



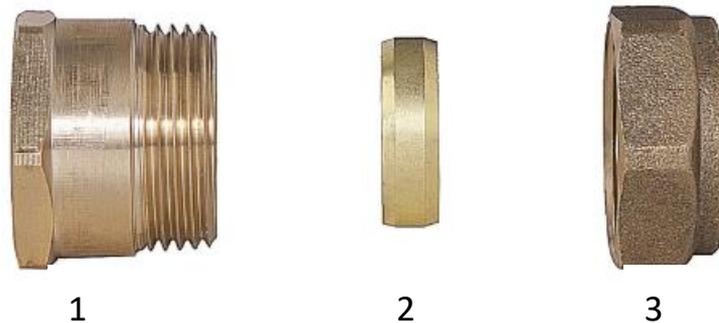
HS100 Brass Compression fittings for copper tube / stainless steel tube / plastic tube

HONSON HS100 brass compression fittings are specifically designed for use on hot and cold water services and heating installations. They are ideally compatible with copper, low carbon steel, stainless steel and a range of plastic pipe by means of compressing a brass ring onto the tube without the application of heat.

HONSON HS100 compression fittings as specified in EN1254-2 are suitable for use of the following pressures and temperatures.

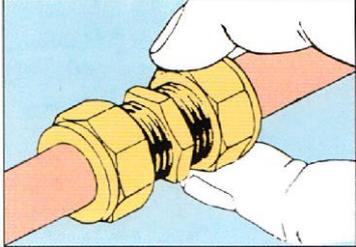
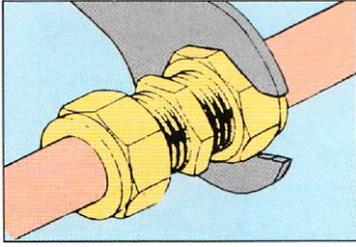
Medium	Service temp up to °C	Max working pressure	
		bar	psi
Water or Light Mineral Oils 10 to 54 mm sizes	30	16	230
	65	10	145
	110	6	87
	120	5	75
Saturated Steam	120	3	45
LPG & Natural Gas 10 to 28 mm sizes only	30	1	15

Structure



Item	Description	Material
1	Body	CW617N-4MS / HPb57-3 / DZR
2	Olive	Brass / Copper
3	Nut	CW617N-4MS / HPb57-3

Installation Instruction

<p>1. Cut the pipe to length, making sure that the cut is square and clean, the pipe is not deformed. Remove the burrs from the cut end.</p>	
<p>2. Slide the nut and ring onto the pipe, and insert the tube into the fitting fully.</p>	
<p>3. Tighten the nut onto the fitting until the pipe can't be rotated by hand. A drop of light machine oil on the threads will facilitate tightening (particularly on larger sizes)</p>	
<p>4. Tighten the nut with a good, well-fitting spanner and followed by the recommended minimum number of turns as shown below.</p>	

Types of Tube	Minimum Number of Turns As Per Size					
	10 - 15 mm	22 mm	28 mm	35 mm	42 mm	54 mm
EN 1057 Copper Tube	1 - 1 1/4	3/4 - 1	3/4-1	3/4-1	3/4-1	3/4-1
En 10312 Stainless Steel Tube	3/4	3/4	1/2	1/2	1/2	1/2

NOTES:

1. Seal tape, jointing compounds or sealants are not necessary with HS100 compression fittings; the use of these materials could impair the efficiency of the joint.
2. Over-tightening will not produce a better joint and may lead to problems in service.
3. For connecting plastic tube, a brass support sleeve should be inserted into the tube to reinforce pipe strength.

ADDITIONAL TECHNIQUE TO STRENGTHEN A JOINT - GROOVE METHOD

Groove method is now accepted as the most effective method of connection. It can be applied to copper tube (EN1057) or stainless steel tube (EN10312) especially for tube

sizes above 28mm. With the groove method, joints are strengthened and can withstand greater pressure. All that is needed is a normal cutter with a blunt blade and perform the following steps:

1. Repeat step 1 and 2.	
2. Remove the nut, hold the ring and tube with one hand and remove the body of fitting.	
3. Mark the position of the ring on the side nearest to the cut end of the tube.	
4. Position a tube cutter with the blade edge on the marked position (use only a blunt blade) and cut a circular groove around the tube.	
5. Roll a string seal tape over the groove for several rounds. Normal seal tape can be twirled into a string tape.	
6. Insert the body of the fitting back to the tube end and tighten the nut to the body with hand as far as possible.	
7. Tighten the nut with a spanner as usual.	

Features

- Suitable for gas, compressed air and water application
- Wide range of fittings from 8mm to 54mm
- WRAS Approved, compliant with the relevant British standards EN1254-2
- SABS Approved, compliant with SANS 1067-1:2005
- DVGW Approved

- Marked for full traceability
- High quality copper material options, CW617N-DW, DZR
- Surface treatment options: raw, chrome-plated, nickel-plated
- Fast and easy installation
- Eliminate the harsh noise during installation