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DESCRIPTION**"GAS CYLINDER"**

[0001] The subject-matter of the present invention is a gas cylinder intended as a transportable container used
5 to store pressurized gas, and provided with a valve that allows the closure thereof.

The cylinder can be completely made from metal, or it can be composed of an inner liner, for example, in steel, which is reinforced by an outer layer of fiber
10 reinforced composite material.

[0002] Gases in the cylinders are classified in compressed gases if the critical temperature thereof is below -50 °C, such as hydrogen or oxygen, in liquefied gases if the critical temperature is higher than -50 °C,
15 such as LPG, and in dissolved gases such as, for example, acetylene in acetone.

[0003] The cylinders are intended for multiple uses, and the standards for the construction and testing thereof vary according to the application. Among the main
20 applications of gas cylinders, the storage of liquefied or compressed gases for autotractor, domestic or industrial uses, the storage of compressed or liquefied gases for industrial use, air holding tanks for compressed air, the storage of breathable mixtures for
25 breathing apparatuses, the storage of medical gases, and

fire extinguishers may be mentioned.

[0004] The gas cylinders for liquefied gas known for domestic uses are of a cylindrical shape, made of welded steel sheet, and have a handle on the upper part to facilitate the grip thereof and to protect the closure valve to which a pressure reducer has to be applied before the first connection to a domestic use. The known gas cylinder for liquefied gas has an internal space that can hold 10 Kg to 25 kg of liquefied gas which partially fills such internal space, leaving a residual space that compensates for the pressure as temperature varies.

[0005] The known gas cylinders for LPG-powered vehicles are also of a cylindrical shape and made of welded steel sheet, and usually secured in a horizontal position in the vehicle boot.

[0006] The known gas cylinders for compressed gases-powered vehicles, among which methane, hydrogen, and mixtures, are also of a cylindrical shape and generally made of seamless steel, and firmly secured to the vehicle.

[0007] The known gas cylinders for the storage of compressed gases operate at a pressure of 200 bar and above, and therefore they have to be constructively robust. They have a cylindrical body with convex or

concave base and hemispherical or elliptical ogive, and a closure valve arranged on the upper part of the cylinder, and protected by a cap screwed to a threaded collar. This type of cylinder is usually made of
5 seamless steel.

[0008] According to the the structural and pressure resistance needs, the known gas cylinders can be manufactured by welding operations of steel sheets, by cold deep drawing of steel sheets, by formation starting
10 from a tube portion in steel, or by formation starting from a steel billet. For securing the closure valve to the cylinder body, it is known to provide (by welding, or hot or cold formation) a threaded tubular neck axially extending from the cylinder upper ogive
15 outwardly and to which it is possible to screw the closure valve.

[0009] The gas cylinders are usually locked, for example, within a vehicle or another application, through one or more clamps or brackets which at least partially embrace
20 the cylinder cylindrical body in order to safely lock it in the expected position.

[0010] The securing brackets are, in turn, arranged and anchored within a special cylinder compartment of the vehicle or the application in general, and determinate a
25 more or less large and unused interspace between the gas

cylinder and such compartment.

[0011] Furthermore, in many uses, the space available to accommodate the gas cylinders has an irregular shape, for example, approximately trapezoidal rather than rectangular, and can be interrupted by further functional elements, for example, tubes or reinforcement props, of the use itself. Even in these conditions it is desirable to reduce the available, but unused, spaces in order to store gas.

10 [0012] The object of the present invention is to provide a gas cylinder of the type specified before, having such characteristics as to better exploit the space that is available within the cylinder compartments for the storage of gas and therefore, with particular reference to gas-traction vehicles, to increase the traction autonomy, while keeping the overall dimensions constant.

[0013] This and other objects are achieved by a gas cylinder comprising a cylinder body internally defining a gas storing space that is closable by a closure valve, in which said cylinder body comprises a tubular wall extending along a longitudinal axis, a bottom wall defining the gas storing space on a cylinder lower side, and an upper wall defining the gas storing space on an upper side opposite the lower side, as well as a threaded tubular neck, formed at the cylinder body so as

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to be able to receive the closure valve in communication with the gas storing space, in which the tubular wall comprises at least a first enlarged tubular portion and at least a second tubular portion that is adjacent and
5 narrowed relative to the first tubular portion.

[0014] Thanks to the enlarged tubular portion adjacent to the narrowed tubular portion, it is possible to adapt the overall dimensions of the gas cylinders to irregular-shaped spaces, and to receive locking clamps
10 or brackets in an outer circumferential seat formed by the narrowed tubular portion, and to exploit the zones that are adjacent to the locking brackets for the gas storage.

[0015] In accordance with an aspect of the invention, the
15 tubular wall containing such enlarged and narrowed tubular portions is formed in a single piece of seamless steel, the thickness thereof is formed by a single layer, with the exception of optional paint layers, which are optionally applied on the tubular wall outer
20 or inner surface.

[0016] This facilitates the cylinder suitability testing and increases the tubular wall resistance in the transition areas between the enlarged portions and the narrowed portions, and therefore allows limiting the
25 thickness of the wall itself.

[0017] In accordance with a further aspect of the present invention, the narrowed portions form a plurality of preferably two annular narrowings, each of which is defined on both sides by corresponding enlarged tubular portions 11.

[0018] This particular configuration of the cylinder allows a correct positioning of the locking clamps and prevents an accidental withdrawal thereof in the longitudinal direction of the gas cylinder.

10 [0019] In order to better understand the present invention and appreciate the advantages thereof, some exemplary, non-limiting embodiments thereof will be described herein below, with reference to the Figures, in which:

[0020] Fig. 1 is a side view, with partial longitudinal section of a gas cylinder according to an embodiment of the invention;

[0021] Fig. 2 is a side view, with partial longitudinal section of a gas cylinder according to a further embodiment of the invention;

20 [0022] Fig. 3 is a partial view in longitudinal section of a gas cylinder according to a still further embodiment of the invention, applicable both to the gas cylinder in Fig. 1 and to the gas cylinder in Fig. 2;

[0023] Figs. 4A and 4B schematically illustrate cylinder compartment - gas cylinder assemblies according to

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embodiments of the invention;

[0024] Fig. 5 is a side view, with partial longitudinal section of a gas cylinder according to a further embodiment of the invention;

5 [0025] Fig. 6 schematically illustrates a further cylinder compartment - gas cylinder assembly according to the invention;

[0026] Figs. 7 and 8 schematically illustrate methods for the fabrication of a gas cylinder according to
10 embodiments of the invention;

[0027] Fig. 9 is a side view, with partial longitudinal section of a gas cylinder according to a further embodiment of the invention;

[0028] With reference to the Figures, a gas cylinder
15 (hereinafter the "cylinder") is generally indicated with the numeral reference 1. The cylinder 1 comprises a cylinder body 2 internally defining a gas storing space 3 that is closable by a closure valve (not indicated in the Figures). The cylinder body 2 comprises a tubular
20 wall 5, preferably substantially cylindrical, and extending along a longitudinal axis L of the cylinder 1, a bottom wall 6, for example, in the shape of a spherical or elliptical cap, connecting to a tubular wall 5 lower end and defines the gas storing space 3 on
25 a cylinder 1 lower side 7, as well as an upper wall 8,

for example, in the shape of an ogive, connecting to a tubular wall 5 upper end and defines the gas storing space 3 on an upper side 9 of the cylinder 1 opposite the lower side 7. The cylinder 1 further comprises a threaded tubular neck 10, formed at the cylinder body 2 so as to be able to receive (by screwing) the closure valve in communication with the gas storing space 3.

[0029] According to an aspect of the present invention, the tubular wall 5 comprises at least a first tubular portion 11 that is enlarged, and at least a second tubular portion 12 that is adjacent and narrowed relative to the first enlarged tubular portion 11.

[0030] Thanks to the enlarged tubular portion 11 adjacent to the narrowed tubular portion 12, it is possible to receive locking clamps or brackets in the narrowed tubular portion 12 and to exploit the zones adjacent to the locking brackets for the storage of gas.

[0031] In accordance with an aspect of the invention, the tubular wall 5 containing such enlarged 11 and narrowed 12 tubular portions is formed in a single piece of seamless steel, the thickness of which is formed by a single layer, with the exception of optional paint layers (not relevant to the aim of the mechanical resistance) optionally applied on the tubular wall 5 outer 13 or inner 14 surface.

[0032] This facilitates the cylinder suitability testing and increases the tubular wall resistance in the transition areas between the enlarged portions 11 and the narrowed portions 12, and therefore allows limiting
5 the thickness of the wall 5 itself.

[0033] In accordance with a further aspect of the present invention (fig. 2), the narrowed portions 12 form a plurality of preferably two annular narrowings 15, each of which is defined on both sides by corresponding
10 enlarged tubular portions 11.

[0034] This particular configuration of the cylinder allows a correct positioning of the locking clamps and prevents an accidental withdrawal thereof in the gas cylinder 1 longitudinal direction L.

15 [0035] With the aim of conciliating at the best the needs of a stress of the tubular wall 5 as much as possible as a "stretched membrane", and of a non-cylindrical shape thereof, such as to exploit at the most the space that is available for the storage of gas, the narrowed
20 portion 11 or, preferably, all the narrowed portions 11 form respectively a circular cylindrical central ring 16 having a constant diameter along the longitudinal axis L and two transition side rings 17 connecting the central ring 16 to the adjacent enlarged tubular portions 11,
25 thus forming a circumferential step.

[0036] Advantageously, the side rings 17 have, in a longitudinal section plane which comprises the longitudinal axis L, a double curvature (Fig. 1) or a truncated cone 25 (Fig. 5) shape and a longitudinal extension L1 smaller than the longitudinal extension L2 of the cylindrical central ring 16. With the aim of reducing the bending stresses of the narrowed zones, it is advantageous to provide the central ring longitudinal extension L2 smaller than the sum of the side rings longitudinal extensions L1, that is, $L2 < 2L1$.

[0037] Also the enlarged tubular portions 11 form preferably one or more circular cylindrical rings with constant diameter along the cylinder 1 longitudinal axis L.

[0038] With the aim of maximizing the gas storing space, it can be provided that the overall longitudinal length of all the enlarged tubular portions 11 is higher than the overall longitudinal length of all the narrowed tubular portions 12, that is, $\Sigma L3 > \Sigma L1 + \Sigma L2$.

[0039] In accordance with an embodiment (Figs. 1, 5), the tubular wall 5 forms a single first enlarged portion 11 and a single second narrowed portion 12 adjacent to the enlarged portion 11 and spaced apart therefrom by a circumferential step 18 (Fig. 1) or by a frustoconical connection 25 (Fig. 5) formed by a single side ring 17

of the narrowed portion 12 that can be shaped as previously described with reference to Fig. 2.

[0040] In this manner, the gas cylinder 1 has a general step tapered shape allowing a securing thereof by one or
5 more locking brackets in the tapered zone without leaving unused spaces in the cylinder compartment of the application, for example, of a gas-powered vehicle.

[0041] In accordance with a further aspect of the present invention (Fig. 9), two narrowed portions 12 form an
10 upper length and a lower length of the tubular wall 5, respectively, between which an enlarged tubular portion 11 extends, forming an intermediate length, preferably substantially central, of such tubular wall 5.

[0042] As it can be seen from the Figures, the tubular
15 wall thickness does not vary substantially, i.e., the tubular wall 5 inner surface 14 substantially follows the trend of the outer surface 13, so that the shape adaptation of the tubular wall 5 to the outer space conditions translate into a maximization of the gas
20 storing space 3 within the cylinder 1.

[0043] According to a further aspect of the present invention (FIG. 3) that is advantageously implementable in combination with one or all of the characteristics hereto described, the gas cylinder 1 neck 10 comprises
25 an inner portion 19, which is internally threaded and

projecting inwardly in the gas storing space 3 in the cylinder body 2.

[0044] Thanks to the configuration of the threaded neck 10 at least partially projecting inwardly of the cylinder
5 body 2, it is possible to exploit for the storage of gas also at least a part of the cylinder height that is in any case necessary for the screwing of the closure valve.

[0045] In accordance with an aspect of the invention, the
10 neck 10 is formed in the cylinder body 2 upper wall 8 so that the gas storing space 3 forms an annular space portion 12 extending about the neck 10 inner portion 19 and defined by the inner portion 11 itself and by such upper wall 8.

15 [0046] In accordance with an embodiment of the invention, the neck 10 inner portion 11 is formed as a single piece with the cylinder body 2.

[0047] Alternatively, the neck 10 inner portion 19, or the whole neck 10, is manufactured separately from the
20 cylinder body 2, and connected thereto subsequently, for example, by screwing or welding.

[0048] The present invention is advantageously applicable to all types of gas cylinders, in particular to metal gas cylinders, preferably in steel, manufactured by cold
25 forming (for example, by deep drawing of sheet) or hot

forming, starting from a steel billet (for example, by cupping and hot piercing), or by hot forming, starting from a steel tube with closure of the ends (for example, by hot spinning), or by welding, starting from one or
5 more steel sheets.

[0049] The tubular wall 5 narrowed portions 12 can be advantageously obtained by hot or cold rolling, by the action of a forming tool 27 acting on the wall of the cylinder or the stage (the term "stage" defines the
10 semi-finished cylinder body before ogive-shaping of the upper portion which forms the neck). To this aim, the cylinder 1 is rotated about the longitudinal axis L thereof, and the tool 27 is contacted with the tubular wall 5 and radially moved closer and at the same time
15 moved in the longitudinal direction L so as to deform the tubular wall 5 and locally reduce the diameter thereof in the zones of the narrowed portions 12 (Fig. 8).

[0050] Alternatively (Fig. 7), it can be advantageous to draw the stage, before forming the ogive, by a punch 28 and a die 29 of a frusto-conical shape, so configured as to obtain, together, a local reduction of the tubular wall 5 diameter in the zones of the narrowed portions
20 12.

25 [0051] The neck 10 itself can be manufactured and/or

connected to the cylinder body 2 by hot forming, welding, or screwing with or without successive mechanical processing.

[0052] Figs. 4A and 4B illustrate embodiments of cylinder compartment - cylinder assemblies 20 for uses of gas, for example, vehicles. The cylinder compartment - cylinder assembly 20 comprises one or more gas cylinders 1 according to what has been described before, a support and holding structure 21 securable or formed to a bearing structure of the use (for example, of a vehicle) and configured to at least partially receive such gas cylinders, as well as one or more locking members 22, preferably locking clamps or brackets, anchored or anchorable to the support and holding structure 21 and adapted to at least partially embrace said gas cylinders 1 in order to lock them to the support and holding structure 21. Such locking members 22 have at least a portion received in a circumferential seat 23 formed by the narrowed portion 12 in the gas cylinder 1 outer surface 13. Furthermore, at least one of the enlarged portions 11 of the gas cylinder tubular wall 5 extends in an interspace 24 (otherwise unused), defined between two locking members 22 or between a locking member 22 and the support and holding structure 21.

[0053] Fig. 6 illustrates a further cylinder compartment -

cylinder assembly 20, in which the holding structure 21 comprises mutually inclined side walls, and/or interruptions due to functional members 26 (for example, tubes or reinforcing props), and the cylinder(s) 1 are
5 adapted to the holding structure 21 shape thanks to the presence of the enlarged and narrowed portions 11, 12.

[0054] On the basis of the description and illustration of the invention hereto provided, those skilled in the art will appreciate how the gas cylinder 1 and the cylinder
10 compartment-cylinder assembly 20 overcome the drawbacks discussed with reference to the prior art, and achieve an increase of the volume of the gas storing space 3, while keeping the overall dimensions of the cylinder compartment-gas cylinder assembly constant, in an
15 application, e.g. vehicle use.

[0055] It shall be apparent that to the gas cylinder and the cylinder compartment-gas cylinder assembly according to the present invention, those of ordinary skill in the art, with the aim of meeting contingent, specific needs,
20 will be able to make further modifications and variations, all of which anyhow falling within the protection scope of the invention, as defined by the following claims.

CLAIMS

1. A gas cylinder (1) comprising a cylinder body (2) internally defining a gas storing space (3) that is closable by a closure valve, in which said cylinder body
5 (2) comprises:

- a tubular wall (5) defining said gas storing space (3);
- a bottom wall (6) connected to a tubular wall (5) lower end and defining the gas storing space (3) on a
10 cylinder (1) lower side (7);

- an upper wall (8) connected to a tubular wall (5) upper end and defining the gas storing space (3) on a cylinder (1) upper side (9) opposite the lower side (7);

characterized in that the tubular wall (5) comprises at
15 least a first tubular portion (11) that is enlarged, and at least a second tubular portion (12) that is adjacent and narrowed relative to the first tubular portion (11).

2. The gas cylinder (1) according to claim 1, wherein the tubular wall (5) containing said enlarged (11) and
20 narrowed (12) tubular portions is formed in a single piece of seamless steel, the thickness of which is formed by a single layer, with the exception of optional paint layers.

3. The gas cylinder (1) according to claim 1 or 2,
25 wherein the narrowed portion (12) forms an annular

narrowing (15) defined on both sides by corresponding extended tubular portions (11).

4. The gas cylinder (1) according to any one of the preceding claims, wherein the narrowed portion (11) forms a substantially cylindrical circular central ring (16) having a constant diameter along the longitudinal axis (L), and two transition side rings (17) connecting the central ring (16) to the adjacent enlarged tubular portions (11).
5. The gas cylinder (1) according to claim 4, wherein the side rings (17) form circumferential steps.
6. The gas cylinder (1) according to claim 4, wherein the side rings (17) have, in a longitudinal section plane comprising the longitudinal axis (L), a double curvature or a truncated cone (25) shape and a longitudinal extension (L1) that is smaller than the cylindrical central ring (16) longitudinal extension (L2).
7. The gas cylinder (1) according to any one of the preceding claims, wherein the enlarged tubular portions (11) form circular cylindrical rings with constant diameter along the cylinder (1) longitudinal axis (L).
8. The gas cylinder (1) according to any one of the preceding claims, wherein the overall longitudinal length of all the enlarged tubular portions (11) is

greater than the overall longitudinal length of all the narrowed tubular portions (12).

9. The gas cylinder (1) according to any one of the preceding claims, wherein said tubular wall (5) forms a
5 single first enlarged portion (11) and a single second narrowed portion (12) adjacent to the enlarged portion (11) and spaced apart therefrom by a circumferential step (18).

10. The gas cylinder (1) according to any one of the
10 preceding claims, wherein said cylinder (1) further comprises a threaded tubular neck (10), formed at the cylinder body (2) so as to be able to receive said closure valve (4) in communication with said gas storing space (3), and the neck (10) comprises an inner portion
15 (11) internally threaded and projecting inwardly in the gas storing space (3) in the cylinder body (2).

11. The gas cylinder (1) according to claim 10, wherein the neck (10) is formed in the cylinder body (2) upper wall (8).

20 12. The gas cylinder (1) according to claim 10 or 11, wherein said gas storing space (3) forms an annular space portion (12) about the neck (10) inner portion (11).

13. The gas cylinder (1) according to any one of the
25 claims 10 to 12, wherein the neck (10) inner portion

(11) is formed as a single piece with the cylinder body (2).

14. The gas cylinder (1) according to any one of the claims 10 to 13, wherein the neck (10) inner portion
5 (11) is manufactured separately from the cylinder body (2) and subsequently connected thereto.

15. A cylinder compartment - gas cylinder assembly 20, comprising:

- one or more gas cylinders (1) according to any one of
10 the preceding claims;
- a support and holding structure (21) securable to a bearing structure of an application, and configured to at least partially receive said gas cylinders (1);
- one or more locking members (22) anchored to the
15 support and holding structure (21) and adapted to at least partially embrace said gas cylinders (1) so as to lock them to the support and holding structure (21),
wherein said locking members (22) are partially received in a circumferential seat (23) of the gas cylinder (1)
20 formed by the narrowed portion (12) thereof and the enlarged portion (11) extends in an interspace (24) between the locking member (22) and the support and holding structure (21).

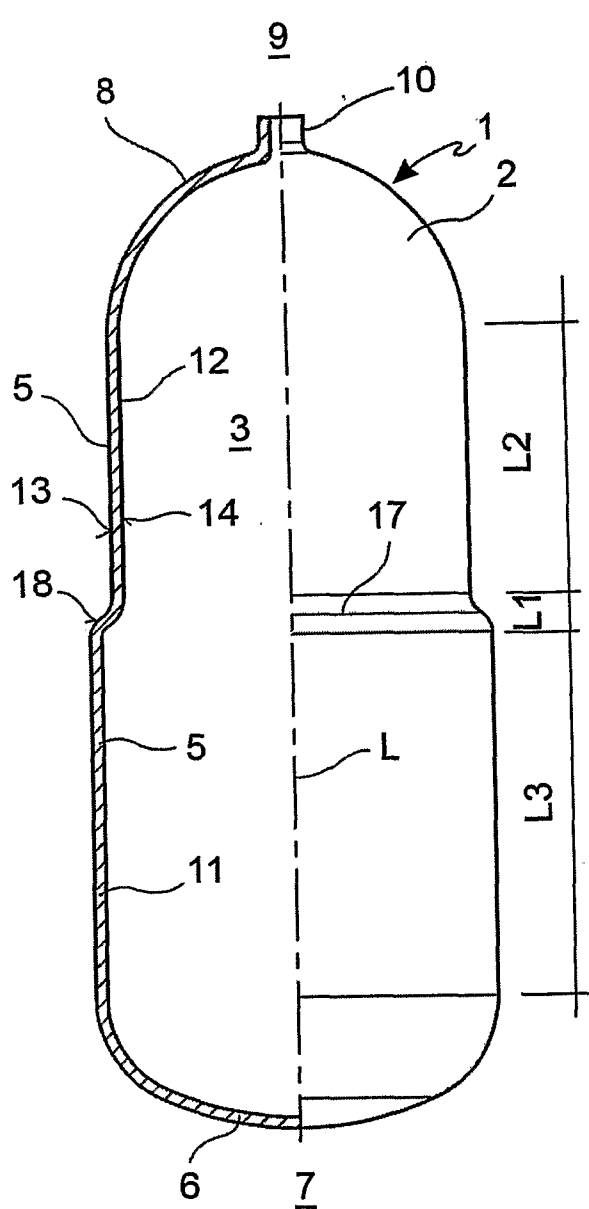


FIG. 1

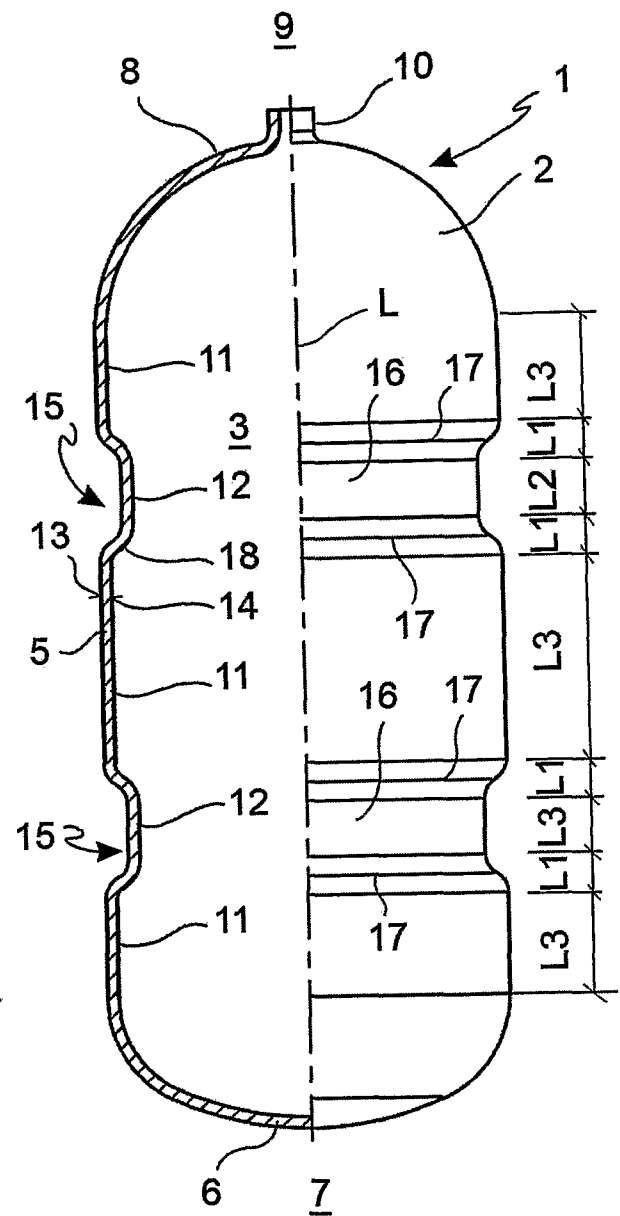


FIG. 2

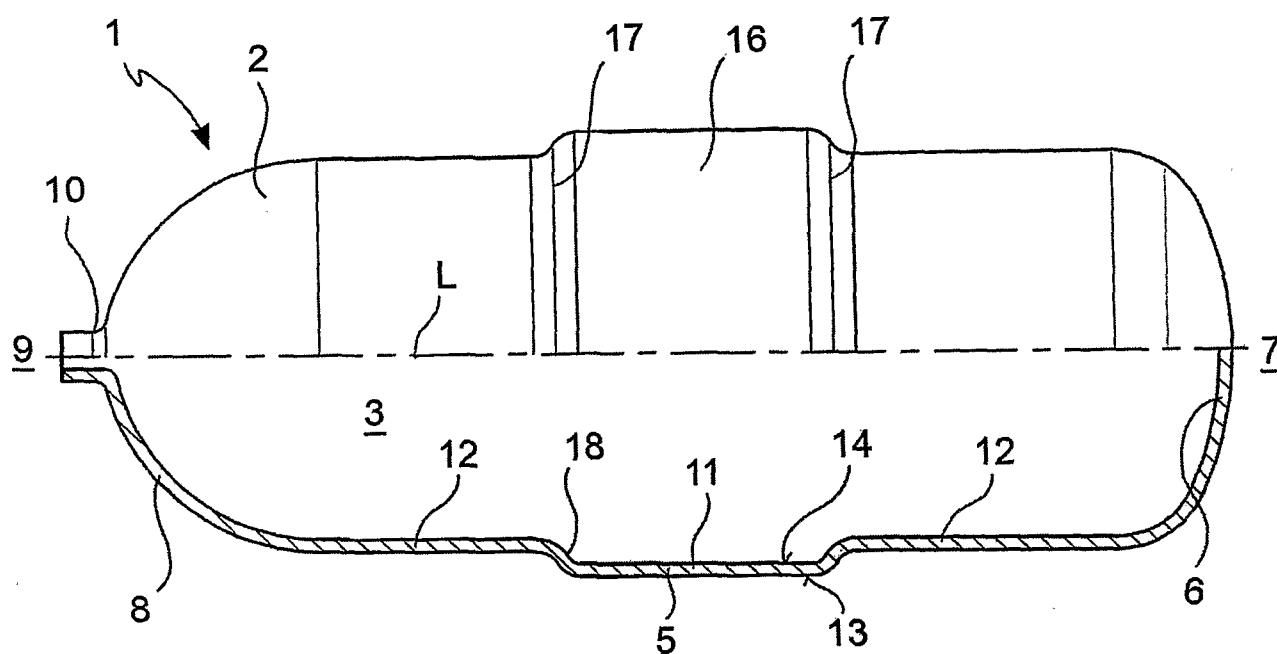


FIG. 9

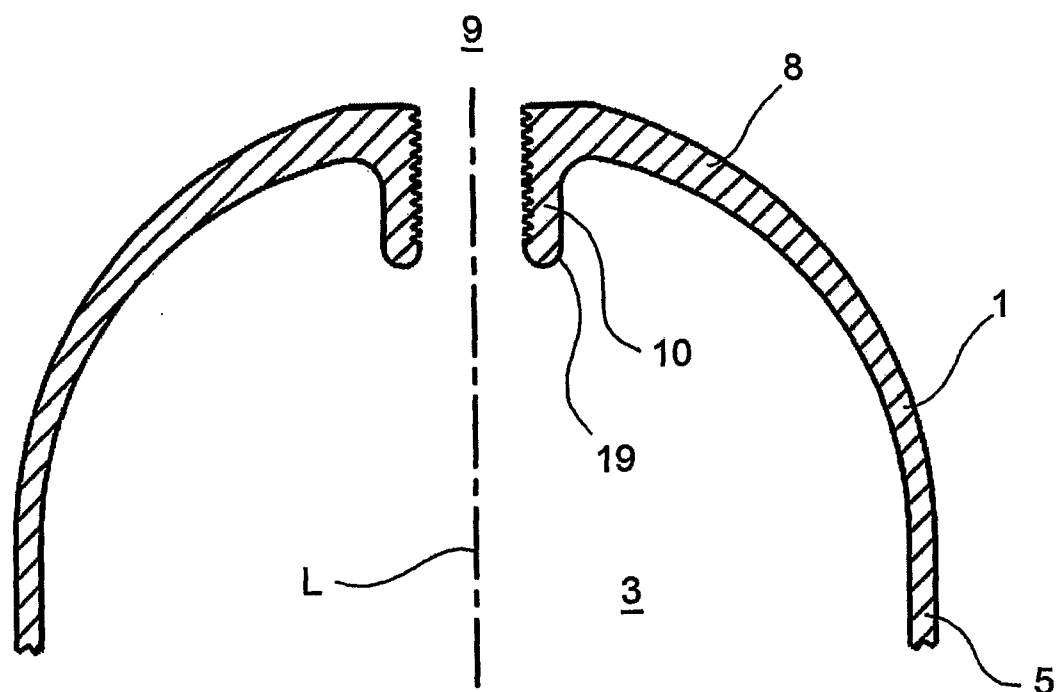
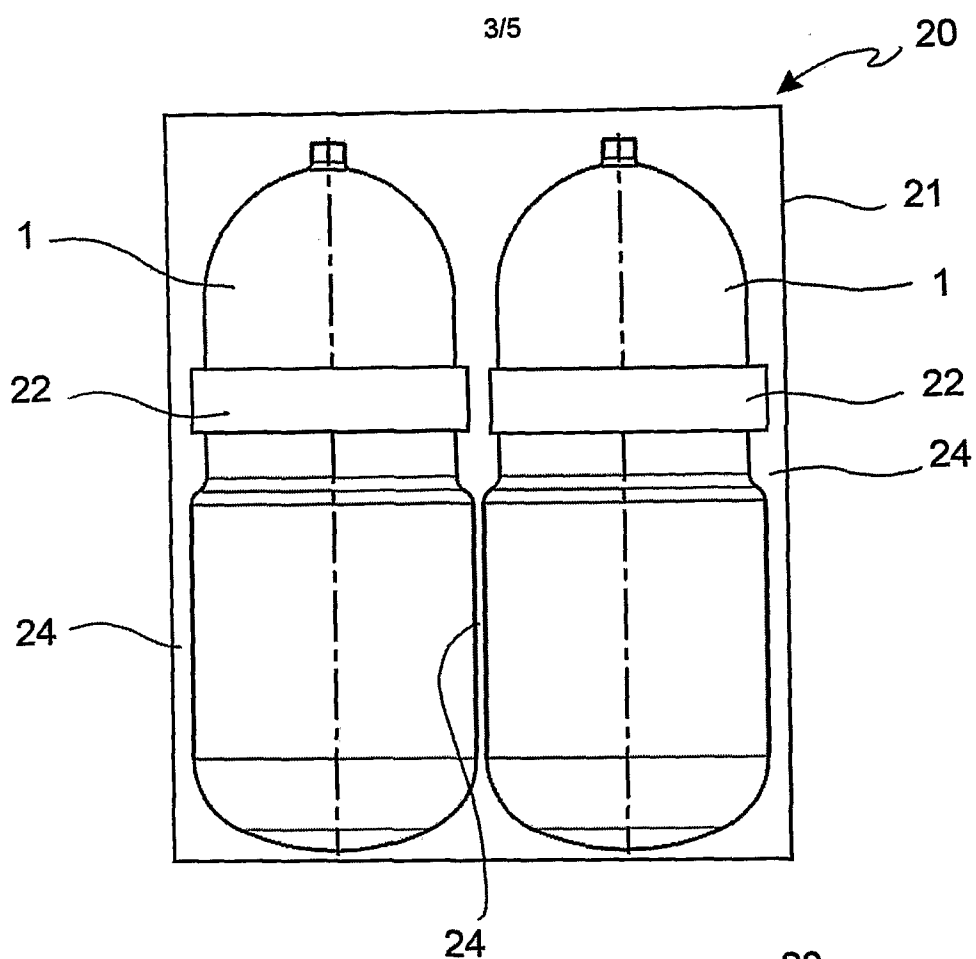
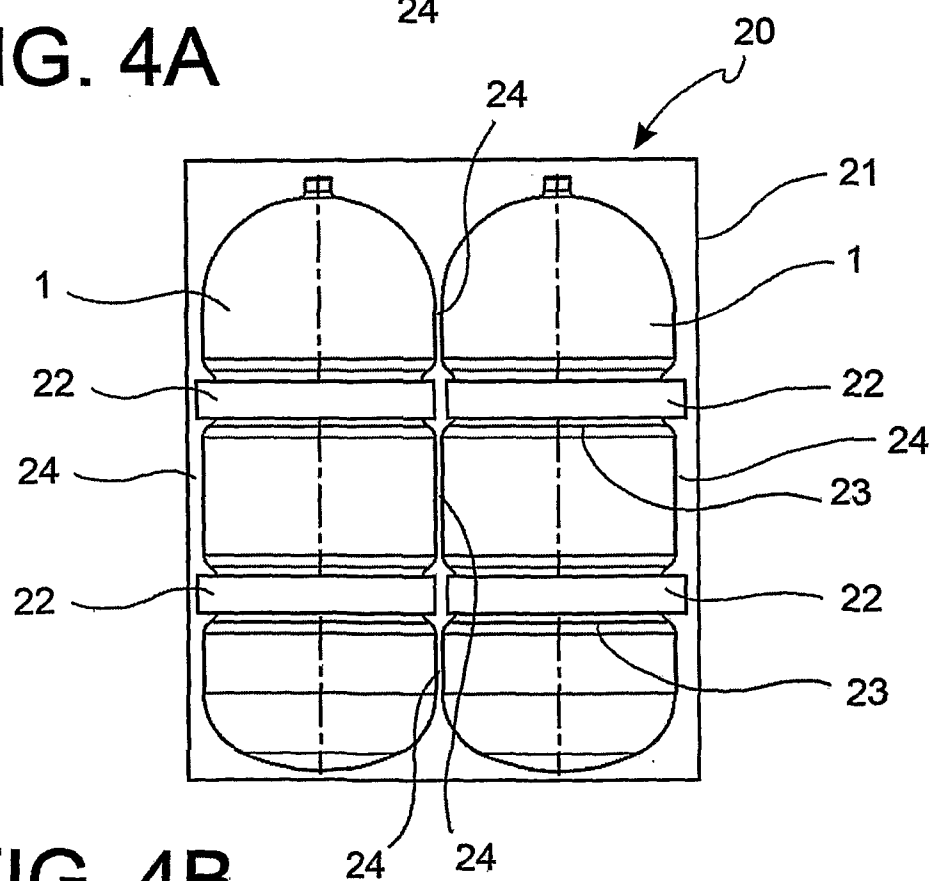
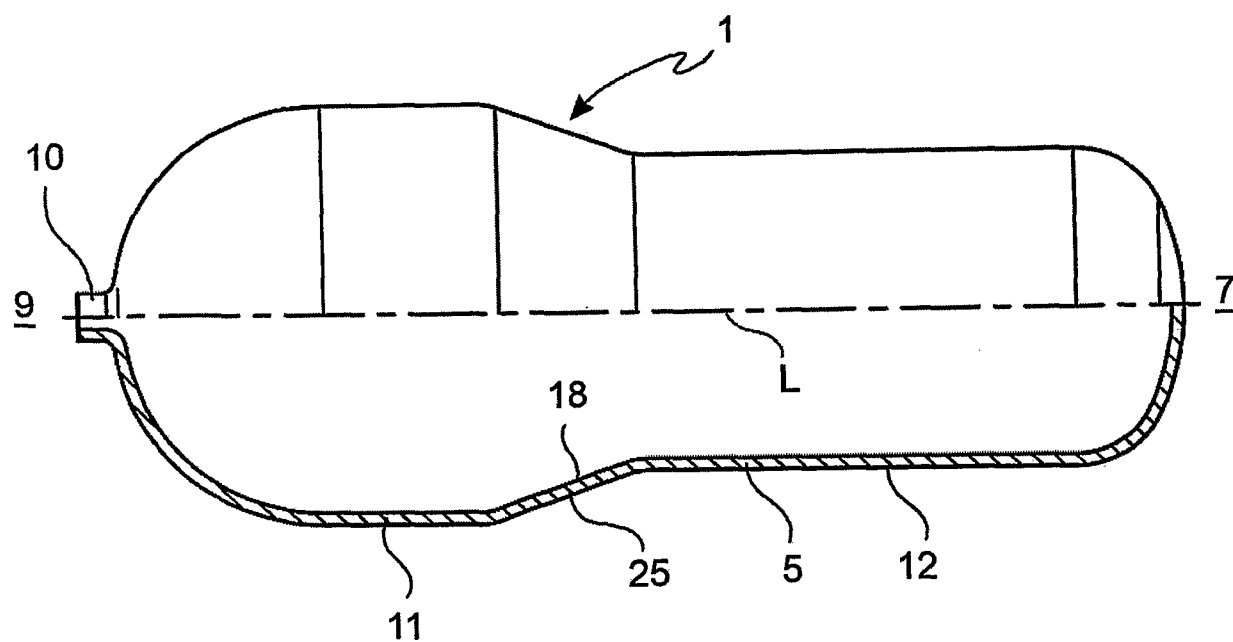
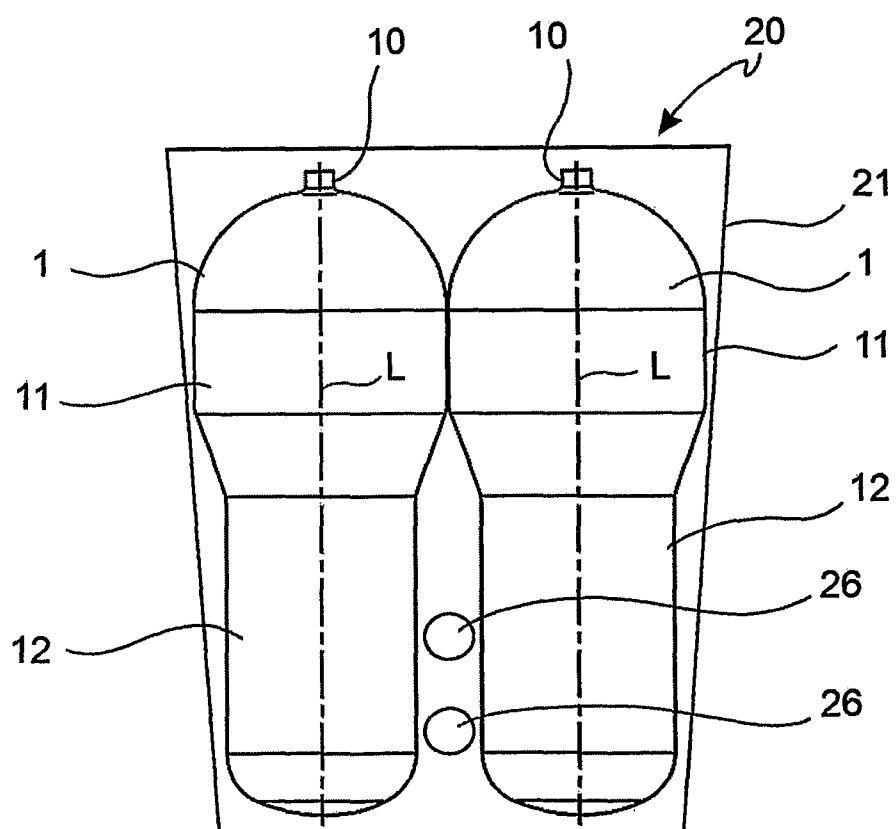


FIG. 3

**FIG. 4A****FIG. 4B**

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**FIG. 5****FIG. 6**

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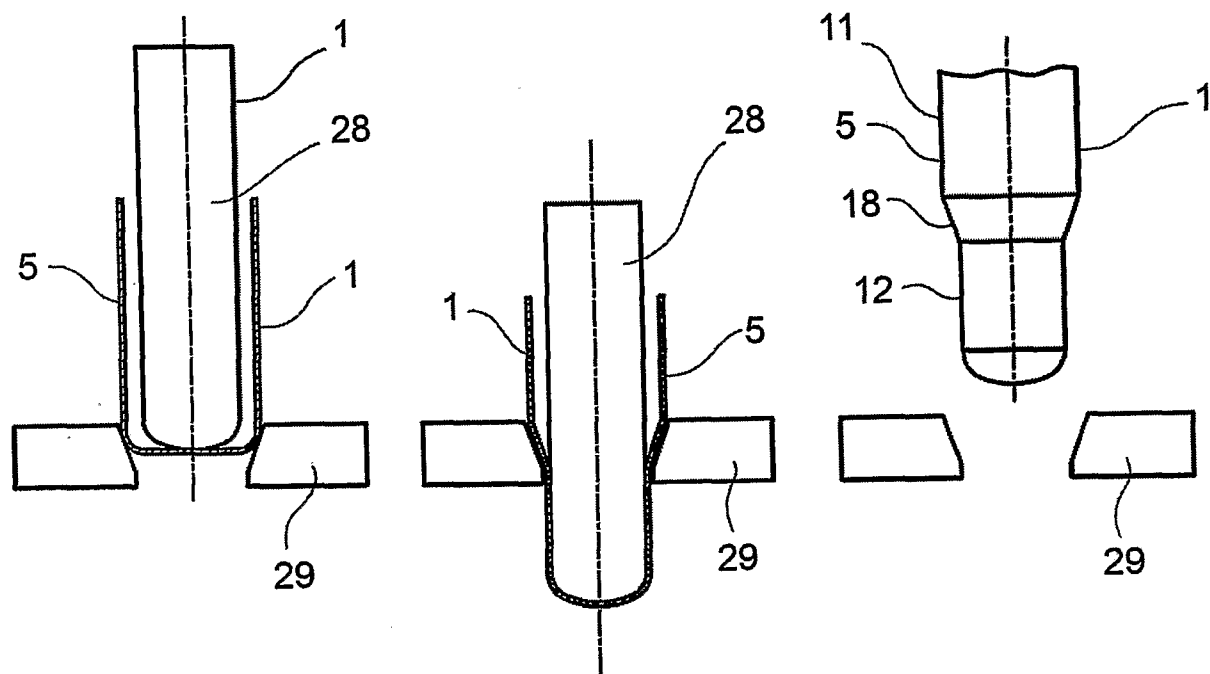


FIG. 7

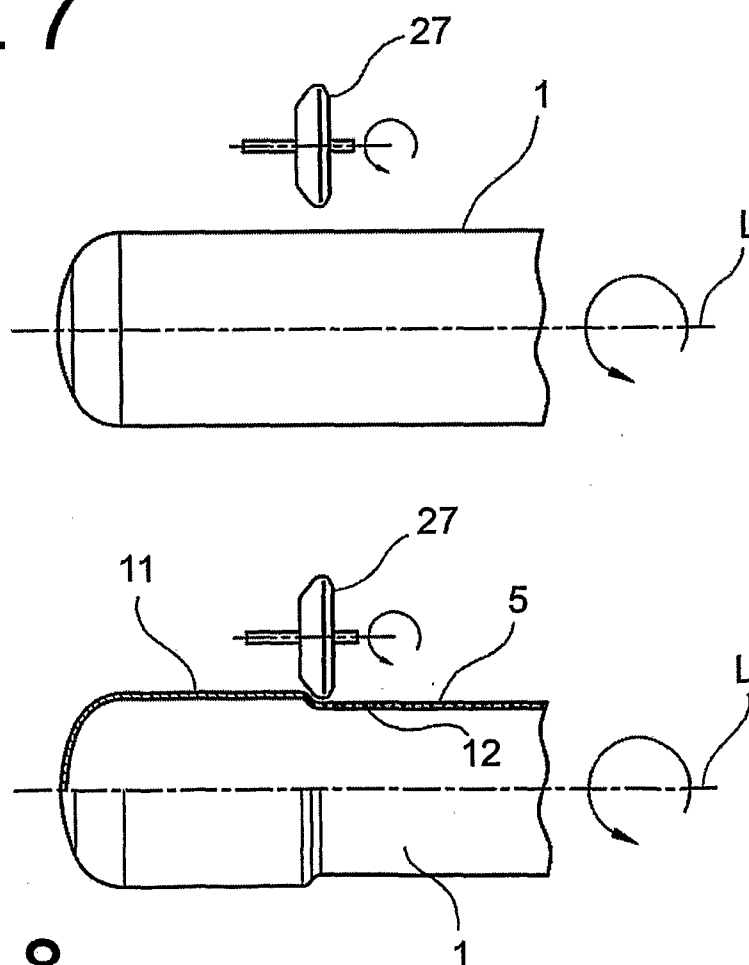


FIG. 8

INTERNATIONAL SEARCH REPORT

International application No
PCT/IT2009/000430

A. CLASSIFICATION OF SUBJECT MATTER
INV. F17C1/00
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
F17C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2002/053573 A1 (BOWEN RONALD R [US] ET AL) 9 May 2002 (2002-05-09) paragraphs [0002], [0051]; figure 2 -----	1-4, 7-14
X	US 2 332 462 A (NILSON ERIC H) 19 October 1943 (1943-10-19) column 1, lines 4-6 column 2, lines 1-4, 36-48 -----	1, 3-5, 7
X	US 6 453 697 B1 (HARMER CHARLES G [US] ET AL) 24 September 2002 (2002-09-24) column 1, line 1 column 2, lines 8-14 column 3, lines 36, 51, 57, 64 column 6, line 36 - column 7, line 24 figures 5a, 6 ----- -/--	1, 2, 8, 9

☒ Further documents are listed in the continuation of Box C.

☒ See patent family annex.

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Date of the actual completion of the international search

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Ott, Thomas

INTERNATIONAL SEARCH REPORT

International application No
PCT/IT2009/000430

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/IT2009/000430

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