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BSI Standards Publication

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

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National foreword

This British Standard is the UK implementation of EN ISO 4671:2022. It is identical to ISO 4671:2022. It supersedes BS EN ISO 4671:2007+A1:2011, which is withdrawn.

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 committee manager.

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EUROPÄISCHE NORM

March 2022

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4671:2007/A1:2011

English Version

Rubber and plastics hoses and hose assemblies - Methods of measurement of the dimensions of hoses and the lengths of hose assemblies (ISO 4671:2022)

Tuyaux et flexibles en caoutchouc et en plastique -
Méthodes de mesurage des dimensions des tuyaux et
de la longueur des flexibles (ISO 4671:2022)

Gummi- und Kunststoffschläuche und -
schlauchleitungen - Verfahren zur Messung der Maße
von Schläuchen und Längen von Schlauchleitungen
(ISO 4671:2022)

This European Standard was approved by CEN on 13 March 2022.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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European foreword

This document (EN ISO 4671:2022) has been prepared by Technical Committee ISO/TC 45 "Rubber and rubber products" in collaboration with 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 September 2022, and conflicting national standards shall be withdrawn at the latest by September 2022.

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

This document supersedes EN ISO 4671:2007.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 4671:2022 has been approved by CEN as EN ISO 4671:2022 without any modification.

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Fourth edition
2022-03

Rubber and plastics hoses and hose assemblies — Methods of measurement of the dimensions of hoses and the lengths of hose assemblies

*Tuyaux et flexibles en caoutchouc et en plastique — Méthodes de
mesurage des dimensions des tuyaux et de la longueur des flexibles*



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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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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of 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 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*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 218, *Rubber and plastics hoses and hose assemblies*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 4671:2007), which has been technically revised. It also incorporates the Amendment ISO 4671:2007/Amd 1:2011. The main changes are as follows:

- permissions (using the term “may”) have been changed to requirements (using the term “shall”) throughout the document along with resultant modified text;
- the position at which the outside diameter is measured has been clarified;
- [Clause 3](#) has been added.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Rubber and plastics hoses and hose assemblies — Methods of measurement of the dimensions of hoses and the lengths of hose assemblies

1 Scope

This document specifies methods of measuring the inside diameter, outside diameter (including diameter over reinforcement of hydraulic hoses), wall thickness, concentricity and lining and cover thickness of hoses, methods of measurement and identification of the lengths of hoses and hose assemblies, and a method of verifying the through-bore of hydraulic hose assemblies.

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 3611, *Geometrical product specifications (GPS) — Dimensional measuring equipment: Micrometers for external measurements — Design and metrological characteristics*

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

ISO 13385-1, *Geometrical product specifications (GPS) — Dimensional measuring equipment — Part 1: Design and metrological characteristics of callipers*

3 Terms and definitions

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

ISO and IEC maintain terminology 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 Test piece conditioning and temperature of measurement

4.1 Conditioning of test pieces

Unless otherwise specified, test pieces shall be taken at least 16 h after manufacture of the hose and conditioned at 23_{-3}^{+7} °C for at least 3 h before measurement. This 3 h shall be included in the 16 h.

4.2 Measurement temperature

Unless otherwise specified, the measurement temperature shall be 23_{-3}^{+7} °C.