



SLOVENSKI STANDARD
SIST EN 1673:2021/oprA1:2025
01-januar-2025

Stroji za predelavo hrane - Peči z vrtljivim vozičkom - Varnostne in higienske zahteve

Food processing machinery - Rotary rack ovens - Safety and hygiene requirements

Nahrungsmittelmaschinen - Stikken-Backöfen - Sicherheits- und Hygieneanforderungen

Machines pour les produits alimentaires - Fours à chariot rotatif - Prescriptions relatives à la sécurité et l'hygiène

Ta slovenski standard je istoveten z: EN 1673:2020/prA1

[SIST EN 1673:2021/oprA1:2025](https://standards.iteh.ai/)

<https://standards.iteh.ai/catalog/standards/sist/4b655cf2-04cc-414f-8093-ca6028081314/sist-en-1673-2021-opra1-2025>

ICS:

67.260	Tovarne in oprema za živilsko industrijo	Plants and equipment for the food industry
97.040.20	Štedilniki, delovni pulti, pečice in podobni aparati	Cooking ranges, working tables, ovens and similar appliances

SIST EN 1673:2021/oprA1:2025

en,fr,de

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

DRAFT
EN 1673:2020
prA1

November 2024

ICS 97.040.20; 67.260

English Version

Food processing machinery - Rotary rack ovens - Safety and hygiene requirements

Machines pour les produits alimentaires - Fours à
chariot rotatif - Prescriptions relatives à la sécurité et
l'hygiène

Nahrungsmittelmaschinen - Stikken-Backöfen -
Sicherheits- und Hygieneanforderungen

This draft amendment is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 153.

This draft amendment A1, if approved, will modify the European Standard EN 1673:2020. If this draft becomes an amendment, CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant national standard without any alteration.

This draft amendment was established by CEN 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of 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, Türkiye and United Kingdom.

Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

Warning : This document is not a European Standard. It is distributed for review and comments. It is subject to change without notice and shall not be referred to as a European Standard.



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

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents	Page
European foreword	3
1 Modifications to Clause 1 “Scope”	4
2 Modification to Clause 2 “Normative references”	4
3 Modifications to subclause 4.1 “General”	5
4 Modification to subclause 4.2.1 “Zone 1: Drive mechanism”	5
5 Modifications to subclause 4.2.2.1 “General”	6
6 Modification to subclause 4.2.3 “Zone 2: Space between the rack and any baking chamber door frame”	6
7 Modification to subclause 4.2.4 “Zone 4: Area in the front of any baking chamber door”	6
8 Modifications to subclause 4.2.5.3 “Stability of rack and trays standing outside the baking chamber”	7
9 Modification to subclause 4.3 “Electrical hazards”	7
10 Modification to subclause 4.4.1 “Escape of steam by opening any baking chamber door”	7
11 Modification to subclause 4.4.2 “Hot external surfaces”	8
12 Modification to subclause 4.4.3 “Fire hazards due to overheating”	9
13 Modification to subclause 4.6 “Hazards from remote control”	9
14 Modification to subclause 4.7 “Hazards from automatic start and/or unexpected start and process restart”	9
15 Modification to subclause 4.8.1 “General”	9
16 Modification to subclause 4.8.1 “General”	9
17 Modifications to subclause 4.9 “Hazards generated by neglecting ergonomic principles “	10
18 Modification to Clause 5 “Verification of the safety and hygiene requirements and/or measures”	10
19 Modification to subclause 6.2 “Information and warnings on the machine”	11
20 Modification to subclause 6.3 “Instruction handbook”	11
21 Modification to Clause 7 “Environmental aspects”	13
22 Modification to Table ZA.1 “Correspondence between this European Standard and Annex I of Directive 2006/42/EC”	13
23 Addition of a new Annex ZB	15
Annex ZB (informative) Relationship between this European Standard and the essential requirements of Regulation (EU) 2023/1230 aimed to be covered.....	16

European foreword

This document (EN 1673:2020/prA1:2024) has been prepared by Technical Committee CEN/TC 153 “Machinery intended for use with foodstuffs and feed”, the secretariat of which is held by DIN.

This document is currently submitted to the CEN Enquiry.

This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annexes ZA and ZB, which are integral parts of this document.

iTeh Standards
(<https://standards.itih.ai>)
Document Preview

[SIST EN 1673:2021/oprA1:2025](https://standards.itih.ai/catalog/standards/sist/4b655cf2-04cc-414f-8093-ca6028081314/sist-en-1673-2021-oprA1-2025)

<https://standards.itih.ai/catalog/standards/sist/4b655cf2-04cc-414f-8093-ca6028081314/sist-en-1673-2021-oprA1-2025>

EN 1673:2020/prA1:2024 (E)**1 Modifications to Clause 1 “Scope”**

Replace:

“The following hazards are not covered by this document:

- hazards from the use of gaseous fuel by gas appliances;
- hazards arising from electromagnetic compatibility issues;
- hazards from the use of trays made of or coated by silicone;
- hazards due to dismantling, disabling and scrapping.”

with the following:

“The following hazards are not covered by this document:

- hazards due to materials and products;
- hazards from the use of other means than electricity for generating the heat for baking;
- hazards due to explosion;
- hazards due to emission of hazardous materials and substances;
- hazards due to access to operating positions and servicing points;
- hazards due to isolation of energy sources;
- hazards due to operator intervention.”

Replace:

“This document does not deal with noise emitted by the machine.”

with the following:

“This standard does not deal with any specific requirements on noise emitted from rotary rack ovens as the generated noise does not cause a relevant hazard.”

2 Modification to Clause 2 “Normative references”

Replace the following normative references:

EN 203-2-2:2006, *Gas heated catering equipment — Part 2-2: Specific requirements — Ovens*

EN 1672-2:2005+A1:2009, *Food processing machinery — Basic concepts — Part 2: Hygiene requirements*

EN 60204-1:2006, *Safety of machinery — Electrical equipment of machines — Part 1: General requirements (IEC 60204:2005, modified)*

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

with the following:

EN 203-2-2:2021+A1:2023, *Gas heated catering equipment — Part 2-2: Specific requirements — Ovens*

EN 1672-2:2020, *Food processing machinery — Basic concepts — Part 2: Hygiene and cleanability requirements*

EN 60204-1:2018, *Safety of machinery — Electrical equipment of machines — Part 1: General requirements*

EN ISO 13849-1:2023, *Safety of machinery — Safety-related parts of control systems — Part 1: General principles for design (ISO 13849-1:2023)*

3 Modifications to subclause 4.1 “General”

Replace the 3rd paragraph:

“Every electrical control circuit with safety functions shall meet at least a performance level “c” defined in accordance with EN ISO 13849-1:2015, unless it is differently specified in this document.”

with the following:

“Every electrical control circuit with safety functions shall meet at least a performance level “c” defined in accordance with EN ISO 13849-1:2023, unless it is differently specified in this document.”

Replace the 5th paragraph:

“A normal stop device shall be provided, and it shall control a stop of category 1 according to EN 60204-1:2006, 9.2.2, except the normal stop controlled by releasing a hold-to-run control which shall be category 0.”

with the following:

“A normal stop device shall be provided, and it shall control a stop of:

- category 0 according to EN 60204-1:2018, 9.2.2; or
- category 1 according to EN 60204-1:2018, 9.2.2, only if the energy supply for the actuators stops within the time of one turn of the rack,

The normal stop controlled by releasing a hold-to-run control shall be category 0 according to EN 60204-1:2018, 9.2.2.”

Replace the last paragraph:

“Where reference is made to interlocking guards, the associated interlocking devices shall comply with EN ISO 14119:2013. If an interlocking device type 2 or type 4, as defined in EN ISO 14119:2013, is used it can be of low level provided that the requested PL is achieved.”

with the following:

“Where reference is made to interlocking guards, the associated interlocking devices shall comply with EN ISO 14119:2013, Clauses 4, 5 and 7. For interlocking devices of type 2 and type 4 as defined in EN ISO 14119:2013, 3.17 and 3.19, all levels of coding as defined in EN ISO 14119:2013, 3.13.1, 3.13.2 and 3.13.3, are permitted.”

4 Modification to subclause 4.2.1 “Zone 1: Drive mechanism”

Replace the following text:

- a) fixed enclosing guards according to EN ISO 13857:2019 and EN ISO 14120:2015; and/or
- b) distance guards according to EN ISO 13857:2019, Table 1, and EN ISO 14120:2015.

EN 1673:2020/prA1:2024 (E)

If there are openings in the guard, they shall comply with EN ISO 13857:2019, Table 3 and/or Table 4.”

with the following:

“a) fixed enclosing guards according to EN ISO 14120:2015, 5.3.7, 5.3.9 and 5.3.10.

b) distance guards according to EN ISO 14120:2015, 5.2.4, 5.3.7, 5.3.9 and 5.3.10 and EN ISO 13857:2019, Table 1.

If there are openings in the guard, they shall comply with EN ISO 13857:2019, Table 3, Table 4 and/or Table 6.”

5 Modifications to subclause 4.2.2.1 “General”

In the first indent b), replace the following text:

“EN ISO 13849-1:2015”

with the following:

“EN ISO 13849-1:2023”

Replace the following text:

“Access to the fan of the ventilator shall be prevented by:

a) fixed enclosing guards according to EN ISO 13857:2019 and EN ISO 14120:2015; and/or

b) distance guards according to EN ISO 13857:2019, Table 1, and EN ISO 14120:2015.

If there are openings in the guard, they shall comply with EN ISO 13857:2019, Table 3 and/or Table 4.”

with the following:

“Access to the fan of the ventilator shall be prevented by:

a) fixed enclosing guards according to EN ISO 14120:2015, 5.3.7, 5.3.9 and 5.3.10.

b) distance guards according to EN ISO 14120:2015, 5.2.4, 5.3.7, 5.3.9 and 5.3.10 and EN ISO 13857:2019, Table 1.

If there are openings in the guard, they shall comply with EN ISO 13857:2019, Table 3, Table 4 and/or Table 6.”

6 Modification to subclause 4.2.3 “Zone 2: Space between the rack and any baking chamber door frame”

At the end of the paragraph, replace “(see 6.3)” with “(see 6.3f)”

7 Modification to subclause 4.2.4 “Zone 4: Area in the front of any baking chamber door”

At the end of the second paragraph, replace “(see 6.3)” with “(see 6.3i)”

8 Modifications to subclause 4.2.5.3 “Stability of rack and trays standing outside the baking chamber”

Replace indent 1):

“1) by practical test: the empty rack (without trays) shall not overturn when it is tilted by more than 7° with respect to the horizontal plane in the most unfavourable position and with wheels positioned as shown in Figure 3 and locked.”

with the following:

“1) by practical test: the empty rack (without trays) shall not overturn when it is tilted by more than 7° with respect to the horizontal plane in every direction and with the castors arranged as shown in Figure 3 and blocked.”

In the last paragraph, replace “(see 6.3)” with “(see 6.3c) and 6.3s)”

9 Modification to subclause 4.3 “Electrical hazards”

Replace the text:

“The electrical equipment shall comply with EN 60204-1:2006. According to EN 60204-1:2006, 18.1, tests a), b), c), d) and f) shall be carried out to machine distribution board.”

with the following:

“The electrical equipment shall comply with EN 60204-1:2018. According to EN 60204-1:2018, 18.1, tests a), b), c), d) and f) shall be carried out to machine distribution board.”

10 Modification to subclause 4.4.1 “Escape of steam by opening any baking chamber door”

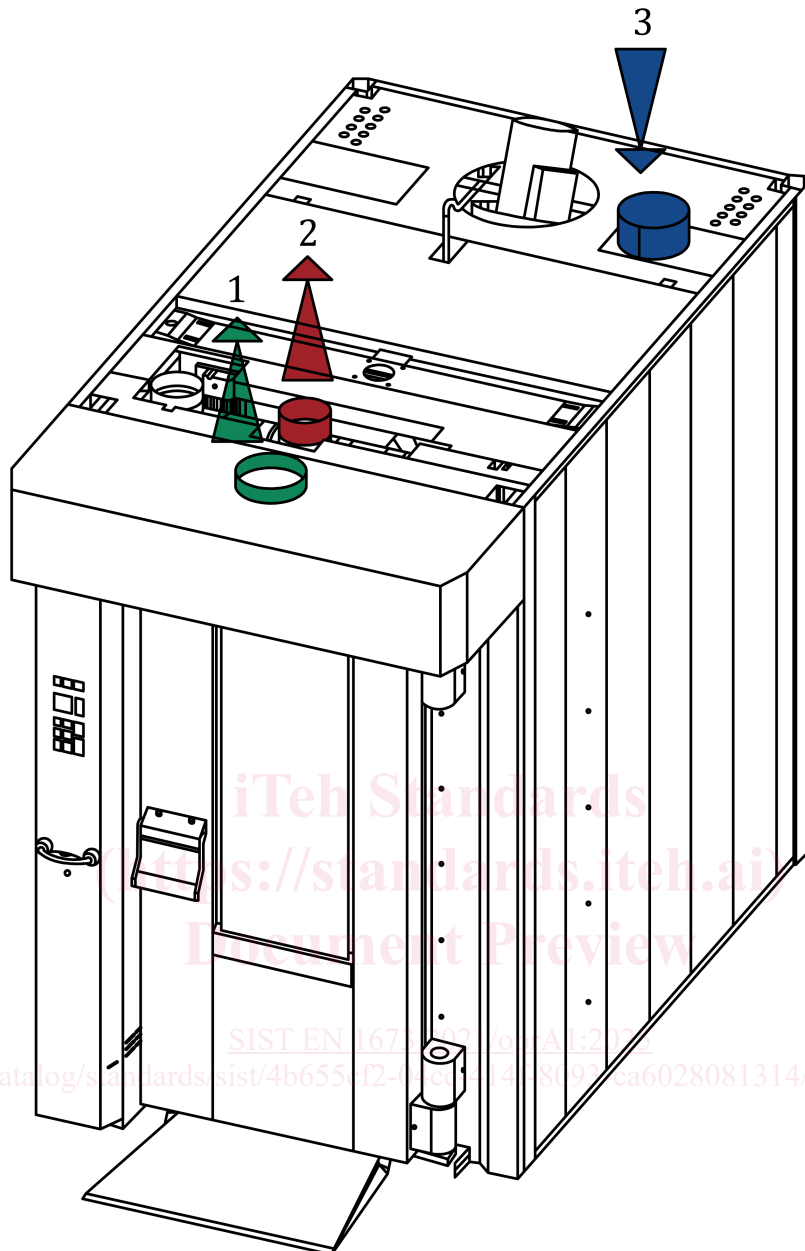
Replace the first paragraph:

“Escape of steam by opening any baking chamber door shall be minimized by suitable means, for example by an extractor running when opening any baking chamber door, evacuation of the steam before the end of the baking.”

with the following:

“Escape of steam by opening any baking chamber door shall be minimized by a steam exhausting system which has to comply with one of the following requirements (see Figure 4):

- a) an extractor whose flow rate shall be ≥ 200 times of the volume of the baking chamber per hour placed over the door outside of the baking chamber;
- b) a system evacuating the steam directly from the baking chamber at the end of the baking process cycle, the evacuated flow of the outlet shall be ≥ 60 times of the volume of the baking chamber per hour.

**Key**

- 1 hood extractor exhaust
- 2 evacuation of fumes directly from the baking chamber
- 3 fresh air intake to compensate the evacuation of baking fumes

Figure 4 — Steam exhausting system

The manufacturer shall provide, in the instructions handbook, information on how to check the flow rate of the steam exhausting system (see 6.3u)."

11 Modification to subclause 4.4.2 "Hot external surfaces"

In the subclause and title of the figure, replace "Figure 4" with "Figure 5".