

**Stainless Steel Press Fitting**  
Simple. Reliable. Permanent.





## Precise Simple Reliable Crimpling Operation

Designed for potable water application where water quality and hygiene are crucial, MELCO press fittings are manufactured from 304/316L stainless steel. By crimping the press fittings and the pipe using a pressing tool<sup>1</sup>, a permanent hydraulic tightness will be obtained through the resilience of a black EPDM (Ethylene Propylene Diene Monomer) 'O' ring.

*<sup>1</sup>The pressing tool must be maintained according to the respective manufacturer's guidelines. For more information, please check with the supplier prior to installation.*

- Fittings are manufactured from 304/316L stainless steel
- Ideal for hygienically fastidious application such as potable water supply and food production
- High resistance to pressure
- Clean and heat free jointing
- Light weight and easy to handle
- Tested independently by accredited laboratories

## MPF101

(Press-fit Coupling)



### Dimensions

15 x 15
22 x 22
28 x 28
35 x 35
42 x 42
54 x 54

## MPF103

(Adaptor With Female Thread)



### Dimensions

15 x 1/2"
22 x 3/4"
28 x 1"
35 x 1 1/4"
42 x 1 1/2"
54 x 2"
15 x 3/4"
15 x 1"
22 x 1/2"
22 x 1"
28 x 1/2"
28 x 3/4"

## MPF101R

(Reducer with Plain End)



### Dimensions

22 x 15	42 x 15
28 x 15	42 x 22
28 x 22	42 x 28
35 x 15	42 x 35
35 x 22	54 x 15
35 x 28	54 x 22
	54 x 28
	54 x 35
	54 x 42

## MPF201

(90° Press-fit Elbow)



### Dimensions

15 x 15
22 x 22
28 x 28
35 x 35
42 x 42
54 x 54

## MPF101S

(Slip Coupling)



### Dimensions

15 x 15
22 x 22
28 x 28
35 x 35
42 x 42
54 x 54

## MPF201P

(90° Elbow With Plain End)



### Dimensions

15 x 15
22 x 22
28 x 28
35 x 35
42 x 42
54 x 54

## MPF102 (Adaptor With Male Thread)



### Dimensions

15 x 1/2"	
22 x 3/4"	
28 x 1"	22 x 1"
35 x 1 1/4"	28 x 1/2"
42 x 1 1/2"	28 x 3/4"
54 x 2"	28 x 1 1/4"
15 x 3/4"	28 x 1 1/2"
15 x 1"	35 x 1 1/2"
22 x 1/2"	35 x 2"
	42 x 2"

## MPF202 (90° Male Elbow)



### Dimensions

15 x 1/2"
22 x 3/4"
28 x 1"
35 x 1 1/4"
42 x 1 1/2"
54 x 2"
22 x 1/2"
28 x 1/2"
35 x 1/2"
42 x 1/2"
54 x 1/2"

## MPF203

(90° Female Elbow)



### Dimensions

15 x 1/2"  
22 x 3/4"  
28 x 1"  
35 x 1 1/4"  
42 x 1 1/2"  
54 x 2"  
22 x 1/2"  
28 x 1/2"  
35 x 1/2"  
42 x 1/2"  
54 x 1/2"

## MPF301

(Press-fit Tee)



### Dimensions

15 x 15 x 15  
22 x 22 x 22  
28 x 28 x 28  
35 x 35 x 35  
42 x 42 x 42  
54 x 54 x 54  
22 x 22 x 15  
28 x 28 x 15  
28 x 28 x 22  
35 x 35 x 15  
35 x 35 x 22  
35 x 35 x 28  
42 x 42 x 15  
42 x 42 x 22  
42 x 42 x 28  
42 x 42 x 35  
54 x 54 x 15  
54 x 54 x 22  
54 x 54 x 28  
54 x 54 x 35  
54 x 54 x 42

## MPF204

(90° Female Elbow with Wallplate)



### Dimensions

15 x 1/2"  
22 x 3/4"

## MPF302

(Tee With Male Thread End)



### Dimensions

15 x 15 x 1/2"  
22 x 22 x 3/4"  
28 x 28 x 1"  
35 x 35 x 1 1/4"  
42 x 42 x 1 1/2"  
54 x 54 x 2"  
22 x 22 x 1/2"  
28 x 28 x 1/2"  
35 x 35 x 1/2"  
42 x 42 x 1/2"  
54 x 54 x 1/2"

## MPF205

(45° Press-fit Elbow)



### Dimensions

15 x 15  
22 x 22  
28 x 28  
35 x 35  
42 x 42  
54 x 54

## MPF303

(Tee With Female Thread End)



### Dimensions

15 x 15 x 1/2"  
22 x 22 x 3/4"  
28 x 28 x 1"  
22 x 22 x 1/2"  
28 x 28 x 1/2"  
35 x 35 x 1/2"  
42 x 42 x 1/2"  
54 x 54 x 1/2"

## MPF205P

(45° Elbow With Plain End)



### Dimensions

15 x 15  
22 x 22  
28 x 28  
35 x 35  
42 x 42  
54 x 54

## MPF406 (Press-fit Cap)



### Dimensions

15  
22  
28  
35  
42  
54

# Preparation

1



Select the correct size of tube and fitting for the job. Ensure that both are clean, in good condition and free from damage and imperfections. Cut the tube square using a cutting tool such as a rotary tube cutter.

4



If a deburrer is not available use a fine file to prepare the tube end.

2

Care must be taken to ensure that tube is cut square, properly deburred and free from scores.



5



The tube must be fully inserted to the fitting until it meets the tube stop. Use a depth gauge or ruler to mark the insertion (socket) depth of the fitting onto the tube - see table.

3



Deburr both internal and external tube ends then wipe clean of all swarf and debris to avoid damage to the 'O' ring upon tube insertion.

## Socket Depth

Size	Socket Depth
15mm	20mm
22mm	21mm
28mm	23mm
35mm	26mm
42mm	30mm
54mm	35mm

## Press-fit Installation instruction

# 15mm to 54mm sizes

1



Keep all fitting in their bag prior to installation to ensure the lubrication does not dry out. Ensure the 'O' ring is seated correctly within the fitting socket.

2



Assemble the joint, ensuring the tube is inserted into fitting until it meets the stop, using the insertion depth mark as a visual aid. Only when the tube reached the tube stop should the pressing operation be undertaken.

3

Select the correct jaw for the joint being made, checking that they are free from damage. Attach the jaws, following the instructions for your particular press-tool, and reconnect the power supply when ready.

Insert the correctly sized jaw into pressing tool and place them over the bead at the mouth of the fitting.

4



A 90° angle between the tube and jaws must be maintained when pressing all joints. This will ensure the integrity of the joint as well as protecting you from "Kickback". The pressing operation should only be carried out when the tube is adequately supported by brackets, not when the tube is suspended in the fitting socket alone.

5



Keep your hands safely away from the joint and press the trigger or button to start the jointing cycle. When the jaws fully enclose the mouth of the fitting, the joint is complete. The jaw should then be released from around the fitting. If all is in order, mark the joint as complete.



The products specified in this brochure are subjected to continual development and improvement. Information in this brochure is subject to alteration without notice.