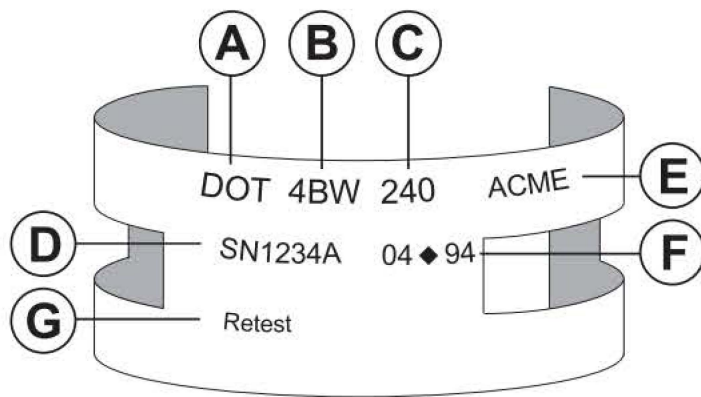


# Requalification Guidance for Propane Cylinders

Propane cylinders have identifying marks on the cylinder neckring (collar), or cylinder shoulder depending on the cylinder type. The diagram below depicts examples of several of the required markings.



- Ⓐ Manufactured to U.S. DOT specifications
- Ⓑ Cylinder specification type (e.g. 4B, 4BA, 4BW, and 4E)
- Ⓒ Cylinder service pressure (psig)
- Ⓓ Cylinder serial number
- Ⓔ Manufacturer's name (or registered symbol)
- Ⓕ Original manufacture/test date, month and year, and inspector's mark, as required (i.e., this diagram indicates April 1994 and inspectors's mark ♦)
- Ⓖ Area for date requalified/retested (no date is shown indicating that the 10-year requalification is *overdue*)

\* Additional markings may be present as authorized by HMR under the specification

## Requalification/Retesting (49 CFR § 180.205)

The "requalification" date, also known as the "retest" date (Ⓖ), is an important marking for fillers and/or consumers.

Propane cylinders must be requalified or replaced every 5 or 10 years depending on the cylinder type, condition, and previous requalification method. (Ref. 49 CFR § 180.205(d) and 180.209(e).)

The original manufacture/test date (Ⓕ) and any requalification/ retest date(s) (Ⓖ) must be presented in a specific manner, reviewed, and determined to be within test prior to filling.

## Visual Cylinder Inspection

In accordance with 49 CFR § 173.301(a)(2), cylinders must undergo a visual inspection prior to being filled. If any of the defects noted in items 1 through 4 below are present, the cylinder **must not be filled** and may only be repaired, requalified, or rebuilt by an authorized U.S. DOT facility (see authorized RIN and VIN holders below):

1. Damage to the cylinder's exterior including dents; bulges; cuts; or cracks on the cylinder's surface, or to welds; and any evidence of physical abuse; fire; or heat damage.
2. Detrimental rust, corrosion, or pitting on the cylinder, particularly on the bottom.
3. Absence of/damage to a cylinder footing, cylinder neckring (collar), or valve cover.
4. A leaking or defective valve or leaking or defective pressure relief device.

A cylinder conforming to the Visual Inspection criteria also must be examined for the most recent repair, requalification, or rebuild date prior to filling. Cylinders that are overdue for requalification must **NOT** be refilled.

- DOT 4-series propane cylinders must be requalified following their manufacture date every **5** or **10** years.
  - » If no requalification date is present, 10-years from the date of manufacture.
  - » If requalification was completed by the "**Volumetric Expansion**" method, as indicated by a valid RIN holder's requalification mark, 10-years after that date.
  - » If requalification was completed by the "**Proof-Pressure**" method, as indicated by a valid RIN holder's requalification mark followed by an "**S**" 10-years after that date.
  - » If requalification was completed by the "**External Visual**" method, as indicated by a valid RIN or VIN holder's requalification mark followed by an "**E**" 5-years after that date.

## Sample Requalification Marks (49 CFR § 180.213)

01 A 1 07  
3 2

An approved RIN holder's marking "A123" certifying a 10-year Volumetric Expansion test conducted in January 2007

01 A 1 07 "X"  
3 2

The same RIN holder's marking where "X" represents the symbol of the testing method used for requalification:  
"E": 5-Year External Visual Method  
"S": 10-Year Proof-Pressure Method

V123456 0107 E

An External Visual marking for an approved VIN holder denoting the 5-Year External Visual method conducted in January 2007 (Ref. VIN Approval Letter)

**NOTE!** Requalification Marks may only be applied by valid U.S. DOT RIN (Requalifier Identification Number) or VIN (Visual Identification Number) holders!

Authorized RIN and VIN holders are listed: <http://phmsa.dot.gov/hazmat/regs/sp-a/approvals/cylinders>