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**Hand-held non-electric power tools - Safety requirements - Part 1: Assembly power tools for non-threaded mechanical fasteners**

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Handgehaltene nicht-elektrisch betriebene Maschinen - Sicherheitsanforderungen - Teil 1: Maschinen für gewindelose mechanische Befestigungen

Machines portatives a moteur non électrique - Prescriptions de sécurité - Partie 1: Machines portatives de pose d'éléments de fixation non-filetés

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Hand-held non-electric power tools - Safety requirements - Part  
1: Assembly power tools for non-threaded mechanical fasteners

Machines portatives à moteur non électrique - Prescriptions  
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gewindelose mechanische Befestigungen

This European Standard was approved by CEN on 26 May 2000.

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 Central Secretariat 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 Central Secretariat has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## Foreword

This European Standard has been prepared by Technical Committee CEN/TC 255 "Hand-held, non electric power tools - Safety ", the secretariat of which is held by SIS.

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of an identical text or by endorsement, at the latest by December 2000 and conflicting national standards shall be withdrawn at the latest by December 2000.

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

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

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

The standard has been created in close co-operation with CENELEC/TC 61F with the aim of achieving requirements for mechanical safety in the EN 50 144 series, which are similar for hand-held electric and non-electric power tools.

The annexes to this part of the standard are:

Annex A (informative) Examples of power tools covered by this part

Annex B (informative) Labels, signs and tags

Annex ZA (informative) Clauses of this European Standard addressing essential requirements or other provisions of EU Directives.

This standard also contains a Bibliography.

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## 0 Introduction

This European standard is a type C standard as stated in EN 1070.

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

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

The European Standard, EN 792, consists of a number of independent parts for individual types of hand-held non-electric power tools.

Other EN standards deal with safety rules for hand-held power tools used in e. g. the following fields:

- agriculture and forestry such as chain saws, hedge-trimmers, brush cutters, grass trimmers
- construction and building such as cutting-off power tools, concrete vibrators
- food industry, such as fowl secateurs, sheep shears.

Endeavours have been made to achieve co-ordination with the relevant Technical Committees so that the safety requirements are compatible.

This standard is divided in the following parts:

- Part 1 - Assembly power tools for non-threaded mechanical fasteners ( former part 14)
- Part 2 - Cutting-off and crimping power tools (former part 15)
- Part 3 - Drills and tappers
- Part 4 - Non-rotary percussive power tools
- Part 5 - Rotary, percussive power drills
- Part 6 - Assembly power tools for threaded fasteners
- Part 7 - Grinders
- Part 8 - Sanders and polishers
- Part 9 - Die grinders
- Part 10 - Compression power tools
- Part 11 - Nibblers and shears
- Part 12 - Small circular, small oscillating and reciprocating saws
- Part 13 - Fastener driving tools

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Certain parts of EN 792 cover hand-held non-electric power tools, driven by internal combustion engines powered by gaseous or liquid fuel. In these parts, the safety aspects relating to internal combustion engines are found in a normative annex.

The parts are type C standards and refer to pertinent European Standards of type A and B where such standards are applicable.

## 1 Scope

The standard EN 792 applies to hand-held non-electric power tools driven by rotary or linear motors, powered by compressed air, hydraulic fluid and intended to be used by one operator and supported by:

- the operator's hand or hands
- a harness
- a suspension, e. g. a balancer.

This part, EN 792-1, applies to hand-held non-electric power tools for the installation, tightening or removal of both break stem and non-break stem rivets, bolts, plugs and fasteners from one side of a workpiece into metals, plastics and other materials.

This part lists the significant hazards caused by such power tools and specifies safety requirements valid for different aspects of safety during their foreseeable lifetime.

Power tools covered by this part of the standard:

- breakstem fastener, rivet or plug tools
- breakstem lockbolt tools
- mandrel loaded riveting tools
- rivet nut setter

Special requirements and modifications on a hand-held power tool for the purpose of mounting it in a fixture are not covered by this part.

*NOTE: At the date of publication no power tools driven by internal combustion engines are known.*

## 2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of the publications referred to in this European Standard are valid only when they are incorporated in this standard by amendment or revision. For undated references the latest edition of the publication referred to, applies (including amendments).

EN 292-1:1991	Safety of machinery - Basic concepts, general principles for design - Part 1: Basic terminology, methodology
EN 292-2:1991	Safety of machinery - Basic concepts, general principles for design - Part 2: Technical principles and specifications
EN 563	Safety of machinery - Temperatures of touchable surfaces - Ergonomics data to establish temperature limit values for hot surfaces
EN 614-1	Safety of machinery - Ergonomic design principles Part 1: Terminology and general principles
EN 1070	Safety of machinery - Terminology



EN 12096	Mechanical vibration - Declaration and verification of vibration emission values
EN ISO 4871	Acoustics - Declaration and verification of noise emission values of machinery and equipment (ISO 4871:1996)
prEN ISO 15744 :1999	Hand held non-electric power tools – Noise measurement code - Engineering method (grade 2) (ISO/DIS 15744:1999)
EN 28662-1	Hand-held portable power tools - Measurement of vibrations at the handle - Part 1: General (ISO 8662-1:1988)
ISO 3857-3	Compressors, pneumatic tools and machines - Vocabulary Part 3: Pneumatic tools and machines.
ISO 5391	Pneumatic tools and machines - Vocabulary

### 3 Terms and definitions

For the purposes of this part of the standard, the following terms and definitions apply:

#### 3.1 General terms and definitions

**3.1.1 hand-held power tool:** Machine driven by rotary or linear motors powered by compressed air, hydraulic fluid, gaseous or liquid fuel, electricity or stored energy (e.g. by a spring) to do mechanical work and so designed that the motor and the mechanism form an assembly that can easily be brought to its place of operation. The hand-held power tool is operated by one or two hands.

*NOTE: Hand-held power tools driven by compressed air or gas are called pneumatic tools. Hand-held power tools driven by hydraulic liquid are called hydraulic tools.*

**3.1.2 inserted tool:** Tool inserted in the hand-held power tool to perform the intended work.

**3.1.3 service tool:** Tool intended for performing maintenance or service on the hand-held power tool.

**3.1.4 control device:** Device to start and stop the hand-held power tool or to change the direction of the rotation or to control the functional characteristics such as speed and power.

**3.1.5 maximum operating pressure:** Maximum pressure that a hand-held power tool may be operated at, as specified by the manufacturer.

#### 3.2 Terms and definitions related to assembly power tools for non-threaded mechanical fasteners

**3.2.1 assembly tool for non-threaded mechanical fasteners:** Power tool with an axial displacement, for the purposes of installing or tightening fasteners, such as breakstem fasteners, plugs or rivets, from one side of a work piece.



**3.2.2 break stem lockbolt tool:** Power tool with an axial displacement, fastener stem gripping and lockbolt collar swaging device for the installation, tightening or removing of lockbolts whereby the retaining lockbolt collar may be permanent or removable.

**3.2.3 mandrel loaded riveting tool:** Power tool with an axial displacement cylinder or cylinders with means to grip a mandrel onto which hollow rivets or fasteners are loaded either singly or in quantity. Mandrels feature an enlarged head which, when displaced through the fastener, cause it to clench and expand in the workpiece.

**3.2.4 blind riveter:** Power tool for installing fasteners with breakstems.

For other terms, see EN 1070 and also ISO 3857-3 and ISO 5391.  
For examples of assembly power tools see annex A.

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## 4 List of hazards

The following hazards can occur in the use of assembly power tools.

Hazard type	Reference to safety requirement	
	By design or guarding	Information for use
<b>4.1 Mechanical hazards</b> - cutting - drawing in or trapping (caused by hair, clothing etc. getting entangled in a rotating power tool) - friction or abrasion hazard - whipping hose - ejection from high pressure hydraulic systems - ejection of parts - loss of stability - hose and hose coupling specifications	5.1.1  5.1.1  5.1.4 5.1.3 5.1.2	6.2.2  6.2.2  6.2.2
<b>4.2 Electrical hazards</b>		6.2.2
<b>4.3 Thermal hazards</b> - explosions - health damage due to hot or cold surfaces	5.2 5.2	
<b>4.4 Hazards caused by noise</b>	5.3	6.2.2
<b>4.5 Hazards generated by vibration</b>	5.4	6.2.2
<b>4.6 Hazards generated by materials and substances processed, used or exhausted</b> - inhalation of harmful dust - exhaust air - lubricants - hydraulic fluid	5.5.1 5.5.1 5.5.2	6.2.2
<b>4.7 Hazards caused by neglecting ergonomic principles</b> - repetitive strain injuries - unsuitable postures - inadequate grip design and tool balance - neglected use of personal protection equipment	5.6.1, 5.6.2, 5.6.3  5.6.1	6.2.2  6.2.2
<b>4.8 Hazards caused by failure of energy supply</b> - unexpected return of energy supply after a breakdown - incorrect hydraulic fluid flow and outlet pressure		6.2.2 6.2.2
<b>4.9 Hazards caused by missing and/or incorrectly positioned safety related means</b> - start and stop device - unintentional start	5.7.1 5.7.2	6.2.2

## 5 Safety requirements and measures

### 5.1 Mechanical safety

#### 5.1.1 Surfaces, edges and corners

Accessible parts of power tools, except the inserted tool, shall not have sharp edges or angles or rough or abrasive surfaces, see 3.1 of EN 292-2:1991.

#### 5.1.2 Supporting surface and stability

Power tools shall be so designed that they can be laid aside and remain in stable position on a plane surface.

#### 5.1.3 Collection of ejected stems

Bottles and/or deflectors shall be fitted to the rear of blind riveters and break stem lockbolt tools to either collect or deflect stems in such a way that their forcible ejection does not cause operator injury.

#### 5.1.4 High pressure ejection

Hydraulic systems of the power tool shall be enclosed so as to give protection against high pressure fluid ejection.

### 5.2 Thermal safety

Surface temperatures of parts of the power tool which are held during use or could be inadvertently touched shall follow the provisions of EN 563.

*NOTE 1: The limit values for low temperatures are studied by CEN/TC 122.*

Power tools for use in potentially explosive atmospheres should comply with EN 1127-1. However because the suitability of a power tool for use in potentially explosive atmospheres will depend not only on the power tool but the inserted tool and the workpiece, it is not possible to give any detailed advice in this standard.

### 5.3 Noise

#### 5.3.1 General

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The emission of noise from a hand-held power tool shall be kept as low as possible.

The noise emission from using hand-held power tools emanates from three main sources:

- the hand-held power tool itself
- the inserted tool
- the workpiece.

*NOTE: Generally, the manufacturer has no possibility of influencing the noise emitted by the processed workpiece.*