DIN EN 16509:2014-12 (E)

Transportable gas cylinders - No n-refillable, small transportable, steel cylinders of capacities up to and including 120 ml containing compressed or liquefied gases (compact cylinders) - Design, construction, filling and testing

Contents

Page

Foreword 3

Introduction 4

1 Scope 5

2 Normative References 5

3 Terms and Definitions 5

4 Requirements 6
4.1 General 6
4.2 Design 6
4.2.1 General 6
4.2.2 Design drawing and specification 7
4.3 Materials and construction 7
4.3.1 General 7
4.3.2 Cylinder shells 8
4.3.3 Closures 8
4.4 Minimum and maximum operating temperatures 8
4.5 Gas 8

5 Tests 9
5.1 General 9
5.2 Hydraulic tests 9
5.2.1 Pressure test 9
5.2.2 Burst test 9
5.3 Ductility tests 9
5.3.1 General 9
5.3.2 Gas burst test 10
5.3.3 Flattening test 10
5.4 Proof pressure test 10
5.5 Water capacity check 10
5.6 Gas quantity check 11
5.7 Leakage test 11
5.7.1 General 11
5.7.2 Hot water bath test 11
5.7.3 Leakage testing by alternative methods 11
5.8 Check of gross mass 12
5.9 Check of force to open the closure 12

6 Type approval procedure 12
6.1 General requirements 12
6.2 Prototype tests 13

7 Batch tests 13

8 Tests/examinations on every compact cylinder 13

9 Marking of compact cylinders 13
9.1 General 13
9.2 Required markings 14
9.2.1 On cylinder and outer packaging 14
9.2.2 On outer packaging only 14
9.2.3 On cylinder only 14

Bibliography 15