INTERNATIONAL STANDARD

ISO 18418-1

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Gasoline engines — Medium pressure liquid fuel supply connections —

Part 1: 60° female cone connectors

Moteurs à essence — Connections pour des lignes de combustible liquide à moyenne pression —

Partie 1: Raccords à cônes femelle de 60°

Reference number
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Foreword

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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).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 22, *Road vehicles*, Subcommittee SC 7, *Injection equipment and filters for use on road vehicles*.

ISO 18418 consists of the following parts, under the general title *Gasoline engines — Medium pressure liquid fuel supply connections*:

— *Part 1: 60° female cone connectors*

— *Part 2: Pipe assemblies*

Introduction

Some spark ignition (SI) engines use direct injection (DI) fuel systems which supply gasoline under pressure to a rail and to the injectors via pipe assemblies with a 60° female cone connector. Such components are similar to ISO 2974 and ISO 13296 for the diesel injection systems except for the relationship between the outside and inside diameters of the pipes due to the lower pressure range.

Connectors defined either in ISO 2974 or in this part of ISO 18418 can be used.

Gasoline engines — Medium pressure liquid fuel supply connections —

Part 1:
60° female cone connectors

1 Scope

This part of ISO 18418 specifies the dimensional requirements of medium-pressure pipe end-connections for gasoline (spark-ignition) engine fuel injection equipment.

It is applicable to externally threaded end-connections having a 60° female cone (see Figure 1), as well as to the pipe end assemblies of medium-pressure fuel injection pipes with outside diameters of up to and including 10 mm (see Table 1).

2 Normative reference

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 261, *ISO general purpose metric screw threads — General plan*

3 Requirements

3.1 Dimensions and tolerances

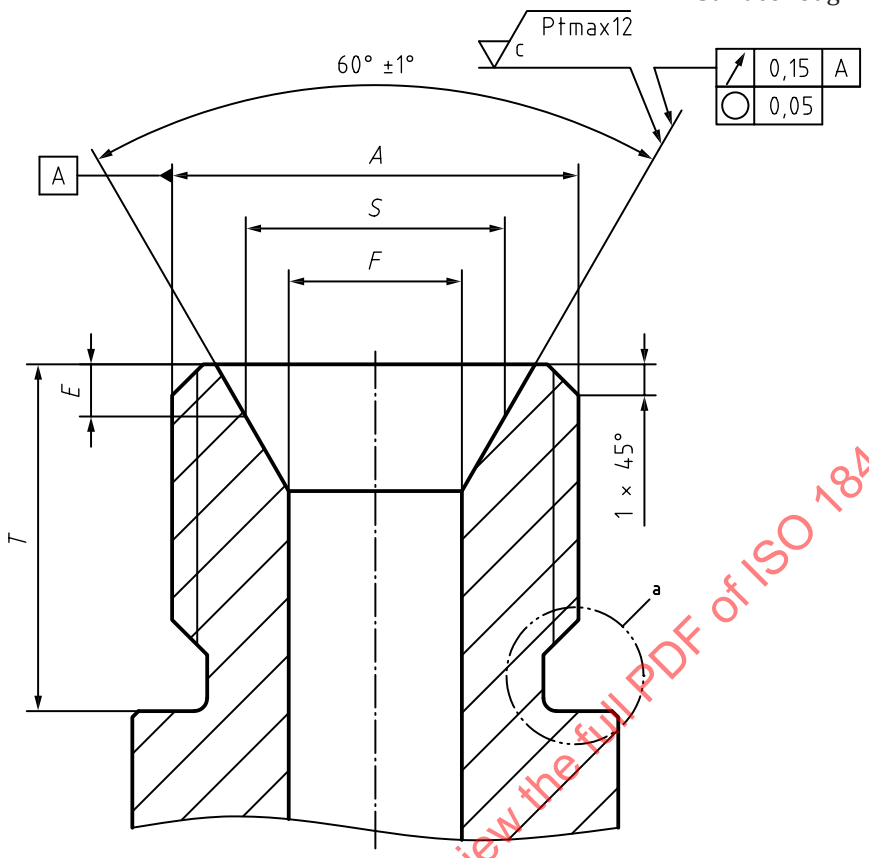
Figure 1 indicates the basic requirements for the end-connection at the rail, at the fuel injection pump, and at the injector to allow interchangeability for medium-pressure fuel injection pipe assemblies.

The 60° female cone and its relationship to the external thread of the end-connection shall meet the requirements of Figure 1.

It is important that the dimensions and tolerances are valid after the final assembly (heat treating, brazing, welding) of the end-connection to the rail, the pump, or the injector and prior to the assembly of the pipe.

Dimensions and tolerances are given in Table 1. Unspecified details are left to the manufacturer's choice.

Dimensions in millimetres
Surface roughness in micrometres



Key

A thread
S reference diameter
E depth of reference diameter plane
F bore diameter
T connector length
a Undercut: design according to agreement between customer and supplier maintaining a minimum thread engagement of 3x pitch when assembled with pipe end nut.

NOTE 1 See Table 1 for dimensions of *A*, *S*, *E*, *F*, and *T*.

NOTE 2 All non-dimensioned edges -0,2 .

Figure 1 — End-connector with integral 60° female cone

Table 1 — 60° female cones

Dimension in millimetres

Tube outside diameter	Thread[a] *A*	Reference diameter *S*	Bore diameter *F* max.	Depth of reference diameter plane *E*	Connector length *T* min.
8	M14 × 1,5	8,5	6,1	2,2 ± 0,08	11
10	M16 × 1,5	8,5	8,1	3,9 ± 0,08	11
a Tolerance classes of threads 6g for external threaded end-connection.					

3.2 Materials

The specification of material and heat treatment shall be made according to the intended use.

4 Operating pressure

The permissible operating pressure shall be specified with an adequate safety margin to ensure the sealing of the joint under maximum internal pressure, and shall be agreed upon between supplier and customer.

5 Designation

An end-connection conforming to this part of ISO 18418 shall be designated by the following elements, in the order given:

a) a reference to this part of ISO 18418, i.e. ISO 18418-1;

b) the tube outside diameter, in millimetres (mm);

c) the thread designation, in accordance with ISO 261.

EXAMPLE An end-connection of pipe outside diameter 8 mm, with an M14 thread is designated:

ISO 18418-1: 8 - M14