Selection Guide for CNC Rotary Tables ... ((*))







FEHLMANN

... for Picomax- and Versa-series

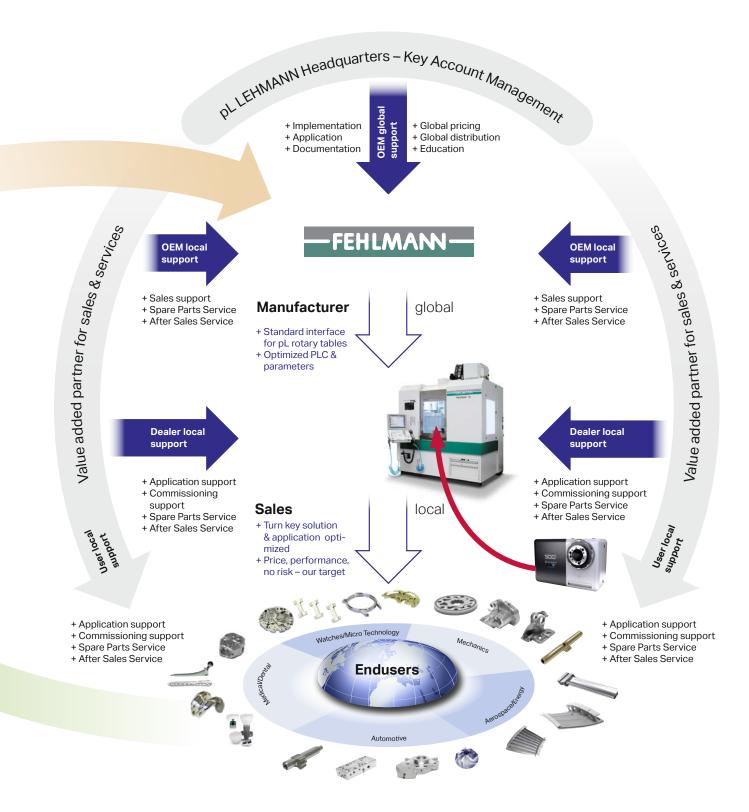
CNC rotary tables for economical manufacturing: pL LEHMANN has suitable and rational solutions for nearly every industry



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





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

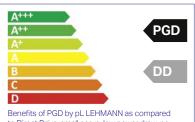








Save energy



berieffish if Poly by BLEENMANN 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.

Rotary tables suitable for simultaneous operation!

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



Feed torque up to 850 Nm (provisional)

Adaptability

Multifunctional spindle HSK

Precision

On the workpiece, as precise as $2 \mu m / 100 mm$





up to 7,000 Nm

High clamp

Large parts up to ø 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 crosswise clamping.

M-Series





(((P))) Bluetooth

Connectivity

Wireless monitoring, for operation & service

No adjust

Load change without parameter adjustment

Less cost

No cooling system, no hydraulics





Picomax 56









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!»

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

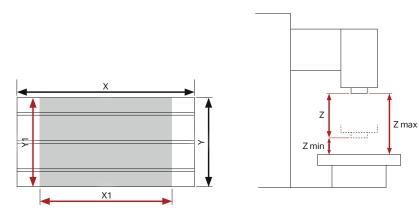


	Table diam	neter [mm]	Permissible		Table load **				
	x	Υ	overhang *	X1	Y1	z	Zmin	Zmax	max [kg]
Picomax 56	908	480	10%	500	400	400	120	520	250
Picomax 56L	1'400	480	10%	800	400	400	120	520	350
Picomax 75	1'160	475	10%	600	400	610	125	735	400
Picomax 95	1'600	550	10%	800	500	610	160	770	600
Versa 823	1'200	750	10%	820	700	450	150	600	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.)

Table explanation for pp. 8-11

	EA-507	EA-510	EA-520	EA-530
	X2	X2	X2	X2
Picomax 56	537	521	495	

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.

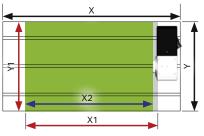


^{10 %} of the machine width Y with Y-clamping or 10 % of the table length X with X-clamping.)
** The recommended rotary tables do not exceed 50 % of the allowed table load.

For further details about the rotary tables, see p. 12 and higher or refer to the main catalog



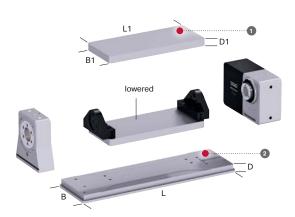
	EA-507	EA-510	EA-520	EA-530
	X2	X2	X2	X2
Picomax 56	537	521	495	
Picomax 56L	933	917	891	
Picomax 75	713	697	671	
Picomax 95	1'033	1'017	991	962
Versa 823			801	772



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-S	530	
	Sph	[mm]	19	190		180		210			218	
Clamping	Length L1	[mm]	350	450	500	600	600	700	800	800	1000	
yokes	Width B1	[mm]	165		2	215		270			0	
	Thickness D1	[mm]	20		35		40			40		
2 Base	Length L	[mm]	622	722	785	885	916	1016	1116	1172	1372	
plates	Width B	[mm]	168		248			301		36	8	
	Thickness D	[mm]	30		30			30			3	
Weights /	Weight (AI)	[kg]	10	12	23	28	40	45	52			
moments of	Weight (steel)	[kg]	29	34	66	80	117	130	152			
inertia (without rotary table, without	Mom. inert. (AI)	[kgm ²]	0.02	0.02	0.06	0.07	0.16	0.17	0.21	on rec	quest	
counter bearing)	Mom. inert. (steel)	[kgm ²]	0.04	0.05	0.17	0.21	0.46	0.50	0.60			

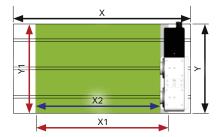
Explanations for pp. 8 to 11

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
		х	2	
Picomax 56	478	468		
Picomax 56L	874	864		
Picomax 75	654	644		
Picomax 95	974	964	974	
Versa 823	784	774	784	774

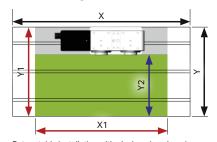
Y-mounting



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

	M2-507	M2-510	M3-507	M3-510
		Y2	2	
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

Machine combinations with T-type rotary tables

Y-mounting

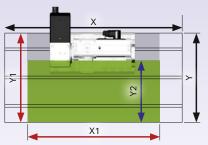


Dotor	, tabla	inotallatio	on moin	a holo	nottorn	in	haaa	plate
RULai	y table	installation	วท นรแ	gnoie	pattern	1111	Dase	plate

	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
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	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
Picomax 56											
Picomax 56L											
Picomax 75											
Picomax 95											
Versa 823	820		840	820		840			840		

X-mounting

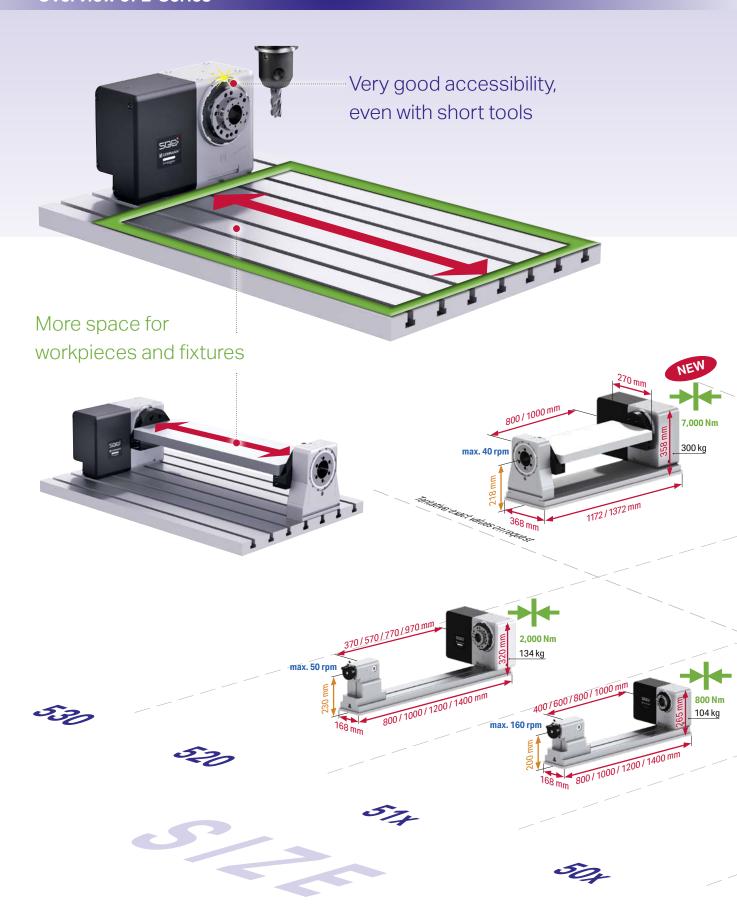






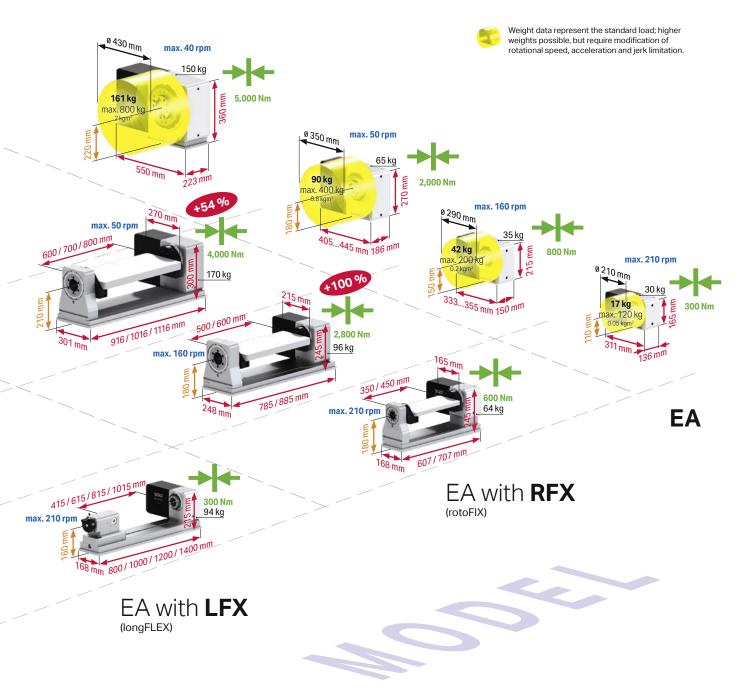
	TIP1c TF-507510	TIP2c TF-510520	TIP3c TF-520530	TAP1c T1-507510	TAP2c T1-510520	TAP3c T1-520530	TAP1 T1-507510	TAP2 T1-510520	TAP3 T1-520530	TOP1 T1-507510
	Y2	Y2	Y2	Y2	Y2	Y2	Y2	Y2	Y2	Y2
Picomax 56		266					270			270
Picomax 56L										
Picomax 75			244		248			248		268
Picomax 95										
Versa 823										

	TOP2	TOP3	TAP1c.2	TAP2c.2	TAP3c.2	TAP1.2	TAP2.2	TAP3.2	TOP1.2	TOP2.2	TOP3.2
	T1-510520 Y2	T1-520530 Y2	T1-507510 Y2	T1-510520 Y2	T1-520530 Y2	T1-507510 Y2	T1-510520 Y2	T1-520530 Y2	T2-507510 Y2	T2-510520 Y2	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



News in brief

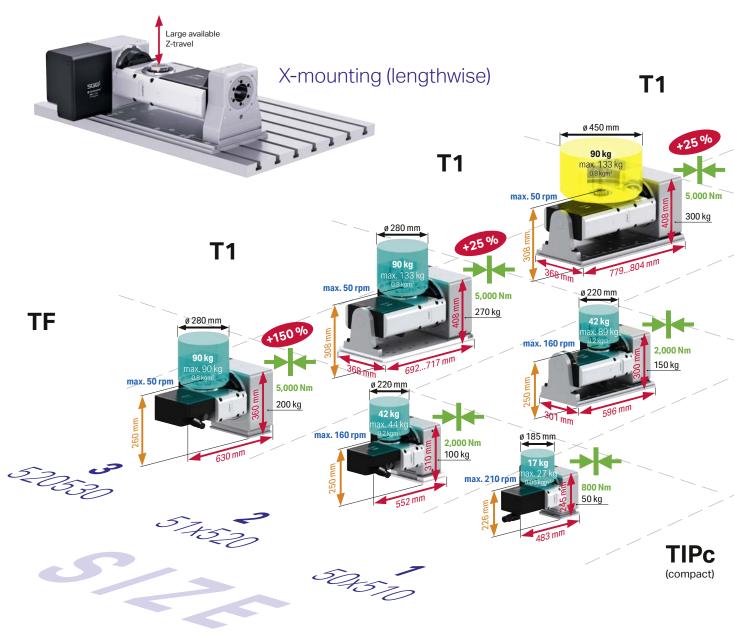
- 1. High speed up to 210 rpm
- 2. Feed torque up to 850 Nm (tentative)
- 3. Steel base plates with hole pattern (suitable for slot spacing of 100 and 125 mm)
- 4. Cycle time 90° as fast as 0.21 sec.



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





News in brief

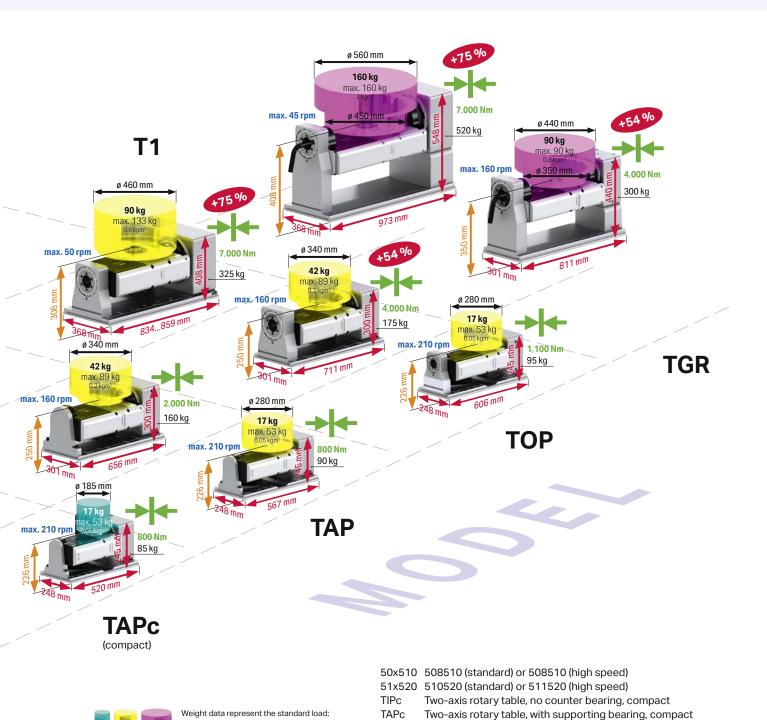
- 1. Up to 150 % higher clamping torque in tilting axis
- 2. Fewer variant more solution
- 3. Larger workpiece ø possible

higher weights possible, but require

modification of rotational speed,

acceleration and jerk limitation.

4. Spatially optimized arrangement of the dividing axis



□ LEHMANN®

TAP

TOP

TGR

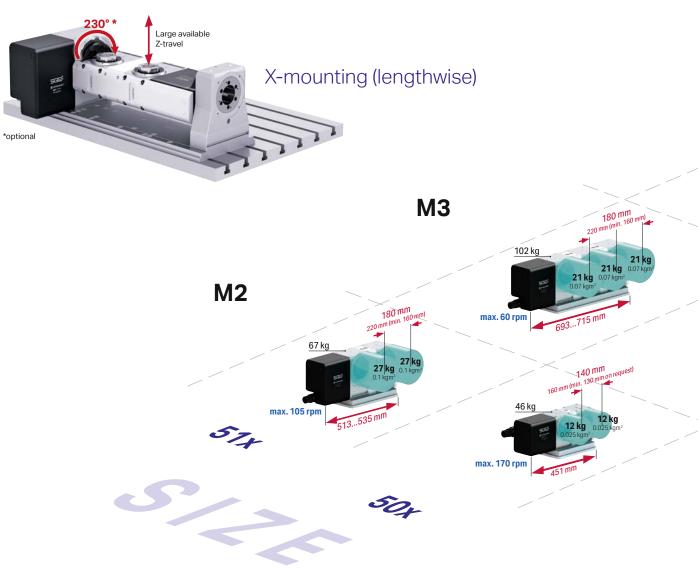
Two-axis rotary table, with supporting bearing

specifically for grinding applications

Two-axis rotary table, with clamped counter bearing

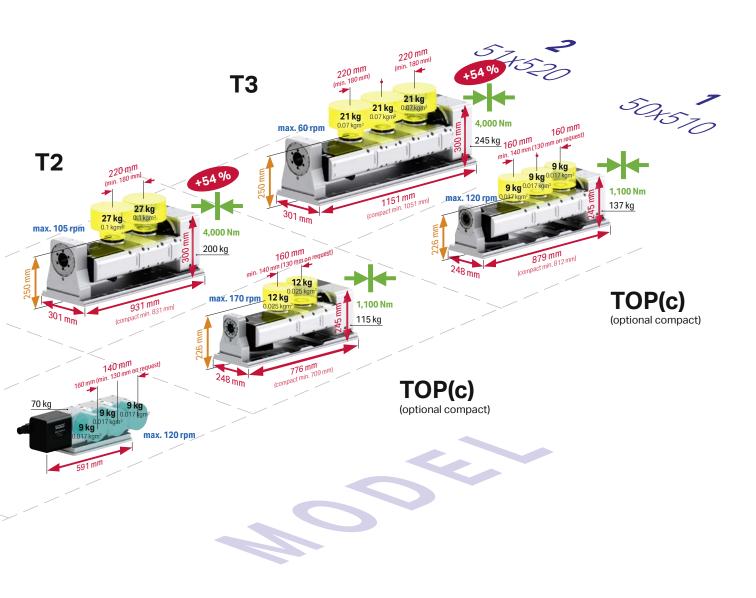
Two-axis rotary table, with clamped counter bearing,

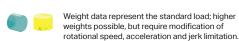




News in brief

- 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





- 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-positionT3 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



CAPTO clamping (on request)



EA-507 with CAPTO retrofit kit



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



After Sales

eShop

Service points in 25 countries PTSE Spare parts worldwide by

In-field support by

flying doctors

Services from A to Z

Sales & Post **Sales**

- Specified offers for each machine
- Wide range of workpiece clamping systems
- Standardized interfaces

Commissioning

- Parameter lists
- Machine-specific commissioning instructions
- User manual
- Partner kit
- On-site support



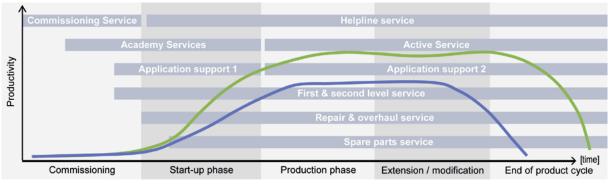
Pre Sales

- First class literature
- Application drawings 2D
- 3D models
- Example of applications



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

America Asia - Brazil - China - Canada - India acant) - Mexico - Japan - USA - Malaysia - Singapore - South Korea - Taiwan - Thailand - Vietnam

Africa

- South Africa

◯ Headquarters
 ◯ direct sales partner
 ◯ pL Solutions® partner
 More information (address, telephone number...) at www.lehmann-rotary-tables.com

o value added reseller & partner