TECHNICAL REPORT

ISO/TR 11364

First edition
2012-12-01

Gas cylinders — Compilation of national and international valve stem/gas cylinder neck threads and their identification and marking system

Bouteilles à gaz — Compilation des filetages nationaux et internationaux des queues de robinets/goulots de bouteilles et leurs systèmes d'identification et de marquage

Reference number
ISO/TR 11364:2012(E)

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Published in Switzerland

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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.

In exceptional circumstances, when a technical committee has collected data of a different kind from that which is normally published as an International Standard ("state of the art", for example), it may decide by a simple majority vote of its participating members to publish a Technical Report. A Technical Report is entirely informative in nature and does not have to be reviewed until the data it provides are considered to be no longer valid or useful.

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/TR 11364 was prepared by Technical Committee ISO/TC 58, *Gas cylinders*.

Introduction

There is a huge variety of valve to gas cylinder neck thread connections worldwide and ISO cylinders are free to be equipped with any thread according to a recognized thread standard. ISO standards for cylinders and valves require the marking of an identification of the thread on valve and cylinder but there is presently no harmonized marking system.

The purpose of this Technical Report is to list all known cylinder/valve threads currently used and also threads used in the past and to specify a harmonized identification code and marking system for both cylinders and valves. The aim is to reduce the risk of mismatches when valves are fitted to gas cylinders and avoid related safety incidents.

Gas cylinders — Compilation of national and international valve stem/gas cylinder neck threads and their identification and marking system

1 Scope

This Technical Report lists the different valve stem to gas cylinder connection threads currently and historically existing worldwide and provides official coded designations for them. These coded designations will then be available for identification and marking purposes.

It also gives guidance concerning which threads are dimensionally identical and which are interchangeable.

Furthermore, this Technical Report provides guidance for valving procedures when fitting valves to gas cylinders.

2 Normative references

The following referenced documents are indispensable for the application 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 13341, *Gas cylinders — Fitting of valves to gas cylinders*

3 Interchangeability of valve/cylinder threads

Threads of recognized standards which are dimensionally identical but have historically been named differently are fully interchangeable.

Experience has shown that the following combination of threads can be safely used in service: 25E valve with T8, T23 and T26 cylinder threads. However, for small steel (less than 5 l water capacity) and aluminium alloy cylinders, users should examine the suitability of the resulting combination for each application in order for them to be interchangeable.

4 Lists of threads

4.1 General

The lists of threads are given in Table 1 for taper threads and Table 2 for parallel threads. The columns in the tables have the following meaning:

Column 1 – Ref. No.

Reference Number of the thread starting with a “T” for taper threads and “P” for parallel threads; followed by a consecutive number in the order as they are listed.

Column 2 – Origin

Country or region of origin of the thread.

Column 3 – Nominal designation of thread