
**Rubber and plastics hoses —
Determination of adhesion between
components**

*Tuyaux en caoutchouc et en plastique — Détermination de l'adhérence
entre éléments*

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. 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.

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

ISO 8033 was prepared by Technical Committee ISO/TC 45, *Rubber and rubber products*, Subcommittee SC 1, *Hoses (rubber and plastics)*.

This third edition cancels and replaces the second edition (ISO 8033:1991), Clause 5, Subclause 6.3, Table 1 and Figure 8 of which have been technically revised.

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Rubber and plastics hoses — Determination of adhesion between components

1 Scope

Adequate adhesion between the various components of a hose is essential if it is to perform satisfactorily in service. This International Standard specifies methods for the determination of the adhesion between lining and reinforcement, between cover and reinforcement, between reinforcement layers, between cover and outer lamination (thin layer of material outside the cover for protection) and between lining and inner lamination (thin layer of material inside the lining to reduce permeation of fluid into the lining). It covers all bore sizes and the following types of hose construction:

- woven textile fabric;
- braided textile fabric;
- knitted textile fabric;
- circular-woven textile fabric;
- textile spiral;
- textile cord;
- wire braid;
- wire spiral;
- hoses containing a supporting helix.

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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.

ISO 5893:2002, *Rubber and plastics test equipment — Tensile, flexural and compression types (constant rate of traverse) — Specification*

ISO 6133, *Rubber and plastics — Analysis of multi-peak traces obtained in determinations of tear strength and adhesion strength*

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

3 Principle

Using test pieces of standard dimensions, the adhesion strength between lining and reinforcement, between cover and reinforcement, between reinforcement layers, between cover and outer lamination and between lining and inner lamination is measured under specified conditions.

4 Apparatus

A test machine having the following characteristics is required:

4.1 Test machine

The machine shall be power driven, equipped with a suitable dynamometer, capable of maintaining a substantially constant rate of traverse of the moving head during the test and fitted with an autographic recorder. It shall comply with the requirements for class 0,5 or 1 of ISO 5893:2002.

An inertialess dynamometer shall be used.

4.2 Grips

The grips shall be capable of holding the test piece without slippage.

Self-tightening grips are recommended.

For strip test pieces, provision shall be made to maintain the strip in the appropriate plane of the grips during the test, for example by attaching sufficient weights to the free end of the test piece or by fitting a supporting plate, coated with a low-friction material such as polytetrafluoroethylene (PTFE), to the non-driven grip.

4.3 Mandrel

For testing ring test pieces (type 6 and type 8), a mandrel shall be provided that is a close sliding fit in the test piece. This mandrel shall be capable of being fitted into the driven head of the machine so that it will rotate freely during the test.

5 Test pieces

5.1 Types of test piece

5.1.1 General

Eight types of test piece are specified to cover the range of hose constructions and bore sizes normally encountered (see Figures 1 to 8).

5.1.2 Type 1

Strip, cut from the hose as a 25 mm \pm 0,5 mm wide ring which is then cut transversely to form a strip.

5.1.3 Type 2

Strip, 160 mm \times half the hose circumference.

5.1.4 Type 3

Strip, cut from the hose as a 35 mm \pm 2 mm wide ring which is then cut transversely to form a strip.

5.1.5 Type 4

Strip, 160 mm × half the hose circumference or 10 mm whichever is smaller.

5.1.6 Type 5

Strip, 160 mm long × half the hose circumference.

5.1.7 Type 6

Ring, 35 mm ± 2 mm wide.

5.1.8 Type 7

Strip, cut along a reinforcing helix, 25 mm ± 0,5 mm wide or the maximum obtainable.

5.1.9 Type 8

Ring, 25 mm ± 0,5 mm wide.

5.2 Test piece selection

Unless specified in the particular product standard or otherwise agreed between the interested parties, the type of test piece shall be selected from Table 1. Results obtained with different test pieces and/or hoses of the same construction but of different diameters are not comparable.

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Table 1 — Test piece selection

Hose construction	Adhesion between	Hose nominal bore size, d (mm)		
		$d \leq 20$	$20 < d \leq 50$	$50 < d$
Woven textile fabric	Lining and reinforcement	Type 4 or 8	Type 1 or 8	Type 1 or 8
Braided textile fabric	Reinforcement layers	Type 4 or 8	Type 1 or 8	Type 1 or 8
Knitted textile fabric	Cover and reinforcement	Type 4 or 8	Type 1 or 8	Type 1 or 8
Circular-woven textile fabric				
Textile spiral	Lining and reinforcement	Type 2, 6 or 8	Type 3, 6 or 8	Type 3, 6 or 8
Textile cord	Reinforcement layers	Type 2 ^a , 6 or 8	Type 2, 3 ^a , 6 or 8	Type 3 ^a , 6 or 8
	Cover and reinforcement	Type 2, 6 or 8	Type 3, 6 or 8	Type 3, 6 or 8
Wire braid	Lining and reinforcement	Type 5 ^b	Type 5	Type 5
Wire spiral	Reinforcement layers	— ^c	— ^c	— ^c
	Cover and reinforcement	Type 2, 6 or 8	Type 2, 6 or 8	Type 2, 6 or 8
Hoses containing a supporting helix	Lining and reinforcement	Type 7	Type 7	Type 7
	Reinforcement layers	Type 7	Type 7	Type 7
	Cover and reinforcement	Type 7	Type 7	Type 7
All constructions	Lining and inner lamination	Type 2, 4, 5 or 8	Type 2, 4, 5 or 8	Type 2, 4, 5 or 8
	Cover and outer lamination	Type 2, 4, 5 or 8	Type 2, 4, 5 or 8	Type 2, 4, 5 or 8

^a If the determination of adhesion is affected by difficulty in obtaining a cleanly separating interface because of fraying of the yarns, indicate this in the test report.

^b Determination is impracticable below 12,5 mm bore size since insufficient test piece width is available.

^c Determination is impracticable since the wire braid or spiral layers tend to disintegrate and the result is in any case significantly affected by the forces required to bend the wires.

5.3 Test piece preparation

5.3.1 General

Test pieces shall be prepared by a method that does not produce high temperatures due to the action of the cutting blade.

The thickness of test pieces shall be adjusted by buffing so that the separated faces are positioned as close as possible to the axis of traction of the grips.

Test pieces that contain foreign matter or have blisters or flaws shall not be used for tests.

5.3.2 Type 1

Cut a ring 25 mm \pm 0,5 mm wide from the hose at right angles to its longitudinal axis. Cut the ring transversely and open it out to form a strip.

Separate a layer for a distance sufficient to enable the separated ends to be held in the grips of the test machine (see Figure 1).

Where heat build-up might cause deterioration of properties, use test pieces of type 2, 3, 5 or 6.

5.3.3 Type 2

Cut a suitable length of hose in half longitudinally. From one of the halves, make two cuts parallel to the axis of the test piece 25 mm \pm 0,5 mm, 10 mm \pm 0,5 mm or 5 mm \pm 0,2 mm apart, depending on the width available, taking care not to cut through the yarns.

Separate a layer for a distance sufficient to enable the separated ends to be held in the grips of the test machine (see Figure 2).

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5.3.4 Type 3

Cut a ring 35 mm \pm 2 mm wide from the hose at right angles to its longitudinal axis. Cut the ring transversely and open it to form a strip.

Make two parallel cuts on the strip 25 mm \pm 0,5 mm apart, taking care not to cut through the yarns.

Separate a layer for a distance sufficient to enable the separated ends to be held in the grips of the test machine (see Figure 3).

5.3.5 Type 4

Cut a suitable length of hose in half longitudinally. From one of the halves, cut a strip 10 mm \pm 0,5 mm wide, or of the maximum width obtainable if the width is less than 10 mm.

Separate a layer for a distance sufficient to enable the separated ends to be held in the grips of the test machine (see Figure 4).

5.3.6 Type 5

Cut a suitable length of hose in half longitudinally. Using a twin-bladed tool, cut from one of the halves a centrally located longitudinal strip 5 mm \pm 0,2 mm wide through the lining and open up one end of the test piece to form a lip.

Separate a layer for a distance sufficient to enable the separated ends to be held in the grips of the test machine (see Figure 5).

5.3.7 Type 6

Cut a ring 35 mm \pm 2 mm wide from the hose at right angles to its longitudinal axis. Make two circumferential cuts through the cover 25 mm \pm 0,5 mm apart and located centrally on the test piece. Make a transverse cut across the 25 mm width through the cover and open up on one side of the cut to form a lip (see Figure 6).

NOTE When cutting ring-shaped test pieces from a hose, it is advisable to insert a wooden cylinder, or similar device, into the hose before cutting out the test piece.

5.3.8 Type 7

Obtain a strip from the hose wall by cutting along the reinforcing helix through the complete thickness of the hose, and trim to 160 mm long and 25 mm \pm 0,5 mm wide or the maximum width obtainable if the width is less than 25 mm.

Separate a layer for a distance sufficient to enable the separated ends to be held in the grips of the test machine (see Figure 7).

NOTE This is an optional test for helix-reinforced hoses made in long lengths. It does not apply to hoses made to individual lengths, with special ends, built-in fittings, etc. It is only applicable if the spacing between individual helices is greater than 10 mm.

5.3.9 Type 8

Cut a ring-shaped test piece 25 mm \pm 0,5 mm wide from the hose at right angles to its longitudinal axis. Make a transverse cut across the 25 mm width through the cover and open up on one side of the cut to form a lip (see Figure 8).

NOTE When cutting ring-shaped test pieces from a hose, it is advisable to insert a wooden cylinder, or similar device, into the hose before cutting out the test piece. [ISO 8033:2006](https://standards.iteh.ai/catalog/standards/sist/2f2e2d98-650a-4839-9482-5e4def6e23e0/iso-8033-2006)

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5.4 Conditioning of test pieces [5e4def6e23e0/iso-8033-2006](https://standards.iteh.ai/catalog/standards/sist/2f2e2d98-650a-4839-9482-5e4def6e23e0/iso-8033-2006)

No tests shall be carried out within 24 h of manufacture. Before testing, test pieces shall be conditioned at standard temperature and humidity (see ISO 23529) for at least 16 h; this may be part of the 24 h after manufacture.

5.5 Time interval between vulcanization and testing

For evaluations intended to be comparable, the tests should, as far as possible, be carried out after the same time interval after manufacture. ISO 23529 shall be followed for the time between sample manufacture and testing.

6 Procedure

6.1 Preparation

A separate test piece shall be used for each interface to be tested.

6.2 Insertion of test pieces

Take a test piece from the conditioning atmosphere and measure the actual width of the test piece. For types 1, 2, 3, 4, 5 and 7, fix the separated ends of the test piece in the grips of the test machine. For types 6 and 8, place the test piece on the mandrel (4.3) and the separated ends in the grips. Adjust so that the tension is distributed uniformly and that no twisting of the test piece occurs during the test. Place the test piece in the grips so that the angle of separation is approximately 180° for strip or 90° for ring test pieces.