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Machine tools safety - Machining centres, milling machines, transfer machines - Part 1: Safety requirements (ISO 16090-1:2022)

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

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Machine tools safety - Machining centres, milling  
machines, transfer machines - Part 1: Safety requirements  
(ISO 16090-1:2022)

Sécurité des machines-outils - Centres d'usinage,  
fraiseuses, machines transfert - Partie 1: Exigences de  
sécurité (ISO 16090-1:2022)

Werkzeugmaschinen-Sicherheit - Bearbeitungszentren,  
Fräsmaschinen, Transfermaschinen - Teil 1:  
Sicherheitsanforderungen (ISO 16090-1:2022)

This European Standard was approved by CEN on 17 October 2022.

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**EN ISO 16090-1:2022 (E)**

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## **European foreword**

This document (EN ISO 16090-1:2022) has been prepared by Technical Committee ISO/TC 39 "Machine tools" in collaboration with Technical Committee CEN/TC 143 "Machine tools - Safety" the secretariat of which is held by SNV.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2023, and conflicting national standards shall be withdrawn at the latest by June 2023.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 16090-1:2018.

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

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

## **Endorsement notice**

The text of ISO 16090-1:2022 has been approved by CEN as EN ISO 16090-1:2022 without any modification.

# INTERNATIONAL STANDARD

# ISO 16090-1

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## Machine tools safety — Machining centres, milling machines, transfer machines —

### Part 1: Safety requirements

*Sécurité des machines-outils — Centres d'usinage, fraiseuses,  
machines transfert —*

*Partie 1: Exigences de sécurité*



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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 10, *Safety*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 143, *Machine tools — Safety*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 16090-1:2017), which has been technically revised.

The main changes are as follows:

- update and addition of safety functions in [Annex J](#),
- revision of operating modes and change of designation from MSO (mode of safe operation) to MO (mode of operation),
- former MSO 3 (optional special mode for manual intervention under restricted operating conditions), in the current addition referred to as MO 3 (manual intervention under restricted operating conditions), has been revised in a way, that the usage of an enabling device is necessary in any case, i.e. dispensing of the enabling device is no longer possible.

A list of all parts in the ISO 16090 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

## ISO 16090-1:2022(E)

### Introduction

This document is a type-C standard as stated in ISO 12100.

This document is of relevance, in particular for the following stakeholder groups representing the market players with regard to machinery safety:

- machine manufacturers (small, medium and large enterprises);
- health and safety bodies (regulators, accident prevention organisations, market surveillance, etc.).

Others can be affected by the level of machinery safety achieved with the means of the document by the above-mentioned stakeholder groups:

- machine users/employers (small, medium and large enterprises);
- machine users/employees (e.g. trade unions, organizations for people with special needs);
- service providers, e.g. for maintenance (small, medium and large enterprises);
- consumers (in case of machinery intended for use by consumers).

The above-mentioned stakeholder groups have been given the possibility to participate at the drafting process of this document.

The machinery concerned and the extent to which hazards, hazardous situations or hazardous events are covered are indicated in the Scope of this document.

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

Machining centres, milling machines and transfer machines present a wide range of hazards. Protection of operators and other persons from contact with moving cutting tools, especially when being rapidly rotated in the spindle or being swung from a tool magazine to the spindle during power-operated tool changing, or from contact with fast-moving workpieces, is of great importance.

When power-operated mechanisms are provided for workpiece transfer, they can also create hazardous situations during loading/unloading and workpiece alignment, clamping or releasing of the workpiece.

The significant hazards covered by this document are those listed in [Clause 4](#). The safety requirements and/or protective measures to prevent or minimize those hazards identified in [Table 1](#) and procedures for verification of these requirements or measures are found in [5.17](#).

[Figures D.1](#) to [D.8](#) are examples only and are not intended to illustrate the only interpretation of the text.

# Machine tools safety — Machining centres, milling machines, transfer machines —

## Part 1: Safety requirements

### 1 Scope

This document specifies the technical safety requirements and protective measures for the design, construction and supply (including installation and dismantling, with arrangements for transport and maintenance) of:

- milling machines (see [3.1.1](#)), including machines capable of performing boring operations (see [3.1.2](#));
- machining centres; and
- transfer machines (see [3.1.3](#))

designed for continuous production use, which are intended to cut cold metal and other non-combustible cold materials, except wood or materials with physical characteristics similar to those of wood as defined in ISO 19085-1 and glass, stone and engineered/agglomerated materials as defined in EN 14618.

This document covers the following machines (referred to as "machines" in this document):

- a) manually, without numerical control, operated boring and milling machines (see [3.2.1](#), Group 1), e.g. knee and column type milling machines (see [Figures C.1](#) and [C.2](#));
- b) manually, with limited numerical control, operated boring and milling machines (see [3.2.2](#), Group 2), e.g. profile and contouring milling machines (see [Figures C.3](#) and [C.4](#));
- c) numerically controlled milling machines and machining centres (see [3.2.3](#), Group 3), e.g. automatic milling machines and milling centres, e.g. multi-spindle milling machines, gear-milling machines (see [Figures C.5](#) to [C.7](#));
- d) transfer and special-purpose machines (see [3.2.4](#), Group 4), which are designed to process only pre-specified workpieces or limited range of similar workpieces by means of a predetermined sequence of machining operations and process parameters (see [Figures C.8](#) to [C.13](#)).
- e) machines fitted with the following devices/facilities, whose hazards have been dealt with:
  - tool magazine(s);
  - tool changer(s);
  - workpiece handling mechanism(s);
  - powered workpiece clamping mechanism(s);
  - swarf/chip conveyor(s);
  - power-operated door(s);
  - moveable operator cabin(s);

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- additional equipment for turning;
- additional equipment for grinding.

This document deals with all significant hazards, hazardous situations and events relevant to this type of machinery which can occur during transportation, assembly and installation, setting, operation, cleaning and maintenance, troubleshooting, dismantling or disabling according to ISO 12100, when the machinery is used as intended and under conditions of misuse which are reasonably foreseeable by the manufacturer (see [Clause 4](#)).

This document presumes accessibility to the machine from all directions and specifies access conditions to operator positions. It also applies to workpiece transfer devices including transport devices for loading/unloading when they form an integral part of the machine.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 230-5:2000, *Test code for machine tools — Part 5: Determination of the noise emission*

ISO 3744:2010, *Acoustics — Determination of sound power levels and sound energy levels of noise sources using sound pressure — Engineering methods for an essentially free field over a reflecting plane*

ISO 3746:2010, *Acoustics — Determination of sound power levels and sound energy levels of noise sources using sound pressure — Survey method using an enveloping measurement surface over a reflecting plane*

ISO 4413:2010, *Hydraulic fluid power — General rules and safety requirements for systems and their components*

ISO 4414:2010, *Pneumatic fluid power — General rules and safety requirements for systems and their components*

ISO 4871:1996, *Acoustics — Declaration and verification of noise emission values of machinery and equipment*

ISO 9355-1:1999<sup>1)</sup>, *Ergonomic requirements for the design of displays and control actuators — Part 1: Human interactions with displays and control actuators*

ISO 9355-2:1999, *Ergonomic requirements for the design of displays and control actuators — Part 2: Displays*

ISO 9355-3:2006, *Ergonomic requirements for the design of displays and control actuators — Part 3: Control actuators*

ISO 11202:2010, *Acoustics — Noise emitted by machinery and equipment — Determination of emission sound pressure levels at a work station and at other specified positions applying approximate environmental corrections*

ISO 11204:2010, *Acoustics — Noise emitted by machinery and equipment — Determination of emission sound pressure levels at a work station and at other specified positions applying accurate environmental corrections*

ISO 12100:2010, *Safety of machinery — General principles for design — Risk assessment and risk reduction*

ISO 13849-1:2015, *Safety of machinery — Safety-related parts of control systems — Part 1: General principles for design*

ISO 13849-2:2012, *Safety of machinery — Safety-related parts of control systems — Part 2: Validation*

1) Now withdrawn.

- ISO 13850:2015, *Safety of machinery — Emergency stop function — Principles for design*
- ISO 13851:2019, *Safety of machinery — Two-hand control devices — Principles for design and selection*
- ISO 13855:2010, *Safety of machinery — Positioning of safeguards with respect to the approach speeds of parts of the human body*
- ISO 13856-1:2013, *Safety of machinery — Pressure-sensitive protective devices — Part 1: General principles for design and testing of pressure-sensitive mats and pressure-sensitive floors*
- ISO 13856-2:2013, *Safety of machinery — Pressure-sensitive protective devices — Part 2: General principles for design and testing of pressure-sensitive edges and pressure-sensitive bars*
- ISO 13857:2019, *Safety of machinery — Safety distances to prevent hazard zones being reached by upper and lower limbs*
- ISO 14118:2017, *Safety of machinery — Prevention of unexpected start-up*
- ISO 14119:2013, *Safety of machinery — Interlocking devices associated with guards — Principles for design and selection*
- ISO 14120:2015, *Safety of machinery — Guards — General requirements for the design and construction of fixed and movable guards*
- ISO 14738:2002, *Safety of machinery — Anthropometric requirements for the design of workstations at machinery*
- ISO 15534-1:2000, *Ergonomic design for the safety of machinery — Part 1: Principles for determining the dimensions required for openings for whole-body access into machinery*
- ISO 15534-2:2000, *Ergonomic design for the safety of machinery — Part 2: Principles for determining the dimensions required for access openings*
- ISO 15641:2001, *Milling cutters for high speed machining — Safety requirements*
- ISO 16156:2004, *Machine-tools safety — Safety requirements for the design and construction of work holding chucks*
- ISO 19353:2019, *Safety of machinery — Fire prevention and fire protection*
- ISO 23125:2015, *Machine tools — Safety — Turning machines*
- IEC 60204-1:2016, *Safety of machinery — Electrical equipment of machines — Part 1: General requirements*
- IEC 60825-1:2014, *Safety of laser products — Part 1: Equipment classification and requirements*
- IEC 61000-4-2:2008, *Electromagnetic compatibility (EMC) — Part 4-2: Testing and measurement techniques — Electrostatic discharge immunity test*
- IEC 61000-4-4:2012, *Electromagnetic compatibility (EMC) — Part 4-4: Testing and measurement techniques — Electrical fast transient/burst immunity test*
- IEC 61000-6-2:2016, *Electromagnetic compatibility (EMC) — Part 6-2: Generic standards — Immunity for industrial environments*
- EN 614-1+A1:2009, *Safety of machinery - Ergonomic design principles - Part 1: Terminology and general principles*
- EN 1005-1+A1:2008, *Safety of machinery — Human physical performance — Part 1: Terms and definitions*
- EN 1005-2+A1:2008, *Safety of machinery — Human physical performance — Part 2: Manual handling of machinery and component parts of machinery*

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EN 1005-3+A1:2008, *Safety of machinery - Human physical performance - Part 3: Recommended force limits for machinery operation*

EN 1005-4+A1:2008, *Safety of machinery — Human physical performance — Part 4: Evaluation of working postures and movements in relation to machinery*

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