

(XVIII)

DOT INSPECTION REPORT OF COMPRESSED GAS CYLINDER REQUALIFICATION FACILITY

This inspection report has been produced to assist the facility manager in performing an in house audit of the requalification facility. It is recommended that this report be used to check your facility and employees that perform re-qualification of cylinders.

Inspection Date: _____

Hydrostatic Test Operators:

Name	Initials
_____	_____
_____	_____
_____	_____
_____	_____

DOT RIN: _____ Date issued: _____ Expiration Date: _____

49CFR revision date: _____ Applicable Sections: _____

Compressed Gas Association pamphlets on file:

C1 _____ yr C5 _____ yr C6 _____ yr

C6.1 _____ yr C6.2 _____ yr C6.3 _____ yr

C8 _____ yr Others: _____

Are cylinder test dates checked prior to charging a cylinder Yes ___ No ___

If cylinders are charged, is the cylinder inspected for leaks after filling ? Yes ___ No ___

DOT specification cylinders tested:

3A ___ 3B ___ 4BA ___ 3AL ___ 3HT ___

3AA ___ 4B ___ 4BW ___ 8AL ___

Exemption Cylinders ___

Are DOT Exemption cylinders marked as E-6498, E-7042, E-8107, E-8364, or E-8422
being retested ? Yes ___ No ___

Are these cylinders remarked 3AL ? Yes ___ No ___

WHAT OPERATIONS ARE PERFORMED

Valve and devalve ? Yes ___ No ___

Is the same valve used except when faulty Yes ___ No ___

Method used to track valves and the corresponding cylinders:

Verification of the correct safety disc: Yes ___ No ___

VISUAL INSPECTION

Internal inspection light in working order ? Yes ___ No ___

Visual inspection inside before testing ? Yes ___ No ___

Visual inspection outside before testing ? Yes ___ No ___

Visual inspection inside after testing / drying ? Yes ___ No ___

Is light capable of illuminating sidewalls and bottom of all cylinders ? Yes ___ No ___

Is excessive paint, labels and corrosion (internal & external)
removed prior to cylinder visual inspection ? Yes ___ No ___

Method to remove paint ? _____

Are removable attachments (bands, boots, etc.) removed from cylinder to perform a complete visual
examination ? Yes ___ No ___

Rejection criteria used to condemn a cylinder visually:

Corrosion _____ Pits _____ Dents _____ Arc Burns _____ Fire Damage _____

Other _____

Are cylinders marked before or after they are visually inspected and hydrostatically retested ? _____

Hand stamps:

Date: _____ Size _____ inches

Retester Identification Number: _____ Size _____ inches

Marking Pattern:



Low stress steel stamps:

Date: _____ Size _____ inches

Retester Identification Number: _____ Size _____ inches

Are cylinders made from 6351-T6 alloy being requalified ? Yes___ No___
How are they identified: _____
Are these 6351-T6 alloy cylinders being inspected for sustained load cracking: Yes___ No___
How: _____

Are cylinders marked with a plus (+) sign ? Yes___ No___
What criteria is used to find REE value: _____

Are cylinders marked with a five (5) pointed star ? Yes___ No___
What section of CFR is being followed for this marking requirement: _____

Rejected cylinders are:
___ Returned to owner / customer unmarked. ___ Stamped with CONDEMNED
___ Drilled with a hole or otherwise mutilated beyond use.
___ Stamped with series of X's over DOT specification and service pressure
___ Other _____

Is the permission of the owner of a cylinder obtained prior to destroying a condemned cylinder ?
Yes___ No___

TEST INFORMATION

Method(s) used to test all cylinders:
Water jacket volumetric___ Direct Expansion___
Modified "proof test" hydrostatic___

Are cylinders dried with hot air ? Yes___ No___
Maximum internal temperature of cylinder ? _____ °F
Are cylinders steam cleaned ? Yes___ No___
Maximum internal temperature of cylinder ? _____ °F

How long are cylinders held at test pressure ? _____
Timer or clock with second hand situated near hydrostatic test console ?
Yes___ No___

CALIBRATION DATA

Method(s) used to insure the accuracy of the hydrostatic test equipment to within 1 percent ?

How often is the test equipment checked for accuracy ? _____

Calibrated cylinder information:
Manufacturer: _____ S/N _____
Calibration date: _____ by _____
Maximum calibration pressure: _____ psig

Calibration chart available and situated near or at test station? Yes ___ No ___

Reads Burettes First _____ Pressure Gauge First _____

Are burettes adjustable ? Yes ___ No ___

Are all readings taken at zero level ? Yes ___ No ___

Pressure Gauges:

Main 0- _____ psig, increments _____ psig useable range: _____

Alt 0- _____ psig, increments _____ psig useable range: _____

Frequency of calibration _____

Last calibration:

Date: _____ Name _____

Date: _____ Name _____

How do you distinguish between test equipment failure and cylinder failure ?

If due to test equipment failure, the test pressure on a cylinder cannot be maintained, is the cylinder retested ? Yes ___ No ___

At what pressure is the cylinder retested ? _____

Are cylinders dried after the test to remove all traces of moisture ?

INSPECTION REPORTS

Do retest records contain:

Daily calibration of equipment _____	Serial number _____
Manufacturer' identification symbol _____	DOT / ICC specification _____
Service Pressure _____	Test Pressure _____
Visual inspection results _____	Total expansion results _____
Permanent expansion results _____	Disposition of cylinder _____
Retester's initials _____	Remarks _____
Certification signature _____	Test record attached _____
Are condemned cylinders noted on test records _____	Are owners identified _____

How long are records kept on file _____

Do all hydrostatic test records and corresponding recording charts, if use, represent retests on only DOT / ICC specification or DOT exemption cylinders _____

Would the test records reflect results of retest on foreign cylinders for export _____

Are all of the cylinders listed on the hydrostatic test records marked with the test date and retesters identification number, except when noted as condemned _____

Can the retest facility provide:

Training records _____ Registration letter _____