

INTERNATIONAL STANDARD

**ISO
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Third edition
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Rubber and plastics hoses for general-purpose industrial applications — Bore diameters and tolerances, and tolerances on length

*Tuyaux en caoutchouc et en plastique à usage général dans les
applications industrielles — Diamètres intérieurs et leurs tolérances, et
tolérances sur la longueur*



Reference number
ISO 1307:1992(E)

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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 1307 was prepared by Technical Committee ISO/TC 45, *Rubber and rubber products*, Sub-Committee SC 1, *Hoses (rubber and plastics)*.

This third edition cancels and replaces the second edition (ISO 1307:1983), of which it constitutes a technical revision.

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Rubber and plastics hoses for general-purpose industrial applications — Bore diameters and tolerances, and tolerances on length

1 Scope

This International Standard specifies preferred bore diameters and tolerances, and tolerances on length, for rubber and plastics hoses for general-purpose industrial applications. Rubber and plastics hoses for hydraulic and automotive applications are not included. The standard is to be used only if the relevant product standard does not list its own specific diameters and tolerances.

2 Bore diameters and tolerances

The bore diameters of rubber and plastics hoses and the tolerances on bore diameter shall be in accordance with the requirements of table 1.

3 Tolerances on length

The tolerances on cut lengths shall be in accordance with the requirements of table 2.

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Table 1 — Bore diameters and tolerances

Dimensions in millimetres

Nominal bore diameter	Tolerances on:		
	Hoses built on rigid mandrels	Hoses built on flexible mandrels	Non-mandrel-built hoses
3,2	± 0,30	+ 0,50 to - 0,30	± 0,60
4,0 5,0	± 0,40	+ 0,60 to - 0,40	
6,3 8,0 10,0			± 0,60
12,5 16	± 0,80	+ 0,90 to - 0,70	
19 20			± 0,80
25	± 1,00	+ 1,50 to - 1,00	
31,5 38 40			± 1,20
50 51	± 1,40	± 1,60	
63			± 1,60
76 80	± 2,00	± 2,50	
100 125			± 2,50
150	± 3,00	± 3,00	
200			± 3,00
250 315	± 3,00	± 3,00	

Table 2 — Tolerances on length

Values in millimetres,
unless otherwise shown

Length	Tolerance
≤ 300	± 3
> 300 to ≤ 600	± 4,5
> 600 to ≤ 900	± 6
> 900 to ≤ 1 200	± 9
> 1 200 to ≤ 1 800	± 12
> 1 800	± 1 %

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