

Selection Guide for CNC Rotary Tables ...



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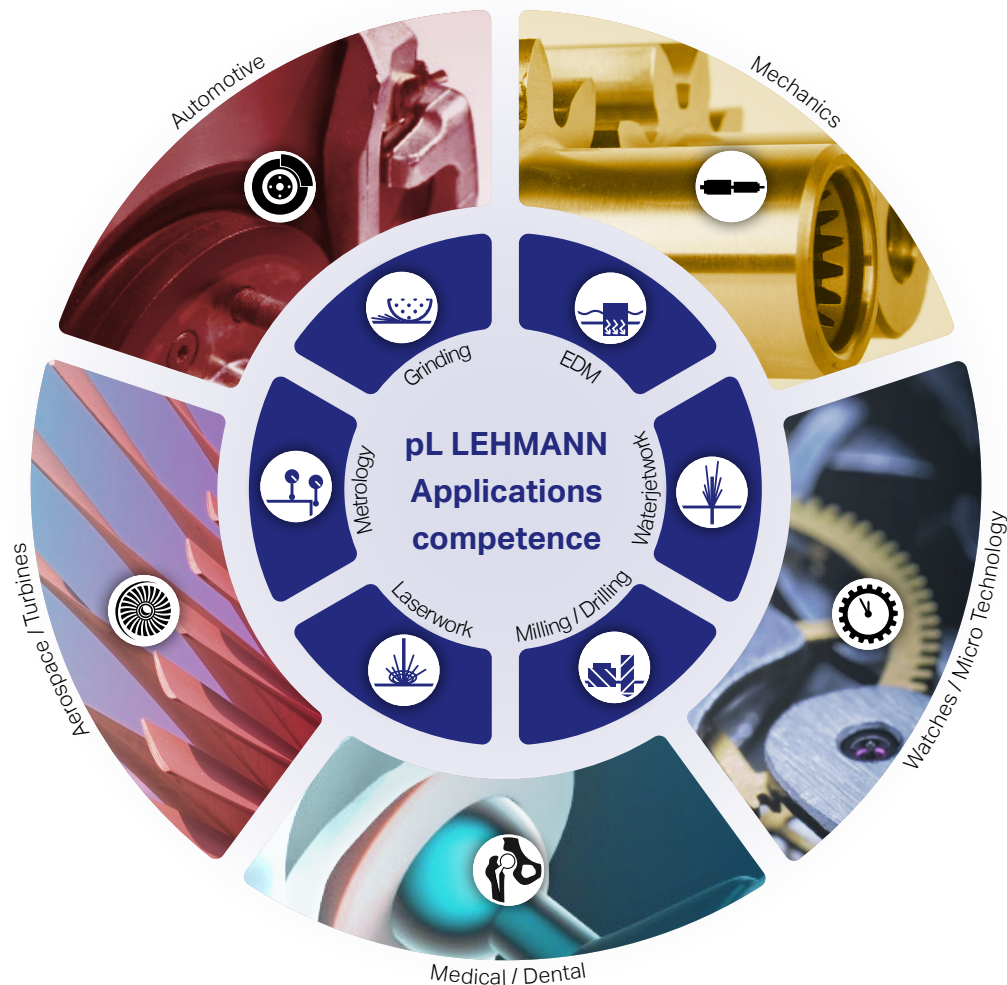
 **VICTOR
TAICHUNG**

02/2021 | EN



... for vertical machining centers

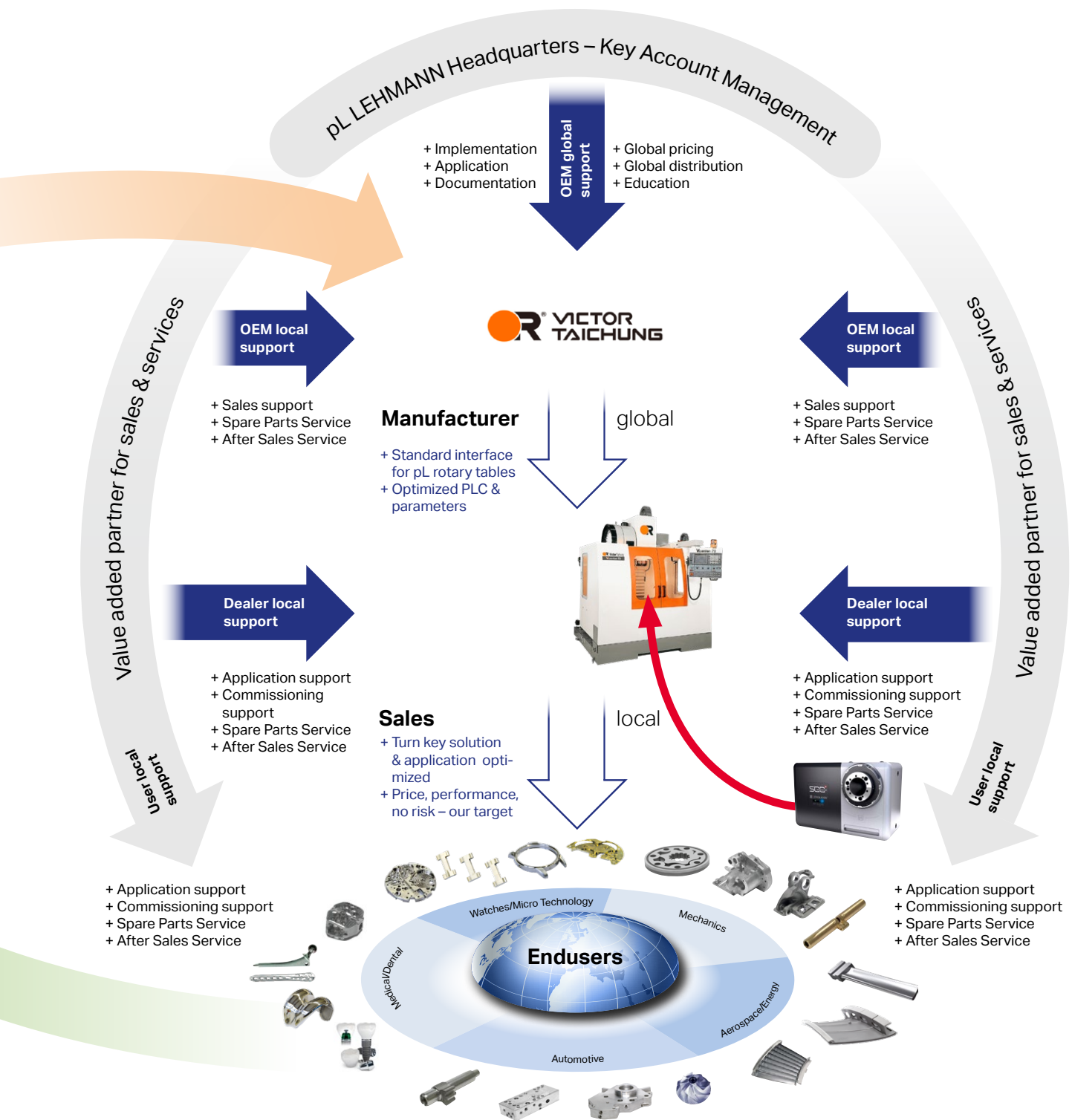
CNC rotary tables for economical manufacturing:
pL LEHMANN has suitable and rational solutions for
nearly every industry



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:
VICTOR 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

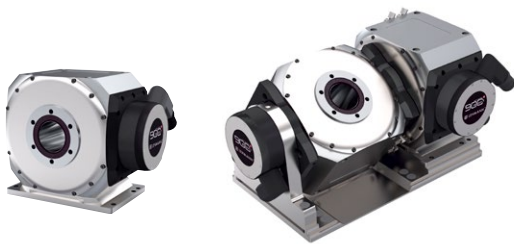
E-Series



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 μ m / 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



Vcenter-70



Vcenter-102B



Vcenter-102E



Vcenter-145



Vcenter-A130



Vcenter-P76

A word from VICTOR :

Invest in the Future

Founded in 1954, Victor Taichung Machinery Works Co., Ltd. started with making conventional lathes in Taiwan and now steadily supplies CNC lathes and machining centers by devoting her management to non-stop R&D and innovations. With more than 65% in-house manufacturing and her own foundry to offer highly reliable Meehanite® castings to further assure machine quality. All products are marketed globally under the brand names VICTOR or FORTUNE (in North America) which highlight her strong position as the leading machine tool manufacturer in Taiwan.

To ensure marketing for her own products, Victor Taichung has invested considerably in setting up a global distribution network. As well as numerous agents around the world the Victor group has 8 technical support and distribution centers located in USA, France, Germany, South Africa, Malaysia, Thailand and China. These centers act not only to market our machines but also to provide our customers with an efficient after-sales service and technical support. In 2019, Victor Taichung celebrates her 65 anniversary and is greatly confident to meet the fierce challenge of machine tool market.

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

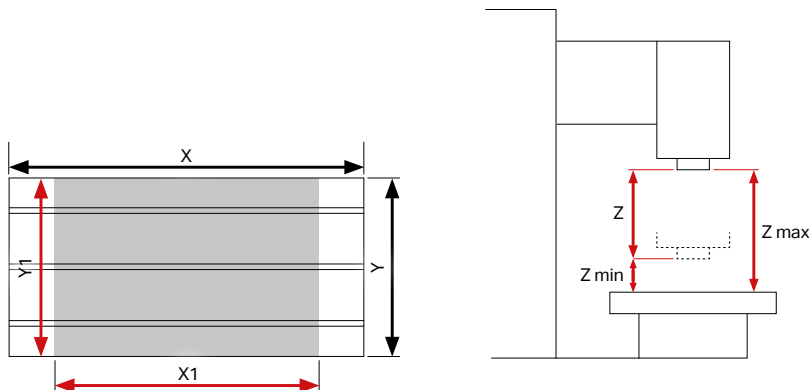


	Table diameter [mm]		Permissible overhang *	Traverse stroke [mm]					Table load ** max [kg]
	X	Y		X1	Y1	Z	Zmin	Zmax	
Vcenter-55	800	460	10%	550	460	460	150	610	300
Vcenter-70	800	460	10%	700	480	510	150	660	500
Vcenter-85A/B/C	1'100	510	10%	850	520	560	150	710	750
Vcenter-102A/B/C	1'100	510	10%	1'020	520	560	150	710	750
Vcenter-102E	1'100	510	10%	1'020	600	560	150	710	750
Vcenter-110	1'400	550	10%	1'100	600	560	180	740	800
Vcenter-130	1'400	550	10%	1'300	600	610	155	765	800
Vcenter-145	1'650	650	10%	1'450	700	700	200	900	2'200
Vcenter-165	1'700	800	10%	1'650	850	900	200	1'100	2'500
Vcenter-A72	800	460	10%	720	480	660	150	810	500
Vcenter-A85	1'100	600	10%	850	600	560	150	710	1'000
Vcenter-A110	1'350	600	10%	1'100	600	560	150	710	1'200
Vcenter-A130	1'400	700	10%	1'300	780	700	100	800	1'500
Vcenter-P76	840	500	10%	760	500	510	120	630	500
Vcenter-P106	1'120	520	10%	1'060	600	560	150	710	600
Vcenter-P136	1'400	700	10%	1'360	700	700	100	800	1'000

* 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
Vcenter-55	508	492	466	

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

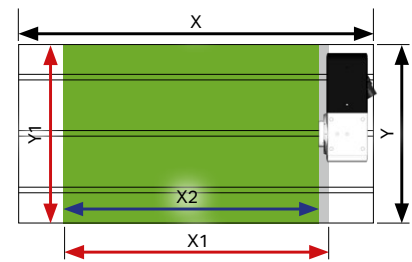


EA-510

EA-520

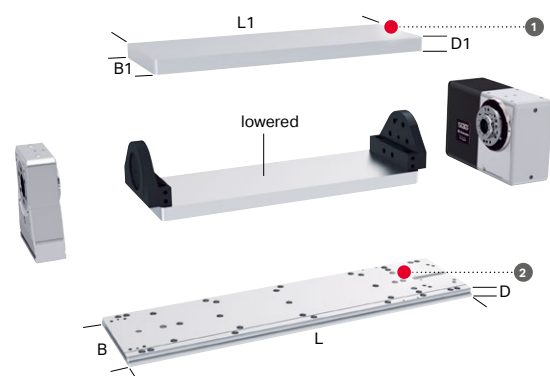
EA-530

	EA-507 X2	EA-510 X2	EA-520 X2	EA-530 X2
Vcenter-55	508	492	466	
Vcenter-70	583	567	541	
Vcenter-85A/B/C	808	792	766	737
Vcenter-102A/B/C	893	877	851	822
Vcenter-102E	893	877	851	822
Vcenter-110	1'083	1'067	1'041	1'012
Vcenter-130	1'183	1'167	1'141	1'112
Vcenter-145		1'367	1'341	1'312
Vcenter-165			1'466	1'437
Vcenter-A72	593	577	551	
Vcenter-A85	808	792	766	737
Vcenter-A110	1'058	1'042	1'016	987
Vcenter-A130			1'141	1'112
Vcenter-P76	633	617	591	562
Vcenter-P106	923	907	881	852
Vcenter-P136			1'171	1'142



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	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		

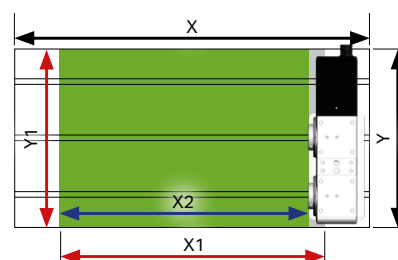
Explanations for pp. 8 to 11

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			
Vcenter-55	449			
Vcenter-70	524			
Vcenter-85A/B/C	749	739		
Vcenter-102A/B/C	834	824		
Vcenter-102E	834	824		
Vcenter-110	1'024	1'014	1'024	
Vcenter-130	1'124	1'114	1'124	
Vcenter-145	1'324	1'314	1'324	1'314
Vcenter-165	1'449	1'439	1'449	1'439
Vcenter-A72	534			
Vcenter-A85	749	739	749	
Vcenter-A110	999	989	999	
Vcenter-A130	1'124	1'114	1'124	1'114
Vcenter-P76	574	564		
Vcenter-P106	864	854		
Vcenter-P136	1'154	1'144	1'154	1'144

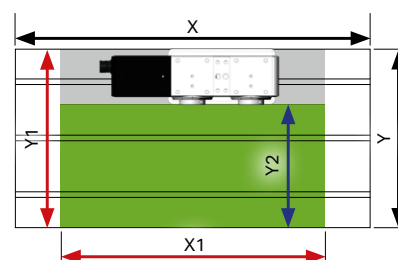
Y-mounting



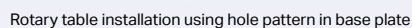
Rotary table installation with pL clamping claws in accordance with the operating manual

	M2-507	M2-510	M3-507	M3-510
	Y2			
Vcenter-55		224	234	224
Vcenter-70		234	244	234
Vcenter-85A/B/C			289	279
Vcenter-102A/B/C			289	279
Vcenter-102E			329	319
Vcenter-110				
Vcenter-130				
Vcenter-145				
Vcenter-165				
Vcenter-A72		234	244	234
Vcenter-A85				364
Vcenter-A110				364
Vcenter-A130				
Vcenter-P76			274	264
Vcenter-P106			334	324
Vcenter-P136				

X-mounting



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

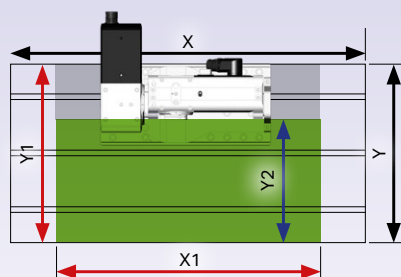


TAP1

TOP1.2

[illegible]

X-mounting



Rotary table installation using hole pattern in base plate



TIP1

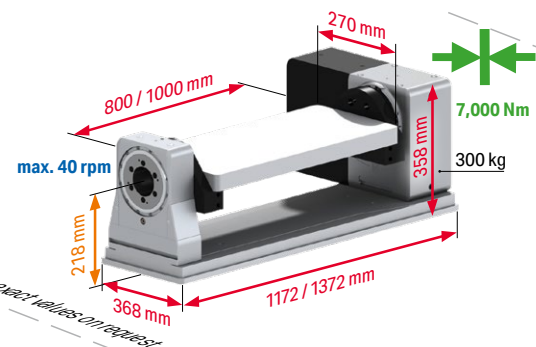
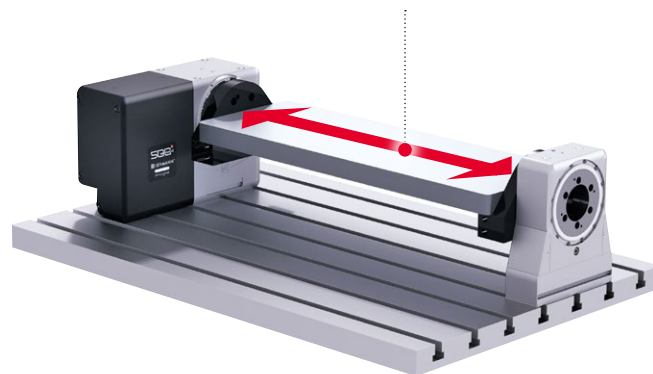


TAP1



TOP1.2

[illegible][illegible]



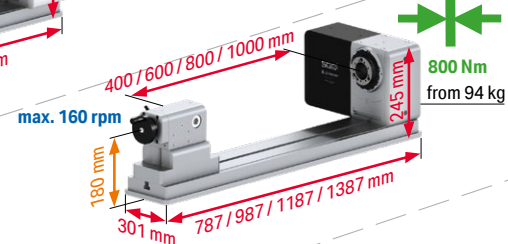
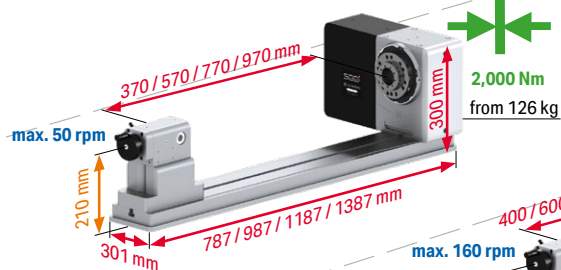
530

520

51x

SIZE

50x

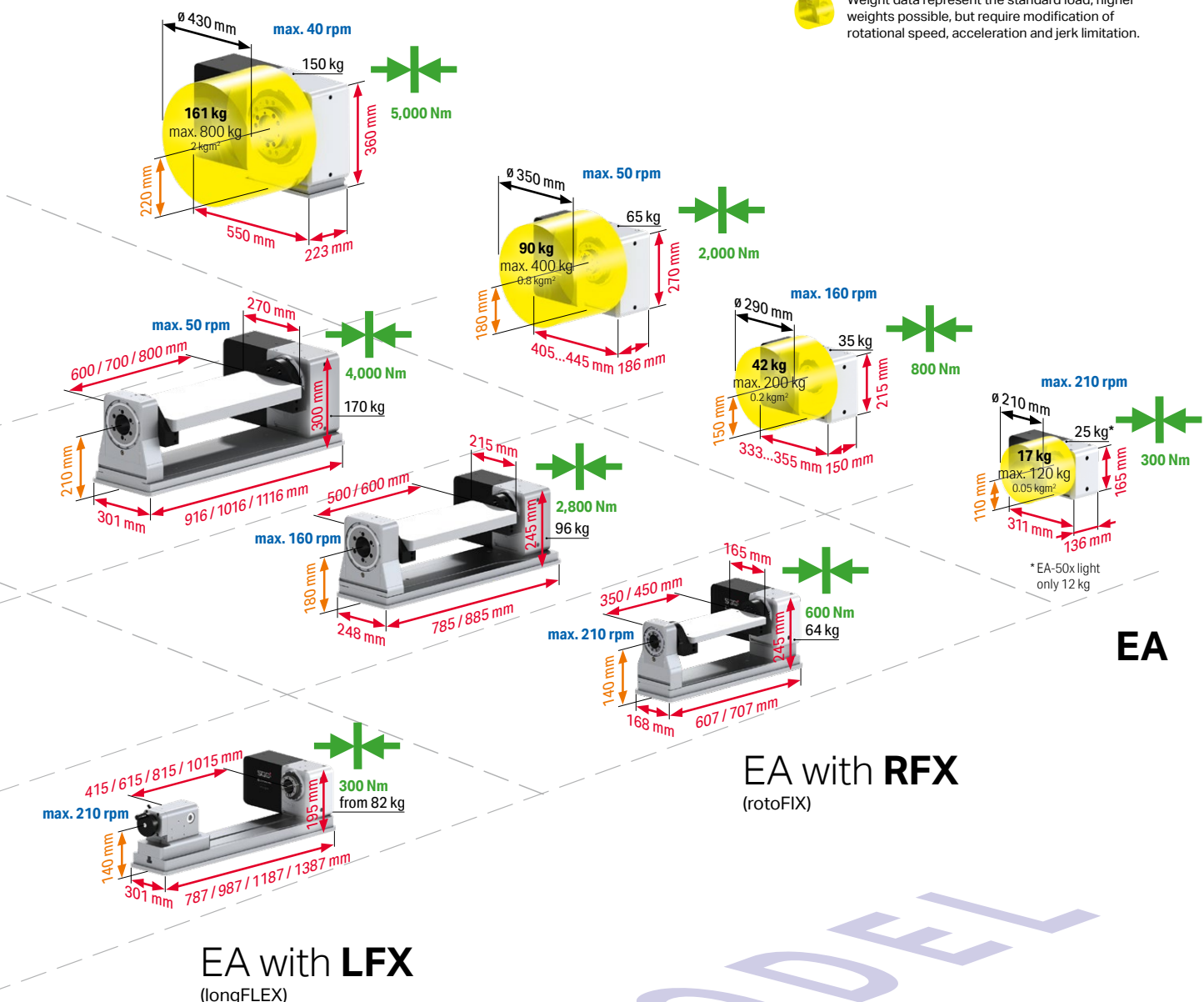


Facts

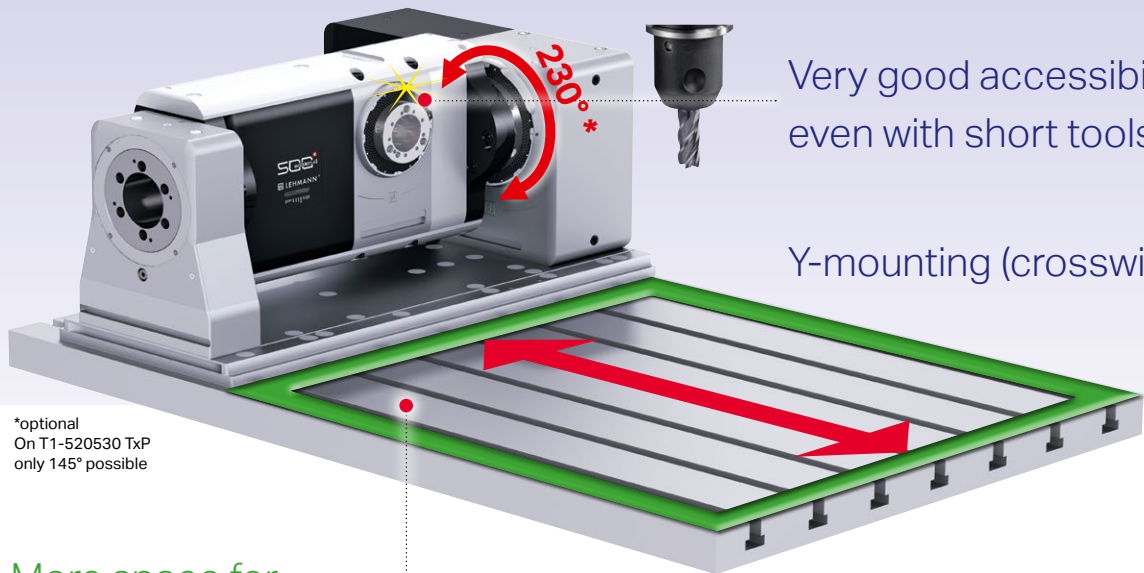
1. High speed up to **210 rpm**
2. Feed torque up to **850 Nm** (tentative)
3. Steel base plates with hole pattern (suitable for slot spacing of 100 and 125 mm)
4. Cycle time **90°** as fast as **0.21 sec.**



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

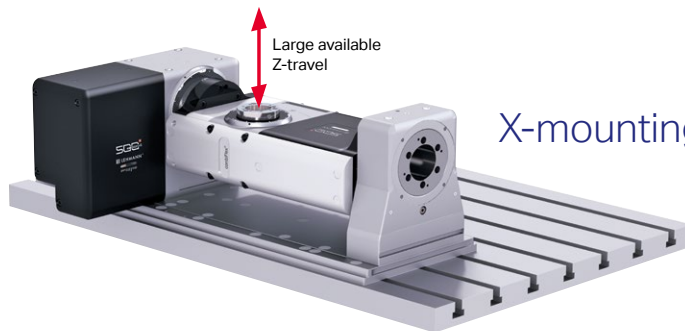


Very good accessibility,
even with short tools

Y-mounting (crosswise)

*optional
On T1-520530 TxP
only 145° possible

More space for
workpiece and fixtures



Large available
Z-travel

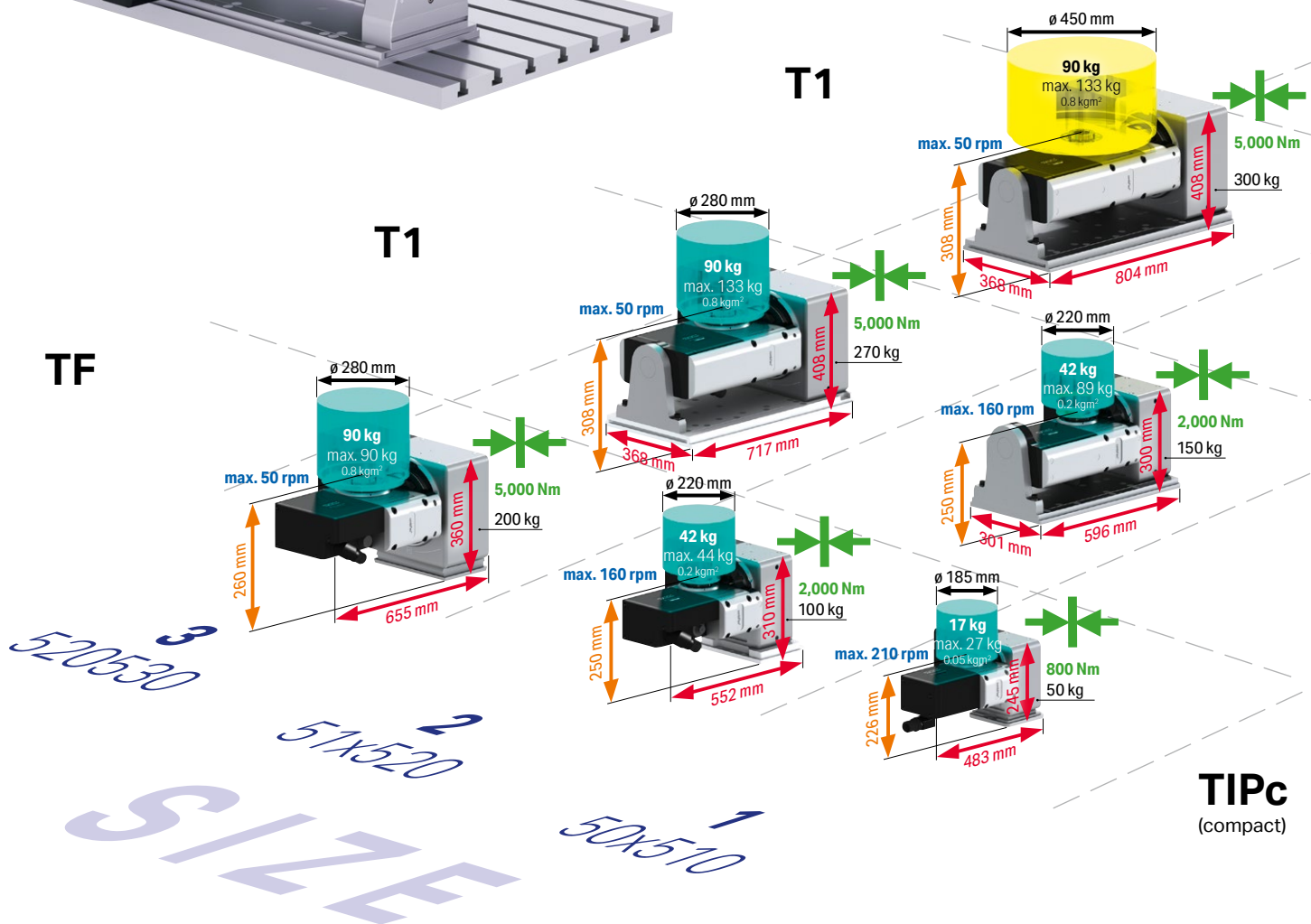
X-mounting (lengthwise)

T1

T1

T1

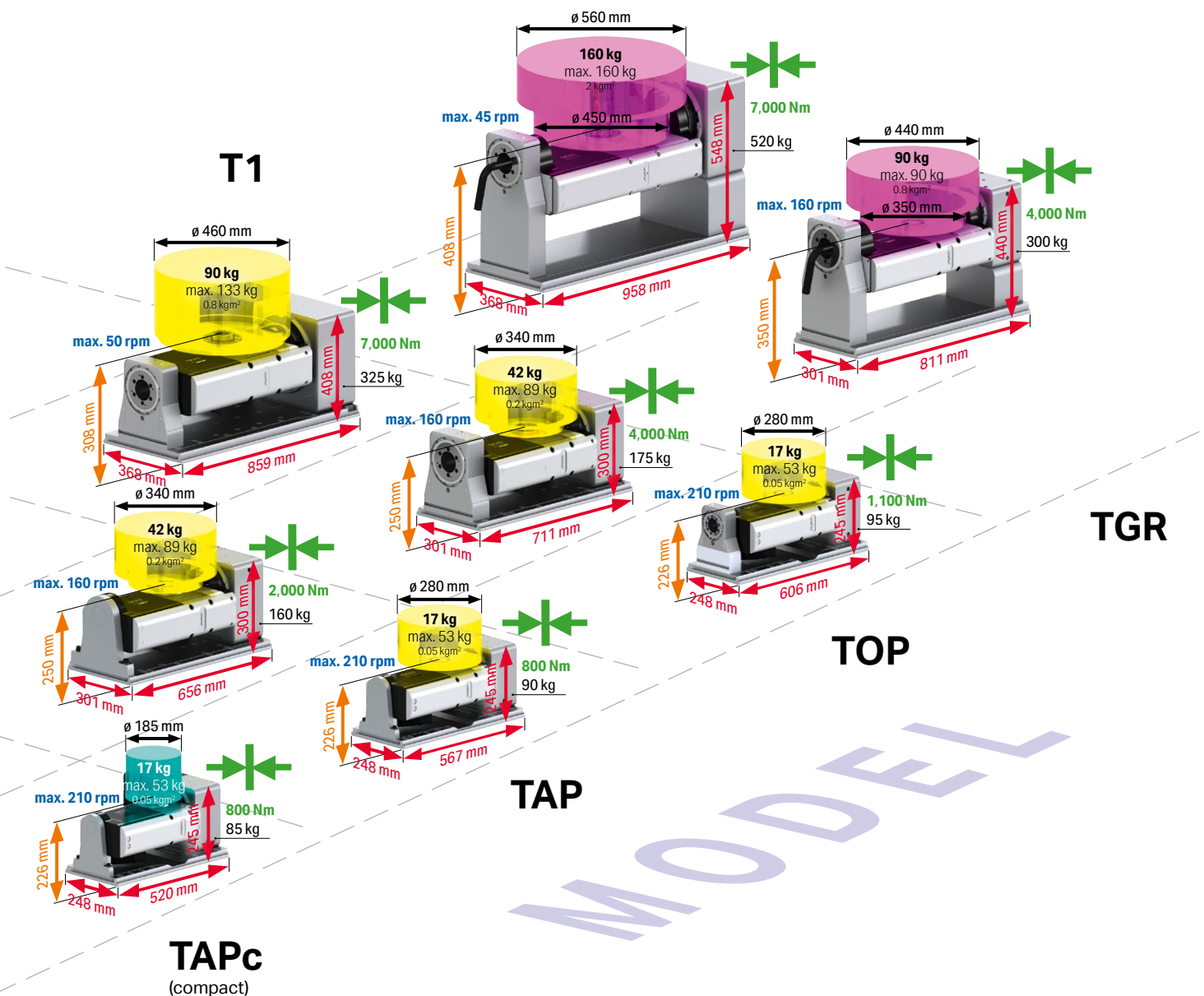
TF



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



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

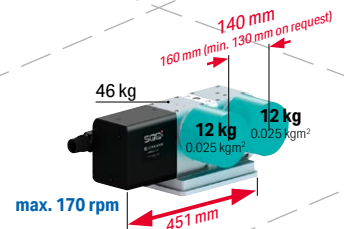
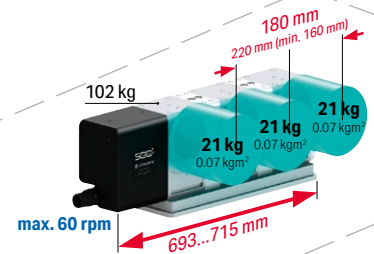
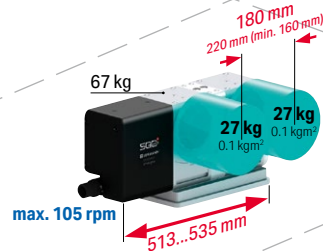


M2

M3

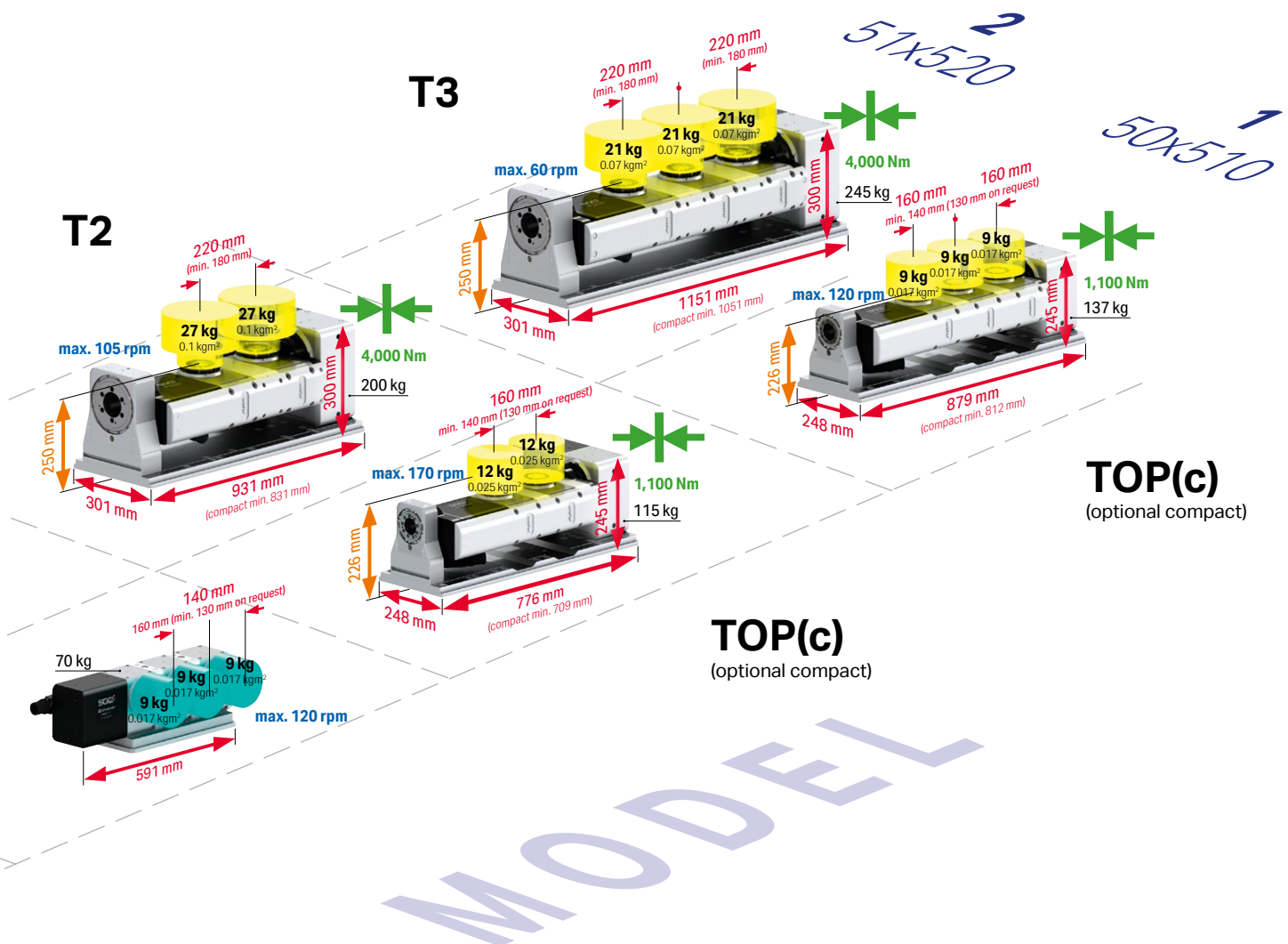
SIZE

50x



Facts

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

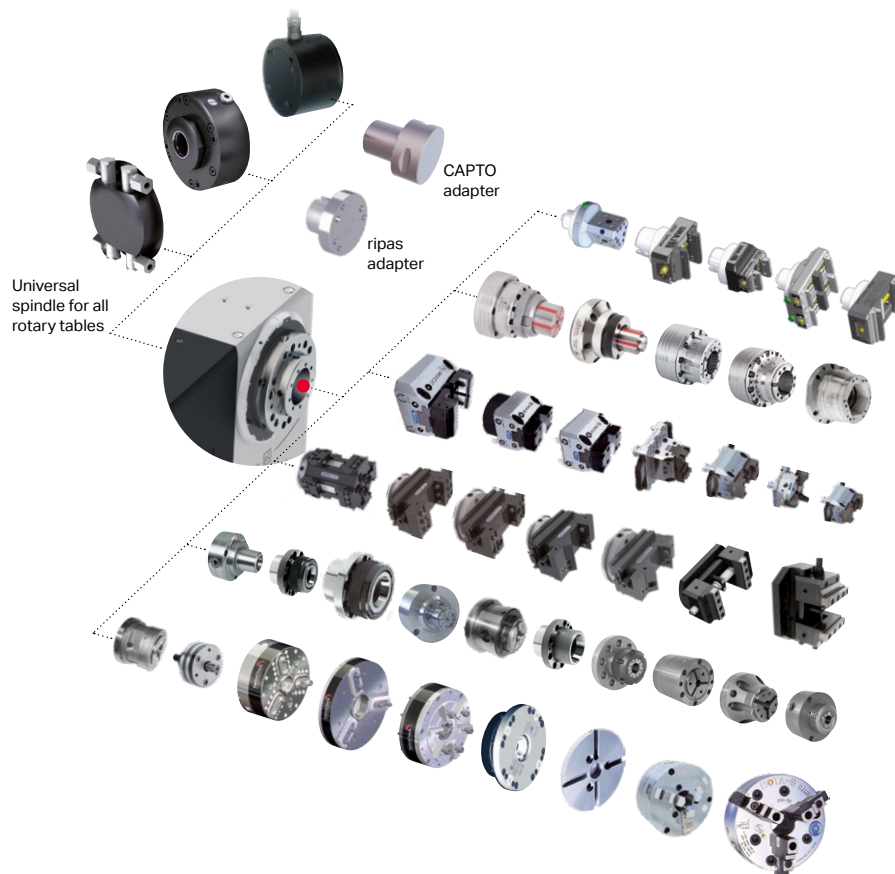


- 50x 507 (standard) or 508 (high speed)
- 51x 510 (standard) or 511 (high speed)
- M2 Single-axis, multi-spindle rotary table, 2-position
- M3 Single-axis, multi-spindle rotary table, 3-position
- T2 Two-axis multi-spindle rotary table, 2-position
- T3 Two-axis multi-spindle rotary table, 3-position

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

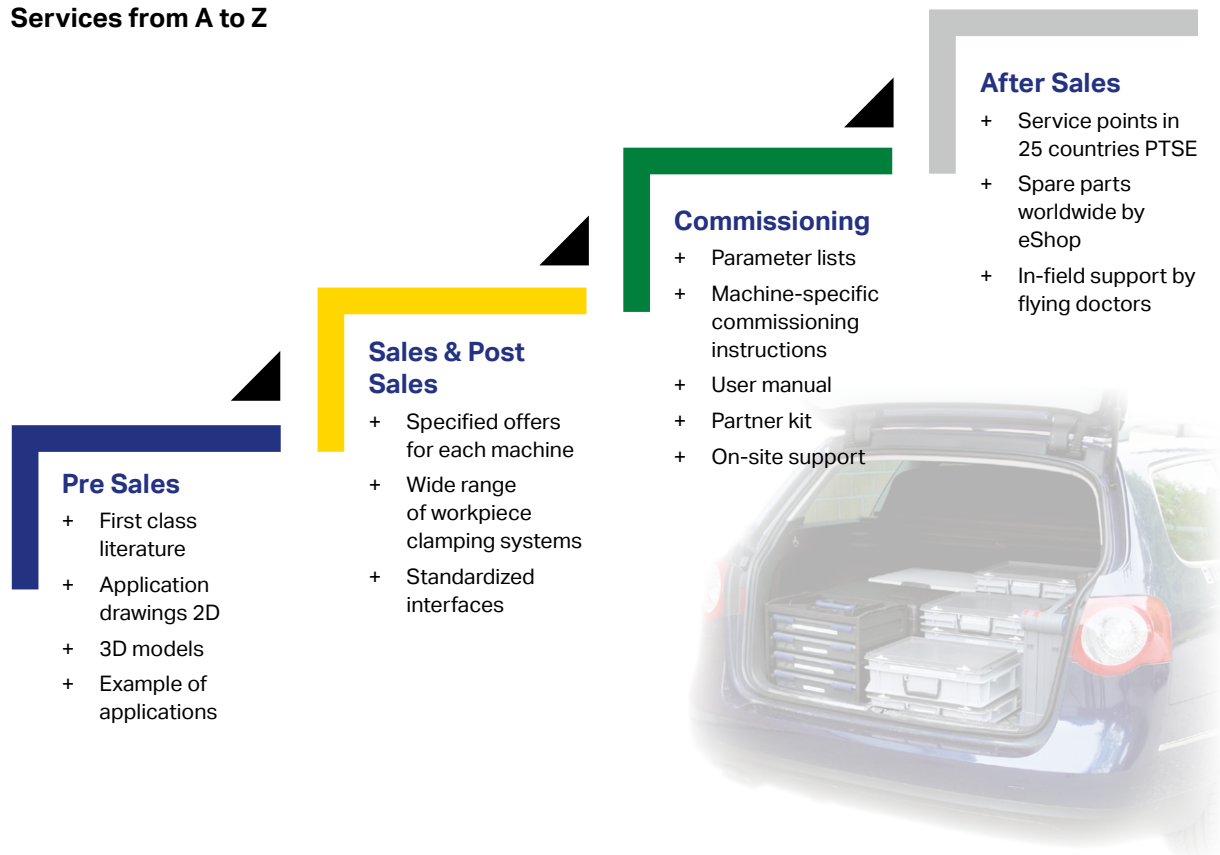


EA-507 with CAPTO retrofit kit

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

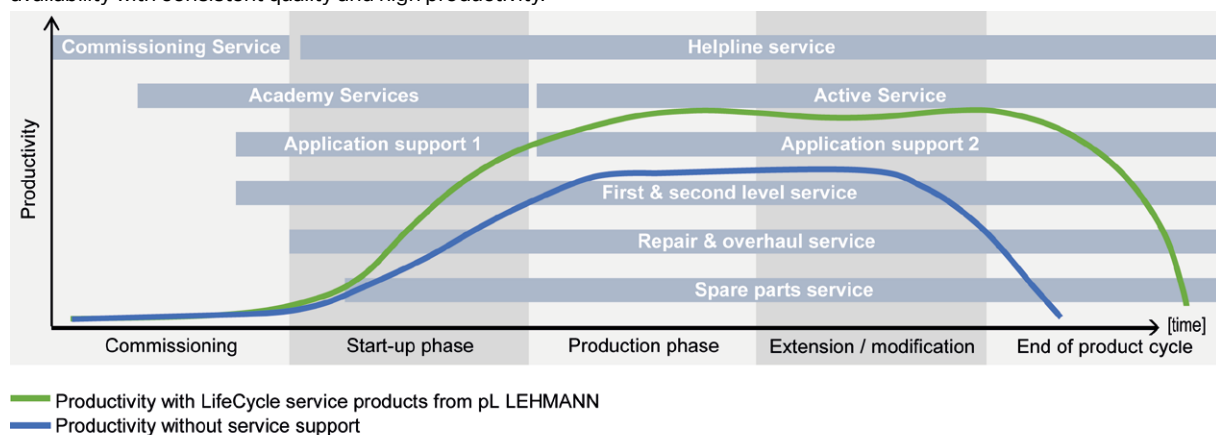


Services from A to Z



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.



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● Headquarters ● direct sales/service partner ● pL SOLUTIONS® partner ● value added reseller & partner

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