

Robust, compact high performance machine for threading, cutting, deburring, threading of nipples, roll grooving. For installation, metalworking, industry. For job site and workshop.

Pipe threads	( $\frac{1}{16}$ ) $\frac{1}{2}$ –4", 16–63 mm
Bolt threads	(6) 20–60 mm, $\frac{1}{2}$ –2"

Thread types see page 40.

Pipe grooving with REMS roll grooving attachment	DN 25–200 (300) 1–8" (12")
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**REMS Magnum – the super machine up to 4".**  
**Exceptionally round and clean threads up to 4"**  
**by using 6 threading dies.**

### Operating principle

Rotating material - stationary tools.

### Execution

Robust, compact, job site-proven design. Favorable size and weight, e.g. REMS Magnum 4000 L-T only 81 kg. Large work and chip compartment. Tool support.

#### 2 versions:

- Light version L-T with removable large oil basin and chip tray.
- Version T with integrated, even larger oil basin and chip tray.

For workbench. Stand or wheel stand with material support, as accessory, for easy transport, optimum work height and secure standing.

### Drive

Extremely powerful and fast. Completely maintenance-free gear which runs in a sealed oil bath.

#### Choice of 3 powerful motors:

- Strong universal motor, 1700 W.  
Overload protection. Spindle speed 23 rpm.
- Pole-reversible capacitor motor, 2100 W.  
Overload protection. 2 spindle speeds 20 and 10 rpm, also under full load. **Extremely quiet running.**
- Pole-reversible 3~ induction motor, 2000 W.  
Overload protection. 2 spindle speeds 20 and 10 rpm, also under full load. **Extremely quiet running.**

Operator-friendly safety foot switch with emergency-stop, 2-step. Foot switch, can be loaded with the full body weight during operation.

### Chuck

Proven quick-action hammer chuck, self-tightening. No slipping of pipes. Large space between chuck and centering device ensures secure clamping of long pipes. Rear centering device for alignment of the material.

### Automatic lubrication and cooling

Robust, proven oil pump with high pumping volume. Optimized oil distribution directly onto the threading point through the die head ensures clean threads and long service life of dies, gear and motor.

### Universal automatic die head

Only 1 universal automatic die head each for the sizes  $\frac{1}{16}$ –2" and  $2\frac{1}{2}$ –4" for all threads, including long threads; automatic opening with automatic thread-length-stop for tapered threads. 6 dies  $2\frac{1}{2}$ –4" ensure a favourable distribution of the cutting force onto the pipe, hence round and clean threads. Fast and easy adjustment of thread size. Simple and fast change of dies through lock-in positioning in die holder.

### Dies

The proven, indestructible REMS quality dies with precise cutting geometry ensure an excellent start-cutting performance, easy threading and clean threads. Dies in a high-quality special-grade steel, fully tempered and hardened, for extremely long die life.

### Pipe cutter

Self centering. Robust body made of forged steel. Ergonomic, wide handle for powerful infeed of spindle. Specially hardened cutter wheel in tough-hard REMS die-steel ensures long service life.

### Inner pipe deburrer

Robust, easy-to-handle deburring device for adjustable deburring positioning. Specially hardened and designed deburring blade ensures easy deburring and extremely long service life. Two cutting edges for optimum chip flow, specially for small diameters.

### Tool sets

For  $2\frac{1}{2}$ –4" and  $\frac{1}{4}$ –2" one complete tool set each adapted to the work range universal die head, pipe cutter, inner-pipe-deburring device, pressing lever, dies.



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Choice of 3 powerful motors.



### 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 automatic internal clamping REMS Nippelfix ½–4" or with internal clamping REMS Nippelspanner ¾–2" (page 49)

### Material supports

Vertically adjustable material supports REMS Herkules and REMS Herkules Y (page 86).

### REMS roll grooving attachment

Robust, compact roll grooving attachment with oil hydraulic in-feed for pipe grooving of grooved coupling systems DN 25–200 (300), 1–8" (12") (page 52).



Stand (Accessory)



Wheel stand (Accessory)

### Supply format

**REMS Magnum.** Threading machine for pipe threads (1/16) ½–4", 16–63 mm, bolt threads (6) 20–60 mm, ½–2". With maintenance-free gear, safety foot switch with emergency-stop, self-tightening quick-action hammer chuck, rear centering device, automatic lubrication and cooling. With tool sets 1/16–2" and/or 2½–4", each consisting of universal automatic die head for all threads, also long threads; automatic opening, with automatic thread-length-stop for tapered threads, dies for pipe threads, tapered, ISO 7-1, DIN EN 10226 (DIN 2999, BSPT) R right-hand, pipe cutter, inner pipe deburrer, pressing lever. Tool support. Choice of 3 motors. Version L-T with removable large oil basin and chip tray. Version T with integrated, even larger oil basin and chip tray. For workbench, stand or wheel stand with material support.

Description	Version/Equipment	Art.-No.
4000 L-T	Universal motor 230 V or 110 V, 50–60 Hz, 1700 W. 23 rpm.	
	Equipment R ½–2	380447
	Equipment R 2½–4	380441
	Equipment R ½–4	380444
4010 L-T	Pole-reversible capacitor motor 230 V, 50 Hz, 2100 W. 20/10 rpm, also under full load. Extremely quiet running.	
	Equipment R ½–2	380448
	Equipment R 2½–4	380442
	Equipment R ½–4	380445
4020 L-T	Pole-reversible 3~ induction motor 400 V, 50 Hz, 2000 W. 20/10 rpm, also under full load. Extremely quiet running.	
	Equipment R 2½–4 Equipment R ½–4	380443 380446
4000 T	Universal motor 230 V or 110 V, 50–60 Hz, 1700 W. 23 rpm.	
	Equipment R 2½–4 Equipment R ½–4	380426 380429
4010 T	Pole-reversible capacitor motor 230 V, 50 Hz, 2100 W. 20/10 rpm, also under full load. Extremely quiet running.	
	Equipment R 2½–4 Equipment R ½–4	380427 380430
4020 T	Pole-reversible 3~ induction motor 400 V, 50 Hz, 2000 W. 20/10 rpm, also under full load. Extremely quiet running.	
	Equipment R 2½–4 Equipment R ½–4	380428 380431

Other voltages and NPT versions on request.

### Accessories

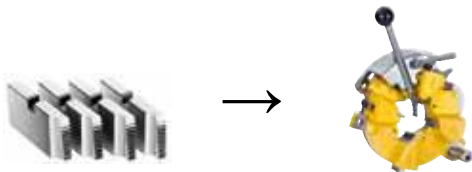
Description	Art.-No.
<b>Stand</b>	344105
<b>Wheel stand with material support</b>	344100
<b>Dies</b> see page 40.	
<b>Tool set 1/16–2" complete</b> with universal automatic die head, dies for pipe threads, tapered, ISO 7-1, DIN EN 10226 (DIN 2999, BSPT) R ½–¾ and R 1–2 right-hand, pipe cutter, inner pipe deburrer, pressing lever.	340100
<b>Universal automatic die head 1/16–2" and others</b>	341000
<b>Universal automatic die head 2½–4"</b>	381000
<b>REMS cutter wheel St ½–4", s 8</b>	341614
<b>REMS cutter wheel St 1–4", s 12</b>	381622
<b>Thread-cutting oil</b> see page 49.	
<b>Nipple holder</b> see page 48.	
<b>REMS Herkules material supports</b> , see page 86.	
<b>REMS roll grooving attachment</b> for pipe grooving, see page 52.	347000



## REMS dies

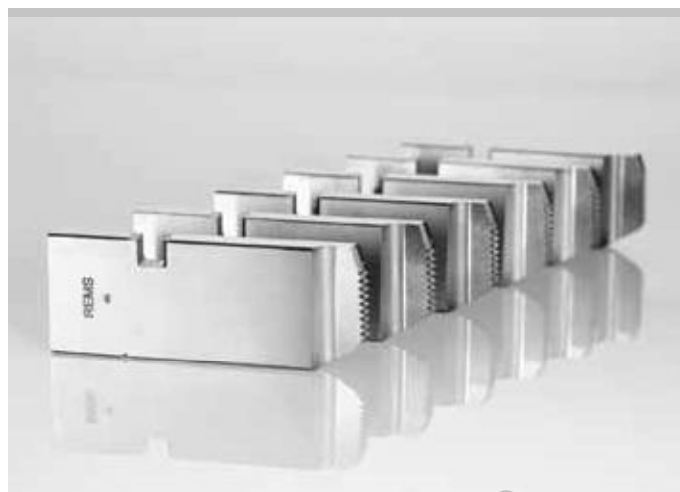
The proven REMS quality dies with precise cutting geometry ensure an excellent start-cutting performance, easy threading and clean threads. Dies in a high-quality special-grade steel, fully tempered and hardened, for extremely long die life.

Dies for other threads (e.g. BSW) on request. Dies in HSS for machining high strength materials 50% extra charge. <sup>1)</sup> Some dies only available in HSS.

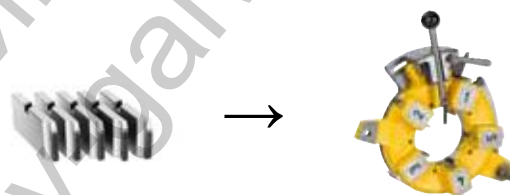


### For universal automatic die head 1/16–2"

Thread type	Size	Art.-No.
Pipe threads tapered, right-hand ISO 7-1, DIN EN 10226 (DIN 2999, BSPT)	R 1/16–1/8 HSS <sup>1)</sup>	341401
	R 1/4–3/8	341402
	R 1/2–3/4	341403
	R 1–2	341404
Pipe threads parallel, right-hand ISO 228-1 (DIN 259, BSPP)	G 1/16–1/8	341406
	G 1/4–3/8	341407
	G 1/2–3/4	341408
	G 1–2	341409
Pipe threads tapered, right-hand Taper Pipe Thread ASME B1.20.1	NPT 1/16–1/8 HSS <sup>1)</sup>	341411
	NPT 1/4–3/8	341412
	NPT 1/2–3/4	341413
	NPT 1–2	341414
Pipe threads parallel, right-hand Straight Pipe Thread ASME B1.20.1	NPSM 1/8	341416
	NPSM 1/4–3/8	341417
	NPSM 1/2–3/4	341418
	NPSM 1–2 HSS <sup>1)</sup>	341419
Conduit threads Pg DIN 40430	Pg 7	341466
	Pg 9	341467
	Pg 11	341468
	Pg 13,5	341469
	Pg 16	341470
	Pg 21	341471
	Pg 29	341472
	Pg 36	341473
	Pg 42	341474
	Pg 48	341475
Conduit threads DIN EN 60423	M 16 × 1,5	341493
	M 20 × 1,5	341494
	M 25 × 1,5	341495
	M 32 × 1,5	341496
	M 40 × 1,5	341497
	M 50 × 1,5	341498
Metric bolt threads M ISO 261 (DIN 13)	M 6	341426
	M 8	341427
	M 10	341428
	M 12	341429
	M 14	341430
	M 16	341431
	M 18	341432
	M 20	341433
	M 22	341434
	M 24	341435
	M 27	341436
	M 30	341437
	M 33	341438
	M 36	341439
	M 39	341440
	M 42	341441
	M 45	341442
	M 48	341443
M 52	341444	
M 56 HSS <sup>1)</sup>	341445	
M 60 HSS <sup>1)</sup>	341446	
Bolt threads UNC Unified Inch Screw Thread ASME B1.1	UNC 1/4–20	341476
	UNC 5/16–18	341477
	UNC 3/8–16 HSS <sup>1)</sup>	341478
	UNC 7/16–14	341479
	UNC 1/2–13 HSS <sup>1)</sup>	341480
	UNC 9/16–12	341481
	UNC 5/8–11 HSS <sup>1)</sup>	341482
	UNC 3/4–10 HSS <sup>1)</sup>	341483
	UNC 7/8–9 HSS <sup>1)</sup>	341484
	UNC 1–8 HSS <sup>1)</sup>	341485
	UNC 1 1/8–7	341486
	UNC 1 1/4–7 HSS <sup>1)</sup>	341487
	UNC 1 3/8–6	341488
	UNC 1 1/2–6 HSS <sup>1)</sup>	341489
	UNC 1 3/4–5	341490
UNC 2–4,5	341491	

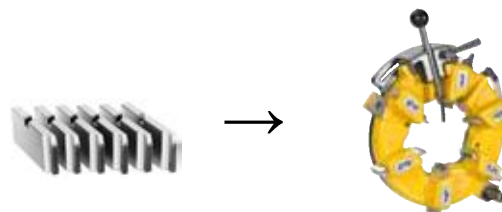


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### For universal automatic die head 2 1/2–3"

Thread type	Size	Art.-No.
Pipe threads tapered, right-hand ISO 7-1, DIN EN 10226 (DIN 2999, BSPT)	R 2 1/2–3	381430
Pipe threads parallel, right-hand ISO 228-1 (DIN 259, BSPP)	G 2 1/2–3 HSS <sup>1)</sup>	381431
Pipe threads tapered, right-hand Taper Pipe Thread ASME B1.20.1	NPT 2 1/2–3 HSS <sup>1)</sup>	381432
Pipe threads parallel, right-hand Straight Pipe Thread ASME B1.20.1	NPSM 2 1/2–3 HSS <sup>1)</sup>	381433



### For universal automatic die head 2 1/2–4"

Thread type	Size	Art.-No.
Pipe threads tapered, right-hand ISO 7-1, DIN EN 10226 (DIN 2999, BSPT)	R 2 1/2–4	381401
Pipe threads parallel, right-hand ISO 228-1 (DIN 259, BSPP)	G 2 1/2–4 HSS <sup>1)</sup>	381405
Pipe threads tapered, right-hand Taper Pipe Thread ASME B1.20.1	NPT 2 1/2–4 HSS <sup>1)</sup>	381410
Pipe threads parallel, right-hand Straight Pipe Thread ASME B1.20.1	NPSM 2 1/2–4 HSS <sup>1)</sup>	381415

Robust, compact threading attachment for efficient threading of tapered pipe threads, nipple-threading.

Pipe threads 2½–4"

**REMS 4" automatic die head – excellent threads up to 4" thanks to 5 threading dies and stepless automatically opening die head. No time consuming reverse.**

### Operating principle

Stationary material – rotating die head.

### Execution

Compact unit of die head, clamping chuck and gear. Maintenance-free. Easy to transport.

### Technique and operation

- Secure grip, self-tightening chuck, no slipping of pipe.
- Easy start-cutting with pressing lever and rack.
- 5 dies per size ensure favourable distribution of cutting force onto the pipe for round and clean threads.
- During threading the die head opens tapered in a gradual manner (copying unit), which enables a high cutting speed with low power requirements. Provides perfect threads as well as low impact on dies and machines.
- Automatic die head opening after reaching the standard thread length.
- After threading, immediate re-use possible, no guide thread required, no time-consuming reverse.
- Connection for automatic lubrication and cooling.

### Dies

The proven, indestructible REMS quality dies with precise cutting geometry ensure an excellent start-cutting performance, easy threading and clean threads. Dies in a high-quality special-grade steel, fully tempered and hardened, for extremely long die life.

### Drive

Through REMS Magnum, REMS Tornado, REMS Amigo 2 and threading machines of other makes. Fast, simple assembly. Rugged drive shaft for secure clamping and optimum power transmission.

### 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 nipple threading 2½–4" with the automatic internal clamping REMS Nippelfix (page



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### Supply format

**REMS 4" automatic die head.** Threading device for pipe threads 2½–4". Die head with copying unit, automatic opening after reaching the standard thread length, no time-consuming reverse. Self-tightening clamping device. Reduction gear with drive shaft, maintenance-free. Connection for automatic cooling and lubrication. Chip tray. Dies optional for pipe threads, tapered, ISO 7-1, DIN EN 10226 (DIN 2999, BSPT) R 2½, 3, 4, right-hand or for pipe threads, tapered, NPT 2½, 3, 4, right-hand.

Description	Equipment	Art.-No.
<b>REMS 4" automatic die head</b> fits to REMS Magnum, REMS Tornado, and others	R 2½, 3, 4	370010
<b>REMS 4" automatic die head</b> fits to REMS Magnum, REMS Tornado, and others	NPT 2½, 3, 4	370011
<b>REMS 4" automatic die head</b> fits to REMS Amigo 2	R 2½, 3, 4	370012
<b>REMS 4" automatic die head</b> fits to REMS Amigo 2	NPT 2½, 3, 4	370013



### Accessories

Description	Size	Art.-No.
<b>Dies</b>		
Pipe threads tapered right-hand ISO 7-1, DIN EN 10226 (DIN 2999, BSPT)	R 2½ R 3 R 4	371109 371113 371117
Pipe threads tapered right-hand Taper Pipe Thread ASME B1. 20.1	NPT 2½ HSS <sup>1)</sup> NPT 3 HSS <sup>1)</sup> NPT 4 HSS <sup>1)</sup>	371134 371138 371142

**Dies in HSS** for machining high strength materials 50% extra charge. <sup>1)</sup> Some dies only available in HSS.

**Thread-cutting oil** see page 49.

**Nippelfix 2½–4"** see page 48.

