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Second edition  
2017-07

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## **Gas cylinders — Residual pressure valves — Specification and type testing of cylinder valves incorporating residual pressure devices**

*Bouteilles à gaz — Robinets à pression résiduelle — Spécifications et essais de type de robinets de bouteille intégrant des dispositifs de pression résiduelle*



Reference number  
ISO 15996:2017(E)

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 58, *Gas cylinders*, Subcommittee SC 2, *Cylinder fittings*.

This second edition cancels and replaces the first edition (ISO 15996:2005), which has been technically revised. It also incorporates the Amendment ISO 15996:2005/Amd 1:2007.

The main changes compared to the previous edition are as follows:

- a) Title and scope: extension to cover the complete RPV (valve including the residual pressure device) and not the RPD (residual pressure device) only; informative reference to ISO 10297 was modified;
- b) Scope: inclusion of main valves, valves with integrated pressure regulator (VIPRs) and RPVs for pressure drums and tubes; exclusion of dissolved gases, possible application for RPD stand-alone devices;
- c) Terms, definitions and symbols: introduction of new definitions and adaptation of existing definitions; introduction of different types of RPDs to replace the old descriptions and change of order (type A became type 2 and type B became type 1);
- d) Valve design considerations: inclusion of design considerations with addition of informative [Annex A](#);
- e) Performance requirements and considerations:
  - 1) Closing-off pressure and opening pressure: introduction of requirements for opening pressure and closing-off pressure, especially of a minimum value for the closing-off pressure;
  - 2) Endurance: reduction of number of endurance cycles for type 2 RPDs;
  - 3) Visual examination: introduction of visual examination at the end of the complete test procedure;

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- 4) Resistance of the non-return function against pressure in the reverse direction for type 1 RPDs: exclusion of RPDs in VIPRs and adaptation of pass-fail requirements;
  - 5) Leak tightness in the reverse direction for type 1 RPDs: exclusion of RPDs in VIPRs;
  - 6) Integrity under high flow: exclusion of RPDs when installed outside the filling path in a VIPR;
- f) RPV type testing:
- 1) General: introduction of information on how to deal with changes within the RPV design;
  - 2) Test samples: addition of requirement to submit the test samples for oxygen pressure surge testing with the relevant filling connector(s);
  - 3) Test gases: introduction of requirements on the use and quality of the test gases;
  - 4) Test schedule: adaptation to meet the new requirements, addition of test pressure and test temperature; deletion of information on variants;
  - 5) Strength test of the non-return function in the reverse direction for type 1 RPD tests: decrease of number of test samples to one;
  - 6) Verification of opening pressure and closing-off pressure: addition of verification at low and high temperature; addition of detailed test procedure;
  - 7) Leak tightness test in the reverse direction for type 1 RPDs: modification and clarification of tightness test in the flow direction; addition of test at 0,5 bar in the reverse direction;
  - 8) Visual examination: addition of visual examination to the test sequence;
  - 9) Oxygen pressure surge test: information transferred to normative [Annex B](#); addition of test for main valves; addition of detailed information on test procedure;
- g) Marking: introduction of marking requirements;
- h) [Annex A](#) (informative): deletion of examples of RPV designs; introduction of design considerations;
- i) [Annex B](#) (normative): information on test equipment transferred to informative [Annex D](#); new [Annex B](#) giving mandatory requirements on oxygen pressure surge test;
- j) [Annex C](#) (informative): update of MIL standard reference for vibration test;
- k) [Annex D](#) (informative): complete modification of integrity under high flow test (reduction of number of test samples, adaptation of gases for which an additional test with carbon dioxide should be carried out, change from liquid carbon dioxide to gaseous carbon dioxide as test gas, modification of test procedure);
- l) [Annex E](#): new informative [Annex E](#) giving information on test equipment (former [Annex B](#)).

## Introduction

Increased requirements to avoid contamination of gases and cylinders have led to the development of valves incorporating residual pressure devices (RPDs) hereinafter referred to as residual pressure valves (RPVs).

These devices are designed to maintain a positive pressure relative to atmosphere within the cylinder by closing off its internal gas passages in the discharging direction. This prevents the cylinder from being completely emptied in customer use and stops ingress of atmospheric contamination if the valve operating mechanism (main shut-off) is left open. Many of these devices include a non-return function that protects the cylinder from backflow from downstream processes.

This document has been written so that it is suitable for the application of the UN Model Regulations.

Considering the changes described in the Foreword, when an RPV has been approved according to the previous version of this document, the body responsible for approving the same RPV to this new edition should consider which tests need to be performed.

In this document the unit bar is used, due to its universal use in the field of technical gases. It should, however, be noted that bar is not an SI unit, and that the corresponding SI unit for pressure is Pa (1 bar =  $10^5$  Pa =  $10^5$  N/m<sup>2</sup>).

Pressure values given in this document are given as gauge pressure (pressure exceeding atmospheric pressure) unless noted otherwise.