Test Report issued under the responsibility of:

TEST REPORT **EN 60204-1** **Safety of Machinery – Electrical equipment of machines** **Part 1: General requirements**	
Report Reference No......:	AOC250609004S
Compiled by (+ signature).....:	Steven Liu
Reviewed by (+ signature).....:	Johnson Wang
Approved by (+ signature).....:	Robin Liu
Date of issue.....:	May 1, 2025
Testing laboratory	
Name.....:	Shenzhen AOCE Electronic Technology Service Co., Ltd
Address.....:	Room 202, 2nd Floor, No.12th Building of Xinhe Tongfuyu Industrial Park, Fuhai Street, Baoan District, Shenzhen, Guangdong, China
Testing location.....:	Same as above
Client	
Name.....:	SHANDONG SUDIAO INTELLIGENT EQUIPMENT CO., LTD
Address.....:	NO. 6-11 BINHE INDUSTRIAL ZONE HUIHE STREET JIYANG DISTRICT JINAN SHANDONG CHINA
Test specification Standard.....:	EN 60204-1:2018; EN ISO 12100: 2010; EN 19085-1:2021; EN 19085-3:2021;
Test procedure .....:	Compliance with EN 60204-1:2018; EN ISO 12100: 2010; EN 19085-1:2021; EN 19085-3:2021;
Procedure deviation.....:	N/A
Test item Description.....:	CNC ROUTER
Trademark.....:	N/A
Model and/or type reference.....:	SD-1325CC, SD-6090, SD-1212, SD-1313, SD-1325, SD-1325R, SD-1325 STONE SD-1530, SD-1530, STONE, SD-1631, SD-2030, SD-2131, SD-2040, SD-2140 ATC, SD-2130, SD-2130 ATC, SD-2137, S3-1328DF, J1, D1-N, D1-E, M1, S1-4E, S2, S3, S5, S6, SD-1325S, SD-V1-12, SH-32, SS280, SS330, SS380
Manufacturer.....:	SHANDONG SUDIAO INTELLIGENT EQUIPMENT CO., LTD
Address.....:	NO. 6-11 BINHE INDUSTRIAL ZONE HUIHE STREET JIYANG DISTRICT JINAN SHANDONG CHINA
Rated.....:	AC 380V

Test case verdicts

Test case does not apply to the test object..... : N(/A)

Test item does meet the requirement..... : P(ass)

Test item does not meet the requirement..... : F(ail)

Testing

Date of receipt of test item ..... : April 21, 2025

Date(s) of performance of test..... : April 21, 2025 –May 1, 2025

General remarks

This test report shall not be reproduced except in full without the written approval of the testing laboratory.

The test results presented in this report relate only to the object tested and information given from applicant or manufacturer.

"(see appended table)" refers to a table appended to the report.

Throughout this report a comma is used as the decimal separator.

Additional information

This test report consist of:
1. Main Report
2. Annex A Tests of Continuity of the protective bonding circuit
   Insulation resistance tests
   Voltage tests
3. Annex B Product photo-documents

Copy of marking plate:

CNC ROUTER
SD-1325CC
AC 380V

Manufacturer: SHANDONG SUDIAO INTELLIGENT EQUIPMENT CO., LTD
Address: NO. 6-11 BINHE INDUSTRIAL ZONE HUIHE STREET JIYANG DISTRICT JINAN SHANDONG CHINA

Made in China

Examination types of machine

1.2. The category is described hereafter:

Model:	Main test model: SD-1325CC
Test items particulars:	N/A
Modifications allowed:	No
Ambient temperature range (°C):	15~30°C
Humidity range:	<60%
Altitude:	< 1000m above sea level
Environmental requirements:	N/A
Radiation:	N/A
Vibration, shock:	No hazard
Special installation and operation requirements:	See instruction
Anticipated voltage fluctuations (if more than ± 10 %):	N/A
Anticipated frequency fluctuations (if more than in cl. 4.3.2):	--
- specification of short-term value:	N/A
Indicate of possible future changes in electrical equipment:	N/A
Indicate for each source of electrical supply the requirements:	--
- nominal voltage (V):	N/A
- number of phases:	N/A
- frequency(Hz):	N/A
- prospective short-circuit current at point of supply to machine:	N/A
- fluctuations outside to values given in cl. 4.3.2:	± 10 %
Type of power supply earthing:	Pass
Electrical equipment to be connected to neutral (N):	--
User or supplier provide overcurrent protection of the supply conductors:	Pass
- type and rating of overcurrent protective device:	N/A
- settings of protective device:	No possible to set
Supply disconnecting device:	Appliance inlet
- disconnection of neutral (N) conductor required:	No
- link for neutral (N) permissible:	--
- type of disconnecting device to be provided:	Appliance inlet
Limit of power up to which three-phase AC-motors may be started directly across the incoming supply lines:	Pass

May number of motor overload detection devices be reduced:	N/A
Where machine is equipped with local lighting:	N/A
- highest permissible voltage:	N/A
- if lighting circuit voltage is not obtained directly from the power supply, state preferred voltage:	N/A
Functional identification:	Pass
Inscriptions / special markings:	See below
- mark of certification:	CE symbol provided
- on electrical equipment:	Pass
- language :	English
Technical documentation (media, language):	Provided by English or local official language
Size, location and purpose of ducts, open cable trays or cable-supports to be provided by the user:	N/A
For which of following classes of persons is access to the interior of the switchgear cabinets required during normal operation of the equipment:	Pass
Locks with removable keys provided for fastening doors or covers :	Pass
Type of two-hand control to be provided:	N/A
- where it is type III, time limit (max. 0,5 s) within which each pair of push-buttons are to be operated:	N/A
Indicate special limitations on size or weight which affect the transport of a particular machine or control gear assemblies to the installation site:	Pass
- maximum dimensions(mm):	--
- maximum weight:	--
Repetition of manual controlled cycles of operation:	N/A
- length of time expected that machine will be operated at this rate without subsequent pause:	N/A
Certificate for operating tests	Pass
- with the loaded machine to be supplied (specially built machines):	N/A
- on a loaded prototype machine to be supplied (normal machines):	Pass
Time delay for cableless control systems:	N/A
Specific method of conductor identification to be used:	N/A

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict

1	**Scope**		--
	This standard applies to the application electrical and electronic equipment and systems to machines.	The product is within the scope of EN 60204-1 for industrial use.	**Pass**

4	**General requirements**		--
4.1	General		**Pass**
4.2	Selection of equipment		**Pass**
4.3	The electrical equipment shall operate correctly under full load.	According to marking on the equipment and function test, the electrical equipment would operate correctly.	**Pass**
4.3.1	a.c. supplies	AC supplies	**Pass**
	Voltage variations: 0,9 - 1,1		**Pass**
	Frequency variation: 0,99 - 1,01 0,98 - 1,02	Ditto	**N/A**
	Harmonics distortion: 10% 2nd to 5th harmonics 12% 6th to 30th harmonics	Ditto	**N/A**
	Voltage unbalance in 3-phase supplies	Ditto	**Pass**
	Voltage impulses (1,5ms ....)	Ditto	**N/A**
	Voltage interruption (3ms)	Ditto	**N/A**
	Voltage dips (20%)	Ditto	**N/A**
4.3.2	d.c. supplies		**N/A**
	From batteries:		**N/A**
	Voltage variations: 0,85 - 1,15 0,7 - 1,2		**N/A**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
	Voltage interruption (5ms)		**N/A**
	From converting equipment		**N/A**
	Voltages variations: 0,85 - 1,15 0,7 - 1,2		**N/A**
	Voltage interruption (5ms)		**N/A**
	Ripple (0,05% of nom. voltage)		**N/A**
4.4	Physical environment and operating condition	Reference to instruction	**--**
4.4.1	Electromagnetic compatibility (EMC)		**Pass**
	Withstand test specified in EN61004-6-4 , EN61000-6-2	Complies	**Pass**
4.4.2.	Temperature, between 5°C to 40 °C Average temp. not more than +35°C	According to the instruction manual, this machine is designed within this range.	**Pass**
	Temperature, between 5°C to 40 °C	Ditto	**Pass**
4.4.3.	Humidity:	Ditto	**Pass**
4.4.4.	Altitude: max 1000m	Ditto	**Pass**
4.4.5.	Contaminants: Adequate protection against the ingress of solid bodies and liquids.	The clause has been met. metal enclosure used and comply with IPX0 requirement according to IEC 60529	**Pass**
4.4.6.	Ionizing and non-ionizing radiation: When the equipment is subject to radiation	Not applicable	**N/A**
4.4.7.	Vibration, shock and bump.	No particular requirements for vibration, shock & bump are found required, unless otherwise special agreement.	**Pass**
4.5	Transportation and storage. -25 to +55 °C and short periods up to +70 °C	According to safe instruction of instruction manual, this machine is designed within this range.	**Pass**
4.6	Provisions for handling. Suitable means for handling by cranes or similar equipment.	Not applicable	**N/A**
4.7	Installation and operation Suppliers instruction	All the electrical equipment have been installed, and operated in accordance with the supplier‘s manual.	**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict

5.0	**Incoming supply conductors termination and devices for disconnecting and switching of.**		**--**
5.1	Incoming supply conductor termination		**--**
	Single or multiple power supply		**Pass**
	Separate terminals	Separate terminals have been provided.	**Pass**
	Plug provided with the machine	Not applicable	**N/A**
	Neutral conductor labelled and marked in installation instruction.		**N/A**
	Connection between protective earth and neutral.		**Pass**
	Identification of incoming supply connection.		**Pass**
5.2	External protective conductor terminal	No such terminals	**N/A**
	The placing of the terminal		**N/A**
	Size of the terminal		**N/A**
	Marking of the external protective conductor with letters “PE”		**N/A**
	Other protective terminals shall be marked with the symbol 417-IEC-5019 or by use of bicolour combination GREEN-AND-YELLOW		**N/A**
5.3	Supply disconnecting (isolating) device		**--**
5.3.1	Hand operated disconnect device for each incoming device.		**N/A**
	Interlocks		**N/A**
5.3.2	a) Switch-disconnecting device b) A disconnector with auxiliary device c) Circuit breaker d) Plug / socket combination.		**N/A**
5.3.3	Requirements		**--**
5.3.3.1	General		**Pass**
	Marked with “I” and “O”		**N/A**
	When “Off” then all conductors are open		**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
	Have an external operating handle. Not emergency stop device and not RED.		**Pass**
	Means to be locked in “OFF” position		**Pass**
	Disconnect all live conductors		**N/A**
	Breaking capacity		**N/A**
5.3.3.2	Power operated circuit-breakers		**N/A**
	Means for manual operation		**N/A**
	Manual as well as remote closing		**N/A**
5.3.4	Disconnect device shall be easily accessible. 0,6 and 1,9 m		**Pass**
5.3.5	Excepted circuits - lightning - plug / Socked circuits - Undervoltage protection - Circuits supplying equipment - Control circuits	No excepted circuit	**N/A**
	Warning label for excepted circuits - Warning label at disconnect device - Warning label at each circuit - Statement in maintenance manual	Not applicable	**N/A**
5.4	Not applicable		**N/A**
5.5	Devices for disconnecting electrical equipment		**N/A**
5.6	Protection against unauthorized, inadvertent and/or mistaken connection		**N/A**
6	**Protection against electric shock**		**--**
6.1	General: Protections against: - direct contact; and - indirect contact	According clause 6.2. and 6.3., No PELV of clause 6.4., it is not applicable.	**Pass**
6.2	Protection against direct contact. 6.2.1. and 6.2.2. are applicable and 6.2.3. shall be applied		**Pass**
6.2.1	Protection by enclosures.		**Pass**
	Minimum protection : IP4X or IPXXB		**N/A**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
a)	Use of key or tool for access for skilled persons.		**N/A**
	Minimum requirement inside doors: IP1X or IPXXA		**N/A**
	Minimum requirement inside doors for live parts which are likely to be touched: IP2X or IPXXB		**Pass**
	Rooms used as enclosures which are accessible only to skilled persons, then IEC 364-4-41, IEC 364-4-47 and EN 60439-1 apply.	Not applicable	**N/A**
b)	Interlocking of doors		**N/A**
	Device or tools to defeat the interlock		**N/A**
	Disconnect device shall be protected against direct contact to at least IP2X or IPXXB		**N/A**
	Warning sign according to 18.2		**N/A**
c)	without use of key or tool		**N/A**
	Protected against direct contact to at least IP2X or IPXXB		**N/A**
	Where barriers are used then tool or disconnect device are required.		**N/A**
6.2.2	Protection by insulation of live parts		**Pass**
	Live part shall be covered by insulation which withstand mechanical, chemical, electrical and thermal stresses during normal service conditions.		**Pass**
	Protection against residual voltages		**Pass**
	After disconnection the voltage shall drop to 60V or less within 5 second.		**Pass**
	Exemption: - Components with stored charge of 60μC or less or - If the rate of discharge does interfere with the proper function of the equipment.	No this situation	**N/A**
	Warning notice located on or adjacent to the enclosure.	No this situation	**N/A**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
	Plugs: Discharge time shall not exceed 1 second.	No this situation	**N/A**
	Exemption: The conductors are protected against direct contact to at least IP2X or IPXXB.	No this situation	**N/A**
6.3	Protection against indirect contact		**Pass**
	Hazardous condition when insulation fails between live parts and exposed conductive parts.	According to clause 6.3.2. and 6.3.3. to fulfil with statement.	**Pass**
	Each circuit or part one of 6.3.1, 6.3.2 or 6.3.3 shall be applied.	See following test	**Pass**
6.3.1	Protection by automatic disconnection of supply.	No device of able automatic disconnection of supply	**N/A**
	Protective bonding circ		**N/A**
	Protective device for automatic disconnection of the supply in case of insulation failure.		**N/A**
	Co-ordination between type of power supply and disconnect device accordance with 413.1 of IEC 364-4-41		**N/A**
6.3.2	Protection by use of Class II equipment or by equivalent insulation		**N/A**
	- Use of class II electrical device or reinforced or by equivalent insulation.		**N/A**
	- Use of switchgear and controlgear assemblies		**N/A**
	- application of supplementary or reinforced insulation according to IEC 364-4-41		**N/A**
6.3.3	Protection by electrical separation		**Pass**
	Electrical separation by an individual circuit to prevent shock current through contact with exposed conductive parts. IEC 364-4-41 shall apply.		**Pass**
6.4	Protection by use of PELV (Protective Extra Low Voltage).	No PELV circuit	**N/A**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
	PELV shall satisfy all of the following conditions: a) Max 25 Vac or 60Vdc b) Max current when failure to 1A a.c. or 0,2A d.c. c) Max 80 mm2 of area not protected. d) Only indoor with dry condition. e) Source of supply shall be insulated according to with higher voltage according to 6.3.3 and 15.1.3 f) PELV circuit shall be bonded to protective earth. g) Exposed conductive parts associated with PELV shall be insulated or bonded. h) Plugs and socket outlets: 1) Plugs shall not be able to enter other sockets than in PELV circuits 2) Socket outlets shall exclude plugs from other circuits than PELV i) Where this circuits are used as control circuits then they shall also fulfil the relevant requirements of clause 9.		**N/A**
7	**Protection of equipment**		**--**
7.1	General		**Pass**
7.2	Overcurrent protection		**Pass**
7.2.1	Supply conductors		**Pass**
	The supplier is not responsible for the overcurrent device for the supply conductors.		**Pass**
	Installation diagram with data necessary for selection of overcurrent protective device.		**Pass**
7.2.2	Power circuits		**Pass**
	All live conductors except earthed neutral conductor shall be protected against overcurrent.		**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
	Cross section area for Neutral conductor is at least equal to or equivalent to that of the phase conductors. It is not necessary		**N/A**
	For Neutral conductors smaller than phase conductors then IEC 60364-4-473 shall apply	The clause has been met.	**Pass**
	For IT power system it is generally necessary to provide an overcurrent protection.	No IT power system	**N/A**
7.2.3	Control circuits		**Pass**
	Conductors for control circuits connected to supply voltage shall be protected against overcurrent according to 7.2.2	Conductors for control circuit have overcurrent protective device in approved switch power supply.	**Pass**
	Control circuits feed through a transformer		**N/A**
7.2.4	Socket outlets and their associated conductors		**Pass**
	Overcurrent protection is required for socket outlets		**Pass**
	Provided in phase conductors	Not applicable	**N/A**
7.2.5	Local lightning circuits	Without local lighting circuit	**N/A**
	Separate protected by overcurrent device	Not applicable	**N/A**
7.2.6	Transformers		**N/A**
	Transformers shall be protected against overcurrent in accordance with IEC 76-5 and EN 60742	Not applicable	**N/A**
7.2.7	Location of overcurrent protective device		**Pass**
	Overcurrent protective device shall be located where the conductors are connected to the power supply.		**Pass**
7.2.8	Overcurrent protective device		**Pass**
	The breaking capacity		**Pass**
7.2.9	Rating and setting of overcurrent device		**Pass**
7.3	Overload protection of motors		**Pass**
7.4	Abnormal temperature protection		**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
7.5	Protection against supply interruption or voltage reduction and subsequent restoration		**Pass**
7.6	Motor overspeed protection		**Pass**
7.7	Earth fault/residual current protection	Not applicable	**N/A**
7.8	Phase sequence port	Not applicable	**N/A**
7.9	Protection against overvoltages due to lightning and to switching surges	Not applicable	**N/A**
8	**Equipotent bonding**		**--**
8.1	General		**Pass**
8.2	Protective bonding circuit		**Pass**
8.2.1	General		**Pass**
8.2.2	Protective conductors		**Pass**
8.2.3	Continuity of the protective bonding circuit		**Pass**
8.2.4	Exclusion of switching devices from the protective bonding circuit	No this device	**N/A**
8.2.5	Parts which need not to be connected to the protective bonding circuit		**Pass**
8.2.6	Interruption of the protective bonding circuits		**Pass**
	Protective conductor connecting points		**Pass**
8.2.7	Mobile machines	No this situation	**N/A**
8.2.8	Additional protective bonding requirements for electrical equipment having earth leakage currents higher than 10mA a.c. or d.c.		**N/A**
8.3	Bonding to the protective circuit for operational purposes	No this situation	**N/A**
8.4	insulation failures Measures to limit the effects of high leakage current	Adequate protection has been provided.	**N/A**
8.5	Bonding to a common reference potential	No this situation	**N/A**
8.6	Electrical interference	No this situation	**N/A**
9	**Control circuits and control functions**		**--**
9.1	Control circuits		**--**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
9.1.1	Control circuit supply		**Pass**
9.1.2	Control circuit voltages		**Pass**
9.1.3	Protections		**Pass**
9.1.4	Connection to control devices		**Pass**
9.2	Control function		**Pass**
9.2.1	Start functions		**Pass**
9.2.2	Stop functions		**Pass**
9.2.3	Operating modes		**N/A**
9.2.4	Suspensions of safeguards		**N/A**
9.2.5	Operation		**Pass**
9.2.5.1	General		**Pass**
9.2.5.2	Start		**Pass**
	Interlocks		**N/A**
	Machines which require more than one control station to indicate a start.	Not applicable	**N/A**
9.2.5.3	Stop		**Pass**
	Interlocks		**N/A**
	The reset of the stop function		**N/A**
	Machines which require more than one control station to indicate a start.	Not applicable, only one starts.	**N/A**
9.2.5.4	Emergency stop		**Pass**
9.2.5.5	Monitoring of command actions		**N/A**
9.2.6	Other control functions		**N/A**
9.2.6.1	Hold-to-run controls	No this device	**N/A**
9.2.6.2	Two-hand control	No this device	**N/A**
9.2.6.3	Enabling control		**N/A**
9.2.6.4	Combined start and stop controls		**N/A**
9.2.7	Cableless control	Not applicable	**N/A**
9.3	Protective interlocks		**N/A**
9.3.1	Restoration of interlocked safeguards	Not applicable	**N/A**
9.3.2	Overtravel limits		**N/A**
9.3.3	Operation of auxiliary functions	Not applicable	**N/A**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
9.3.4	Interlocks between different operations and for contrary motions		**N/A**
9.3.5	Reverse current breaking	No this device	**N/A**
9.4	Control functions in case of failure		**N/A**
9.4.1	General requirements		**N/A**
9.4.2	Measures to minimize risk in case of failure		**N/A**
9.4.2.1	Use of proven circuit techniques and components		**N/A**
9.4.2.2	Provision of redundancy		**N/A**
9.4.2.3	Use of diversity		**N/A**
9.4.2.4	Functional test		**N/A**
9.4.3	Protection against maloperations due to earth faults and voltage interruption		**N/A**
9.4.3.1	Earth faults		**N/A**
9.4.3.2	Voltage interruptions		**N/A**
9.4.3.3	Loss of circuit continuity		**N/A**
10	**Operator interface and machine mounted control devices**		**--**
10.1	General	Comply with requirement	**Pass**
10.1.1	Location and mounting		**Pass**
10.1.2	Protection		**Pass**
10.1.3	Position sensors	Not applicable	**N/A**
10.2	Push-buttons		**Pass**
10.2.1	Colours		**Pass**
10.2.2	Markings	Markings are compliance with IEC-417	**Pass**
10.3	Indicator lights and displays		**Pass**
10.3.1	Modes of use		**Pass**
10.3.2	Colours		**Pass**
10.3.3	Flashing lights	No this device	**N/A**
10.4	Illuminated push-buttons		**Pass**
10.5	Rotary control devices	Not applicable	**N/A**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
10.6	Start devices	They are constructed to minimize inadvertent operation.	**N/A**
10.7	Emergency stop devices		**Pass**
10.7.1	Location of emergency stop devices E		**Pass**
10.7.2	Types		**Pass**
10.7.3	Colour of actuators		**Pass**
10.7.4	Local operation of the supply disconnecting device to effect emergency stop		**Pass**
10.7.5	Use of means of disconnection	No this situation	**N/A**
10.8	Emergency switching off device		**Pass**
10.8.1	Location		**Pass**
10.8.2	Types		**Pass**
10.8.3	Colour of actuators		**Pass**
10.8.4	Local operation of the supply disconnecting device to effect emergency switching off		**Pass**
10.9	Enabling control device		**Pass**
11	**Electronic equipment**		**--**
11.1	General		**Pass**
11.2	Basic requirements	Indications of state about input and output are supplied.	**Pass**
11.2.2	Electronic control equipment		**Pass**
11.2.3	Equipotent bonding		**N/A**
11.3	Programmable equipment	Not applicable	**N/A**
11.3.1	Programmable controllers	Not applicable	**N/A**
11.3.2	Memory retention and protection	The clause has been met.	**Pass**
11.3.3	Programming equipment	Not applicable	**N/A**
11.3.4	Software verification	Software verification has been carried out.	**N/A**
11.3.5	Use in safety-related functions	It has been tested.	**Pass**
11	**Controlgear: location, mounting and enclosures**		**--**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
11.1	General requirements		**Pass**
11.2	Location and mounting		**Pass**
11.2.1	Accessibility and maintenance	Not applicable	**N/A**
11.2.2	Segregation		**Pass**
11.2.3	Heating effects		**Pass**
11.3	Degrees of protection		**Pass**
11.4	Enclosures, doors and openings		**Pass**
11.5	Access to controlgear Minimum dimension of gangways	No this situation	**N/A**
12	**Conductors and cables**		**--**
12.1	General requirements		**Pass**
12.1	General requirements	Suitable for the operating condition.	**Pass**
12.2	Conductors		**Pass**
12.3	Insulation		**Pass**
12.4	Current carrying capacity in normal service		**Pass**
12.5	Voltage drop		**Pass**
12.6	Minimum cross-section area		**Pass**
12.6	Flexible cables		**Pass**
12.6.1	General		**Pass**
12.6.2	Mechanical rating		**Pass**
12.6.3	Current-carrying capacity of cables wound on drums		**Pass**
12.7	Collector wires, collector bars and slip-ring assemblies		**N/A**
12.7.1	Protection of against direct contact		**Pass**
17.2	Protective conductor circuit	Not applicable	**N/A**
12.7.3	Protective conductor current collectors	Not applicable	**N/A**
12.7.4	Removable current collectors with a disconnector function	Not applicable	**N/A**
12.7.5	Clearances in air (IEC60664-1)		**Pass**
12.7.6	Creepage distance (IEC60664-1)		**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
12.7.7	Conductor system section	Not applicable	**N/A**
12.7.8	Construction and installation		**Pass**
13	**Wiring practices**		**--**
13.1	Connection and routing		**Pass**
13.1.1	General requirements	Compliance by inspection	**Pass**
13.1.2	Conductor and cable runs	Compliance by inspection	**Pass**
13.1.3	Conductors of different circuits	Compliance by inspection	**Pass**
13.2	Identification of conductors		**Pass**
13.2.1	General requirements	Conductors can be identifiable	**Pass**
13.2.2	Identification of the protective conductor		**Pass**
13.2.3	Identification of Neutral conductor		**Pass**
13.2.4	Identification by colour		**Pass**
13.3	Wiring inside enclosures	Compliance by inspection	**Pass**
13.4	Wiring outside enclosures		**Pass**
13.4.1	General requirements	IP is the same with enclosure.	**Pass**
13.24.2	External ducts	Compliance by inspection	**Pass**
13.4.3	Connection to moving elements of the machine	No this situation	**N/A**
13.4.4	Interconnection of devices on the machine	Compliance by inspection	**Pass**
13.4.5	Plug and socket connection		**Pass**
13.4.6	Dismantling for shipment	Compliance by inspection of instruction manual	**Pass**
13.4.7	Additional conductors	Not applicable	**N/A**
13.5	Ducts, connection and junction boxes		**Pass**
13.5.1	General requirements	No sharp edges	**Pass**
13.5.2	Percentage fill of ducts	Suitable	**Pass**
13.5.3	Rigid metal conduit and fittings	Conduits are securely held in place.	**Pass**
13.5.4	Flexible metal conduit and fittings		**Pass**
13.5.5	Flexible non-metal conduit and fittings		**N/A**
13.5.6	Cable trunking systems		**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
13.5.7	Machines compartments and cable trunking systems	Not applicable	**N/A**
13.5.8	Connection boxes and other boxes		**Pass**
13.5.9	Motor connection boxes		**Pass**
14	**Electric motors and associated equipment**		**--**
14.1	General requirements (IEC60034)		**Pass**
14.2	Motor enclosures		**Pass**
14.3	Motor dimensions (IEC60072)		**Pass**
14.4	Motor mounting and compartments		**Pass**
14.5	Criteria for motor selections		**N/A**
14.6	Protective devices for mechanical brakes		**N/A**
15	**Accessories and lightning**		
15.1	Accessories	No accessories	**N/A**
15.2	Local lightning of the machines and equipment		**N/A**
15.2.1	General		**N/A**
15.2.2	Supply		**N/A**
15.2.3	Protection		**N/A**
15.2.4	Fittings		**N/A**
16	**Marking, warning signs and reference designation**		**--**
16.1	General--Nameplates, marking and identification plates	Nameplates, marking and identification plates have been provided.	**Pass**
16.2	Warning signs		**Pass**
16.2.1	Electric shock hazard	Machine is marked with warning signs.	**Pass**
16.2.2	Hot surfaces hazard	Machine is marked with warning signs.	**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
16.3	Functional identification	According to symbol of panel and instruction manual, it is met.	**Pass**
16.4	Marking of control equipment	Marking of equipment is checked by inspection.	**Pass**
16.5	Reference designations	The clause has been met.	**Pass**
17	**Technical documentation**		**--**
17.1	General	English approved	**Pass**
17.2	Information to be provided	The clause has been met.	**Pass**
17.3	Requirements applicable to all documentation	These documents are: Installation diagram, Circuit diagram, Parts list of electrical components, Marking, Instruction manual	**Pass**
18.4	Basic information	Information is fulfilled.	**Pass**
17.4	Installation diagram Documents	Installation diagram is checked by inspection.	**Pass**
17.5	System (bloc) diagram Overview diagrams and function diagrams	The clause has been met.	**Pass**
17.6	Circuit diagrams	Circuit diagram is checked by inspection.	**Pass**
17.7	Operating manual	Operating of instruction manual is checked by inspection.	**Pass**
17.8	Maintenance manual	Maintenance of instruction manual is checked by inspection.	**Pass**
17.9	Part list	Parts list of electrical components is checked by inspection.	**Pass**
18	**Verification**		**--**
18.1	General	See the following test reports of annex A	**Pass**
18.2	Continuity of the protective bonding circuit	circuit Refer to the Test report	**Pass**
18.3	Insulation resistance test	Refer to the Test report	**Pass**
18.4	Voltage	Refer to the Test report	**Pass**

EN 60204-1			
Clause	Requirement – Test	Result - Remark	Verdict
18.5	Protection against residual voltages	Refer to the Test report	**Pass**
18.6	Functional	Functional tests have carried out.	**Pass**
18.7	Retesting	Refer to instruction manual, being the fulfilment with this statement.	**Pass**

EN 19085-1			
Clause	Requirement – Test	Result - Remark	Verdict
4	List of significant hazards		- -
5	Safety requirements and measures for controls		- -
5.1	Safety and reliability of control systems	See the requirements of ISO 13849-1:2015	Pass
5.2	Control devices	All hand-operated control devices shall be positioned ≥600 mm and ≤1 800 mm above floor level. For electric control devices, see also IEC 60204-1:2005, 10.1.2	Pass
5.3	Start		Pass
5.4	Safe stops		Pass
5.4.1	General	The stop function shall be realized according to IEC 60204-1:2005, 9.2.2	Pass
5.4.2	Normal stop		Pass
5.4.3	Operational stop		Pass
5.4.4	Emergency stop	Comply with the requirements of ISO 13850:2015	Pass
5.5	Braking function of tool spindles		Pass
5.6	Mode selection		Pass
5.7	Spindle speed changing		Pass
5.7.1	Spindle speed changing by changing belts on the pulleys		Pass
5.7.2	Spindle speed changing by incremental speed change motor		Pass
5.7.3	Infinitely variable speed by frequency inverter		Pass
5.8	Failure of any power supply	For electric supply, see IEC 60204-1:2005, 7.5. The requirements of ISO 14118:2000, Clause 6 apply.	Pass
5.9	Manual reset control	The requirements of ISO 13849-1:2015, 5.2.2 apply.	Pass

EN 19085-1			
Clause	Requirement – Test	Result - Remark	Verdict
5.10	Enabling control .	The requirements of IEC 60204-1:2005, 9.2.6.3 and 10.9 apply.	Pass
5.11	Machine moving parts speed monitoring	For software requirements, see ISO 13849-1:2015, 4.6	Pass
5.12	Time delay	The SRP/CS for the delay function shall achieve PL r = c.	Pass
6	Safety requirements and measures for protection against mechanical hazards		- -
6.1	Stability		Pass
6.1.1	Stationary machines		Pass
6.1.2	Displaceable machines		Pass
6.2	Risk of break-up during operation		Pass
6.3	Tool holder and tool design		Pass
6.3.1	General		Pass
6.3.2	Spindle locking	an integral locking bar	Pass
6.3.3	Circular saw blade fixing device		N/A
6.3.4	Flange dimension for circular saws blades		N/A
6.4	Braking		Pass
6.4.1	Braking of tool spindles		Pass
6.4.2	Maximum run-down time	The maximum run-down time shall be 10 s.	Pass
6.4.3	Brake release	The SRP/CS for the interlocking shall achieve PL r = c.	Pass
6.5	Safeguards		Pass
6.5.1	Fixed guards	Fixed guards shall be designed in accordance with ISO 14120:2015.	Pass
6.5.2	Interlocking movable guards	Movable guards shall be designed in accordance with ISO 14120:2015	Pass
6.5.3	Hold-to-run control	a hold-to-run according	Pass

EN 19085-1			
Clause	Requirement – Test	Result - Remark	Verdict
		to IEC 60204-1:2005, 9.2.6.1, the following requirements apply	
6.5.4	Two-hand control		N/A
6.5.5	Electro-sensitive protective equipment (ESPE)		Pass
6.5.6	Pressure-sensitive protective equipment (PSPE)		Pass
6.6	Prevention of access to moving parts		Pass
6.6.1	General		Pass
6.6.2	Guarding of tools		Pass
6.6.3	Guarding of drives		Pass
6.6.4	Guarding of shearing and/or crushing zones		Pass
6.7	Impact hazard	the speed of these movements shall not exceed 25 m/min	Pass
6.8	Clamping devices	two-stage clamping with a maximum clamping force at the clamping device of 50 N for the first stage, followed by full clamping force actuated by a manual control	Pass
6.9	Measures against ejection		Pass
6.9.1	General		Pass
6.9.2	Guards materials and characteristics		Pass
6.10	Work-piece supports and guides		Pass
7	Safety requirements and measures for protection against other hazards		- -
7.1	Fire		Pass
7.2	Noise		Pass
7.2.1	Noise reduction at the design stage	When designing machinery, the information and technical measures to control noise at source given in	Pass

EN 19085-1			
Clause	Requirement – Test	Result - Remark	Verdict
		ISO/TR 11688-1:1995 shall be taken into account	
7.2.2	Noise emission measurement		Pass
7.3	Emission of chips and dust		Pass
7.4	Electricity		Pass
7.4.1	General		Pass
7.4.2	Displaceable machines	If the power supply cord is permanently fitted to the machines, it shall be of type H07 or better in accordance with the requirements of EN 50525-2-21:2011	Pass
7.5	Ergonomics and handling	The machine and its controls shall be designed according to ergonomic principles (see EN 1005-4) for work posture which is not fatiguing	Pass
7.6	Lighting		Pass
7.7	Pneumatics	For machines fitted with pneumatic equipment, the requirements of ISO 4414:2010 apply.	Pass
7.8	Hydraulics	For machines fitted with hydraulic equipment, the requirements of ISO 4413:2010 apply.	Pass
7.9	Electromagnetic compatibility	The machine shall have sufficient immunity to electromagnetic disturbances to enable it to operate	Pass

EN 19085-1			
Clause	Requirement – Test	Result - Remark	Verdict
		correctly in accordance with IEC 61439-1:2011, EN 50370-1:2005 and EN 50370-2:2003	
7.10	Laser	If the machine is fitted with a laser to indicate the cutting lines, the laser shall be of category 2, 2M or a lower risk category in accordance with the requirements of IEC 60825-1:2014.	Pass
7.11	Static electricity		Pass
7.12	Errors of fitting		Pass
7.13	Isolation	The requirements of ISO 12100:2010, 6.3.5.4 and of ISO 14118:2000, Clause 5 apply and in addition, the following.	Pass
7.14	Maintenance	The basic principles of ISO 12100:2010, 6.2.15 shall beobserved, and in addition, at least the Information for maintenance listed in ISO 12100:2010, 6.4.5.1 e) shall be provided.	Pass
8	Information for use		- -
8.1	Warning devices	The basic principles of ISO 12100:2010, 6.4.3 shall be observed	Pass
8.2	Marking		Pass
8.2.1	General	If graphical symbols related to the operation of actuators are used, they	Pass

EN 19085-1			
Clause	Requirement – Test	Result - Remark	Verdict
		shall be in accordance with IEC 61310-1:2007, Table A.1. The principles of ISO 12100:2010, 6.4.4 shall be observed	
8.2.2	Additional markings	The following additional information shall be marked legibly and indelibly throughout the expected life of the machine, either directly on the machine	Pass
8.3	Instruction handbook		Pass
8.3.1	General	The principles of ISO 12100:2010, 6.4.5 shall be observed	Pass
8.3.2	Additional information	a) instruction for safe use shall also include: 1) when using milling tools with diameter ⩾16 mm and circular saw-blades, they shall conform to EN 847-1:2013 and EN 847-2:2013; tool holders shall conform to EN 847-3:2013; 2) work-piece to be adequately supported during machining /feeding using, where necessary, additional support, e.g. for long work-pieces; b) that where the noise enclosures (if provided) are not	Pass

EN 19085-1			
Clause	Requirement – Test	Result - Remark	Verdict
		interlocked (see 6.6), the noise enclosures shall remain in the closed position as long as possible to ensure the most efficient noise reduction; c) to stop the machine whilst unattended; d) information that before manually changing any tool, the spindles shall be stopped, to wait for standstill of all tools and that the unexpected start-up shall be prevented.	

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
4	List of significant hazards ----		----
	This Clause contains all significant hazards, hazardous situations and events (see ISO 12100:2010), identified by risk assessment as significant for the machines as defined in the scope and which require action to eliminate or reduce the risk. This document deals with these significant hazards by defining safety requirements and/or measures or by reference to relevant standards. These hazards are listed in Table 1.		Pass
5	Safety requirements and measures for controls		----
5.1	Safety and reliability of control systems		----
	This subclause of ISO 19085-1:2017 applies.	This requirement is complied with.	Pass
5.2	Control devices		----
	This subclause of ISO 19085-1:2017 applies with the following additions, subdivided into further specific subclauses.	This requirement is complied with.	Pass
5.2.1	General		----
	The control devices for control power-on, operational/normal stop, emergency stop, mode selection shall be located at the operator's position adjacent to the control display (at the main control panel). Hold-to-run control devices and/or enabling control devices for tool or axes movements shall be located on the main control panel and/or on a hand-held set of controls connected to the machine by cable or wireless; As an exception to the requirement in ISO 19085-1:2017 at machines with more than one loading/unloading zone, the reset of the safeguarding system at the loading/unloading zone may be achieved by the manual control		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	device for cycle start. In this case reset and cycle start may occur at the same time. The emergency stop device shall be provided at each working station and in particular, a) at the main control panel, b) at the hand-held control set, c) adjacent to all hold-to-run control devices, d) at the workpiece loading and unloading station, e) close to or inside the tool magazine, where this is separated from the machining area and the magazine is under power during loading and unloading of the tools, f) inside any enclosure fitted with access door when required according 6.6.2.2, and g) adjacent to all cycle start control devices. If, in fulfilment of the above requirements, the distance between two separate emergency-stop devices results to be less than 1 m, one device is sufficient and its position can be chosen. Verification: By checking the relevant drawings and/or circuit diagrams, inspection of the machine and relevant functional testing of the machine.		
5.2.2	Hand-held control sets		----
	Additional control devices for cycle starting (not including reset function), operational/normal stopping (if provided) may be duplicated/provided on hand-held control sets with or without cable connection taking account of the requirements of 5.4.4 for emergency stop. Reset function control devices, control power-on control devices and mode selector shall not be fitted on hand-held control sets. When a wireless control set loses its connection to the machine, an emergency stop shall be automatically activated. Verification: By checking the relevant	This requirement is complied with.	Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	drawings and/or circuit diagrams, inspection of the machine and relevant functional testing of the machine.		
5.3	Start		----
	This subclause of ISO 19085-1:2017 is replaced by the following specific text. Control power-on activation shall only be possible if all relevant safeguards are in placeand operational. This is achieved by the interlocking arrangement, including PL required, described in 5.6, 6.5, 6.6 and 6.8. The control power-on device shall be protected against unintended actuation, e.g. by shroud. Cycle start or restart shall only be possible after actuation of a control device provided for that purpose, and after control power-on activation. The SRP/CS for control power-on and for interlocking of control power-on with safeguards shall achieve PL r = c. Closure of interlocking movable guards or moving away from a triggered ESPE or PSPE shall not lead to an automatic restart of dangerous movements. For each restart, a deliberate action of the operator is required, i.e. safeguard reset. If only one safeguard is triggered, safeguard local reset and cycle start may occur at the same time. Verification: By checking the relevant drawings and/or circuit diagrams, inspection of the machine and relevant functional testing of the machine.		Pass
5.4	Safe stops		----
5.4.1	General		----
	This subclause of ISO 19085-1:2017 applies with the following additions. At the end of stopping sequence, powered workpiece clamping devices may be de-energized if no		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	additional hazard will occur. Stop initiated by opening of moveable guards or activation/triggering of the safety related control system of a protective device shall be either a normal stop or an operational stop or an emergency stop. If the machine is divided into physically separated danger zones, actuators to be stopped may be only those of the relevant danger zone. In this case, a local manual reset control device is required.		
5.4.2	Normal stop		----
	This subclause of ISO 19085-1:2017 applies.		Pass
5.4.3	Operational stop		----
	This subclause of ISO 19085-1:2017 applies.		Pass
5.4.4	Emergency stop		----
	This subclause of ISO 19085-1:2017 applies.		Pass
5.5	Braking function of tool spindles		----
	This subclause of ISO 19085-1:2017 applies with the following addition. Only electric braking systems are allowed,except for a mechanical device for positioning and locking.		Pass
5.6	Mode selection		----
	This subclause of ISO 19085-1:2017 applies with the following addition, subdivided into further specific subclauses.		Pass
5.6.1	General		----
	In addition to the requirements in ISO 19085-1:2017, 5.6 a) to d), the following requirements also apply: a) the mode selection switch shall be located outside the hazards zone, e.g. on the main control panel and not reachable from inside the hazards zone; b) the safeguarding requirements given in 5.6.2, 5.6.3 and 5.6.4 shall be effective in their respective mode of operation.		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
5.6.2	In machining mode, movement shall only be possible when the interlocking moveable guards and protective devices are in place and functional. The safety related maximum speed of axes movement and spindle rotation shall fulfil the requirements of 5.11 and 5.7.3 respectively.		Pass
5.6.3	Machine setting mode [MODE 2]		----
	In machine setting mode of operation, when moveable guards are opened and protective devices disabled, any dangerous movement shall only be possible when all following requirements are met: a) spindle rotation, if provided, shall be controlled by a jog control together with an enabling control; the jog control need not achieve any PL r ; b) only one powered (physical or virtual) axis movement shall be possible at a time; The SRP/CS for the selection of the axis shall achieve PL r = b; c) any physical or virtual axis movement shall be controlled by a jog control together with an enabling control; the jog control need not achieve any PL r . The movement speed of each physical axis shall be limited to 2 m • min −1 according to 5.11. In addition, the movement speed of linear virtual axis (i.e. axis, vector or tangential speed) shall be limited to 2 m • min −1 without PL r , e.g. by PLC; d) if tool rotation is provided, it shall be limited to a maximum of 300 m • min −1 ; e) tool rotation shall stop in less than 2 revolutions after release of the enabling control device; the SRP/CS for monitoring the tool stopping in maximum of 2 revolutions shall achieve PL r = c;		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	f) speed monitoring in accordance with 5.7.3 shall be provided for spindle rotation; g) unexpected movement of the automatic tool change mechanism shall be prevented by SRP/CS achieving PL r = c. When crushing and shearing hazards exist, two-hand control device shall be provided; h) initiation of any other dangerous movement shall be prevented. The SRP/CS for prevention of unexpected start up shall achieve PL r = c.		
5.6.4	Clamping device manual positioning mode [MODE 3]		----
	For machines without bumpers or sensitive edges, trip bars or trip plates, in clamping device manual positioning mode with laser indication fitted to the moving machining head, if front side safeguards are disabled, any hazardous movement shall only be possible when all following requirements are met: a) spindle rotation shall not be allowed; b) machining head movement in direction where crushing and shearing hazards may occur shall be controlled by a jog control together with an enabling control. This axis movement speed shall be limited to 10 m • min −1 according to 5.11. The jog control does not need to achieve any PL r		Pass
5.7	Spindle speed changing		----
5.7.1	Spindle speed changing by changing belts on the pulleys		----
	This subclause of ISO 19085-1:2017 applies to milling aggregates with fixed spindle speed not controlled by inverter and for boring tools.	This requirement is complied with.	Pass
5.7.2	Spindle speed changing by incremental speed change motor		----
	This subclause of ISO 19085-1:2017 does		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	not apply.		
5.7.3	Infinitely variable speed by frequency inverter		----
	This subclause of ISO 19085-1:2017 applies with the following additions. As an exception to speed monitoring with the selected speed as limit value, the monitoring may use the maximum rotational speed of the tool. Unless the tool characteristics are automatically read from the tool, at least the maximum rotational speed of the tool needs to be set by the operator after loading of the tool changing system or after manual insertion of the tool. These stored data shall be displayed, and confirmed by the operator. Alternatively, tool ID can be confirmed if already associated with tool maximum rotational speed. When tool ID is edited, tool maximum rotational speed shall be confirmed. It shall not be possible to select a speed value higher than the maximum rotational speed of the tool stored in the memory of the control system (no PL r). NOTE During the next revision of this document, it is intended that it deals with requirements on tool identification. For spindles with speed pre-set at a fixed value and for spindles which are only capable of being used with boring tools, no speed monitoring is required.		Pass
5.8	Failure of any power supply		----
	This subclause of ISO 19085-1:2017 applies with the following addition. In the case of machines incorporating pneumatic/hydraulic clamping of the workpiece, in the event of a failure in the pneumatic or hydraulic power supply a normal or emergency stop shall be activated.		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
5.9	Manual reset control		----
	This subclause of ISO 19085-1:2017 applies.		Pass
5.10	Enabling control		----
	This subclause of ISO 19085-1:2017 applies.		Pass
5.11	Machine moving parts speed monitoring		----
	This subclause of ISO 19085-1:2017 applies.		Pass
5.12	Time delay		----
	This subclause of ISO 19085-1:2017 applies.		Pass
5.13	Teleservice		----
	This subclause is specific to this document. For machines equipped with teleservice facility, the following requirements apply. A secure connection line shall be in place between the provider of the teleservice and customer. The teleservice functions provided for diagnosis, functional software update and/or telecontrol shall be enabled from the machine side. Indication that the teleservice mode is activated shall be provided at the machine (noPL required), e.g. by a message on the screen. Any single machine shall be readily and clearly identifiable by the teleservice remote operator. The emergency stop control function at the machine shall take precedence over any command issued by the remote teleservice operator. Any teleservice operation shall not activate control power-on, nor mode selection and shall neither suspend nor reset any safeguardor safety function. Before software update, the machine shall be on, in normal stop condition and empty from workpieces. The telecontrol shall be activated with the machine operator present at the machine. A warning shall appear on the control panel		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	stating that the operator shall check that all safeguards are in place and operational, the machine is in automatic mode (MODE 1), and that the operator shall stay at the machine during all telecontrol operation checking that nobody else is around the machine. A confirmation of the above from the operator shall be required before starting the telecontrol function. (no PL required). After the teleservice operations are accomplished, a message shall appear on the control panel stating that the machine is ready to work. Verification: By checking the relevant drawings and/or circuit diagrams, inspection and relevant functional testing of the machine.		
6	Safety requirements and measures for protection against mechanical hazards		----
6.1	Stability		----
6.1	Stationary machines		----
	This subclause of ISO 19085-1:2017 applies with the following additions. The same requirement apply to any auxiliary equipment, e.g. vacuum pump. Unintended dangerous movements of the machine or part of it caused by gravity, pressure etc. shall be avoided, e.g. by mechanical blocking devices capable of withstanding the maximum load for which the machine is designed.		Pass
6.1.2	Displaceable machines		----
	This subclause of ISO 19085-1:2017 does not apply.		Pass
6.2	Risk of break-up during operation		----
	This subclause of ISO 19085-1:2017 is replaced by the following specific text. To reduce the probability of break up during		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	operation, the requirements of 6.3 apply. To reduce the effect of break up during operation, the requirements of 6.9, 6.5.1 and 6.5.2 apply. Verification: By checking relevant drawings and inspection of the machine.		
6.3	Tool holder and tool design		----
6.3.1	General		----
	This subclause of ISO 19085-1:2017 applies with the following additions. Hydrostatic tool fixing devices which are an integral part of the spindle or which are permanently connected with it shall have an additional mechanical device to prevent loosening of the tool in case of leakage in the hydrostatic system (see also 8.3). Milling tool spindle run-out shall not exceed 0,02 mm. Tool release shall only be possible if the spindle is stopped and restart is prevented (this second requirement applies only when operator changes the tool manually). The SRP/CS for interlocking between tool release and spindle rotation shall achieve PL r = c or consist of two independent systems both achieving PL r = b. As an exception, tool release function may achieve PL r = b if there is an additional mechanical system which prevents tool release during rotation. Verification: By checking the relevant drawings and/or circuits diagrams, measurement, inspection of the machine and relevant functional testing of the machine.		Pass
6.3.2	Spindle locking		----
	This subclause of ISO 19085-1:2017 applies.		Pass
6.3.3	Circular saw blade fixing device		----
	This subclause of ISO 19085-1:2017 applies.		Pass
6.3.4	Flange dimension for circular saw blades		----

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	This subclause of ISO 19085-1:2017 applies.		Pass
6.4	Braking		----
6.4.1	Braking of tool spindle		----
	This subclause of ISO 19085-1:2017 applies		Pass
6.4.2	Maximum run-down time		----
	This subclause of ISO 19085-1:2017 applies	This requirement is complied with.	Pass
6.4.3	Brake release		----
	This subclause of ISO 19085-1:2017 applies	This requirement is complied with.	Pass
6.5	Safeguards		----
6.5.1	Fixed guards		----
	This subclause of ISO 19085-1:2017 applies.	This requirement is complied with.	Pass
6.5.2	Interlocking moveable guards		----
6.5.3	Hold-to-run control		----
	This subclause of ISO 19085-1:2017 applies.	This requirement is complied with.	Pass
6.5.4	Two-hand control		----
	This subclause of ISO 19085-1:2017 applies.	This requirement is complied with.	Pass
6.5.5	Electro-sensitive protective equipment (ESPE)		----
	This subclause of ISO 19085-1:2017 applies with the following additions. If light barriers (AOPD) are used, the following requirements apply: a) If mounted horizontally: 1) the elements shall be situated at a height between 100 mm and 400 mm above the floor level; 2) the pitch between two elements shall be equal to or less than 180 mm; 3) the distance C in Figure 10 between the active part of the light barriers and the machine at the light barrier level shall not exceed 100 mm and the distance D in Figure	This requirement is complied with.	Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	10 between the active part of the light barriers and fixed guards at the light barrier levels shall not exceed 80 mm. b) If mounted inclined: 1) the pitch between two elements shall be equal to or less than 180 mm, measured on the horizontal projection; 2) the elements shall be mounted at a height between 400 mm and 800 mm above the floor level; 3) the horizontal distance between top and bottom ray shall be equal to or greater than 400 mm. c) If mounted vertically, the elements shall be situated: 1) at a height of 400 mm and 900 mm above the floor level, for two beams; 2) at a height of 300 mm, 700 mm and 1 100 mm above the floor level, for three beams. d) A manual reset control device shall be provided. If stationary laser scanners are used, the protected area of the scanner shall be situated at a height between 100 mm and 400 mm above the floor level.		
6.5.6	Pressure-sensitive protective equipment (PSPE)		----
	This subclause of ISO 19085-1:2017 applies with the following addition, subdivided into further specific subclauses.	This requirement is complied with.	Pass
6.6	Prevention of access to moving parts		----
6.6.1	General		----
	This subclause of ISO 19085-1:2017 applies with the following additions. Access to moving parts shall be prevented as far as possible by fixed or interlocking moveable guards extending from 180 mm up to at least 1 800 mm above the floor level, building together a partial or peripheral enclosure. Access to moving parts through		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	the area of the machine that needs to be accessible for loading and unloading the workpieces shall be prevented by one or more safeguards, described in 6.5, as follows. a) Where using stationary protective devices as light barriers (including those with at least either the receiver or the emitter being stationary), or stationary laser scanners or pressure-sensitive mats to prevent access to the crushing, shearing or cutting area (protected zone): 1) the detection zone (light barrier, stationary laser scanners) or effective sensing surface (pressure-sensitive mats) shall extend at least 850 mm from any crushing, shearing, drawing in and entanglement point being in the closest possible position to the operator, measured in horizontal direction; 2) where the protective device is divided into an active and an inactive part to allow the machine to work in one area while the other area is accessible for loading/unloading: — the horizontal distance between the area accessible for loading/unloading and the protected zone where the machine is working shall be at least 850 mm; if this safety distance falls below 850 mm, a normal stop shall be initiated; — the inactive part of such safeguarding shall be manually reset by the operator before the machining head is allowed to traverse into this area; automatic reset shall not be possible; NOTE The prevention of automatic reset is required since the operator can involuntarily release the protective safety device, e.g. by stepping or leaning onto the workpiece support. 3) when a person is detected, a normal stop		

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	shall be initiated and the machining head shall stop within 700 mm. Alternatively, where only the speed of the machining head is reduced by triggering the stationary protective device, the machine shall be equipped with additional bumpers or edges or trip bars or trip plates fulfilling, after speed reduction, the requirements for the systems with only bumpers/edges/trip bars/trip plates given in b). Speed shall be reduced within 500 mm. After activation of the limited speed, a manual reset control device shall be activated to restore the full speed. b) Where using only moving protective devices mounted to the moving part of the machine as pressure-sensitive bumpers, edges, trip bars, trip plates or laser scanner, to prevent access to the crushing, shearing or cutting area (protected zone): 1) for laser scanner, the safety distance from the machining head enclosure, when it has come to a stop from the maximum machine feeding speed, shall be at least 850 mm; 2) for pressure-sensitive bumpers, edges, trip bars, trip plates, the remaining safety distance between the test probe and any crushing, shearing, drawing in and entanglement point inside the machining head enclosure shall be at least y (see Figure 12): y = 550 mm, where openings height x for workpiece loading/unloading is up to 200 mm; y = 550 + ¾ (x – 200) mm, where openings height x is between 200 mm and 600 mm; 3) moving protective devices shall also detect		

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	an operator if he has no contact to the floor, e.g. by stepping or leaning onto the workpiece support; 4) when moving protective device is triggered, a normal stop shall be initiated. c) Where using moving protective devices mounted to the moving part of the machines, as laser scanner, only for machining head speed reduction, together with pressure-sensitive bumpers or edges or trip bars or trip plates for machining head stopping and preventing access to the crushing, shearing or cutting area (protected zone): 1) machining head speed reduction shall be activated by triggering laser scanner, and the limited speed value shall be monitored and allow the bumpers/edges/trip bars/trip plates to fulfil the requirements defined in 2); 2) the remaining safety distance referred to bumpers/edges/trip bars/trip plates between the test probe and any crushing, shearing, drawing in and entanglement point inside the machining head enclosure shall be at least y (see Figure 12): y = 550 mm, where openings height x for workpiece loading/unloading is up to 200 mm; y = 550 + ¾ (x – 200) mm, where openings height x is between 200 mm and 600 mm; 3) laser scanner, pressure-sensitive bumpers, edges, trip bars and trip plates shall detect an operator also if he has no contact to the floor, e.g. by stepping or leaning onto the workpiece support; 4) no laser scanner manual reset is required when moving away from the area		

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	safeguarded by laser scanner to restore the full machining head speed if bumpers/edges/trip bars/trip plates have not been triggered; 5) when bumpers/edges/trip bars/trip plates are triggered, a normal stop shall be initiated. The SRP/CS for ensuring the safety distance in a) 1), a) 2) and b) 1) and the remaining safety distance in b) 2) and c) 2) shall achieve PL r = c. Unexpected restart by the closure of a movable guard shall be prevented. The SRP/CS for prevention of restart shall achieve PL r = c.		
6.6.2	Guarding of tools		----
	This subclause of ISO 19085-1:2017 is replaced by the following text, subdivided into further specific subclauses.		Pass
6.6.3	Guarding of drives		----
	This subclause of ISO 19085-1:2017 applies with the following additions. Interlocking moveable guards shall be provided in any case with guard locking according 6.5.3.		Pass
6.6.4	Guarding of shearing and/or crushing zones		----
	This subclause of ISO 19085-1:2017 is replaced by the following specific text. Crushing hazard between moving parts (table or machining head) and fixed guards shall be avoided by dimensioning the machine such that a minimum distance of 500 mm between the extreme positions of the moving part (table or machining head) and the side fixed guards is ensured at front side (see dimension A in Figure 10). This requirement does not apply on the rear side where access is prevented by a fence. As an exception, minimum distance A can be		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	reduced to 300 mm where sensitive bumpers or edges are provided to prevent crushing hazard to the whole body. The minimum distance defined above shall be ensured by mechanical end-stops. Verification: By checking the relevant drawings and/or circuit diagram measurements, inspection of the machine and relevant functional testing of the machine.		
6.7	Impact hazard		----
	This subclause of ISO 19085-1:2017 applies with the following additions. The detection zone when using light barriers or laser scanners or the effective sensing surface when using pressure-sensitive mats shall extend at least 700 mm from any impact point being in the closest possible position to the operator, measured in horizontal direction (distance B of Figure 10), where only impact hazards from machining head or table exist. The limited speed shall be monitored according to 5.11.		Pass
6.8	Clamping device		----
	This subclause of ISO 19085-1:2017 is replaced by the following text. Where powered clamping is provided, crushing hazards shall be prevented by one of the following measures: a) a two-hand control to control the clamping stroke; b) two-stage clamping with a maximum clamping force at the clamping device of 150 N for the first stage, followed by full clamping force actuated by a manual control; c) reduction of the gap between clamp and workpiece to 6 mm or less by a manually adjustable device in combination with		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	clamping stroke limitation to a maximum of 10 mm; d) guarding of the clamp by a guard fixed to the clamping device to reduce the gap between workpiece and guard to less than 6 mm; the maximum extension of the clamp outside the guard shall not exceed 6 mm; e) limitation of the clamp closing speed to 10 mm s −1 or less. The SRP/CS for prevention of unexpected activation of second stage clamping force in b) shall achieve PL r = b. The SRP/CS for the limitation of the clamp closing speed in e) shall achieve PL r = b. Where pneumatic or hydraulic clamping is provided, the requirements of ISO 4413:2010 or ISO 4414:2010 shall be met. When powered clamping is selected (vacuum, pneumatic or hydraulic), the following requirements apply: 1) feed and spindle rotation shall be interlocked so that axes and/or spindle movements cannot start and run until clamping pressure/vacuum supply for clamping is available (no PL is required for interlocking); 2) in the area where the workpiece is processed, the release of clamping pressure/vacuum during rotation of the spindle shall only be possible if the machining head is in the rest position and the integrated feed has stopped. (no PL is required for interlocking); 3) where twin table or separate loading/unloading sections are provided, the requirements for release of clamping pressure/vacuum stated in 2) only apply for the part of the machine where machining is under progress. Release of clamping		

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	pressure/vacuum on the table where no machining is in progress shall only be possible when the corresponding table has come to rest. (no PL is required for interlocking); 4) for vacuum clamping: i) the vacuum sensor shall achieve at least PL = b; ii) the vacuum sensor shall be adjustable and the lower limit shall be 25 % of the rated under pressure and shall be located as close as possible to the table; iii) the loss of vacuum shall initiate the machine operational stop or emergency stop.		
6.9	Measures against ejection		----
6.9.1	General		----
	This subclause of ISO 19085-1:2017 applies with the following addition. Anti-splinter and anti-kickback devices are not relevant/applicable. Direct ejection of parts of the tool or parts of the workpiece in any direction shall be prevented by fixed guards from 180 mm up to at least 1 800 mm above the floor level. Where those fixed guards need to have openings for workpiece loading/unloading, processing and/or feeding, curtains shall be provided, except for the case given in 6.6.2.2.3.2. Fixed guards and curtains may be mounted to the machine body or the machining head. As exceptions: — direct ejection through the space between the clamping bars shall be prevented up to the lowest level on which the workpiece can be clamped only at the front and at the rear by fixed guards; — ejection to the side through the space between the clamping bars is considered to be an acceptable residual risk.	This requirement is complied with.	Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
6.9.2	Guards materials and characteristics		----
6.10	Workpiece support and guides		----
	This subclause of ISO 19085-1:2017 applies with the following addition. Examples of workpiece supports are solid table and supporting bars (see Figure 12, key 2).		Pass
7	Safety requirements and measures for protection against other hazards		----
7.1	Fire		----
	This subclause of ISO 19085-1:2017 applies.	This requirement is complied with.	Pass
7.2	Noise		----
7.2.1	Noise reduction at the design stage		----
	This subclause of ISO 19085-1:2017 applies with the following additions. Other major noise sources are a) axle drives, and b) clamping, i.e. any of the following clamping system:1) vacuum system including vacuum pump; 2) pneumatic system; 3) hydraulic system.		Pass
7.2.2	Noise emission measurement		----
	This subclause of ISO 19085-1:2017 applies with the following addition. The operating conditions for noise measurement shall comply with Annex E.		Pass
7.3	Emission of chips and dust		----
	This subclause of ISO 19085-1:2017 applies with the following additions. Unintended access to the rotating tool through any dust extraction outlet with disconnected exhaust system shall be impeded. The requirements of ISO 13857:2008 shall not be applied here due to the negative impact on the extraction of chips and dust. A means shall be provided to improve the		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	efficiency of guiding the chips and dust to the opening of the capture device, e.g. a deflector mounted to the tool or brushes mounted around the machining head.		
7.4	Electricity		----
7.4.1	General		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.4.2	Displaceable machines		----
	This subclause of ISO 19085-1:2017 does not apply.		Pass
7.5	Ergonomics and handling		----
	This subclause of ISO 19085-1:2017 applies with the following addition. The height of the workpiece support surface should be between 750 mm and 900 mm above the floor level. Deviation to such dimensions may apply due to the size of the workpieces.		Pass
7.6	Lighting		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.7	Pneumatics		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.8	Hydraulics		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.9	Electromagnetic compatibility		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.10	Laser		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.11	Static electricity		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.12	Errors of fitting		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.13	Isolation		----
	This subclause of ISO 19085-1:2017 applies.		Pass
7.14	Maintenance		----
	This subclause of ISO 19085-1:2017 applies.		Pass
8	Information for use		----

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
8.1	Warning devices		----
	This subclause of ISO 19085-1:2017 applies with the following additions. An audible or visual warning (e.g. a yellow light) of impending start up of machines fitted with access door to peripheral enclosure shall be provided, if from the control position the operator does not have a complete view of the machining area; see 6.6.2.2.2 a).		Pass
8.2	Marking		----
8.2.1	General		----
	This subclause of ISO 19085-1:2017 applies.		Pass
8.2.2	Additional markings		----
	This subclause of ISO 19085-1:2017 does not apply.		N/A
8.3	Instruction handbook		----
8.3.1	General		----
	This subclause of ISO 19085-1:2017 applies.		Pass
8.3.2	Additional information		----
	This subclause of ISO 19085-1:2017 is replaced by the following specific text. The following additional information shall be provided in the instruction handbook: a) instructions for safe use shall also include: 1) the correct selection of milling tools for each operation, which includes precautions during machining as i) the range of milling tool diameters and lengths which are suitable for the machine, and ii) that only milling tools with a cutting diameter below 16 mm shall be used or milling tools with a cutting diameter above 16 mm and/or saw blades both manufactured in accordance with EN 847-1:2013 and EN 847-2:2013 shall be used; 2) information regarding the requirements for other tools, e.g. boring tools, sanding		Pass

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	wheels, etc. that can be used on the machine; 3) information that the pull-in force of spindles of HSK clamping systems shall be periodically checked by personnel authorized by the manufacturer, including the intervals; 4) where applicable (see 6.6.2.2.3.2), information not to use complex milling tools according to EN 847-1:2013; b) warnings regarding residual risks shall also include: 1) recommendation that the off-cut is either clamped, e.g. by mechanical clamp, or completely machined prior to its detachment to avoid the risk of off-cut ejection; 2) reminder not to remove chips while the tool is running and the machining head is not in the rest position; 3) reminder to take precautions to reduce the risk of production of ignition sources; 4) where applicable, reminder to be aware about the residual risk of parts being ejected to the sides through the space between the clamping bars; c) instructions about protective device tests, method and frequency shall also include: 1) curtain maintenance by checking the of absence of damage (at least each month); 2) vacuum clamping by functional test; d) instructions for setting the machine and precautions during setting: 1) that during setting, it shall be verified that no contact exists between non-rotating tools and any workpiece clamping device or machine element; 2) instructions for clamping device mounting, setting and use; 3) information regarding the required		

EN 19085-3			
Clause	Requirement – Test	Result - Remark	Verdict
	clamping pressure (e.g. vacuum and minimum clamping surfaces of the workpiece if the machine is fitted with vacuum clamping); 4) adjustment method for the pressure devices and the method for fixing auxiliaries; 5) method for choosing the spindle speed, taking into account the work to be done and the tool used; the relationship between the tool diameter, the cutting length and the maximum rotational speed of the spindle is important; examples may be given for the most common cutting lengths; 6) instructions for the use of special equipment, e.g. gauges for setting the tool when machine is at a standstill; 7) instruction for adjustment and use of the safeguarding prescribed in 6.6.2; e) for machines equipped with hydrostatic tool-fixing facilities, only tool-fixing devices with additional mechanical device to protect against loosening of the tool in case of leakage in the hydrostatic system shall be used. Verification: By checking the information given in the instruction handbook and relevant drawings.		

Tables

Annex A – Test tables

18.2 for EN 60204-1	TABLE: Continuity of the protective bonding circuit			P
Location	Current(A)	Frequency(Hz)	Time(s)	Measured voltage(V)
Between PE terminal and relevant points that are part of the protective bonding circuit	25	50	60	8V

18.3 for EN 60204-1	TABLE: Insulation resistance tests			P
Location	Voltage(V) d.c.	Frequency(Hz)	Time(s)	Measured insulation resistance(MΩ)
Between power circuit conductors and protective bonding circuit	500	--	60	>100
Between secondary power circuit conductors to protective bonding circuit	500	--	60	>100

18.4 for IEC 60204-1	TABLE: voltage tests	P
test voltage applied between:	Test Voltage (V) a.c / d.c	Breakdown YES/NO
The conductors of all circuits and the protective bonding circuits	1000AC/50Hz/1min	NO

EN ISO 12100		
Clause	Requirement – Test	Verdict

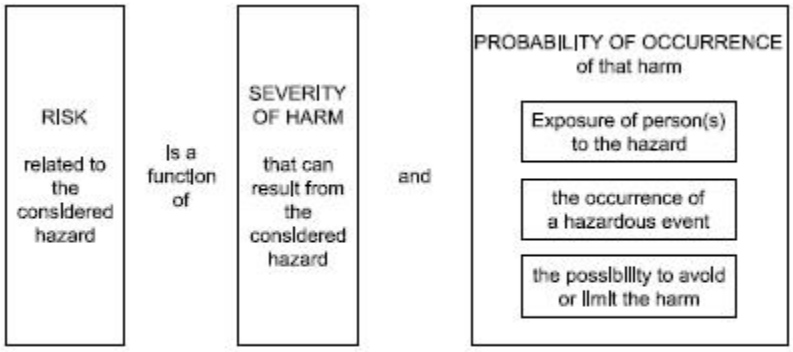
1	**Scope**	**--**
2	**Normative references**	**--**
3	**Terms and definitions**	**--**
4	**Strategy for risk assessment and risk reduction**	**--**
5	**Risk assessment**	**--**
5.1	**General**	**--**
	Risk assessment comprises (see Figure 1) - risk analysis, comprising 1) determination of the limits of the machinery (see 5.3), 2) hazard identification (5.4 and Annex B), and 3) risk estimation (see 5.5), and - risk evaluation (see 5.6).	**Pass**
	Risk analysis provides information required for the risk evaluation, which in turn allows judgments to be made about whether or not risk reduction is required.	**Pass**
	These judgments shall be supported by a qualitative or, where appropriate, quantitative estimate of the risk associated with the hazards present on the machinery.	**Pass**
	The risk assessment shall be documented according to Clause 7.	**Pass**
5.2	**Information for risk assessment**	**--**
	The information for risk assessment should include the following.	**--**
	a) **Related to machinery description**: 1) user specifications; 2) anticipated machinery specifications, including i) a description of the various phases of the whole life cycle of the machinery, ii) design drawings or other means of establishing the nature of the machinery, and iii) required energy sources and how they are supplied; 3) documentation on previous designs of similar machinery, if relevant; 4) information for use of the machinery, as available.	**Pass**
	b) **Related to regulations, standards and other applicable documents**: 1) applicable regulations; 2) relevant standards; 3) relevant technical specifications; 4) relevant safety data sheets.	**Pass**
	c) **Related to experience of use:** 1) any accident, incident or malfunction history of the actual or similar	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	machinery; 2) the history of damage to health resulting, for example, from emissions (noise, vibration, dust, fumes, etc.), chemicals used or materials processed by the machinery; 3) the experience of users of similar machines and, whenever practicable, an exchange of information with the potential users.	
	d) **Relevant ergonomic principles.**	**--**
	The information shall be updated as the design develops or when modifications to the machine are required.	**Pass**
	Comparisons between similar hazardous situations associated with different types of machinery are often possible, provided that sufficient information about hazards and accident circumstances in those situations is available.	**Pass**
	For quantitative analysis, data from databases, handbooks, laboratories or manufacturers' specifications may be used, provided that there is confidence in the suitability of the data. Uncertainty associated with these data shall be indicated in the documentation (see Clause 7).	**Pass**
5.3	**Determination of limits of machinery**	**--**
5.3.1	**General**	**-**
	Risk assessment begins with the determination of the limits of the machinery, taking into account all the phases of the machinery life. This means that the characteristics and performances of the machine or a series of machines in an integrated process, and the related people, environment and products, should be identified in terms of the limits of machinery as given in 5.3.2 to 5.3.5.	**Pass**
5.3.2	**Use limits**	**--**
	Use limits include the intended use and the reasonably foreseeable misuse. Aspects to be taken into account include the following:	**--**
	a) the different machine operating modes and different intervention procedures for the users, including interventions required by malfunctions of the machine;	**N/A**
	b) the use of the machinery (for example, industrial, non-industrial and domestic) by persons identified by sex, age, dominant hand usage, or limiting physical abilities (visual or hearing impairment, size, strength, etc.);	**Pass**
	c) the anticipated levels of training, experience or ability of users including 1) operators, 2) maintenance personnel or technicians, 3) trainees and apprentices, and 4) the general public;	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	d) exposure of other persons to the hazards associated with the machinery where it can be reasonably foreseen: 1) persons likely to have a good awareness of the specific hazards, such as operators of adjacent machinery; 2) persons with little awareness of the specific hazards but likely to have a good awareness of site safety procedures, authorized routes, etc., such as administration staff; 3) persons likely to have very little awareness of the machine hazards or the site safety procedures, such as visitors or members of the general public, including children.	**Pass**
	If specific information is not available in relation to b), above, the manufacturer should take into account general information on the intended user population (for example, appropriate anthropometric data).	**Pass**
5.3.3	**Space limits**	**--**
	Aspects of space limits to be taken into account include a) the range of movement, b) space requirements for persons interacting with the machine, such as during operation and maintenance, c) human interaction such as the operator–machine interface, and d) the machine–power supply interface.	**Pass**
5.3.4	**Time limits**	**--**
	Aspects of time limits to be taken into account include a) the life limit of the machinery and/or of some of its components (tooling, parts that can wear, electromechanical components, etc.), taking into account its intended use and reasonably foreseeable misuse, and b) recommended service intervals.	**Pass**
5.3.5	**Other limits**	**--**
	Examples of other limits include a) properties of the material(s) to be processed, b) housekeeping — the level of cleanliness required, and c) environmental — the recommended minimum and maximum temperatures, whether the machine can be operated indoors or outdoors, in dry or wet weather, in direct sunlight, tolerance to dust and wet, etc.	**Pass**
5.4	**Hazard identification**	**--**
	After determination of the limits of the machinery, the essential step in any risk assessment of the machinery is the systematic identification of reasonably foreseeable hazards (permanent hazards and those which can	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	appear unexpectedly), hazardous situations and/or hazardous events during all phases of the machine life cycle, i.e.: - transport, assembly and installation; - commissioning; - use; - dismantling, disabling and scrapping.	
	Only when hazards have been identified can steps be taken to eliminate them or to reduce risks. To accomplish this hazard identification, it is necessary to identify the operations to be performed by the machinery and the tasks to be performed by persons who interact with it, taking into account the different parts, mechanisms or functions of the machine, the materials to be processed, if any, and the environment in which the machine can be used.	**Pass**
	The designer shall identify hazards taking into account the following.	**--**
	a) **Human interaction during the whole life cycle of the machine** Task identification should consider all tasks associated with every phase of the machine life cycle as given above. Task identification should also take into account, but not be limited to, the following task categories: - setting; - testing; - teaching/programming; - process/tool changeover; - start-up; - all modes of operation; - feeding the machine; - removal of product from machine; - stopping the machine; - stopping the machine in case of emergency; - recovery of operation from jam or blockage; - restart after unscheduled stop; - fault-finding/trouble-shooting (operator intervention); - cleaning and housekeeping; - preventive maintenance; - corrective maintenance.	**Pass**
	All reasonably foreseeable hazards, hazardous situations or hazardous events associated with the various tasks shall then be identified. Annex B gives examples of hazards, hazardous situations and hazardous events to assist in this process. Several methods are available for the systematic identification of hazards. See also ISO/TR 14121-2.	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	In addition, reasonably foreseeable hazards, hazardous situations or hazardous events not directly related to tasks shall be identified.	**Pass**
	EXAMPLE Seismic events, lightning, excessive snow loads, noise, break-up of machinery, hydraulic hose burst.	**Pass**
	b) **Possible states of the machine**	**--**
	These are as follows: 1) the machine performs the intended function (the machine operates normally); 2) the machine does not perform the intended function (i.e. it malfunctions) due to a variety of reasons, including - variation of a property or of a dimension of the processed material or of the workpiece, - failure of one or more of its component parts or services, - external disturbances (for example, shocks, vibration, electromagnetic interference), - design error or deficiency (for example, software errors), - disturbance of its power supply, and - surrounding conditions (for example, damaged floor surfaces).	**Pass**
	c) **Unintended behaviour of the operator or reasonably foreseeable misuse of the machine**	**--**
	Examples include - loss of control of the machine by the operator (especially for hand-held or mobile machines), - reflex behaviour of a person in case of malfunction, incident or failure during the use of the machine, - behaviour resulting from lack of concentration or carelessness, - behaviour resulting from taking the “line of least resistance” in carrying out a task, - behaviour resulting from pressures to keep the machine running in all circumstances, and - behaviour of certain persons (for example, children, disabled persons).	**Pass**
5.5	**Risk estimation**	**--**
5.5.1	**General**	**--**
	After hazard identification, risk estimation shall be carried out for each hazardous situation by determining the elements of risk given in 5.5.2. When determining these elements, it is necessary to take into account the aspects given in 5.5.3.	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	If standardized (or other suitable) measurement methods exist for an emission, they should be used, in conjunction with existing machinery or prototypes, to determine emission values and comparative emission data. This makes it possible for the designer to - estimate the risk associated with the emissions, - evaluate the effectiveness of the protective measures implemented at the design stage, - provide potential buyers with quantitative information on emissions in the technical documentation, and - provide users with quantitative information on emissions in the information for use.	**Pass**
	Hazards other than emissions that are described by measurable parameters can be dealt with in a similar manner.	**Pass**
5.5.2	**Elements of risk**	**--**
5.5.2.1	**General**	**--**
	The risk associated with a particular hazardous situation depends on the following elements: a) the severity of harm; b) the probability of occurrence of that harm, which is a function of 1) the exposure of person(s) to the hazard, 2) the occurrence of a hazardous event, and 3) the technical and human possibilities to avoid or limit the harm.	**Pass**
	The elements of risk are shown in Figure 3. Additional details are given in 5.5.2.2, 5.5.2.3 and 5.5.3.  Figure 3 — Elements of risk	**--**
5.5.2.2	**Severity of harm**	**--**
	The severity can be estimated by taking into account the following:	**--**
	a) the severity of injuries or damage to health, for example,	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	- slight, - serious, - death.	
	b) the extent of harm, for example, to - one person, - several persons.	**N/A**
	When carrying out a risk assessment, the risk from the most likely severity of the harm that is likely to occur from each identified hazard shall be considered, but the highest foreseeable severity shall also be taken into account, even if the probability of such an occurrence is not high.	**N/A**
5.5.2.3	**Probability of occurrence of harm**	**--**
5.5.2.3.1	**Exposure of persons to the hazard**	**--**
	The exposure of a person to the hazard influences the probability of the occurrence of harm. Factors to be taken into account when estimating the exposure are, among others, a) the need for access to the hazard zone (for normal operation, correction of malfunction, maintenance or repair, etc.), b) the nature of access (for example, manual feeding of materials), c) the time spent in the hazard zone, d) the number of persons requiring access, and e) the frequency of access.	**Pass**
5.5.2.3.2	**Occurrence of a hazardous event**	**--**
	The occurrence of a hazardous event influences the probability of occurrence of harm. Factors to be taken into account when estimating the occurrence of a hazardous event are, among others, a) reliability and other statistical data, b) accident history, c) history of damage to health, and d) comparison of risks (see 5.6.3).	**Pass**
5.5.2.3.3	**Possibility of avoiding or limiting harm**	**--**
	The possibility of avoiding or limiting harm influences the probability of occurrence of harm. Factors to be taken into account when estimating the possibility of avoiding or limiting harm are, among others, the following:	**--**
	a) different persons who can be exposed to the hazard(s), for example, - skilled, - unskilled;	**Pass**
	b) how quickly the hazardous situation could lead to harm, for example, - suddenly,	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	- quickly, - slowly;	
	c) any awareness of risk, for example, - by general information, in particular, information for use, - by direct observation, - through warning signs and indicating devices, in particular, on the machinery;	**Pass**
	d) the human ability to avoid or limit harm (for example, reflex, agility, possibility of escape);	**Pass**
	e) practical experience and knowledge, for example, - of the machinery, - of similar machinery, - no experience.	**Pass**
5.5.3	**Aspects to be considered during risk estimation**	**--**
5.5.3.1	**Persons exposed**	**--**
	Risk estimation shall take into account all persons (operators and others) for whom exposure to the hazard is reasonably foreseeable.	**Pass**
5.5.3.2	**Type, frequency and duration of exposure**	**--**
	The estimation of the exposure to the hazard under consideration (including long-term damage to health) requires analysis of, and shall account for, all modes of operation of the machinery and methods of working. In particular, the analysis shall account for the needs for access during loading/unloading, setting, teaching, process changeover or correction, cleaning, fault-finding and maintenance.	**Pass**
	The risk estimation shall also take into account tasks, for which it is necessary to suspend protective measures.	**Pass**
5.5.3.3	**Relationship between exposure and effects**	
	The relationship between an exposure to a hazard and its effects shall be taken into account for each hazardous situation considered. The effects of accumulated exposure and combinations of hazards shall also be considered. When considering these effects, risk estimation shall, as far as practicable, be based on appropriate recognized data.	**Pass**
	NOTE 1 Accident data can assist in establishing the probability and severity of injury associated with the use of a particular type of machinery with a particular type of protective measure. NOTE 2 Zero accident data is, however, no guarantee of the low probability and severity of an injury.	**Pass**
5.5.3.4	**Human factors**	**--**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	Human factors can affect risk and shall be taken into account in the risk estimation, including, for example,	--
	a) the interaction of person(s) with the machinery, including correction of malfunction, b) interaction between persons, c) stress-related aspects, d) ergonomic aspects, e) the capacity of persons to be aware of risks in a given situation depending on their training, experience and ability, f) fatigue aspects, and g) aspects of limited abilities (due to disability, age, etc.).	**Pass**
	Training, experience and ability can affect risk; nevertheless, none of these factors shall be used as a substitute for hazard elimination, risk reduction by inherently safe design measure or safeguarding, wherever these protective measures can be practicably implemented.	**Pass**
5.5.3.5	**Suitability of protective measures**	--
	Risk estimation shall take into account the suitability of protective measures and shall a) identify the circumstances which can result in harm, b) whenever appropriate, be carried out using quantitative methods to compare alternative protective measures (see ISO/TR 14121-2), and c) provide information that can assist with the selection of appropriate protective measures.	**Pass**
	When estimating risk, those components and systems identified as immediately increasing the risk in case of failure need special attention.	**Pass**
	When protective measures include work organization, correct behaviour, attention, application of personal protective equipment (PPE), skill or training, the relatively low reliability of such measures compared with proven technical protective measures shall be taken into account in the risk estimation.	
5.5.3.6	**Possibility of defeating or circumventing protective measures**	--
	For the continued safe operation of a machine, it is important that the protective measures allow its easy use and do not hinder its intended use. Otherwise, there is a possibility that protective measures might be bypassed in order for maximum utility of the machine to be achieved.	**N/A**
	Risk estimation shall take account of the possibility of defeating or circumventing protective measures. It shall also take account of the incentive to defeat or circumvent protective measures when, for example, a) the protective measure slows down production or interferes with another	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	activity or preference of the user, b) the protective measure is difficult to use, c) persons other than the operator are involved, or d) the protective measure is not recognized by the user or not accepted as being suitable for its function.	
	Whether or not a protective measure can be defeated depends on both the type of protective measure, such as an adjustable guard or programmable trip device, and its design details.	**N/A**
	Protective measures that use programmable electronic systems introduce additional possibilities of defeat or circumvention if access to safety-related software is not appropriately restricted by design and monitoring methods. Risk estimation shall identify where safety-related functions are not separated from other machine functions and shall determine the extent to which access is possible. This is particularly important when remote access for diagnostic or process correction purposes is required.	**N/A**
5.5.3.7	**Ability to maintain protective measures**	**--**
	Risk estimation shall consider whether the protective measures can be maintained in the condition necessary to provide the required level of protection.	**Pass**
	NOTE If the protective measure cannot easily be maintained in correct working order, this can encourage the defeat or circumvention of the protective measure in order to allow continued use of the machinery.	**Pass**
5.5.3.8	**Information for use**	**--**
	Risk estimation shall take into account the information for use, as available. See also 6.4.	**Pass**
5.6	**Risk evaluation**	**--**
5.6.1	**General**	**--**
	After risk estimation has been completed, risk evaluation shall be carried out to determine if risk reduction is required. If risk reduction is required, then appropriate protective measures shall be selected and applied (see Clause 6). As shown in Figure 1, the adequacy of the risk reduction shall be determined after applying each of the three steps of risk reduction described in Clause 6. As part of this iterative process, the designer shall also check whether additional hazards are introduced or other risks increased when new protective measures are applied. If additional hazards do occur, they shall be added to the list of identified hazards and appropriate protective measures will be required to address them.	**Pass**
	Achieving the objectives of risk reduction and a favourable outcome of risk	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	comparison applied when practicable gives confidence that risk has been adequately reduced.	
5.6.2	**Adequate risk reduction**	**--**
	Application of the three-step method described in 6.1 is essential in achieving adequate risk reduction.	**Pass**
	Following the application of the three-step method, adequate risk reduction is achieved when - all operating conditions and all intervention procedures have been considered, - the hazards have been eliminated or risks reduced to the lowest practicable level, - any new hazards introduced by the protective measures have been properly addressed, - users are sufficiently informed and warned about the residual risks (see 6.1, step 3), - protective measures are compatible with one another, - sufficient consideration has been given to the consequences that can arise from the use in a nonprofessional/ non-industrial context of a machine designed for professional/industrial use, and - the protective measures do not adversely affect the operator's working conditions or the usability of the machine.	**Pass**
5.6.3	**Comparison of risks**	**--**
	As part of the process of risk evaluation, the risks associated with the machinery or parts of machinery can be compared with those of similar machinery or parts of machinery, provided the following criteria apply: - the similar machinery is in accordance with the relevant type-C standard(s); - the intended use, reasonably foreseeable misuse and the way both machines are designed and constructed are comparable; - the hazards and the elements of risk are comparable; - the technical specifications are comparable; - the conditions for use are comparable.	**Pass**
	The use of this comparison method does not eliminate the need to follow the risk assessment process as described in this International Standard for the specific conditions of use. For example, when a band saw used for cutting meat is compared with a band saw used for cutting wood, the risks associated with the different material shall be assessed.	**Pass**
6	**Risk reduction**	**--**
6.1	**General**	**--**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	The objective of risk reduction can be achieved by the elimination of hazards, or by separately or simultaneously reducing each of the two elements that determine the associated risk: - severity of harm from the hazard under consideration; - probability of occurrence of that harm.	**Pass**
	All protective measures intended for reaching this objective shall be applied in the following sequence, referred to as the three-step method (see also Figures 1 and 2).	**Pass**
	Step 1: Inherently safe design measures	--
	Inherently safe design measures eliminate hazards or reduce the associated risks by a suitable choice of design features of the machine itself and/or interaction between the exposed persons and the machine. See 6.2.	**Pass**
	NOTE 1 This stage is the only one at which hazards can be eliminated, thus avoiding the need for additional protective measures such as safeguarding or complementary protective measures.	--
	Step 2: Safeguarding and/or complementary protective measures	--
	Taking into account the intended use and the reasonably foreseeable misuse, appropriately selected safeguarding and complementary protective measures can be used to reduce risk when it is not practicable to eliminate a hazard, or reduce its associated risk sufficiently, using inherently safe design measures. See 6.3.	**Pass**
	Step 3: Information for use	--
	Where risks remain despite inherently safe design measures, safeguarding and the adoption of complementary protective measures, the residual risks shall be identified in the information for use. The information for use shall include, but not be limited to, the following: - operating procedures for the use of the machinery consistent with the expected ability of personnel who use the machinery or other persons who can be exposed to the hazards associated with the machinery; - the recommended safe working practices for the use of the machinery and the related training requirements adequately described; - sufficient information, including warning of residual risks for the different phases of the life of the machinery; - the description of any recommended personal protective equipment, including detail as to its need as well as to training needed for its use.	**Pass**
	Information for use shall not be a substitute for the correct application of inherently safe design measures, safeguarding or complementary protective measures.	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	NOTE 2 Adequate protective measures associated with each of the operating modes and intervention procedures reduce the possibility of operators being induced to use hazardous intervention techniques in case of technical difficulties.	--
6.2	**Inherently safe design measures**	--
6.2.1	**General**	--
	Inherently safe design measures are the first and most important step in the risk reduction process. This is because protective measures inherent to the characteristics of the machine are likely to remain effective, whereas experience has shown that even well-designed safeguarding can fail or be violated and information for use may not be followed.	**Pass**
	Inherently safe design measures are achieved by avoiding hazards or reducing risks by a suitable choice of design features for the machine itself and/or interaction between the exposed persons and the machine.	**Pass**
	NOTE See 6.3 for safeguarding and complementary measures that can be used to achieve the risk reduction objectives in the case where inherently safe design measures are not sufficient (see 6.1 for the three-step method).	--
6.2.2	**Consideration of geometrical factors and physical aspects**	--
6.2.2.1	**Geometrical factors**	--
	Such factors include the following.	--
	a) The form of machinery is designed to maximize direct visibility of the working areas and hazard zones from the control position — reducing blind spots, for example — and choosing and locating means of indirect vision where necessary (mirrors, etc.) so as to take into account the characteristics of human vision, particularly when safe operation requires permanent direct control by the operator, for example: - the travelling and working area of mobile machines; - the zone of movement of lifted loads or of the carrier of machinery for lifting persons; - the area of contact of the tool of a hand-held or hand-guided machine with the material being worked.	**Pass**
	The design of the machine shall be such that, from the main control position, the operator is able to ensure that there are no exposed persons in the danger zones.	**Pass**
	b) The form and the relative location of the mechanical components parts: for instance, crushing and shearing hazards are avoided by increasing the minimum gap between the moving parts, such that the part of the body under consideration can enter the gap safely, or by reducing the gap so that no part	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	of the body can enter it (see ISO 13854 and ISO 13857).	
	c) Avoiding sharp edges and corners, protruding parts: in so far as their purpose allows, accessible parts of the machinery shall have no sharp edges, no sharp angles, no rough surfaces, no protruding parts likely to cause injury, and no openings which can “trap” parts of the body or clothing. In particular, sheet metal edges shall be deburred, flanged or trimmed, and open ends of tubes which can cause a “trap” shall be capped.	**Pass**
	d) The form of the machine is designed so as to achieve a suitable working position and provide accessible manual controls (actuators).	**Pass**
6.2.2.2	**Physical aspects**	**--**
	Such aspects include the following: a) limiting the actuating force to a sufficiently low value so that the actuated part does not generate a mechanical hazard; b) limiting the mass and/or velocity of the movable elements, and hence their kinetic energy; c) limiting the emissions by acting on the characteristics of the source using measures for reducing 1) noise emission at source (see ISO/TR 11688-1), 2) the emission of vibration at source, such as redistribution or addition of mass and changes of process parameters [for example, frequency and/or amplitude of movements (for hand-held and hand-guided machinery, see CR 1030-1)], 3) the emission of hazardous substances, including the use of less hazardous substances or dust-reducing processes (granules instead of powders, milling instead of grinding), and 4) radiation emissions, including, for example, avoiding the use of hazardous radiation sources, limiting the power of radiation to the lowest level sufficient for the proper functioning of the machine, designing the source so that the beam is concentrated on the target, increasing the distance between the source and the operator or providing for remote operation of the machinery [measures for reducing emission of non-ionizing radiation are given in 6.3.4.5 (see also EN 12198-1 and EN 12198-3)].	**Pass**
6.2.3	**Taking into account general technical knowledge of machine design**	**--**
	This general technical knowledge can be derived from technical specifications for design (standards, design codes, calculation rules, etc.), which should be used to cover	**--**
	mechanical stresses such as - stress limitation by implementation of correct calculation, construction and	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	fastening methods as regards, for example, bolted assemblies and welded assemblies, - stress limitation by overload prevention (bursting disk, pressure-limiting valves, breakage points, torque-limiting devices, etc.), - avoiding fatigue in elements under variable stresses (notably cyclic stresses), and - static and dynamic balancing of rotating elements,	
	b) materials and their properties such as - resistance to corrosion, ageing, abrasion and wear, - hardness, ductility, brittleness, - homogeneity, - toxicity, and - flammability, and	**Pass**
	c) emission values for - noise, - vibration, - hazardous substances, and - radiation.	**Pass**
	When the reliability of particular components or assemblies is critical for safety (for example, ropes, chains, lifting accessories for lifting loads or persons), stress limits shall be multiplied by appropriate working coefficients.	**Pass**
6.2.4	**Choice of appropriate technology**	**--**
	One or more hazards can be eliminated or risks reduced by the choice of the technology to be used in certain applications such as the following:	**--**
	a) on machines intended for use in explosive atmospheres, using - appropriately selected pneumatic or hydraulic control system and machine actuators, - intrinsically safe electrical equipment (see IEC 60079-11);	**N/A**
	b) for particular products to be processed (for example, by a solvent), by using equipment that ensures the temperature will remain far below the flash point;	**N/A**
	c) the use of alternative equipment to avoid high noise levels, such as - electrical instead of pneumatic equipment, - in certain conditions, water-cutting instead of mechanical equipment.	**N/A**
6.2.5	**Applying principle of positive mechanical action**	**--**
	Positive mechanical action is achieved when a moving mechanical component inevitably moves another component along with it, either by direct	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	contact or via rigid elements. An example of this is positive opening operation of switching devices in an electrical circuit (see IEC 60947-5-1 and ISO 14119).	
	NOTE Where a mechanical component moves and thus allows a second component to move freely (for example, by gravity or spring force), there is no positive mechanical action of the first component on the second.	**Pass**
6.2.6	**Provisions for stability**	**--**
	Machines shall be designed so that they have sufficient stability to allow them to be used safely in their specified conditions of use. Factors to be taken into account include - the geometry of the base, - the weight distribution, including loading, - the dynamic forces due to movements of parts of the machine, of the machine itself or of elements held by the machine which can result in an overturning moment, - vibration, - oscillations of the centre of gravity, - characteristics of the supporting surface in case of travelling or installation on different sites (ground conditions, slope, etc.), and - external forces, such as wind pressure and manual forces.	**Pass**
	Stability shall be considered in all phases of the life cycle of the machine, including handling, travelling, installation, use, dismantling, disabling and scrapping.	**Pass**
	Other protective measures for stability relevant to safeguarding are given in 6.3.2.6.	**Pass**
6.2.7	**Provisions for maintainability**	**--**
	When designing a machine, the following maintainability factors shall be taken into account to enable maintenance of the machine: - accessibility, taking into account the environment and the human body measurements, including the dimensions of the working clothes and tools used; - ease of handling, taking into account human capabilities; - limitation of the number of special tools and equipment.	**Pass**
6.2.8	**Observing ergonomic principles**	**--**
	Ergonomic principles shall be taken into account in designing machinery so as to reduce the mental or physical stress of, and strain on, the operator. These principles shall be considered when allocating functions to operator and machine (degree of automation) in the basic design.	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	NOTE Also improved are the performance and reliability of operation and hence the reduction in the probability of errors at all stages of machine use.	--
	Account shall be taken of body sizes likely to be found in the intended user population, strengths and postures, movement amplitudes, frequency of cyclic actions (see ISO 10075 and ISO 10075-2).	**Pass**
	All elements of the operator–machine interface, such as controls, signalling or data display elements, shall be designed to be easily understood so that clear and unambiguous interaction between the operator and the machine is possible. See EN 614-1, EN 13861 and IEC 61310-1.	**Pass**
	The designer's attention is particularly drawn to following ergonomic aspects of machine design.	--
	a) Avoid the necessity for stressful postures and movements during the use of the machine (for example, providing facilities to adjust the machine to suit the various operators).	**Pass**
	b) Design machines, especially hand-held and mobile machines, so as to enable them to be operated easily, taking into account human effort, actuation of controls and hand, arm and leg anatomy.	**Pass**
	c) Limit as far as possible noise, vibration and thermal effects such as extreme temperatures.	**Pass**
	d) Avoid linking the operator's working rhythm to an automatic succession of cycles.	**Pass**
	e) Provide local lighting on or in the machine for the illumination of the working area and of adjusting, setting-up and frequent maintenance zones when the design features of the machine and/or its guards render the ambient lighting inadequate. Flicker, dazzling, shadows and stroboscopic effects shall be avoided if they can cause a risk. If the position or the lighting source has to be adjusted, its location shall be such that it does not cause any risk to persons making the adjustment.	**Pass**
	f) Select, locate and identify manual controls (actuators) so that - they are clearly visible and identifiable, and appropriately marked where necessary (see 6.4.4), - they can be safely operated without hesitation or loss of time and without ambiguity (for example, a standard layout of controls reduces the possibility of error when an operator changes from a machine to another one of similar type having the same pattern of operation), - their location (for push-buttons) and their movement (for levers and hand wheels) are consistent with their effect (see IEC 61310-3), and - their operation cannot cause additional risk.	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	See also ISO 9355-3	
	Where a control is designed and constructed to perform several different actions — namely, where there is no one-to-one correspondence (for example, keyboards) — the action to be performed shall be clearly displayed and subject to confirmation where necessary.	**N/A**
	Controls shall be so arranged that their layout, travel and resistance to operation are compatible with the action to be performed, taking account of ergonomic principles. Constraints due to the necessary or foreseeable use of personal protective equipment (such as footwear, gloves) shall be taken into account.	**Pass**
	g) Select, design and locate indicators, dials and visual display units so that - they fit within the parameters and characteristics of human perception, - information displayed can be detected, identified and interpreted conveniently, i.e. long-lasting, distinct, unambiguous and understandable with respect to the operator's requirements and the intended use, and - the operator is able to perceive them from the control position.	**Pass**
6.2.9	**Electrical hazards**	**--**
	For the design of the electrical equipment of machines, IEC 60204-1 gives general provisions about disconnection and switching of electrical circuits and for protection against electric shock. For requirements related to specific machines, see corresponding IEC standards (for example, IEC 61029, IEC 60745 or IEC 60335).	**N/A**
6.2.10	**Pneumatic and hydraulic hazards**	**--**
	Pneumatic and hydraulic equipment of machinery shall be designed so that	**--**
	- the maximum rated pressure cannot be exceeded in the circuits (using, for example, pressure-limiting devices), - no hazard results from pressure fluctuations or increases, or from loss of pressure or vacuum, - no hazardous fluid jet or sudden hazardous movement of the hose (whiplash) results from leakage or component failures, - air receivers, air reservoirs or similar vessels (such as in gas-loaded accumulators) comply with the applicable design standard codes or regulations for these elements, - all elements of the equipment, especially pipes and hoses, are protected against harmful external effects, - as far as possible, reservoirs and similar vessels (for example, gas-loaded accumulators) are automatically depressurized when isolating the machine from its power supply (see 6.3.5.4) and, if not possible, means are provided	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	for their isolation, local depressurizing and pressure indication (see also ISO 14118:2000, Clause 5), and - all elements which remain under pressure after isolation of the machine from its power supply are provided with clearly identified exhaust devices, and there is a warning label drawing attention to the necessity of depressurizing those elements before any setting or maintenance activity on the machine.	
	NOTE See also ISO 4413 and ISO 4414.	--
6.2.11	**Applying inherently safe design measures to control systems**	--
6.2.11.1	**General**	--
	The design measures of the control system shall be chosen so that their safety-related performance provides a sufficient amount of risk reduction (see ISO 13849-1 or IEC 62061).	**Pass**
	The correct design of machine control systems can avoid unforeseen and potentially hazardous machine behaviour.	**Pass**
	Typical causes of hazardous machine behaviour are - an unsuitable design or modification (accidental or deliberate) of the control system logic, - a temporary or permanent defect or failure of one or several components of the control system, - a variation or a failure in the power supply of the control system, and - inappropriate selection, design and location of the control devices.	**Pass**
	Typical examples of hazardous machine behaviour are - unexpected start-up (see ISO 14118), - uncontrolled speed change, - failure to stop moving parts, - dropping or ejection of part of the machine or of a workpiece clamped by the machine, and - machine action resulting from inhibition (defeating or failure) of protective devices.	**Pass**
	In order to prevent hazardous machine behaviour and to achieve safety functions, the design of control systems shall comply with the principles and methods presented in this subclause (6.2.11) and in 6.2.12. These principles and methods shall be applied singly or in combination as appropriate to the circumstances (see ISO 13849-1, EN 60204-1 and EN 62061).	**Pass**
	Control systems shall be designed to enable the operator to interact with the machine safely and easily. This requires one or several of the following solutions:	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	- systematic analysis of start and stop conditions; - provision for specific operating modes (for example, start-up after normal stop, restart after cycle interruption or after emergency stop, removal of the workpieces contained in the machine, operation of a part of the machine in case of a failure of a machine element); - clear display of the faults; - measures to prevent accidental generation of unexpected start commands (for example, shrouded start device) likely to cause dangerous machine behaviour (see ISO 14118:2000, Figure 1); - maintained stop commands (for example, interlock) to prevent restarting that could result in dangerous machine behaviour (see ISO 14118:2000, Figure 1).	
	An assembly of machines may be divided into several zones for emergency stopping, for stopping as a result of protective devices and/or for isolation and energy dissipation. The different zones shall be clearly defined and it shall be obvious which parts of the machine belong to which zone. Likewise, it shall be obvious which control devices (for example, emergency stop devices, supply disconnecting devices) and/or protective devices belong to which zone. The interfaces between zones shall be designed such that no function in one zone creates hazards in another zone which has been stopped for an intervention.	**Pass**
	Control systems shall be designed to limit the movements of parts of the machinery, the machine itself, or workpieces and/or loads held by the machinery, to the safe design parameters (for example, range, speed, acceleration, deceleration, load capacity). Allowance shall be made for dynamic effects (swinging of loads, etc.).	**Pass**
	For example: - the travelling speed of mobile pedestrian controlled machinery other than remote-controlled shall be compatible with walking speed; - the range, speed, acceleration and deceleration of movements of the person-carrier and carrying vehicle for lifting persons shall be limited to non-hazardous values, taking into account the total reaction time of the operator and the machine; - the range of movements of parts of machinery for lifting loads shall be kept within specified limits. When the machinery contains various elements that can be operated independently, the control system shall be designed to prevent risks arising out of a lack of coordination (for example,	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	collision prevention system).	
6.2.11.2	**Starting of an internal power source/switching on an external power supply**	**--**
	The starting of an internal power source or switching-on of an external power supply shall not result in a hazardous situation.	**Pass**
	For example: - starting the internal combustion engine shall not lead to movement of a mobile machine; - connection to mains electricity supply shall not result in the starting of working parts of a machine. See IEC 60204-1:2005, 7.5 (see also Annexes A and B).	**Pass**
6.2.11.3	**Starting/stopping of a mechanism**	**--**
	The primary action for starting or accelerating the movement of a mechanism should be performed by the application or an increase of voltage or fluid pressure, or — if binary logic elements are considered — by passage from state 0 to state 1 (where state 1 represents the highest energy state).	**Pass**
	The primary action for stopping or slowing down should be performed by removal or reduction of voltage or fluid pressure, or — if binary logic elements are considered — by passage from state 1 to state 0 (where state 1 represents the highest energy state).	**N/A**
	In certain applications, such as high-voltage switchgear, this principle cannot be followed, in which case other measures should be applied to achieve the same level of confidence for the stopping or slowing down.	**N/A**
	When, in order for the operator to maintain permanent control of deceleration, this principle is not observed (for example, a hydraulic braking device of a self-propelled mobile machine), the machine shall be equipped with a means of slowing and stopping in case of failure of the main braking system.	**Pass**
6.2.11.4	**Restart after power interruption**	**--**
	If a hazard could be generated, the spontaneous restart of a machine when it is re-energized after power interruption shall be prevented (for example, by use of a self-maintained relay, contactor or valve).	**Pass**
6.2.11.5	**Interruption of power supply**	**--**
	Machinery shall be designed to prevent hazardous situations resulting from interruption or excessive fluctuation of the power supply. At least the following requirements shall be met: - the stopping function of the machinery shall remain; - all devices whose permanent operation is required for safety shall operate in an effective way to maintain safety (for example, locking, clamping devices,	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	cooling or heating devices, power-assisted steering of self-propelled mobile machinery); - parts of machinery or workpieces and/or loads held by machinery which are liable to move as a result of potential energy shall be retained for the time necessary to allow them to be safely lowered.	
6.2.11.6	**Use of automatic monitoring**	**--**
	Automatic monitoring is intended to ensure that a safety function or functions implemented by a protective measure do not fail to be performed if the ability of a component or an element to perform its function is diminished, or if the process conditions are changed such that hazards are generated.	**N/A**
	Automatic monitoring either detects a fault immediately or carries out periodic checks so that a fault is detected before the next demand upon the safety function. In either case, the protective measure can be initiated immediately or delayed until a specific event occurs (for example, the beginning of the machine cycle).	**N/A**
	The protective measure may be, for example, - the stopping of the hazardous process, - preventing the restart of this process after the first stop following the failure, or - the triggering of an alarm.	**N/A**
6.2.11.7	**Safety functions implemented by programmable electronic control systems**	**--**
6.2.11.7.1	**General**	**--**
	A control system that includes programmable electronic equipment (for example, programmable controllers) can, where appropriate, be used to implement safety functions at machinery. Where a programmable electronic control system is used, it is necessary to consider its performance requirements in relation to the requirements for the safety functions. The design of the programmable electronic control system shall be such that the probability of random hardware failures and the likelihood of systematic failures that can adversely affect the performance of the safety-related control function(s) is sufficiently low. Where a programmable electronic control system performs a monitoring function, the system behaviour on detection of a fault shall be considered (see also the IEC 61508 series for further guidance).	**Pass**
	NOTE Both ISO 13849-1 and IEC 62061, specific to machinery safety, provide guidance applicable to programmable electronic control systems.	**--**
	The programmable electronic control system should be installed and	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	validated to ensure that the specified performance [for example, safety integrity level (SIL) in IEC 61508] for each safety function has been achieved. Validation comprises testing and analysis (for example, static, dynamic or failure analysis) to show that all parts interact correctly to perform the safety function and that unintended functions do not occur.	
6.2.11.7.2	**Hardware aspects**	**--**
	The hardware (including, for example, sensors, actuators and logic solvers) shall be selected, and/or designed and installed, to meet both the functional and performance requirements of the safety function(s) to be performed, in particular, by means of - architectural constraints (the configuration of the system, its ability to tolerate faults, its behaviour on detection of a fault, etc.), - selection, and/or design, of equipment and devices with an appropriate probability of dangerous random hardware failure, and - the incorporation of measures and techniques within the hardware so as to avoid systematic failures and control systematic faults.	**Pass**
6.2.11.7.3	**Software aspects**	**--**
	The software, including internal operating software (or system software) and application software, shall be designed so as to satisfy the performance specification for the safety functions (see also IEC 61508-3).	**Pass**
	Application software should not be reprogrammable by the user. This may be achieved by use of embedded software in a non-reprogrammable memory [for example, micro-controller, application-specific integrated circuit (ASIC)].	**Pass**
	When the application requires reprogramming by the user, the access to the software dealing with safety functions should be restricted (for example, by locks or passwords for the authorized persons).	**N/A**
6.2.11.8	**Principles relating to manual control**	**--**
	These are as follows.	**--**
	a) Manual control devices shall be designed and located according to the relevant ergonomic principles given in 6.2.8, item f).	**Pass**
	b) A stop control device shall be placed near each start control device. Where the start/stop function is performed by means of a hold-to-run control, a separate stop control device shall be provided when a risk can result from the hold-to-run control device failing to deliver a stop command when released.	**Pass**
	c) Manual controls shall be located out of reach of the danger zones (see IEC 61310-3), except for certain controls where, of necessity, they are located within a danger zone, such as emergency stop or teach pendant.	**Pass**
	d) Whenever possible, control devices and control positions shall be located	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	so that the operator is able to observe the working area or hazard zone. 1) The driver of a ride-on mobile machine shall be able to actuate all control devices required to operate the machine from the driving position, except for functions which can be controlled more safely from other positions. 2) On machinery intended for lifting persons, controls for lifting and lowering and, if appropriate, for moving the carrier shall generally be located in the carrier. If safe operation requires controls to be situated outside the carrier, the operator in the carrier shall be provided with the means of preventing hazardous movements.	
	e) If it is possible to start the same hazardous element by means of several controls, the control circuit shall be so arranged that only one control is effective at a given time. This applies especially to machines which can be manually controlled by means of, among others, a portable control unit (such as a teach pendant), with which the operator can enter danger zones.	**Pass**
	f) Control actuators shall be designed or guarded so that their effect, where a risk is involved, cannot occur without intentional operation (see ISO 9355-1, ISO 9355-3 and ISO 447).	**Pass**
	g) For machine functions whose safe operation depends on permanent, direct control by the operator, measures shall be implemented to ensure the presence of the operator at the control position (for example, by the design and location of control devices)..	**Pass**
	h) For cableless control, an automatic stop shall be performed when correct control signals are not received, including loss of communication (see IEC 60204-1)	**N/A**
6.2.11.9	**Control mode for setting, teaching, process changeover, fault-finding, cleaning or maintenance**	**--**
	Where, for setting, teaching, process changeover, fault-finding, cleaning or maintenance of machinery, a guard has to be displaced or removed and/or a protective device has to be disabled, and where it is necessary for the purpose of these operations for the machinery or part of the machinery to be put into operation, the safety of the operator shall be achieved using a specific control mode which simultaneously a) disables all other control modes, b) permits operation of the hazardous elements only by continuous actuation of an enabling device, a two-hand control device or a hold-to-run control device, c) permits operation of the hazardous elements only in reduced risk conditions (for example, reduced speed, reduced power/force, step-by-step,	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	for example, with a limited movement control device), and d) prevents any operation of hazardous functions by voluntary or involuntary action on the machine's sensors.	
	NOTE For some special machinery other protective measures can be appropriate.	--
	This control mode shall be associated with one or more of the following measures: - restriction of access to the danger zone as far as possible; - emergency stop control within immediate reach of the operator; - portable control unit (teach pendant) and/or local controls (allowing sight of the controlled elements).	N/A
	See IEC 60204-1.	N/A
6.2.11.10	**Selection of control and operating modes**	
	If machinery has been designed and built to allow for its use in several control or operating modes requiring different protective measures and/or work procedures (for example, to allow for adjustment, setting, maintenance, inspection), it shall be fitted with a mode selector which can be locked in each position. Each position of the selector shall be clearly identifiable and shall exclusively allow one control or operating mode.	N/A
	The selector may be replaced by another selection means which restricts the use of certain functions of the machinery to certain categories of operators (for example, access codes for certain numerically controlled functions).	N/A
6.2.11.11	**Applying measures to achieve electromagnetic compatibility (EMC)**	--
	For guidance on electromagnetic compatibility, see IEC 60204-1 and IEC 61000-6.	N/A
6.2.11.12	**Provision of diagnostic systems to aid fault-finding**	--
	Diagnostic systems to aid fault-finding should be included in the control system so that there is no need to disable any protective measure.	N/A
	NOTE Such systems not only improve availability and maintainability of machinery, they also reduce the exposure of maintenance staff to hazards.	--
6.2.12	**Minimizing probability of failure of safety functions**	--
6.2.12.1	**General**	--
	Safety of machinery is not only dependent on the reliability of the control systems but also on the reliability of all parts of the machine.	Pass
	The continued operation of the safety functions is essential for the safe use of the machine. This can be achieved by the measures given in 6.2.12.2 to 6.2.12.4.	Pass
6.2.12.2	**Use of reliable components**	--

EN ISO 12100		
Clause	Requirement – Test	Verdict
	"Reliable components" means components which are capable of withstanding all disturbances and stresses associated with the usage of the equipment in the conditions of intended use (including the environmental conditions), for the period of time or the number of operations fixed for the use, with a low probability of failures generating a hazardous malfunctioning of the machine. Components shall be selected taking into account all factors mentioned above (see also 6.2.13).	**Pass**
	NOTE 1 "Reliable components" is not a synonym for "well-tried components" (see ISO 13849-1:2006, 6.2.4). NOTE 2 Environmental conditions for consideration include impact, vibration, cold, heat, moisture, dust, corrosive and/or abrasive substances, static electricity and magnetic and electric fields. Disturbances which can be generated by those conditions include insulation failures and temporary or permanent failures in the function of control system components.	**--**
6.2.12.3	**Use of "oriented failure mode" components**	**--**
	"Oriented failure mode" components or systems are those in which the predominant failure mode is known in advance and which can be used so that the effect of such a failure on the machine function can be predicted.	**N/A**
	NOTE In some cases, it will be necessary to take additional measures to limit the negative effects of such a failure.	**--**
	The use of such components should always be considered, particularly in cases where redundancy (see 6.2.12.4) is not employed.	**N/A**
6.2.12.4	**Duplication (or redundancy) of components or subsystems**	**--**
	In the design of safety-related parts of the machine, duplication (or redundancy) of components may be used so that, if one component fails, another component or components continue to perform the respective function(s), thereby ensuring that the safety function remains available.	**N/A**
	In order to allow the proper action to be initiated, component failure shall be detected by automatic monitoring (see 6.2.11.6) or in some circumstances by regular inspection, provided that the inspection interval is shorter than the expected lifetime of the components.	**N/A**
	Diversity of design and/or technology can be used to avoid common cause failures (for example, from electromagnetic disturbance) or common mode failures.	**N/A**
6.2.13	**Limiting exposure to hazards through reliability of equipment**	**--**
	Increased reliability of all component parts of machinery reduces the frequency of incidents requiring intervention, thereby reducing exposure to hazards.	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	This applies to power systems (operative part, see Annex A) as well as to control systems, and to safety functions as well as to other functions of machinery.	**Pass**
	Safety-related components (for example, certain sensors) of known reliability shall be used.	**Pass**
	The elements of guards and of protective devices shall be especially reliable, as their failure can expose persons to hazards, and also because poor reliability would encourage attempts to defeat them.	**Pass**
6.2.14	**Limiting exposure to hazards through mechanization or automation of loading (feeding)/unloading (removal) operations**	**--**
	Mechanization and automation of machine loading/unloading operations and, more generally, of handling operations — of workpieces, materials or substances — limits the risk generated by these operations by reducing the exposure of persons to hazards at the operating points.	**N/A**
	Automation can be achieved by, for example, robots, handling devices, transfer mechanisms and air-blast equipment. Mechanization can be achieved by, for example, feeding slides, push-rods and hand-operated indexing tables.	**N/A**
	While automatic feeding and removal devices have much to offer in preventing accidents to machine operators, they can create danger when any faults are being corrected. Care shall be taken to ensure that the use of these devices does not introduce further hazards, such as trapping or crushing, between the devices and parts of the machine or workpieces/materials being processed. Suitable safeguards (see 6.3) shall be provided if this cannot be ensured.	**N/A**
	Automatic feeding and removal devices with their own control systems and the control system of the associated machine shall be interconnected after thorough study of how all safety functions are performed in all the control and operation modes of the entire equipment.	**N/A**
6.2.15	**Limiting exposure to hazards through location of setting and maintenance points outside danger zones**	**--**
	The need for access to danger zones shall be minimized by locating maintenance, lubrication and setting points outside these zones.	**Pass**
6.3	**Safeguarding and complementary protective measures**	**--**
6.3.1	**General**	**--**
	Guards and protective devices shall be used to protect persons whenever an inherently safe design measure does not reasonably make it possible either to remove hazards or to sufficiently reduce risks. Complementary protective	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	measures involving additional equipment (for example, emergency stop equipment) may have to be implemented.	
	NOTE The different kinds of guards and protective devices are defined in 3.27 and 3.28.	--
	Certain safeguards may be used to avoid exposure to more than one hazard.	**Pass**
	EXAMPLE A fixed guard preventing access to a zone where a mechanical hazard is present used to reduce noise levels and collect toxic emissions.	--
6.3.2	**Selection and implementation of guards and protective devices**	--
6.3.2.1	**General**	--
	This subclause gives guidelines for the selection and the implementation of guards and protective devices the primary purpose of which is to protect persons against hazards generated by moving parts, according to the nature of those parts (see Figure 4) and to the need for access to the danger zone(s).	**Pass**
	The exact choice of a safeguard for a particular machine shall be made on the basis of the risk assessment for that machine.	**Pass**
	In selecting an appropriate safeguard for a particular type of machinery or hazard zone, it shall be borne in mind that a fixed guard is simple and shall be used where the access of an operator into a danger zone is not required during the normal operation (operation without malfunction) of the machinery.	**Pass**
	As the need for frequency of access increases, this inevitably leads to the fixed guard not being replaced. This requires the use of an alternative protective measure (movable interlocking guard, sensitive protective equipment).	**Pass**
	A combination of safeguards can sometimes be required. For example, where, in conjunction with a fixed guard, a mechanical loading (feeding) device is used to feed a workpiece into a machine, thereby removing the need for access to the primary hazard zone, a trip device can be required to protect against the secondary drawing-in or shearing hazard between the mechanical loading (feeding) device, when reachable, and the fixed guard.	**Pass**
	Consideration shall be given to the enclosure of control positions or intervention zones to provide combined protection against several hazards including a) hazards from falling or ejected objects, using, for example, protection in the form of a falling object protection structure (FOPS), b) emission hazards (protection against noise, vibration, radiation, substances hazardous to health, etc.), c) hazards due to the environment (protection against heat, cold, foul	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	weather, etc.), d) hazards due to tipping over or rolling over of machinery, using, for example, protection in the form of roll-over or tip-over protection structures (ROPS and TOPS).	
	The design of enclosed work stations, such as cabs and cabins, shall take into account ergonomic principles concerning visibility, lighting, atmospheric conditions, access, posture.	**N/A**
6.3.2.2	**Where access to the hazard zone is not required during normal operation**	**--**
	Where access to the hazard zone is not required during normal operation of the machinery, safeguards should be selected from the following: a) fixed guards (see also ISO 14120); b) interlocking guards with or without guard locking (see also 6.3.3.2.3, ISO 14119 and ISO 14120); c) self-closing guards (see ISO 14120:2002, 3.3.2); d) sensitive protective equipment, such as electrosensitive protective equipment (see IEC 61496) or pressure-sensitive protective devices (see ISO 13856).	**N/A**
6.3.2.3	**Where access to the hazard zone is required during normal operation**	**--**
	Where access to the hazard zone is required during normal operation of the machinery, safeguards should be selected from the following: a) interlocking guards with or without guard locking (see also ISO 14119, ISO 14120 and 6.3.3.2.3 of this document); b) sensitive protective equipment, such as electrosensitive protective equipment (see IEC 61496); c) adjustable guards; d) self-closing guards (see ISO 14120:2002, 3.3.2); e) two-hand control devices (see ISO 13851); f) interlocking guards with a start function (control guard) (see 6.3.3.2.5).	**Pass**
6.3.2.4	**Where access to the hazard zone is required for machine setting, teaching, process changeover, fault-finding, cleaning or maintenance**	**--**
	As far as possible, machines shall be designed so that the safeguards provided for the protection of the production operator also ensure the protection of personnel carrying out setting, teaching, process changeover, fault-finding, cleaning or maintenance, without hindering them in the performance of their task. Such tasks shall be identified and considered in the	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	risk assessment as parts of the use of the machine (see 5.2).	
	NOTE Isolation and energy dissipation for machine shut-down (see 6.3.5.4, and also ISO 14118:2000, 4.1 and Clause 5) ensure the highest level of safety when carrying out tasks (especially maintenance and repair tasks) that do not require the machine to remain connected to its power supply.	--
6.3.2.5	**Selection and implementation of sensitive protective equipment**	--
6.3.2.5.1	**Selection**	--
	Due to the great diversity of the technologies on which their detection function is based, all types of sensitive protective equipment are far from being equally suitable for safety applications. The following provisions are intended to provide the designer with criteria for selecting, for each application, the most suitable device(s).	**N/A**
	Types of sensitive protective equipment include - light curtains, - scanning devices, for example, laser scanners, - pressure-sensitive mats, and - trip bars, trip wires.	**N/A**
	Sensitive protective equipment can be used - for tripping purposes, - for presence sensing, - for both tripping and presence sensing, or - to re-initiate machine operation — a practice subject to stringent conditions.	**N/A**
	NOTE Some types of sensitive protective equipment can be unsuitable either for presence sensing or for tripping purposes.	--
	The following characteristics of the machinery, among others, can preclude the sole use of sensitive protective equipment: - tendency for the machinery to eject materials or component parts; - necessity to guard against emissions (noise, radiation, dust, etc.); - erratic or excessive machine stopping time; - inability of a machine to stop part-way through a cycle.	**N/A**
6.3.2.5.2	**Implementation**	--
	Consideration should be given to a) the size, characteristics and positioning of the detection zone (see ISO 13855, which deals with the positioning of some types of sensitive protective equipment), b) the reaction of the device to fault conditions (see IEC 61496 for electrosensitive protective equipment), c) the possibility of circumvention, and	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	d) detection capability and its variation over the course of time (as a result, for example, of its susceptibility to different environmental conditions such as the presence of reflecting surfaces, other artificial light sources and sunlight or impurities in the air).	
	NOTE 1 IEC 61496 defines the detection capability of electrosensitive protective equipment.	--
	Sensitive protective equipment shall be integrated in the operative part and associated with the control system of the machine so that - a command is given as soon as a person or part of a person is detected, - the withdrawal of the person or part of a person detected does not, by itself, restart the hazardous machine function(s), and therefore the command given by the sensitive protective equipment is maintained by the control system until a new command is given, - restarting the hazardous machine function(s) results from the voluntary actuation by the operator of a control device placed outside the hazard zone, where this zone can be observed by the operator, - the machine cannot operate during interruption of the detection function of the sensitive protective equipment, except during muting phases, and - the position and the shape of the detection field prevents, possibly together with fixed guards, a person or part of a person from entering or being present in the hazard zone without being detected.	**N/A**
	NOTE 2 Muting is the temporary automatic suspension of a safety function(s) by safety-related parts of the control system (see ISO 13849-1).	**N/A**
	For detailed consideration of the fault behaviour of, for example, active optoelectronic protective devices, IEC 61496 should be taken into account.	**N/A**
6.3.2.5.3	**Additional requirements for sensitive protective equipment when used for cycle initiation**	
	In this exceptional application, the starting of the machine cycle is initiated by the withdrawal of a person or of the detected part of a person from the sensing field of the sensitive protective equipment, without any additional start command, hence deviating from the general requirement given in the second point of the dashed list in 6.3.2.5.2, above. After switching on the power supply, or when the machine has been stopped by the tripping function of the sensitive protective equipment, the machine cycle shall be initiated only by voluntary actuation of a start control.	**N/A**
	Cycle initiation by sensitive protective equipment shall be subject to the following conditions: a) only active optoelectronic protective devices (AOPDs) complying with IEC	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	61496 series shall be used; b) the requirements for an AOPD used as a tripping and presence-sensing device (see IEC 61496) are satisfied — in particular, location, minimum distance (see ISO 13855), detection capability, reliability and monitoring of control and braking systems; c) the cycle time of the machine is short and the facility to re-initiate the machine upon clearing of the sensing field is limited to a period commensurate with a single normal cycle; d) entering the sensing field of the AOPD(s) or opening interlocking guards is the only way to enter the hazard zone; e) if there is more than one AOPD safeguarding the machine, only one of the AOPDs is capable of cycle re-initiation; f) with regard to the higher risk resulting from automatic cycle initiation, the AOPD and the associated control system comply with a higher safety-related performance than under normal conditions.	
	NOTE 1 The hazard zone as referred to in d) is any zone where the hazardous function (including ancillary equipment and transmission elements) is initiated by clearing of the sensing field. NOTE 2 See also IEC/TS 62046.	--
6.3.2.6	**Protective measures for stability**	--
	If stability cannot be achieved by inherently safe design measures such as weight distribution (see 6.2.6), it shall be maintained by the use of protective measures such as - anchorage bolts, - locking devices, - movement limiters or mechanical stops, - acceleration or deceleration limiters, - load limiters, and - alarms warning of the approach to stability or tipping limits.	**Pass anchorage bolts,**
6.3.2.7	**Other protective devices**	--
	When a machine requires continuous control by the operator (for example, mobile machines, cranes) and an error of the operator can generate a hazardous situation, this machine shall be equipped with the necessary devices to enable the operation to remain within specified limits, in particular - when the operator has insufficient visibility of the hazard zone, - when the operator lacks knowledge of the actual value of a safety-related parameter (distance, speed, mass, angle, etc.), and - when hazards can result from operations other than those controlled by the	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	operator.	
	The necessary devices include a) devices for limiting parameters of movement (distance, angle, velocity, acceleration), b) overloading and moment limiting devices, c) devices to prevent collisions or interference with other machines, d) devices for preventing hazards to pedestrian operators of mobile machinery or other pedestrians, e) torque limiting devices, and breakage points to prevent excessive stress of components and assemblies, f) devices for limiting pressure or temperature, g) devices for monitoring emissions, h) devices to prevent operation in the absence of the operator at the control position, i) devices to prevent lifting operations unless stabilizers are in place, j) devices to limit inclination of the machine on a slope, and k) devices to ensure that components are in a safe position before travelling.	**Pass**
	Automatic protective measures triggered by such devices that take operation of the machinery out of the control of the operator (for example, automatic stop of hazardous movement) should be preceded or accompanied by a warning signal to enable the operator to take appropriate action (see 6.4.3).	**N/A**
6.3.3	**Requirements for design of guards and protective devices**	**--**
6.3.3.1	**General requirements**	**--**
	Guards and protective devices shall be designed to be suitable for the intended use, taking into account mechanical and other hazards involved. Guards and protective devices shall be compatible with the working environment of the machine and designed so that they cannot be easily defeated. They shall provide the minimum possible interference with activities during operation and other phases of machine life, in order to reduce any incentive to defeat them.	**Pass**
	NOTE For additional information, see ISO 14120, ISO 13849-1, ISO 13851, ISO 14119, ISO 13856, IEC 61496 and IEC 62061.	**--**
	Guards and protective devices shall a) be of robust construction, b) not give rise to any additional hazard, c) not be easy to bypass or render non-operational, d) be located at an adequate distance from the danger zone (see ISO 13855 and ISO 13857),	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	e) cause minimum obstruction to the view of the production process, and f) enable essential work to be carried out for the installation and/or replacement of tools and for maintenance by allowing access only to the area where the work has to be carried out — if possible, without the guard having to be removed or protective device having to be disabled.	
	For openings in the guards, see ISO 13857.	**Pass**
6.3.3.2	**Requirements for guards**	**--**
6.3.3.2.1	**Functions of guards**	**--**
	The functions that guards can achieve are - prevention of access to the space enclosed by the guard, and/or - containment/capture of materials, workpieces, chips, liquids which can be ejected or dropped by the machine, and reduction of emissions (noise, radiation, hazardous substances such as dust, fumes, gases) that can be generated by the machine.	**Pass**
	Additionally, they could need to have particular properties relating to electricity, temperature, fire, explosion, vibration, visibility (see ISO 14120) and operator position ergonomics (for example, usability, operator's movements, postures, repetitive movements).	**Pass**
6.3.3.2.2	**Requirements for fixed guards**	**--**
	Fixed guards shall be securely held in place either - permanently (for example by welding), or - by means of fasteners (screws, nuts) making removal/opening impossible without using tools; they should not remain closed without their fasteners (see ISO 14120).	**Pass**
	NOTE A fixed guard can be hinged to assist in its opening.	**--**
6.3.3.2.3	**Requirements for movable guards**	**--**
	Movable guards which provide protection against hazards generated by moving transmission parts shall a) as far as possible when open remain fixed to the machinery or other structure (generally by means of hinges or guides), and b) be interlocking (with guard locking when necessary) (see ISO 14119). See Figure 4.	**N/A**
	Movable guards against hazards generated by non-transmission moving parts shall be designed and associated with the machine control system so that - moving parts cannot start up while they are within the operator's reach and the operator cannot reach moving parts once they have started up, with this able to be achieved by interlocking guards, with guard locking when	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	necessary, - they can be adjusted only by an intentional action, such as the use of a tool or a key, and - the absence or failure of one of their components either prevents starting of the moving parts or stops them, with this able to be achieved by automatic monitoring (see 6.2.11.6). See Figure 4 and ISO 14119.	
6.3.3.2.4	**Requirements for adjustable guards**	**--**
	Adjustable guards may only be used where the hazard zone cannot for operational reasons be completely enclosed.	**N/A**
	Manually adjustable guards shall be - designed so that the adjustment remains fixed during a given operation, and - readily adjustable without the use of tools.	**N/A**
6.3.3.2.5	**Requirements for interlocking guards with a start function (control guards)**	**--**
	An interlocking guard with a start function may only be used provided that a) all requirements for interlocking guards are satisfied (see ISO 14119), b) the cycle time of the machine is short, c) the maximum opening time of the guard is preset to a low value (for example, equal to the cycle time) and, when this time is exceeded, the hazardous function(s) cannot be initiated by the closing of the interlocking guard with a start function and resetting is necessary before restarting the machine, d) the dimensions or shape of the machine do not allow a person, or part of a person, to stay in the hazard zone or between the hazard zone and the guard while the guard is closed (see ISO 14120), e) all other guards, whether fixed (removable type) or movable, are interlocking guards, f) the interlocking device associated with the interlocking guard with a start function is designed such that — for example, by duplication of position detectors and use of automatic monitoring (see 6.2.11.6) — its failure cannot lead to an unintended/unexpected start-up, and g) the guard is securely held open (for example, by a spring or counterweight) such that it cannot initiate a start while falling by its own weight.	**N/A**
6.3.3.2.6	**Hazards from guards**	**--**
	Care shall be taken to prevent hazards which could be generated by - the guard construction (sharp edges or corners, material, noise emission, etc.),	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict

	- the movements of the guards (shearing or crushing zones generated by power-operated guards and by heavy guards which are liable to fall).	
6.3.3.3	**Technical characteristics of protective devices**	**--**
	Protective devices shall be selected or designed and connected to the control system such that correct implementation of their safety function(s) is ensured.	**Pass**
	Protective devices shall be selected on the basis of their having met the appropriate product standard (for example, IEC 61496 for active optoelectronic protective devices) or shall be designed according to one or several of the principles formulated in ISO 13849-1 or IEC 62061.	**Pass**
	Protective devices shall be installed and connected to the control system so that they cannot be easily defeated.	**Pass**
6.3.3.4	**Provisions for alternative types of safeguards**	**Pass**
	Provisions should be made to facilitate the fitting of alternative types of safeguards on machinery where it is known that it will be necessary to change the safeguards because of the range of work to be carried out.	
6.3.4	**Safeguarding to reduce emissions**	**--**
6.3.4.1	**General**	**--**
	If the measures for the reduction of emissions at source specified in 6.2.2.2 are not adequate, the machine shall be provided with additional protective measures (see 6.3.4.2 to 6.3.4.5).	**Pass**
6.3.4.2	**Noise**	**--**
	Additional protective measures against noise include - enclosures (see ISO 15667), - screens fitted to the machine, and - silencers (see ISO 14163).	**Pass**
6.3.4.3	**Vibration**	**--**
	Additional protective measures against vibration include - vibration isolators, such as damping devices placed between the source and the exposed person, - resilient mounting, and - suspended seats.	**N/A**
	For measures for vibration isolation of stationary industrial machinery see EN 1299.	**N/A**
6.3.4.4	**Hazardous substances**	**--**
	Additional protective measures against hazardous substances include - encapsulation of the machine (enclosure with negative pressure), - local exhaust ventilation with filtration, - wetting with liquids, and	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	- special ventilation in the area of the machine (air curtains, cabins for operators). See ISO 14123-1.	
6.3.4.5	**Radiation**	**--**
	Additional protective measures against radiation include - use of filtering and absorption, and - use of attenuating screens or guards.	**N/A**
6.3.5	**Complementary protective measures**	**--**
6.3.5.1	**General**	**--**
	Protective measures which are neither inherently safe design measures, nor safeguarding (implementation of guards and/or protective devices), nor information for use, could have to be implemented as required by the intended use and the reasonably foreseeable misuse of the machine. Such measures include, but are not limited to, those dealt with in 6.3.5.2 to 6.3.5.6.	**Pass**
6.3.5.2	**Components and elements to achieve emergency stop function**	**--**
	If, following a risk assessment, a machine needs to be fitted with components and elements to achieve an emergency stop function for enabling actual or impending emergency situations to be averted, the following requirements apply: - the actuators shall be clearly identifiable, clearly visible and readily accessible; - the hazardous process shall be stopped as quickly as possible without creating additional hazards, but if this is not possible or the risk cannot be reduced, it should be questioned whether implementation of an emergency stop function is the best solution; - the emergency stop control shall trigger or permit the triggering of certain safeguard movements where necessary.	**N/A**
	NOTE For more detailed provisions, see ISO 13850.	**--**
	Once active operation of the emergency stop device has ceased following an emergency stop command, the effect of this command shall be sustained until it is reset. This reset shall be possible only at the location where the emergency stop command has been initiated. The reset of the device shall not restart the machinery, but shall only permit restarting.	**N/A**
	More details for the design and selection of electrical components and elements to achieve the emergency stop function are provided in IEC 60204.	**N/A**
6.3.5.3	**Measures for the escape and rescue of trapped persons**	**--**
	Measures for the escape and rescue of trapped persons may consist, among others, of	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	- escape routes and shelters in installations generating operator-trapping hazards, - arrangements for moving some elements by hand, after an emergency stop, - arrangements for reversing the movement of some elements, - anchorage points for descender devices, - means of communication to enable trapped operators to call for help.	
6.3.5.4	**Measures for isolation and energy dissipation**	**--**
	Machines shall be equipped with the technical means to achieve isolation from power supply(ies) and dissipation of stored energy by means of the following actions: a) isolating (disconnecting, separating) the machine (or defined parts of the machine) from all power supplies; b) locking (or otherwise securing) all the isolating units in the isolating position; c) dissipating or, if this is not possible or practicable, restraining (containing) any stored energy which can give rise to a hazard; d) verifying, by means of safe working procedures, that the actions taken according to a), b) and c) above have produced the desired effect. See ISO 14118:2000, Clause 5, and IEC 60204-1:2005, 5.5 and 5.6.	**N/A**
6.3.5.5	**Provisions for easy and safe handling of machines and their heavy component parts**	**--**
	Machines and their component parts which cannot be moved or transported by hand shall be provided or be capable of being provided with suitable attachment devices for transport by means of lifting gear.	**Pass**
	These attachments may be, among others, - standardized lifting appliances with slings, hooks, eyebolts, or tapped holes for appliance fixing, - appliances for automatic grabbing with a lifting hook when attachment is not possible from the ground, - fork locating devices for machines to be transported by a lift truck, - lifting and stowing gear and appliances integrated into the machine.	**Pass**
	Parts of machinery which can be removed manually in operation shall be provided with means for their safe removal and replacement. See also 6.4.4 c), item 3).	**Pass**
6.3.5.6	**Measures for safe access to machinery**	**--**
	Machinery shall be so designed as to enable operation and all routine tasks relating to setting and/or maintenance to be carried out as far as possible by a person remaining at ground level.	**Pass**
	Where this is not possible, machines shall have built-in platforms, stairs or	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	other facilities to provide safe access for those tasks; however, care should be taken to ensure that such platforms or stairs do not give access to danger zones of machinery.	
	The walking areas shall be made from materials which remain as slip resistant as practicable under working conditions and, depending on the height from the ground, shall be provided with suitable guard-rails (see ISO 14122-3).	**Pass**
	In large automated installations, particular attention shall be given to safe means of access, such as walkways, conveyor bridges or crossover points.	**N/A**
	Means of access to parts of machinery located at height shall be provided with collective means of protection against falls (for example, guard-rails for stairways, stepladders and platforms and/or safety cages for ladders). As necessary, anchorage points for personal protective equipment against falls from height shall also be provided (for example, in carriers of machinery for lifting persons or with elevating control stations).	**Pass**
	Openings shall, whenever possible, open towards a safe position. They shall be designed to prevent hazards due to unintended opening.	**Pass**
	The necessary aids for access shall be provided (steps, handholds, etc.). Control devices shall be designed and located to prevent their being used as aids for access.	**Pass**
	When machinery for lifting goods and/or persons includes landings at fixed levels, these shall be equipped with interlocking guards for preventing falls when the platform is not present at a level. Movement of the lifting platform shall be prevented while the guards are open.	**N/A**
	For detailed provisions see ISO 14122.	--
6.4	**Information for use**	--
6.4.1	**General requirements**	--
6.4.1.1	Drafting information for use is an integral part of the design of a machine (see Figure 2). Information for use consists of communication links, such as texts, words, signs, signals, symbols or diagrams, used separately or in combination to convey information to the user. Information for use is intended for professional and/or non-professional users.	**Pass**
	NOTE See also IEC 62079 for structuring and presentation of information for use.	--
6.4.1.2	Information shall be provided to the user about the intended use of the machine, taking into account, notably, all its operating modes.	**Pass**
	The information shall contain all directions required to ensure safe and correct use of the machine. With this in view, it shall inform and warn the user	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	about residual risk.	
	The information shall indicate, as appropriate, - the need for training, - the need for personal protective equipment, and - the possible need for additional guards or protective devices (see Figure 2, Footnote d).	**Pass**
	It shall not exclude uses of the machine that can reasonably be expected from its designation and description and shall also warn about the risk which would result from using the machine in other ways than the ones described in the information, especially considering its reasonably foreseeable misuse.	**Pass**
6.4.1.3	Information for use shall cover, separately or in combination, transport, assembly and installation, commissioning, use of the machine (setting, teaching/programming or process changeover, operation, cleaning, fault-finding and maintenance) and, if necessary, dismantling, disabling and scrapping.	**Pass**
6.4.2	**Location and nature of information for use**	**--**
	Depending on the risk, the time when the information is needed by the user and the machine design, it shall be decided whether the information — or parts thereof — are to be given a) in/on the machine itself (see 6.4.3 and 6.4.4), b) in accompanying documents (in particular instruction handbook, see 6.4.5), c) on the packaging, d) by other means such as signals and warnings outside the machine.	**Pass**
	Standardized phrases shall be considered where important messages such as warnings are given (see also IEC 62079).	**Pass**
6.4.3	**Signals and warning devices**	**--**
	Visual signals, such as flashing lights and audible signals such as sirens may be used to warn of an impending hazardous event such as machine start-up or overspeed. Such signals may also be used to warn the operator before the triggering of automatic protective measures (see 6.3.2.7).	**N/A**
	It is essential that these signals a) be emitted before the occurrence of the hazardous event, b) be unambiguous, c) be clearly perceived and differentiated from all other signals used, and d) be clearly recognized by the operator and other persons.	**N/A**
	The warning devices shall be designed and located such that checking is easy. The information for use shall prescribe regular checking of warning	**N/A**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	devices.	
	The attention of designers is drawn to the possibility of “sensorial saturation”, which can result from too many visual and/or acoustic signals and which can also lead to defeating the warning devices.	**N/A**
	NOTE Consultation of the user on this subject is often necessary.	--
6.4.4	**Markings, signs (pictograms) and written warnings**	--
	Machinery shall bear all markings which are necessary	--
	a) for its unambiguous identification, including at least 1) the name and address of the manufacturer, 2) the designation of series or type, and 3) the serial number, if any,	**Pass**
	b) in order to indicate its compliance with mandatory requirements, comprising 1) marking, and 2) written indications, such as the authorized representative of the manufacturer, designation of the c) for its safe use, for example, 1) maximum speed of rotating parts, 2) maximum diameter of tools, 3) mass (in kilograms) of the machine itself and/or of removable parts, 4) maximum working load, 5) necessity of wearing personal protective equipment, 6) guard adjustment data, and 7) frequency of inspection.	**Pass**
	Information printed directly on the machine should be permanent and remain legible throughout the expected life of the machine.	**Pass**
	Signs or written warnings indicating only “Danger” shall not be used.	**Pass**
	Markings, signs and written warnings shall be readily understandable and unambiguous, especially as regards the part of the function(s) of the machine to which they are related. Readily understandable signs (pictograms) should be used in preference to written warnings.	**Pass**
	Signs and pictograms should only be used if they are understood in the culture in which the machinery is to be used.	**Pass**
	Written warnings shall be drawn up in the language(s) of the country in which the machine will be used for the first time and, on request, in the language(s) understood by operators.	**Pass**
	NOTE In some countries the use of specific language(s) is covered by legal requirements.	--
	Markings shall comply with recognized standards (for example, ISO 2972 or	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	ISO 7000, for pictograms, symbols and colours in particular).	
	See IEC 60204-1 as regards marking of electrical equipment.	**Pass**
	See ISO 4413 and ISO 4414 for hydraulic and pneumatic equipment.	**Pass**
6.4.5	**Accompanying documents (in particular — instruction handbook)**	**N/A**
6.4.5.1	**Contents**	**--**
	The instruction handbook or other written instructions (for example, on the packaging) shall contain, among others, the following:	**Pass**
	a) information relating to transport, handling and storage of the machine, such as 1) storage conditions for the machine, 2) dimensions, mass value(s), position of the centre(s) of gravity, and 3) indications for handling (for example, drawings indicating application points for lifting equipment);	**Pass**
	b) information relating to installation and commissioning of the machine, such as 1) fixing/anchoring and dampening of noise and vibration requirements, 2) assembly and mounting conditions, 3) space needed for use and maintenance, 4) permissible environmental conditions (for example, temperature, moisture, vibration, electromagnetic radiation), 5) instructions for connecting the machine to power supply (particularly on protection against electrical overloading), 6) advice on waste removal/disposal, and 7) if necessary, recommendations related to protective measures which have to be implemented by the user — for example, additional safeguards (see Figure 2, Footnote d), safety distances, safety signs and signals;	**Pass**
	c) information relating to the machine itself, such as 1) detailed description of the machine, its fittings, guards and/or protective devices, 2) the comprehensive range of applications for which the machine is intended, including prohibited usages, if any, taking into account variations of the original machine if appropriate, 3) diagrams (especially schematic representation of safety functions), 4) data on noise and vibration generated by the machine, and on radiation,	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	gases, vapours and dust emitted by it, with reference to the measuring methods (including measurement uncertainties) used, 5) technical documentation of electrical equipment (see IEC 60204), and 6) documents attesting that the machine complies with mandatory requirements;	
	d) information relating to the use of the machine, such as that related to or describing 1) intended use, 2) manual controls (actuators), 3) setting and adjustment, 4) modes and means for stopping (especially emergency stop), 5) risks which could not be eliminated by the protective measures implemented by the designer, 6) particular risks which can be generated by certain applications, by the use of certain fittings, and about specific safeguards necessary for such applications, 7) reasonably foreseeable misuse and prohibited applications, 8) fault identification and location, for repair and for restarting after an intervention, and 9) personal protective equipment needed to be used and the training that is required;	**Pass**
	e) information for maintenance, such as 1) the nature and frequency of inspections for safety functions, 2) specification of the spare parts to be used when these can affect the health and safety of operators, 3) instructions relating to maintenance operations which require a definite technical knowledge or particular skills and hence need to be carried out exclusively by skilled persons (for example, maintenance staff, specialists), 4) instructions relating to maintenance actions (replacement of parts, etc.) which do not require specific skills and hence may be carried out by users (for example, operators), and 5) drawings and diagrams enabling maintenance personnel to carry out their task rationally (especially fault-finding tasks);	**Pass**
	f) information relating to dismantling, disabling and scrapping;	**Pass**
	g) information for emergency situations, such as 1) the operating method to be followed in the event of accident or breakdown, 2) the type of fire-fighting equipment to be used, and	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	3) a warning of possible emission or leakage of hazardous substance(s) and, if possible, an indication of means for fighting their effects;	
	h) maintenance instructions provided for skilled persons [item e) 3) above] and maintenance instructions provided for unskilled persons [item e) 4) above], that need to appear clearly separated from each other.	**Pass**
6.4.5.2	**Production of instruction handbook**	**--**
	The following applies to the production and presentation of the instruction handbook. a) The type fount and size of print shall ensure the best possible legibility. Safety warnings and/or cautions should be emphasized by the use of colours, symbols and/or large print. b) The information for use shall be given in the language(s) of the country in which the machine will be used for the first time and in the original version. If more than one language is to be used, each should be readily distinguished from another, and efforts should be made to keep the translated text and relevant illustration together. NOTE In some countries the use of specific language(s) is covered by legal requirements. c) Whenever helpful to the understanding, text should be supported by illustrations. These illustrations should be supplemented with written details enabling, for example, manual controls (actuators) to be located and identified. They should not be separated from the accompanying text and should follow sequential operations. d) Consideration should be given to presenting information in tabular form where this will aid understanding. Tables should be adjacent to the relevant text. e) The use of colours should be considered, particularly in relation to components requiring quick identification. f) When information for use is lengthy, a table of contents and/or an index should be provided. g) Safety-relevant instructions which involve immediate action should be provided in a form readily available to the operator.	**Pass**
6.4.5.3	**Drafting and editing information for use**	**--**
	The following applies to the drafting and editing of information for use. a) Relationship to model: the information shall clearly relate to the specific model of machine and, if necessary, other appropriate identification (for example, by serial number). b) Communication principles: when information for use is being prepared, the	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	communication process “see – think – use” should be followed in order to achieve the maximum effect and should follow sequential operations. The questions, “How?” and “Why?” should be anticipated and the answers provided. c) Information for use shall be as simple and as brief as possible, and should be expressed in consistent terms and units with a clear explanation of unusual technical terms. d) When it is foreseen that a machine will be put to non-professional use, the instructions should be written in a form that is readily understood by the non-professional user. If personal protective equipment is required for the safe use of the machine, clear advice should be given, for example, on the packaging as well as on the machine, so that this information is prominently displayed at the point of sale. e) Durability and availability of the documents: documents giving instructions for use should be produced in durable form (i.e. they should be able to survive frequent handling by the user). It can be useful to mark them “keep for future reference”. Where information for use is kept in electronic form (CD, DVD, tape, hard disk, etc.), information on safety-related issues that need immediate action shall always be backed up with a hard copy that is readily available.	
7	**Documentation of risk assessment and risk reduction**	**--**
	The documentation shall demonstrate the procedure that has been followed and the results that have been achieved. This includes, when relevant, documentation of	**--**
	a) the machinery for which the risk assessment has been made (for example, specifications, limits, intended use); b) any relevant assumptions that have been made (loads, strengths, safety factors, etc.); c) the hazards and hazardous situations identified and the hazardous events considered in the risk assessment; d) the information on which risk assessment was based (see 5.2): 1) the data used and the sources (accident histories, experience gained from risk reduction applied to similar machinery, etc.); 2) the uncertainty associated with the data used and its impact on the risk assessment; e) the risk reduction objectives to be achieved by protective measures; f) the protective measures implemented to eliminate identified hazards or to reduce risk;	**Pass**

EN ISO 12100		
Clause	Requirement – Test	Verdict
	g) residual risks associated with the machinery; h) the result of the risk assessment (see Figure 1); i) any forms completed during the risk assessment.	
	Standards or other specifications used to select protective measures referred to in f) above should be referenced.	**Pass**
	NOTE No requirement is given in this International Standard to deliver the risk assessment documentation together with the machine. See ISO/TR 14121-2 for information on documentation.	**--**

EN ISO 12100		
Clause	Requirement – Test	Verdict

TABLE OF CONTENTS

EN ISO 12100		
Clause	Requirement – Test	Verdict

I. Introduction.

In general this risk assessment report for the machines listed in previous page made by Shenzhen AOCE Electronic Technology Service Co., Ltd. was carried out in accordance with the requirements of Machinery Directive and the standards of EN ISO 14121-1, in which an explicit risk level is evaluated with 4 factors described in next clause.

After the first assessment, some measures to eliminate the risks are given for the modification of machine or of relative documents with taking into account the explicit C-type EN standard or related B-type standard.

While taking appropriate provisions for the existing risks, the procedures and principles to eliminate the risk according to the most general B-type standard for any kind of machine:

- First step: consider the possibility of eliminating risk at design stage.

- Second step: if impossible, protect the dangerous zone with appropriate design of safety guard or safety device.

- Third step: if above impossible, give warning signs to draw attention of operators about the residual risks.

In addition, some check list drawn from the explicit C-type EN standards, which are found suitable for or near the characteristic of this machine, maybe used to help developing the provisions for the elimination of the risks.

Finally the risk assessment was carried out again to ensure this machine and its relative documents are totally compliance with the Machinery Directive.

EN ISO 12100		
Clause	Requirement – Test	Verdict

II. Risk assessment Methodology

The risk assessment is based on the method recommended in EN ISO 14121-1 and, in which the
4 factors S-A-G-W are used to evaluate the level of risk. The meaning of those is described in the following:

(A) S: Severity of the possible harm.
- S1: Slight (normally reversible) injury or damage to health.
- S2: Serious (normally irreversible) injury or damage to health, or cause one man dies.
- S3: Cause a few men die.
- S4: Catastrophe or many men die.

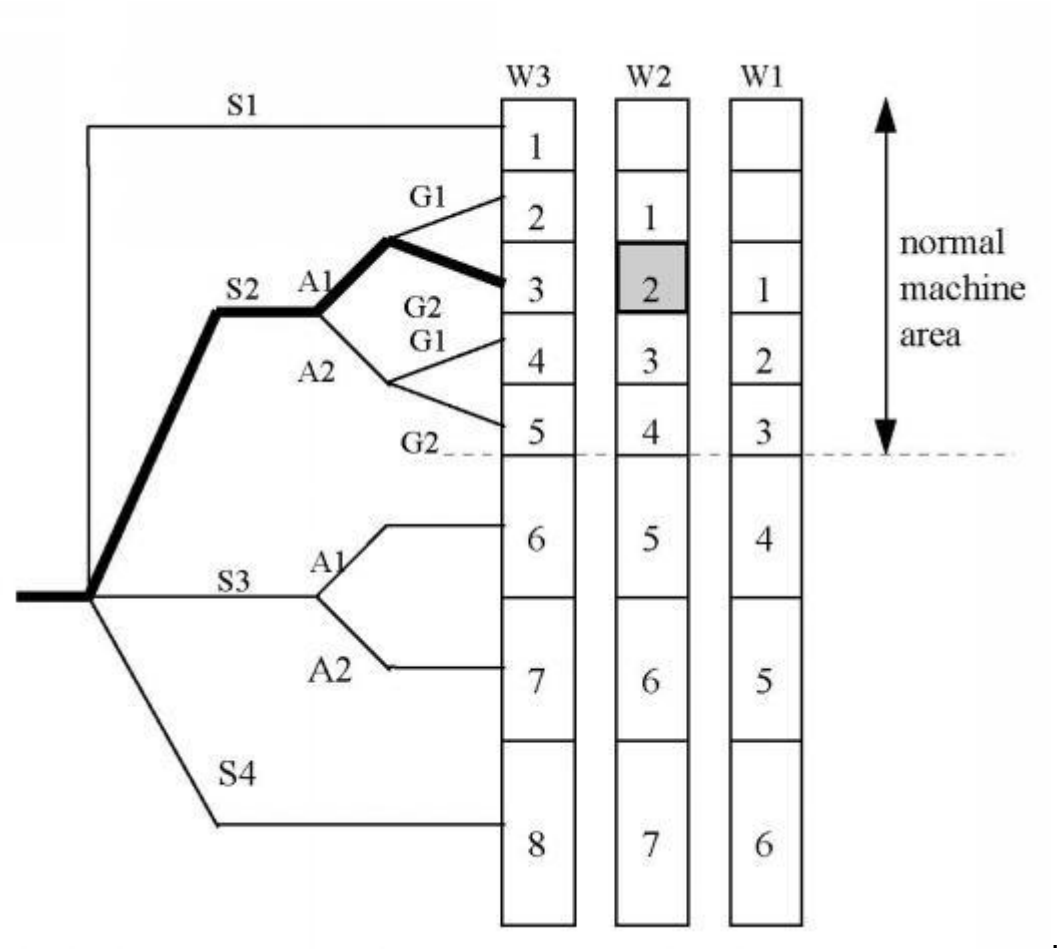
(B) A: Frequency of exposure.
- A1: Seldom to quite often.
- A2: Frequent to continuous.

(C) G: Possibilities of avoidance.
- G1: Possible to be avoided.
- G2: Impossible to be avoided.

(D) W: Probility of occurrence of an event that can cause harm.
- W1: Low (So unlikely, it can be assumed occurrence may not be experienced.)
- W2: Medium (likely to occur sometime in life time of an item)
- W3: High (likely to occur frequently)

EN ISO 12100		
Clause	Requirement – Test	Verdict

The decision for the level of risk could be made in according to the following Fig



Corresponding measures:
1 : Protected by warning
2 : Protected by guard and warning
3 : Consider another design, adopt the best one, add both guard and warning
4 : Consider another two designs, adopt the best one, add both guard and warning
5 : Consider another three or more designs, adopt the one add both guard and warning

EN ISO 12100		
Clause	Requirement – Test	Verdict

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class

III. Assessment Result
Please see the following Table

Mechanical hazards								
1.0.1	Mechanical hazards due to machine part or work piece.	N/A		-	-	-	-	-
1.0.2	Mechanical hazards due to accumulation of energy under pressure.	N/A		-	-	-	-	-
1. 1	Crushing / Squeezing	Injury on hand		S1	A1	G2	W2	-
1.2	Shearing	N/A		-	-	-	-	-
1.3	Cutting or severing	N/A		-	-	-	-	-
1.4	Entanglement	N/A		-	-	-	-	-
1.5	Drawing-in or Trapping	N/A		-	-	-	-	-
1.6	Impact	Injury on hand		S1	A1	G2	W2	-
1.7	Stabbing or puncture	N/A		-	-	-	-	-
1.8	Friction or abrasion	N/A		-	-	-	-	-
1.9	High pressure fluid injection	N/A		-	-	-	-	-
1.10	Ejection of parts (of machinery and processed material/work piece)	N/A		-	-	-	-	-
1.11	Loss of stability (of machinery and machine parts).	N/A		-	-	-	-	-
1.12	Slip, trip and fall hazards in relationship with machinery (because of their mechanical nature)	N/A		-		- -	-	-
Electrical hazards								

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
2.1	Electrical contact: direct	Serious injury to human	Electric circuit contact when power on	S2	A2	G2	W2	4
2.2	Electrical contact: indirect	ditto	Electric circuit contact when insulation failure.	S2	A2	G2	W2	4
2.3	Approach to live part under high voltage	ditto		S2	A2	G2	W1	3
2.4	Electrostatic phenomena	N/A		-	-	-	-	-
2.5	Thermal radiation or other phenomena such as projection of molten particles and chemical effects from short-circuits, overloads etc.	N/A		-	-	-	-	-
Thermal hazards								
3.1	Burns and scalds, by a possible contact of persons by flames or explosions and also by radiation of heat sources	Injury to human		S1	A1	G1	W1	-
3.2	Health-damaging effects by hot or cold work environment	N/A		-	-	-	-	-
Hazards generated by noise								
4.1	Hearing losses (deafness), other physiological disorders (e.g. loss of balance, loss of awareness)	N/A		-	-	-	-	-
4.2	Health-damaging effects by hot or cold work environment	N/A		-	-	-	-	-
Hazards generated by vibration								
5.1	Use of hand-held machines resulting in a variety of	N/A		-	-	-	-	-

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
	neurological and vascular disorder							
5.2	Whole body vibration, particular when combined with poor postures	N/A		-	-	-	-	-
Hazards generated by vibration								
6.1	Low / high frequency, radio frequency radiation, microwaves	N/A		-	-	-	-	-
6.2	Infrared, visible and ultraviolet Light	N/A		-	-	-	-	-
6.3	X and gamma rays	N/A		-	-	-	-	-
6.4	Alpha, beta rays, electron or ion beams, neutrons	N/A		-	-	-	-	-
6.5	Lasers	N/A	No such lasers	-	-	-	-	-
Hazards generated by materials and substances processed, used or exhausted by machinery								
7.1	Hazards resulting from contact with or inhalation of harmful fluids, gases, mists, fumes and dusts	N/A	Harmful fumes and dusts will be emission when processing the workpiece.	S2	A2	G1	W2	3
7.2	fire and explosion	Serious injury to human	When machine processes the workpiece made by flammable material	S2	A2	G1	W2	-3
7.3	Biological and micro-biological (viral or bacterial)	N/A		-	-	-	-	-
Hazards generated by neglecting ergonomic principles in machine design (mismatch of machinery with human characteristics and abilities)								
8.1	Unhealthy posture or excessive efforts	N/A		-	-	-	-	-
8.2	Inadequate with hand-arm or foot-leg anatomy	N/A		-	-	-	-	-

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
8.3	Neglected use of personal protection equipment	N/A		-	-	-	-	-
8.4	Inadequate local lighting	Injury to human		S2	A2	G1	W1	2
8.5	Mental overload or under-load, stress etc.	N/A		-	-	-	-	-
8.6	Human errors, human behavior	Injury to human		S2	A2	G1	W1	2
8.7	Inadequate design, location or identification of manual controls	N/A		-	-	-	-	-
8.8	Inadequate design or location of visual display units	N/A		-	-	-	-	-
Combination of hazards								
9.1	Unhealthy posture or excessive efforts	N/A		-	-	-	-	-
Unexpected start-up, unexpected overrun / over-speed								
10.1	Failure/disorder of control system (unexpected start-up, unexpected overrun)	Injury to human		S2	A2	G2	W2	4
10.2	Restoration of energy supply after an interruption.	N.A		-	-	-	-	-
10.3	External influence on electrical equipment	N/A		-	-	-	-	-
10.4	Other external influences (Gravity, wind, etc.)	N/A		-	-	-	-	-
10.5	Errors in the software	N/A		S2	A2	G2	W1	3
10.6	Errors made by the operator (due to mismatch of machine with human characteristic and abilities, see 8.6)	N/A		S2	A2	G2	W2	4
Impossibility of stopping the machine in the best possible condition								

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
11	Impossibility of stopping the machine in the best possible condition	N/A		-	-	-	-	-
Variations in the rotational speed of tools								
12	Variations in the rotational speed of tools	N/A		-	-	-	-	-
Failure of the power supply								
13	Failure of the power supply	N.A		-	A2	G2	W2	-
Failure of the control circuit								
14	Failure of the control circuit	Injury to human		S2	A2	G2	W2	4
Errors of fitting								
15	Errors of fitting	N/A		-	-	-	-	-
Break-up during operation								
16	Break-up during operation	N/A		-	-	-	-	-
Falling or ejected objects or fluids								
17	Falling or ejected objects or fluids	Injury to human		-	-	-	-	-
Loss of stability / overturning of machinery								
18	Loss of stability / overturning of machinery	N/A		-	-	-	-	-
Slip, trip and fall of persons (related to machine)								
19	Slip, trip and fall of persons (related to machine)	N/A		-	-	-	-	-
Additional hazards, hazardous situation and hazardous events due to mobility								
20.1	Movement when starting the engine	N/A		-	-	-	-	-

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
20.2	Movement without a driver at the driving position	N/A		-	-	-	-	-
20.3	Movement without all parts in a safe position	N/A		-	-	-	-	-
20.4	Excessive speed of pedestrian controlled machinery	N/A		-	-	-	-	-
20.5	Excessive oscillations when moving	N/A		-	-	-	-	-
20.6	Insufficient ability of machinery to be slowed down, stopped and immobilized.	N/A		-	-	-	-	-
Linked to the work position (including driving station) on the machine								
21.1	Fall of persons during access to (or at/from) the work station	N/A		-	-	-	-	-
21.2	Exhaust gases/lack of oxygen at the work position	N/A		-	-	-	-	-
21.3	Fire (flammability of the cab, lack of extinguishing means)	N/A		-	-	-	-	-
21.4	Mechanical hazards at the work position: a) contact with the wheels; b) rollover; c) fall of objects, penetration by objects; d) break-up of parts rotating a high speed; e) contact of persons with machine parts or tools (pedestrian controlled machines).	N/A		-	-	-	-	-
21.5	Insufficient visibility from the work positions	N/A		-	-	-	-	-
21.6	Inadequate lighting.	N/A		-	-	-	-	-
21.7	Inadequate seating	N/A		-	-	-	-	-

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
21.8	Noise at the work position	N/A		-	-	-	-	-
21.9	Vibration at the work position	N/A		-	-	-	-	-
21.10	Insufficient means for evacuation / emergency exit	N/A		-	-	-	-	-
Due to the control system								
22.1	Inadequate location of manual controls	N/A		-	-	-	-	-
22.2	Inadequate design of manual controls and their mode of operation	N/A		-	-	-	-	-
From handling the machine (lack of stability)								
23	From handling the machine (lack of stability)	N/A		-	-	-	-	-
Due to the power source and to the transmission of power								
24.1	Hazards from the engine and the batteries	N/A		-	-	-	-	-
24.2	Hazards from transmission of power between machines	N/A		-	-	-	-	-
24.3	Hazards from coupling and towing	N/A		-	-	-	-	-
From / to third persons								
25.1	Unauthorized start-up / use	N/A		-	-	-	-	-
25.2	Drift of a part away from its stopping position	N/A		-	-	-	-	-
25.3	Lack of inadequacy of visual or acoustic warning means	N/A		-	-	-	-	-
Insufficient instructions for the driver / operator								
26	Insufficient instructions for the driver / operator	N/A		-	-	-	-	-
Mechanical hazards and hazardous events								

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
27.1	From load falls, collisions, machine tipping caused by;	N/A		-	-	-	-	-
27.1.1	lack of stability	N/A		-	-	-	-	-
27.1.2	uncontrolled loading - overturning moments exceeded	N/A		-	-	-	-	-
27.1.3	uncontrolled amplitude of movements	N/A		-	-	-	-	-
27.1.4	unexpected / unintended movement of loads	N/A		-	-	-	-	-
27.1.5	inadequate holding devices / accessories	N/A		-	-	-	-	-
27.1.6	Collision of more than one machine	N/A		-	-	-	-	-
27.2	From access of persons to load support	N/A		-	-	-	-	-
27.3	From derailment	N/A		-	-	-	-	-
27.4	From insufficient mechanical strength of parts	N/A		-	-	-	-	-
27.5	From inadequate design of pulleys, drums.	N/A		-	-	-	-	-
27.6	From inadequate selection of chains, ropes, lifting and accessories and their inadequate integration into the machine	N/A		-	-	-	-	-
27.7	From lowering of the load under the control of friction brake	N/A		-	-	-	-	-
27.8	From abnormal conditions of assembly/ testing/ use/ maintenance	N/A		-	-	-	-	-
27.9	From the effect of load on persons (impact by load or counterweight)	N/A		-	-	-	-	-

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
Electrical hazards								
28	From lighting	N/A		-	-	-	-	-
Hazards generated by neglecting ergonomic principle								
29	Insufficient visibilities form the driving position.	N/A		-	-	-	-	-
Additional hazards, hazardous situations and hazardous events due to underground work								
30	Mechanical hazards and hazardous events due to:	N/A		-	-	-	-	-
30.1	Lack of stability of powered roof supports	N/A		-	-	-	-	-
30.2	Falling accelerator or brake control of machinery running on rails	N/A		-	-	-	-	-
30.3	Falling or lack of deadman's control of machinery running on rails	N/A		-	-	-	-	-
Restricted movement of persons								
31	Restricted movement of persons	N/A		-	-	-	-	-
Fire and explosion								
32	Fire and explosion	Injury to human	When machine processes the workpiece made by flammable material	S2	A2	G1	W2	3
Emission of dust, gases etc.								
33	Emission of dust, gases etc.	Injury to human	Harmful fumes and dusts will be emission when processing the workpiece.	S2	A2	G1	W2	3
Additional hazards, hazardous situations and hazardous events due to the lifting or moving of persons								

No.	Hazard source	Unwanted incident	Cause	Probability of harm to person				Risk class
				S class	**A** class	**G** class	**W** class	Risk class
34	Mechanical hazards and hazardous events due to:	-		-	-	-	-	-
34.1	Inadequate mechanical strength and inadequate working coefficient	N/A		-	-	-	-	-
34.2	Failing of loading control	N/A		-	-	-	-	-
34.3	Failing of controls in person carrier (function, priority)	N/A		-	-	-	-	-
34.4	Overspeed of person carrier	N/A		-	-	-	-	-
Falling of person from person carrier								
35	Falling of person from person carrier	N/A		-	-	-	-	-
Falling or overturning of person carrier								
36	Falling or overturning of person carrier	N/A		-	-	-	-	-
Human error, human behavior								
37	Human error, human behavior	N/A		-	-	-	-	-

Note:
1) For the risk marked with “N/A”, either
   a) it means the risk has been eliminated by general design and manufacture of machine. The harm caused these risks may not be considered. or
   b) The risk is not applicable for the machine under assessment.
2) This list is fully completed compared to the list presented in Annex A of EN ISO 14121-1.

IV. Measures to eliminate the risk & its improvement.

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**		
Id No.	2.1	**Factors:**	S2-A2-G2-W2		**Level:**	4	
Description	Electrical contact directly						
Where / When	Electric circuit contact when power on						
Measures	- To design the electrical circuit and electrical equipment according to EN 60204-1 - Place warning label						
Reference	EN 60204-1						
Improvement	**Factors:**	S2-A2-G2-W1		**Level:**	3		

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**		
Id No.	2.2	**Factors:**	S2-A2-G2-W2		**Level:**	4	
Description	Electrical contact indirectly						
Where / When	Electric circuit contact when insulation failure						
Measures	- To design the electrical circuit and electrical equipment according to EN 60204-1 - Place warning label						
Reference	EN 60204-1						
Improvement	**Factors:**	S2-A2-G2-W1		**Level:**	3		

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**		
Id No.	2.3	**Factors:**	S2-A2-G2-W1		**Level:**	3	
Description	Approach to the live part under high voltage.						
Where / When	- The source of power supply is still live when power is disconnected.						
Measures	- To design the electrical circuit and electrical equipment according to EN 60204-1 - To perform test for protection against residual voltage						

Reference	EN 60204-1 6.2.4			
Improvement	**Factors:**	S2-A2-G2-W1	**Level:**	3

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	3.1	**Factors:**	S1-A1-G1-W1		**Level:**	-
Description	Burns and scalds, by a possible contact of persons by flames or explosions and also by radiation of heat sources					
Where / When	High temperature of ventilation hot wind.					
Measures	- Verify the temperature lower than 40 ℃ - Place warning label					
Reference	-					
Improvement	**Factors:**	S1-A1-G1-W1		**Level:**	-	

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	7.1	**Factors:**	S2-A2-G1-W2		**Level:**	3
Description	Hazards resulting from contact with or inhalation of harmful fluids, gases, mists, fumes and dusts.					
Where / When	Harmful fumes and dusts will be emission when processing the workpiece.					
Measures	- Design a internal exhaust device or interface with external exhaust device - Instruct the information and precaution for processing workpiece in use manual.					
Reference	EN ISO 12100-1, -2					
Improvement	**Factors:**	S2-A2-G1-W1		**Level:**	1	

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	7.2	**Factors:**	S2-A2-G1-W2		**Level:**	3
Description	Fire and explosion					
Where / When	When machine processes the workpiece made by flammable material					

Measures	- Instruct the information and precaution for processing workpiece in user manual..			
Reference	EN 60204-1			
Improvement	**Factors:**	S1-A2-G1-W1	**Level:**	1

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	10.2	**Factors:**	S2-A2-G2-W2	**Level:**	4	
Description	Hazards caused by the restoration of energy after interruption.					
Where / When	Automatic emission of laser beam while energy supply recovery.					
Measures	- Prohibit the restart directly of laser beam while energy supply recovery through the design of electrical circuit. - Perform the functional test					
Reference	EN 60204-1					
Improvement	**Factors:**	S2-A1-G1-W1		**Level:**	-	

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	10.5	**Factors:**	S2-A2-G2-W1	**Level:**	3	
Description	Hazards caused by the error in the software.					
Where / When	Errors in the software to unexpected emit laser beam.					
Measures	- Perform software functional test - Let the working of protective guard over the controls by software.					
Reference	-					
Improvement	**Factors:**	S2-A1-G1-W1		**Level:**	-	

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	10.6	**Factors:**	S2-A2-G2-W2	**Level:**	4	
Description	Hazards caused by Errors made by the operator					
Where / When	Human exposure in laser beam area without guard.					

Measures	- . Require the operator should be trained and skilled in user manual. - Provide the interlock protection			
Reference	EN 60204-1			
Improvement	**Factors:**	S2-A1-G1-W1	**Level:**	-

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	32	**Factors:**	S2-A2-G1-W2		**Level:**	3
Description	Fire and explosion					
Where / When	When machine processes the workpiece made by flammable material					
Measures	- Instruct the information and precaution for processing workpiece in use manual					
Reference	-					
Improvement	**Factors:**	S2-A2-G1-W1		**Level:**	2	

Working Phase	**Operation:**	√	**Maintenance:**	√	**Other:**	
Id No.	33	**Factors:**	S2-A2-G1-W2		**Level:**	3
Description	Emission of dust, gases etc					
Where / When	Harmful fumes and dusts will be emission when processing the workpiece.					
Measures	- Design a internal exhaust device or interface with external exhaust device - Instruct the information and precaution for processing workpiece in use manual					
Reference	-					
Improvement	**Factors:**	S2-A2-G1-W1		**Level:**	-	

Pictures

Annex B – Product Photo-documents

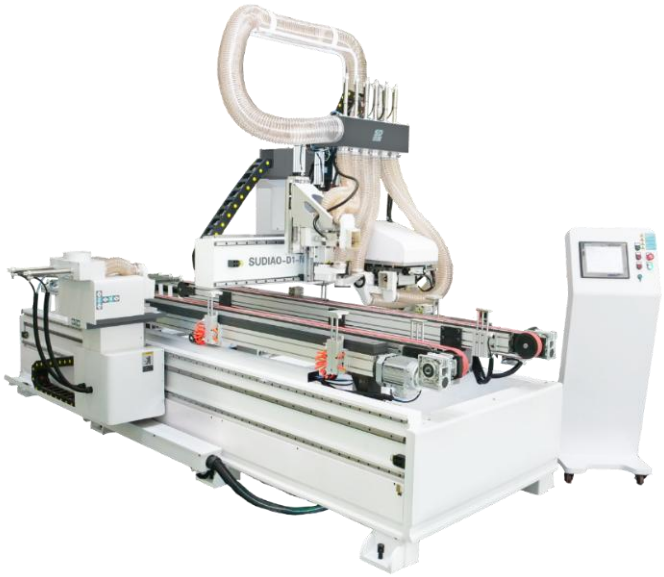


Fig.1

----------THE END OF TEST REPORT----------