



Selection Guide for CNC Rotary Tables ...



Bluetooth®

pl

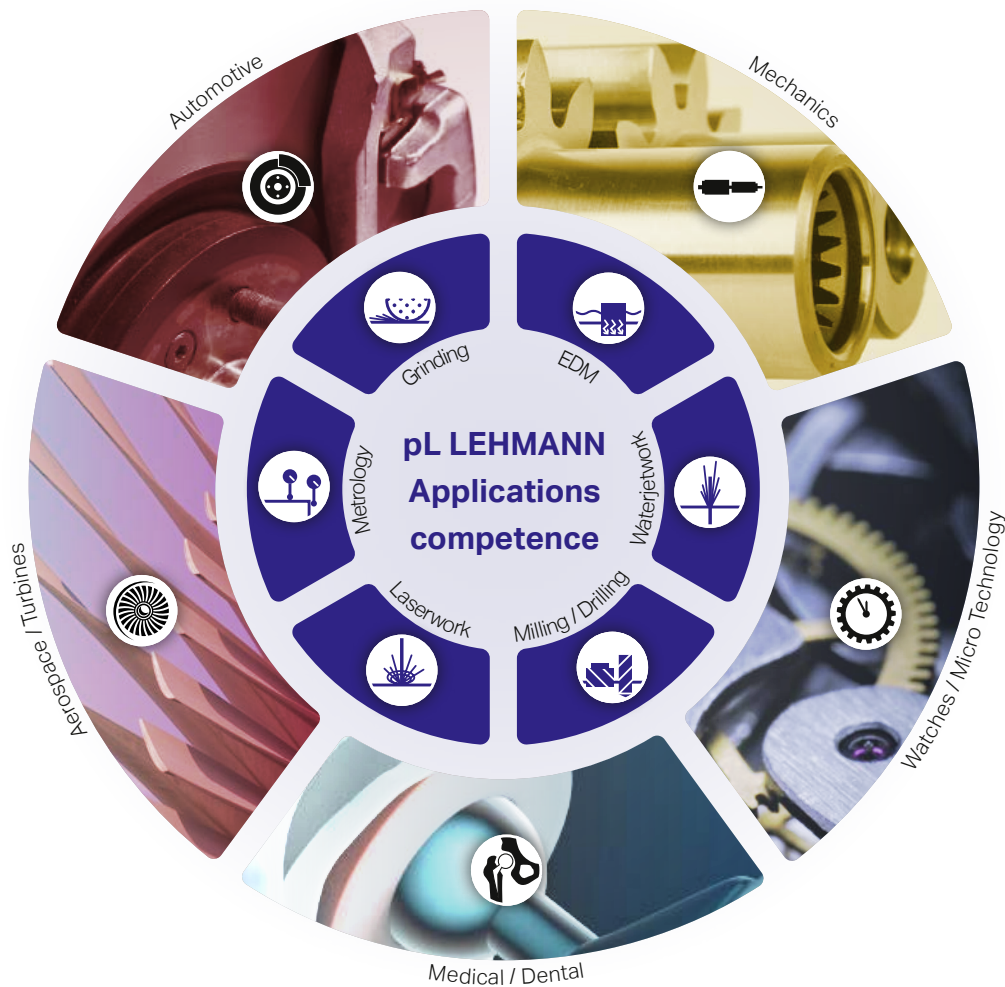
FEHLMANN

10/2018 | EN



... for Picomax- and Versa-series

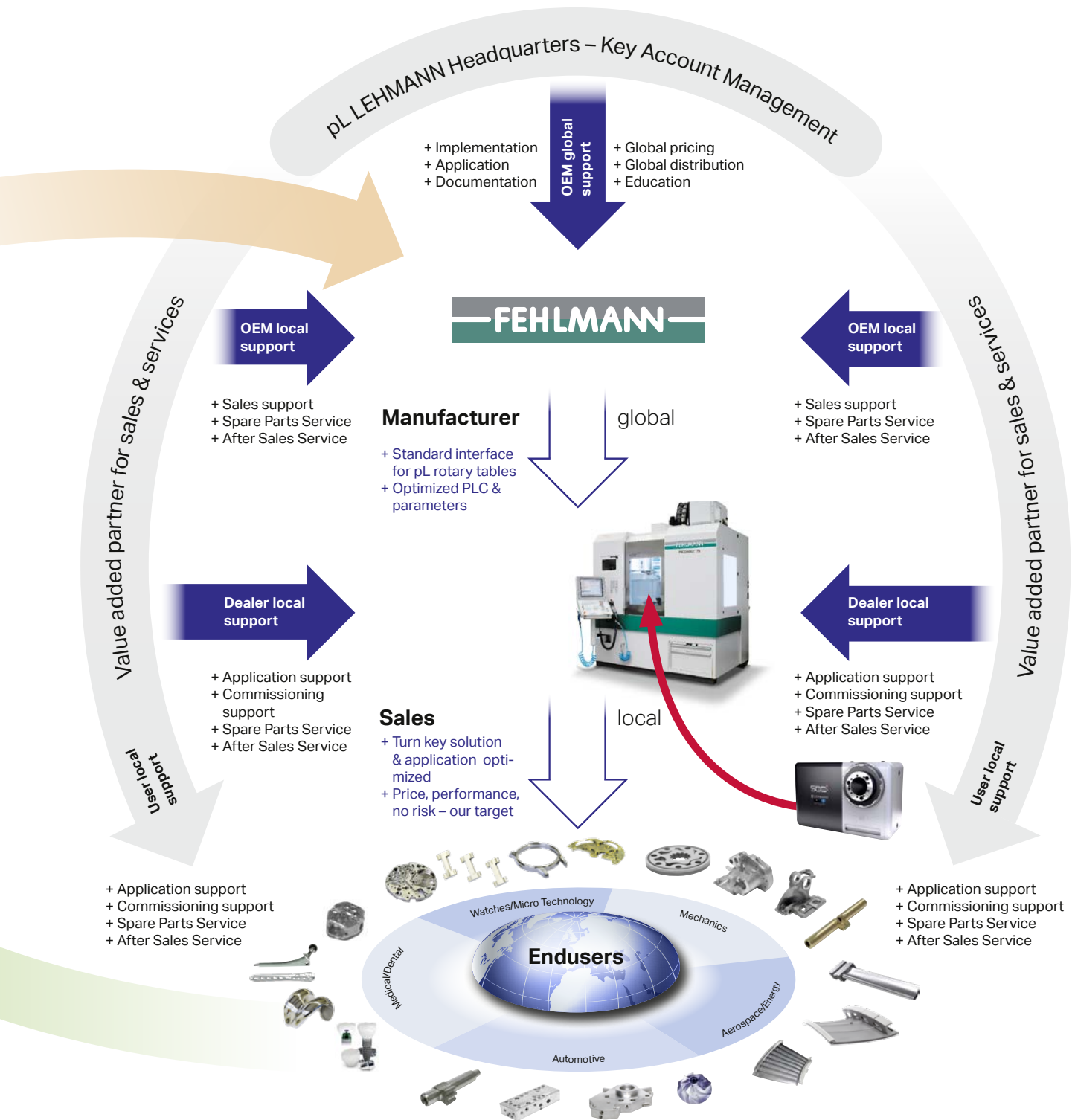
CNC rotary tables for economical manufacturing:
pL LEHMANN has suitable and rational solutions for
nearly every industry



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:
FEHLMANN and pL LEHMANN provide
first-class service to common customers



NEW
up to +30 %

Up to **210 rpm**
up to **0.21 sec / 90°**

Extended travel in
Z- and X-direction

High spindle load,
heavy-duty bearing

High speed

More space

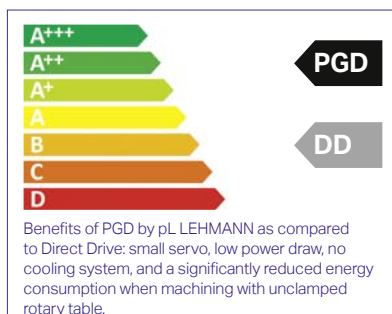
Heavy duty

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

Bluetooth

Connectivity

Wireless monitoring,
for operation & service

No adjust

Load change without
parameter adjustment

Less cost

No cooling system,
no hydraulics



Picomax 56



Picomax 56L



Picomax 75



Picomax 95



Versa 823

A word from FEHLMANN:

«Productivity comes first!

Highest precision, reliability, efficiency and productivity are quality features of the FEHLMANN milling machines, as well as the FEHLMANN manufacturing processes. Our quality management ensures continuous development and optimization of our processes and structures. This ensures that you, the FEHLMANN customer, always enjoys the highest levels of satisfaction and quality. Come see for yourself: premium products, innovative technologies and a business culture based on fairness and team spirit is what Fehlmann AG is all about!»

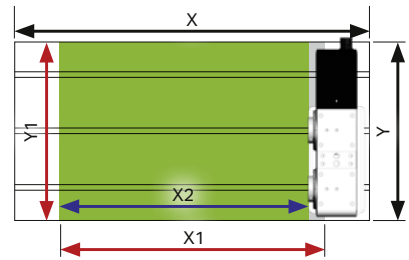
Explanations for pp. 8 to 11

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	X2	
Picomax 56	478	468		
Picomax 56L	874	864		
Picomax 75	654	644		
Picomax 95	974	964	974	
Versa 823	784	774	784	774

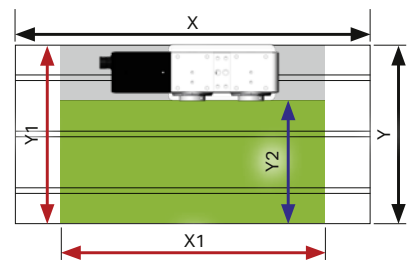
Y-mounting



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

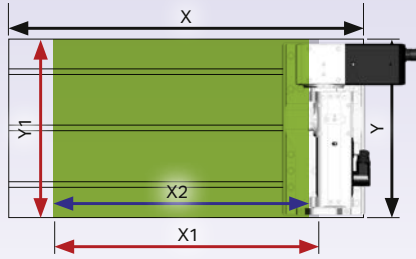
	M2-507	M2-510	Y2	
Picomax 56			214	204
Picomax 56L				
Picomax 75			212	202
Picomax 95				
Versa 823				

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

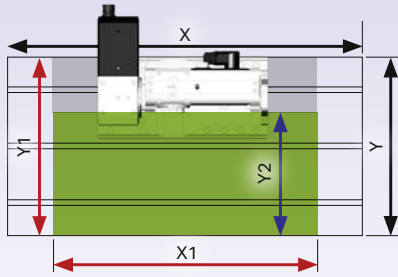


TOP1.2

	TIP1c TF-507510 X2	TIP2c TF-510520 X2	TIP3c TF-520530 X2	TAP1c T1-507510 X2	TAP2c T1-510520 X2	TAP3c T1-520530 X2	TAP1 T1-507510 X2	TAP2 T1-510520 X2	TAP3 T1-520530 X2	TOP1 T1-507510 X2
Picomax 56	574			534						
Picomax 56L	970			930						
Picomax 75	750			710						
Picomax 95	1'070	1'026		1'030	1'010		1'030			
Versa 823	880	836	816	840	820	786	840	820	786	840

	TOP2 T1-510520 X2	TOP3 T1-520530 X2	TAP1c.2 T1-507510 X2	TAP2c.2 T1-510520 X2	TAP3c.2 T1-520530 X2	TAP1.2 T1-507510 X2	TAP2.2 T1-510520 X2	TAP3.2 T1-520530 X2	TOP1.2 T2-507510 X2	TOP2.2 T2-510520 X2	TOP3.2 T2-520530 X2
Picomax 56											
Picomax 56L											
Picomax 75											
Picomax 95											
Versa 823	820		840	820		840			840		

X-mounting



Rotary table installation using hole pattern in base plate



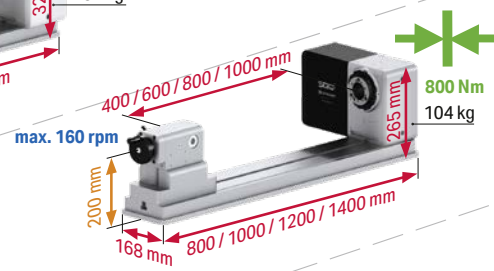
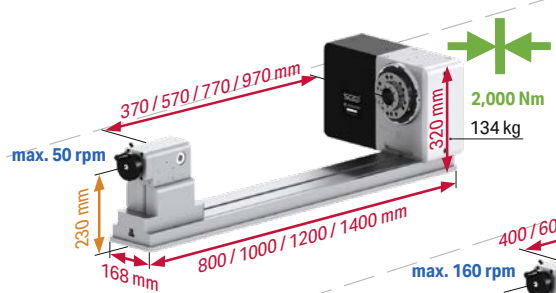
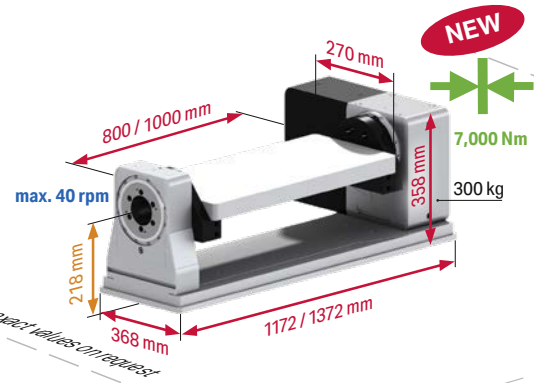
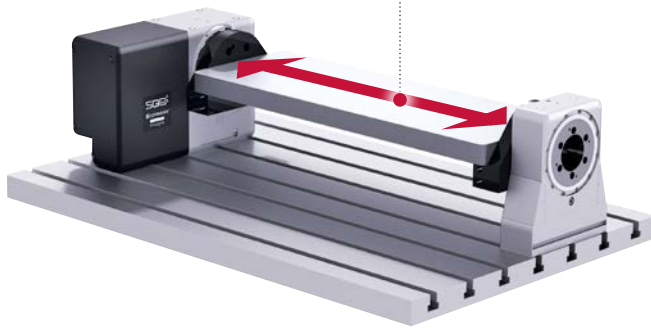
	TIP1c TF-507510 Y2	TIP2c TF-510520 Y2	TIP3c TF-520530 Y2	TAP1c T1-507510 Y2	TAP2c T1-510520 Y2	TAP3c T1-520530 Y2	TAP1 T1-507510 Y2	TAP2 T1-510520 Y2	TAP3 T1-520530 Y2	TOP1 T1-507510 Y2
Picomax 56		266					270			270
Picomax 56L										
Picomax 75			244		248			248		268
Picomax 95										
Versa 823										

	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
Picomax 56			270			270			270		
Picomax 56L	250			250		270	250		270	250	
Picomax 75	248		268	248		268	248		268	248	
Picomax 95				335	301		335	301		335	
Versa 823		501			501		535	501		535	501



Very good accessibility, even with short tools

More space for workpieces and fixtures



530

520


51x

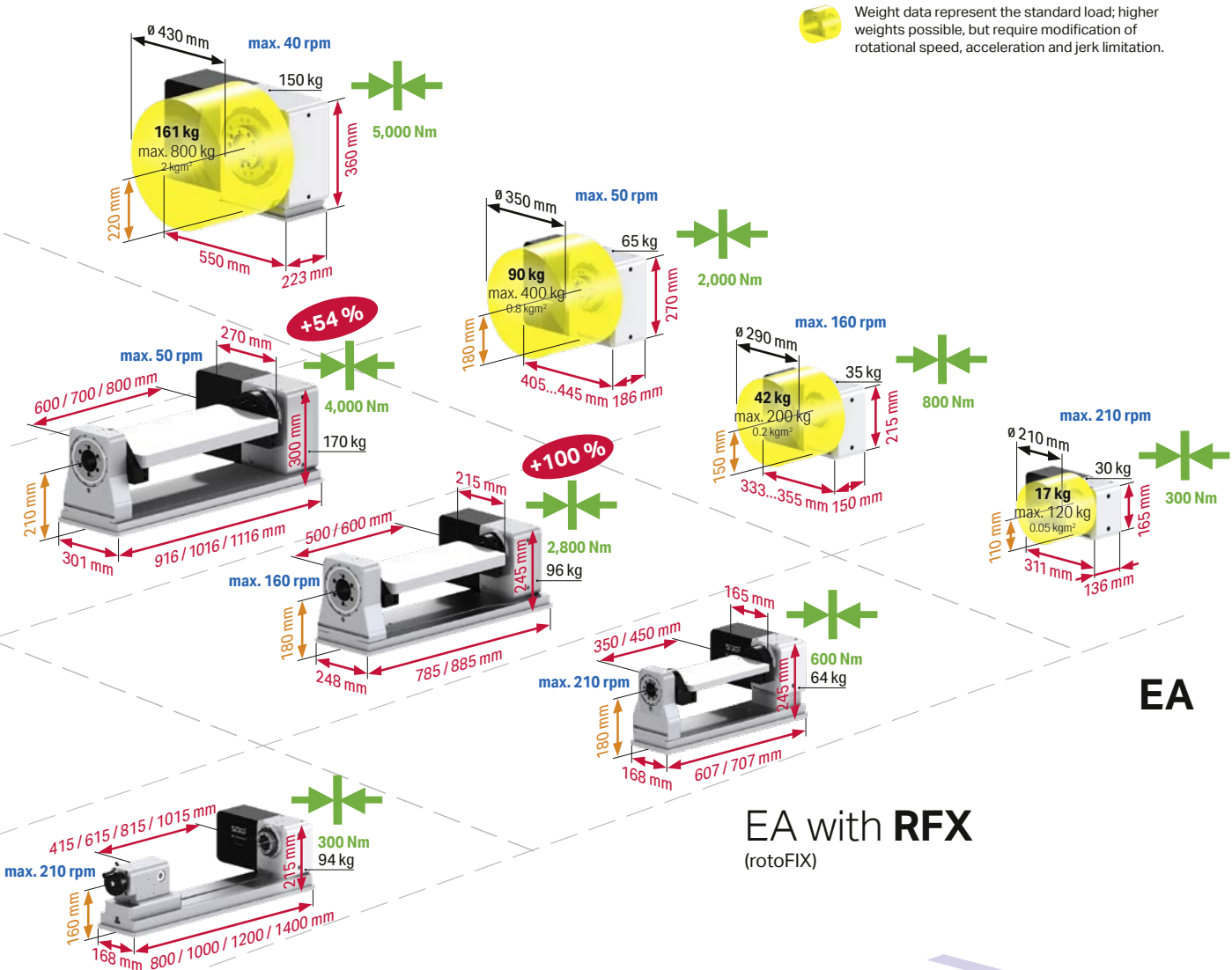
50x

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.



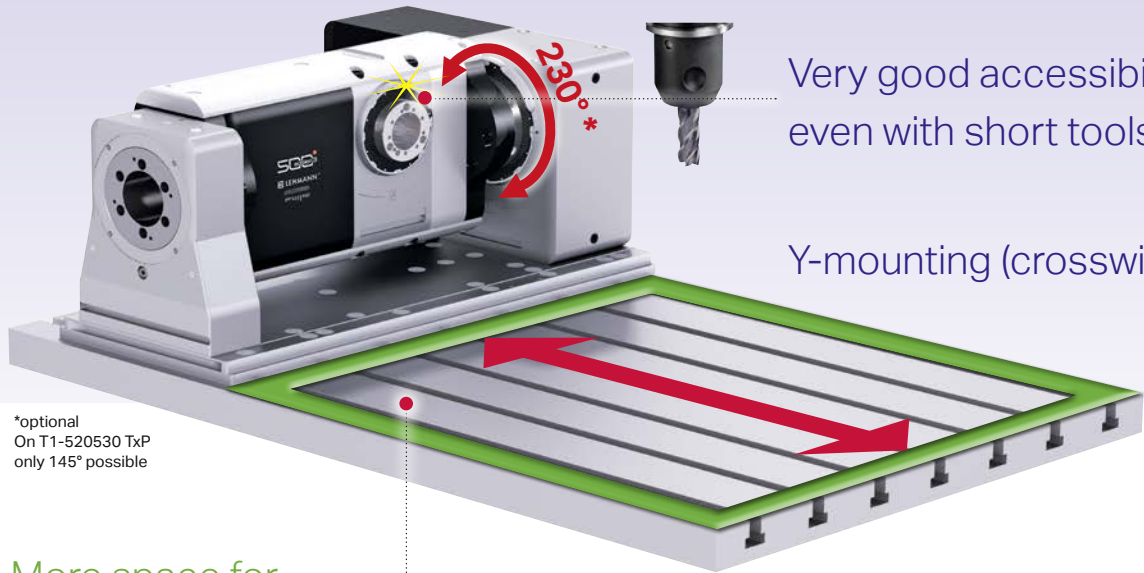
EA

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

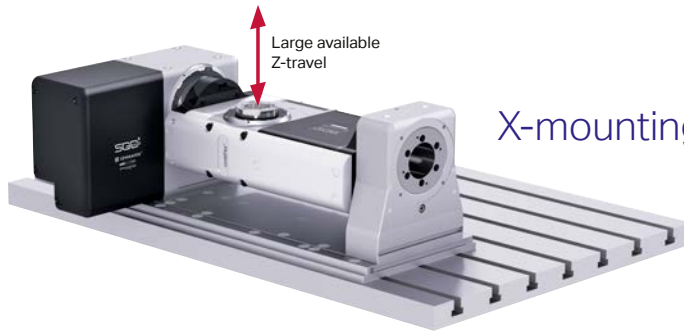


Very good accessibility, even with short tools

Y-mounting (crosswise)

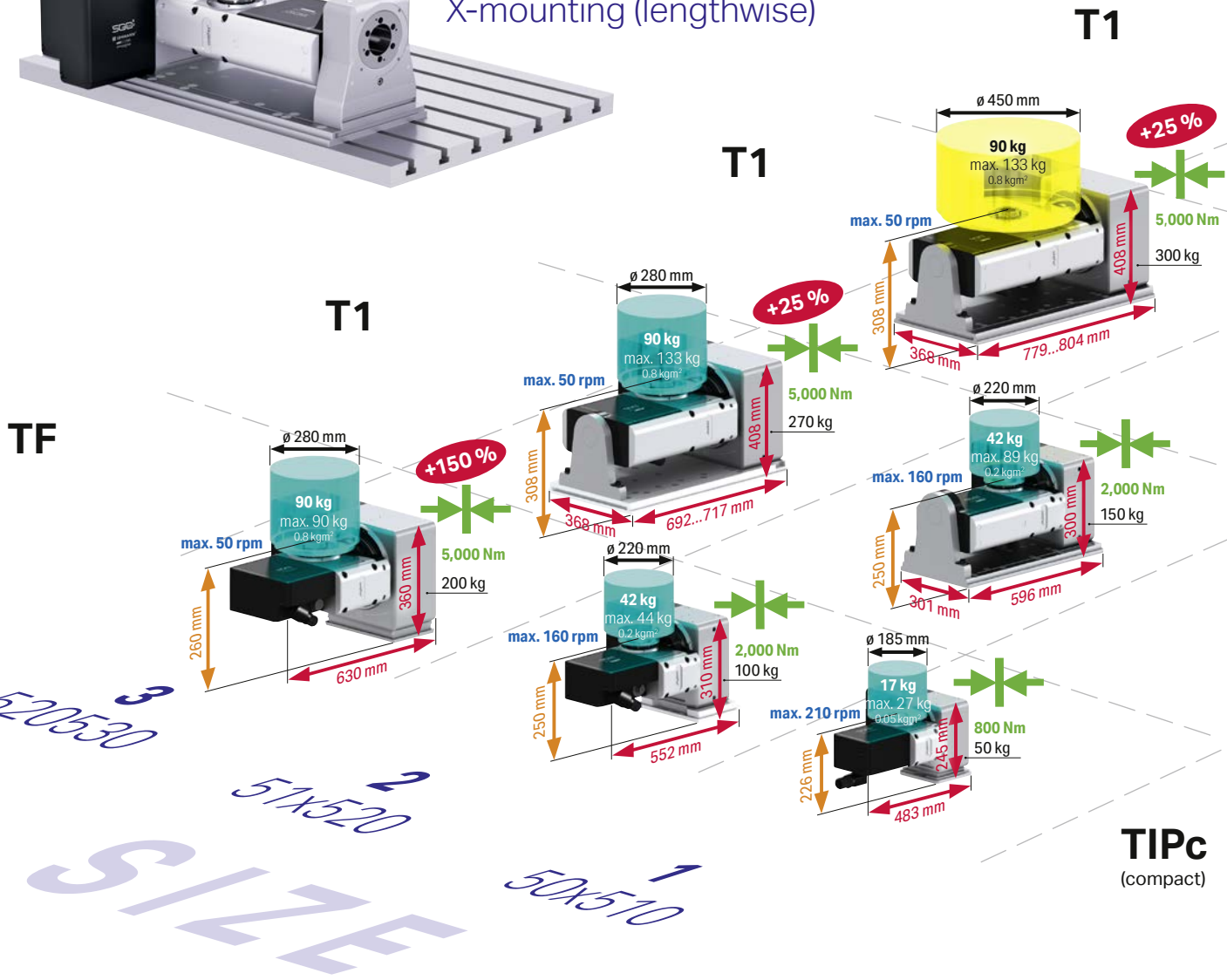
*optional
On T1-520530 TxP
only 145° possible

More space for workpiece and fixtures



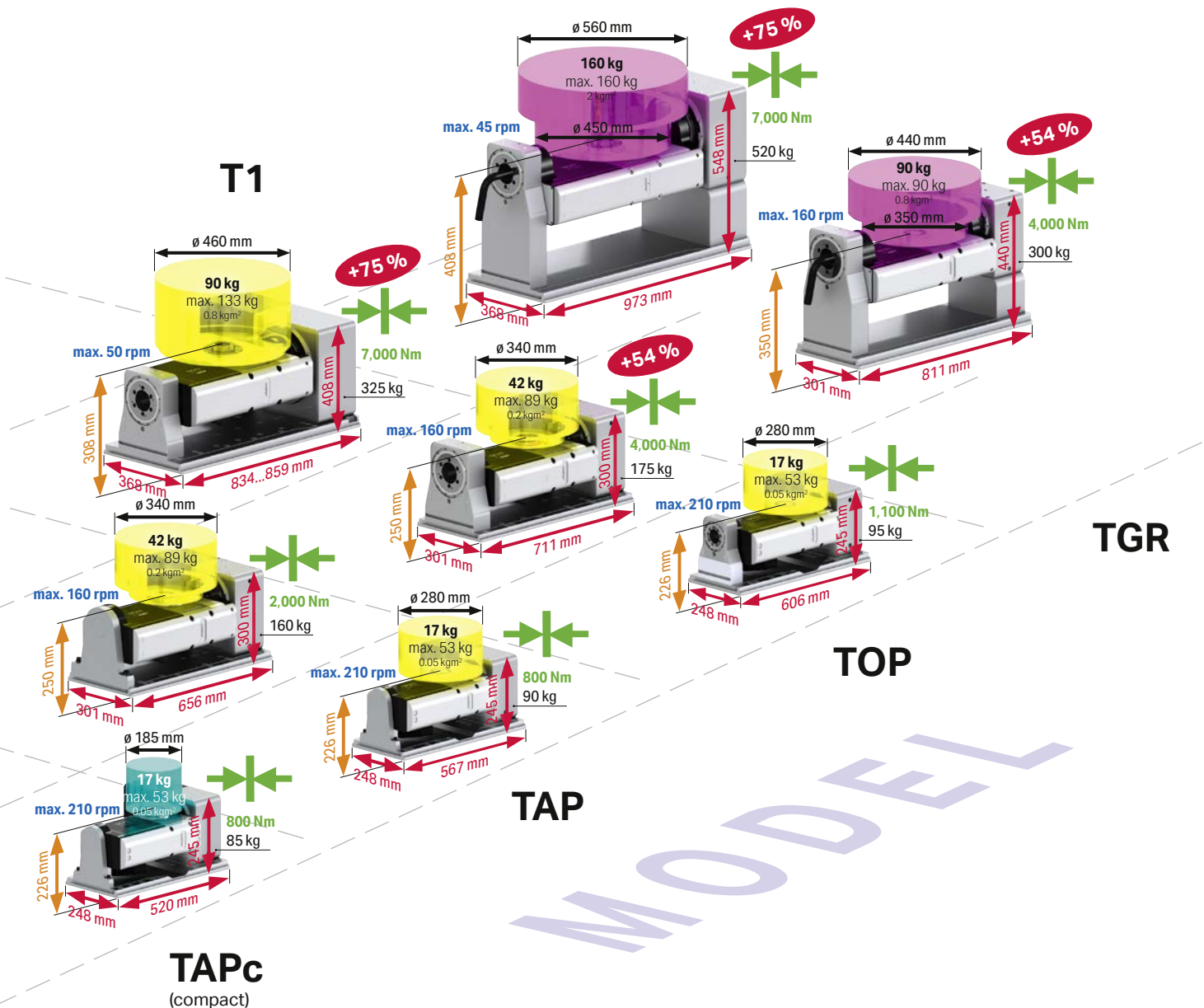
X-mounting (lengthwise)

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

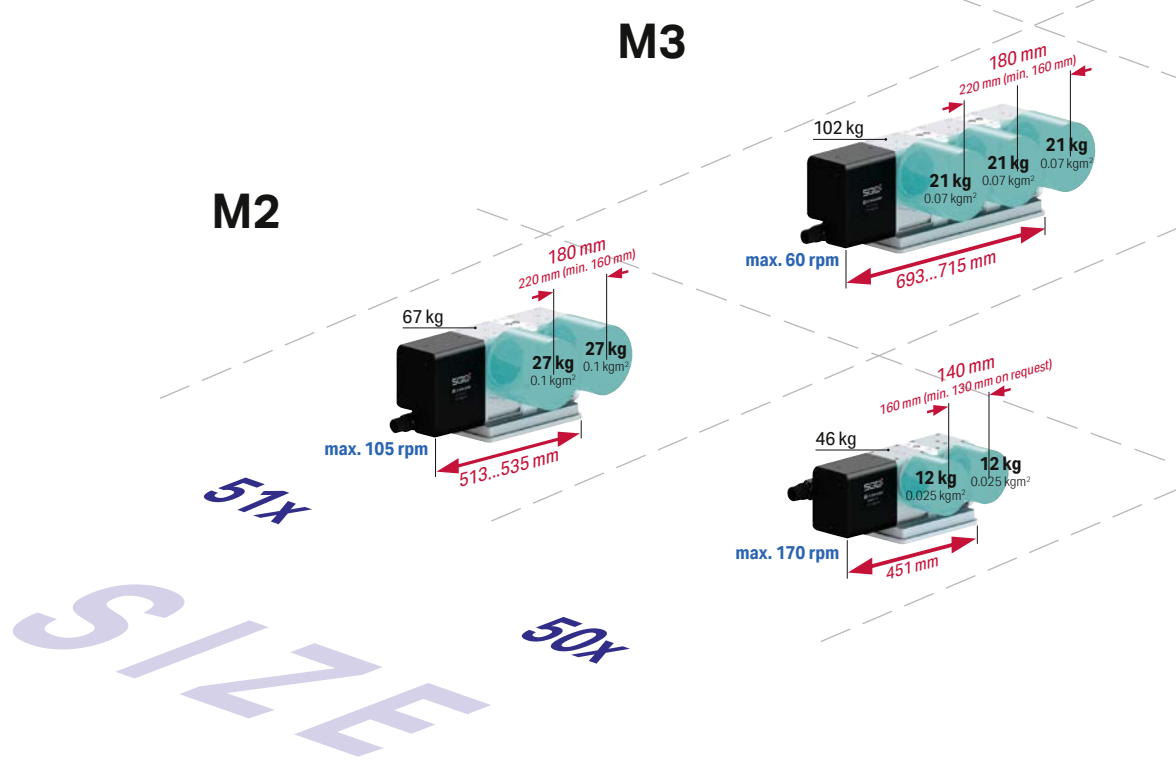


Weight data represent the standard load; higher weights possible, but require modification of rotational speed, acceleration and jerk limitation.

- 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

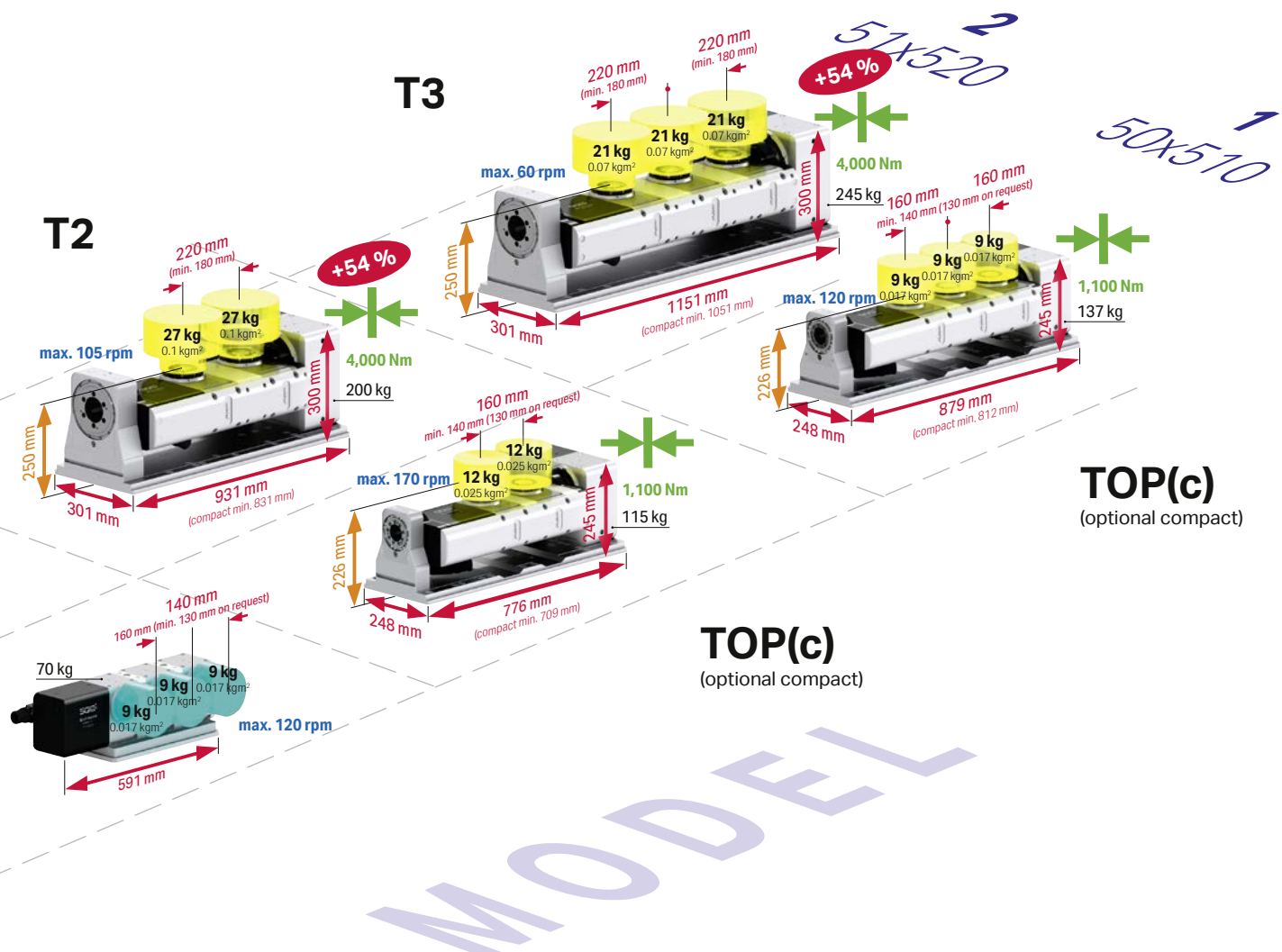



More space for workpiece and fixtures



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)

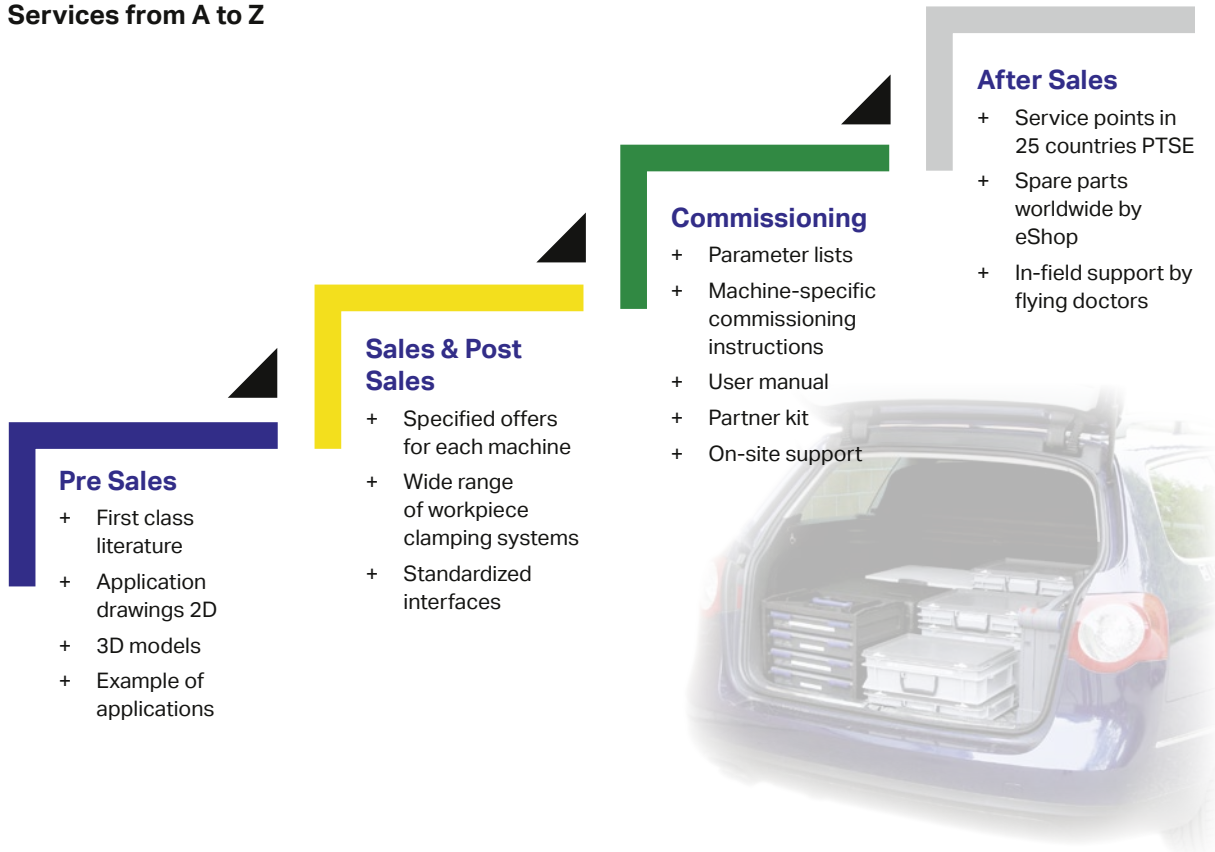


EA-507 with CAPTO retrofit kit

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

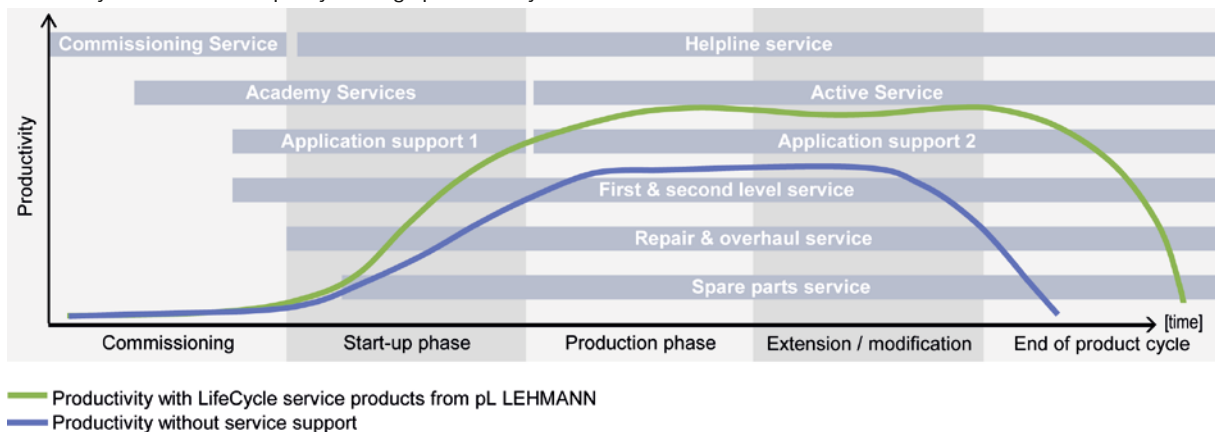


Services from A to Z



Increase productivity – Extend lifecycle

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



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



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

America

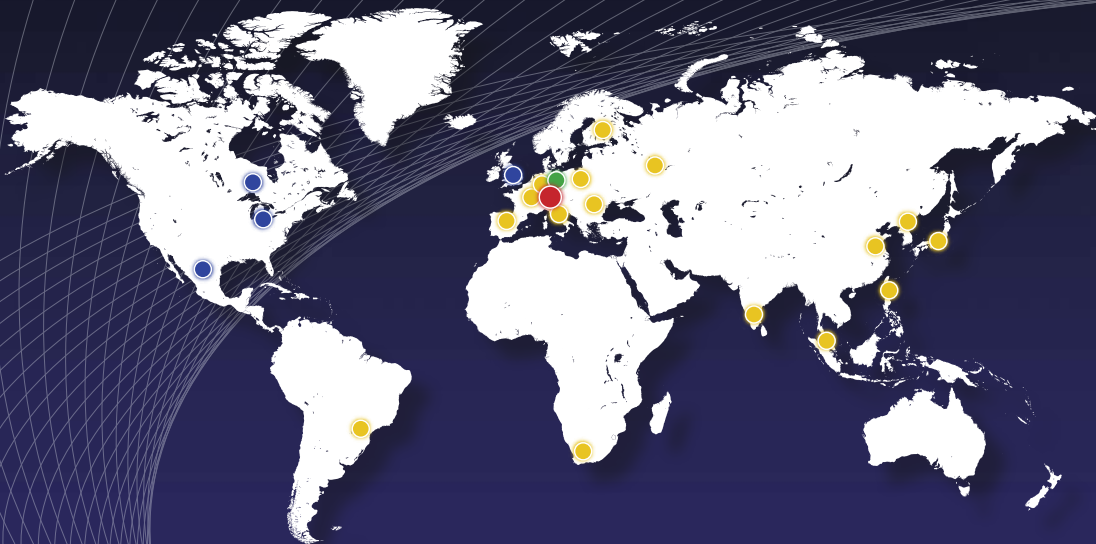
- Brazil
- Canada
- Mexico
- USA

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

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