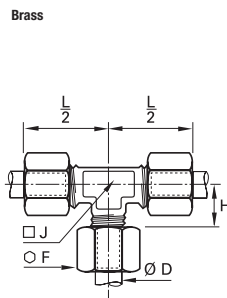



# Brass Compression Fittings

## 0104 Equal Tee



ØD		F	H	J	L/2	kg
4	<a href="#">0104 04 00</a>	10	9.5	8	19	0.028
5	<a href="#">0104 05 00</a>	12	11	8	21	0.036
6	<a href="#">0104 06 00</a>	13	11	8	22	0.040
8	<a href="#">0104 08 00</a>	14	15	10	28	0.055
10	<a href="#">0104 10 00</a>	19	14.5	12	30	0.105
12	<a href="#">0104 12 00</a>	22	15	15	30	0.142
14	<a href="#">0104 14 00</a>	24	18	19	35	0.190
15	<a href="#">0104 15 00</a>	24	18	19	35	0.175
16	<a href="#">0104 16 00</a>	27	21	19	39	0.239
18	<a href="#">0104 18 00</a>	30	21.5	23	41	0.330
20	<a href="#">0104 20 00</a>	32	21.5	23	42	0.330
22	<a href="#">0104 22 00</a>	36	29	27	50	0.518
25	<a href="#">0104 25 00</a>	41	29	27	54	0.630
28	<a href="#">0104 28 00</a>	42	30	32	55	0.660

Brass Compression Fittings

Compression Fittings

# Brass Compression Fittings

These "universal" fittings provide users with numerous connection options for a wide variety of tube materials without the need for tube threading or soldering. This range guarantees excellent long-term sealing and performance.

## Product Advantages

### Simple to Install and Use

- Suitable for pneumatic and medium pressure hydraulic applications
- Compatible with many industrial fluids
- Large product range: 22 configurations
- Excellent sealing due to the tightening of the olive onto the tube
- Metallic sealing guarantees maximum service life
- High strength brass for increased mechanical reliability

### Wide Variety of Tubing

- Connection of different types of tubing and hose: metal, polymer, steel, rubber, etc.
- Multiple tube diameters can be connected using the Parker Legris reducer assembly system
- No insert required for rigid and semi-rigid polyamide tubing below 14 mm



**Applications**

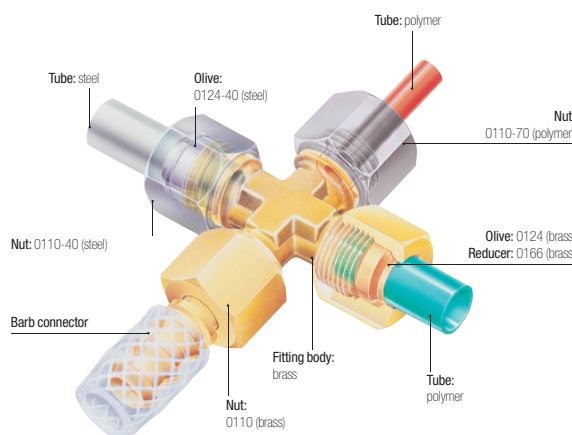
- Pneumatics
- Cooling
- Automotive Process
- Lubrication
- Fluid Transmission
- Packaging
- Industrial Machinery

## Technical Characteristics

<b>Compatible Fluids</b>	Water, machining oil, fuel, hydraulic oil, compressed air, chemical fluids, disinfectants
<b>Working Pressure</b>	Vacuum to 550 bar
<b>Working Temperature</b>	-40°C to +250°C
<b>Tightening Torque</b>	See "Technical Characteristics" on opposite page

Reliable performance is dependent upon the type of fluid conveyed, component materials and tubing being used. Guaranteed for use with a vacuum of 755 mm Hg (99% vacuum).

### Component Materials



### Silicone-free

### Maximum Bore Diameters

The table below shows the recommended compatibility of tube size, BSPP male thread and maximum bore.

Tube O.D.	BSPP Thread	Max. Bore
4-5-6	G1/8	4
6-8-10	G1/4	7
10-12-14	G3/8	11
14-15-16-18	G1/2	14
18-20-22	G3/4	18
22-25-28	G1	24

### Tube Length for Assembly

Minimum length of tube (L) between 2 fittings.



ØD	L (mm)	ØD	L (mm)	ØD	L (mm)
4	26.5	12	39	20	51
5	26	14	41	22	54
6	26	15	41	25	62
8	32	16	46.5	28	62
10	39	18	49.5		

### Regulations

**CNOMO:** E07.21.115N  
(for robotic equipment in the automotive industry)  
**DI:** 97/23/EC (PED)  
**RG:** 1907/2006 (REACH)  
**DI:** 2002/95/EC (RoHS)  
**DI:** 94/9/EC (ATEX)

# Technical Characteristics

## Installing Compression Fittings

### Cutting the Tube



Cut the polymer or metal tube square.

### Preparing the Connection



For metal tubing, de-burr the tube prior to connection. Tube bending should be done before connection.



Slide the nut onto the tube; lubricate the threads on the body and nut along with the olive to facilitate tightening (for metal tubing as well). Fit the olive onto the end of the tube.

### Connecting the Tube



Push the tube up against the shoulder of the body of the fitting and hand tighten.

### Final Assembly



Tighten the nut using a spanner or torque wrench to enable the olive to bite on the tube, the connection being completed when the recommended tightening torque is reached (see tables below).



It is recommended to use an insert in order to prevent tube creeping (diameter > 14mm)

Brass Compression Fittings

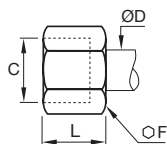
Compression Fittings

## Recommended Nut Tightening Torque

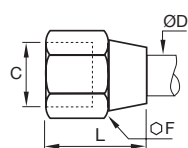
### Tightening torque

in daN.m =

maximum tightening torque of a 0110 nut and 0124 olive with copper, brass or steel tube.



Nut 0110 and 0110..40



Nut 0110..60

Ø D (mm)	Ø F 0110	Ø F 0110..60	Max. daN.m Copper or Brass	Ø F 0110..40	Max. daN.m Steel
4	10	11	0.7	10	1.5
5	12	13	0.7	12	1.5
6	13	13	1.5	13	2.5
8	14	16	1.5	14	2.5
10	19	20	1.8	19	3
12	22	22	3	22	4.5
14	24	24	3.5	24	5.5
15	24	24	4	24	6
16	27	27	5	27	7
18	30	30	6	30	9
20	32	32	6	32	10
22	36	36	7	36	12
25	41	41	8	41	13
28	42		9		

## Customised Fittings

Working directly with its customers and based on its knowledge and experience, Parker Legris can design customised brass compression fittings for specific requirements using the customer's specifications.

The range of compression fittings also offers nickel chemical surface treatment in order to improve the corrosion resistance and chemical compatibility of the fittings (the model number of the fitting is then given the suffix 99).

The above recommendations are given in good faith. However, since each application is different, it is advisable to undertake tests in actual working conditions.



# Technical Characteristics

The use of Parker Legris brass compression fittings is dependant on the tube material. Tables of recommended working pressure for the different tubes are shown below.

## Recommended Tube Type

**Copper tube:** copper which has been "cold rolled", cold drawn and in straight lengths.  
**Brass tube:** in cold-rolled straight lengths (same working pressure as for copper tube).  
**"Coiled annealed" copper tube:** reduces working pressure by 35%; must be avoided completely if vibration is present.

**Steel tube:** "thin wall" cold drawn, seamless, bright annealed and in straight lengths.  
 6 mm to 16 mm O.D.: max. wall thickness 1 mm  
 Above 16 mm O.D.: max. wall thickness 1.5 mm

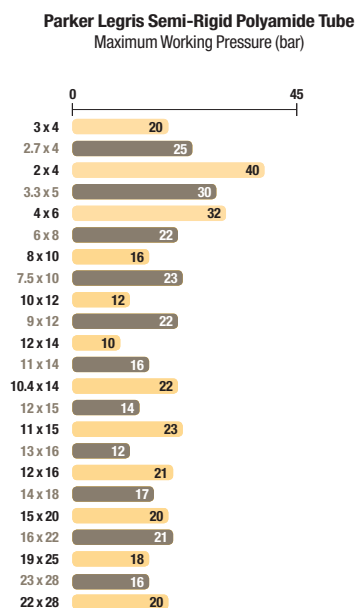
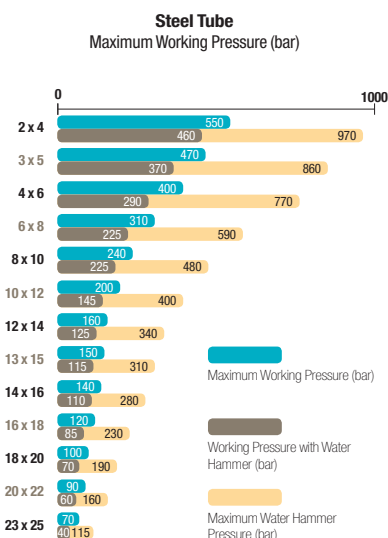
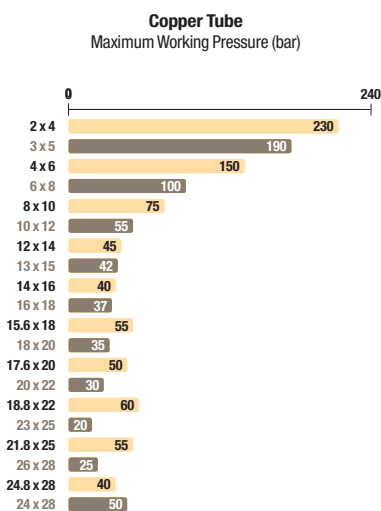
**Polyamide tube:** semi-rigid  
 For rigid polyamide tube, multiply the figures in this table by 1.8.

## Recommended Tube-Fitting Assembly Configurations

Assembled using Parker Legris brass olive and nut.

Assembled using Parker Legris steel olive and nut (nut type 0110..40).

Assembled using Parker Legris brass olive and nut.



When using a plastic nut type 0110..70, the maximum working pressure is 10 bar, for all diameters.

### Working Pressure Coefficients for Semi-Rigid Polyamide Tubing

Temperature °C	-40°C / -15°C	-15°C / +30°C	+30°C / +50°C	+50°C / +70°C	+70°C / +100°C
Factor	1.8	1	0.68	0.55	0.31

Parker Legris brass compression fittings are not compatible with ammonia and its derivatives.

The above recommendations are given in good faith. However, since each application is different, it is advisable to undertake tests in actual working conditions.

# Compression Fittings

## Brass Compression Fittings

(P. 5-5)



**Fluids:** compressed air, non-corrosive industrial fluids

**Materials:** forged or machined brass

**Pressure:** 550 bar

**Temperature:** -40°C to +250°C

**Ø metric:** 4 mm to 28 mm

## Stainless Steel Compression Fittings

(P. 5-31)



**Fluids:** compressed air, coolants, industrial and corrosive fluids

**Materials:** 316L stainless steel

**Pressure:** 400 bar

**Temperature:** -40°C to +250°C

**Ø metric:** 6 mm to 16 mm

## PL Nickel-Plated Brass Spigot Fittings

(P. 5-41)



**Fluids:** compressed air, compatible industrial fluids

**Materials:** forged or machined nickel-plated brass

**Pressure:** 40 bar

**Temperature:** -40°C to +100°C

**Ø metric:** 4 mm to 14 mm

## Compression Fitting Part Numbers

**0105 14 27 99**

### Item Type

01XX: brass  
18XX: stainless steel

### Suffix

39: bonded seal  
40: treated steel  
60: nut  
70: polymer nut  
99: chemical nickel

### Ø

04 = 4 mm  
06 = 6 mm  
...  
20 = 20 mm  
28 = 28 mm

### Thread

10 = 1/8  
13 = 1/4  
...  
21 = 1/2  
27 = 3/4

## PL Fitting Part Numbers

**F3BPL 8/10 -1/4**

### Item Type

FBPL  
F3BPL  
HBPL  
WBPL  
...

### Ø

2.7/4  
4/6  
6/8  
7.5/10  
8/10  
10/12  
11/14

### Thread

BSPT & NPT:  
1/8  
1/4  
3/8  
...  
Metric:  
M10  
M12