



NSAI
Standards

Irish Standard
I.S. EN ISO 13341:2010&A1:2015

Gas cylinders - Fitting of valves to gas cylinders (ISO 13341:2010)

I.S. EN ISO 13341:2010&A1:2015

Incorporating amendments/corrigenda/National Annexes issued since publication:

EN ISO 13341:2010/A1:2015

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Údarás um Chaighdeáin Náisiúnta na hÉireann

EUROPEAN STANDARD

EN ISO 13341:2010/A1

NORME EUROPÉENNE

EUROPÄISCHE NORM

June 2015

ICS 23.020.30

English Version

**Gas cylinders - Fitting of valves to gas cylinders - Amendment 1
(ISO 13341:2010/Amd 1:2015)**

Bouteilles à gaz - Montage des robinets sur les bouteilles à gaz - Amendement 1 (ISO 13341:2010/Amd 1:2015)

Gasflaschen - Eindrehen von Ventilen in Gasflaschen - Änderung 1 (ISO 13341:2010/Amd 1:2015)

This amendment A1 modifies the European Standard EN ISO 13341:2010; it was approved by CEN on 12 March 2015.

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EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

EN ISO 13341:2010/A1:2015 (E)

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Foreword

This document (EN ISO 13341:2010/A1:2015) 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 Amendment to the European Standard EN ISO 13341:2010 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by December 2015, and conflicting national standards shall be withdrawn at the latest by December 2015.

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

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Endorsement notice

The text of ISO 13341:2010/Amd 1:2015 has been approved by CEN as EN ISO 13341:2010/A1:2015 without any modification.

EUROPEAN STANDARD

EN ISO 13341

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2010

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Supersedes EN ISO 13341:1997

English Version

Gas cylinders - Fitting of valves to gas cylinders (ISO 13341:2010)

Bouteilles à gaz - Montage des robinets sur les bouteilles à gaz (ISO 13341:2010)

Gasflaschen - Eindrehen von Ventilen in Gasflaschen (ISO 13341:2010)

This European Standard was approved by CEN on 25 September 2010.

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EN ISO 13341:2010 (E)

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Foreword

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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 April 2011, and conflicting national standards shall be withdrawn at the latest by April 2011.

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Endorsement notice

The text of ISO 13341:2010 has been approved by CEN as a EN ISO 13341:2010 without any modification.

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INTERNATIONAL STANDARD

ISO 13341

Second edition
2010-10-01

Gas cylinders — Fitting of valves to gas cylinders

Bouteilles à gaz — Montage des robinets sur les bouteilles à gaz



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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.

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ISO 13341 was prepared by Technical Committee ISO/TC 58, *Gas cylinders*.

This second edition cancels and replaces the first edition (ISO 13341:1997), which has been technically revised. It also incorporates the Technical Corrigendum ISO 13341:1997/Cor.1:1998.

Gas cylinders — Fitting of valves to gas cylinders

1 Scope

This International Standard 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 10920 and ISO 11363-1. It defines routines 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 gas cylinders including composite cylinders with steel or aluminium boss.

NOTE The procedures and practices specified in this International Standard can be beneficially applied to other valve to cylinder screw thread connection systems. ISO/TR 11364^[4] 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 taping procedure and torque values specified in this International Standard can be used. ISO/TR 11364^[4] gives clear guidance for the method and torque for all listed inlet threads, which are not interchangeable.

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 11114-2, *Transportable gas cylinders — Compatibility of cylinder and valve materials with gas contents — Part 2: Non-metallic materials*

ISO 11119-2, *Gas cylinders of composite construction — Specification and test methods — Part 2: Fully wrapped fibre reinforced composite gas cylinders with load-sharing metal liners*

ISO 11119-3, *Gas cylinders of composite construction — Specification and test methods — Part 3: Fully wrapped fibre reinforced composite gas cylinders with non-load-sharing metallic or non-metallic liners*

ISO 15245-1, *Gas cylinders — Parallel threads for connection of valves to gas cylinders — Part 1: Specification*

3 General requirements and recommendations

Gas cylinders and valves shall be connected so that when in use the combination is gas tight and the valve cannot be removed inadvertently from the cylinder.

The tools used to screw the valve into the gas cylinder shall fit the valve properly and the gas cylinder shall be secured against rotation during the torquing process. The tools shall not cause damage to either the valve or the cylinder. Minor marks to the valve and the cylinder are acceptable. The cylinder and the valving tool axes shall be aligned.

In addition, some composite cylinders need special treatment for the valving process, for example fixing the neck/metal boss during torquing.

Any special instructions given by the cylinder manufacturer shall be followed.

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