

BS EN 853:2015



BSI Standards Publication

Rubber hoses and hose assemblies — Wire braid reinforced hydraulic type — Specification

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National foreword

This British Standard is the UK implementation of EN 853:2015. It supersedes BS EN 853:1997, which is withdrawn.

BSI, as a member of CEN, is obliged to publish EN 853 as a British Standard. However, attention is drawn to the fact that during the development of this European Standard, the UK committee voted against its approval as a European Standard.

This is due to concerns about the abrasion test method detailed in Annex A (normative). It is the opinion of the UK committee that the abrasion test method is not reliable and gives inconsistent results.

The UK participation in its preparation was entrusted to Technical Committee PRI/66, Rubber and plastics tubing, hoses and hose assemblies.

A list of organizations represented on this committee can be obtained on request to its secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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Rubber hoses and hose assemblies - Wire braid reinforced hydraulic type - Specification

Tuyaux et flexibles en caoutchouc - Type hydraulique avec armature de fils métallique tressés - Spécification

Gummischläuche und -schlauchleitungen - Hydraulikschläuche mit Drahtgeflechteinlage - Spezifikation

This European Standard was approved by CEN on 31 January 2015.

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Foreword

This document (EN 853:2015) has been prepared by Technical Committee CEN/TC 218 “Rubber and plastics hoses and hose assemblies”, the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2015 and conflicting national standards shall be withdrawn at the latest by October 2015.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 853:1996.

In comparison with EN 853:1996, the following significant changes have been made:

- updated normative references;
- tolerances for inside diameter in Table 1;
- added Annex A;
- added Annex B;
- added Annex C.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

1 Scope

This European Standard specifies requirements for four types of wire braid reinforced hoses and hose assemblies of nominal bore from 5 to 51. They are suitable for use with:

- hydraulic fluids in accordance with ISO 6743-4 with the exception of HFD R, HFD S and HFD T at temperatures ranging from -40 °C to +100 °C;
- water based fluids at temperatures ranging from -40 °C to +70 °C;
- water at temperatures ranging from 0 °C to +70 °C.

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

NOTE 1 The hoses are not suitable for use with castor oil based and ester based fluids.

NOTE 2 Hoses and hose assemblies are not be operated outside the limits of this standard.

NOTE 3 Requirements for hydraulic hoses for underground mining are standardized in separate standards.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN ISO 1302, *Geometrical Product Specifications (GPS) - Indication of surface texture in technical product documentation (ISO 1302)*

EN ISO 1402:2009, *Rubber and plastics hoses and hose assemblies - Hydrostatic testing (ISO 1402:2009)*

EN ISO 4671, *Rubber and plastics hoses and hose assemblies - Methods of measurement of the dimensions of hoses and the lengths of hose assemblies (ISO 4671)*

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

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

EN ISO 7233, *Rubber and plastics hoses and hose assemblies - Determination of resistance to vacuum (ISO 7233)*

EN ISO 7326, *Rubber and plastics hoses - Assessment of ozone resistance under static conditions (ISO 7326)*

EN ISO 8033:2006, *Rubber and plastics hoses - Determination of adhesion between components (ISO 8033)*

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

ISO 1817:2005, *Rubber, vulcanized - Determination of the effect of liquids*

ISO 23529, *Rubber - General procedures for preparing and conditioning test pieces for physical test methods*

3 Types of hoses

Four types of hoses are specified:

- 1) Type 1ST - hoses with a single braid of wire reinforcement;
- 2) Type 2ST - hoses with two braids of wire reinforcement;
- 3) Type 1SN - hoses with a single braid of wire reinforcement;
- 4) Type 2SN - hoses with two braids of wire reinforcement.

Types 1SN and 2SN shall be of the same reinforcement construction as types 1ST and 2ST, except that they shall have thinner covers designed to assemble with fittings that do not require removal of the cover or a portion of the cover.

4 Materials and construction

4.1 Hoses

Hoses shall consist of an oil and water resistant synthetic rubber lining, one or two layers of high tensile steel wire and an oil and weather resistant rubber cover.

4.2 Hose assemblies

Hose assemblies shall only be manufactured with those hose fittings whose functionality has been verified in accordance with subclauses 6.1, 6.3, 6.4 and 6.5 of this European Standard.

5 Dimensions

5.1 Diameters and concentricity

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

Table 1 — Diameters of hoses

Dimensions in millimetres except nominal bore

Nominal bore	All types		Type 1ST				Type 1SN				Type 2ST				Type 2SN			
	Inside diameter		Diameter over reinforcement		Outside diameter of hose		Outside diameter of hose		Cover thickness		Diameter over reinforcement		Outside diameter of hose		Outside diameter of hose		Cover thickness	
	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.
5	4,9	5,4	9,0	10,0	11,9	13,5	12,5	12,5	0,8	1,5	10,6	11,6	15,1	16,7	14,1	0,8	1,5	
6	6,4	7,0	10,6	11,6	15,1	16,7	14,1	14,1	0,8	1,5	12,1	13,3	16,7	18,3	15,7	0,8	1,5	
8	7,9	8,5	12,1	13,3	16,7	18,3	15,7	15,7	0,8	1,5	13,7	14,9	18,3	19,9	17,3	0,8	1,5	
10	9,5	10,1	14,5	15,7	19,0	20,6	18,1	18,1	0,8	1,5	16,1	17,3	20,6	22,2	19,7	0,8	1,5	
12	12,7	13,5	17,5	19,1	22,2	23,8	21,4	21,4	0,8	1,5	19,0	20,6	23,8	25,4	23,0	0,8	1,5	
16	15,8	16,7	20,6	22,2	25,4	27,0	24,5	24,5	0,8	1,5	22,2	23,8	27,0	28,6	26,2	0,8	1,5	
19	18,8	19,8	24,6	26,2	29,4	31,0	28,5	28,5	0,8	1,5	26,2	27,8	31,0	32,6	30,1	0,8	1,5	
25	25,4	26,4	32,5	34,1	37,1	39,1	36,6	36,6	0,8	1,5	34,1	35,7	38,5	40,9	38,9	1,0	2,0	
31	31,8	33,0	39,3	41,7	44,4	47,6	44,8	44,8	1,0	2,0	43,3	45,7	49,2	52,4	49,5	1,0	2,0	
38	38,1	39,3	45,6	48,0	50,8	54,0	52,1	52,1	1,5	2,5	49,6	52,0	55,6	58,8	55,9	1,3	2,5	
51	50,6	52,0	58,7	61,7	65,1	68,3	65,5	65,5	1,5	2,5	62,3	64,7	68,2	71,4	68,6	1,3	2,5	

When measured in accordance with EN ISO 4671, the concentricity of the hoses shall conform to the values given in Table 2.

Table 2 — Concentricity of hoses

Dimensions in millimetres, except nominal bore

Nominal bore	Maximum variation in wall thickness		
	Between inside diameter and outside diameter	Between inside diameter and reinforcement diameter	
		All types	Types 1ST and 1SN
Up to and including 6	0,8	0,4	0,4
Over 6 and including 19	1,0	0,6	0,7
Over 19	1,3	0,8	0,9

5.2 Length

5.2.1 Hoses

Hoses shall 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 shall be as follows:

- over 20 m : not less than 80 % of total length;
- over 10 m to 20 m : not more than 20 % of total length;
- 1 m to 10 m : not more than 3 % of total length.

The length of hose shall be at least 1 m.

5.2.2 Hose assemblies

The tolerances on the length of hose assemblies shall conform to Table 3.

Table 3 — Tolerances of length of hose assemblies

Hose assembly length mm	Nominal bore		
	Up to and including 25	Over 25 and including 50	Over 50
	Tolerance	Tolerance	Tolerance
Up to and including 630	+ 7 mm - 3 mm	+ 12 mm - 4 mm	+ 25 mm - 6 mm
Over 630 and including 1 250	+ 12 mm - 4 mm	+ 20 mm - 6 mm	
Over 1 250 and including 2 500	+ 20 mm - 6 mm	+ 25 mm - 6 mm	
Over 2 500 and including 8 000	+ 1,5 % - 0,5 %		
Over 8 000	+ 3 % - 1 %		

6 Requirements

6.1 Hydrostatic requirements

6.1.1 When tested in accordance with EN ISO 1402, the maximum working pressure, the proof pressure and burst pressure of the hoses and hose assemblies shall conform to the values given in Table 4.

6.1.2 When tested in accordance with EN ISO 1402, the change in length of hose at the maximum working pressure shall not exceed +2 % to -4 %.

Table 4 — Maximum working pressure, proof pressure and burst pressure

Nominal bore	Maximum working pressure bar ^a		Proof pressure bar		Burst pressure bar	
	Types 1ST and 1SN	Types 2ST and 2SN	Types 1ST and 1SN	Types 2ST and 2SN	Types 1ST and 1SN	Types 2ST and 2SN
5	250	415	500	830	1 000	1 650
6	225	400	450	800	900	1 600
8	215	350	430	700	850	1 400
10	180	330	360	660	720	1 320
12	160	275	320	550	640	1 100
16	130	250	260	500	520	1 000
19	105	215	210	430	420	850
25	88	165	175	325	350	650
31	63	125	150	250	250	500
38	50	90	100	180	200	360
51	40	80	80	160	160	320

^a 1 bar = 0,1 MPa.

6.2 Minimum bend radius

When bent to the minimum bend radius given in Table 5 measured on the inside of the bend, the flatness shall not exceed 10 % of the original outside diameter.

Measure the hose outside diameter with a calliper before bending the hose. Bend the hose to the minimum bend radius and measure the flatness with the calliper.

Table 5 — Minimum bend radius

Nominal bore	Minimum bend radius mm
5	90
6	100
8	115
10	130
12	180
16	200
19	240
25	300
31	420
38	500
51	630

6.3 Impulse test requirements

6.3.1 The impulse test shall be in accordance with EN ISO 6803. The test temperature shall be 100 °C.

6.3.2 For type 1ST and 1SN hoses, when tested at impulse pressure equal to 125 % of the maximum working pressure for hoses of nominal bore 25 and smaller, and at 100 % of the maximum working pressure for nominal bore 31 and above, the hose shall withstand a minimum of 150 000 impulse cycles.

For type 2ST and 2SN hoses, when tested at impulse pressure equal to 133 % of the maximum working pressure, the hose shall withstand a minimum of 200 000 impulse cycles.

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

6.3.4 This test shall be considered a destructive test and the test piece shall be disposed of in accordance with local environmental guidelines.

6.4 Leakage of hose assemblies

When tested in accordance with EN ISO 1402:2009, 8.4, there shall be no leakage or evidence of failure. This test shall be considered a destructive test and the test piece shall be disposed of in accordance with local environmental guidelines.

6.5 Cold flexibility

When tested in accordance with Method B of EN ISO 10619-2 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 EN ISO 1402 after regaining ambient temperature.

6.6 Adhesion between components

When tested in accordance with EN ISO 8033, the adhesion between lining and reinforcement, and between cover and reinforcement shall not be less than 2,5 kN/m.

Test pieces shall be Type 5 for lining and reinforcement and Type 2 or Type 6 or Type 8 for cover and reinforcement as described in Table 1 of EN ISO 8033:2006.

6.7 Vacuum resistance

When tested in accordance with EN ISO 7233, the hoses and hose assemblies shall conform to the values given in Table 6.

Table 6 — Degree of vacuum

Nominal bore	Negative gauge pressure bar ^a max.	
	Types 1ST and 1SN	Types 2ST and 2SN
5	-0,8	-0,95
6		
8		
10		
12		
16		
19	-0,6	-0,8
25		
31		
38		
51		

^a 1 bar = 0,1 MPa.

6.8 Abrasion resistance

All hose types shall be tested in accordance with Annex A.

For hose types 1ST and 2ST when tested with a vertical force of $(50 \pm 0,5)$ N the loss of mass after 2 000 cycles shall not be greater than 1 g for the average value of three or more test pieces.

For hose types 1SN and 2SN when tested with a vertical force of $(25 \pm 0,5)$ N the loss of mass after 2 000 cycles shall not be greater than 0,5 g for the average value of three or more test pieces.

6.9 Fluid resistance

6.9.1 Test pieces

The fluid resistance tests shall be carried out on moulded sheets of lining and cover compound, 2 mm minimum thickness, of equivalent cure state to that of the hose.

6.9.2 Oil resistance

When tested in accordance with ISO 1817, the lining immersed in oil No. 3 for 168 h at a temperature of 100 °C shall show no shrinkage and no volume swelling greater than 25 %.

When tested in accordance with ISO 1817, the cover immersed in oil No. 3 for 168 h at a temperature of 70 °C shall show no shrinkage and no volume swelling greater than 100 %.

6.9.3 Water based fluid resistance

When tested in accordance with ISO 1817, the lining and cover immersed in a test liquid made up of equal volumes of 1,2-ethanediol and distilled water for 168 h at a temperature of 70 °C shall show no shrinkage. The volume swelling shall be not greater than 25 % for lining and 100 % for cover.

6.9.4 Water resistance

When tested in accordance with ISO 1817, the lining and cover immersed in distilled water for 168 h at a temperature of 70 °C shall show no shrinkage. The volume swelling shall be not greater than 25 % for lining and 100 % for cover.

6.10 Ozone resistance

The test shall be in accordance with EN ISO 7326, Method 1 or 2, depending on the nominal bore of the hose. There shall be no cracking and no deterioration of the cover visible under x2 magnification.

7 Designation

Hoses shall be designated as the following example.

Designation of a Type 1ST hydraulic hose with wire braid reinforcement and a nominal bore of 10:

Hose EN 853 — 1ST 10

8 Marking

8.1 Hoses

Hoses shall be marked at a maximum spacing of 500 mm with at least the following information:

- a) manufacturer's name or identification, e.g. XXX;
- b) the number of this European Standard 'EN 853';
- c) type, e.g. 2ST;
- d) nominal bore, e.g. 16;
- e) quarter and last two digits of year of manufacture, e.g. 1Q15.

EXAMPLE XXX/EN 853/2ST/16/1Q15.

NOTE Other information as agreed between the purchaser and the manufacturer can be included, if requested.

8.2 Hose assemblies

Hose assemblies shall be marked with at least the following information:

- a) Hose assembler's name or identification, e.g. XXX;
- b) Maximum working pressure, of the assemblies in bar, e.g. 250 bar;
- c) Last two digits of year and month of assembly, e.g. 1501.

EXAMPLE XXX/250bar/1501.

NOTE Other information as agreed between the purchaser and the hose assembler can be included, if requested.

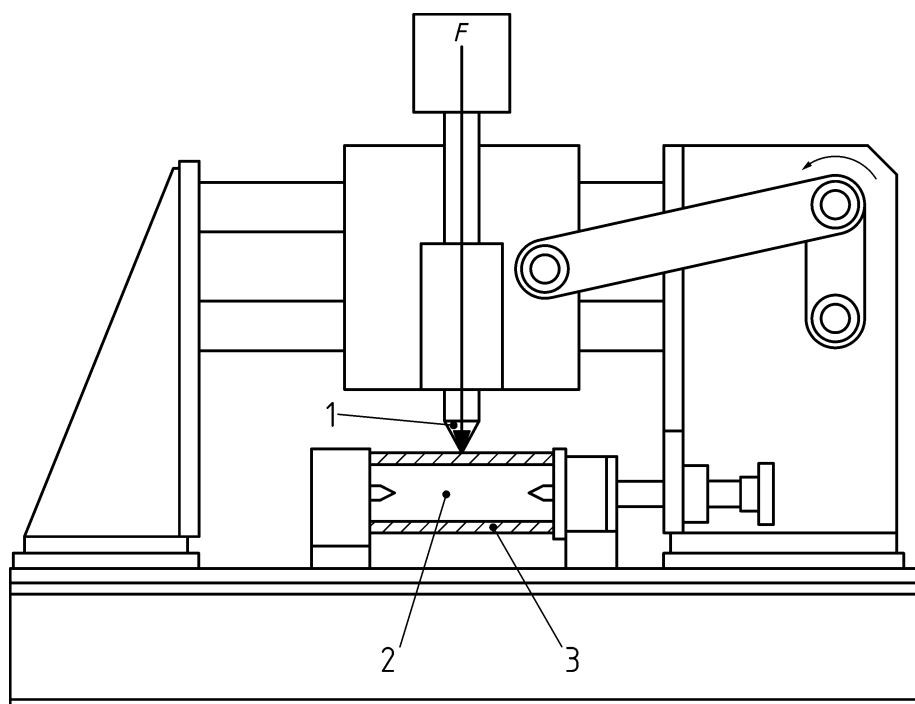
Annex A (normative)

Procedure for the measurement of abrasion

A.1 Apparatus

This method uses an apparatus consisting of a wheel and crank arrangement, capable of moving the abrading tool 100 mm back and forth along the test piece with sinusoidal motion at a rate of 1,25 Hz (one cycle equals 200 mm of travel). A typical arrangement is shown in Figure A.1. The traversing arrangement shall be designed to ensure that:

- the mid-point of the traversed length is coincident with the mid-point of the assembled hose and mandrel;
- the axes of the abrading tool and hose are mutually perpendicular at the mid-point;
- the plane of travel is parallel to the longitudinal axis of the test piece.



Key

- 1 abrading tool
- 2 mandrel
- 3 hose test piece

Figure A.1 — Typical test apparatus

This method requires a recording device, to record the number of cycles completed, and capable of being pre-set to terminate the test after completion of the specified number of cycles.

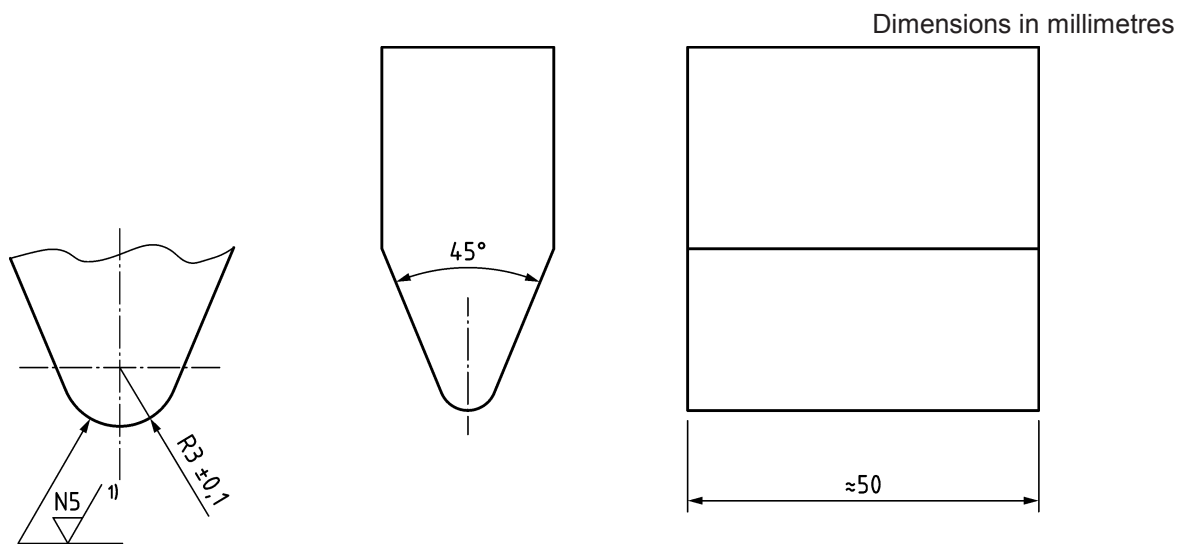
This method requires means of applying a vertical force F , as specified in this product standard, to the abrading tool at the point of contact with the test piece.

This method requires a mandrel, 150 mm long, on to which the test piece will fit tightly. It is essential that the mandrel is a tight fit in the test piece to prevent distortion of the test piece under the action of the reciprocating abrading tool. For accurate determinations, it is recommended that the mandrel is made of lightweight materials and is of hollow section, so that it is capable of supporting the abrading load but its mass is kept to an absolute minimum. If a solid mandrel is used, this shall be removed prior to weighing the test piece, taking care to avoid loss of material from the hose lining.

A.2 Method

This method uses an abrading tool manufactured from tool steel, heat-treated to give a minimum hardness of HV 890.

The principal dimensions shall be as shown in Figure A.2. It is essential that the specified profile and surface finish are maintained, and that any extraneous material on the surface of the abrading tool is cleaned off before testing is started.



¹⁾ The roughness grade N5 in accordance with EN ISO 1302 corresponds to a roughness value Ra of 0,4 µm.

Figure A.2 — Abrading tool

A.3 Test pieces

Each test piece shall be a sample of hose of length 150 mm ± 0,5 mm. A minimum of three test pieces shall be tested.

NOTE Selection of test pieces is permitted to ensure that there are no surface irregularities greater than 0,5 mm and that they are free from surface contamination.

A.4 Condition of test pieces

No test shall be carried out within 24 h of manufacture. For evaluations which are intended to be comparable, the test shall, as far as possible, be carried out after the same time interval after manufacture. Before testing, test pieces shall be conditioned for at least 3 h at the standard temperature and humidity of 23 °C ± 2 °C and (50 ± 5) % relative humidity or 27 °C ± 2 °C and (65 ± 5) % relative humidity, in accordance with ISO 23529; this 3 h period may be part of the 24 h interval after manufacture.

A.5 Procedure

Weigh each test piece on or off the mandrel and record the mass (m_1). Mount the assembled test piece and mandrel in the apparatus, ensuring that the test piece is restrained from axial and/or rotational movement. Place the abrading tool in contact with the test piece, apply the vertical static force F as specified in this product standard, and start the machine. Continue until the specified number of cycles has been completed, then remove the test assembly from the apparatus and reweigh the test piece, either on or off the mandrel, as for the initial weighing. It is important to remove any loose particles of cover compound prior to weighing. Record the mass (m_2) and the number of cycles completed.

For guidance in preparing requirements in product standards, the static force should be 50 N or 100 N, the latter being selected where higher abrasion resistance if the cover is expected. If it becomes evident during the test that wear has taken place to an extent that the reinforcement is exposed, stop the test, remove the test assembly from the apparatus and reweigh. Record the mass and the number of cycles completed. All weighings shall be carried out to an accuracy of $\pm 0,01$ g.

A.6 Expression of results

The loss of mass Δm , in grams, is given by the formula:

$$\Delta m = m_1 - m_2$$

where

m_1 is the mass, in grams, of the test piece before testing;

m_2 is the mass, in grams, of the test piece after testing.

A.7 Test report

The test report shall include the following information:

- a) a reference to this European Standard;
- b) a full description of the hose tested;
- c) the temperature at which the test was carried out;
- d) the number of cycles specified;
- e) the number of cycles completed on each test piece;
- f) the vertical static force F applied;
- g) the mass of each test piece before the test;
- h) the mass of each test piece after completion of the specified number of cycles or after discontinuation of the test;
- i) the loss of mass from each test piece;
- j) the average loss in mass of the three (or more) test pieces;
- k) any observations on the nature of wear, particularly any evidence of exposure of reinforcement;
- l) the date of the test.

Annex B
(normative)

Type and routine testing of production hoses

Property	Type tests Frequency (for each hose type and size): at initial product qualification, in the event of product changes after initial qualification and after 5 years	Routine tests Performed on each length of finished hose prior to warehousing or sale
Dimensions		
Measurement of inside diameter	X	X
Measurement of outside diameter	X	X
Measurement of outer cover thickness (if applicable – see Table 1)	X	N/A
Measurement of concentricity	X	N/A
Hose tests		
Proof test	X	X
Burst test	X	N/A
Minimum bend radius test	X	N/A
Change in length test (see 6.1.2)	X	X
Impulse test	X	N/A
Leakage test (hose assemblies)	X	N/A
Cold flexibility test	X	N/A
Adhesion (cover)	X	N/A
Adhesion (lining)	X	N/A
Vacuum resistance test	X	N/A
Fluid resistance test for cover	X	N/A
Fluid resistance test for lining	X	N/A
Ozone resistance test	X	N/A
Visual examination	X	X
X Test shall be carried out. N/A Test not applicable		

Annex C
(informative)

Production acceptance testing

Property	Productions tests	
	Frequency: every 3 000 m produced of each hose type and size	Frequency: every 12 months of production for each hose type and size
Dimensions		
Measurement of inside diameter	X	X
Measurement of outside diameter	X	X
Measurement of outer cover thickness (if applicable – see Table 1)	X	X
Measurement of concentricity	X	X
Hose tests		
Proof test	X	X
Burst test	X	X
Minimum bend radius test	N/A	X
Change in length test (see 6.1.2)	X	X
Impulse test	N/A	X
Leakage test (hose assemblies)	N/A	X
Cold flexibility test	N/A	X
Adhesion (cover)	N/A	X
Adhesion (lining)	N/A	X
Vacuum resistance test	N/A	X
Fluid resistance test for cover	N/A	X
Fluid resistance test for lining	N/A	X
Ozone resistance test	N/A	X
Visual examination	X	X
X Test shall be carried out. N/A Test not applicable		

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