More than 40 experienced agencys and sole distributors throughout the world ...



History

The HUNGER company name has existed for almost 100 years. In 1922 Ludwig Hunger started a factory in Munich to produce precision cutting tools (Hunger reamers). Due to the lack of space in the original factory, a separate production plant and subsidiary was planned in Kaufering in 1965, and on May 22, 1967 production started there.

In 1970, this subsidiary was changed into an independent company under the direction of Manfred Hunger as CEO and associate. In 1982 the company moved into the present factory location at Ludwig-Hunger-Strasse 1 in Kaufering. Since 1995, his two sons Markus and Thomas Hunger – helped by their team in the daily business – are responsible for the company. ... are guaranteeing skilled and fast response, advise and support for our products. Please contact us for adresses of our partners worldwide!



- Long-standing experience in brake service equipment
- Design, production, sale and after-sales service at the same location
- 6,000 square meters of production surface in Bavaria near Munich
- ISO certified quality management

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The B 325 is a universal brake drum and brake disc turning and grinding machine complete with cross-feed. It is also eminently suitable for turning and grinding flywheel clutch faces.

Due to its many advantages, it has now become the standard machine in brake servicing shops. Key features include:

Technically up-to-date "intermittent feed" – short toolholders due to axially adjustable base slide – steplessly variable spindle speeds and feeds – longitudinal and surface feeds in both directions – Tool feed drive by electronically controlled 3phase motors – generously dimensioned slideways for saddle and cross-slide.

The far forward position of the spindle bearing with precision taper roller bearings allows the work arbor to be subjected to high loads (800 kg!) without additional support. This allows quick, simple and unobstructed front loading of brake drums, with or without wheels.

Brake drums are usually just turned, using an inward roughing and an outward finishing cut. If necessary however, simultaneous turning and grinding can be carried out.

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The powerful and effective dust and chip extraction provides a healthy and clean working environment.

The particularly cost-effective B 325 with its highly perfected mode of operation offers an excellent price/performance ratio and rapid amortisation, even with only partial utilization.

Machining approximately 85 brake drums on the B 325 covers the entire annual fixed costs. Every drum thereafter is profit! Let us send you a detailed cost calculation.

The machine has been tested and approved by virtually all the leading commercial vehicle manufacturers.



LCD-digital read-out

For rapid and precise adjustment of the drum diameter and spindle speed a LCD digital read-out can be incorporated optionally.



Intermittent feed

The B 325 machine employs the intermittent feed technique developed by HUNGER. This produces feed marks of an approximately circular instead of the usual helical form.

Advantages

1. Lateral drift of the brake shoes during braking is prevented. This obviates the unpleasant "brake shoe knocking".

Accessories

Tooling and workholding equipment for all brake drums - grinding attachment for brake drums and flywheels - double mounting for simultaneous turning and grinding of brake drums - double toolholder for brake discs - workholding equipment for brake discs - tooling and workholding equipment for flywheels LCD-digital displays for brake drum diameter and speeds - lifting and mounting trolley - jib crane with electrically powered or manually operated chain hoist - machine lamp - dust and chip extraction - protective guard and many other accessories.

- 2. A much greater feed can be employed, so that machining time is reduced by up to 60 %.
- 3. Coarser brake drum surfaces accelerate the bedding in process between brake lining and drum.
- 4. Grinding of brake drums is usually no longer necessary.



intermittent

continued

The axially adjustable base slide



The compound slide of the B 325 is mounted on a base slide with 200 mm axial adjustment, allowing it to be moved nearer the workpiece. This enables drums (left photo) and espe-



cially brake discs and flywheels (right photo) to be mounted rigidly with very short cutting tools to avoid vibration.

CE-Specification



The CE safety guard with electrical gate contacts satisfies the stringent requirements of the 2006/42/EU guide lines ("CE" suffix) and is mandatory for deliveries into countries of the European Union.

Lifting and mounting trolley

The HUNGER lifting and mounting trolley is suitable for transporting sets of wheels and brake drums as well as for loading and unloading the machines B 325 and B 355.

Jib crane



The jib crane is directly mounted to the machine. It can be delivered with an electrically powered or manually operated chain hoist. Complete sets of wheels are lifted with

a sling (photo), individual wheels with a wheel gripper and detached brake drums with a forked beam.

Versatility is paramount: **Operations** possible with the B 325.

Brake drums



Skimming of brake drums can be carried out either in the inward or outward direction. Any desired feed can be employed.

If a ground surface is preferred, simultaneous turning and grinding can be carried out.

Flywheels

Brake discs



Facing of a car flywheel.



Brake discs of any size, with or without hub, can be finely turned on both sides in one operation with the adjustable toolholder.

Flywheel clutch faces are usually ground subsequent to turning.







Brake drums without hub can be mounted in a three-jaw chuck. Car brake drums are turned with a cranked toolholder.



B 325	
Max. workpiece-Ø mm	n 1800
Max. turning-Ø on drums mm	n 1000
Min. turning-Ø on drums mn	n 150
Max. depth of drum mn	n 315
Max. brake disc-Ø mm	n 600
Max. brake disc thickness mm	n 60
Max. flywheel-Ø mm	n 600
Speed range rpn	20 – 125 steplessly variable
Longitudinal feeds mm/	r 0-0.40
Transverse feeds mm/	r 0-0.40
Main motor kW	V 1.5

Special voltages on request.

