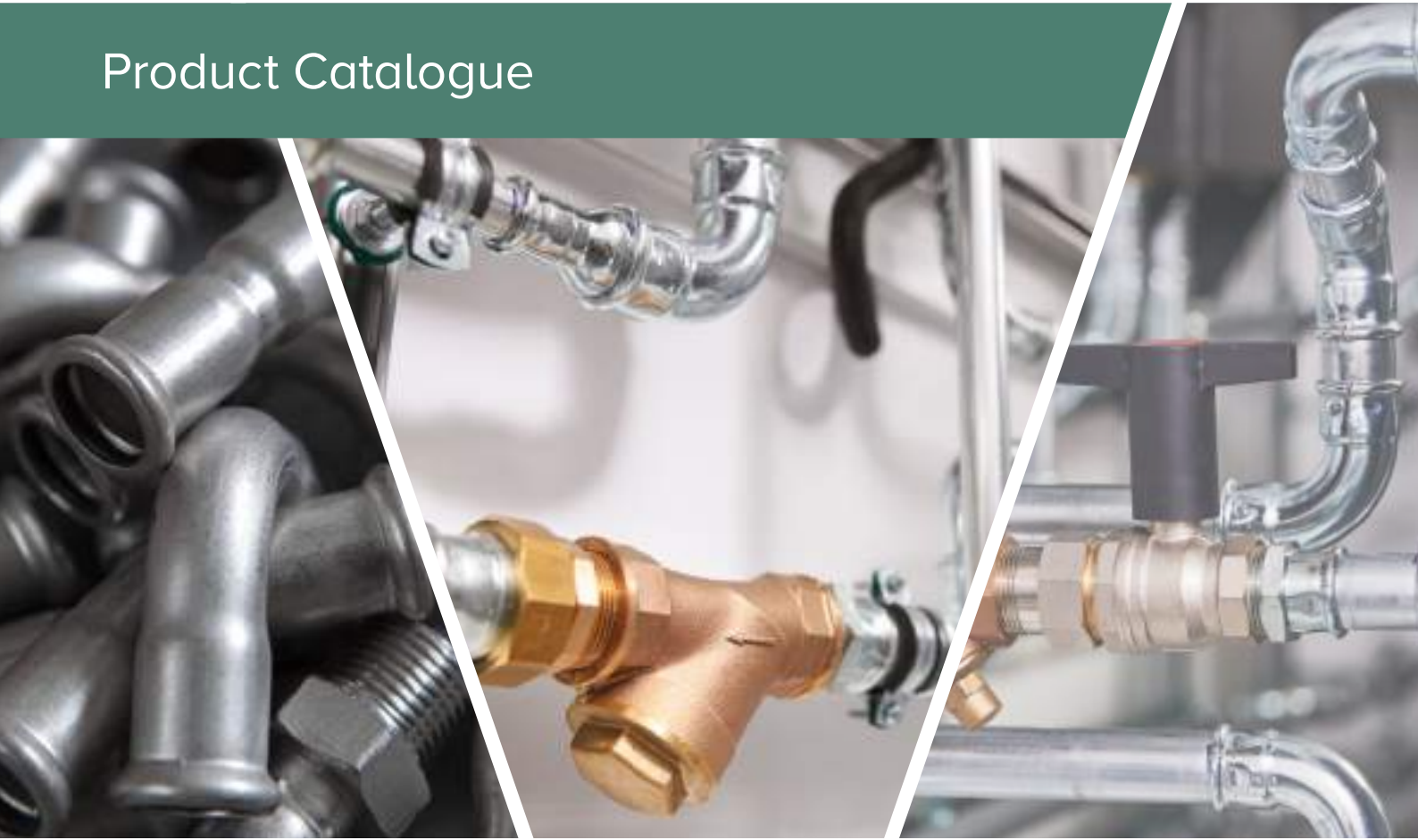




Product Catalogue



# Stainless Steel Press Fittings

[www.melco.com.sg](http://www.melco.com.sg)

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# MELCO

## Quality Without Compromise.

### Vision

“To be recognized as a global trademark of Quality and Reliability”

### Mission

“To be a One-Stop centre delivering products, solutions and services of the highest quality to the plumbing industry”

### ABOUT US

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Since its inception in 1990, RFT Marketing have expanded and diversified over the past three decades to become a leading supplier in the plumbing industry. Equipped with extensive industry knowledge and supported by key manufacturers in Asia, Asia Pacific and Europe, we have access to international resources which includes world class manufacturing facilities and extensive research and development. This enables us to embark on a mission to explore new opportunities and gives our customers access to installation solutions that are optimized for efficiency, time and quality.

MELCO – the widely recognized brand identity of RFT Marketing, has been synonymous with the supply of quality products for various applications in the plumbing industry, and we have built its success on a continuous product development. Apart from producing traditional fittings, our range were expanded to include green technology – Press-fit solution which offers flame-free, quick and easy installation, and a leak proof joint.

With a heritage of quality and reliability, we provide construction professionals a complete solution of Connect and Control installations for use with copper, stainless steel and plastic components.

# Awards & Accolades

For the past 20 years, RFT Marketing has been building its reputation for supplying quality products backed by first class customer service and unrivalled expertise. The continuous success of RFT Marketing is built firmly on 3 strategic pillars: Brand Management, Product

Development and Proactive Customer Relationship Management. This put us in good stead with our strategic partners and we are widely recognized as the undeniable market leader that has won numerous accolades for its brand and management.

## EYA

In commendation of our founder's committed entrepreneurship and tenacious efforts towards the company, we were conferred with The Entrepreneur of the Year Award. His strong leadership values have successfully navigated RFT Marketing forward to today's business landscape.

This award is organized by the Association of Small & Medium Enterprises and the Rotary Club of Singapore.



## SPBA

In recognition of our branding excellence, MELCO was awarded as a winner in the Singapore Prestige Brand Award in the category of Established Brand. This is an important milestone and elevated our brand to another level.

This award is organized by the Association of Small & Medium Enterprises and LianHe Zaobao Newspaper.



## SINGAPORE 500/1000

In view of our outstanding financial performances, we are acknowledge as a SME 500 and S1000 company from 2010 - 2019.

The event is organized and ranked by DP Information Group.



## ISO 9001

Since 2001, RFT Marketing is certified to be in conformance with ISO 9001. It reflects deeply on us as one who seek continuous implementation and improvement to our business processes.







## MPF Series

MELCO “M” profile stainless steel press fittings are produced in AISI 304 and 316L material, in sizes 15mm to 54mm, and they comply with the stringent requirements of BS EN 1254-2, AS 3688 and JWWA G116.

Incorporating a high quality rubber O-ring made of Ethylene Propylene Diene Monomer (EPDM), MELCO stainless steel press fittings offer a strong

resistance against aging, high pressure and temperature.

MELCO press solution is a simple and quick way of jointing tubes. With the assistance of a press tool, a permanent hydraulic tightness is obtained by crimping the press fitting onto the tube. It is suitable for carrying water in domestic and commercial applications such as plumbing and fire fighting.

### Features & Benefits

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- ☑ Produced in AISI 304 and 316L.
- ☑ Added confidence in every joint with test complying to various international standards.
- ☑ High resistance against corrosion and proven hygienic properties.
- ☑ Exceptionally fast and reliable jointing method which result in cost saving.
- ☑ Suitable for connecting stainless steel tube to BS EN 10312.
- ☑ Available from sizes 15mm to 54mm.

## Stainless Steel Press Fittings

### MPF101



#### COUPLING F/F

Product Size	
15mm x 15mm	35mm x 35mm
22mm x 22mm	42mm x 42mm
28mm x 28mm	54mm x 54mm

### MPF101P



#### REDUCER M/F

Product Size	
22mm x 15mm	42mm x 28mm
28mm x 15mm	42mm x 35mm
28mm x 22mm	54mm x 15mm
35mm x 15mm	54mm x 22mm
35mm x 22mm	54mm x 28mm
35mm x 28mm	54mm x 35mm
42mm x 15mm	54mm x 42mm
42mm x 22mm	

### MPF101R



#### REDUCING COUPLING F/F

Product Size	
22mm x 15mm	42mm x 28mm
28mm x 15mm	42mm x 35mm
28mm x 22mm	54mm x 15mm
35mm x 15mm	54mm x 22mm
35mm x 22mm	54mm x 28mm
35mm x 28mm	54mm x 35mm
42mm x 15mm	54mm x 42mm
42mm x 22mm	

### MPF101S



#### SLIP COUPLING F/F

Product Size	
15mm x 15mm	35mm x 35mm
22mm x 22mm	42mm x 42mm
28mm x 28mm	54mm x 54mm

### MPF102



#### MALE ADAPTOR

Product Size	
15mm x 1/2"	28mm x 3/4"
22mm x 3/4"	28mm x 1-1/4"
28mm x 1"	28mm x 1-1/2"
35mm x 1-1/4"	35mm x 1-1/2"
42mm x 1-1/2"	35mm x 2"
54mm x 2"	42mm x 1-1/4"
15mm x 3/4"	42mm x 2"
15mm x 1"	54mm x 1-1/4"
22mm x 1/2"	54mm x 1-1/2"
22mm x 1"	54mm x 2"
28mm x 1/2"	

### MPF103



#### FEMALE ADAPTOR

Product Size	
15mm x 1/2"	22mm x 1/2"
22mm x 3/4"	22mm x 1"
28mm x 1"	28mm x 1/2"
35mm x 1-1/4"	28mm x 3/4"
42mm x 1-1/2"	35mm x 1/2"
54mm x 2"	42mm x 1/2"
15mm x 3/4"	54mm x 1/2"
15mm x 1"	

## MPF201



### 90DEG ELBOW F/F

Product Size	
15mm x 15mm	35mm x 35mm
22mm x 22mm	42mm x 42mm
28mm x 28mm	54mm x 54mm

## MPF201P



### 90DEG ST ELBOW M/F

Product Size	
15mm x 15mm	35mm x 35mm
22mm x 22mm	42mm x 42mm
28mm x 28mm	54mm x 54mm

## MPF201R



### REDUCING ELBOW F/F

Product Size	
22mm x 15mm	42mm x 28mm
28mm x 15mm	42mm x 35mm
28mm x 22mm	54mm x 15mm
35mm x 15mm	54mm x 22mm
35mm x 22mm	54mm x 28mm
35mm x 28mm	54mm x 35mm
42mm x 15mm	54mm x 42mm
42mm x 22mm	

## MPF202



### MALE ELBOW

Product Size	
15mm x 1/2"	28mm x 1/2"
22mm x 3/4"	28mm x 3/4"
28mm x 1"	35mm x 1/2"
35mm x 1-1/4"	35mm x 1"
42mm x 1-1/2"	42mm x 1/2"
54mm x 2"	42mm x 1"
22mm x 1/2"	54mm x 1/2"
22mm x 1"	54mm x 1"

## MPF203



### FEMALE ELBOW

Product Size	
15mm x 1/2"	22mm x 1"
22mm x 3/4"	28mm x 1/2"
28mm x 1"	28mm x 3/4"
35mm x 1-1/4"	35mm x 1/2"
42mm x 1-1/2"	42mm x 1/2"
54mm x 2"	54mm x 1/2"
22mm x 1/2"	

## MPF204



### FEMALE FLANGE ELBOW

Product Size
15mm x 1/2"
22mm x 3/4"

## Stainless Steel Press Fittings

### MPF205



**45DEG  
ELBOW F/F**

Product Size	
15mm x 15mm	35mm x 35mm
22mm x 22mm	42mm x 42mm
28mm x 28mm	54mm x 54mm

### MPF205P



**45DEG ST  
ELBOW M/F**

Product Size	
15mm x 15mm	35mm x 35mm
22mm x 22mm	42mm x 42mm
28mm x 28mm	54mm x 54mm

### MPF301



**EQUAL TEE  
F/F/F**

Product Size	
15mm	35mm
22mm	42mm
28mm	54mm

### MPF301R



**REDUCING TEE  
F/F/F**

Product Size *
22 x 22 x 15mm
28 x 28 x 15mm
28 x 28 x 22mm
35 x 35 x 15mm
35 x 35 x 22mm
35 x 35 x 28mm
42 x 42 x 15mm
42 x 42 x 22mm
42 x 42 x 28mm
42 x 42 x 35mm
54 x 54 x 15mm
54 x 54 x 22mm
54 x 54 x 28mm
54 x 54 x 35mm
54 x 54 x 42mm

\* Sequence of sizes: Side x Side x Center  
eg. 22 (side) x 22 (side) x 15mm (center)

### MPF302



**MALE TEE**

Product Size *	
15 x 15mm x 1/2"	28 x 28mm x 3/4"
22 x 22mm x 3/4"	35 x 35mm x 1/2"
28 x 28mm x 1"	35 x 35mm x 1"
35 x 35mm x 1-1/4"	42 x 42mm x 1/2"
42 x 42mm x 1-1/2"	42 x 42mm x 1"
54 x 54mm x 2"	54 x 54mm x 1/2"
22 x 22mm x 1/2"	54 x 54mm x 1"
28 x 28mm x 1/2"	

\* Sequence of sizes: Side x Side x Center  
eg. 22 (side) x 22mm (side) x 1/2" (center)

### MPF303



**FEMALE TEE**

Product Size *	
15 x 15mm x 1/2"	35 x 35mm x 1/2"
22 x 22mm x 3/4"	35 x 35mm x 1"
28 x 28mm x 1"	42 x 42mm x 1/2"
22 x 22mm x 1/2"	42 x 42mm x 1"
28 x 28mm x 1/2"	54 x 54mm x 1/2"
28 x 28mm x 3/4"	54 x 54mm x 1"

\* Sequence of sizes: Side x Side x Center  
eg. 22 (side) x 22mm (side) x 1/2" (center)

### MPF401



**STOP END**

Product Size	
15mm	35mm
22mm	42mm
28mm	54mm



## Operating Parameters

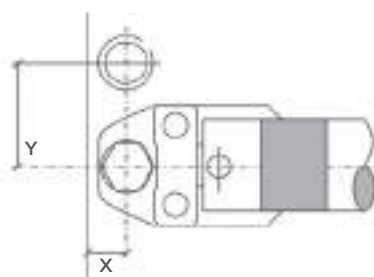
The maximum operating temperatures and pressures are shown in Table 1.

STAINLESS STEEL TUBE			
For use with	Tube sizes	Temps not exceeding	Max working pressures
	Ø mm	°C	Bar
Potable Water	15 to 54	25	16
		95	10
		115	6

Table 1

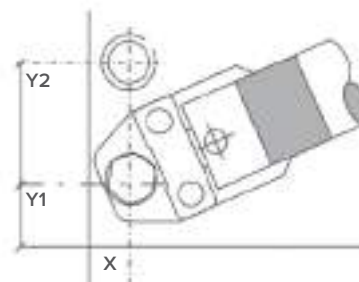
## Space Requirements For Pressing Process

The following minimum clearances are required from structural components to allow operation of tool for press fitting.



Space required for the pressing process between fittings		
External tube	X	Y
Size mm	mm	mm
12	26	51
15	26	53
18	26	54
22	26	54
28	33	69
35	33	73
42	75	115
54	85	120

Table 2



Space required for the pressing process between fittings			
External tube	X	Y1	Y2
Size mm	mm	mm	mm
12	31	45	71
15	31	45	73
18	31	45	74
22	31	45	76
28	38	55	80
35	38	55	85
42	75	75	115
54	85	85	140

Table 3

## Compatible Press Tools \*

15 – 35mm Compact Press Tool & 15 - 54mm Standard 32 kN Press Tool			
Manufacturer	Press Tool	Press Jaws	Jaw Profile
Novopress	ACO 102	Novopress PB1	M
Novopress	ACO 103	Novopress PB1	M
REMS	Mini Press ACC	REMS Mini	M
Novopress	ECO / ACO 202	Novopress PB2	M
Novopress	ECO / ACO 203	Novopress PB2	M
REMS	Power Press ACC	REMS Standard	M
REMS	Akku Press ACC	REMS Standard	M

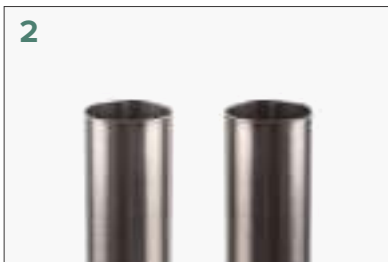
Table 4

\* Press tools must be maintained according to the respective manufacturer's guidelines. For press tools outside those stated in the table above, please contact our technical department for clarification.

## Stainless Steel Tube Preparation



Select the correct size of tube and cut the tube square using a cutting tool such as a rotary tube cutter. (Fig. 1)



Care must be taken to ensure that tube is cut square, properly deburred and free from scores. (Fig. 2)



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. (Fig. 3a)

If a deburrer is not available, use a fine file to prepare the tube end. (Fig. 3b)



The tube must be fully inserted to the fitting until it meets the tube stop.

Use a depth gauge (Fig. 4a) or ruler (Fig. 4b) to mark the insertion socket depth of the fitting onto the tube.

Refer to Table 5 for the insertion socket depth requirements.

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

Table 5

## Press Fit Installation 15mm to 54mm



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. (Fig. 1)



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. (Fig. 2)



Select the correct jaw for the joint being made, checking that they are free from damage. Attach the correctly sized jaw, following the instructions for your particular press-tool, and reconnect the power supply when ready. Place them over the bead at the mouth of the fitting. (Fig. 3)



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. (Fig. 4)



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. (Fig. 5)

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