

Unacceptable Defects Guide

For Customer Owned Cylinders (C.O.C)

The Thoroughbred Industrial Cylinder Exchange program is built around accepting empty Customer Owned Cylinders for full Thoroughbred cylinders. However, some unscrupulous customers are using our program to trade in cylinders that have defects which are unacceptable by the Department of Transportation rules and regulations. These "Scrap" cylinders are worthless and cannot be filled with gas so they must not be accepted for exchange under any circumstances.

Below are listed the parts of the cylinder that must be inspected when a customer is attempting to trade in his Customer Owned Cylinder. Note if the COC cylinder offered for exchange has just **ONE** of the following defects the cylinder **CANNOT** be exchanged into the program.

Thoroughbred only allows the exchange of cylinders containing the same gas. Please examine the cylinders DOT label, which will advise you of the cylinder gas contents. For example, a straight CO2 cylinder used in the beverage industry which has a CGA 320 male threaded valve CANNOT be exchanged into the program.

Note: If you are in doubt that cylinder is unacceptable for exchange do not accept cylinder for exchange.

1. DOT Shoulder Label:

The label must be present and readable on the cylinder. Note the good example of the label. (IMAGE 1)
The only exception to this rule is the new #1 cylinders that are sold in the "Porta Torch Outfits".

Note that worn, faded or partially missing labels are a **"RED FLAG"** that the cylinder is not in acceptable condition. (IMAGE 2)

2. High Pressure Cylinder date code (Oxygen and Argon/CO2):

Note the most current date on the cylinder shoulder area. (IMAGE 3)

If the date is expired then the customer must be charged for the Hydrostatic retest fee. An expired cylinder is also a **"RED FLAG"** that the cylinder might have other issues. Low pressure acetylene cylinders are not required to be checked for date codes.

Be sure to check the cylinder for the other inspection points as we cannot accept out of date cylinders that have other "Unacceptable Issues".

Note: Cylinder that have been tested and failed, will have their serial numbers (X'ed) out. Do not accept these cylinders. (IMAGE 4)



IMAGE 1



IMAGE 2



IMAGE 3



IMAGE 4



IMAGE 5



IMAGE 6

MISSING VALVE
HAND WHEEL



IMAGE 7



IMAGE 8

MISSING RELIEF
NUT

3. Valve Condition:

Note: To inspect the valve on cylinders sizes 3 and above the cylinders metal screw on valve protection cap must be removed.

The valve should be perfectly straight in line with the cylinder. Any deflection in any direction is a compromised valve and cannot be exchanged. (IMAGE 5 PAGE 1)

All cylinders both High Pressure Oxygen, Argon/CO2 and low pressure acetylene must have valve hand wheels present to be exchanged. (IMAGE 6 PAGE 1)

Acetylene #1 and #2 cylinders do not have hand valve wheels so they are the exception.

Note that the valve threads where the regulator attaches must be in good condition. Smashed or damaged threads are cause not to accept the cylinder. (IMAGE 7 PAGE 1)

Also note that if you see threads on both sides of the valve this means the relief nut is missing causing this cylinder to be unacceptable. (IMAGE 8 PAGE 1)

4. Excessive Mud and Dirt:

Incoming cylinders that have been stored outside and are covered with excessive mud, dirt, grease or oil **CANNOT** be accepted for exchange into the program. Also note that cylinders with valve protection caps that contain (Mud Dobber) nests inside or on the valve **CANNOT** be accepted for exchange into the program.

4. Cylinder Body:

The cylinder must be free of "Dents" of any size. (IMAGE 9)

The cylinder must be free of "Arc Welder Burns". (IMAGE 10)

The cylinder must be free of "Rust Pitting". Almost all cylinders have surface rust but pitting is when small dimples are created in the cylinder by intense exposure to the elements.

(IMAGE 11)

The cylinder must be free of "Gouges" or "Grinder Marks".

(IMAGE 12)

NOTE: All of these defects can be covered with paint in effort to conceal them. A freshly painted cylinder is a **"RED FLAG"** that the cylinder has a problem and should be reviewed carefully for any and all of the above issues.

5. Cylinder Caps:

Both high pressure oxygen and Argon/CO2 as well as low pressure acetylene cylinders sizes 3, 4, 5 & 6 must have caps in place when traded in. (IMAGE 13)

6. Pressed on Foot Rings:

Low pressure acetylene cylinders with pressed on foot rings cannot be accepted. (IMAGE 14)



IMAGE 9



IMAGE 10



IMAGE 11



IMAGE 12



IMAGE 13



IMAGE 14

