SLOVENSKI STANDARD
SIST EN ISO 11363-2:2010

01-oktober-2010

Nadomešča:
SIST EN 629-2:1999
SIST EN ISO 11116-2:2000

Plinske jeklenke - Konična navoja 17E in 25E za priključitev ventila na plinsko jeklenko - 2. del: Kalibri za kontrolo (ISO 11363-2:2010)

Gas cylinders - 17E and 25E taper threads for connection of valves to gas cylinders - Part 2: Inspection gauges (ISO 11363-2:2010)

Gasflaschen - 17E und 25E kegeliges Gewinde zur Verbindung von Ventilen mit Gasflaschen - Teil 2: Lehrenprüfung (ISO 11363-2:2010)

Bouteilles à gaz - Filetages coniques 17E et 25E pour le raccordement des robinets sur les bouteilles à gaz - Partie 2: Calibres de contrôle (ISO 11363-2:2010)

Ta slovenski standard je istoveten z: **EN ISO 11363-2:2010**

ICS:

21.040.30	Posebni navoji	Special screw threads
23.020.30	Tlačne posode, plinske jeklenke	Pressure vessels, gas cylinders

SIST EN ISO 11363-2:2010 **en,fr,de**

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 11363-2

May 2010

ICS 23.020.30

Supersedes EN 629-2:1996, EN ISO 11116-2:1999

English Version

Gas cylinders - 17E and 25E taper threads for connection of valves to gas cylinders - Part 2: Inspection gauges (ISO 11363-2:2010)

Bouteilles à gaz - Filetages coniques 17E et 25E pour le raccordement des robinets sur les bouteilles à gaz - Partie 2: Calibres de contrôle (ISO 11363-2:2010)

Gasflaschen - 17E und 25E kegeliges Gewinde zur Verbindung von Ventilen mit Gasflaschen - Teil 2: Lehreninspektion (ISO 11363-2:2010)

This European Standard was approved by CEN on 23 January 2010.

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 CEN Management Centre 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 CEN Management Centre has the same status as the official versions.

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

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: Avenue Marnix 17, B-1000 Brussels

Contents

Page

Foreword.....3

Foreword

This document (EN ISO 11363-2:2010) has been prepared by Technical Committee ISO/TC 58 "Gas cylinders" in collaboration with Technical Committee CEN/TC 23 “Transportable gas cylinders” the secretariat of which is held by BSI.

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 November 2010, and conflicting national standards shall be withdrawn at the latest by November 2010.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 629-2:1996, EN ISO 11116-2:1999.

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

Endorsement notice

The text of ISO 11363-2:2010 has been approved by CEN as a EN ISO 11363-2:2010 without any modification.

INTERNATIONAL STANDARD

ISO 11363-2

First edition
2010-05-15

Gas cylinders — 17E and 25E taper threads for connection of valves to gas cylinders —

Part 2: Inspection gauges

Bouteilles à gaz — Filetages coniques 17E et 25E pour le raccordement des robinets sur les bouteilles à gaz —
Partie 2: Calibres de contrôle

Reference number
ISO 11363-2:2010(E)

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Terms and definitions 1

4 Requirements 2
4.1 Materials 2
4.2 Thread profile 2
4.3 Thread handedness 4
4.4 Taper 4
4.5 Pitch, P 4

5 Gauge dimensions 4

6 Inspection gauges 5
6.1 Gauges for cylinder neck thread 5
6.2 Gauges for valve stem thread 7

7 Check gauges 9

8 Use of inspection gauges 9
8.1 Plain gauges 9
8.2 Threaded plug gauges 9
8.3 Accept or reject criteria using plug gauges 9
8.4 Accept or reject criteria using ring gauges 10

9 Verification of inspection gauges 11
9.1 General 11
9.2 Plug gauges 12
9.3 Ring gauges 12
9.4 Use of check plug gauges 12

10 Identification 12
10.1 Inspection gauges 12
10.2 Check gauges 13

Annex A (informative) **Examples of calculation for thread gauge dimensions on the large end diameter** 14

Annex B (informative) **Limitation of gauging system** 16

Bibliography 18

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 11363-2 was prepared by Technical Committee ISO/TC 58, *Gas cylinders*, Subcommittee SC 2, *Cylinder fittings*.

This first edition of ISO 11363-2 cancels and replaces ISO 11116-2:1999 and ISO 11191:1997.

ISO 11363 consists of the following parts, under the general title *Gas cylinders — 17E and 25E taper threads for connection of valves to gas cylinders*:

— *Part 1: Specifications*

— *Part 2: Inspection gauges*

Introduction

Gas cylinders intended to contain compressed, liquefied or dissolved gas under pressure are fitted with accessories to allow release and refilling of gas. Hereinafter, the term “valve” will apply to such accessories.

The connection between cylinder and valve is obtained by assembly of two taper-threads (an external one on the valve stem and an internal one in the cylinder neck), both having the same nominal taper, thread pitch and thread profile.