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**Woodworking machines — Safety —**  
**Part 2:**  
**Horizontal beam panel circular sawing**  
**machines**

*Machines à bois — Sécurité —*

*Partie 2: Scies circulaires à panneaux horizontales à presseur*



Reference number  
ISO 19085-2:2017(E)

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# Contents

Page

<b>Foreword</b>	<b>v</b>
<b>Introduction</b>	<b>vi</b>
<b>1 Scope</b>	<b>1</b>
<b>2 Normative references</b>	<b>2</b>
<b>3 Terms and definitions</b>	<b>2</b>
<b>4 List of significant hazards</b>	<b>7</b>
<b>5 Safety requirements and measures for controls</b>	<b>9</b>
5.1 Safety and reliability of control systems	9
5.2 Control devices	9
5.3 Start	10
5.3.1 General	10
5.3.2 Operating conditions	11
5.4 Safe stops	11
5.4.1 General	11
5.4.2 Normal stop	12
5.4.3 Operational stop	12
5.4.4 Emergency stop	12
5.5 Braking function of tool spindles	12
5.6 Mode selection	12
5.7 Spindle speed changing	12
5.7.1 Spindle speed changing by changing belts on the pulleys	12
5.7.2 Spindle speed changing by incremental speed change motor	12
5.7.3 Infinitely variable speed by frequency inverter	12
5.8 Failure of any power supply	12
5.9 Manual reset control	13
5.10 Enabling control	13
5.11 Machine moving parts speed monitoring	13
5.12 Time delay	13
<b>6 Safety requirements and measures for protection against mechanical hazards</b>	<b>13</b>
6.1 Stability	13
6.1.1 Stationary machines	13
6.1.2 Displaceable machines	13
6.2 Risk of break-up during operation	13
6.3 Tool holder and tool design	13
6.3.1 General	13
6.3.2 Spindle locking	13
6.3.3 Circular saw blade fixing device	14
6.3.4 Flange dimension for circular saw blades	14
6.4 Braking	14
6.4.1 Braking of tool spindles	14
6.4.2 Maximum run-down time	14
6.4.3 Brake release	14
6.5 Safeguards	14
6.5.1 Fixed guards	14
6.5.2 Interlocking movable guards	14
6.5.3 Hold-to-run control	14
6.5.4 Two-hand control	14
6.5.5 Electro-sensitive protective equipment (ESPE)	14
6.5.6 Pressure-sensitive protective equipment (PSPE)	15
6.6 Prevention of access to moving parts	15
6.6.1 General	15
6.6.2 Guarding of tools	15

6.6.3	Guarding of drives .....	16
6.6.4	Guarding of shearing and/or crushing zones .....	17
6.7	Impact hazard .....	24
6.8	Clamping devices .....	25
6.9	Measures against ejection .....	25
6.9.1	General .....	25
6.9.2	Guards materials and characteristics .....	25
6.10	Work-piece supports and guides .....	25
<b>7</b>	<b>Safety requirements and measures for protection against other hazards .....</b>	<b>26</b>
7.1	Fire .....	26
7.2	Noise .....	26
7.2.1	Noise reduction at the design stage .....	26
7.2.2	Noise emission measurement .....	26
7.3	Emission of chips and dust .....	26
7.4	Electricity .....	26
7.4.1	General .....	26
7.4.2	Displaceable machines .....	26
7.5	Ergonomics and handling .....	26
7.6	Lighting .....	27
7.7	Pneumatics .....	27
7.8	Hydraulics .....	27
7.9	Electromagnetic compatibility .....	27
7.10	Laser .....	27
7.11	Static electricity .....	27
7.12	Errors of fitting .....	27
7.13	Isolation .....	27
7.14	Maintenance .....	27
<b>8</b>	<b>Information for use .....</b>	<b>27</b>
8.1	Warning devices .....	27
8.2	Marking .....	27
8.2.1	General .....	27
8.2.2	Additional markings .....	27
8.3	Instruction handbook .....	28
8.3.1	General .....	28
8.3.2	Additional information .....	28
	<b>Annex A (informative) Performance levels required .....</b>	<b>30</b>
	<b>Annex B (normative) Test for braking function .....</b>	<b>31</b>
	<b>Annex C (normative) Stability test for displaceable machines .....</b>	<b>32</b>
	<b>Annex D (normative) Impact test for guards .....</b>	<b>33</b>
	<b>Annex E (normative) Noise emission measurement for machines not in ISO 7960:1995 .....</b>	<b>34</b>
	<b>Annex F (normative) Rigidity tests for sectional safety curtain material .....</b>	<b>35</b>

## 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](http://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](http://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 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 the following URL: [www.iso.org/iso/foreword.html](http://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.

This corrected version of ISO 19085-2:2017 incorporates the following corrections:

- [Figures 5](#) and [9](#) have been changed.

## 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 that the manufacturer will need to give to the user.

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.

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 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 part of ISO 19085 without correspondent in ISO 19085-1:2017 are indicated by the introductory sentence: “Subclause (or annex) specific to this part of ISO 19085.”

[Clauses 1, 2, 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.

# Woodworking machines — Safety —

## Part 2:

## Horizontal beam panel circular sawing machines

### 1 Scope

This document gives the safety requirements and measures for horizontal beam panel circular sawing machines with the saw carriage of the front cutting line mounted below the work-piece support, which are manually and/or powered loaded and manually unloaded, hereinafter referred to as “machines”.

It deals with all significant hazards, hazardous situations and events as listed in [Clause 4](#), relevant to the 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 have been 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:

- side pressure device;
- device for powered unloading;
- unit for scoring;
- unit for post-formed/soft-formed edge pre-cutting;
- panel turning device;
- front side turn table;
- pushing out device;
- pneumatic clamping of the saw blade;
- powered panel loading device;
- device for grooving by milling tool;
- one or more additional cutting lines inside the machine for longitudinal and/or head cut (before the transversal cutting line);
- work-piece vacuum clamping as part of a front side turn table or of a panel loading device.

The machines are designed for cutting panels consisting of

- a) solid wood,
- b) material with similar physical characteristics to wood (see ISO 19085-1:2017, 3.2),
- c) gypsum boards, gypsum bounded fibreboards,
- d) composite boards made from the materials listed above, and
- e) composite materials with core consisting of e.g. polyurethane or mineral material laminated with light alloy.

This document does not deal with hazards related to

- specific features that differ from the dashed list above,
- the machining of panels with milling tools for grooving,
- powered unloading of panels,
- rear half of split pressure beam on the front cutting line,
- the combination of a single machine being used with any other machine (as part of a line).

It is not applicable to machines intended for use in potentially explosive atmospheres or to machines manufactured prior to the date of its publication.

## 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 7960:1995, *Airborne noise emitted by machine tools — Operating conditions for woodworking machines*

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

ISO 14118:2000, *Safety of machinery — Prevention of unexpected start-up*

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

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

IEC 60204-1:2005, *Safety of machinery — Electrical equipment of machines — Part 1: General requirements*

## 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 <http://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

### 3.1

#### **horizontal beam panel sawing machine**

machine, designed for cutting panels, fitted with one travelling *saw carriage* (3.6) per cutting line incorporating one or more circular saw blades

Note 1 to entry: The work-piece is supported in the horizontal plane and may be mechanically positioned by a panel pusher for the cuts and held in position during cutting by a pressure beam. The cutting stroke is power driven. Before the cutting stroke commences, the saw blade is automatically raised/lowered and is retracted or out of operation for the return stroke. The cut takes place only in a single straight line. For examples, see [Figure 1](#). The work-piece is loaded manually and/or by means of a powered panel loading device and manually unloaded. The machine may have any of the devices/additional working units listed in the scope.