



**SLOVENSKI STANDARD**  
**SIST EN 12717:2002+A1:2009**  
**01-maj-2009**

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**Varnost obdelovalnih strojev - Vrtalni stroji**

Safety of machine tools - Drilling machines

Sicherheit von Werkzeugmaschinen - Bohrmaschinen

Sécurité des machines-outils - Perceuses

**Ta slovenski standard je istoveten z: EN 12717:2001+A1:2009**

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**ICS:**

25.080.40      Vrtalniki      Drilling machines

**SIST EN 12717:2002+A1:2009**      en,fr

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 12717:2001+A1**

February 2009

ICS 25.080.40

Supersedes EN 12717:2001

English Version

## Safety of machine tools - Drilling machines

Sécurité des machines-outils - Perceuses

Sicherheit von Werkzeugmaschinen - Bohrmaschinen

This European Standard was approved by CEN on 7 March 2001 and includes Amendment 1 approved by CEN on 29 December 2008.

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## Foreword

This document (EN 12717:2001+A1:2009) has been prepared by Technical Committee CEN/TC 143 "Machine tools - Safety", the secretariat of which is held by SNV.

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of an identical text or by endorsement, at the latest by August 2009, and conflicting national standards shall be withdrawn at the latest by December 2009.

This document includes Amendment 1, approved by CEN on 2008-12-29.

This document supersedes EN 12717:2001.

The start and finish of text introduced or altered by amendment is indicated in the text by tags  $\square_{A1}$   $\square_{A1}$ .

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 EC Directive(s).

This standard has been prepared to provide one means of conforming with the essential requirements of the Machinery Directive and associated EFTA regulations.

$\square_{A1}$  Annexes A, ZA and ZB are informative. Annex B is normative.  $\square_{A1}$  This European Standard also contains a Bibliography.

$\square_{A1}$  For relationship with EC Directive(s), see informative Annexes ZA and ZB, which are integral parts of this document.  $\square_{A1}$

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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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

**EN 12717:2001+A1:2009 (E)****Introduction**

This European standard is a type C standard as stated in EN 292–1.

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.

Drilling machines present a wide range of hazards, not least from their wide application as rotating tool, 'stationary' workpiece machine tools, for general purpose cutting of cold metal work material.

Protection of operators and other persons from contact with moving cutting tools, especially when being rapidly rotated in the spindle or from contact with fast–moving workpieces, is of great importance.

When power–operated mechanisms are provided for workpiece transfer, they can also create hazardous situations during loading/unloading and workpiece alignment or clamping.

On automatic drilling machines, total enclosure of the work zone using guards during cutting is the preferred method of safeguarding. Where this is not practicable (e.g. due to size of the workpiece, its geometry, or its special characteristics), operators may be safeguarded by other means (e.g. perimeter fencing, protective devices at the operating position). Operators may also benefit from pendant controls, which enable them to move about the machine.

The significant hazards covered by this standard are those listed in clause 4. The safety requirements and/or protective measures to prevent or minimize those hazards identified in table 1 and procedures for verification of these requirements or measures are found in clause 5.

The figures in annex A are examples only and are not intended to illustrate the only interpretation of the text.

**1 Scope**

**1.1** This standard specifies the technical safety requirements and measures to be adopted by persons undertaking the design, construction and supply (including installation and dismantling, with arrangements for transport and maintenance) of stationary drilling machines (see 3.1).

This standard covers both manual and automatic drilling machines. These include but are not limited to:

- pedestal drilling machines (see figure A.1);
- radial arm drilling machines (see figure A.2);
- coordinate table drilling machines (see figure A.3);
- horizontal spindle drilling machines (see figure A.4);
- multi–spindle drilling machines (see figure A.5)
- turret type drilling machines with manual control of turret index.

**1.2** This standard takes account of intended use including reasonably foreseeable misuse, maintenance, cleaning, and setting operations. It presumes access to the machine from all directions. It describes means to reduce risks to operators and other exposed persons.

**1.3** This standard also applies to workpiece transfer devices when they form an integral part of the machine.

**1.4** This standard deals with significant hazards relevant to drilling machines when they are used as intended and under the conditions foreseen by the manufacturer (see clause 4).

**1.5** Hazards arising from other metal working processes (e.g. milling, grinding, turning, forming, EDM, laser processing) are covered by other standards (see Bibliography).

**1.6** Automatic drilling machines with automatic tool changing capabilities are not covered by this standard (see prEN 12417:1996).

**1.7** This standard is not applicable to drilling machines, which were manufactured before the date of publication by CEN of this standard.

## 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 these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 292-1:1991 and EN 292-2/A1:1995, *Safety of machinery – Basic concepts, general principles for design – Part 1: Basic terminology, methodology*  
<https://standards.gost.org/catalog/standards/sist/f6146ea8-d4bc-4ef6-844b-894044a324ed/sist-en-12717-2002a1-2009>

EN 292-2:1991, *Safety of machinery - Basic concepts, general principles for design – Part 2: Technical principles and specifications*

EN 294:1992, *Safety of machinery – Safety distances to prevent danger zones being reached by the upper limbs*

EN 349, *Safety of machinery – Minimum gaps to avoid crushing of parts of the human body*

EN 457, *Safety of machinery - Auditory danger signals - General requirements, design and testing (ISO 7731:1986 modified)*

EN 574, *Safety of machinery - Two hand control devices – Functional aspects – Principles for design*

EN 614, *Safety of machinery - Ergonomic design principles – Part 1: Terminology and general principles  
Part 2: Interaction between machinery design and work tasks*

EN 626, *Safety of machinery – Reduction of risks to health from hazardous substances emitted by machinery*

EN 894:1997, *Safety of machinery –Ergonomics requirements and data for the design of displays and control actuators – Part 1: Human interactions  
Part 2: Displays*

EN 894:2000, *Part 3: Control actuators*

EN 953:1997, *Safety of machinery – Guards – General requirements for the design and construction of fixed and movable guards*

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- EN 954-1, *Safety of machinery - Safety-related parts of control systems – Part I: General principles for design*
- EN 982:1996, *Safety of machinery - Safety requirements for fluid power systems and their components - Hydraulics*
- EN 983:1996, *Safety of machinery - Safety requirements for fluid power systems and their components - Pneumatics*
- EN 999, *Safety of machinery – The positioning of protective equipment in respect of approach speeds of parts of the human body*
- prEN 1005:1998, *Safety of machinery – Human physical performance –*  
*Part 1: Terms and definitions*  
*Part 2: Manual handling of heavy weights associated with machinery*  
*Part 3: Recommended force limits for machinery operation*
- EN 1037:1995, *Safety of machinery – Prevention of unexpected start-up*
- EN 1050:1996, *Safety of machinery - Principles for risk assessment*
- EN 1088:1995, *Safety of machinery - Interlocking devices associated with guards – Principles for design and selection*
- EN 1127–1:1997, *Explosive atmospheres - Explosion prevention and protection – Part 1: Basic concepts and methodology*
- EN 1760–1:1997, *Safety of machinery - Pressure sensitive protective devices – Part 1: General principles for the design and testing of pressure sensitive mats and pressure sensitive floors*
- EN 1837, *Safety of machinery – Integral lighting of machines*
- EN ISO 3744:1995, *Acoustics – Determination of sound power level of noise sources using sound pressure – Engineering method in an essentially free field over a reflecting plane*
- EN ISO 3746:1995, *Acoustics – Determination of sound power level of noise sources using sound pressure – Survey method using an enveloping measurement surface over a reflecting plane*
- EN ISO 4871, *Acoustics – Declaration and verification of noise emission values of machinery and equipment*
- EN ISO 9614-1:1995, *Acoustics – Determination of sound power level of noise sources using sound intensity – Part 1: Measurement at discrete points*
- EN ISO 11202:1995, *Acoustics – Noise emitted by machinery and equipment – Measurement method of emission sound power levels at the work station and at other specified positions – Survey method in situ*
- EN ISO 11204:1995, *Acoustics - Noise emitted by machinery and equipment – Method requiring environmental corrections*
- EN ISO 14122, *Permanent means of access to machines and industrial plants*  
*Part 2: Working platforms and gangways*  
*Part 3: Stairways, stepladders and guard-rails*
- prEN 13478:1999, *Safety of machinery - Fire prevention and protection*
- EN ISO 11688-1, *Acoustics – Recommended practice for the design of low-noise machinery and equipment - Part 1: Planning*
- ISO/TR 11688-2:1998, *Acoustics – Recommended practice for the design of low-noise machinery and equipment - Part 2: Introduction to the physics of low-noise design*



EN 60204-1:1997, *Safety of machinery - Electrical equipment of machines - Part 1: General requirements*

EN 60529:1991, *Degrees of protection provided by enclosures (IP Code)*

EN 61496-1:1997, *Safety of machinery - Electrosensitive protective equipment – Part 1: General requirements and tests*

IEC 61496-2, *Safety of machinery – Electro-sensitive protective equipment – Part 2: Particular requirements for equipment using active opto-electronic protective devices (AOPDs)*

EN 50081-2, *Electromagnetic compatibility - Generic emission standard – Part 2: Industrial environment*

EN 61000-6-2, *Electromagnetic compatibility (EMC) – Part 6-2: Generic standards - Immunity for industrial environments (IEC 61000-6-2:1999)*

### 3 Terms and definitions

For the purposes of this standard, the following terms and definitions apply. For other terms and definitions, see EN 292–1, EN 292–2/A1.

#### 3.1

##### **drilling machine**

a machine designed to produce holes in cold metal by the use of a rotating cutting tool

#### 3.1.1

##### **manual drilling machine**

a machine where the axial motion of the cutting tool is controlled through the actuation of a handwheel or lever (may include powered axial feed or powered unprogrammed positioning of spindle or workpiece)

#### 3.1.2

##### **automatic drilling machine**

a machine with the capability to perform programmed multiple position drilling operations

#### 3.2

##### **workpiece transfer device**

a mechanism integrated with the machine as a means of supplying a previously loaded workpiece to a machine in exchange for a finished workpiece (e.g. pallet changing device)

#### 3.3

##### **work zone**

the space where the metal cutting process can take place

#### 3.4

##### **electronic handwheel**

a manually operated control device which initiates and maintains an axis movement by pulse generation input to the numerical control during its rotation

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**EN 12717:2001+A1:2009 (E)****4 List of significant hazards**

**4.1** The list of hazards contained in table 1 is the result of a hazard identification and risk assessment carried out as described by EN 1050, for the wide range of drilling machines covered by the scope of this standard. The safety requirements and/or measures and information for use contained in clauses 5 and 7 are based on the risk assessment and deal with the identified hazards by either eliminating them or reducing the effects of the risks they generate.

**4.2** The risk assessment assumes foreseeable access from all directions, as well as unexpected start-up. Risks to both the operators and other persons who can have access to the hazard zones are identified, taking into account hazards which can occur under various conditions (e.g. commissioning, set-up, production, maintenance, repair, decommissioning) during the life of the machine. The assessment includes an analysis of the effect of failure in the control system.

**4.3** In addition, the user of this standard (i.e. the designer, manufacturer, supplier) shall validate that the risk assessment is complete for the machine under consideration with particular attention to:

- the intended use of the machine including maintenance, setting and cleaning, and its reasonably foreseeable misuse;
- the identification of the significant hazards associated with the machine.

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**Table 1 — List of significant hazards and major sources of these hazards associated with drilling machines**

*	Description	Example(s) of related hazardous situation(s)	Associated activity	Related danger zone	Clause 5 Reference
<b>1</b>	<b>Mechanical hazards</b>				
1.1	Crushing	moving axes, tool clamping	setting, manual tool exchange, maintenance	between fixed and moving elements of the machine	Tables 2, 3 and 4 (1.1.1–1.4.3)
1.2	Shearing	moving axes	manual operation	between tool/ spindle and table/ workpiece	
1.3	Cutting or severing	tool running	drilling with hand held workpiece	work zone	
1.4	Entanglement	rotating spindle or tool	workpiece load/ unload, positional adjustment, manual swarf/chip removal, cutting fluid application	at spindle or tool	
		other rotating parts (e.g. conveyors, transmission elements)	setting, cleaning, maintenance	swarf/chip collection and discharge zones, transmission elements	
1.5	Drawing-in or trapping	rapid travel of table or spindle head	power-operated motion of workpiece on table or tool in spindle	envelope of movement of workpiece on table axes; envelope of movement of tool in spindle head	Tables 2, 3 and 4 (1.1.1–1.4.3)
		rotating power transmission mechanisms	maintenance	in or around machine	
1.6	Impact	unintended movement (rotation) of workpiece	during drilling with inadequate workpiece clamping	work zone	
		rapid movement of workpiece or spindle head, automatic workpiece transfer	during powered traverse  power-operated workpiece transfer	at machine  envelope of motion of workpiece and workpiece transfer mechanisms	
1.7	Stabbing or puncture	handling tools	during manual tool change	at sharp cutter faces	(see clause 7)
		handling swarf/chips	during loading/ unloading and cleaning	at workpiece, table, and swarf /chip collecting and discharge zones	(see clause 7)
<b>2</b>	<b>Electrical hazards</b>				
2.1	Contact of persons with live parts (direct contact)	contact with live parts or connections	during commissioning, maintenance, trouble shooting	electrical cabinet, terminal boxes, control panels at machine	2.1
2.2	Contact of persons with parts which have become live under faulty conditions (indirect contact)	contact with live parts or connections	during operation, inspection and maintenance of machine	at machine or faulty part	2.2

Table 1 (continued)

*	Description	Example(s) of related hazardous situation(s)	Associated activity	Related danger zone	Clause 5 Reference
4	<b>Hazards generated by noise</b>				
4.1	Hearing loss (deafness), other physiological disorders (e.g. loss of balance, loss of awareness)	motion of power transmission elements, cutting processes and fluid power systems	during operating cycle of machine	near machine	4.1
4.2	Interference with speech communication, acoustical signals	air blast used for cleaning of tool or workpiece locations	during operating cycle of machine	near machine	4.2
7	<b>Hazards generated by materials and substances</b>				
7.1	Hazards from contact with or inhalation of harmful fluids, gases, mists, fumes, and dusts	conditions near machine caused by ejection of particles of work material, fluid droplets or mist from metal working fluids	during operating cycle of the machine	at or near machine	7.1
7.2	Fire or explosion	flammable work material, flammable (low flash point) metal working fluids	during operating cycle of the machine	at or near machine	7.2
7.3	Biological or micro-biological (viral or bacterial) hazards	contact with hydraulic or metal working fluid as liquid or mist containing detritus and bacteria	during operation, process control, and maintenance	at or near machine	7.3
8	<b>Hazards generated by neglecting ergonomic principles in the design process</b>				
8.1	Unhealthy postures or excessive effort (repetitive strain)	lifting and reaching while handling workpiece, tools, and machine parts	during loading/unloading, process control, and maintenance	at load/unload and tool mounting positions, maintenance action points	8.1
8.2	Inadequate consideration of hand-arm or foot-leg anatomy	inappropriate location of controls	during loading/unloading, process control, and maintenance	at load/unload and tool mounting positions, maintenance action points	8.2
8.4	Inadequate local lighting	judgment and accuracy of manual actions impaired during handling/ positioning of work materials and cutters	during loading/unloading, process control, tool handling	at load/unload, tool mounting positions	8.4
8.6	Human errors, human behaviour	reasonably foreseeable misuse, inadvertent operation of controls, incorrect work material and cutter handling and setting	during loading/unloading, process control, tool handling	at load/unload, tool mounting positions	8.6
8.7	Inadequate design, location or identification of manual controls	inadvertent operation of controls	during setting, operating cycle	at or near machine	8.7
8.8	Inadequate design or location of visual display units	misinterpretation of displayed information	during setting, operating cycle	at or near machine	8.8

Table 1 (concluded)

*	Description	Example(s) of related hazardous situation(s)	Associated activity	Related danger zone	Clause 5 Reference
10	<b>Unexpected start-up, unexpected overrun/ overspeed</b>				
10.1	Failure/disorder of the control system	mechanical hazards associated with selected machine movement	during setting, cleaning	at machine	10.1
10.2	Restoration of energy supply after an interruption	unexpected movements of machine	during setting, cleaning or maintenance	at or near machine	10.2
10.3	External influences on the electrical equipment	unpredictable behaviour of electronic controls due to electromagnetic interference	during setting or operating cycle of the machine	at or near machine	10.3
13	<b>Failure of the power supply</b>	malfunctions of the control with consequent misapplication of stored energy or power. Power workholding fails, motor overspeed. Part breakage causes machine elements to move under residual forces (inertia, gravity, spring/ energy storage means) causing external elements to move unexpectedly	during operation, process control, maintenance	at machine – machine elements retained in a safe condition by the application of power or fluid pressure.	13
14	<b>Failure of the control circuit</b>	Unexpected movement of machine	During setting, cleaning or maintenance	At or near machine	14
15	<b>Errors of fitting</b>	machine elements fail or swing unexpectedly			15
17	<b>Falling or ejected objects or fluids</b>	ejection of machine parts, workpiece or tools caused by clamping device, control system failures or collision due to data errors	during machine operation	at or near machine	17
18	<b>Loss of stability, overturning of machinery</b>	unrestrained machine or machine part (maintained in position by gravity), falls or overturns	during loading/ unloading and process control, at heavy/unwielding workpieces during maintenance (disassembly/ relocation)	at machine	18
19	<b>Slip , trip, and fall of persons</b>	ejection or spillage of metal working fluids and lubricants (also hydraulic fluid if used); work at heights	during workpiece load/unload, setting, process control and maintenance work at heights work to replenish fluids (e.g. lubricants)	machine table, floor area around machine and workpiece permanent means of access to the machine	19
* This list is derived from annex A of EN 1050:1996.					