

# ANSI B11.15 – 2001 (R2020)

*American National Standard*

*Safety Requirements for  
Pipe, Tube, and Shape Bending Machines*

ANSI-Accredited Standards Developer and Secretariat:



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POB 690905  
Houston, TX 77269, USA

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by the American National Standards Institute  
Board of Standards Review

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## **Foreword** (This Foreword is not part of the requirements of American National Standard B11.15-2001 R2020)

The primary objective of this standard is to eliminate or control the risk of injuries to personnel associated with pipe tube and shape bending machines by establishing requirements for the machine's construction, operation and maintenance and for the production systems in which pipe, tube and shape bending machines are used. To accomplish this objective, responsibilities have been assigned to the supplier (manufacturer, rebuilder, reconstructor, and user) as well as to personnel in the working environment. Point-of-operation safeguarding is the single most important factor in the elimination of point-of-operation injuries. A production system consists of the pipe, tube or shape bender as one component, feeding methods (including part or scrap removal) as a second component, and the third component, point-of-operation safeguarding. The vital third component, point-of-operation safeguarding, can be evaluated for effectiveness only after the first two components and operator involvement is known.

The safeguarding of production systems in pipe, tube and shape bending operations is complicated by the wide variety of operations and operating conditions, the variations in size, speed, and type of pipe, tube and shape bending machine used; the size, thickness, and kind of pieces to be worked; the required accuracy of the finished work; the skill of operators; the length of run; and the method of tube or shape feeding and part and scrap removal. Because of these varying factors in the operations and in the workplace, a wide variety of point-of-operation safeguarding methods (guards and devices) have been covered in this standard.

The words "safe" and "safety" are not absolutes. Safety begins with good design. While the goal of this standard is to eliminate injuries, it is recognized that risk factors cannot possibly be reduced to zero in any human activity. This standard is not intended to replace good judgment and personal responsibility. Operator skill, attitude, training, job monotony, ergonomic factors, fatigue and experience are safety factors that must be considered by the user.

Pipe, tube and shape bending machines, and associated equipment technologies are continuously evolving. This standard reflects the most commonly used and time-tested state of the art at the time of its approval. The inclusion or omission of language relative to any evolving technology, either in the requirements or explanatory area of this standard, in no way infers acceptance or rejection of such technologies.

## **EFFECTIVE DATE**

The following information on effective dates is informative guidance only, and not a normative part of this standard. This subcommittee recognizes that some period of time after the approval date on the title page of this document is necessary for suppliers and users to develop new designs, or modify existing designs or manufacturing processes in order to incorporate the new or revised requirements of this standard into their product development or production system.

This subcommittee recommends that suppliers complete and implement design changes for new machines and machinery systems within 30 months of the approval of this standard.

The subcommittee recommends that users evaluate whether existing machinery and machinery systems have acceptable risk within 30 months of the approval date of this standard using generally recognized risk assessment methods. If the risk assessment shows that modification(s) is necessary, refer to the requirements of this standard to implement risk reduction measures (risk reduction measures) for appropriate risk reduction.

Inquiries with respect to the application or the substantive requirements of this standard, and suggestions for its improvement, are welcomed and should be sent to B11 Standards, Inc., POB 690905, Houston, TX 77269, Attention: Secretariat.

**DEVELOPMENT**

This standard was prepared by the B11.15 Subcommittee, processed and submitted for ANSI approval by the B11 Accredited Standards Committee on Safety Standards for Machines. Committee approval of this standard does not necessarily imply that all committee members voted for its approval. At the time this standard was reaffirmed, the ANSI B11 Accredited Standards Committee was composed of the following Members:

Alan Metelsky, Chairman  
 Barry Boggs, Vice-Chairman  
 David Felinski, Secretary

**Organizations Represented**

**Name of Representative Delegate**

**Alternate**

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Association For Manufacturing Technology	Russell Bensman	Alan Metelsky
The Boeing Company	Don Nelson	Lance Chandler, PE
Canadian Standards Association	Elizabeth Rankin, CRSP	Walter Veugen
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Komatsu America Industries	George Schreck	James Landowski
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Rockwell Automation	Patrick Barry	Michael Miller
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System Safety Society	John Etherton, PhD, CSP	Rod Simmons, PhD
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International United Automotive Workers	Tom Ford	

At the time this standard was approved, the ANSI B11 ASC **B11.15 Subcommittee** had the following members who participated in the development of this revision:

Robert Grice, Chairman	Creation Windows
Thomas Glissman, Secretary	Pines Manufacturing
Robert Eggleston	Drion Safety Service, Inc. (Previously with G.E. Aircraft Engines)
Joseph Kelly	(Previously with Allegheny Teledyne Industries; past Chairman of the B11.15 Subcommittee)
David Felinski, Secretary	AMT

## Explanation of the format of the standard

This ANSI B11.15 – 2001 (R20) standard is divided into parts formerly referred to as sections or chapters and now referred to as clauses in line with the current ANSI style manual. Major divisions of clauses are referred to as subclauses and, when referenced by other text in the standard, are denoted by the subclause number (e.g., see 5.1).

The standard uses a two-column format to provide supporting information for requirements. The material in the left column is confined to “Standards Requirements” only, and is so captioned. The right column, captioned “Explanatory Information” contains information that the writing Subcommittee felt would clarify the standard. This column should not be construed as being a part of the requirements of this American National Standard.

Operating rules (safe practices) are not included in either column of this standard unless they are of such nature as to be vital safety requirements, equal in weight to other requirements, or guides to assist in compliance with the standard.

As in all American National Standards, the term “SHALL” denotes a requirement that is to be strictly followed in order to conform to this standard; no deviation is permitted. The term “SHOULD” denotes a recommendation, a practice or condition among several alternatives, or a preferred method or course of action.

Similarly, the term “CAN” denotes a possibility, ability or capability, whether physical or causal, and the term “MAY” denotes a permissible course of action within the limits of the standard.

By convention, the B11 standards do not use the term “and/or” but instead, the term “OR” is used as an inclusive disjunction, meaning *one or the other or both*.

Suggestions for improvement of this standard will be welcome. They should be sent to B11 Standards, Inc., POB 690905, Houston, TX 77269 - Attention: B11 Secretariat.

## Introduction

The primary purpose of every machine tool is to process parts. This is accomplished by the machine imparting process energy onto the workpiece. Inadvertent interference with, or accidental misdirection of the released energy during production, maintenance, commissioning and de-commissioning may result in injury.

The purpose of the ANSI B11 series of machine tool safety standards is to devise and propose ways to minimize risks of the potential hazards. This can be accomplished either by an appropriate machine design or by restricting personnel or other individuals' access to hazard areas, and by devising work procedures to minimize personnel exposure to hazardous situations. This is the essence of the ANSI B11 series of safety standards.

The responsibility for the alleviation of these risks is divided between the equipment supplier, its user and its operating personnel, as follows (numbers in parentheses refer to the clause numbers in these standards which address that responsibility):

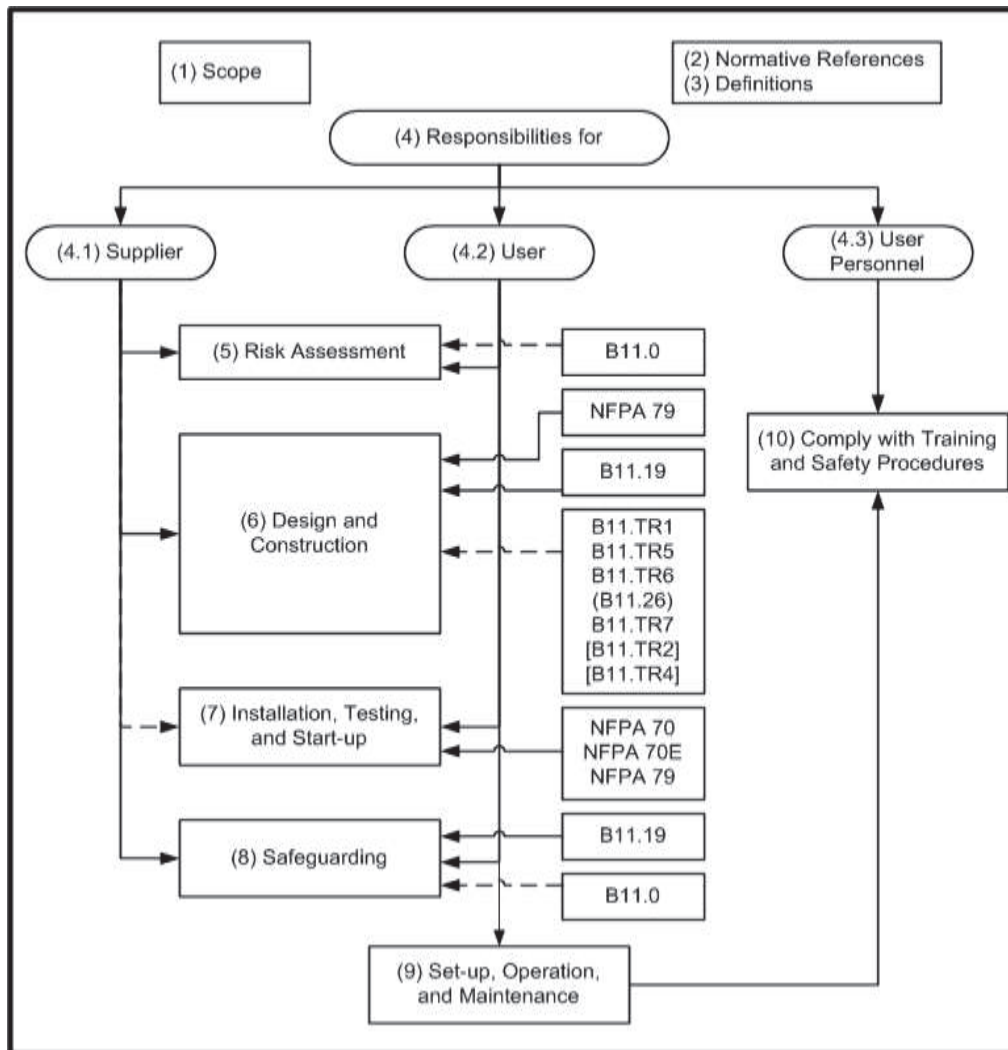


Figure 1 – Typical layout of B11 base standards showing the various responsibilities

Figure 1 (previous page) provides an overview of this standard and in particular, the responsibilities of and requirements for the supplier and user, including the user personnel. Numbers in parentheses denote the particular clause or subclause of the standard. A solid line between a block showing reference standard(s) and a block showing a normative clause denotes part of the requirements. A dashed line denotes an informative reference.

**Notes for Figure 1:**

- 1) Scope – Provides the boundaries or limits of the standard (i.e., what is/is not included in the coverage or requirements).
- 2) Normative references – Other standards which in whole or in part provide additional requirements when referenced in the normative text (i.e., left-hand column of clauses 4 – 9) of this standard.
- 3) Definitions – Terms used in this standard in a unique or particular manner, together with their definitions (terms used in the same context as are generally understood and commonly used in everyday English are not defined).
- 4) Responsibility – The general responsibilities of the supplier (builder), user, and the user personnel are listed in clause 4 together with which of the remaining clauses they have primary responsibility.
- 5) Risk assessment process – Clause 5 presents the general approach to risk assessment (see B11.0 [B11.TR3] for further explanation of hazard/task identification and risk assessment/risk reduction).
- 6) Design and construction – Generally, the supplier will be responsible for the requirements of clause 6, understanding that the user may add to or modify these requirements through the purchase agreement.
- 7) Layout, installation, testing and start-up – Although the requirements of clause 7 are predominantly the responsibility of the user, the supplier will normally provide assistance either directly (providing personnel) or indirectly (instruction materials).
- 8) Safeguarding – This is normally a shared responsibility between the supplier and user but often, either the supplier or the user will provide and/or meet most or even all of the requirements of clause 8.
- 9) Setup, operation and maintenance – The user is generally responsible for the requirements of clause 9, with possible assistance from the supplier for training.

# *American National Standard – Safety Requirements for Pipe, Tube, and Shape Bending Machines*

## **STANDARDS REQUIREMENTS**

### **1 Scope**

The requirements of this standard apply to any power-driven machine designed for bending pipe, tube, and shapes by means of bending dies, clamp dies, pressure dies, mandrels, wiper dies, vertical bending punches, radius dies, wing dies, and associated tooling.

NOTE - In the context of this standard, machine refers to pipe, tube, and shape bending machines.

#### **1.1 Applications**

The requirements of this standard apply to:

- Vertical hydraulic benders;
- Horizontal hydraulic benders;
- Horizontal mechanical benders;
- Horizontal or vertical combination hydraulic and mechanical benders and combination pneumatic and mechanical benders;
- Compression benders;
- Draw benders;
- Pipe benders;
- Stretch benders;
- Tube benders.

#### **1.2 Exclusions**

The requirements of this standard do not apply to:

- Bench presses;
- Hydro forming;
- Forging presses;
- Four-slide machines;
- Hydraulic presses;
- Mechanical presses;
- Power press brakes;
- Roll benders;
- Roll formers;
- Assembly machines.

## **EXPLANATORY INFORMATION**

(Not part of the requirements of American National Standard for Machines – Safety Requirements for Manual Turning Machines with or without Automatic Control - ANSI B11.15-2001 R2020)

### **E1**

For examples of bending applications, see Figure 1.