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Food processing machinery - Food depositors - Safety and hygiene requirements

Táto norma obsahuje anglickú verziu európskej normy.

This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 05/25

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 15180**

March 2025

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Supersedes EN 15180:2014

English Version

**Food processing machinery - Food depositors - Safety and  
hygiene requirements**

Machines pour les produits alimentaires - Doseuses  
alimentaires - Prescriptions relatives à la sécurité et à  
l'hygiène

Nahrungsmittelmaschinen -  
Nahrungsmittelportioniermaschinen - Sicherheits- und  
Hygieneanforderungen

This European Standard was approved by CEN on 3 February 2025.

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 CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

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## European foreword

This document (EN 15180:2025) has been prepared by Technical Committee CEN/TC 153 “Machinery intended for use with foodstuffs and feed”, 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of an identical text or by endorsement, at the latest by September 2025, and conflicting national standards shall be withdrawn at the latest by September 2025.

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 15180:2014.

EN 15180:2025 includes the following significant technical changes with respect to EN 15180:2014:

- Normative references have been changed to reflect the changes that have been made to B1- and B2-standards.
- The structure of the standard has been changed, so it complies with CEN Guide 414:2017.
- Annex ZA has been updated regarding the requests of the European Commission on Machinery Directive (2006/42/EC).

This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

For the relationship with EU Legislation, see informative Annex ZA, which is an integral part of this document.

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

According to the CEN-CENELEC Internal Regulations, the national standards organisations 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.

**EN 15180:2025 (E)****Introduction**

Food depositors are used extensively in Europe, in commercial and industrial food preparation applications. They present some health and safety hazards that have the potential to cause serious injury.

This document is a type-C standard as stated in EN ISO 12100:2010.

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

- machine manufacturers (small, medium and large enterprises);
- health and safety bodies (regulators, accident prevention organizations, 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);

The above-mentioned stakeholder groups have been given the possibility to participate at the drafting process of this document. The machinery concerned and the extent to which hazards, hazardous situations or hazardous events are covered are indicated in the Scope of this document.

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



# 1 Scope

## 1.1 General

This document is applicable to food depositors as listed in 1.2 and the equipment typically integrated with them, i.e. product pumps, product elevators, conveyors and indexing mechanisms, when they are used as intended and under conditions of misuse which are reasonably foreseeable by the manufacturer (see Annex B).

This document deals with the significant hazards, hazardous situations and events during transport, assembly and installation, commissioning, use, decommissioning, disabling, dismantling and scrapping.

NOTE 1 According to the clause which is referred to, “use” includes “setting, teaching/programming or process changeover, operation, cleaning, fault finding and maintenance”.

NOTE 2 Although this document is intended to apply to depositors used in the food industry, many of its requirements can also be used for the same or similar machines used in other industries.

This document does not apply to the following machines:

- auger depositors or auger fillers and gravimetric filling machines; safety requirements for these machines are contained in EN 415-3;
- automatic dough dividers, safety requirements for these machines are contained in EN 12042;
- filling machines for sausages, safety requirements for these machines are contained in EN 12463;
- mincing machines, safety requirements for these machines are contained in EN 12331;
- food depositors that are powered exclusively by manual effort;
- roller depositors intended for use in craft bakeries. Safety requirements for these machines are in EN 17677.

This document does not deal with the following hazards:

- hazards related to the use of food depositors in a potentially explosive atmosphere;
- hazards that can arise from using a food depositor to deposit a non-food product.

This document is not applicable to food depositors that were manufactured before the date of its publication as a European Standard.

## 1.2 Types of food depositors

### 1.2.1 General

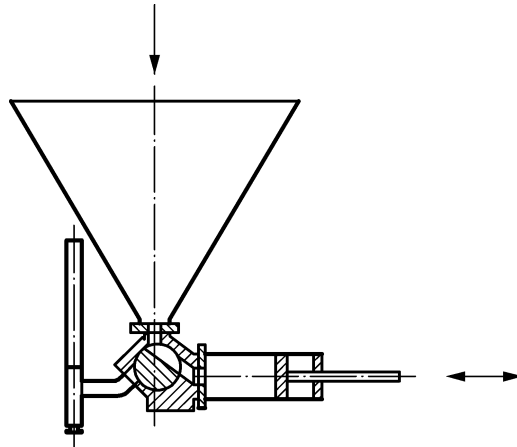
This document deals with five different types of food depositor. The component parts of each of the different types of depositor are labelled in the figures shown in Clause 4 of this document.

### 1.2.2 Piston depositor

A piston depositor typically comprises a hopper, a rotary valve, a product measuring chamber in the form of a piston and a product dispensing valve. Some piston depositors incorporate several product measuring chambers and dispensing valves. Some designs dispense the product directly from the rotary valve without the use of a separate product dispensing valve. The volume of product dispensed is varied by altering the stroke of the product measuring chamber piston. Piston depositors are used to fill liquids, liquids containing solids in suspension and pastes. The product dispensing valve can be attached rigidly

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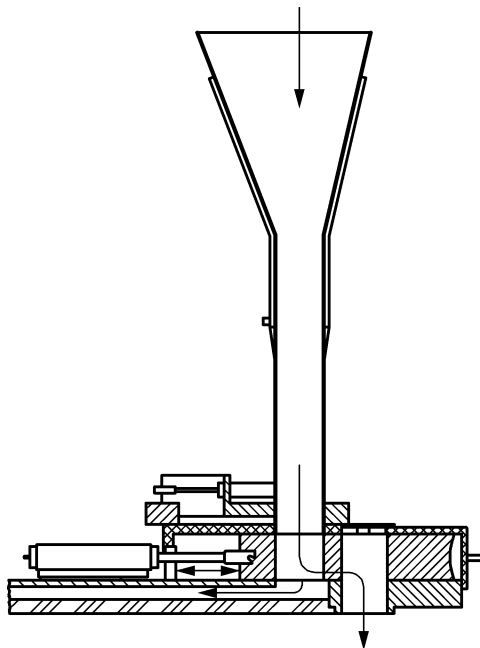
to the depositor or using a flexible pipe and in some cases is held by the operator. Figure 1 shows the typical cross section of a piston depositor.



**Figure 1 — Piston depositor**

**1.2.3 Chamber depositor**

A chamber depositor comprises a hopper feeding one or more product measuring chambers that are filled under gravity from the top. When the chamber has been filled with product the flow of product is stopped either by moving the chamber or using a product cutting device. The product is then discharged through the bottom of the chamber either by moving the chamber or by moving a plate in the base of the chamber. The volume of product dispensed is varied by altering the volume of the chamber. Chamber depositors are typically used to deposit free-flowing products like cooked rice or pasta. Figure 2 shows the typical cross section of a chamber depositor.



**Figure 2 — Chamber depositor**

### 1.2.4 Roller depositor

A roller depositor typically comprises a hopper that feeds product to two or more fluted contra-rotating rollers. These rollers force the product through one or more dies that shape the product. The product is then separated using a product cutting device like a wire cut mechanism. On some designs of the machine the dies are moved while the product is dispensed to produce a shaped product. The volume of product dispensed is varied by altering the timing of the product cut-off device. Roller depositors are typically used to deposit dough or confectionery products. Figure 3 shows the typical cross section of a roller depositor.

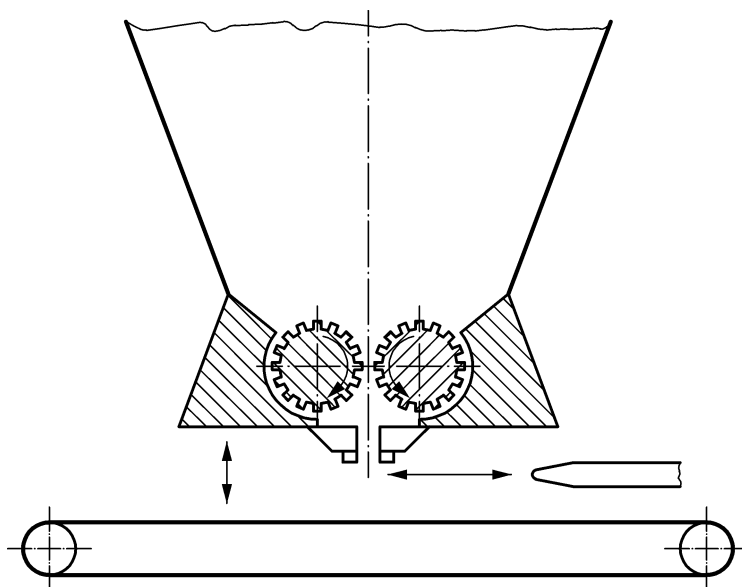


Figure 3 — Roller depositor

### 1.2.5 Pump depositor

A pump depositor comprises a hopper that feeds a pump which in turn feeds pipe work on which are mounted one or more product dispensing valves. The dispensing valves can remain fixed, move up and down or from side to side in synchronization with a product conveyor. The volume of product dispensed is varied by altering the length of time that the dispensing valves are open. Pump depositors are typically used to deposit liquids or liquids containing finely divided solids. Figure 4 shows the typical cross section of a pump depositor.

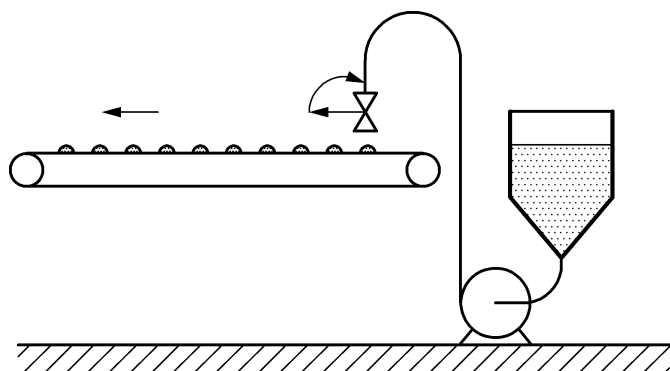
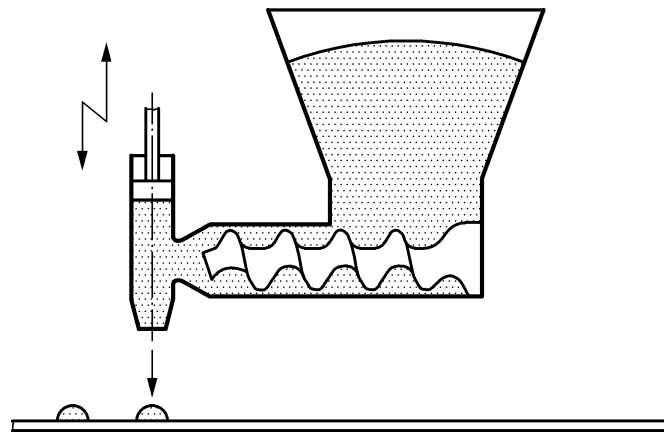


Figure 4 — Pump depositor

**EN 15180:2025 (E)****1.2.6 Screw depositor**

A screw depositor comprises a hopper in which a screw is mounted. When the screw rotates it draws product from the hopper into a pipe. The hopper can be equipped with stirrers to move the product towards the screw and a product measuring chamber or product dispensing valve can be fitted to the discharge of the screw. The volume of product can be varied by increasing or decreasing the speed of the screw, by varying the volume of the measuring chamber or by controlling the actuation of the product dispensing valve. Screw depositors are typically used to deposit dough, pastes or creams. Figure 5 shows the typical cross section of a screw depositor.



**Figure 5 — Screw depositor**

**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.

EN 618:2002+A1:2010, *Continuous handling equipment and systems — Safety and EMC requirements for equipment for mechanical handling of bulk materials except fixed belt conveyors*

EN 619:2022, *Continuous handling equipment and systems — Safety requirements for equipment for mechanical handling of unit loads*

EN 620:2021, *Continuous handling equipment and systems — Safety requirements for fixed belt conveyors for bulk materials*

EN 894-1:1997+A1:2008, *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 894-2:1997+A1:2008, *Safety of machinery — Ergonomics requirements for the design of displays and control actuators — Part 2: Displays*

EN 894-3:2000+A1:2008, *Safety of machinery — Ergonomics requirements for the design of displays and control actuators — Part 3: Control actuators*

EN 1005-2:2003+A1:2008, *Safety of machinery — Human physical performance — Part 2: Manual handling of machinery and component parts of machinery*

EN 1005-3:2002+A1:2008, *Safety of machinery — Human physical performance — Part 3: Recommended force limits for machinery operation*

EN 1672-2:2020, *Food processing machinery — Basic concepts — Part 2: Hygiene and cleanability requirements*

EN 60204-1:2018, *Safety of machinery — Electrical equipment of machines — Part 1: General requirements (IEC 60204-1:2016, modified)*

EN 60529:1991<sup>1)</sup>, *Degrees of protection provided by enclosures (IP Code) (IEC 60529:1989)*

EN IEC 61000-6-2:2019, *Electromagnetic compatibility (EMC) — Part 6-2: Generic standards — Immunity standard for industrial environments (IEC 61000-6-2:2016)*

EN 61310-1:2008, *Safety of machinery — Indication, marking and actuation — Part 1: Requirements for visual, acoustic and tactile signals (IEC 61310-1:2007)*

EN 61310-3:2008, *Safety of machinery — Indication, marking and actuation — Part 3: Requirements for the location and operation of actuators (IEC 61310-3:2007)*

EN 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 3744:2010)*

EN 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 3746:2010)*

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

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

EN ISO 4871:2009, *Acoustics — Declaration and verification of noise emission values of machinery and equipment (ISO 4871:1996)*

EN ISO 7010:2020, *Graphical symbols — Safety colours and safety signs — Registered safety signs (ISO 7010:2019, Corrected version 2020-06)*

EN ISO 11201:2010, *Acoustics — Noise emitted by machinery and equipment — Determination of emission sound pressure levels at a work station and at other specified positions in an essentially free field over a reflecting plane with negligible environmental corrections (ISO 11201:2010)*

EN ISO 11202:2010<sup>2)</sup>, *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 11202:2010)*

EN ISO 12001:2009, *Acoustics — Noise emitted by machinery and equipment — Rules for the drafting and presentation of a noise test code (ISO 12001:1996)*

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<sup>1)</sup> As impacted by EN 60529:1991/A1:2000 and EN 60529:1991/A2:2013.

<sup>2)</sup> As impacted by EN ISO 11202:2010/A1:2021.

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

EN ISO 13732-1:2008, *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 13849-1:2023, *Safety of machinery — Safety-related parts of control systems — Part 1: General principles for design (ISO 13849-1:2023)*

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

EN ISO 13851:2019, *Safety of machinery — Two-hand control devices, principles for design and selection (ISO 13851:2019)*

EN ISO 13854:2019, *Safety of machinery — Minimum gaps to avoid crushing of parts of the human body (ISO 13854:2017)*

EN ISO 13855:2024, *Safety of machinery — Positioning of safeguards with respect to the approach of the human body (ISO 13855:2024)*

EN ISO 13857:2019, *Safety of machinery — Safety distances to prevent hazard zones being reached by upper and lower limbs (ISO 13857:2019)*

EN ISO 14118:2018, *Safety of machinery — Prevention of unexpected start-up (ISO 14118:2017)*

EN ISO 14119:2013, *Safety of machinery — Interlocking devices associated with guards — Principles for design and selection (ISO 14119:2013)*

EN ISO 14120:2015, *Safety of machinery — Guards — General requirements for the design and construction of fixed and movable guards (ISO 14120:2015)*

EN ISO 14122-1:2016, *Safety of machinery — Permanent means of access to machinery — Part 1: Choice of fixed means and general requirements of access (ISO 14122-1:2016)*

EN ISO 14122-2:2016, *Safety of machinery — Permanent means of access to machinery — Part 2: Working platforms and walkways (ISO 14122-2:2016)*

EN ISO 14122-3:2016, *Safety of machinery — Permanent means of access to machinery — Part 3: Stairs, stepladders and guard-rails (ISO 14122-3:2016)*

**koniec náhľadu – text ďalej pokračuje v platenej verzii STN**