
Varnost pakirnih strojev - 4. del: Stroji za nakladanje in razkladanje palet ter pripadajoča oprema

Safety of packaging machines - Part 4: Palletizers and depalletizers and associated equipment

Sicherheit von Verpackungsmaschinen - Teil 4: Palettierer und Depalettierer und zugehörige Ausrüstungen

Sécurité des machines d'emballage - Partie 4 : Palettiseurs et dépalettiseurs et équipement associé

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Sécurité des machines d'emballage - Partie 4 :
Palettiseurs et dépalettiseurs et équipement associé

Sicherheit von Verpackungsmaschinen - Teil 4:
Palettierer und Depalettierer und zugehörige
Ausrüstungen

This European Standard was approved by CEN on 4 November 2024.

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EN 415-4:2025 (E)**European foreword**

This document (EN 415-4:2025) has been prepared by Technical Committee CEN/TC 146 “Packaging machines - Safety”, the secretariat of which is held by UNI.

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of an identical text or by endorsement, at the latest by June 2026, and conflicting national standards shall be withdrawn at the latest by June 2026.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 415-4:1997.

EN 415-4:2025 includes the following significant technical changes with respect to EN 415-4:1997:

- palletizers and depalletizers that incorporate industrial robots and multi-stations palletizing systems have been added to the scope;
- safety requirements have been rewritten so they are in line with EN 415-10:2014;
- normative references have been changed to reflect the current B1 and B2 standards;
- the performance level required PLr (specified by EN ISO 13849-1:2023) is specified for the safety-related parts of control systems

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 Annex ZA, which is an integral part of this document.

This document is part of the series EN 415, *Safety of packaging machines*, which consists of the following parts:

- *Part 1: Terminology and classification of packaging machines and associated equipment;*
- *Part 2: Pre-formed rigid container packaging machines;*
- *Part 3: Form, fill and seal machines; fill and seal machines;*
- *Part 5: wrapping machines;*
- *Part 6: Pallet wrapping machines;*
- *Part 7: Group and secondary packaging machines;*
- *Part 8: Strapping machines;*
- *Part 9: Noise measurement methods for packaging machines, packaging lines and associated equipment, grade of accuracy 2 and 3;*

— *Part 10: General requirements.*

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