

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.



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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	23.400,00
REMS Unimat 75 Basic pS	oil-hydraulic/pneumatic vice clamping device	750004R380	27.480,00

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	1.450,00
Closing lever for closing and opening the chasers		
R for taper pipe threads, right-hand	751040R90	189,00
R-L for taper pipe threads, left-hand	751050R90	189,00
G for cylindrical pipe threads, right-hand	751060R90	189,00
G-L for cylindrical pipe threads, left-hand	751070R90	189,00
M for all bolt threads, right-hand	751080R90	189,00
M-L for all bolt threads, left-hand	751090R90	189,00
Chamfering/peeling die head 45°, Ø 7–62 mm, with chamfering/peeling chasers 45°, Ø 7–62 mm, HSS, with holder	751100	3.548,00
Chamfering/peeling die head 45°, Ø 7–62 mm, without threading sets	751102	1.510,00
Chamfering/peeling chasers 45°, Ø 7–46 mm, HSS, with holder	751096	1.019,00
Chamfering/peeling chasers 45°, Ø 40–62 mm, HSS, with holder	751098	1.019,00
Chamfering/peeling chasers 45°, Ø 7–62 mm, pack of 4, with holder	751097	588,60
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	1.540,00

Thread-cutting oil see page 53.

Nipple holder see page 52.

REMS Herkules material supports, see page 115.

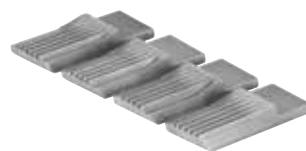




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Chasers and holders (threading set)

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	872,00
	R 1/8 - 3/16	759251RWS	872,00
	R 1/2 - 3/4	759252RWS	872,00
	R 1 - 2	759253RWS	872,00
	R 2 1/2	759254RWS	872,00
Pipe threads G parallel, right-hand ISO 228-1 (DIN 259, BSPP)	G 1/16 - 1/8	759255RWS	872,00
	G 1/8 - 3/16 HSS ¹⁾	759256RHSS	1.071,50
	G 1/2 - 3/4 HSS ¹⁾	759257RHSS	1.071,50
	G 1 - 2 HSS ¹⁾	759258RHSS	1.071,50
	G 2 1/2 HSS ¹⁾	759259RHSS	1.071,50
Pipe threads NPT tapered, right-hand Taper Pipe Thread ASME B1. 20.1	NPT 1/16 - 1/8	759360RWS	872,00
	NPT 1/8 - 3/16 HSS ¹⁾	759361RHSS	1.071,50
	NPT 1/2 - 3/4 HSS ¹⁾	759362RHSS	1.071,50
	NPT 1 - 2 HSS ¹⁾	759363RHSS	1.071,50
	NPT 2 1/2 HSS ¹⁾	759364RHSS	1.071,50
Pipe threads NPSM parallel, right-hand Straight Pipe Thread ASME B1. 20.1	NPSM 1/16 - 1/8	759365RWS	872,00
	NPSM 1/8 - 3/16	759366RWS	872,00
	NPSM 1/2 - 3/4 HSS ¹⁾	759367RHSS	1.071,50
	NPSM 1 - 2 HSS ¹⁾	759368RHSS	1.071,50
Conduit threads Pg DIN 40430	Pg 7	759260RWS	872,00
	Pg 9 - 16	759261RWS	872,00
	Pg 21 - 48	759262RWS	872,00
Conduit threads M EN 60423	M 16 - 20 x 1.5	759263RWS	872,00
	M 25 - 32 x 1.5	759264RWS	872,00
	M 40 - 50 x 1.5	759265RWS	872,00
	M 63 x 1.5 HSS ¹⁾	759330RHSS	1.071,50
Threads M for rebar ISO 261 (DIN 13)	M 14 - 16 HSS	759274RHSSZ	1.071,50
	M 18 - 22 HSS	759275RHSSZ	1.071,50
	M 24 - 27 HSS	759276RHSSZ	1.071,50
	M 30 - 33 HSS	759277RHSSZ	1.071,50
	M 36 - 39 HSS	759278RHSSZ	1.201,00
	M 42 - 45 HSS	759279RHSSZ	1.201,00
Metric bolt threads M ISO 261 (DIN 13)	M 6 HSS ¹⁾	759270RHSS	1.071,50
	M 8	759271RWS	872,00
	M 10	759272RWS	872,00
	M 12	759273RWS	872,00
	M 14 - 16	759274RWS	872,00
	M 18 - 22	759275RWS	872,00
	M 24 - 27	759276RWS	872,00
	M 30 - 33	759277RWS	872,00
	M 36 - 39	759278RWS	963,00
	M 42 - 45	759279RWS	963,00
	M 48 - 52 HSS ¹⁾	759280RHSS	1.201,00
	M 56 - 60 HSS ¹⁾	759281RHSS	1.201,00
	M 64 - 72 HSS ¹⁾	759282RHSS	1.201,00
	UNC 1/4 - 20	759370RWS	872,00
	UNC 5/16 - 18	759371RWS	872,00
	UNC 3/8 - 16	759372RWS	872,00
Bolt threads UNC Unified Inch Screw Thread ASME B1.1	UNC 7/16 - 14	759373RWS	872,00
	UNC 1/2 - 13	759374RWS	872,00
	UNC 5/8 - 12	759375RWS	872,00
	UNC 3/4 - 11	759376RWS	872,00
	UNC 7/8 - 10	759377RWS	872,00
	UNC 1 - 8	759378RWS	872,00
	UNC 1 - 8 HSS ¹⁾	759379RHSS	1.071,50
	UNC 1 1/8 - 7	759380RWS	872,00
	UNC 1 1/2 - 6	759381RWS	963,00
	UNC 1 3/4 - 5	759382RWS	963,00
	UNC 2 - 2 1/4 - 4.5	759383RWS	963,00
	UNC 2 1/2 - 2 3/4 - 4	759384RWS	963,00

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	399,00
	R 1/8 - 3/16	751502RWS	399,00
	R 1/2 - 3/4	751503RWS	399,00
	R 1 - 2 1/2	751504RWS	399,00
Pipe threads G parallel, right-hand ISO 228-1 (DIN 259, BSPP)	G 1/16 - 1/8 HSS ¹⁾	751505RHSS	598,50
	G 1/8 - 3/16	751506RHSS	598,50
	G 1/2 - 3/4 HSS ¹⁾	751507RHSS	598,50
	G 1 - 2 1/2 HSS ¹⁾	751508RHSS	598,50
Pipe threads NPT tapered, right-hand Taper Pipe Thread ASME B1. 20.1	NPT 1/16 - 1/8	751544RWS	399,00
	NPT 1/8 - 3/16 HSS ¹⁾	751545RHSS	598,50
	NPT 1/2 - 3/4 HSS ¹⁾	751546RHSS	598,50
	NPT 1 - 2 HSS ¹⁾	751547RHSS	598,50
Pipe threads NPSM parallel, right-hand Straight Pipe Thread ASME B1. 20.1	NPSM 1/16 - 1/8	751548RHSS	598,50
	NPSM 1/8 - 3/16	751549RWS	399,00
	NPSM 1/2 - 3/4 HSS ¹⁾	751550RWS	399,00
	NPSM 1 - 2	751551RHSS	598,50
Conduit threads Pg DIN 40430	Pg 7	751509RWS	399,00
	Pg 9 - 16	751510RWS	399,00
	Pg 21 - 48	751511RWS	399,00
Conduit threads M EN 60423	M 16 - 63 x 1.5 (M 10)	751518RWS	399,00
Threads M for rebar ISO 261 (DIN 13)	M 14 - 16 HSS	751520RHSSZ	598,50
	M 18 - 22 HSS	751521RHSSZ	598,50
	M 24 - 27 HSS	751522RHSSZ	598,50
	M 30 - 33 HSS	751523RHSSZ	598,50
	M 36 - 39 HSS	751524RHSSZ	714,00
	M 42 - 45 HSS	751525RHSSZ	714,00
Metric bolt threads M ISO 261 (DIN 13)	M 6	751516RHSS	598,50
	M 8	751517RWS	399,00
	M 10 (M 16 - 63 x 1.5)	751518RWS	399,00
	M 12	751519RWS	399,00
	M 14 - 16	751520RWS	399,00
	M 18 - 22	751521RWS	399,00
	M 24 - 27	751522RWS	399,00
	M 30 - 33	751523RWS	399,00
	M 36 - 39	751524RWS	476,00
	M 42 - 45	751525RWS	476,00
	M 48 - 52	751526RWS	476,00
	M 56 - 60	751527RWS	476,00
	M 64 - 72	751528RWS	476,00
Bolt threads UNC Unified Inch Screw Thread ASME B1.1	UNC 1/4 - 20	751557RWS	399,00
	UNC 5/16 - 18	751558RWS	399,00
	UNC 3/8 - 16	751559RWS	399,00
	UNC 7/16 - 14	751560RWS	399,00
	UNC 1/2 - 13	751561RWS	399,00
	UNC 5/8 - 12	751562RWS	399,00
	UNC 3/4 - 11	751563RWS	399,00
	UNC 7/8 - 10	751564RWS	399,00
	UNC 1 - 8	751565RWS	399,00
	UNC 1 - 8 HSS ¹⁾	751566RHSSZ	598,50
	UNC 1 1/8 - 7	751567RWS	399,00
	UNC 1 1/2 - 6	751568RWS	476,00
	UNC 1 3/4 - 5	751569RWS	476,00
	UNC 2 - 2 1/4 - 4.5	751570RWS	476,00
	UNC 2 1/2 - 2 3/4 - 4	751571RWS	476,00

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.