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Food processing machinery - Bowl lifting and tilting machines - Safety and hygiene requirements

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

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**EN 13288**

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English Version

## Food processing machinery - Bowl lifting and tilting machines - Safety and hygiene requirements

Machines pour les produits alimentaires -  
Élévateurs/basculateurs de cuve - Exigences relatives à  
la sécurité et à l'hygiène

Nahrungsmittelmaschinen - Hub- und  
Kippenrichtungen für Bottiche - Sicherheits- und  
Hygieneanforderungen

This European Standard was approved by CEN on 29 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.

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

## EN 13288:2025 (E)

| <b>Contents</b>  | <b>Page</b> |
|--|-------------|
| European foreword .....  | 4           |
| Introduction .....   | 5           |
| <b>1 Scope.....</b>  | <b>6</b>    |
| <b>2 Normative references.....</b>   | <b>7</b>    |
| <b>3 Terms and definitions .....</b>   | <b>8</b>    |
| <b>4 Safety and hygiene requirements and/or protective/risk reduction measures.....</b>  | <b>9</b>    |
| <b>4.1 General.....</b>  | <b>9</b>    |
| <b>4.2 Safety requirements to prevent mechanical hazards.....</b>  | <b>10</b>   |
| <b>4.2.1 General.....</b>  | <b>10</b>   |
| <b>4.2.2 Zone 1 – Safety requirements to prevent trapping and crushing.....</b>  | <b>10</b>   |
| <b>4.2.3 Zone 2 – Safety requirements to prevent impact or crushing by unintended movement of the lifting system, the bowl or mixing machine and placing the bowl for being locked by the bowl or mixing machine locking device.....</b> | <b>14</b>   |
| <b>4.2.3.1 General.....</b>  | <b>14</b>   |
| <b>4.2.3.2 Measures to prevent movements of the bowl or mixing machine related to the support of the bowl or mixing machine .....</b>  | <b>14</b>   |
| <b>4.2.3.3 Measures to prevent uncontrolled descent of the support of the bowl or mixing machine....</b>   | <b>15</b>   |
| <b>4.2.4 Safety requirements to prevent overstroke.....</b>  | <b>16</b>   |
| <b>4.2.4.1 Zone 3 – Safety requirements to prevent the bowl support falling down at the end of the upwards stroke .....</b>  | <b>16</b>   |
| <b>4.2.4.2 Zone 4 – Safety requirements to prevent impact or crushing by machine overturning due to the overstroke of the bowl support downwards .....</b>   | <b>16</b>   |
| <b>4.2.5 Zone 5 – Safety requirements to prevent drawing in, shearing, crushing or entanglement by transmission system .....</b>   | <b>16</b>   |
| <b>4.2.5.1 General.....</b>  | <b>16</b>   |
| <b>4.2.5.2 Additional requirements for rope guided lifting systems .....</b>   | <b>17</b>   |
| <b>4.2.6 Zone 6 – Safety requirements to prevent impact or crushing by the falling down of the tipped contents of the bowl or mixing machine .....</b>   | <b>17</b>   |
| <b>4.2.7 Zone 7 – Safety requirements to prevent impact or crushing by introducing into the bowl or extracting from the bowl of the scraper (optional) .....</b>   | <b>18</b>   |
| <b>4.2.7.1 Safety requirements to prevent impact due to the scraper movement.....</b>  | <b>18</b>   |
| <b>4.2.7.2 Safety requirements to prevent crushing between the scraper and the bowl by introducing of the scraper into the bowl .....</b>  | <b>18</b>   |
| <b>4.2.7.3 Safety requirements to prevent crushing between the scraper and the bowl by extracting of the scraper from the bowl.....</b>  | <b>19</b>   |
| <b>4.2.8 Zone 8 – Safety requirements to prevent drawing-in, crushing, entanglement, trapping and shearing by bowl driving mechanism.....</b>  | <b>20</b>   |
| <b>4.2.9 Zone 9 – Safety requirements to prevent impact and crushing between the rotating scraper and its support and other part of the machine .....</b>  | <b>21</b>   |
| <b>4.2.10 Zone 10 – Safety requirements to prevent crushing, shearing, impact due to loss of stability of the machine .....</b>  | <b>23</b>   |
| <b>4.2.10.1 Mechanical strength and stability.....</b>   | <b>23</b>   |
| <b>4.2.10.2 Overload tests.....</b>  | <b>23</b>   |
| <b>4.3 Safety requirements to prevent electrical hazards .....</b>   | <b>25</b>   |
| <b>4.3.1 Motor enclosures .....</b>  | <b>25</b>   |
| <b>4.3.2 Electrical requirements of controls .....</b>   | <b>25</b>   |

|              |   |           |
|--------------|---|-----------|
| <b>4.4</b>   | <b>Safety requirements for the control system .....</b>   | <b>25</b> |
| <b>4.4.1</b> | <b>Emergency stop .....</b>   | <b>25</b> |
| <b>4.4.2</b> | <b>Safety requirements to prevent automatic start and/or unexpected start and restart ...</b>   | <b>25</b> |
| <b>4.4.3</b> | <b>Safety requirements for machines with remote control .....</b>   | <b>26</b> |
| <b>4.5</b>   | <b>Hygiene requirements .....</b>   | <b>26</b> |
| <b>4.5.1</b> | <b>Food area .....</b>  | <b>26</b> |
| <b>4.5.2</b> | <b>Splash area .....</b>  | <b>27</b> |
| <b>4.5.3</b> | <b>Non-food area.....</b>   | <b>27</b> |
| <b>4.6</b>   | <b>Safety requirements with regard to ergonomic principles.....</b>   | <b>27</b> |
| <b>4.7</b>   | <b>Safety requirements for pneumatic and hydraulic equipment .....</b>  | <b>27</b> |
| <b>5</b>     | <b>Verification of safety and hygiene requirements and/or protective/risk reduction measures.....</b>   | <b>27</b> |
| <b>6</b>     | <b>Information for use.....</b>   | <b>29</b> |
| <b>6.1</b>   | <b>General .....</b>  | <b>29</b> |
| <b>6.2</b>   | <b>Signal and warning devices.....</b>  | <b>29</b> |
| <b>6.3</b>   | <b>Instruction handbook .....</b>   | <b>31</b> |
| <b>6.4</b>   | <b>Marking.....</b>   | <b>33</b> |
|              | <b>Annex A (informative) Description .....</b>  | <b>34</b> |
|              | <b>Annex B (informative) List of significant hazards.....</b>   | <b>36</b> |
|              | <b>Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of Directive 2006/42/EC aimed to be covered.....</b> | <b>39</b> |
|              | <b>Bibliography .....</b>   | <b>42</b> |

**EN 13288:2025 (E)****European foreword**

This document (EN 13288:2025) 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 May 2026, and conflicting national standards shall be withdrawn at the latest by May 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 13288:2005+A1:2009.

EN 13288:2025 includes the following significant technical changes with respect to EN 13288:2005+A1:2009:

- normative references were updated;
- new informative annex relating to updated list of significant hazards;
- all safety requirements were updated;
- list of verification was updated;
- Annex ZA was updated regarding 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.

## Introduction

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 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.

**EN 13288:2025 (E)****1 Scope**

**1.1** This document specifies safety and hygiene requirements for the design and manufacture of bowl lifting and tilting machines (see description in Annex A) which:

- a) are intended to be used in bakeries and pastry shops for discharging masses of dough and/or ingredients for bakery and/or pastry products all at once or progressively tipping a container or a machine with non-removable container by lifting and/or tilting it according to a guided path;
- b) are intended to be used with manual inlet and outlet of the bowl.

NOTE b) does not refer to machines with integrated mixing machine with non-removable bowl.

The lifting and tilting machines can be equipped with a scraper (optional) for removing the rests of dough from the bowl after the dough has been discharged.

**1.2** The following relevant hazards are not covered by this document:

- hazards due to the mixing process (for dough mixers see EN 453:2014 and for planetary mixers see EN 454:2014);
- hazards associated to the properties of the content of the bowl (except the mass);
- hazards due to operational stop;
- hazards due to failure of the power supply;
- hazards due to laser radiation;
- hazards due to machinery maintenance;
- hazards due to information and information devices;
- hazards due to materials and products;
- hazards due to lack of design of the machine to facilitate its handling;
- hazards due to lack of stability during transport, assembly and disassembly;
- hazards due to pulleys, drums, wheels, ropes and chains.

This document does not deal with any specific requirements on noise emitted from bowl lifting and tilting machines as the generated noise does not cause a relevant hazard.

The significant hazards covered by this document are described in Annex B.

**1.3** The following machines are excluded from the scope of this document:

- a) experimental and testing machines under development by the manufacturer;
- b) self-propelled movable bowl lifting and tilting machines;
- c) lift trucks;

- d) bowl lifting and tilting machines working in automatic production lines where the initiation of the movement is not due to a human voluntary action;
- e) domestic appliances.

In case of a movable machine, this document does not deal with:

- hazards due to transportation of bowls with the machine;
- hazards due to the displacement of the machine on its own wheels;
- powered equipment that may be provided to assist the mobility of mobile bowl lifting and tilting machine.

When drafting this document, it has been assumed that the machines are not intended to be cleaned with water and steam jets.

**1.4** This document is not applicable to machines which are manufactured before the date of publication of this document.

## 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 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 60204:2016)*

EN 60529:1991, *Degrees of protection provided by enclosures (IP code) (IEC 60529:1989)*

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

EN ISO 7731:2008, *Ergonomics — Danger signals for public and work areas — Auditory danger signals (ISO 7731:2003)*

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

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 13288:2025 (E)**

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 13855:2010, *Safety of machinery — Positioning of safeguards with respect to the approach speeds of parts of the human body (ISO 13855:2010)*

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)*

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