



Selection Guide for CNC Rotary Tables ...



Bluetooth®

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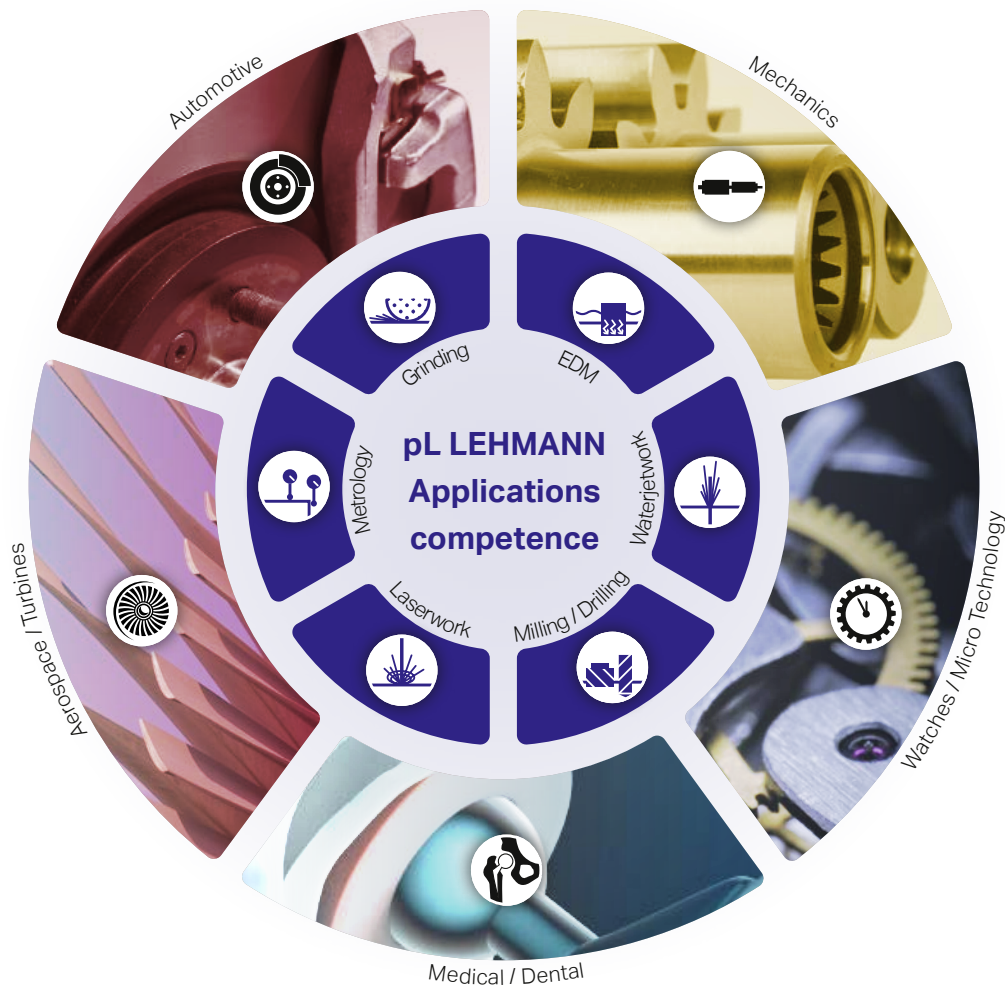
Takumi

10/2018 | EN



... for B-, G-, H-, V-, VC- and VT-series

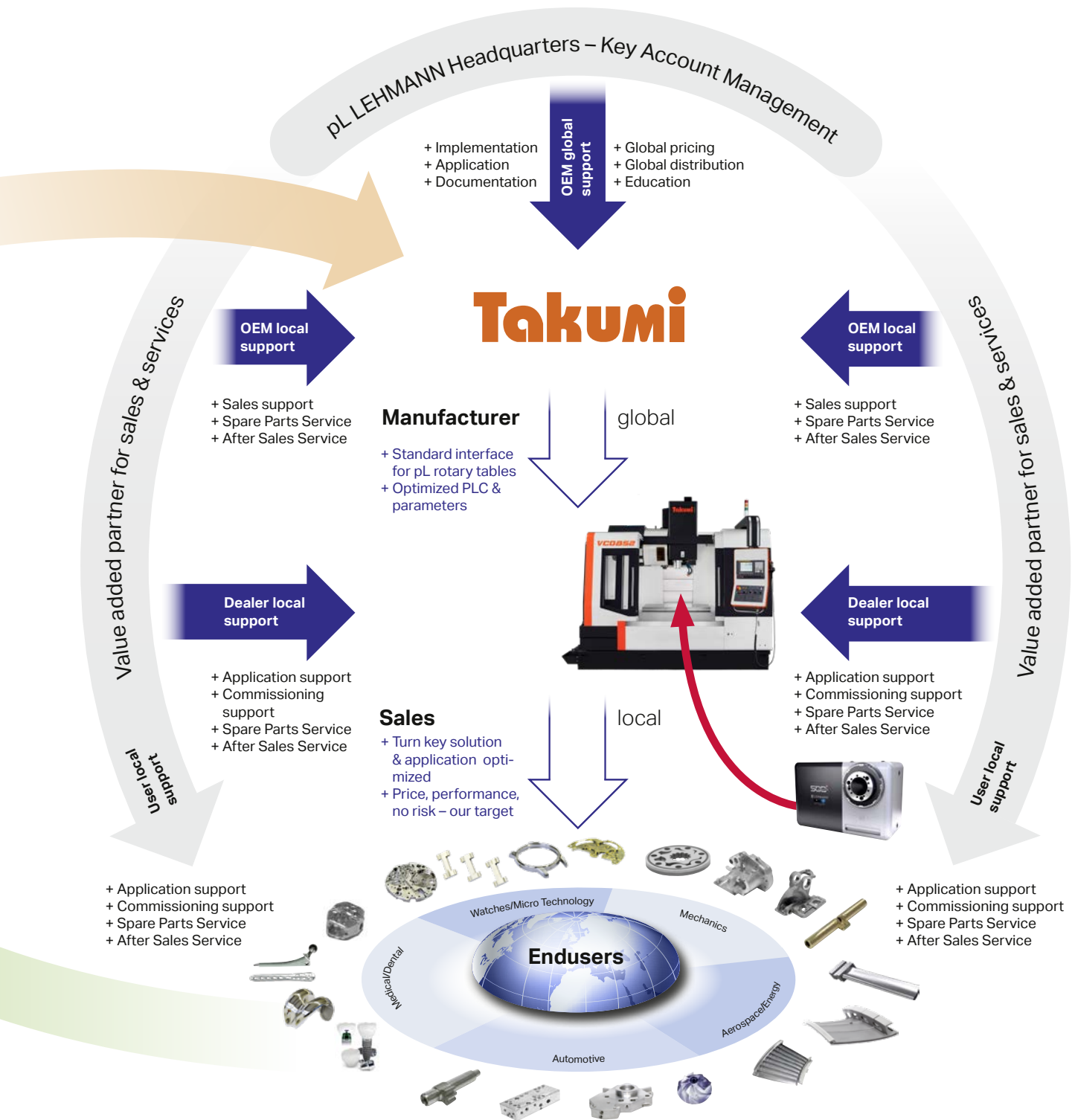
CNC rotary tables for economical manufacturing:
pL LEHMANN has suitable and rational solutions for
nearly every industry



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:
 Takumi 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

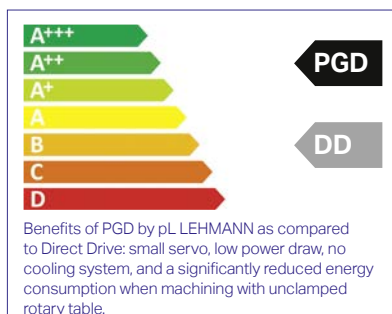
Heavy duty

E-Series



Rotary tables suitable for simultaneous operation!

Save energy



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

Connectivity

Wireless monitoring,
for operation & service

No adjust

Load change without
parameter adjustment

Less cost

No cooling system,
no hydraulics



G700



H10



H12



V10



VC0852



VT500

A word from Takumi:

«Professional Team and Outstanding Brand

At Takumi, our focus is customer-oriented design. Our products are designed based on market analysis. Our parts are sourced from first-class manufacturers and professional suppliers in Taiwan. We have established long-term partnerships with our main suppliers. Takumi understands our customers' requirements. We provide professional service at our complete sales and service centers. Based on the guiding principles of «respect, teamwork, innovation, and service,» the Takumi team of professionals continues to develop vertical machining centers, high speed double-column machining centers, and 5-axis machining centers. Takumi is dedicated to providing a complete product line and fulfilling diverse customer needs.»

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

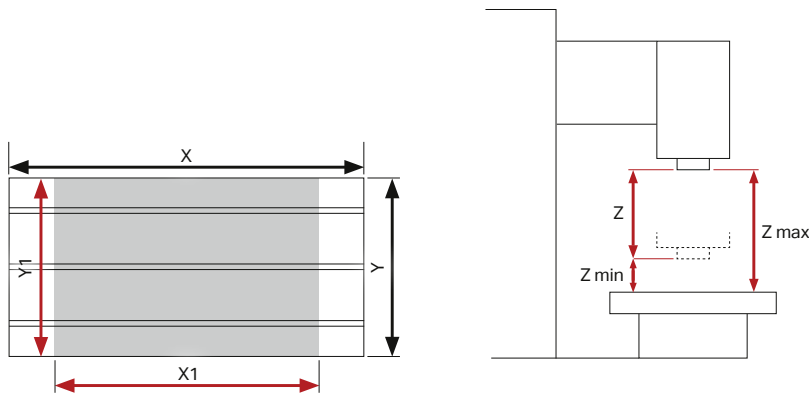


	Table diameter [mm]		Permissible overhang *	Traverse stroke [mm]					Table load ** max [kg]
	X	Y		X1	Y1	Z	Zmin	Zmax	
B5	550	600	10%	550	600	350	90	440	500
G5	650	600	10%	550	600	350	90	440	500
G700	810	620	10%	750	600	500	150	650	1'000
G1000	1'050	700	10%	1'020	700	500	150	650	1'000
H7	810	620	10%	750	600	500	150	650	500
H10	1'050	700	10%	1'020	700	500	180	680	800
H12	1'500	960	10%	1'350	900	600	200	800	2'500
V10	1'050	650	10%	1'000	660	610	150	760	1'000
V11	1'150	650	10%	1'100	660	610	150	760	1'100
V12	1'250	650	10%	1'200	660	610	150	760	1'200
V15	1'600	760	10%	1'524	762	720	150	870	1'500
VC0852	1'000	520	10%	860	520	610	115	725	500
VC1052	1'160	520	10%	1'060	520	610	115	725	650
VC1200	1'500	660	10%	1'270	660	610	150	760	1'360
VT500	650	400	40%	500	400	330	150	480	250

* 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

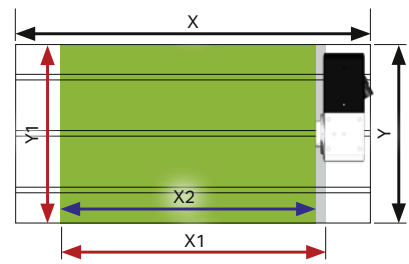
	EA-507 X2	EA-510 X2	EA-520 X2	EA-530 X2
G1000			826	797

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

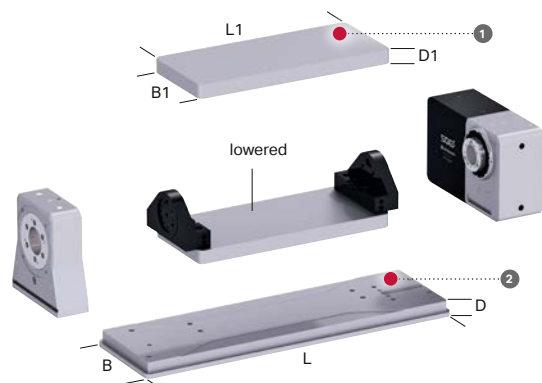


	EA-507 X2	EA-510 X2	EA-520 X2	EA-530 X2
B5	383	367	341	312
G5	433	417	391	362
G700	613	597	571	542
G1000			826	797
H7	613	597	571	542
H10			826	797
H12				1'187
V10		842	816	787
V11		942	916	887
V12		1'042	1'016	987
V15			1'353	1'324
VC0852	763	747	721	692
VC1052	943	927	901	872
VC1200		1'202	1'176	1'147
VT500	408	392	366	



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]	190	180	210	218							
	Length L1 [mm]	350 450	500 600	600 700 800	800 1000							
	Width B1 [mm]	165	215	270	270							
2 Base plates	Thickness D1 [mm]	20	35	40	40							
	Length L [mm]	622 722	785 885	916 1016 1116	1172 1372							
	Width B [mm]	168	248	301	368							
Weights / moments of inertia (without rotary table, without counter bearing)	Thickness D [mm]	30	30	30	38							
	Weight (Al) [kg]	10	12	23	28							
	Weight (steel) [kg]	29	34	66	80							
	Mom. inert. (Al) [kgm ²]	0.02	0.02	0.06	0.07							
Mom. inert. (steel) [kgm ²]	0.04	0.05	0.17	0.21								
					0.16	0.17	0.21	0.21	0.46	0.50	0.60	on request

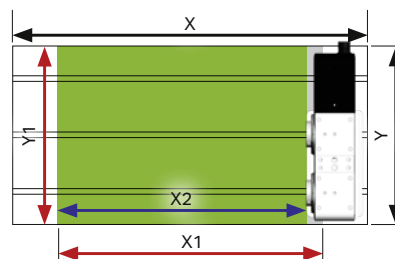
Explanations for pp. 8 to 11

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			
B5	324	314	324	
G5	374	364	374	
G700	554	544	554	
G1000	809	799	809	799
H7	554	544	554	
H10	809	799	809	799
H12		1'189	1'199	1'189
V10	799	789	799	789
V11	899	889	899	889
V12	999	989	999	989
V15	1'336	1'326	1'336	1'326
VC0852	704	694		
VC1052	884	874		
VC1200	1'159	1'149	1'159	1'149
VT500	349	339		

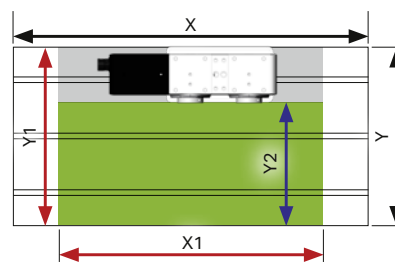
Y-mounting



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

	M2-507	M2-510	M3-507	M3-510
	Y2			
B5				
G5				364
G700				374
G1000				
H7				374
H10				
H12				
V10				
V11				
V12				
V15				
VC0852			294	284
VC1052			294	284
VC1200				
VT500			174	164

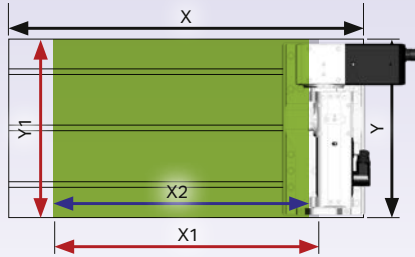
X-mounting



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

Machine combinations with T-type rotary tables

Y-mounting



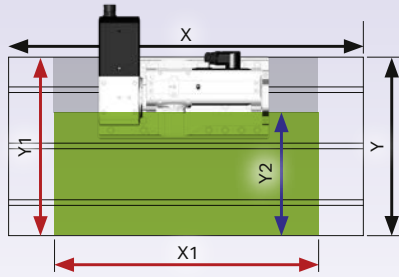
Rotary table installation using hole pattern in base plate



	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	TOP1 T1-507510
	X2	X2	X2	X2	X2	X2	X2	X2	X2	X2
B5	420	376	356	380	360		380	360		380
G5	470	426	406	430	410		430	410		430
G700	650	606	586	610	590		610	590		610
G1000	905	861	841	865	845	811	865	845		865
H7	650	606	586	610	590		610	590		610
H10	905	861	841	865	845	811	865	845		865
H12		1'251	1'231	1'255	1'235	1'201	1'255	1'235	1'201	1'255
V10	895	851	831	855	835	801	855	835		855
V11	995	951	931	955	935	901	955	935		955
V12	1'095	1'051	1'031	1'055	1'035	1'001	1'055	1'035		1'055
V15	1'432	1'388	1'368	1'392	1'372	1'338	1'392	1'372	1'338	1'392
VC0852	800	756		760			760			
VC1052	980	936		940			940			
VC1200	1'255	1'211	1'191	1'215	1'195	1'161	1'215	1'195		1'215
VT500	445	401		405						

	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	X2	X2	X2	X2	X2	X2	X2	X2	X2	X2
B5			380								
G5			430								
G700			610								
G1000	845		865			865			865		
H7			610								
H10	845		865			865			865		
H12	1'235	1'201	1'255	1'235		1'255	1'235		1'255	1'235	
V10	835		855			855					
V11	935		955			955					
V12	1'035		1'055			1'055					
V15	1'372	1'338	1'392	1'372		1'392			1'392		
VC0852											
VC1052											
VC1200	1'195		1'215			1'215					
VT500											

X-mounting



Rotary table installation using hole pattern in base plate



TIP1



TAP1



TOP1.2

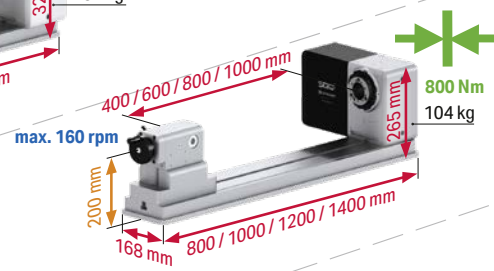
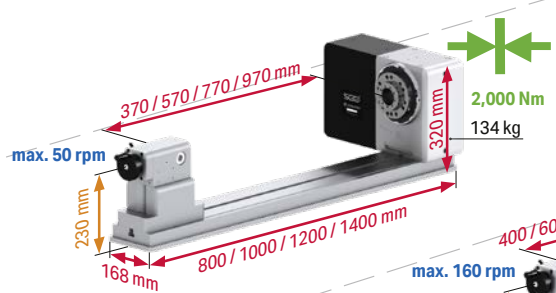
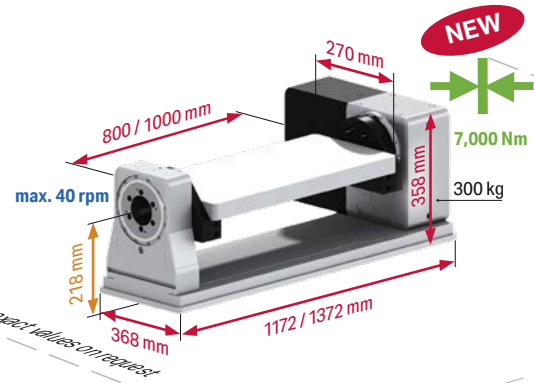
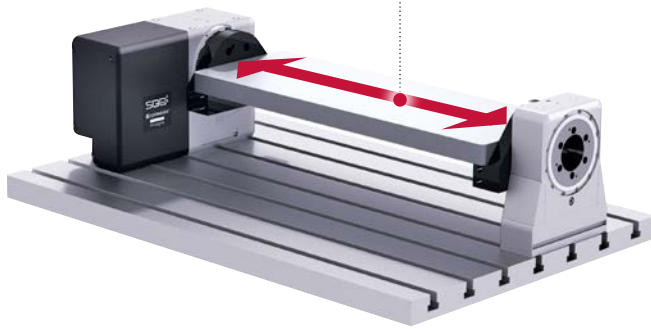
	TIP1c TF-507510 Y2	TIP2c TF-510520 Y2	TIP3c TF-520530 Y2	TAP1c T1-507510 Y2	TAP2c T1-510520 Y2	TAP3c T1-520530 Y2	TAP1 T1-507510 Y2	TAP2 T1-510520 Y2	TAP3 T1-520530 Y2	TOP1 T1-507510 Y2
B5										
G5										
G700						386			386	
G1000									476	
H7										
H10									476	
H12										
V10									431	
V11									431	
V12									431	
V15										
VC0852			326		330			330		350
VC1052			326		330	296		330	296	350
VC1200									436	
VT500							230			230

	TOP2 T1-510520 Y2	TOP3 T1-520530 Y2	TAP1c.2 T1-507510 Y2	TAP2c.2 T1-510520 Y2	TAP3c.2 T1-520530 Y2	TAP1.2 T1-507510 Y2	TAP2.2 T1-510520 Y2	TAP3.2 T1-520530 Y2	TOP1.2 T2-507510 Y2	TOP2.2 T2-510520 Y2	TOP3.2 T2-520530 Y2
B5											
G5	410					430					
G700	420	386		420		440	420		440		
G1000		476		510	476		510			510	
H7	420			420		440	420		440		
H10		476		510	476		510			510	
H12					706			706			706
V10		431		465	431		465		485	465	
V11		431		465	431		465	431	485	465	
V12		431		465	431		465	431	485	465	431
V15					537		571	537		571	537
VC0852	330		350	330		350	330		350	330	
VC1052	330	296	350	330	296	350	330	296	350	330	
VC1200		436		470	436		470	436		470	436
VT500			230			230					



Very good accessibility, even with short tools

More space for workpieces and fixtures



530

520


51x

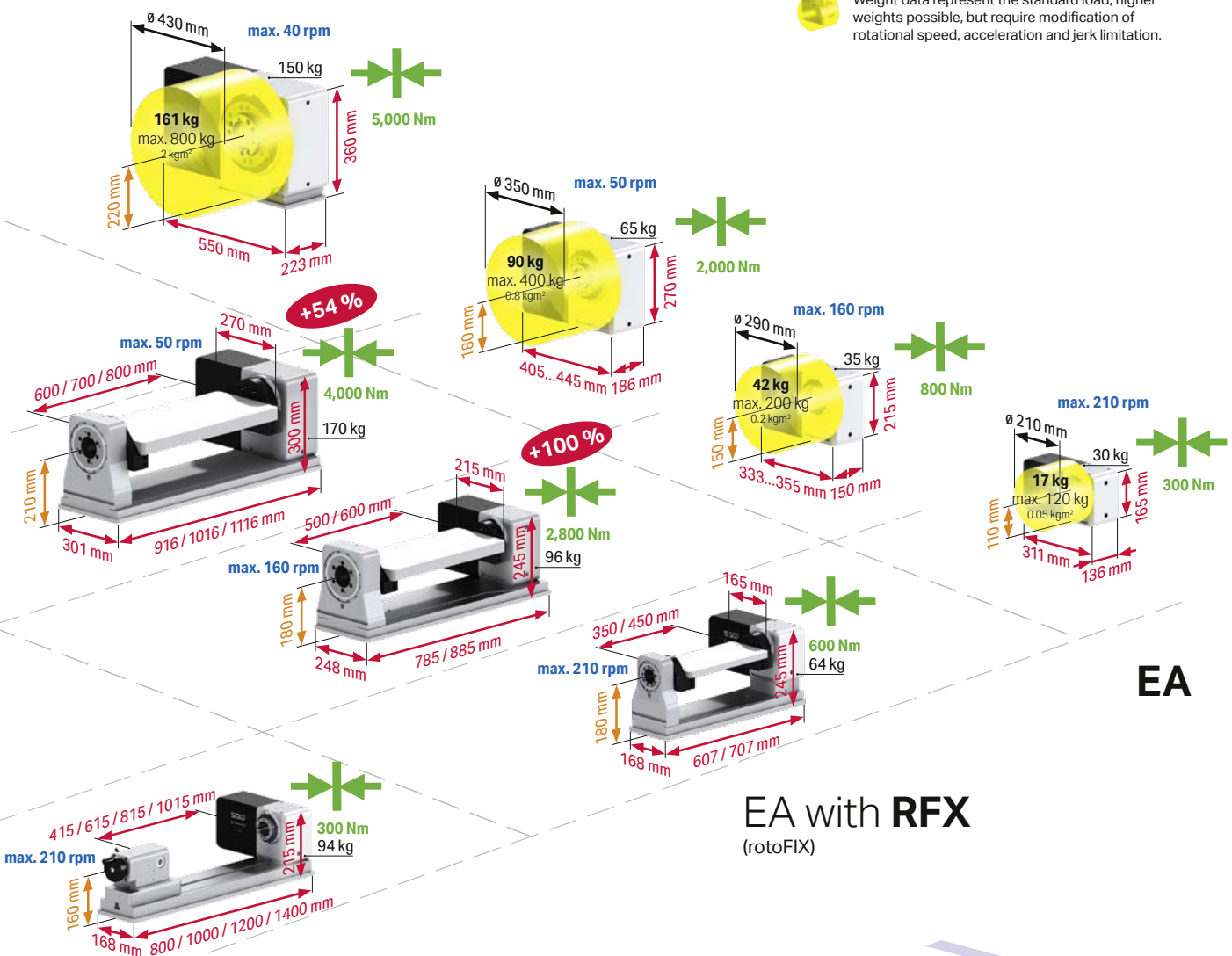
50x

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.



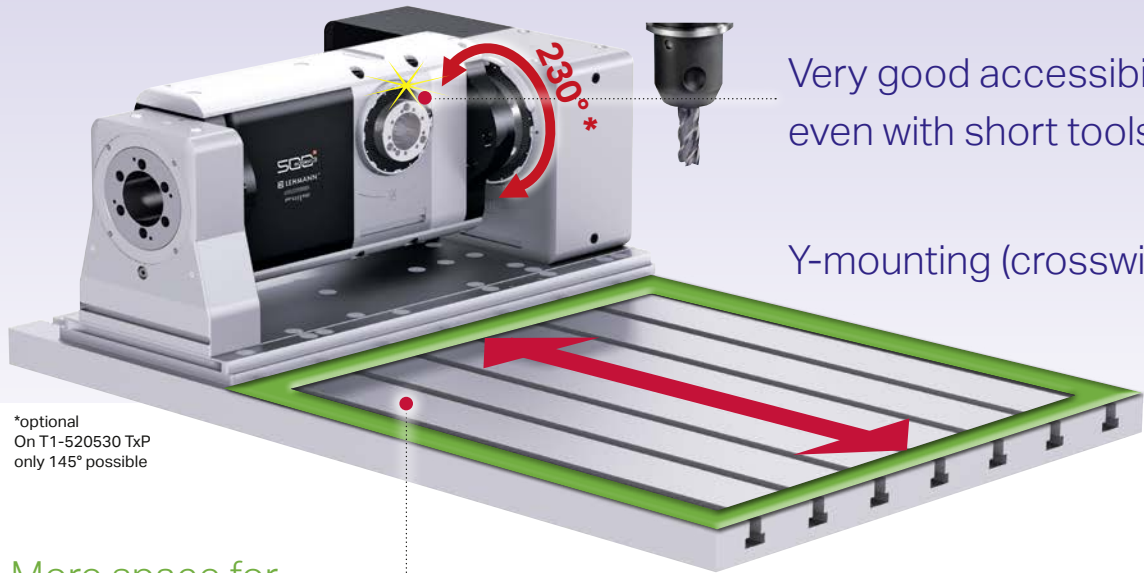
EA

EA with **RFX**
(rotoFIX)

EA with **LFX**
(longFLEX)

MODEL

- 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

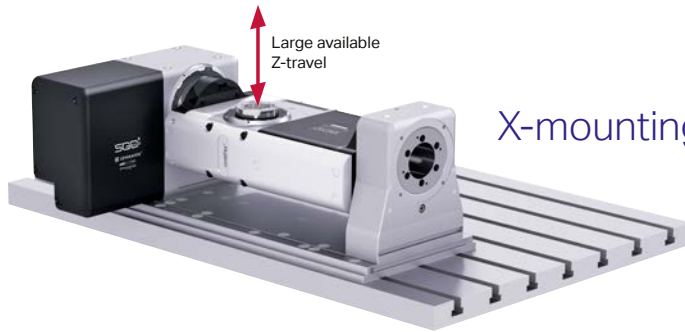


Very good accessibility, even with short tools

Y-mounting (crosswise)

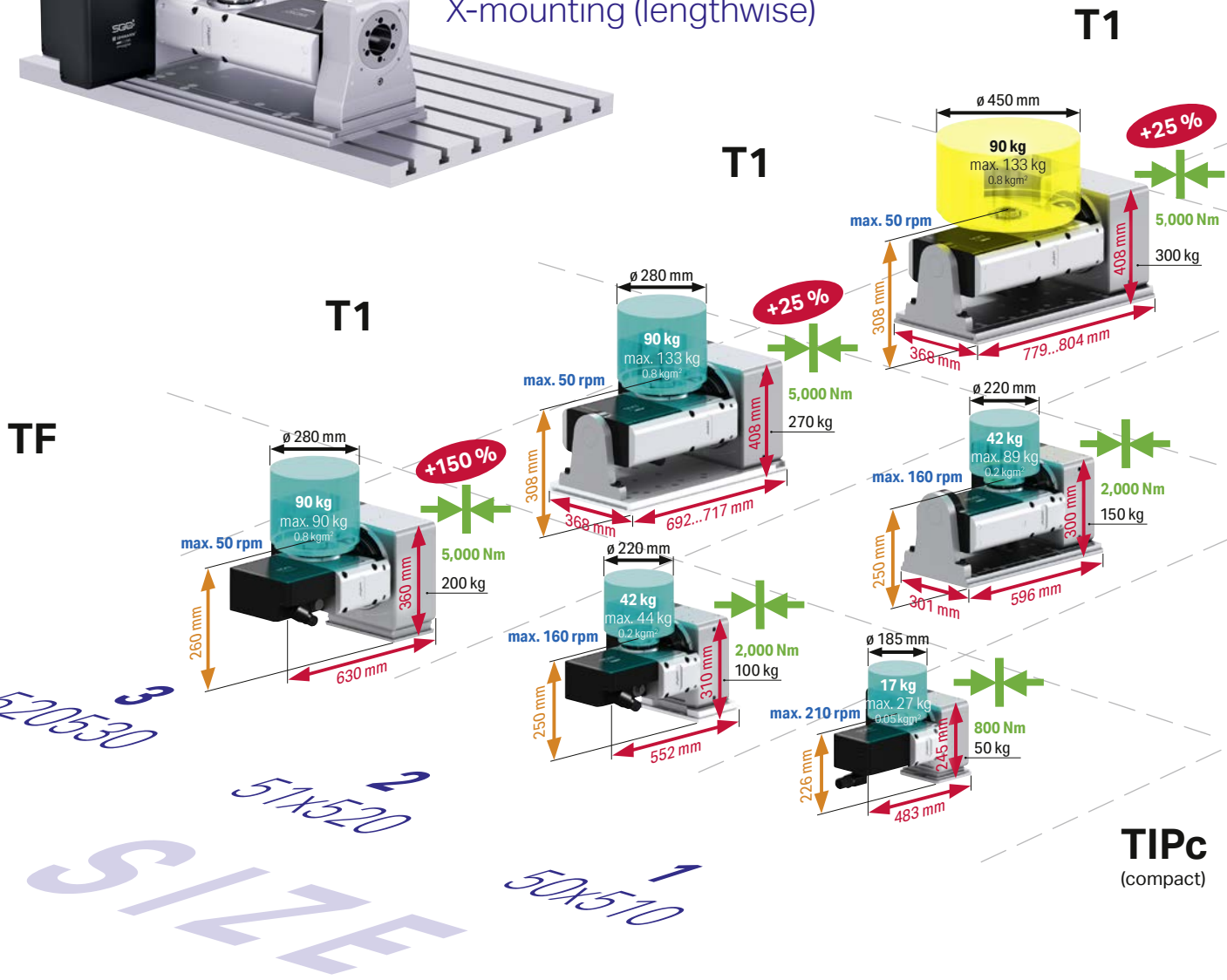
*optional
On T1-520530 TxP
only 145° possible

More space for workpiece and fixtures



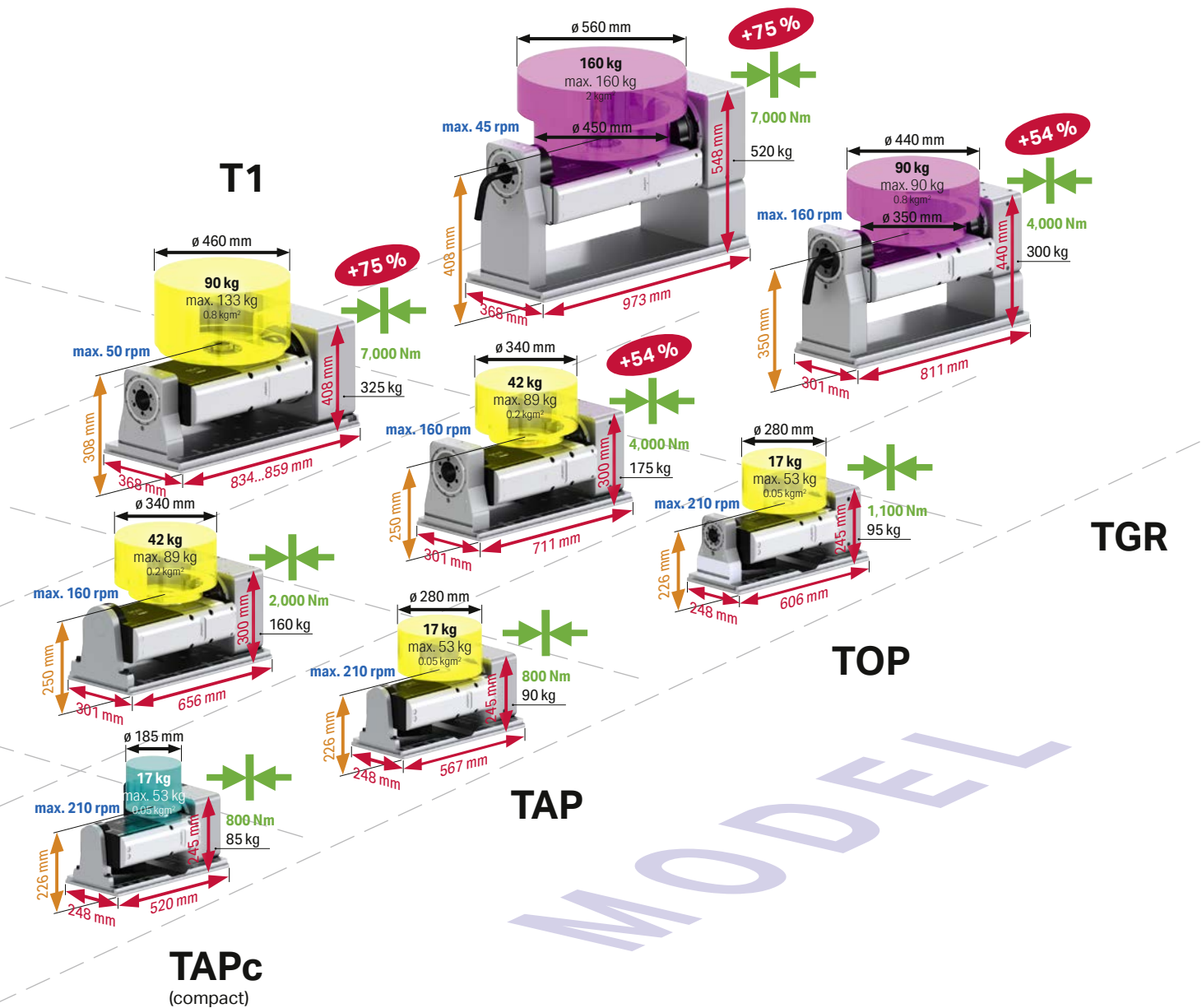
X-mounting (lengthwise)

T1



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

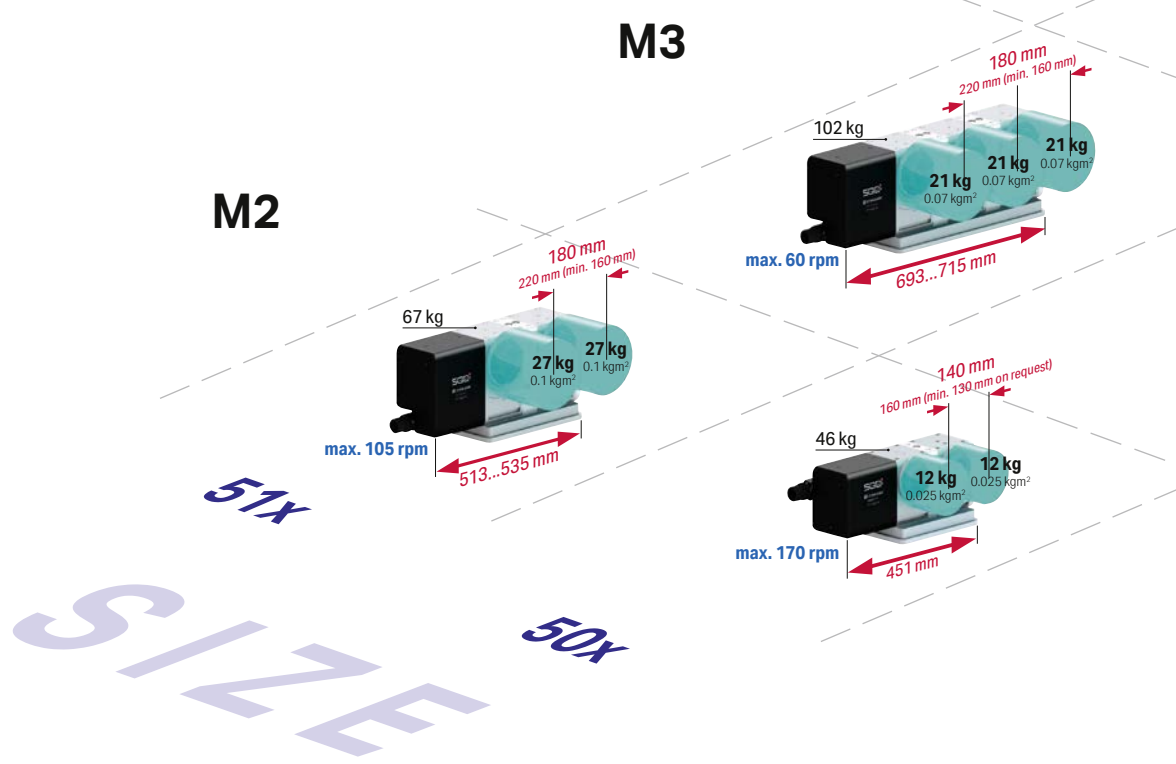


Weight data represent the standard load; higher weights possible, but require modification of rotational speed, acceleration and jerk limitation.

- 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

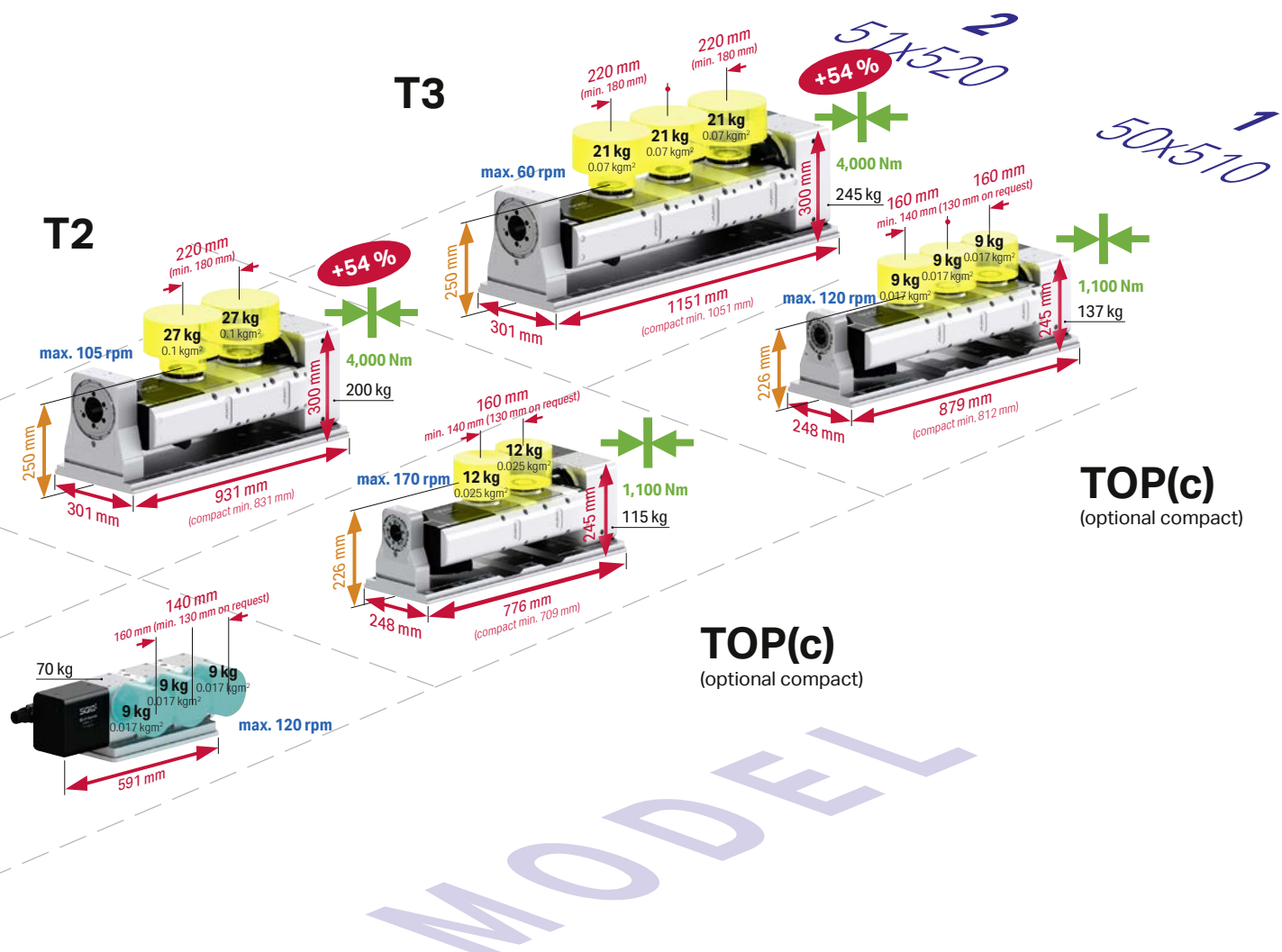



More space for workpiece and fixtures



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)

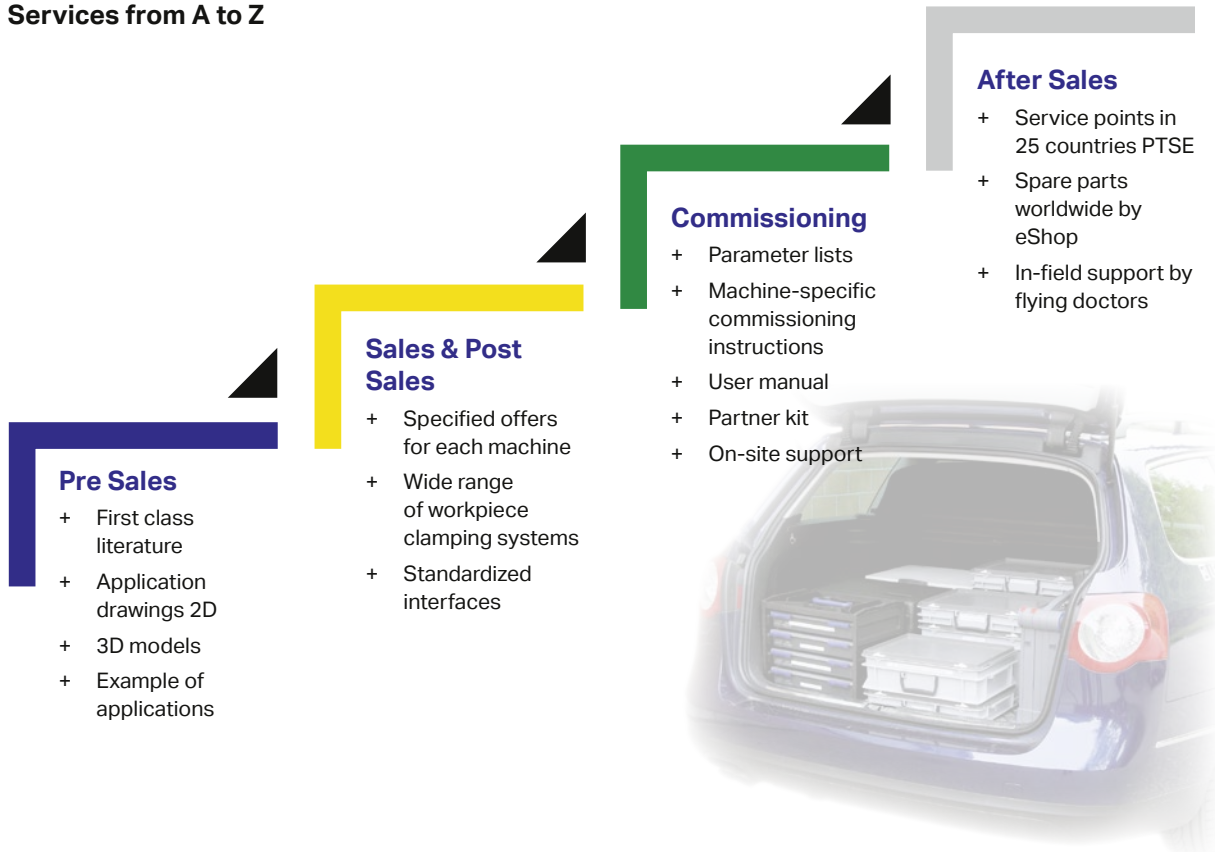


EA-507 with CAPTO retrofit kit

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

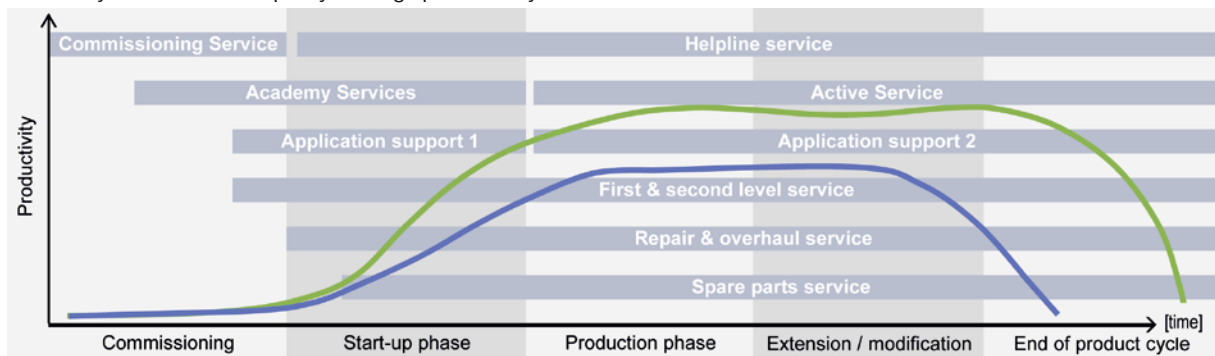


Services from A to Z



Increase productivity – Extend lifecycle

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



— Productivity with LifeCycle service products from pL LEHMANN
 — Productivity without service support

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



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Europe

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

America

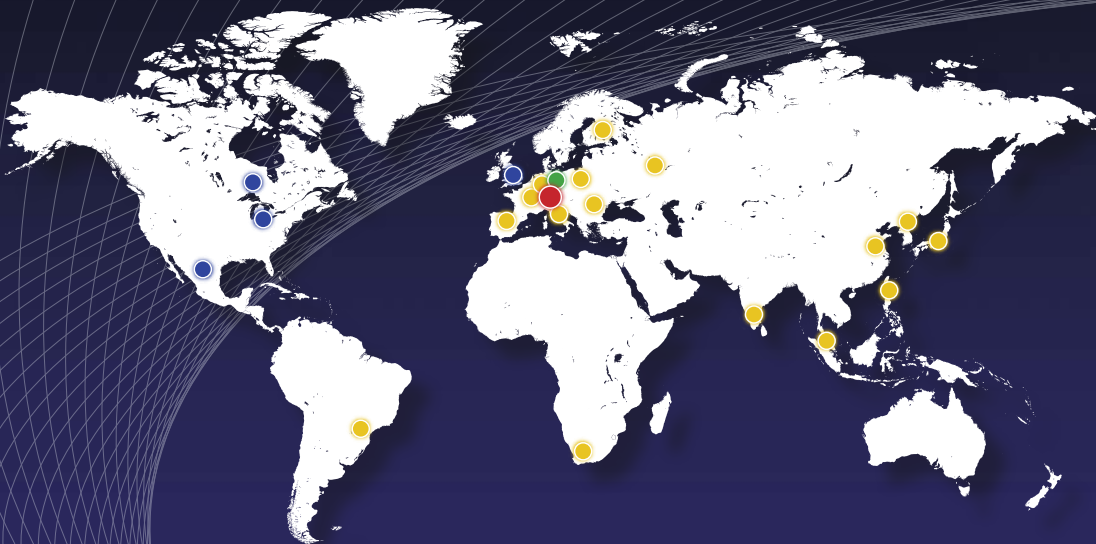
- Brazil
- Canada
- Mexico
- USA

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