
**Plastics hoses and hose assemblies —
Textile-reinforced types for hydraulic
applications — Specification**

*Tuyaux et flexibles en plastique — Types hydrauliques avec armature
textile — Spécifications*

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html

This document was prepared by technical Committee ISO/TC 45, *Rubber and rubber products*, Subcommittee SC 1, *Rubber and plastics hoses and hose assemblies*.

This fifth edition cancels and replaces the fourth edition (ISO 3949:2009), which has been technically revised. The main changes compared to the previous edition are as follows:

- Clause 1 has been updated to be more precise;
- Requirements for type R8, hose nominal size 8 have been added in [Tables 1, 3, 4](#) and [5](#);
- Reference to method A1 of ISO 10619-1:2017, has been added in [7.3](#);
- Additional requirement for marking of hoses has been added in [10.1](#);
- Reference to ISO 17165-1 has been made in [10.2](#).

Plastics hoses and hose assemblies — Textile-reinforced types for hydraulic applications — Specification

1 Scope

This document specifies requirements for three types of textile-reinforced thermoplastics hose and hose assembly of nominal size from 3,2 to 25. Each type is divided into two classes dependent on electrical conductivity requirements.

They are suitable for use with:

- oil-based hydraulic fluids HH, HL, HM, HR and HV as defined in ISO 6743-4 at temperatures ranging from $-40\text{ }^{\circ}\text{C}$ to $+93\text{ }^{\circ}\text{C}$;
- water-based fluids HFC, HFAE, HFAS and HFB as defined in ISO 6743-4 at temperatures ranging from $0\text{ }^{\circ}\text{C}$ to $+60\text{ }^{\circ}\text{C}$
- water at temperatures ranging from $0\text{ }^{\circ}\text{C}$ to $+60\text{ }^{\circ}\text{C}$.

This document does not include requirements for end fittings. It is limited to the performance of hoses and hose assemblies.

NOTE It is the responsibility of the user, in consultation with the hose manufacturer, to establish the compatibility of the hose with the fluid to be used.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1402, *Rubber and plastics hoses and hose assemblies — Hydrostatic testing*

ISO 1817, *Rubber, vulcanized or thermoplastic — Determination of the effect of liquids*

ISO 4671, *Rubber and plastics hoses and hose assemblies — Methods of measurement of the dimensions of hoses and the lengths of hose assemblies*

ISO 6743-4, *Lubricants, industrial oils and related products (class L) — Classification — Part 4: Family H (Hydraulic systems)*

ISO 6803, *Rubber or plastics hoses and hose assemblies — Hydraulic-pressure impulse test without flexing*

ISO 7326:2016, *Rubber and plastics hoses — Assessment of ozone resistance under static conditions*

ISO 8330, *Rubber and plastics hoses and hose assemblies — Vocabulary*

ISO 10619-1:2017, *Rubber and plastics hoses and tubing — Measurement of flexibility and stiffness — Part 1: Bending tests at ambient temperature*

ISO 10619-2:2017, *Rubber and plastics hoses and tubing — Measurement of flexibility and stiffness — Part 2: Bending tests at sub-ambient temperatures*

ISO 17165-1, *Hydraulic fluid power — Hose assemblies — Part 1: Dimensions and requirements*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 8330 apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

4 Classification

Three types of hose are specified, distinguished by their maximum working pressure:

- a) Type R7: hoses with one or more layers of reinforcement;
- b) Type R8: hoses with one or more layers of reinforcement, for operation at higher working pressures;
- c) Type R18: hoses with one or more layers of reinforcement, 21,0 MPa (210 bar) working pressure based.

Each type of hose is divided into two classes according to its electrical properties:

- 1) Class 1, no electrical requirements;
- 2) Class 2, “non-conductive” (see 7.8).

5 Materials and construction

5.1 Hoses

Hoses shall consist of a seamless thermoplastic lining resistant to hydraulic fluids, with suitable textile yarn reinforcement and a thermoplastic cover resistant to hydraulic fluids, water and the weather.

For class 2 hoses, the cover shall not be perforated. The cover shall be orange (colour code RAL 2004).

5.2 Hose assemblies

Hose assemblies shall only be manufactured with those hose fittings whose functionality conforms to the requirements of 7.1, 7.4, 7.5 and, for class 2 only, 7.8.

6 Dimensions and tolerances

6.1 Diameters

When measured in accordance with ISO 4671, the diameters of the hoses shall conform to the values given in Table 1.

Table 1 — Dimensions of hoses

Nominal size	Inside diameter						Maximum outside diameter		
	mm						mm		
	Type R7		Type R8		Type R18		Type R7	Type R8	Type R18
	min.	max.	min.	max.	min.	max.			
3,2	3,4	4,0	3,4	4,0	3,4	4,0	9,5	10,5	9,5
5	4,6	5,4	4,6	5,4	4,6	5,4	11,4	14,6	10,8
6,3	6,2	7,0	6,2	7,0	6,2	7,0	13,7	16,8	13,5
8	7,7	8,5	7,7	8,5	7,7	8,5	15,6	18,6	16,6
10	9,3	10,3	9,3	10,3	9,3	10,3	18,4	20,3	18,4
12,5	12,3	13,5	12,3	13,5	12,3	13,5	22,5	24,6	22,8
16	15,5	16,7	15,5	16,7	15,5	16,7	25,8	29,8	27,2
19	18,6	19,8	18,6	19,8	18,6	19,8	28,6	33,0	31,5
25	25,0	26,4	25,0	26,4	25,0	26,4	36,7	38,6	40,4

6.2 Concentricity

When measured in accordance with ISO 4671, the concentricity of the hoses shall conform to [Table 2](#).

Table 2 — Concentricity of hoses

Nominal size	Maximum variation in wall thickness between inside diameter and outside diameter
	mm
Up to and including 6,3	0,8
Over 6,3 and including 19	1,0
Over 19	1,3

7 Physical properties

7.1 Hydrostatic requirements

When tested in accordance with ISO 1402 at the relevant proof pressure given in [Table 3](#) and the relevant minimum burst pressure given in [Table 4](#), the hoses and hose assemblies shall not leak.

Table 3 — Proof pressure

Nominal size	Type		
	R7	R8	R18
	MPa (bar)	MPa (bar)	MPa (bar)
3,2	42,0 (420)	84,0 (840)	42,0 (420)
5	42,0 (420)	70,0 (700)	42,0 (420)
6,3	38,4 (384)	70,0 (700)	42,0 (420)
8	35,0 (350)	62,0 (620)	42,0 (420)
10	31,4 (314)	56,0 (560)	42,0 (420)
12,5	28,0 (280)	49,0 (490)	42,0 (420)
16	21,0 (210)	38,5 (385)	42,0 (420)
19	17,4 (174)	31,4 (314)	42,0 (420)
25	14,0 (140)	28,0 (280)	42,0 (420)

Table 4 — Minimum burst pressure

Nominal size	Type		
	R7	R8	R18
	MPa (bar)	MPa (bar)	MPa (bar)
3,2	84,0 (840)	168,0 (1 680)	84,0 (840)
5	84,0 (840)	140,0 (1 400)	84,0 (840)
6,3	76,8 (768)	140,0 (1 400)	84,0 (840)
8	70,0 (700)	124,0 (1 240)	84,0 (840)
10	62,8 (628)	112,0 (1 120)	84,0 (840)
12,5	56,0 (560)	98,0 (980)	84,0 (840)
16	42,0 (420)	77,0 (770)	84,0 (840)
19	34,8 (348)	62,8 (628)	84,0 (840)
25	28,0 (280)	56,0 (560)	84,0 (840)

7.2 Change in length

When tested in accordance with ISO 1402, the change in length of hose at the maximum working pressure (see [Table 5](#)) shall not exceed ± 3 %.

Table 5 — Maximum working pressure

Nominal size	Type		
	R7	R8	R18
	MPa (bar)	MPa (bar)	MPa (bar)
3,2	21,0 (210)	42,0 (420)	21,0 (210)
5	21,0 (210)	35,0 (350)	21,0 (210)
6,3	19,2 (192)	35,0 (350)	21,0 (210)
8	17,5 (175)	31,0 (310)	21,0 (210)
10	15,7 (157)	28,0 (280)	21,0 (210)
12,5	14,0 (140)	24,5 (245)	21,0 (210)
16	10,5 (105)	19,2 (192)	21,0 (210)
19	8,7 (87)	15,7 (157)	21,0 (210)
25	7,0 (70)	14,0 (140)	21,0 (210)

7.3 Minimum bend radius

When bent to the minimum bend radius in [Table 6](#), measured unpressurized in accordance with method A1 of ISO 10619-1:2017, the flatness shall not exceed 10 % of the original outside diameter.

Table 6 — Minimum bend radius

Nominal size	Minimum bend radius	
	mm	
	Type	
	R7 and R8	R18
3,2	25	25
5	90	30
6,3	100	45
8	115	50
10	125	75
12,5	180	90
16	205	125
19	240	165
25	300	250

7.4 Resistance to impulse

7.4.1 The impulse test shall be in accordance with ISO 6803. The test fluid temperature shall be 93 °C.

7.4.2 For type R7 hoses, when tested at an impulse pressure equal to 125 % of the maximum working pressure, the hose shall withstand a minimum of 150 000 impulse cycles.

For type R8 and R18 hoses, when tested at an impulse pressure equal to 133 % of the maximum working pressure, the hose shall withstand a minimum of 200 000 impulse cycles.

7.4.3 There shall be no leakage or other malfunction before reaching the specified number of cycles.

7.4.4 This test shall be considered a destructive test and the test pieces shall be discarded.

7.5 Leakage of hose assemblies

When tested in accordance with ISO 1402, there shall be no leakage or evidence of failure. This test shall be considered a destructive test and the test piece shall be destroyed.

7.6 Cold flexibility

When tested in accordance with method B of ISO 10619-2:2017 at a temperature of –40 °C, there shall be no cracking of the lining or cover. The test piece shall not leak or crack when subjected to a proof pressure test in accordance with ISO 1402 after regaining ambient temperature.

7.7 Ozone resistance

When tested in accordance with method 1 or 2 of ISO 7326:2016, depending on the nominal bore of the hose, no cracking or deterioration of the cover shall be visible under ×2 magnification.

7.8 Electrical conductivity

This test applies to class 2 hoses only.

When tested in accordance with [Annex D](#), the current reading shall be no greater than 50 µA.

7.9 Fluid resistance

7.9.1 Test pieces

The fluid resistance tests specified in [7.9.2](#) to [7.9.4](#) shall be carried out on moulded sheets of lining and cover material having a minimum thickness of 2 mm.

7.9.2 Oil resistance

When determined in accordance with ISO 1817 by immersion in oil No. 3 for 72_{-2}^0 h at a temperature of $100\text{ }^{\circ}\text{C} \pm 3\text{ }^{\circ}\text{C}$, the percentage change in volume of the lining and cover shall be between -15 % and +35 %.

7.9.3 Water-based fluid resistance

When determined in accordance with ISO 1817 by immersion in a test fluid made up of equal volumes of 1,2-ethanediol and distilled water for 168_{-2}^0 h at a temperature of $70\text{ }^{\circ}\text{C} \pm 1\text{ }^{\circ}\text{C}$, the percentage change in volume of the lining and cover shall be between 0 % and +25 %.

7.9.4 Water resistance

When determined in accordance with ISO 1817 by immersion in distilled water for 168_{-2}^0 h at a temperature of $70\text{ }^{\circ}\text{C} \pm 1\text{ }^{\circ}\text{C}$, the percentage change in volume of the lining and cover shall be between -10 % and +25 %.

7.10 Visual examination

Hoses shall be examined for visible defects in the outer cover and to verify that the hose identification is correct and has been properly marked. Hose assemblies shall, in addition, be inspected to verify that the correct fittings are fitted.

8 Frequency of testing

Type testing and routine testing shall be as specified in [Annex A](#).

Type tests are those tests required to confirm that a particular hose or hose assembly design, manufactured by a particular method from particular materials, meets all the requirements of this document. The tests shall be repeated at a maximum of five-year intervals, or whenever a change in the method of manufacture or materials used occurs. They shall be performed on all sizes and on all classes and types except those of the same size and construction.

Routine tests are those tests required to be carried out on each length of finished hose prior to dispatch.

Production tests are those tests, specified in [Annex B](#), which should preferably be carried out to control the quality of manufacture. The frequencies specified in [Annex B](#) are given as a guide only.

9 Designation

Hoses shall be designated as in the following example for a Type R7 thermoplastics textile-reinforced hydraulic hose, class 1 with a nominal size of 10.

EXAMPLE ISO 3949-R7-1/10.

10 Marking

10.1 Hoses

Hoses shall be marked with at least the following information, and the marking shall be repeated at least once every 760 mm:

- a) the manufacturer's name or identification, e.g. XXX;
- b) the number of this document, i.e. ISO 3949;
- c) the type and class, e.g. R7-1;
- d) for class 2 hoses, the words "NON-CONDUCTIVE";
- e) the nominal size, e.g. 16;
- f) the maximum working pressure, in megapascal with conversion into bar, with the units indicated, e.g. 10,5 MPa (105 bar);
- g) the quarter and last two digits of the year of manufacture, e.g. 2Q18.

EXAMPLE 1 XXX/ISO 3949/R7-1/16/10,5 MPa (105 bar)/2Q18.

EXAMPLE 2 XXX/ISO 3949/R7-2 NON-CONDUCTIVE/16/10,5 MPa (105 bar)/2Q18.

For [10.1 b\)](#), the hose manufacturer shall use the latest version of this document, otherwise the year of the version used shall be included in the marking.

10.2 Hose assemblies

Hose assemblies using hose in accordance with this document shall be manufactured and marked in accordance with ISO 17165-1.

11 Recommendations for packing and storage

These are given in ISO 8331.

12 Recommendations for length of supplied hoses and tolerances on lengths of hose assemblies

The length of supplied hoses and hose assemblies shall be the subject of agreement between the manufacturer and the purchaser. However, recommendations for the length of supplied hoses and tolerances on lengths of hose assemblies are given in [Annex C](#).

13 Test certificate

When requested by the purchaser, the manufacture or supplier shall provide a test certificate with each length of hose or batch of hoses supplied to the purchaser.

Annex A (normative)

Type and routine testing of hoses

Property	Type test Frequency (for each hose size and type): at initial product qualification, in the event of product changes after initial qualification and after 5 years	Routine test Performed on each length of finished hose prior to warehousing or sale
Hoses/hose assemblies (as appropriate)		
Measurement of inside diameter	X	X
Measurement of outside diameter	X	X
Measurement of concentricity	X	X
Proof test	X	X
Burst test	X	X
Change-in-length test	X	N/A
Minimum bend radius	X	N/A
Impulse test	X	N/A
Leakage test	X	N/A
Cold bending test	X	N/A
Ozone resistance test	X	N/A
Electrical conductivity (class 2 only)	X	N/A
Resistance to fluids		
Oil resistance test for cover	X	N/A
Oil resistance test for lining	X	N/A
Water-based fluid resistance test for cover	X	N/A
Water-based fluid resistance test for lining	X	N/A
Water resistance test for cover	X	N/A
Water resistance test for lining	X	N/A
X = Test required		
N/A = Test not applicable		

Annex B (informative)

Production testing

Property	Production test
	Frequency: every 3 000 m produced or every 12 months of production of each type and hose size, whichever occurs first
Hoses/hose assemblies (as appropriate)	
Visual examination (inside and outside)	X
Measurement of inside diameter	X
Measurement of outside diameter	X
Measurement of concentricity	X
Proof test	X
Burst test	X
Change-in-length test	X
Minimum bend radius	N/A
Impulse test	N/A
Leakage test	X
Cold bending test	N/A
Ozone resistance test	N/A
Electrical conductivity (class 2 only)	N/A
Resistance to fluids	
Oil resistance test for cover	N/A
Oil resistance test for lining	N/A
Water-based fluid resistance test for cover	N/A
Water-based fluid resistance test for lining	N/A
Water resistance test for cover	N/A
Water resistance test for lining	N/A
X = Test required	
N/A = Test not applicable	

Annex C (informative)

Recommendations for lengths of supplied hoses and tolerances on lengths of hose assemblies

C.1 Hoses

The hoses should be supplied in lengths as specified by the purchaser, subject to a tolerance on the specified lengths of $\pm 2\%$.

When no specific hose lengths have been ordered, the percentages of different lengths in any given delivery should be as indicated in Table C.1.

Table C.1 — Hose lengths in delivery when no lengths specified

Length of hose	Percentage of total length
Greater than or equal to 1 m but less than or equal to 10 m	3 % max.
Greater than 10 m but less than or equal to 20 m	20 % max.
Greater than 20 m	80 % min.

No hose length should be less than 1 m.

C.2 Hose assemblies

The tolerances on the length of hose assemblies should conform to the values given in [Table C.2](#).

Table C.2 — Tolerances on lengths of hose assemblies

Hose assembly length mm	Tolerance
Up to and including 630	+7 -3 mm
Over 630 and up to and including 1 250	+12 -4 mm
Over 1 250 and up to and including 2 500	+20 -6 mm
Over 2 500 and up to and including 8 000	+1,5 -0,5 %
Over 8 000	+3 -1 %