



CEM Fittings

COPPER, SOLDER-RING
CAPILLARY FITTINGS



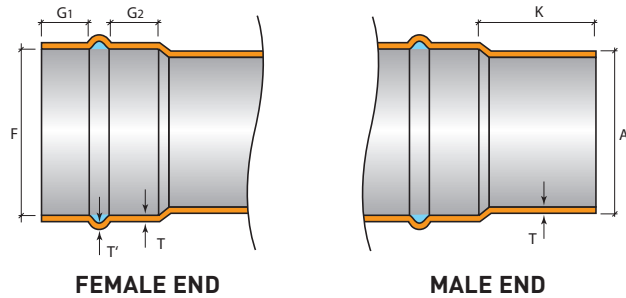
CEM Copper Solder-Ring Capillary Fittings

Manufactured to BSEN 1254-1 : 1998



The CEM range of copper solder-ring capillary fittings comply with the following standards:

- BRITISH STANDARD BSEN 1254 - PART 1
- Nominal sizes ranging up to and including 54mm.
- CEM range of copper solder-ring fittings has received WRAS (Water Regulations Advisory Scheme) approval, Certificate No.0702121.



Dimensions of CEM Copper Solder-Ring Capillary Fittings (mm)								
Nominal Size of Fitting	Female End			Male End			Minimum Wall Thickness	
	Inside Diameter		Length	Outside Diameter		Length		
	F		G1 + G2	A	K	T	T'	
mm	mm max.	mm min.	mm min.	mm max.	mm min.	mm min.	mm min.	mm min.
15	15.15	15.06	10.6	15.04	14.95	12.6	0.70	0.63
22	22.18	22.07	15.4	22.05	21.94	17.4	0.90	0.81
28	28.18	28.07	18.4	28.05	27.94	20.4	0.90	0.81
35	35.23	35.09	23.0	35.06	34.93	25.0	1.00	0.90
42	42.23	42.09	27.0	42.06	41.93	29.0	1.10	0.99
54	54.23	54.09	32.0	54.06	53.93	34.0	1.20	1.08



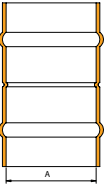
JOINING SYSTEMS → FITTINGS → COPPER → BSEN 1254

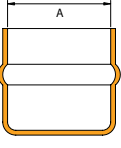
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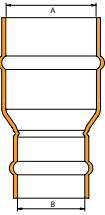
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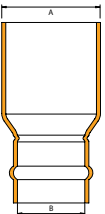


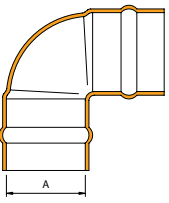
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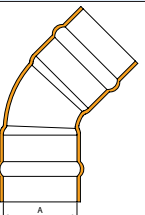
COUPLING	NOMINAL SIZE A (mm)	DESCRIPTIVE CODE	PART NUMBER
	15	SR-SC-15	50131609
	22	SR-SC-22	50131610
	28	SR-SC-28	50131611
	35	SR-SC-35	50131612
	42	SR-SC-42	50131613
	54	SR-SC-54	50131614

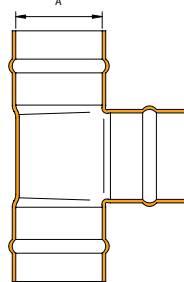
STOP END	NOMINAL SIZE A (mm)	DESCRIPTIVE CODE	PART NUMBER
	15	SR-SE-15	50131671
	22	SR-SE-22	50131672
	28	SR-SE-28	50131673
	35	SR-SE-35	50131674
	42	SR-SE-42	50131675
	54	SR-SE-54	50131676

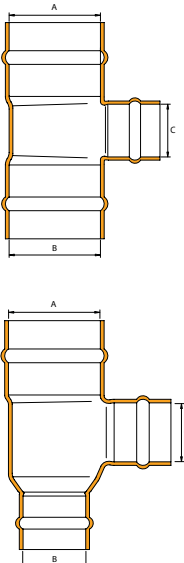
REDUCING COUPLING	NOMINAL SIZE A x B (mm)	DESCRIPTIVE CODE	PART NUMBER
	22 x 15	SR-RC-2215	50131615
	28 x 22	SR-RC-2822	50131616
	42 x 28	SR-RC-4228	50131617
	42 x 35	SR-RC-4235	50131618
	54 x 15	SR-RC-5415	50131619
	54 x 22	SR-RC-5422	50131620
	54 x 28	SR-RC-5428	50131621
	54 x 35	SR-RC-5435	50131622
	54 x 42	SR-RC-5442	50131623

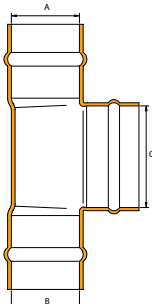
FITTING REDUCER	NOMINAL SIZE A x B (mm)	DESCRIPTIVE CODE	PART NUMBER
	22 x 15	SR-FR-2215	50131624
	28 x 15	SR-FR-2815	50131625
	28 x 22	SR-FR-2822	50131626
	35 x 22	SR-FR-3522	50131627
	35 x 28	SR-FR-3528	50131628
	42 x 28	SR-FR-4228	50131629
	42 x 35	SR-FR-4235	50131630
	54 x 35	SR-FR-5435	50131631
	54 x 42	SR-FR-5442	50131632

ELBOW 90°	NOMINAL SIZE A (mm)	DESCRIPTIVE CODE	PART NUMBER
	15	SR-9E-15	50131633
	22	SR-9E-22	50131634
	28	SR-9E-28	50131635
	35	SR-9E-35	50131636
	42	SR-9E-42	50131637
	54	SR-9E-54	50131638

ELBOW 45°	NOMINAL SIZE A (mm)	DESCRIPTIVE CODE	PART NUMBER
	15	SR-4E-15	50131639
	22	SR-4E-22	50131640
	28	SR-4E-28	50131641
	35	SR-4E-35	50131642
	42	SR-4E-42	50131643
	54	SR-4E-54	50131644

EQUAL TEE	NOMINAL SIZE A (mm)	DESCRIPTIVE CODE	PART NUMBER
	15	SR-ET-15	50131645
	22	SR-ET-22	50131646
	28	SR-ET-28	50131647
	35	SR-ET-35	50131648
	42	SR-ET-42	50131649
	54	SR-ET-54	50131650

REDUCING TEE	NOMINAL SIZE A x B x C (mm)	DESCRIPTIVE CODE	PART NUMBER
	22 x 15 x 15	SR-RT-221515	50131651
	22 x 15 x 22	SR-RT-221522	50131652
	22 x 22 x 15	SR-RT-222215	50131653
	28 x 22 x 15	SR-RT-282215	50131654
	28 x 22 x 22	SR-RT-282222	50131655
	28 x 15 x 28	SR-RT-281528	50131656
	28 x 22 x 28	SR-RT-282228	50131657
	28 x 28 x 15	SR-RT-282815	50131658
	28 x 28 x 22	SR-RT-282822	50131659
	35 x 35 x 15	SR-RT-353515	50131660
	35 x 35 x 22	SR-RT-353522	50131661
	35 x 35 x 28	SR-RT-353528	50131662
	42 x 42 x 15	SR-RT-424215	50131663
	42 x 42 x 22	SR-RT-424222	50131664
	42 x 42 x 28	SR-RT-424228	50131665
	42 x 42 x 35	SR-RT-424235	50131666
	54 x 54 x 35	SR-RT-545435	50131667
	54 x 54 x 42	SR-RT-545442	50131668

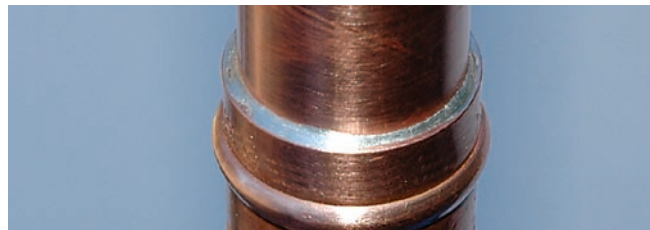
EXPANDING TEE	NOMINAL SIZE A x B x C (mm)	DESCRIPTIVE CODE	PART NUMBER
	15 x 15 x 22	SR-XT-151522	50131669
	22 x 22 x 28	SR-XT-222228	50131670

CEM Copper Solder-Ring Capillary Fittings

Manufactured to BSEN 1254-1 : 1998

Installation Procedure for CEM Copper Solder-Ring Capillary Fittings

- 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 flux to the area of the fitting and the tube that will form 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. Wipe off any excess flux.
- 7 Heat the jointing area evenly using a gas torch.
- 8 When the appropriate temperature is reached, solder will flow into the capillary gap of the joint. When the joint is complete, a ring of solder should appear 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.



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Crane Copper Tube

ABN 51 008 408 151

A Division of Crane Enfield Metals Pty. Limited

PO Box 319, Penrith NSW 2751 Australia

Phone: +612 4720 5350

Fax : +612 4720 5390

sales@cranecopper.com.au

www.cranecopper.com.au

CRN8798.0907