

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 1939

withdrawn 1975

PNEUMATIC CYLINDERS

CYLINDER BORES AND PORT SIZES

1st EDITION

October 1970

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BRIEF HISTORY

The ISO Recommendation R 1939, *Pneumatic cylinders – Cylinder bores and port sizes*, was drawn up by Technical Committee ISO/TC 39, *Machine tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question led to the adoption of Draft ISO Recommendation No. 1939 which was circulated to all the ISO Member Bodies for enquiry in November 1969. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Belgium	Italy	Sweden
France	Japan	Switzerland
Germany	Poland	Thailand
Greece	Portugal	U.A.R.
Hungary	Romania	United Kingdom
India	South Africa, Rep. of	U.S.S.R.
Israel	Spain	

The following Member Body opposed the approval of the Draft :

U.S.A.

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided to accept it as an ISO RECOMMENDATION.

PNEUMATIC CYLINDERS

CYLINDER BORES AND PORT SIZES

1. SCOPE

This ISO Recommendation specifies the port sizes corresponding to a recommended range of pneumatic cylinder bores.

Its purpose is to prevent cylinders with ports which are too small coming on the market. In other words, by observing the indicated port dimensions a suitable minimum piston speed will be assured.

2. CYLINDER BORE

Dimensions in millimetres

25	32	40	50	63	80	100	125	160	200	250	320	400
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3. PORT SIZES

Cylinder bore	Minimum internal thread Designation according to ISO/R 228-1961, Class A	Corresponding minimum port diameter	
		mm	in
25 32	$\frac{1}{8}$	3	0.125
40 50	$\frac{1}{4}$	6	0.250
63 80	$\frac{3}{8}$	9	0.375
100 125	$\frac{1}{2}$	12.5	0.500
160 200	$\frac{3}{4}$	19	0.750
250 320 400	1	25	1.000