



A SINGER INDUSTRIAL COMPANY

FORCE TO BEND & MINIMUM BEND RADIUS:

Understanding Minimum Bend Radius:

The minimum bend radius of a hose is the smallest radius it can be bent without damage or significant performance reduction. This is measured from the inside of the curve and is critical for ensuring hose longevity and functionality. If a hose is bent beyond this limit, it can lead to:

- Kinking, which restricts flow and can cause pressure loss.
- Internal damage, such as layer separation or reinforcement failure.
- Premature wear, reducing the service life of the hose.

For any application, the actual bend radius must be equal to or greater than the minimum rated bend radius of the hose. This prevents unnecessary strain and mechanical failure.

Force-to-Bend and Flexibility:

The force-to-bend is the amount of force required to bend a hose around a specified radius. A lower force requirement means the hose is easier to handle and install, which is important in applications requiring frequent movement. **Factors Affecting Force-to-Bend:**

- Hose construction (reinforcement layers, wall thickness, material flexibility).
- Hose diameter (larger diameters require more force).
- Temperature effects (some hoses become stiffer in cold conditions).

Different hose designs may have the same minimum bend radius but require different bending forces. Choosing the right balance between flexibility and durability is key.

Formula for Minimum Hose Length:

To ensure a hose is not over-bent, the minimum hose length for a 90° bend can be calculated as follows:

$$\text{Minimum Hose Length} = \frac{\theta}{360} \times 2\pi r$$

$$\text{Minimum Hose Length} = \frac{90}{360} \times 2 \times 3.14 \times 4.5 = 7"$$

Where:

- θ = Angle of the bend (in degrees).
- r = Given bend radius of the hose.
- π = 3.14

Example Calculation:

For a 2" I.D. hose with a bend radius of 4.5 inches making a 90° bend:

$$\frac{90}{360} \times 2 \times 3.14 \times 4.5 = 7"$$

So, the minimum length of hose required to make the bend without damage is 7 inches.

General Formula for Minimum Hose Length in a System:

When considering overall hose assembly length, the following formula applies:

$$\text{Overall Length (OAL)} = (2 \times \text{Length of Coupling}) + (2 \times \text{Hose OD}) + \left(\frac{\theta}{360} \times 2\pi r \right)$$

Overall Length (OAL) = (2 × Length of Coupling) + (2 × Hose OD) + (360θ × 2πr)

This accounts for additional components like couplings and fittings in the system.

Practical Considerations for Hose Bending:

- **Avoid Sharp Bends:** Use elbows and fittings if necessary to maintain the required bend radius
- **Consider Operating Conditions:** Flexibility changes with temperature, pressure, and fluid type
- **Regular Inspection:** Look for signs of kinking, wear, or deformation to prevent failures.
- **Use ASTM Standards:** The ASTM D471 standard provides guidance on hose material properties and bending resistance.

By following these principles, hoses can be installed and used efficiently while maintaining optimal flow, durability, and safety.

