



U.S. Department
of Transportation

Pipeline and
Hazardous Materials
Safety Administration

400 Seventh Street, S.W.
Washington, D.C. 20590

AUG 23 2005

DOT-E 8561
(SIXTH REVISION)

EXPIRATION DATE: July 31, 2007

(FOR RENEWAL, SEE 49 CFR § 107.109)

1. GRANTEE: Pacific Scientific Company
Duarte, CA
2. PURPOSE AND LIMITATIONS:
 - a. This exemption authorizes the manufacture, mark, sale and use of a non-DOT specification cylinder conforming with all regulations applicable to a DOT Specification 3HT cylinder, except as specified herein, for the transportation in commerce of the materials authorized by this exemption. This exemption provides no relief from the Hazardous Materials Regulations (HMR) other than as specifically stated herein.
 - b. The safety analyses performed in development of this exemption only considered the hazards and risks associated with transportation in commerce.
3. REGULATORY SYSTEM AFFECTED: 49 CFR Parts 106, 107 and 171-180.
4. REGULATIONS FROM WHICH EXEMPTED: 49 CFR §§ 173.302a(a) and 175.3 in that a non-DOT specification cylinder is not authorized, except as specified herein.
5. BASIS: This exemption is based on the application of Pacific Scientific Company dated July 21, 2005, submitted in accordance with § 107.109.

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6. HAZARDOUS MATERIALS (49 CFR § 172.101):

Hazardous Material Description			
Proper Shipping Name	Hazard Class/ Division	Identification Number	Packing Group
Oxygen, compressed	2.2	UN1072	N/A

7. SAFETY CONTROL MEASURES:

a. PACKAGING - Prescribed packaging is a non-DOT specification girth welded stainless steel cylinder having 25 cubic inches maximum water capacity and 2200 psi maximum service pressure, manufactured in compliance with HTL Industries' drawing 32197800 dated December 18, 1980, or Pacific Scientific's drawing 53040292 dated August 28, 2002, on file with the Office of Hazardous Materials Exemptions and Approvals (OHMEA) and DOT Specification 3HT, except as follows:

§ 178.35(e) *Safety relief devices.*

Applies except that a statement verifying the adequacy of the pressure relief devices for each cylinder design must be submitted to the OHMEA prior to initial shipment.

§ 178.44(a) *Type, size and pressure.*

Girth welded stainless steel cylinders with 2 end fittings welded as shown on the drawing not over 25 cubic inches water volume and a service pressure of 2,200 pounds per square inch.

§ 178.44(b) *Authorized Material.*

Type ARMCO Nitronic 40 (21-6-9) stainless steel with the following analysis is authorized with proper welding procedure.

<u>CHEMICAL ANALYSIS</u>	<u>PERCENT</u>
Carbon	0.040 max.
Manganese	8.00/10.00
Phosphorus	0.060 max.
Sulfur	0.030 max.

Silicon	1.00 Max.
Chromium	19.00/21.50
Nickel	5.50/7.50
Nitrogen	0.15/0.40

§ 178.44(d) *Manufacture.*

(Added) Each cylinder shall be subjected to a process treatment after welding and before stress relieving by hydrostatically pressurizing to at least 100 percent but not more than 110 percent of the test pressure, and maintained at this pressure for 3 minutes. The process treatment must be witnessed by the independent inspector.

§ 178.44(e) *Welding or Brazing.*

(Added) Welding as prescribed in § 178.44(d) of this exemption is authorized. All pressure welds shall be 100 percent radio-graphed after hydrostatic test.

§ 178.44(f) *Wall thickness.*

(1) Minimum wall thickness for any cylinder must be 0.050 inch. The minimum wall thickness must be such that the wall stress at the minimum specified test pressure shall not exceed 120,000 psi.

* * *

§ 178.44(g) *Heat treatment.*

The half cylinders may be stress relieved or annealed for forming. Welded cylinders must be stress relieved at a temperature of 900 °F. ± 25° for one hour. Stress relieving to be done after process treatment and before hydrostatic test.

§ 178.44(j) *Cycling test.*

* * *

(1) * * *

(2) Results of design qualification testing per § 178.44(p)(4) of this exemption must be submitted to the OHMEA prior to initial shipment. Cycle test on each lot is not required.

(3) A lot is defined as group of cylinders sequentially produced from the same heat of steel, manufactured by the same process and stress relieved in the same equipment under the same conditions of time temperature and atmosphere and shall not exceed a quantity of 200 cylinders.

(4) * * *

§ 178.44(m) *Physical tests.*

Not required.

§ 178.44(n) *Magnetic particle inspection.*

Not required. Instead, of each cylinder must be inspected using apparatus and procedures for liquid penetrant examination in accordance with ASTM E-165-65. Inspection shall be performed externally on the finished cylinder after hydrostatic test. Evidence of discontinuities, which in the opinion of the independent inspector may appreciably weaken or decrease the durability of the cylinder, shall be cause of rejection.

§ 178.44(p) *Acceptable results of tests.*

(1) Flattening required without cracking to six times the wall thickness of the cylinder.

(2) Physical tests: Not required.

(3) Burst pressure shall be at least $4/3$ times the test pressure. Failure must initiate in the sidewall of the cylinder in a longitudinal direction. Actual burst pressure must be recorded.

(4) Cycling: The design must be qualified by cycling 3 cylinders from zero to service pressure to at least 50,000 pressurizations without evidence of distortion or failure.

§ 178.44(q) *Rejected cylinders.*

Repair of welded seams by welding prior to process treatment authorized; subsequent thereto cylinders must be heat treated and pass all prescribed tests.

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§ 178.44(r) *Marking.*

Applies except that instead of DOT-3HT, cylinders must be marked DOT-E 8561 followed by the service pressure. Stamping of elastic expansion is not required.

§ 178.44(s) *Inspectors Report.*

(Add) Inspectors report must be appropriately modified to reflect identification and compliance with this exemption.

b. TESTING - Each cylinder must be re-inspected and hydrostatically retested every 3 years in accordance with § 180.205 as prescribed for DOT-3HT cylinders except that the rejection elastic expansion does not apply.

c. OPERATIONAL CONTROL - The pressure vessels are authorized for transportation when equipped with actuating cartridges installed in the discharge outlet. The actuating cartridges must be approved by the Associate Administrator for Hazardous Materials Safety.

8. SPECIAL PROVISIONS:

a. In accordance with the provisions of Paragraph (b) of § 173.22a, persons may use the packaging authorized by this exemption for the transportation of the hazardous materials specified in paragraph 6, only in conformance with the terms of this exemption.

b. A person who is not a holder of this exemption, but receives a package covered by this exemption, may reoffer it for transportation provided no modification or change is made to the package or its contents and it is offered for transportation in conformance with this exemption and the HMR.

c. A current copy of this exemption must be maintained at each facility where the package is offered or reoffered for transportation.

d. Each packaging manufactured under the authority of this exemption must be either (1) marked with the name of the manufacturer and location (city and state) of the facility at which it is manufactured or (2) marked with a registration symbol designated by the Office of Hazardous

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Materials Exemptions and Approvals for a specific manufacturing facility.

e. A current copy of this exemption must be maintained at each facility where the package is manufactured under this exemption. It must be made available to a DOT representative upon request.

f. Cylinders are limited to use in military weapons systems only. A copy of the inspector's report on the first lot of cylinders produced must be submitted to the OHMEA prior to initial shipment.

g. Cylinders must be shipped in strong outside packagings in conformance with §§ 173.301(a)(9) and 173.301(a)(1).

h. A cylinder is not authorized 15 years from the date of manufacture.

9. MODES OF TRANSPORTATION AUTHORIZED: Motor vehicle, rail freight, cargo aircraft only.
10. MODAL REQUIREMENTS: A current copy of this exemption must be carried aboard each aircraft used to transport packages covered by this exemption. The shipper shall furnish a copy of this exemption to the air carrier before or at the time the shipment is tendered.
11. COMPLIANCE: Failure by a person to comply with any of the following may result in suspension or revocation of this exemption and penalties prescribed by the Federal hazardous materials transportation law, 49 U.S.C. 5101 et seq:
- o All terms and conditions prescribed in this exemption and the Hazardous Materials Regulations, 49 CFR Parts 171-180.
 - o Persons operating under the terms of this exemption must comply with the security plan requirement in Subpart I of Part 172 of the HMR, when applicable.
 - o Registration required by § 107.601 et seq., when applicable.

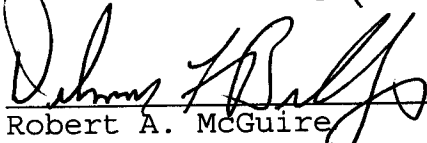
Each "Hazmat employee", as defined in § 171.8, who performs a function subject to this exemption must receive training on the requirements and conditions of this exemption in

addition to the training required by §§ 172.700 through 172.704.

No person may use or apply this exemption, including display of its number, when this exemption has expired or is otherwise no longer in effect.

12. REPORTING REQUIREMENTS: Shipments or operations conducted under this exemption are subject to the Hazardous Materials Incident Reporting requirements specified in 49 CFR §§ 171.15 - Immediate notice of certain hazardous materials incidents, and 171.16 - Detailed hazardous materials incident reports. In addition, the grantee(s) of this exemption must notify the Associate Administrator for Hazardous Materials Safety -- OHMEA, in writing, of any incident involving a package, shipment or operation conducted under terms of this exemption.

Issued in Washington, D.C.:


Robert A. McGuire
Associate Administrator for
Hazardous Materials Safety

AUG 23 2005
(DATE)

Address all inquiries to: Associate Administrator for Hazardous Materials Safety, Pipeline and Hazardous Materials Safety Administration, Department of Transportation, Washington, D.C. 20590. Attention: PHH-31.

Copies of this exemption may be obtained by accessing the Hazardous Materials Safety Homepage at <http://hazmat.dot.gov/exemption> Photo reproductions and legible reductions of this exemption are permitted. Any alteration of this exemption is prohibited.

PO: KFW/dl/kah