

SLOVENSKI STANDARD

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Nadomešča:
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Plastomerne večslojne (nevulkanizirane) cevi in cevni priključki za pretok utekočinjenega naftnega plina in utekočinjenega zemeljskega plina - Specifikacija

Thermoplastic multi-layer (non-vulcanized) hoses and hose assemblies for the transfer of liquid petroleum gas and liquefied natural gas - Specification

Thermoplastische, mehrlagige (nicht vulkanisierte) Schläuche und Schlauchleitungen für die Förderung von Flüssiggas und verflüssigtem Erdgas - Spezifikation

Tuyaux et flexibles en thermoplastique multi couches (non vulcanisés) utilisés pour le dépotage de gaz pétrolier liquide et gaz naturel liquéfié - Spécification

Ta slovenski standard je istoveten z: **EN 13766:2010**

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EUROPEAN STANDARD

EN 13766

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Thermoplastic multi-layer (non-vulcanized) hoses and hose assemblies for the transfer of liquid petroleum gas and liquefied natural gas - Specification

Tuyaux et flexibles en thermoplastique multi couches (non vulcanisés) utilisés pour le dépotage de gaz pétrolier liquide et gaz naturel liquéfié - Spécification

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This European Standard was approved by CEN on 5 May 2010.

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 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 Management Centre has the same status as the official versions.

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Contents

Page

Foreword.....	3
1 Scope	4
2 Normative references	4
3 Terms and definitions	5
4 Classification.....	5
5 Materials and construction	5
6 Dimensions.....	6
6.1 Internal diameters, with tolerances and minimum bend radii.....	6
6.2 Tolerance on length.....	7
7 Performance requirements of hoses and hose assemblies.....	7
7.1 Film and fabric	7
7.2 Hoses	7
7.3 End fittings	8
7.4 Hose assemblies.....	8
7.5 Electrical continuity.....	9
8 Test frequency	9
9 Type tests	9
10 Marking	10
10.1 Hose marking	10
10.2 Hose assembly marking.....	10
Annex A (normative) Crush recovery test	11
Annex B (normative) Method of test for thermal ageing.....	13
Annex C (normative) Method of test of fittings subjected to low temperatures.....	14
C.1 General.....	14
C.2 Specimen size	14
Annex D (normative) Sequence of hydrostatic tests.....	15
Annex E (normative) Method of test for fitting security.....	16
Annex F (normative) Method of test for leak tightness.....	18
Annex G (normative) Type and routine tests for hoses and hose assemblies	19
Annex H (informative) Batch tests for hoses and hose assemblies	20
Bibliography	21

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[SIST EN 13766:2011](https://standards.iteh.ai/catalog/standards/sist/5b5c7fd6-a9c8-4a82-8322-a52aca5cd6cf/sist-en-13766-2011)

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Foreword

This document (EN 13766:2010) 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 December 2010, and conflicting national standards shall be withdrawn at the latest by December 2010.

This document supersedes EN 13766:2003.

Compared to the 2003 version, changes have been made to the following (sub)clauses, tables and annexes:

- Scope: Reference to EN 1474-2 added;
- Table 1: Temperature has been changed to –196 °C;
- 7.1: Reference to new test standards added;
- Table 3: Change in length test refined;
- Table 4: Electrical resistance test refined;
- 7.5: Electrical Continuity text added; [SIST EN 13766:2011](https://standards.iteh.ai/catalog/standards/sist/5b5c7fd6-a9c8-4a82-8322-a52aea5cd6ef/sist-en-13766-2011)
- 10.1: Hose marking simplified; <https://standards.iteh.ai/catalog/standards/sist/5b5c7fd6-a9c8-4a82-8322-a52aea5cd6ef/sist-en-13766-2011>
- Annex E: text revised to incorporate cyclic testing to low temperatures;
- Annex G: Tests moved from hose to hose assemblies;
- Annex H: Tests moved from hose to hose assemblies.

This document has also been presented to ISO/TC 45/SC 1, for adoption as an ISO standard under the Vienna agreement.

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, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

EN 13766:2010 (E)

1 Scope

This European Standard specifies requirements for two types of thermoplastic multi-layer (non-vulcanized) transfer hoses and hose assemblies for carrying liquefied petroleum gas and liquefied natural gas. Each type is subdivided into two classes, one for onshore duties, and the other for offshore.

This European Standard is applicable for hose sizes from 25 mm to 250 mm, working pressures from 10,5 bar to 25 bar and operating temperatures from $-196\text{ }^{\circ}\text{C}$ to $+45\text{ }^{\circ}\text{C}$.

NOTE Offshore LNG hose assemblies are also specified in EN 1474-2.

WARNING — Persons using this European Standard should be familiar with normal laboratory practice.

This standard does not purport to address all the safety problems, if any, associated with its use. It is the responsibility of the user to establish appropriate health and safety practices and to ensure compliance with any national regulatory conditions.

2 Normative references

The following referenced documents are indispensable for the application 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.

EN 10045-1, *Metallic materials — Charpy impact test — Part 1: Test method*

EN 10088-3, *Stainless steels — Part 3: Technical delivery conditions for semi-finished products, bars, rods, wire, sections and bright products of corrosion resisting steels for general purposes*

EN ISO 527-1, *Plastics - Determination of tensile properties — Part 1: General principles (ISO 527-1:1993 including Corr 1:1994)*

EN ISO 1043-1, *Plastics — Symbols and abbreviated terms — Part 1: Basic polymers and their special characteristics (ISO 1043-1:2001)*

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

EN ISO 1746, *Rubber or plastics hoses and tubing — Bending tests (ISO 1746:1998, including technical corrigendum 1:1999)*

EN ISO 4671, *Rubber and plastics hose and hose assemblies — Methods of measurement of the dimensions of hoses and the lengths of hose assemblies (ISO 4671:2007)*

EN ISO 4672, *Rubber and plastics hoses — Sub-ambient temperature flexibility tests (ISO 4672:1997)*

EN ISO 7326, *Rubber and plastics hoses — Assessment of ozone resistance under static conditions (ISO 7326:2006)*

EN ISO 8031:2009, *Rubber and plastics hoses and hose assemblies — Determination of electrical resistance and conductivity (ISO 8031:2009)*

EN ISO 8330:2008, *Rubber and plastics hoses and hose assemblies — Vocabulary (ISO 8330:2007)*

EN ISO 13934-1, *Textiles — Tensile properties of fabrics — Part 1: Determination of maximum force and elongation at maximum force using the strip method (ISO 13934-1:1999)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 8330:2008 apply.

4 Classification

Hoses shall be classified according to their usage, working pressure and working temperature range as given in Table 1.

Table 1 — Pressure and temperature range

Pressure/temperature	Class A ^a	Class B ^b	Class A	Class B
	Type 1	Type 1	Type 2	Type 2
Maximum working pressure (bar)	25	20	13	10,5
Proof pressure (bar)	37,5	30	19,5	15,8
Minimum burst pressure (bar)	100	100	52	52,5
Working temperature range (°C)	- 50 ± 3 to + 45	- 50 ± 3 to + 45	- 196 ± 5 to + 45	- 196 ± 5 to + 45
NOTE 1 1 bar = 0,1 Mpa				
NOTE 2 Due to pressurisation during test and operations the temperature of the fluid could increase. The indicated temperatures are measured at atmospheric pressure;				
^a Class A is for use onshore. ^b Class B is for use offshore.				

5 Materials and construction

Hoses shall be constructed as shown in Figure 1 and shall consist of the following:

a) Class A:

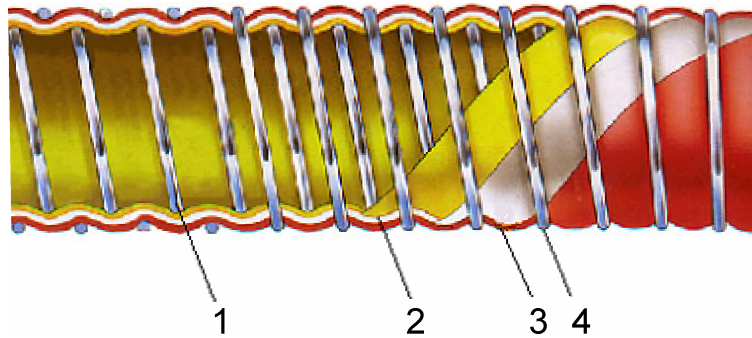
- 1) An internal wire helix of stainless steel conforming to EN 10088-3, numbers 1.4306, 1.4401, 1.4404 or 1.4436;
- 2) A multi-ply wall of layers of films and fabrics made of thermoplastics that in combination give the required properties specified in Table 1 and provide a complete seal;
- 3) An external wire helix of stainless steel conforming to EN 10088-3, numbers 1.4306, 1.4401, 1.4404 or 1.4436.

b) Class B:

- 1) An internal wire helix of stainless steel conforming to EN 10088-3, numbers 1.4401, 1.4404 or 1.4436;
- 2) A multi-ply wall of layers of films and fabrics made of thermoplastics that in combination give the required properties specified in Table 1 and provide a complete seal;
- 3) An external wire helix of stainless steel conforming to EN 10088-3, numbers 1.4401, 1.4404 or 1.4436.

EN 13766:2010 (E)

NOTE By agreement between manufacturer and purchaser, the outer layer may have colour identification.



Key

- 1 internal wire
- 2 film
- 3 fabric
- 4 external wire

Figure 1 — Section of a typical thermoplastic multilayer hose

6 Dimensions

6.1 Internal diameters, with tolerances and minimum bend radii

When measured in accordance with EN ISO 4671, the values of the internal diameter of the hose shall conform to Table 2. When tested by the method described in EN ISO 1746 the value of the minimum bend radius shall be as given in Table 2. The hose shall show no sign of permanent deformation of the cross section i.e. kinking.

Table 2 — Dimensions and minimum bend radius

Dimensions in millimetres

Internal diameter	Tolerance	Minimum bend radius
25	± 1	150
32	± 1	175
38	± 1	175
40	± 1	200
50	± 1	200
65	± 2	200
75	± 2	250
80	± 2	250
100	± 2	500
150	± 2	660
200	± 3	910
250	± 3	2 500

6.2 Tolerance on length

When tested in accordance with EN ISO 4671 the tolerance on the measured length of delivered hose assemblies shall be ${}^{+2}_{-1}$ %.

7 Performance requirements of hoses and hose assemblies

7.1 Film and fabric

When tested at the minimum temperature, Type 1: -50 ± 3 °C and Type 2: -196 ± 5 °C (and in accordance with EN ISO 13934-1 or equivalent for fabric testing and EN ISO 527-1 or equivalent for film testing) samples of film and fabric shall have an elongation at break of not less than 10 %.

7.2 Hoses

When tested in accordance with the methods given in Table 3, the physical properties of the hoses shall conform to Table 3.

Table 3 — Physical properties of hoses

Property	Unit	Requirement	Method
Proof pressure	Bar	No leakage or other signs of damage at pressure given in Table 1 (standards.iteh.ai)	EN ISO 1402 with pressure increase not less than 1,7 bar/min
Change in length at proof pressure (max)	%	10 SIST EN 13766:2011 https://standards.iteh.ai/catalog/standards/sist/5b5c7fd6-a9c8-4a81-8322-a52aea5cd6ef/sist-en-13766-2011	EN ISO 1402:2009, 8.2 initial length measured when the hose is pressurised to 0,7 bar
Twist at proof pressure (max)	°/m	10	EN ISO 1402:2009, 8.2 initial reading taken when hose is pressurised to 0,7 bar
Burst pressure	Bar	≥ Values in Table 1	EN ISO 1402
Bend	—	No leakage or visible damage when the hose is bent to radius given in Table 2 and subjected to the proof pressure.	EN ISO 1746
Crush recovery (max)	%	3	Annex A
Ozone resistance 72 h at 40 °C	—	No cracking observed at × 2 magnification	EN ISO 7326
Thermal ageing	—	No leakage at proof pressure given in Table 1	Annex B
Low temperature flexibility	—	Test at minimum temperature given in Table 1	EN ISO 4672

EN 13766:2010 (E)**7.3 End fittings**

End fittings and metallic ferrules shall be made from the following materials depending on the type of hose to be used in the assembly:

- Type 1 hose: LT (low temperature) grade carbon steel or stainless steel;
- Type 2 hose: austenitic stainless steel tested in accordance with Annex C.

For all types of end fittings, that part of the fitting that enters the hose and forms the means by which the fitting is connected to the hose shall be provided with scrolls or protrusions on the surface that correspond to the pitch of the internal helix wire of the hose.

7.4 Hose assemblies

Hose assemblies shall be fitted with end fittings as described in 7.3.

End fittings shall be attached to the hose by one of the following methods:

- a) by the use of a seal and a metal ferrule which is swaged or crimped;
- b) by the use of a thermoset resin e.g. epoxy and a metal ferrule which is swaged or crimped.

NOTE Hoses should be assembled by the hose manufacturer.

When tested by the methods given in Table 4, hose assembly shall conform to Table 4.

When assembled to a hose there shall be electrical continuity between the end fitting and the internal and external wires.

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Table 4 — Physical properties of hose assemblies

Property	Unit	Requirements	Method(s)
Proof pressure	Bar	No leakage or other signs of weakness at pressure given in Table 1	EN ISO 1402 with a pressure increase not less than 1,7 bar/min
Bend	—	No leakage or visible damage when the hose is bent to the radius given in Table 2 and is subjected to the proof pressure	EN ISO 1746
Series of hydrostatic tests	Bar % °/m	≥ burst pressure given in Table 1 Change in length as in Table 3 Twist as given in Table 3	Annex D
Security of end fitting	Bar	No leakage at proof pressure given in Table 1	Annex E and EN ISO 1402
Electrical resistance between end fittings	Ω	No reduction of electrical resistance between end fittings ≤ 2,5 ohm/m for sizes less than 50 mm ≤ 1,0 ohm/m for the 50 mm size and above sizes	EN ISO 8031:2009, 4.8
Leak tightness	—	No leakage of air when subjected to 3,5 bar for 5 min	Annex F

7.5 Electrical continuity

There shall be electrical continuity between both internal and external wires and the end fittings. Manufacturers shall demonstrate by testing or calculation that the measured overall electrical resistance of the hose assembly incorporates both inner and outer wires being part of the circuit.

8 Test frequency

Routine tests shall be carried out on each hose assembly and in accordance with Annex G.

It is recommended that batch tests are carried out for every 10 000 m of manufacture or once a year, varying the sizes and types and in accordance with Annex H.

9 Type tests

Type tests shall be carried out to confirm that the hose assembly design, materials and method of manufacture meets the requirements of this standard.

Type tests shall be carried out on at least three sizes of hose including the smallest and largest for each type in the manufacturer's range.