DIN EN ISO 11363-2:2018-03 (E)

Gas cylinders - 17E and 25E taper threads for connection of valves to gas cylinders - Part 2: Inspection gauges (ISO 11363-2:2017)

Contents

Page

European foreword ... **3**

Foreword ... **4**

Introduction ... **5**

1 Scope ... **6**

2 Normative references ... **6**

3 Terms and definitions ... **6**

4 Requirements ... **7**
4.1 Materials ... 7
4.2 Thread profile ... 7
4.3 Thread handedness ... 9
4.4 Taper ... 9
4.5 Pitch, *P* ... 9

5 Gauge dimensions ... **9**

6 Inspection gauges ... **10**
6.1 Gauges for cylinder neck thread ... 10
6.1.1 Single-part plug gauges ... 10
6.1.2 Two-part plug gauges, small end diameter ... 11
6.1.3 Two-part plug gauges, large end diameter ... 12
6.2 Gauges for valve stem thread ... 13
6.2.1 Single-part ring gauges ... 13
6.2.2 Two-part ring gauges, small end diameter ... 13
6.2.3 Two-part ring gauges, large end diameter ... 14

7 Check gauges ... **15**

8 Use of inspection gauges ... **15**
8.1 Plain gauges ... 15
8.2 Threaded plug gauges ... 15
8.3 Accept or reject criteria using plug gauges ... 15
8.4 Accept or reject criteria using ring gauges ... 16

9 Verification of inspection gauges ... **17**
9.1 General ... 17
9.2 Plug gauges ... 18
9.3 Ring gauges ... 18
9.4 Use of check plug gauges ... 18

10 Identification ... **18**
10.1 Inspection gauges ... 18
10.2 Check gauges ... 18

Annex A (informative) **Examples of calculation for thread gauge dimensions on the large end diameter** ... **20**

Annex B (informative) **Limitation of gauging system** ... **22**

Bibliography ... **24**