SLOVENSKI STANDARD
SIST EN 560:2005

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SIST EN 560:1997

Oprema za plamensko varjenje – Cevne spojke za opremo za varjenje, rezanje in sorodne postopke

Gas welding equipment - Hose connections for equipment for welding, cutting and allied processes

Gasschweißgeräte - Schlauchanschlüsse für Geräte und Anlagen für Schweißen, Schneiden und verwandte Prozesse

Matériel de soudage aux gaz - Raccords pour tuyaux souples pour appareils de soudage, coupage et techniques connexes

Ta slovenski standard je istoveten z: **EN 560:2005**

ICS:

25.160.30	Varilna oprema	Welding equipment
83.140.40	Gumene cevi	Hoses

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EUROPEAN STANDARD

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English version

Gas welding equipment - Hose connections for equipment for welding, cutting and allied processes

Matériel de soudage aux gaz - Raccords pour tuyaux souples pour appareils de soudage, coupage et techniques connexes

Gasschweißgeräte - Schlauchanschlüsse für Geräte und Anlagen für Schweißen, Schneiden und verwandte Prozesse

This European Standard was approved by CEN on 4 May 2005.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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Foreword

This document (EN 560:2005) has been prepared by Technical Committee CEN/TC 121 “Welding”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by December 2005, and conflicting national standards shall be withdrawn at the latest by December 2005.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

1 Scope

This European Standard lays down the dimensions and specifies the characteristics of the constituent parts of hose connections for welding, cutting and allied processes, for example for pressure regulators according to EN ISO 2503 and blowpipes. This European Standard does not cover the design of the part of the hose tail inserted into the hose. This is specified in EN 1256.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

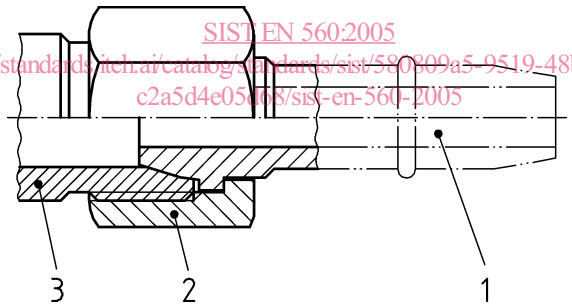
EN 29539, *Materials for equipment used in gas welding, cutting and allied processes (ISO 9539:1988)*

EN ISO 228-1, *Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions, tolerances and designation (ISO 228-1:2000)*

3 General

The gas pipe threads shall be in accordance with the requirements of EN ISO 228-1. All other dimensions are given in millimetres.

The joint is made with a bull nose and cone seal (see Figure 1).



Key

1 hose tail
2 union nut
3 threaded union

Figure 1 — Hose connection

4 Material

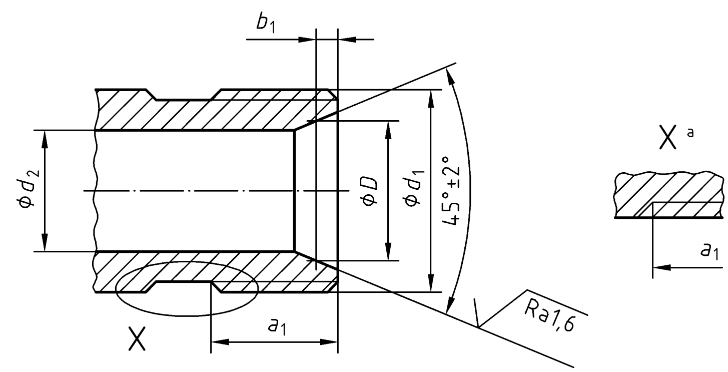
The material shall conform to EN 29539.

5 Dimensions

5.1 General

The dimensions of threaded union, union nut and hose tail shall be as specified in 5.2, 5.3 and 5.4.

5.2 Threaded union



Key

a alternative

Figure 2 — Threaded union

Table 1 — Dimensions of threaded union

d_1	D [a] mm	a_1 [b] min. mm	b_1 J_s15 mm	d_2 max. mm
G 1/8	6,5	7,5	1,2	5
G 1/4	8,3	9,5	1,4	7
G 3/8	11,5	10,5	1,8	10
G 1/2	13,9	12	2	12
G 3/4	18,5	13,5	2,2	16
G 1	24	14,5	2,4	22

[a] Datum diameter (nominal diameter of contact).
[b] Effective length of thread.

All values given in Table 1 are in millimetres except those of the „d_1“ column, which are thread sizes as specified in EN ISO 228-1.

Tolerances for external thread according to class A.

The dimensions not given are left to the discretion of the manufacturer.

Type of thread to be used:

— right-hand for oxygen and non-combustible gases;

— left-hand for combustible gases.

5.3 Union nut

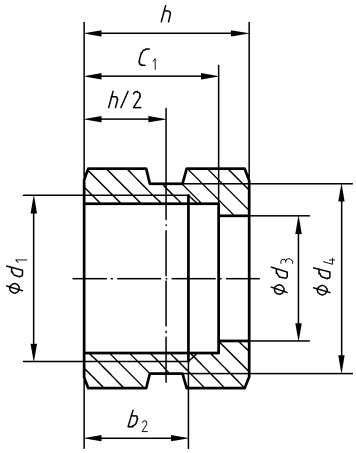


Figure 3 a — With left-hand thread

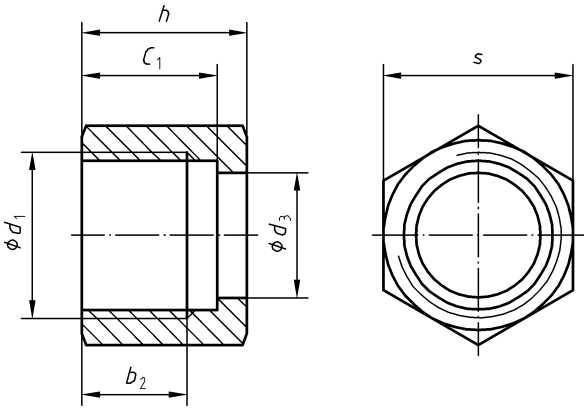


Figure 3 b — With right-hand thread

Figure 3 — Union nut

Table 2 — Dimensions of union nut

d_1	b_2 min. mm	c_1 J_s15 mm	d_3 H12 mm	d_4 h14 mm	h h14 mm	s h11 mm
G 1/8	8	10	6,5	11	12	11
G ¼	10	12,5	9,5	17	15,5	17
G 3/8	10,5	13,5	12,5	19	16,5	19
G ½	13	16,5	14,5	24	20,5	24
G ¾	15	18,5	19,5	30	22,5	30
G 1	17	21,5	25,5	41	26,5	41

All values given in Table 2 are in millimetres except those of the „d_1“ column, which are thread sizes as specified in EN ISO 228-1.

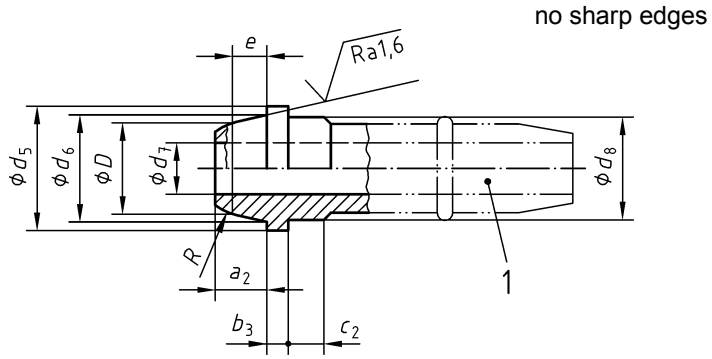
The dimensions not given are left to the discretion of the manufacturer.

Type of thread to be used:

— right-hand for oxygen and non-combustible gases;

— left-hand for combustible gases.

5.4 Hose nipple



Key

1 see EN 1256 for examples of hose tail profiles

Figure 4 — Hose nipple

Table 3 — Dimensions of the hose nipple

Internal diameter of hose[a] mm	d_1	a_2 h14 mm	b_3 h14 mm	c_2 min. mm	D[b] mm	d_5 h12 mm	d_6 h12 mm	d_8 h12 mm	e h14 mm	R h14 mm
3,2 4 5	G 1/8	4,5	2	4	6,5	8	7	6	3	3,5
4 5 6,3 8	G 1/4	5	2,5	5	8,3	11	9	9	3,5	4,5
5 6,3 8 10	G 3/8	6	2,5	5	11,5	14,5	12,5	12	4	6,25
6,3 8 10	G 1/2	6	3,5	6	13,9	18	15	14	4,5	7,5
10 12,5 16	G 3/4	8	3,5	6	18,5	23,5	20	19	5,25	10
16 20	G 1	10	4,5	7	24	29,75	26	25	6,5	13

[a] These values are given as a guide. To every hose diameter correspond the appropriate dimensions of the part to be engaged in the hose.

[b] Datum diameter (nominal of contact).

All values given in Table 3 are in millimetres except those of the „d_1“ column, which are thread sizes as specified in EN ISO 228-1.

The dimensions not given and the profile of the part to be engaged in the hose are left to the discretion of the manufacturer. See EN 1256 for examples of hose tail profiles.

The diameter „d_7“ shall be as large as possible to ensure maximum flow capacity. To ensure correct seating between the hose tail and the threaded union, the diameter „d_7“ shall not exceed „d_2“.