



**SLOVENSKI STANDARD**  
**oSIST prEN ISO 11363-2:2016**  
**01-maj-2016**

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**Plinske jeklenke - Konična navoja 17E in 25E za priključitev ventila na plinsko jeklenko - 2. del: Kalibri za kontrolo (ISO/DIS 11363-2:2016)**

Gas cylinders - 17E and 25E taper threads for connection of valves to gas cylinders - Part 2: Inspection gauges (ISO/DIS 11363-2:2016)

Gasflaschen - 17E und 25E kegeliges Gewinde zur Verbindung von Ventilen mit Gasflaschen - Teil 2: Prüflehren (ISO/DIS 11363-2:2016)

Bouteilles à gaz - Filetages coniques 17E et 25E pour le raccordement des robinets sur les bouteilles à gaz - Partie 2: Calibres de contrôle (ISO/DIS 11363-2:2016)

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

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**ICS:**

21.040.30	Posebni navoji	Special screw threads
23.020.35	Plinske jeklenke	Gas cylinders

**oSIST prEN ISO 11363-2:2016**

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# DRAFT INTERNATIONAL STANDARD

## ISO/DIS 11363-2

ISO/TC 58/SC 2

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## 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*

ICS: 23.020.30

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### ISO/CEN PARALLEL PROCESSING

This draft has been developed within the International Organization for Standardization (ISO), and processed under the **ISO lead** mode of collaboration as defined in the Vienna Agreement.

This draft is hereby submitted to the ISO member bodies and to the CEN member bodies for a parallel three month enquiry.

To expedite distribution, this document is circulated as received from the committee secretariat. ISO Central Secretariat work of editing and text composition will be undertaken at publication stage.



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## 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 second edition cancels and replaces the first edition (ISO 11363-2:2010), Figure 9 has been corrected.

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*

**ISO/DIS 11363-2:2016(E)****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.

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# Gas cylinders — 17E and 25E taper threads for connection of valves to gas cylinders — Part 2: Inspection gauges

## 1 Scope

This part of ISO 11363 specifies types, dimensions and principles of use of gauges, to be used in conjunction with the taper threads specified in ISO 11363-1 (i.e. 17E and 25E threads).

It provides examples of calculations for thread gauge dimensions on the large end diameter (Annex A) and draws attention to the limitations of the gauging system specified (Annex B).

## 2 Normative references

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

ISO 11363-1, *Gas cylinders — 17E and 25E taper threads for connection of valves to gas cylinders — Part 1: Specifications*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 11363-1 and the following apply.

### 3.1

#### **check gauge**

gauge for checking dimensional conformity of inspection gauges

Note to entry: This gauge is not used for gauging cylinder neck threads or valve stem threads.

### 3.2

#### **inspection gauge**

gauge used for the routine gauging of cylinder neck and valve stem threads

Note to entry: This gauge is not used for checking other gauges.

### 3.3

#### **single-part gauge**

gauge of sufficient length to contact the length of full form taper threads

Note to entry: These gauges are either plugs or rings, plain or threaded.

**ISO/DIS 11363-2:2016(E)****3.4****two-part gauge**

gauge consisting of 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

Note to entry: These sets of gauges are either plugs or rings, 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.

The thread profile is a British Standard Whitworth (BSW)<sup>1)</sup> form with a 55° angle (see Figure 1).

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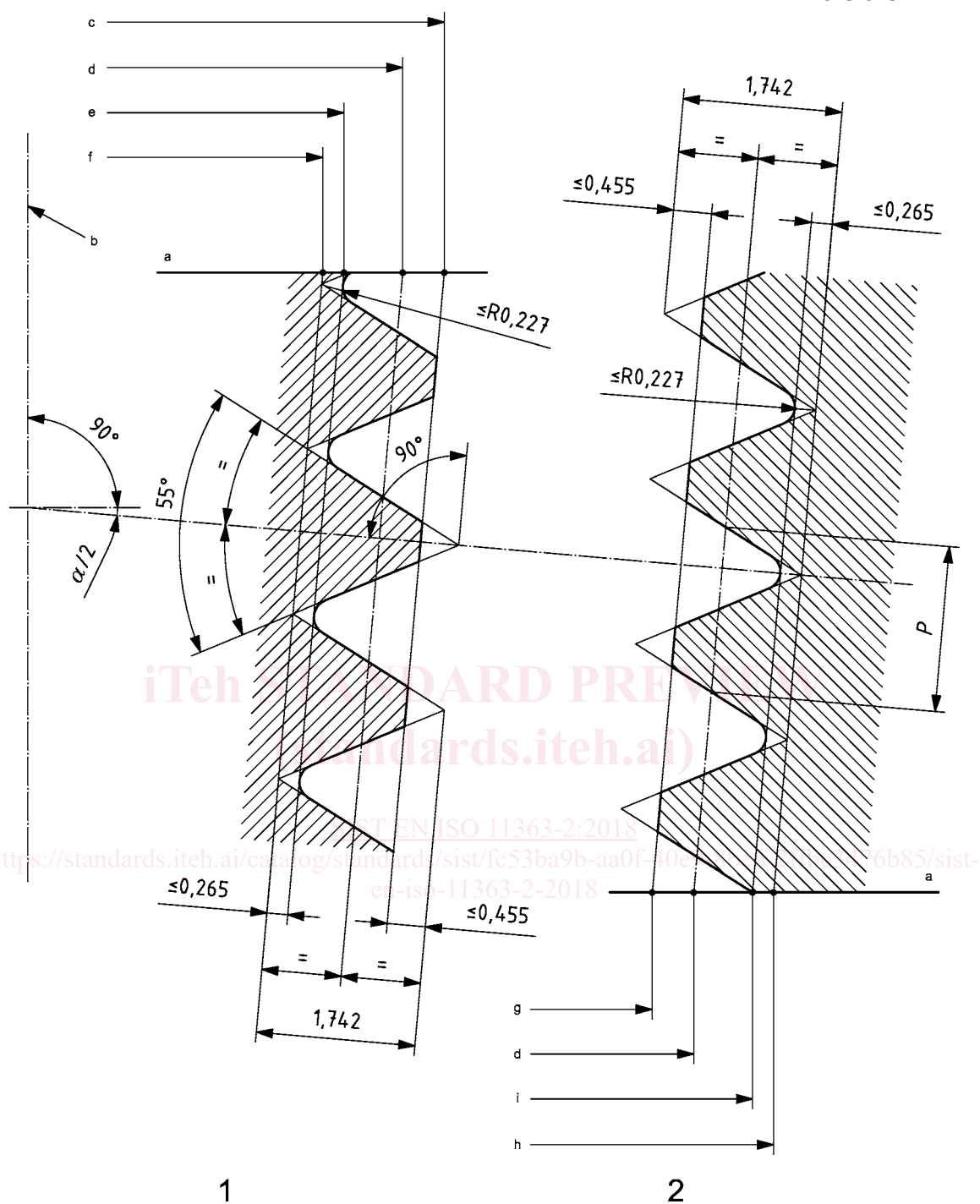
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<sup>1)</sup> A coarse thread devised and standardized in 1841 by British engineer Sir Joseph Whitworth (1803-87). It has an angle of thread of 55° and ranges in size from 1/16 in to 2 1/2 in. It is used in many types of engineering throughout the world, although in the UK its use is now being superseded by the ISO metric system (ISO 68-1).

Dimensions in millimetres

**Key** $P$  pitch

1 plug gauge thread profile

2 ring gauge thread profile

a Gauge plane.

b Thread axis.

c Major diameter.

d Pitch diameter.

e Maximum minor diameter.

f Minimum minor diameter.

g Minor diameter.

h Maximum major diameter.

i Minimum major diameter.

**Figure 1 — Thread profiles**