82, further comprising a workpiece support automatically moving the workpiece relative to the laser pulse, and the controller operably controlling the workpiece support.

86. The system of Claim 82, wherein the sensor is a diode.

87. The system of Claim 82, wherein the sensor operably detects when the pulse has penetrated completely through the workpiece.

30 88. The system of Claim 82, wherein the controller automatically controlling the workpiece-to-pulse location for subsequent micromachining

pulses based at least in part on a signal from the sensor, in a real-time, feedback control loop.

89. The system of Claim 82, further comprising an electrical circuit conducting electrical current and supplying an electrical arc to the workpiece adjacent the pulse.

90. A laser material processing system comprising:
a laser beam pulse;
a shaper operable to shape the pulse;
a tank containing a liquid; and
a workpiece micromachined by the pulse, the workpiece being entirely submerged in the liquid during micromachining, and the liquid assisting in focusing the laser pulses.

91. The system of Claim 90, further comprising a hollow waveguide located in the path of the pulse to broaden the bandwidth of the pulse greater than about 20 nm.

92. The system of Claim 90, further comprising a pulse shaper and a programmable controller operably using multiphoton intrapulse interference phase scan for pulse characterization and compensation of the pulse.

93. The system of Claim 90, wherein the pulse has a duration of about 100-500 femtoseconds and the workpiece is metal.

94. The system of Claim 90, wherein the pulse is transform limited and has a duration of about 10-50 femtoseconds, and the workpiece is a nonmetallic material.

95. The system of Claim 90, wherein the liquid is oil and a micromachined hole in the workpiece is no greater than 500 nm in diameter.

96. A laser system comprising:
a first laser beam pulse;
a pulse shaper operably shaping the first pulse;
a spectrometer; and
a programmable controller connected to the shaper and spectrometer;

the controller operably causing the shaper to vary the pulse shape of one or more subsequent pulses transmitted through the shaper during laser induced breakdown spectroscopy based at least in part on a signal from the spectrometer.

5 97. The system of Claim 96, further comprising a workpiece, wherein each of the pulses micromachines the workpiece, and each of the pulses has a duration of no greater than 1 picosecond.

 98. The system of Claim 96, wherein the pulse shaper includes a two-dimensional SLM varied by the controller.

10 99. The system of Claim 96, wherein the controller operably uses multiphoton intrapulse interference phase scan programmed instructions to automatically perform pulse characterization and compensation in the pulses.

 100. The system of Claim 96, further comprising a waveguide located in the path of the pulses to broaden the bandwidth of the pulses greater than about
15 20 nm.

 101. A method of material processing, the method comprising:

 (a) emitting at least one laser pulse having a duration less than about 500 femtoseconds;

 (b) correcting spectral phase distortions in the at least one
20 pulse using multi-photon intrapulse interference phase scan, after step (a);

 (c) broadening the bandwidth of the at least one pulse to about 10-200 nm;

 (d) placing a workpiece in a liquid; and

 (e) micromachining the workpiece in the liquid with the at least
25 one pulse.

 102. The method of Claim 101, further comprising automatically shaping laser pulses based at least in part on sensed characteristics of prior laser pulses.

 103. The method of Claim 101, further comprising assisting in focusing the laser pulse with the liquid.

30 104. The method of Claim 101, further comprising entirely submerging the workpiece in the liquid during micromachining.

105. The method of Claim 101, further comprising broadening the bandwidth with a hollow waveguide.

106. The method of Claim 101, further comprising submerging the workpiece in oil and micromachining at least one hole in the workpiece of a diameter no greater than 500 nm.

107. The method of Claim 101, further comprising using a datum marking on the workpiece to visually align a laser objective with a desired location on the workpiece prior to micromachining.

108. A method of material processing, the method comprising:

- 10 (a) emitting at least one laser pulse onto a workpiece;
(b) collecting a surface second harmonic emission from the pulse contacting the workpiece;
(c) determining a phase distortion in the emission from step (b);
and
15 (d) automatically optimizing subsequent laser pulses emitted onto the workpiece.

109. The method of Claim 108, further comprising micromachining the workpiece with the optimized pulses.

110. The method of Claim 108, further comprising entirely submerging the workpiece in a liquid and thereafter micromachining the workpiece.

111. The method of Claim 108, further comprising automatically shaping the laser pulses based at least in part on sensed characteristics of prior laser pulses.

112. The method of Claim 108, further comprising broadening a bandwidth of the pulses with a hollow waveguide.

113. The method of Claim 108, further comprising using a datum marking on the workpiece to visually align a laser objective with a desired location on the workpiece prior to micromachining.

114. A method of material processing, the method comprising:

- 30 (a) emitting at least one laser pulse onto a workpiece;
(b) creating an electrical arc, adjacent the pulse, to the workpiece; and

(c) machining the workpiece by at least the pulse.

115. The method of Claim 114, further comprising automatically shaping the laser pulses based at least in part on sensed characteristics of prior laser pulses.

5 116. The method of Claim 114, further comprising using multiphoton intrapulse interference phase scan to cause pulse characterization and compensation in a path of the pulse.

10 117. The method of Claim 114, further comprising focusing the pulse with an objective, emitting the electrical arc from an elongated and conductive pin connected to the objective, and emitting the pulse substantially concentric with the electrical arc.

118. The method of Claim 114, further comprising varying the electrical current associated with the arc due to ionization caused by workpiece ablation from the pulse.

15 119. The method of Claim 114, further comprising a programmable controller operably causing subsequent laser pulses to have different characteristics based at least in part on a signal associated with the electrical arc.

20 120. The method of Claim 114, further comprising using the laser pulse to assist in directing the electrical arc toward the area being machined by the laser pulse.

121. A method of manufacturing an optical waveguide, the method comprising:

25 (a) creating a hollow and elongated waveguide body from a material including glass or quartz;

(b) creating end caps; and

(c) fusing the end caps directly onto the corresponding ends of the waveguide body to attach the end caps to the body.

30 122. The method of Claim 121, further comprising making the waveguide body and end caps from a glass material.

123. The method of Claim 121, further comprising making the waveguide body and end caps from a quartz material.

124. The method of Claim 121, further comprising drawing a vacuum in the waveguide and thereafter filling the waveguide with a gas other than air.

125. The method of Claim 121, further comprising making the waveguide body rigid and straight.

5 126. The method of Claim 121, further comprising adding an anti-reflective coating to at least one of the waveguide body and the end caps.

127. The method of Claim 121, further comprising making at least one of the end caps with a leg projecting offset from an elongated direction of the waveguide body.

10 128. A method of material processing, the method comprising:
(a) emitting at least one laser pulse onto a workpiece;
(b) shaping the at least one laser pulse with a two-dimensional spatial light modulator; and
(c) machining the workpiece by the at least one laser pulse.

15 129. The method of Claim 128, further comprising shaping the at least one laser pulse with another pulse shaper at a Fourier plane, based at least in part on sensed characteristics of prior laser pulses.

20 130. The method of Claim 128, further comprising using multiphoton intrapulse interference phase scan to cause pulse characterization and compensation in a path of the pulse.

131. The method of Claim 128, further comprising making a polygonal shaped hole in the workpiece with the at least one shaped pulse.

25 132. The method of Claim 128, further comprising using a programmable controller to automatically cause subsequent laser pulses to have different characteristics.

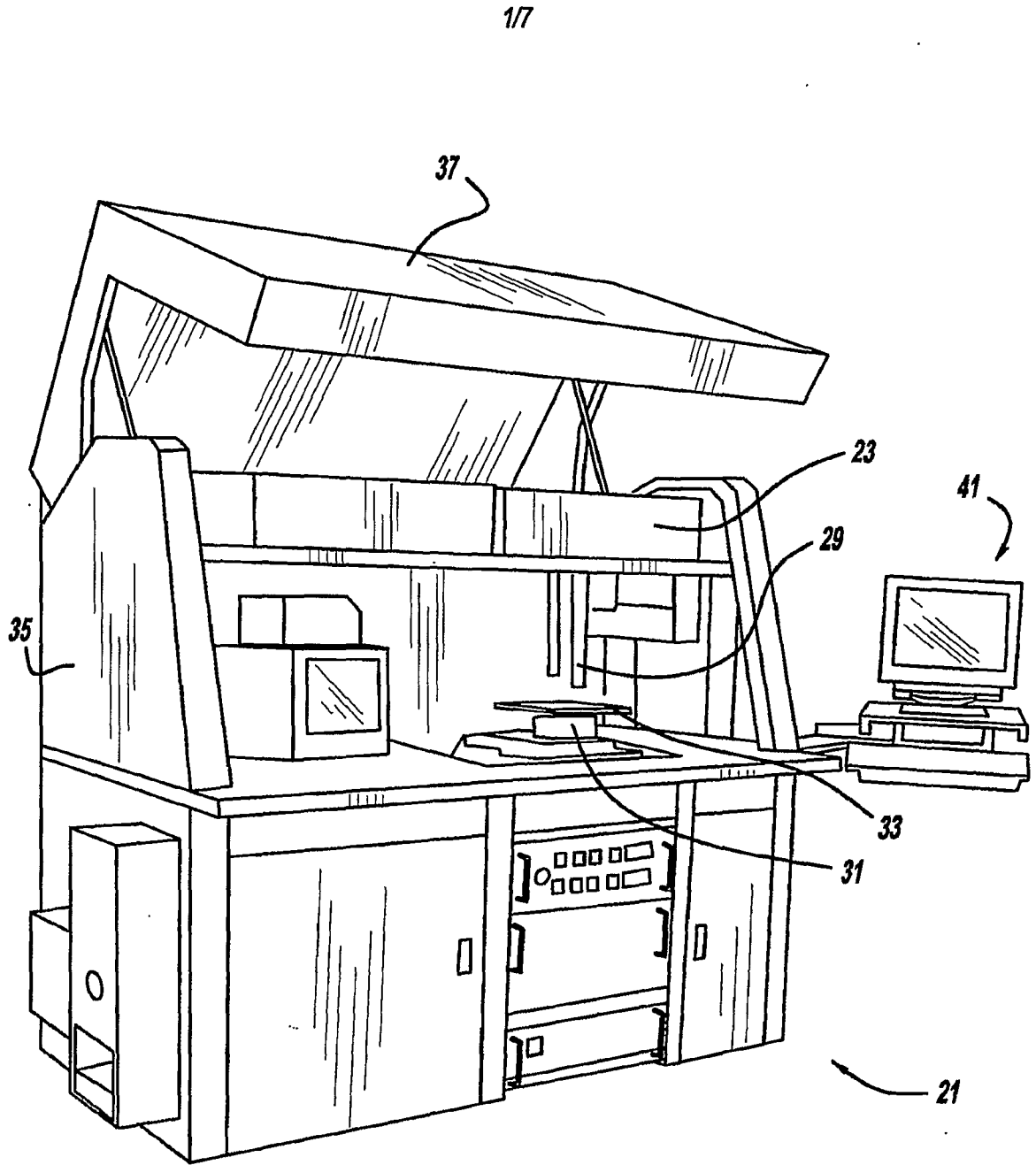


FIG - 1

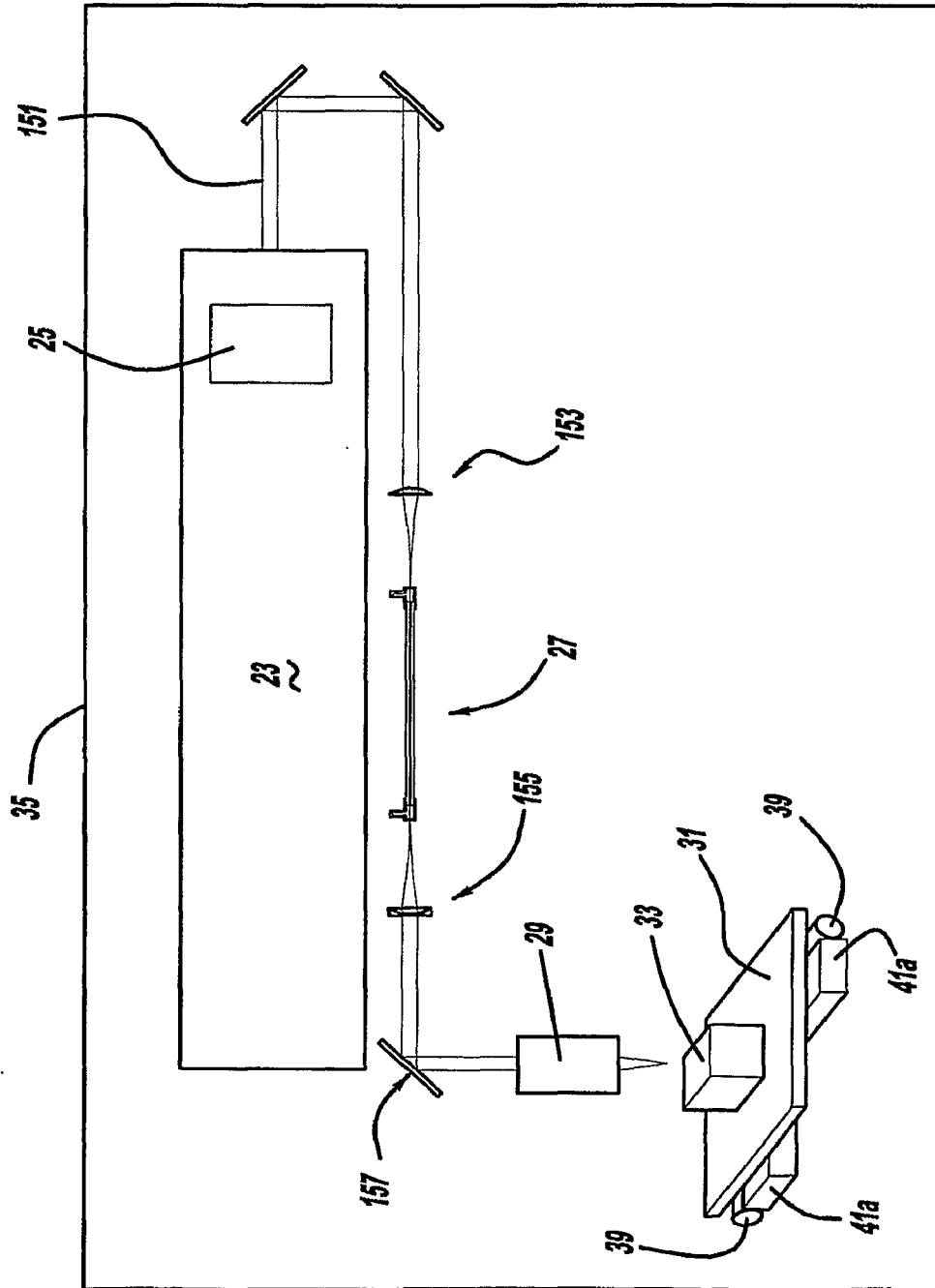


FIG - 2

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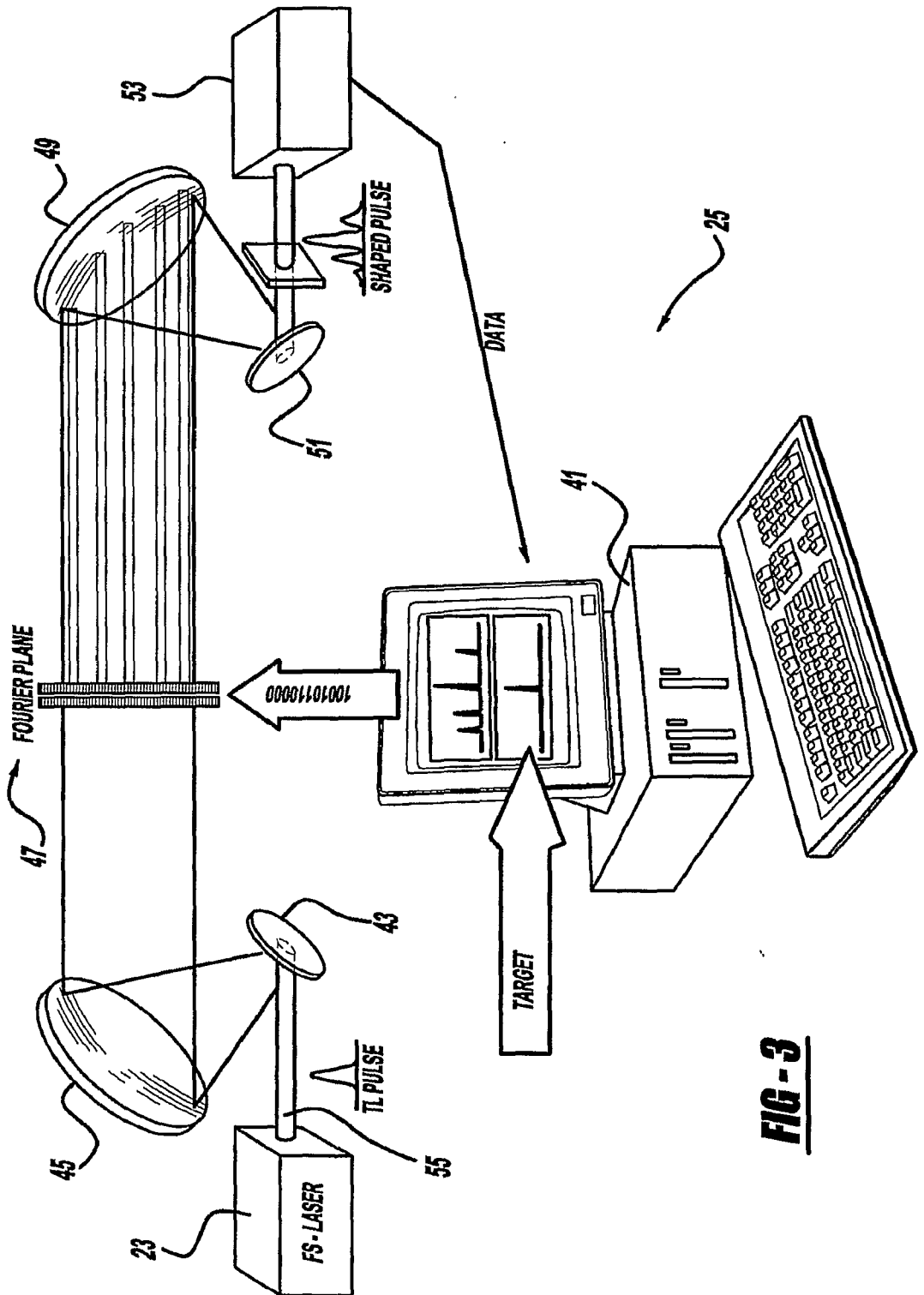


FIG - 3

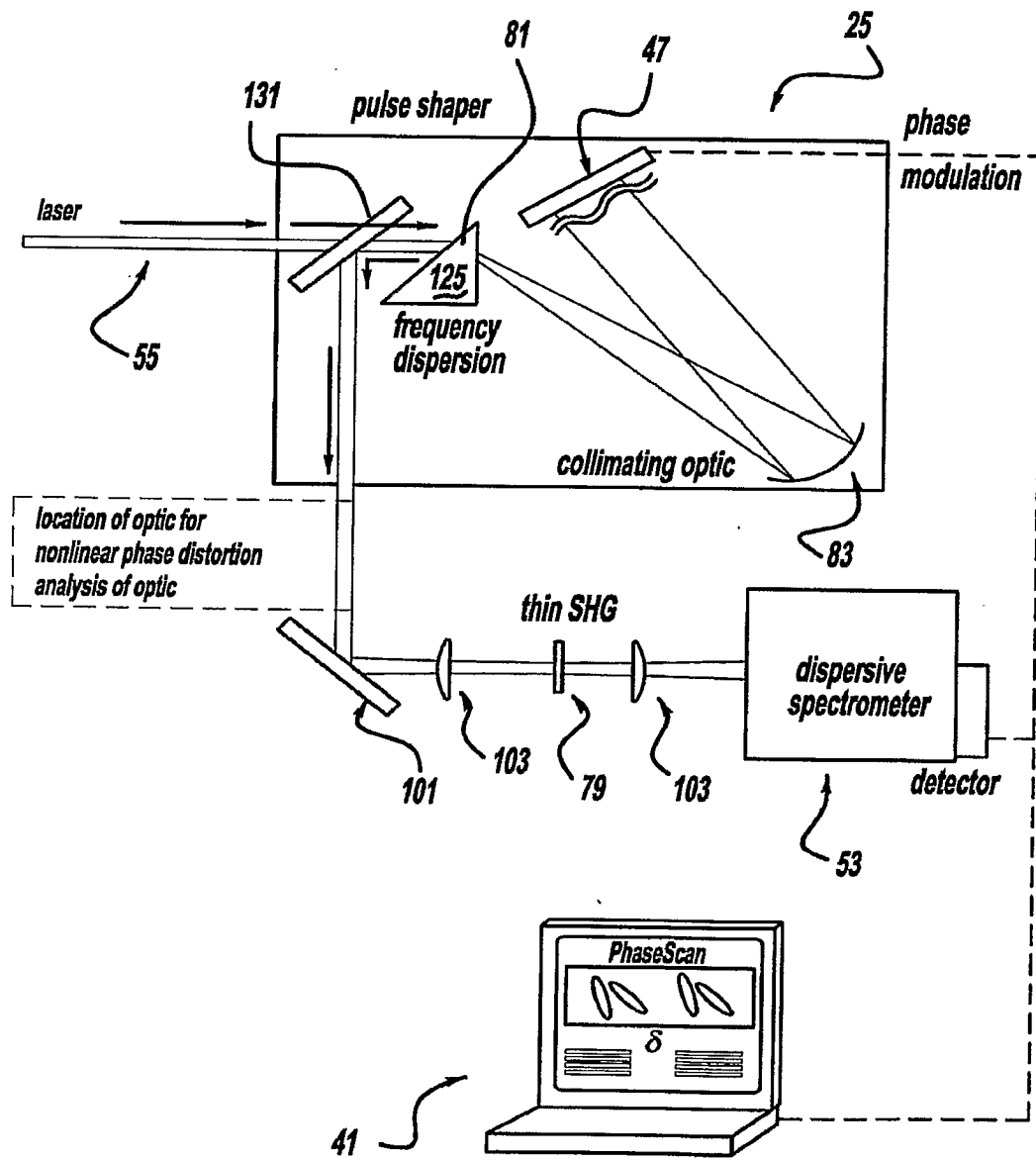
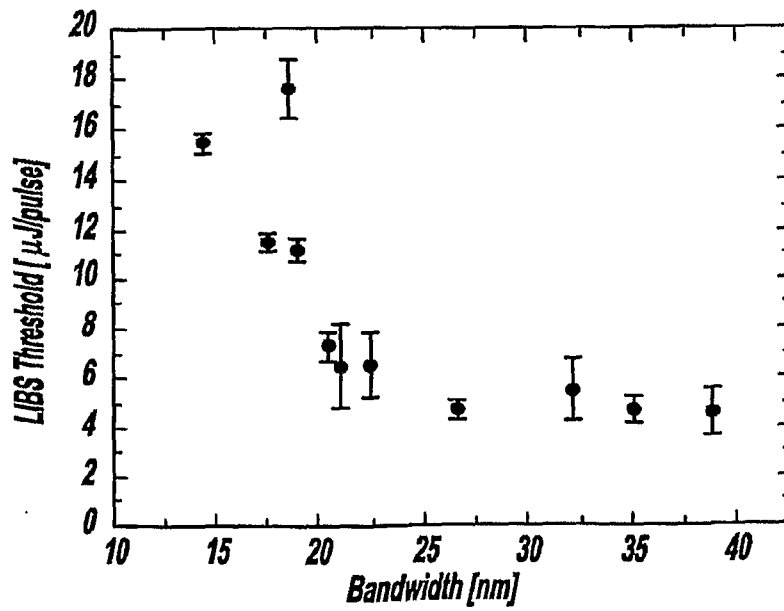
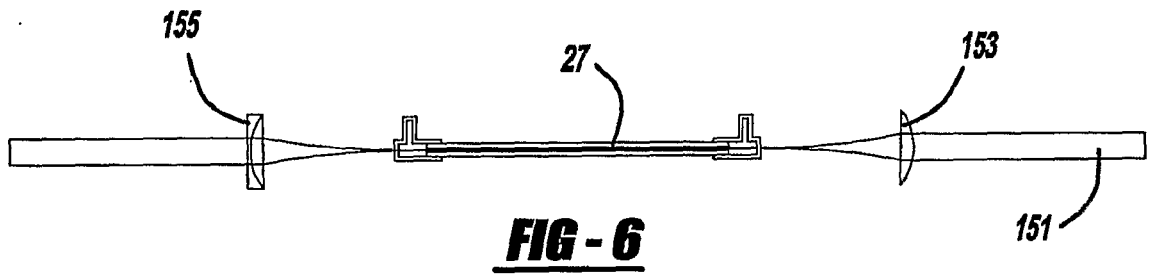
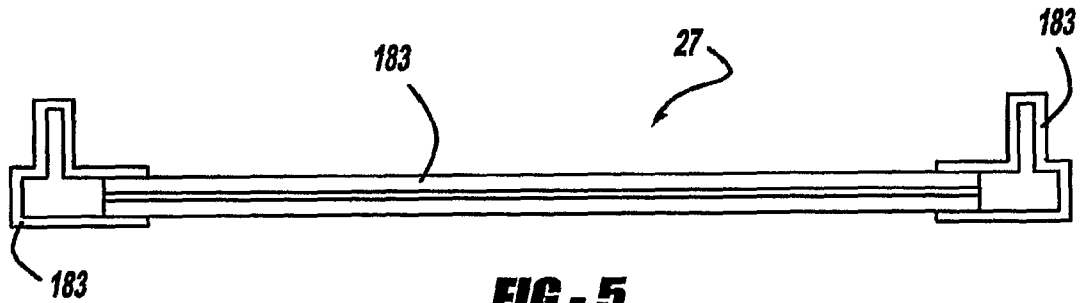


FIG - 4

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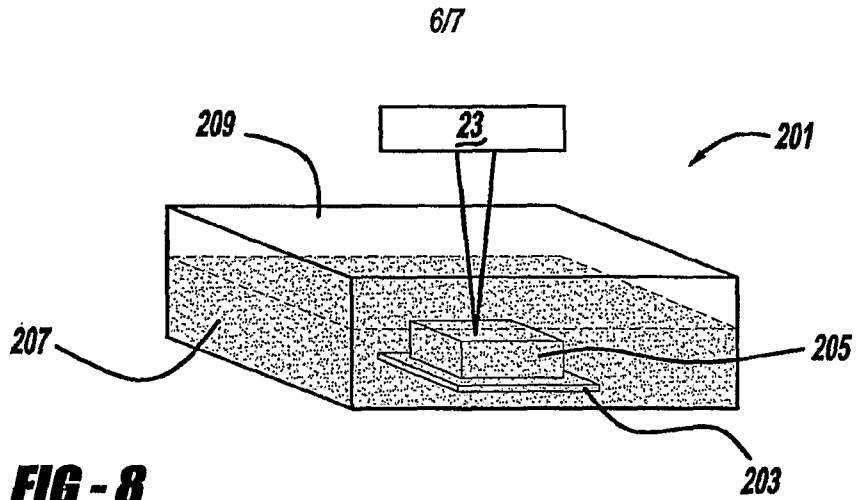


FIG - 8

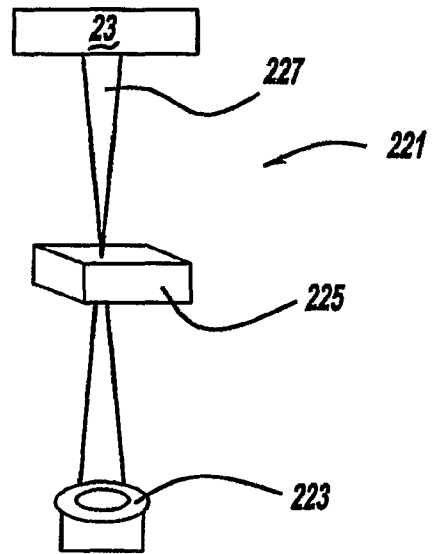


FIG - 9

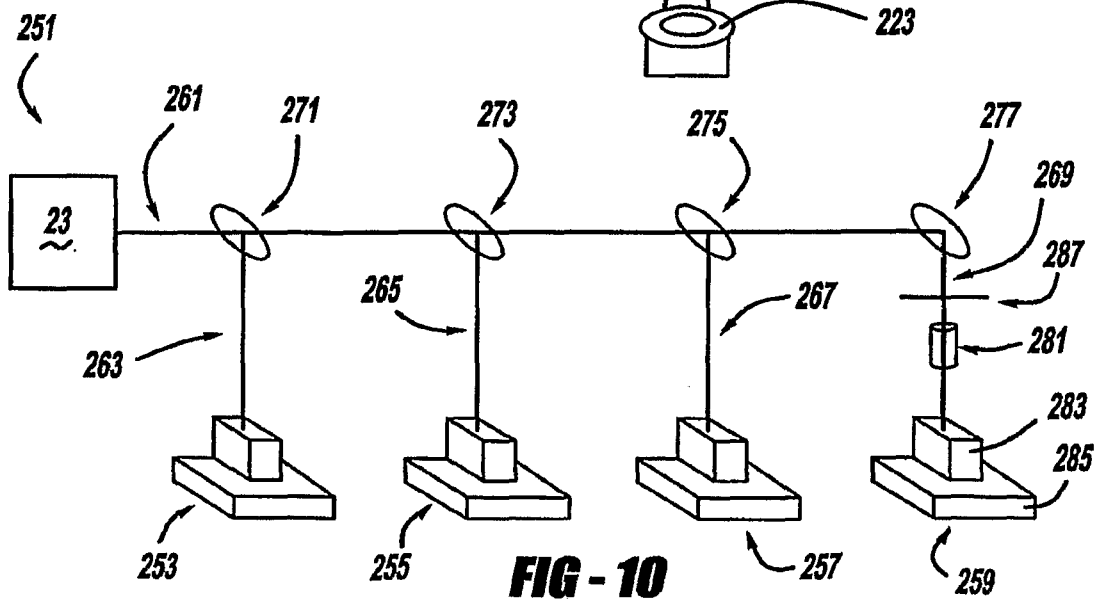


FIG - 10

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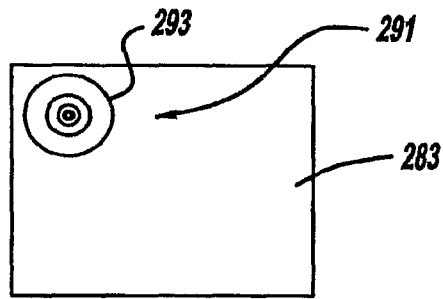


FIG - 11

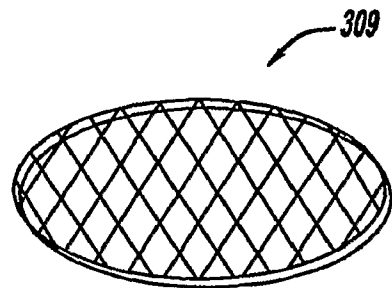


FIG - 12

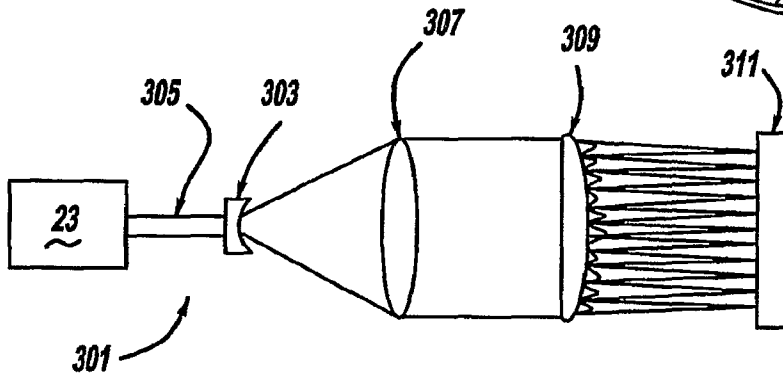


FIG - 13

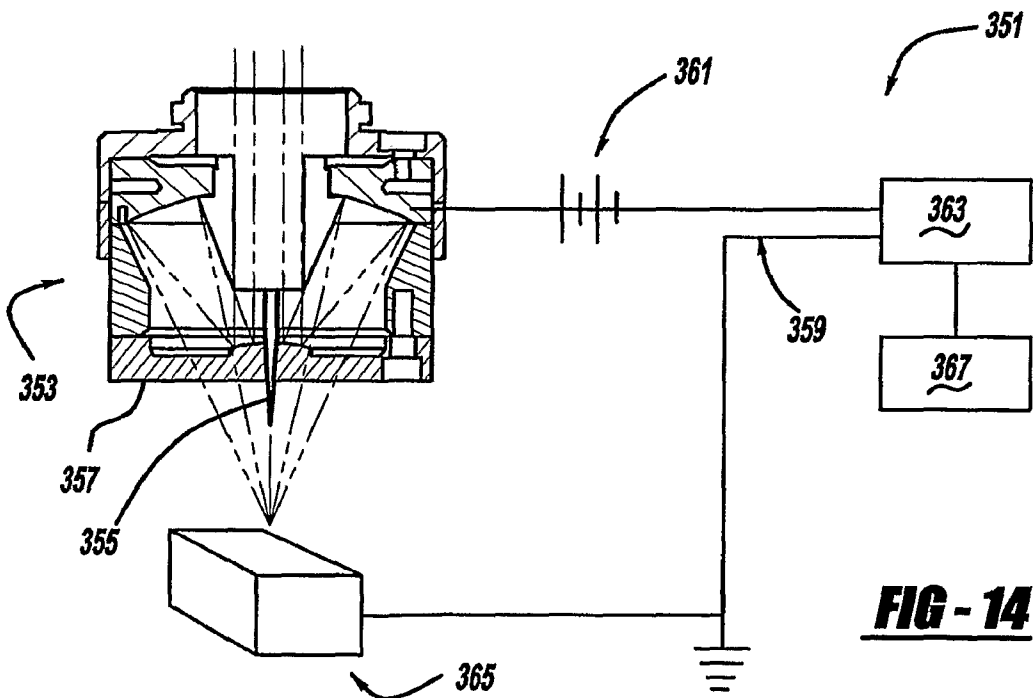


FIG - 14