



Selection Guide for CNC Rotary Tables ...

**Smart
Solution**

We will
support you

2023

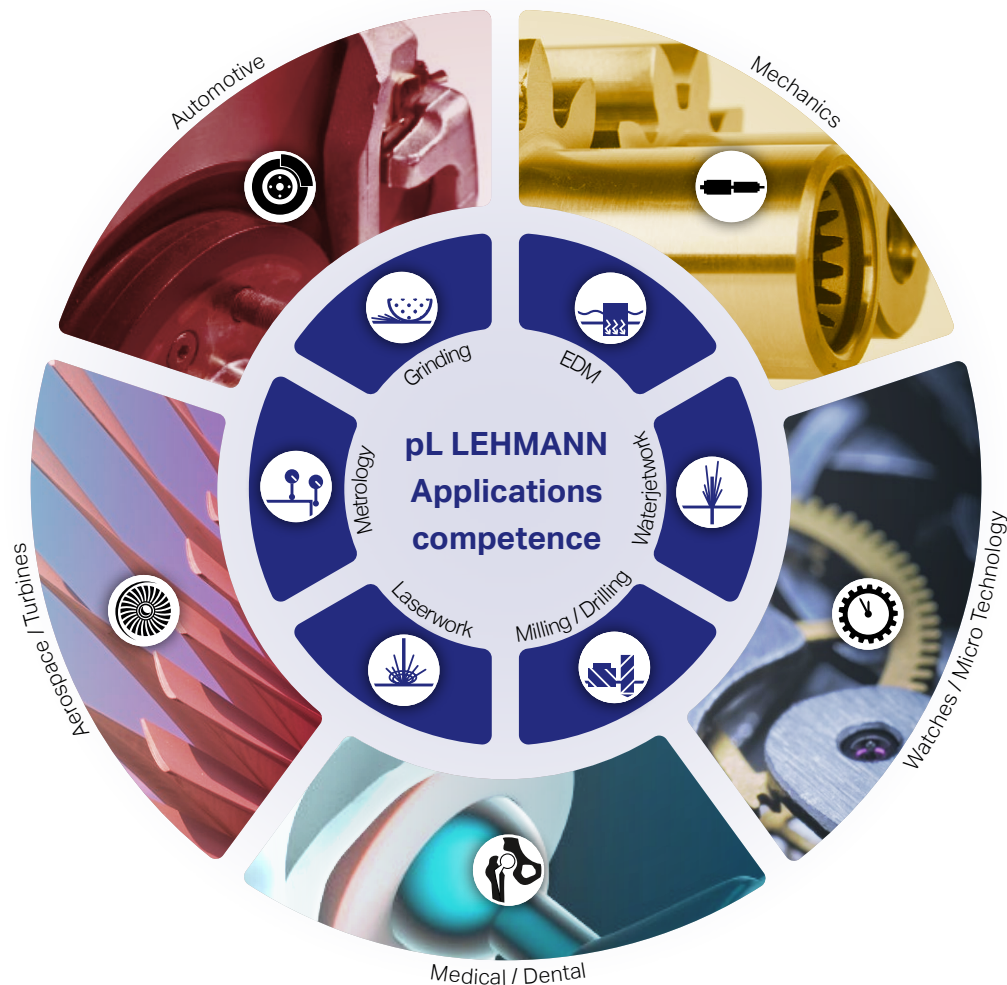
DN SOLUTIONS

01/2023 | EN



... for vertical machining centers

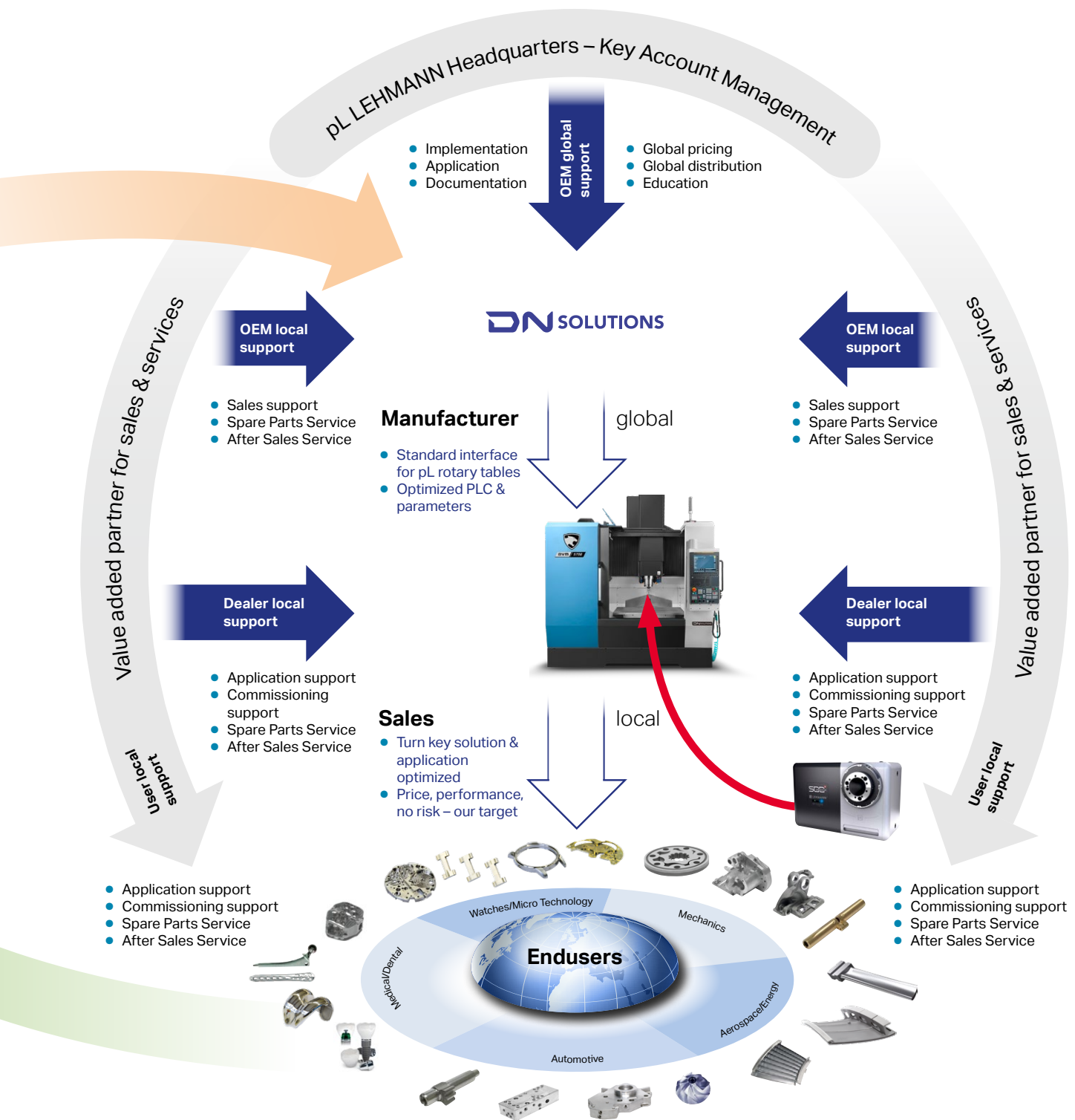
CNC rotary tables for economical manufacturing:
pL LEHMANN has suitable and rational solutions for
nearly every industry



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:
DN SOLUTIONS 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

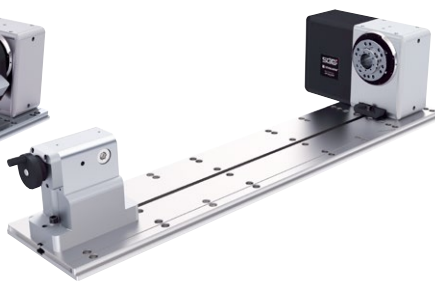
High spindle load,
heavy-duty bearing

Heavy duty

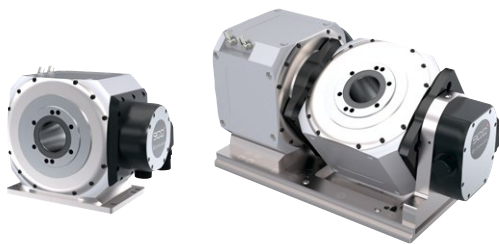
E-Series



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



BVM 5700



DNM 5700



MP 6500

A word from DN SOLUTIONS:

«DN Solutions always stands by its customers

Based on a customer-oriented approach it has pursued for the last 40 years, DN Solutions continues to strive to provide products with the highest quality in order to maximize customer satisfaction. DN Solutions's commitment to customer satisfaction stems from its powerful and successful products.»



Mynx 7500



SVM 4100



T 4000L



VC 3600

The right machine/rotary table combination
for economical production: this Selection
Guide helps you make the right selection

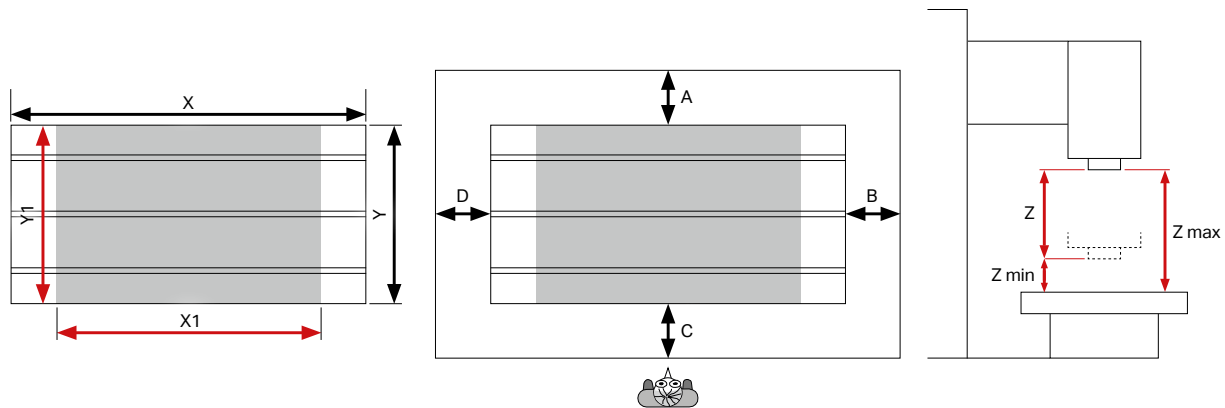


	Table diameter [mm]		Permissible overhang *	Traverse stroke [mm]					Minimum distance [mm]				Table load ** max [kg]
	X	Y		X1	Y1	Z	Zmin	Zmax	A	B	C	D	
BVM 5700	1'300	570	10%	1'050	570	460	150	610					1'000
DMP 500 2SP	1'500	570	10%	600	570	625	200	825					1'100
DMP 570/50-2SP	1'500	570	10%	600	570	625	200	825					1'100
DNM 750 II	1'630	760	10%	1'630	762	650	150	800					1'500
DNM 4000	650	400	10%	520	400	480	150	630					400
DNM 4500	1'000	450	10%	800	450	510	150	660					600
DNM 5700	1'300	570	10%	1'050	570	510	150	660					1'000
DNM 5700 L	1'500	570	10%	1'300	570	510	150	660					1'000
DNM 6700	1'500	670	10%	1'300	670	625	150	775					1'300
DNM 6700 L	1'600	670	10%	1'500	670	625	150	775					1'300
DNM 6700 XL	2'200	670	10%	2'100	670	625	150	775					1'300
DVM 500 II	1'200	540	10%	1'020	540	510	150	660					800
DVM 650 II	1'300	670	10%	1'270	670	625	150	775					1'000
MP 6500	1'200	650	10%	1'100	650	550	150	700					800
Mynx 5400 II	1'200	540	10%	1'020	550	530	150	680					1'000
Mynx 6500 II	1'400	670	10%	1'270	670	625	150	775					1'300
Mynx 7500 II	1'600	750	10%	1'525	770	625	150	775					1'500
Mynx 9500	2'500	950	10%	2'500	950	850	200	1'050					3'500
NX 5500 II	1'000	550	10%	900	550	500	150	650					700
SVM 4100	920	410	10%	770	410	510	100	610					600
T 4000 HS	650	400	10%	520	400	350	150	500					200
T 4000/HP	650	400	40%	520	400	350	150	500					300
T 4000L	850	400	40%	700	400	350	150	500					300
VC 430	712	490	0%	560	430	570	150	720					300
VC 510	860	570	0%	762	516	570	210	780					350
VC 3600	650	375	10%	520	360	465	150	615					400
VM 1260	2'800	1'260	10%	2'500	1'260	900	200	1'100					8'000
VM 5400	1'200	540	10%	1'020	540	530	150	680					800
VM 6500	1'400	670	10%	1'270	670	625	150	775					1'000
VX 6500 C/G	1'200	650	10%	1'050	650	550	150	700					800
XC 4000DA-2SP	790	300	10%	630	400	360	168	528					200

* The recommended rotary tables can overhang the machine table by so many % (e.g. 10 % means: the rotary table length can be greater than dimension Y or X by max. 10 % of the machine width Y with Y-clamping or 10 % of the table length X with X-clamping.)

** 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						
DNM 750 II		1'421	1'392			

Wherever values are listed, the combination is recommended. Empty cells mean that a combination is not possible, because the rotary table is too large, or is not recommended, because the rotary table is disproportionately small or heavier than 50% of the table load.

For further details about the rotary tables, see p. 12 and higher or refer to the main catalog

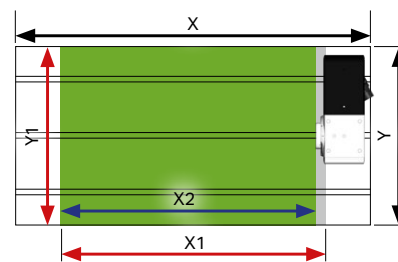


EA-510

EA-530

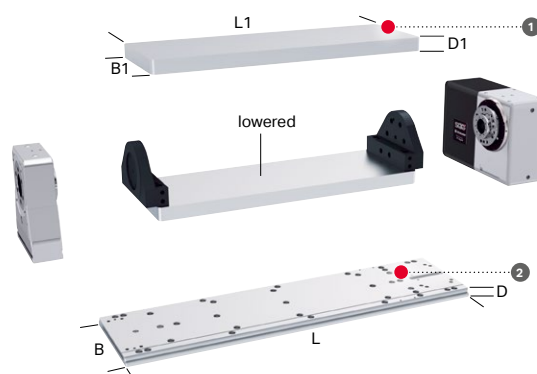
EA-915

	EA-507	EA-510	EA-520	EA-530	EA-913	EA-915	EA-918
				X2			
BVM 5700	1'008	992	966	937	972	972	922
DMP 500 2SP	883	867	841	812	847	847	797
DMP 570/50-2SP	883	867	841	812	847	847	797
DNM 750 II			1'421	1'392			
DNM 4000	418	402	376		382	382	332
DNM 4500	733	717	691		697	697	647
DNM 5700	1'008	992	966	937	972	972	922
DNM 5700 L	1'233	1'217	1'191	1'162	1'197	1'197	1'147
DNM 6700			1'191	1'162			
DNM 6700 L			1'341	1'312			
DNM 6700 XL			1'941	1'912			
DVM 500 II	943	927	901	872	907	907	857
DVM 650 II			1'076	1'047			
MP 6500		967	941	912	947	947	897
Mynx 5400 II	943	927	901	872	907	907	857
Mynx 6500 II			1'126	1'097			
Mynx 7500 II			1'354	1'325			
Mynx 9500				2'262			
NX 5500 II	783	767	741	712	747	747	697
SVM 4100	678	662	636		642	642	592
T 4000 HS	418	402	376		382	382	332
T 4000/HP	418	402	376	347	382	382	332
T 4000L	608	592	566	537	572	572	522
VC 430	469	453	427		433	433	383
VC 510	644	628	602	573	608	608	558
VC 3600	418	402	376		382	382	332
VM 1260							
VM 5400	943	927	901	872	907	907	857
VM 6500			1'126	1'097			
VX 6500 C/G		942	916	887	922	922	872
XC 4000DA-2SP	543				507	507	457



Rotary table installation with pL clamping claws in accordance with the operating manual

Clamping yokes for EA-type rotary tables



			EA-507		EA-510		EA-520			EA-530	
1 Clamping yokes	Sph	[mm]	140		180		210			218	
	Length L1	[mm]	350	450	500	600	600	700	800	800	1000
	Width B1	[mm]	165		215		270			270	
	Thickness D1	[mm]	20		35		40			40	
2 Base plates	Length L	[mm]	622	722	785	885	916	1016	1116	1172	1372
	Width B	[mm]	168		248		301			368	
	Thickness D	[mm]	30		30		30			38	
Weights / moments of inertia (without rotary table, without counter bearing)	Weight (Al)	[kg]	10	12	23	28	40	45	52	on request	
	Weight (steel)	[kg]	29	34	66	80	117	130	152		
	Mom. inert. (Al)	[kgm ²]	0.02	0.02	0.06	0.07	0.16	0.17	0.21		
	Mom. inert. (steel)	[kgm ²]	0.04	0.05	0.17	0.21	0.46	0.50	0.60		

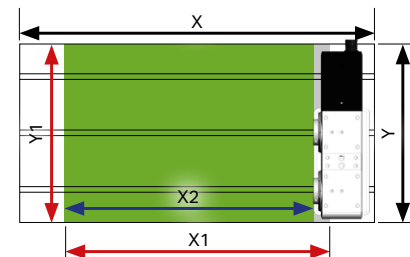
Explanations for pp. 8 to 11

The recommendations are for information purposes only. We recommend that you verify the effective dimensions prior to ordering. Modifications on the machine can lead to collisions and affect the dimensions X2 and Y2.



	M2-507	M2-510	M3-507	M3-510
	X2			
BVM 5700	949	939	949	
DMP 500 2SP	824	814	824	
DMP 570/50-2SP	824	814	824	
DNM 750 II	1'404	1'394	1'404	1'394
DNM 4000				
DNM 4500	674			
DNM 5700	949	939	949	
DNM 5700 L	1'174	1'164	1'174	
DNM 6700	1'174	1'164	1'174	1'164
DNM 6700 L	1'324	1'314	1'324	1'314
DNM 6700 XL	1'924	1'914	1'924	1'914
DVM 500 II	884	874	884	
DVM 650 II	1'059	1'049	1'059	1'049
MP 6500	924	914	924	914
Mynx 5400 II	884	874	884	
Mynx 6500 II	1'109	1'099	1'109	1'099
Mynx 7500 II	1'337	1'327	1'337	1'327
Mynx 9500		2'264	2'274	2'264
NX 5500 II	724	714	724	
SVM 4100	619			
T 4000 HS				
T 4000/HP	359	349		
T 4000L	549	539		
VC 430	410			
VC 510	585	575		
VC 3600				
VM 1260				2'414
VM 5400	884	874	884	
VM 6500	1'109	1'099	1'109	1'099
VX 6500 C/G	899	889	899	889
XC 4000DA-2SP				

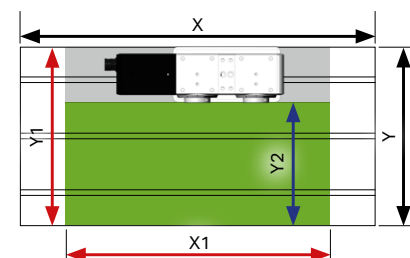
Y-mounting



Rotary table installation with pL clamping claws in accordance with the operating manual

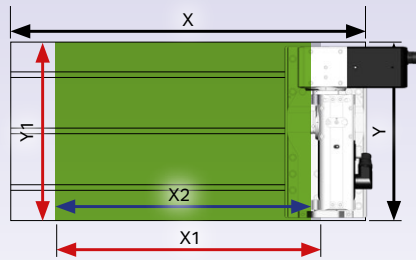
	M2-507	M2-510	M3-507	M3-510
	Y2			
BVM 5700				334
DMP 500 2SP				
DMP 570/50-2SP				
DNM 750 II				
DNM 4000	174	164	174	164
DNM 4500		214	224	214
DNM 5700				334
DNM 5700 L				
DNM 6700				
DNM 6700 L				
DNM 6700 XL				
DVM 500 II				304
DVM 650 II				
MP 6500				309
Mynx 5400 II				
Mynx 6500 II				
Mynx 7500 II				
Mynx 9500				
NX 5500 II				314
SVM 4100		174	184	174
T 4000 HS	174	164	174	164
T 4000/HP			174	164
T 4000L			174	164
VC 430		224	234	224
VC 510			317	307
VC 3600	142	132	142	132
VM 1260				
VM 5400				304
VM 6500				
VX 6500 C/G				
XC 4000DA-2SP	124	114	124	114

X-mounting



Rotary table installation with pL clamping claws in accordance with the operating manual

Y-mounting



Rotary table installation using hole pattern in base plate



TIP1



TAP1

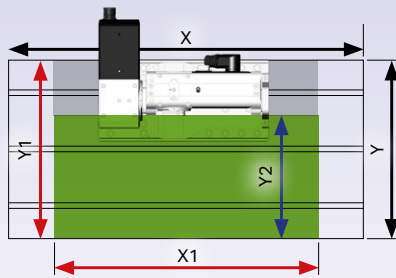


TOP1.2

	TIP1c TF-507510	TIP2c TF-510520	TIP3c TF-520530	TAP1c T1-507510	TAP2c T1-510520	TAP3c T1-520530	TAP1 T1-507510	TAP2 T1-510520	TAP3 T1-520530	TAP5 T1-913520	TAP5v T1-913520	TAP9 T1-913915
	X2											
BVM 5700	1'045	1'001		1'005	985		1'005			955	973	953
DMP 500 2SP	920	876		880	860		880			830	848	828
DMP 570/50-2SP	920	876		880	860		880			830	848	828
DNM 750 II	1'500	1'456	1'436	1'460	1'440	1'406	1'460	1'440	1'406	1'410	1'428	1'408
DNM 4000												
DNM 4500	770											
DNM 5700	1'045	1'001		1'005	985		1'005			955	973	953
DNM 5700 L	1'270	1'226		1'230	1'210		1'230			1'180	1'198	1'178
DNM 6700	1'270	1'226	1'206	1'230	1'210	1'176	1'230	1'210		1'180	1'198	1'178
DNM 6700 L	1'420	1'376	1'356	1'380	1'360	1'326	1'380	1'360		1'330	1'348	1'328
DNM 6700 XL	2'020	1'976	1'956	1'980	1'960	1'926	1'980	1'960		1'930	1'948	1'928
DVM 500 II	980	936		940			940			890		
DVM 650 II	1'155	1'111	1'091	1'115	1'095	1'061	1'115	1'095		1'065	1'083	1'063
MP 6500	1'020	976	956	980	960	926	980	960		930	948	928
Mynx 5400 II	980	936		940			940			890		
Mynx 6500 II	1'205	1'161	1'141	1'165	1'145	1'111	1'165	1'145		1'115	1'133	1'113
Mynx 7500 II	1'433	1'389	1'369	1'393	1'373	1'339	1'393	1'373	1'339	1'343	1'361	1'341
Mynx 9500		2'326	2'306	2'330	2'310	2'276	2'330	2'310	2'276	2'280	2'298	2'278
NX 5500 II	820	776		780	760		780			730		728
SVM 4100												
T 4000 HS												
T 4000/HP	455	411		415								
T 4000L	645	601		605								
VC 430	506											
VC 510	681	637		641			641					
VC 3600												
VM 1260						2'426		2'460	2'426			
VM 5400	980	936		940			940			890		
VM 6500	1'205	1'161	1'141	1'165	1'145	1'111	1'165	1'145		1'115	1'133	1'113
VX 6500 C/G	995	951	931	955	935	901	955	935		905	923	903
XC 4000DA-2SP												

	TAP9v T1-913918	TOP1 T1-507510	TOP2 T1-510520	TOP3 T1-520530	TAP1c.2 T1-507510	TAP2c.2 T1-510520	TAP3c.2 T1-520530	TAP1.2 T1-507510	TAP2.2 T1-510520	TAP3.2 T1-520530	TOP1.2 T2-507510	TOP2.2 T2-510520	TOP3.2 T2-520530
	X2												
BVM 5700		1'005											
DMP 500 2SP		880											
DMP 570/50-2SP		880											
DNM 750 II	1'427	1'460	1'440	1'406	1'460	1'440		1'460			1'460		
DNM 4000													
DNM 4500													
DNM 5700		1'005											
DNM 5700 L		1'230											
DNM 6700	1'197	1'230	1'210		1'230			1'230					
DNM 6700 L	1'347	1'380	1'360		1'380			1'380					
DNM 6700 XL	1'947	1'980	1'960		1'980			1'980					
DVM 500 II													
DVM 650 II	1'082	1'115	1'095		1'115			1'115					
MP 6500	947	980	960		980			980					
Mynx 5400 II													
Mynx 6500 II	1'132	1'165	1'145		1'165			1'165					
Mynx 7500 II	1'360	1'393	1'373		1'393	1'373		1'393			1'393		
Mynx 9500	2'297	2'330	2'310	2'276	2'330	2'310		2'330	2'310		2'330	2'310	
NX 5500 II													
SVM 4100													
T 4000 HS													
T 4000/HP													
T 4000L													
VC 430													
VC 510													
VC 3600													
VM 1260	2'447		2'460	2'426	2'480	2'460	2'426	2'480	2'460	2'426	2'480	2'460	2'426
VM 5400													
VM 6500	1'132	1'165	1'145		1'165			1'165					
VX 6500 C/G	922	955	935		955			955					
XC 4000DA-2SP													

X-mounting



Rotary table installation using hole pattern in base plate



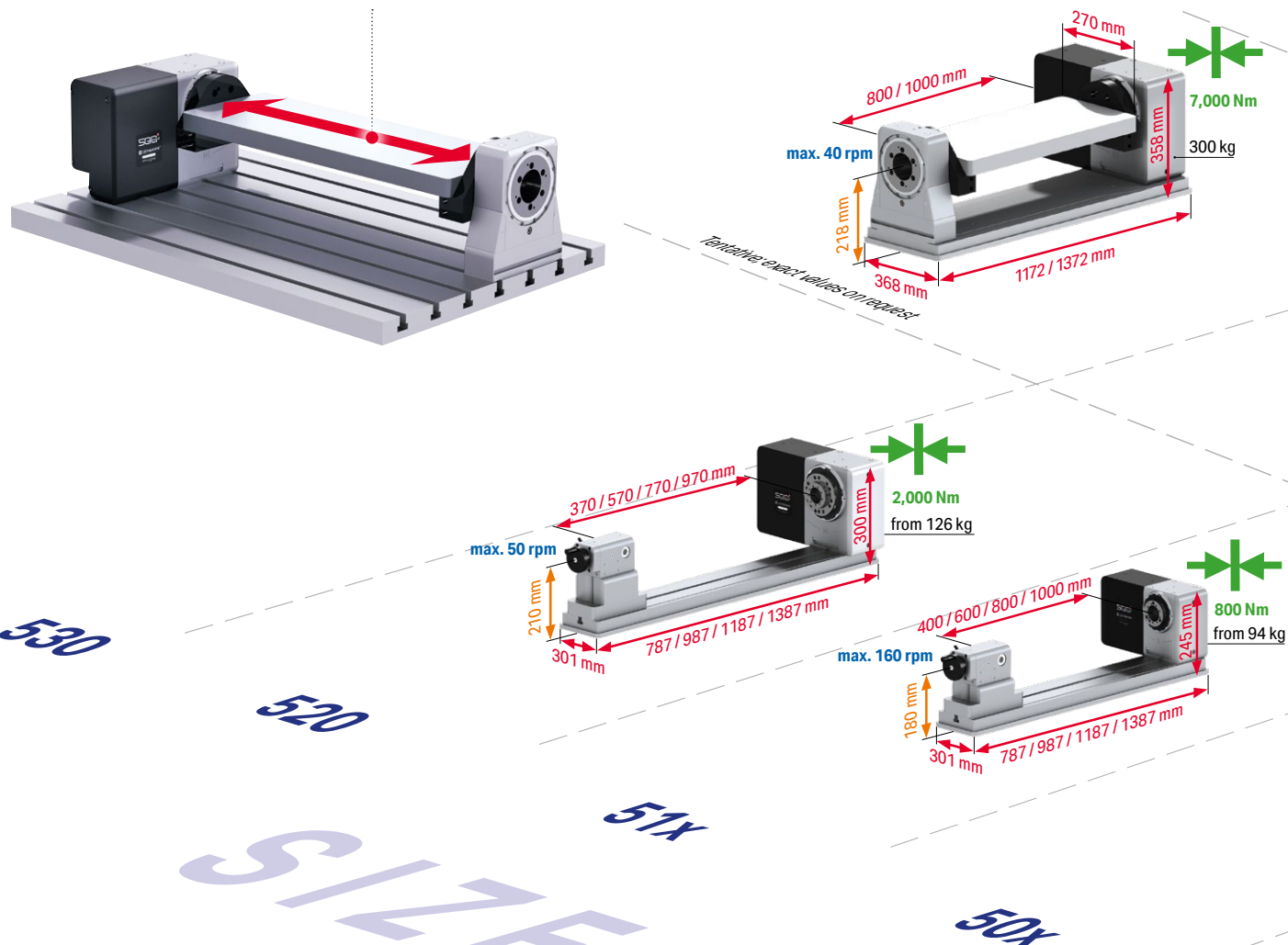
TAP9



TAP5v

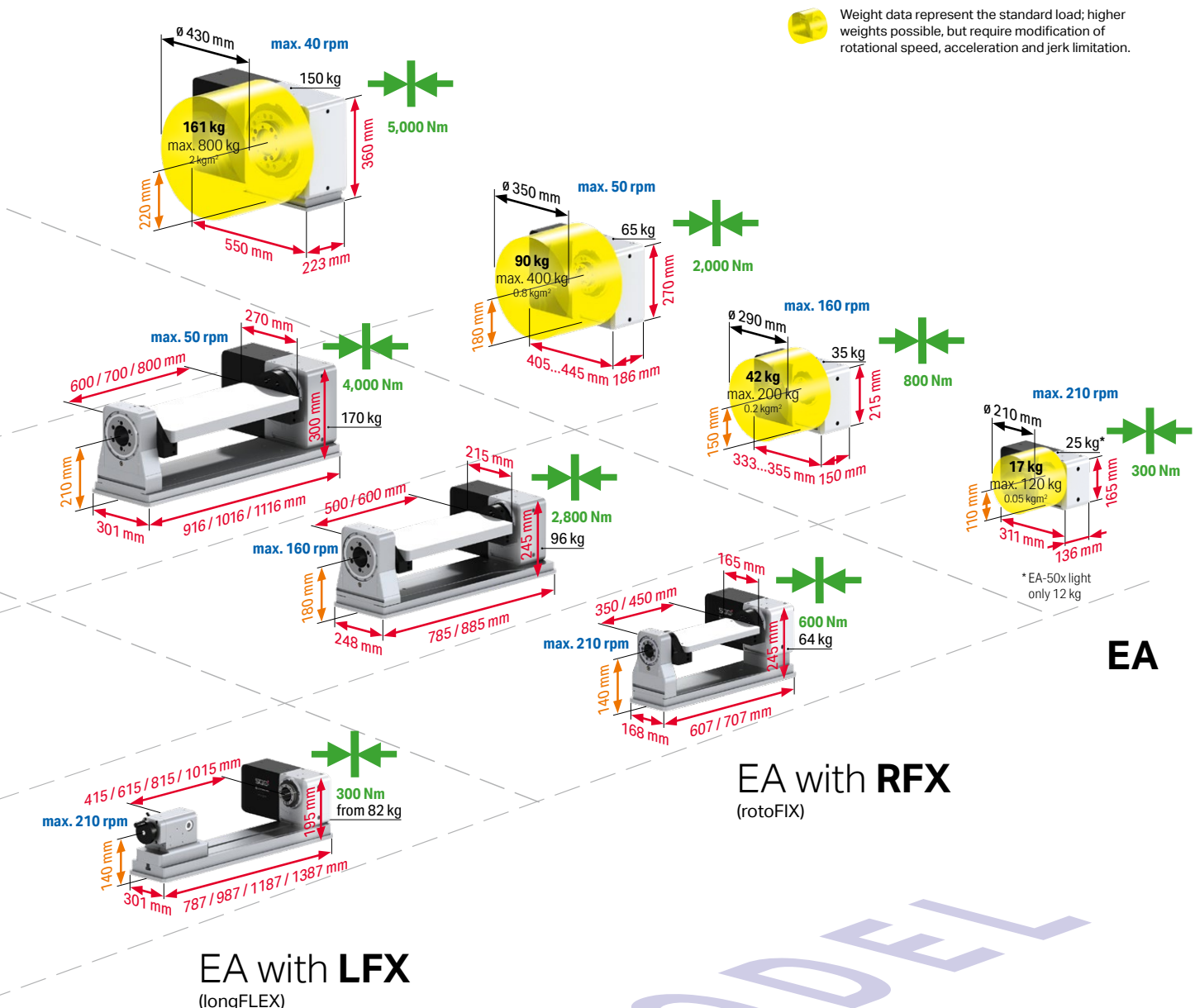
	TIP1c TF-507510	TIP2c TF-510520	TIP3c TF-520530	TAP1c T1-507510	TAP2c T1-510520	TAP3c T1-520530	TAP1 T1-507510	TAP2 T1-510520	TAP3 T1-520530	TAP5 T1-913520	TAP5v T1-913520	TAP9 T1-913915
	Y2											
BVM 5700						346		380	346			
DMP 500 2SP									346			
DMP 570/50-2SP									346			
DNM 750 II												
DNM 4000	270	226	206	230	210	176	230	210		180	198	178
DNM 4500		276	256	280	260	226	280	260	226	230	248	228
DNM 5700						346		380	346			
DNM 5700 L									346			
DNM 6700									446			
DNM 6700 L												
DNM 6700 XL												
DVM 500 II			346			316		350	316		338	
DVM 650 II									446			
MP 6500									426			
Mynx 5400 II			351			321		355	321		343	
Mynx 6500 II									446			
Mynx 7500 II												
Mynx 9500												
NX 5500 II			356			326		360	326		348	
SVM 4100	280	236	216	240	220	186	240	220	186	190	208	188
T 4000 HS	270	226		230			230					
T 4000/HP			206		210		230	210		180	198	178
T 4000L			206		210		230	210		180	198	178
VC 430		286	266	290	270		290	270		240	258	238
VC 510			349		353			353		323	341	321
VC 3600	238	194	174	198	178	144	198	178		148	166	146
VM 1260												
VM 5400			346			316		350	316		338	
VM 6500									446			
VX 6500 C/G									426			
XC 4000DA-2SP	220	176		180			180					

	TAP9v T1-913918	TOP1 T1-507510	TOP2 T1-510520	TOP3 T1-520530	TAP1c.2 T1-507510	TAP2c.2 T1-510520	TAP3c.2 T1-520530	TAP1.2 T1-507510	TAP2.2 T1-510520	TAP3.2 T1-520530	TOP1.2 T2-507510	TOP2.2 T2-510520	TOP3.2 T2-520530
	Y2												
BVM 5700	367		380	346	400	380	346	400	380	346	400	380	346
DMP 500 2SP				346		380	346		380	346		380	346
DMP 570/50-2SP				346		380	346		380	346		380	346
DNM 750 II							537		571	537		571	537
DNM 4000	197	230	210		230			230					
DNM 4500	247	280	260	226	280	260		280	260		280	260	
DNM 5700	367		380	346	400	380	346	400	380	346	400	380	346
DNM 5700 L				346		380	346		380	346		380	346
DNM 6700				446		480	446		480	446		480	446
DNM 6700 L				446		480	446		480	446		480	446
DNM 6700 XL							446			446			446
DVM 500 II	337	370	350	316	370	350	316	370	350	316	370	350	316
DVM 650 II				446		480	446		480	446	500	480	446
MP 6500				426		460	426		460	426	480	460	426
Mynx 5400 II	342	375	355	321	375	355	321	375	355	321	375	355	321
Mynx 6500 II				446		480	446		480	446	500	480	446
Mynx 7500 II				536			536		570	536		570	536
Mynx 9500													726
NX 5500 II	347	380	360	326	380	360		380	360		380	360	
SVM 4100	207	240	220	186	240	220		240	220		240	220	
T 4000 HS		230			230			230					
T 4000/HP		230	210		230			230					
T 4000L		230	210		230	210		230	210		230	210	
VC 430		290	270		290			290			290		
VC 510		373	353		373	353		373	353		373	353	
VC 3600	165	198	178		198			198					
VM 1260													
VM 5400	337	370	350	316	370	350	316	370	350	316	370	350	316
VM 6500				446		480	446		480	446	500	480	446
VX 6500 C/G				426		460	426		460	426	480	460	426
XC 4000DA-2SP		180			180			180			180		

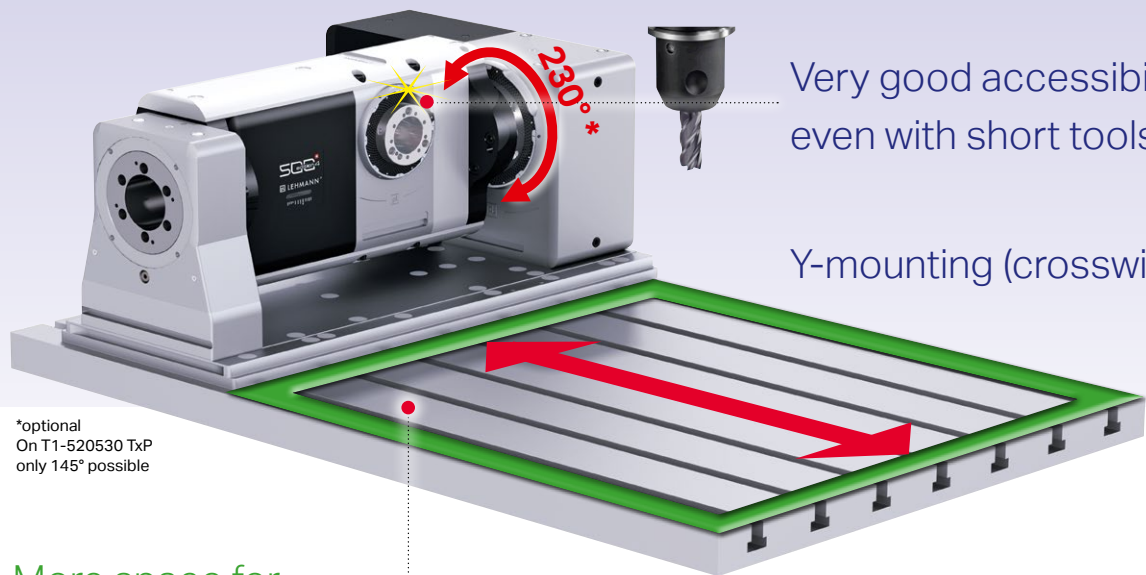


Facts

- High speed up to 210 rpm
- Feed torque up to 850 Nm (tentative)
- 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

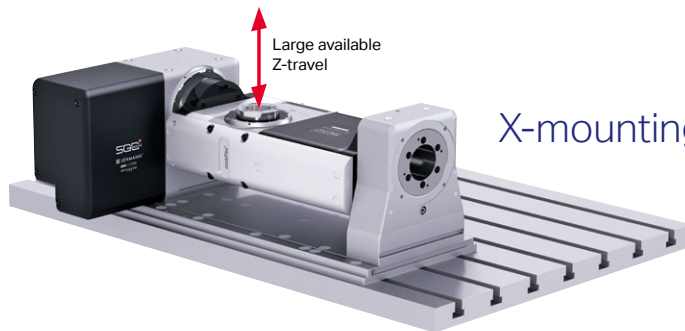


Very good accessibility,
even with short tools

Y-mounting (crosswise)

*optional
On T1-520530 TxP
only 145° possible

More space for
workpiece and fixtures



Large available
Z-travel

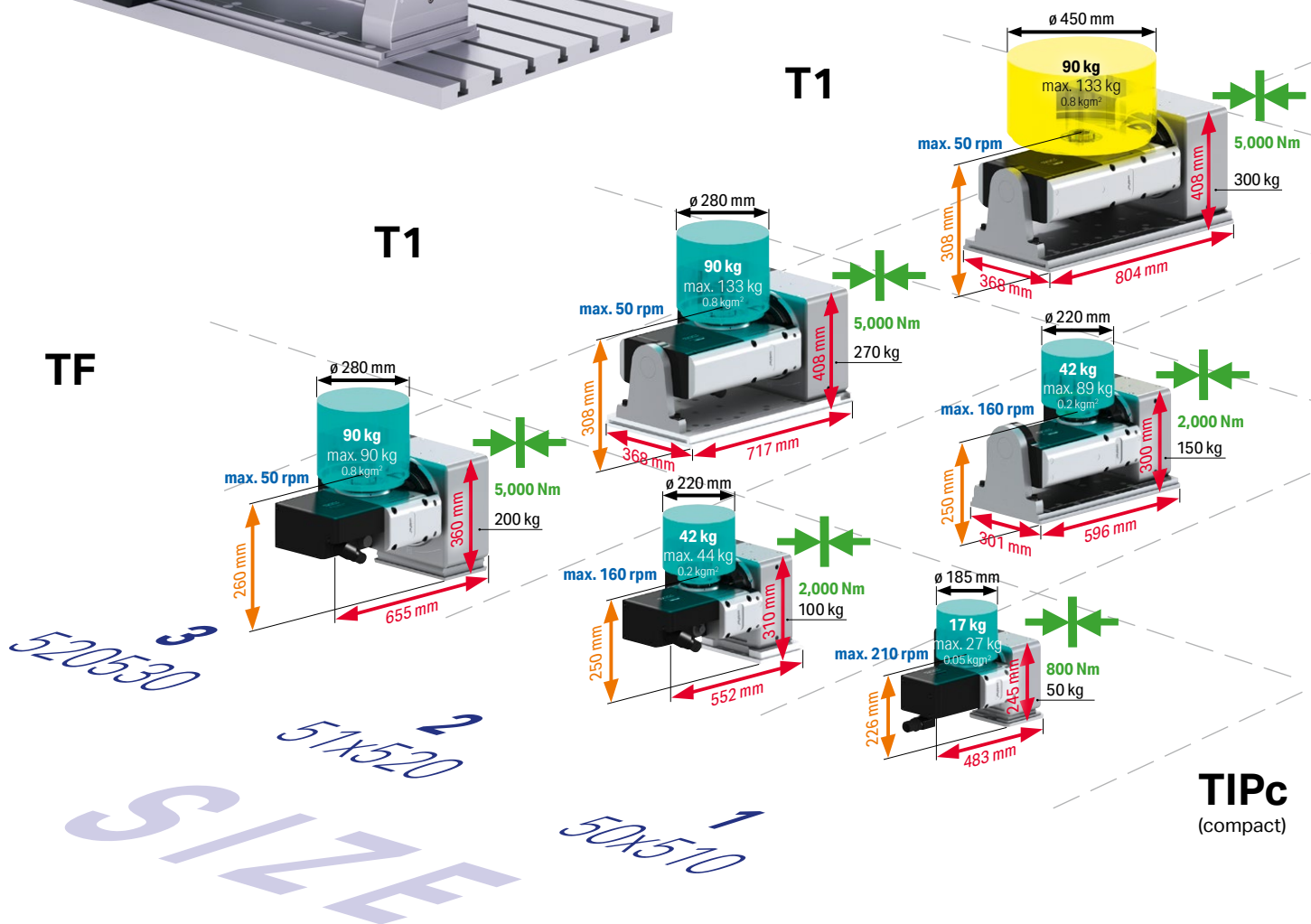
X-mounting (lengthwise)

T1

T1

T1

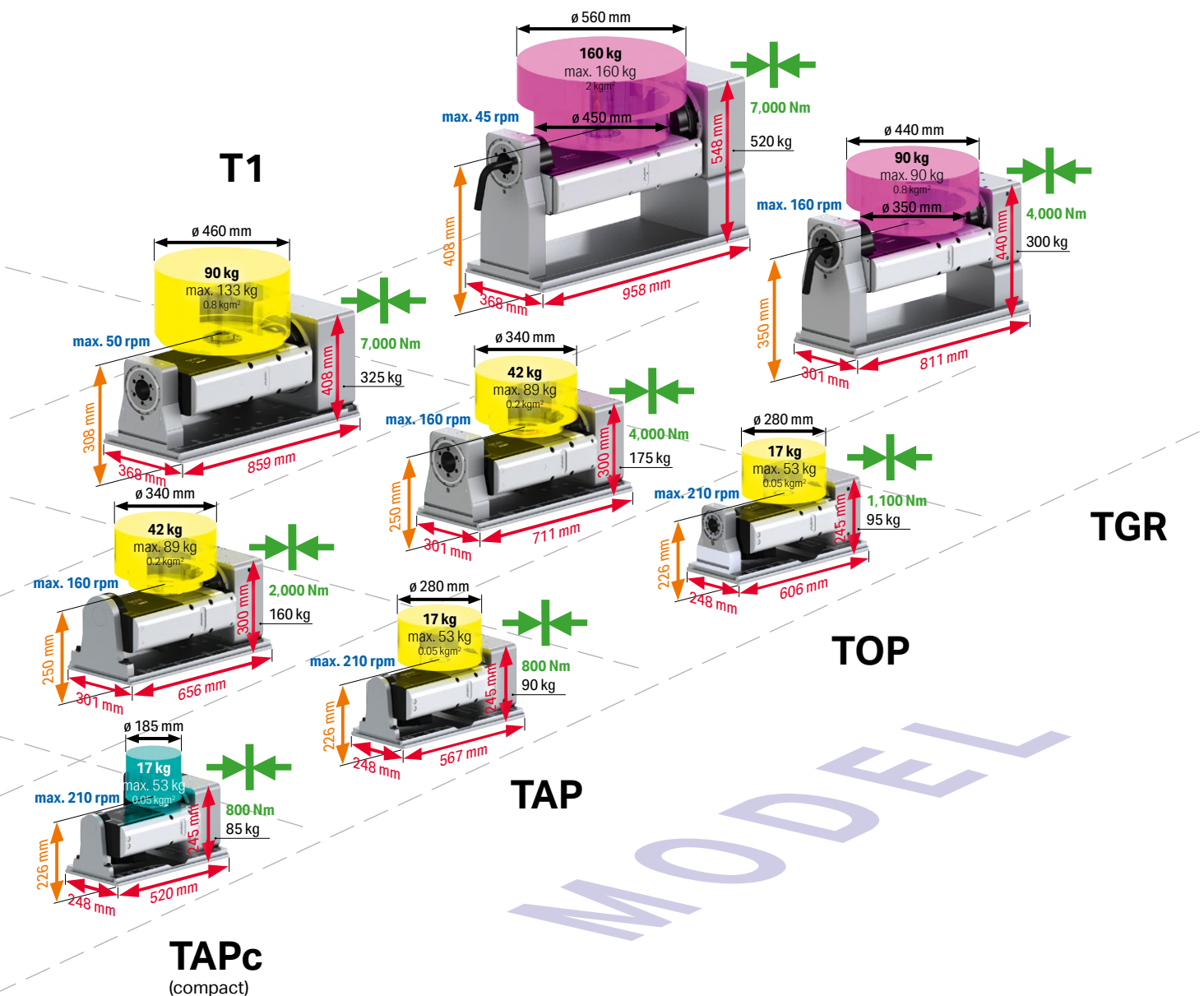
TF



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

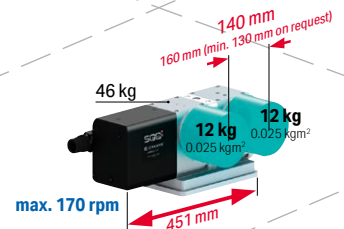
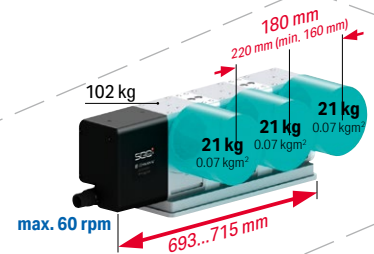
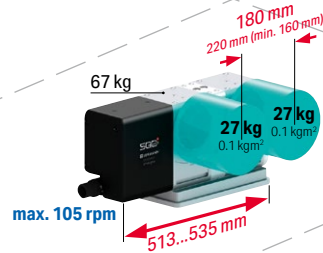


M2

M3

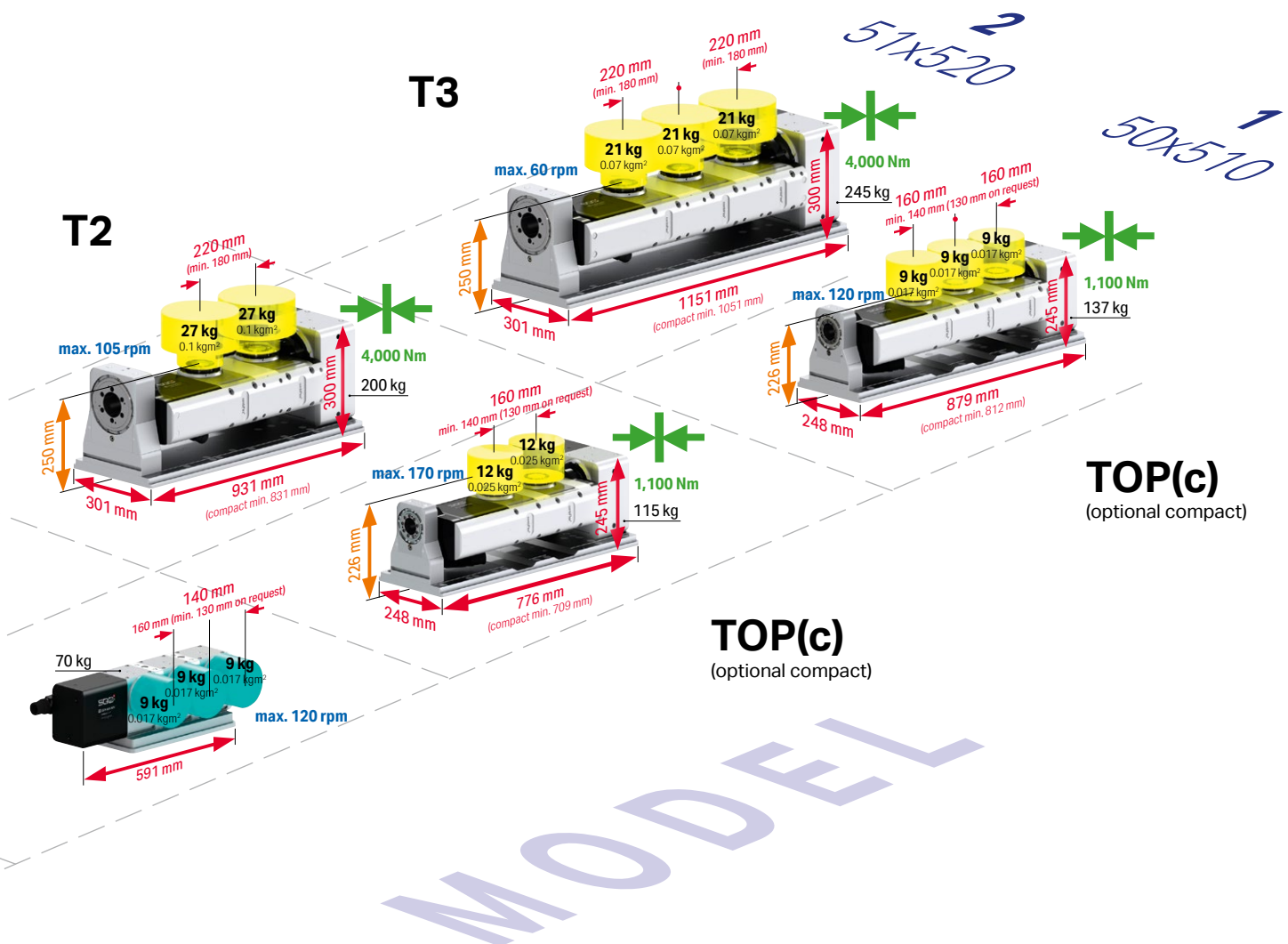
SIZE

50x



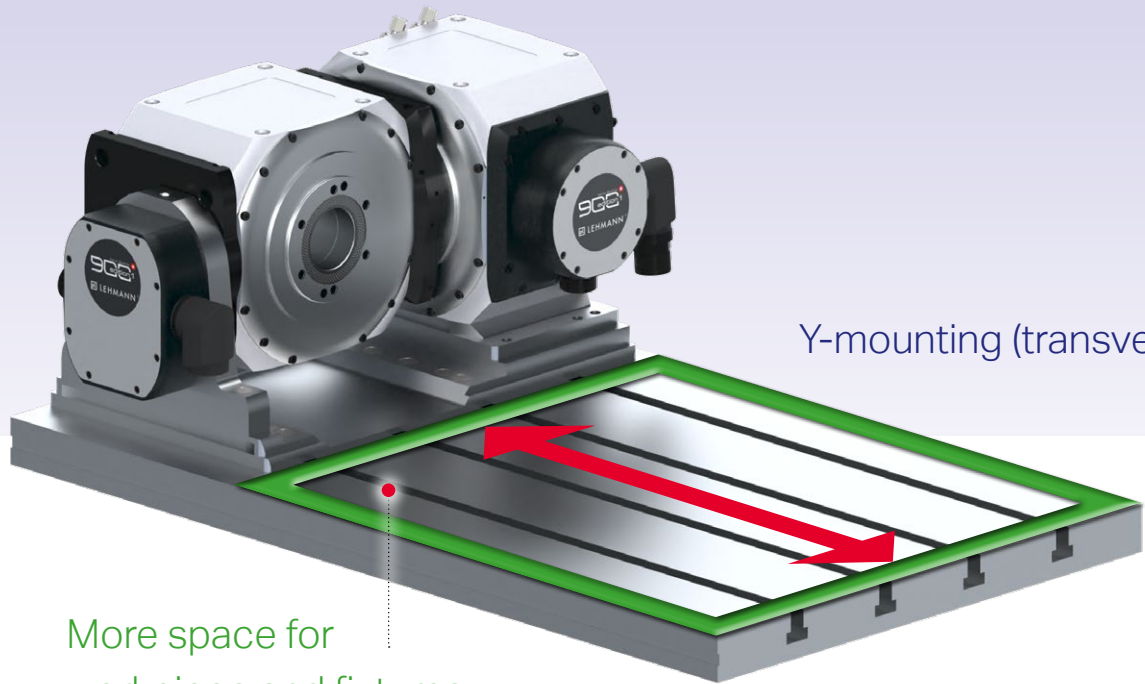
Facts

- 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.

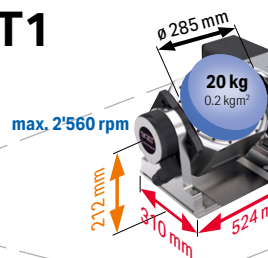
- 50x 507 (standard) or 508 (high speed)
- 51x 510 (standard) or 511 (high speed)
- M2 Single-axis, multi-spindle rotary table, 2-position
- M3 Single-axis, multi-spindle rotary table, 3-position
- T2 Two-axis multi-spindle rotary table, 2-position
- T3 Two-axis multi-spindle rotary table, 3-position



T1

T1

T1

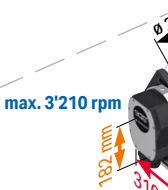
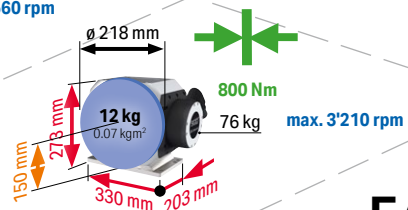
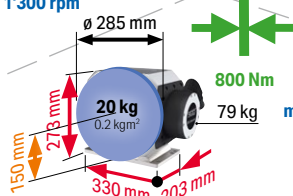
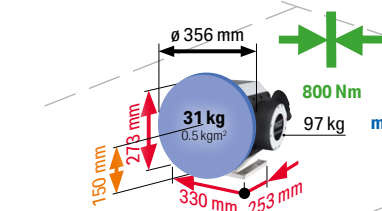


915520

913520

913918

913915



918

915

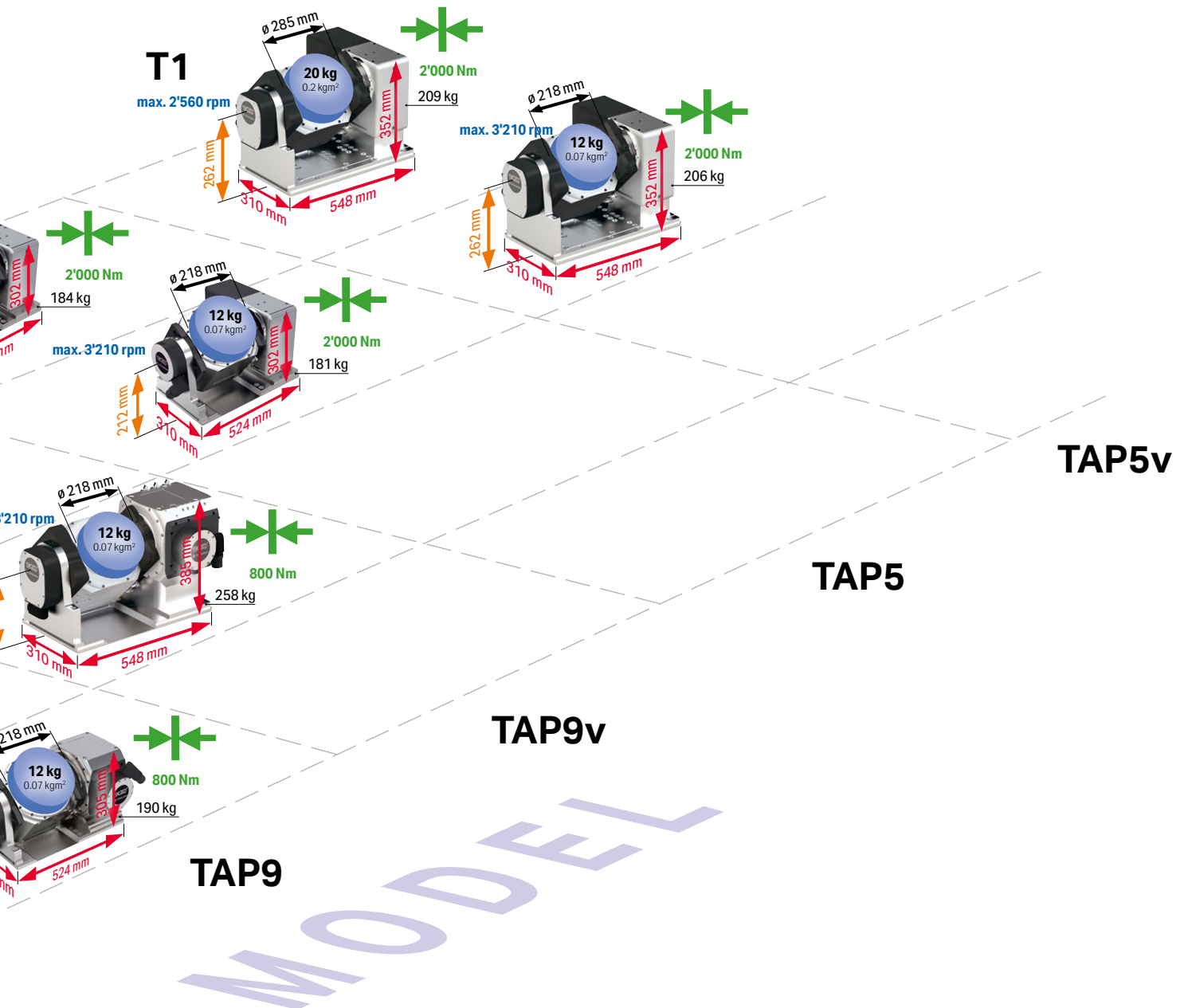
913

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.

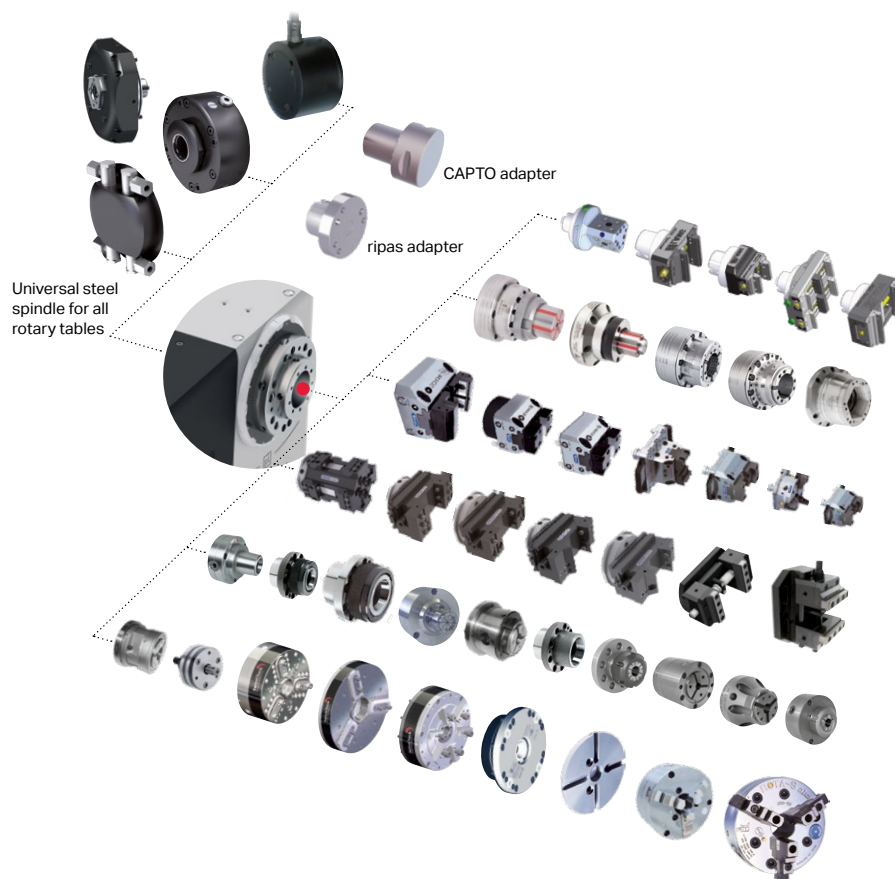
EA single-axis, single-spindle CNC rotary table
TAP two-axis rotary table, with supporting bearing
TAPv Two-axis rotary table, with support bearing, low-profile version (vario)

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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- Iceland
- Ireland
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- Kosovo

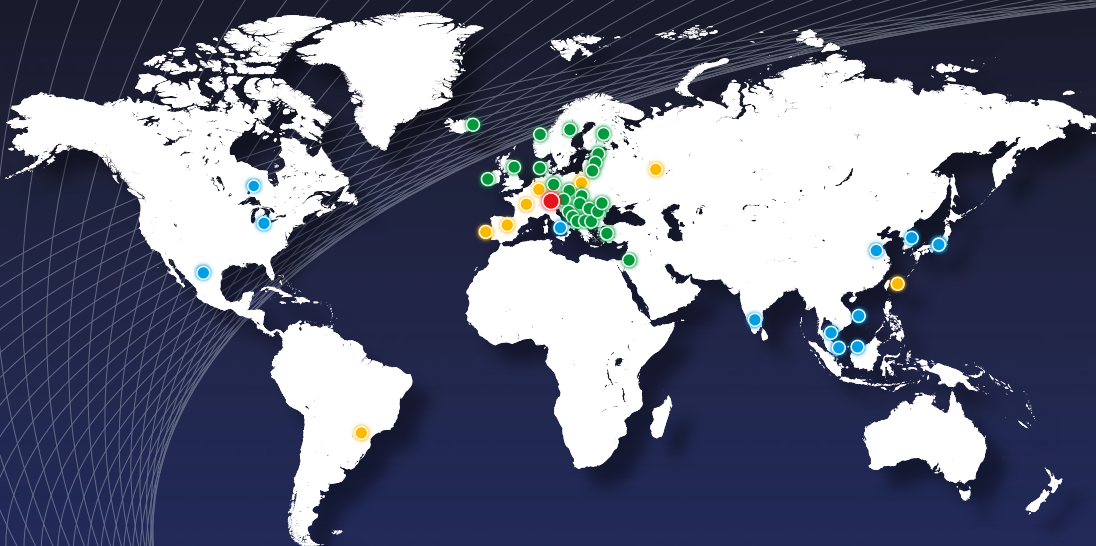
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