

Working Temperature and Pressures

When correctly assembled with copper tubes manufactured to BS EN 1057 Compression fittings can operate at the temperatures and pressures below:

Maximum Temperatures	Max pressures for nominal diameters from 6mm up to and including 54mm
°C	BAR
30	16
65	10
110	6
120	5

Note 1: Intermediate pressure rating shall be determined by interpolation.

Note 2: Certain designs of compression fittings are suitable for use at temperatures / pressure ratings outside those given in this table. For such application the advice of the manufacturer should be sought.

Tightening Compression Fittings Guidance:

12mm	1 1/4 Turns
15mm	1 1/4 Turns
18mm	1 1/4 Turns
22mm	1 1/4 Turns
28mm	1 1/4 Turns
35mm	3/4 Turns
42mm	3/4 Turns
54mm	3/4 Turns

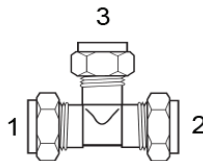
Dimensions and Codes:

Equal fittings with uniform connections are shown with one size. **E.G. 15mm**




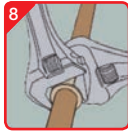
Reduced fittings with two connections are shown with the largest size first. **E.G. 22 x 15mm**

Tees and other reduced fittings of unequal sizes are shown with the largest end first, then the opposite run, followed by the branch.

E.G. 22 x 22 x 15mm



Joining Techniques for Compression fittings with Copper Tube to BS EN1057

1. Ensure the tube conforms to BS EN 1057. 
2. Select the correct fitting for the size of the tube to be connected.
3. Ends of the tube for joining must be cut cleanly across the tube diameter and be free from contamination, surface damage or defects. 
4. Enter the tube through the thrust nut and compression ring full into the fitting until positive contact is made with the tube stop.
5. Make sure the sealing faces of the joint and threads are clean and free from swarf and any contamination. A little light oil applied to the threads of the fittings is useful in reducing friction during tightening. With correctly made joints, jointing compounds should not be required, although in certain circumstances these may offer practical advantages. 
6. Care should be taken that the compression olive is not placed over any identification mark or other indentation on the tube. 
7. Hand tighten the thrust nuts until ALL slack in joint is taken up.
8. Complete tightening should be made using a suitable spanner. Ensure the axial alignment of the tube and fittings during tightening operation and thereafter. Over-tightening should be avoided as this may destroy the watertight seal. (For guidance see table on previous page)

Male and Female Joints

- Taper threads should be assembled using a WRAS Approved sealant or tape. E.G. PTFE.
- Parallel threads should be assembled using washers WRAS Approved.

Notes: Some authorities and System Specifications preclude the use of jointing compounds or require that only certain proprietary material may be used. Before utilising jointing compound it is the responsibility of the installer to ensure compliance.