

STANDARD MACHINES



**MAIN CATALOGUE 2025/26**

*OFFER FOR OUR CUSTOMERS WHO ARE ENTREPRENEURS AND NOT CONSUMERS*

## HOLZKRAFT woodworking machines for trade, commerce and industry



*Sales and Service Germany in Hallstadt / Bamberg*

### Dear customers,

**It is worthwhile in several respects  
to study this catalogue intensively!**

CASADEI continues to enjoy success in Europe thanks to its top-quality machines, which combine tradition with progress.

HOLZKRAFT has been the authorised sales and service representative for CASADEI in Germany for over 10 years.

HOLZKRAFT Casadei machines are manufactured in close cooperation with the SCM Group, the world market leader in woodworking machinery, in Italy.

Production is certified in accordance with DIN ISO 9001. This means that the machines are designed right from the development stage to ensure maximum operating safety in accordance with the strictest international standards. Experience gained from 70 years of developing, designing and producing all types of woodworking machines goes into every single machine, guaranteeing very high quality.

Thanks to our comprehensive network of HOLZKRAFT specialist dealers, you will always find a local partner who can provide personal support, expert advice and excellent after-sales service.

Of course, our HOLZKRAFT service team with its own workshops and expert advisors is also available to provide you with advice and assistance at any time.

With HOLZKRAFT Casadei you acquire woodworking machines that stand up to any comparison with



corresponding products in terms of ease of use, equipment, quality and technology. In addition, the entire programme impresses with an optimum price-performance ratio.

[www.holzskraft.de](http://www.holzskraft.de)

**Kilian Stürmer**

Managing Director

**Robert Stürmer**

Sales Manager



The **SLD STÜRMER** logistics centre with approx. 22000 m<sup>2</sup> of warehouse space

The **STÜRMER** logistics centre has more than 345000 items available from stock. This enables prompt despatch of almost all items throughout Germany and Europe.

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## HOLZKRAFT CASADEI XENIA 40 - sliding table saws with swivelling 400 mm saw blade and scoring unit. M version with motorised height and angle adjustment of the saw blade

- ▶ Sturdy grey cast steel construction guarantees precision, smooth running and durability
- ▶ Smooth-running and precise size sliding carriage made of anodised aluminium with proven and permanently smooth-running ball contact system on hardened guides (10-year guarantee\*)
- ▶ Grey cast iron saw table
- ▶ Large support surfaces thanks to standard table extension and widening
- ▶ Foldable rip fence with fine adjustment
- ▶ Angle-adjustable cut-to-length fence, extendable with two folding stops
- ▶ Extension arm with material roll
- ▶ Round steel guide with diameter Ø 50 mm (Xenia 40 M A version)
- ▶ Laterally swivelling saw blade pendulum guard with integrated extraction nozzle
- ▶ Standard with 3 saw blade speeds (from M version onwards)
- ▶ Scoring unit with separate scoring motor
- ▶ Numerical display for saw blade swivelling on the front of the machine (XENIA 40)
- ▶ Industrial motor for continuous operation

**10 Jahre Garantie**

**10 Jahre Garantie**

**Swivelling segment**

- ▶ Long-lasting precision thanks to dual swivel segment guide

\* On wear of the carbide guideways

**Sliding carriage with ball contact system**

- ▶ Equipped with ball contact system proven a thousand times over
- ▶ Permanently smooth-running
- ▶ Insensitive to dust and dirt due to minimum contact point between ball and trapezoidal rail

Equipment	Xenia Execution		
	40	40 M	40 M A
Manual version; 3700 min <sup>-1</sup>	✓		
Motorised version; 3000/4000/5000 min <sup>-1</sup>		✓	✓
Motorised lifting, lowering and swivelling of the saw unit		✓	
Amplified main motor 9.0 kW with automatic star-delta start			✓
Parallel fence with electronic positioning			✓
Control panel at eye level			✓



Fig. shows Xenia 40

Model	Xenia 40	Xenia 40 M
Art. No.	5223442	5223440
<b>Technical data</b>		
Trimming length	3200 mm	3200 mm
Cutting height at 90°/45° max.	140/97 mm	140/97 mm
Cutting width with rip fence	1270 mm	1270 mm
Cutting width to the left of the saw blade max.	3200 mm	3200 mm
Saw blade swivelling	90° - 45°	90° - 45°
Saw blade diameter max.	400 mm	400 mm
Scoring saw blade diameter	120 mm	120 mm
Main saw blade speed	3700 min <sup>-1</sup>	3000 - 4000 - 5000 min <sup>-1</sup>
Scoring saw blade speed	8500 min <sup>-1</sup>	8500 min <sup>-1</sup>
Suction nozzle Ø at bottom	120 mm	120 mm
Saw blade guard suction nozzle Ø	80 mm	80 mm
Motor power 400 V / ~50 Hz / S6-40%	7.0 kW	7.0 kW
Scoring unit motor power	0.9 kW	0.9 kW
Weight approx.	661 kg	764 kg

Equipment options <sup>(2)</sup>	Art. No.
Trimming frame with CompeX device for mitre cuts with automatic compensation the fence position	5256231
Cut-to-length fence with 2 LCD displays for stops	5256189
Mitre fence with telescopic fence 1500 mm and two folding fences	5256186
Additional rip fence on the size sliding table	5256188
XENIA 40 electronic position indicator on the rip fence, manually adjustable with magnetic tape measuring system	5256190
Parallel cutting width up to 1500 mm	5256193
Parallel cutting width up to 1000 mm	5256192
Adjustable start/stop buttons	5256230

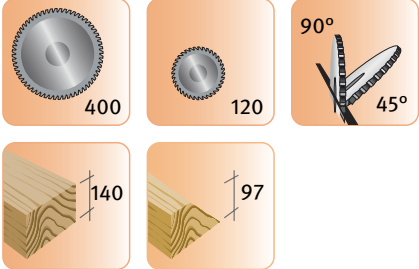
(1) Warranty conditions can be requested at [www.stuermer-maschinen.de](http://www.stuermer-maschinen.de) or from Stürmer Maschinen GmbH.

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



Fig. shows Xenia 40 MA with *option* "adjustable start/stop buttons" (for starting the main saw, scoring saw and its stop) Art. No.: 5256230

**Xenia 40**



**Option**



▶ Trimming frame with CompeX device for mitre cuts with automatic length compensation

**Option**



**Cut-to-length fence with 2 LCD displays**  
▶ Quick adjustment and easy use thanks to the electronic digital display showing the stop position. Art. No.: 5256189

**M series**



▶ Saw blade with 3 speeds (3000/4000/5000 min<sup>-1</sup>)  
▶ Easy manual adjustment from above

**Option**



**Additional rip fence**  
▶ On on the sliding table for long and narrow workpieces Art. No.: 5256188

**Option MA series**



**Swivelling control panel and driven rip fence with programming**  
▶ Comfort and precision: once the working position has been set using the numeric keypad, the stop is quickly positioned by pressing the corresponding key. The stop position is visualised on an electronic display. (For Xenia 40 MA only) Art. No.: 5256234



**Saw unit**  
▶ The saw unit consists of a single cast iron block with a closed ring structure for maximum torsional rigidity  
▶ The vertical movement of the unit is positively driven by two ground shafts  
▶ Adjustment is smooth and vibration-free at all times, with maximum precision.



**Sliding carriage**  
▶ Smooth running and precision are the special features of the sliding carriage. Its exclusive sliding system, which uses rigid aluminium profiles on steel guides with curved contact surfaces, guarantees maximum precision and running accuracy along the entire trimming path. The result is impressive: Precision even after many years of intensive use without any maintenance



**FOX 100 control panel at eye level (XENIA 40 MA)**  
▶ Thanks to the control commands on the freely suspended control panel, settings can be made quickly and easily. The control panel is included in the version with a powered rip fence.

## HOLZKRAFT CASADEI XENIA 60 – Heavy-duty professional sliding table saw with high-quality equipment for work results of the highest quality

- ▶ Sturdy grey cast steel construction
- ▶ Smooth-running and precise aluminium sliding carriage, anodised, with proven and permanently smooth-running ball contact system on hardened guides
- ▶ Large support surfaces thanks to standard table extension and widening
- ▶ Grey cast iron saw table
- ▶ Laterally swivelling saw blade pendulum guard with integrated extraction nozzle
- ▶ Angle-adjustable cut-to-length fence, extendable up to 3200 mm, with two folding stops
- ▶ Extension arm with material roll
- ▶ Standard with three speeds
- ▶ Scoring unit with separate scoring motor
- ▶ Powerful industrial motors
- ▶ Cutting width with rip fence 1270 mm
- ▶ Automatic motor brake for main saw blade

### Casadei Xenia 60 A version:

- ▶ With 4-axis electronic positioning for raising, lowering and swivelling the saw blade unit and adjusting the scoring unit
- ▶ Possibility to store up to 300 programmes

### Equipment

Scoring unit
Anodised aluminium sliding carriage
2600 or 3200 or 3800 mm
Handle for sliding carriage
Extension arm with material roll
Professional folding stops
Trimming shoe
Eccentric clamp
Table widening
Table extension
Saw blade pendulum guard

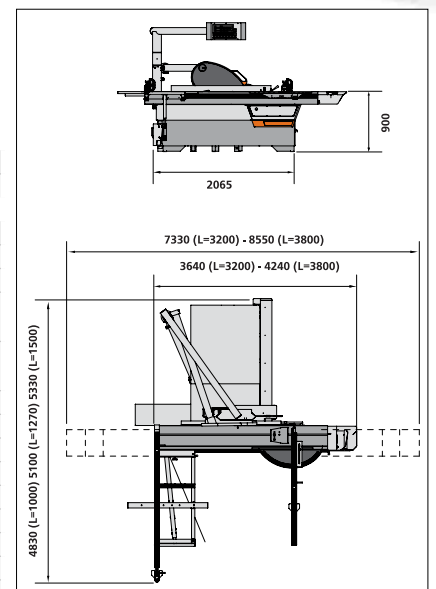


Xenia 60/32 A

Xenia	Xenia 60/26	Xenia 60/26 A	Xenia 60/32	Xenia 60/32 A	Xenia 60/38
Art. No.	5223501	5223503	5223500	5223502	5223505

### Technical data

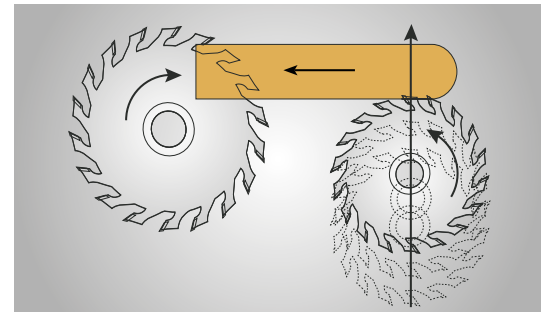
Trimming length	mm	2600		3200	3800
Cutting height at 90°/45° max.	mm			130/92	
Cutting width with rip fence	mm			1500	
Cutting width to the left of the saw blade max.	mm	2600		3200	3800
Saw blade swivelling	°			90 - 45	
Saw blade diameter max.	mm			400	
Scoring saw blade diameter	mm			120	
Main saw blade speed	min <sup>-1</sup>			3000 / 4000 / 5000	
Scoring saw blade speed	min <sup>-1</sup>			8500	
Suction nozzle Ø at bottom	mm			120	
Suction nozzle Ø at top	mm			100	
Motor power	kW	7.0	9.0	7.0	9.0
Scoring unit motor power	kW			0.9	



Xenia 60/32 / Xenia 60/38



Xenia 60/32



► Automatic scoring setting



Option

► Length stop with 3 folding stops and 3 digital displays (5256133)



Option

► Trimming frame with CompeX device for mitre cuts with automatic length compensation (5256152)

**Xenia 60**

- 400mm blade
- 120mm blade
- 90° / 45° angle
- 130mm rip fence
- 92mm rip fence
- Option: CompeX device

**Xenia 60 A**

- 400mm blade
- 120mm blade
- 90° / 45° angle
- 130mm rip fence
- 92mm rip fence
- Option: CN control panel
- Option: INVERTER 6000/2700 RPM

Equipment options <sup>(1)</sup> Xenia 60	Art. No.
Swivelling control panel at eye level (A version)	5256006
Adjustable start/stop buttons	5256123
Additional frame with mounting support on slide rails	5256179
Mitre fence for attachment to the sliding carriage	5256003
Device for mitre cuts with compensation	5256004
Cut-to-length stop with LCD	5256009
Cutting width with rip fence 1000 mm	5256007
Cutting width with rip fence 1500 mm	5256008
Electronic position indicator on the rip fence	5256143
Electronically positionable rip fence with THK linear guides (A version)	5256132
Inverter for speed control from 2700 to 6000 min <sup>-1</sup> (A version)	5256120
Motor power 9 kW	5256121
Trimming frame with CompeX device for mitre cuts with automatic compensation the fence position	5256152

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

**10 Jahre Garantie**

**10 Jahre Garantie**

**Swivelling segment**

- Long-lasting precision thanks to dual swivel segment guide

**Sliding carriage with ball contact system**

- Equipped with ball contact system proven a thousand times over
- Permanently smooth-running
- Insensitive to dust and dirt due to minimum contact point between ball and trapezoidal rail

\* On wear of the carbide guideways

## HOLZKRAFT CASADEI XENIA 70 A – Professional sliding table saw with a maximum 550 mm saw blade and a cutting height of 200 mm. Customisable for specific applications thanks to modular equipment options

- ▶ Sturdy grey cast steel construction guarantees precision, smooth running and durability
- ▶ Smooth-running and precise size sliding carriage made of anodised aluminium with proven and permanently smooth-running ball contact system on hardened guides (10-year guarantee\*)
- ▶ Grey cast iron saw table
- ▶ Large support surfaces thanks to standard table extension and widening
- ▶ Fold-able rip fence
- ▶ with round bar guide
- ▶ Cut-to-length fence, extendable with two folding stops
- ▶ Top control panel
- ▶ Extra-large extension arm with material roller, extendable up to 2400 mm
- ▶ Swivelling saw blade pendulum guard with integrated extraction nozzle
- ▶ Powerful industrial motors
- ▶ and saw blade tilt
- ▶ Numerous equipment options for individual customisation
- ▶ Scoring unit with separate drive motor can be positioned electronically
- ▶ Preparation for 550 mm saw blade

▶ With electric positioning of the cut

**SmartControl S with 10" touch screen and operating position at eye level.**

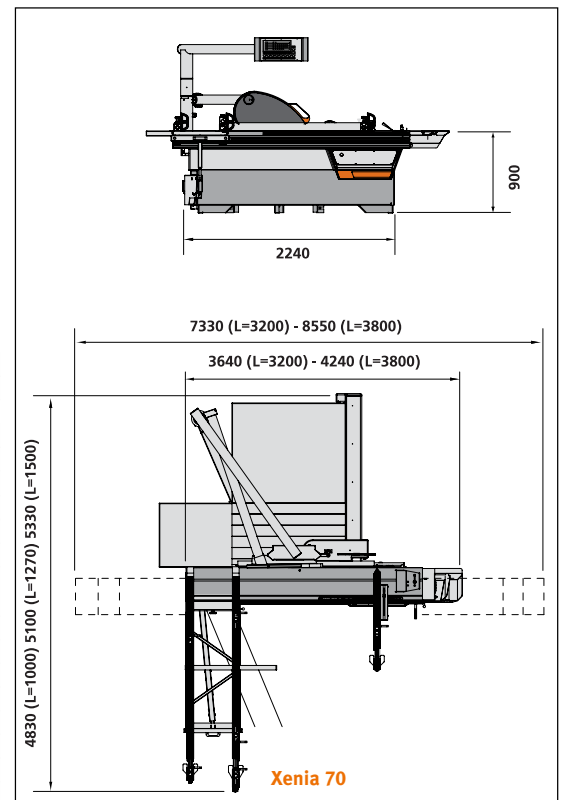


Fig. shows Xenia 70 A with optional swivelling control panel, Art. No.: 5256006

Equipment	Xenia Execution	
	70/32	70/38
Scoring unit	✓	✓
Anodised aluminium sliding carriage	✓	✓
Handle for sliding carriage	✓	✓
Extension arm with material roll	✓	✓
Parallel saw fence	Round bar guide, can be swivelled away	
Stops	2 professional folding stops	
Trimming shoe	✓	✓
Eccentric clamp	✓	✓
Table widening	✓	✓
Table extension	✓	✓
Saw blade pendulum guard	with quick release device	
Preparation for saw blade Ø	550 mm	

	-550	XENIA 70/38 A
Art. No.	5223504A	5223507

Technical data		
Trimming length	3200 mm	3800 mm
Cutting height at 90°/45° max.	200 / 129 mm	
Cutting width with rip fence	1270 mm	
Cutting width to the left of the saw blade max.	3200 mm	
Saw blade swivelling	90° - 45°	
Saw blade diameter (without scoring blade) max.	550 mm	
Scoring saw blade diameter	120 mm	
Main saw blade speed	2500 - 3500 - 5000 min <sup>-1</sup>	
Scoring saw blade speed	8500 min <sup>-1</sup>	
Scoring unit motor power	0.9 kW	
Suction nozzle Ø at bottom	120 mm	
Saw blade guard suction nozzle Ø	100 mm	
Motor power ~50 Hz / S6-40%	7.0 kW / 400V	
Weight approx.	1000 kg	





**Speeds of the main saw blade**

- ▶ Standard with three speeds
- ▶ Easy speed change via opening in the worktable



**Precision sawing unit**

- ▶ Three speeds
- ▶ Opening in the worktable for easy belt replacement



**With NC control as standard**

- ▶ Adjustment of all axes of the machine
- ▶ Storage space for up to 300 programmes
- ▶ Display via 7-inch LC display
- ▶ Alphanumeric keypad
- ▶ Spindle speed control if the machine is equipped with an inverter
- ▶ USB port for loading parameters



**Option**  
**Cut-to-length stop for large dimensions with LCD**  
Art. No.: 5256147

- ▶ Three folding stops
- ▶ Three digital displays



**Option**  
**Trimming frame with CompeX device**  
Art. No.: 5256004

- ▶ for mitre cuts with automatic length compensation



**Option**  
**THK linear guide parallel stop**  
Art. No.: 5256132

- ▶ With electronic programming unit available on request. Travel system on precise THK guides using ball screws and ball slide rails. Fence can be swivelled away under the table. Anti-collision system

Equipment options <sup>(1)</sup> Xenia 70	Art. No.
Swivelling control panel	5256006
Preparation for 550 mm saw blade	5256196
Mechanical preparation for DADO/ grooves	5256197
On/off switch for main and scoring saw blade on the sliding carriage	5256123
Additional frame with mounting support on slide rails	5256199
Mitre fence for attachment to the sliding carriage	5256003
Device for mitre cuts with length compensation	5256004
Cut-to-length stop for large dimensions with LCD	5256147
Cutting width with rip fence 1000 mm	5256007
Cutting width with rip fence 1500 mm	5256008
Electronically positionable rip fence with THK linear guides <b>(A version)</b>	5256132
Electronic position indicator on the rip fence	5256143
Inverter for speed control from 2350-5200 rpm <b>(A version)</b>	5256135
Motor power 9 kW, 50 Hz (S6-40%)	5256136
Motor power 14 kW 50 Hz (S6-40%)	5256137
Trimming frame with CompeX device for mitre cuts with automatic compensation the fence position	5256152

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

\* On wear of the carbide guideways

**Swivelling segment**  
▶ Long-lasting precision thanks to dual swivel segment guide

**Sliding carriage with ball contact system**

- ▶ Equipped with ball contact system proven a thousand times over
- ▶ Permanently smooth-running
- ▶ Insensitive to dust and dirt due to minimum contact point between ball and trapezoidal rail

Warranty conditions can be requested at [www.stuermer-maschinen.de](http://www.stuermer-maschinen.de) or from Stürmer Maschinen GmbH

**Xenia 70 A**

450

120

45°

150  
(Ø450)

106  
(Ø450)

CN

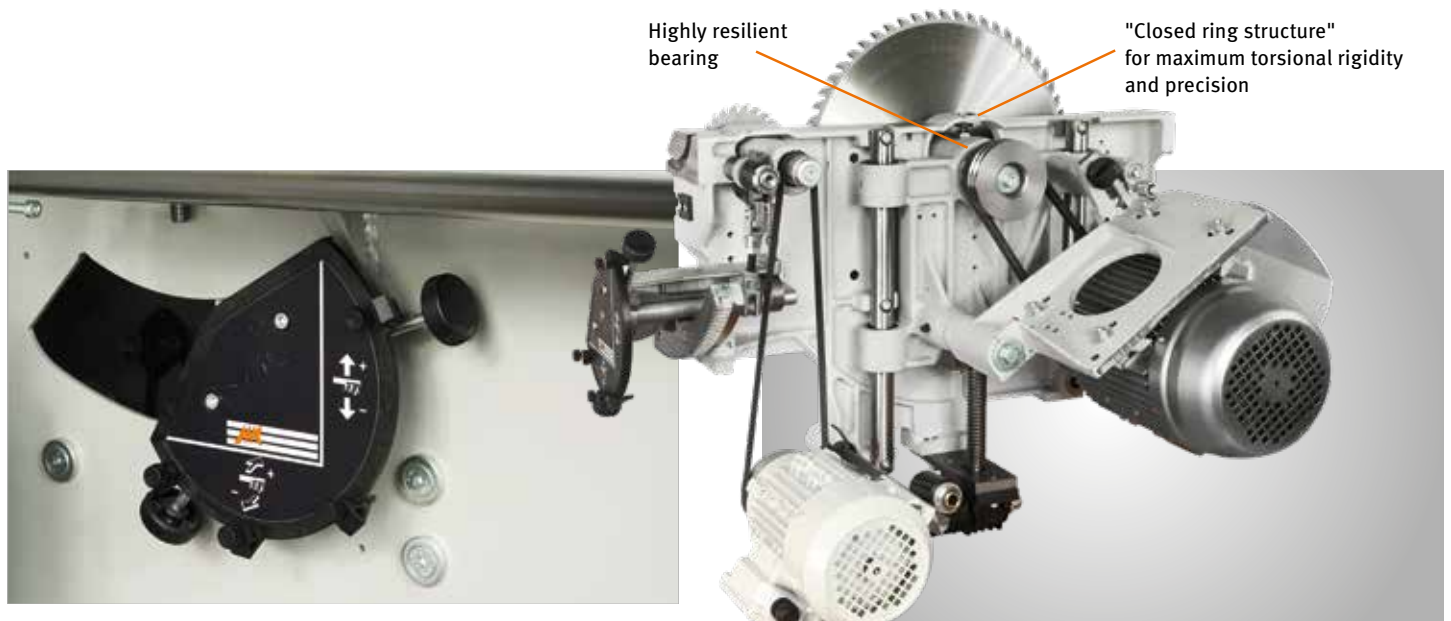
550

200  
(Ø550)

141  
(Ø550)

**INVERTER**  
5200  
2350  
RPM

# Sliding table saws



## Saw unit

- ▶ The saw unit consists of a single cast iron block with a closed ring structure for maximum torsional rigidity
- ▶ The vertical movement of the unit is positively driven by two ground shafts
- ▶ Adjustment is smooth and vibration-free at all times, with maximum precision.
- ▶ Maximum power transmission

- ▶ through quality V-belts
- ▶ Equipped with high-torque industrial motors for very high cutting performance
- ▶ The separate scoring motor enables individual use of the scoring unit
- ▶ The scoring unit is adjusted horizontally and vertically from the outside using two operating

- ▶ levers (see illustration above)
- ▶ The adjustment range of the operating levers can be limited by end stops, allowing the adjustment position to be quickly restored, e.g. after a change.



## Rip fence

- ▶ The rip fences from Holzkraft Casadei are equipped with fine adjustment as standard
- ▶ The standard cutting width is 1270 mm
- ▶ Widths of 1000 mm and 1500 mm are optionally available
- ▶ Both the manually and electrically adjustable rip fence, which is available as an option, can be folded down completely below table level.

## Optional programmable rip fence

- ▶ Stop guide via ball screw and THK linear guide with a speed of 25 m/min
- ▶ Cutting width 1500 mm
- ▶ The aluminium profile of the stop can be rotated 90° for cutting narrow workpieces without having to adjust the measurement.
- ▶ Folds down below table level
- ▶ 300 programme memory locations
- ▶ Only available for Xenia 60 and Xenia 70



### Swivelling segment

- ▶ Permanent precision thanks to dual swivelling segment guide
- \* On wear of the swivelling segments



**THK linear guide and ball screw parallel stop**

- ▶ With electronic programming unit available on request. Travel system on precise THK guides using ball screws and ball slide rails. Fence can be swivelled away under the table. Anti-collision system



**SmartControl S**

- ▶ Electronic control with touch screen display. Control of the height adjustment of the main saw blade, rip fence adjustment,
- ▶ inclination of the saw unit possible in manual, semi-automatic and automatic mode.
- ▶ Possibility of saving up to 1000 programmes with relative image.



**Automatic adjustment of the scoring unit**

- ▶ Correction of the height and lateral adjustment of the scoring saw blade from the control panel (optional for Xenia 60 and Xenia 70 only)

**Stepless saw blade speed via inverter**

- ▶ Adjustable via the control panel (optional only for Xenia 60 and Xenia 70 and in conjunction with max. 7.5 kW main motor)



**Control panel at eye level**

- ▶ Control with touch screen display
- ▶ Swivelling and rotatable in both directions
- ▶ Available as an optional extra for Xenia 60 and Xenia 70

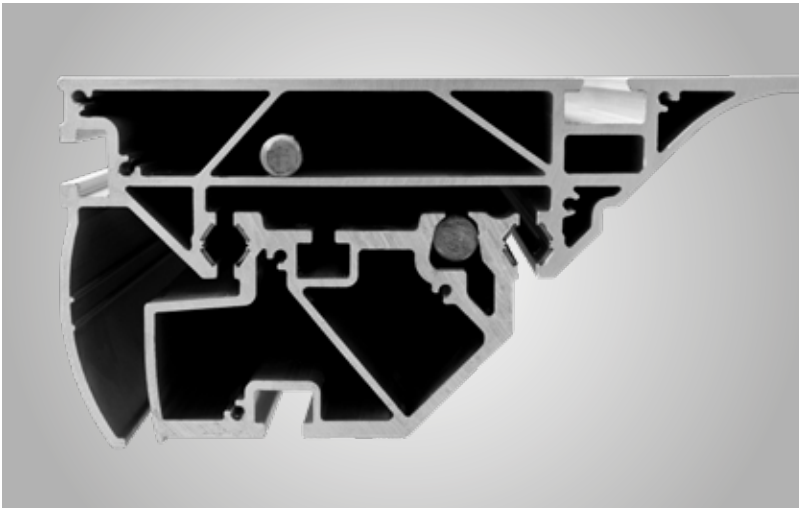
# Sliding table saws



► Fig. shows the clamp for locking the sliding table

## Anodised aluminium sliding carriage

- Long-term proven aluminium sliding table with ball contact system on steel guides
- The ease of movement of the ball contact system is based on a minimum contact point between ball and guideway
- The hardened and ground steel guideways are flanged and not glued
- This system ensures that the sliding carriage always runs smoothly and without jerking
- Low maintenance thanks to a special self-cleaning system that prevents dust from settling
- The sliding carriage remains permanently smooth-running, quiet and precise when cutting
- 10-year HOLZKRAFT warranty\* on wear and tear of the guide rails



## Aluminium sliding carriage profile

- The aluminium profile with a closed chamber structure gives the sliding carriage particularly high rigidity
- The aluminium is insensitive to temperature fluctuations
- Anodised as standard to prevent aluminium discolouration on the workpiece
- Length of sliding carriage: 2600 mm, 3200 mm and 3800 mm



## Table extension

- The table extension of the Xenia 40, Xenia 40 M, Xenia 60 and Xenia 60 A has a material roller, an angle-adjustable telescopic cutting fence up to 3200 mm with scale and angle grid as well as two folding stops
- The cantilever arm of the Xenia 70 and Xenia 70 A is equipped with a material roller that can be extended up to 2400 mm. The extendable telescopic cut-off stop with a maximum length of 3200 mm is equipped with two folding stops and is particularly easy to remove thanks to its eccentric quick-release clamp. The Xenia 70 is also equipped with a mitre fence that can be extended up to 1500 mm, including a folding fence. This mitre fence is available as an accessory for the other sliding table saw models.



**Additional stop for parallel cuts**

- ▶ Quick assembly on the sliding carriage
- ▶ With extendable stop up to 1000 mm and scale



**Digital displays on the cut-to-length fence**

- ▶ With three folding stops with digital display
- ▶ Position display via magnetic tape
- ▶ Only available for Xenia 60/A and Xenia 70/A with sliding carriage length 3200 or 3800 mm (extendable material roller only for Xenia 70/A)



**Stop**

- ▶ For longitudinal and mitre cuts on large workpieces on the cantilever



**Option**

**Trimming frame with CompeX device**

- ▶ Trimming frame with CompeX device for mitre cuts with automatic length compensation



- ▶ Optional **standard mitre stop**



**Option**

- ▶ Optional **mitre stop with length compensation**, the set length dimension remains constant without readjustment
- ▶ With aluminium fence 1250 mm, workpiece clamp and degree indicator

## HOLZKRAFT CASADEI PF 41 / PF 52 – Planing machines with 410 mm or 520 mm planing width and **TERSA** quick-change planing blade system

- ▶ Sturdy grey cast steel construction guarantees precision and durability
- ▶ Large planer tables made from grey cast iron
- ▶ The planing table is adjusted via a precise parallelogram system, so that the distance between the table tips and the cutterblock remains the same in every adjustment position
- ▶ The large, stable planing fence made of anodised aluminium is easy to move and can be tilted from 0° - 45°
- ▶ The inclination of the stop can be readable from the workstation
- ▶ With auxiliary stop as standard
- ▶ Large four-blade shaft, precision bearings
- ▶ Smooth running thanks to precision unit and heavy cast design
- ▶ Powerful industrial motor
- ▶ Maximum user safety with simplest operation
- ▶ Display for chip removal via scale
- ▶ Manual table adjustment
- ▶ Motor circuit switch



PF 41 Tersa

▶ 410 mm working width  
▶ With fold-down auxiliary stop for narrow workpieces

Manual quick adjustment of chip removal with scale & clamping rotary head

Model	PF 41	PF 52
Art. No.	5220041	5220052

Model	PF 41 Tersa	PF 52 Tersa
Art. No.	5220042	5220053

Model	PF 41 Spiral	PF 52 Spiral
Art. No.	5220043	on request

Technical data		
Total length of the dressing tables	2600 mm	2720 mm
Planing width	410 mm	520 mm
Dimensions of the planer fence approx.	1200 x 190 mm	1200 x 190 mm
Swivelling range of planer fence	90 - 45°	90 - 45°
Chip removal max.	8 mm	8 mm
Planing shaft Ø/Number of planing blades	120 mm /4 pcs.	120 mm /4 pcs.
Speed	5000 min <sup>-1</sup>	5000 min <sup>-1</sup>
Motor power ~50 Hz	5.0 kW / 400 V	7.0 kW / 400 V
Suction nozzle Ø	120 mm	120 mm
Weight approx.	590 kg	680 kg

Accessories PF 41	Article no.	Pc
Tersa planer blade 410 mm standard	5270411	VE 4
Tersa planer blade 410 mm HSS	5271411	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10

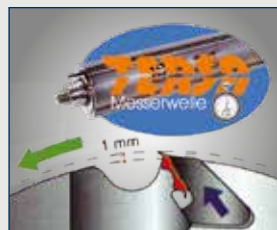
PF 52 accessory	Art. No.	Pc
Tersa planer blade 520 mm standard	5270520	VE 4
Tersa planer blade 520 mm HSS	5271520	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10



**The protective device**

► The safety guard can be folded down and has been designed so that the operator is not hindered during work and is protected at the same time

**TERSA planer blade shaft**



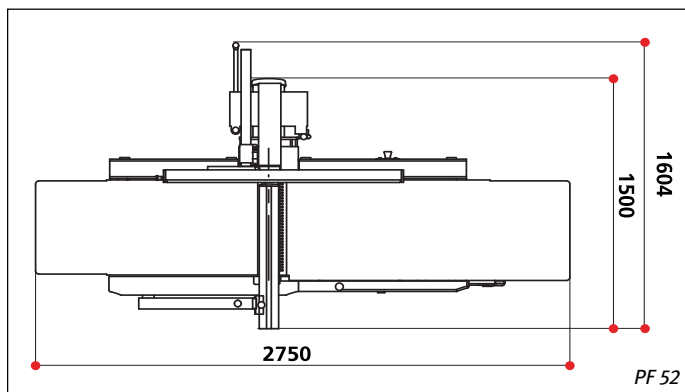
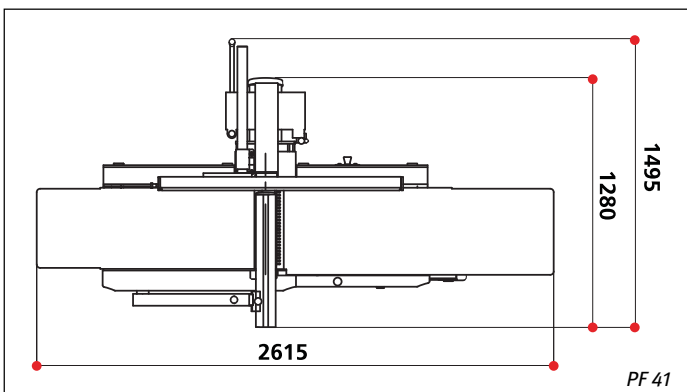
- No more adjusting and screwing
- Changing planing blades in seconds
- Self-locking
- Particularly quiet
- Perfect planing result



- 520 mm working width
- With fold-down auxiliary stop for narrow workpieces



PF 52 TERSA



**CASADEI PF 410** – Heavy-duty surface planer with 410 mm planing width

**CASADEI PF 520 M** – Surface planer with 520 mm planing width and motorised table adjustment

- ▶ Control panel above table
- ▶ Planing tables made of grey cast iron
- ▶ The planing table is adjusted via a precise precise parallelogram system, so that the distance between the table tips and the cutterblock remains the same in every adjustment position
- ▶ Large, precise cast planing fence, easy to tilt 90° - 45°
- ▶ The angle of the fence can be easily read from the operator's side.

- ▶ Comes standard with auxiliary stop for safe planing, even of narrow workpieces
- ▶ Large four-blade shaft, precision bearings
- ▶ Smooth running thanks to precision unit and heavy cast design
- ▶ Powerful industrial motor

**Additional equipment PF 520 M:**

- ▶ Extra long infeed table
- ▶ Motorised adjustment of the planing table
- ▶ Digital display for chip removal



PF 410 with optional equipment

- ▶ 520 mm working width
- ▶ With fold-down auxiliary stop for narrow workpieces

<b>Model</b>	<b>PF 410</b>	<b>PF 520 M</b>
Art. No.	5221410	5221520

<b>Model</b>	<b>PF 410 Tersa</b>	<b>PF 520 M Tersa</b>
Art. No.	5221411	5221522

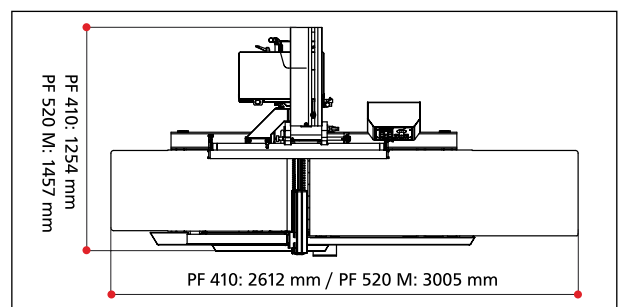
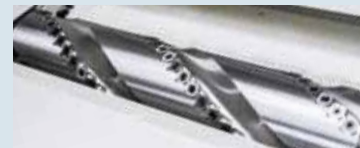
<b>Model</b>	<b>PF 410 Spiral</b>	<b>PF 520 Spiral</b>
Art. No.	on request	5221525

<b>Model</b>		<b>PF 520 M Tersa TX MATIC</b>
Art. No.		5221524

<b>Technical data</b>		
Total length of the dressing tables	2600 mm	3000 mm
Planing width	410 mm	520 mm
Dimensions of the planer fence approx.	1100 x 160 mm	1100 x 160 mm
Swivelling range of planer fence	90 - 45°	90 - 45°
Chip removal max.	8 mm	8 mm
Planing shaft Ø/Number of planing blades	120 mm / 4 pcs.	120 mm / 4 pcs.
Speed	5000 min <sup>-1</sup>	5000 min <sup>-1</sup>
Motor power 400 V/ 50 Hz	5.0 kW	5.0 kW
Suction nozzle Ø	120 mm	<b>M Tersa TX MATIC: 7.0 kW</b>
Weight approx.	605 kg	870 kg

**SPIRAL CUTTERHEAD**

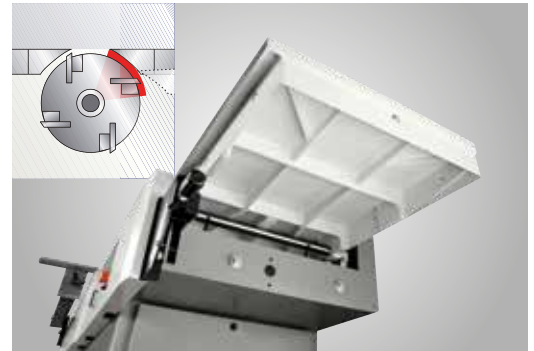
- ▶ Pulling cut, therefore lower power requirement
- ▶ Very quiet



**TERSA planer blade shaft**



- No more adjusting and screwing
- Changing planing blades in seconds
- Self-locking
- Particularly quiet
- Perfect planing result



- ▶ The planing tables made from a heavily ribbed cast construction remain permanently flat and precise
- ▶ The planing tables are adjusted using a precise parallelogram system
- ▶ This means that the distance between the table tips and the cutterblock remains the same in every adjustment position

- ▶ Control panel above table
- ▶ PF 520 M with motorised height adjustment of the infeed table and digital display of chip removal



PF 520 M Tera

- ▶ 520 mm working width
- ▶ **Motorised height** adjustment of the feed table
- ▶ **Control panel** above table
- ▶ Chip removal **digital display**
- ▶ **Incl. swivelling auxiliary fence**
- ▶ **Amplified motor 7.0 kW**
- ▶ **Longer feed table**
- ▶ **Aluminium planer fence**

Equipment options PF 410*	Art. No.
TX Matic planer shaft guard with automatic height adjustment	5256071
Slot drilling device (90 kg)	5256072
Amplified main motor 7 kW with automatic star-delta start	5256074

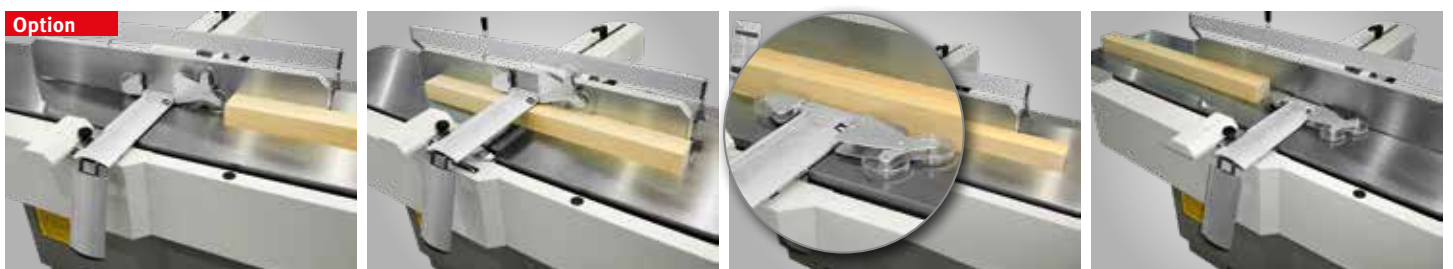
\* cannot be retrofitted, only when ordering a new machine

Accessories PF 410	Art. No.	Pc
Tersa planer blade 410 mm standard	5270411	VE 4
Tersa planer blade 410 mm HSS	5271411	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10

Equipment options PF 520 M*	Art. No.
Planing shaft protection device with automatic height adjustment TX Matic	5256075
Slot drilling device (90 kg)	5256076

\* cannot be retrofitted, only when ordering a new machine

Accessory PF 520 M	Art. No.	Pc
Tersa planer blade 520 mm standard	5270520	VE 4
Tersa planer blade 520 mm HSS	5271520	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10



**How the "TX Matic" works**

- ▶ Optional lifting device for the guard

- ▶ The preload presses the guard against the workpiece

- ▶ This means that the cutterhead is always covered, which offers greater safety

# Surface planer

## HOLZKRAFT CASADEI surface planers – Equipment options



Planing fence made of ground cast iron, 90° - 45° infinitely variable swivelling

Auxiliary stop (Series)

All control elements are centralised and easily accessible in the control panel

Machine frame can be driven under

### TERSA planer blade shaft



- No more adjusting and screwing
- Changing planing blades in seconds
- Self-locking
- Particularly quiet
- Perfect planing result



▶ Thanks to the wide contact surface, the ground cast iron joining fence enables precision machining of large and heavy workpieces.  
The side stop can be swivelled continuously up to 45°.



▶ The planing tables made from a heavily ribbed cast construction remain permanently flat and precise

▶ The planing tables are adjusted using a precise parallelogram system  
▶ This means that the distance between the table tips and the cutterblock remains the same in every adjustment position



**"TX MATIC"**  
▶ Automatically adapts to the material thicknesses  
▶ Spring-mounted system



▶ The TX-Matic protective device can be folded down. It has been designed to provide protection without hindering the operator during work.

Heavily ribbed cast tables.  
Total length 3000 mm (PF 520M)



**How the "TX MATIC" works**

▶ Optional lifting device for the guard



▶ The preload presses the guard against the workpiece



▶ This means that the cutterhead is always covered, which offers greater safety

## HOLZKRAFT CASADEI PS 52 / PS 63 - The robust craftsman machines

- ▶ Highly robust steel housing construction
- ▶ Motorised thickening table lift with two speeds
- ▶ Numerical display for working height
- ▶ Thickening table made of grey cast iron

- ▶ The thickening table is mounted on four large trapezoidal threaded spindles for maximum stability and precision
- ▶ Four feed speeds
- ▶ Optionally with two rolls in the thickness table

- ▶ Standard with noise protection and chip protection curtain at the workpiece inlet and outlet
- ▶ Adjustable roller contact pressure
- ▶ Front feed roller with helical teeth
- ▶ Pull-out roller with rubber coating
- ▶ Powerful industrial motor



- ▶ The work table is mounted on four large trapezoidal thread spindles, which ensure maximum stability under all working conditions.
- ▶ With electric table adjustment as standard
- ▶ Thanks to the special lifting device, the table position is maintained perfectly even without locking



- ▶ Helically toothed steel infeed roller for constant and even wood infeed
- ▶ Second, rubberised feed roller in the outfeed
- ▶ Solid anti-kickback devices prevent workpieces from kicking back
- ▶ 4-fold cutting shaft ensures an optimised planing pattern

Model	CASADEI PS 52	CASADEI PS 63
Art. No.	5220452	5220163
Model	CASADEI PS 52 Tersa	CASADEI PS 63 Tersa
Art. No.	5220453	5220164
Model	CASADEI PS 52 Spiral	CASADEI PS 63 Spiral
Art. No.	5220454	5220165

Technical data		
Thickening table dimensions approx.	520 x 1000 mm	630 x 1000 mm
Planing width	520 mm	630 mm
Chip removal max.	8 mm	8 mm
Working length min.	210 mm	210 mm
Working height min./max.	3.5/250 mm	3.5/300 mm
Planer shaft Ø/planer blade	120 mm / 4 pcs.	120 mm / 4 pcs.
Feed speed	5/8/12/18 m/min	5/8/12/18 m/min
Speed	4500 min <sup>-1</sup>	4500 min <sup>-1</sup>
Suction nozzle Ø	150 mm	150 mm
Motor power ~50 Hz / S6-40%	7.5 kW/ 400 V	9.0 kW/ 400 V
Weight approx.	660 kg	750 kg

- ▶ 520 mm working width
- ▶ 250 mm working height



PS 52 with optional equipment

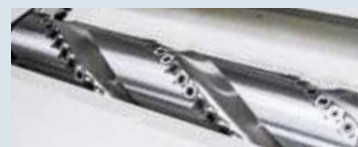
### TERSA planer blade shaft



- No more adjusting and screwing
- Changing planing blades in seconds
- Self-locking
- Particularly quiet
- Perfect planing result

### SPIRAL CUTTERHEAD

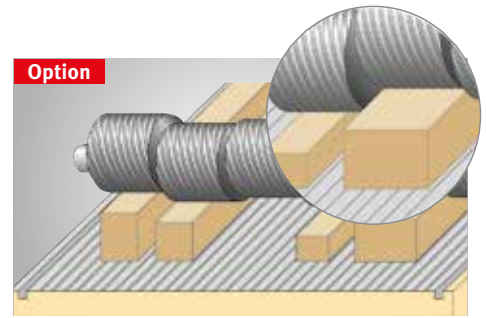
- ▶ Pulling cut, therefore lower power requirement
- ▶ Very quiet



- ▶ 630 mm working width
- ▶ 300 mm working height

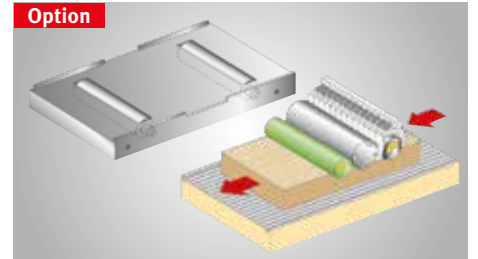


PS 63 with optional Equipment



Option

- ▶ Optionally with sectional feed roller, with which workpieces of different thicknesses can be processed simultaneously



Option

- ▶ Optionally with two rollers in the thicknessing table for easier feeding
- ▶ The adjustable contact pressure of the rollers, the selectable feed speed and the feed roller with helical teeth ensure an optimum feed rate for every type of wood, even with heavy chip removal



Option

Option two rollers in the thickness table



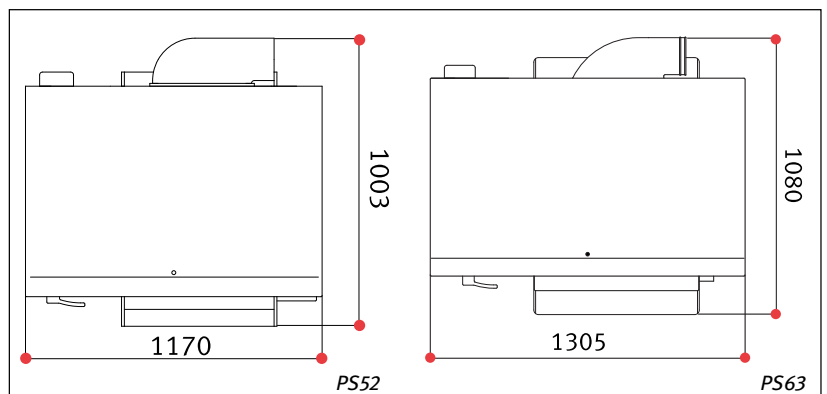
Option

Option 3. Feed roller with rubber coating

Equipment options*	Art. No.
Steel sectional feed roller PS 52	5230402
Additional rubber pull-out roller, motorised in third position PS 52	5230403
Two rollers in the thickness table PS 52	5230404
Amplified main motor 9 kW (12HP) with automatic star-delta start for PS 52	5230408
Steel sectional feed roller PS 63	5230405
Additional rubber pull-out roller motorised in third position PS 63	5230406
Two rollers in the thickness table PS 63	5230407

\* cannot be retrofitted, only when ordering a new machine

Accessory	Art. No.	Pc
Tersa planer blade 520 mm standard	5270520	VE 4
Tersa planer blade 520 mm HSS	5271520	VE 4
Tersa planer blade 630 mm standard	5270620	VE 4
Tersa planer blade 630 mm HSS	5271620	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10



## HOLZKRAFT CASADEI PS 520 / PS 630 –

For the highest demands with comfortable equipment

- ▶ Highly robust steel housing construction
- ▶ Motorised thickening table lift with two speeds and digital display
- ▶ The tables are made of ribbed grey cast iron
- ▶ 4 feed speeds
- ▶ Stepless feed speed adjustment from 4-20 m/min with PS 630
- ▶ Standard with noise protection and chip protection curtain at the workpiece inlet and outlet
- ▶ Precisely adjustable roller contact pressure
- ▶ Feed roller easy to replace
- ▶ Helicolly toothed steel infeed roller for constant and even wood infeed
- ▶ Pull-out roller with rubber coating
- ▶ Solid anti-kickback devices prevent workpieces from kicking back
- ▶ 4-fold cutting shaft ensures an optimised planing pattern
- ▶ Powerful industrial motor



PS 520 with optional equipment

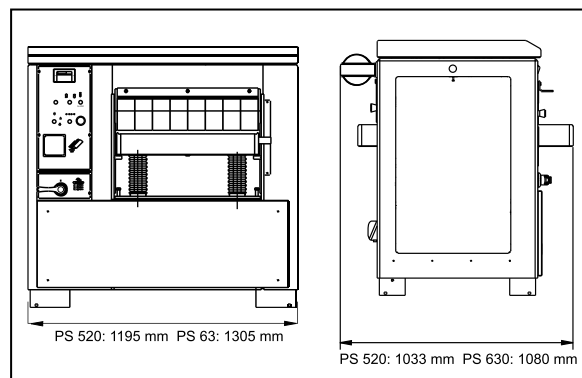


- ▶ The work table is mounted on four large trapezoidal thread spindles, which ensure maximum stability under all working conditions.
- ▶ With electric table adjustment as standard
- ▶ Thanks to the special lifting device, the table position is maintained perfectly even without locking

Model	PS 520	PS 630
Art. No.	5221521	5221630
Model	PS 520 Tersa	PS 630 Tersa
Art. No.	5221523	5221632
Model	PS 520 Spiral	PS 630 Spiral
Art. No.	on request	5221635
Technical data		
Thickening table dimensions approx.	530 x 900 mm	640 x 1000 mm
Planing width	520 mm	630 mm
Chip removal max.	8 mm	8 mm
Working length min.	220 mm	260 mm
Working height min./max.	3.5/300 mm	3.5/300 mm
Planing shaft Ø / Number of planing blades	120 mm / 4 pcs.	120 mm / 4 pcs.
Feed speed	5/8/12/18 m/min	Stepless, 4-20
Speed	4500 min <sup>-1</sup>	4500 min <sup>-1</sup>
Suction nozzle diameter	150 mm	150 mm
Motor power ~50 Hz / S6-40%	7.0 kW / 400V	9.0 kW / 400 V
Weight approx.	695 kg	810 kg

### SPIRAL CUTTERHEAD

- ▶ Pulling cut, therefore lower power requirement
- ▶ Very quiet



**TERSA planer blade shaft**



- No more adjusting and screwing
- Changing planing blades in seconds
- Self-locking
- Particularly quiet
- Perfect planing result



**Option:** Electronic thicknessing table positioning via keypad with incremental and pocket calculator function



- ▶ Solid steel anti-kickback devices
- ▶ Helical steel feed roller and sectional pressure beam
- ▶ Rubber-coated pull-out roller
- ▶ The rollers are easy to replace

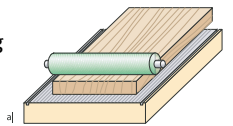


**Fig. shows option "Pneumatic pressure setting of the upper feed rollers" for PS 630**

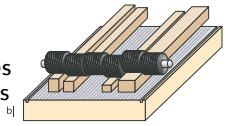


**Option:** 3. Feed roller with rubber coating

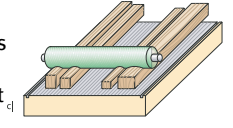
**a)Option:** First roller rubberised for machining sensitive workpieces; for PS 630 only



**b)Option:** Steel sectional feed roller for processing workpieces with different thicknesses



**c)Option:** First roller made of two rubber compounds for processing sensitive workpieces with different thicknesses



*PS 630 with optional equipment*

Equipment options PS 520*	Art. No.
Steel sectional feed roller	5256077
Two rollers in the thickness table	5256078
Additional, motorised rubber pull-out roller in third position	5256079
Electronic thickness table positioning with incremental function for calculating the thickness adjustment and calculator function	5256081
Amplified main motor 9 kW (12 HP) with automatic star-delta start	5256082

Accessories PS 520	Art. No.	Pc
Tersa blade 520 mm standard	5270520	VE 4
Tersa blade 520 mm HSS	5271520	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10

Equipment options PS 630*	Art. No.
Steel sectional feed roller	5256034
Rubber feed roller (instead of the standard steel feed roller)	5256035
Two rollers in the thickness table	5256036
Additional, motorised rubber pull-out roller in third position	5256037
Feed roller made of two rubber compounds, as an alternative to the sectional feed roller	5256038
Pneumatic pressure adjustment on feed roller instead of spring pressure	5256083
Electronic thickness table positioning with incremental function for calculating the thickness adjustment and calculator function	5256040
Table extension (630 x 1200 mm) <b>New</b>	5258192

Accessories PS 630	Art. No.	Pc
Tersa blade 630 mm standard	5270620	VE 4
Tersa blade 630 mm HSS	5271620	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10

\* cannot be retrofitted, only when ordering a new machine

# Combination planer-thicknesser



## HOLZKRAFT CASADEI PFS 520 – Planer-thicknesser with 520 mm planing width, motorised thickening table adjustment and comfort adjustment

- ▶ Sturdy grey cast steel construction
- ▶ Large, ribbed planer tables made from grey cast iron
- ▶ Smooth running due to high dead weight
- ▶ Four feed speeds
- ▶ Motorised thickening table lift with two speeds and digital display
- ▶ Sectional pressure bar in the inlet
- ▶ 4-blade shaft, precision bearings

- ▶ Helical toothed steel feed roller for particularly even and gentle wood feed
- ▶ Pull-out roller with rubber coating
- ▶ Large planing fence, tilttable 90°- 45°
- ▶ With auxiliary stop as standard
- ▶ Powerful industrial motor
- ▶ Pneumatic quick changeover system with pneumatic lifting and lowering of the planing

- ▶ table
- ▶ The connection position of the extraction unit is always in the same place for both surface planing and thickening, so no additional extraction hose or awkward repositioning and guiding around the machine is necessary



- ▶ Dual folding of the work tables for even shorter set-up times and maximum user safety
- ▶ Pneumatic quick changeover system with pneumatic lifting and lowering of the planer table and automatic closing of the planing shaft cover
- ▶ Particularly convenient, time-saving and safe



Fig. with optional equipment

### SPIRAL CUTTERHEAD

- ▶ Pulling cut, therefore lower power requirement
- ▶ Very quiet

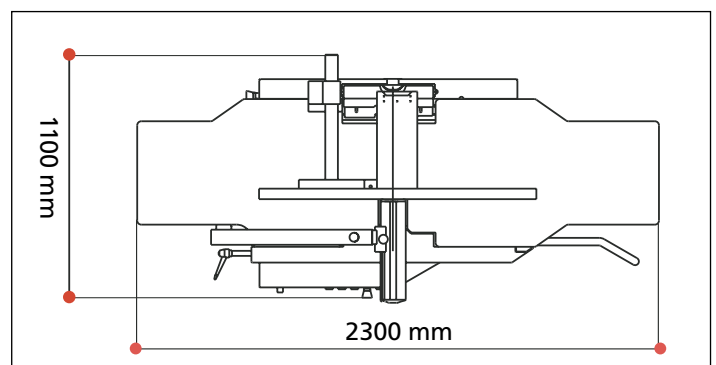


<b>Model</b>	<b>PFS 520</b>
Art. No.	5221631

<b>Model</b>	<b>PFS 520 Tersa</b>
Art. No.	5221633

<b>Model</b>	<b>PFS 520 Spiral</b>
Art. No.	5221634

Technical data	
Total length of the dressing tables	2300 mm
Table length	1200 mm
Planing width	520 mm
Dimensions of the planer fence approx.	1200 x 190 mm
Swivelling range of planer fence	90 - 45°
Planing height min./max.	3.5/250 mm
Planing shaft Ø/Number of planing blades	120 mm /4 pcs.
Feed speed	5/8/12/18 m/min
Speed	5000 min <sup>-1</sup>
Motor power ~50 Hz / S6-40%	7.0 kW/ 400 V
Suction nozzle diameter	120 mm
Weight approx.	980 kg



**TERSA planer blade shaft**



- No more adjusting and screwing
- Changing planing blades in seconds
- Self-locking
- Particularly quiet
- Perfect planing result

**Option**



- ▶ **Option PFS 520:** Electronic thickness table positioning via keyboard with incremental and calculator function



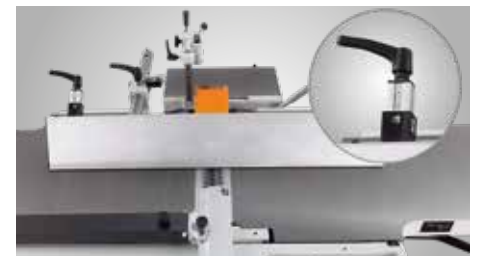
*Fig. with optional equipment*



- ▶ Helically toothed steel infeed roller for constant and even wood infeed
- ▶ Rubber roller in the outlet
- ▶ Massive anti-kickback devices
- ▶ 4-fold cutting shaft ensures an optimised planing pattern



- ▶ The planing table is adjusted using a precise parallelogram system, ensuring that the distance between the table tips and the cutter shaft remains the same in every adjustment position.



- ▶ The sturdy aluminium joining stop is anodised as standard, easy to move and offers a generous support surface
- ▶ The adjustable inclination of 90° to 45° is easy to read from the workstation
- ▶ Comes standard with auxiliary stop for safe planing, even of narrow workpieces

Equipment options PFS 520*	Art. No.
Electronic thickening table positioning with incremental function and calculator function	5256085
Two rollers in the thickness table	5256089
Steel sectional feed roller	5256090
Amplified motor 9 kW with automatic star-delta start-up	5256092

\* cannot be retrofitted, only when ordering a new machine

Accessory	Art. No.	Pc
Tersa blade 520 mm standard	5270520	VE 4
Tersa blade 520 mm HSS	5271520	VE 4
Spare blade set for spiral cutterhead 15 x 15 x 2.5 mm	5514127	VE 10

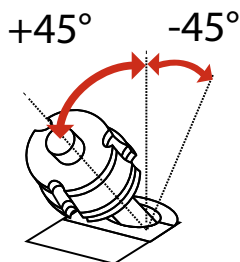
## HOLZKRAFT CASADEI F 25 – Table routers with swivelling router spindle from +45° to -45° and MT4 interchangeable spindle

- ▶ 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<sup>-1</sup>

- ▶ 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



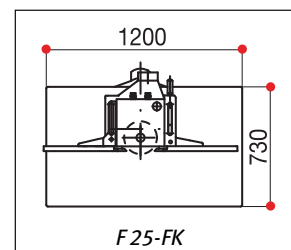
Can be swivelled on 2 sides



F25 LL-FK



F25-FK



F25-FK

Model		CASADEI F 25-FK	CASADEI F 25 LL-FK	CASADEI F 25 M LL-FK
Art. No.		5220729	5220728	5220730
<b>Technical data</b>				
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 <sup>(1)</sup> / 180 <sup>(2)</sup>		
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 <sup>-1</sup>	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.



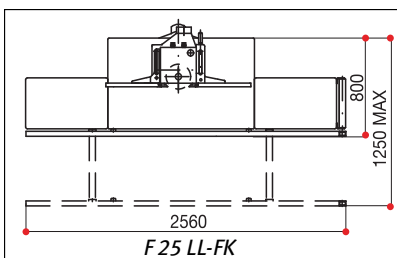
**Milling fence with crank adjustment**

- ▶ Convenient operation
- ▶ Fast and precise adjustment



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

Motorised height adjustment and swivelling 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

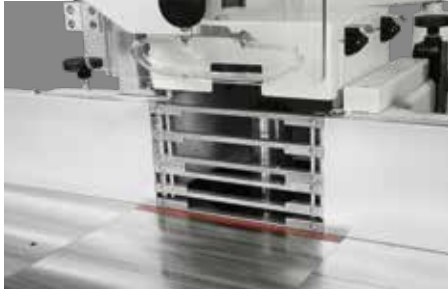
**Accessory**



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

**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<sup>-1</sup> 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<sup>-1</sup> 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<sup>-1</sup>
- ▶ 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



<b>Model</b>	<b>F 255 A2</b>
Art. No.	5222102

<b>Model</b>	<b>F 255 A3</b>
Art. No.	5222103

<b>Model</b>	<b>F 255 A3 PL</b>
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 <sup>(1)</sup> / 180 mm <sup>(2)</sup>
Milling spindle stroke	130 mm
Profiling tool Ø max.	250 mm
Tenon tool Ø max.	300 mm <sup>(1)</sup> / 350 mm <sup>(2)</sup>
Form milling tool Ø max.	160 mm
Tool Ø can be lowered max.	300 x 80 mm
Speeds, infinitely variable	900– 12000 min <sup>-1</sup>
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:

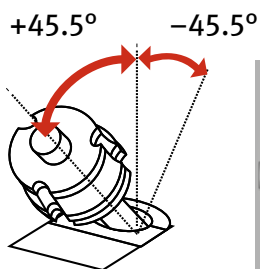
- ▶ With table extension on the right and left and extendable workpiece support at the front
- ▶ Material roll right
- ▶ Total width 2540 mm



You can find suitable feeders on pages 34/35.



F 255 A3 PL



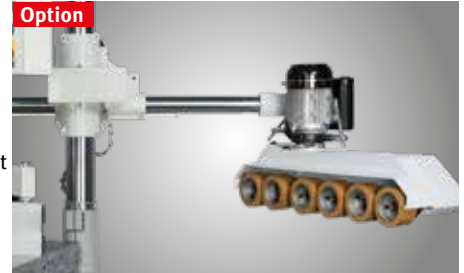
**Swivelling interchangeable spindle**

- ▶ 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)



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)

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)



**Equipment options F 255<sup>(3)</sup>**

Equipment options F 255 <sup>(3)</sup>	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 <b>A version</b> ; PL or TPL required)	5256206
Swivelling device for milling fence (standard with <b>A-3</b> )	5256208
Stand for feed unit on the control panel column (only for A version)	5256209
Motorised stand for feed unit ( <b>only for A</b> )	5256210
Integral stop both halves each 500 mm long with sensor monitoring for F 255 A3 PL <b>Neu</b>	5855020
Integral stop both halves each 650 mm long with sensor monitoring for F 255 A3 PL <b>Neu</b>	5855021
Surcharge "HSK" version, with HSK B 63 quick-change system, incl. 1 mould carrier and blowing nozzles	5256214

**Accessory**

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 ( <b>series for A-3</b> ; 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

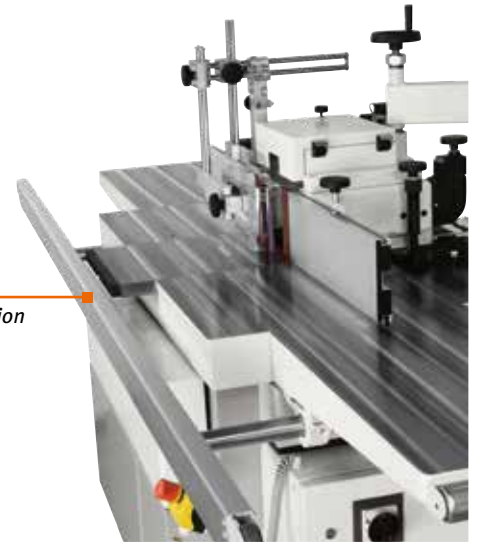
(3) cannot be retrofitted, only when ordering a new machine

# 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<sup>-1</sup>, e.g. for fine sanding work



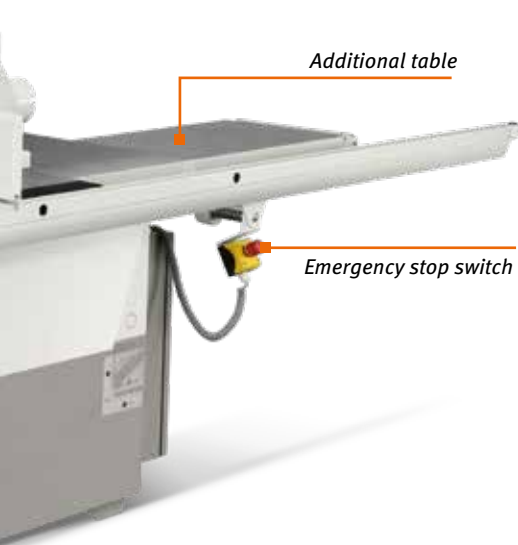
### Milling unit

- ▶ The large-dimensional 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

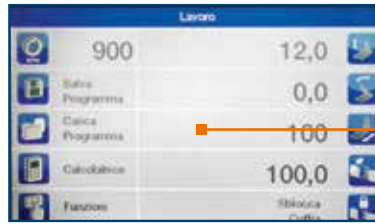
## HOLZKRAFT CASADEI table routers – Equipment and operation

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<sup>-1</sup> optional for F 235 A
- ▶ F 255 A with electrospindle infinitely variable from 900 - 12000 min<sup>-1</sup>

*Setting the speed for machines without N.C. Control*



F 255 A

### 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 (+/- 45.5° 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  $-60^{\circ}$  to  $+60^{\circ}$
- ▶ Tool diameter max. 250 mm
- ▶ With splinter wood and eccentric clamp

# Feed devices

## VSA 2032 / VSA 2038L / VSA 2048L

### Feed devices for table routers. Proven quality

- ▶ Consistent feed speed without loss of power
- ▶ Clockwise and anti-clockwise rotation
- ▶ Includes tripod, individually swivelling and adjustable for horizontal and vertical use
- ▶ Speeds infinitely adjustable via rotary knob
- ▶ Speed transmission through conical pulley belt drive



### VSA 2032



### VSA 2038L



### VSA 2048L



#### Accessories VSA 2032 Article no.

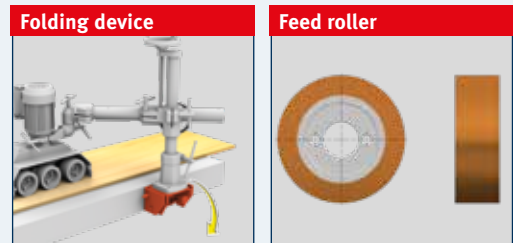
Folding device	5119510
Feed roller Ø80mm (width 28 mm)	5119520

#### VSA accessories 2038L / VSA 2048L Article no.

Folding device	5119511
Feed roller Ø120mm (width 60 mm) 50 Shore	5119525
Spare roller Ø120mm (width 60 mm) 50 Shore without rim	5119526
Feed roller Ø120mm (width 60mm) 40 Shore for smooth surfaces	5119527
Feed roller Ø118mm (width 50mm) 65 Shore for rough surfaces	5119528

#### Tripod accessories Article no.

Tripod 1050	5119500
Tripod 1050 PLUS	5119505
EASY joint (except VSA 400DC)	5119509



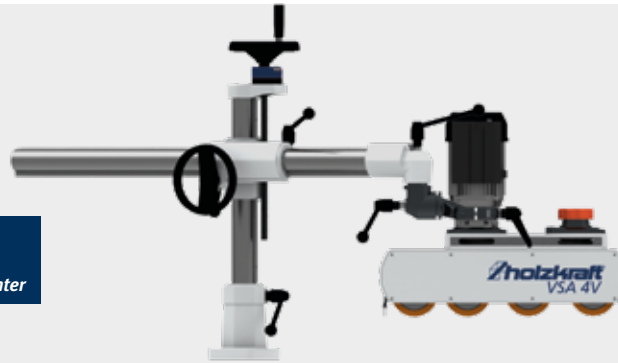
Model		VSA 2032	VSA 2038L	VSA 2048L
Article no.		5119032	5119038	5119048
<b>Technical data</b>				
max. radius	mm	660		1050
Number of feed rollers	Pc	3	3	4
Roller diameter	mm	80		120
Roller width	mm	28		60
Spring travel of the rollers	mm	15		20
speeds	m/min	4/8/9/18 (4 stages)	2/4/5.5/6.5/11/13/16.5/33 (8 stages)	
Motor power ~50 Hz	W/V	180 / 400		750 / 400
Dimensions (L x W x H) approx.	mm	1222 x 152 x 566	1523 x 220 x 540	1665 x 220 x 540
Weight approx.	kg	32.5	69.5	73.5

## VSA 4V / VSA 4V DC / VSA 400 DC

### Feed devices with infinitely variable speed control

- ▶ Consistent feed speed without loss of power
- ▶ Speeds Infinitely adjustable via rotary knob
- ▶ Speed transmission through conical pulley belt drive
- ▶ Clockwise and anti-clockwise rotation

### VSA 4V

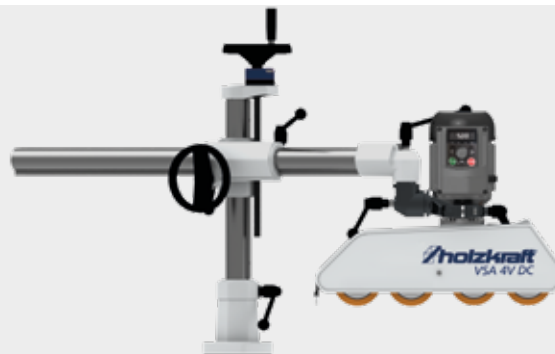


**Tripod 1050 PLUS**  
with high-quality  
clamping levers and counter

**Four rollers**

**Stepless**  
adjustable via rotary knob

### VSA 4V DC



**Tripod 1050 PLUS**  
with high-quality  
clamping levers and counter

**Four rollers**

**Stepless**  
adjustable via rotary knob  
and digital display

### VSA 400DC



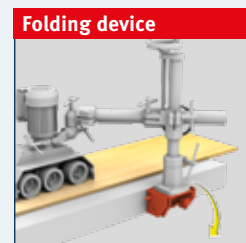
**Tripod 1050 PLUS**  
with high-quality  
clamping levers and counter

**Tripod**

**Four rollers**

**Stepless**  
adjustable via rotary knob

Accessory	Article no.
Folding device	5119511
Feed roller Ø120mm (width 60 mm) 50 Shore	5119525
Spare roller Ø120mm (width 60 mm) 50 Shore without rim	5119526
Feed roller Ø120mm (width 60mm) 40 Shore for smooth surfaces	5119527
Feed roller Ø118mm (width 50mm) 65 Shore for rough surfaces	5119528
Tripod accessories	Article no.
Tripod 1050	5119500
Tripod 1050 PLUS	5119505
EASY joint (except VSA 400DC)	5119509



Model	VSA 4V	VSA 4V DC	VSA 400 DC
Article no.	5119104**	5119114	5110403
<b>Technical data</b>			
max. radius	mm	1050	
Number of feed rollers	Pc	4	4
Roller diameter	mm	120	
Roller width	mm	60	
Spring travel of the rollers	mm	20	18
speeds	m/min	3 - 18 stepless, mechanical	0.5 - 25 stepless, electronic
Motor power ~50 Hz	W/V	750 / 400	750 / 400
Dimensions (L x W x H) approx.	mm	1670 x 206 x 540	643 x 245 x 315
Weight approx.	kg	75.5	67.5

## VSA 2038 L PLUS / VSA 2048 L PLUS

### Feed devices with 1050 PLUS tripod, high-quality clamping levers and counter

- ▶ Consistent feed speed without loss of power
- ▶ Includes tripod, individually swivelling and adjustable for horizontal and vertical use
- ▶ Speeds infinitely adjustable via rotary knob
- ▶ Speed transmission through conical pulley belt drive
- ▶ Clockwise and anti-clockwise rotation

### VSA 2038L PLUS

*Tripod 1050 PLUS  
with high-quality  
clamping levers and counter*



*Three rolls*

*Eight speeds*

### VSA 2048L PLUS

*Tripod 1050 PLUS  
with high-quality  
clamping levers and counter*

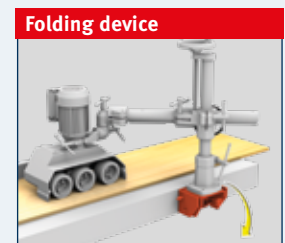


*Four rollers*

*Eight speeds*

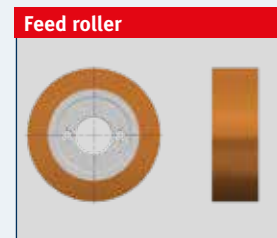
Accessory	Article no.
Folding device	5119511
Feed roller Ø120mm (width 60 mm) 50 Shore	5119525
Spare roller Ø120mm (width 60 mm) 50 Shore without rim	5119526
Feed roller Ø120mm (width 60mm) 40 Shore for smooth surfaces	5119527
Feed roller Ø118mm (width 50mm) 65 Shore for rough surfaces	5119528

Tripod accessories	Article no.
Tripod 1050	5119500
Tripod 1050 PLUS	5119505
EASY joint	5119509



Model	VSA 2038L Plus	VSA 2048L Plus
Article no.	5119039	5119049

Technical data		VSA 2038L Plus	VSA 2048L Plus
max. radius	mm	1050	
Number of feed rollers	Pc	3	4
Roller diameter	mm	120	
Roller width	mm	60	
Spring travel of the rollers	mm	20	
Speed settings (8)	m/min	2/4/5.5/6.5/11/13/16.5/33	
Motor power ~50 Hz	W/V	750 / 400	
Dimensions (L x W x H) approx.	mm	1523 x 220 x 540	1665 x 220 x 540
Weight approx.	kg	71.5	75.5





## VSA 2038 L EASY / VSA 2048 L EASY

### Feed units with eight speeds and patented EASY joint

- ▶ Consistent feed speed without loss of power
- ▶ Includes EASY tripod with patented joint - no more double adjustment necessary
- ▶ Eight speeds possible, speed selection via switch and change gearbox
- ▶ Clockwise and anti-clockwise rotation

### VSA 2038 L EASY

**Tripod 1050 EASY**  
facilitates and speeds up the handling



**Three rolls**  
**Eight speeds**

### VSA 2048 L EASY

**Tripod 1050 EASY**  
facilitates and speeds up the handling



**Four rollers**  
**Eight speeds**

### TRIPOD 1050 EASY

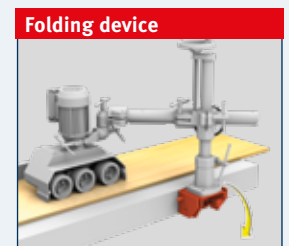
- ▶ Fast and simple operation
- ▶ Patented joint
- ▶ No more double setting necessary
- ▶ Adjust the position of the feed unit conveniently and fix it in place with just one clamping lever
- ▶ Counter for precise height adjustment
- ▶ Maximum throat depth 1050 mm
- ▶ Dimensions (L x W) approx. 1050 x 540 mm
- ▶ Weight approx. 44 kg



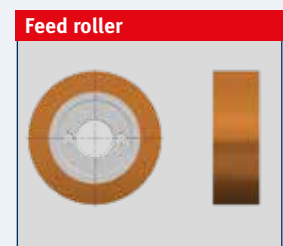
**Security without compromise**  
• The locking mechanism prevents unintentional movement of the feed unit and ensures accident-proof positioning.

Accessory	Article no.
Folding device	5119511
Feed roller Ø120mm (width 60 mm) 50 Shore	5119525
Spare roller Ø120mm (width 60 mm) 50 Shore without rim	5119526
Feed roller Ø120mm (width 60mm) 40 Shore for smooth surfaces	5119527
Feed roller Ø118mm (width 50mm) 65 Shore for rough surfaces	5119528

Tripod accessories	Article no.
Tripod 1050 Easy	5119501
EASY joint	5119509



Model		VSA 2038 L EASY	VSA 2048 L EASY
Article no.		5119040	5119050
<b>Technical data</b>			
max. radius	mm		1050
Number of feed rollers	mm	3	4
Roller diameter	mm		120
Roller width	mm		60
Spring travel of the rollers	mm		20
Speed settings (8)			2 - 33
Speed levels	m/min		2 / 4 / 5,5 / 6,5 / 11 / 13 / 16,5 / 33
Drive motor power ~ 50 Hz	kW/V		0.75 / 400
Dimensions (L x W x H) approx.	mm	1524 x 220 x 540	1665 x 220 x 540
Weight approx.	kg	71.5 including tripod	75.5 including tripod





## Clean air deduster RLA 125 / 140 / 160 / 210 for wood chips, designed for commercial use

- ▶ Clean air deduster of this series dust-tested to H3, residual dust content less than 0.1 mg/m<sup>3</sup>
- ▶ **Not suitable for sanding dust!**
- ▶ High extraction performance with low space requirements
- ▶ Maximum performance in this class
- ▶ Very quiet
- ▶ All models with collision protection

### Area of application

- ▶ Extraction of wood chips
- ▶ Commercial use
- ▶ For all woodworking machines with the corresponding extraction nozzle diameter

### High-quality, well thought-out design

- ▶ Robust and compact housing made of galvanised sheet steel
- ▶ Suction nozzle can be easily converted from left to right for flexible use
- ▶ Large inspection openings
- ▶ Large, mobile chip container with clamping bracket and chip collection bag
- ▶ Deduster already fully assembled on delivery, so can be used quickly
- ▶ All models mobile
- ▶ **For model RLA 210:** Optimum chip distribution in the chip container due to large filter surface

### Description of the filter

- ▶ Ultra compact with maximum filter area
- ▶ Filter material made of polyester fleece, aluminium-coated, washable and therefore with a long service life
- ▶ Antistatic filter tested and approved to category M-BIA as standard
- ▶ Filter resistance monitoring via differential pressure box, adjustable with warning light on the control box
- ▶ The fan is connected downstream of the filter



RLA 125



RLA 140



All devices in this series are dust-tested to H3, residual dust content below 0.1 mg/m<sup>3</sup>

Model	RLA 125	RLA 140	RLA 160	RLA 210
Art. No.	5131255	5131400	5131620	5132100
Model	RLA 125 M	RLA 140 M	RLA 160 M	RLA 210 M
Art. No.	5131256	5131401	5131621	5132105
Model	RLA 125 PM	RLA 140 PM	RLA 160 PM	RLA 210 PM
Art. No.	5131257	5131402	5131622	5132110

Technical data	RLA 125	RLA 140	RLA 160	RLA 210
Nominal suction nozzle size outside	125 mm	140 mm	160 mm	200 mm
Nominal volume flow	884 m <sup>3</sup> /h	1108 m <sup>3</sup> /h	1448 m <sup>3</sup> /h	2262 m <sup>3</sup> /h
Volume flow max.	1400 m <sup>3</sup> /h	1750 m <sup>3</sup> /h	2400 m <sup>3</sup> /h	3700 m <sup>3</sup> /h
Negative pressure at Vnominal	2210 Pa	2615 Pa	2247 Pa	2482 Pa
Filter area	5.31 m <sup>2</sup>	8.5 m <sup>2</sup>	9.21 m <sup>2</sup>	22 m <sup>2</sup>
Filter material	Dust class M	Dust class M	Dust class M	Dust class M
Residual dust content	H3 (< 0.1 mg/m <sup>3</sup> )	H3 (< 0.1 mg/m <sup>3</sup> )	H3 (< 0.1 mg/m <sup>3</sup> )	H3 (< 0.1 mg/m <sup>3</sup> )
Chip collection volume	1x165 (239) l	1x165 (239) l	2x165 (193) l	2x165 (193) l
Max. sound pressure level	71 dB(A)	71 dB(A)	73 dB(A)	72 dB(A)
Dimensions (L x W x H) approx.	1241 x 830 x 1553 mm	1241 x 830 x 1700 mm	1755 x 830 x 1654 mm	1755 x 830 x 1800 mm
Axis suction nozzle to floor	850 mm	850 mm	827 mm	826 mm
Motor power IE3	2.2 kW	2.2 kW	2.2 kW	3.0 kW
Mains voltage ~ 50 Hz	400V	400V	400V	400V
Weight approx. – / M / PM	205 / 215 / 210 kg	210 / 210 / 210 kg	260 / 287 / 274 kg	259 / 235 / 289 kg

**BAFA**  
FEDERAL OFFICE FOR ECONOMIC AFFAIRS  
AND EXPORT CONTROL  
\* only valid in Germany

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Contact: (09 51) 96 555-505 [beratung@holzkraft.de](mailto:beratung@holzkraft.de)



RLA 160



With innovative locking device for secure container positioning

- > Small footprint
- > Ultra compact with max. filter area 22.0 m<sup>2</sup>
- > Maximum performance in this class
- > Optimum chip distribution

Model	Basic equipment	M equipment	PM equipment
	RLA 125 (5131255) RLA 140 (5131400) RLA 160 (5131620) RLA 210 (5132100)	RLA 125 M (5131256) RLA 140 M (5131401) RLA 160 M (5131621) RLA 210 M (5132105)	RLA 125 PM (5131257) RLA 140 PM (5131402) RLA 160 PM (5131622) RLA 210 PM (5132110)
<b>Equipment</b>			
Metal fan wheel	S	S	S
Inspection opening for cleaning the bypass filter	S	S	S
Connection cable 5 m with 5-pin CEE plug and phase inverter	S	S	S
Two fixed and two swivel rollers with parking brake	S	S	S
Pre-equipment for connecting machine detection for up to eight machines and gate valve controls	○	S	S
Machine detection for up to eight machines and gate valve controls	○	Z	Z
Machine detection for up to eight machines and automatic gate valve control for up to eight electromagnetic or electric gate valves in 230 V incl. external connection box	○	Z	Z
Machine detection via potential-free contact	○	○	S
Manual dedusting	S	S	○
Pneumatic cleaning (compressed air connection via standard plug, working pressure 4 - 6 bar)	○	○	S
Silencer	Z	Z	Z
Briquetting press as retrofit kit (not available for RLA 140)	Z	Z	Z

S = standard equipment / ○ = not available / Z = available as an accessory (see accessories table)

Accessories	RLA 125	RLA 140	RLA 160	RLA 210	Art. No.
Set of PVC chip bags RLA (PU = 12 pcs.)	x	x	x	x	5141212
Bypass filter RLA	x	x	x	x	5141215
Filter cassette small 3.9 m <sup>2</sup>			x	x	5141606
Large filter cassette 5.31 m <sup>2</sup>	x		x		5141213
Filter cassette 8.5 m <sup>2</sup>		x	x		5141214
Filter cassette 22 m <sup>2</sup>				x	5141221
Silencer	x	x	x		5140020
PU flexible hose-Ø 125 mm, 10 metres <sup>(1)</sup>	x				5142509
PU flexible hose-Ø 140 mm, 10 metres <sup>(1)</sup>		x			5142505
PU flexible hose-Ø 160 mm, 10 metres <sup>(1)</sup>			x		5142507
PU flexible hose-Ø 200 mm, 10 metres <sup>(1)</sup>				x	5142508

Accessories suitable for models M and PM	RLA 125	RLA 140	RLA 160	RLA 210	Art. No.
Machine detection for up to 8 machines via transducer coils incl. external connection box for independent wall mounting <sup>(2)</sup>		x	x	x	5132401
Converter coil for machine detection <sup>(3)</sup>		x	x	x	5132410
Machine detection for up to 8 machines via transducer coils and automatic gate valve control for up to 8 electro-pneumatic or electric gate valves in 230 V incl. external terminal box for independent wall mounting		x	x	x	5132403

(1) flame-retardant in accordance with DIN 4102, available in lengths of 2.5 / 5.0 / 7.5 and 10.0 m  
 (2) Transducer coils not included in the scope of delivery  
 (3) Can only be used in conjunction with art. no. 5132401

## RLA 1601P - 3001P

### Clean air deduster tested for economical and convenient air purification

- ▶ For use in workshops with a simultaneity factor of 1-2 machines, from RLA 2501 2-3 machines (depending on the required volume flow) or as a decentralised extraction unit to supplement an existing stationary system
- ▶ For use with a wide variety of materials - also suitable for dry aluminium chips
- ▶ Tested by the employers' liability insurance association
- ▶ 100% air recirculation without additional costs and structural effort
- ▶ Ready-to-connect delivery
- ▶ High suction power
- ▶ Low costs for pipe components and installation, especially when replacing old and no longer approved systems
- ▶ Integrated pre-separation chamber to reduce the load and protect the filters
- ▶ Compact dimensions, allowing the devices to be installed in previously unused areas
- ▶ Intake side can be ordered with orientation to the left or right, thus also enabling the use of workshop niches
- ▶ Control system can be expanded using "plug-in" technology
- ▶ For installation in workrooms, the regulations of the wood trade association GS-HM-03 are taken into account
- ▶ **From model RLA 2501 P onwards** with integrated, maintenance-free automatic extinguishing system tested in accordance with GS-HM-03 with pressure diaphragm, for which no additional G1/4" compressed air connection and no direct water connection are required.
- ▶ Optimal filter cleaning during operation (RLA 1601P-2001P) and during downtime after the minimum operating time has been reached



RLA 1601 P



RLA 2001 P



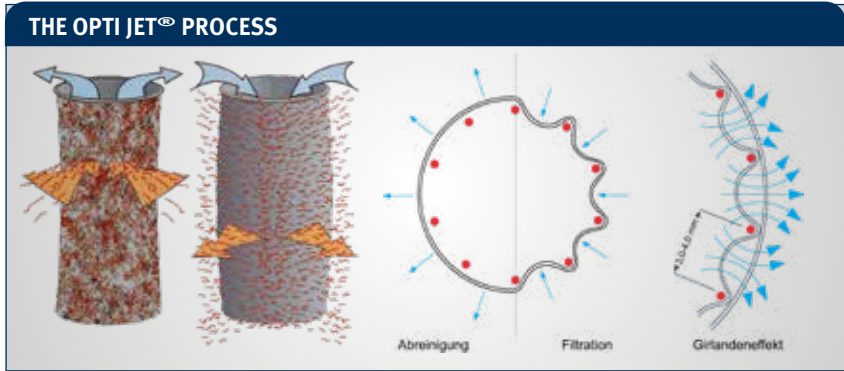
RLA 2501 P



All devices in this series are dust-tested to H3, residual dust content below 0.1 mg/m<sup>3</sup>

**Also for dry aluminium chips suitable!**

Model	RLA 1601 P	RLA 2001 P	RLA 2501 P	RLA 3001 P
Art. No.	5131612	5132011	5132501	5133001
<b>Technical data</b>				
Suction nozzle	160 mm	200 mm	250 mm	300 mm
Nominal volume flow	1448 m <sup>3</sup> /h	2262 m <sup>3</sup> /h	3534 m <sup>3</sup> /h	5089 m <sup>3</sup> /h
Volume flow max.	2000 m <sup>3</sup> /h	3010 m <sup>3</sup> /h	4900 m <sup>3</sup> /h	6000 m <sup>3</sup> /h
Negative pressure	2503 Pa	2563 Pa	3184 Pa	2587 Pa
Filter area	9.1 m <sup>2</sup>	13.8 m <sup>2</sup>	22.4 m <sup>2</sup>	30 m <sup>2</sup>
Residual dust content	< 0,1 mg/m <sup>3</sup>	< 0,1 mg/m <sup>3</sup>	< 0,1 mg/m <sup>3</sup>	< 0,1 mg/m <sup>3</sup>
Filter cleaning	Compressed air	Compressed air	Compressed air	Compressed air
Filter category	M	M	M	M
Chip collection volume	1 x 165 (24(1) l	2 x 165 (24(1) l	2 x 165 (250) l	3 x 165 (250) l
Sound pressure level	70 dB(A)	72 dB(A)	71 dB(A)	71 dB(A)
Rated motor power ~50 Hz	2.2 kW / 400 V	3.0 kW / 400 V	7.5 kW / 400 V	7.5 kW / 400 V
Dimensions (L x W x H) approx.	1716 x 830 x 2050 mm	2296 x 830 x 2050 mm	2351 x 1058 x 2351 mm	3050 x 1058 x 2361 mm
Weight approx.	340 kg	460 kg	758 kg	838 kg



· Cleaning is carried out by compressed air pulses, which clean the filter from the inside out. The resulting mechanical deformation of the filters optimises the degree of regeneration in the event of heavy soiling.



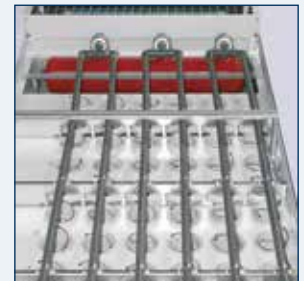
RLA 3001 P




· From model RLA 2501 P with integrated automatic extinguishing system tested in accordance with GS-HO-07

Accessories

	RLA 1601 P	RLA 2001 P	RLA 2501 P	RLA 3001 P	Art. No.
Machine detection for up to 8 machines via transducer coils and automatic valve control for up to 8 electro-pneumatic or electric shut-off valves in 230 V or 24 V, including external connection box for independent wall mounting.	x	x	x	x	5132403
Machine detection for up to four machines via transducer coils or potential-free contact and automatic valve control for up to four electro-pneumatic shut-off valves	x	x			
▶ Integrated in dust extractor control (max. 2 pieces), for 24V					5132417
▶ External connection box for independent wall mounting	x	x	x	x	5132418
Machine detection for eight to 16 processing machines via transducer coils or potential-free contact and automatic slide valve control for eight to 16 electro-pneumatic shut-off valves; external connection box for independent wall mounting:	x	x	x	x	
▶ for up to eight processing machines / eight gate valves					5132419
▶ for up to twelve processing machines / twelve gate valves	x	x	x	x	5132420
▶ for up to 16 processing machines / 16 gate valves	x	x	x	x	5132421
Pneumatic gate valve Ø100 24V for Art. No.: 5132417 to 5132421	x	x	x	x	395.00
Pneumatic gate valve Ø120 24 V for Art. No.: 5132417 to 5132421	x	x	x	x	5144132
<b>Neu</b> Pneumatic gate valve Ø140 24 V for Art. No.: 5132417 to 5132421	x	x	x	x	5144133
<b>Neu</b> Pneumatic gate valve Ø160 24 V for Art. No.: 5132417 to 5132421	x	x	x	x	5144134
<b>Neu</b> Pneumatic gate valve Ø180 24 V for Art. No.: 5132417 to 5132421	x	x	x	x	5144135
<b>Neu</b> Pneumatic gate valve Ø200 24 V for Art. No.: 5132417 to 5132421	x	x	x	x	5144136
<b>Neu</b> Pneumatic gate valve Ø250 24 V for Art. No.: 5132417 to 5132421	x	x	x	x	5144137
<b>Neu</b> Pneumatic gate valve Ø300 24 V for Art. No.: 5132417 to 5132421	x	x	x	x	5144138
<b>Neu</b> ▶ Control with frequency converter from 2.2 to 7.5 kW incl. control panel and plain text display, integrated control circuit with pressure transmitter for demand-orientated control of the dust extractor:					
▶ 2.2 kW Control	x				5132422
▶ 3.0 kW Control		x			5132423
▶ 7.5 kW Control			x	x	5132424
Level indicator with ultrasonic sensor incl. signal lamp and 24 V power supply, monitors the level of a chip container (signal height adjustable on the sensor)	x	x	x	x	5132416
Chip bag (PU20)	x	x			5126007
Chip bag (PU20)			x	x	5126008
Dust bulkhead	x				5149008
Dust bulkhead		x			5149009
Dust bulkhead			x		5149010
Dust bulkhead				x	5149011



· OPTI JET® filter cleaning



Information on the EasySwitch automatic switch-on system can be found in the Holzkraft catalogue.



**New** · Pneumatic gate valve, electropneumatic gate valve with short response time for shutting off pipes



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