

DIN EN 1440:2006-03 (E)

LPG equipment and accessories - Transportable refillable welded and brazed steel Liquefied Petroleum Gas (LPG) cylinders - Periodic inspection

Contents		Page
Foreword		4
Introduction		5
1	Scope	6
2	Normative references	6
3	Terms and definitions	6
4	Written scheme of inspection	7
5	Procedures for periodic inspection	7
5.1	General	7
5.2	External visual inspection	8
5.2.1	Preparation for external visual inspection	8
5.2.2	Inspection procedure	8
5.2.3	Visible defects	8
5.3	Additional inspection / test procedures	10
5.3.1	Preparation of cylinders	10
5.3.2	Hydraulic proof pressure test	10
5.3.3	Internal visual inspection	11
5.3.4	Pneumatic proof test and leak test	12
5.3.5	Pneumatic leak test	13
5.4	Periodic inspection for protected cylinders	13
6	Inspection of cylinder threads	14
6.1	General	14
6.2	Internal threads	14
6.3	External threads	14
6.4	Damaged threads	14
7	Final operations	14
7.1	Drying	14
7.2	Valving	14
7.3	Tare weight	14
7.4	Marking	14
7.5	Purging	15
8	Records	15
Annex A (normative) Requirements for 15-year periodic inspection interval		16
A.1	General	16
A.2	Concept of control	16
A.3	Conditions	16
Annex B (normative) Periodic inspection procedure for a particular design of protected cylinder		18
B.1	Scope and cylinder description	18
B.2	Cylinders design and manufacturing requirements	19

B.2.1	Steel vessel	19
B.2.2	External protection	19
B.2.3	Marking and recording requirements	19
B.3	Inspection at filling	19
B.4	Periodic destructive tests on batch sampling	19
B.4.1	Testing procedure	19
B.4.2	Destructive tests	20
B.4.3	Rejection criteria and batch sampling	20
B.4.4	Periodic inspection tests reports and records	20
	Bibliography	21