



BSI Standards Publication

Personal protective equipment — Occupational footwear

National foreword

This British Standard is the UK implementation of EN ISO 20347:2022+A1:2024. It is identical to ISO 20347:2021, incorporating amendment 1:2024. It supersedes BS EN ISO 20347:2022, which is withdrawn.

The start and finish of text introduced or altered by amendment is indicated in the text by tags. Tags indicating changes to ISO text carry the number of the ISO amendment. For example, text altered by ISO amendment 1 is indicated by A1 A1.

The UK participation in its preparation was entrusted to Technical Committee PH/1, Safety, protective and occupational footwear.

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

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English Version

Personal protective equipment - Occupational footwear
(ISO 20347:2021)

Équipement de protection individuelle - Chaussures de
travail (ISO 20347:2021)

Persönliche Schutzausrüstung - Berufsschuhe (ISO
20347:2021)

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European foreword

This document (EN ISO 20347:2022) has been prepared by Technical Committee ISO/TC 94 "Personal safety -- Personal protective equipment" in collaboration with Technical Committee CEN/TC 161 "Foot and leg protectors" the secretariat of which is held by BSI.

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of an identical text or by endorsement, at the latest by September 2022, and conflicting national standards shall be withdrawn at the latest by March 2023.

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For the relationship with EU Directive(s) / Regulation(s), see informative Annex ZA, which is an integral part of this document.

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The text of ISO 20347:2021 has been approved by CEN as EN ISO 20347:2022 without any modification.

European foreword to Amendment 1

This document (EN ISO 20347:2022/A1:2024) has been prepared by Technical Committee ISO/TC 94 "Personal safety -- Personal protective equipment" in collaboration with Technical Committee CEN/TC 161 "Foot and leg protectors" the secretariat of which is held by BSI.

This Amendment to the European Standard EN ISO 20347:2022 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 2024, and conflicting national standards shall be withdrawn at the latest by August 2024.

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Endorsement notice

The text of ISO 20347:2021/Amd 1:2024 has been approved by CEN as EN ISO 20347:2022/A1:2024 without any modification.

Annex ZA (informative)

Relationship between this European Standard and the essential requirements of PPE Regulation (EU) 2016/425 aimed to be covered

This European Standard has been prepared under a Commission's standardization request M/571 to provide one voluntary means of conforming to essential requirements of REGULATION (EU) 2016/425 OF THE EUROPEAN PARLIAMENT AND OF THE COUNCIL of 9 March 2016 on personal protective equipment and repealing Council Directive 89/686/EEC.

Once this standard is cited in the Official Journal of the European Union under that REGULATION (EU) 2016/425, 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 Regulation, and associated EFTA regulations.

Table ZA.1 — Correspondence between this European Standard and Annex II of REGULATION (EU) 2016/425

ESSENTIAL HEALTH AND SAFETY REQUIREMENTS of REGULATION (EU) 2016/425	Clause(s)/sub-clause(s) of this EN ISO	Remarks/Notes
1.1 General requirements applicable to all PPE		
1.1.1 Ergonomics	5.3.3	
1.1.2.1 Optimum level of protection possible	5.3.3	
1.2.1 Absence of risks and other inherent nuisance factors	6.2.1, 6.2.5, 6.3	
1.2.1.1 Suitable constituent materials	5.3.5,	
1.2.1.2 Satisfactory surface condition of all PPE parts in contact with the user	5.3.3	
1.2.1.3 Maximum user impediment	5.3.3	
1.3 Comfort and efficiency		
1.3.1 Adaptation of PPE to user morphology	5.3.3	
1.3.2 Lightness and design strength	5.3.1.2, 5.4.3, 5.4.4, 5.4.5, 5.5.2, 5.7.4, 5.8.3, 5.8.4, 5.8.6, 6.2.1.4	
1.4 Information supplied by the manufacturer	Clause 7, Clause 8	
2.2 PPE enclosing the parts of the body to be protected	5.4.6; 5.5.4, 5.7.2, 5.7.3	
2.4 PPE subject to ageing	5.4.7, 5.8.5, 6.2, 6.4.1, 6.4.2, Clause 7 and Clause 8	

2.6 PPE for use in explosive atmospheres	6.2.2.1; 6.2.2.2	
2.12 PPE bearing one or more identification or recognition marks directly indirectly relating to health and safety	6.1 Table 14, Clause 7	
2.14 Multi-risk PPE	5.3.4, 6.2.1, 6.2.2, 6.2.3, 6.2.4, 6.2.5, 6.2.6, 6.2.7, 6.2.9, 6.4.1, 6.4.2	
3.1.2.1 Prevention of falls due to slipping	5.3.4, 6.2.9, 6.4.3	
3.3 Protection against mechanical injuries	5.5.2, 5.8.3, 6.2.1, 6.2.9	
3.6 Protection against heat and/or fire	6.2.3.1; 6.4.1	
3.7 Protection against cold	6.2.3.2	

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.

Contents

Page

Foreword	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Classification and designs	7
5 Basic requirements for occupational footwear	8
5.1 General	8
5.2 Design	10
5.2.1 General	10
5.2.2 Height of upper	10
5.2.3 Heel area	10
5.3 Whole footwear	11
5.3.1 Constructional performance	11
5.3.2 Leak proofness	11
5.3.3 Specific ergonomic features	11
5.3.4 Slip resistance	12
5.3.5 Innocuousness	12
5.3.6 Seam strength	12
5.4 Upper	12
5.4.1 General	12
5.4.2 Thickness	13
5.4.3 Tear strength	14
5.4.4 Tensile properties	14
5.4.5 Flexing resistance	14
5.4.6 Water vapour permeability and coefficient	14
5.4.7 Resistance to hydrolysis	15
5.5 Lining	15
5.5.1 General	15
5.5.2 Tear strength	15
5.5.3 Abrasion resistance	15
5.5.4 Water vapour permeability and coefficient	15
5.6 Tongue	16
5.6.1 General	16
5.6.2 Tear strength	16
5.7 Insole, insock and footbed	16
5.7.1 Thickness	16
5.7.2 Water permeability	16
5.7.3 Water absorption and desorption	16
5.7.4 Abrasion resistance	16
5.8 Outsole	17
5.8.1 General	17
5.8.2 Design	17
5.8.3 Tear strength	17
5.8.4 Abrasion resistance	18
5.8.5 Flexing resistance	18
5.8.6 Resistance to hydrolysis	18
5.8.7 Interlayer bond strength	18
6 Additional requirements for occupational footwear	18
6.1 General	18
6.2 Whole footwear	19
6.2.1 Perforation resistance	19
6.2.2 Electrical properties	21

6.2.3	Resistance to inimical environments	21
6.2.4	Energy absorption of seat region	21
6.2.5	Water resistance	21
6.2.6	Ankle protection	22
6.2.7	Cut resistance	22
6.2.8	Scuff cap abrasion	22
6.2.9	Slip resistance	22
6.3	Upper — Water penetration and absorption	23
6.4	Outsole	23
6.4.1	Resistance to hot contact	23
6.4.2	Resistance to fuel oil	23
6.4.3	Ladder grip	23
7	Marking	24
8	Manufacturer's instructions and information	25
8.1	General	25
8.2	Electrical properties	26
8.2.1	Partially conductive footwear	26
8.2.2	Antistatic footwear	26
8.3	Insocks	27
8.4	Perforation resistance	27
8.5	Date of obsolescence	27
Annex A (normative) Customized occupational footwear (occupational footwear adapted to fit an individual user or a single unit to fit an individual user)		29
Annex B (informative) Assessment of the footwear by the wearer		33
Annex C (informative) Slip resistance		35
Bibliography		38

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).

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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.

ISO 20347 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 161, *Foot and leg protectors*, in collaboration with Technical Committee ISO/TC 94, *Personal safety — Protective clothing and equipment*, Subcommittee SC 3, *Foot protection*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 20347:2012), which has been technically revised. The main changes compared to the previous edition are as follows:

- revision of the terms and definitions in [Clause 3](#);
- [Figure 1](#) to [Figure 4](#) revised;
- [Tables 1, 2](#) and [3](#) revised;
- heel area defined ([5.2.3](#));
- requirement on slip resistance revised ([5.3.4](#) and [6.2.9](#)); marking “SRA, SRB and SRC” deleted; marking “SR” and “Ø” introduced;
- pH value and chromium VI tests added in [5.3.5](#); former separate clauses under upper, lining, tongue and insole/insock deleted;
- requirement for seam strength of hybrid footwear added ([5.3.6](#));
- requirement for upper materials not fulfilling WVP explained ([5.4.6](#));
- abrasion of insoles revised ([5.7.4](#));
- outsole requirements revised ([5.8](#));
- outsole thickness revised ([5.8.2.1](#));
- flexing resistance of outsole clarified ([5.8.5](#));

- perforation resistant insert, depending on ISO 22568-3 and ISO 22568-4 exchanging EN 12568:2010;
- tolerance added ([6.2.3.1](#));
- former [Annex A](#) Hybrid Footwear included in the general text ([Table 2](#), [5.4.1.2](#));
- optional requirement on ankle protection clarified ([6.2.6](#));
- optional requirement for “SC” scuff caps added ([6.2.8](#));
- water penetration and absorption, symbol “WRU” deleted, symbol “WPA” introduced;
- optional requirement for “LG” Ladder grip of outsoles added ([6.4.3](#));
- marking revised ([Table 14](#) and 18);
- two new categories added, O6 and O7 ([Table 17](#));
- information on obsolescence date added ([8.5](#));
- [Annex A](#) with requirements for customized occupational footwear added;
- [Annex B](#) assessment of the footwear by the wearer added;
- [Annex C](#) Slip resistance added;
- requirement for electrically insulating footwear (EN 50321) deleted.

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.

Personal protective equipment — Occupational footwear

1 Scope

This document specifies basic and additional (optional) requirements for occupational footwear used for general purpose. It includes, for example, mechanical risks, slip resistance, thermal risks, ergonomic behaviour. It also specifies requirements for occupational footwear equipped with customized insoles, customized occupational footwear or individual manufactured customized occupational footwear. This standard does not cover the property of high visibility because of interaction with the clothing (e.g. trousers cover the footwear) and work area conditions (e.g. dirt, mud).

Special risks are covered by complementary job-related standards (e.g. footwear for firefighters, electrical insulating footwear, protection against chain saw injuries, protection against chemicals and against molten metal splash, protection for motorcycle riders).

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 20344:2021+Amd.1:2024 ^{A1}, *Personal protective equipment — Test methods for footwear*

EN 13832-3:2018, ^{A1} *Footwear protecting against chemicals — Part 3: Requirements for prolonged contact with chemicals* ^{A1}

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological 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/>

NOTE 1 The component parts of footwear are illustrated in [Figures 1, 2 and 3](#).

NOTE 2 Further terms and definitions can be found in ISO 19952^[1].

3.1

occupational footwear

footwear incorporating features to protect the wearer from injuries which could arise through accidents

3.2

upper

part or parts of a footwear that cover the toes, the top of the foot, the sides of the foot, and optionally the back of the heel; it is attached to the outsole of a footwear

3.3

leather

hide or skin tanned to be imperishable

3.3.1

leather split

flesh or middle part of a hide or skin, obtained by splitting a thick *leather* (3.3), which is tanned to be imperishable

3.4

rubber

type of elastic *polymeric material* (3.5) which can be vulcanized

3.5

polymeric material

large molecules composed of repeating structural units (monomer) typically connected by chemical bond

EXAMPLE Polyurethane (PU) or polyvinylchloride (PVC).

3.6

insole

non-removable component used to form the base of the shoe to which the *upper* (3.2) is usually attached during lasting

3.7

insock

removable or non-removable footwear component used to cover completely the *insole* (3.6)

3.7.1

seat sock

removable or non-removable footwear component used to cover the *insole* (3.6) in the heel area

3.7.2

footbed

insock (3.7) designed according to the sole of the foot with or without the aim of correcting the posture

Note 1 to entry: "Non-removable" means that the component cannot be removed without any damage.

Note 2 to entry: "Removable" means that the component can be removed, but the protective features are only maintained when it is placed into the footwear while wearing.

3.8

lining

material covering the inner surface of the footwear

Note 1 to entry: The wearer's foot is in direct contact with the lining.

Note 2 to entry: Where an upper is split at the forepart to house the toe puff, or if an external piece of material is stitched to the upper to form a pocket to house the toe puff, the material under the toe puff acts as a lining.

3.9

cleat

protruding part of the outer surface of the outsole

3.10

outsole

outermost part to provide footwear with the necessary traction and protection from the floor surfaces it will be in contact with

3.10.1

rigid outsole

outsole, which can be bent less than an angle of 45° under a load of 30 N

Note 1 to entry: According to  ISO 20344:2021+Amd.1:2024 , 8.5.

3.10.2**multi-layer outsole**

made up of two or more material layers completely covering the entire surface; a tread cover of less than 0,5 mm is not considered a layer

3.11**perforation-resistant insert**

component placed in the *outsole* (3.10) complex or used as an *insole* (3.6) simultaneously in order to provide protection against perforation

3.12**scuff caps**

abrasion resistant materials or component to protect against scuff of the upper external toe region

3.13**heel area**

counter (stiffener) area, rear part of the footwear

3.14**partially conductive footwear**

footwear with low electrical resistance between the wearer and the ground, able to dissipate static electricity

3.15**antistatic footwear**

footwear maintaining some electrical resistance between the wearer and the ground, able to dissipate some static electricity

3.16**fuel oil**

aliphatic hydrocarbon constituent of petroleum

3.17**customized occupational footwear**

covering all individual customized footwear and other specific conditions of a foot

Note 1 to entry: Customized occupational footwear integrate in their design the recipient's own physiognomy and the specific arrangements aimed at modifying, correcting, compensating, curing, preventing, relieving a pathology, e.g. overweight, diabetes, hyperhidrosis, misalignments etc ...

Note 2 to entry: Several types of customized occupational footwear and footwear adaptations exist:

Type 1 — equipped with customized insoles

Occupational footwear (according to this document) incorporating a customized insoles adapted to the wearers needs.

Type 2 — modified occupational footwear

Occupational footwear (according to this document) modified from its original construction to fit to an individual user.

See examples in ISO 21064:2017, 6.4

Type 3 — Bespoke occupational footwear

Occupational footwear (according to this document) constructed as a single unit to fit an individual user.

See examples in ISO 21064:2017, 6.3.2 and 6.3.3

Note 3 to entry: Adapted to fit an individual user or a single unit to fit an individual user.

Note 4 to entry: According to ISO 21064:2017, 3.2.