

STN	Drevárske stroje Bezpečnosť Časť 13: Vialistové kotúčové píly s ručným vkladáním a/alebo odoberaním (ISO 19085-13: 2025)	STN EN ISO 19085-13 49 6115
------------	---	---

Woodworking machines - Safety - Part 13: Multi-blade rip sawing machines with manual loading and/or unloading (ISO 19085-13:2025)

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. 02/26

Obsahuje: EN ISO 19085-13:2025, ISO 19085-13:2025

Oznámením tejto normy sa ruší
STN EN ISO 19085-13 (49 6115) z novembra 2020

141969

Úrad pre normalizáciu, metrológiu a skúšobníctvo Slovenskej republiky, 2026
Slovenská technická norma a technická normalizačná informácia je chránená zákonom č. 60/2018 Z. z. o technickej normalizácii v znení neskorších predpisov.

EUROPEAN STANDARD

EN ISO 19085-13

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2025

ICS 13.110; 79.120.10

Supersedes EN ISO 19085-13:2020

English Version

Woodworking machines - Safety - Part 13: Multi-blade rip sawing machines with manual loading and/or unloading (ISO 19085-13:2025)

Machines à bois - Sécurité - Partie 13: Déligneuses
multi-lames à chargement et/ou déchargement manuel
(ISO 19085-13:2025)

Holzbearbeitungsmaschinen - Sicherheit - Teil 13:
Mehrblattkreissägemaschinen für Längsschnitt mit
Handbeschickung und/oder Handentnahme (ISO
19085-13:2025)

This European Standard was approved by CEN on 1 September 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.

CEN members are the national standards bodies of 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 United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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

EN ISO 19085-13:2025 (E)

Contents	Page
European foreword.....	3
Annex ZA (informative) Relationship between this European Standard and the essential requirements of Directive 2006/42/EC aimed to be covered	4

European foreword

This document (EN ISO 19085-13:2025) has been prepared by Technical Committee ISO/TC 39 "Machine tools" in collaboration with Technical Committee CEN/TC 142 "Woodworking machines - Safety" the secretariat of which is held by UNI.

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 April 2026, and conflicting national standards shall be withdrawn at the latest by April 2026.

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 19085-13:2020.

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/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 19085-13:2025 has been approved by CEN as EN ISO 19085-13:2025 without any modification.

EN ISO 19085-13:2025 (E)**Annex ZA**
(informative)**Relationship between this European Standard and the essential requirements of Directive 2006/42/EC aimed to be covered**

This European Standard has been prepared under a Commission's standardization request "M/396 Mandate to CEN and CENELEC for Standardisation in the field of machinery" to provide one voluntary means of conforming to essential requirements of Directive 2006/42/EC of the European Parliament and of the Council of 17 May 2006 on machinery, and amending Directive 95/16/EC (recast).

Once this standard is cited in the Official Journal of the European Union under that Directive, compliance with the normative clauses of this standard given in [Table ZA.1](#) confers, within the limits of the scope of this standard, a presumption of conformity with the corresponding essential requirements of that Directive and associated EFTA regulations.

Table ZA.1 — Correspondence between this European Standard and Annex I of Directive 2006/42/EC

The relevant Essential Requirements of Directive 2006/42/EC	Clause(s)/subclause(s) of this EN	Remarks/Notes
1.1.2 Principles of safety integration		
a) fitted for its function	Clauses 4, 5, 6, 7	
c) intended use and reasonably foreseeable misuse	Clauses 4, 5, 6, 7	
d) constraints in use	Clauses 4, 5, 6, 7	
1.1.3 Materials and products	6.3	
1.1.5 Design of machinery to facilitate its handling	6.5, 7.3	
1.1.6 Ergonomics	6.5	
1.2.1 Safety and reliability of control systems	4.1, 6.7, 6.8	
1.2.2 Control devices	4.2, 4.3, 4.4, 4.7	
1.2.3 Starting	4.3	
1.2.4.1 Normal stop	4.4.1, 4.4.2, 4.5, 5.4	
1.2.4.3 Emergency stop	4.4.1, 4.4.4, 4.5, 5.4	
1.2.6 Failure of the power supply	4.8, 6.7, 6.8	
1.3.1 Risk of loss of stability	5.1, 7.3	
1.3.2 Risk of break-up during operation	4.3.1, 5.3, 5.9, 7.3	
1.3.3 Risks due to falling or ejected objects	5.3, 5.5, 5.7, 5.9, 7.3	
1.3.6 Risks relating to variations in the operating conditions	4.7, 5.6	
1.3.7 Risks related to moving parts	5.5, 5.6, 5.7, 7.3	
1.3.8 Choice of protection against risks related to moving parts	5.6	

The relevant Essential Requirements of Directive 2006/42/EC	Clause(s)/subclause(s) of this EN	Remarks/Notes
1.3.9 Risk of uncontrolled movements	4.5, 4.8, 5.4	
1.4.1 General requirements	5.9	
1.4.2.1 Fixed guards	5.5.1	
1.4.2.2 Interlocking movable guards	5.5.2	
1.4.3 Special requirements for protective devices	5.5.3, 5.5.6	
1.5.1 Electricity supply	6.4, 6.13	
1.5.2 Static electricity	6.11	
1.5.3 Energy supply other than electricity	6.7, 6.8	
1.5.4 Errors of fitting	6.12	
1.5.6 Fire	6.1	
1.5.8 Noise	6.2, Annex F	
1.5.11 External radiation	6.9	
1.5.12 Laser equipment	6.10	
1.5.13 Emission of hazardous materials and substances	6.3	
1.6.1 Machinery maintenance	6.14, 7.3	
1.6.2 Access to operating position and servicing points	6.14, 7.3	
1.6.3 Isolation of energy sources	6.13, 7.3	
1.6.4 Operator intervention	6.14, 7.3	
1.6.5 Cleaning of internal parts	6.14, 7.3	
1.7.1 Information and warnings on the machinery	6.10, 7.1, 7.2	
1.7.2 Warning devices	6.10, 7.1	
1.7.3 Marking of machinery	7.2	
1.7.4 Instructions	6.2.2, 6.10, 7.3, Annex F	
2.3 Machinery for working wood and analogous materials		
a) guiding	5.10	
b) ejection	5.3, 5.5, 5.6, 5.9, 7.3	
c) brake	4.5, 5.4	
d) accidental tool contact	5.6, 7.3	

WARNING 1 Presumption of conformity stays valid only as long as a reference to this European Standard is maintained in the list published in the Official Journal of the European Union. Users of this standard should consult frequently the latest list published in the Official Journal of the European Union.

WARNING 2 Other Union legislation may be applicable to the product(s) falling within the scope of this standard.



International Standard

ISO 19085-13

Woodworking machines — Safety — Part 13: Multi-blade rip sawing machines with manual loading and/or unloading

Machines à bois — Sécurité —

*Partie 13: Déligneuses multi-lames à chargement et/ou
déchargement manuel*

**Second edition
2025-09**

ISO 19085-13:2025(en)**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2025

All rights reserved. Unless otherwise specified, or required in the context of its implementation, no part of this publication may be reproduced or utilized otherwise in any form or by any means, electronic or mechanical, including photocopying, or posting on the internet or an intranet, without prior written permission. Permission can be requested from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

ISO 19085-13:2025(en)**Contents**

Page

Foreword	v
Introduction	vi
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Safety requirements and measures for controls	5
4.1 Safety and reliability of control systems.....	5
4.2 Control devices.....	5
4.3 Start.....	6
4.3.1 Direct start.....	6
4.3.2 Start via control power-on.....	6
4.4 Safe stops.....	6
4.4.1 General.....	6
4.4.2 Normal stop.....	6
4.4.3 Operational stop.....	7
4.4.4 Emergency stop.....	7
4.5 Braking function of tools.....	7
4.6 Mode selection.....	7
4.6.1 Pressure shoe or pressure board cutting mode.....	7
4.6.2 Cleaning mode.....	8
4.6.3 Powered axial adjustment mode.....	8
4.7 Tool speed changing.....	8
4.7.1 Speed changing by shifting the belts on the pulleys.....	8
4.7.2 Speed changing by incremental speed change motor.....	8
4.7.3 Infinitely variable speed by frequency inverter.....	8
4.8 Failure of any power supply.....	8
4.9 Manual reset control.....	8
4.10 Standstill detection and monitoring.....	8
4.11 Machine moving parts speed monitoring.....	9
4.12 Time delay.....	9
4.13 Teleservice.....	9
4.14 Powered adjustments when guards are closed.....	9
5 Safety requirements and measures for protection against mechanical hazards	9
5.1 Stability.....	9
5.2 Risk of break-up during operation.....	9
5.3 Tool and tool fixing design.....	9
5.3.1 General.....	9
5.3.2 Spindle locking.....	10
5.3.3 Circular saw blade fixing device.....	10
5.3.4 Flanges dimensions for circular saw blades.....	10
5.4 Braking.....	10
5.4.1 Braking of tools.....	10
5.4.2 Maximum run-down time.....	10
5.4.3 Brake release.....	10
5.5 Safeguards.....	10
5.5.1 Fixed guards.....	10
5.5.2 Interlocking moveable guards.....	10
5.5.3 Hold-to-run control.....	11
5.5.4 Two-hand control.....	11
5.5.5 Electro-sensitive protective equipment (ESPE).....	11
5.5.6 Pressure sensitive protective equipment (PSPE).....	11
5.5.7 Enabling control.....	11
5.6 Prevention of access to hazardous moving parts.....	11

ISO 19085-13:2025(en)

5.6.1	Access to the saw blades.....	11
5.6.2	Access to the saw blades through the chip and dust outlets.....	11
5.6.3	Access to the crushing and shearing points of the feed mechanism	11
5.6.4	Access to the feed rollers	11
5.6.5	Access to crushing points on conveyor chains	12
5.6.6	Access to hazardous movements of drives	12
5.7	Impact hazard	12
5.8	Clamping devices.....	12
5.9	Measures against ejection.....	13
5.9.1	General.....	13
5.9.2	Guards materials and characteristics.....	13
5.9.3	Measures against ejection through the infeed opening.....	13
5.9.4	Measures against ejection through the outfeed opening.....	26
5.10	Workpiece support and guide.....	29
6	Safety requirements and measures for protection against other hazards.....	29
6.1	Fire.....	29
6.2	Noise	29
6.2.1	Noise reduction at the design stage	29
6.2.2	Noise emission measurement and declaration	29
6.3	Emission of chips and dust.....	29
6.4	Electricity.....	30
6.5	Ergonomics and handling	30
6.6	Lighting.....	30
6.7	Pneumatics.....	30
6.8	Hydraulics.....	30
6.9	Electromagnetic compatibility.....	30
6.10	Laser	30
6.11	Static electricity.....	30
6.12	Errors of fitting.....	30
6.13	Isolation.....	30
6.14	Maintenance.....	31
6.15	Relevant but not significant hazards.....	31
7	Information for use.....	31
7.1	Warning devices.....	31
7.2	Marking.....	31
7.2.1	General.....	31
7.2.2	Additional marking.....	31
7.3	Instruction handbook.....	31
7.3.1	General.....	31
7.3.2	Additional information.....	31
Annex A	(informative) List of significant hazards.....	33
Annex B	(informative) Performance level required.....	35
Annex C	(informative) Stability test.....	36
Annex D	(normative) Test for braking function.....	37
Annex E	(normative) Impact test for guards.....	38
Annex F	(normative) Noise test code.....	39
Annex G	(normative) Test for the anti-splinter system on machines with one chain conveyor.....	42
Bibliography	47

ISO 19085-13:2025(en)

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 document 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).

ISO draws attention to the possibility that the implementation of this document may involve the use of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at www.iso.org/patents. ISO shall not be held responsible for identifying any or all such patent rights.

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.

This document was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 4, *Woodworking machines*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 142, *Woodworking machines - 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 19085-13:2020), which has been technically revised.

The main changes are as follows:

- the Scope has been revised to specify that machines are intended for continuous production use;
- machines with all saw blades spindles mounted below the workpiece support/level only have been covered and their exclusion deleted from Scope;
- the list of significant hazards has been moved to a new [Annex A](#) and subsequent clauses and annexes have been renumbered;
- [subclause 6.2](#) has been updated and a new full noise test code has been added in [Annex F](#).

This document is intended to be used in conjunction with ISO 19085-1:2021.

A list of all parts in the ISO 19085 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.

ISO 19085-13:2025(en)

Introduction

The ISO 19085 series provides technical safety requirements for the design and construction of woodworking machinery, as well as for the content of the relevant instruction handbook. It concerns designers, manufacturers, suppliers and importers of the machines specified in the Scope.

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

The curtain described in [5.9.3.1.5](#) as part of the relevant anti-splinter system is patented. However, the patent holder is willing to negotiate licences with other parties on a non-discriminatory basis on reasonable terms and conditions, and has provided ISO with the relevant Patent Statement and Licensing Declaration.

The full set of requirements for a particular type of woodworking machine are those given in the part of the ISO 19085 series applicable to that type, together with the relevant requirements from ISO 19085-1:2021, to the extent specified in the Scope of the applicable part of the ISO 19085 series.

As far as possible, the safety requirements of parts of the ISO 19085 series refer to the relevant subclauses of ISO 19085-1:2021. Each part contains replacements and additions to the common requirements given in ISO 19085-1:2021.

All parts of the ISO 19085 series have the same structure, so that reference to ISO 19085-1:2021 is made always and only from and to the same subclause number at the last indent level.

[Clauses 1 to 3](#) are specific to each part and, therefore are distinct from ISO 19085-1:2021, Clauses 1 to 3.

For [Clauses 4 to 7](#) and the annexes, each subclause in ISO 19085-1:2021 is cited as either:

- confirmed as a whole;
- confirmed with additions;
- excluded entirely; or
- replaced with specific text.

ISO 19085-13:2025(en)

This is indicated by one of the following possible statements:

- “ISO 19085-1:2021, [subclause/Annex], applies”;
- “ISO 19085-1:2021, [subclause/Annex], applies with the following additions.” or “ISO 19085-1:2021, [subclause/Annex], applies with the following additions, subdivided into further specific subclauses.”;
- “ISO 19085-1:2021, [subclause/Annex], does not apply.”;
- “ISO 19085-1:2021, [subclause/Annex], is replaced by the following text.” or “ISO 19085-1:2021, [subclause/Annex], is replaced by the following text, subdivided into further specific subclauses.”.

Other subclauses and annexes specific to this document are indicated by the introductory sentence: “Subclause/Annex specific to this document.”.

Woodworking machines — Safety —

Part 13:

Multi-blade rip sawing machines with manual loading and/or unloading

1 Scope

This document specifies the safety requirements and measures for multi-blade rip sawing machines with manual loading or unloading or both, capable of continuous production use, hereinafter referred to also as “machines”, designed to cut solid wood and materials with similar physical characteristics to wood.

This document deals with all significant hazards, hazardous situations and events as listed in [Annex A](#), relevant to the machines, when operated, adjusted and maintained as intended and under the conditions foreseen by the manufacturer including reasonably foreseeable misuse. Transport, assembly, dismantling, disabling and scrapping phases are also taken into account.

This document does not deal with specific hazards related to the combination of single machines with any other machine as part of a line.

This document is not applicable to machines:

- intended for use in potentially explosive atmosphere;
- manufactured prior to its publication.

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 1421:2016, *Rubber- or plastics-coated fabrics — Determination of tensile strength and elongation at break*

ISO 2060:1994, *Textiles — Yarn from packages — Determination of linear density (mass per unit length) by the skein method*

ISO 2286-2:2016, *Rubber- or plastics-coated fabrics — Determination of roll characteristics — Part 2: Methods for determination of total mass per unit area, mass per unit area of coating and mass per unit area of substrate*

ISO 4649:2024, *Rubber, vulcanized or thermoplastic — Determination of abrasion resistance using a rotating cylindrical drum device*

ISO 7211-2:2024, *Textiles — Methods for analysis of woven fabrics construction — Part 2: Determination of number of threads per unit length*

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

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 13856-3:2013, *Safety of machinery — Pressure-sensitive protective devices — Part 3: General principles for design and testing of pressure-sensitive bumpers, plates, wires and similar devices*

ISO 19085-13:2025(en)

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

ISO 19085-1:2021, *Woodworking machines — Safety — Part 1: Common requirements*

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

EN 847-1:2017, *Tools for woodworking — Safety requirements — Part 1: Milling tools, circular saw blades*

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

koniec náhľadu – text ďalej pokračuje v platenej verzii STN