

AUTOMATIC TUBE WELD FITTINGS



SANKO KOGYO CO., LTD.

<http://www.jsk-sanko.co.jp>



AUTOMATIC TUBE WELD FITTINGS

Components are ordered by product code as listed in this catalogue

DESIGNATIONS PART NUMBER SYSTEM

| | | | | |
|----------|----------|----------|----------|-----------|
| M | E | 4 | S | EP |
| ① | ② | ③ | ④ | ⑤ |

| | | |
|----------|---|---------------------------|
| ① Series | M | Micro Fitting L=6.35 mm |
| | S | Short Fitting L=10 mm |
| | L | Forged Fitting L=19.05 mm |

| | | |
|-----------|----|---------|
| ② Product | E | Elbow |
| | T | Tee |
| | CT | Cross |
| | TB | Tribow |
| | R | Reducer |

| | | |
|--------|----|---------|
| ③ Size | 2 | 1/8" OD |
| | 4 | 1/4" OD |
| | 6 | 3/8" OD |
| | 8 | 1/2" OD |
| | 12 | 3/4" OD |
| | 16 | 1" OD |

| | | |
|------------|---|-----------------------|
| ④ Material | S | Single Melt (316L) |
| | V | Double Melt (VIM+VAR) |

| | | |
|-------------|----|------------|
| ⑤ Finishing | BA | Ry < 3.0μm |
| | EP | Ry < 0.7μm |



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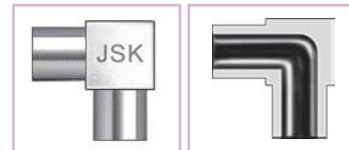


AUTOMATIC TUBE WELD FITTINGS



■ Features

- 316L VIM/VAR material.
- Permanently heat code marked; traceable to original mill certificated of test.
- Electropolished components permanently marked with designator on cube (P or PX)
- Critical surfaces are 100% visually inspected using magnification and lighting.



■ Materials

- 316 VIM/VAR materials comply with ASTM A267 and ASME SA479. Recommended tubing specifications will be including ASME SA213, ASTM A213, ASTM A249, ASTM A269, MIL T8506 and JIS G4303.

■ Specifications

- Pressure Ratings will be governed by the tubing selected for a particular application. Working Pressures are calculated below for tubing using maximum allowable stress levels in accordance with ASME/ANSI B31.3, at ambient temperature.
- Dimensions are for reference only and are subjected to change.
- Internal Surface Finishes: Standard Finish Micro Fittings have an internal Surface Roughness of 3.0µm Ry. Electropolished Micro Fittings have an internal Surface Roughness of 0.7µm Ry.

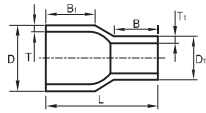
| Tube O.D. | Pressure Rating | | Normal Wall Thickness mm |
|-----------|-----------------|---------------------|--------------------------|
| | psig | kgf/cm ² | |
| 1/4"OD | 5100 | 358 | 1.0 (0.89) |
| 3/8"OD | 3300 | 232 | 1.0 (0.89) |
| 1/2"OD | 3500 | 246 | 1.24mm |
| 3/4"OD | 2400 | 160 | 1.65mm |

Optional: 1/4"OD Wall Thickness 0.89mm

| Designator | Surface Finish(Ry) |
|------------|--------------------|
| | Maximum |
| EP | 0.7 µm |
| BA | 3.0 µm |



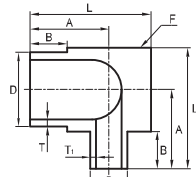
MICRO WELD FITTINGS



□: BA or EP

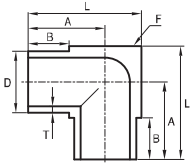
Micro Reducer (MR)

| Size (OD) | Size (OD ₁) | Ordering Number | D | D ₁ | T | T ₁ | B | B ₁ | L |
|-----------|-------------------------|-----------------|-------|----------------|------|----------------|------|----------------|------|
| 3/8" | 1/4" | MR64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 6.35 | 10.4 | 19.1 |
| 1/2" | 1/4" | MR84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 6.35 | 10.4 | 19.1 |
| 1/2" | 3/8" | MR86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 6.35 | 10.4 | 19.1 |
| 3/4" | 1/4" | MR124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 6.35 | 10.4 | 19.1 |
| 3/4" | 3/8" | MR126S□ | 19.05 | 9.53 | 1.65 | 1.00 | 6.35 | 10.4 | 19.1 |
| 3/4" | 1/2" | MR128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 6.35 | 10.4 | 19.1 |



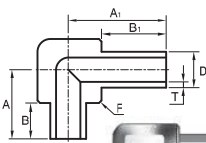
Micro Reducing 90° Elbow (ME)

| Size (OD) | Size (OD ₁) | Ordering Number | D | D ₁ | T | T ₁ | A | B | F Body Cube | L |
|-----------|-------------------------|-----------------|-------|----------------|------|----------------|-------|------|-------------|-------|
| 3/8" | 1/4" | ME64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 11.91 | 6.35 | 11.11 | 17.46 |
| 1/2" | 1/4" | ME84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 13.50 | 6.35 | 14.29 | 20.64 |
| 1/2" | 3/8" | ME86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 13.50 | 6.35 | 14.29 | 20.64 |
| 3/4" | 1/4" | ME124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 16.68 | 6.35 | 20.65 | 27.00 |
| 3/4" | 3/8" | ME126S□ | 19.05 | 9.53 | 1.65 | 1.00 | 16.68 | 6.35 | 20.65 | 27.00 |
| 3/4" | 1/2" | ME128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 16.68 | 6.35 | 20.65 | 27.00 |



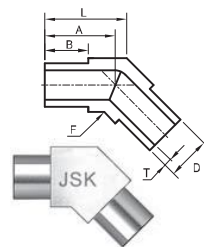
Micro 90° Elbow (ME)

| Size (OD) | Ordering Number | D | T | A | B | F Body Cube | L |
|-----------|-----------------|-------|------|-------|------|-------------|-------|
| 1/4" | ME4S□ | 6.35 | 1.00 | 10.32 | 6.35 | 7.94 | 14.29 |
| 3/8" | ME6S□ | 9.53 | 1.00 | 11.91 | 6.35 | 11.11 | 17.46 |
| 1/2" | ME8S□ | 12.70 | 1.24 | 13.50 | 6.35 | 14.29 | 20.64 |
| 3/4" | ME12S□ | 19.05 | 1.65 | 16.68 | 6.35 | 20.65 | 27.00 |



Micro Extended Leg 90° Elbow (MEL)

| Size (OD) | Ordering Number | D | T | A | A ₁ | B | B ₁ | F Body Cube |
|-----------|-----------------|------|------|-------|----------------|------|----------------|-------------|
| 1/4" | MEL4S□ | 6.35 | 1.00 | 12.30 | 17.38 | 6.35 | 11.43 | 11.11 |



Micro 45° Elbow (MEF)

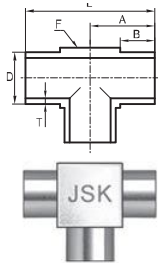
| Size (OD) | Ordering Number | D | T | A | B | F Body Cube | L |
|-----------|-----------------|-------|------|-------|------|-------------|-------|
| 1/4" | MEF4S□ | 6.35 | 1.00 | 10.32 | 6.35 | 7.94 | 11.96 |
| 3/8" | MEF6S□ | 9.53 | 1.00 | 11.91 | 6.35 | 11.11 | 14.21 |
| 1/2" | MEF8S□ | 12.70 | 1.24 | 13.50 | 6.35 | 14.29 | 16.46 |
| 3/4" | MEF12S□ | 19.05 | 1.65 | 16.68 | 6.35 | 20.65 | 20.95 |

* Dimensions are in millimeters unless specified as * inch*

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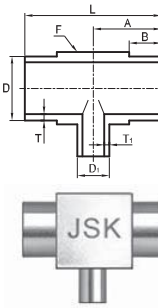
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□: BA or EP

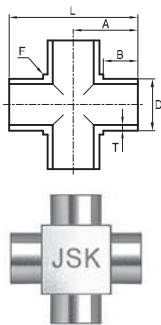
Micro Tee (MT)

| Size (OD) | Ordering Number | D | T | A | B | F Body Cube | L |
|-----------|-----------------|-------|------|-------|------|-------------|-------|
| 1/4" | MT4S□ | 6.35 | 1.00 | 10.32 | 6.35 | 7.94 | 20.64 |
| 3/8" | MT6S□ | 9.53 | 1.00 | 11.91 | 6.35 | 11.11 | 23.81 |
| 1/2" | MT8S□ | 12.70 | 1.24 | 13.50 | 6.35 | 14.29 | 26.99 |
| 3/4" | MT12S□ | 19.05 | 1.65 | 16.68 | 6.35 | 20.65 | 33.35 |



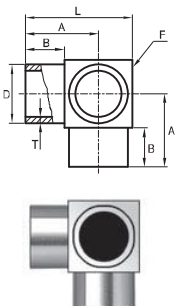
Micro Reducing Tee (MT)

| Size (OD) | Size (OD ₁) | Ordering Number | D | D ₁ | T | T ₁ | A | B | F Body Cube | L |
|-----------|-------------------------|-----------------|-------|----------------|------|----------------|-------|------|-------------|-------|
| 3/8" | 1/4" | MT64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 11.91 | 6.35 | 11.11 | 23.81 |
| 1/2" | 1/4" | MT84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 13.50 | 6.35 | 14.29 | 26.99 |
| 1/2" | 3/8" | MT86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 13.50 | 6.35 | 14.29 | 26.99 |
| 3/4" | 1/4" | MT124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 16.68 | 6.35 | 20.65 | 27.00 |
| 3/4" | 3/8" | MT126S□ | 19.05 | 9.53 | 1.65 | 1.00 | 16.68 | 6.35 | 20.65 | 27.00 |
| 3/4" | 1/2" | MT128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 16.68 | 6.35 | 20.65 | 27.00 |



Micro Cross (MCT)

| Size (OD) | Ordering Number | D | T | A | B | F Body Cube | L |
|-----------|-----------------|-------|------|-------|------|-------------|-------|
| 1/4" | MCT4S□ | 6.35 | 1.00 | 10.32 | 6.35 | 7.94 | 20.64 |
| 3/8" | MCT6S□ | 9.53 | 1.00 | 11.91 | 6.35 | 11.11 | 23.81 |
| 1/2" | MCT8S□ | 12.70 | 1.24 | 13.50 | 6.35 | 14.29 | 26.99 |
| 3/4" | MCT12S□ | 19.05 | 1.65 | 16.68 | 6.35 | 20.65 | 33.35 |



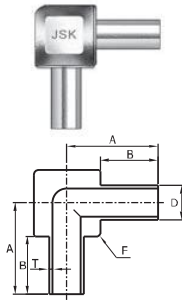
Micro Tribow (MTB)

| Size (OD) | Ordering Number | D | T | A | B | F Body Cube | L |
|-----------|-----------------|-------|------|-------|------|-------------|-------|
| 1/4" | MTB4S□ | 6.35 | 1.00 | 10.32 | 6.35 | 7.94 | 14.29 |
| 3/8" | MTB6S□ | 9.53 | 1.00 | 11.91 | 6.35 | 11.11 | 17.46 |
| 1/2" | MTB8S□ | 12.70 | 1.24 | 13.50 | 6.35 | 14.29 | 20.64 |
| 3/4" | MTB12S□ | 19.05 | 1.65 | 16.68 | 6.35 | 20.65 | 27.00 |

• Dimensions are in millimeters unless specified as "inch"



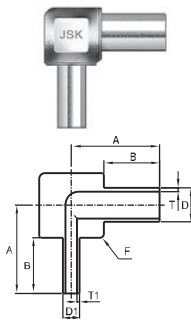
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□: BA or EP

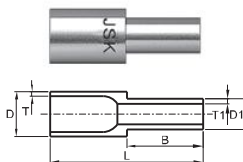
90° Elbow (LE,SE)

| Size (OD) | Ordering Number | D | T | A | B | F Body Cube |
|-----------|-----------------|-------|------|------|-------|-------------|
| 1/4" | LE4S□ | 6.35 | 1.00 | 25.0 | 19.05 | 11.2 |
| 3/8" | LE6S□ | 9.53 | 1.00 | 25.0 | 19.05 | 11.2 |
| 1/2" | LE8S□ | 12.70 | 1.24 | 29.0 | 19.05 | 17.5 |
| 3/4" | LE12S□ | 19.05 | 1.65 | 35.8 | 23.30 | 25.0 |
| 1" | LE16S□ | 25.40 | 1.65 | 38.3 | 23.30 | 30.0 |
| 1/4" | SE4S□ | 6.35 | 1.00 | 15.9 | 10.00 | 11.2 |
| 3/8" | SE6S□ | 9.53 | 1.00 | 15.9 | 10.00 | 11.2 |
| 1/2" | SE8S□ | 12.70 | 1.24 | 19.9 | 10.00 | 17.5 |
| 3/4" | SE12S□ | 19.05 | 1.65 | 22.4 | 10.00 | 25.0 |



Reducing 90° Elbow (LE)

| Size (OD) | Size (OD ₁) | Ordering Number | D | D ₁ | T | T ₁ | B | A | F Body Cube |
|-----------|-------------------------|-----------------|-------|----------------|------|----------------|-------|-------|-------------|
| 3/8" | 1/4" | LE64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 19.05 | 25 | 11.2 |
| 1/2" | 1/4" | LE84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 19.05 | 29 | 17.5 |
| 1/2" | 3/8" | LE86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 19.05 | 29 | 17.5 |
| 3/4" | 1/4" | LE124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 23.30 | 35.80 | 25.0 |
| 3/4" | 3/8" | LE126S□ | 19.05 | 9.52 | 1.65 | 1.00 | 23.30 | 35.80 | 25.0 |
| 3/4" | 1/2" | LE128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 23.30 | 35.80 | 25.0 |
| 1" | 1/4" | LE164S□ | 25.40 | 6.35 | 1.65 | 1.00 | 23.30 | 38.30 | 30.0 |
| 1" | 3/8" | LE166S□ | 25.40 | 9.52 | 1.65 | 1.00 | 23.30 | 38.30 | 30.0 |
| 1" | 1/2" | LE168S□ | 25.40 | 12.70 | 1.65 | 1.24 | 23.30 | 38.30 | 30.0 |
| 1" | 3/4" | LE1612S□ | 25.40 | 19.05 | 1.65 | 1.65 | 23.30 | 38.30 | 30.0 |



Reducer (LR,SR)

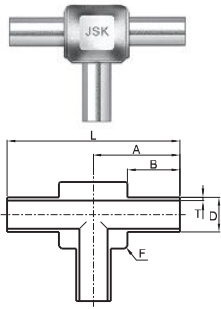
| Size (OD) | Size (OD ₁) | Ordering Number | D | D ₁ | T | T ₁ | B | L |
|-----------|-------------------------|-----------------|-------|----------------|------|----------------|-------|-------|
| 3/8" | 1/4" | LR64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 19.05 | 38.10 |
| 1/2" | 1/4" | LR84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 19.05 | 38.10 |
| 1/2" | 3/8" | LR86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 19.05 | 38.10 |
| 3/4" | 1/4" | LR124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 19.05 | 42.90 |
| 3/4" | 3/8" | LR126S□ | 19.05 | 9.53 | 1.65 | 1.00 | 19.05 | 42.90 |
| 3/4" | 1/2" | LR128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 19.05 | 42.90 |
| 1" | 1/4" | LR164S□ | 25.40 | 6.35 | 1.65 | 1.00 | 19.05 | 42.90 |
| 1" | 3/8" | LR166S□ | 25.40 | 9.52 | 1.65 | 1.00 | 19.05 | 42.90 |
| 1" | 1/2" | LR168S□ | 25.40 | 12.70 | 1.65 | 1.24 | 19.05 | 42.90 |
| 1" | 3/4" | LR1612S□ | 25.40 | 19.05 | 1.65 | 1.65 | 23.30 | 47.15 |
| 3/8" | 1/4" | SR64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 10.00 | 20.0 |
| 1/2" | 1/4" | SR84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 10.00 | 20.0 |
| 1/2" | 3/8" | SR86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 10.00 | 20.0 |
| 3/4" | 1/4" | SR124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 10.00 | 20.0 |
| 3/4" | 3/8" | SR126S□ | 19.05 | 9.53 | 1.65 | 1.00 | 10.00 | 20.0 |
| 3/4" | 1/2" | SR128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 10.00 | 20.0 |

* Dimensions are in millimeters unless specified as * inch*

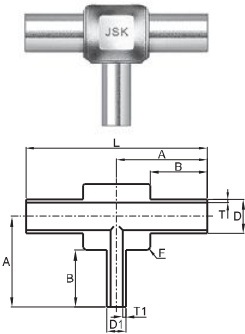
AUTO TUBE WELD Fittings



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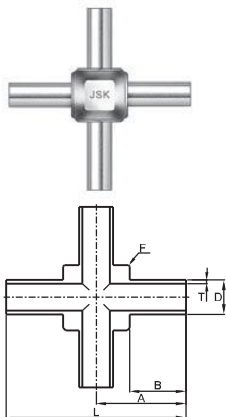


| Tee (LT,ST) | | | | | | | |
|-------------|-----------------|-------|------|------|-------|-------------|------|
| Size (OD) | Ordering Number | D | T | A | B | F Body Cube | L |
| 1/4" | LT4S□ | 6.35 | 1.00 | 25.0 | 19.05 | 11.2 | 50.0 |
| 3/8" | LT6S□ | 9.53 | 1.00 | 25.0 | 19.05 | 11.2 | 50.0 |
| 1/2" | LT8S□ | 12.70 | 1.24 | 29.0 | 19.05 | 17.5 | 58.0 |
| 3/4" | LT12S□ | 19.05 | 1.65 | 35.8 | 23.30 | 25.0 | 71.6 |
| 1" | LT16S□ | 25.40 | 1.65 | 38.3 | 23.30 | 30.0 | 76.6 |
| 1/4" | ST4S□ | 6.35 | 1.00 | 15.9 | 10.00 | 11.2 | 31.8 |
| 3/8" | ST6S□ | 9.53 | 1.00 | 15.9 | 10.00 | 11.2 | 31.8 |
| 1/2" | ST8S□ | 12.70 | 1.24 | 19.9 | 10.00 | 17.5 | 39.8 |
| 3/4" | ST12S□ | 19.05 | 1.65 | 22.4 | 10.00 | 25.0 | 44.8 |



| Reducing Tee (LT,ST) | | | | | | | | | | |
|----------------------|-------------------------|-----------------|-------|----------------|------|----------------|------|-------|-------------|------|
| Size (OD) | Size (OD ₁) | Ordering Number | D | D ₁ | T | T ₁ | A | B | F Body Cube | L |
| 3/8" | 1/4" | LT64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 25.0 | 19.05 | 11.2 | 50.0 |
| 1/2" | 1/4" | LT84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 29.0 | 19.05 | 17.5 | 58.0 |
| 1/2" | 3/8" | LT86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 29.0 | 19.05 | 17.5 | 58.0 |
| 3/4" | 1/4" | LT124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 35.8 | 23.30 | 25.0 | 71.6 |
| 3/4" | 3/8" | LT126S□ | 19.05 | 9.53 | 1.65 | 1.00 | 35.8 | 23.30 | 25.0 | 71.6 |
| 3/4" | 1/2" | LT128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 35.8 | 23.30 | 25.0 | 71.6 |
| 1" | 1/4" | LT164S□ | 25.40 | 6.35 | 1.65 | 1.00 | 38.3 | 23.30 | 30.0 | 76.6 |
| 1" | 3/8" | LT166S□ | 25.40 | 9.52 | 1.65 | 1.00 | 38.3 | 23.30 | 30.0 | 76.6 |
| 1" | 1/2" | LT168S□ | 25.40 | 12.70 | 1.65 | 1.24 | 38.3 | 23.30 | 30.0 | 76.6 |
| 1" | 3/4" | LT1612S□ | 25.40 | 19.05 | 1.65 | 1.65 | 38.3 | 23.30 | 30.0 | 76.6 |
| 3/8" | 1/4" | ST64S□ | 9.53 | 6.35 | 1.00 | 1.00 | 15.9 | 10.00 | 11.2 | 31.8 |
| 1/2" | 1/4" | ST84S□ | 12.70 | 6.35 | 1.24 | 1.00 | 19.9 | 10.00 | 17.5 | 39.8 |
| 1/2" | 3/8" | ST86S□ | 12.70 | 9.53 | 1.24 | 1.00 | 19.9 | 10.00 | 17.5 | 39.8 |
| 3/4" | 1/4" | ST124S□ | 19.05 | 6.35 | 1.65 | 1.00 | 22.4 | 10.00 | 25.0 | 44.8 |
| 3/4" | 3/8" | ST126S□ | 19.05 | 9.53 | 1.65 | 1.00 | 22.4 | 10.00 | 25.0 | 44.8 |
| 3/4" | 1/2" | ST128S□ | 19.05 | 12.70 | 1.65 | 1.24 | 22.4 | 10.00 | 25.0 | 44.8 |

□: BA or EP



| Tee (LCT, SCT) | | | | | | | |
|----------------|-----------------|-------|------|------|-------|-------------|------|
| Size (OD) | Ordering Number | D | T | A | B | F Body Cube | L |
| 1/4" | LCT4S□ | 6.35 | 1.00 | 25.0 | 19.05 | 11.2 | 50.0 |
| 3/8" | LCT6S□ | 9.53 | 1.00 | 25.0 | 19.05 | 11.2 | 50.0 |
| 1/2" | LCT8S□ | 12.70 | 1.24 | 29.0 | 19.05 | 17.5 | 58.0 |
| 3/4" | LCT12S□ | 19.05 | 1.65 | 35.8 | 23.30 | 25.0 | 71.6 |
| 1/4" | SCT4S□ | 6.35 | 1.00 | 15.9 | 10.00 | 11.2 | 31.8 |
| 3/8" | SCT6S□ | 9.53 | 1.00 | 15.9 | 10.00 | 11.2 | 31.8 |
| 1/2" | SCT8S□ | 12.70 | 1.24 | 19.9 | 10.00 | 17.5 | 39.8 |
| 3/4" | SCT12S□ | 19.05 | 1.65 | 22.4 | 10.00 | 25.0 | 44.8 |

• Dimensions are for reference only and are subject to change.

• Dimensions are in millimeters unless specified as "inch"