

ANSI B11.3 – 2022

an American National Standard –

Safety Requirements for Power Press Brakes



B11 Standards, Inc.
POB 690905
Houston, TX 77269, USA

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by the American National Standards Institute
Board of Standards Review



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Table of Contents		Page
FOREWORD		vii
History		vii
Effective Date		viii
Context (how to read/use this document)		viii
Inquiries		viii
Development		viii
INTRODUCTION		xi
1 Scope		15
1.1 General		15
1.2 Exclusions.....		15
2 Normative references		16
2.1 Informative references		17
3 Definitions		18
4 Responsibilities		24
4.1 Supplier responsibilities		24
4.2 User responsibilities.....		24
4.3 Integrator, modifier or rebuilder responsibilities.....		24
4.4 Personnel responsibilities		25
5 Risk assessment process		26
6 Design, construction, re-construction, and modification		28
6.1 General requirements for all press brakes.....		28
6.1.1 <i>Hazards associated with broken components</i>		28
6.1.2 <i>Tool fastening provisions</i>		28
6.1.3 <i>Opening control space</i>		29
6.1.4 <i>Press brake capacity data plate</i>		29
6.1.5 <i>Pressure rating of components</i>		29
6.1.6 <i>Stored and residual energy</i>		29
6.1.7 <i>Performance of safety function(s)</i>		30
6.1.8 <i>Safe condition monitoring system</i>		30
6.1.9 <i>Presence-Sensing Device Initiation (PSDI)</i>		33
6.2 Electrical controls.....		34
6.2.1 <i>Disconnect means</i>		35
6.2.2 <i>General requirements for stop functions, circuits and actuators</i>		35
6.2.3 <i>Motor start actuator</i>		39
6.2.4 <i>Motor starter</i>		40
6.2.5 <i>Top stop control</i>		40
6.2.6 <i>Return (stop-return) control</i>		40
6.2.7 <i>Voltage</i>		40
6.2.8 <i>Grounds</i>		41
6.2.9 <i>External and line interferences</i>		41
6.3 Requirements for mechanical press brakes		41

6.3.1	Ram counterbalance systems	41
6.3.2	Clutches and brakes	41
6.3.3	Cycle control of mechanically actuated or air operated press brakes	42
6.3.4	Mode control	44
6.3.5	Actuating means	50
6.3.6	Motorized ram adjustment	51
6.4	Requirements for hydraulic press brakes	52
6.4.1	Return (stop-return) control	52
6.4.2	Ram counterbalance system	52
6.4.3	Foot pedal (mechanical)	52
6.4.4	Unintended actuation by foot treadle	53
6.4.5	Mode control for hydraulic press brakes	53
6.4.6	Actuating means	59
6.4.7	Hydraulic components and circuits	60
6.5	Requirements for pneumatic press brakes	63
6.5.1	Return (stop-return) control	63
6.5.2	Ram counterbalance systems	63
6.5.3	Air-controlling equipment	63
6.5.4	Actuating means	63
6.5.5	Pneumatic components and circuits	64
7	Layout, installation, testing and start-up	66
7.1	General	66
7.2	Layout	66
7.3	Installation	67
7.3.1	Floor loading	67
7.3.2	Anchoring	67
7.3.3	Electrical requirements for installation	67
7.3.4	Control of hazardous energy	67
7.3.5	Lighting	68
7.4	Testing and start-up	68
8	Risk reduction	69
8.1	Hazards assoc. with press brake production systems other than point-of-operation hazards	69
8.2	Hazards associated with missing or broken components	70
8.3	Performance of the safety function(s)	70
8.4	Perimeter risk reduction measures	70
8.5	Hazards associated with point of operation	71
8.5.1	Risk reduction measures	71
8.6	Engineering control – guards	72
8.6.1	Design and construction	72
8.6.2	Installation and operation	74
8.7	Point of operation engineering control – devices	76
8.7.1	Movable barrier devices	77
8.7.2	Presence-sensing device	79
8.7.3	Pull-back device	83
8.7.4	Hold-out (restraint) device	84
8.7.5	Two-hand control device	84
8.7.6	Single control devices	86
8.7.7	Close proximity point of operation AOPDs	86
8.8	Slow speed risk reduction	90
8.9	Safe-distance risk reduction	91

8.10	Auxiliary safety aids	92
8.11	Span of control.....	93
	8.11.1 <i>Layout analysis</i>	93
	8.11.2 <i>Level of safety performance</i>	94
	8.11.3 <i>Identification</i>	95
9	Set up, operation and maintenance	95
9.1	General	95
9.2	Machine set-up procedures	95
	9.2.1 <i>Die set-up procedures</i>	96
9.3	Operation	100
	9.3.1 <i>Observations</i>	100
9.4	Maintenance	102
	9.4.1 <i>General</i>	102
	9.4.2 <i>Maintenance inspections</i>	103
9.5	Supervision	104
9.6	Control of hazardous energy	105
9.7	Initiation of normal operations.....	105
9.8	Safety signs	105
9.9	Personal protective equipment (PPE).....	105
10	Training	106
10.1	General	106
10.2	Training elements	106
	10.2.1 <i>Training programs</i>	107
10.3	Operator training	108
10.4	Maintenance personnel training.....	108
10.5	Supervisor training	109
10.6	Retraining.....	109
11	Decommissioning process	109
11.1	Supplier responsibilities	109
11.2	User responsibilities	109
11.3	Modifier responsibilities.....	110
11.4	Decommissioning task.....	110
11.5	Control of hazardous energy	110
11.6	Layout	111
12	Additional requirements for PSDI operation	111
12.1	General	111
12.2	Whole body access.....	111
12.3	Multiple operators	111
12.4	Presence-sensing device used for PSDI	111
12.5	Supplemental engineering controls	112
12.6	Hand tools.....	112
12.7	Inspection and maintenance.....	112
12.8	Operator training.....	113

Annex A – Figures.....	114
Annex B – Task / Hazard Identification	125
Annex C – Performance of the safety function(s)	127
Annex D – Example Manual Test Proc. for Close Proximity POO AOPDs	128
Annex E – Checklist.....	129
ANNEX F – Example Die Setting Procedure	130
Annex G – Automatic Backgage Hazards	134
Annex H – General guidelines for operator training	135

FOREWORD

(This Foreword is not a normative part of American National Standard B11.3-2022)

The primary objective of this standard is to eliminate, control or reduce hazards to individuals associated with power press brakes by establishing requirements for the design, construction, operation and maintenance of these machines. To accomplish this objective, responsibilities have been assigned to the various entities such as the supplier (manufacturer), modifier, rebuilder, integrator, the user, and individuals in the working environment.

The words "safe" and "safety" are not absolutes. Safety is an attitude. While the goal of this standard is to eliminate injuries, it is recognized that risk factors cannot be practically reduced to zero in any human activity. This standard is not intended to replace good judgment and personal responsibility. Operator skill, attitude, training, job monotony, fatigue and experience are safety factors that must be considered by the user.

Power press brake technology is continuously evolving. This standard reflects the most commonly used and time-tested state of the art at the time of its approval. The inclusion or omission of language relative to any evolving technology, either in the requirements or explanatory area of this standard, in no way infers acceptance or rejection of such technologies.

History

The B11 standards for machine safety were first approved beginning with safety requirements for power presses in 1922. Since that time, safety requirements for a variety of machines have been developed and continually updated and revised to become a series of some three dozen B11 standards and technical reports. Maintaining these documents with consistent language proved a significant challenge. In 2008 ANSI B11-GSR (*General Safety Requirements*), was published with the long-term objective to reorganize the B11 series of standards by gathering the requirements common to many or most of the B11 standards into a single document while retaining the machinery specific requirements in the machine-specific standards. It was revised, re-designated and published as ANSI B11.0 in 2012. This ANSI B11.3 type-C standard is intended to be used with ANSI B11.0 type-A and ANSI B11.19 type-B standards. The requirements of all three standards must be met as applicable to a particular machine.

The original ANSI B11.3 standard was approved in 1973 and revised in 1982, in 2002 and again in 2012. In the 2002 document, powered folding machines were included in the scope of the standard because they were predominantly similar to press brakes in that they are metal bending machines and the fact they were not covered by any other standard. During the 2012 revision process, the subcommittee determined that powered folding machines have evolved into multi-axis machines that process metal in numerous ways, many of which are unlike a press brake. Additionally, there was then a type-A standard, ANSI B11.0, which can be used in conjunction with the type-B standard, ANSI B11.19 to provide guidance for the safe use of machines in general. It is for these reasons that the subcommittee decided to exclude powered folding machines in the scope of the 2012 edition of ANSI B11.3.

New topics included in the 2012 revision of ANSI B11.3 were the "close proximity point of operation AOPD" engineering controls – devices, a risk reduction measure called "Safe Speed" and a new clause 10 and Annex I on training was added.

The 2022 edition of ANSI B11.3 is more of a "cosmetic" than "substantively technical" revision of the previous (2012) edition; while the entire document has been scrutinized to ensure it is up-to-date with current technology and state-of-the-art, the bulk of changes fall within in the category of harmonization and alignment with concepts contained in the latest editions of the type-A standard ANSI B11.0 (Safety of Machinery) and the type-B standard ANSI B11.19 (Risk Reduction Measures). These efforts include terminology changes, a listing of which terms affected can be found at the end of [clause 3](#).

Effective Date

The following information on effective dates is informative guidance only, and not a normative part of this standard. This Subcommittee recognizes that some period of time after the approval date on the title page of this document is necessary for suppliers and users to develop new designs or modify existing designs or manufacturing processes in order to incorporate the new or revised requirements of this standard into their product development or production system.

This Subcommittee recommends that suppliers complete and implement design changes for new machines and machinery systems within 30 months of the approval date of this standard.

The Subcommittee recommends that users evaluating whether existing machinery and machinery systems implement this edition within 30 months of the approval date of this standard using generally recognized risk assessment methods. If the risk assessment shows that modification(s) is necessary, refer to the requirements of this standard or the machine-specific “base” safety standard to implement risk reduction measures (protective measures) for appropriate risk reduction.

Context (how to read/use this document)

The writers of this document understand that the reader/user of this American National Standard is unlikely to read it cover-to-cover but instead (for example), might use the Table of Contents as a sort of ‘roadmap’ to find a specific topic and then review only that topic. However, the reader/user of this standard is informed that the elements (clauses, subclauses, etc.) of these documents are sequenced and often interrelated in such a way as to state requirements that may very well be dependent on text in a section(s) that precedes the actual requirement. It therefore becomes vital and important for the reader/user of this standard to ensure they understand the depth, range and especially the context of the section(s) in which the actual requirement appears.

Inquiries

Suggestions for improvement to the content of this standard are welcomed. Similarly, any inquiries with respect to the application of the substantive requirements of this standard are to be sent to B11 Standards, Inc., PO Box 690905, Houston, Texas 77269-0905, USA. Attention: B11 Secretariat.

Development

This current 2022 standard was revised by the B11.3 Subcommittee, processed and administered by the Secretariat, and approved by the B11 Standards Development Committee (B11SDC) for submittal to the ANSI Board of Standards Review for approval as an American National Standard. B11 SDC approval of this standard does not necessarily imply that all committee members voted for its approval. At the time this standard was approved as an American National Standard, the ANSI B11 SDC was composed of the following member organizations:

Alan Metelsky, FS Eng., **Chair** / Anne Mathias, PE, **Vice-Chair** / David Felinski, **Secretary**

Organizations Represented

Aluminum Extruders Council
 American Society of Safety Professionals
 Association for Advancing Automation
 Association for Manufacturing Technology
 Association for Packaging & Processing Technology
 The Boeing Company
 Bridgestone
 Canadian Standards Association
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Safe-T-Sense	Michael Poynter, FS Eng	Federico Badano
SICK, Inc.	Chris Soranno, FS Exp	Nate Gose, FS Eng
Sheet Metal & Air Cond. Contractors Nat'l. Assoc.	Justin Crandol, CSP	Rick Di Ioli
Toyota Motor Manufacturing North America	Chip Boertlein	Michael Collier, B11 LMSS

The B11.3 Subcommittee which revised the 2012 standard, had the following members:

Name	Company
James V. Kirton, Co-Chairman	Kirton Industrial Equipment, LLC
Christopher Soranno, Co-Chairman	Omron STI
David A. Felinski, Secretary	B11 Standards, Inc.
Rob Appleyard	LazerSafe, Pty
Doug Boyer	Advanced Manufacturing Solutions
Roy Brown	SMACNA
Dennis Cloutier	Cloutier Consulting, LLC
Howard DeWees	SICK, Inc.
Lutz Fiessler	Fiessler Elektronik GmbH
Rob Hamilton	Trumpf, Inc.
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Scott Ottens	Amada America
Ted Sberna	Applied Engineering Concepts
Jim Van Kessel	JVK Industrial Automation, Inc.
Walter Veugen	Veugen Integrated Technologies, Ltd.
Scott Whittington	Cincinnati Incorporated

Since the last revision of B11.3, the format/style and even some content elements within the ANSI B11 series have evolved. This current revision has maintained many of those same safety requirements and in several instances, updated requirements while updating the format of the standard to the modern B11 standards structure. Additionally, the ANSI B11 series of standards now incorporates the integration of a stratified approach using “types” of standards (i.e., type-A, type-B and type-C standards – see a more detailed explanation of this approach in the Introduction). ANSI B11.3 is considered a type-C standard and is intended to be used (at a minimum) in conjunction with the type-A ANSI B11.0 and type-B ANSI B11.19 (see the B11 documents list on page xi).

The Subcommittee which developed the standardized elements to the B11 series as well as updating this current edition of B11.3 had the following members:

Jim Kirton, Co-Chair, Kirton Industrial Equipment LLC	Heinz Knackstedt, Machine Control Safety Training
Chris Soranno, Co-Chair, FS Exp, SICK, Inc.	Bruce Main, PE, CSP, design safety engineering, inc.
Mike Douglas, General Motors	Ted Sberna, Sr., White Horse Safety
Chris Felinski, Secretary, B11 Standards, Inc.	Mike Taubitz, FDR Safety
David Felinski, Secretariat, B11 Standards, Inc.	

Explanation of the format, and ANSI B11 conventions

This standard uses a two-column format to provide supporting information for requirements. The text in the left column is confined to “Standards Requirements” and is so captioned. The right-hand column, captioned “Explanatory Information” contains information that the writing Subcommittee believed would help to clarify the requirements contained in the standard. This column should not be construed as being a part of the requirements of this American National Standard. Operating rules (safe practices) are not included in either column of this standard unless they are of such nature as to be vital safety requirements, equal in weight to other requirements, or guides to assist in compliance with the standard.

As in all American National Standards, the term “SHALL” denotes a requirement that is to be strictly followed in order to conform to this standard; no deviation is permitted. The term “SHOULD” denotes a recommendation, a practice or condition among several alternatives, or a preferred method or course of action.

Generally speaking, the term “CAN” denotes a possibility, ability or capability, whether physical or causal, and the term “MAY” denotes a permissible course of action within the limits of the standard, however, the terms can often be used interchangeably.

B11 conventions:

Normative inter-document or intra-document references are denoted by “See #.##.” Informative inter-document or intra-document references are denoted by “See also, #.##.”

The use of “hard” conversion between metric and English units does not imply a tolerance requirement.

Operating rules (safe practices) are not included in either column of this standard unless they are of such nature as to be vital safety requirements, equal in weight to other requirements, or guides to assist in conformance with the standard.

The ANSI B11 standards generally use the term “OR” as an inclusive disjunction, meaning *one or the other or both*, but on occasion will use the term “and/or” to emphasize the fact that both are fully intended in cases where the Subcommittee believed it was imperative to make that clear.

A distinction between the terms “*individual*” and “*personnel*” is drawn. Individual includes personnel (employees, subcontractors, consultants, or other contract workers under the indirect control of the supplier or user) but also encompasses persons who are not under the direct or indirect

INTRODUCTION

The main purpose of every machine tool is to process materials. Inadvertent interference with, or accidental misdirection of the released energy during production, maintenance, commissioning and de-commissioning can result in injury.

The purpose of the ANSI B11 series of machinery safety standards is to devise and propose ways to eliminate or minimize risks of the potential hazards associated with the required tasks. This can be accomplished either by an appropriate machine design or by restricting personnel or other individuals' access to hazard zones, and by devising work procedures to minimize personnel exposure to hazardous situations. This is the essence of the ANSI B11 series of safety standards. This standard recognizes that zero risk does not exist and cannot be attained. However, a good faith approach to risk assessment and risk reduction should achieve an acceptable risk level.

Organization and Application of B11 Documents

The B11 standards and technical reports can be associated with the ISO “type A-B-C” structure as described immediately below, and as shown in Figure 1.

- **Type-A standards** (basis standards) give basic concepts, principles for design, and general aspects that can be applied to machinery;
- **Type-B standards** (generic safety standards) deal with one or more safety aspects or one or more types of engineering controls that can be used across a wide range of machinery;
- **Type-C standards** (machinery safety standards) deal with detailed safety requirements for a particular machine or group of machines.

The B11.0 standard on general safety requirements common to ANSI B11 machines is primarily a “type -A” standard in that it applies to a broad array of machines and contains very general requirements. However, in many areas it also contains very specific requirements. B11.19, B11.20, B11.21, B11.25, B11.26, as well as the entire B11 series of Technical Reports are all typical “Type-B” documents addressing general safety elements that can be used across a wide range of machinery (such as B11.19 and B11.26) or as a standard when combining machines (B11.20). The B11 series of Technical Reports are informative documents that may be generally applied to many different machines, and as such would fall into the “type-B” category. The machine-specific (“type-C”) B11 standards contain detailed safety requirements for a particular machine or group of machines (such as this standard). The type-A B11.0 and the type-C (machine-specific) B11 standards are intended to be used concurrently by the supplier and user of machines. When a type-C standard deviates from one or more provisions dealt with by this standard or by a type-B standard, the type-C standard requirement generally takes precedence. Any deviation in conforming to a requirement of any standard should be carefully evaluated and based on a documented risk assessment.

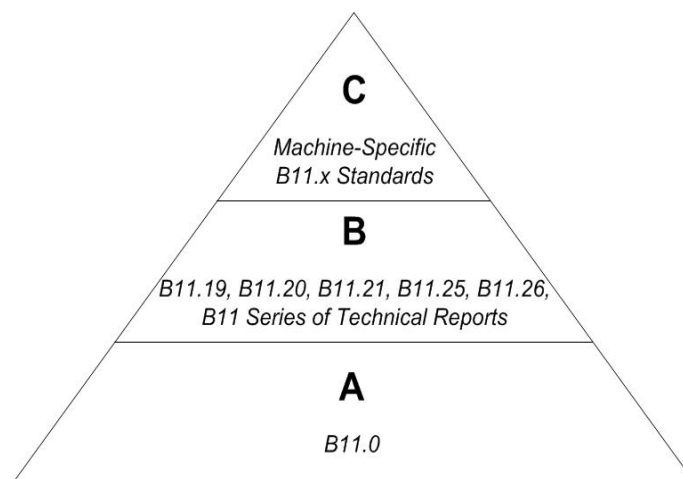


Figure 1 — Organization of the B11 Series of Documents

An overview of each clause of this standard as shown in Figure 2 is provided below.

- 1) Scope – Provides the boundaries or limits of the standard (i.e., what is/is not included).
- 2) Normative references – Other standards which in whole or in part provide additional requirements when referenced in the normative text (i.e., left-hand column of clauses 4 – 9) of this standard.
- 3) Definitions – Terms used in this standard, together with their definitions (terms used in the same context as are generally understood and commonly used in everyday English are not defined).
- 4) Responsibilities – The general responsibilities of the supplier (builder), user, modifier and the user personnel are listed in [clause 4](#) together with the remaining clauses for which they have primary responsibility.
- 5) Risk assessment process – [Clause 5](#) presents the general approach to risk assessment (see B11.0 for further explanation of hazard/task identification and risk assessment/risk reduction).
- 6) Design and construction – It is assumed that the supplier of new equipment to the user will be responsible for the requirements of [clause 6](#), understanding that the user may add to or modify these requirements through the purchase agreement. For existing machinery, the user is generally responsible for the requirements of [clause 6](#).
- 7) Layout, installation, testing and start-up – Although the requirements of [clause 7](#) are predominantly the responsibility of the user, the supplier will normally provide assistance either directly (providing personnel) or indirectly (instruction materials).
- 8) Risk reduction measures – This is normally a shared responsibility but often, either the supplier or the user will provide and/or meet the requirements of [clause 8](#).
- 9) Set-up, operation and maintenance – The user is normally responsible for the requirements of [clause 9](#) with possible assistance from the supplier for training.
- 10) Training – The user is normally responsible for the requirements of [clause 10](#) with possible assistance from the supplier for materials or the training itself.
- 11) Decommissioning – This is primarily a user responsibility, however, the supplier shares responsibility for taking this aspect into consideration during the design.
- 12) Presence-sensing device initiation – This clause contains additional requirements (beyond those of 6.1.9) for the use of PSDI.

Notes for Column Headings in Figure 2:

SUPPLIER: The early stages of a project present the greatest opportunity to determine project requirements and to anticipate and eliminate hazards and hazardous situations.

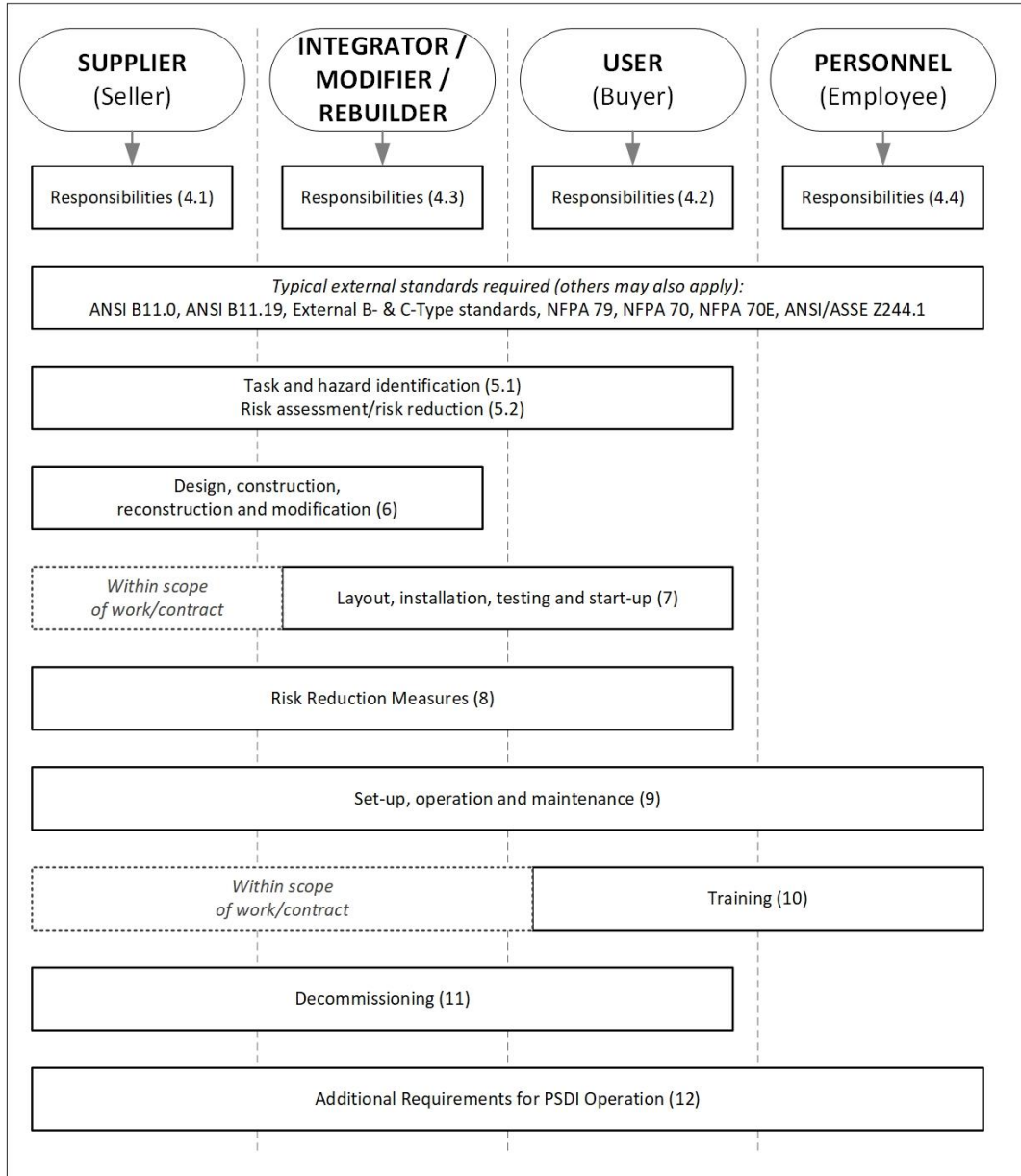
MODIFIER: The entity (OEM, Supplier, or the expert) in that discipline responsible for creating or modifying the system, machinery or equipment, should have all relevant design standards documentation. The entity should begin by working with the end user to list all tasks to achieve an appropriate comprehensive task list base of the “context of use” for the system, machine or equipment.

USER: The company representatives (can be from many disciplines) where the system, machinery or equipment will reside during its productive life. They should engage in participating or reviewing the risk assessment and what will be necessary for a final safety buy-off at the final location.

PERSONNEL: The group “at risk” from any hazards or hazardous situation presented by the system, machinery, or equipment while performing their tasks to achieve the company’s desired productive life. This would include at a minimum, operators, maintenance personnel for both planned and unplanned maintenance, housekeeping and safety representatives. This group would evaluate the engineering controls, complementary measures and administrative controls (see ANSI B11.19).

Figure 2 provides an overview of this standard and in particular the responsibilities of and requirements for the supplier, modifier, user, and the user personnel. Numbers in parentheses denote the particular clause or subclause of the standard.

Figure 2 – Typical clause layout of B11 base standards showing the various responsibilities



As of the date of approval of this standard, the ANSI B11 series of American National Standards and Technical Reports on machinery safety consisted of the following documents shown in the list below. The user should check a licensed reseller such as ANSI (www.ansi.org) for the current versions of any of these documents. All archival / historical versions of the documents are available at www.b11standards.org.

List of the ANSI B11 Series of Safety Standards and Technical Reports

#	SHORT TITLE / TOPIC	YEAR	TYPE
B11.0	Safety of Machinery	2020	A
B11.1	Mechanical Power Presses	2009 (R20)	C
B11.2	Hydraulic & Pneumatic Power Presses	2013	C
B11.3	Power Press Brakes	2022	C
B11.4	Shears	2003 (R20)	C
B11.5	Ironworkers	1988 (R20)	C
B11.6	Manual Turning Machines w/ or without Auto Control	2001 (R20)	C
B11.7	Cold Headers and Cold Formers	2020	C
B11.8	Manual Milling, Drilling, & Boring Machines	2022	C
B11.9	Grinding Machines	2010 (R20)	C
B11.10	Sawing Machines	2003 (R20)	C
B11.11	Gear and Spline Cutting Machines	2001 (R12)	C
B11.12	Roll Forming and Roll Bending Machines	2005 (R20)	C
B11.13	Single & Multiple-Spindle Automatic Bar and Chucking Machines	2020	C
B11.14	<i>Withdrawn</i> (Coil Slitting Machines; combined into B11.18)	(1996)	C
B11.15	Bar, Pipe, Tube and Shape Bending Machines	2022	C
B11.16	Powder / Metal Compacting Presses	2014 (R20)	C
B11.17	Horizontal Hydraulic Extrusion Presses	2004 (R20)	C
B11.18	Machines Processing or Slitting Coiled or Non-Coiled Metal	2006 (R20)	C
B11.19	Performance Requirements for Risk Reduction Measures (Safeguarding)	2019	B
B11.20	Integration of Machinery into a System	2017	B
B11.21	Machine Tools Using Lasers for Processing Materials	2006 (R20)	B
B11.22	Turning Centers and Automatic Numerically Controlled Turning Machines	2002 (R20)	C
B11.23	Machining Centers & CNC Milling, Drilling & Boring Machines	2002 (R20)	C
B11.24	Transfer Machines	2002 (R20)	C
B11.25	Large Machines	2015 (R20)	B
B11.26	Functional Safety for Equipment / Machine Control Systems	2018	B
B11.27	Electro-Discharge Machines	2020	C
B11.TR1	Ergonomics	2016	B
B11.TR2	Metal Working Fluids	1997 (R16)	B
B11.TR3	<i>Withdrawn</i> (Risk Assessment / Risk Reduction Guide)	(2000 R15)	B
B11.TR4	Selection of Programmable Electronic Systems (PES/PLC)	2004 (R15)	B
B11.TR5	Noise Measurement	2006	B
B11.TR6	<i>Withdrawn</i> (Safety Control Systems for Machines)	(2010)	B
B11.TR7	Integration of Lean and Safety	2007 (R17)	B
B11.TR8	Guide to Inspection of Risk Reduction Measures	2022	B
B11.TR9	Cybersecurity	2019	B
B11.TR10	Guidance on Artificial Intelligence into Machinery Safety Applications	2020	B
ANSI/ISO 12100	Safety of machinery (identical adoption of ISO 12100-2010)	2012	A



STANDARD REQUIREMENTS

EXPLANATORY INFORMATION

American National Standard – Safety Requirements for Power Press Brakes

(This column is not part of the requirements of this American National Standard for Machines - *Safety Requirements for Power Press Brakes - ANSI B11.3-2022*)

1 Scope

1.1 General

The requirements of this standard apply to those machines classified as power press brakes (hereinafter referred to simply as “press brakes”), which are designed and constructed for the specific purpose of bending material.

Where used in this standard, the terms *machine* or *machine system* refer to the press brake or press brake production system, respectively.

1.2 Exclusions

Excluded from the requirements of this standard are the following:

- Manual apron brakes;
- Folding machines;
- Hand brakes;
- Hydraulic or pneumatic power presses;

E1.1

To achieve this purpose, the press brake is provided with a plate-type ram and a plate-type bed with standard provisions for attaching standardized press brake tooling.

When used for operations other than bending material, other standards may provide additional information and requirements for the specific use or application.

E1.2

These exclusions exempt machines that normally do not have the characteristics of power press brakes, or are addressed by specific standards. If a machine is not addressed by a specific B11 standard, see ANSI B11.0 for guidance on general safety / risk assessment, and ANSI B11.19 for guidance on risk reduction measures.

- An apron brake uses a clamping bar and several removable blocks which may be removed and rearranged to permit bending of restricted areas of a piece of sheet material or of already partially formed pieces. These machines are also called ‘box-and-pan brake.’
- A folding machine typically uses a clamping beam and a folding beam to fold the workpiece. These machines are also called a ‘powered folding machine’ or ‘bending brake.’
- A hand brake bends material by using a hinged clamping bar to hold the metal down against the bed. A hinged bending “leaf” is manually lifted to fold the metal around the fulcrum point of the clamping bar to the desired angle. These machines are also called ‘leaf brake.’
- A hydraulically or pneumatically powered machine which transmits force using fluid power (hydraulic or pneumatic) to