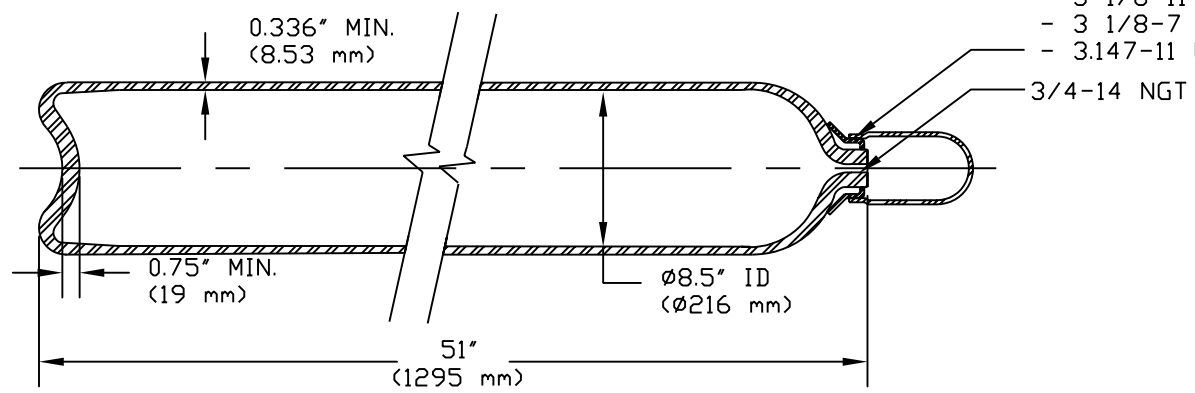


REV.	ECN - DESCRIP.	DATE	DRWN.	CHKD.	APP.
01	1161	09/02/93			
02	1394	1/02/97	T.CRAVEN		


**Choice of Neck Ring Threads**

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



**DRAWING FOR REFERENCE ONLY**

<b>SPECIFICATION:</b> DOT 3AA 3600 / TC 3AAM 275	
<b>MODEL:</b> 8BC345/TC	
<b>1. Principal Elements:</b> - Min. water capacity: 92.2 lbs (41.8 kg) - Min. water volume: 2557 in <sup>3</sup> (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)	<b>3. Manufacture:</b> Hot billet pierce followed by hot drawing.
<b>2. Material:</b> Chrome-Moly steel, (A.I.S.I. 4130X)	<b>4. Heat Treatment:</b> Q & T <b>5. Norris Standard Mechanical Properties:</b> - Tensile: ≥ 105,000 psi (724 MPa) - Elong: ≥ 20% (on 2" gauge) - Flattening: to 6xt without cracks
<b>D.O.T. Wall Stress Calculations:</b> $S = P(1.3D^2 + 0.4d^2)/(D^2 - d^2)$	
S = Maximum wall stress, psi P = Test pressure, psi D = Outside diameter, inch d = Inside diameter, inch Required Minimum tensile:	$S = \frac{6000 [1.3 (9.172)^2 + 0.4 (8.5)^2]}{(9.172)^2 - (8.5)^2}$ $S = 69,856 \text{ psi (481.7 MPa)}$ $= \frac{69,856}{0.67} = 104,263 \text{ psi (718.9 MPa)}$

 <b>NORRIS CYLINDER COMPANY</b> P.O. BOX 7486 LONGVIEW, TEXAS 75607			
<b>REFILLABLE SEAMLESS STEEL GAS CYLINDER, MODEL 8BC345/TC</b>			
SCALE	NOT TO SCALE	DRAWING NO.	REV.
DWN. BY	S. JOHNSON	10/31/91	<b>901A-B-9109</b>
CHK'D BY	R. S.	11/15/91	
APP'D BY	B. A.	11/25/91	SHEET NO. <b>1</b> OF <b>1</b> SHEETS