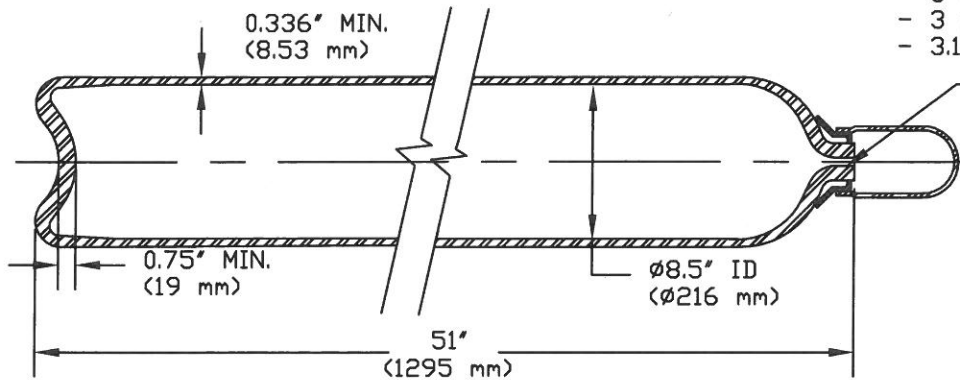


REV.	ECN - DESCIP.	DATE	DRWN.	CHKD.	APP.
01	1161	09/02/93			
02	1394	1/02/97	T.CRAVEN		
03	2896 - Threads	9/03/09	JJM		

Optional Neck Ring Threads


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

3/4-14 NGT (8BC345-3),
 1-11 1/2 NGT (8BC345-1),
 25E (8BC345-25E FOR TC-SU10088),
 DIN 477 28,8 (8BC345-D for TC-SU10088),
 OR COMPARABLE



DRAWING FOR REFERENCE ONLY

SPECIFICATION:DOT 3AA 3600 / TC 3AAM 275 or TC-SU10088-275	
MODEL: 8BC345	
1. Principal Elements: - Min. water capacity: 92.2 lbs (41.8 kg) - Min. water volume: 2557 in ³ (41.8 liter) - Approx. tareweight: 170 lbs (77.1 kg) -DOT Service pressure: 3600psi (248.2 bar) -TC Service pressure: 275 bar - Test pressure: 6000psi (413.8 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: $S = P(1.3D^2 + 0.4d^2)/(D^2 - d^2)$	
$S = \frac{6000 [1.3 (9.172)^2 + 0.4 (8.5)^2]}{(9.172)^2 - (8.5)^2}$ $S = 69,856 \text{ psi } (481.7 \text{ MPa})$ $\text{Required Minimum tensile: } = \frac{69,856}{0.67} = 104,263 \text{ psi } (718.9 \text{ MPa})$	
S = Maximum wall stress, psi P = Test pressure, psi D = Outside diameter, inch d = Inside diameter, inch	

 NORRIS CYLINDER COMPANY 4818 WEST LOOP 281 LONGVIEW, TEXAS 75603 USA			
REFILLABLE SEAMLESS STEEL GAS CYLINDER, MODEL 8BC345			
SCALE	NOT TO SCALE	DRAWING NO.	REV.
DWN. BY	S. JOHNSON	10/31/91	901A-B-9109 03
CHK'D BY	R. S.	11/15/91	
APP'D BY	B. A.	11/25/91	SHEET NO. 1 OF 1 SHEETS