



BSI Standards Publication

Woodworking machines — Safety

Part 15: Presses

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National foreword

This British Standard is the UK implementation of EN ISO 19085-15:2021. It is identical to ISO 19085-15:2021.

The UK participation in its preparation was entrusted to Technical Committee MTE/23, Woodworking machines.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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UK Government is responsible for legislation. For information on legislation and policies relating to that legislation, consult the relevant pages of www.gov.uk.

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 May 2022.

Amendments/corrigenda issued since publication

Date	Text affected
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EUROPÄISCHE NORM

November 2021

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English Version

Woodworking machines - Safety - Part 15: Presses (ISO 19085-15:2021)

Machines à bois - Sécurité - Partie 15: Presses (ISO 19085-15:2021)

Holzbearbeitungsmaschinen - Sicherheit - Teil 15: Pressen (ISO 19085-15:2021)

This European Standard was approved by CEN on 4 September 2021.

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-CENELEC Management Centre or to any CEN member.

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European foreword

This document (EN ISO 19085-15:2021) has been prepared by Technical Committee ISO/TC 39 "Machine tools" in collaboration with Technical Committee CEN/TC 142 "Woodworking machines - Safety" the secretariat of which is held by UNI.

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of an identical text or by endorsement, at the latest by May 2022, and conflicting national standards shall be withdrawn at the latest by May 2022.

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

This document has been prepared under a Standardization Request given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s) / Regulation(s).

For the relationship with EU Directive(s) / Regulation(s), see informative Annex ZA, which is an integral part of this document.

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

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, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 19085-15:2021 has been approved by CEN as EN ISO 19085-15:2021 without any modification.

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Annex ZA (informative)

Relationship between this European Standard and the essential requirements of EU Directive 2006/42/EC aimed to be covered

This European Standard has been prepared under a Commission's standardization request "M/396 Mandate to CEN and CENELEC for standardisation in the field of machinery" to provide one voluntary means of conforming to essential requirements of Directive 2006/42/EC of the European Parliament and of the Council of 17 May 2006 on machinery, and amending Directive 95/16/EC (recast).

Once this standard is cited in the Official Journal of the European Union under that Directive, compliance with the normative clauses of this standard given in Table ZA.1 confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding essential requirements of that Directive, and associated EFTA regulations.

Table ZA.1 — Correspondence between this European Standard and Directive 2006/42/EC

The relevant Essential Requirements (ERs) of Directive 2006/42/EC	Clause(s)/sub-clause(s) of this EN	Remarks/Notes
1.1.2 Principles of safety integration		
a) fitted for its function	Clauses 5, 6, 7, 8	
c) intended use and reasonably foreseeable misuse	Clauses 5, 6, 7, 8	
d) constraints in use	7.5, 8.3	
e) equipment	6.1, 8.3	
1.1.4 Lighting	7.6, 8.3	
1.1.5 Design of machinery to facilitate its handling	7.5	
1.1.6 Ergonomics	7.5	
1.2.1 Safety and reliability of control systems	5.1, 7.7, 7.8	
1.2.2 Control devices	5.2, 5.3, 5.4	
1.2.3 Starting	5.3	
1.2.4.1 Normal stop	5.4.2	
1.2.4.3 Emergency stop	5.4.4	
1.2.6 Failure of the power supply	5.8, 7.7, 7.8	
1.3.1 Risk of loss of stability	6.1, 8.3	
1.3.2 Risk of break-up during operation	7.8, 8.3	
1.3.3 Risks due to falling or ejected objects	6.5, 8.3	
1.3.7 Risks related to moving parts	6.5, 6.6, 6.7, 8.3	
1.3.8.1 Moving transmission parts	6.6.1, 6.6.3, 6.6.4, 6.7	
1.3.8.2 Moving parts involved in the process	6.6.1	

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1.3.9 Risk of uncontrolled movements	6.1.1	
1.4.1 General requirements	6.5.1 6.5.2, 7.4.1	
1.4.2.1 Fixed guards	6.5.1	
1.4.2.2 Interlocking movable guards	6.5.2	
1.4.3 Special requirements for protective devices	6.5.3, 6.5.4, 6.5.5, 6.5.6	
1.5.1 Electricity supply	7.4, 7.13	
1.5.2 Static electricity	7.4.1	
1.5.3 Energy supply other than electricity	7.7, 7.8	
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1.5.11 External radiation	7.9	
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1.6.4 Operator intervention	7.14, 8.3	
1.6.5 Cleaning of internal parts	7.14, 8.3	
1.7.1 Information and warnings on the machinery	8.1, 8.2	
1.7.2 Warning devices	8.1	
1.7.3 Marking of machinery	8.2	
1.7.4 Instructions		
1.7.4.1 General principles for the drafting of instructions	8.3	
1.7.4.2 Contents of the instructions	8.3, Annex E	
1.7.4.3 Sales literature	Annex E, E.8.1	
2.3 Machinery for working wood and analogous materials		
a) guiding	6.10	

WARNING 1 — Presumption of conformity stays valid only as long as a reference to this European Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

WARNING 2 — Other Union legislation may be applicable to the product(s) falling within the scope of this standard.

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 4, *Woodworking machines*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 142, *Woodworking machines - Safety*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

This document is intended to be used in conjunction with ISO 19085-1:2017¹⁾, which gives requirements common to the different machine types.

A list of all parts in the ISO 19085 series can be found on the ISO website.

1) This document refers to ISO 19085-1:2017 because it experienced delays in preparation. A new edition of this document is under preparation, which refers to ISO 19085-1:2021.

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Introduction

The ISO 19085 series of International Standards provides technical safety requirements for the design and construction of woodworking machinery. It concerns designers, manufacturers, suppliers and importers of the machines specified in the Scope. It also includes a list of informative items to be provided the user by the manufacturer.

This document is a type-C standard as stated in ISO 12100.

This document is of relevance, in particular, for the following stakeholder groups representing the market players with regard to machinery safety:

- machine manufacturers (small, medium and large enterprises);
- health and safety bodies (regulators, accident prevention organisations, market surveillance etc.)

Others can be affected by the level of machinery safety achieved with the means of the document by the above-mentioned stakeholder groups:

- machine users/employers (small, medium and large enterprises);
- machine users/employees (e.g. trade unions, organizations for people with special needs);
- service providers, e. g. for maintenance (small, medium and large enterprises);
- consumers (in case of machinery intended for use by consumers).

The above-mentioned stakeholder groups have been given the possibility to participate at the drafting process of this document.

The machinery concerned and the extent to which hazards, hazardous situations or hazardous events are covered are indicated in the Scope of this document.

When requirements of this type-C standard are different from those which are stated in type-A or type-B standards, the requirements of this type-C standard take precedence over the requirements of the other standards for machines that have been designed and built according to the requirements of this type-C standard.

The full set of requirements for a particular type of woodworking machine are those given in the part of ISO 19085 applicable to that type, together with the relevant requirements from ISO 19085-1:2017, to the extent specified in the Scope of the applicable part of ISO 19085.

As far as possible, in parts of ISO 19085 other than ISO 19085-1:2017, safety requirements are referenced to the relevant sections of ISO 19085-1:2017, to avoid repetition and reduce their length. The other parts contain replacements and additions to the common requirements given in ISO 19085-1:2017.

Thus, [Clauses 5, 6, 7 and 8](#) with their subclauses and the annexes of this document can either

- confirm as a whole,
- confirm with additions,
- exclude in total, or
- replace with specific text

the corresponding subclauses or annexes of ISO 19085-1:2017.

This interrelation is indicated in the first paragraph of each subclause or annex right after the title by one of the following possible statements:

- "ISO 19085-1:2017, [subclause/Annex], applies";

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- “ISO 19085-1:2017, [subclause/Annex], applies with the following additions.” or “ISO 19085-1:2017, [subclause/Annex], applies with the following additions, subdivided into further specific subclauses.”;
- “ISO 19085-1:2017, [subclause/Annex], does not apply.”;
- “ISO 19085-1:2017, [subclause/Annex], is replaced by the following text.” or “ISO 19085-1:2017, [subclause/Annex], is replaced by the following text, subdivided into further specific subclauses.”.

Specific subclauses and annexes in this document without correspondent in ISO 19085-1:2017 are indicated by the introductory sentence: “Subclause/Annex specific to this document.”.

[Clauses 1, 2](#) and [4](#) replace the corresponding clauses of ISO 19085-1:2017, with no need for indication since they are specific to each part of the series.

This document refers to ISO 19085-1:2017 because it experienced delays in preparation. A new edition of this document is under preparation, which refers to ISO 19085-1:2021.

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Woodworking machines — Safety —

Part 15: Presses

1 Scope

This document gives the safety requirements and measures for stationary manually loaded and unloaded:

- cold presses;
- hot presses;
- bending presses;
- edge/face gluing presses;
- membrane presses;
- embossing presses;

where the pressing force is applied by hydraulic actuators pushing two flat or shaped surfaces against each other, hereinafter referred to as "machines".

It deals with all significant hazards, hazardous situations and events as listed in [Clause 4](#) relevant to machines, when operated, adjusted and maintained as intended and under the conditions foreseen by the manufacturer including reasonably foreseeable misuse. Also, transport, assembly, dismantling, disabling and scrapping phases are taken into account.

NOTE For relevant but not significant hazards, e.g. sharp edges of the machine frame, see ISO 12100:2010.

It is also applicable to machines fitted with one or more of the following devices/additional working units, whose hazards have been dealt with:

- a) device for hot gluing;
- b) device for high-frequency gluing;
- c) device for high-frequency shaping;
- d) automatic work-piece loading and unloading system;
- e) intermediate additional platens;
- f) work-piece extractor;
- g) work-piece clamping pressure beam;
- h) split moveable platens.

The machines are designed to process work-pieces consisting of:

- 1) solid wood;
- 2) materials with similar characteristics to wood (see ISO 19085-1:2017, 3.2);
- 3) honeycomb board.