



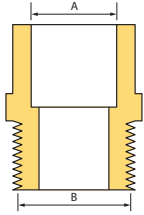
# CEM Fittings

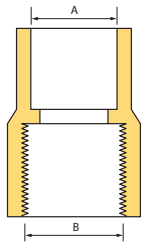
BRASS, END-FEED  
CAPILLARY FITTINGS

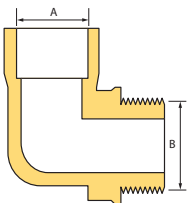


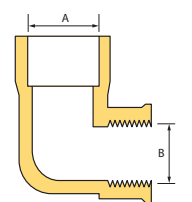
# CEM Brass End-Feed Capillary Fittings

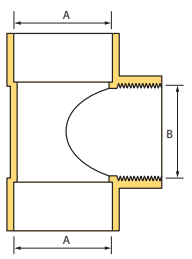
Manufactured to BSEN 1254-1 and BSEN 1254-4

MALE COUPLING MBL x MI	NOMINAL SIZE A x B	DESCRIPTIVE CODE	PART NUMBER
	15mm x 1/2"	BE-CM-1512	50131677
	22mm x 1/2"	BE-CM-2212	50131678
	22mm x 3/4"	BE-CM-2234	50131679
	28mm x 1"	BE-CM-281	50131680
	35mm x 1-1/4"	BE-CM-35114	50131681
	42mm x 1-1/2"	BE-CM-42112	50131682
	54mm x 2"	BE-CM-542	50131683
	67mm x 2-1/2"	BE-CM-67212	50131684
76mm x 3"	BE-CM-763	50131685	

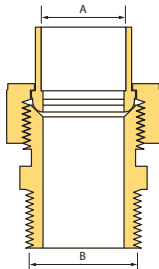
FEMALE COUPLING MBL x FI	NOMINAL SIZE A x B	DESCRIPTIVE CODE	PART NUMBER
	15mm x 1/2"	BE-CF-1512	50131686
	22mm x 1/2"	BE-CF-2212	50131687
	22mm x 3/4"	BE-CF-2234	50131688
	28mm x 1"	BE-CF-281	50131689
	35mm x 1-1/4"	BE-CF-35114	50131690
	42mm x 1-1/2"	BE-CF-42112	50131691
	54mm x 2"	BE-CF-542	50131692

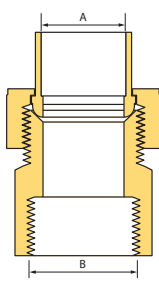
MALE ELBOW MBL x MI	NOMINAL SIZE A x B	DESCRIPTIVE CODE	PART NUMBER
	15mm x 1/2"	BE-9M-1512	50131693
	22mm x 1/2"	BE-9M-2212	50131694
	22mm x 3/4"	BE-9M-2234	50131695
	28mm x 1"	BE-9M-281	50131696

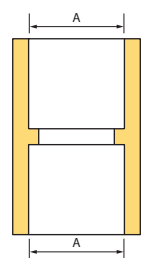
FEMALE ELBOW MBL x FI	NOMINAL SIZE A x B	DESCRIPTIVE CODE	PART NUMBER
	15mm x 1/2"	BE-9F-1512	50131697
	22mm x 1/2"	BE-9F-2212	50131698
	22mm x 3/4"	BE-9F-2234	50131699
	28mm x 1"	BE-9F-281	50131700
	35mm x 1-1/4"	BE-9F-35114	50131701
	42mm x 1-1/2"	BE-9F-42112	50131702
	54mm x 2"	BE-9F-542	50131703

FEMALE TEE MBL x MBL x FI	NOMINAL SIZE A x A x B	DESCRIPTIVE CODE	PART NUMBER
	15 x 15mm x 1/2"	BE-TF-151512	50131704

## Products not suitable for use in Hong Kong.

MALE BRAZING UNION MBL x MI	NOMINAL SIZE A x B	DESCRIPTIVE CODE	PART NUMBER
	14mm x 3/8"	BE-UM-1438	50131707
	14mm x 1/2"	BE-UM-1412	50131708
	15mm x 1/2"	BE-UM-1512	50131709
	15mm x 3/4"	BE-UM-1534	50131710
	18mm x 1/2"	BE-UM-1812	50131711
	18mm x 3/4"	BE-UM-1834	50131712
	22mm x 3/4"	BE-UM-2234	50131713
	22mm x 1"	BE-UM-221	50131714
	28mm x 1"	BE-UM-281	50131715
	28mm x 1-1/4"	BE-UM-28114	50131716

FEMALE BRAZING UNION MBL x FI	NOMINAL SIZE A x B	DESCRIPTIVE CODE	PART NUMBER
	14mm x 1/2"	BE-UF-1412	50131717
	15mm x 1/2"	BE-UF-1512	50131718
	15mm x 3/4"	BE-UF-1534	50131719
	22mm x 3/4"	BE-UF-2234	50131720
	22mm x 1"	BE-UF-221	50131721
	28mm x 1"	BE-UF-281	50131722
	28mm x 1-1/4"	BE-UF-28114	50131723

UNION MBL x MBL	NOMINAL SIZE A	DESCRIPTIVE CODE	PART NUMBER
	15 x 15mm	BE-UN-1515	50131705
	22 x 22mm	BE-UN-2222	50131706

# CEM Brass End-Feed Capillary Fittings

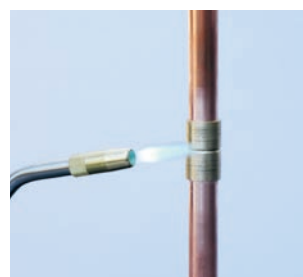
Manufactured to BSEN 1254-1 and BSEN 1254-4

JOINING SYSTEMS → FITTINGS → BRASS → BSEN 1254

## Installation Procedure for CEM Brass End-Feed Capillary Fittings

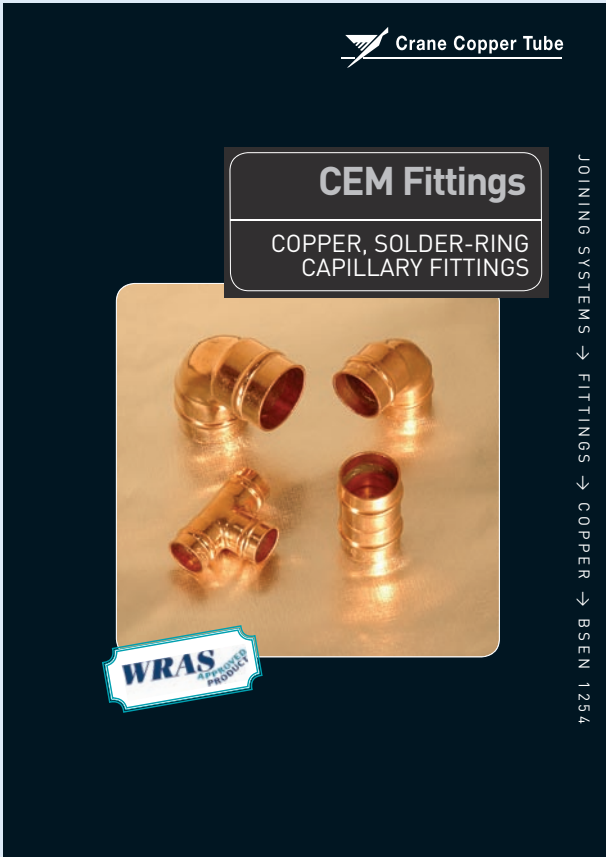
**NOTE: CEM Brass End-Feed Capillary Fittings are designed for BRAZING and are not suitable for soft soldering.**

- 1 Select an appropriate fitting to match the tube size and check that they will fit neatly together.
- 2 Cut the copper tube to the required length by using the tube cutter or a fine tooth hacksaw. Ensure that the tube ends are cut square, and the tube remains round in section. Re-rounding may be required for Annealed Tube that complies with BSEN 1057 R220.
- 3 Remove all burrs from the inside and outside surface of the tube ends.
- 4 Use steel wool, fine sanding paper, a cleaning pad or a brush to clean inside the socket of the fitting. Clean the outside surface of the tube using fine steel wool, fine sanding paper or a cleaning pad.
- 5 Apply a thin coating of brazing flux to the area of the fitting and the tube that will form the joint. A coating of flux on the tube in the area to be heated can protect the tube from oxidising and improve the final appearance of the joint.
- 6 Ensure that the tube end is pushed fully home within the fitting. Twist the assembly to spread the flux over the jointing area. Support the joint to ensure a straight joint and equal capillary gap on all sides in the fitting.
- 7 Begin heating the tube with the flame perpendicular to the tube. Sweep the flame around the tube and do not overheat one area. The copper tube conducts the initial heat into the fitting cup for better distribution of heat. Preheating of the assembly should include the entire tube circumference to bring the entire assembly up to a suitable preheat condition. For joints in the horizontal position, avoid directly preheating the top of the joint as heat will rise to ensure adequate preheat of the top of the assembly.
- 8 When the flux turns clear, the appropriate temperature has been reached. Apply brazing solder at the junction of tube and fitting and maintain heating the assembly with the flame just ahead of the solder rod. If solder does flow into the capillary gap remove the solder and continue heating in a sweeping action. When the joint is complete, a ring of solder should be seen all around the mouth of the fitting.
- 9 Allow the joint to cool down. Do not move the joint assembly during cooling.
- 10 To prevent corrosion, wipe and wash all excess flux from the outside surfaces. Flush the system thoroughly to remove internal residues.



# CEM Copper & Brass Fittings

Ask about other fittings in the CEM range



JOINING SYSTEMS → FITTINGS → COPPER & BRASS

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