
**Plinske jeklenke - Konični navoj 25E za povezavo ventila z jeklenko - 2. del:
Umerjanje**

Transportable gas cylinders - 25E taper thread for connection of valves to gas cylinders -
Part 2: Gauge inspection

Ortsbewegliche Gasflaschen - 25E kegeliges Gewinde zum Anschluß von Ventilen an
Gasflaschen - Teil 2: Lehrenprüfung

Bouteilles a gaz transportables - Filetages coniques 25E pour le raccordement des
robinets sur les bouteilles a gaz - Partie 2: Calibres de vérification

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Ta slovenski standard je istoveten z: EN 629-2:1996

ICS:

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

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en

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EUROPEAN STANDARD

EN 629-2

NORME EUROPÉENNE

EUROPÄISCHE NORM

June 1996

ICS 23.020.30

Descriptors: gas cylinders, gas valves, junctions, tapered screw threads, specifications, dimensions, dimensional measurements, standard gauges

English version

**Transportable gas cylinders - 25E taper thread for
connection of valves to gas cylinders - Part 2:
Gauge inspection**

Bouteilles à gaz transportables - Filetages
coniques 25E pour le raccordement des robinets
sur les bouteilles à gaz - Partie 2: Calibres
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This European Standard was approved by CEN on 1995-12-03. 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.

The European Standards exist 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, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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Foreword

This European Standard has been prepared by 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 December 1996, and conflicting national standards shall be withdrawn at the latest by December 1996.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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Introduction

This European Standard is a two part standard, belonging to a series of standards specifying thread dimensions and gauge requirements:

- Part 1: Specification;
- Part 2: Gauge inspection.

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1 Scope

This European Standard specifies types, dimensions and principles of use of gauges, to be used in conjunction with the taper thread specified in EN 629-1.

Annex A provides examples of calculations for thread gauge dimensions on the large end diameter.

Annex B draws attention to the limitations of the gauging system specified.

2 Normative reference

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies. (standards.iteh.ai)

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SIST EN 629-2:1999
Transportable gas cylinders - 25E taper thread for connection of valves to gas cylinders
Part 1: Specification

3 Definitions

For the purposes of this standard, the following definitions apply:

3.1 inspection gauge: Gauge used for the routine gauging of cylinder neck and valve stem threads. This gauge is not used for checking other gauges.

3.2 check gauge: Gauge for checking dimensional conformity of inspection ring gauges. This gauge is not used for gauging cylinder neck threads.

3.3 single part gauge: Gauge of sufficient length to contact the full length of taper thread. These gauges are plug or ring, plain or threaded.

3.4 two part gauges: Two separate inspection gauges, used in combination, where one is used to contact the large end of the taper cone and the other the small end. These sets of gauges are plug or ring, plain or threaded.

4 Requirements

4.1 Materials

All gauges shall be manufactured from material of suitable strength, stability and hardness.

4.2 Thread profile

The thread profile of threaded inspection and check gauges shall be as shown in figure 1.

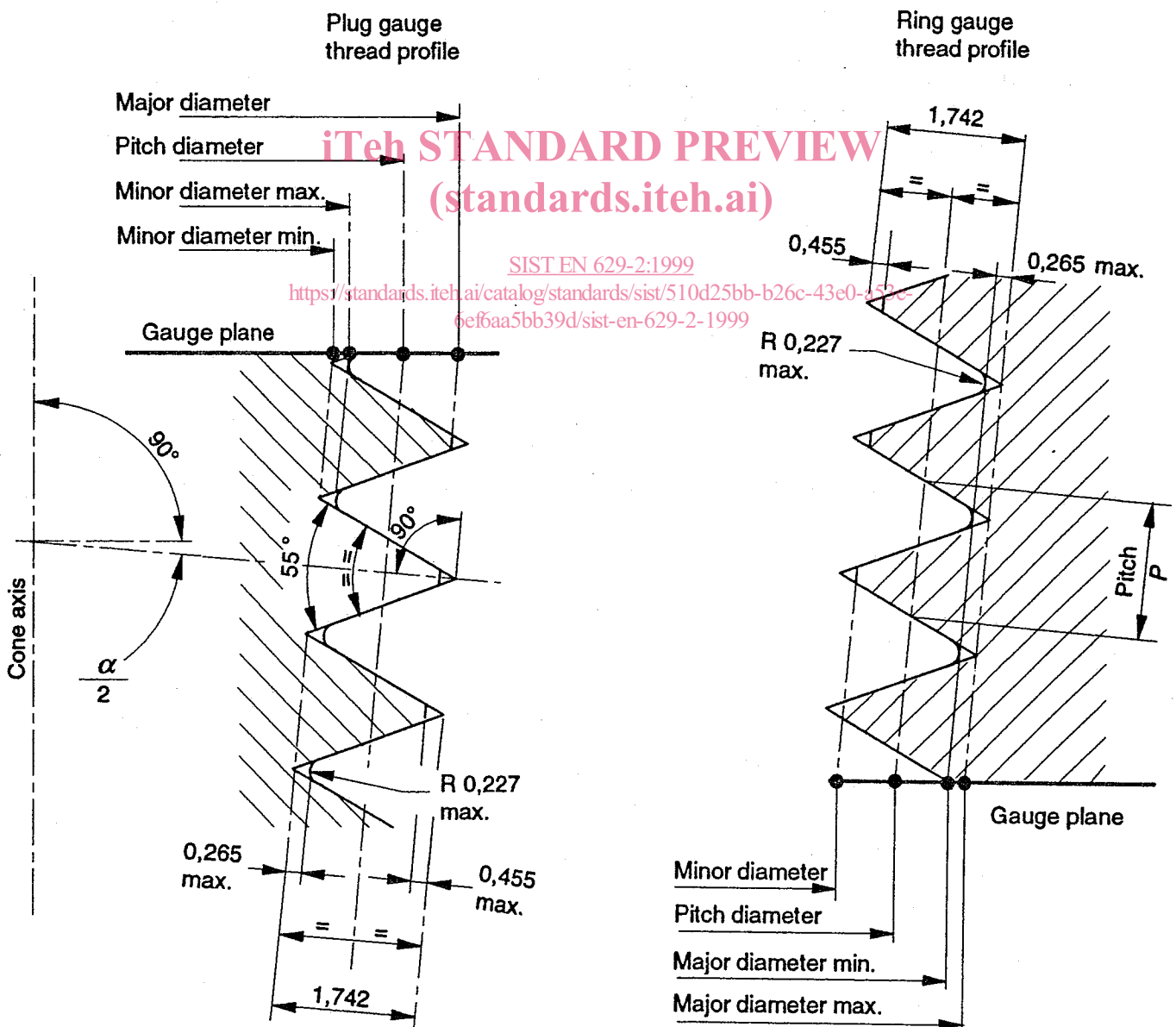


Figure 1: Thread profiles

4.3 Thread rotation

The thread shall be a right hand thread, such that it moves away from an observer, when rotated clockwise.

4.4 Taper

Taper: 3 / 25;

Taper angle: 6° 52';

Taper slope: 12 %.

4.5 Thread profile

The thread profile has a 55° angle. The form and thread height measurements are perpendicular to the cone surface (see figure 1).

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4.6 Pitch P

The pitch is 1,814 mm (derived from $\frac{25,4}{14}$ mm) (see figure 1).
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5 Gauge dimensions

The following dimensional requirements apply to gauges shown in figure 2 to figure 15, inclusive.

5.1 All dimensions are given in millimetres.

5.2 Tolerances for specified dimensions on all gauges are:

- ± 0,01 mm on all lengths;
- ± 0,01 mm on diameters of inspection gauges;
- - $\left. \begin{array}{l} 0,01 \text{ mm} \\ 0,02 \text{ mm} \end{array} \right\}$ on diameters of check gauges.

5.3 For threaded gauges, pitch diameters only are specified. For minor and major diameters see figure 1.

5.4 Unspecified dimensions shall be chosen by the manufacturer of the gauges.

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6 Inspection gauges

All dimensions are given in millimetres

6.1 Cylinder neck thread

6.1.1 Single part plug gauges

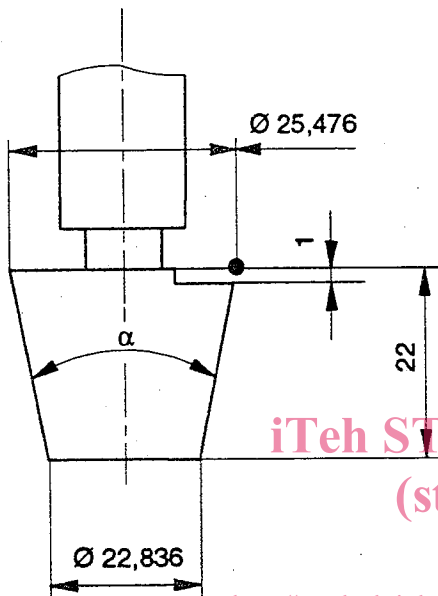


Figure 2: Plain plug gauge for minor diameters "I-1"

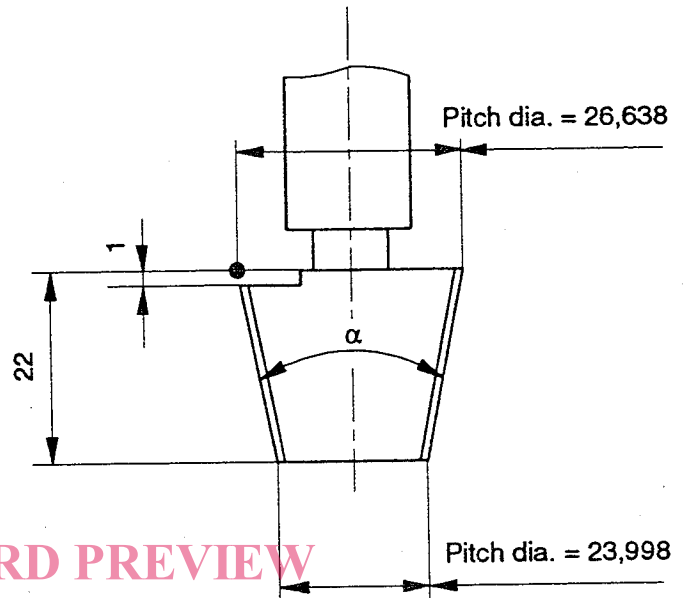


Figure 3: Threaded plug gauge for pitch diameters "I-2"

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6.1.2 Two part plug gauges - small end diameter

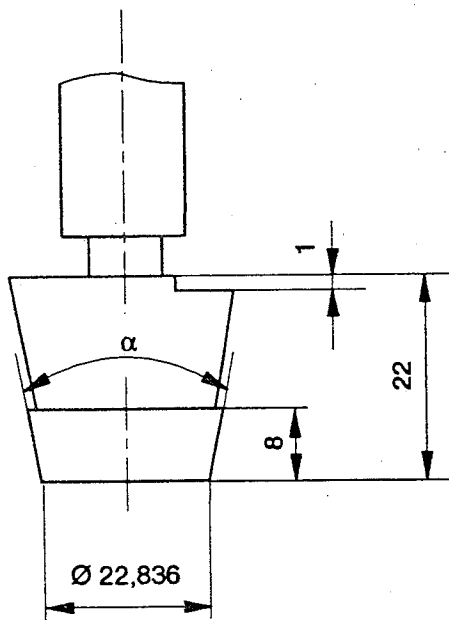


Figure 4: Plain plug gauge for minor diameters "I-3"

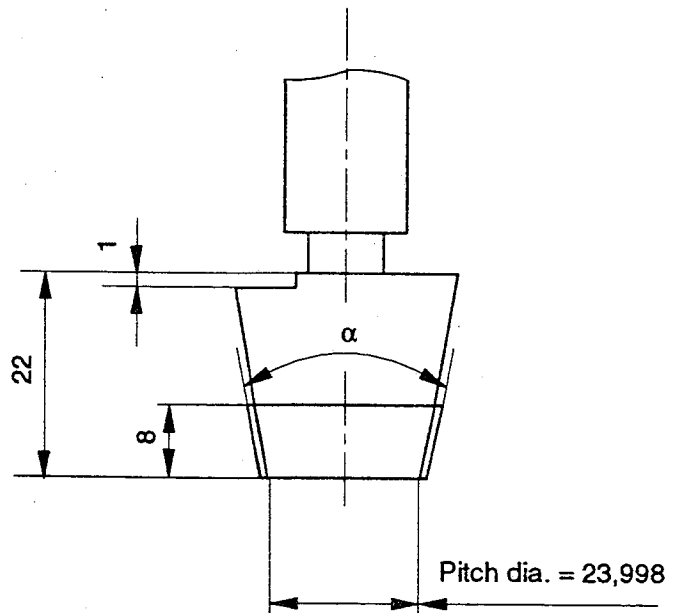


Figure 5: Threaded gauge for pitch diameters "I-4"