

# JH

Jhu Heng Enterprise Co., LTD



***JH-125A/150A/150L***  
*Performance & Operation Instructions*

## I. JH-125A Performance Spec :

- Swing Over Cross Slide : 200~280 (mm)
- Motor Spec : 0.5HP(0.37kw)
- Spindle Speed : Outside Grinding -4300 rpm  
Inner Grinding -18000 rpm
- Weight : 21kg

## JH-150A

- Swing Over Cross Slide : 200~280 (mm)
- Motor Spec : 1HP(0.75kw)
- Spindle Speed : Outside Grinding -4300 rpm  
Inner Grinding -18000 rpm
- Weight : 28kg

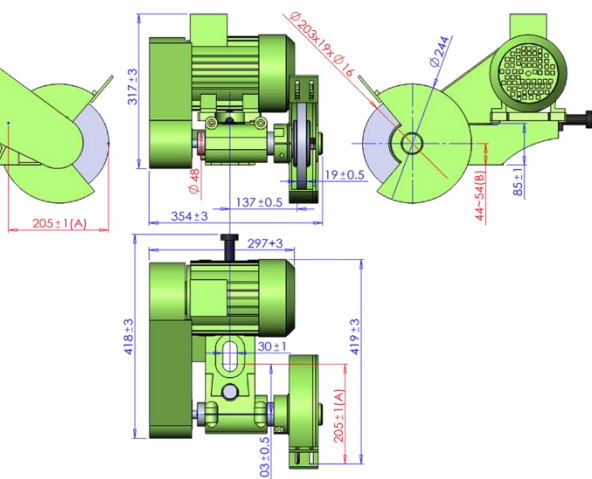
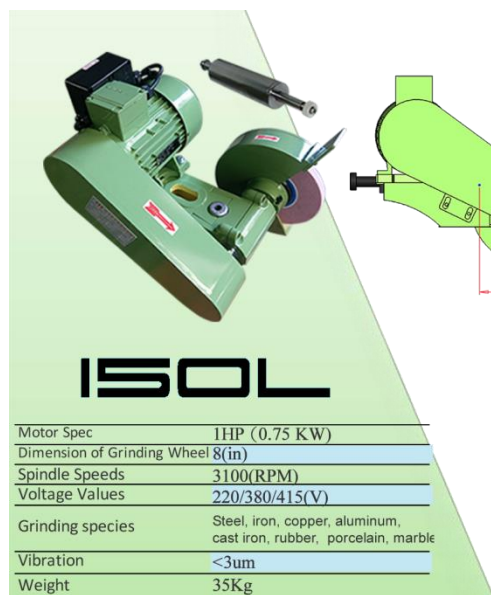
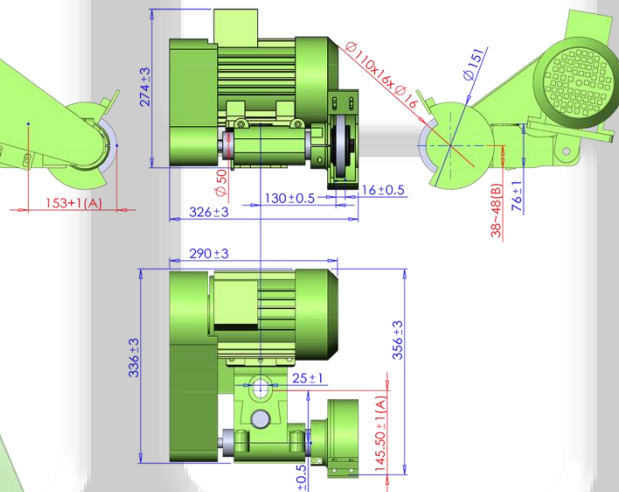
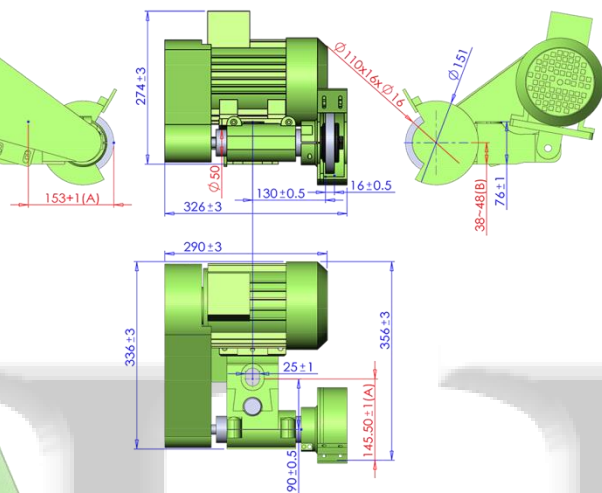
## JH-150L

- Swing Over Cross Slide : 280~340 (mm)
- Motor Spec : 1HP(0.75kw)
- Spindle Speed : Outside Grinding -3100 rpm  
Inner Grinding -18000 rpm
- Weight : 35kg

## Common Specifications :

- Voltage Values : 220V / 380V / 415V / 440V / 480V
- Vibration :  $<3 \mu m$
- Working temperature : 5~40°C / Relative humidity (< 80%)
- Power Spec : Three-phase/ three -wire system
- Grinding species : steel, iron, copper, aluminum, cast iron, rubber, porcelain, marble...and other work pieces

### Performance & Operation Instructions



## II. JH-125A/150A/150L Installation &amp; Operation :

## —、Installation Notes

1. Remove the tool rest of lathe, and cleanse the transverse feed thoroughly.

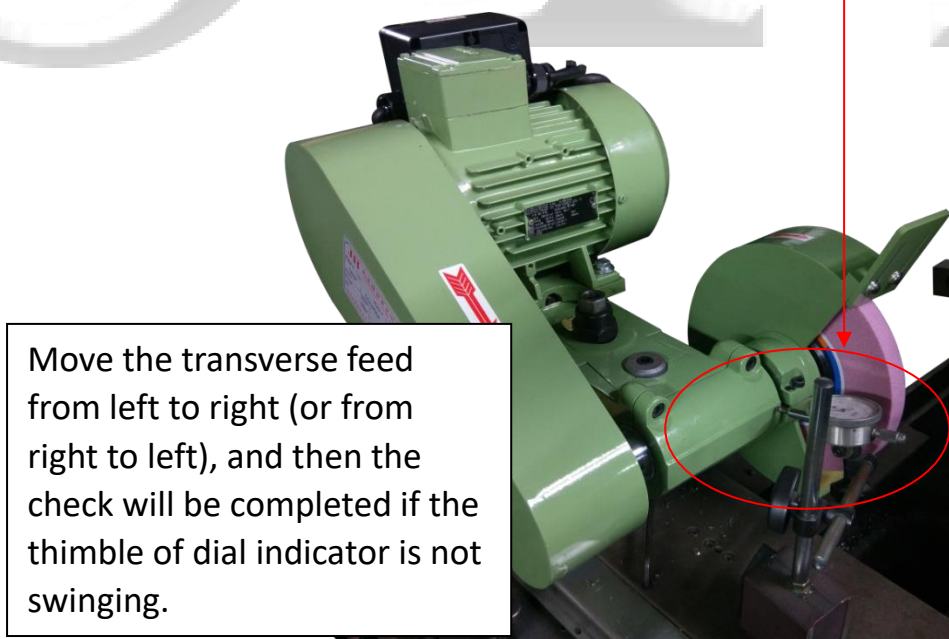
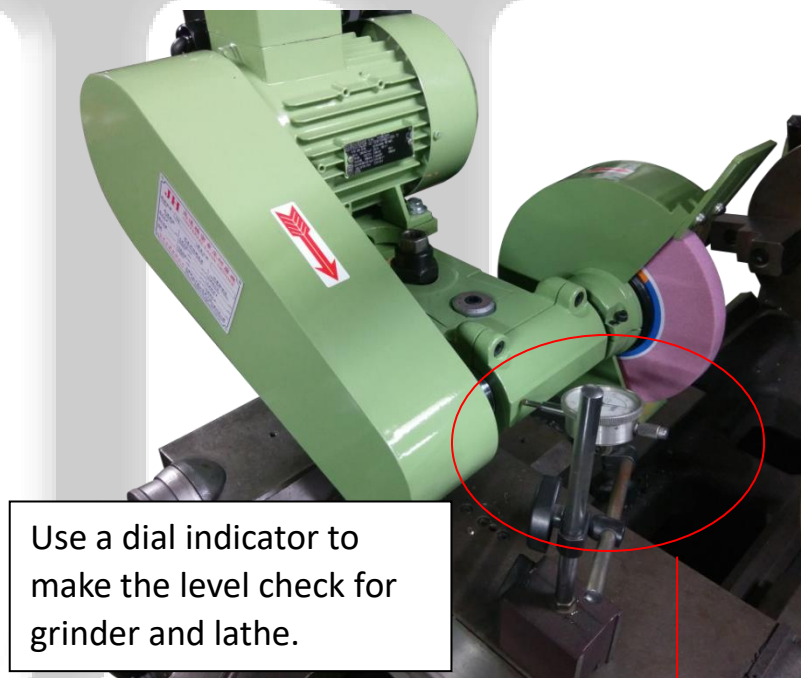


2. Install the grinder on the tool rest, and use a hex screw to fix it.



## Performance &amp; Operation Instructions

- Using a dial indicator to check the level of grinding machine and lathe. The thimble of dial indicator is contacted to the front plane of spindle base on grinder, then move the transverse feed from left to right (or from right to left), and the check is completed if the thimble of dial indicator is not swinging

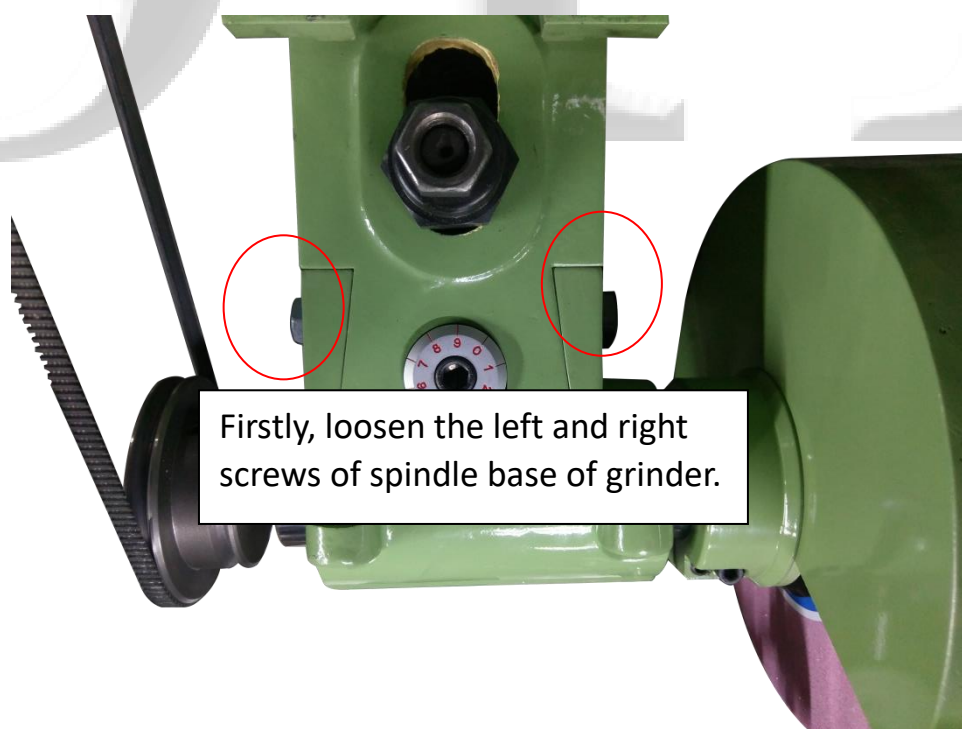


## Performance &amp; Operation Instructions

4. Use the tailstock thimble to check the vertical height of grinder and lathe. The tailstock thimble is aimed at the center point of belt roller on grinder.



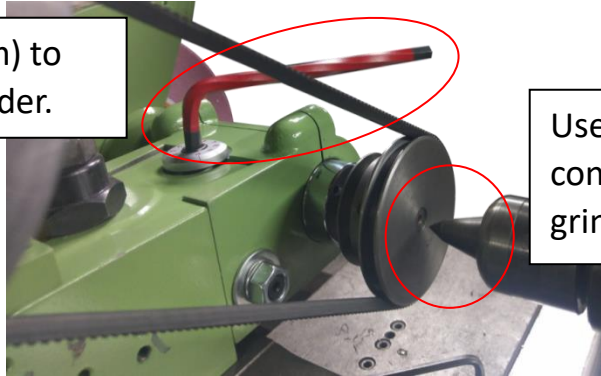
Remove the screws securing the belt guard and the belt guard itself.



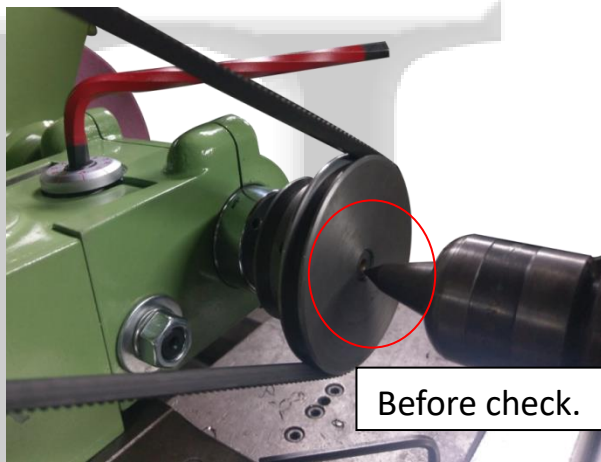
Firstly, loosen the left and right screws of spindle base of grinder.

### Performance & Operation Instructions

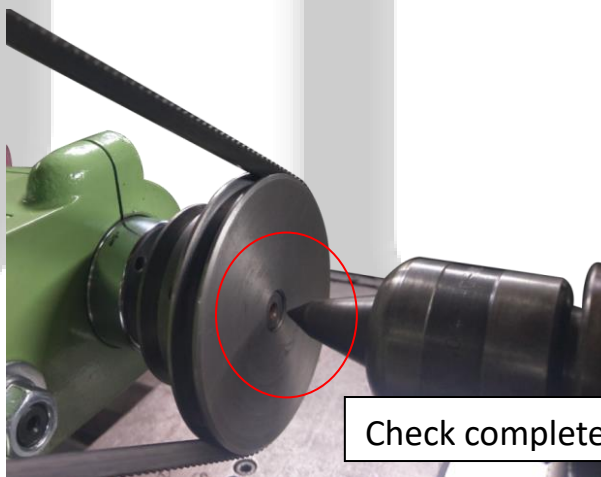
Use a hexagon key (8mm) to adjust the height of grinder.



Use a tailstock thimble to conduct vertical check of grinder and lathe.



Before check.



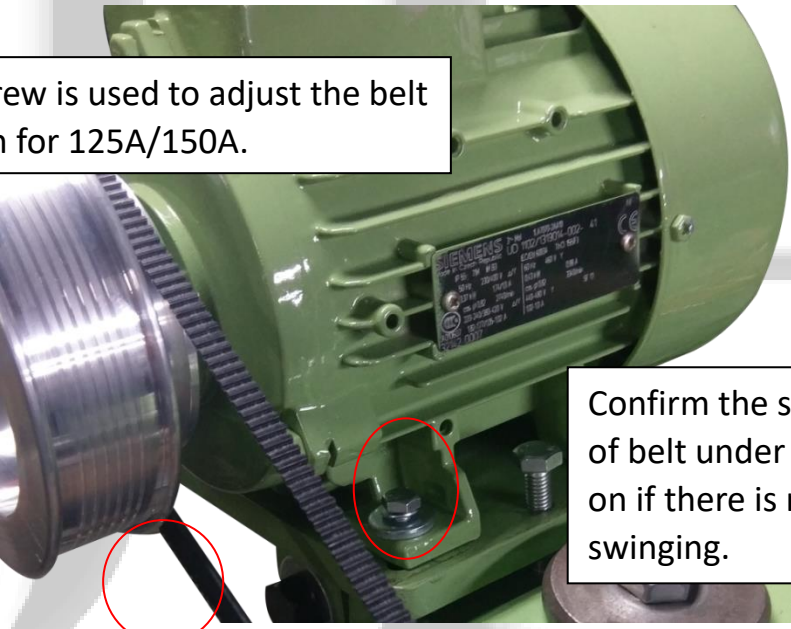
Check completed.



Check completed.

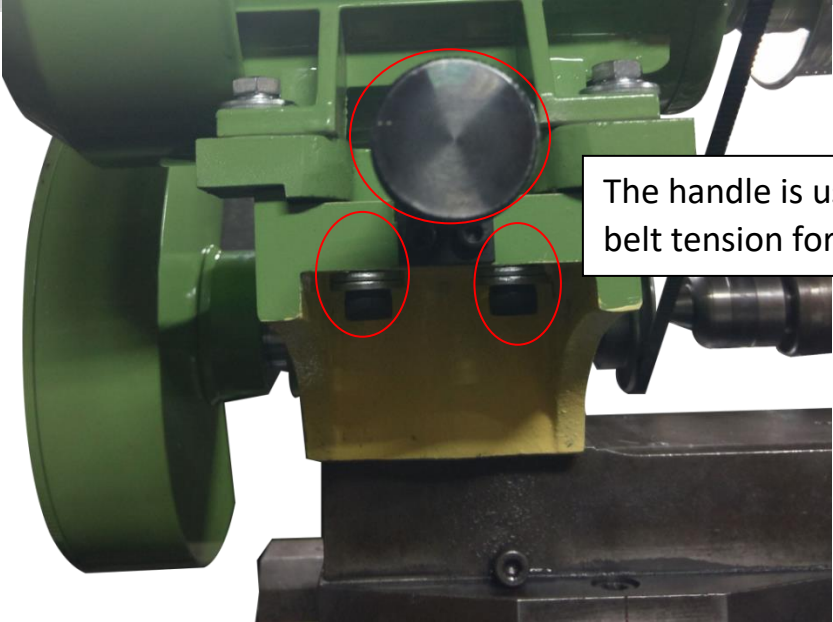
5. Adjust the belt tension. It will affect the belt tension when adjusting the height of grinder, so after the adjustment of grinder's height, it needs to confirm the belt tension again. Under the running condition, if the belt doesn't swing significantly, the belt tension is OK.

### 5.1 JH-125A / JH-150A Belt adjustment procedure.



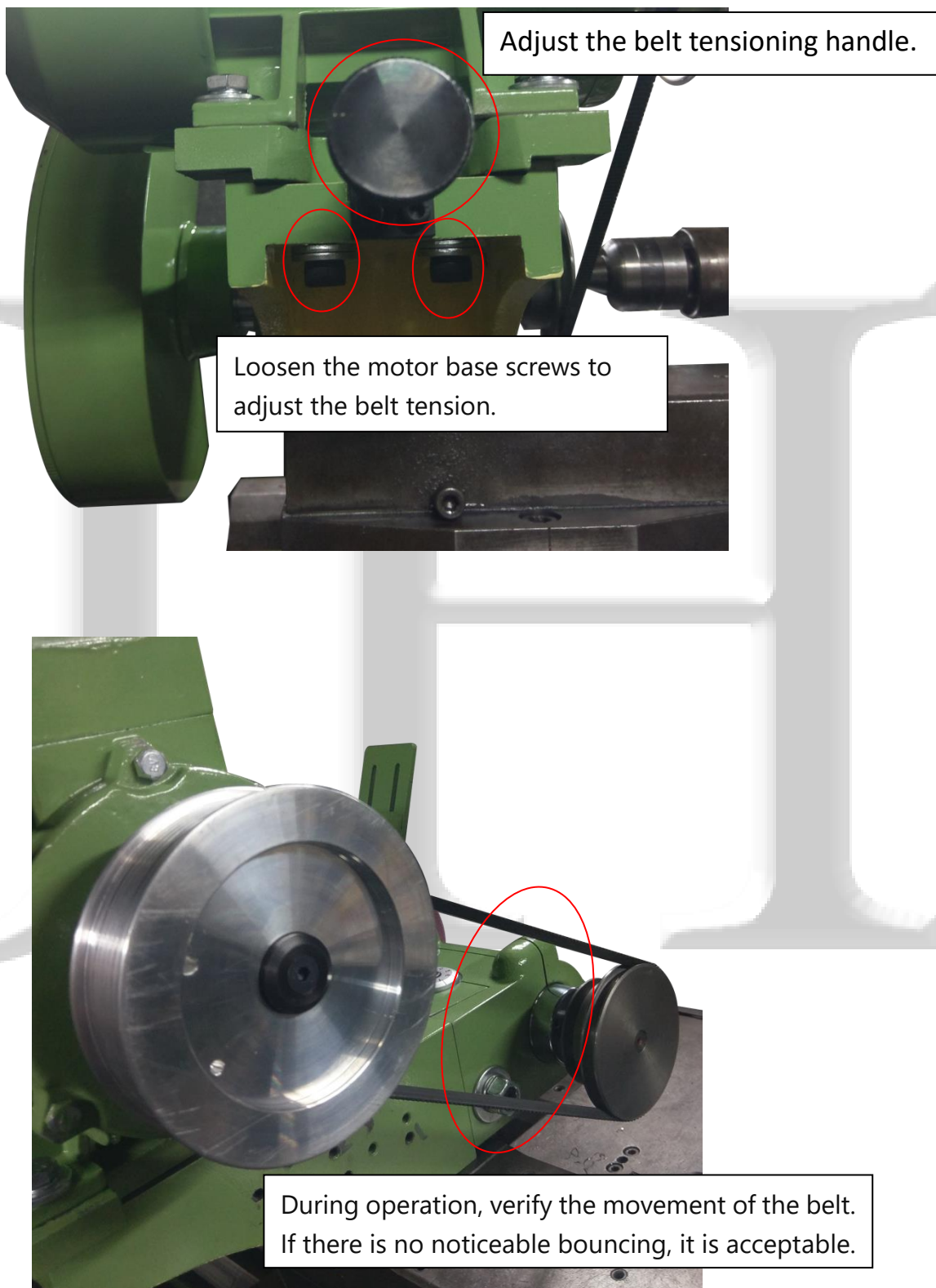
The screw is used to adjust the belt tension for 125A/150A.

Confirm the swinging condition of belt under running. It will be on if there is no significantly swinging.



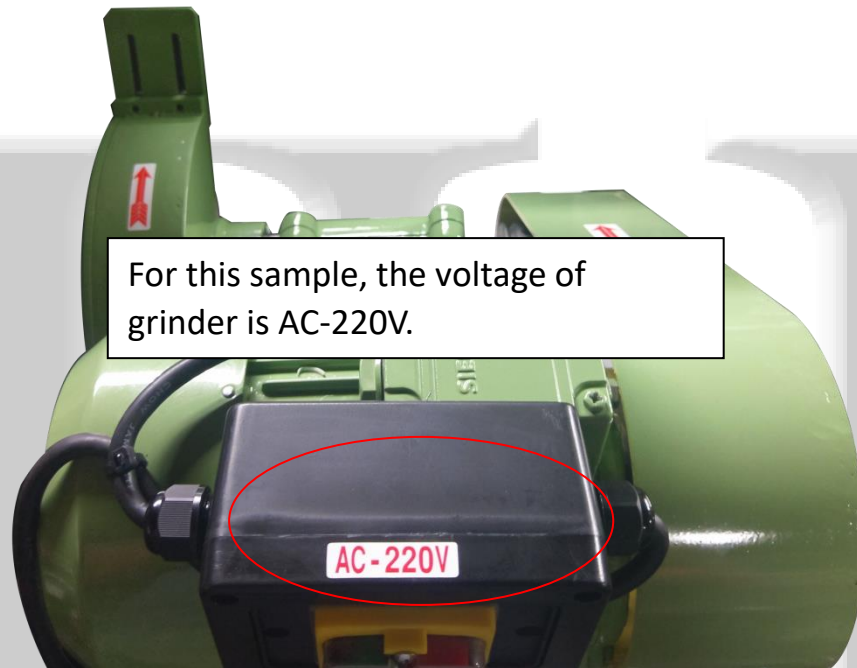
The handle is used to adjust the belt tension for 150L.

## 5.2 JH-150L Belt adjustment procedure.

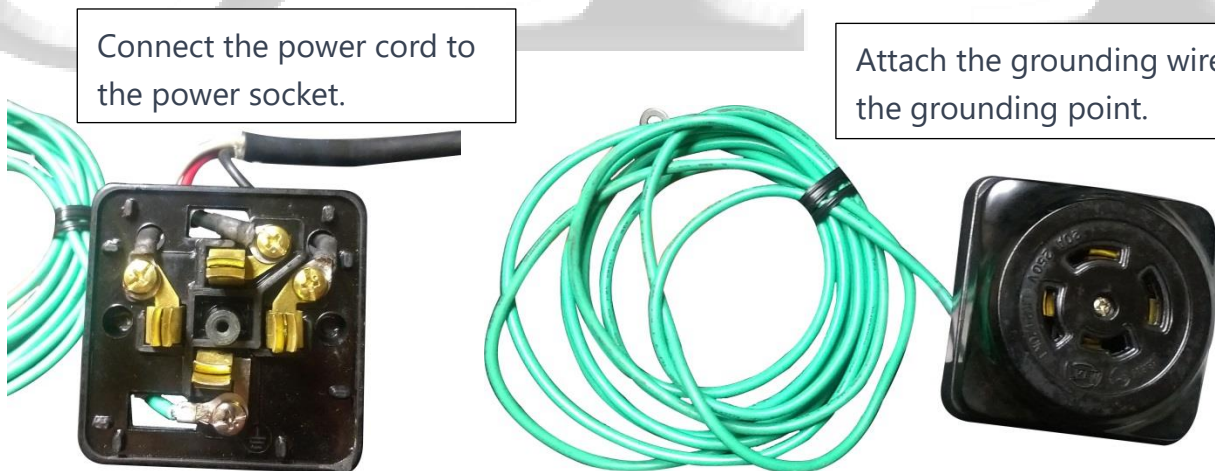


## 二、 Operation Notes

1. Confirm whether the voltage is consistent with the indicated voltage of grinder or not.



2. Connect the power cord to the provided power socket, and attach the grounding wire to the designated grounding point.



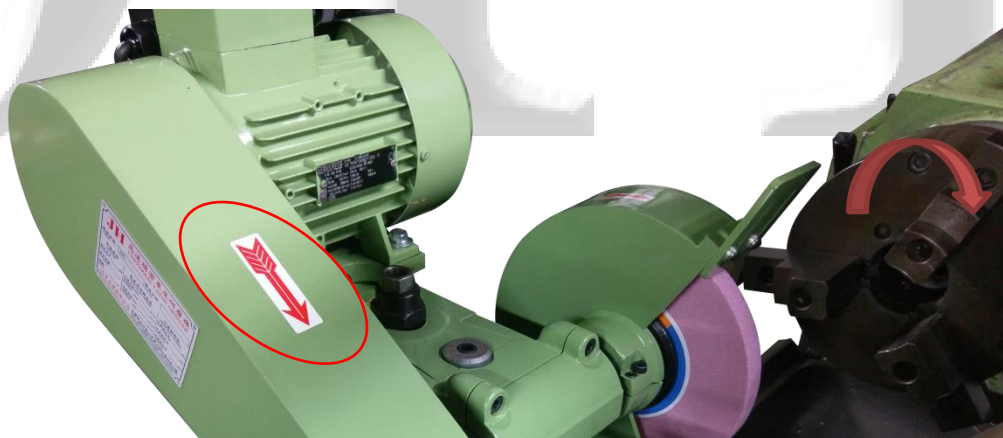
## Performance &amp; Operation Instructions

3. Conduct a test run to confirm whether the running direction of grinding wheel is consistent with the indicated direction of grinder. (If not, please change any two contacts in R.S.T.)

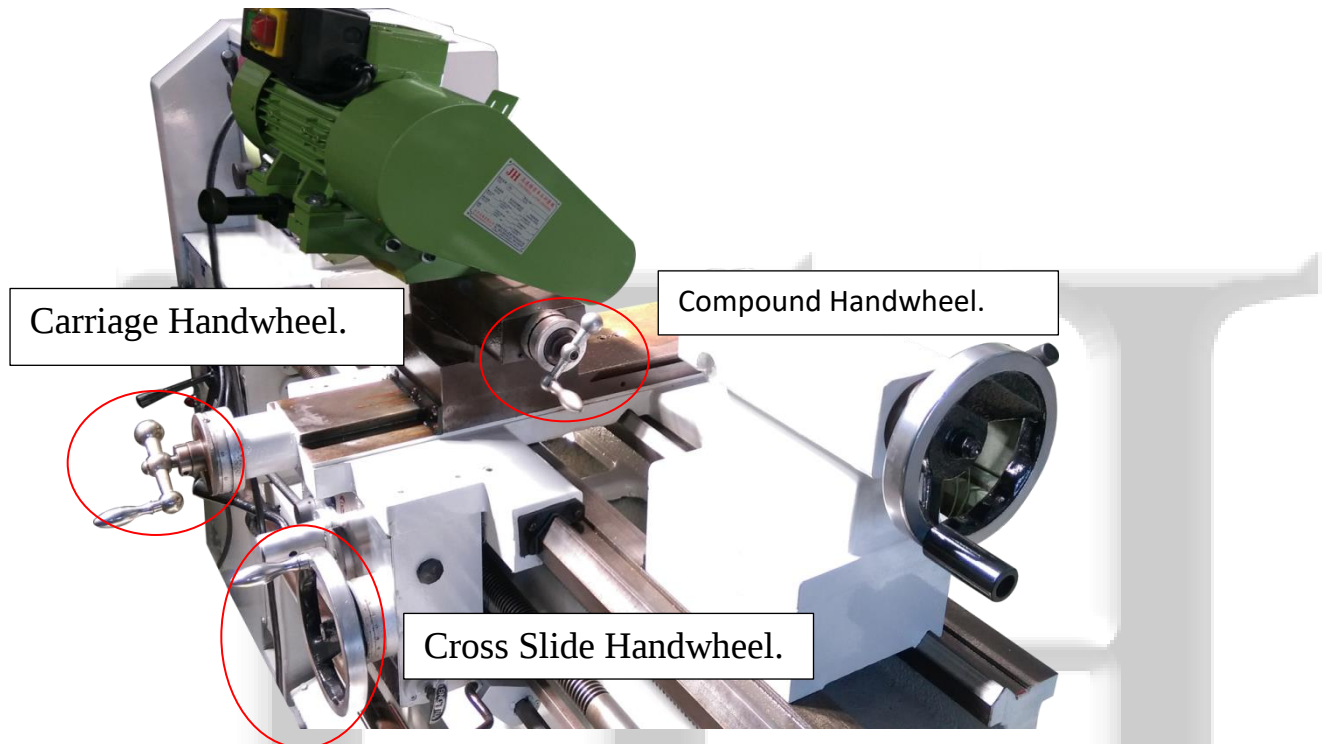


Confirm whether the running direction of grinding wheel is consistent with the indicated direction of grinder.

4. When grinding, the latch should rotate towards the same direction indicated by the grinder.

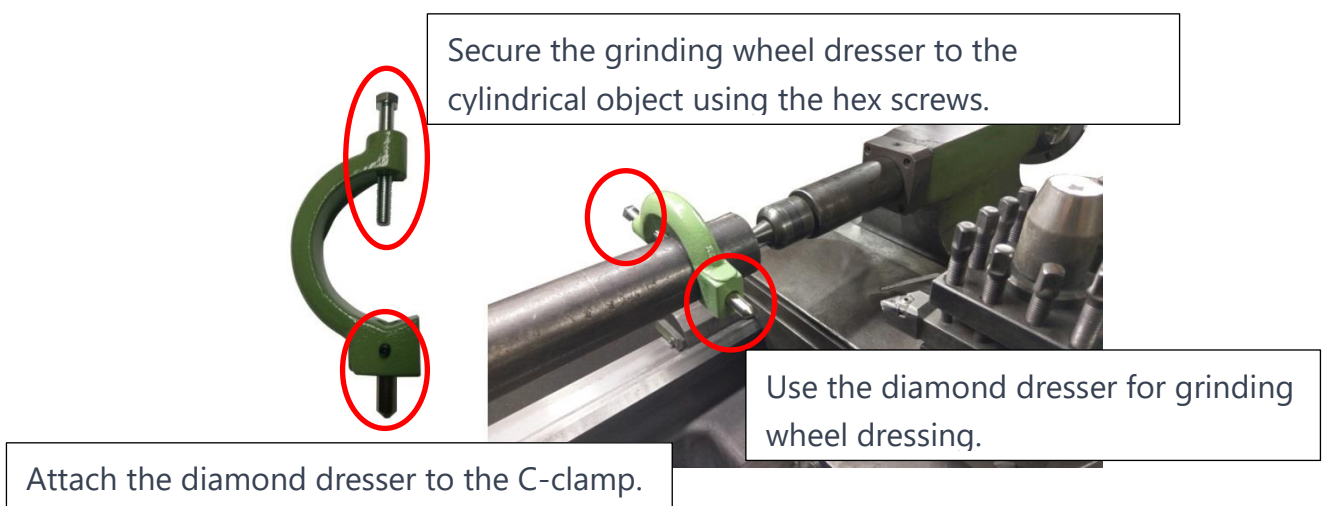


5. Use the compound rest vertical feeding, compound handwheel, carriage handwheel and cross slide handwheel for grinding.



### 三、Operating Instructions for the Grinding Wheel Dresser.

1. Secure the C-clamp onto the cylindrical object (such as the tail end of the workpiece, tailstock top pin, etc.), and use the diamond dresser for grinding wheel dressing.



### III. Safety Precautions

#### 1. Personnel standing position

When the grinder is in operation or in use, the personnel should never stand in front of the grinder, but on the back side or right back side.

#### 2. Change grinding wheel – check the condition of grinding wheel

When changing the grinding wheel, the operation personnel should firstly conduct sound test on the grinding wheel based on the following method. (1) Take the wood hammer or the handle of screwdriver as the tool. (2) Tap the surface of grinding wheel from the angle of 45 degrees or 135 degrees with the tool (Determine the 0 degree position yourself). (3) Listen to the sound of grinding wheel carefully. For V-based grinding wheel, the normal sound should be light metal sound. For B-based and Mg-based grinding wheel, it should be heavy sound. (4) For non-defective grinding wheel, the sound won't change when tapping on any position.

### 3. Change grinding wheel – install grinding wheel

Before installing grinding wheel, it should (1) check the flange, core axis of grinding wheel, and the hole of grinding wheel (whether there are impurities, whether the flange support is leveling, and whether it is bending); (2) Install the fixed flange, grinding wheel, movable flange and nuts (screws) in order; (3) The nuts (screws) can't be locked too tightly, which should be in appropriate tightness (The force on the screws should be uniform). It is recommended using torque wrench.

### 4. When operating new grinding wheel for the first time, it should keep it in empty running for more than 3 minutes, so as to ensure normal working.

### 5. The applicable ranges for the grinding wheel are as follows:

- The 5" (125mm) wheel can only be used up to 3.7" (95mm).
- The 8" (203mm) wheel can only be used up to 5.1" (130mm).

\*It is not recommended to use the wheel at its minimum range as it may pose a safety risk.