



Selection Guide for CNC Rotary Tables ...

**Smart
Solution**

We will
support you

2023

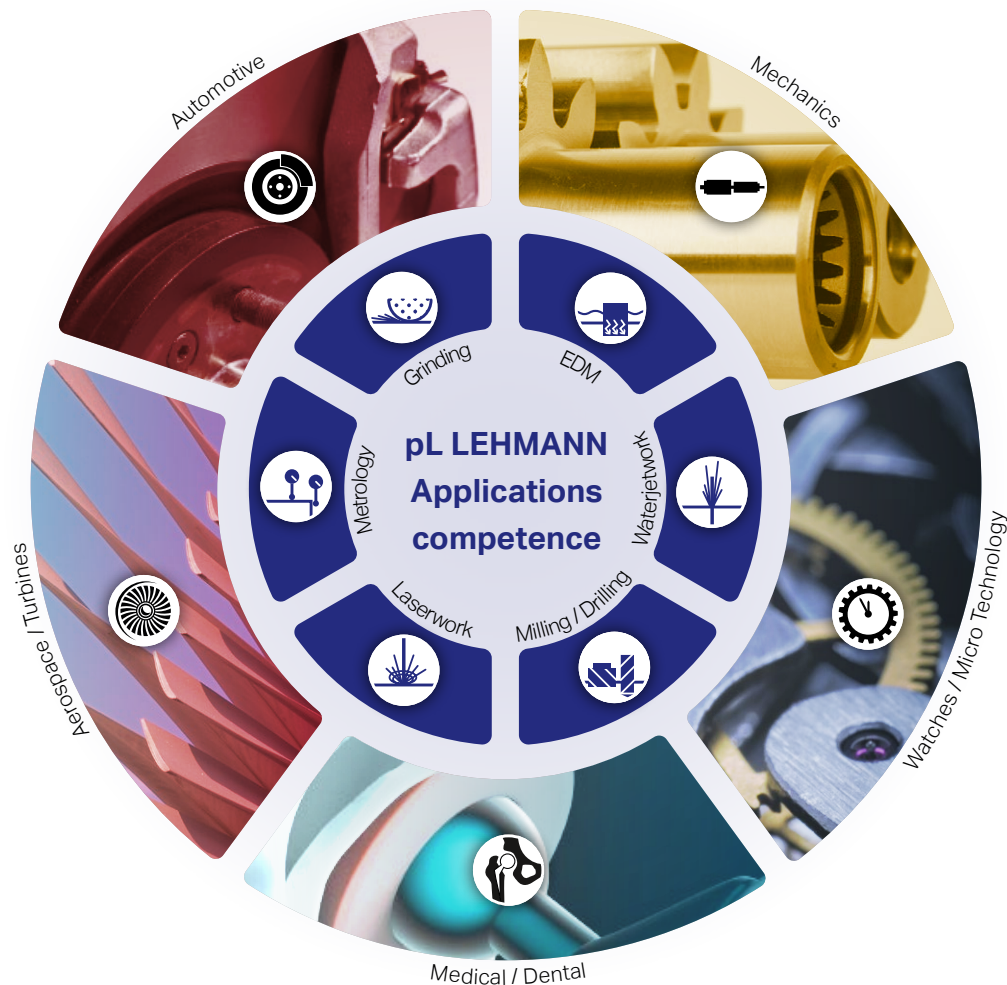
Mazak

1/2023 | EN



... for vertical machining centers

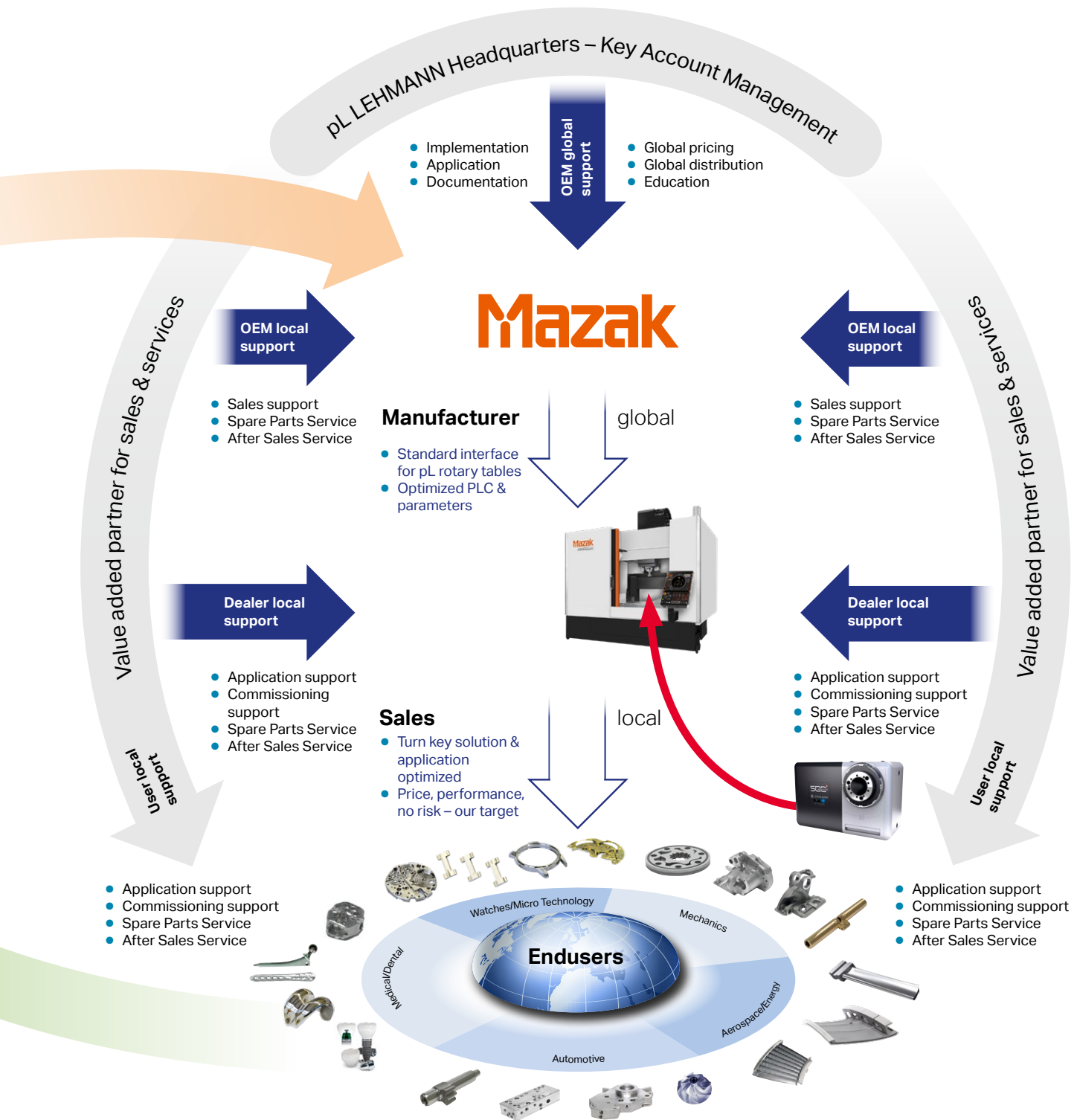
CNC rotary tables for economical manufacturing:
pL LEHMANN has suitable and rational solutions for
nearly every industry



pL rotary tables in use: on over **40** different machine brands
and over **160** different machine models.

pL competence: Integration in **all known** CNC control systems
(Fanuc, Siemens, Heidenhain ...), for new machines as well as
for retrofits

Professional products from professional partners:
Mazak and pL LEHMANN provide
first-class service to common customers



Up to 210 rpm
up to 0.21 sec / 90°

High speed GD

Extended travel in
Z- and X-direction

More space

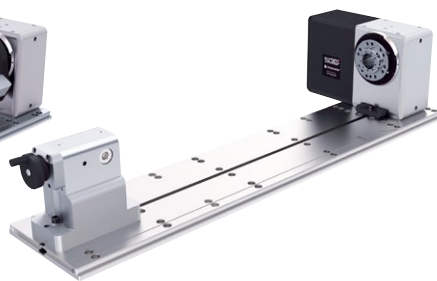
High spindle load,
heavy-duty bearing

Heavy duty

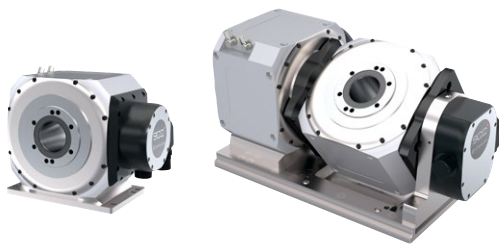
E-Series



EA-50x light only 12 kg



DD Series



**Request our
special catalog**

High speed DD

up to 5'450 rpm

Adaptability

Multifunctional
spindle HSK

Precision

On the workpiece, as
precise as 2 µm / 100 mm

Pneum. clamping
up to 7,000 Nm

High clamp

Large parts
up to $\varnothing$ 500

Big size

PGD backlash-free
long-life gear unit

No backlash

T-Series



**All base plates
made of steel**

with integrated hole pattern for
slot spacing of 100 and 125 mm,
integrated alignment system
lineFIX for lengthwise or cross-
wise clamping.

M-Series



Connectivity

Monitoring for
operation & service

No adjust

Load change without
parameter adjustment

Less cost

No cooling system,
no hydraulics



FJV-250



MTV-655/60



VCE-600



VCN-535C



VCN-600



VC-Primos 400 L



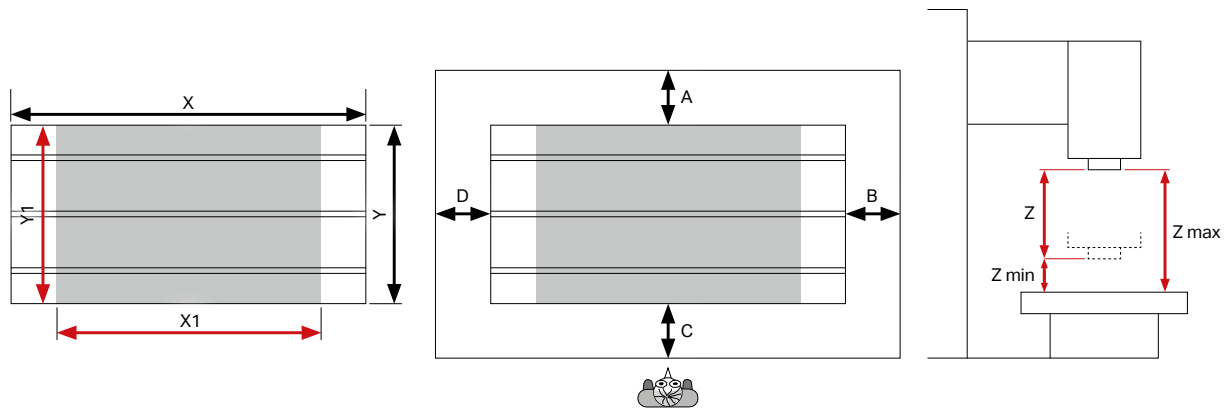
VTC-530C

A word from Mazak:

«High Quality – Advanced – International

These values have underpinned the development of «world manufacturing» by offering machine tools that satisfy manufacturers' needs.

We will continue to take on new challenges as the world's top machine tool maker. It is a great honor to us that we contribute to the wealth of people's lives «anytime, anywhere» through manufacturing.»

[illegible]

** The recommended rotary tables do not exceed 50 % of the allowed table load.

Table explanation for pp. 8–11

	EA-507	EA-510	EA-520	EA-530	EA-913	EA-915	EA-918
				X2			
FJV-200		575	549	520			

pl LEHMANN®

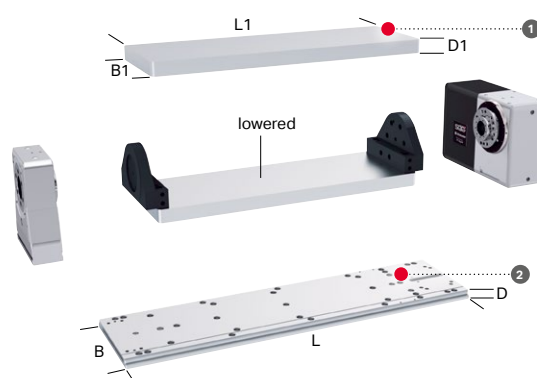


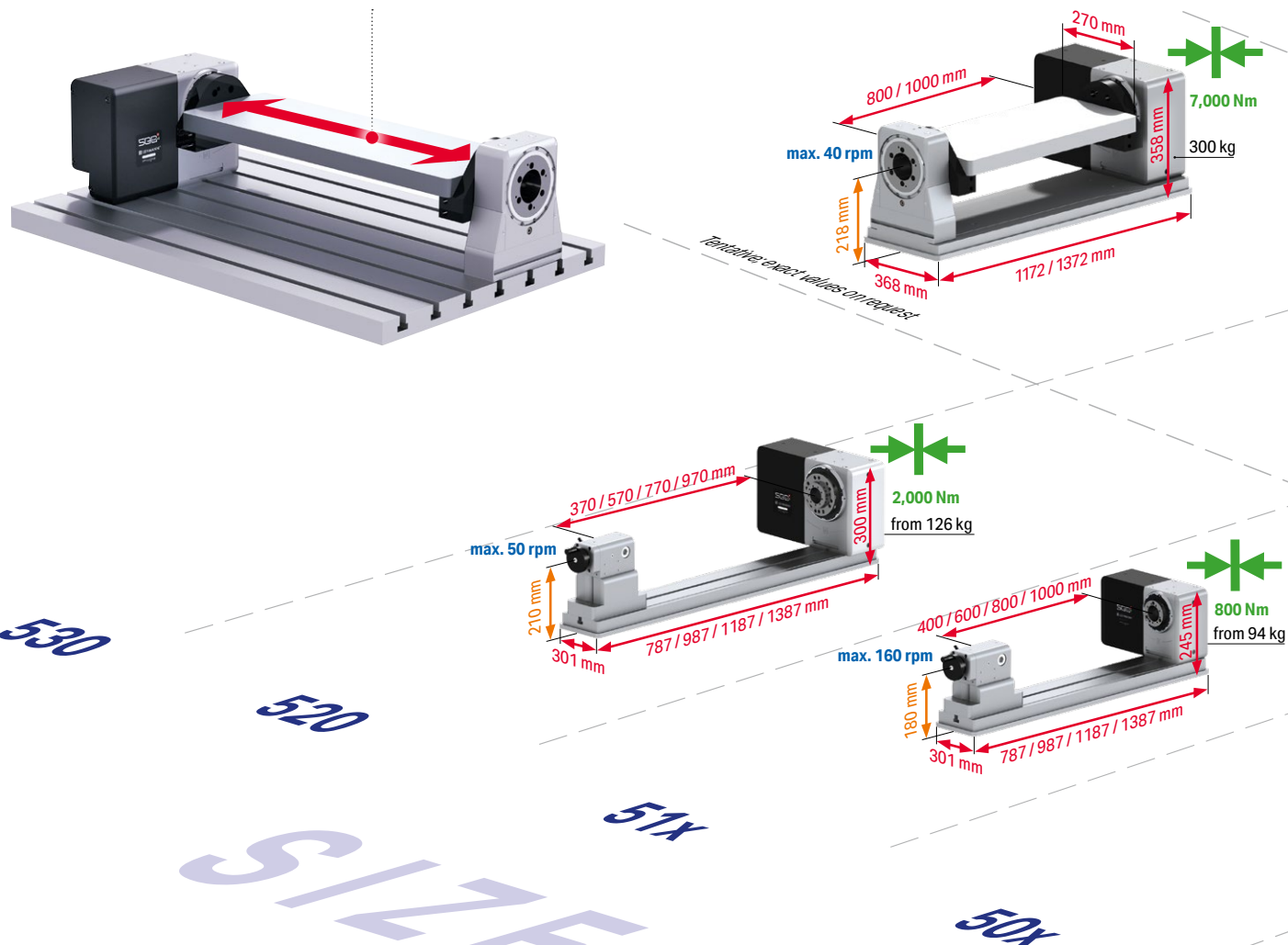
EA-530

EA-915

A diagram of a rectangular area, likely representing a field or a plot. The area is divided into three horizontal sections. The top section is green, the middle section is white, and the bottom section is green. The dimensions are labeled as follows: X is the total width, $Y1$ is the height of the top green section, $X2$ is the width of the middle white section, and $X1$ is the width of the bottom green section. A small black and white object is shown on the right side of the plot.

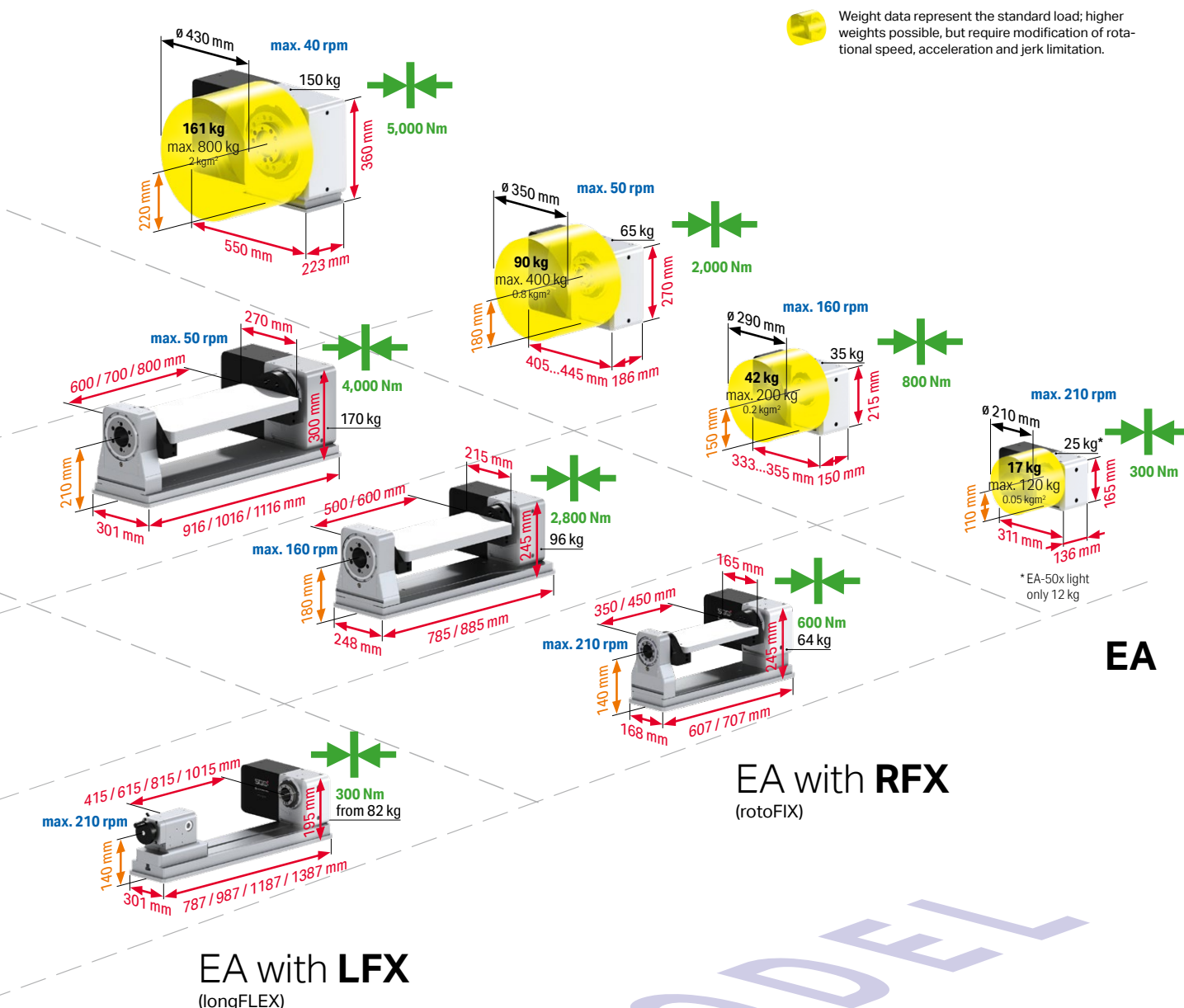
Clamping yokes for EA-type rotary tables

8

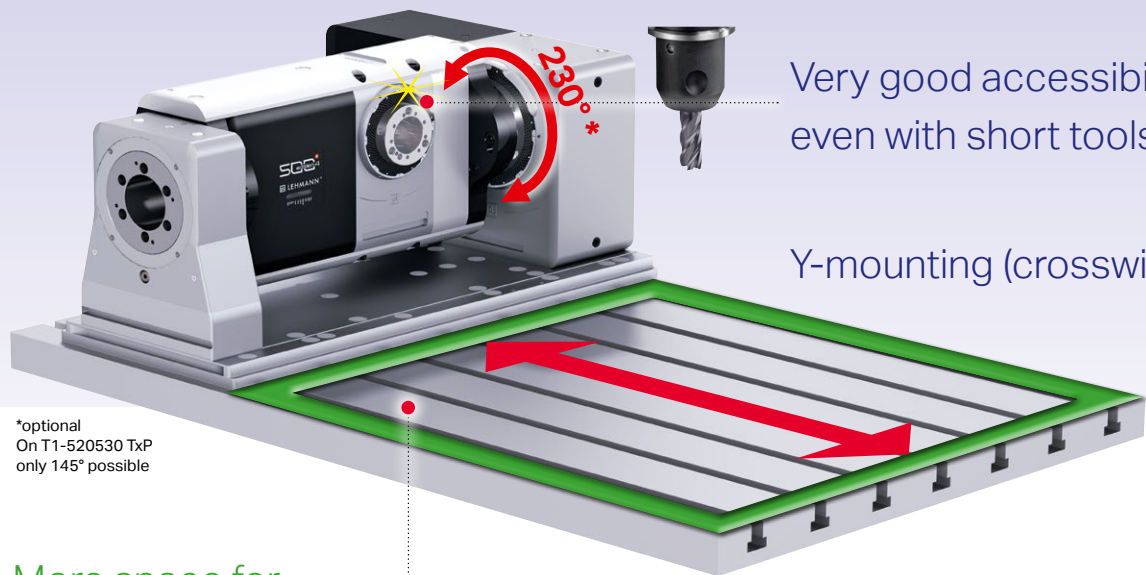


Facts

- High speed up to 210 rpm
- Steel base plates with hole pattern (suitable for slot spacing of 100 and 125 mm)
- Cycle time 90° as fast as 0.21 sec.



50x	507 (standard) or 508 (high speed)
51x	510 (standard) or 511 (high speed)
EA	single-axis, single-spindle CNC rotary table
rotoFIX	modular clamping yoke system
longFLEX	modular shaft clamping system

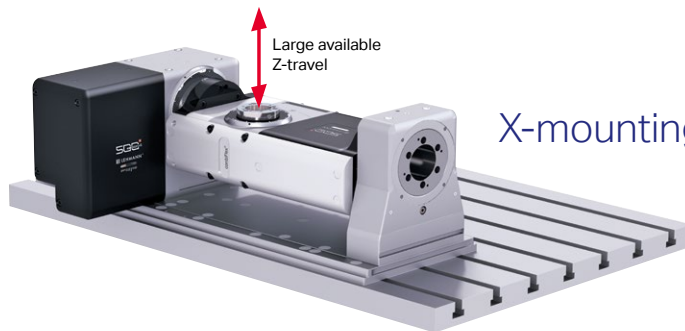


Very good accessibility,
even with short tools

Y-mounting (crosswise)

*optional
On T1-520530 TxP
only 145° possible

More space for
workpiece and fixtures



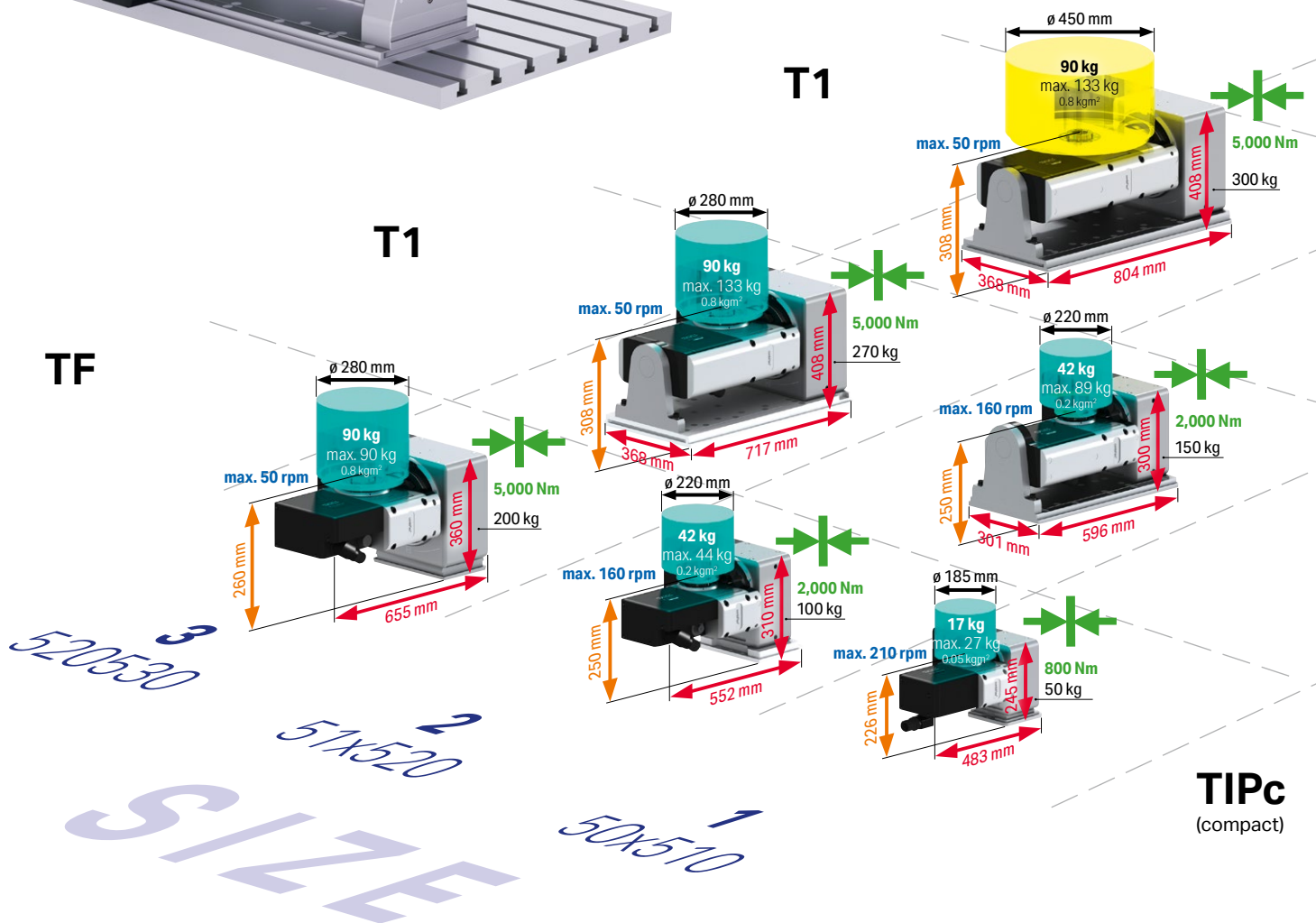
X-mounting (lengthwise)

T1

T1

T1

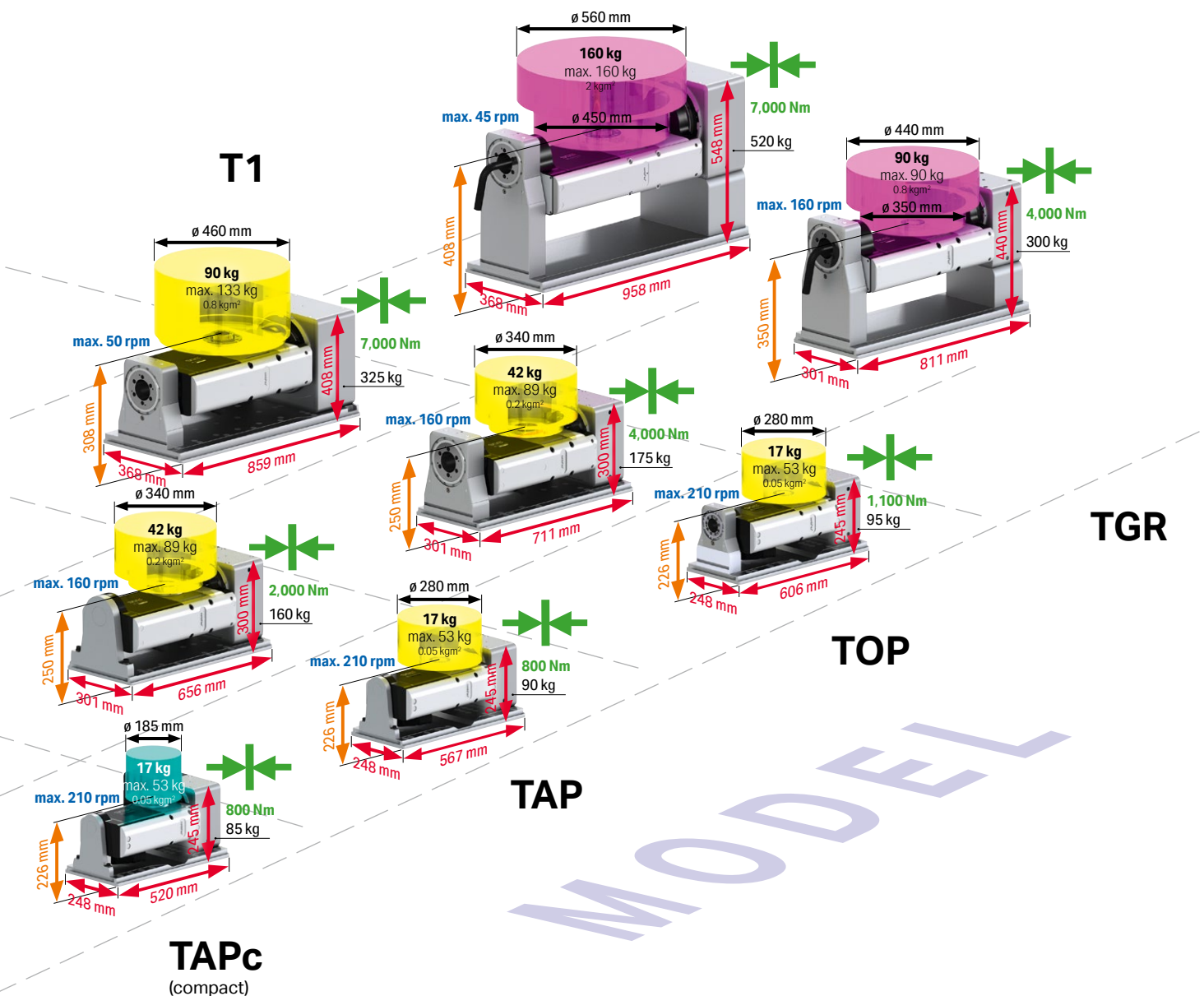
TF



TIPc
(compact)

Facts

- Up to 150 % higher clamping torque in tilting axis
- Fewer variant – more solution
- Larger workpiece $\varnothing$ possible
- Spatially optimized arrangement of the dividing axis

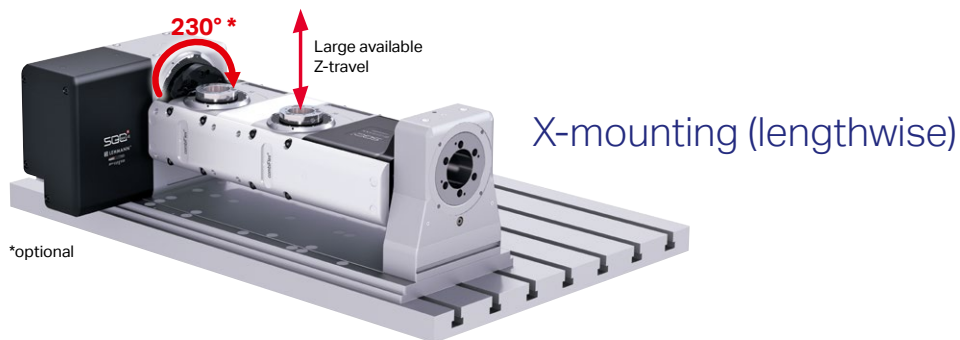


Weight data represent the standard load; higher weights possible, but require modification of rotational speed, acceleration and jerk limitation.

50x510	508510 (standard) or 508510 (high speed)
51x520	510520 (standard) or 511520 (high speed)
TIPc	Two-axis rotary table, no counter bearing, compact
TAPc	Two-axis rotary table, with supporting bearing, compact
TAP	Two-axis rotary table, with supporting bearing
TOP	Two-axis rotary table, with clamped counter bearing
TGR	Two-axis rotary table, with clamped counter bearing, specifically for grinding applications



More space for workpiece and fixtures



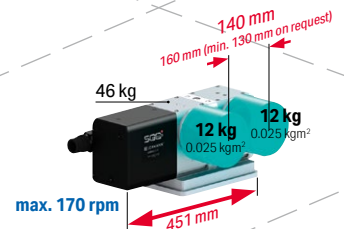
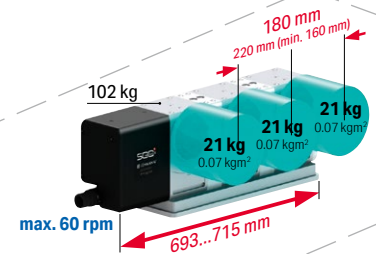
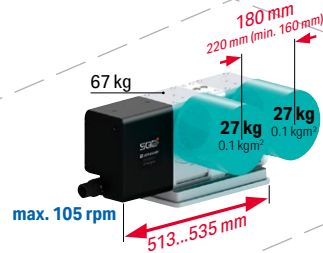
M2

M3

SIZE

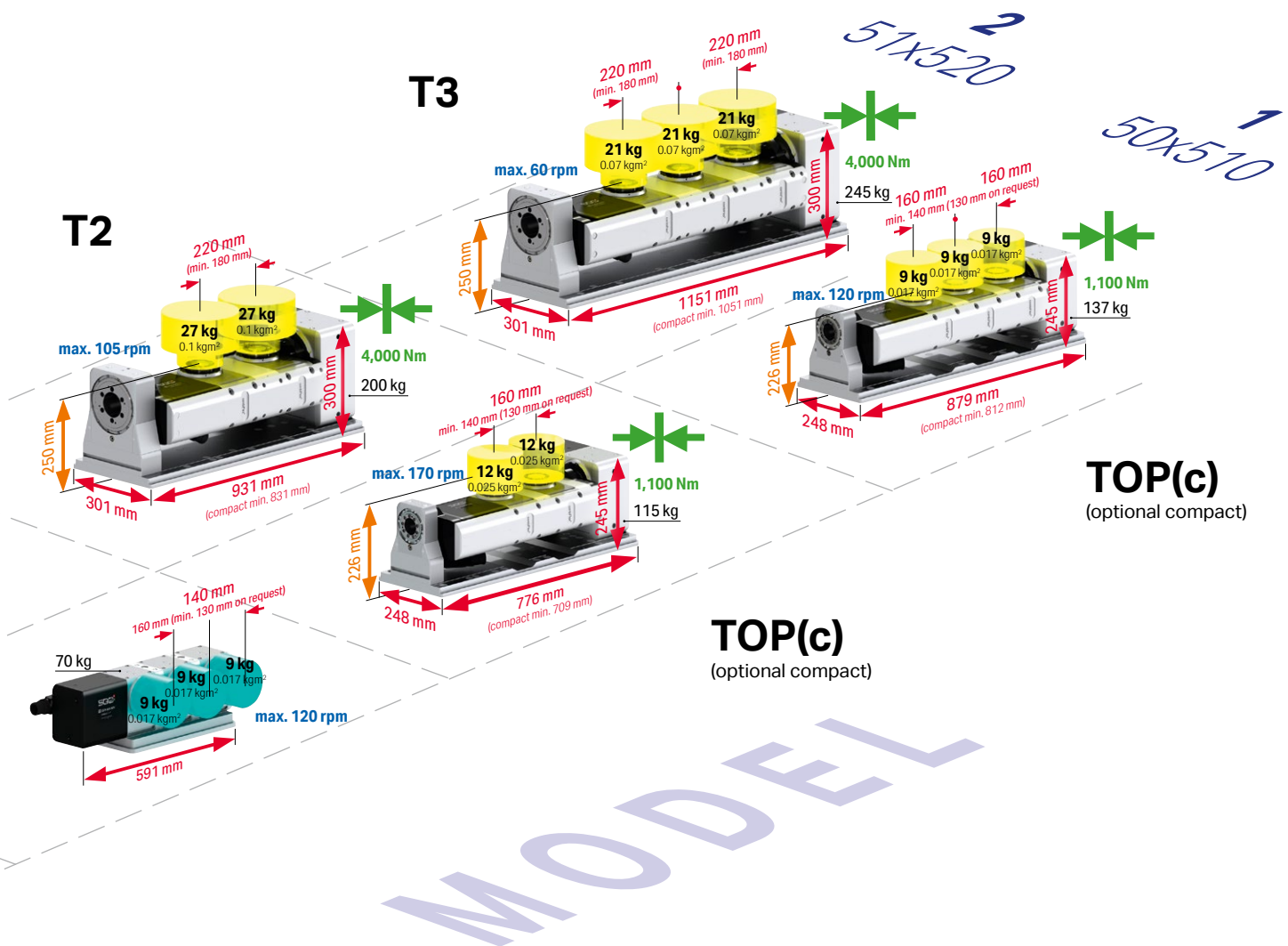
51x

50x



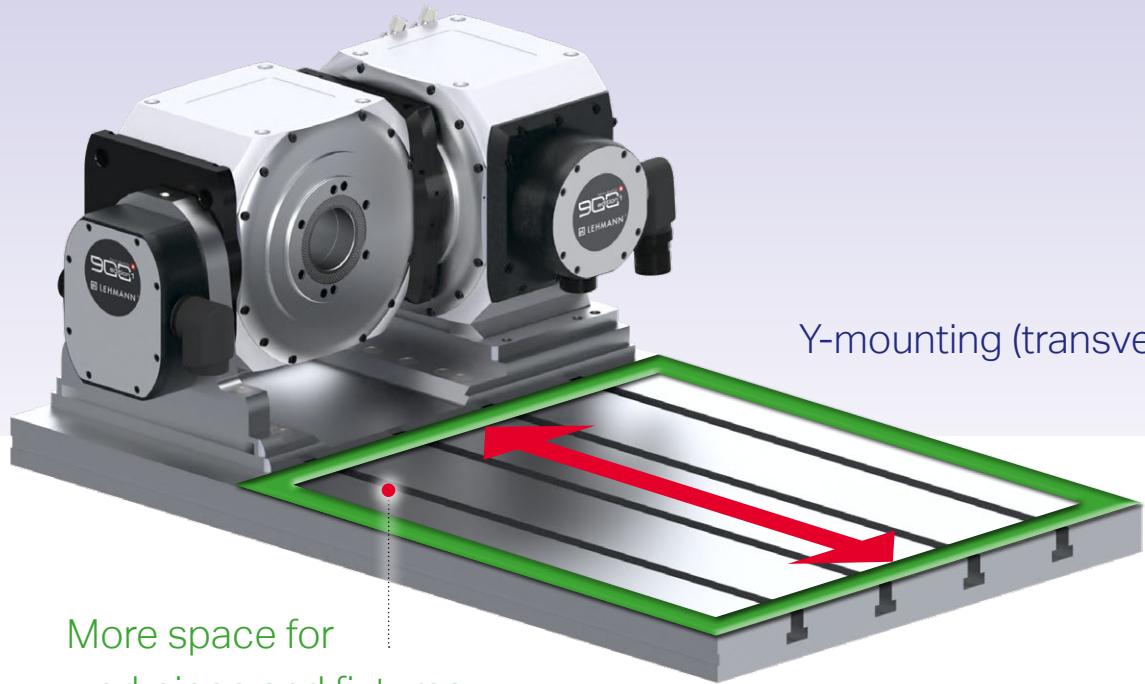
Facts

- Up to 54 % higher clamping torque in tilting axis
- Fewer variant – more solution
- Spindle distance min. 130 mm
- Spatially optimized arrangement of the dividing axis



Weight data represent the standard load; higher weights possible, but require modification of rotational speed, acceleration and jerk limitation.

- 50x 507 (standard) or 508 (high speed)
- 51x 510 (standard) or 511 (high speed)
- M2 Single-axis, multi-spindle rotary table, 2-position
- M3 Single-axis, multi-spindle rotary table, 3-position
- T2 Two-axis multi-spindle rotary table, 2-position
- T3 Two-axis multi-spindle rotary table, 3-position

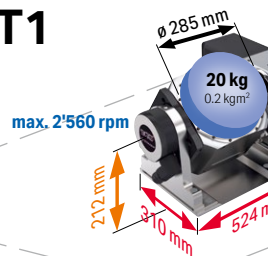


More space for
workpiece and fixtures



T1

T1



915520

913520

913918

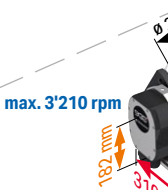
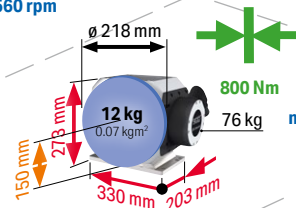
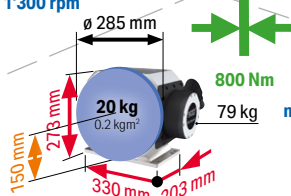
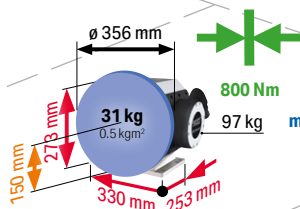
913915

918

915

913

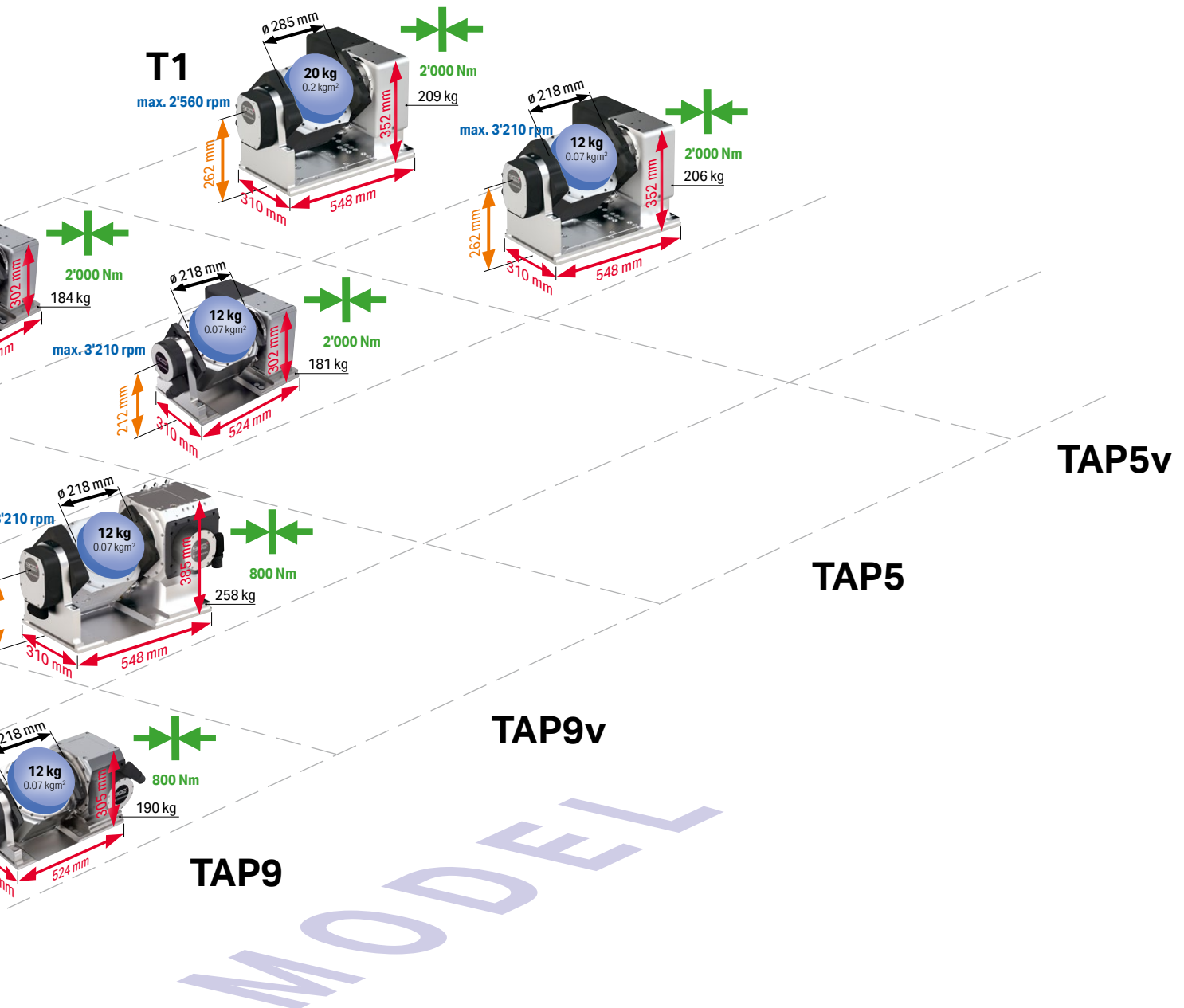
EA



SIZE

Highlights

- For millturn applications (e.g. watch cases from bar stock)
- DD up to 3,000 rpm available (up to 5,450 rpm technically possible; upon request)
- Very compact
- For Siemens, Mitsubishi, Heidenhain and Fanuc with Fanuc measuring system, 100% Fanuc DDT-compatible (other upon request)



Weight data represent the standard load; higher weights possible, but require modification of rotational speed, acceleration and jerk limitation.

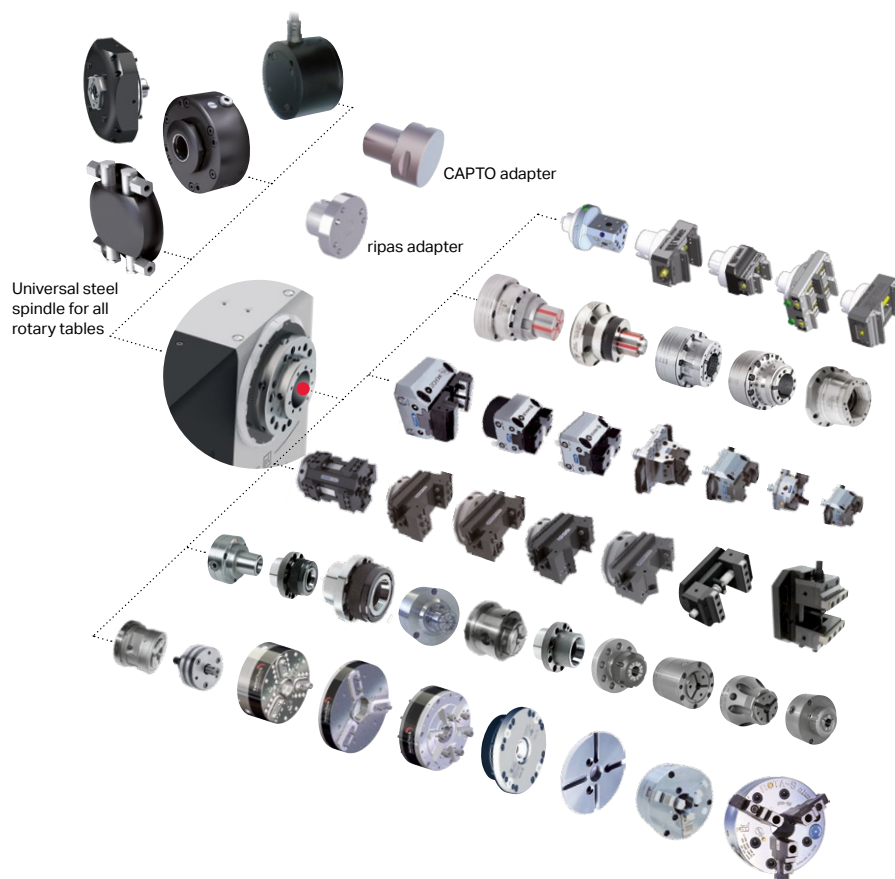
EA single-axis, single-spindle CNC rotary table
TAP two-axis rotary table, with supporting bearing
TAPv Two-axis rotary table, with support bearing, low-profile version (vario)

Feed max.: without flux weakening

Extremely wide assortment for workpiece clamping.
Standardized interface in front and rear: maximum universality

Spindle accessories, rear

- Rotary unions **up to 250 bar**
- Hydraulic clamping cylinder **23 kN at 120 bar**
- Pneumatic clamping cylinder **11 kN at 10 bar**
- Angular position measuring systems **as precise as ± 1 arcsec**



Spindle accessories in front



Tailstock and counter bearing



ripas zero point clamping system



EA-507 with ripas auto and ripas adapter

CAPTO clamping



EA-507 with CAPTO retrofit kit

Present in over 20 countries: from sales consultation to the final service



Get an offer

Please send us your request with the following information:

1. Do you need a 4th or 4th/5th axis?
2. On which machine should the rotary table get installed?
(Name and exact type; e.g. DMG MORI 850V)
3. Which controller is on the machine?
(Name and exact type; e.g. Heidenhain TNC 640)
4. What do you want to process on your machine?
 - Workpiece size
 - Weight
 - Material
 - Size of the series (number of pieces/year)
 - Loading and unloading (automatic or manual)
5. Is the machine completely prepared for the 4th or 4th/5th axis
(PLC, software activation, hardware interface)?

Services from A to Z

Pre Sales

- First class literature
- Application drawings 2D
- 3D models
- Example of applications

Sales & Post Sales

- Specified offers for each machine
- Wide range of work piece clamping systems
- Standardized interfaces

Commissioning

- Parameter lists
- Machine specified commissioning instructions
- User manual
- Partner Kit
- On-site support

After Sales

- Service points in 25 countries PTSE
- Spare parts worldwide by eShop
- In-field support by flying doctors





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Global network

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- Bosnia
- Bulgaria
- Croatia
- Czech Republic
- Denmark
- Estonia
- Finland
- France
- Germany
- Hungary
- Iceland
- Ireland
- Italy
- Kosovo

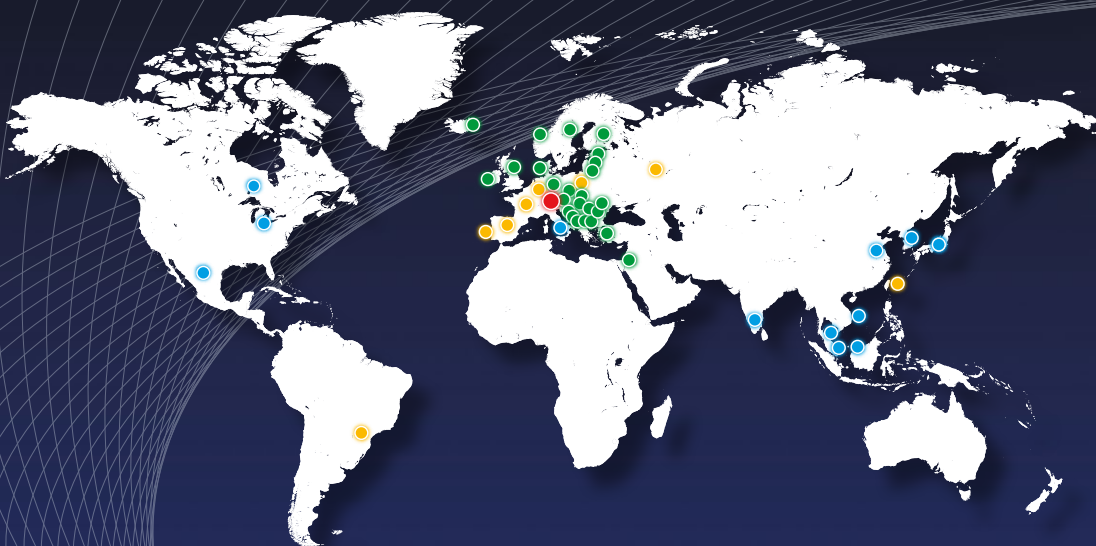
- Latvia
- Lithuania
- Macedonia
- Norway
- Poland
- Portugal
- Romania
- Russia
- Serbia
- Slovakia
- Slovenia
- Spain
- Sweden
- Turkey
- UK

America

- Brazil
- Canada
- Mexico
- USA

Asia

- China
- India
- Israel
- Japan
- Malaysia
- Singapore
- South Korea
- Taiwan
- Thailand
- Vietnam



● Headquarters ● direct sales ● pL SOLUTIONS® partner ● value added reseller & partner
More information (address, telephone number...) at www.lehmann-rotary-tables.com