

Technical Information

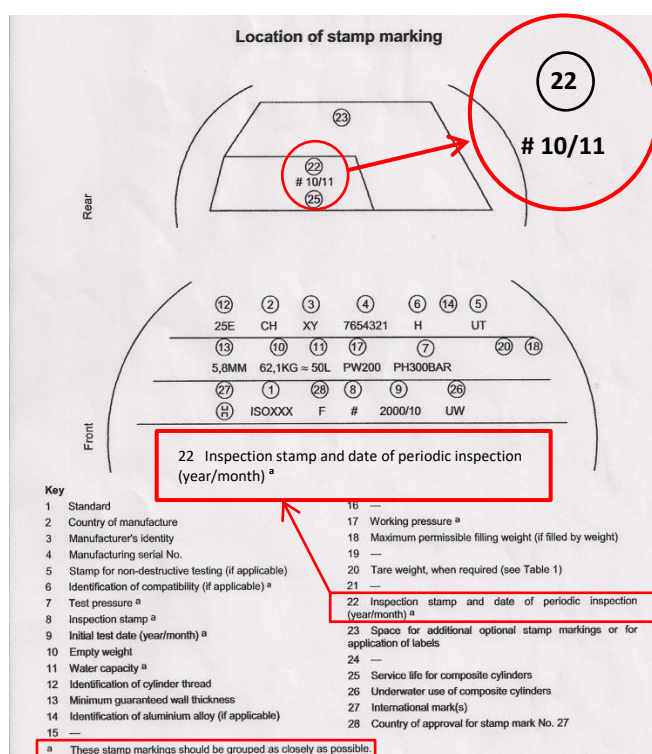
STAMPING OF CYLINDERS

T004

Guidance on correct stamping of metal cylinders at the time of testing

Stamping a cylinder incorrectly can cause confusion when checking the cylinder prior to filling or during later testing. The method that should be followed is that specified in **ISO 13769**.

Below is an extract from the standard (Figure C.1) clearly showing the layout of the stamp details to be added to a cylinder's shoulder.



Providing the cylinder passes the test applied, whether it is a Volumetric or Proof test, then the stamp must be punched into the shoulder of the cylinder. Paint should be removed using a scraper or Dremel and then the stamp punched into the metal using metal punches and a lump hammer to apply the force. A thin coat of anti-corrosion paint should be applied to protect the cylinder but not so thick as to obscure the stamp details.

The format of the details required consists of the **TEST HOUSE LOGO**, in our case an IDEST cylinder logo containing the test centre ID number, followed by the **YEAR** that the test was passed, a **SLASH** marker then **MONTH**. **XX YY/MM**

The test centre logo must be clearly stamped so that it can be identified during the rest of the approved use period. Care must be taken to punch the stamp squarely otherwise double punching can cause distortion. A solid "anvil" should be used, such as a piece of channel securely fixed to avoid vibration. The month should be punched with a zero for the months less than 10.



Visual inspections do not require a stamp but will be identified using an IDEST Green Quadrant sticker suitably punched out