
**Woodworking machines — Safety —
Part 15:
Presses**

*Machines à bois — Sécurité —
Partie 15: Presses*

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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 (standards.iteh.ai)

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.

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”;

- “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.

This document does not deal with any hazards related to:

- specific devices that differ from the list above;
- hot fluid heating systems internal to the machine other than electrical;
- any hot fluid heating systems external to the machine;
- operation of taking intermediate platens out and in again;
- the combination of a single machine being used with any other machine (as part of a line).

It is not applicable to:

- frame presses;
- membrane presses where the pressing force is applied by vacuum only;
- presses for producing chipboard, fibreboard, OSB;
- machines intended for use in potentially explosive atmosphere;
- machines manufactured before the date of its publication as an international standard.

2 Normative references

The following documents are referred to in the 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 3744:2010, *Acoustics — Determination of sound power levels and sound energy levels of noise sources using sound pressure — Engineering methods for an essentially free field over a reflecting plane*

ISO 11201:2010, *Acoustics — Noise emitted by machinery and equipment — Determination of emission sound pressure levels at a work station and at other specified positions in an essentially free field over a reflecting plane with negligible environmental corrections*

ISO 11202:2010, *Acoustics — Noise emitted by machinery and equipment — Determination of emission sound pressure levels at a work station and at other specified positions applying approximate environmental corrections*

ISO 11204:2010, *Acoustics — Noise emitted by machinery and equipment — Determination of emission sound pressure levels at a work station and at other specified positions applying accurate environmental corrections*

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

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

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

ISO/TR 11688-1:1995, *Acoustics — Recommended practice for the design of low-noise machinery and equipment — Part 1: Planning*

IEC 60204-1:2016, *Safety of machinery — Electrical equipment of machines — Part 1: General requirements*

IEC 61310-1:2007, *Safety of machinery — Indication, marking and actuation — Part 1: Requirements for visual, acoustic and tactile signals*

IEC 61800-5-2:2016, *Adjustable speed electrical power drive systems — Part 5-2: Safety requirements — Functional*

ISO 7010:2019, *Graphical symbols — Safety colours and safety signs — Registered safety signs*

EN 12198-1:2000+A1:2008, *Safety of machinery — Assessment and reduction of risks arising from radiation emitted by machinery — Part 1: General principles*

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 <https://www.electropedia.org/>

3.1

cold press

machine used to laminate and/or join together flat panels, in which the pressing force is applied by hydraulic actuators pushing two cold flat platens against each other

Note 1 to entry: The moveable platen can be the top or the bottom one or both. Examples of different machine designs are illustrated in [Figures 1](#) and [2](#) (safeguarding devices are not fully illustrated).

Note 2 to entry: The following devices can be provided:

- automatic panel loading and unloading;
- split moveable platens (see [Figure 14](#)).

3.2

hot press

machine used to laminate and/or join together flat panels, in which the pressing force is applied by hydraulic actuators pushing two hot flat platens against each other

Note 1 to entry: The moveable platen can be the top or the bottom one or both. Examples of different machine designs are illustrated in [Figures 1](#) and [2](#) (safeguarding devices are not fully illustrated).

Note 2 to entry: The following devices can be provided:

- automatic panel loading and unloading;
- intermediate additional platens (see [Figure 3](#)).

Note 3 to entry: Platens heating systems can be by electrical resistance or hot fluid (e.g. diathermic oil, water). Fluid heating system can be internal to the machine or external.

3.3

bending press

machine with manual loading and/or unloading used to assembly and/or shape flat panels, in which the pressing force is applied by hydraulic actuators pushing two shaped surfaces against each other, and hot gluing process is by hot dies or high-frequency system

Note 1 to entry: An example of a bending press is illustrated in [Figure 4](#) (safeguarding devices are not fully illustrated).

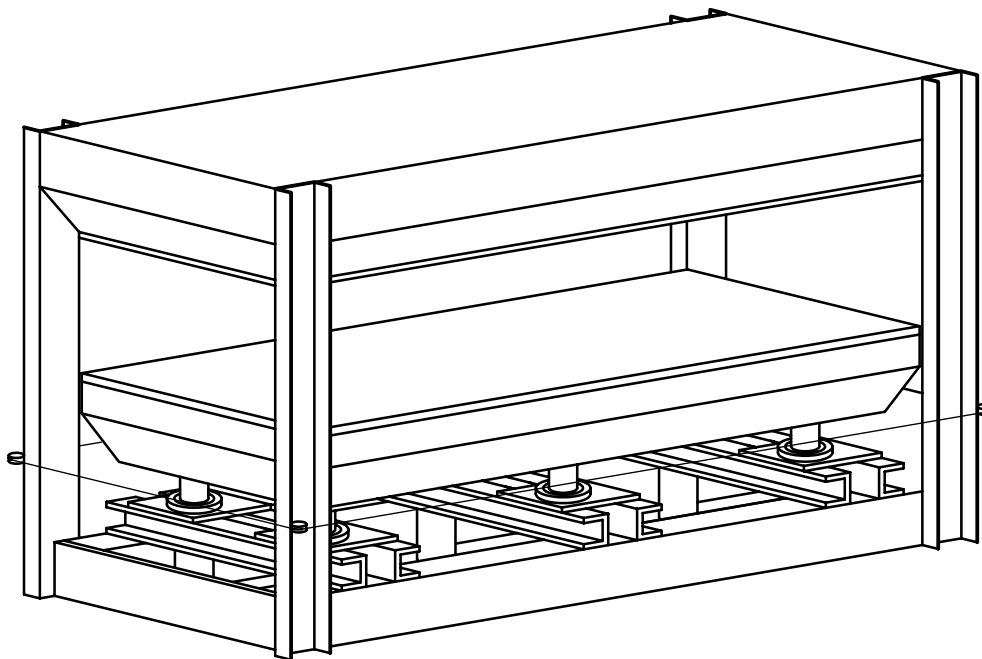


Figure 1 — Example of cold or hot press with bottom actuators

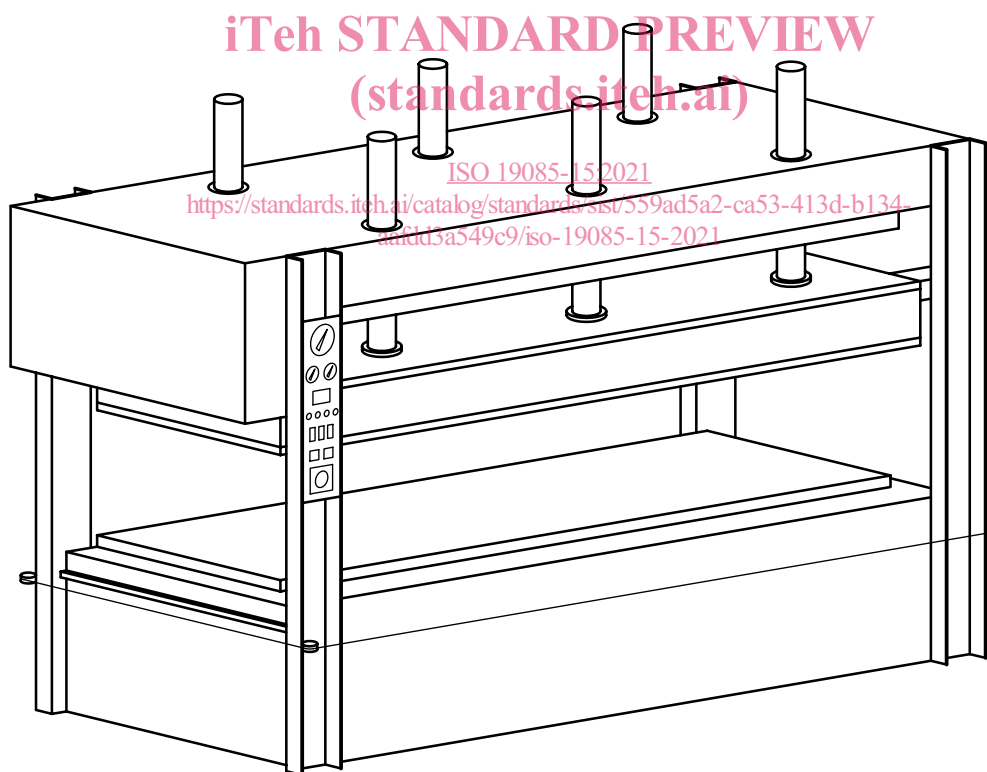


Figure 2 — Example of cold or hot press with top actuators

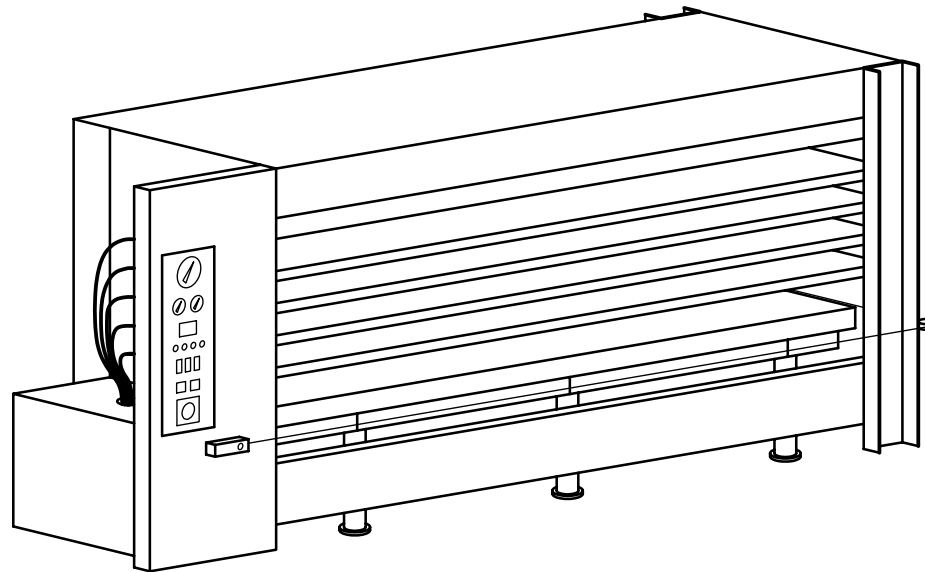


Figure 3 — Example of hot press with intermediate platens

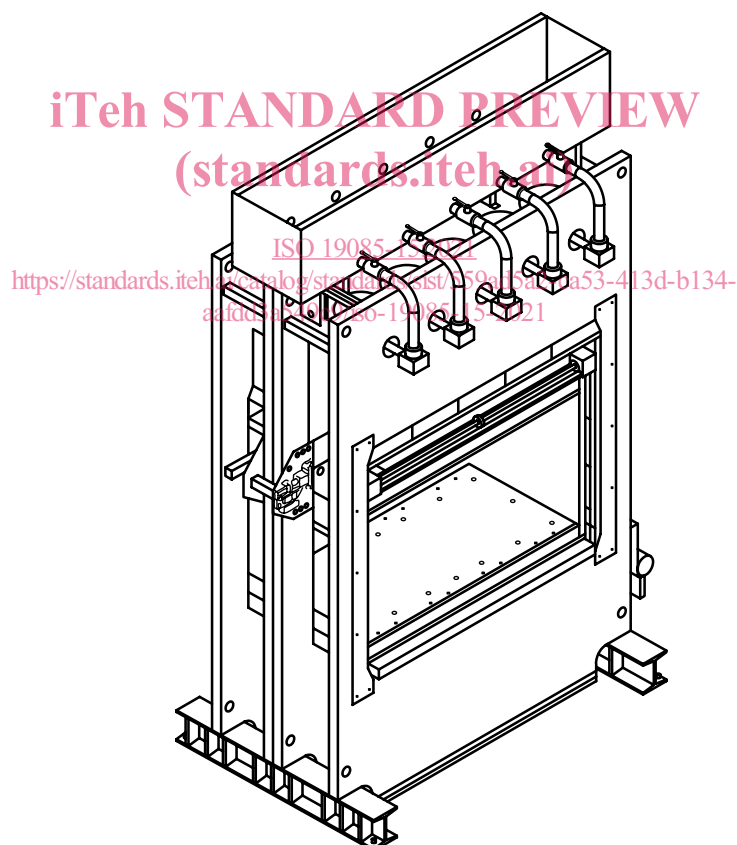


Figure 4 — Example of a bending press with top actuators

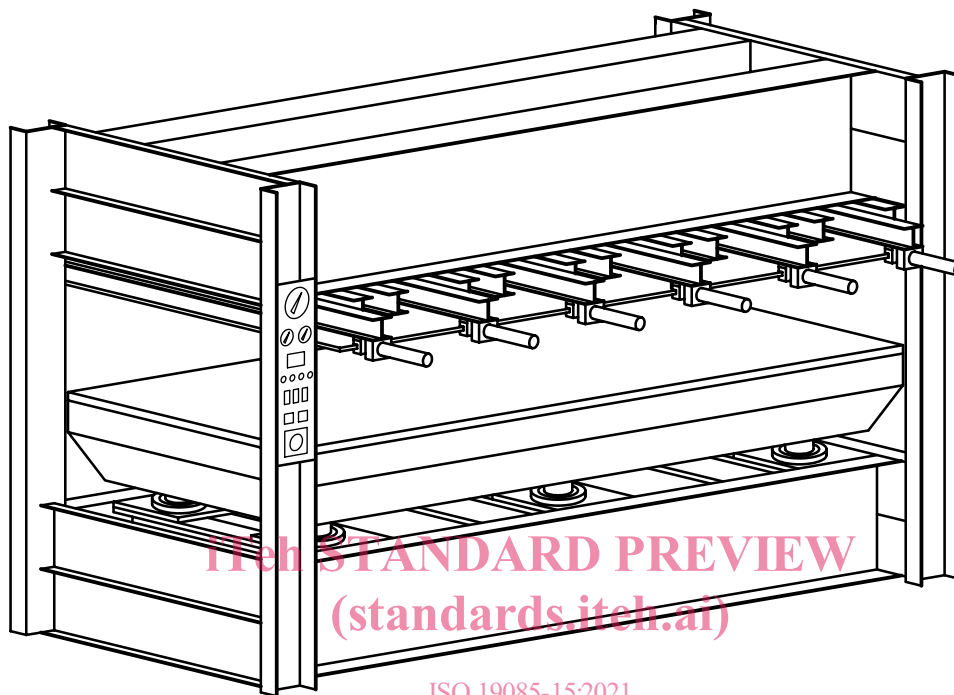
3.4 edge/face gluing press

machine used to join together solid wood bars, in which the pressing force is applied by hydraulic actuators vertically pushing two flat platens against each other, and horizontally pushing elements against each other, and hot gluing process is by hot platens or high-frequency system

Note 1 to entry: The following devices can be provided:

- work-pieces extractor;
- automatic panel loading and unloading system;
- *work-piece clamping pressure beam* (3.15).

Note 2 to entry: An example of edge/face gluing press is illustrated in [Figure 5](#) (safeguarding devices are not fully illustrated).



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Figure 5 — Example of edge/face gluing press

3.5 membrane press

machine used to laminate or veneer flat or shaped work-pieces, in which the pressing force is applied through a membrane pushed onto the work-piece by compressed air from above and by vacuum from below, hermetically enclosed by two shells, of which the upper one is heated, pushed against each other by hydraulic actuators

Note 1 to entry: Automatic panel loading and unloading devices can be provided.

Note 2 to entry: Upper shell heating systems can be by electrical resistance or hot fluid (e.g. diathermic oil, water). Fluid heating system can be internal to the machine or external.

Note 3 to entry: An example of membrane press is illustrated in [Figure 6](#) (safeguarding devices are not fully illustrated).

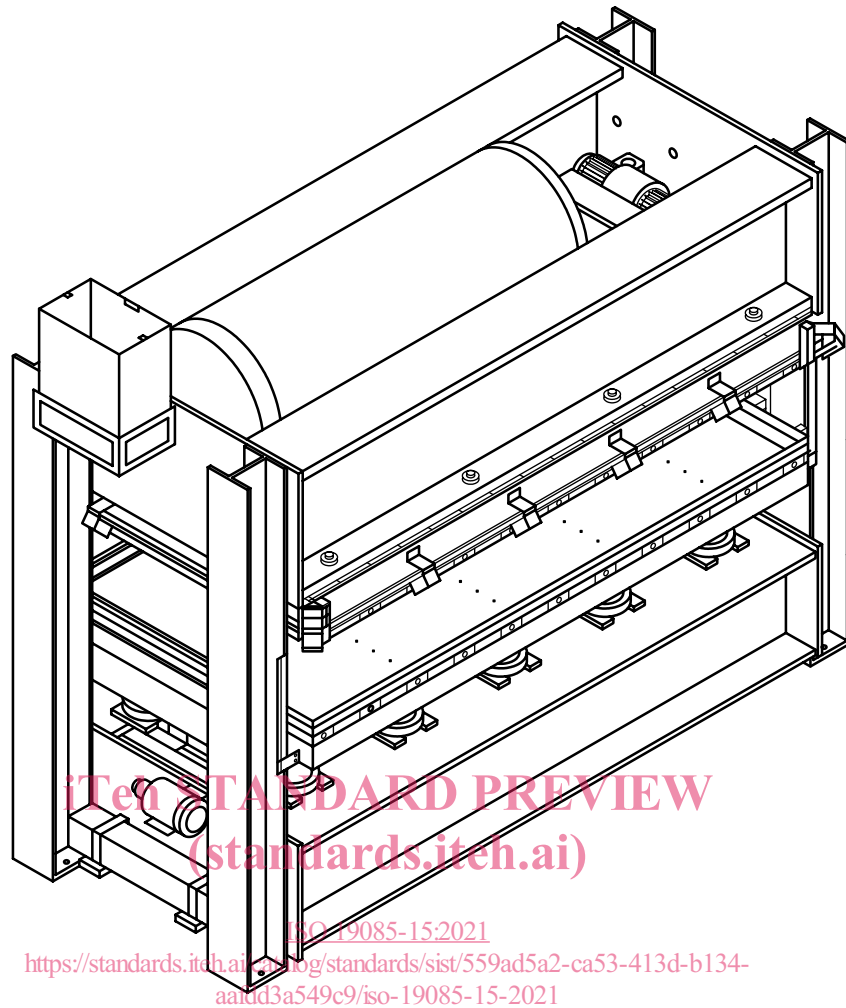


Figure 6 — Example of membrane press

3.6 embossing press

machine used to emboss work-pieces by a special mould/die fixed to the upper plate, in which the pressing force is applied by hydraulic actuators pushing two hot flat platens against each other

Note 1 to entry: The moveable platen can be the top or the bottom one or both. Examples of different machine designs are illustrated in [Figures 1](#) and [2](#) (safeguarding devices are not fully illustrated).

Note 2 to entry: Automatic panel loading and unloading devices can be provided.

Note 3 to entry: Platens heating systems can be by electrical resistance or hot fluid (e.g. diathermic oil, water). Fluid heating system can be internal to the machine or external.

3.7 daylight

compartment between two consecutive pressing platens

3.8 automatic work-piece loading/unloading system

system for automatic feed of work-pieces into/out of the machine, whereby the work-piece is manually loaded/unloaded into/out of it

Note 1 to entry: Six usual types of automatic work-piece loading/unloading systems are considered in this document.