

Guidance Note: Cylinder Inspection/Test Marks – 04/05.

Amendment 02 – 10/11.

BS EN 1802 and BS EN 1968 require that cylinders are **both stamped with the date of the inspection or test and labelled to indicate when the next inspection or test is due**. See Figures below.

The manufacturer's marks should be legible and unaltered. **The alteration of original stamp marking is not routine and should be viewed with suspicion**. Stamping is normally applied to the top dome above the shoulder, where the cylinder is thickest. **The parallel part must never be stamped**. See BS EN 1802 and BS EN 1968.

POSITIONING

On cylinders manufactured to earlier standards, test marks were positioned at random; **however, EN, EEC and ISO types have a reserved space, low on the dome, on the opposite side to the manufacturing marks**. The technician should endeavour to stamp in the correct place; refer to BS EN ISO 13769 or the appropriate manufacturing standard for correct positioning.

Although now largely obsolete, there are some old lightweight types, such as HOT, still in service. These are fitted with a brass neck ring to carry the required data and test marks. If fitted, test marks should only be applied to the neck ring. **A neck ring without a space in which to stamp is not an excuse to stamp elsewhere on the cylinder**. Stamping produces a "stress raiser" in the metal and is normally unacceptable on the shoulder of these thin walled types. If a neck ring is fitted, there are no original manufacturer's marks on the top dome and it has been test stamped there, it is recommended that the cylinder be withdrawn from service.

The inspection/test stamps and labels should be applied in the following order from left to right:

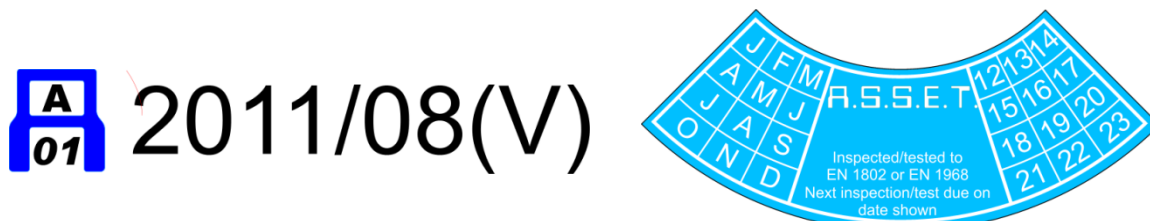
- Test station mark.
- Year and Month of test, i.e. YY / MM.

Note: To prevent confusion with previous practice, it is recommended to stamp YYYY / MM, until 2013.

- The letter "V" is stamped to differentiate between a visual only and a hydraulic test.

Note: The letter "H" **must never be used to indicate a hydraulic test**; "H" is reserved to indicate that a cylinder is suitable for use with Hydrogen.

A label must be applied to indicate when the next inspection or test is due. See example.



This guidance is offered in good faith and is believed to be correct to the best of our knowledge. Nothing contained herein shall be deemed to override good practice, manufacturers' policies, the relevant Standards and the Law.

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