

Selection Guide for CNC Rotary Tables ...



pl

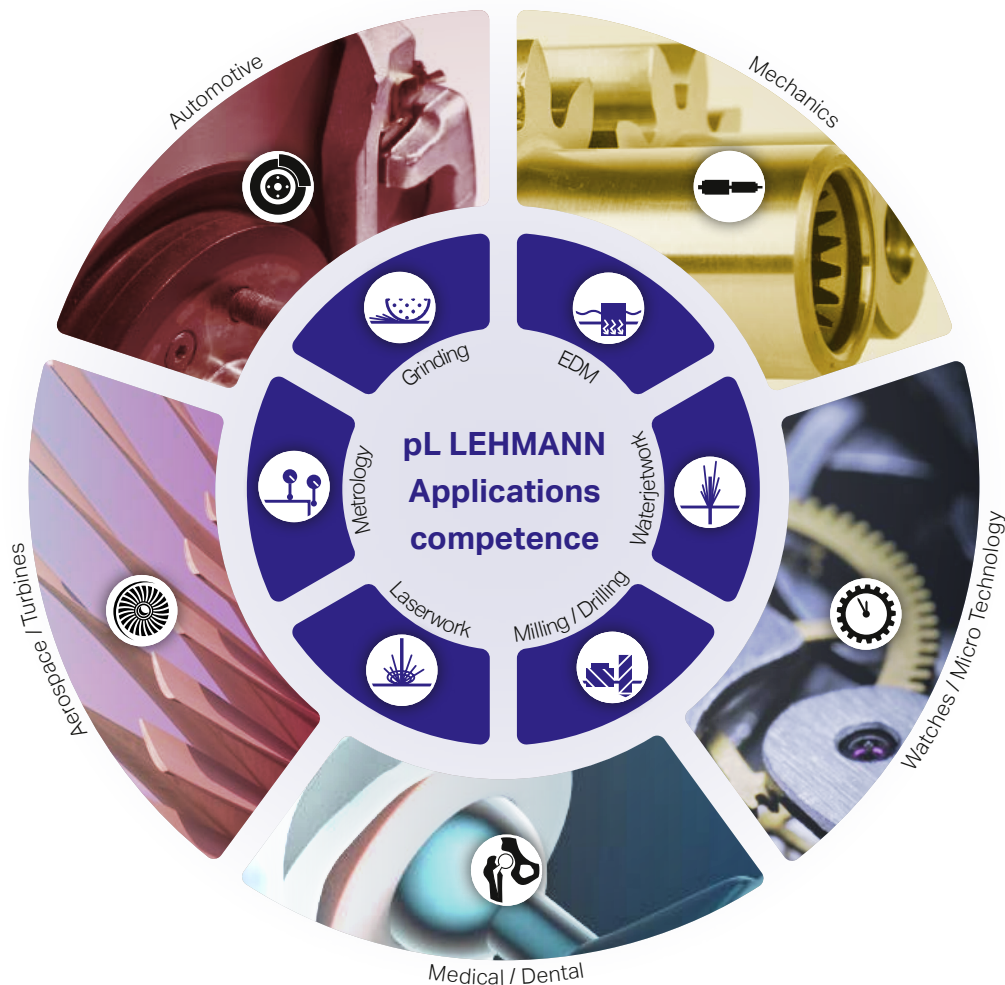
maxmill

04/2020 | EN



... for HQM, NVM, QMC and VMC series

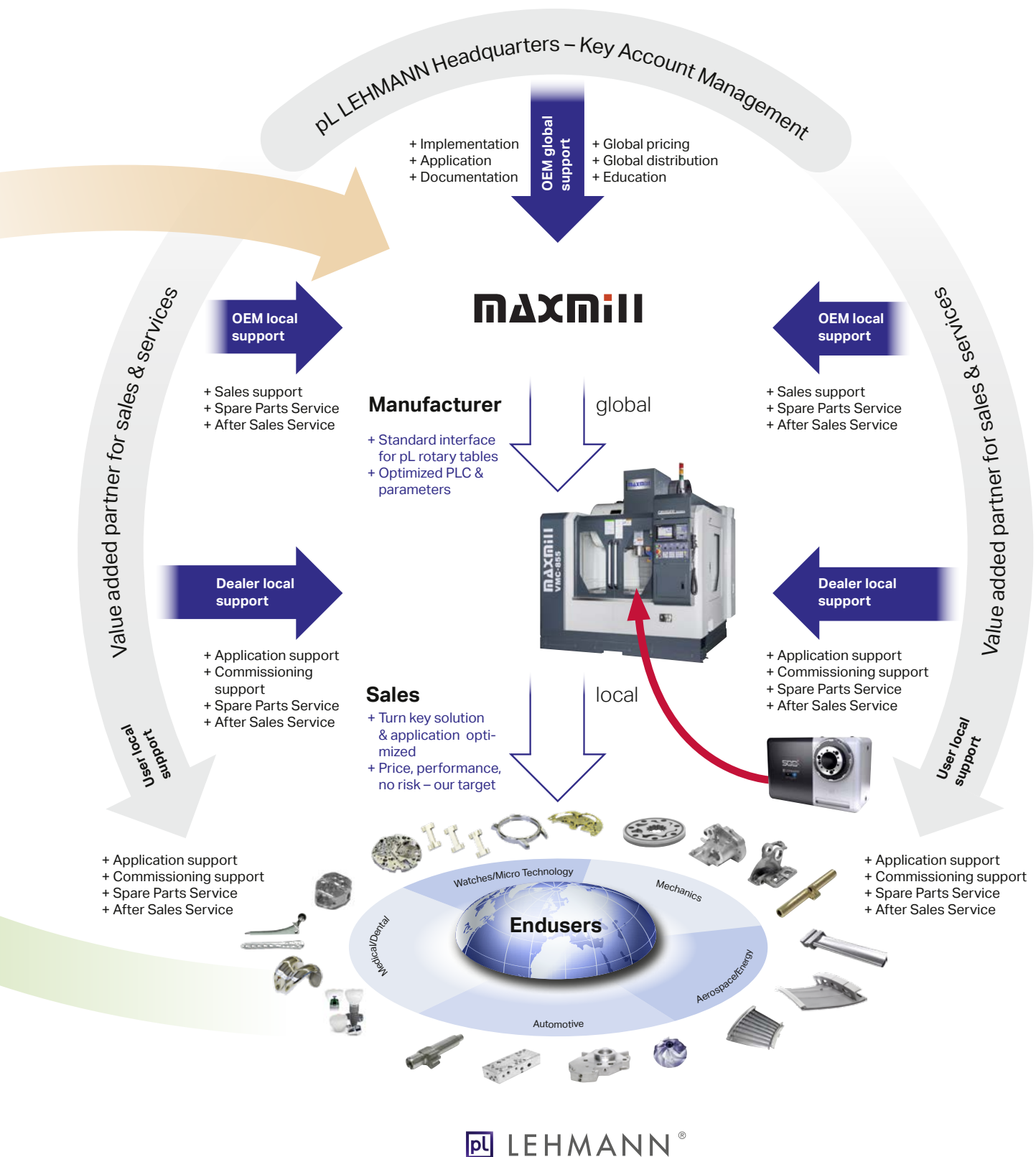
CNC rotary tables for economical manufacturing:
pL LEHMANN has suitable and rational solutions for
nearly every industry



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:
KAAST 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

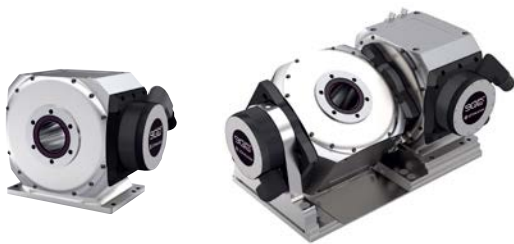
E-Series



EA-50x light only 12 kg



DD Series **NEW**



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

Wireless monitoring,
for operation & service

No adjust

Load change without
parameter adjustment

Less cost

No cooling system,
no hydraulics



HQM-1260



NVM-1166



QMC-500



QMC-600



VMC-855

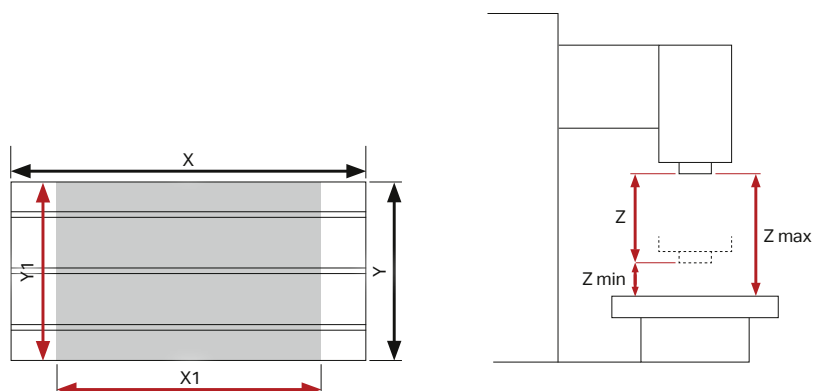


VMC-1690

A word from MAXMILL:

«Brilliant research and development capabilities

Our commitment to all of our customers drives us to constantly research new technologies to upgrade Maxmill machines. Outstanding research and development is a key factor in this process. At Maxmill, we have highly qualified R&D engineers with over 10 years' experience in the machine tool industry. The design procedures are done by using advanced software system for simulation on computer. One reason for the excellence of Maxmill VMC's results from our innovative design concepts. We will maintain this tradition to stay competitive now and in the future.»

[illegible]

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

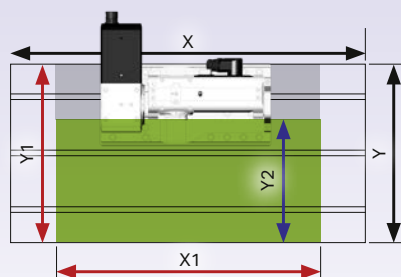
	EA-507 X2	EA-510 X2	EA-520 X2	EA-530 X2
HQM-1060	1'038	1'022	996	967

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.

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

 LEHMANN®

X-mounting



Rotary table installation using hole pattern in base plate



TIP1



TAP1

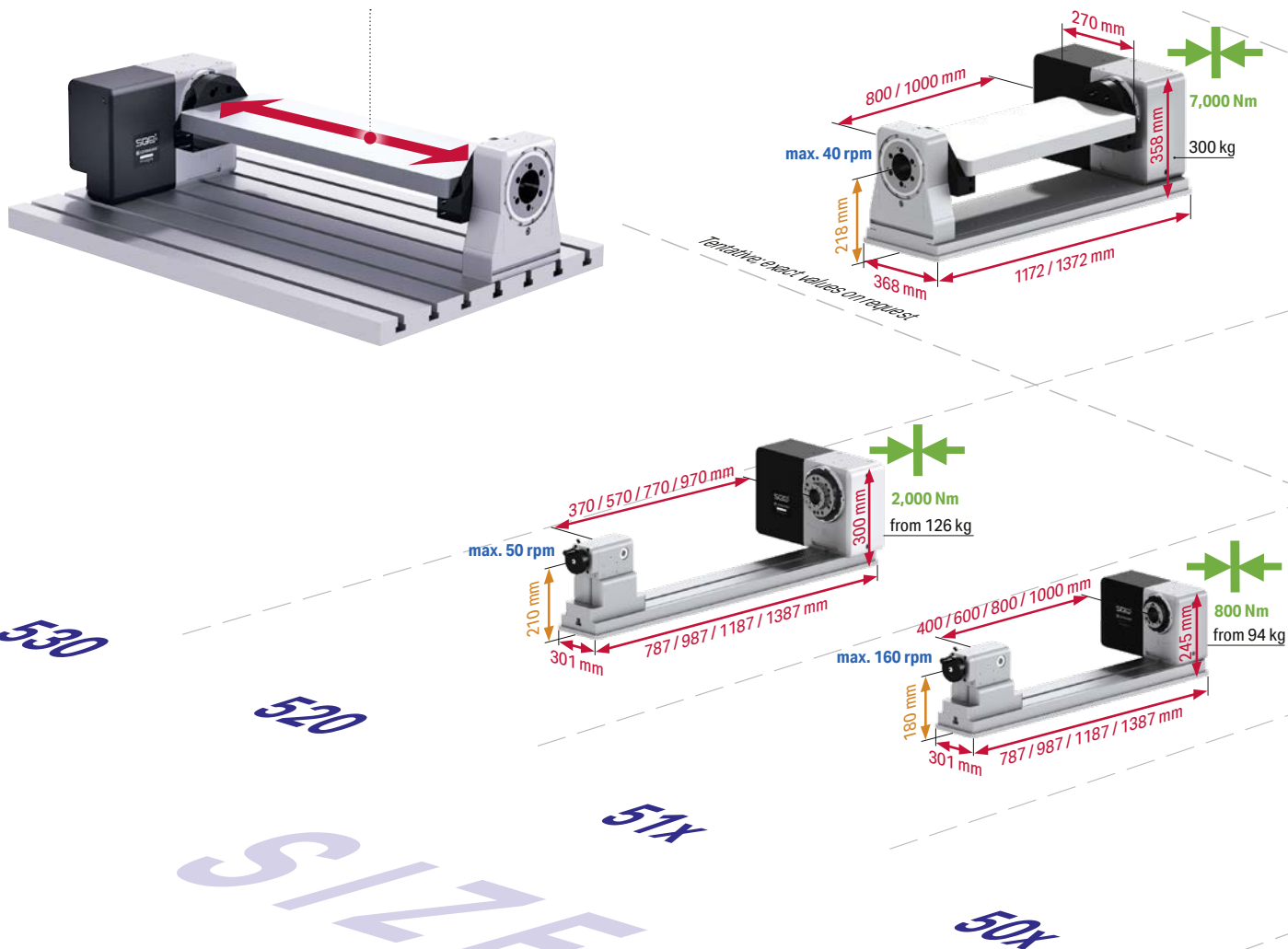


TOP1.2

[illegible][illegible]



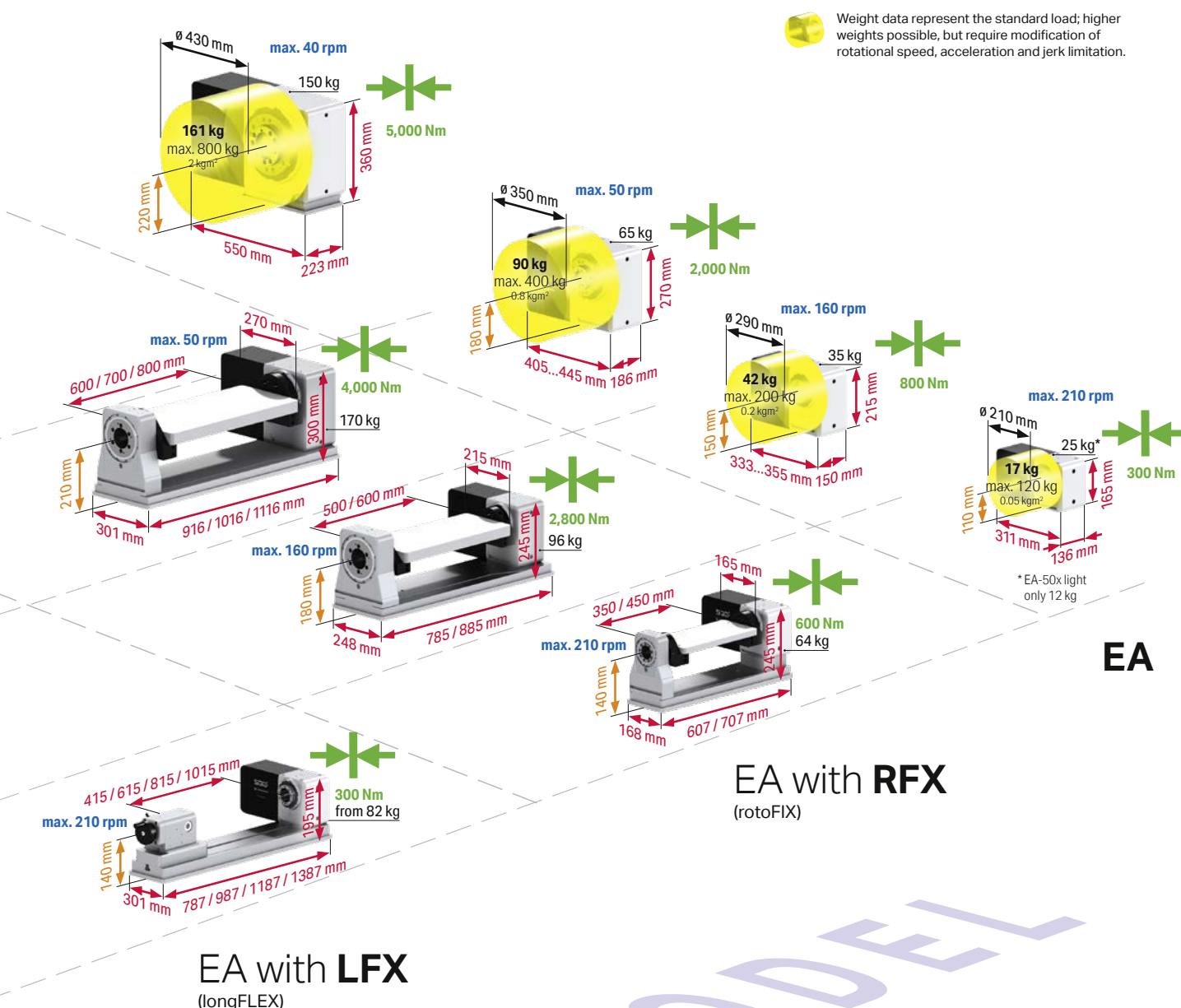
More space for workpieces and fixtures



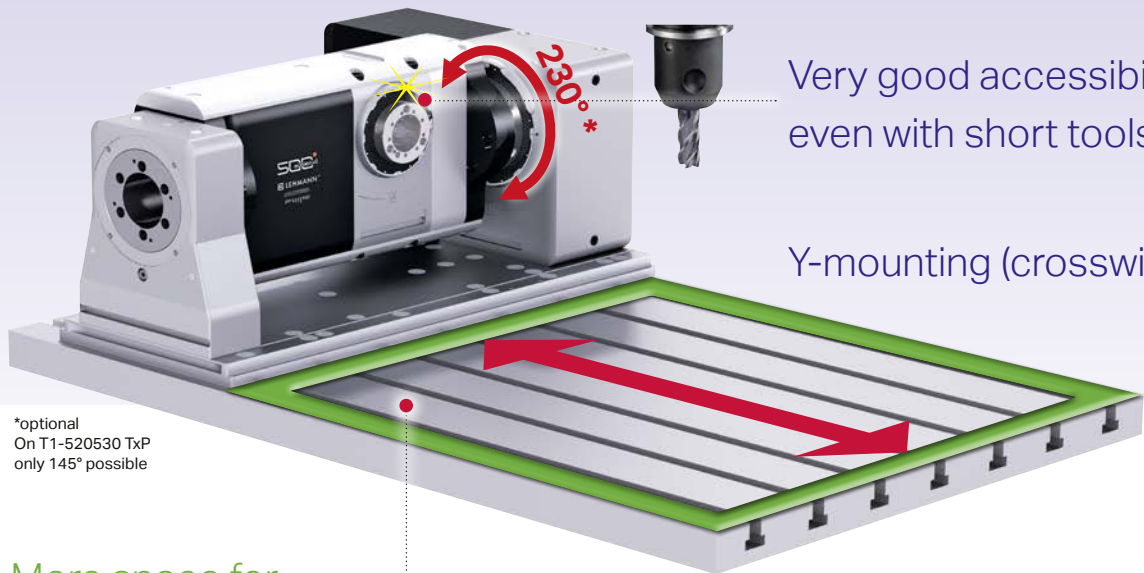
SIZE

Facts

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.**



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

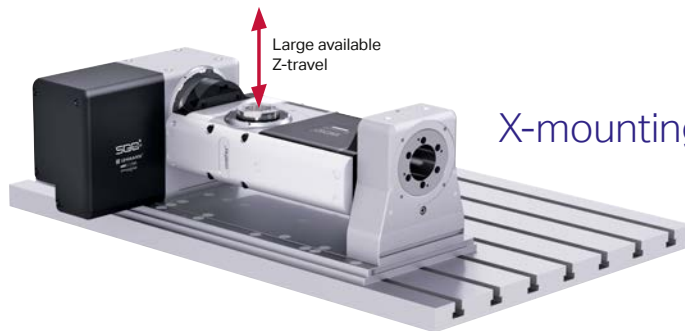


Very good accessibility,
even with short tools

Y-mounting (crosswise)

*optional
On T1-520530 TxP
only 145° possible

More space for
workpiece and fixtures



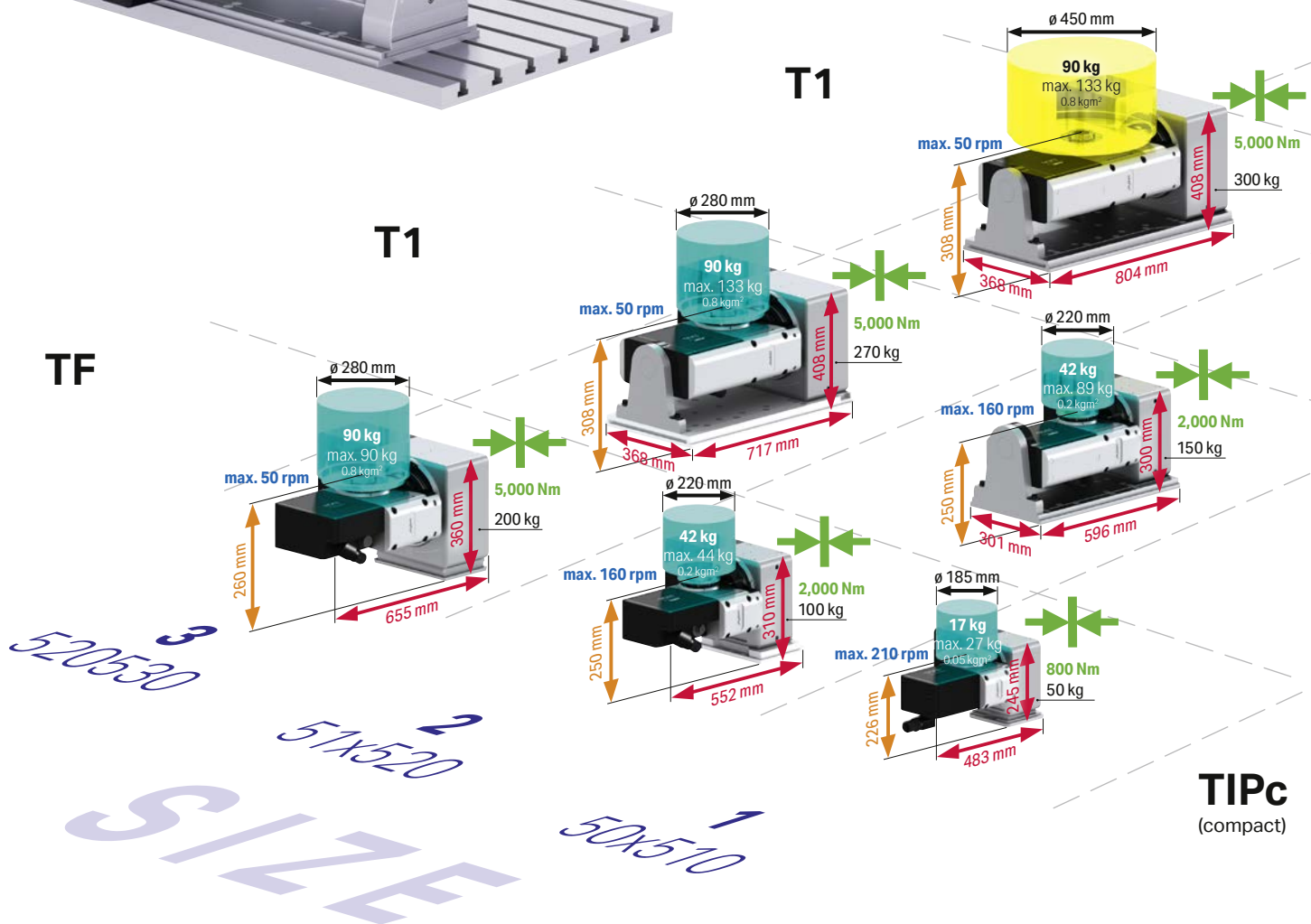
X-mounting (lengthwise)

T1

T1

T1

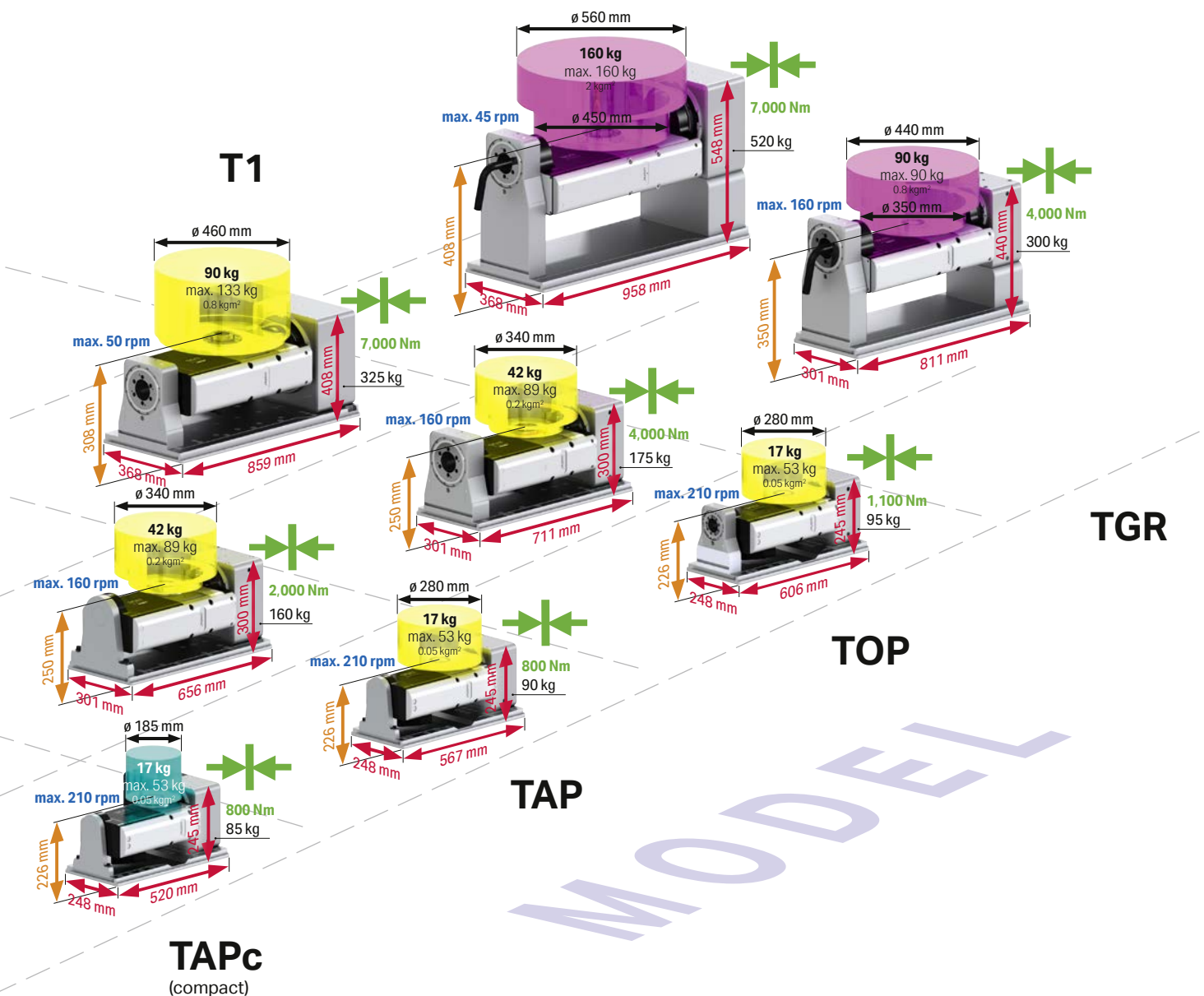
TF



TIPc
(compact)

Facts

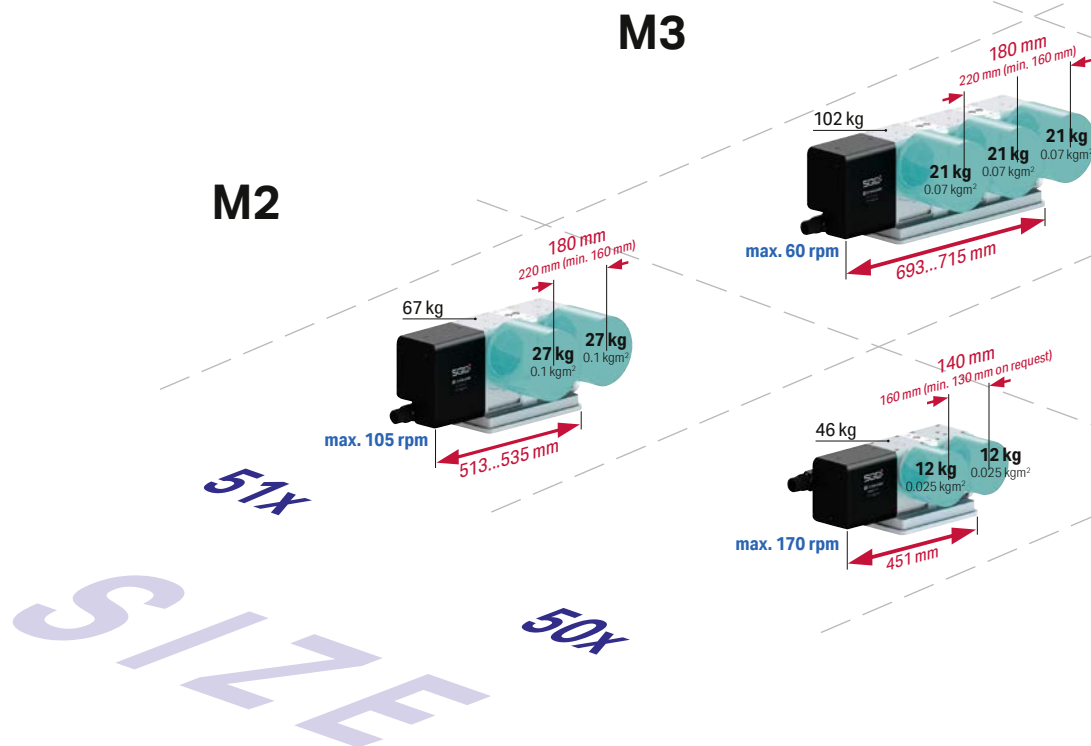
1. Up to 150 % higher clamping torque in tilting axis
2. Fewer variant – more solution
3. Larger workpiece $\varnothing$ possible
4. Spatially optimized arrangement of the dividing axis



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

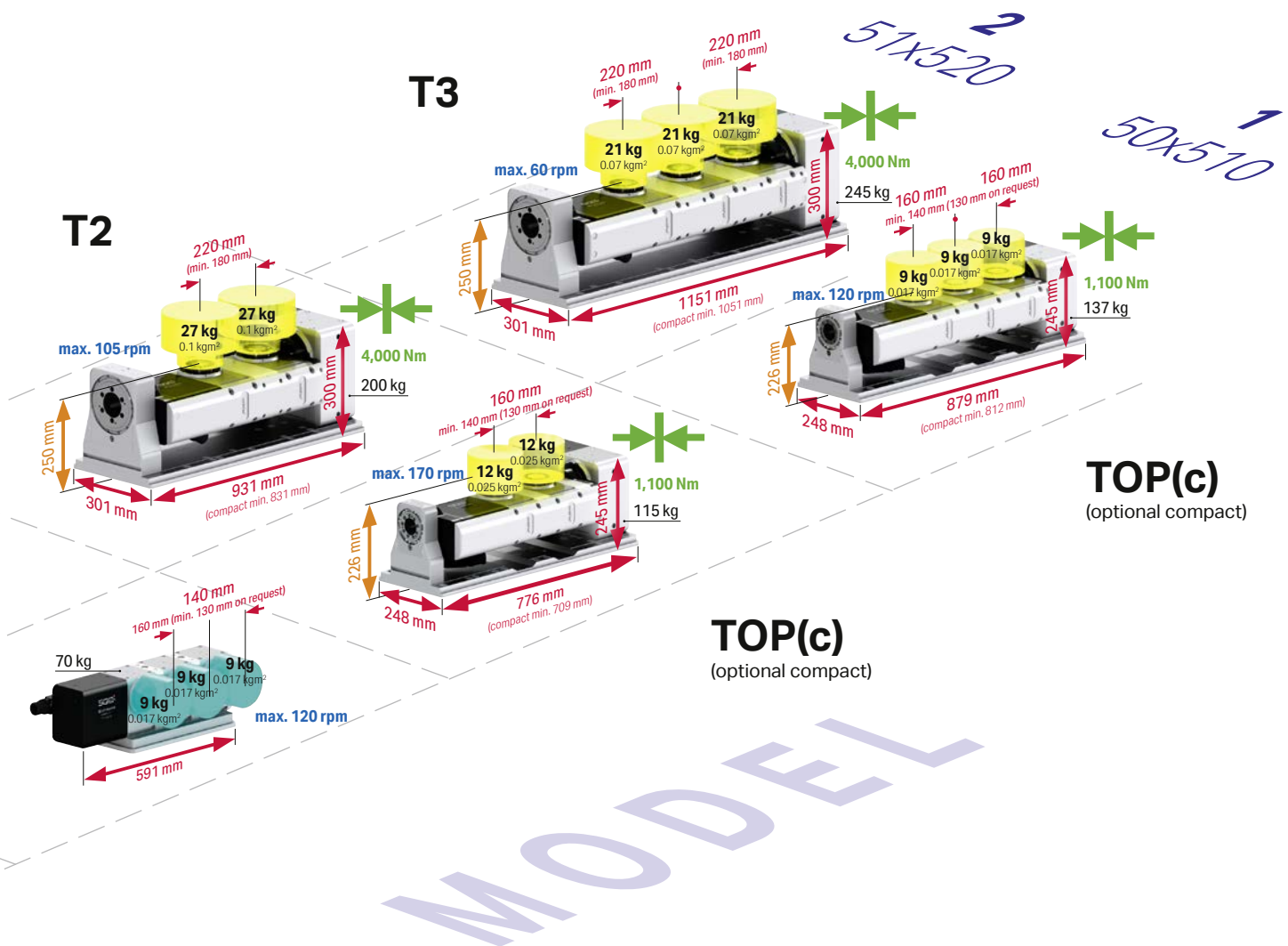


More space for workpiece and fixtures



Facts

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



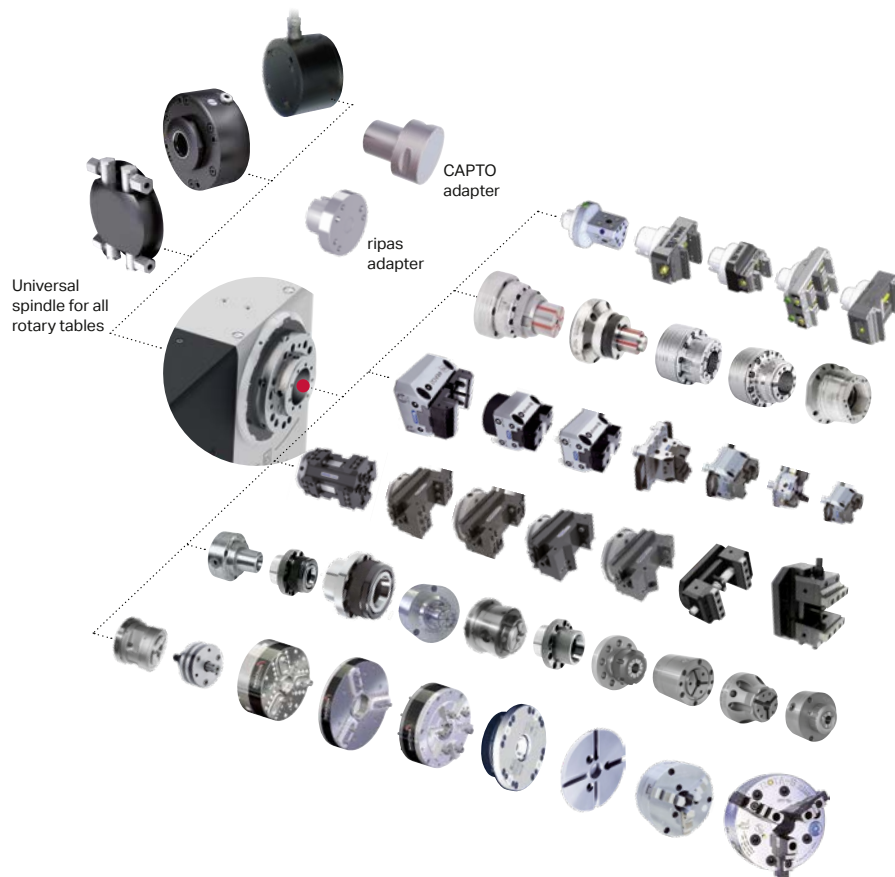
Weight data represent the standard load; higher weights possible, but require modification of rotational speed, acceleration and jerk limitation.

- 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

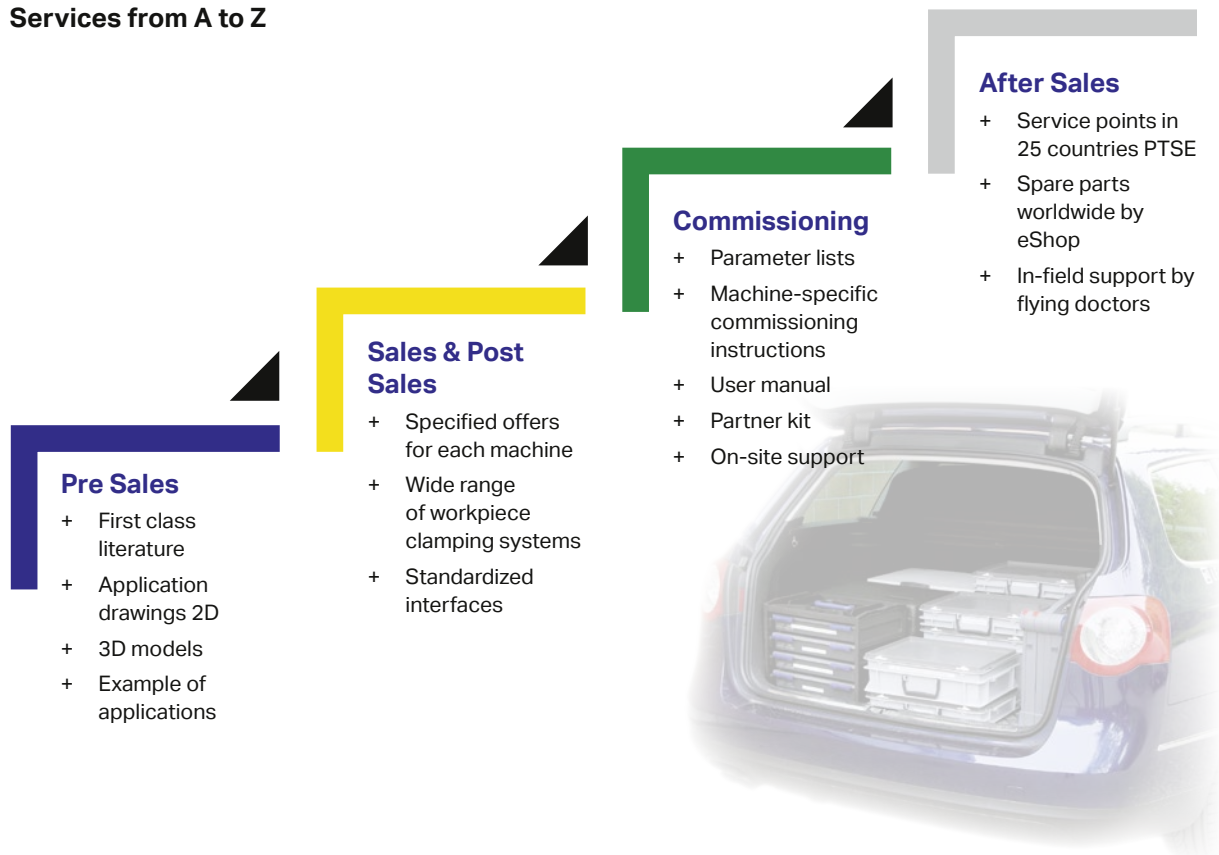


EA-507 with CAPTO retrofit kit

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

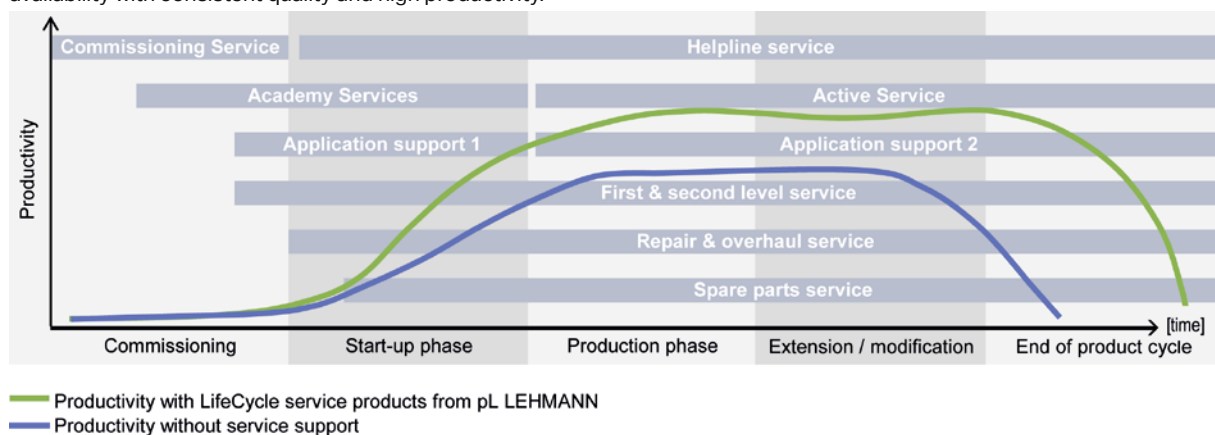


Services from A to Z



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.



ROTARY TABLES · PRECISION TECHNOLOGY · SOFTWARE

Headquarters

PETER LEHMANN AG
CH-3552 Bârau
Phone +41 (0)34 409 66 66
Fax +41 (0)34 409 66 00
pls@plehmann.com
www.lehmann-additive.com
www.lehmann-rotary-tables.com

Global network

Europe

- Austria
- Benelux
- Czech Republic
- Finland
- France
- Germany
- Hungary
- 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/service partner ● pL SOLUTIONS® partner ● value added reseller & partner

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