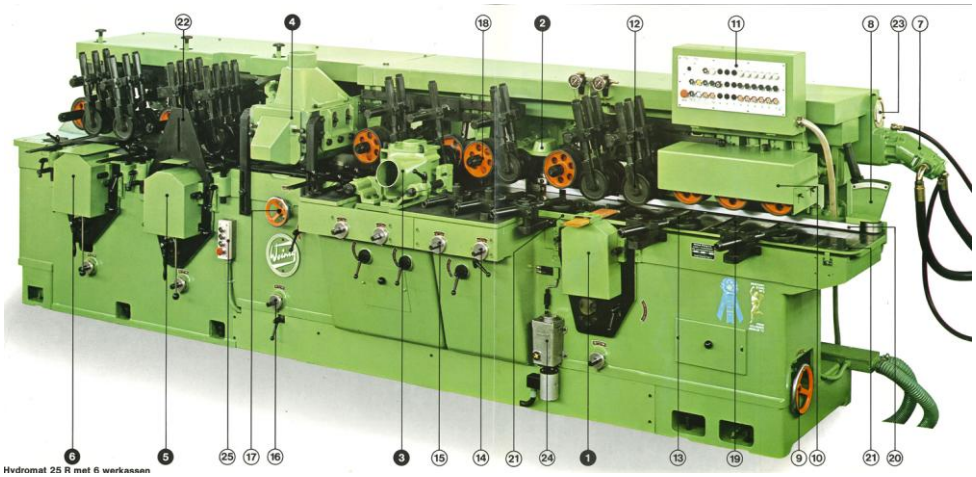
Hydromat 25 R with 6 working spindles

Numbered component key (as shown in the large machine illustration):

1. Lower spindle
2. Right-hand spindle
3. Left-hand spindle
4. Upper spindle
5. Lower spindle (Rotaplan spindle)
6. Lower spindle (crankshaft spindle)
7. Hydraulic motor
8. Chip-removal adjustment for the first right-hand spindle
9. Chip-removal adjustment for the first lower spindle
10. Six-roller infeed unit
11. Control panel
12. Heavy-duty upper pressure rollers
13. Heavy-duty lateral pressure rollers
14. Horizontal movement of the vertical spindles15. Vertical movement of the vertical spindles
16. Vertical movement of the horizontal spindles
17. Horizontal movement of the horizontal spindles
18. Chainless-driven feed rollers above the table, with pneumatic pressure
19. Chainless-driven feed rollers in the table
20. Hardened fences
21. Hardened machine table
22. Mounting for the pressure shoe above the Rotaplan spindle when machining workpieces less than 10 mm thick23. Feed-speed tachometer
24. Automatic Waxilit pump for removing resin from the machine tables and fences (optional)
25. Electrical vertical adjustment of the complete feed unit and thicknessing spindle; inching switch for the feed and emergency stop (alsooperable from the control panel) **Feed motor** with hydraulic drive unit.



Hydromat 25 R met 6 werkassen

PAGE 4 — TECHNICAL DATA

Standard specification

Working width*	250 mm
Working height	140 mm
Cutter-spindle motor power	7.5 hp
Feed motor power	20 hp
Cutter-spindle speed	6,000 rpm
Rotaplan-spindle speed	3,500 rpm
Cutter-spindle diameter	50 mm
Cutting-circle diameter — horizontal cutter spindles	110–240 mm
Cutting-circle diameter — vertical cutter spindles	100–200 mm
Continuous, infinitely variable feed speed	0–60 m/min
Feed rollers above the table — lift	170 mm
Width of these feed rollers	2 × 50 mm
Diameter of powered feed rollers in the table	110 mm
Adjustment range of front table and straightedge fence	10 mm
Adjustment range of vertical tools below the table surface	40 mm

* With a tool having a 140 mm cutting-circle diameter on the left-hand vertical spindle.

Electrical installation

The electrical installation complies with VDE regulations: push-button relay control, central high/low adjustment, a setting control for machine adjustment, and thermal overload protection for all motors.

Optional equipment / special version

• Increased motor rating for the horizontal spindle: up to 25 hp.

• Increased motor rating for the vertical spindle: up to 20 hp.

• Increased feed motor rating (for feed speeds up to 100 m/min): 25 hp.

• Feed roller widths: 30 / 20 / 15 mm.

• Feed speed: up to 100 m/min.

an individual arrangement.