Stainless Steel Compression Fitting Range

Stainless Steel Fittings

Stud Fittings

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Stainless Steel Compression Fittings

Manufactured in 316L stainless steel, these fittings combine all the advantages of the "universal" compression fitting with **excellent resistance** to environmental conditions and **corrosive fluids.** They are pressure and temperature-resistant and are able to withstand strong vibration and water hammer.

Product Advantages

For Use in Many Environments

- Manufactured in 316L stainless steel
- Suitable for all environments and fluids
- Resistant to water hammer and vibration
- Excellent sealing and retention of the tube
- Suitable for pneumatic and medium pressure hydraulic applications
- Metallic sealing guarantees maximum service life

Many Tube Options

- Possibility of easily connecting different tube materials and diameters to the same fitting body
- No tube support required for rigid and semi-rigid polyamide tubing below 12 mm

Applications

Food Process
Fluid Transmission
Pneumatics
Automotive Process
Petrochemical
Chemical
Offshore Oil & Gas

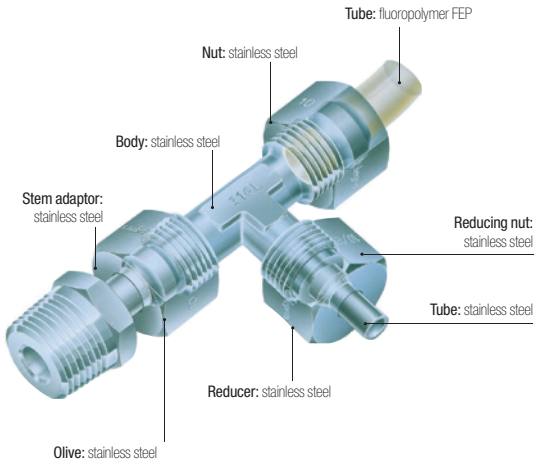
Technical Characteristics

Compatible Fluids	Many fluids
Working Pressure	Vacuum to 400 bar (80 bar in corrosive environments)
Working Temperature	-40°C to +250°C

Tightening Torques	DN	6	8	10	12	16
	daN.m	2	3	4	6.5	9.5

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

Component Materials



Silicone-free

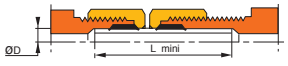
Maximum Bore Diameters

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

Tube O.D	BSPP Thread	Max. Bore
6	G1/8	4
6-8-10	G1/4	7
10-12	G3/8	11
16	G1/2	14

Tube Length for Assembly

Minimum length of tube (L) between 2 fittings.



ØD	L mm	ØD	L mm
4	26.5	10	39
6	26	12	39
8	32	16	46.5

Regulations

DI: 2002/95/EC (RoHS), 2011/65/EC
DI: 97/23/EC (PED)
RG: 1935/2004
RG: 1907/2006 (REACH)
DI: 94/09/EC (ATEX)
FDA: 21 CFR 177.1550
NACE MR0175: compatible materials
ISO 15156-1/-2/-3: compatible materials

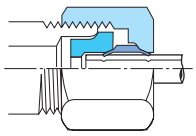
Stainless Steel Compression Fittings

Installation

Fitting

The fitting comprises three parts (body/olive/nut). For assembly procedure, please see Brass Compression Fitting page.

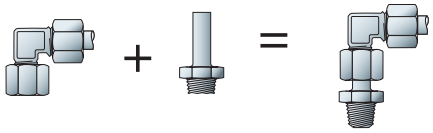
Diagram: Assembled Fitting



A very slight distortion of the tube appears; this shows the fitting has been correctly tightened.

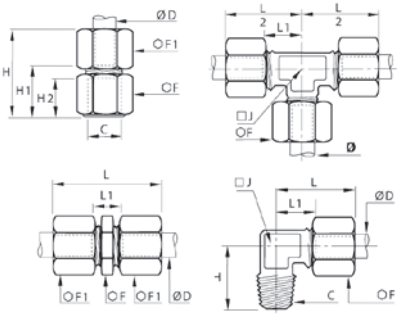
Orientable Elbow Assembly

Elbow **1802** + Adaptor **1820** =



Customised Fittings

If our standard range does not meet your needs, Parker Legris can develop customised solutions for your applications.



Technical Characteristics

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

Recommended Tube Type

Semi-rigid polyamide or fluoropolymer tube

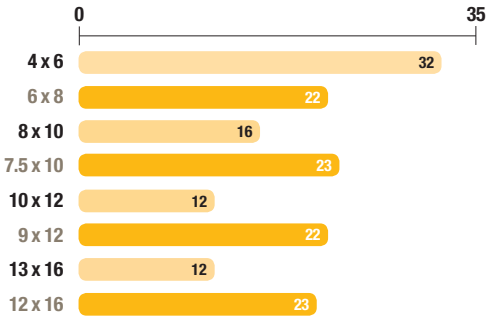
Stainless steel tube
"Thin Wall" cold-drawn seamless, annealed and passivated:
wall thickness tolerance +/-0.1 mm.
For use with "thin wall" stainless steel tube from 6 mm to 16 mm O.D., maximum wall thickness 1 mm.

Recommended Tube/Fitting Assembly Configurations

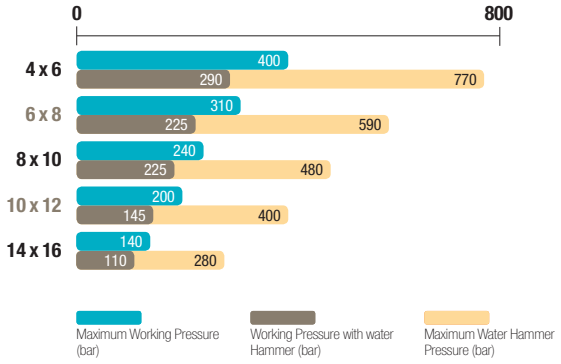
Assembled using Parker Legris olive and nut in stainless steel, with a tube support.

Stainless steel tube
Stainless steel tube: in cold-rolled straight lengths
Coiled annealed stainless tube : reduces working pressure by 35%; do not use if there is vibration.

Semi-Rigid Polyamide Tube
Maximum Working Pressure (bar)



Stainless Steel Tube
Maximum Working Pressure (bar)



Working Pressure Coefficients for Semi-Rigid Tubing

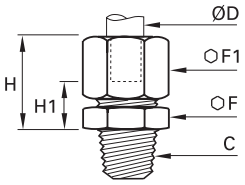
Temperature °C	-40°C / -15°C	-15°C / +30°C	+30°C / +50°C	+50°C/+70°C	+70°C/+100°C
Factor	1.8	1	0.68	0.55	0.31

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

Stainless Steel Compression Fittings

1805 Stud Fitting, Male BSPT Thread

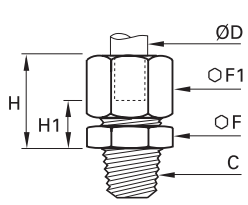
Stainless steel 316L



ØD	C		F	F1	H max	H1	kg
6	R1/8	1805 06 10	12	13	19.5	7.5	0.017
	R1/4	1805 06 13	14	13	19.5	7.5	0.025
8	R1/8	1805 08 10	13	14	21	7	0.019
	R1/4	1805 08 13	14	14	21	7	0.024
10	R1/4	1805 10 13	17	19	25.5	9	0.044
	R3/8	1805 10 17	17	19	25.5	9	0.049
	R1/2	1805 10 21	22	19	26.5	10	0.076
12	R1/4	1805 12 13	19	22	26	9	0.054
	R3/8	1805 12 17	19	22	26	9	0.058
	R1/2	1805 12 21	22	22	27	10	0.081
16	R3/8	1805 16 17	24	27	28.5	9.5	0.086
	R1/2	1805 16 21	24	27	28.5	9.5	0.094

1805 Stud Fitting, Male NPT Thread

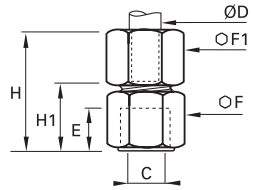
Stainless steel 316L



ØD	C		F	F1	H max	H1	kg
6	NPT1/8	1805 06 11	12	13	19.5	7.5	0.018
	NPT1/4	1805 06 14	14	13	19.5	7.5	0.027
	NPT3/8	1805 06 18	19	13	20.5	8.5	0.033
	NPT1/2	1805 06 22	22	13	21.5	9.5	0.049
8	NPT1/8	1805 08 11	13	14	21	7	0.020
	NPT1/4	1805 08 14	14	14	21	7	0.027
10	NPT1/4	1805 10 14	17	19	25.5	9	0.045
	NPT3/8	1805 10 18	19	19	25.5	9	0.055
	NPT1/2	1805 10 22	22	19	26.5	10	0.083
12	NPT1/4	1805 12 14	19	22	26	9	0.056
	NPT3/8	1805 12 18	19	22	26	9	0.061
	NPT1/2	1805 12 22	22	22	27	10	0.087
16	NPT3/8	1805 16 18	24	27	28.5	9.5	0.087
	NPT1/2	1805 16 22	24	27	28.5	9.5	0.097

1814 Stud Fitting, Female BSPP Thread

Stainless steel 316L

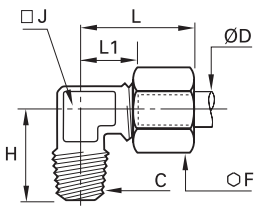


ØD	C		E	F	F1	H max	H1	kg
6	G1/8	1814 06 10	7.5	14	13	29	17	0.023
	G1/4	1814 06 13	11	17	13	29	21	0.032
8	G1/4	1814 08 13	11	17	14	34.5	20.5	0.033
10	G3/8	1814 10 17	11.5	22	19	38.5	22	0.064
	G1/2	1814 10 21	15	27	19	43	26.5	0.093
12	G3/8	1814 12 17	11.5	22	22	39	22	0.072
	G1/2	1814 12 21	15	27	22	43.5	26.5	0.100
16	G1/2	1814 16 21	15	27	27	45	26	0.120

Stainless Steel Compression Fittings

1809 Stud Elbow, Male BSPT Thread

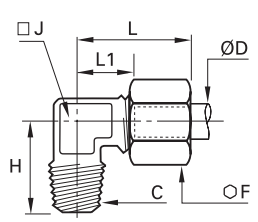
Stainless steel 316L



ØD	C		F	H	J	L max	L1	kg
6	R1/8	1809 06 10	13	18	8	25.5	13.5	0.021
	R1/4	1809 06 13	13	23	10	25.5	13.5	0.030
8	R1/8	1809 08 10	14	20.5	10	28.5	14.5	0.027
	R1/4	1809 08 13	14	23	10	28.5	14.5	0.031
10	R1/4	1809 10 13	19	25	12	32.5	16	0.050
	R3/8	1809 10 17	19	25.5	12	32.5	16	0.058
	R1/2	1809 10 21	19	32	18	36.5	20	0.091
12	R1/4	1809 12 13	22	26	14	34	17	0.067
	R3/8	1809 12 17	22	27	14	34	17	0.070
	R1/2	1809 12 21	22	32	18	37	20	0.098
16	R3/8	1809 16 17	27	28.5	18	39.5	21	0.107
	R1/2	1809 16 21	27	31.5	18	39.5	21	0.114

1809 Stud Elbow, Male NPT Thread

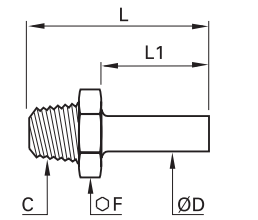
Stainless steel 316L



ØD	C		F	H	J	L max	L1	kg
6	NPT1/8	1809 06 11	13	19.5	8	25.5	13.5	0.022
	NPT1/4	1809 06 14	13	25.5	10	25.5	13.5	0.031
	NPT3/8	1809 06 18	13	28	12	27	15	0.046
	NPT1/2	1809 06 22	13	34	12	29	17	0.072
8	NPT1/8	1809 08 11	14	22	10	28.5	14.5	0.028
	NPT1/4	1809 08 14	14	25.5	10	28.5	14.5	0.033
10	NPT1/4	1809 10 14	19	27.5	12	32.5	16	0.052
	NPT3/8	1809 10 18	19	28	12	32.5	16	0.061
	NPT1/2	1809 10 22	19	35	18	36.5	20	0.096
12	NPT1/4	1809 12 14	22	28.5	14	34	17	0.069
	NPT3/8	1809 12 18	22	29.5	14	34	17	0.074
	NPT1/2	1809 12 22	22	35	18	37	20	0.102
16	NPT3/8	1809 16 18	27	31	18	39.5	21	0.110
	NPT1/2	1809 16 22	27	34.5	18	39.5	21	0.116

1820 Stud Standpipe, Male BSPT Thread

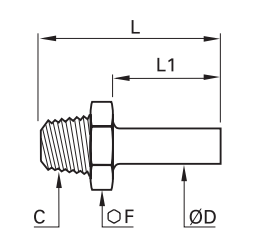
Stainless steel 316L



ØD	C		F	L	L1	kg
6	R1/8	1820 06 10	12	26.5	15	0.009
	R1/4	1820 06 13	14	31	15	0.017
8	R1/8	1820 08 10	12	28.5	17	0.008
	R1/4	1820 08 13	14	33	17	0.016
10	R1/4	1820 10 13	14	36	20	0.016
	R3/8	1820 10 17	17	36.5	20	0.025
	R1/2	1820 10 21	22	41	20	0.052
12	R1/4	1820 12 13	14	36	20	0.016
	R3/8	1820 12 17	17	36.5	20	0.022
	R1/2	1820 12 21	22	41	20	0.048
16	R3/8	1820 16 17	17	39.5	23	0.022
	R1/2	1820 16 21	22	44	23	0.038

1820 Stud Standpipe, Male NPT Thread

Stainless steel 316L

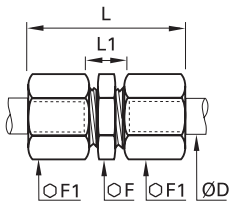


ØD	C		F	L	L1	kg
6	NPT1/8	1820 06 11	12	26.5	15	0.009
	NPT1/4	1820 06 14	14	31	15	0.019
8	NPT1/8	1820 08 11	12	28.5	17	0.009
	NPT1/4	1820 08 14	14	33	17	0.019
10	NPT1/4	1820 10 14	14	36	20	0.018
	NPT3/8	1820 10 18	19	36.5	20	0.032
	NPT1/2	1820 10 22	22	41	20	0.060
12	NPT1/4	1820 12 14	14	36	20	0.019
	NPT3/8	1820 12 18	19	36.5	20	0.028
	NPT1/2	1820 12 22	22	41	20	0.053
16	NPT3/8	1820 16 18	19	39.5	23	0.027
	NPT1/2	1820 16 22	22	44	23	0.042

Stainless Steel Compression Fittings

1806 Equal Tube-to-Tube Connector

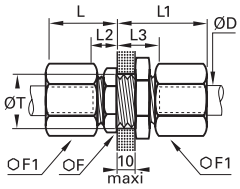
Stainless steel 316L



ØD		F	F1	L max	L1	kg
6	1806 06 00	12	13	34.5	11	0.025
8	1806 08 00	13	14	38.5	10	0.029
10	1806 10 00	17	19	46	13	0.066
12	1806 12 00	19	22	47	13	0.085
16	1806 16 00	24	27	51	13	0.135

1816 Equal Bulkhead Connector

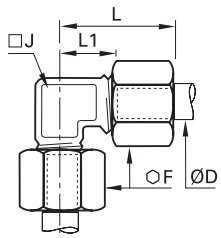
Stainless steel 316L



ØD		F	F1	L max	L1 max	L2	L3	ØT min	kg
6	1816 06 00	13	13	28	19	7.5	17	10.5	0.034
8	1816 08 00	14	14	29	20	7	17	12.5	0.042
10	1816 10 00	19	19	33	25	9	19	16.5	0.094
12	1816 12 00	22	22	33	25	9	19	18.5	0.113
16	1816 16 00	27	27	36	28	9.5	19.5	22.5	0.179

1802 Equal Elbow

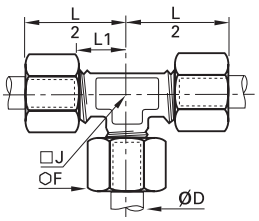
Stainless steel 316L



ØD		F	J	L max	L1	kg
6	1802 06 00	13	8	25.5	13.5	0.028
8	1802 08 00	14	10	28.5	14.5	0.035
10	1802 10 00	19	12	32.5	16	0.071
12	1802 12 00	22	14	34	17	0.093
16	1802 16 00	27	18	39.5	21	0.151

1804 Equal Tee

Stainless steel 316L



ØD		F	J	L1	L/2	kg
6	1804 06 00	13	8	13.5	25.5	0.040
8	1804 08 00	14	10	14.5	28.5	0.050
10	1804 10 00	19	12	16	32.5	0.103
12	1804 12 00	22	14	17	34	0.133
16	1804 16 00	27	18	21	39.5	0.214

Complementary Stainless Steel Fittings
Reducers, Olives and Nuts

This innovative reducer system, using a full range of nuts and olives, enables **different diameters** of stainless steel, fluoropolymer or polymer tubes to be fitted onto **a single Parker Legris compression fitting**.

Product Advantages

Efficient Solution

- Reduces envelope dimensions
- Quick and easy to assemble, whatever the diameters and tube material
- Improved stock management
- Silicone-free

Multiple Combinations

A single connector for up to 3 different tube materials and sizes.

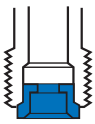
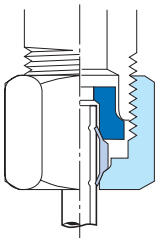
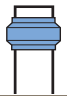
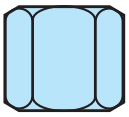
Example:
- Advanced PE tubing 6 mm O.D.
- stainless steel tubing 8 mm O.D.
- fluoropolymer tubing 12 mm O.D. or braided PVC hose 10 mm I.D.

A full range of olives and nuts to optimise all assembly operations

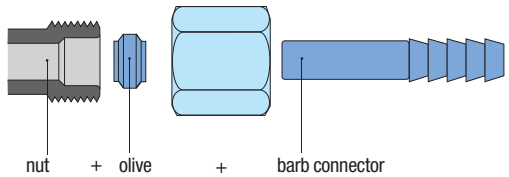
Applications

Food Process
Fluid Transmission
Pneumatics
Automotive Process
Petrochemical
Cooling & Heating
Chemical
Offshore Oil & Gas

Reducer Assembly Procedure

Operation	Assembly Sequence	Assembled Fitting
1 **Assemble the reducer** Place the reducer in the fitting body.	1 	
2 **Assemble the nut and olive** Place the nut and then the olive onto the tube.	2 	
3 **Assemble the nut** Push the tube into the fitting until it bottoms on the reducer. Tighten the nut to the recommended torque (see opposite page).	3 	

Assembly: Barb Connectors



Our barb connector 1822 is designed to be also used with different types of hose.
It is secured using the nut and olive provided with the fitting.

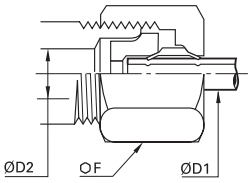
Regulations

DI: 2002/95/EC (RoHS), 2011/65/EC
DI: 97/23/EC (PED)
RG: 1935/2004
RG: 1907/2006 (REACH)
DI: 94/09/EC (ATEX)
FDA: 21 CFR 177.1550
NACE MR0175: compatible materials
ISO 15156-1/-2/-3: compatible materials

Stainless Steel Compression Fittings

1866 3-Piece Reducer

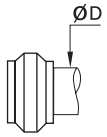
Stainless steel 316L



ØD1	ØD2		F	kg
6	8	1866 06 08	14	0.011
	10	1866 06 10	19	0.028
	12	1866 06 12	22	0.040
8	10	1866 08 10	19	0.026
	12	1866 08 12	22	0.037
	16	1866 08 16	27	0.071
10	12	1866 10 12	22	0.034
	16	1866 10 16	27	0.065
12	16	1866 12 16	27	0.061

1824 Stainless Steel Olive

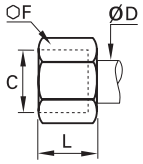
Stainless steel 316L



ØD		kg
6	1824 06 00	0.001
8	1824 08 00	0.001
10	1824 10 00	0.003
12	1824 12 00	0.004
16	1824 16 00	0.005

1810 Stainless Steel Nut

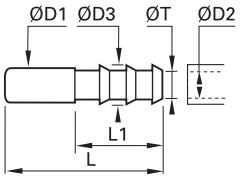
Stainless steel 316L



ØD	C		F	L	kg
6	M10x1	1810 06 00	13	11	0.007
8	M12x1	1810 08 00	14	13	0.008
10	M16x1.5	1810 10 00	19	15	0.017
12	M18x1.5	1810 12 00	22	15	0.024
16	M22x1.5	1810 16 00	27	17	0.041

1822 Barb Adaptor for Hose

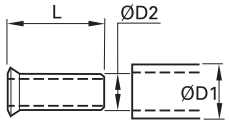
Stainless steel 316L



ØD1	ØD2		ØD3	L	L1	ØT min	kg
6	7	1822 06 07	9	37.5	22.5	6	0.006
8	6	1822 08 06	8	40	22.5	5	0.007
	7	1822 08 07	9	40	22.5	6	0.007
	10	1822 08 10	12.5	40	22.5	9	0.011
10	7	1822 10 07	9	43	22.5	6	0.009
	10	1822 10 10	12.5	43	22.5	9	0.013
12	10	1822 12 10	12.2	43	22.5	9	0.012
	13	1822 12 13	15	50	29.5	13	0.016

1827 Stainless Steel Tube Support

Stainless steel 316L



ØD1	ØD2		L	kg
6	4	1827 06 00	11.5	0.001
8	6	1827 08 00	14	0.001
10	8	1827 10 00	18	0.001
12	9	1827 12 09	18	0.001
	10	1827 12 00	18	0.001
16	14	1827 16 00	18	0.002

This tube support is necessary when using fluoropolymer tubing at all temperatures compatible with the fitting/tubing assembly.