
Safety of machinery — Safety requirements for hydraulically powered open die hot forging presses for the forging of steel and non-ferrous metals

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National foreword

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**Safety of machinery - Safety requirements for hydraulically
powered open die hot forging presses for the forging of steel
and non-ferrous metals**

Sécurité des machines - Exigences de sécurité pour les
presses à commande hydraulique de forgeage libre pour le
formage à chaud de l'acier et des métaux non ferreux

Sicherheit von Maschinen - Sicherheitsanforderungen an
hydraulisch angetriebene Warm-Freiformschmiedepressen
zum Schmieden von Stahl und NE-Metallen

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CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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Foreword

This document (EN 14673:2006) has been prepared by Technical Committee CEN/TC 322 "Equipments for making and shaping of metals - Safety requirements", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2007, and conflicting national standards shall be withdrawn at the latest by May 2007.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

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

This European Standard was elaborated by CEN/TC 322/WG5, comprising experts from the following countries: France, Germany, Sweden and United Kingdom.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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Introduction

This European Standard is a type C standard as stated in EN ISO 12100.

The machinery concerned and the extent to which hazards and hazardous situations and events are covered are indicated in the scope of this European Standard.

Where for clarity an example of a preventative measure is given in the text, this should not be considered as the only possible solution. Any other solution leading to the same risk reduction is permissible if an equivalent level of safety is achieved.

This European Standard assumes that the equipment is operated and maintained by trained personnel.

When provisions of this type C standard are different from those which are stated in type A or B standards, the provisions of this type C standard take precedence over the provisions of the other standards, for machines that have been designed and built according to the provisions of this type C standard.

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1 Scope

This European Standard applies to:

hydraulically powered open die forging presses for hot working;

handling and cooling equipment connected with the control system of the forging line, e. g., manipulators, rotating type handling devices, die shifting devices, table devices and tool changing devices;

handling equipment designed specifically to be used within the forging line, e. g., material manipulation devices, turnover or handling devices attached to fork lift trucks or cranes etc.

It specifies the health and safety requirements at all stages in the life of the equipment, its design, ordering, construction, use and disposal.

This European Standard specifies requirements to be met by the manufacturer to ensure the health and safety of persons during construction, transport, commissioning, operation, maintenance and de-commissioning, as well as in the event of foreseeable faults as malfunctions which may occur in the equipment.

This European Standard deals with all significant hazards, hazardous situations and events relevant to hydraulically powered hot forging presses when they are used as intended and under conditions foreseeable by the manufacturer (see Clause 4).

This European Standard does not cover:

hydraulically controlled closed die forging presses for hot working;

mechanically powered hot forging presses;

mobile manipulators as defined in 3.4.2;

standard transport and lifting equipment modified for use with material manipulation devices, turnover and handling devices such as for fork lift trucks and cranes.

This European Standard is not applicable to machinery which was manufactured before the date of publication of this standard by CEN.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 294, *Safety of machinery — Safety distance to prevent danger zones being reached by the upper limbs*

EN 349, *Safety of machinery — Minimum gaps to avoid crushing of parts of the human body*

EN 418:1992, *Safety of machinery - Emergency stop equipment, functional aspects - Principles for design*

EN 614-1, *Safety of machinery — Ergonomic design principles — Part 1: Terminology and general principles*

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EN 626-1, *Safety of machinery — Reduction of risks to health from hazardous substances emitted by machinery — Part 1: Principles and specifications for machinery manufacturers*

EN 811, *Safety of machinery — Safety distances to prevent danger zones being reached by the lower limbs*

EN 842, *Safety of machinery - Visual danger signals - General requirements, design and testing*

EN 894-1, *Safety of machinery — Ergonomics requirements for the design of displays and control actuators — Part 1: General principles for human interactions with displays and control actuators*

EN 894-2, *Safety of machinery — Ergonomics requirements for the design of displays and control actuators — Part 2: Displays*

EN 894-3, *Safety of machinery — Ergonomics requirements for the design of displays and control actuators - Part 3: Control actuators*

EN 953:1997, *Safety of machinery — Guards — General requirements for the design and construction of fixed and movable guards*

EN 954-1¹, *Safety of machinery — Safety-related parts of control systems — Part 1: General principles for design*

EN 981:1996, *Safety of machinery — System of auditory and visual danger and information signals*

EN 982:1996, *Safety of machinery — Safety requirements for fluid power systems and their components — Hydraulics*

EN 983:1996, *Safety of machinery — Safety requirements for fluid power systems and their components — Pneumatics*

EN 999, *Safety of machinery — The positioning of protective equipment in respect of approach speeds of parts of the human body*

EN 1037:1995, *Safety of machinery — Prevention of unexpected start-up*

EN 1050, *Safety of machinery — Principles for risk assessment*

EN 1088, *Safety of machinery — Interlocking devices associated with guards - Principles for design and selection*

EN 1299, *Mechanical vibration and shock — Vibration isolation of machines — Information for the application of source isolation*

EN 1591-1, *Flanges and their joints — Design rules for gasketed circular flange connections — Part 1: Calculation method*

EN 10204, *Metallic products — Types of inspection documents*

EN 13480-1, *Metallic industrial piping — Part 1: General*

EN 13480-2, *Metallic industrial piping — Part 2: Materials*

EN 13480-3:2002, *Metallic industrial piping — Part 3: Design and calculation*

EN 13480-4:2002, *Metallic industrial piping — Part 4: Fabrication and installation*

¹) Will be replaced by prEN ISO 13849-1.

EN 13480-5:2002, *Metallic industrial piping — Part 5: Inspection and testing*

EN 60204-1:2006, *Safety of machinery — Electrical equipment of machines — Part 1: General requirements (IEC 60204-1:2005)*

EN 60825-1:1994, *Safety of laser products - Part 1: Equipment classification, requirements and user's guide (IEC 60825-1:1993)*

EN 61310-1, *Safety of machinery — Indication, marking and actuation — Part 1: Requirements for visual, auditory and tactile signals (IEC 61310-1:1995)*

EN 61310-2, *Safety of machinery - Indication, marking and actuation - Part 2: Requirements for marking (IEC 61310-2:1995)*

EN 61496-1, *Safety of machinery — Electro-sensitive protective equipment — Part 1: General requirements and tests (IEC 61496-1:2004, modified)*

EN ISO 3744, *Acoustics — Determination of sound power levels of noise sources using sound pressure — Engineering method in an essentially free field over a reflecting plane (ISO 3744:1994)*

EN ISO 3746, *Acoustics — Determination of sound power levels of noise sources using sound pressure — Survey method using an enveloping measurement surface over a reflecting plane (ISO 3746:1995)*

EN ISO 3747, *Acoustics — Determination of sound power levels of noise sources using sound pressure — Comparison method for use in situ (ISO 3747:2000)*

EN ISO 7731, *Ergonomics - Danger signals for public and work areas - Auditory danger signals (ISO 7731:2003)*

EN ISO 9614-1, *Acoustics — Determination of sound power levels of noise sources using sound intensity — Part 1: Measurement at discrete points (ISO 9614-1:1993)*

EN ISO 9614-2, *Acoustics - Determination of sound power levels of noise sources using sound intensity - Part 2: Measurement by scanning (ISO 9614-2:1996)*

EN ISO 11064-1, *Ergonomic design of control centres — Part 1: Principles for the design of control centres (ISO 11064-1:2000)*

EN ISO 11202, *Acoustics — Noise emitted by machinery and equipment — Measurement of emission sound pressure levels at a work station and at other specified positions - Survey method in situ (ISO 11202:1995)*

EN ISO 11688-1, *Acoustics — Recommended practice for the design of low-noise machinery and equipment — Part 1: Planning (ISO/TR 11688-1:1995)*

EN ISO 12100-1:2003, *Safety of machinery — Basic concepts, general principles for design — Part 1: Basic terminology, methodology (ISO 12100-1:2003)*

EN ISO 12100-2:2003, *Safety of machinery — Basic concepts, general principles for design — Part 2: Technical principles (ISO 12100-2:2003)*

EN ISO 13732-1, *Ergonomics of the thermal environment – Methods for the assessment of human responses to contact with surfaces – Part 1: Hot surfaces (ISO 13732-1:2006)*

EN ISO 14122-1, *Safety of machinery - Permanent means of access to machinery - Part 1: Choice of fixed means of access between two levels (ISO 14122-1:2001)*

EN ISO 14122-2, *Safety of machinery - Permanent means of access to machinery - Part 2: Working platforms and walkways (ISO 14122-2:2001)*

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EN ISO 14122-3, *Safety of machinery - Permanent means of access to machinery - Part 3: Stairs, stepladders and guard-rails (ISO 14122-3:2001)*

ISO 3795, *Road vehicles, and tractors and machinery for agriculture and forestry — Determination of burning behaviour of interior materials*

ISO 3864-1, *Graphical symbols — Safety colours and safety signs — Part 1: Design principles for safety signs in workplaces and public areas*

ISO 7000, *Graphical symbols for use on equipment — Index and synopsis*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 12100-1:2003 and the following apply.

NOTE Definitions used in EN and ISO standards referred to in this European Standard are also valid for this European Standard.

3.1

hydraulically powered open die hot forging press

machine, which is hydraulically powered and which is used for the mechanical forming of hot metals between flat or shaped dies where flow of the metal is not completely restricted

3.2

manufacturer

body responsible for the final installation and commissioning of equipment within the scope of this standard and which issues the declaration of conformity

3.3

foreseeable risk

hazardous event which may occur during installation, commissioning, operation, maintenance and de-commissioning (with the manufacturer's instructions) of the equipment

3.4

manipulator

device to supply and handle material for the forging process

3.4.1 rail-bound manipulator

manipulator guided by rails to supply and handle material for the forging process. It is controlled by the control system of the forging press or manually

3.4.2 mobile manipulator

free moving manipulator operated by a driver to supply and handle material for the forging process

NOTE This specifically excludes cranes and its manual operated handling equipment, mobile manipulators, fork lift trucks with specific handling equipment, tongs and other similar manual handling devices

3.5

maintenance

maintenance in this standard includes maintenance, inspection, servicing, repair, lubrication, adjustment and replacement of the equipment in accordance with the manufacturer's instructions

3.6

site inspection

any inspection carried out in order to gather information relevant to the design and construction of the equipment

3.7**safety layout**

description, e. g., by drawings, of plant-related equipment with safety functions which either impedes access or having another plant-related safety function

3.8**pulpit**

enclosed room in which the control desk and monitoring facilities for a machine or equipment are located and the whole operating process can be controlled

3.9**trained personnel**

persons with the knowledge of systems, background, experience and ability to operate and/or maintain the intended use and proper operation of the equipment

3.10**unauthorised person**

person not permitted to enter certain areas or to perform certain actions in the area of the forging press in relation with the operation and/or maintenance equipment, because not having the required specific knowledge and skill, and/or not being properly equipped, in order to avoid the related hazards

4 List of significant hazards

This clause contains all the significant hazards, hazardous situations and events, as far as they are dealt with in this standard, identified by risk assessment as significant for this type of machinery and which require action to eliminate or reduce the risk.

This assessment then forms the basis for determining:

- a) the safety features which will need to be incorporated into the equipment; and
- b) any special instructions which will need to be communicated to the user.

The significant hazards and hazardous situations are defined in 5.2 and listed in columns 1 and 2 of Table 1 and Table A.1.

In addition to using this standard it is important for the manufacturer to carry out a risk assessment of the equipment according to EN 1050 to identify any other relevant hazards and, where possible, shall eliminate the identified risks.

The manufacturer shall establish at the contract stage all hazards which may arise from any cause in which the equipment may be used, and the appropriate preventative measures.

Equipment shall be manufactured in accordance with the principles contained in EN ISO 12100-2 by eliminating or reducing the foreseeable risks. In addition, the requirements defined in Clauses 4 and 5 shall be adopted.

The repeated reference to "operating/maintenance instruction" in Table 1 is an instruction to the manufacturer to give details of the information that shall be included in the information for use manual (see 7.5) which shall be supplied with the equipment and which shall be available at all times to the operator(s) and maintenance personnel of the equipment.

5 Safety requirements and/or measures

5.1 General

5.1.1 Introduction

Hydraulically powered open die hot forging presses for steel and non-ferrous metals shall comply with the safety requirements and/or measures of Clause 5.

This clause specifies and explains the preventative measures given in Table 1 and it also describes additional safety features, procedures and techniques which shall be considered by the designer and the manufacturer of the equipment.

The designer and manufacturer of hydraulically powered hot forging presses shall comply with the health and safety requirements and/or measures in this clause.

This clause does not include safety requirements and/or measures for mobile manipulators.

5.1.2 Site inspections

The manufacturer shall undertake sufficient site inspections to establish all health and safety requirements of the equipment design for:

- accessibility, according to the requirements of EN ISO 14122-1 to -3;

- maintenance and clearance gaps for cleaning, according to the requirements of EN 294, EN 811, EN 953 and EN 1088;

- movement of machinery and materials, according to the requirements of EN 999;

- safe operation, according to the requirements of 5.2;

- health and safety at the workplace, according to the requirements of EN 294, EN 811, EN 953; and

- prevention of emissions hazardous to health at the workplace (e. g. noise, vibration, pollution).

5.1.3 Structural assembly

The manufacturer shall undertake and record design calculations to show that the structural assembly of the equipment, e. g., materials, auxiliaries and potential foundation block ground loading, are adequate for safety function of the equipment under intended use.

NOTE It remains the responsibility of the user to ensure the ground is suitable to withstand the forces generated by the equipment based on the information supplied by the manufacturer.

5.1.4 Safety layout

A safety layout showing all plant-related safety devices and their position in the plant shall be provided by the manufacturer and shall describe:

- isolators according to EN 60204-1;

- emergency stops, according to the requirements of EN 418;

- escape routes, if necessary, e. g., for large plants;

- other safety-related safety marking, according to the requirements of EN ISO 7731, EN 842;

guards (generic terms), according to the requirements of EN 294, EN 811, EN 953, EN ISO 14122-2; and fire precautions, if applicable, according to 5.1.20 and 5.1.21.

5.1.5 Safety devices

Safety devices which require regular monitoring, e. g., fixed guards, interlocked guards, light beams, proximity devices and emergency stops, shall be accessible for inspection and maintenance and protected against damage under foreseeable conditions. In particular, they shall be selected, constructed and be sufficiently robust to operate reliably.

5.1.6 Railings

Railings shall not be used as the sole measure for safeguarding danger zones: they are intended to prevent slips, trips and falls.

5.1.7 Discharge of fluids

The manufacturer shall give instructions for discharge of fluids in case of internal leakage or due to maintenance of the fluid systems. This shall include information for tight surfaces, drains and the material that will be discharged.

5.1.8 Personal protective equipment (PPE)

The manufacturer shall give information in the Information for use manual (see 7.5) on the required type of personal protective equipment needed to safeguard personnel from any risks remaining after applying the safety measures.

5.1.9 Warning devices and safety signs

Warning devices and safety signs are additions to the design requirements to reduce hazards in case of significant risks.

Safety signs and warning devices according to EN 61310-1 and -2 shall be used.

Graphical symbols shall be in accordance with ISO 3864-1 and/or ISO 7000.

Danger signals shall be in accordance with EN ISO 7731 and/or EN 842 and/or EN 981.

Warning signs shall be affixed so that they are visible from outside the danger zone.

If an audible warning device is required (e. g., horn), the A-weighted sound pressure level measured according to EN ISO 7731 shall be 10 dB higher than the environmental noise of the operating forging presses, measured at 7 m distance from the audible warning device.

NOTE The manufacturer should not rely upon warning signs alone to reduce hazards in the case of significant risks being present.

5.1.10 Access

The manufacturer shall define and discuss the final overall design and layout of the plant to prevent unintentional access. In particular, the manufacturer shall take account of the following:

- a) access to the plant shall be controlled in such a way that unintentional entry into any danger zone shall not be possible, considering EN ISO 12100-2 and EN 953; where this is not possible due to the operating process, other means shall ensure that hazardous situations be avoided or minimized (e. g., scanner, light beams or similar equipment at the rail-bound manipulator);

- b) warning signs shall be affixed so that they are visible from outside the danger zone;
- c) access to control desks, pulpits, underground areas, inspection and service floors shall be protected against heat radiation, jets of high pressure fluids and designed to withstand moving materials and tools (if any), considering EN 294, EN 811, EN ISO 14122-1 to -3;
- d) surfaces for walking or standing shall be provided so that risks of slipping caused by scale, oil, emulsion and/or lubricant are minimized;
- e) the relevant category for controls for access to equipment during operation or maintenance shall be selected from B.2 and consider the requirements of EN 1037;
- f) areas identified as requiring routine maintenance shall be easily accessible.

5.1.11 Electrical equipment

Electrical equipment shall meet the requirements of EN 60204-1. In particular the manufacturer shall construct and install all electrical equipment so that it is capable of withstanding all hazards, including those from heat, vibration, wet conditions, identified in the risk assessment required at the design stage and taking into account the requirement set out in Annex B.

5.1.12 Safety control system

Each safety control system shall be selected in accordance with the severity of the risk as described in EN 954-1. The function of each safety control shall be considered in combination with other elements of the safety control system and shall maintain the safety level of all other components of the control system.

For the hazards listed in Table 1 where an electrical control system is involved a risk assessment has been carried out according to EN 954-1.

5.1.13 Guards

Guards shall be provided to prevent access to a danger zone. They shall be selected as appropriate for the degree and frequency of access to be permitted, e. g., an enclosing guard or distance guard, fixed or movable with interlock. This selection shall be made according to EN 953. Interlock systems shall meet the requirements of EN 1088.

The requirements of the guards shall conform with Clause 5 of EN 953:1997 and to EN 294, EN 349, EN 811.

5.1.14 Surface temperatures

Surfaces, which are intended to be touched with bare hands, shall have temperatures not exceeding the burn threshold for the contact time and material as specified in EN ISO 13732-1.

5.1.15 Operators' visibility

A good operators' visibility to the operating process shall be provided. Where it is not possible to prevent access to hazardous areas which are not naturally visible from the operator's position, the manufacturer shall provide devices:

to prevent the operation of the equipment while a person is present in the area; and/or

to give the operator a clear view of the hazardous area, e. g., suitably placed mirrors or closed circuit television (CCTV).

5.1.16 Hydraulic and pneumatic systems

Hydraulic and pneumatic systems shall meet the requirements of EN 982 and EN 983.

5.1.17 Ergonomics

Operators' positions and places which are regularly visited for the purposes of routine maintenance shall be designed to ergonomic principles described in EN 894-1 to -3, EN 614-1 and EN ISO 11064-1.

5.1.18 Manipulators

Danger zones due to the movement of rail-bounded manipulators shall be monitored by scanners, light beams or similar devices. They shall be selected in accordance with 5.1.12.

5.1.19 Pulpit

Pulpits shall comply with EN ISO 11064-1. Visual displays shall be so arranged that they are free of reflections and can be unambiguously identified.

The pulpit shall be

- air conditioned;
- thermal insulated;
- noise protected;
- if necessary, equipped with heat reflecting windows;
- if necessary, equipped with special coloured glass areas to protect operators eyes against radiation light;
- if necessary, protected against external impact by, e. g., scale and material fragments.

5.1.20 Fire resistance

The interior, upholstery and insulation of the pulpit and other parts of the machinery and equipment where insulation materials are used, shall be made of flame retardant materials. The burning rate shall not exceed 200 mm/min, tested in accordance with ISO 3795.

5.1.21 Fire extinguisher

Hot forging presses shall have space for installation of the fire extinguishers, easily accessible for the operator, or a built-in extinguishing system to permit the operator and other personnel a safe exit of the machine.

5.2 List of significant hazards, hazardous situations, safety requirements and/or measures

Table 1 is constructed and laid out to allow the designer and manufacturer of the equipment to apply a logical approach to checking their design proposals against the list of significant hazards that have to be addressed for their particular hot forging equipment.

Table 1 is a comprehensive presentation of identified significant hazards, the situations that give rise to the hazards, the safety requirements to reduce risks, and the means of verifying their presence:

- column 1 identifies the significant hazards;
- column 2 describes the hazardous situations;

column 3 specifies the safety requirements and/or measures to avoid or minimize the risk. They are shown as combined measures or as options;

column 4 makes references to clauses or standards which are relevant to the safety requirements and/or measures identified in this European Standard to avoid or minimize the risk;

NOTE 1 When implementing safety requirements and/or measures it should be considered that different hazards may appear at the same time.

NOTE 2 5.3 contains special safety requirements or measures.

column 5 identifies the verification method(s) to be used to demonstrate conformity. Verification may involve more than one method. The abbreviations V, D and M are defined as follows:

V: Visual inspection verifies the required features of the components.

D: Drawings and/or calculations verify that the design characteristics of the components provided meet the requirements of the relevant standards.

M: Measurement or mode test verifies that requirements are met, within the tolerances permitted by the relevant standards.

For further information on verification see Clause 6.

Table 1 — Significant Hazards, Hazardous Situations, Safety Requirements and/or Measures

Column 1	Column 2	Column 3	Column 4	Column 5
Significant Hazards	Hazardous Situation	Safety Requirements and/or Measures	References	Verification
5.2.1 General requirements				
5.2.1.1 Mechanical hazards				
General	1 Unauthorized access into hazardous work zones	1.1 Restrict access to authorized personnel	5.1.10	V, D
		1.2 Provide warning signs and visible and/or audible signals.	7.5.5 5.1.9	V,
		1.3 Provide devices to give clear view to areas not visible from control stand.	M 5.1.15	V,
		1.4 Operating/maintenance instruction: advice on the use of safe working procedures, e. g., use of safety locks, access only for authorised persons.	D 7.5.5 V	
Slips, trips, falls	1 On or from stairs, ladders, platforms or walkways.	1.1 Open sides of platforms and walkways shall be fitted with, e. g., guard-rails and toeboards.	5.1.10 D	V,
		1.2 Stairways shall be provided with a handrail	5.1.10 D	V,
		1.3 All treading surfaces of stairs, walkways and platforms shall be constructed to prevent slipping and to be easily cleaned of oil, grease etc.	5.1.10, d) D	V,
Impact	1 Struck by falling materials, equipment or tools falling from overhead.	1.1 Provide toeboards at open edges of permanent working platforms and walkways.	5.1.10 V	
Crushing, shearing, cutting, severing, entanglement	1 Below ground and/or below machine locations, e. g., service pits, pump rooms.	1.1 In any confined space where it is not possible to eliminate crushing between moving equipment and fixed structures access shall be prevented by either interlocked doors to the space or enclosures with interlocking doors around the danger zone.	5.1.12 5.1.13	V, M
	2 Access to moving parts of machinery, e. g., chains and sprockets, belts and pulleys and rotating drive shafts.	2.1 Totally enclose in the machine frame or provide local fixed guards which prevent access to the injury-causing components, e. g., shafts and in-running nips.	5.1.13 5.3.2	V
5.2.1.2 Noise (see 5.4, Clause 6 and Annex C)				
5.2.1.3 Radiation hazards				
Laser beam	1 Laser light can cause eye damage.	1.1 Use of low energy lasers and, where possible, a controlled beam path.	EN 60825-1	D,
		1.2 Safety marking.	M EN 60825-1:1994;	V, D
		1.3 Operating/maintenance instruction: PPE.	Clause 5, Clause 6, Table D.2 5.1.8 V	

Table 1 (continued)

Column 1	Column 2	Column 3	Column 4	Column 5
Significant Hazards	Hazardous Situation	Safety Requirements and/or Measures	References	Verifi- cation
5.2.1.4 Hazards due to materials and substances				
Substances hazardous to health	1 Combustion of hydraulic fluids can cause release of substances hazardous to health.	1.1 Provide safe hydraulic system	5.1.16 Annex A	D
	2 Accidental discharge of gases from fixed fire extinguishing systems, where provided, in base-ments, control rooms etc.	2.1 Manual override to isolate automatic extinguishing systems when area is occupied.		
		5.1.12		
5.1.21				
5.2.1.5 Ergonomic hazards				D, M
		2.2 Audible warning devices.	5.1.9	V,
		2.3 Operating/maintenance instruction: procedures for maintenance and servicing.	7.5.5 7.6	V
Musculo-skeletal da- mage, men- tal overload, fatigue of operators, decrease in concentrat- ion	1 Poor design of equipment may cause fatigue, backache and lack of concentration.	1.1 Provide equipment to meet ergonomic standards on reach, height and standing conditions.	5.1.17 M	D,
	2 Manual handling	2.1 Operating/maintenance instruction: Provide mechanical handling aids, accessories and lifting aids.	7.5.5	V
	when changing equipment, e. g., pumps and motors.	3.1 Design equipment to provide safe reach, limit the need for lifting or provide lifting equipment as necessary.	5.1.17 D	V,
	3 Restricted working areas particularly during changing dies and tools and during maintenance.	3.2 Calibration and lubrication points shall be positioned at easily accessible areas.	5.1.10 D	V,
5.2.1.6 Hydraulics (for significant hazards see Annex A)				
5.2.1.7 Electrical hazards				
Failure of energy supply	1 Loss of electrical power	1.1 Provide emergency energy for the control system	5.1.11 5.1.12	D, M
		1.2 Hydraulic system shall switch into a safe mode	5.1.16 Annex A	D, M
		2.1 Select the appropriate category of the control system	5.1.12 Annex B	V, D
Failure, mal- function of the control system	2 Unexpected movements			

Burns	1 Burns from radiated heat, contact with hot surfaces and scale.	1.1 Provide air conditioned pulpits with tinted glass, where appropriate.	5.1.19	V,
		D		
		1.2 Provide appropriate warning signs.	5.1.9	V,
		D		

Table 1 (continued)

Column 1	Column 2	Column 3	Column 4	Column 5
Significant Hazards	Hazardous Situation	Safety Requirements and/or Measures	References	Verification
		1.3 Operating/maintenance instruction: advice on maintenance in hot environment and appropriate PPE, e. g., fire resistant gloves and overalls for maintenance and similar activities.	5.1.8 5.1.14 7.6	V
		1.4 In case of aluminium forging: screens shall be provided and Operating/maintenance instruction: the colour of the product does not indicate the temperature.	5.1.13 7.5.5 7.6	V, D
5.2.2 Process requirements				
5.2.2.1	Inlet material and outlet product handling			
Crushing, shearing, severing, entanglement	1 Movement of manipulators.	1.1 Restrict access to the area behind the manipulator and between manipulator and press.	5.1.10 EN 61496-1	
		1.2 Provide direct view to the danger zone and where needed, visual aids, e. g., by mirrors, CCTV		
		1.3 Provide visual and audible warning.	5.1.9	V, M
		1.4 Provide emergency stops.	5.1.11 5.1.12	V, D, M
		1.5 Operating/maintenance instruction: advice on the use of safe working procedures, e. g., access only for authorised persons.	7.5.5 V	
	2 In transmission machinery, e. g., gears, pulleys, belts, shafts, chains, couplings etc.	2.1 Rotating parts of transmission equipment shall be guarded	5.3.2 D	V,
Slip, trip, fall	1 Movement of manipulator cables and hoses.	2.2 Operating/maintenance instruction: safe working procedures	7.5.5	V
		1.1 Provide cable duct or locate the cable and hose routes over head.		V, D
	2 Slip, trip, fall on or from stairs, ladders, platforms or walkways.	1.2 Operating/maintenance instruction	7.5.5	V
		2.1 Open sides of platforms and walkways shall be fitted with, e. g., guard-rails and toeboards.	5.1.10 D	V,
		2.2 Stairways shall be provided with a handrail	5.1.10 D	V,
		2.3 Provision of slip-resistant surfaces of stairs, walkways and platforms and to be easily cleaned of oil, grease etc.	5.1.10, d) D	V,

Table 1 (continued)

Column 1	Column 2	Column 3	Column 4	Column 5
Significant Hazards	Hazardous Situation	Safety Requirements and/or Measures	References	Verifi- cation
Crushing, shearing, cutting, severing, entanglement	5.2.2.2 Press, die and workpiece handling			
	1 Movement of upper die, lower die and work piece.	1.1 Operating/maintenance instruction: advice on the use of tools to manipulate work pieces and procedures for safe systems of working.	7.5.5 5.1.16	V V, D, M
	2 Unexpected stroke of the press caused by control failure.	2.1 Provide means to release potential energy, e. g., dump valves.	Annex A Annex B	
		2.2 Operating/maintenance instruction: advice on the use of procedures for safe systems of working, e. g., use of safety locks, access only for authorised persons.	5.1.5 5.3.4	V
	3 Unintended movement caused by operators error.	3.1 Provide control system to prevent unintended movement, e. g., shrouded pedals, hold-to-run devices.	5.1.10 5.1.12 5.3.3	V, D, M
	4 Injuries resulting from non-observance of correct tool changing, location procedures and practices	4.1 Operating/maintenance instruction: Provide safe working/maintenance and process control procedures	7.5.5 7.6	V
	Impact 1 Die and workpiece shatters	1.1 Operating/maintenance instruction: Information about the need to check at prescribed frequencies the condition of the dies, e. g., visually or by non-destructive testing, e. g., magnetic particle inspection process, ultrasonic or equivalent methods.	V 7.5.5	
		1.2 Provide shielding at local observation points.	5.1.13	V,
Slip, trip and fall	1 Falls from heights	1.1 Design to obtain access to various parts of machine and eliminate potential risks by guard rails around open edges of platforms or on open sides of stairs and fencing.	D 5.1.10 D	V,

5.3 Special safety requirements and/or measures

5.3.1 General

The application of the following safety requirements are given in Table 1 of 5.2.

5.3.2 Accessible rotating/moving parts

Accessible drive shafts, couplings, belts and chains, pulleys and sprockets (i. e. where the safety distances in EN 294 cannot be achieved) shall be guarded in accordance with EN 953 and 5.1.13.

Drive shafts and couplings shall be designed with a smooth surface without protruding parts except where they are operationally essential.

Rotating shafts shall be marked so that it is visually evident when the shafts are in motion.

5.3.3 Hold-to-run control device

If necessary, a hold-to-run control device shall be provided to ensure that the operator can control and stop hazardous movement of the component(s) during access. The operator shall have full visibility of the danger zone, if needed, by use of closed circuit television (see also 5.1.15). Release of a hold-to-run control device shall bring the movement to standstill immediately.

5.3.4 Mechanical restraint devices

Mechanical restraint devices shall be selected depending on the design, e. g., safety bolts, latches, scotches and brakes. Where safety bolts are selected which operate automatically, e. g., by hydraulic cylinders, they shall be monitored by the controls in their end-positions. Where safety bolts or latches are to be set by hand they shall be clearly identifiable and installed directly on the equipment to be protected, e. g., with a chain.

In case the moving parts are controlled by electrical (voltage) switches, it shall be ensured that the component is held in a process-related and safe position with all movement-forces released.

5.4 Noise reduction as a safety requirement

5.4.1 Noise reduction at source by design

When designing a machine, the technical measures for reducing noise at source at the design stage shall be considered, see EN ISO 11688-1. Examples for general measures which should be considered are:

- selection of low noise components such as low noise hydraulic pumps, motors or control elements;
- reduce impact energy, e. g., by height of fall of butt-ends and scrap;
- reduce oscillation amplitude or vibration frequency, e. g., by reducing unbalance, increasing mass;
- reduce noise of gas flow, e. g., low-noise nozzles and sound absorbers;
- dampening of structure-borne noise, e. g., by design and material selection;
- insulation of structure-borne noise, e. g., by vibration isolated mounting of pumps.

The above list of technical measures is not exhaustive; alternative technical measures for noise reduction with identical or greater efficacy can be used.

Where the above technical measures do not reduce noise to safe levels, noise reduction by protective measures will be necessary.

NOTE EN ISO 11688-2 gives useful information on noise generation mechanisms.

5.4.2 Noise reduction by protective measures

The secondary noise control can be achieved, e. g., by the increase of noise dampening and insulation, physical separation for noise source and receiver, sound-insulated control rooms. Examples are reductions by using:

- enclosures, e. g., encasing pumps and motors with sound insulating materials;
- screens fitted to the machine;

silencers in pneumatic exhaust, outlets and radial fan inlets; and/or

increased distance between source and operator (e. g., pulpit, local control desks).

NOTE The efficacy of such protective measures can be estimated, e. g., by using EN ISO 11546-2 (for enclosures), EN ISO 11691, EN ISO 11820 (for silencers) and EN ISO 11821 (for screens).

5.4.3 Noise reduction by PPE

Recommendation to wear a hearing protection shall be given in the information for use manual see 7.5.5, indent l), 3).

6 Verification of the safety requirements and/or measures

A verification of the safety requirements and/or measures detailed in 5.2 (Table 1) and Annex A (Table A.1) of this standard shall be carried out by inspection and/or testing of the function, testing of electrical safety according to EN 60204-1 and measurement according to the noise test code given in Annex C. If other methods of verification apply these are also indicated under 5.2 (Table 1) and Annex A (Table A.1).

7 Information for use

7.1 General

The essential requirements for the information for use are listed in Clause 6 of EN ISO 12100-2:2003.

Essential maintenance operations carried out in hazardous areas shall be authorised and performed in accordance with a written safe system of work.

In addition to these requirements special consideration shall be given to the following points:

7.2 Location and nature of information for use

The manufacturer shall decide in agreement with the user the location for such information for use and shall provide in the information for use a safety layout according to 5.1.4 showing the type and location of the relevant signals and warning devices on or near the point.

7.3 Safety devices, warning signs and labels

7.3.1 Safety devices

The manufacturer shall instruct the user that if a faulty or ineffective safety device is discovered (see also 5.1.5), either it shall be replaced immediately or if a replacement is not available, the equipment shall be shut-down.

7.3.2 Warning signs and labels

Any warning sign or label attached to or adjacent to any machinery dealt with in this European Standard shall meet the requirements of ISO 7000 and EN 61310-1.

7.4 Marking

The following information shall be attached clearly, readably and durably to the equipment:

name and address of manufacturer;

designation of series or type;
 mandatory marking²⁾;
 serial number/machine number, if any; and
 year of manufacture.

Auxiliary electric equipment shall be fitted with durable plates containing data, in accordance with EN 60204-1 including casing protection grade.

The hydraulic and/or pneumatic equipment shall be fitted with legible and durable plates containing data in accordance with 7.3 of EN 982:1996 and/or 7.3 of EN 983:1996.

7.5 Information for use manual

7.5.1 General

The manufacturer shall provide an information for use manual for each machinery/equipment (see also Clause 6 of EN ISO 12100-2:2003), covering all auxiliary systems.

The following items describe the structure and content of an information for use manual and shall be completed or extended in consideration of the specific machine.

7.5.2 Machine declaration

The machine declaration shall include the following:

- a) manufacturer, type of machinery, year of manufacturing, serial number (if any);
- b) technical documents (circuit diagrams, data sheets, information/reference for spare parts);
- c) particulars of interfaces with additional machinery outside the scope of this standard; and
- d) description of auxiliary equipment and the installation of the control system of these, e. g., emergency stop and the effect of this upon the safety devices.

7.5.3 Instructions about transport and installation

Instructions on the above matters shall include the following:

- a) instructions for safe lifting, e. g., position of points and techniques;
- b) transportation weight;
- c) transport safety devices and removal of these before commissioning;
- d) dimensional plan(s) of machine layout and ancillary equipment within the scope of this standard; and
- e) how to install and assemble the machine or single parts of it.

2) For machines and their related products intended to be put on the market in EEA, CE marking as defined in the European applicable directive(s), e. g., Machinery, Low Voltage, Explosive Atmosphere, Gas appliances

7.5.4 Information about commissioning and de-commissioning

Information shall be given highlighting the associated significant risks and instructions on remedial measures needed to be taken. In particular, they should include details about:

- a) location and type of energy systems (electric, hydraulic, pneumatic);
- b) fluid contents in the systems;
- c) specification of fluids;
- d) use and fitting of special devices, e. g., for lifting, emptying hydraulic systems, etc.;
- e) safe starting, operation and shut-down;
- f) inspection and proofing of safety devices before commissioning;
- g) prohibition of unauthorised reconstruction and modification; and
- h) reference for de-commissioning, e. g., disposal of high pressure fluids, emptying instructions (see Annex D).

7.5.5 Instructions about operation, including significant hazards and their remedies

Instructions on the above matters shall include the following:

- a) use of safety devices;
- b) regular inspection of safety devices;
- c) instructions for the use of personal protective equipment (PPE);
- d) characteristic hazards, e. g., current, hydraulic, especially references to setting up and re-commissioning after setting up;
- e) processing materials which generate fume or dust hazardous to health including cleaning requirements;
- f) description of safety related control systems;
- g) references about the qualification level of operators;
- h) instruction to be given to the operator on how to operate the machine;
- i) action in the event of faults or irregularities and abnormal operation;
- j) information on hazards due to:
 - 1) non-relieved pressures;
 - 2) malfunction of programmable electronic systems;
 - 3) temperature; and
 - 4) fire;
- k) escape routes;

- l) information about noise emission in accordance with Annex C of this European Standard, where necessary recommendation to, e. g.,
 - 1) implement enclosures, screens by the user;
 - 2) use of cabins for the personnel;
 - 3) wear personal protective equipment, i. e., hearing protection; and
 - 4) visual sign posting of noisy areas;
- m) information on residual hazards, for example, due to:
 - 1) radiation;
 - 2) hot surfaces in the working area;
 - 3) ejection of material or product parts; and
 - 4) information on particular hazards in case of access on special occasions, e. g., maintenance, trouble-shooting shall be pointed out in the information for use manual and on the machine by markings / symbols referring to the nature of hazard (see EN 61310-1). If the protective devices are not operational during this action, the necessary actions shall be indicated;
- n) non-intended use, e. g., forbidden use of specific auxiliary equipment, prohibition of specific materials; and
- o) intended use.

7.6 Maintenance manual

The maintenance manual shall contain instructions for or information on:

- a) maintenance activities that require special knowledge or qualification, e. g., press alignment;
- b) spare parts with reference to drawings or circuit diagrams;
- c) inspection schedule of the safety devices (the frequency of these thorough inspections shall be defined at the design stage according to the reliability, nature and importance of the device);
- d) checking effective isolation of dangerous components before maintenance work commences;
- e) precautions needed during re-commissioning;
- f) preventative measures, e. g., inspection and replacement of safety related wear parts within the scope of this standard;
- g) action to take at prime fault information from the control panel;
- h) fault lists with specifications of causes and action to be taken;
- i) which parts of the system(s) shall be electrically isolated during repair work;
- j) remaining residual energy (hydraulic reservoir etc.); and
- k) where necessary, warnings and instructions about hot surfaces.

Annex A

(normative)

Safety requirements for hydraulic, pressure water and lubrication systems

A.1 Significant hazards

Risks identified as significant as a result of using the equipment were considered when this annex was prepared.

The significant hazards and hazardous situations are tabulated in Table A.1 together with the appropriate safety requirements and/or measures. This table contains all hazards identified as significant for this type/types of machinery equipment and which require measures to eliminate or minimize risks. For easy reference Table A.1 also indicates the corresponding additional preventative measures in conjunction with A.2 if necessary.

Manufactures shall identify through their own risk assessment (EN 1050) which of the hazards listed below are significant for custom made equipment. Additional significant risks identified in the individual risk assessment shall be dealt with according to EN ISO 12100-2.

A.2 Safety requirements and/or measures

A.2.1 General

Equipment shall comply with the safety requirements and/or measures of A.1 and A.2. In addition, the equipment shall be designed according to the principles of EN ISO 12100-2 for hazards relevant but not significant which are not dealt with by this standard.

When more than one measure is necessary to safeguard a hazard then all the necessary measures shall be used. When selecting the safety requirements and/or measures it has to be considered that different hazards may appear at the same time.

A.2.2 General design requirements

As applicable, the manufacturer of the equipment shall design the systems to provide practical solutions for the following:

- accessibility;
- visibility of operation;
- maintenance and cleaning clearances;
- movement of machinery and material;
- safety in operation;
- safe mode conditions;
- health and safety at workplace; and

prevention of pollution.

Fluid systems carrying or containing fluids which are likely to solidify and/or have high or low viscosity shall be protected against the effects of temperature extremes which can influence the functionality of the fluid and can subsequently lead to potential damage of parts of the equipment.

The chemical composition of lubricants, as far as possible, shall not be harmful.

The manufacturer shall give information that drains, which form part of the equipment, shall discharge into a suitable isolated sump.

A.2.3 Requirements of piping

High pressure pipes used in hydraulic driven presses are subjected to fatigue loading and rated to a temperature up to 120 °C. For the design of high pressure pipes EN 13480 parts 1 to 5 shall be considered.

NOTE Caution should be taken when using EN 13480-3:2002 to calculate wall thicknesses of pipes because the formula in this version produces pipes of unrealistic dimensions. Until EN 13480-3 is revised manufacturers should use appropriate proven standards, whether current or withdrawn.

High pressure pipes ($\geq 6,4 \text{ N/mm}^2$) used as pre-material for the fabrication of the piping shall have an inspection certificate according to 3.1B of EN 10204.

The hazard class for the calculation of the pipes according to EN 13480-1 shall be designed in accordance with the operating medium (for water = 1, for all other media = 11). It should be noted that the fatigue strength of pipes with a heavily corroded inner surface will be considerably lower than that of uncorroded pipes. On mineral oil based hydraulic fluids the influence corrosion factor is normally negligible. The design wall thickness shall take into account any ovality caused by bending operations. The fatigue strength of oval bends will decrease in direct proportion to their degree of ovality. With standard bending procedures the ovality should be below 4 %. Accounting for such ovality under fatigue loading, the characteristic strength value shall be multiplied by the factor 0,9. If the type of bending procedure cannot guarantee an ovality smaller than 4 %, then the strength value shall be reduced in accordance with the requirements of EN 13480-3:2002; Table 10.3.2-5.

For fatigue loading the analysis is based on a fatigue strength at over 2×10^6 cycles (life time service).

For predominantly static loading the maximum pressure is defined as the maximum operating pressure including a possible maximum pressure peak, e. g., travelling on mechanical stops).

Fabrication and installation shall be in accordance with EN 13480-4.

The pipework shall be tested in accordance with EN 13480-5 and documented in accordance with EN 13480-5:2002, Table 9.6-1.

Examples for the design of pipework systems is given in EN 13480-3.

A.2.4 Detail of the hydraulic diagram for limitation of set-up speed

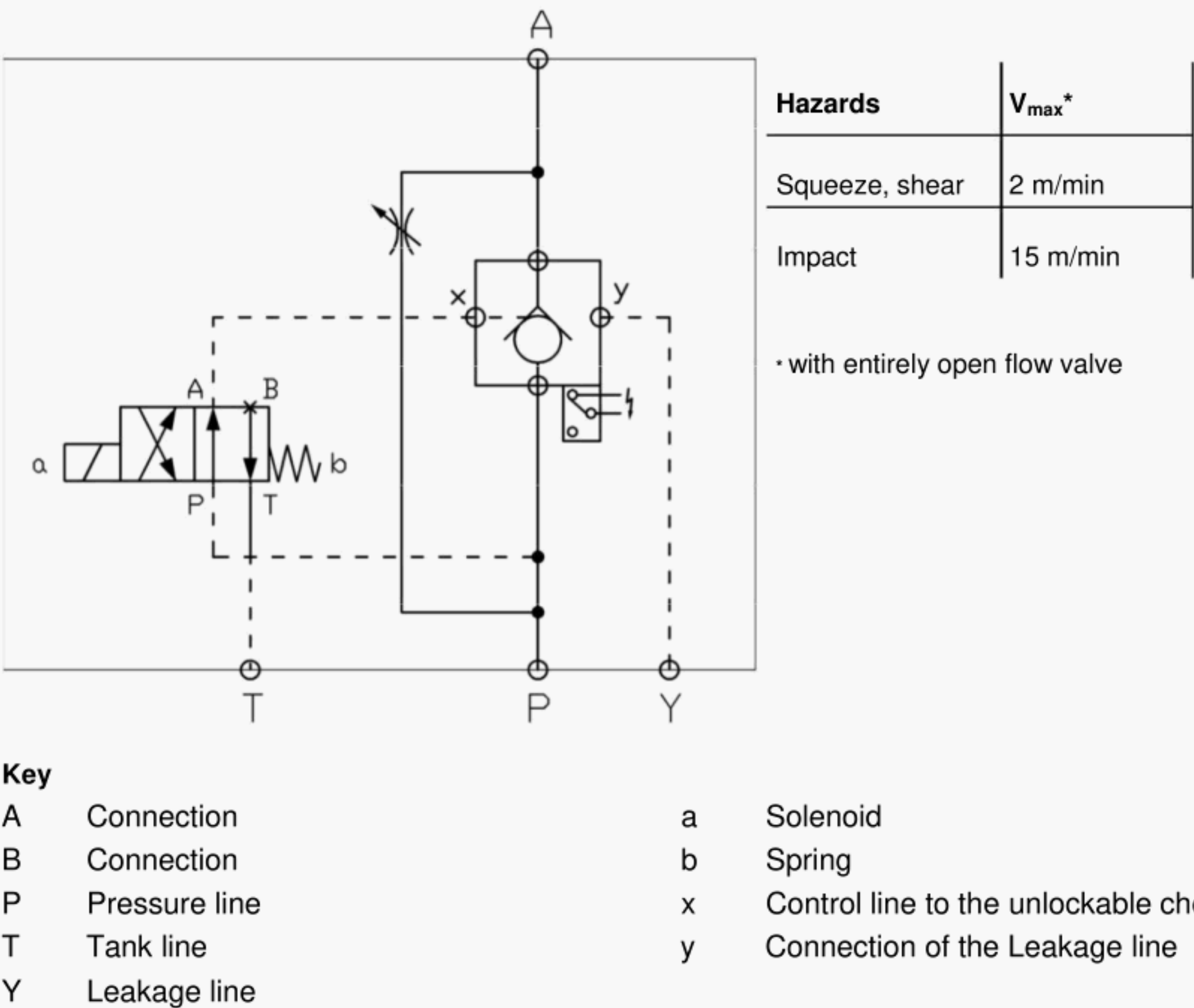


Figure A.1 — Detail of the hydraulic diagram for limitation of set-up speed

A.2.5 List of hazards, hazardous situations, safety requirements and/or measures

Table A.1 is a comprehensive presentation of identified significant hazards for hydraulic, pressure water and emulsion systems (column 1 of Table A.1), the situations that give rise to the hazards (column 2 of Table A.1), the safety requirements to reduce risks (column 3 of Table A.1), reference to appropriate standards (column 4 of Table A.1) and means of verifying their presence (column 5 of Table A.1). See 5.2 for further information with regard to the columns and verification.

Table A.1 — Significant Hazards, hazardous situations, safety requirements and/or measures

Column 1	Column 2	Column 3	Column 4	Column 5
Significant Hazards	Hazardous Situation	Safety Requirements and/or Measures	References	Verifi- cation
A.2.5.1 High pres- sure fluid ejection which may cause injury to persons	Hydraulic, pressure water and emulsion systems			
	1 Hose or pipe break due to inadequate dimen- sions of hoses, pipes and fittings.	1.1 Use of adequately dimensioned hoses, pipes and fittings.	EN 13480-3	D
			EN 1591-1	D
	2 Hose or pipe break due to vibration	1.2 Selection of component material.	A.2.3	
		2.1 Vibration reduction at source.	EN 13480-2 EN 1299	D,
		2.2 Provision of isolation/damping measures.	EN 1299	
		2.3 Dimensioning taking into account the vibration load.	D EN 13480-3	
	3 Hose or pipe break due to reversed bending stress	2.4 Adequate connections. 982:1996;	D EN 5.3.4.2	V, D
		3.1 Selection of material, dimensioning and bending radii, taking into account the fatigue strength.	A.2.3 EN 13480-2	D
			EN 13480-3	
	4 Hose or pipe break due to mechanical stress, kinking	4.1 Dimensioning taking into account mechanical stress and kinking.	A.2.3	D
		4.2 Protected location.	See A.2	V, D
		4.3 Protection against mechanical damage by covering.	5.1.13 D	V,
	5 Hose or pipe break due to thermal overload	5.1 Position at adequate distance from heat source.	See A.2 D	V,
		5.2 Covering against thermal radiation.	5.1.13	V, D
	6 Hose or pipe break due to chemical reaction	6.1 Selection of compatible materials and fluids.	A.2.3 D	
		6.2 Taking corrosion into account when dimensioning wall thickness.	A.2.3 EN 13480- 3:2002; 4.3	D
	7 Hose or pipe break due to incorrect installation	6.3 Use of inhibitors in fluids.	See A.2	D
		7.1 Provide instruction for correct installation.	EN 13480- 4:2002; Clause 8	V, D
	8 Hose or pipe break due to incorrect welding	8.1 Provide instructions for correct welding and	EN 13480- 4:2002; Clause 9	V
		8.2 Operating/maintenance instruction: welding shall be done only by trained welders or certified welders.	7.6 V	
	9 Unexpected start-up during dismantling and repair.	9.1 Automatic pressure reduction in the pressure system (vessels) when switching-off the forging press	See 5.1.12 EN 982:1996; 5.3.4.5	D, M

9.2 Measures to prevent start-up by
third parties, e. g., key-operated switch.

See 5.1.12
EN 1037

D, M

Table A.1 (continued)

Column 1	Column 2	Column 3	Column 4	Column 5
Significant Hazards	Hazardous Situation	Safety Requirements and/or Measures	References	Verification
		9.3 Audible and visual warning device for restart.	See 5.1.9 EN 981	V, D, M
		9.4 Attachment of measuring points with pressure relief facility.	EN 842	V, D
		9.5 Operating/maintenance instruction: indicate the need to disconnect the hoses only in depressurised state.	7.6 EN 982:1996; 5.3.4.3	V
Burns, fire, explosion	1 Combustion of fluids may cause release of substances hazardous to health and poisoning caused by fumes.	1.1 Use of low-toxicity fluids in the hydraulic equipment.	EN 983:1996; 5.3.4.3 See A.2.2	V, D
			EN 626-1 EN 982:1996; 5.3.4	
	2 Combustion of fluids may cause asphyxiation by fire extinguishing agents.	1.2 Position at adequate distance from heat source.	See A.2	V,
		2.1 Manual override to isolate automatic extinguishing systems when area is occupied.	EN 954-1	D, M
		2.2 Audible warning devices.	See 5.1.9	V, D, M
	3 High pressure leaking through a defective pre-fill valve into the low pressure system.	3.1 Provide a pressure relief valve and explosion relief panel on the low pressure vessel.	EN 981:1996; Table 3 EN 982:1996; 5.3	V,
		3.2 Relief panel to be situated to eject to a safe area and vessel mountings designed to withstand recoil forces.	See A.2.2 EN 982	V, D
	4 High pressure may flow backwards from the accumulators over a defective check valve and pump into the tank.	NOTE Any ejected fluid should be contained in a sealed area or tank.	See 5.1.7	V,
		4.1 Provide means to de-energise a jet of fluid going into tank.	EN 982	
	5 Overfilling of the high pressure accumulators may cause too high pressure.	5.1 Provide safety valves and a "fail-safe" level control system. Ensure that the outlet of the safety valve(s) is(are) direct in a safe direction.	EN 982	V, D,
Impact	1 Maintenance work on pressurised air vessels.	1.1 Provide means to depressurise compressed air vessels and fit pressure gauge.	EN 983	V,
		1.2 Operating/maintenance instruction: include instruction to drain exhaust vessels before work begins.	7.6	V

Table A.1 (continued)

Column 1	Column 2	Column 3	Column 4	Column 5
Significant Hazards	Hazardous Situation	Safety Requirements and/or Measures	References	Verifi- cation
	2 Maintenance work on pressurised pipes to the air vessels.	2.1 Provide means to isolate and exhaust pipework. 2.2 Operating/maintenance instruction: advise the user not to weld pressurised pipes and vessels.	EN 982:1996; 5.3.4.5 7.6	V, D V
Crushing, shearing, cutting	1 Safety equipment for the hydraulic control system in set-up mode.	1.1 When using accumulators or pressure - controlled pumps a second element with mechanically limited flow capacity shall be applied in order to ensure correct setting of set-up mode. In addition, the main shut-off valve shall be equipped with switch position control.	EN ISO 12100-2:2003; 4.11.9 EN 954-1; A.2.4	D, M
		1.2 Hydraulic systems shall be so designed and constructed to prevent danger from any unexpected movement of components.	EN 60204-1 EN 954-1 EN 1037	V, D
		1.3 Presses which cannot be fully depressurised before entry into danger zones, e. g., water presses, the hydraulic system to the main components will be fitted with two valves installed in series and acting independently of one another.	EN 954-1 M	V, D,

Annex B

(normative)

Safety requirements and/or measures for electrical equipment of hydraulically powered hot forging presses

B.1 General

Manufacturer shall identify through their own risk assessment (EN 1050) which electrical hazards (EN 60204-1) are significant for equipment and the quoted affects of Table B.1.

All necessary measures shall be taken in order to preclude any electrical hazards at the machines. The relevant clauses of EN 60204-1 shall be complied with.

B.2 Special requirements for controls

The IP-class of the electrical equipment shall be determined according to its use and the environmental conditions during risk assessment (EN 60204-1:2006; 10.1.3; 11. 3).

NOTE 1 The IP-code classification only takes into account the ingress of water and not of other fluids. In case of other fluids their influence should be considered.

Where access to a danger zone is required for any reason during normal operation the safety related control system of the equipment shall be in accordance with the appropriate category given in EN 954-1. If the access is required for the operations described as examples in Annex A of EN 1037:1995, the measures defined in EN 1037 shall be employed (EN 60204-1:2006; 5.4; 5.5; 5.6).

All isolating devices, either main or local, designed to be locked shall include facilities to apply one or more padlock (see 5.2 of EN 1037:1995).

Controls frequently include safety functions; in which case they are classified under the general term "safety-related parts of controls" of EN 954-1. The following is applicable to the design of such controls:

Safety-related controls shall at least be designed corresponding to category 1;

If access to the danger zone is only occasionally required during operation, e. g., for eliminating scale, the signal processing equipment shall at least correspond to category 2;

If access to the danger zone is required during operation, e. g., in each working cycle, the protection devices and signal processing equipment shall correspond to category 3.

NOTE 2 In general, it is not necessary to have access to the danger zone in each working cycle.

B.3 Special requirements for shut-down equipment

B.3.1 Stop and emergency-off functions

In conformity with the requirements of 4.11.3 of EN ISO 12100-2:2003, EN 418 and EN 60204-1 as well as EN 1037, the stop and emergency-off functions in B.3.3 of this annex shall be applied.

Furthermore, the following shall be applicable to normal stop and emergency-stop functions:

In inter-linked plants, it shall be ensured that the upstream or downstream equipment of a machine is shut down and the stored energies are eliminated, isolated or reduced to a level which does not cause a risk, if such energies are a source of danger. It may be necessary that power remains available and controlled for certain purposes:

- to preserve the effectiveness of safety devices or equipment with a safety-related function according to 4.1.9 of EN 418:1992;

- to preserve the integrity of facilities provided for rescuing stranded personnel from the danger zone according to 4.1.10 of EN 418:1992; and

- to carry out mechanical movements of machinery for releasing trapped personnel or rescuing injured persons.

Design of the control actuator for the shutdown functions shall be such as to ensure that:

- there can be no confusion, e. g., by colour and marking according to 10.2.1 of EN 60204-1:2006;

- inadvertent actuation is eliminated/avoided; and

- the control actuators are at all times prominent and readily and safely accessible according to 4.4.2 of EN 418:1992.

B.3.2 Emergency stops

Emergency stops shall be:

- easily identifiable in accordance with the requirements of EN 418;

- located at control desk(s), in the pump room, one at each opposing corner and, if a manipulator is fitted on that side, opposite from the working position and other locations identified in the risk assessment;

- marked to indicate the area of the plant affected by their operation(s) according to 4.4.4 of EN 418:1992;

- readily accessible as defined in EN 418;

- for re-start purposes, provided with time-delayed visible/audible warning devices (EN ISO 7731, EN 842), as applicable; and

- provided with means of locking in their off-position.

B.3.3 Stop functions

Table B.1 shows a compilation of different kind of applicable stop functions. On the basis of the assessment of electrical risk the manufacturer shall select the categories according to EN 60204-1 regarding the given examples and the quoted effects in Table B.1.

Table B.1 — Stop functions for open die forging presses

Function	Category according to EN 60204-1	Setting	Location (examples)	Effect
Emergency stop	Category 1	Red mushroom push-button before yellow background and with reclosing lockout (lock) and possibly with pilot lamp Main switch Mechanical device against unintended use on control panels necessary	Main control desk Auxiliary control panel Separated devices of category 1 emergency-stops for different parts of the equipment might be necessary (e. g., for the hydraulic system)	Shut-down of main drives with electric and/or mechanical braking Shut-down of auxiliary drives while maintaining operation with self-resetting control. Energy supply is maintained up to the standstill, then power-off Mechanical damage possible Potentially, rescue of persons by moving units into an open position might not be possible
Normal stop	Category 1	Push-button (colour according to EN 60204-1:2006; 10.2.1)	Main control desk Auxiliary control panel	Stopping of the complete installation: 1st step: Production stop 2nd step: interruption of energy supply
Emergency off	Category 0	Red mushroom push-button before yellow background and with reclosing lockout (lock) and possibly with pilot lamp Main switch Mechanical device against unintended use might be necessary	Transformer room Computer room Rectifier room Switch cabinet feeder panel Not adjacent to operational control desks with category 1	Immediate Power-off Uncontrolled shut-down All accumulators which might cause self-starting are relieved Shut-down of all drives Application of mechanical brakes Potentially, rescue of persons by moving units into an open position might not be possible
Quick stop	Category 2 This does not meet the requirements of an emergency stop or normal stop	Push-button (colour according to EN 60204-1:2006; 10.2.1)	where required	Maximum possible negative acceleration during shut-down All operating conditions are maintained Energy supply remains on during standstill
Production stop	Category 2 This does not meet the requirements of an emergency stop or normal stop	Push-button (colour according to EN 60204-1: 2006; 10.2.1)	Main control desk and every auxiliary control panel Usually combined with category 1 emergency stop (see above)	Possibly automatic standstill monitoring Stop function for normal operating conditions All operating conditions are maintained Energy supply remains on during standstill monitoring Possibly automatic standstill

Annex C

(normative)

Noise test code

C.1 Introduction

This noise test code specifies all the information necessary to carry out efficiently and under standardised conditions the determination, declaration and verification of noise emission for the equipment within the scope.

In order that the noise test can be repeated, representative operating conditions of the equipment has to be defined. This is why this noise test code requires these operating conditions to be recorded, reported and declared in detail.

Hydraulically powered open die hot forging presses never operate at the manufacturer's place. Noise emission measurement can only be carried out after commissioning is completed.

The noise emission of a machine in general is described by two quantities:

- the A-weighted emission sound pressure level at work stations; and

- the A-weighted sound power level.

The determination of these quantities is necessary for:

- Manufacturers to declare the noise emitted; and

- Purposes of noise control at the source at the design stage.

This noise test code gives information on the selection of suitable standards for noise measurement. The use of this European Standard ensures the reproducibility of the determination of the noise emission characteristics within specified limits determined by the grade of accuracy of the basic noise measurement method used. Methods of grade 2 of accuracy (engineering method) shall be preferably used. Methods of grade 3 of accuracy (survey method) can be used, but the reasons for not using a grade 2 method shall be reported.

NOTE For further information see series EN ISO 11200, EN ISO 9614-1, EN ISO 9614-2 and EN ISO 3740.

C.2 Determination of sound power level

C.2.1 General method

The A-weighted sound power level shall be determined in accordance with EN ISO 3744 (grade 2) or EN ISO 3747 (grade 2) or EN ISO 9614-1 (grade 2) or EN ISO 9614-2 (grade 2).

Where these standards are not applicable, the A-weighted sound power level shall be determined in accordance with EN ISO 3746 (grade 3) or EN ISO 3747 (grade 3) or EN ISO 9614-2 (grade 3). The report shall give a justification why a grade 2 method is not applicable.

When using EN ISO 3744 or EN ISO 3746, the measurement surface shall be a parallelepiped and the measurement distance to the surface shall be preferably 1 m.

NOTE 1 EN ISO 3740 gives guidance on the choice of measurement methods given in the EN ISO 3740 and EN ISO 9614 series.

NOTE 2 Sound power levels in frequency bands may also be determined.

C.2.2 Method for large machines/plants

Large machines/plants are those where the greatest linear dimension exceeds 15 m. In case of hydraulically powered open die hot forging equipment greater than 15 m in length (which is relevant for the predominant part of forging equipment), it is permissible to determine and report the emission sound pressure level at specified measuring points instead of the sound power level.

Specified measuring points shall be along a path around the machine at a height of 1,6 m above the floor or access level and at a distance of 1 m from the machine surface. They shall be spaced so that the difference in emission sound pressure levels between adjacent measuring points does not exceed 5 dB(A). The number of measuring points will depend on the characteristic of the noise emission. For even distribution of sound pressure levels, a low number of measuring points may be required. There should, however, be at least one measuring point at each side of the machine.

For determining the emission sound pressure level, the method described under C.3 shall be used.

C.3 Determination of emission sound pressure level at workstations

The A-weighted emission sound pressure level at workstations shall be determined in accordance with EN ISO 11202 (grade 3).

The regular operators' areas, i. e., permanent or temporary workstations, shall be determined by the manufacturer with consultation of the user of the equipment, but in all cases shall include the main control desk and local control desks (e. g., see workstations 5 (permanent) and 6 (temporary) in Figure C.1).

Where measuring is made difficult due to strong environmental influences such as reverberation and high levels of noise from other sources, EN ISO 11203 may be applied using the sound power level determined according to EN ISO 9614-1 or EN ISO 9614-2.

NOTE EN ISO 11200 gives guidance on the choice of measurement methods given in the EN ISO 11200 series.

C.4 Measurement uncertainty

Total measurement uncertainty of sound emission values is that given in the basic standard used.

C.5 Operating conditions

Measurements shall be made under defined representative operating conditions for the main part of the production and shall at least cover:

type, size and temperature of metal forged;

dimension of the upper and lower die;

number of strokes per minute;

penetration;

operating pressures of hydraulic systems;

manipulator step and rotation angle of the tong.

The installation and mounting conditions shall be those recommended by the manufacturer.

Operating conditions shall be the same for the determination of both sound power level and emission sound pressure level.

C.6 Information to be recorded and reported

The information recorded when carrying out the test and the test report shall at least contain the following information:

- a) manufacturer, kind of machine/plant, boundary and technical data and sizes;
- b) operating conditions under which noise is measured (see C.5);
- c) reference of the basic standards used for the determination of noise emission according to this noise test code (see C.2 and C.3); and
- d) measurement results

A-weighted emission sound pressure level at the permanent and/or temporary work station(s);

if required, A-weighted sound power level;

for large machines/plants, individual values of the A-weighted emission sound pressure levels along the measurement path; and

possible deviations to this noise test code or to the basic standards used, with the justification for them;

- e) position of workstation and measurement points; and
- f) place, date and responsible person for measurement.

C.7 Declaration and verification of noise emission values

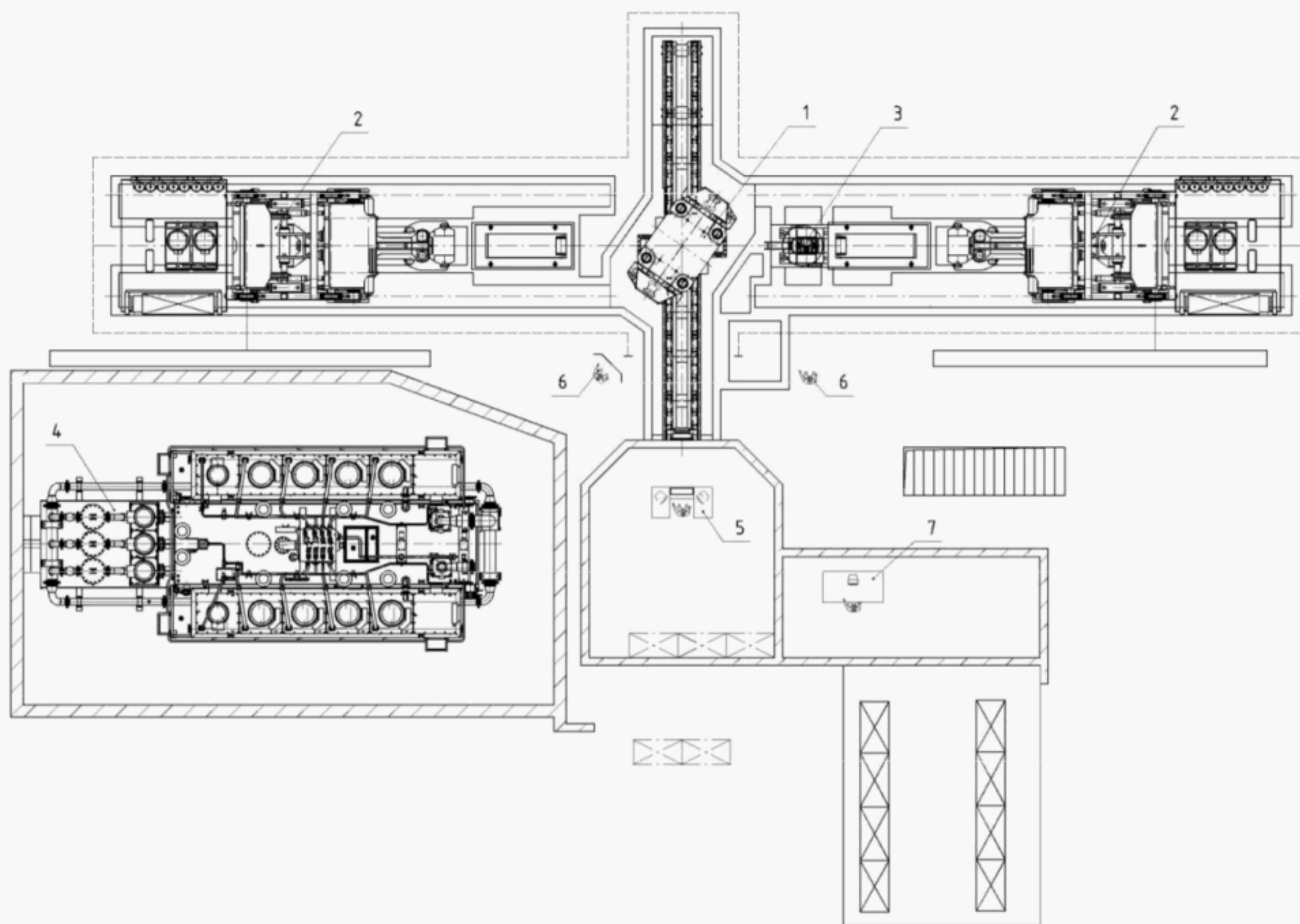
The declaration of the noise emission values at workstations shall be included in the operating manual. It shall be made in accordance with Annex C of this European Standard. The declaration shall be made as dual-number noise emission values and is the sole responsibility of the manufacturer. The noise declaration shall be made in such a way that the values can be verified according to 6.2 of EN ISO 4871:1996.

For equipment subject to this European Standard only typical values can be given as noise emission values before commissioning. The noise emission shall then be measured under defined representative operating conditions (see C.5) and declared after the plant has been put into operation.

The noise declaration shall explicitly mention the fact that the noise emission values have been obtained according to the specifications of this noise test code and indicate which basic standards have been used. If this statement is not true, the noise declaration shall indicate clearly what the deviations are from these specifications and/or from the basic standards.

Additional noise emission quantities such as sound power levels in octave bands may also be given in the noise declaration. In this case, care shall be taken to avoid confusion between these additional noise emission data and the declared dual-number noise emission values.

Table C.1 shows an example of a dual-number noise declaration.



Key

- | | | | |
|---|---------------------|---|--|
| 1 | Forging press | 5 | Main control room, operator permanently present |
| 2 | Forging manipulator | 6 | Local workstations, operator not permanently present |
| 3 | Pop-up turn table | 7 | Maintenance systems room |
| 4 | Pump station room | | |

**Figure C.1 — Example of measuring points for noise measurement
(location of permanent and temporary workstations)**

Table C.1 — Example of declared dual-number noise emission values

identifying information, e. g.,

Machine Type	
Type of metal forged	
Billet sizes (start and finished dimensions)	
Temperatures (start and finished)	
Operating hydraulic pressures	
Number of strokes per minute	
Penetration	

declaration of measured values, e. g., at workstations

DECLARED DUAL-NUMBER NOISE EMISSION VALUES				
Declared A-weighted emission sound pressure level at workstations				
Measurement at workstations (see e. g. Figure C.1)		Measured value L_{pA} [dB] (re 20 μ Pa)	Uncer- tainty K_{pA} [dB]	Location x,y [m]
5	Main control room			
6 (1)	Local workstation (left hand side of the forging press)			
6 (2)	Local workstation (right hand side of the forging press)			
7	Maintenance systems room			
Values determined according to noise test code Annex C of this European Standard and measurement standard EN ISO 11202				

if applicable:

Declared A-weighted sound power level:	
Measured value: L_{WA} = ____ dB (re 1 pW)	
Uncertainty: K_{WA} = ____ dB	
Values determined according to noise test code Annex C of this European Standard and measurement standard EN ISO 3747	

NOTE The sum of a measured noise emission value and its associated uncertainty factor represents an upper bound of the range of values which can occur in the measurements.

Annex D
(informative)

De-commissioning

As no present European Directive exists to cover the requirements for de-commissioning, manufacturers are advised to consult the present national laws on de-commissioning of the Member States to which they are selling the equipment to ensure themselves that they meet those requirements.

Note should also be made of the need to address the disposal of toxic waste material and any soil that might be contaminated.

Companies are advised to seek expert advice from suitable qualified consultants.

Annex ZA

(informative)

Relationship between this European Standard and the Essential Requirements of EU Directive 98/37/EC

This European Standard has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association to provide one means of conforming to Essential Requirements of the New Approach Directive Machinery 98/37/EC, amended by 98/79/EC.

Once this standard is cited in the Official Journal of the European Communities under that Directive and has been implemented as a national standard in at least one Member State, compliance with the normative clauses of this standard confers, within the limits of the scope of this standard, a presumption of conformity with the relevant Essential Requirements of that Directive and associated EFTA regulations.

WARNING: Other requirements and other EU Directives may be applicable to the product(s) falling within the scope of this standard.

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