
**Woodworking machines — Safety
requirements —**

**Part 3:
Numerically controlled (NC) boring
and routing machines**

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Machines à bois — Sécurité —
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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 on 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 the following URL: www.iso.org/iso/foreword.html.

The committee responsible for this document is ISO/TC 39, *Machine tools*, Subcommittee SC 4, *Woodworking machines*.

This document is intended to be used in conjunction with ISO 19085-1:2017, which gives requirements common to different machine types.

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

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.

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.

This document is intended to be used in conjunction with ISO 19085-1:2017, which gives requirements common to the different machine types.

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

- confirm as a whole, <https://standards.iteh.ai/catalog/standards/sist/355e6166-89fc-4091-b232-a12964af26df/iso-19085-3-2017>
- 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 clause, subclause or annex, right after the title, by one of the following statements:

- “This subclause of ISO 19085-1:2017 applies”;
- “This subclause of ISO 19085-1:2017 applies with the following additions”, or “This subclause of ISO 19085-1:2017 applies with the following additions, subdivided into further specific subclauses.”;
- “This subclause of ISO 19085-1:2017 does not apply.”;
- “This subclause of ISO 19085-1:2017 is replaced by the following text.”, or “This subclause of ISO 19085-1:2017 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: "This subclause (or annex) is specific to this document."

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

NOTE Requirements for tools are given in EN 847-1:2013 and EN 847-2:2013.

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Woodworking machines — Safety requirements —

Part 3:

Numerically controlled (NC) boring and routing machines

1 Scope

This document gives the safety requirements and measures for numerically controlled (NC) boring machines, NC routing machines and NC combined boring/routing machines (as defined in [3.1](#)), hereinafter referred to as "machines".

This document deals with all significant hazards, hazardous situations and events, listed in [Clause 4](#), relevant to the machines when they are 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 have been taken into account.

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

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

- additional equipment for sawing, sanding, edge banding or assembly units and dowel devices;
- fixed or movable workpiece support;
- mechanical, pneumatic, hydraulic or vacuum workpiece clamping;
- automatic tool change facilities.

Machines covered in this document are designed for workpieces consisting of

- solid wood,
- material with similar physical characteristics to wood (see ISO 19085-1:2017, 3.2),
- gypsum boards, gypsum bounded fibreboards,
- composite materials with core consisting of polyurethane or mineral material laminated with light alloy,
- polymer-matrix composite materials and reinforced thermoplastic/thermoset/elastomeric materials, and
- composite boards made from the materials listed above.

This document does not deal with specific hazards related to

- edge-banding equipment fitted to the machines,
- use of grinding wheels,
- ejection from milling and/or sawing tools through openings guarded by curtains on machines where the distance between the workpiece support surface and the lower edge of the partial enclosure exceeds 600 mm,
- ejection due to failure of milling tools with a cutting circle diameter equal to or greater than 16 mm and sawing tools not conforming to EN 847-1:2013 and EN 847-2:2013,

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- the combination of a single machine being used with other machines (as a part of a line),
- the necessity to step onto or into the machine body due to its large size, e.g. to adjust clamping elements on machines for wooden walls, and
- integrated workpiece loading/unloading systems (e.g. robots).

This document is not applicable to single spindle hand fed or integrated fed routing machines, machines intended for use in potentially explosive atmosphere, or to machines manufactured prior to its publication.

2 Normative references

The following documents are referred to in text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2602:1980, *Statistical interpretation of test results — Estimation of the mean — Confidence interval*

ISO 4413:2010, *Hydraulic fluid power — General rules and safety requirements for systems and their components*

ISO 4414:2010, *Pneumatic fluid power — General rules and safety requirements for systems and their components*

ISO 12100:2010, *Safety of machinery — General principles for design — Risk assessment and risk reduction*

ISO 19085-1:2017, *Woodworking machines — Safety — Part 1: Common requirements*

ISO 13849-1:2015, *Safety of machinery — Safety-related parts of control systems — Part 1: General principles for design*

ISO 13856-3:2013, *Safety of machinery — Pressure-sensitive protective devices — Part 3: General principles for design and testing of pressure-sensitive bumpers, plates, wires and similar devices*

ISO 13857:2008, *Safety of machinery — Safety distances to prevent hazard zones being reached by upper and lower limbs*

EN 847-1:2013, *Tools for woodworking — Safety requirements — Part 1: Milling tools, circular saw blades*

EN 847-2:2013, *Tools for woodworking — Safety requirements — Part 2: Requirements for the shank of shank mounted milling tools*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 12100:2010, ISO 13849-1:2015, ISO 19085-1:2017 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

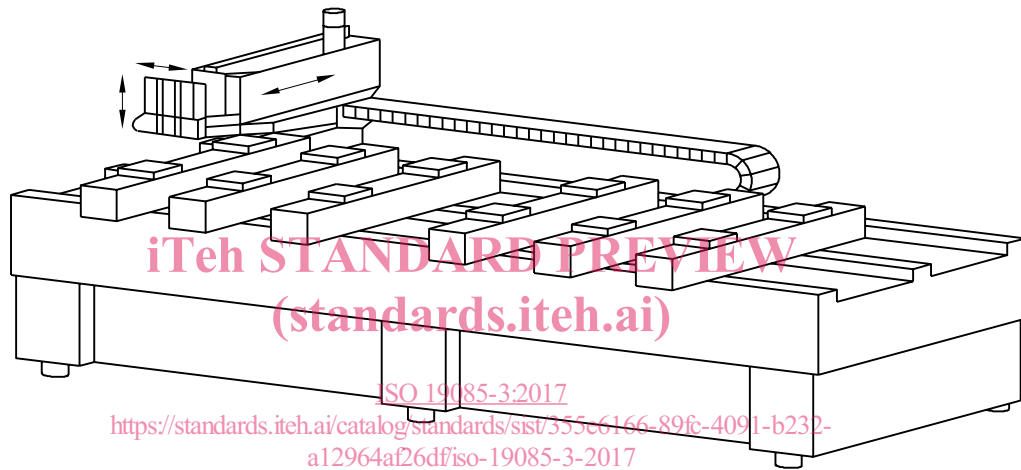
3.1 numerically controlled boring and routing machine NC boring and routing machine

integrated fed machine designed for the machining of workpieces by the use of milling and/or boring tools having at least two orthogonal axes programmable by the user (e.g. X, Y) for positioning and/or machining, where the axes operate in accordance with a NC work programme

Note 1 to entry: The machine may also be fitted with one or more of the following devices/facilities:

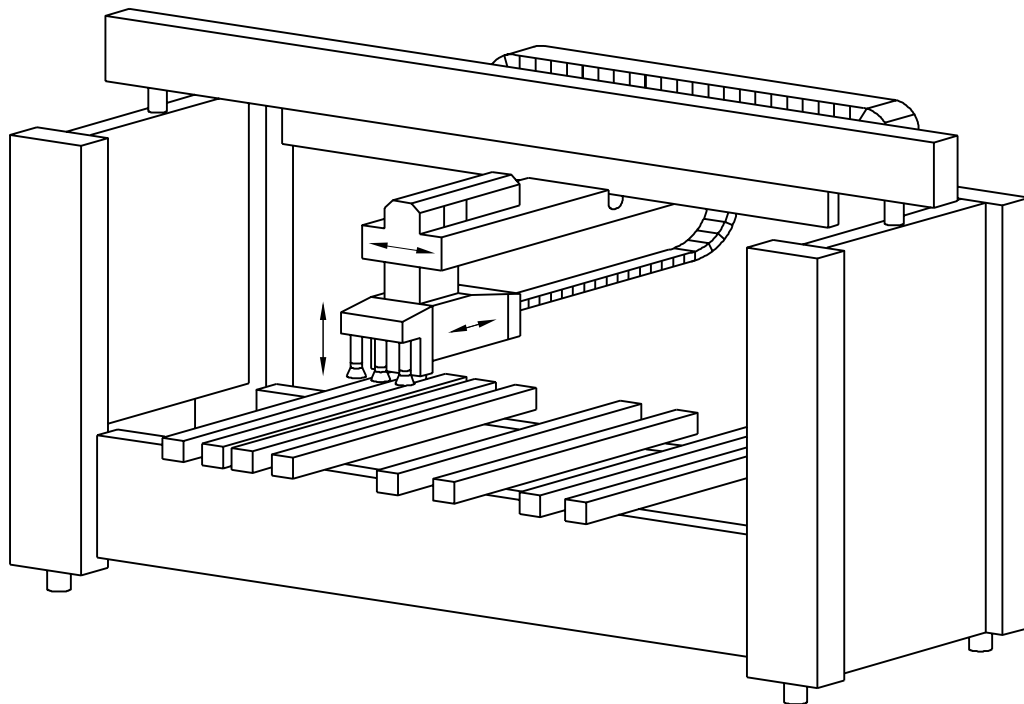
- additional equipment for sawing, sanding, edge banding or assembly units and dowel devices;
- fixed or movable workpiece support;
- mechanical, pneumatic, hydraulic or vacuum workpiece clamping;
- automatic tool change facilities.

Examples of different machine designs are illustrated in [Figures 1 to 9](#).



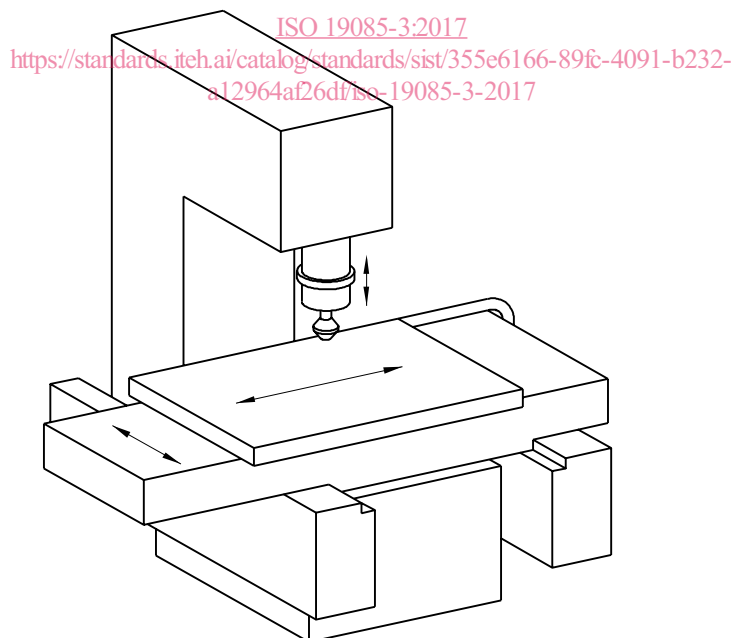
NOTE Safeguarding devices are not illustrated.

Figure 1 — Example of a C frame machine with fixed table and moveable machining head



NOTE Safeguarding devices are not illustrated.

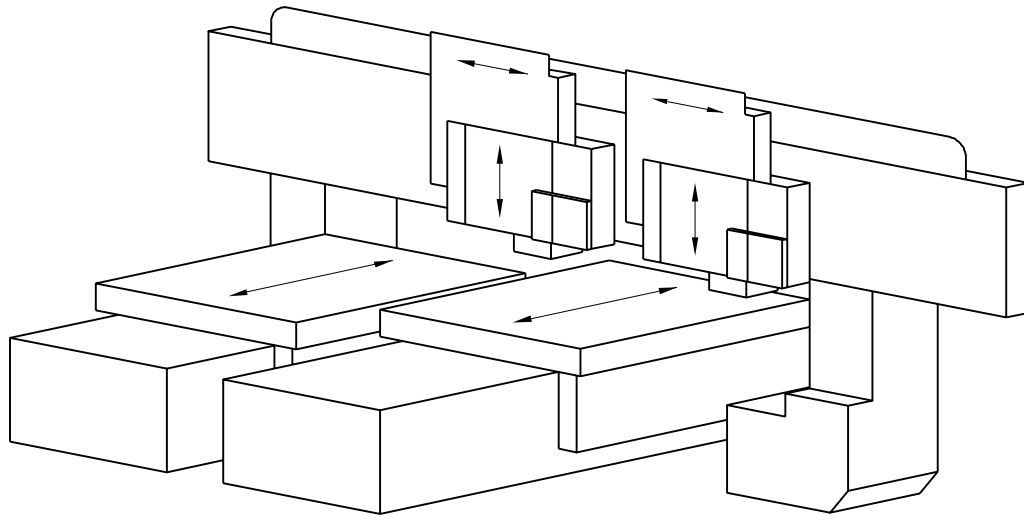
Figure 2 — Example of a portal frame machine with fixed portal, fixed table, moving machining head



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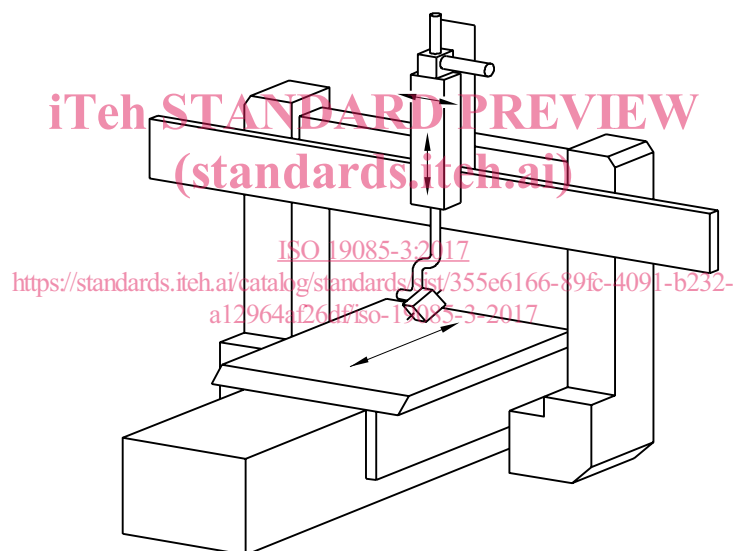
NOTE Safeguarding devices are not illustrated.

Figure 3 — Example of an overhead router with moving table



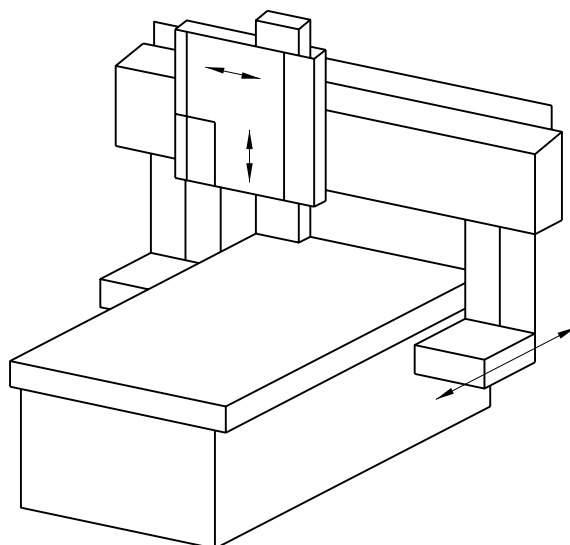
NOTE Safeguarding devices are not illustrated.

Figure 4 — Example of overhead router with moving tables, fixed portal, moving machining heads



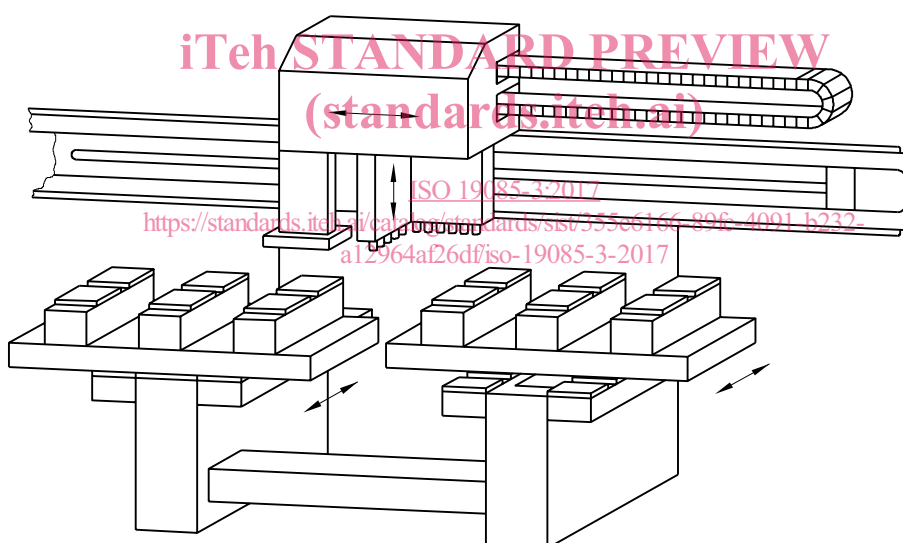
NOTE Safeguarding devices are not illustrated.

Figure 5 — Example of a machining centre with moving table, fixed portal, moving machining head



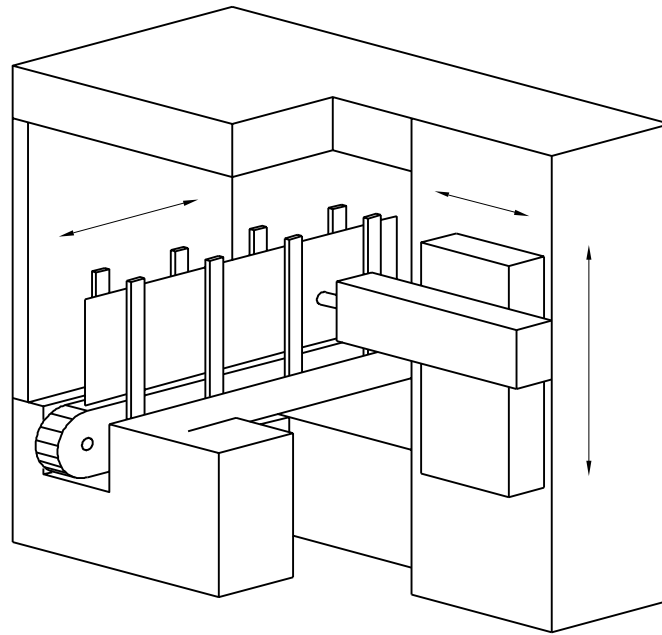
NOTE Safeguarding devices are not illustrated.

Figure 6 — Example of an overhead router with fixed table, moving portal, moving machining head



NOTE Safeguarding devices are not illustrated.

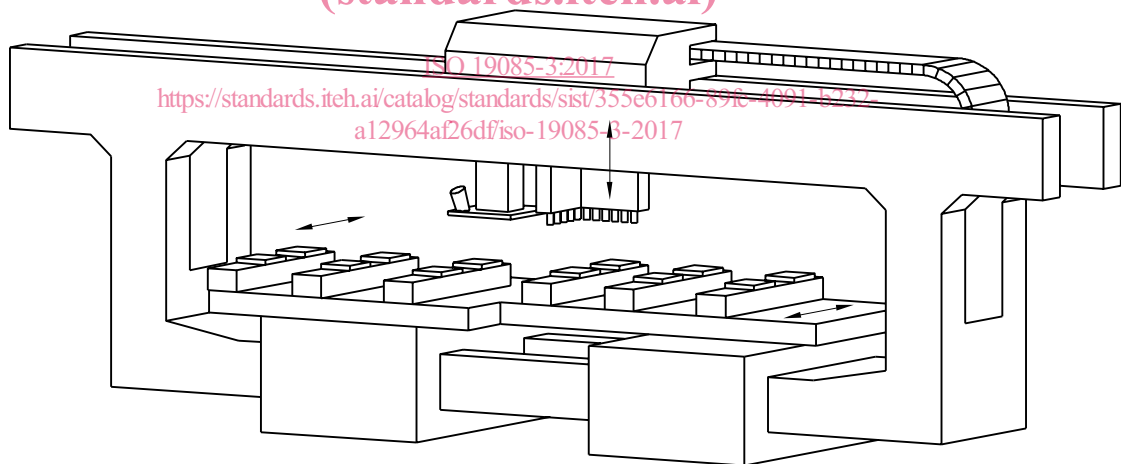
Figure 7 — Example of a C frame boring machine with moving tables, fixed portal, moving machining head



NOTE Safeguarding devices are not illustrated.

Figure 8 — Example of a vertical machine with moving support, fixed frame, moving machining head

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NOTE Safeguarding devices are not illustrated.

Figure 9 — Example of a portal frame boring machine with moving tables, fixed portal, moving machining head

3.2 control power-on

control that after activation enables providing power to machines actuators, also on a lower control level, e.g. by the PLC (Programmed Logic Control)

3.3 machining mode
MODE 1

automatic, programmed, sequential operation of the machine