

Semi-automatic high-performance machine for efficient cutting of bolt and pipe threads.

Bolt threads	6 – 72 mm 1/4 – 2 3/4"	
Pipe threads	1/16 – 2 1/2", 16 – 63 mm	
Tolerance class corresponding to ISO 261 (DIN 13)	"medium" (6 g)	
Thread length	≤ Ø 30 mm	unlimited
	≤ Ø 72 mm	≤ 200 mm
Chamfering	Range	7 – 62 mm
	Chamfered Ø	≥ 7 mm
	Maximum chamfer	7 mm
	Chamfer angle	45°
Peeling	Range	7 – 62 mm
	Peeled Ø	≥ 7 mm

Thread types see page 50.

REMS Unimat 75 – high efficiency.

Tangential-chaser-threading-system. Large threading range. Fast working, short resetting time. For single and series production. Low hourly rate for the machine. Simple operation. Relieves expensive turning machines and specialists.

Operating principle

Stationary material – rotating die head.

Design

Compact, rugged design for continuous use. Die head with regrindable tangential chasers in self centering holder system. After start-cutting with feed lever and rack mechanism self feeding action of die head (no guide thread). Welded, sturdy machine stand with large oil compartment and removeable chip drawer.

Drive

Indestructible planetary gear with annulus gear for long threads up to Ø 30 mm. Proven and powerful pole-reversible three-phase motor, specially designed for threading, with hollow shaft, 2000/2300 W. Overload protection. Reverse switch for cutting right and left-hand threads. High operating speed, 2 spindle speeds 70 and 35 rpm.

Clamping device

Self-centering universal vice for the complete range with specially toothed and hardened clamping jaws. Choice of manual or hydraulic clamping with operation by foot switch (working pressure 6 bar).

Special clamping jaws

For drawn material, stud bolts, hex screws and pipe nipples, as accessory.

Automatic lubrication and cooling

Robust, proven oil pump with high pumping volume. Ample oil volume ensures longer service life of chasers, gear and motor.

Universal automatic die head

Only **one** universal automatic die head for all threads. Fine adjustment of thread diameter with spindle and scale. Die head closes automatically and opens automatically when the required thread length is reached. After starting the thread via feed lever and rack the chaser-system initiates an automatic feed-forward of the die head. All threads can be cut in a single pass. Copying unit for tapered threads. Instead of changing the dies, additional quick-change die heads ensure shorter resetting time.

Chasers

The proven regrindable REMS tangential chasers with precise cutting geometry ensure an excellent start-cutting performance and clean threads. Tool steel chasers made of special hardened steel for material < 500 N/mm² (MPa). HSS chasers for hard-to-machine material ≥ 500 N/mm² (MPa). The chasers sit in a special holder system. Chasers and holders together form a threading set.

Thread cutting on rebar

Special chaser dies M with additional, ground cut for cutting threads on rebar in a single pass. Driven by REMS Unimat 75 with oil-hydraulic/pneumatic vice, for high clamping pressure.



German Quality Product

Machining examples



Info



Thread-cutting oil

REMS Sanitol and REMS Spezial (page 53). Specially developed for threading. High cooling and lubricating effect. Essential for clean threads and longer service life of dies, tools and machines.

Nipple-threading

Efficient with special clamping jaws $\frac{1}{16}$ – $1\frac{1}{4}$ " or with the automatic internal clamping REMS Nippelfix $\frac{1}{2}$ – $2\frac{1}{2}$ " or with the manual internal clamping REMS Nippelspanner $\frac{3}{8}$ – 2 " (page 52).

Supply format

REMS Unimat 75 Basic. Semi-automatic threading machine for bolt threads 6–72 mm, $\frac{1}{4}$ – $2\frac{3}{4}$ ", pipe threads $\frac{1}{16}$ – $2\frac{1}{2}$ ", 16–63 mm. Machine on stand. Pole-reversible 3~ induction motor with hollow shaft, 400 V, 50 Hz, 2000/2300 W, right and left-hand rotation. Die head speed 70 and 35 rpm. Self-centering universal chuck for the complete clamping range, choice of manual or oil-hydraulic/pneumatic operation. Automatic lubrication and cooling. 1 universal automatic die head for all threads, opens and closes automatically. Without threading sets, without closing lever. Electric locking system of safety cover. Adjustment gauge. Wrench. In transport case.

Description	Version	Art.-No.	€
REMS Unimat 75 Basic mS	manual clamping device	750003R380	22.740,00
REMS Unimat 75 Basic pS	oil-hydraulic/pneumatic vice clamping device	750004R380	26.700,00

Other voltages on request.



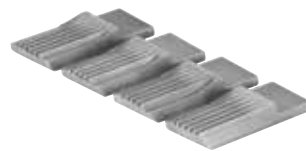
Accessories

Description	Art.-No.	€
Chasers and holders (threading sets) and chasers see page 50.		
Universal automatic die head, without threading sets, without closing lever	751000	1.400,00
Closing lever for closing and opening the chasers		
R for taper pipe threads, right-hand	751040R90	183,00
R-L for taper pipe threads, left-hand	751050R90	183,00
G for cylindrical pipe threads, right-hand	751060R90	183,00
G-L for cylindrical pipe threads, left-hand	751070R90	183,00
M for all bolt threads, right-hand	751080R90	183,00
M-L for all bolt threads, left-hand	751090R90	183,00
Chamfering/peeling die head 45°, Ø 7–62 mm, with chamfering/peeling chasers 45°, Ø 7–62 mm, HSS, with holder	751100	3.440,00
Chamfering/peeling die head 45°, Ø 7–62 mm, without threading sets	751102	1.460,00
Chamfering/peeling chasers 45°, Ø 7–46 mm, HSS, with holder	751096	990,00
Chamfering/peeling chasers 45°, Ø 40–62 mm, HSS, with holder	751098	990,00
Chamfering/peeling chasers 45°, Ø 7–62 mm, pack of 4, with holder	751097	572,00
Special clamping jaws, pair, for drawn material, stud bolts and hex screws. Workpiece length protrude from vice without thread, minimum 15 mm, Ø 6–42 mm	753240	1.490,00
Thread-cutting oil see page 53.		
Nipple holder see page 52.		
REMS Herkules material supports, see page 115.		





German Quality Product



German Quality Product

Chasers and holders (threading set)

The proven regrindable REMS tangential chasers with precise cutting geometry ensure an excellent start-cutting performance and clean threads. Tool steel chasers made of special hardened steel for material < 500 N/mm² (MPa). HSS chasers for hard-to-machine material ≥ 500 N/mm² (MPa). The chasers sit in a special holder system. Chasers and holders together form a threading set.

Thread type	Size	Art.-No.	€
Pipe threads R tapered, right-hand ISO 7-1, EN 10226 (DIN 2999, BSPT)	R 1/16 - 1/8	759250RWS	847,00
	R 1/8 - 3/16	759251RWS	847,00
	R 1/2 - 3/4	759252RWS	847,00
	R 1 - 2	759253RWS	847,00
	R 2 1/2	759254RWS	847,00
Pipe threads G parallel, right-hand ISO 228-1 (DIN 259, BSPP)	G 1/16 - 1/8	759255RWS	847,00
	G 1/8 - 3/16 HSS ¹⁾	759256RHSS	1.040,50
	G 1/2 - 3/4 HSS ¹⁾	759257RHSS	1.040,50
	G 1 - 2 HSS ¹⁾	759258RHSS	1.040,50
	G 2 1/2 HSS ¹⁾	759259RHSS	1.040,50
Pipe threads NPT tapered, right-hand Taper Pipe Thread ASME B1. 20.1	NPT 1/16 - 1/8	759360RWS	847,00
	NPT 1/8 - 3/16 HSS ¹⁾	759361RHSS	1.040,50
	NPT 1/2 - 3/4 HSS ¹⁾	759362RHSS	1.040,50
	NPT 1 - 2 HSS ¹⁾	759363RHSS	1.040,50
	NPT 2 1/2 HSS ¹⁾	759364RHSS	1.040,50
Pipe threads NPSM parallel, right-hand Straight Pipe Thread ASME B1. 20.1	NPSM 1/16 - 1/8	759365RWS	847,00
	NPSM 1/8 - 3/16	759366RWS	847,00
	NPSM 1/2 - 3/4 HSS ¹⁾	759367RHSS	1.040,50
	NPSM 1 - 2 HSS ¹⁾	759368RHSS	1.040,50
Conduit threads Pg DIN 40430	Pg 7	759260RWS	847,00
	Pg 9 - 16	759261RWS	847,00
	Pg 21 - 48	759262RWS	847,00
Conduit threads M EN 60423	M 16 - 20 x 1.5	759263RWS	847,00
	M 25 - 32 x 1.5	759264RWS	847,00
	M 40 - 50 x 1.5	759265RWS	847,00
	M 63 x 1.5 HSS ¹⁾	759330RHSS	1.040,50
Threads M for rebar ISO 261 (DIN 13)	M 14 - 16 HSS	759274RHSSZ	1.040,50
	M 18 - 22 HSS	759275RHSSZ	1.040,50
	M 24 - 27 HSS	759276RHSSZ	1.040,50
	M 30 - 33 HSS	759277RHSSZ	1.040,50
	M 36 - 39 HSS	759278RHSSZ	1.166,00
	M 42 - 45 HSS	759279RHSSZ	1.166,00
Metric bolt threads M ISO 261 (DIN 13)	M 6 HSS ¹⁾	759270RHSS	1.040,50
	M 8	759271RWS	847,00
	M 10	759272RWS	847,00
	M 12	759273RWS	847,00
	M 14 - 16	759274RWS	847,00
	M 18 - 22	759275RWS	847,00
	M 24 - 27	759276RWS	847,00
	M 30 - 33	759277RWS	847,00
	M 36 - 39	759278RWS	935,00
	M 42 - 45	759279RWS	935,00
	M 48 - 52 HSS ¹⁾	759280RHSS	1.166,00
	M 56 - 60 HSS ¹⁾	759281RHSS	1.166,00
	M 64 - 72 HSS ¹⁾	759282RHSS	1.166,00
Bolt threads UNC Unified Inch Screw Thread ASME B1.1	UNC 1/4 - 20	759370RWS	847,00
	UNC 5/16 - 18	759371RWS	847,00
	UNC 3/8 - 16	759372RWS	847,00
	UNC 7/16 - 14	759373RWS	847,00
	UNC 1/2 - 13	759374RWS	847,00
	UNC 5/8 - 12	759375RWS	847,00
	UNC 3/4 - 11	759376RWS	847,00
	UNC 7/8 - 10	759377RWS	847,00
	UNC 1 - 8	759378RWS	847,00
	UNC 1 - 8 HSS ¹⁾	759379RHSS	1.040,50
	UNC 1 1/8 - 7	759380RWS	847,00
	UNC 1 1/4 - 6	759381RWS	935,00
	UNC 1 3/4 - 5	759382RWS	935,00
	UNC 2 - 2 1/4 - 4.5	759383RWS	935,00
	UNC 2 1/2 - 2 3/4 - 4	759384RWS	935,00

Dies for other threads (e.g. bicycle threads, fine threads, BSW) and HSS chaser dies for materials above 500 N/mm² (MPa) that are difficult to cut on request. Dies with HSS chaser dies with 50% surcharge on chaser dies. ¹⁾ Some chasers only available in HSS. Threading sets for left-hand threads 50% extra charge on chasers.

Chasers (set)

The proven regrindable REMS tangential chasers with precise cutting geometry ensure an excellent start-cutting performance and clean threads. Tool steel chasers made of special hardened steel for material < 500 N/mm² (MPa). HSS chasers for hard-to-machine material ≥ 500 N/mm² (MPa).

Thread type	Size	Art.-No.	€
Pipe threads R tapered, right-hand ISO 7-1, EN 10226 (DIN 2999, BSPT)	R 1/16 - 1/8	751501RWS	387,00
	R 1/8 - 3/16	751502RWS	387,00
	R 1/2 - 3/4	751503RWS	387,00
	R 1 - 2 1/2	751504RWS	387,00
Pipe threads G parallel, right-hand ISO 228-1 (DIN 259, BSPP)	G 1/16 - 1/8 HSS ¹⁾	751505RHSS	580,50
	G 1/8 - 3/16	751506RHSS	580,50
	G 1/2 - 3/4 HSS ¹⁾	751507RHSS	580,50
	G 1 - 2 1/2 HSS ¹⁾	751508RHSS	580,50
Pipe threads NPT tapered, right-hand Taper Pipe Thread ASME B1. 20.1	NPT 1/16 - 1/8	751544RWS	387,00
	NPT 1/8 - 3/16 HSS ¹⁾	751545RHSS	580,50
	NPT 1/2 - 3/4 HSS ¹⁾	751546RHSS	580,50
	NPT 1 - 2 HSS ¹⁾	751547RHSS	580,50
Pipe threads NPSM parallel, right-hand Straight Pipe Thread ASME B1. 20.1	NPSM 1/16 - 1/8	751548RHSS	580,50
	NPSM 1/8 - 3/16	751549RWS	387,00
	NPSM 1/2 - 3/4 HSS ¹⁾	751550RWS	387,00
	NPSM 1 - 2	751551RHSS	580,50
Conduit threads Pg DIN 40430	Pg 7	751509RWS	387,00
	Pg 9 - 16	751510RWS	387,00
	Pg 21 - 48	751511RWS	387,00
Conduit threads M EN 60423	M 16 - 63 x 1.5 (M 10)	751518RWS	387,00
Threads M for rebar ISO 261 (DIN 13)	M 14 - 16 HSS	751520RHSSZ	580,50
	M 18 - 22 HSS	751521RHSSZ	580,50
	M 24 - 27 HSS	751522RHSSZ	580,50
	M 30 - 33 HSS	751523RHSSZ	580,50
	M 36 - 39 HSS	751524RHSSZ	693,00
	M 42 - 45 HSS	751525RHSSZ	693,00
Metric bolt threads M ISO 261 (DIN 13)	M 6	751516RHSS	580,50
	M 8	751517RWS	387,00
	M 10 (M 16 - 63 x 1.5)	751518RWS	387,00
	M 12	751519RWS	387,00
	M 14 - 16	751520RWS	387,00
	M 18 - 22	751521RWS	387,00
	M 24 - 27	751522RWS	387,00
	M 30 - 33	751523RWS	387,00
	M 36 - 39	751524RWS	462,00
	M 42 - 45	751525RWS	462,00
	M 48 - 52	751526RWS	462,00
	M 56 - 60	751527RWS	462,00
	M 64 - 72	751528RWS	462,00
Bolt threads UNC Unified Inch Screw Thread ASME B1.1	UNC 1/4 - 20	751557RWS	387,00
	UNC 5/16 - 18	751558RWS	387,00
	UNC 3/8 - 16	751559RWS	387,00
	UNC 7/16 - 14	751560RWS	387,00
	UNC 1/2 - 13	751561RWS	387,00
	UNC 5/8 - 12	751562RWS	387,00
	UNC 3/4 - 11	751563RWS	387,00
	UNC 7/8 - 10	751564RWS	387,00
	UNC 1 - 8	751565RWS	387,00
	UNC 1 - 8 HSS ¹⁾	751566RHSSZ	580,50
	UNC 1 1/8 - 7	751567RWS	387,00
	UNC 1 1/4 - 6	751568RWS	462,00
	UNC 1 3/4 - 5	751569RWS	462,00
	UNC 2 - 2 1/4 - 4.5	751570RWS	462,00
	UNC 2 1/2 - 2 3/4 - 4	751571RWS	462,00

Chaser dies for other threads (e.g. bicycle threads, fine threads, BSW) and HSS chaser dies for materials above 500 N/mm² (MPa) that are difficult to cut on request. HSS chaser dies with 50% surcharge. ¹⁾ Some chasers only available in HSS. Chasers for left-hand threads 50% extra charge.