

Transportable gas cylinders — 25E taper thread for connection of valves to gas cylinders

Part 2. Gauge inspection

The European Standard EN 629-2 : 1996 has the status of a
British Standard

ICS 23.020.30

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- Aluminium Federation
- British Compressed Gases Association
- Health and Safety Executive
- Ministry of Defence
- Co-opted members

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Contents

	Page
Committees responsible	Inside front cover
National foreword	ii
Foreword	2
Text of EN 629-2	3

National foreword

This British Standard has been prepared by Subcommittee PVE/3/1 and is the English language version of EN 629-2 : 1996 *Transportable gas cylinders — 25E taper thread for connection to gas cylinders — Part 2: Gauge inspection*, published by the European Committee for Standardization (CEN).

EN 629-2 was produced as a result of international discussion in which the United Kingdom took part.

Cross-references

Publication referred to	Corresponding British Standard
EN 629-1 : 1996	BS EN 629 <i>Transportable gas cylinders — 25E taper thread for connection to gas cylinders</i> Part 1 : 1996 <i>Specification</i>

Compliance with a British Standard does not of itself confer immunity from legal obligations.

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Descriptors: Gas cylinders, gas valves, junctions, tapered screw threads, specifications, dimensions, dimensional measurements, standard gauges

English version

Transportable gas cylinders — 25E taper thread for connection of valves to gas cylinders — Part 2: Gauge inspection

Bouteilles à gaz transportables — Filetages
coniques 25E pour le raccordement des robinets
sur les bouteilles à gaz —
Partie 2: Calibres de vérification

Ortsbewegliche Gasflaschen — 25E kegeliges
Gewinde zum Anschluß von Ventilen an
Gasflaschen —
Teil 2: Lehrenprüfung

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Foreword

This European Standard has been prepared by 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of an identical text or by endorsement, at the latest by December 1996, and conflicting national standards shall be withdrawn at the latest by December 1996.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

Contents

	Page
Foreword	
Introduction	
1 Scope	3
2 Normative reference	3
3 Definitions	3
4 Requirements	3
5 Gauge dimensions	3
6 Inspection gauges	5
7 Use of inspection gauges	12
8 Verification of inspection gauges	13
9 Identification	13
Annex A (informative) Examples of calculation for thread gauge dimensions on the large end diameter	15
Annex B (informative) Limitations of gauging system	15

Introduction

This European Standard is a two part standard, belonging to a series of standards specifying thread dimensions and gauge requirements:

- Part 1: *Specification*;
- Part 2: *Gauge inspection*.

1 Scope

This European Standard specifies types, dimensions and principles of use of gauges, to be used in conjunction with the taper thread specified in EN 629-1.

Annex A provides examples of calculations for thread gauge dimensions on the large end diameter.

Annex B draws attention to the limitations of the gauging system specified.

2 Normative reference

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 629-1 *Transportable gas cylinders — 25E taper thread for connection of valves to gas cylinders*
Part 1: *Specification*

3 Definitions

For the purposes of this standard, the following definitions apply.

3.1 inspection gauge

Gauge used for the routine gauging of cylinder neck and valve stem threads. This gauge is not used for checking other gauges.

3.2 check gauge

Gauge for checking dimensional conformity of inspection ring gauges. This gauge is not used for gauging cylinder neck threads.

3.3 single part gauge

Gauge of sufficient length to contact the full length of taper thread. These gauges are plug or ring, plain or threaded.

3.4 two part gauges

Two separate inspection gauges, used in combination, where one is used to contact the large end of the taper cone and the other the small end. These sets of gauges are plug or ring, plain or threaded.

4 Requirements

4.1 Materials

All gauges shall be manufactured from material of suitable strength, stability and hardness.

4.2 Thread profile

The thread profile of threaded inspection and check gauges shall be as shown in figure 1.

4.3 Thread rotation

The thread shall be a right hand thread, such that it moves away from an observer when rotated clockwise.

4.4 Taper

- Taper ratio: 3 / 25;
- Taper angle: 6° 52';
- Taper slope: 12%.

4.5 Thread profile

The thread profile has a 55° angle. The form and thread height measurements are perpendicular to the cone surface (see figure 1).

4.6 Pitch *P*

The pitch is 1,814 mm (derived from $\frac{25,4}{14}$ mm) (see figure 1).

5 Gauge dimensions

The following dimensional requirements apply to gauges shown in figure 2 to figure 15, inclusive.

5.1 All dimensions are given in millimetres.

5.2 Tolerances for specified dimensions on all gauges are:

- $\pm 0,01$ mm on all lengths;
- $\pm 0,01$ mm on diameters of inspection gauges;
- $\begin{matrix} -0,01 \\ -0,02 \end{matrix}$ mm on diameters of check gauges.

5.3 For threaded gauges, pitch diameters only are specified. For minor and major diameters see figure 1.

5.4 Unspecified dimensions shall be chosen by the manufacturer of the gauges.