

Technical Information

STAMPING OF CYLINDERS

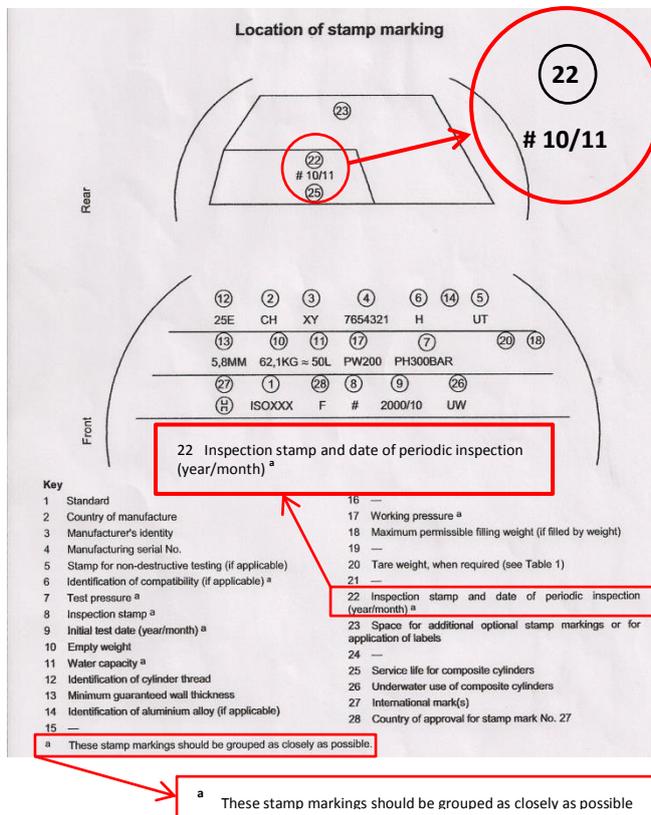
T004

Guidance on correct stamping of cylinders at the time of testing

It has come to our notice that Test Centres have a variety of methods of stamping customer cylinders with the test date. Stamping a cylinder incorrectly can cause technicians confusion at other dive centres when they are checking the cylinder prior to filling. Other Test Centres also complain that a cylinder has been incorrectly stamped by another Test Centre, some of them being IDEST centres.

The method that should be followed is that specified in **BS EN ISO 13769:2009**.

Below is an extract from the standard (page 8) 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 and then the stamp is punched into the metal of the shoulder using metal punches and a lump hammer to apply the force. A thin coat of 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 and then the **MONTH**.

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.

Prior to 2013 the '20' preceding the two digits of the current test year should have been included. This avoids a mix up with the month. After 2012, because there is no month 13 etc., the '20' in the year stamping may be omitted. The month should also be punched, with a zero for the months less than 10. A 'V' must be added after the month when it is a visual inspection.