

STANDARD MACHINES

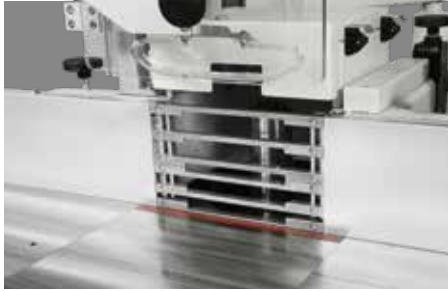


MAIN CATALOGUE 2025/26

OFFER FOR OUR CUSTOMERS WHO ARE ENTREPRENEURS AND NOT CONSUMERS

HOLZKRAFT CASADEI F 255 – For the highest demands with comfortable equipment. Table router with direct drive electric spindle, infinitely variable speed from 900 to 12000 min⁻¹ and swivelling router spindle from +45.5° to -45.5°.

- ▶ Highly stable grey cast steel construction
- ▶ Large grey cast iron worktable
- ▶ 7.5 kW electric spindle drive with maintenance-free direct drive guarantees maximum precision thanks to extremely smooth running
- ▶ Maximum power is already available from 3400 min⁻¹ onwards
- ▶ Precision units and high dead weight
- ▶ Rapid table insert, infinitely manually adjustable to tool diameter (optionally electronically positionable)
- ▶ Standard clockwise/anti-clockwise rotation with electronic locking during tool change
- ▶ Stepless speed via inverter from 900 - 12000 min⁻¹
- ▶ Digital speed display on the front
- ▶ Interchangeable spindle MT 5
- ▶ Control elements on the front
- ▶ Milling fence with fine adjustment, linear adjustable via hand wheels from the operator front
- ▶ Automatic star-delta start-up
- ▶ Automatic motor brake
- ▶ Connection for feed unit



Supersafe system as standard
Milling fence with aluminium fence jaws and connecting bars

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

Milling fence swivelling device

- Can be conveniently swivelled from the worktable
- For shorter set-up times

Swivelling NC control at eye level

- ▶ The standard NC control system controls all axes of the machine and the speed of the milling spindle (picture left), if the machine is equipped with an inverter
- ▶ Large 7" screen, 16:9 format. All spindle controls are on one side and allow the machine to be adjusted quickly
- ▶ The software is easy to use. The memory capacity comprises up to 300 programmes, which can also be transferred with various parameters via a USB interface



Model	F 255 A2
Art. No.	5222102

Model	F 255 A3
Art. No.	5222103

Model	F 255 A3 PL
Art. No.	5222104

Technical data	
Work table dimensions approx.	1200 x 780 mm
Interchangeable spindle	MT 5
Milling spindle swivelling	+45.5 to -45.5°
Working length of the spindle	140 mm ⁽¹⁾ / 180 mm ⁽²⁾
Milling spindle stroke	130 mm
Profiling tool Ø max.	250 mm
Tenon tool Ø max.	300 mm ⁽¹⁾ / 350 mm ⁽²⁾
Form milling tool Ø max.	160 mm
Tool Ø can be lowered max.	300 x 80 mm
Speeds, infinitely variable	900– 12000 min ⁻¹
Suction nozzle Ø limit stop	1 x 120 mm
Suction nozzle Ø Machine stand	2 x 100 mm
Suction nozzle Ø Forced cooling E-spindle	1 x 100 mm
Motor power ~50 Hz / S6-40%	7.5 kW / 400 V
Weight approx.	950 kg

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

A version with:

- › NC program control with 7" colour display in 16/9 format (300 programmes) for positioning two or three axes via keyboard and digital display, continuous or incremental
- › Automatic calibration
- › Electronic speed display
- › With eye-level control panel as standard
- › Automatic star-delta start-up
- › With electrical positioning of the spindle height, spindle swivel and milling fence, additionally with aluminium fence jaws with adjustable filler rods (Supersafe system) and swivel device for swivelling the milling fence to the side as standard

Option PL version with:

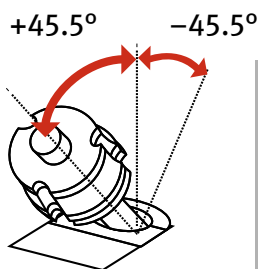
- ▶ With table extension on the right and left and extendable workpiece support at the front
- ▶ Material roll right
- ▶ Total width 2540 mm



You can find suitable feeders on pages 34/35.



F 255 A3 PL



Swivelling interchangeable spindle

- Interchangeable spindle MT 5 as standard
- Spindle can be swivelled from +45.5° to -45.5°, making the feed device extremely versatile (see image above)
- Swivelling allows the use of tools with small diameters and for specific machining operations

Replaceable spindle, HSK
(Art. No. 5256214)



Option



Cross support and swivelling device option for feed unit
With manual adjustment via handwheels
(Art. No. 5256209)

Or motorised horizontal and vertical adjustment with automatic locking via the control unit (see fig. Art. No. 5256210)

Option



The integral fence is a high-precision routing fence with a vertical spindle. The folding bars allow the danger zone to be covered in stages, thus providing continuous and safe guidance for the workpiece.
(Art. No. 5855020/5855021)

Option



Equipment options F 255 ⁽³⁾	Art. No.
Electronic NC programming of the Rapid table insert (A version only)	5256201
Surcharge PL version	5256203
Surcharge for TPL version (for tenoning and profiling)	5256204
Glazing bead sawing unit (only for A version; PL or TPL required)	5256206
Swivelling device for milling fence (standard with A-3)	5256208
Stand for feed unit on the control panel column (only for A version)	5256209
Motorised stand for feed unit (only for A)	5256210
Integral stop both halves each 500 mm long with sensor monitoring for F 255 A3 PL Neu	5855020
Integral stop both halves each 650 mm long with sensor monitoring for F 255 A3 PL Neu	5855021
Surcharge "HSK" version, with HSK B 63 quick-change system, incl. 1 mould carrier and blowing nozzles	5256214
Accessory	Art. No.
Sliding carriage for small tenon cutting operations, telescopic extension and eccentric clamp (tool diameter 250 mm)	5256205
Aluminium instead of wooden stop jaws with connecting bars (series for A-3; not with glazing bead sawing unit)	5256207
Replacement mandrel MT 5	5256211
Tool holder taper MT 5:	5256212
- right, with ring without pliers	
- left, with ring without pliers	5256213
4 HSK B 63 tool carriers incl. storage stand with 5 places	5256215
1 HSK B 63 tool carrier (additional)	5256216
Tool holder taper HSK B 63:	5256217
- right, with ring without pliers	
- left, with ring without pliers	5256218
Tool trolley complete with two tool stands for HSK	5256219

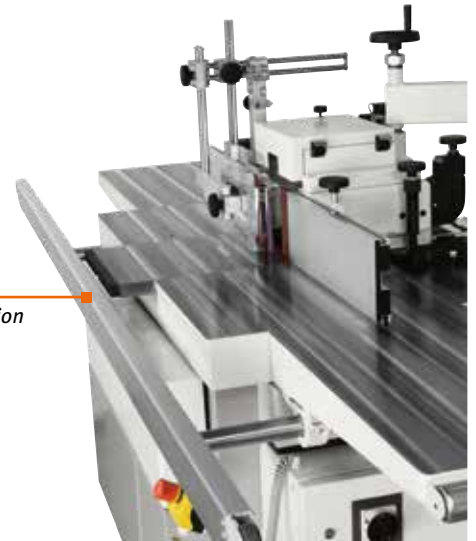
(3) cannot be retrofitted, only when ordering a new machine

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



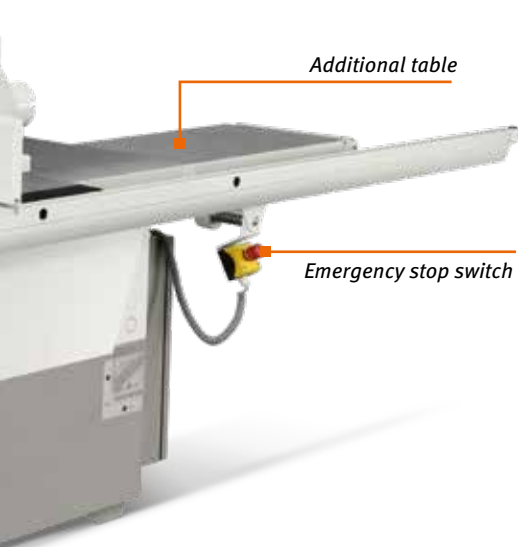
Milling unit

- 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



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.



- 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

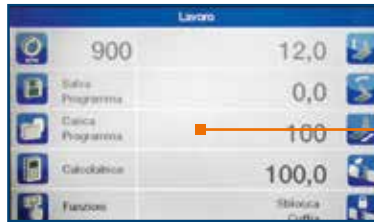
HOLZKRAFT CASADEI table routers – Equipment and operation

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