

STANDARD MACHINES



MAIN CATALOGUE 2025/26

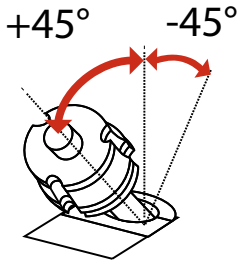
OFFER FOR OUR CUSTOMERS WHO ARE ENTREPRENEURS AND NOT CONSUMERS

HOLZKRAFT CASADEI F 25 – Table routers with swivelling router spindle from + 45° to - 45° and MT4 interchangeable spindle

- ▶ Sturdy grey cast steel construction
- ▶ Dynamically balanced milling unit anchored to the work table
- ▶ Particularly robust construction
- ▶ Smooth running thanks to precision units and high dead weight
- ▶ Clockwise and anti-clockwise rotation as standard
- ▶ Five speeds from 3000 to 10000 min⁻¹
- ▶ With MT 4 interchangeable spindle system as standard
- ▶ Large grey cast iron worktable for lasting precision
- ▶ Easy handling thanks to operating elements and speed display on the front of the machine
- ▶ Milling fence with fine adjustment and aluminium fence jaws as standard
- ▶ Powerful industrial motors

CASADEI F 25 LL FK

- ▶ Complete with table extension on the right and left with material rollers and pull-out workpiece support at the front
- ▶ Total length 2500 mm
- ▶ Incl. milling fence with crank adjustment with numerical display



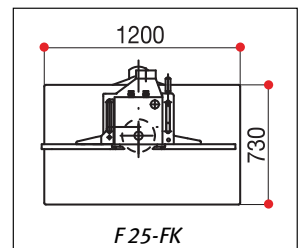
Can be swivelled on 2 sides



F 25-FK



F 25 LL-FK



F 25-FK

Model		CASADEI F 25-FK	CASADEI F 25 LL-FK	CASADEI F 25 M LL-FK
Art. No.		5220729	5220728	5220730
Technical data				
Work table dimensions approx.	mm	1200 x 810	2500 x 810	
Interchangeable spindle		MT 4		
Milling spindle swivelling range	°	+45 to -45		
Working length of the spindle	mm	140 ⁽¹⁾ / 180 ⁽²⁾		
Milling spindle stroke	mm	90		
Profiling tool Ø max.	mm	250		
Tenon tool Ø max.	mm	350		
Form milling tool Ø max.	mm	160		
Tool Ø can be lowered max.	mm	320 x 60 mm		
Rotational speeds	min ⁻¹	3000 / 4500 / 6000 / 8000 / 10000		
Suction nozzle Ø limit stop	mm	1 x 120 mm		
Suction nozzle Ø under the table	mm	2 x 80 mm		
Motor power ~50 Hz / S6-40%	kW	7.0 kW / 400 V		
Weight approx.	kg	480		

(1) for spindle Ø 30-35 mm (2) for spindle Ø 40-50 mm

Incl. equipment package F25-FK

with manually swivelling milling spindle from +45° to -45°, speed display via LED on the front, aluminium stop jaws and arc milling protection bonnet

Amplified 7.0 kW motor

Right/left rotation of the milling spindle

MT 4 interchangeable milling spindle

Includes milling stop with crank/handwheel adjustment from the front, with numerical display

Equipment package F 25 LL-FK additionally with:

Table extension left and right and extendable workpiece support (2500 mm width)

Equipment package F 25 M LL-FK additionally with:

Motorised height adjustment and swivelling of the milling spindle



You can find suitable feeders
on pages 34/35.



Milling fence

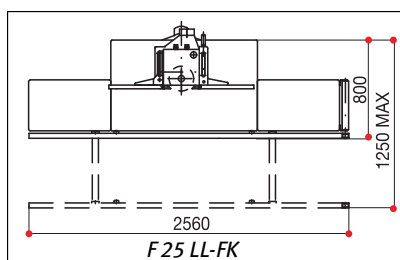
with crank adjustment

- Convenient operation
- Fast and precise adjustment



CASADEI F 25 M LL-FK
Fig. shows optional swivel device for
milling stop

Motorised height adjustment and swiv-
elling of the milling spindle



Accessory	Art. No.
Sliding carriage for small tenoning operations, with telescopic stop and eccentric clamp (max. tool Ø 250 mm)	5230600
Tool mandrel Ø 30 mm / 140 mm	5230601
Tool mandrel Ø 35 mm / 140 mm	5230602
Tool mandrel Ø 40 mm / 180 mm	5230603
Tool mandrel Ø 50 mm / 180 mm	5230604



The milling stops

- The milling fence is equipped as standard with aluminium stop jaws and fine adjustment
- The stop is adjusted using a crank handle
- The set values are read on numerical digital displays.



Manual control panel

- Operation is from the front
- The manual models are conveniently and easy to adjust via hand wheels on the machine front
- Numerical displays indicate the value for the spindle height and spindle tilt
- The set speed is displayed via LEDs on the control panel
- Standard with right-left rotation of the router spindle



- Interchangeable spindle MT 4 as standard on all CASADEI F 25 models



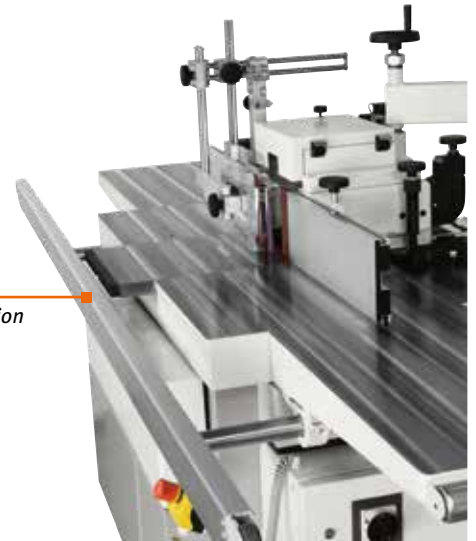
- Sliding carriage accessories for small tenon cutting operations and for slotting

Table routers

HOLZKRAFT CASADEI table routers - Components and units of the F series



- **Heavy and stable welded construction**
- Holzkraft Casadei machines are characterised by their particularly stable machine frame, to which all units are attached



Telescopic extension at the front

Speed change

- The large opening at the front of the machine body makes it easy and convenient to change belts for speed selection
- Optionally available with inverter for infinitely variable speed changes from 900 - 10000 min⁻¹, e.g. for fine sanding work



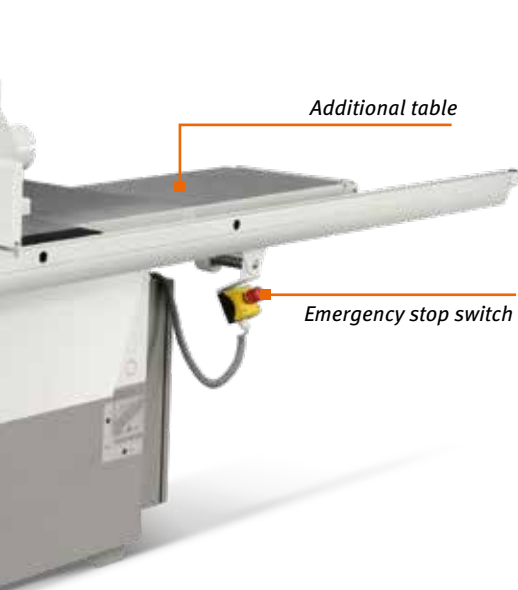
Milling unit

- The large-dimensioned milling unit made of grey cast iron is built for maximum precision and durability.
- Double-sided guide with precision ball bearing



Interchangeable spindle

- With MT 5 holder or with F 255 A also optionally with HSK B 63 quick-change system



Additional table

Emergency stop switch



F 25 FK / F 25 LL FK

Milling fences

- The milling fence is equipped as standard with aluminium stop jaws and fine adjustment
- The stop is adjusted using a crank handle
- The set values are read on numerical digital displays.



F 255 A

- The milling fence on A models with motorised milling fence is equipped as standard with anodised aluminium fence jaws, adjustable filling bars (Supersafe system) and a swing-away mechanism.
- The swivelling device allows the milling fence to be conveniently swivelled to the side

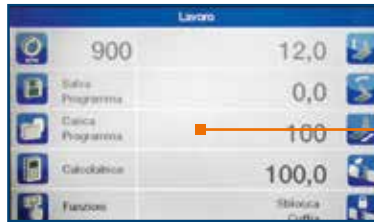
HOLZKRAFT CASADEI table routers – Equipment and operation

F 25 FK / F 25 LL FK



Manual control panel

- ▶ Operation is carried out entirely from the front
- ▶ The manual models are conveniently and easy to adjust via hand wheels on the machine front
- ▶ Numerical displays indicate the value for the spindle height and spindle tilt (for F 25).
- ▶ The set speed is displayed via LEDs on the control panel
- ▶ Standard with right-left rotation of the router spindle



Operating panel

- ▶ Setting the speed for machines with N.C. Control

Electronic programme control A version

- ▶ All A models are equipped with NC programme control
- ▶ 7" colour display in 16/9 format with alphanumeric keypad
- ▶ 300 programmes can be saved
- ▶ The axes are adjusted continuously or incrementally for each axis individually or together



F 255 A-3

- ▶ Automatic calibration
- ▶ The standard eye-level control panel can be swivelled and tilted
- ▶ The set values and the set speed are shown on the display
- ▶ All A models are equipped with automatic star-delta starting

Inverter

- ▶ For electronic adjustment of the spindle speed
- ▶ This special accessory not only allows the correct spindle speed to be selected, but also quick and precise adjustment
- ▶ Standard with model F 255 A
- ▶ Optionally available for the other models
- ▶ Infinitely variable speed adjustment from 900 - 10000 min⁻¹ optional for F 235 A
- ▶ F 255 A with electrospindle infinitely variable from 900 - 12000 min⁻¹

Setting the speed for machines without N.C. Control



Automatic spindle lock

- ▶ All M models are equipped with an electromagnetic spindle lock
- ▶ Activation, e.g. for tool change, is carried out via a rotary switch on the control panel
- ▶ On the manual models, the spindle is locked mechanically using a corresponding lever

Electrical equipment for feed unit

- ▶ The electrical equipment for feeders, standard for all CE versions, ensures safe working. The electrical components of the feed unit are integrated into the electrical equipment of the machine and pressing the emergency switch switches off both the machine and the feed unit

Table routers

HOLZKRAFT CASADEI table routers – Equipment and operation

F 255 A



Electrospindle

The F255A is equipped with a swivelling electrospindle as standard ($\pm 45.5^\circ$ front and rear), which is controlled by the inverter. Two swivelling segments are used for swivelling. The axes (swivelling and height adjustment) are controlled by 2 independent motors.



F 255 A



HSK device

Quick tool change with HSK B 63 spindle. The system allows a quick tool change and reduces the set-up and adjustment time of the machine.

Available on request for A versions

Option



F 255 A



In the A versions, the 'Rapid' table insert can be controlled by N.C. control on request.

Machine table

The 'Rapid' machine table with movable table insert allows maximum contact surface for the workpiece to be machined with any tool diameter and optimum suction performance. Adjustment is also possible with the tool fitted. The "Rapid" system makes it possible to work without bearing rings in the milling table.

HOLZKRAFT CASADEI table routers – Operation

F 255 A



Feed support and swivelling device

- ▶ Cross support and swivelling device for the feed unit on the column of the control panel (only available in conjunction with eye-level control panel)
- ▶ With manual adjustment of the feed unit via numerical displays
- ▶ Or with horizontal and vertical motorisation with automatic locking and digital displays as shown (only available for A models)

F 255 A



Cross support for feed unit on control panel column

- ▶ On request, the Series 200 routers can be equipped with a cross support for the feed device on the control panel column.

F 255 A



Two cross supports are available:

- ▶ **Manual cross support** (available for all versions, control panel required) complete with manual horizontal/vertical adjustment of the support by handwheel
- ▶ Motorised cross support (only available for certain models)

F 25 FK / F 25 LL FK / F 255 A



Tenoning and slotting device

- ▶ With telescopic fence, can be swivelled from -60° to +60°
- ▶ Tool diameter max. 250 mm
- ▶ With splinter wood and eccentric clamp