

Selection Guide for CNC Rotary Tables ...



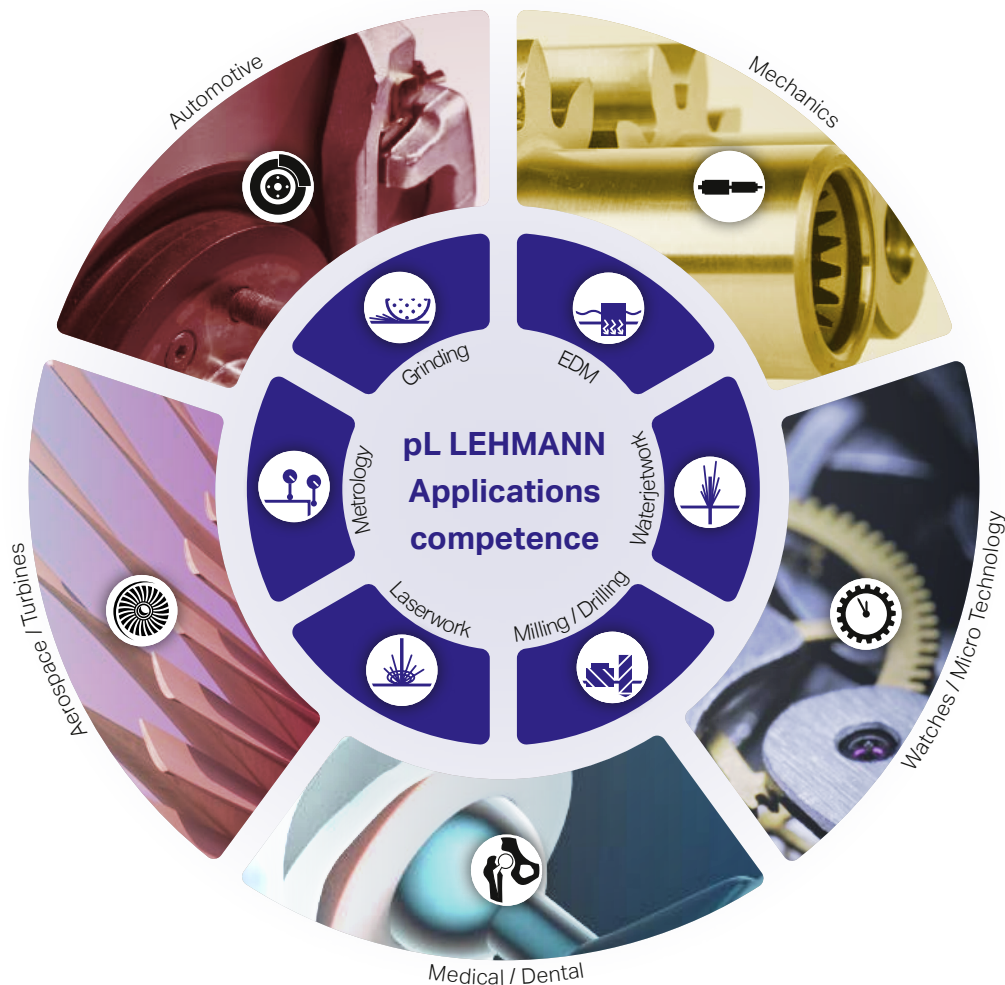
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10/2018 | EN

... for ME- and M-One-series

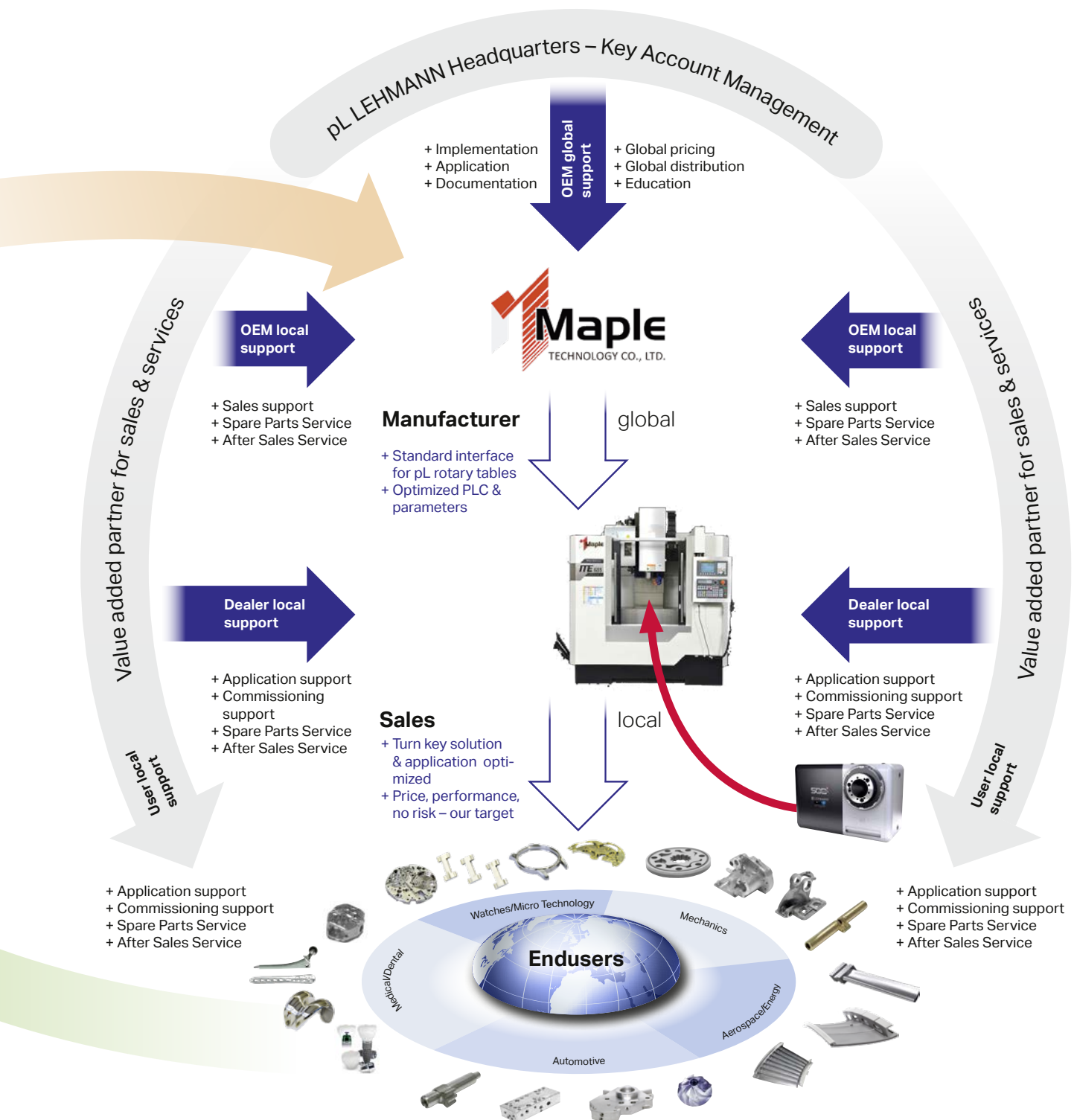
CNC rotary tables for economical manufacturing:
pL LEHMANN has suitable and rational solutions for
nearly every industry



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, Haas, Winmax, Mitsubishi, Brother,
Mazatrol, Okuma ...), for new machines as well as for retrofits

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



NEW
up to +30 %

Up to 210 rpm
up to 0.21 sec / 90°

High speed

Extended travel in
Z- and X-direction

More space

High spindle load,
heavy-duty bearing

Heavy duty

E-Series



Rotary tables suitable for
simultaneous operation!

Save energy



PGD

DD

Benefits of PGD by pL LEHMANN as compared to Direct Drive: small servo, low power draw, no cooling system, and a significantly reduced energy consumption when machining with unclamped rotary table.

Energy label at the left

An intuitive rating as consumption greatly depends on usage, and without any liability assumed, following the directives on energy labelling

**See main catalog
for more features**

NEW
up to +30 %

High torque

Feed torque up to
850 Nm (provisional)

Adaptability

Multifunctional
spindle HSK

Precision

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

NEW
up to +150 %

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**

NEW

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

M-Series



NEW



Bluetooth®

Connectivity

Wireless monitoring,
for operation & service

No adjust

Load change without
parameter adjustment

Less cost

No cooling system,
no hydraulics



ME-655



M-One 6



M-One 6 APC



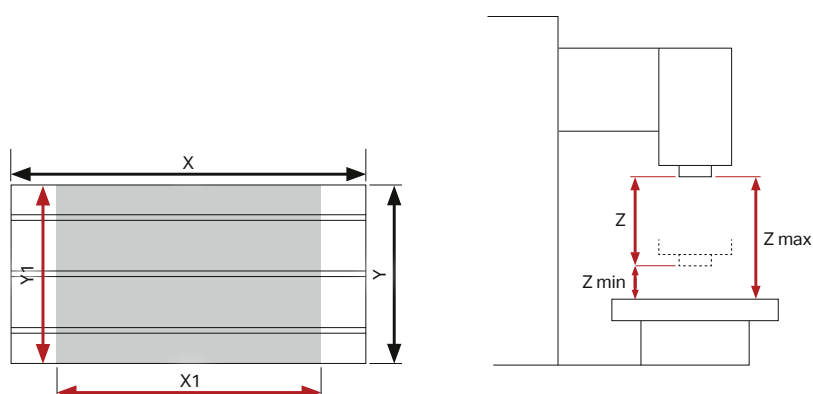
M-One 80

A word from Maple:

«Where quality comes standard – 25 Years of Endless Innovation

With countless years of past experience for improving and join new technology; we are able to promote better efficiency products, and achieve better results and large lasting accuracy. In last then 3 years, we have sold many hundreds units of CNC products to the world.

MAPLE appreciates all our customers support and will strive to prove our customers better products and more ways to help you find the Maple machine that best fits your needs.»

[illegible]

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

Table explanation for pp. 8–11

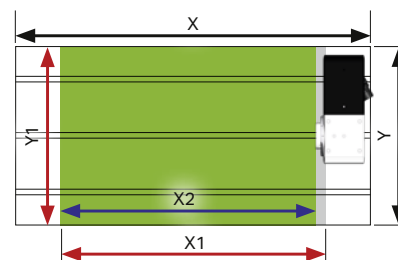
	EA-507 X2	EA-510 X2	EA-520 X2	EA-530 X2
M-One 6 APC	433	417		

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.

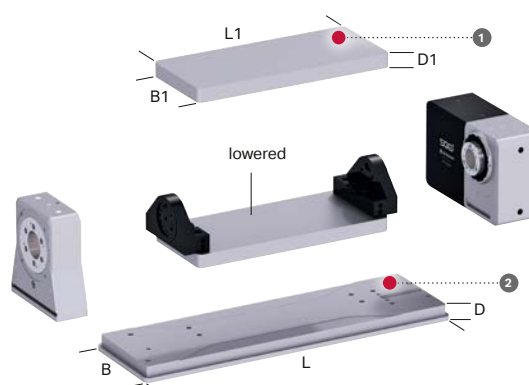


EA-520

EA-530

[illegible]

Clamping yokes for EA-type rotary tables



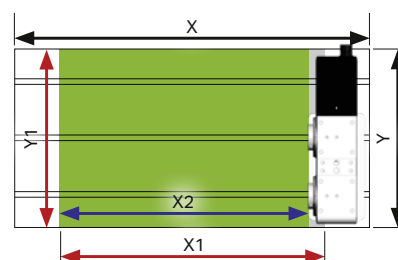
			EA-507		EA-510		EA-520			EA-530	
1 Clamping yokes	Sph	[mm]					210			218	
	Length L1	[mm]					600	700	800	800	1000
	Width B1	[mm]					270			270	
	Thickness D1	[mm]					40			40	
2 Base plates	Length L	[mm]					916	1016	1116	1172	1372
	Width B	[mm]					301			368	
	Thickness D	[mm]					30			38	
Weights / moments of inertia (without rotary table, without counter bearing)	Weight (Al)	[kg]					40	45	52	on request	
	Weight (steel)	[kg]					117	130	152		
	Mom. inert. (Al)	[kgm²]					0.16	0.17	0.21		
	Mom. inert. (steel)	[kgm²]					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.

[illegible]

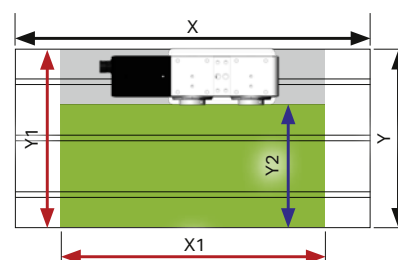
Y-mounting



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

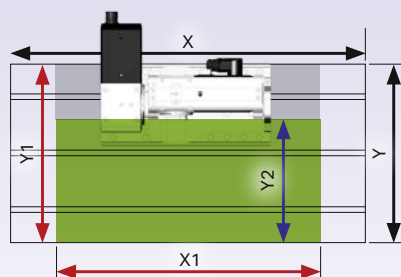
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X-mounting



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

X-mounting



Rotary table installation using hole pattern in base plate



TIP1

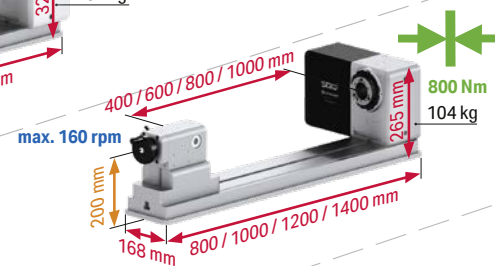
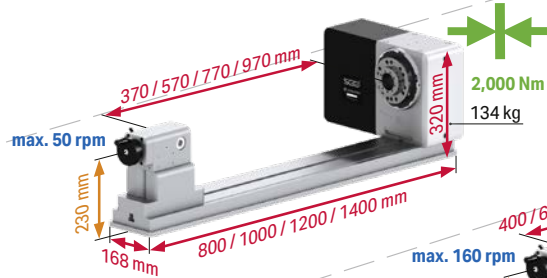
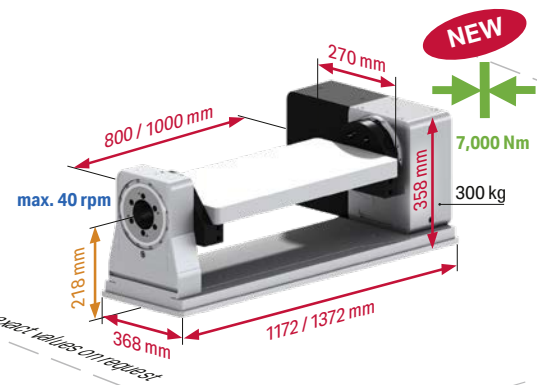
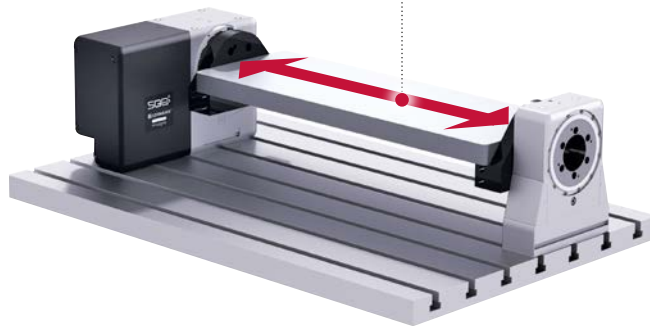


TAP1



TOP1.2

[illegible][illegible]



530

520

51x

50x

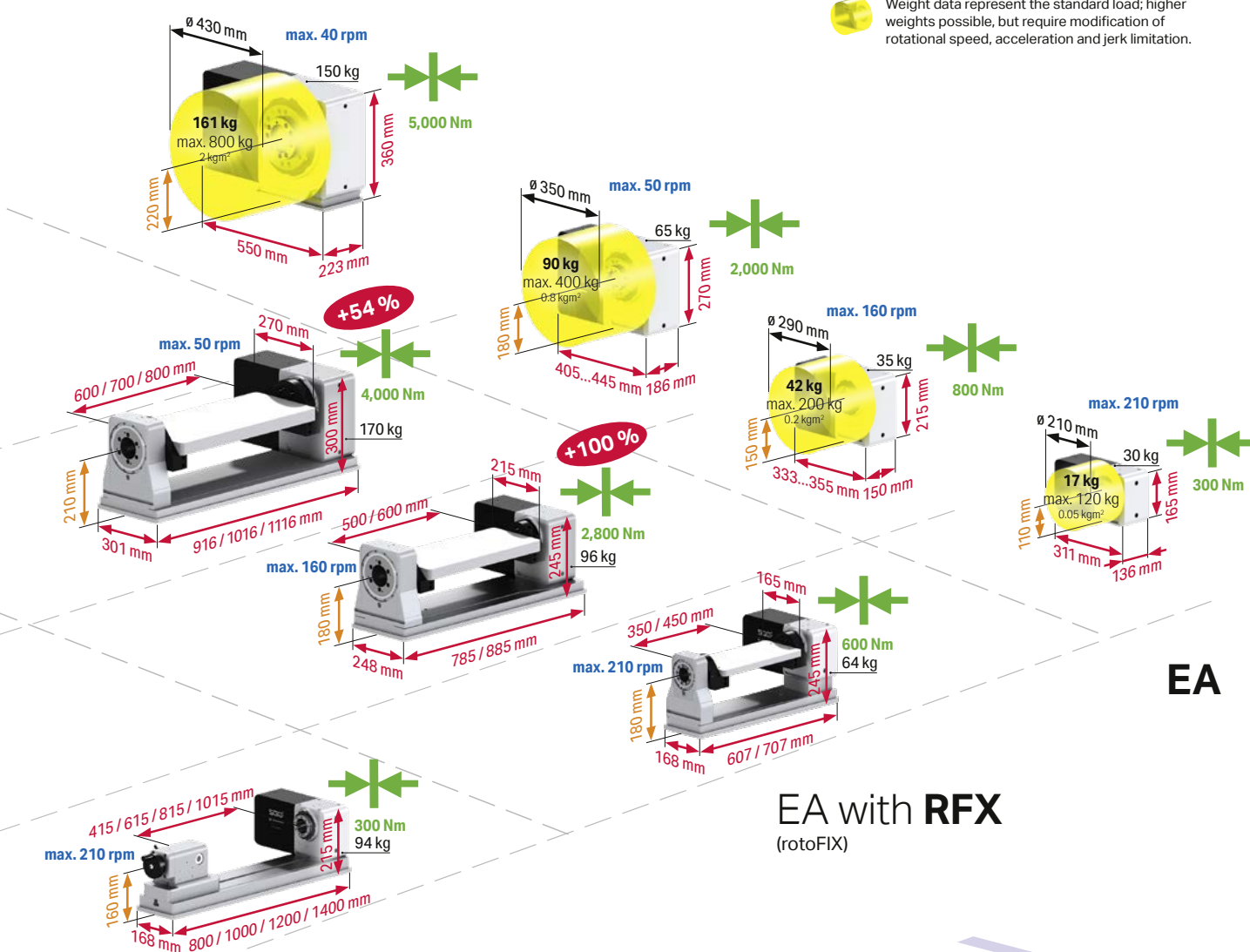
SIZE

News in brief

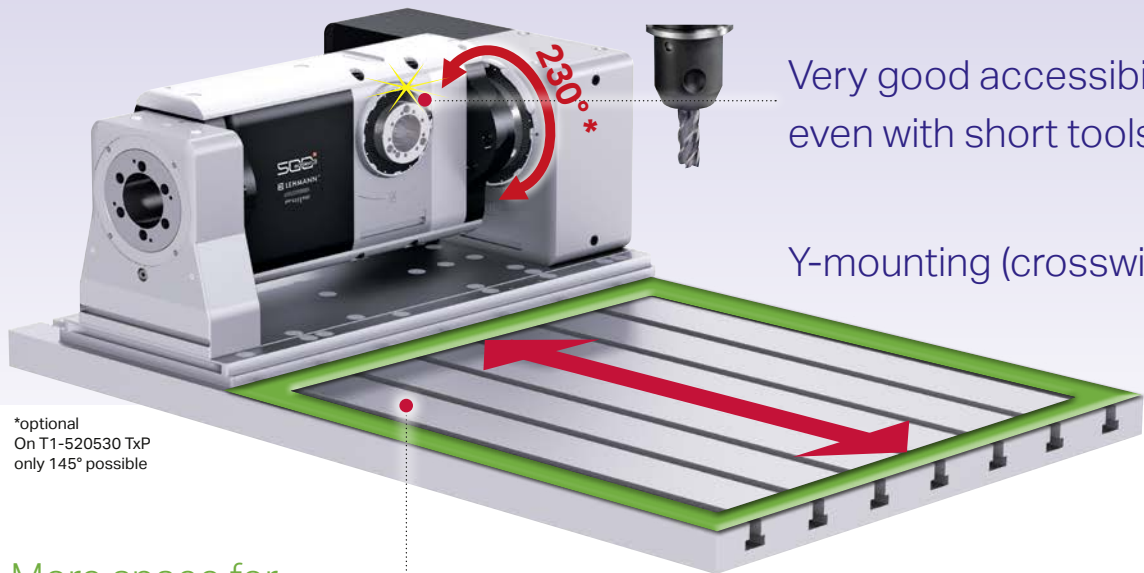
1. High speed up to **210 rpm**
2. Feed torque up to **850 Nm** (tentative)
3. Steel base plates with hole pattern (suitable for slot spacing of 100 and 125 mm)
4. Cycle time **90°** as fast as **0.21 sec.**



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)
EA	single-axis, single-spindle CNC rotary table
rotoFIX	modular clamping yoke system
longFLEX	modular shaft clamping system

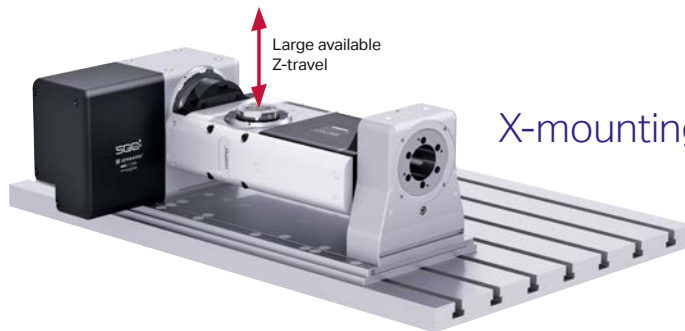


Very good accessibility,
even with short tools

Y-mounting (crosswise)

*optional
On T1-520530 TxP
only 145° possible

More space for
workpiece and fixtures



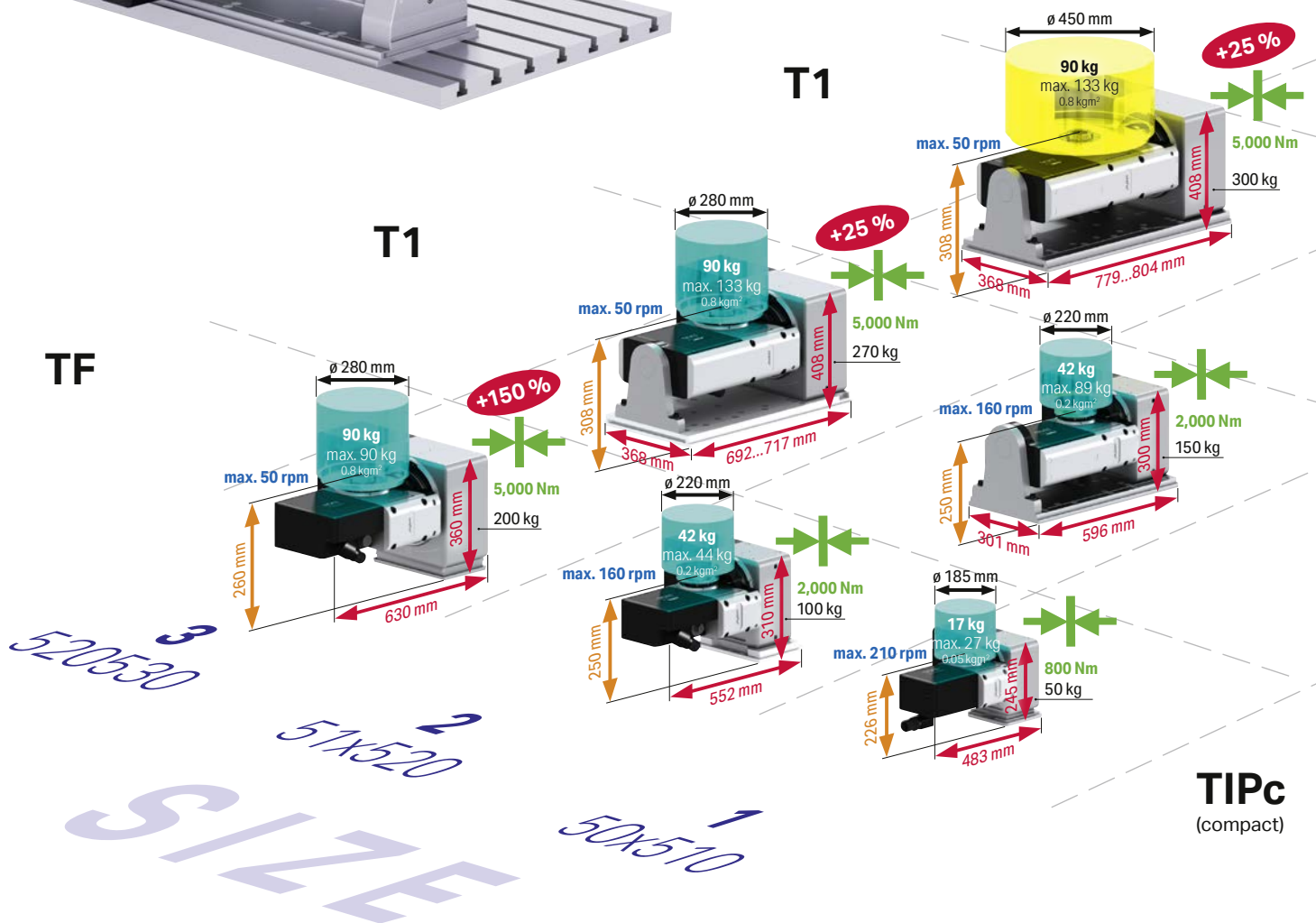
X-mounting (lengthwise)

T1

T1

T1

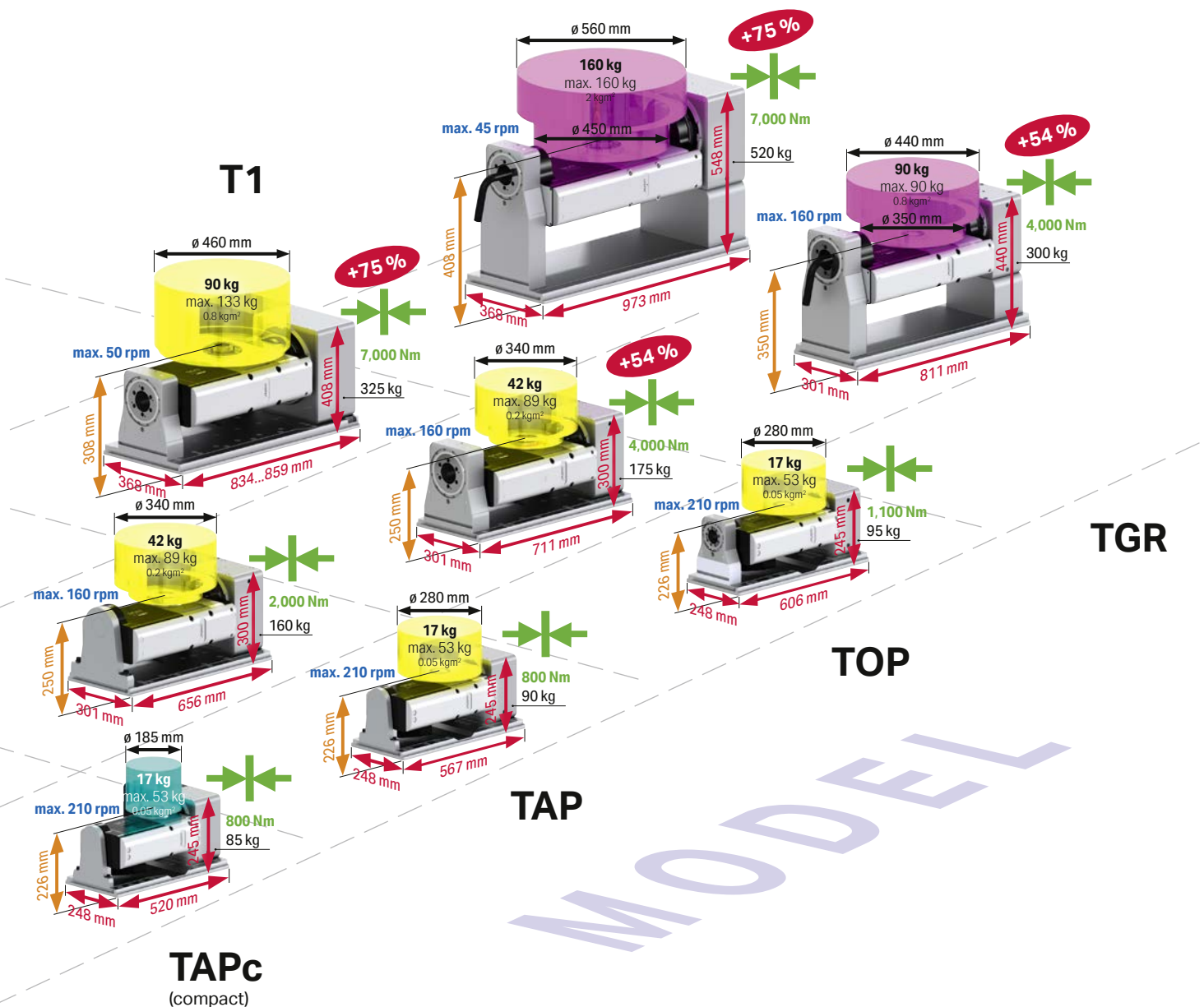
TF



TIPc
(compact)

News in brief

1. Up to **150 %** higher clamping torque in tilting axis
2. Fewer variant – more solution
3. Larger workpiece $\varnothing$ possible
4. Spatially optimized arrangement of the dividing axis

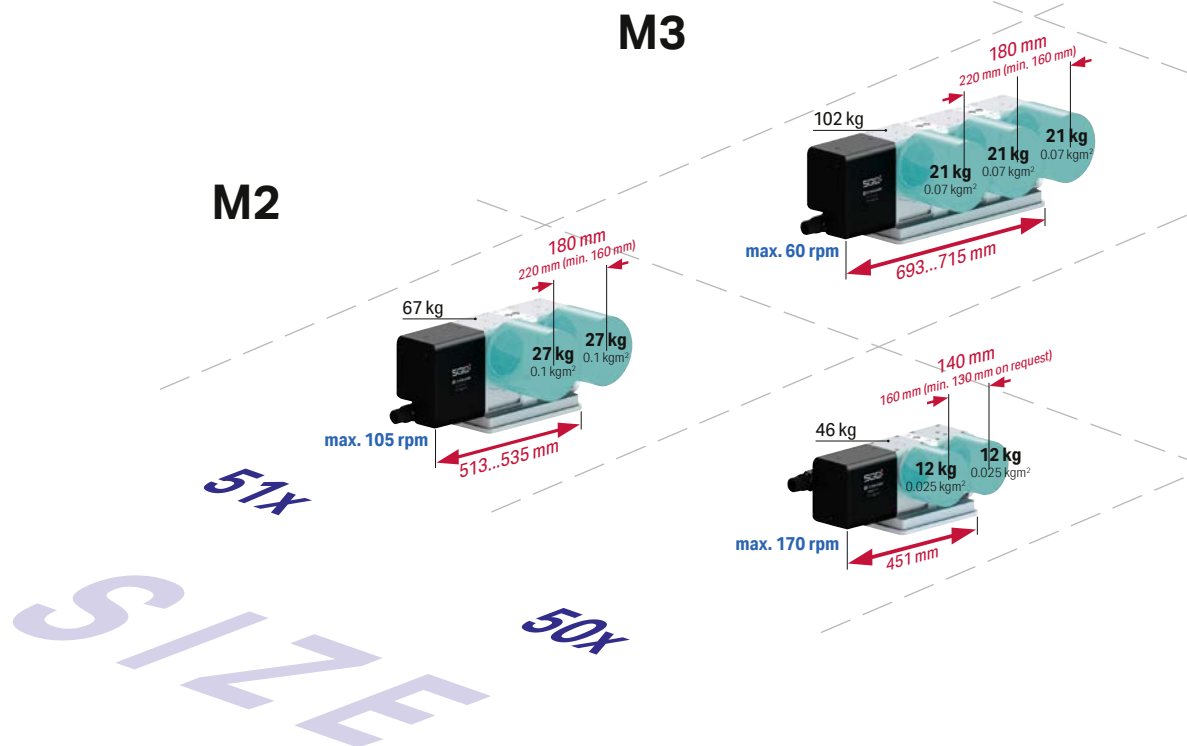


Weight data represent the standard load; higher weights possible, but require modification of rotational speed, acceleration and jerk limitation.

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

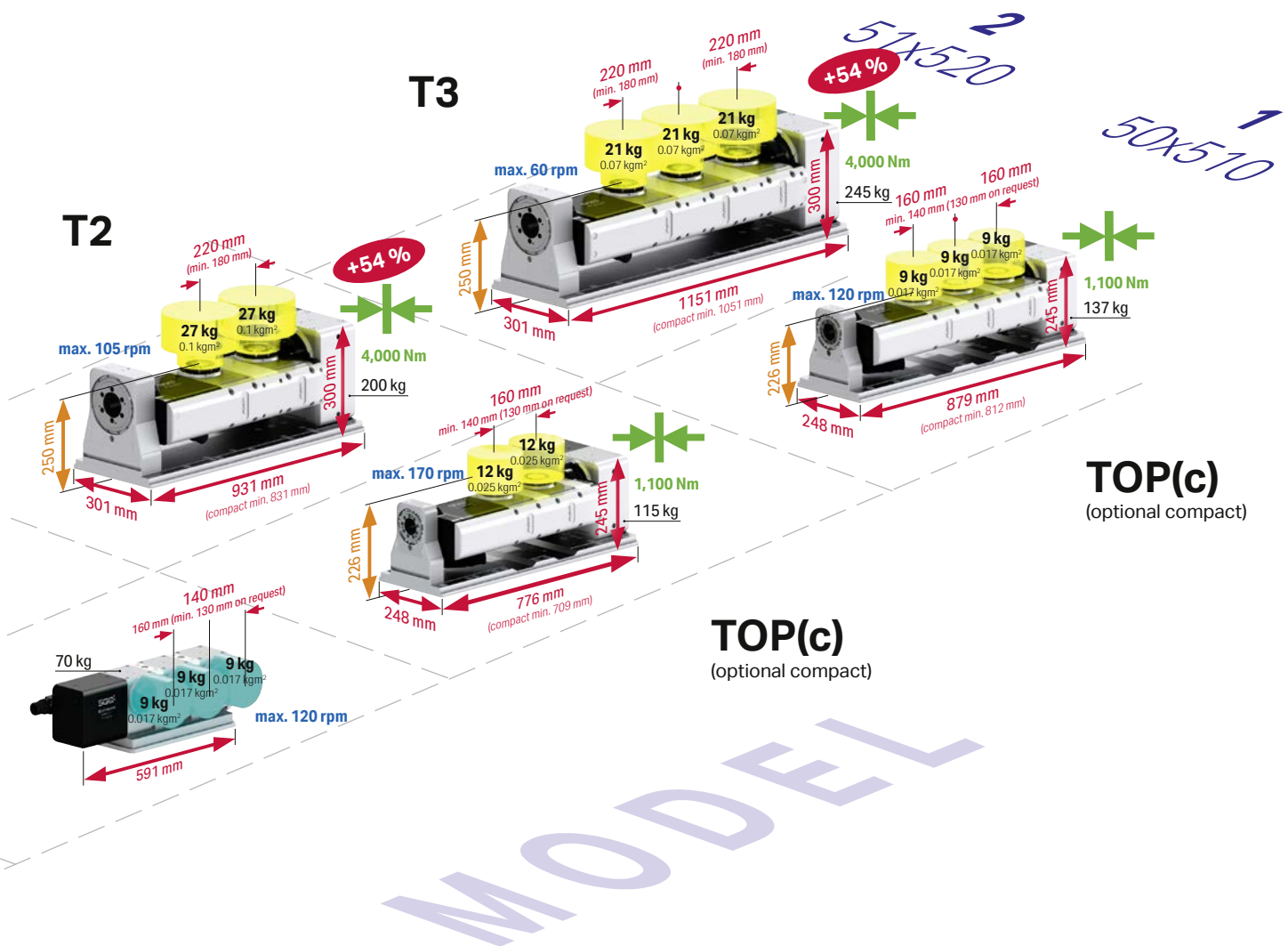


More space for workpiece and fixtures



News in brief

1. Up to **54 %** higher clamping torque in tilting axis
2. Fewer variant – more solution
3. Spindle distance min. **130 mm**
4. 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

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

Spindle accessories in rear

- + Rotary unions **up to 250 bar**
- + Clamping cylinder **23 kN at 120 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 (on request)

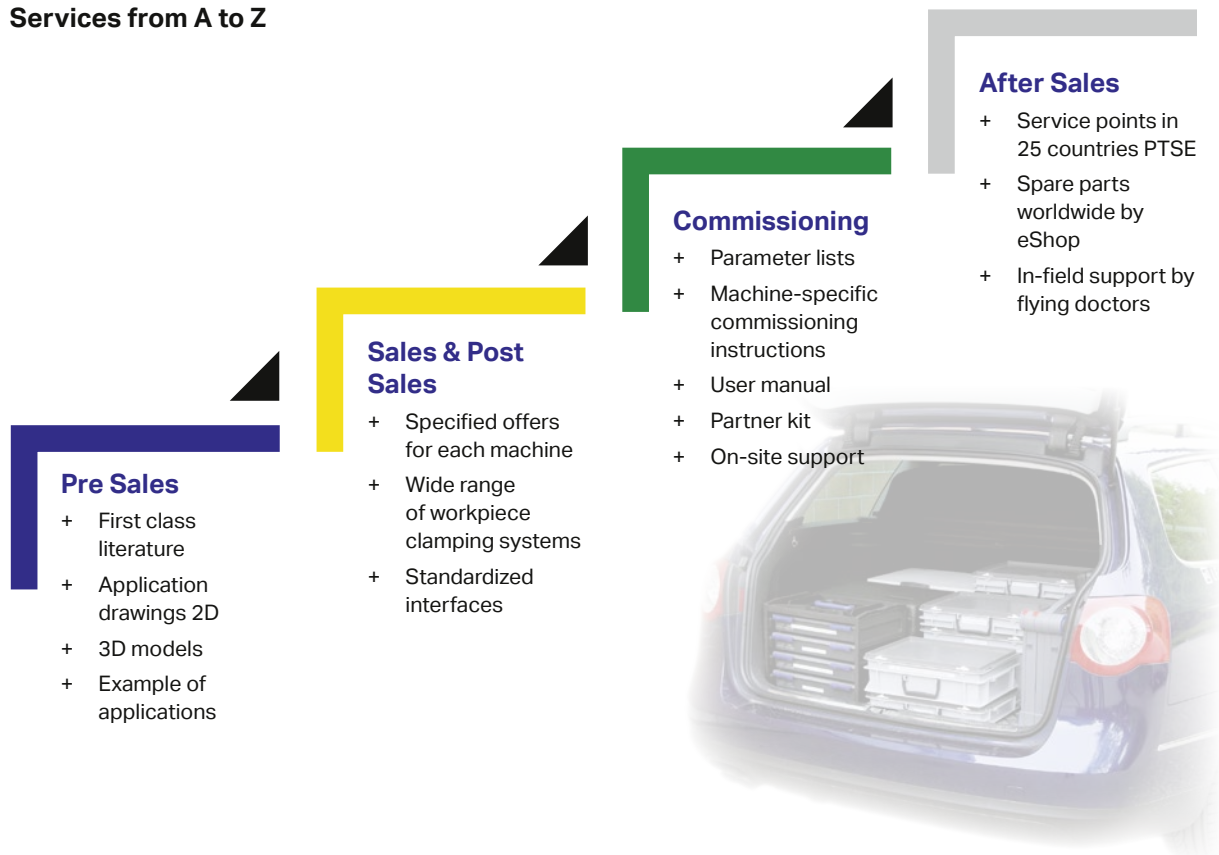


EA-507 with CAPTO retrofit kit

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

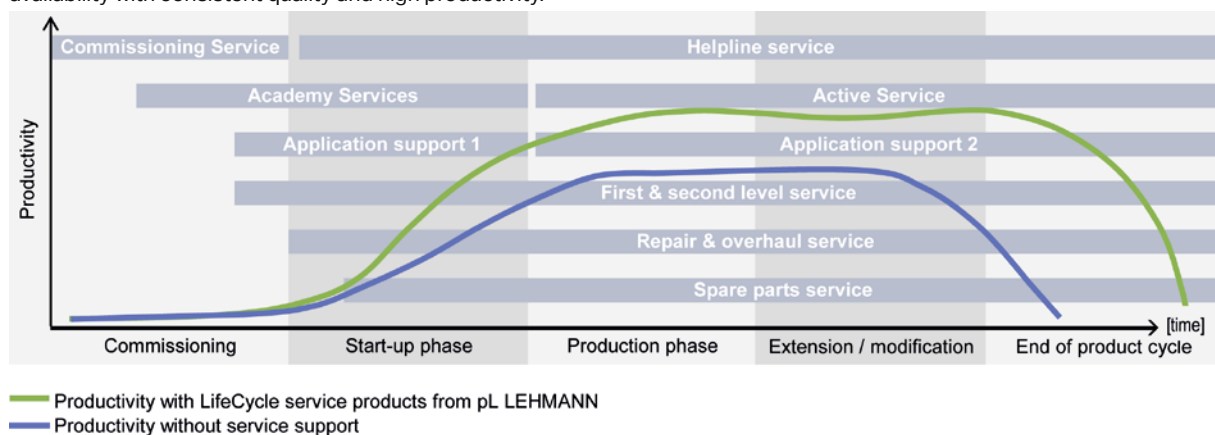


Services from A to Z



Increase productivity – Extend lifecycle

Comprehensive and professional services throughout the product life cycle – maximum availability with consistent quality and high productivity.



For more information please see www.lehmann-rotary-tables.com.



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- Czech Republic (vacant)
- Finland
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- Germany
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- Italy
- Norway
- Poland
- Portugal
- Russia
- Slovenia
- Spain
- Sweden
- Turkey
- UK

America

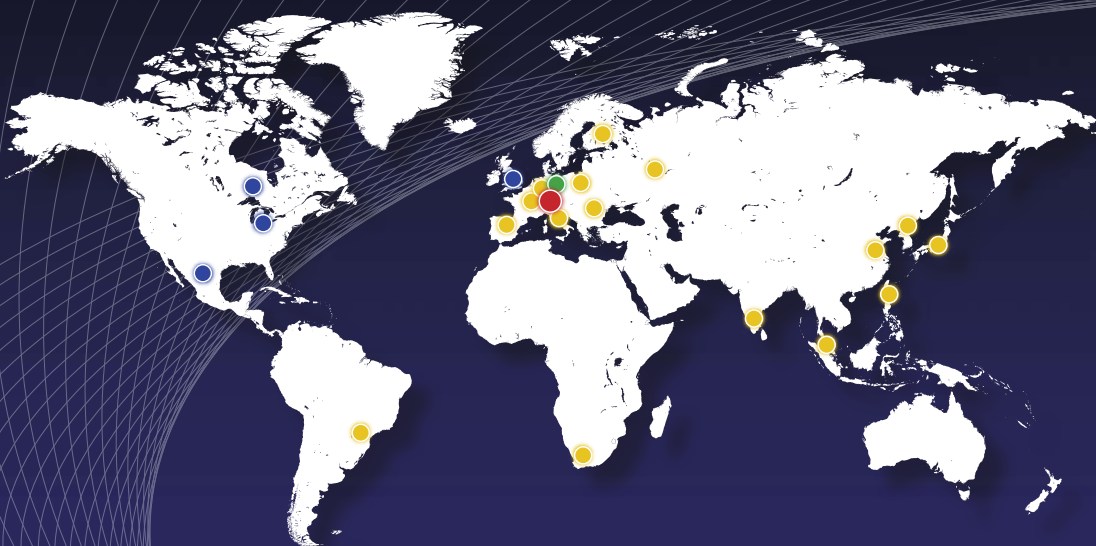
- Brazil
- Canada
- Mexico
- USA

Asia

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

Africa

- South Africa



● Headquarters ● direct sales partner ● pL Solutions® partner ● value added reseller & partner

More information (address, telephone number...) at www.lehmann-rotary-tables.com