ISO 6909:2026-05 (E)

Machine tools - Safety - Press brakes

Contents

Page

Foreword ..... **v**

Introduction ..... **vi**

1 Scope **1**

2 Normative references **2**

3 Terms and definitions **4**

4 List of significant hazards **14**

5 Safety requirements and/or protective measures **15**

5.1 General 15

5.2 Protection of mechanical hazards 15

5.2.1 Description of the safeguarding of access to moving parts 15

5.2.2 Location of the safeguarding of access to moving parts 27

5.3 Control systems 29

5.3.1 General 29

5.3.2 Manual control devices 29

5.3.3 Failure of power supply 29

5.3.4 Protection against external influences 30

5.3.5 Safety functions 30

5.3.6 Other functions 53

5.3.7 Use of electronic components 54

5.4 Mode of operation 54

5.4.1 Description of the various modes of operation 54

5.4.2 Setting mode 55

5.4.3 Production modes 55

5.5 Consideration of basic design and other mechanical hazards 56

5.5.1 Prevention of unintended gravity fall of the beam (down-stroking press brakes) 56

5.5.2 Stability of the press brake 56

5.5.3 Risk of break up during operation 56

5.5.4 Tool holder and tool design 56

5.5.5 Access to raised work stations or platforms 57

5.5.6 Slips, trips and falls 57

5.5.7 Release of trapped persons 57

5.5.8 Safeguarding of drives, transmission machinery and ancillary devices 57

5.6 Protection against non-mechanical hazard 58

5.6.1 Noise 58

5.6.2 Electrical hazards 58

5.6.3 Ergonomics 58

5.6.4 Hydraulic and pneumatic systems 59

5.6.5 Thermal hazards 60

5.6.6 Hazards generated by materials and substances 60

5.6.7 Hazards generated by lasers 60

5.6.8 High pressure fluid ejection hazards 60

5.6.9 Isolation and energy dissipation 60

5.6.10 Maintenance 60

5.6.11 Errors of fitting 61

6 Verification of the safety requirements and/or protective measures **61**

7 Information for use **65**

7.1 Marking 65

7.1.1 General 65

7.1.2 Content 65
7.2 Instruction handbook 65
7.2.1 General 65
7.2.2 Content 65
Annex A (informative) **Significant hazards, hazardous situations and protective measures** **68**
Annex B (normative) **Calculation of separation distances** **72**
Annex C (normative) **Overall system response time of the press brake stopping performance** **75**
Annex D (informative) **Example of redundant and monitored hydraulic control circuits for a down-stroking press brake** **76**
Annex E (normative) **Noise test code for press brakes** **77**
Annex F (informative) **Side safeguarding for press brakes with manually loaded and/or unloaded** **82**
Annex G (normative) **Markings** **83**
Annex H (normative) **Laser actuated AOPD system tests** **84**
Annex I (informative) **Bending speed** **86**
Annex J (informative) **Press brakes technologies** **88**
Bibliography **89**