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Gas cylinders - Fitting of valves to gas cylinders (ISO 13341:2025)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

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ICS 23.020.35

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EUROPEAN STANDARD

EN ISO 13341

NORME EUROPÉENNE

EUROPÄISCHE NORM

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13341:2010/A1:2015

English Version

Gas cylinders - Fitting of valves to gas cylinders (ISO 13341:2025)

Bouteilles à gaz - Montage des robinets sur les
bouteilles à gaz (ISO 13341:2025)

Gasflaschen- Eindrehen von Ventilen in Gasflaschen
(ISO 13341:2025)

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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

European foreword

This document (EN ISO 13341:2025) 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of an identical text or by endorsement, at the latest by February 2026, and conflicting national standards shall be withdrawn at the latest by February 2026.

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

This document supersedes EN ISO 13341:2010.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

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Endorsement notice

The text of ISO 13341:2025 has been approved by CEN as EN ISO 13341:2025 without any modification.

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

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.

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 tapping 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/>