

# REMS Unimat 75

Threading machine

Semi-automatic high-performance machine for efficient cutting of bolt and pipe threads. For industry, metalworking, installation.

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 44.		



German Quality Product

**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 up to 500 N/mm<sup>2</sup>. HSS chasers for hard-to-machine material above 500 N/mm<sup>2</sup>. 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.

Machining examples



## Thread-cutting oil

REMS Sanitol and REMS Spezial (page 49). 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  $1/16$ – $1/4$ " or with the automatic internal clamping REMS Nippelfix  $1/2$ – $2 1/2$ " or with the manual internal clamping REMS Nippelspanner  $3/8$ – $2$ " (page 48).



## Supply format

**REMS Unimat 75 Basic.** Semi-automatic threading machine for bolt threads 6–72 mm,  $1/4$ – $2 3/4$ ", pipe threads  $1/16$ – $2 1/2$ ", 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.
<b>REMS Unimat 75 Basic mS</b>	manual clamping device	750003
<b>REMS Unimat 75 Basic pS</b>	oil-hydraulic/pneumatic vice clamping device	750004

Other voltages on request.

## Accessories

Description	Art.-No.
<b>Chasers and holders (threading sets) and chasers</b> see page 44.	
<b>Universal automatic die head</b> , without threading sets, without closing lever	751000
<b>Closing lever</b> for closing and opening the chasers	
<b>R</b> for taper pipe threads, right-hand	751040
<b>R-L</b> for taper pipe threads, left-hand	751050
<b>G</b> for cylindrical pipe threads, right-hand	751060
<b>G-L</b> for cylindrical pipe threads, left-hand	751070
<b>M</b> for all bolt threads, right-hand	751080
<b>M-L</b> for all bolt threads, left-hand	751090
<b>Chamfering/peeling die head 45°, Ø 7 – 62 mm</b> , with chamfering/peeling chasers 45°, Ø 7 – 62 mm, HSS, with holder	751100
<b>Chamfering/peeling die head 45°, Ø 7 – 62 mm</b> , without threading sets	751102
<b>Chamfering/peeling chasers 45°, Ø 7 – 46 mm</b> , HSS, with holder	751096
<b>Chamfering/peeling chasers 45°, Ø 40 – 62 mm</b> , HSS, with holder	751098
<b>Chamfering/peeling chasers 45°, Ø 7 – 62 mm</b> , pack of 4, with holder	751097
<b>Special clamping jaws, pair</b> , for drawn material, stud bolts and hex screws. Workpiece length protrude from vice without thread, minimum 15 mm, Ø 6 – 42 mm	753240
<b>Thread-cutting oil</b> see page 49.	
<b>Nipple holder</b> see page 48.	
<b>REMS Herkules material supports</b> , see page 96.	

