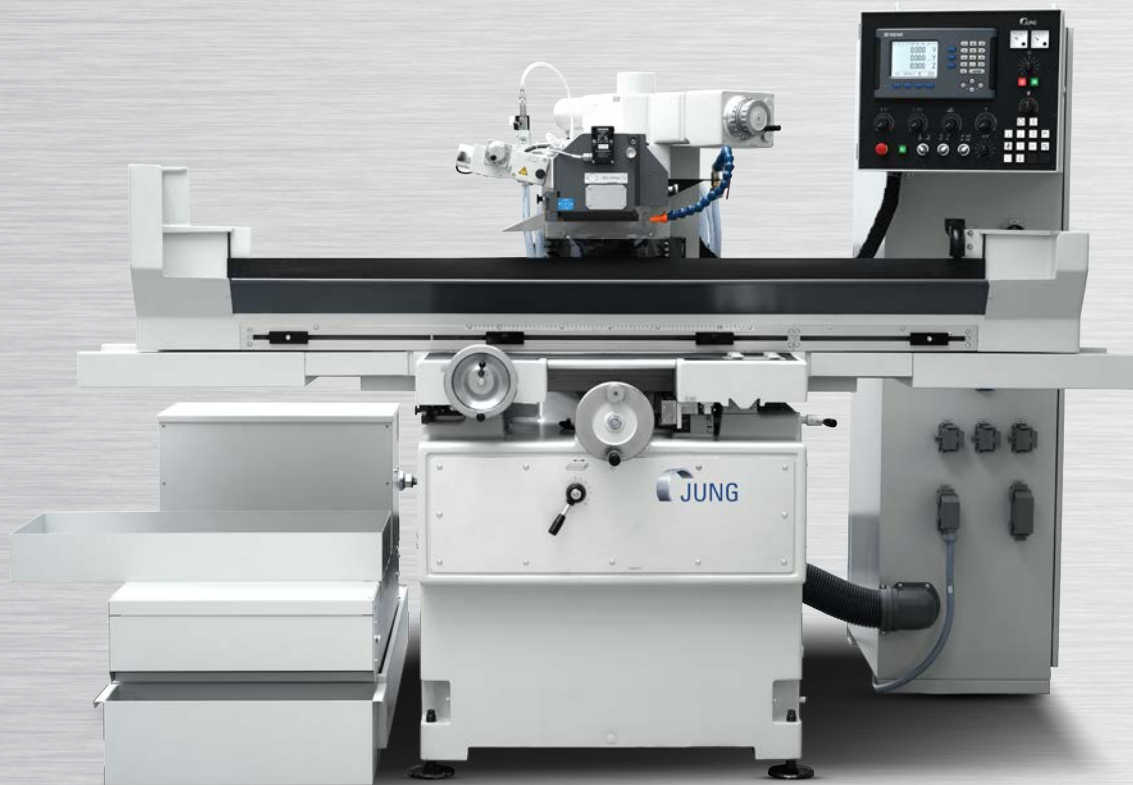


# JUNG REBUILD

Machine overhauls at the highest level



## Key data

Guideway grinding exclusive to JUNG

Double V-guides ground and scraped

Geometrical and electrical overhaul

Repainting

Control system update

Warranty



## Blohm Jung GmbH

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Productivity, performance and precision – three attributes which users worldwide associate with surface and profile grinding machines from BLOHM and JUNG. Our machines have been in use worldwide for decades in widely varying fields of application and under very different conditions.

The experience gained from over 35,000 delivered machines is constantly incorporated into further developments and innovations, increasing our customers' production efficiency even further. The product portfolio of Blohm Jung GmbH extends from surface grinding machines through application-oriented universal machines to customer-oriented production machines. Our Customer Care and technology specialists support our customers throughout the entire lifecycle of the machine. From grinding tests through training and maintenance contracts to retrofits, we offer our customers prompt and personal advice.

In 2008 the two established brands BLOHM and JUNG merged under one roof. Blohm Jung GmbH has thus combined its extensive know-how and constantly enables new, higher standards in the area of precision, quality and cost efficiency. There are also many opportunities for tailoring production solutions to individual customer requirements.

As part of the UNITED GRINDING Group, Blohm Jung GmbH is represented internationally with offices in India, China, Russia and the USA. A further 40 sales and service agencies guarantee a worldwide presence and customer proximity. The company's main locations are the development and production facility in Hamburg and the service and technology center in Göppingen.



# JUNG REBUILD

A machine overhaul at JUNG can be individually tailored to your requirements using our modular system. You can choose between individual assembly overhauls or have a complete rebuild of your machine.



Here you can see a time lapse video of a JUNG REBUILD.

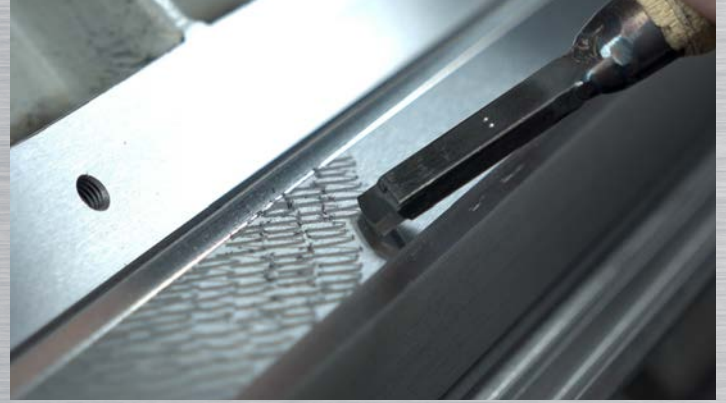
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# Your rebuild options at JUNG

## Guideway overhaul



During a guideway overhaul first of all the double V-guides of cross slide, table and bed (optional) are ground in relative to each other. The result is a perfectly coordinated machine geometry. The procedure is the same as for new machines (type H and J series). During this exclusive machining method a surface hardening takes place and the proven cross hatch finish (other fields of application: medical technology, automotive industry) is ground into the guides. But it is only the combination of guideway grinding



and subsequent scraping of the table that gives the unique precision and longevity of a JUNG grinding machine.

The know-how our employees have amassed over the decades together with constant quality controls and the use of our special machines guarantee the highest quality and precision of your JUNG grinding machine.

Duration: approx. 5-6 weeks

## Grinding spindle overhaul



The condition of your grinding spindle is vital, as it is in direct contact with the workpiece via the grinding wheel and the key factor determining quality or reject. After a grinding spindle overhaul you get an as-new product, which can meet the highest requirements.

Machine types: F, H, J, C, JT series

Duration: generally available as an exchange from stock

## Repainting



It isn't just technology that is crucial today - the look of a machine also plays an increasingly important role. Repainting will significantly enhance your machine and have a positive effect on the presentation of your machinery.

After thorough disassembly of various machine elements, heavily stressed parts are sand-blasted in order to create an ideal basis for our multi-layer paint.

Duration: approx. 3 weeks



## Dresser overhaul

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Another of JUNG's core competencies is the dressing unit, which guarantees reliable contour accuracy. If signs of wear appear, you have the option of an overhaul. The dresser is restored to as-new condition.

After disassembly all spare and wear parts are replaced and the guides are reground if necessary. The dresser is then reassembled and aligned by a service technician.

Types: MA65, AF65/100, HF50, PA30/31/37/120/130

Duration: 2-4 weeks depending on type

## Upgrades/retrofits

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We are very keen to ensure that you are always kept up to date, without having to replace your machine's entire technology. For such cases we offer various upgrades/retrofits, such as e.g.

- Upgrade of the automatic central lubrication system
- Update of individual or a number of scales
- Update of the digital display
- Upgrade of the dressing unit
- Upgrade of technology (e.g. creepfeed, plunge, face grinding, etc.)
- Update of the machine control system

## Loan equipment

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While your unit or machine is with us for an overhaul we can provide you with a loan unit or a JUNG loan machine for this period to avoid serious production losses.

Types: PA3x, JF520

## Warranty

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We offer a warranty of 12 months or 2000 operating hours on overhauls, including the replaced parts.

For rebuilds and machine overhauls with guideway grinding the warranty on the machine geometry is extended to 24 months or 4000 operating hours.

# HF-i series



The time-tested classic  
Familiar handling with new electrics. Glass scales in the Y and Z axis, automatic central lubrication system plus monitoring function as well as an integrated 5.5 kW grinding spindle drive are part of the standard product and qualify the HF-i series as the optimal machine for everyday use or as an auxiliary machine in toolmaking.



Digital measuring systems with display  
Available in Y and Z axes for micron-precise positioning. Equipped with zero switch-off function.



User-friendly control panel  
All settings can be made very easily and are clearly displayed.



Automatic central lubrication system  
For lead screws, column, table and cross slide guides. With oil level and oil pressure monitoring for ultimate reliability of the lubrication function.

# Technical data

## Table

HF50-i

Max. grinding range	mm	600 x 250
Max. table clamping surface	mm	600 x 200
Max. distance table/spindle center	mm	350
Max. load including magnetic chuck	kg	100

## X-axis (table movement)

Feedrate, stepless hydraulic adjustment (reciprocate grinding)	mm/min	1,000 – 24,000
Feed rate, electro-mechanical	mm/min	–
Input resolution	mm	–

## Y-axis (vertical movement)

Feed rate	mm/min	500
Travel	mm	250
Input resolution	mm	0.001
Wheel head infeed per table stroke	mm	0.001 – 0.01
Adjustable return section	mm	–

## Z-axis (transverse movement)

Feed rate	mm/min	1 – 1,000
Travel	mm	225
Adjustable line feed per table double stroke	mm	0.1 – 10
Continuous feed, steplessly adjustable	mm/min	10 – 1,000
Input resolution	mm	0.001

## Main spindle drive

Spindle speed (dependent on grinding wheel diameter)	rpm	100 – 4,200
Taper		1:6
Max. drive capacity	kW	5.5
Cutting speed	m/s	35

## Grinding wheel

Max. diameter x max. width x bore	mm	225 x 20 x 51
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## Connected loads

Voltage supply		400V AC/50Hz
Total connected load	kW	7.5
Fuse	A	25

## Space requirement (without safety distances, including control cabinet/coolant system)

Length x width x height	mm	2,750 x 1,800 x 2,200
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## Weight

Without control cabinet/with control cabinet	kg	–/1,400
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# JF-i series



## The classic universal machine

The JF-i series has everything that is needed to make setting it up and operating a user-friendly experience. The clearly arranged control system with 3-axis position display and conventional operating elements makes the execution of changing grinding tasks child's play, particularly in toolmaking.



**Control panel with digital display**  
All commands are self-explanatory and easily set via function keys, step switches and the digital display.



**Mechanical infeed with fast feed**  
The height infeed is controlled either via handwheel (mechanical) or automatically via stepper motor and fast feed keys.



**Manual head dresser with automatic dressing rate compensation and V-constant**  
Dressing infeed amounts are compensated automatically with the Y-axis and the set grinding spindle speed is kept constant. The dressing movement is executed manually using a hand lever.



# Technical data

Table		JF415-i	JF520-i	JF625-i
Max. grinding range	mm	400 x 200	600 x 250	600 x 300
Max. table clamping surface	mm	400 x 150	600 x 200	600 x 250
Max. distance table/spindle center	mm	400	490	490
Max. load including magnetic chuck	kg	75	100	130

## X-axis (table movement)

Feedrate, stepless hydraulic adjustment (reciprocate grinding)	mm/min	1,000 – 24,000	1,000 – 24,000	1,000 – 24,000
Feed rate, electro-mechanical	mm/min	–	–	–
Input resolution	mm	–	–	–

## Y-axis (vertical movement)

Feed rate	mm/min	600	500	500
Travel	mm	380	380	360
Input resolution	mm	0.001	0.001	0.001
Wheel head infeed per table stroke	mm	0.0005 – 0.05	0.0005 – 0.05	0.0005 – 0.05
Adjustable return section	mm	0.01 – 9.99	0.01 – 9.99	0.01 – 9.99

## Z-axis (transverse movement)

Feed rate	mm/min	1 – 1,000	1 – 1,000	1 – 1,000
Travel	mm	165	225	280
Adjustable line feed per table double stroke	mm	0.1 – 10	0.1 – 10	0.1 – 10
Continuous feed, steplessly adjustable	mm/min	10 – 1,000	10 – 1,000	10 – 1,000
Input resolution	mm	0.001	0.001	0.001

## Main spindle drive

Spindle speed (dependent on grinding wheel diameter)	rpm	100 – 4,200	100 – 4,200	100 – 4,200
Taper		1:6	1:6, 1:10*	1:10; 1:6*
Max. drive capacity	kW	2.5	5.5	9.3
Cutting speed	m/s	35	35	35

\*optional

## Grinding wheel

Max. diameter x max. width x bore	mm	225 x 20 x 51	250 x 25 x 51	300 x 30 x 76.2
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## Connected loads

Voltage supply		400V AC/50Hz	400V AC/50Hz	400V AC/50Hz
Total connected load	kW	6	7.5	13.5
Fuse	A	25	25	35

## Space requirement (without safety distances, including control cabinet/

Length x width x height	mm	2,750 x 1,800 x 2,200	3,000 x 2,050 x 2,440	3,200 x 2,050 x 2,440
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## Weight

Without control cabinet/with control cabinet	kg	1,300/1,550	1,600/1,850	2,250/2,500
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## JF-N series



The modern universal machine  
For the machining of individual parts during surface and profile grinding, the JF-N series is the best suited entry-level machine for the job. The handwheels for "quick grinding" make it easy to operate, while different program cycles can be added, which activate automatically - producing a machine that will soon become a partner you won't want to do without.



Control panel with touch screen  
All commands are intuitively set via function keys, step switches and touch screen.



Electro-mechanical infeed with servo motor and electronic handwheel  
Height infeed is either controlled via handwheel (electronic-mechanical) or automatically via servo motor and fast feed keys. The servo motor also controls the position of the Y-axis.



Automatic head dresser with automatic dressing rate compensation and V-constant dressing  
Dressing infeed amounts are compensated automatically with the Y-axis and the set grinding spindle speed is kept constant. The dressing movement and diamond infeed are programmed via the control panel and executed automatically. (Optional)



# Technical data

Table		JF525N-R	JF630N-R
Max. grinding range	mm	600 x 250	600 x 300
Max. table clamping surface	mm	600 x 200	600 x 250
Max. distance table/spindle center	mm	490	490
Max. load including magnetic chuck	kg	100	130

## X-axis (table movement)

Feed rate, stepless hydraulic adjustment (reciprocate grinding)	mm/min	1,000 – 24,000	1,000 – 24,000
Feed rate, electro-mechanical	mm/min	–	–
Input resolution	mm	–	–

## Y-axis (vertical movement)

Feed rate	mm/min	0.1 – 2,000	0.1 – 2,000
Travel	mm	380	360
Input resolution	mm	0.001	0.001
Wheel head infeed per table stroke	mm	0.0001 – 9.99	0.0001 – 9.99
Adjustable return section	mm	0.0001 – 9,999.9	0.0001 – 9,999.9

## Z-axis (transverse movement)

Feed rate	mm/min	1 – 1,000	1 – 1,000
Travel	mm	225	280
Adjustable line feed per table double stroke	mm	0.1 – 8	0.1 – 8
Continuous feed, steplessly adjustable	mm/min	10 – 1,000	10 – 1,000
Input resolution	mm	0.001	0.001

## Main spindle drive

Spindle speed (dependent on grinding wheel diameter)	rpm	100 – 4,200	100 – 4,200
Taper		1:6, 1:10*	1:10, 1:6*
Max. drive capacity	kW	5.5	9.3
Cutting speed	m/s	35	35

\*optional

## Grinding wheel

Max. diameter x max. width x bore	mm	250 x 25 x 51	300 x 30 x 76.2
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## Connected loads

Voltage supply		400V AC/50Hz	400V AC/50Hz
Total connected load	kW	7.5	13.5
Fuse	A	25	35

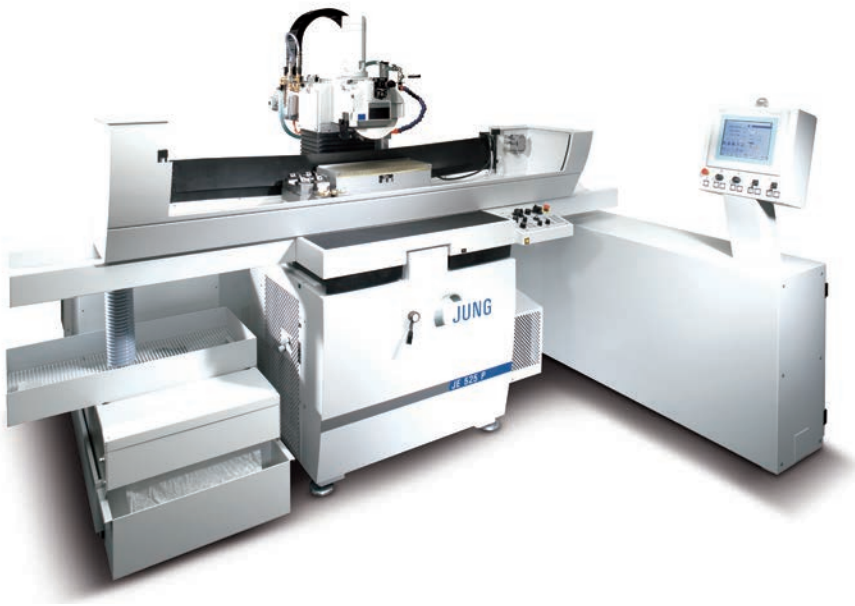
## Space requirement (without safety distances, including control cabinet/

Length x width x height	mm	3,000 x 2,050 x 2,440	3,200 x 2,050 x 2,440
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## Weight

Without control cabinet/with control cabinet	kg	1,600/1,850	2,250/2,500
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## JE-P series



The compact profile grinding machine Surface and profile grinding go hand-in-hand for our customers. Simple, manual set-up of the machine is controlled with electronic handwheels and joystick. The graphic operator guidance supports the processes of grinding and profile dressing.



Control panel with touch screen

All commands are set very simply via function keys, step switches and touch screen. Complex programming tasks ("Profile" basic screen) are supported by the user-friendly graphic menu guidance.



Control panel

Allows positioning of all axes via joystick and electronic handwheels. The speed of the axes can be variably preset.



Table dresser with tilting function

For profiling the grinding wheel, the table dresser tilts up pneumatically and then lowers again below the magnetic chuck. Equipped with 5 tool holders for diamonds (4x 45°; 1x vertical).



# Technical data

Table		JE525P-R	JE630P-R
Max. grinding range	mm	600 x 250	600 x 300
Max. table clamping surface	mm	600 x 200	600 x 250
Max. distance table/spindle center	mm	490	490
Max. load including magnetic chuck	kg	100	130

## X-axis (table movement)

Feedrate, stepless hydraulic adjustment (reciprocate grinding)	mm/min	1,000 – 24,000	1,000 – 24,000
Feed rate, electro-mechanical	mm/min	5 – 5,000	5 – 5,000
Input resolution	mm	0.0001	0.0001

## Y-axis (vertical movement)

Feed rate	mm/min	0.1 – 2,000	0.1 – 2,000
Travel	mm	380	360
Input resolution	mm	0.0001	0.0001
Wheel head infeed per table stroke	mm	0.0001 – 9.99	0.0001 – 9.99
Adjustable return section	mm	0.0001 – 9,999.9	0.0001 – 9,999.9

## Z-axis (transverse movement)

Feed rate	mm/min	0.1 – 2,000	0.1 – 2,000
Travel	mm	225	280
Adjustable line feed per table double stroke	mm	0.1 – 10	0.1 – 10
Continuous feed, steplessly adjustable	mm/min	0.1 – 2,000	0.1 – 2,000
Input resolution	mm	0.0001	0.0001

## Main spindle drive

Spindle speed (dependent on grinding wheel diameter)	rpm	100 – 4,200	100 – 4,200
Taper		1:6, 1:10*	1:10, 1:6*
Max. drive capacity	kW	5.5	9.3
Cutting speed	m/s	35	35

\*optional

## Grinding wheel

Max. diameter x max. width x bore	mm	250 x 25 x 51	300 x 30 x 76.2
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## Connected loads

Voltage supply		400V AC/50Hz	400V AC/50Hz
Total connected load	kW	7.5	13.5
Fuse	A	25	35

## Space requirement (without safety distances, including control cabinet/coolant system)

Length x width x height	mm	3,000 x 2,050 x 2,440	3,200 x 2,050 x 2,440
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## Weight

Without control cabinet/with control cabinet	kg	1,600/1,850	2,250/2,500
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# Transforming OLD into NEW

Your options at a glance

This matrix shows the retrofit options for the different machine models. Find your machine in the left-hand column and you will see the relevant overhaul options marked accordingly.

If your machine is not compatible with the desired retrofit, you have the option of an exchange or new purchase, i.e. we will take your machine in payment (exchange) and supply a machine specified to your requirements.

	HF50-i	JF415-i	JF520-i	JF625-i	JF525N-R	JF630N-R	JE525P-R	JE630P-R
<b>H5</b>								
HF50N,NS,NSE								
HF50R,RS,RSE								
HF50RD,RD/S,RD/SE								
HF50A, HF50P								
<b>J4</b>								
JM400								
JF415D,DS,E,P,R,RD								
JF4, JF400-I,-II								
JF415-1,E1,E2								
JF420								
JF415-B								
<b>J5</b>								
JF520D,DS,E,P,R,RD								
JF500								
JF520-1,E1,E2								
JF525								
JF520M,MS								
JA500CNC-A,-B,-C,-E								
JF520CNC-B								
JC500CNC-B,-C,-E								
J525-C,-E,-F								
JF520CNC								
JE525								
<b>J6</b>								
JF625D,DS,E,P,R,RD								
JF600								
JF625-1,E1,E2								
JF630								
JF625M,MS								
JA600-A,-B,-E								
JF625-B								
J630-C, J630F								



# Customer Care

BLOHM and JUNG surface and profile grinding machines should fulfill the customer's requirements for as long as possible, work cost-effectively, function reliably and be available at all times. From "start up" through to "retrofit" – our Customer Care is there for you throughout the working life of your machine. 6 professional helplines and more than 25 service technicians are available in your area, wherever you are in the world.

- We will provide you with fast, uncomplicated support.
- We will help to increase your productivity.
- We work professionally, reliably and transparently.



Service technicians in your area



Start up  
Commissioning  
Warranty extension



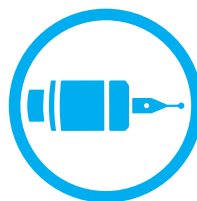
Qualification  
Training  
Production support



Prevention  
Maintenance  
Inspection



Service  
Customer service  
Customer consultation  
HelpLine  
Remote service



Material  
Spare parts  
Replacement parts  
Accessories



Rebuilt  
Machine overhaul  
Assembly overhaul



Retrofit  
Modifications  
Retrofits  
Machine trade-in



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