
Lesnoobdelovalni stroji - Varnost - 15. del: Stiskalnice (ISO/DIS 19085-15:2026)

Woodworking machines - Safety - Part 15: Presses (ISO/DIS 19085-15:2026)

Holzbearbeitungsmaschinen - Sicherheit - Teil 15: Pressen (ISO/DIS 19085-15:2026)

Machines à bois - Sécurité - Partie 15: Presses (ISO/DIS 19085-15:2026)

Ta slovenski standard je istoveten z: prEN ISO 19085-15

ICS:

13.110	Varnost strojev	Safety of machinery
25.120.10	Kovaški stroji. Stiskalnice. Škarje	Forging equipment. Presses. Shears
79.120.10	Lesnoobdelovalni stroji	Woodworking machines

oSIST prEN ISO 19085-15:2026

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ISO/DIS 19085-15

Woodworking machines — Safety — Part 15: Presses

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

ICS: 13.110; 79.120.10

ISO/TC 39/SC 4

Secretariat: **UNI**

Voting begins on:
2026-07-27

Voting terminates on:
2026-10-19

This document has not been edited by the ISO Central Secretariat.

ISO/CEN PARALLEL PROCESSING

Reference number
ISO/DIS 19085-15:2026(en)

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Published in Switzerland

ISO/DIS 19085-15:2026(en)

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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 document 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).

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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.

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).

This document is intended to be used in conjunction with ISO DIS 19085-1:2025.

This third edition cancels and replaces the second edition (ISO 19085-15:2025), which has been technically revised. The main changes are as follows:

- the way of reference from this document to ISO DIS 19085-1:2025 has been simplified, as well as its explanation in Introduction, and aligned to ISO drafting rules;
- the verification methods at the end of each subclause have been deleted, since self-evident;
- [4.2](#), [7.2](#), [7.3](#) have been rearranged, to follow the new subdivision in ISO DIS 19085-1:2025;

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

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.

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Introduction

The ISO 19085 series of International Standards provides technical safety requirements for the design and construction of woodworking machinery, as well as for the content of the relevant instruction handbook. It concerns designers, manufacturers, suppliers and importers of the machines specified in the Scope.

This document is a type-C standard as stated in ISO 12100:2010.

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.

In this document, a subclause can refer to the same subclause of ISO DIS 19085-1:2025 or give specific requirements or both.

Woodworking machines — Safety —

Part 15: Presses

1 Scope

This document specifies the safety requirements and measures for

- cold presses,
- hot presses,
- bending presses,
- edge/face gluing presses,
- membrane presses, and
- embossing presses,

where the pressing force is applied by hydraulic, pneumatic or electrical actuators pushing two flat or shaped surfaces against each other, capable of continuous production use, altogether referred to as “machines”.

This document deals with all significant hazards, hazardous situations and events as listed in [Annex A](#), relevant to machines, when used as intended and under conditions of misuse which are reasonably foreseeable, as well as when it is transported, assembled, adjusted, maintained, disabled, dismantled and scrapped.

The machines are designed to process workpieces consisting of:

- solid wood;
- materials with similar characteristics to wood (see ISO DIS 19085-1:2025, 3.2), except those with light alloy laminates or edges or profiles for high-frequency presses;
- engineered wood (wood-based material) such as particleboard, fibreboard and plywood composed or laminated with steel sheets or edges or profiles, except for high-frequency presses;
- honeycomb board;
- composite boards made from the materials listed above.

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

- a) a device for hot gluing;
- b) a device for high-frequency gluing in the frequency range from 1 MHz to 400 MHz;
- c) a device for high-frequency shaping in the frequency range from 1 MHz to 400 MHz;
- d) an automatic workpiece loading and unloading system;
- e) an intermediate additional platen;
- f) a workpiece extractor;

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- g) a horizontal pressing system;
- h) split moveable platens.

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;
- hot fluid heating systems of any type 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).

This document is not applicable to:

- carcass clamps;
- membrane presses where the pressing force is applied by vacuum only;
- presses for producing particleboard, fibreboard, OSB;
- machines intended for use in potentially explosive atmosphere;
- machines manufactured before the date of publication of this document.

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

ISO 7010:2019/Amd 1:2020, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 1*

ISO 7010:2019/Amd 2:2020, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 2*

ISO 7010:2019/Amd 3:2021, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 3*

ISO 7010:2019/Amd 4:2021, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 4*

ISO 7010:2019/Amd 5:2022, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 5*

ISO 7010:2019/Amd 6:2022, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 6*

ISO 7010:2019/Amd 7:2023, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 7*

ISO 7010:2019/Amd 8:2024, *Graphical symbols — Safety colours and safety signs — Registered safety signs — Amendment 8*

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

ISO 13850:2015, *Safety of machinery — Emergency stop function — Principles for design*

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ISO 13855:2024, *Safety of machinery — Positioning of safeguards with respect to the approach of the human body*

ISO/DIS 19085-1:2025, *Woodworking machines — Safety — Part 1: Common requirements*

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 62311:2019, *Assessment of electronic and electrical equipment related to human exposure restrictions for electromagnetic fields (0 Hz to 300 GHz)*

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 13849-1:2023, ISO DIS 19085-1:2025 and the following apply.

ISO and IEC maintain terminology 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 or join together flat panels, or both, in which the pressing force is applied by hydraulic, pneumatic or electrical 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 or join together flat panels, or both, 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.

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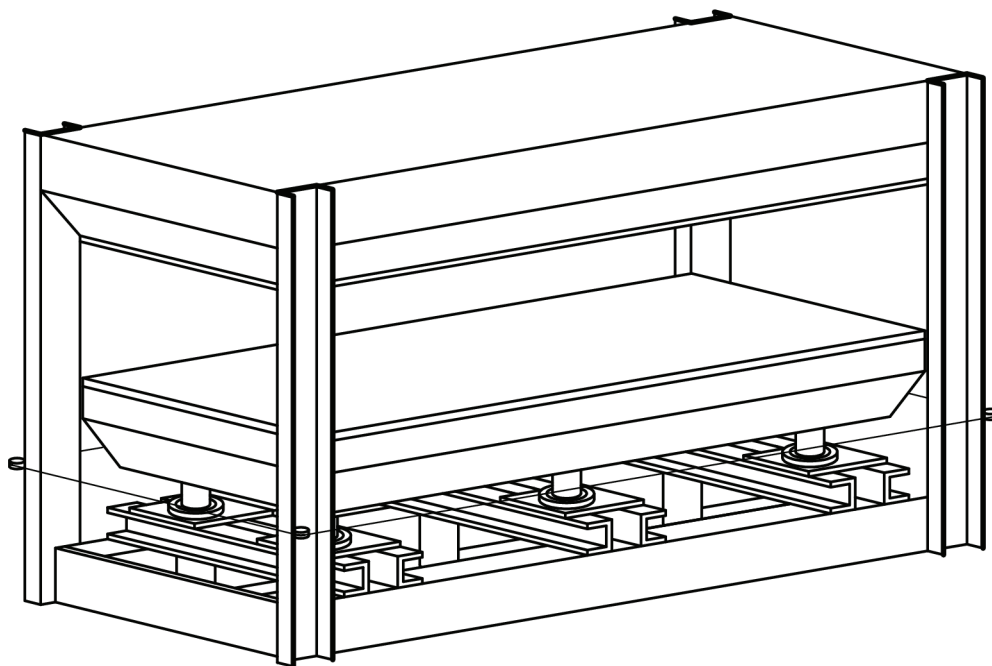


Figure 1 — Example of a cold or hot press with bottom actuators

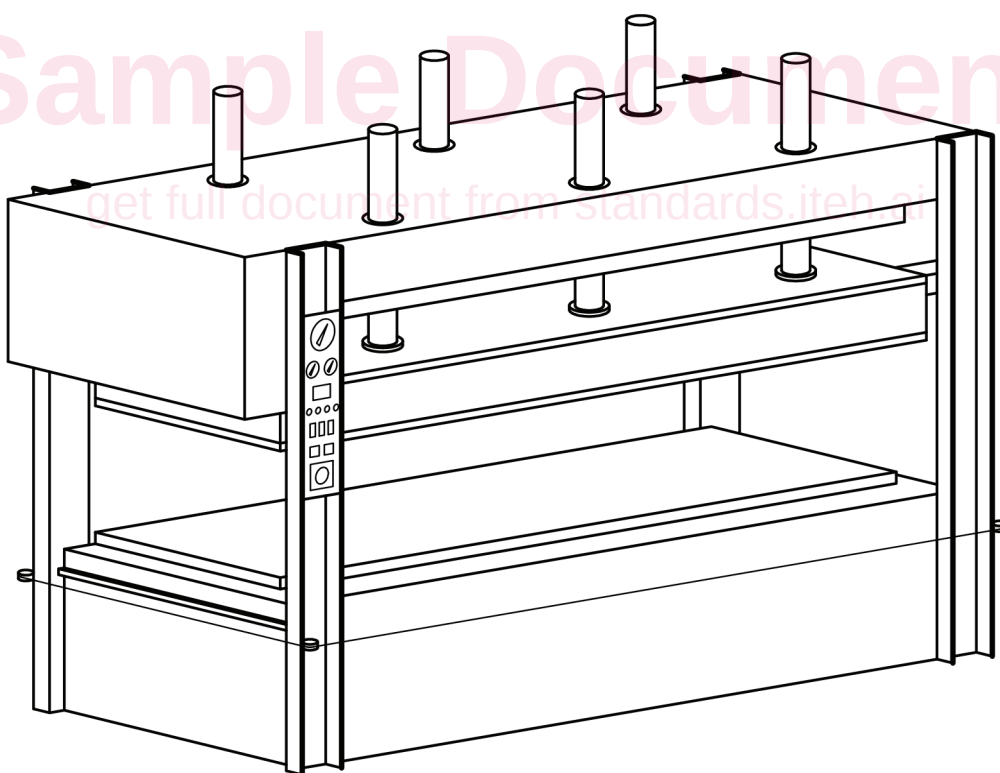


Figure 2 — Example of a cold or hot press with top actuators