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Gas cylinders — Fitting of valves to gas cylinders

Bouteilles à gaz — Montage des robinets sur les bouteilles à gaz

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Foreword

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This document was prepared by Technical Committee ISO/TC 58, *Gas cylinders*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 23, *Transportable gas cylinders*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 13341:2010), which has been technically revised. It also incorporates the Amendment ISO 13341:2010/Amd 1:2015.

The main changes are as follows:

— update of Clause 2 and Bibliography;

— addition of a requirement in 5.3 with regards to the cleaning of cylinder threads.

Any feedback or questions on this document should be directed to the user’s national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Gas cylinders — Fitting of valves to gas cylinders

1 Scope

This document specifies the procedures to be followed when connecting cylinder valves to gas cylinders. It specifically applies to all valve and cylinder combinations connected with ISO screw threads as specified in ISO 11363-1 and ISO 15245-1. It defines procedures and practices for inspection and preparation prior to valving for both taper and parallel screw threads.

Torque values are given in Annex A for steel and aluminium alloy gas cylinders including composite cylinders with steel or aluminium alloy neck boss.

NOTE The procedures and practices specified in this document can be beneficially applied to other valve to cylinder screw thread connection systems. ISO/TR 11364 lists the valve to gas cylinder threads in use worldwide. It gives details of the thread identification codes, whether the threads are interchangeable with ISO threads and if the taping procedure and torque values specified in this document can be used. ISO/TR 11364 gives clear guidance for the method and torque for all listed inlet threads, which are not interchangeable.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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.

ISO 10286, *Gas cylinders — Vocabulary*

ISO 11119-2, *Gas cylinders — Design, construction and testing of refillable composite gas cylinders and tubes — Part 2: Fully wrapped fibre reinforced composite gas cylinders and tubes up to 450 l with load-sharing metal liners*

ISO 11119-3, *Gas cylinders — Design, construction and testing of refillable composite gas cylinders and tubes — Part 3: Fully wrapped fibre reinforced composite gas cylinders and tubes up to 450 l with non-load-sharing metallic or non-metallic liners or without liners*

ISO 11119-4, *Gas cylinders — Refillable composite gas cylinders — Design, construction and testing — Part 4: Fully wrapped fibre reinforced composite gas cylinders up to 150 l with load-sharing welded metallic liners*

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

ISO/TR 11364, *Gas cylinders — Compilation of national and international valve stem/gas cylinder neck threads and their identification and marking system*

ISO 15245-1, *Gas cylinders — Parallel threads for connection of valves to gas cylinders — Part 1: Specification*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 10286 apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

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