BS EN ISO 19085-15:2025

BSI Standards Publication

Woodworking machines — Safety

Part 15: Presses

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National foreword

This British Standard is the UK implementation of EN ISO 19085-15:2025. It is identical to ISO 19085-15:2025. It supersedes BS EN ISO 19085-15:2021, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee MTE/23, Woodworking machines.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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For the Great Britain market (England, Scotland and Wales), if UK Government has designated this publication for conformity with UKCA marking (or similar) legislation, it may contain an additional National Annex. Where such a National Annex exists, it shows the correlation between this publication and the relevant UK legislation. If there is no National Annex of this kind, the relevant Annex ZA or ZZ in the body of the European text will indicate the relationship to UK regulation applicable in Great Britain. References to EU legislation may need to be read in accordance with the UK designation and the applicable UK law. Further information on designated standards can be found at www.bsigroup.com/standardsandregulation.

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UK Government is responsible for legislation. For information on legislation and policies relating to that legislation, consult the relevant pages of www.gov.uk.

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Amendments/corrigenda issued since publication

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EUROPEAN STANDARD

NORME EUROPÉENNE

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December 2025

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Holzbearbeitungsmaschinen - Sicherheit - Teil 15: Pressen (ISO 19085-15:2025)

This European Standard was approved by CEN on 22 February 2025.

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European foreword

This document (EN ISO 19085-15:2025) has been prepared by Technical Committee ISO/TC 39 "Machine tools" in collaboration with Technical Committee CEN/TC 142 “Woodworking 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 ISO 19085-15:2021.

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.

Any feedback and questions on this document should be directed to the users’ national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

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The text of ISO 19085-15:2025 has been approved by CEN as EN ISO 19085-15:2025 without any modification.

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Annex ZA
(informative)

Relationship between this European Standard and the essential requirements of Directive 2006/42/EC aimed to be covered

This European Standard has been prepared under a Commission's standardization request "M/396 Mandate to CEN and CENELEC for standardisation in the field of machinery" to provide one voluntary means of conforming to essential requirements of Directive 2006/42/EC of the European Parliament and of the Council of 17 May 2006 on machinery, and amending Directive 95/16/EC (recast).

Once this standard is cited in the Official Journal of the European Union under that Directive, compliance with the normative clauses of this standard given in Table ZA.1 confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding essential requirements of that Directive, and associated EFTA regulations.

Table ZA.1 — Correspondence between this European Standard and Directive 2006/42/EC

The relevant Essential Requirements (ERs) of Directive 2006/42/EC	Clause(s)/subclause(s) of this EN	Remarks/Notes
1.1.2 Principles of safety integration		
a)	4, 5, 6, 7	
c)	4, 5, 6, 7	
d)	4, 5, 6, 7	
e)	4, 5, 6, 7	
1.1.5 Design of machinery to facilitate its handling	6.5	
1.1.6 Ergonomics	6.5	
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1.2.3 Starting	4.3	
1.2.4.1 Normal stop	4.4.2	
1.2.4.3 Emergency stop	4.4.4	
1.2.6 Failure of the power supply	4.8	
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1.3.2 Risk of break-up during operation	7.3	
1.3.3 Risks due to falling or ejected objects	7.3	
1.3.7 Risks related to moving parts	5.6, 5.7, 7.3	
1.3.8 Choice of protection against risks related to moving parts	5.6, 5.7, 7.3	
1.3.9 Risk of uncontrolled movements	4.8	

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The relevant Essential Requirements (ERs) of Directive 2006/42/EC	Clause(s)/subclause(s) of this EN	Remarks/Notes
1.4.1 General requirements	6.4	
1.5.1 Electricity supply	6.4, 6.13	
1.5.2 Static electricity	6.11	
1.5.5 Extreme temperatures	6.16	
1.5.6 Fire	6.1	
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1.7.4 Instructions	7.3, Annex F	
2.3 Machinery for working wood and analogous materials		
a) guiding	5.10	

WARNING 1 Presumption of conformity stays valid only as long as a reference to this European Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

WARNING 2 Other Union legislation may be applicable to the product(s) falling within the scope of this standard.

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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).

ISO draws attention to the possibility that the implementation of this document may involve the use of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had not received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at www.iso.org/patents. ISO shall not be held responsible for identifying any or all such patent rights.

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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 second edition cancels and replaces the first edition (ISO 19085-15:2021), which has been technically revised. The main changes compared to the previous edition are as follows:

— the Scope has been revised to also cover presses with pneumatic or electrical actuators (not only hydraulic) and to specify that machines are intended for continuous production use;

— the list of significant hazards has been moved to new Annex A;

— the structure has been simplified and modified, in particular in 5.6;

— subclause 6.2 has been updated and the noise test code has been moved to Annex F;

— subclause 6.4 has been improved;

— subclause 6.17 on radiation has been added.

This document is intended to be used in conjunction with ISO 19085-1:2021.

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 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 12100:2010.

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.

The full set of requirements for a particular type of woodworking machine are those given in the part of the ISO 19085 series applicable to that type, together with the relevant requirements from ISO 19085-1:2021, to the extent specified in the Scope of the applicable part of the ISO 19085 series.

This document is intended to be used in conjunction with ISO 19085-1:2021, which gives requirements common to the different woodworking machine types.

As far as possible, the safety requirements of parts of the ISO 19085 series refer to the relevant subclauses of ISO 19085-1:2021. Each part contains replacements and additions to the common requirements given in ISO 19085-1:2021.

Clauses 1 to 3 are specific to each part and, therefore, replace ISO 19085-1:2021, Clauses 1 to 3.

For Clauses 4 to 7 and Annexes A to F, each subclause of ISO 19085-1:2021, Clauses 4 to 7 and Annexes A to F can be:

— confirmed as a whole;

— confirmed with additions;

— excluded in total; or

— replaced with specific text.

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This is indicated by one of the following possible statements:

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— "ISO 19085-1:2021, [subclause/Annex], does not apply.";

— "ISO 19085-1:2021, [subclause/Annex], is replaced by the following text." or "ISO 19085-1:2021, [subclause/Annex], is replaced by the following text, subdivided into further specific subclauses.".

Other subclauses and annexes specific to this document are indicated by the introductory sentence: "Subclause/Annex specific to this document.".

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Woodworking machines — Safety —

Part 15: Presses

1 Scope

1.1 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 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.

1.2 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;

g) a horizontal pressing system;

h) split moveable platens.

1.3 The machines are designed to process workpieces consisting of:

a) solid wood;

b) materials with similar characteristics to wood (see ISO 19085-1:2021, 3.2), except those with light alloy laminates/edges/profiles for high-frequency presses;

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c) wood-based material such as chipboard, fibreboard and plywood composed/laminated with steel sheets/edges/profiles, except for high-frequency presses;

d) honeycomb board;

e) composite boards made from the materials listed above.

1.4 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).

1.5 This document 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 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, *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*

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

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

ISO 19085-1:2021, *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 19085-1:2021 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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