

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

|               |          |
|---------------|----------|
| Pipe threads  | 1/4–4"   |
| Thread length | ≤ 120 mm |

**REMS Unimat 77 – pipe threads up to 4".**

**Tangential-chaser-threading-system.**

**Fast working, short resetting time.**

**For single and series production.**

### 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

Robust worm gear and 2-stage spur gear. Proven and powerful pole-reversible three-phase motor, specially designed for threading, 2000/2300 W. Overload protection. Reverse switch for cutting right and left-hand threads. 4 spindle speeds 50, 25, 16, 8 rpm.

### Clamping device

Self-centering universal vice for the complete range with specially toothed and hardened clamping jaws (1/4–3/4", 1–4"). Choice of manual or hydraulic clamping with operation by foot switch (working pressure 6 bar).

### Automatic lubrication and cooling

Robust, proven oil pump with high pumping volume. Ample oil volume ensures longer 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/mm<sup>2</sup> (MPa). HSS chasers for hard-to-machine material ≥ 500 N/mm<sup>2</sup> (MPa). The chasers sit in a special holder system. Chasers and holders together form a threading set.

### 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 the automatic internal clamping REMS Nippelfix 1/2–4" or with the manual internal clamping REMS Nippelspanner 3/8–2" (page 48).



German Quality Product

Machining examples



Info

