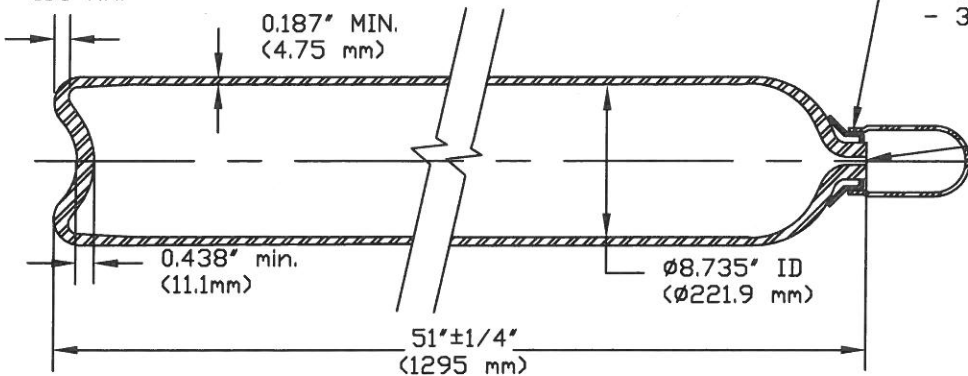


0.438" Min.
(11.1 mm)

0.187" MIN.
(4.75 mm)



Choice of Neck Ring Threads

- 3 1/8-11 UNS Thd.
- 3 1/8-7 UNS Thd.
- 3.147-11 UNS Thd.

3/4-14 NGT (8BC220-3),
1 -11 1/2 NGT (8BC220-1),
25E (8BC220-25E FOR TC-SU10088),
DIN 477 28,8 (8BC220-D for TC-SU10088),
OR COMPARABLE

REV.	ECN - DESCRIPT.	DATE	DRWN.	CHKD.	APP.
01	1042 dot/tc	12/14/92	MB	RS	BA
02	2291	3/26/03	RS	RS	JM
03	2299	5/1/03	RS	RS	BA
04	2371	3/17/04	RS	RS	RS
05	2430	10/7/04	RS	RS	RS
06	2528	1/5/06	RS	RS	
07	2896	8/21/09	JJM		

DRAWING FOR REFERENCE ONLY

SPECIFICATION: DOT 3AA 2015 / TC 3AAM 154 or TC-SU10088-154	
MODEL: 8BC220	
1. Principal Elements: - Min. water capacity: 95.2 lb (43.2 kg) - Min water volume: 2640 in ³ (43.2 liter) - Approx. cyld. weight: 114 lbs (51.7 kg) - DOT Service pressure: 2015psi (138.9 bar) - TC Service pressure: 154 bar - Test pressure: 3360psi (231.7 bar)	3. Manufacture: Hot billet pierce followed by hot drawing.
2. Material: Chrome-Moly steel, (A.I.S.I. 4130X)	4. Heat Treatment: Q & T 5. Norris Standard Mechanical Properties: - Tensile: ≥ 105,000 psi (724 MPa) - Elong.: ≥ 20% (on 2" gauge) - Flattening: to 6xt without cracks
D.O.T. Wall Stress Calculations: $S = P(1.3D^2 + 0.4d^2)/(D^2 - d^2)$	
S = Maximum wall stress, psi P = Test pressure, psi D = Outside diameter, inch d = Inside diameter, inch Required Minimum tensile:	$S = \frac{3360 [1.3 (9.109)^2 + 0.4 (8.735)^2]}{(9.109)^2 - (8.735)^2}$ $S = 69,674 \text{ psi (} 480.4 \text{ MPa)}$ $= \frac{69,674}{0.67} = 103,991 \text{ psi (717 MPa)}$



REFILLABLE SEAMLESS STEEL GAS CYLINDER, MODEL 8BC220

SCALE	NOT TO SCALE		DRAWING NO.	REV.
DWN. BY	MB	2/14/92	901A-B-9104	07
CHK'D BY	RS	2/14/92		
APP'D BY	BA	2/14/92	SHEET NO. 1	OF 1 SHEETS