TEST REPORT
EN 60204-1
Safety of machinery - Electrical equipment of machines
Part 1: General requirements

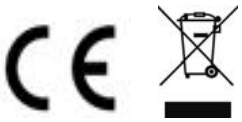
Report reference No...... :	HS202412259129-1ER
Date of issue .....:	2024-12-25
Testing Laboratory.....:	Shenzhen Huasheng Testing Technology Co., Ltd. Room1004, NO.8, Chongqing Road, Qiaotou Community, Fuhai Street, Bao'an District, Shenzhen, Guangdong, China
Applicant's name.....:	Fonland (Wuhan) Optoelectronics Technology Co., Ltd.
Address.....:	Room 04-40, 3rd Floor, Building 3, Gezhouba Sun City, No. 40, Gaoxin 4th Road, Fozuling Street, Donghu New Technology Development Zone, Wuhan City, Hubei Province (Wuhan Area of Free Trade Zone)
Test specification:	
Standard.....:	EN ISO 12100:2010 EN 60204-1:2018
Test procedure.....:	CE-MD
Non-standard test method……..:	N/A
Test Report Form No.....:	IEC60204_1A
Test Report Form(s) Originator.....:	Electrosuisse
Master TRF.....:	Dated 2009-11

Test item description.....:	laser cutting machine
Trade Mark.....:	RUBY
Manufacturer.....:	Fonland (Wuhan) Optoelectronics Technology Co., Ltd.
Address.....:	Room 04-40, 3rd Floor, Building 3, Gezhouba Sun City, No. 40, Gaoxin 4th Road, Fozuling Street, Donghu New Technology Development Zone, Wuhan City, Hubei Province (Wuhan Area of Free Trade Zone)
Model/Type reference.....:	RUBY RUBY3020,RUBY4040,RUBY4060,RUBY6090,RUBY1390, RUBY7050,RUBY1080,RUBY1310,RUBY1325,RUBY1410, RUBY1610,RUBY1810,RUBY1515,RUBY1520,RUBY1530
Ratings.....:	Input:AC 220V,15A,50Hz Output:AC 220V,10A,2200W

Responsible Testing Laboratory (as applicable), testing procedure and testing location(s):			
☒	**Testing Laboratory:**	Shenzhen Huasheng Test Technology Co., Ltd.	
Testing location/ address.....:		Room1004, NO.8, Chongqing Road, Qiaotou Community, Fuhai Street, Bao'an District, Shenzhen, Guangdong, China	
☒	**Associated Testing Laboratory:**		
Testing location/ address.....:			
Tested by (name, function, signature).....:		Rock Ren	Rock.Ren
Approved by (name, function, signature)...:		Snow Wu	Snow Wu
☐	**Testing procedure: TMP/CTF Stage 1:**		
Testing location/ address.....:			
Tested by (name, function, signature).....:			
Approved by (name, function, signature)...:			
☐	**Testing procedure: WMT/CTF Stage 2:**		
Testing location/ address.....:			
Tested by (name + signature).....:			
Witnessed by (name, function, signature)..:			
Approved by (name, function, signature)...:			
☐	**Testing procedure: SMT/CTF Stage 3 or 4:**		
Testing location/ address.....:			
Tested by (name, function, signature).....:			
Witnessed by (name, function, signature)..:			
Approved by (name, function, signature)...:			
Supervised by (name, function, signature) :			

Copy of marking plate

laser cutting machine
Model:RUBY
Input:Input:AC 220V,15A,50Hz
Output:AC 220V,10A,2200W



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Test item particulars..... :	
Classification of installation and use.....:	laser cutting machine
Supply Connection.....:	/
Possible test case verdicts:	
- test case does not apply to the test object..... :	N/A
- test object does meet the requirement..... :	P
- test object does not meet the requirement.....:	Fail

General remarks:

The test results presented in this report relate only to the object tested.
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"(See Enclosure #)" refers to additional information appended to the report.
"(See appended table)" refers to a table appended to the report.

Throughout this report a ~~comma (~~point~~)~~ is used as the decimal separator.
- Determination of the test result includes consideration of measurement uncertainty from the test equipment and methods;
- The related applicable OSM decisions have been considered and the requirements found fulfilled.

General product information:
N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
4	**GENERAL REQUIREMENTS**		**P**
4.1	General		P
	Hazards relevant to the electrical equipment are assessed as part of the overall risk assessment of the machine.		P
4.2	Selection of equipment		P
4.2.1	Electrical components/devices suitable for their intended use and applied in accordance with supplier's instructions.		P
4.2.2	Where possible electrical equipment in compliance with the IEC 60439 series.		N/A
4.3	Electrical supply		P
4.3.1	Electrical equipment to be designed for correct operation within the conditions of mains power supply - as stated below (cl. 4.3.2 or 4.3.3)		P
	or as stated by the user (record specs in this TR)		N/A
	or as stated by the supplier[1]		N/A
4.3.2	AC supplies		P
	Supply Voltage: Steady state voltage: 0,9 ... 1,1 of nominal voltage		P
	Frequency: 0,99 ... 1,01 of nominal frequency continuously; 0,98 ... 1,02 short time.		P
	Harmonics: not exceeding 10 % of the total r.m.s. etc.		P
	Voltage unbalance: not exceeding 2% deviation.		P
	Voltage interruption: interrupted or at zero voltage for not more than 3 ms at any random time in the supply cycle with more than 1 s between successive interruptions.		P
	Voltage dips not exceeding 20 % of the peak voltage of the supply for more than one cycle with more than 1 s between successive dips.		P
4.3.3	DC supplies		N/A
	Supply Voltage: - other:0,85 to 1,15 of nominal voltage; - battery-operated vehicles: 0,7 to 1,2 of nom. volt. - from converting equipment: 0,9 to 1,1 of nom. volt.		N/A
	Voltage interruption: - other: not exceeding 5 ms - converting equipment: not exceeding 20 ms		N/A

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Clause	Requirement - Test	Result - Remark	Verdict
	Ripple (peak-to-peak): not exceed. 0,15 of nom. volt.		N/A
4.3.4	Special supply systems; e.g. on board generators limits acc. 4.3.2 /.3 exceeded, but equipment designed acc. exceeded limits.		N/A
4.4	Physical environment and operating conditions		P
4.4.1	Electrical equipment suitable for the physical environment and operating conditions of its intended use.		P
4.4.2	Electromagnetic compatibility (EMC): Equipment shall not generate electromagnetic disturbances above levels that are appropriate for its intended operating environment and shall have a level of immunity to electromagnetic disturbances so that it can function in its intended environment (IEC 61000-6-1 or IEC 61000-6-2 and CISPR 61000-6-3 or IEC 61000-6-4 give general EMC emission and immunity limits.) Are there sufficient measures to limit the generation of electromagnetic disturbances, i.e. conducted and radiated provided? (E.g. power supply filtering; cable shielding; enclosures designed to minimize RF radiation; RF suppression techniques; design of functional bonding system, using conductors with low RF impedance and as short as practicable.		P
4.4.3	Electrical equipment shall be capable of operating correctly in the intended ambient air temperature. (Minimum requirement: air temperatures of +5 °C and +40 °C)		P
4.4.4	Electrical equipment shall be capable of operating correctly when the relative humidity is up to 50 % at a maximum temperature of +40 °C		P
4.4.5	Electrical equipment shall be capable of operating correctly at altitudes up to 1 000 m above mean sea level.		P
4.4.6	Electrical equipment shall be adequately protected against the ingress of solids and liquids (see 11.3)		P
4.4.7	Electrical equipment shall withstand ionizing and non-ionizing radiation.		P
4.4.8	Electrical equipment shall withstand vibration, shock and bump.		P
4.5	Electrical equipment designed to withstand the effects of transportation and storage within a temperature range of - 25 to + 55 °C.		P
4.6	Heavy or bulky electrical equipment of the machine provided with suitable means for handling.		N/A

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Clause	Requirement - Test	Result - Remark	Verdict
4.7	Electrical equipment is installed and operated in accordance with the supplier's instruction.		P
5	**INCOMING SUPPLY CONDUCTOR TERMINATIONS AND DEVICES FOR DISCONNECTING AND SWITCHING OFF**		**P**
5.1	Incoming supply conductor terminal		N/A
5.1	Electrical equipment of a machine connected to one single power supply (For large complex machinery comprising a number of widely-spaced machines working together in a coordinated manner, there can be a need for more than one incoming supply depending upon the site supply arrangements)		P
	Power supply conductors terminated to main disconnecting device of electrical equipment (unless a plug is provided for disconnection)		P
	Neutral conductor clearly indicated in technical documentation with "N" (see cl. 16.1)		P
	No connection between neutral conductor and protective bonding circuit nor combined PEN-terminals. Exception: a connection may be made between the neutral terminal and the PE terminal at the point of the connection of the power supply to the machine for TN-C systems.		P
	All terminals of incoming supply clearly marked in ac. with cl. 16.1 (symbols acc. to EN 60445)		P
5.2	Terminal for connection to external protective earthing system		P
	For each incoming supply, a terminal shall be provided in the vicinity of the associated phase conductor terminals for connection of the machine to the external protective earthing system or to the external protective conductor, depending upon the supply distribution system.		P
	Cross section of incoming PE conductor acc. to cl. 5.2, table 1. (Where an external protective conductor of a material other than copper is used, the terminal size shall be selected accordingly. See also 8.2.2).		P
	Protective earth identified either by graphic symbol, letters "PE", or bicolour combination GREEN / YELLOW		P
5.3	Supply disconnecting device		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
5.3.1	A supply disconnecting device shall be provided: – for each incoming source of supply to a machine – for each on-board power supply.		P
5.3.2	Type of power supply disconnecting device:		—
	a) Switch-disconnector, acc. to EN 60947-3 for appliance category AC-23 B or DC-23 B		N/A
	b) Disconnector with or without fuses, with aux. contact (acc. to EN 60947-3		N/A
	c) Power circuit breaker suitable for isolation (acc. to EN 60947-2)		N/A
	d) any other switching device in accordance with an IEC product standard for that device and which meets the isolation requirements of IEC 60947-1as well as a utilization category		P
	e) Plug/socket combination for electrical load (requirements see cl. 5.3.3)		N/A
5.3.3	Disconnection device has to fulfil all of the following requirements		—
	- isolate the electrical equipment from the supply and have only one OFF (isolated) and only one ON position marked with "O" and "I"		P
	- visible contact gap or a position indicator which cannot indicate OFF (isolated) until all contacts are actually open and the requirements for the isolating function have been satisfied		P
	- have an external operating means e.g.a handle (except power operated CB's)		P
	- coloured black or grey recommended (If used as an emergency stop, red/yellow combination selected)		P
	- be provided with a means permitting it to be locked in the OFF position (padlocks). When so locked, remote as well as local closing shall be prevented		P
	- disconnect all live conductors of its power supply circuit (For TN supply systems, the neutral conductor may or may not be disconnected except in countries where disconnection of the neutral conductor (when used) is compulsory.)		N/A
	Requirements for plug/socket combination as a disconnection device: - Breaking capacity of the plug/socket combination: sufficient to interrupt the current of the largest motor when stalled together with the sum of the normal running currents of all other motors and/or loads. - further see. cl. 13.4.5 a) to f)		N/A

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Clause	Requirement - Test	Result - Remark	Verdict
5.3.4	The operating means are easily accessible and located between 0,6 m and 1,9 m above the servicing level.		P
5.3.5	Only the following circuits need not be disconnected by the supply disconnecting device: - lighting circuits for lighting needed during maintenance or repair; – plug and socket outlets for the exclusive connection of repair or maintenance tools and equipment; – under voltage protection circuits that are only provided for automatic tripping in the event of supply failure; – circuits supplying equipment that should normally remain energized for correct operation – control circuits for interlocking Such circuits are provided with their own disconnecting device.		P
	Circuits not disconnected by the supply disconnecting device have: - permanent warning labels in accordance with cl. 16.1		N/A
	- a statement is included in the maintenance manual		N/A
	- additionally one or more of the following is applied; - a permanent warning label in accordance with 16.1 is affixed in proximity to each excepted circuit, or - the circuit is separated from other circuits, or - the conductors are identified by colour taking into account the recommendation of Cl.13.2.4.		N/A
5.4	Disconnecting devices to prevent of unexpected start-up:		—
	- Devices for the prevention of unexpected start-up are provided These devices are appropriate and convenient for the intended use, are suitably placed, and readily identifiable as to their function and purpose (for example by a durable marking in accordance with cl. 16.1).		P
	- Means are provided to prevent inadvertent and/or mistaken closure of these devices either at the controller or from other locations		P
	- Devices that do not fulfil the isolation function (e.g. a contactor switched off by a control circuit) are only used for situations that include: – inspections; – adjustments; – no hazardous work on the electrical equipment (for example replacement of plug-in devices without disturbing existing wiring)		P

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Clause	Requirement - Test	Result - Remark	Verdict
5.5	Devices for disconnecting electrical equipment		—
	- Requirements to devices for disconnecting electrical equipment to enable work to be carried out when it is de-energised and isolated: – appropriate and convenient for the intended use; – suitably placed; – readily identifiable as to which part or circuit of the equipment is served (for example by durable marking in accordance with 16.1 where necessary). - Additional means are provided to prevent of inadvertent and/or mistaken closure of these devices either at the controller or from other locations		P
	- Where it is necessary to work on individual parts of the electrical equipment of a machine, or on one of a number of machines fed by a common conductor bar, conductor wire or inductive power supply system, a disconnecting device is provided for each part, or for each machine, requiring separate isolation. In addition to the mentioned supply disconnecting device, the following devices that fulfil the isolation function may be provided for this purpose: – devices described in 5.3.2; – disconnectors, withdrawable fuse links and withdrawable links only if located in an electrical operating area (see 3.15) and relevant information is provided with the electrical equipment (see 17.2 b)9) and b)12)).		P
5.6	Protection against unauthorized, inadvertent and/or mistaken connection		—
	For devices acc. to cl. 5.4(disconnecting electrical equipment) and 5.5 (prevention of unexpected start-up) locking means in OFF position are provided and no remote reconnection is possible.		N/A
	Where a non-lockable disconnecting device is provided (for example withdrawable fuse-links, withdrawable links), other means of protection against unintended energising are used.		N/A
	Where plug/socket combinations according to 5.3.2 e) are used for the purpose of prevention of unexpected start-up the are so positioned that they can be kept under the immediate supervision of the person carrying out the work.		N/A
6	**PROTECTION AGAINST ELECTRIC SHOCK**		**P**
6.2.2	Protection against direct contact		—

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Live parts that are located inside enclosures have to bee conform to the relevant requirements of Clauses 4, 11, and 14 and have to have a protection against direct contact of at least IP2X or IPXXB.		P
	Where the top surfaces of the enclosure are readily accessible, the minimum degree of protection against direct contact provided by the top surfaces shall be IP4X or IPXXD.		P
6.2.2 a	Opening an enclosure (i.e. opening doors, lids, covers, and the like) is possible only when: a) Either the use of a key or tool is necessary for access and: - all live parts, that are likely to be touched when resetting or adjusting devices intended for such operations while the equipment is still connected are protected against direct contact to at least IP2X or IPXXB - live parts on the inside of doors are protected against direct contact to at least IP1X or IPXXA.		P

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Clause	Requirement - Test	Result - Remark	Verdict
6.2.2 b	b) Or the opening of an enclosure (i.e. opening doors, lids, covers, and the like) is possible only if disconnection is provided for all live parts inside the enclosure before it can be opened. Exception: If a special device or tool (intended for use only by skilled or instructed persons) as prescribed by the supplier is provided that can be used to defeat the interlock and that intends that: - it is possible at all times while the interlock is defeated to open the disconnecting device and lock the disconnecting device in the OFF position or otherwise prevent unauthorised closure of the disconnecting device; - upon closing the door, the interlock is automatically restored - all live parts, that are likely to be touched when resetting or adjusting devices intended for such operations while the equipment is still connected are protected against direct contact to at least IP2X or IPXXB - live parts on the inside of doors shall be protected against direct contact to at least IP1X or IPXXA - relevant information is provided with the electrical equipment like instructions on the procedures for securing the machine for safe maintenance and information on the residual risks. - means are provided to restrict access to live parts behind doors not directly interlocked with the disconnecting means to skilled or instructed persons. - parts still alive after switching off are protected at least IP 2X or IP XXB and marked with a warning sign in accordance with 16.2.1  Excepted from this marking are: - parts that can be live only because of connection to interlocking circuits and that are distinguished by colour as potentially live in accordance with 13.2.4 - the supply terminals of the supply disconnecting device when the latter is mounted alone in a separate enclosure.		N/A
6.2.2 c	c) Or the opening without the use of a key or a tool and without disconnection of live parts shall be possible only when all live parts are protected against direct contact to at least IP2X or IPXXB. Where barriers provide this protection, either they shall require a tool for their removal or all live parts protected by them shall be automatically disconnected when the barrier is removed.		N/A
6.2.3	Protection by insulation of live parts:		—

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Live parts are completely covered with insulation that can only be removed by destruction and that is capable of withstanding the mechanical, chemical, electrical, and thermal stresses to which it can be subjected under normal operating conditions.		P
	Paint, varnish lacquer etc. not used as the unique insulation layer.		P
6.2.4	Protection against residual voltages		—
	Live parts with residual voltage greater than 60 V after a time period of 5 s after disconnection of the supply shall be discharged until this interferes with the proper functioning of the equipment. Except are components with charges of ≤ 60 µC (→ equivalent to capacitor with less then 1µF @ 60V).		N/A
	Where pins of plugs or similar devices after withdrawal are exposed, discharge time is ≤ 1s. Otherwise such conductors are protected against direct contact to at least IP2X or IPXXB.		N/A
	If above requirements cannot be achieved, additional disconnecting devices or appropriate warning devices shall be applied (e.g. warning acc. cl. 16.1).		N/A
6.2.5	For protection by barriers, 412.2 of IEC 60364-4-41 is applied.		N/A
6.2.6	For protection by placing out of reach, 412.4 of IEC 60364-4-41 shall apply. For protection by obstacles, 412.3 of IEC 60364-4-41 is applied.		N/A
6.3	Protection against indirect contact		P
6.3.2	Prevention of the occurrence of a touch voltage		—
6.3.2.2	Protection by provision of: - class II electrical devices or apparatus (double insulation, reinforced insulation or by equivalent insulation in accordance with IEC 61140) or - switchgear and control gear assemblies having total insulation in accordance with IEC 60439-1or - supplementary or reinforced insulation in accordance with 413.2 of IEC 60364-4-41.		P
6.3.2.3	Protection by electrical separation. For this type of protection, the requirements of 413.5 of IEC 60364-4-41 apply.		P
6.3.3	Protection by automatic disconnection of supply.		

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EN 60204-1			
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6.3.3 a)	Use of overcurrent protective device for automatic cut-off in the event of an insulation failure in a TN-System. Where disconnection within the time specified in Clause A.1 cannot be assured, supplementary bonding is provided as necessary to meet the requirements of Clause A.3.		P
6.3.3 b)	Use of residual current protective devices (RCD) for automatic cut-off in the event of an insulation failure in a TN - or TT -System.		N/A
6.3.3 c)	Use of earth fault detection device to initiate automatic disconnection in a IT-System.		N/A
6.4	Protection by the use of PELV		N/A
6.4.1 a)	PELV circuits shall satisfy all of the following conditions: -the nominal voltage does not exceed: • 25 V a.c. r.m.s. or 60 V ripple-free d.c. when the equipment is normally used in dry locations and when large area contact of live parts with the human body is not expected; or • 6 V a.c. r.m.s. or 15 V ripple-free d.c. in all other cases;		N/A
6.4.1 b)	one side of the circuit or one point of the source of the supply of that circuit is connected to the protective bonding circuit;		N/A
6.4.1 c)	live parts of PELV circuits is electrically separated from other live circuits		N/A
6.4.1 d)	Conductors of each PELV circuit are physically separated from those of any other circuit. If this requirement is impracticable, the insulation provisions of 13.1.3 are fulfilled;		N/A
6.4.1 e)	plugs and socket-outlets for a PELV circuit are conform to the following: 1) plugs do not to enter socket-outlets of other voltage systems; 2) socket-outlets do not admit plugs of other voltage systems.		N/A
6.4.2	Sources for PELV		—
	The source for PELV shall be one of the following: - safety isolating transformer in accordance with IEC 61558-1 and IEC 61558-2-6 or - a source of current with a degree of safety equivalent to that of the safety isolating transformer or - an source independent of circuit with higher voltage - electronic power supply conforming to appropriate standards		N/A

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EN 60204-1			
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6.1	Other measures from IEC 60364-4-41 are used. (Description!)		N/A
7.	**PROTECTION OF EQUIPMENT**		**P**
7.2.	Overcurrent protection Unless otherwise specified by the user, the supplier of the electrical equipment is not responsible for providing the overcurrent protective device for the supply conductors to the electrical equipment (see Annex B).		P
7.2.2.	On the installation diagram data necessary for selecting the overcurrent protective device are stated for each incoming feeder. (see 7.2.10 and 17.4)		P
7.2.3	Power circuits:		—
	Devices for detection and interruption of overcurrent, selected in accordance with 7.2.10, are applied to each live conductor. And, none of the following conductors, as applicable, is disconnected without disconnecting all associated live conductors: – the neutral conductor of a.c. power circuits; – the earthed conductor of d.c. power circuits; – d.c. power conductors bonded to exposed conductive parts of mobile machines.		P
	Cross section area of neutral conductor is at least equal to the phase conductor. No overcurrent protective/ disconnecting device is required. (For a neutral conductor with a cross sectional area smaller than that of the associated phase conductors, the measures detailed in 524 of IEC 60364-5-52 shall apply.)		P
	IT-Systems:, no neutral conductor is used. Or, when it is used, the measures detailed in 431.2.2 of IEC 60364-4-43 are applied.		N/A
7.2.4	Control circuits		—
	Conductors of control circuits directly connected to the supply voltage and of circuits supplying control circuit transformers are protected against overcurrent in accordance with 7.2.3.		P
	Conductors of control circuits supplied by a control circuit transformer or d.c. supply: see 9.4.3.1		—
7.2.5	Socket outlets and their associated conductors		—
	Overcurrent protection is provided for the circuits feeding the general purpose socket.		N/A
7.2.6	Lighting circuits		—

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Clause	Requirement - Test	Result - Remark	Verdict
	Lighting circuits are protected separate from other circuits.		N/A
7.2.7	Transformers		—
	Transformers are protected in accordance with the manufacturer's instructions and includes: - avoiding tripping due to transformer magnetizing inrush currents - avoiding a winding temperature rise in excess of the permitted value for the insulation class when there is a short circuit at the secondary terminals. - type and setting of the overcurrent protective device in accordance with the recommendations of the transformer supplier.		N/A
7.2.8	Location of overcurrent protective devices:		—
	- located at the point where a reduction in the cross sectional area of the conductors or another change reduces the current-carrying capacity of the conductors.		P
	Exceptions: - current carrying capacity of the conductors is at least equal to that of the load and - conductors between the point of reduction of current-carrying capacity and the position of the overcurrent protective device is ≤ 3 m and - the conductor is protected e.g. by an enclosure or duct.		P
7.2.9	Selection of overcurrent protective devices		—
	The rated short-circuit breaking capacity Icn is at least equal to the prospective fault current at the point of installation. Additional currents other than from the supply (e.g. from motors, from power factor correction capacitors) shall be taken into consideration.		P
	Reduced breaking capacity is permitted, where another protective device is installed at supply side with the necessary breaking capacity. (In that case, the characteristics of the two devices shall be co-ordinated so that the let-through energy (I^2t) of the two devices in series does not exceed that which can be withstood without damage to the overcurrent protective device on the load side and to the conductors protected by that device. See Annex A of IEC 60947-2).		P
	Where fuses are provided as overcurrent protective devices, a type readily available in the country of use shall be selected, or arrangements shall be made for the supply of spare parts.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
7.2.10	Rating and setting of overcurrent protective devices:		—
	Rated current of fuses or overcurrent setting of other protective devices selected as low as possible, but adequate for anticipated overcurrents.		P
	The rated current of overcurrent protective device is determined by the current carrying capacity of the conductors to be protected in accordance with Cl. 12.4, D.2 and the maximum allowable interrupting time *t* in accordance with Clause D.3, taking into account the needs of coordination with other electrical devices in the protected circuit.		P
7.3	Protection of motors against overheating		P
7.3.1	Overload protection for all motors provided for ratings of > 0.5 kW in continuous operation.		P
	Protective device may be omitted for motors, which cannot be overloaded.		P
	Exceptions: In applications where an automatic interruption of the motor operation is unacceptable (for example fire pumps), the means of detection shall give a warning signal to which the operator can respond.		N/A
7.3.2	Protection achieved by overload protection device: - detection in each live conductor - switching off of all live conductors (not necessary to switch of neutral conductor)		P
	For special duty motors, appropriate protective devices are recommended		N/A
7.3.3	Protection achieved by over-temperature protection device: Is recommended in situations where the cooling can be impaired (for example dusty environments)		N/A
7.3.4	Protection achieved by current limiting protection: Where protection against the effects of overheating in three phase motors is achieved by current limitation, the number of current limitation devices may be reduced from 3 to 2.		N/A
7.4	Abnormal temperature protection: Resistance heating or other circuits that are capable of attaining or causing abnormal temperatures and can cause a hazardous situation are provided with suitable detection to initiate an appropriate control response.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
7.5	Protection against supply interruption or voltage reduction and subsequent restoration: Where a supply interruption or a voltage reduction can cause a hazardous situation, damage to the machine, or to the work in progress, undervoltage protection is provided.		N/A
	Upon restoration of supply voltage, automatic or unexpected restarting of machine prevented.		P
	Undervoltage protection does initiate appropriate control responses to ensure necessary coordination of groups of machines working together		N/A
7.6	Motor overspeed protection: Overspeed protection is provided where overspeeding can occur and could possibly cause a hazardous situation.		P
7.8	Phase sequence protection: Where an incorrect phase sequence of the supply voltage can cause a hazardous situation or damage to the machine, protection shall be provided.		N/A
7.9	Protection against overvoltage due to lightning and to switching surges: - Devices are connected to the incoming terminals of the supply disconnecting device.		N/A
8	**EQUIPOTENTIAL BONDING**		**P**
8.2	Protective bonding circuit		P
8.2.1	Where the conductance of structural parts of the electrical equipment or of the machine is less than that of the smallest protective conductor connected to the exposed conductive parts, a supplementary bonding conductor is provided.		P
	In IT distribution systems, the machine structure is part of the protective bonding circuit and insulation monitoring is provided.		N/A
	Exposed conductive parts of equipment in accordance with 6.3.2.3 (Protection by electrical separation) are not connected to the protective bonding circuit. (For this type of protection, the requirements of 413.5 of IEC 60364-4-41 apply.)		N/A
8.2.2	Protective conductors		—
	Protective conductors shall be identified in accordance with 13.2.2.		P
	Copper conductors are preferred.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Where other material is used, its electrical resistance per unit length shall not exceed that of the allowable copper conductor and such conductors shall be not less than 16 mm^2 in cross-sectional area.		N/A
	The cross-sectional area of protective conductors shall be determined in accordance with the requirements of: –543 of IEC 60364-5-54; or –7.4.3.1.7 of IEC 60439-1, as appropriate. This requirement is met in most cases if it is in accordance with Table 1 of this standard (see 5.2).		P
8.2.3	Continuity of the protective bonding circuit		
	All exposed conductive parts are connected to the protective bonding circuit in accordance with 8.2.1. Parts that are mounted so that they do not constitute a hazard because cannot be touched on large surfaces or grasped with the hand and they are small in size (less than approximately 50 mm × 50 mm) or they are located so that either contact with live parts, or an insulation failure is unlikely need not be connected to the protective bonding circuit		P
	Where a part is removed the protective bonding circuit for the remaining parts isn't interrupted.		P
	Current-carrying capacity of connection and bonding points cannot impaired by mechanical, chemical, or electrochemical influences (e.g. electrolytic corrosion on aluminium parts)		P
	Metal ducts of flexible or rigid construction and metallic cable sheaths are not used as protective conductors. Nevertheless they are connected to the protective bonding circuit.		P
	Where the electrical equipment is mounted on lids, doors, or cover plates, continuity of the protective bonding circuit shall be ensured. The use of a protective conductor (see 8.2.2) is recommended.		N/A
	For cables that are exposed to damage (for example flexible trailing cables) the continuity of the protective conductors are ensured by appropriate measures (for example monitoring).		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
8.2.4	No means of interruption of the protective bonding conductor are provided. Exception: links for test or measurement purposes that cannot be opened without the use of a tool and that are located in an enclosed electrical operating area.		P
	As well the protective bonding circuit does not incorporate a switching device or an over current protective device (for example switch, fuse).		P
	Removable current collectors, plug/socket combinations or withdrawable plug-in units: The protective bonding circuit is interrupted by a first make last break contact. (see also 13.4.5)		N/A
8.2.6	Protective conductor connecting points: have no other function and are not intended to attach or connect appliances or parts.		P
	Each protective conductor connecting point is marked or labelled as such using the symbol IEC 60417-5019 or the letters PE or by use of bicolour GREEN / YELLOW		P
8.2.7	Mobile machines with on-board power supplies: The protective bonding system is connected to a single protective bonding terminal. This protective bonding terminal is the connection point for a possible additional external incoming power supply.		N/A
8.2.8	Electrical equipment having earth leakage currents higher than 10 mA a.c. or d.c.: Additional protective bonding requirements: - Cross section of protective conductor ≥ 10 mm^2 CU or 16 mm^2 AL - OR Second protective conductor of at least the same cross sectional area if above cross section is impracticable - OR monitoring of continuity of protective conductor with automatic disconnection function.		N/A
	Additionally a warning label is provided adjacent to the PE terminal.		N/A

9	**CONTROL CIRCUITS AND CONTROL FUNCTIONS**	**P**
9.1.	Control circuit	N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
9.1.1	Control circuit supply: Control transformers mandatory only when more then one motor starter or two control devices are used.		N/A
	Control transformers with separate windings are used for supplying the control circuits.		N/A
	Where several transformers are used, the secondary voltages are in phase.		N/A
	Separate windings on transformer for DC supplies connected to PE.		N/A
	Switch-mode units fitted with transformers in accordance with IEC 61558-2-17		N/A
9.1.2	The nominal voltage of control supply does not exceed 277 V when supplied from a transformer.		N/A
9.1.3	Control circuits are provided with overcurrent protection in accordance with 7.2.4 and 7.2.10.		N/A
9.2.	Control functions		N/A
	Safety related control functions in accordance with ISO 13849-1 (2006), ISO 13849-2 (2003) and /or IEC 62061 (see 9.4.1)		—
9.2.1	Start functions operating by energizing the relevant circuit (see 9.2.5.2).		N/A
9.2.3	Operating modes		—
	Suitable means are prevented for unauthorized or inadvertent mode selection if hazardous situations can result.		N/A
	Mode selection by itself does not initiate machine operation. A separate actuation of the start control has to be stated by the operator.		N/A
	Indication of the selected operating mode is provided (e.g. the position of a mode selector, the provision of an indicating light, a visual display indication).		N/A
9.2.4	Where it is necessary to suspend safety functions and/or protective measures (for example for setting or maintenance purposes), protection is ensured.		N/A
9.2.5	Operation		—
	Prevention of movement of the machine in an unintended or unexpected manner is taken after any stopping of the machine. (e.g. due to locked-off condition, power supply fault, battery replacement, lost signal condition with cableless control)		N/A
	When a machine has more than one control station, measures are provided to ensure that initiation of commands from different control stations do not lead to a hazardous situation.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
9.2.5.2	Start of an operation is possible only when all of the relevant safety functions and/or protective measures are in place and are operational.		P
	Where safety functions and/or protective measures cannot be applied for certain operations, manual control of such operations are by hold-to-run controls, together with enabling devices, as appropriate.		N/A
	In the case of machines requiring the use of more than one control station to initiate a start, each of these control stations shall have a separate manually actuated start control device. The conditions to initiate a start are: - all required conditions for machine operation are met - and all start control devices are in the released (off) position - then all start control devices have to be actuated concurrently (see 3.6).		P
9.2.5.3	Stop category 0 and/or stop category 1 and/or stop category 2 stop functions are provided as indicated by the risk assessment and the functional requirements of the machine (see 4.1).		N/A
	Stop functions override related start functions		N/A
	Facilities to connect protective devices and interlocks are provided, where required. If such a protective device or interlock causes a stop of the machine, it may be necessary for that condition to be signalled to the logic of the control system. The reset of the stop function does not initiate any hazardous situation.		N/A
	Where more than one control station is provided, stop commands from any control station is effective when required by the risk assessment of the machine.		N/A
9.2.5.4	Emergency operations (emergency stop, emergency switching off)		—
	Emergency stop or emergency switching off commands are sustained until it is reset.		P
	This reset is possible only by a manual action at that location where the command has been initiated.		P
	The reset of the command does not restart the machinery but only permit restarting.		N/A
	It is not be possible to restart the machinery until all emergency stop commands are reset.		N/A
	It is not be possible to reenergize the machinery until all emergency switching off commands are reset.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
9.2.5.4.2	The emergency stop does function either as a stop category 0 or as a stop category 1.		P
	- it overrides all other functions and operations in all modes;		P
9.2.5.4.3	Emergency switching off is provided where: -Protection against direct contact is achieved only by placing out of reach or by obstacles (see 6.2.6) - or there is the possibility of other hazards or damage caused by electricity.		N/A
	Emergency switching off is accomplished by electromechanical switching devices, effecting a stop category 0 of machine actuators connected to this incoming supply.		N/A
9.2.5.5	Movement or action that can result in a hazardous situation are monitored by providing, for example, overtravel limiters, motor overspeed detection, mechanical overload detection or anti-collision devices.		N/A
9.2.6	Other control functions		—
9.2.6.2	No type 1 two-hand control device is used for the initiation of hazardous operation. It need type 2 or type 3 two-hand control devices for such operations.		N/A
9.2.6.3	Enabling control: Enabling control are arranged in the way to minimize the possibility of defeating, e. g. by requiring the de-activation of the enabling control device before machine operation may be reinitiated. It is not possible to defeat the enabling function by simple means.		P
9.2.6.4	Combined start and stop controls: Push-buttons etc. that alternately initiate and stop motion are provided only for functions, which cannot result in a hazardous situation.		N/A
9.2.7	Cableless control station		N/A
9.2.7.1	Means shall be provided to readily remove or disconnect the power supply of the operator control station (see also 9.2.7.3).		N/A
	Means (for example key operated switch, access code) are provided, as necessary, to prevent unauthorized use of the operator control station.		N/A
	Each operator control station carries an unambiguous indication of which machine(s) is (are) intended to be controlled by that operator control station.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
9.2.7.2	Measures shall be taken to ensure that control commands: – affect only the intended machine; – affect only the intended functions.		N/A
	Measures are taken to prevent the machine from responding to signals other than those from the intended operator control station(s).		N/A
	Where necessary, means are provided so that the machine can only be controlled from operator control stations in one or more predetermined zones or locations.		N/A
9.2.7.3	Operator control stations include a separate and clearly identifiable means to initiate the stop function of the machine or of all the operations that can cause a hazardous situation. The actuating means to initiate this stop function are not marked or labelled as an emergency stop device, even though the stop function initiated on the machine can fulfil an emergency stop function.		N/A
	Stopping of the machine and preventing a potentially hazardous operation is automatically initiated in the following situations: – when a stop signal is received; – when a fault is detected in the cableless control system; – when a valid signal (which includes a signal that communication is established and maintained) has not been detected within a specified period of time (see Annex B), except when a machine is executing a pre-programmed task taking it outside the range of the cableless control where no hazardous situation can occur.		N/A
9.2.7.4	Machines having more than one operator control station, including one or more cableless control stations, have measures provided to ensure that only one of the control stations can be enabled at a given time.		N/A
	An indication of which operator control station is in control of the machine is provided at suitable locations as determined by the risk assessment of the machine. Exception: a stop command from any one of the control stations are effective when required by the risk assessment of the machine.		N/A
9.2.7.5	Battery-powered cableless operator control stations: A variation in the battery voltage does not cause a hazardous situation.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	A clear warning is given to the operator when a variation in battery voltage exceeds specified limits.		N/A
	Under those circumstances, the cableless operator control station remains functional long enough for the operator to put the machine into a non- hazardous situation.		N/A
9.3	Protective interlocks		N/A
9.3.1	The reclosing or resetting of an interlocking safeguard does not initiate hazardous machine operation.		N/A
9.3.2	Where overtraveling an operating limit (for example speed, pressure, position) can lead to a hazardous situation, means are provided to detect when a predetermined limit(s) is exceeded and initiate an appropriate control action.		N/A
9.3.3	The correct operation of auxiliary functions is checked by appropriate devices.		N/A
	Appropriate interlocking is provided, when non-operation of an auxiliary function (for example lubrication, supply of coolant, swarf removal) can cause a hazardous situation, or cause damage to the machine or to the work in progress.		N/A
9.3.4	Interlocks between different operations and for contrary motions are provided if this operations lead to hazardous situations.		N/A
9.3.5	Reverse current braking: Where braking of a motor is accomplished by current reversal, measures prevent the motor starting in the opposite direction at the end of braking where that reversal can cause a hazardous situation or damage to the machine or to the work in progress.		N/A
	For this purpose, a device operating exclusively as a function of time is not permitted.		N/A
	Control circuits are arranged that rotation of a motor shaft, for example manually, does not result in a hazardous situation.		N/A
9.4	Control functions in the event of failure		P
9.4.1	The safety related electrical control circuits have an appropriate level of safety performance that has been determined from the risk assessment at the machine. The requirements of IEC 62061 and/or ISO 13849-1, ISO 13849-2 are met.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Where memory retention is achieved for example, by battery power, measures are taken to prevent hazardous situations arising from failure or removal of the battery.		N/A
	Means are provided to prevent unauthorized or inadvertent memory alteration by, e.g. requiring the use of a key, access code or tool.		N/A
9.4.2	Measures are taken to minimize risk in the event of failure:		—
9.4.2.1	- Use of proven circuit techniques and components		P
9.4.2.2	- Provisions of partial or complete redundancy		P
9.4.2.3	- Provision of diversity		P
9.4.2.4	- Provision for functional tests		P
9.4.3	Protection against mal-operation due to earth faults, voltage interruptions and loss of circuit continuity		—
9.4.3.1	Earth faults on any control circuit don't cause unintentional starting, potentially hazardous motions, or prevent stopping of the machine. Methods to meet these requirements include but are not limited to the following:		—
	a) 1) Control circuits, fed by control transformers and connected to the protective bonding circuit at the point of supply. (PELV) (see Figure 3 of this standard)		P
	a) 2) Control circuits, fed by control transformers without connection to the protective bonding circuit at the point of supply in the arrangement according to figure 3 and having a device that interrupts the circuit automatically in the event of an earth fault		N/A
	b) Control circuits fed by a control transformer with a centre-tapped winding, this centre tap connected to the protective bonding circuit, arranged as shown in Figure 4 of this standard with the overcurrent protective device having switching elements in all control circuit supply conductors.		N/A
	c) Where the control circuit is not fed from a control transformer and is either: 1) directly connected between the phase conductors of an earthed supply, or; 2) directly connected between the phase conductors or between a phase conductor and a neutral conductor of a supply that is not earthed or is earthed through a high impedance, multpole switch that switch all live conductors are used for those functions that can cause hazardous situations or damage to the machine.		N/A
	Or in case of c) 2), a device is provided that interrupts the circuit automatically in the event of an earth fault.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
9.4.3.2	For control systems using a memory device(s), proper functioning in the event of power failure is ensured (e.g. by using a non-volatile memory) to prevent any loss of memory that can result in a hazardous situation.		N/A
9.4.3.3	Upon sliding contacts the loss of continuity of safety-related control circuits depending on, can result in a hazardous situation. Appropriate measures are taken (for example by duplication of the sliding contacts).		N/A
10	**OPERATOR INTERFACE AND MACHINE-MOUNTED CONTROL DEVICES**		**P**
10.1.1	As far as is practicable, those devices are selected, mounted, and identified or coded in accordance with relevant parts of IEC 61310.		P
10.1.2	As far as is practicable, machine-mounted control devices are: – readily accessible for service and maintenance;		P
	– mounted in such a manner as to minimize the possibility of damage from activities such as material handling.		N/A
	The actuators of hand-operated control devices are selected and installed so that: – they are not less than 0,6 m above the servicing level and		N/A
	– are within easy reach of the normal working position of the operator;		N/A
	– the operator is not placed in a hazardous situation when operating them.		N/A
	The actuators of foot-operated control devices are selected and installed so that: – they are within easy reach of the normal working position of the operator;		N/A
	– the operator is not placed in a hazardous situation when operating them.		N/A
10.1.3	The degree of protection (see IEC 60529) together with other appropriate measures does afford protection against:		P
	– the effects of aggressive liquids, vapours, or gases found in the physical environment or used on the machine;		P
	– the ingress of contaminants (for example swarf, dust, particulate matter).		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	The operator interface control devices has a minimum degree of protection against direct contact of IPXXD (see IEC 60529).		N/A
10.1.4	Position sensors (for example position switches, proximity switches) are so arranged that they will not be damaged in the event of overtravel.		N/A
	Position sensors in circuits with safety-related control functions shall have direct opening action (see IEC 60947-5-1) or shall provide similar reliability (see 9.4.2).		N/A
10.1.5	Portable and pendant operator control stations and their control devices are so selected and arranged as to minimize the possibility of inadvertent machine operations caused by shocks and vibrations		P
10.2	Push-buttons		P
10.2.1	Mandatory: The colour RED is used only for emergency stop and emergency switching off actuators.		P
	The recommend colours of push-buttons are as shown in table 2 of this standard.		P
10.2.2	The recommend markings on push-buttons are as shown in table 3 of this standard.		P
10.3	Indicator lights and displays		P
10.3.1	Indicator lights and displays are selected and installed in such a manner as to be visible from the normal position of the operator (see also IEC 61310-1).		P
	Indicator light circuits used for warning lights are fitted with facilities to check the operability of these lights.		P
	The recommend colours on Indicator light are as shown in table 4 of this standard.		P
	Indicating towers on machines have the applicable colours in the following order from the top down; RED, YELLOW, BLUE, GREEN and WHITE.		P
	Where flashing lights or displays are used to provide higher priority information, audible warning devices should also be provided.		P
10.4	illuminated push-button actuators are colour-coded in accordance with Tables 2 and 4. Where there is difficulty in assigning an appropriate colour, WHITE is used.		N/A
	The colour RED for the emergency stop actuator shall not depend on the illumination of its light.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
10.5	Devices having a rotational member, such as potentiometers and selector switches, have means of prevention of rotation of the stationary member. Friction alone isn't considered sufficient.		P
10.6	Actuators used to initiate a start function or the movement of machine elements (for example slides, spindles, carriers) are constructed and mounted so as to minimize inadvertent operation.		P
	However, mushroom-type actuators are used for two-hand control only. (see also ISO 13851).		N/A
10.7	Emergency stop devices		P
10.7.1	Devices for emergency stop are readily accessible.		P
	They are located at each operator control station and at other locations where the initiation of an emergency stop can be required (exception: see 9.2.7.3).		P
	In circumstances where confusion can occur between active and inactive emergency stop devices caused by disabling the operator control station, means (for example, information for use) are provided to minimise confusion.		N/A
10.7.2	Allowed types of device for emergency stop: – a push-button operated switch with a palm or mushroom head type; – a pull-cord operated switch; – a pedal-operated switch without mechanical guard.		P
	The devices are direct opening operation (see IEC 60947-5-1, Annex K).		P
10.7.3	Actuators are coloured RED. If a background exists immediately around the actuator, then this background is coloured YELLOW. See also ISO 13850.		P
10.7.4	The supply disconnecting device may be locally operated to serve the function of emergency stop when: – it is readily accessible to the operator; and – it is of the type described in 5.3.2 a), b), c), or d). When also intended for this use, the supply disconnecting device meets the colours RED/YELLOW.		N/A
10.8	Emergency switing off device		N/A
10.8.1	Means are provided, where necessary, to avoid confusion between these devices.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
10.8.2	The types of device for emergency switching off include: – a push-button operated switch with a palm or mushroom head type of actuator; – a pull-cord operated switch. The devices are direct opening action (see IEC 60947-5-1, Annex K). The push-button operated switch may be in a break-glass enclosure.		N/A
10.8.3	Actuators are coloured RED. If a background exists immediately around the actuator, then this background is coloured YELLOW. See also ISO 13850.		N/A
10.8.4	Where the supply disconnecting device is to be locally operated for emergency switching off, it is be readily accessible and meets the colours RED/YELLOW.		N/A
10.9	Enabling control device		N/A
	An enabling control device as a part of a system, does allow operation when actuated in one position only. In any other position, operation is stopped or prevented.		N/A
	Functions of two-position types: position 1: off-function of the switch (actuator is not operated); position 2: enabling function (actuator is operated)		N/A
	Functions of three-position types: position 1: off-function of the switch (actuator is not operated); position 2: enabling function (actuator is operated in its mid position); position 3: off-function (actuator is operated past its mid position); when returning from position 3 to position 2, the enabling function is not activated.		N/A
11	**CONTROLGEAR: LOCATION, MOUNTING AND ENCLOSURES**		**P**
11.2.1	All items of controlgear (inclusively terminals that are not part of controlgear components or devices) are placed and oriented so that they can be identified without moving them or the wiring.		P
	For items that require checking for correct operation or that are liable to need replacement, those actions should be possible without dismantling other equipment or parts of the machine (except opening doors or removing covers, barriers or obstacles).		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	All controlgear are mounted so as to facilitate its operation and maintenance from the front.		P
	Necessary tools to adjust, maintain, or remove a device are supplied.		P
	Where access is required for regular maintenance or adjustment, the relevant devices shall be located between 0,4 m and 2,0 m above the servicing level.		P
	Terminals are least 0,2 m above the servicing level and so placed that conductors and cables can be easily connected to them.		P
	Only operating, indicating, measuring, and cooling devices are mounted on doors or on normally removable access covers of enclosures.		P
	Plug-in arrangements of control devices and plug-in-devices:		—
	The connection is clearly identified by shape, marking or reference designation, singly or in combination.		N/A
	When they have to bee handled during normal operation means are provided with non-interchangeable features where the lack of such a facility can result in malfunctioning.		N/A
	Plug/socket combinations that are handled during normal operation are unobstructedly accessible.		N/A
	Test points for connection of test equipment are: – unobstructedly accessible; – clearly identified to correspond with the documentation; – adequately insulated; – sufficiently spaced.		N/A
11.2.2	Non-electrical parts and devices, not directly associated with the electrical equipment, are not located within enclosures containing controlgear.		P
	Devices such as solenoid valves are separated from the other electrical equipment (for example in a separate compartment).		N/A
	Control devices mounted in the same location and connected to the supply voltage, or to both supply and control voltages, are grouped separately from those connected only to the control voltages.		P
	Terminals shall be separated into groups for: – power circuits; – associated control circuits; – other control circuits, fed from external sources (for example for interlocking).		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	The clearances and creepage distances specified by the supplier are maintained, taking into account the external influences or conditions of the physical environment.		P
11.2.3	Heat generating components (for example heat sinks, power resistors) are located so, that the temperature of each component in the vicinity remains within the permitted limit.		P
	Controlgears are sufficiently protected against: - ingress of solid foreign objects - liquids - dust, coolants, and swarf, taking into account the external influences under which the machine is intended to operate (i.e. the location and the physical environmental conditions).		P
	Enclosures of controlgear provide a degree of protection of at least IP22 (see IEC 60529). Exceptions: a) specific electrical operating area b) When with removable collectors on conductor wire or conductor bar systems do not achieve IP22 measures of 6.2.5 are applied.		N/A
11.4	Enclosures, doors and openings		P
	Enclosures (inclusively screens of windows (windows: toughened glass or polycarbonate sheet of not less than 3 mm thickness), joints, gaskets of doors and lids) do withstand the foreseeable mechanical, electrical and thermal stresses and other environmental factors and of the aggressive liquids, vapours, or gases used on the machine.		P
	Fasteners used to secure doors and covers are of the captive type.		N/A
	Enclosure doors are not wider than 0,9 m and have vertical hinges, with an angle of opening > 95°.		N/A
	Openings in enclosures (for example, for cable access), including those towards the floor or foundation or to other parts of the machine are equipped with means to ensure the degree of protection specified for the equipment. A suitable opening may be provided in the base of enclosures within the machine so that moisture due to condensation can drain away.		P
	Openings for cable entries shall be easily re-opened on site.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	No openings between enclosures containing electrical equipment and compartments containing coolant, lubricating or hydraulic fluids, or those into which oil, other liquids, or dust can penetrate.		P
	Holes in an enclosure for mounting do not impair the required protection.		P
	Equipment that, in normal or abnormal operation, can attain a surface temperature sufficient to cause a risk of fire or harmful effect to an enclosure material is: – located within an enclosure that will withstand, such temperatures; and – is located at a sufficient distance from adjacent equipment allowing safe dissipation of heat (see also 11.2.3); or – is otherwise screened by material that can withstand to the harmful effect.		P
11.5	Access to control gear		N/A
	Doors in gangways for access to electrical operating areas: – are at least 0,7 m wide and 2,1 m high; – do open outwards; – have a means (for example panic bolts) to allow opening from the inside without the use of a key or tool.		N/A
	Enclosures which readily allow a person to fully enter are be provided with means to allow escape, e.g. panic bolts on the inside of doors.		N/A
	Enclosures intended for such access, for example for resetting, adjusting, maintenance, shall have a clear width of at least 0,7 m and a clear height of at least 2,1 m When equipment is likely to be live during access with > 1,0m and when on both side with > 1.5m.		N/A
12	**CONDUCTORS AND CABLES**		**P**
	IMPORTANT: The following requirements do not apply to the integral wiring of assemblies, subassemblies, and devices that are manufactured and tested in accordance with their relevant IEC standard (for example IEC 60439-1).		—
12.2	In general, conductors are of copper. Where aluminium conductors are used, the cross-sectional area is at least 16 mm^2.		P
	The cross-sectional areas of conductors are according to Table 5 and its notes.		P
	All conductors that are often in movement (> one movement per hour of machine operation) have flexible stranding of class 5 or class 6.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Where the insulation of conductors and cables (for example PVC) can constitute hazards due to the propagation of a fire or the emission of toxic or corrosive fumes adequate means are provided. Special attention is given to the integrity of a circuit having a safety-related function		P
	Minimum insulation test voltages for used cables are: – ≥ 2 000 V a.c. for a duration of 5 min for operation at voltages higher than 50 V a.c. or 120 V d.c., or – ≥ 500 V a.c. for a duration of 5 min for PELV circuits (see IEC 60364-4-41, class III equipment).		P
	Insulation strong enough to withstand damage due to operation or during laying, especially for cables pulled into ducts.		P
12.4	Current-carrying capacity in normal service in accordance with table 6. Or in accordance with suppliers recommendation.		P
12.6	Flexible cables		P
12.6.1	All flexible cables have Class 5 or Class 6 conductors.		P
	Cables under severe duties are adequately protected against: - abrasion due to mechanical handling and dragging across rough surfaces; - kinking due to operation without guides; - stress resulting from guide rollers and forced guiding, being wound and re-wound on cable drums.		N/A
12.6.2	The tensile stress applied to copper conductors does not exceed 15 N/mm2 of cross-sectional area. Or special measures are taken to withstand the applied stress. For material other than copper the applied stress is within the cable manufacturer’s specification.		N/A
12.6.3	For cables installed on drums, the maximum current-carrying capacity in free air is derated in accordance with Table 7.		N/A
12.7	Conductor wires, conductor bars and slip-ring assemblies		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
12.7.1	During normal access to the machine, protection against direct contact to conductor wires, conductor bars and slip-ring assemblies is achieved by the application of one of the following protective measures: – protection by partial insulation of live parts, or where this is not practicable; – protection by enclosures or barriers of at least IP2X.		N/A
	Horizontal top surfaces of barriers or enclosures that are readily accessible provide a degree of protection of at least IP4X.		N/A
	Where the required degree of protection is not achieved, protection by placing live parts out of reach in combination with emergency switching off in accordance with 9.2.5.4.3 is applied.		N/A
	Conductor wires and conductor bars are so placed / protected as to: – prevent contact with conductive items such as the cords of pull-cord switches, strain-relief devices and drive chains; – prevent damage from a swinging load.		N/A
12.7.2	Protective conductor circuit (PE) and the neutral conductor (N) each use a separate conductor wire, conductor bar or slip-ring.		N/A
	The continuity of the protective conductor circuit using sliding contacts is ensured by taking appropriate measures (for example, duplication of the current collector, continuity monitoring)		N/A
12.7.3	Protective conductor current collectors have a shape or construction so that they are not interchangeable with the other current collectors. Such current collectors shall be of the sliding contact type.		N/A
12.7.4	Removable current collectors (e.g. swivelingable) with disconnector function: The protective conductor circuit interrupts after and reconnects before any live conductor.		N/A
12.7.5	Clearances in air between conductors and adjacent systems are suitable at least a rated impulse voltage of an overvoltage category III in accordance with IEC 60664-1 (For example 4 kV for 230/400 V systems → clearances 3mm)		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
12.7.6	Creepage distances between conductors and adjacent systems are suitable suitable for operation in the intended environment, e.g. open air (IEC 60664-1), inside buildings, protected by enclosures. In abnormally dusty, moist or corrosive environments, the following creepage distance requirements apply: – unprotected conductor etc.: minimum creepage dist. of 60 mm – enclosed conductor etc.: minimum creepage distance of 30 mm		N/A
12.7.7	Conductor system divided into isolated sections: suitable design measures are employed to prevent the energization of adjacent sections by the current collectors themselves.		N/A
12.7.8	Construction of conductor wires etc.: - power circuits are grouped separately from those in control circuits. - do withstand the foreseeable mechanical forces and thermal effects of short-circuit current. - covers can not be opened without the use of a tool - all conductive parts of accompanying enclosures are connected to the protective bonding circuit - underground and underfloor conductor bar ducts have drainage facilities		N/A
13	**WIRING PRACTICES**		**P**
13.1	Connections and routing		P
13.1.1	All connections are secured against accidental loosening.		P
	The means of connection are suitable for the cross-sectional areas and nature of the conductors being terminated.		P
	No connection of two or more conductors to one terminal, unless the terminal is designed for it.		P
	No soldered connections to terminals unless they are suitable for it.		P
	Terminals on terminal blocks are plainly marked or labelled corresponding with the diagrams.		N/A
	Installations of flexible conduits and cables are such that liquids drain away from the fittings.		N/A
	Retaining means for conductor strand and shields provided (no soldering for that purpose)		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Indentification tags legible, permanent, and appropriate for the physical environment.		P
	Terminal blocks mounted and wired so that the internal and external wiring does not cross over the terminals (see IEC 60947-7-1).		N/A
13.1.2	Conductors and cables run from terminal to terminal without splices or joints. Connections using plug/socket combinations with suitable protection against accidental disconnection are not considered to be joints for the purpose of this subclause.		P
	Terminations of cables are adequately supported to prevent mechanical stresses at the terminations of the conductors.		P
	Protective conductor placed close to the associated live conductors in order to decrease the impedance of the loop.		P
13.1.3	Conductors for circuits that operate at different voltages are separated by suitable barriers, or are insulated for the highest voltage that occurs within the same duct.		P
13.2	Connections and routing		N/A
13.2.1	Each conductor is identifiable at each termination in accordance with the technical documentation.		P
13.2.2	The protective conductor has the bicolour combination GREEN-AND-YELLOW Where the protective conductor can be easily identified colour coding throughout its length is not necessary, but the ends or accessible locations are clearly identified by the graphical symbol or by the bicolour combination GREEN-AND-YELLOW.		P
13.2.3	Neutral conductors are identified by the colour LIGHT BLUE. That colour is not used for identifying any other conductor where confusion is possible.		N/A
	Bare conductors used as neutral conductors have at minimum a stripe in LIGHT BLUE 15 mm to 100 mm wide in each compartment or unit and at each accessible location.		N/A
	Identification by colour for other conductors: Colours GREEN or YELLOW are not used. (Details to colour coding see this norm Cl. 13.2.3)		P
13.3	Wiring inside enclosures		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Conductors inside enclosures are supported where necessary. Conductors and cables that do not run in ducts are adequately supported.		P
	Non-metallic supports are made with a flame-retardant insulating material (see IEC 60332 series)		P
	Connections to devices mounted on doors or to other movable parts are using flexible conductors in accordance with 12.2 and 12.6.		P
13.4	Wiring outside enclosures		N/A
13.4.2	Conductors and their connections external to the electrical equipment are placed in suitable ducts (see cl.13.5). Exceptions: - Cables with special suitable protection. - Position switches or proximity switches supplied with a dedicated cable which is sufficiently short.		N/A
	Connections to moving elements of the machine are made of flexible cable in accordance with 12.2 and 12.6.		N/A
	Bending radius of the cable are of at least 10 times the diameter of the cable		N/A
	Cables close to moving parts, maintain a space of at least 25 mm between the moving parts and the cables or barriers are provided.		N/A
	Cable handling systems: Lateral cable angles do not exceeding 5°, at being wound on and off cable drums or approaching and leaving cable guidance devices. The bending radius is in accordance with table 8.		N/A
	Flexible conduit: - is not used for connections to rapidly or frequently moving parts, except when specifically designed for that purpose. - is supported when adjacent to moving parts		N/A
13.4.4	Interconnection of devices on the machine is made through adequate terminals.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
13.4.5	Requirements to plug/socket combinations outside of enclosures: Exceptions: components connected to a bus system by a plug/socket combination a) Prevention for unintentional contact with live parts at any time. At least IPXXB. (PELV circuits are excepted from this requirement.) b) First make last break protective bonding contact if used in TN- or TT-systems. c) Sufficient load-breaking capacity, when intended to be disconnected under running conditions. When rated at ≥ 30 A interlocked with a switching device d) When rated at ≥ 16 A having a retaining means to prevent unintended or accidental disconnection. e) when unintended or accidental disconnection +can cause a hazardous situation, having a retaining means. f) Component remaining live after disconnection having at least IP2X or IPXXB, taking into account the required clearance and creepage distances.(PELV circuits are excepted from this requirement.) g) Metallic housings of plug/socket combinations being connected to the protective bonding circuit. (PELV circuits are excepted from this requirement.) h) Having retaining means to prevent unintended or accidental disconnection and being marked that they are not intended to be disconnected under load. i) Clearly identifiable if more then one plug / socket per device. It is recommended that mechanical coding being used. j) When used in control circuits fulfilling the applicable requirements of IEC 61984. Exception: see item k). k) No plug/socket combinations intended for household and similar general purposes used for control circuits. In plug/socket combinations in accordance with IEC 60309-1, only those contacts shall be used for control circuits which are intended for those purposes. Exception: The requirements of item k) do not apply to control functions using high frequency signals on the power supply.		N/A
13.4.6	Protection of Plug / socket from the physical environment during transportation and storage.		P
13.5	Ducts, connection boxes and other boxes		P
	Provided with a degree of protection suitable for the application.		P

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EN 60204-1			
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	No sharp edges, flash, burrs, rough surfaces, or threads with which the insulation of the conductors can come into contact.		P
	Where human passage is required, least 2 m above the working surface.		N/A
	Not used as connection for protective bonding circuit.		P
	Where cable trays are a.s.o. are only partially covered, the cables used are of a suitable type.		N/A
13.5.2	Filling the percentage of ducts adapted to the straightness and length of the duct and the flexibility of the conductors.		P
13.5.3	Rigid metal conduit and fittings shall galvanized steel or of a corrosion-resistant material		N/A
	Fittings compatible with the conduit.		N/A
	Conduit bends properly made		N/A
13.5.4	Flexible metal tubing or woven wire armour suitable for the expected physical environment.		N/A
13.5.5	Flexible non-metallic conduit resistant to kinking and suitable for the expected physical environment.		N/A
13.5.6	Requirements to cable trunking systems: - Rigidly supported and clear of all moving or contaminating portions of the machine - Covers overlapping the sides and attached.		N/A
13.5.7	The compartments of machine used as cable trunking systems are isolated from coolant or oil reservoirs and are entirely enclosed, and the conductors are secured.		N/A
13.5.8	Connection boxes and other boxes used for wiring: - Are accessible for maintenance. - Provide protection against the ingress of solid bodies and liquids, taking into account the external influences under which the machine is intended to operate (see 11.3). - Do not have unused knockouts etc.		N/A
13.5.9	Motor connection boxes: Encloses only connections to the motor and motor-mounted devices (e.g brakes, temperature sensors)		P

14	**ELECTRIC MOTORS AND ASSOCIATED EQUIPMENT**		P
14.1	Electric motors are conform to the relevant parts of IEC 60034 series.		P
	There protection is conform to the requirements given in 7.2 for overcurrent protection, in 7.3 for overload protection, and in 7.6 for overspeed protection.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Motor control equipment is located and mounted in accordance with Clause 11.		P
14.2	Minimal IP23 protection for all motors. More stringent requirements depending on the application and the physical environment.		P
14.4	Motors incorporated as an integral part of the machine are adequately protected from mechanical damage.		P
	motors and its associated parts (inclusively motor connection box) are easily accessible for inspection and maintenance etc		N/A
	Cooling is ensured and the temperature rise remains within the limits of the insulation class (see IEC 60034-1)		P
	No opening between the motor compartment and any other compartment that does not meet the motor compartment requirements.		P
14.5	The characteristics of motors and associated equipment are selected in accordance with the anticipated service and physical environmental conditions (see 4.4). Detailed criteria see 14.5 of this norm.		P
14.6	Overload and overcurrent protective devices for mechanical brake actuators initiate simultaneously the deenergization (release) of the associated motors.		N/A
15	**ACCESSORIES AND LIGHTING**		N/A
15.1	Requirements for socket-outlets for accessory equipment: – conform to IEC 60309-1 (Where that is not practicable, they are clearly marked with voltage and current ratings); –continuity of the protective bonding circuit to the socket-outlet is ensured, except where protected by PELV; – unearthed conductors connected to the socket-outlet are overcurrent- and if required overload-protected – protection is separately from other circuits; – power supply to the socket-outlet is not disconnected by the supply disconnecting device for the machine or the section of the machine, the requirements of 5.3.5 apply.		N/A

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EN 60204-1			
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15.2.1	Requirements for local lighting of the machine and equipment: - protective bonding circuit in accordance with 8.2.2. - ON/OFF switch incorporated in the lamp-holder or in the flexible connecting cords. - Stroboscopic effects avoided. - Where fixed lighting electromagnetic compatibility is taken into account.		N/A
15.2.2	Requirements to the power supply for local lighting: – Nominal voltage not exceeding 250 V between conductors – isolating transformer connected to the load side of the supply with overcurrent protection in the secondary circuit; or – isolating transformer connected to the line side of the supply disconnecting device with overcurrent protection in the secondary circuit. That source is permitted for maintenance lighting circuits in control enclosures only; or – from a machine circuit with dedicated overcurrent protection; or – from an isolating transformer connected to the line side of the supply disconnecting device, provided with a dedicated primary disconnecting means and secondary overcurrent protection, and mounted within the control enclosure adjacent to the supply disconnecting device; or – from an externally supplied lighting circuit (for example factory lighting supply). This shall be permitted in control enclosures only, and for the machine work light(s) where their total power rating is not more than 3 kW. Exception: Where fixed lighting is out of reach of operators during normal operations, the provisions of this subclause do not apply.		N/A
15.2.3	All unearthed conductors of circuits supplying lighting have their own overcurrent protecting devices.		N/A
15.2.4	Requirements to the fittings for local lighting: – Adjustable lighting fittings are suitable for the physical environment. – lamp holders are in accordance with the relevant IEC standard; – lamp holders are constructed with an insulating material protecting the lamp cap – Reflectors are supported by a bracket and not by the lamp holder. Exception: where fixed lighting is out of reach of operators during normal operation, the provisions of this subclause do not apply.		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict

16	**MARKING, WARNING SIGNS AND REFERENCE DESIGNATIONS**		**P**
16.1	Warning signs, nameplates, markings, and identification plates are of sufficient durability to withstand the physical environment.		P
16.2.1	Enclosures that do not clearly show that they contain electrical equipment that has a risk of electric shock are marked with the graphical symbol  plainly visible on the enclosure door or cover. Exception: – enclosure equipped with a supply disconnecting device; – operator-machine interface or control station; – a single device with its own enclosure (for example position sensor).		P
16.2.2	Hazardous hot surfaces of the electrical equipment, are equipped with the graphical warning symbol 		P
16.2.3	Control devices, visual indicators, and displays are clearly and durably marked to their functions.		P
16.2.4	Equipment (e.g. controlgear assemblies) is legibly and durably marked. A nameplate is attached to the enclosure adjacent to each incoming supply with: – name or trade mark of supplier; – certification mark, when required; – serial number, where applicable; – rated voltage, number of phases and frequency (if a.c.), – full-load current for each supply; – short-circuit rating of the equipment; – main document number (see IEC 62023).		P
16.2.5	All enclosures, assemblies, control devices, and components are plainly identified with the same reference designation as shown in the technical documentation.		P

17	**TECHNICAL DOCUMENTATION**		**P**
17.1	Documentation in agreed language provided.		P

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EN 60204-1			
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17.2	Information provided with the electrical equipment include: a) A main document (parts list or list of documents); b) Complementary documents including: 1) a clear, comprehensive description of the equipment, installation and mounting, and the connection to the electrical supply(ies); 2) electrical supply(ies) requirements; 3) information on the physical environment (for example lighting, vibration, noise levels, atmospheric contaminants) where appropriate; 4) overview (block) diagram(s) where appropriate; 5) circuit diagram(s); 6) information (as applicable) on: • programming, as necessary for use of the equipment; • sequence of operation(s); • frequency of inspection; • frequency and method of functional testing; • guidance on the adjustment, maintenance, and repair, particularly of the protective devices and circuits; • recommended spare parts list; • list of tools supplied. 7) a description (including interconnection diagrams) of the safeguards, interlocking functions, and interlocking of guards against hazards, particularly for machines operating in a co-ordinated manner; 8) a description of the safeguarding and of the means provided where it is necessary to suspend the safeguarding (for example for setting or maintenance), (see 9.2.4); 9) instructions on the procedures for securing the machine for safe maintenance; (see also 17.8); 10) information on handling, transportation and storage; 11) information regarding load currents, peak starting currents and permitted voltage drops, as applicable; 12) information on the residual risks due to the protection measures adopted, indication of whether any particular training is required and specification of any necessary personal protective equipment.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
17.3	Unless otherwise agreed between manufacturer and user: – the documentation is in accordance with relevant parts of IEC 61082; – reference designations are in accordance with relevant parts of IEC 61346; – instructions / manuals are in accordance with IEC 62079. – parts lists where provided are in accordance with IEC 62027, class B.		P
17.4	Installation documents giving all information necessary for the preliminary work of setting up the machine (including commissioning) are provided. (In complex cases, it may be necessary to refer to the assembly drawings for details.)		P
	The recommended position, type, and cross-sectional areas of the supply cables to be installed on are clearly indicated.		P
	Data necessary for choosing the type, characteristics, rated currents, and setting of the overcurrent protective device for the supply conductors to the electrical equipment of the machine is stated (see 7.2.2).		N/A
	The size, purpose, and location of any ducts in the foundation that are to be provided by the user are detailed (see Annex B).		N/A
	The size, type, and purpose of ducts, cable trays, or cable supports between the machine and the associated equipment that are to be provided by the user are detailed (see Annex B).		N/A
	A diagram indicates where space is required for the removal or servicing of the electrical equipment.		N/A
	An interconnection diagram or table is provided, where it is appropriate. They give full information about all external connections.		N/A
	Where the electrical equipment is intended to be operated from more than one source of electrical supply, the interconnection diagram or table does indicate the modifications or interconnections required for the use of each supply.		N/A
17.5	Where it is necessary to facilitate the understanding of the principles of operation, an overview diagram is provided.		P
17.6	The circuit diagram shows the electrical circuits on the machine and its associated electrical equipment.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
	Any graphical symbol not shown in IEC 60617-DB:2001 are separately described on the diagrams or supporting documents.		P
	The symbols and identification of components and devices are consistent throughout all documents and on the machine.		P
	Switch symbols on the electromechanical diagrams are shown with all supplies turned off (for example electricity, air, water, lubricant) and with the machine and its electrical equipment ready for a normal start.		P
	Conductors are identified in accordance with 13.2.		P
	Characteristics relating to the function of the control devices and components which are not evident from their symbolic representation are included on the diagrams adjacent to the symbol or referenced to a footnote.		P
17.7	An operating manual detailing proper procedures for set-up and use of the electrical equipment is provided.		P
	Particular attention is given to the safety measures.		P
	Where the operation of the equipment can be programmed, detailed information on methods of programming, equipment required, program verification, and additional safety procedures (where required) is given.		N/A
17.8	A maintenance manual detailing proper procedures for adjustment, servicing and preventive inspection, and repair is provided. Recommendations on maintenance/service intervals and records are part of that manual. Where methods for the verification of proper operation are provided (for example software testing programs), the use of those methods is detailed		P
17.9	The parts list, where provided, comprises, as a minimum, information necessary for ordering spare or replacement parts (for example components, devices, software, test equipment, technical documentation) required for preventive or corrective maintenance including those that are recommended to be carried in stock by the user of the equipment.		P
18	**VERFICATION**		**P**

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
18.1	The extent of verification will be given in the dedicated product standard for a particular machine. Where there is no dedicated product standard for the machine, the verifications shall always include the items a), b) and f) and may include one or more of the items c) to e): a) verification that the electrical equipment complies with its technical documentation; b) in case of protection against indirect contact by automatic disconnection, conditions for protection by automatic disconnection shall be verified according to 18.2; c) insulation resistance test (see 18.3); d) voltage test (see 18.4); e) protection against residual voltage (see 18.5); f) functional tests (see 18.6).		—
18.2	Verification of conditions for protection by automatic disconnection of supply		P
18.2.2	Test 1: Verification of the continuity of the protective bonding circuit		—
	The resistance of each protective bonding circuit between the PE terminal and relevant points that are part of each protective bonding circuit is measured with a current between at least 0,2 A. And the resistance measured is in the expected range according to the length, the cross sectional area and the material of the related protective bonding conductor.		N/A
	Test 2: Fault loop impedance verification and suitability of the associated overcurrent protective device.		P
	The connections of the power supply and of the incoming external protective conductor to the PE terminal of the machine are verified by inspection.		P
	The conditions for the protection by automatic disconnection of supply in accordance with 6.3.3 and Annex A a verified by both: 1) A verification of the fault loop impedance by - calculation, or - measurement in accordance with A.4, and		P
	2) A confirmation that the setting and characteristics of the associated overcurrent protective device are in accordance with the requirements of Annex A or table 10		P
18.3	Insulation resistance tests (facultative) The insulation resistance measured at 500 V d.c. between the power circuit conductors and the protective bonding circuit are not less than 1 MΩ.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
18.4	Voltage test (facultative) Testing voltage; twice the rated supply voltage of the equipment or 1 000 V whichever is the greater With test voltage applied between the power circuit conductors and the protective bonding circuit for a period of approximately 1 s. there is no disruptive discharge occurred.		P
18.5	Protection against residual voltages (facultative) Compliance with 6.2.4. is ensured		N/A
18.6	Functional tests The function of circuits for electrical safety (for example earth fault detection) is insured.		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict

DECLARATION OF NATIONAL DIFFERENCES

ATTACHMENT TO TEST REPORT IEC 60204-1
EUROPEAN GROUP DIFFERENCES AND NATIONAL DIFFERENCES
SAFETY OF MACHINERY - ELECTRICAL EQUIPMENT OF MACHINES
PART 1: GENERAL REQUIREMENTS

Differences according to.....:	EN 60204-1:2006 + A1:2009
Attachment Form No..... :	EU_GD_IEC60204_1A
Attachment Originator.....:	Electrosuisse
Master Attachment..... :	2009-11

	CENELEC COMMON MODIFICATIONS (EN)		P
1.	Scope		—
	– are sewing machines, units, and systems; NOTE 7 For sewing machines, see EN 60204-31. – are hoisting machines. NOTE 8 For hoisting machines, see EN 60204-32.		—
3.	Terms and definitions		P
3.56	Uncontrolled stop NOTE This definition does not imply any particular state of other (for example, non-electrical) stopping devices, for example mechanical or hydraulic brakes that are outside the scope of this standard.		P
4.2	Section of equipment		P
4.2.2	The electrical equipment of the machine shall satisfy the safety requirements identified by the risk assessment of the machine. Depending upon the machine, its intended use and its electrical equipment, the designer may select parts of the electrical equipment of the machine that are in compliance with EN 60439-1 and, as necessary, other relevant parts of the EN 60439 series (see also Annex F).		P
4.4	Physical environment and operating conditions		P

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
4.4.1	The electrical equipment shall be suitable for the physical environment and operating conditions of its intended use. The requirements of 4.4.2 to 4.4.8 cover the physical environment and operating conditions of the majority of machines covered by this part of EN 60204. When special conditions apply or the limits specified are exceeded, an agreement between user and supplier (see 4.1) is recommended (see Annex B).		P
4.4.3	Electrical equipment shall be capable of operating correctly in the intended ambient air temperature. The minimum requirement for all electrical equipment is correct operation between air temperatures of +5 °C and +40 °C. For very hot environments (for example hot climates, steel mills, paper mills) and for cold environments, additional measures are recommended (see Annex B).		P
4.4.7	When equipment is subject to radiation (for example microwave, ultraviolet, lasers, X-rays), additional measures shall be taken to avoid malfunctioning of the equipment and accelerated deterioration of the insulation. A special agreement is recommended between the supplier and the user (see Annex B).		N/A
4.4.8	Undesirable effects of vibration, shock and bump (including those generated by the machine and its associated equipment and those created by the physical environment) shall be avoided by the selection of suitable equipment, by mounting it away from the machine, or by provision of anti-vibration mountings. A special agreement is recommended between the supplier and the user (see Annex B).		P
5.	Incoming supply conductor terminations and devices for disconnecting and switching off		N/A
5.1	Add: See 17.8 for the provision of instructions for maintenance.		—

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict
5.4	NOTE 2 Further information on the location and actuation of devices such as those used for the prevention of unexpected start-up is provided in EN 60447. After the fifth paragraph, replace note 2 with: NOTE 3 The selection of a device should take into account, for example, information derived from the risk assessment, intended use and foreseeable misuse of the device. For example, the use of disconnectors, withdrawable fuse links		—
9.	Control circuits and control functions		P
9.2.6.3	Enabling control (see also 10.9) is a manually activated control function interlock that:		—
	a) when activated allows a machine operation to be initiated by a separate start control		N/A
	b) when de-activated – initiates a stop function in accordance with 9.2.5.3, and – prevents initiation of machine operation.		N/A
	Enabling control shall be so arranged as to minimize the possibility of defeating, for example by requiring the de-activation of the enabling control device before machine operation may be reinitiated. It should not be possible to defeat the enabling function by simple means.		N/A
9.2.7.3	Stop:		—
	Cableless control stations shall include a separate and clearly identifiable means to initiate the stop function of the machine or of all the operations that can cause a hazardous situation. The actuating means to initiate this stop function shall not be marked or labelled as an emergency stop device (see10.7).		N/A
10.	Operator interface and machine-mounted control devices		N/A

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EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict

Replace table 2 with

Table 2 – Colour coding for push-button actuators and their meanings

Colour	Meaning	Explanation	Examples of application
RED	Emergency	Actuate in the event of a hazardous situation or emergency	Emergency stop Initiation of emergency function (see also 10.2.1)
YELLOW	Abnormal	Actuate in the event of an abnormal condition	Intervention to suppress abnormal condition Intervention to restart an interrupted automatic cycle
BLUE	Mandatory	Actuate for a condition requiring mandatory action	Reset function
GREEN	Normal	Actuate to initiate normal conditions	(See 10.2.1)
WHITE	No specific meaning assigned	For general initiation of functions except for emergency stop	START/ON (preferred) STOP/OFF
GREY			START/ON STOP/OFF
BLACK			START/ON STOP/OFF (preferred)

N/A

12.	Conductors and cables		P
12.7.8	Construction and installation of conductor wire, conductor bar systems and slip-ring assemblies		—
	The protective bonding circuit shall include the covers or cover plates of metal enclosures or underfloor ducts. Where metal hinges form a part of the bonding circuit, their continuity shall be verified (see Clause 18).		P
17.	Technical documentation		P
17.2	Information to be provided 3) information on the physical environment (for example lighting, vibration, atmospheric contaminants) where appropriate;		P
18.	Verification		P
18.1	General (5th paragraph) For tests in accordance with 18.2 and 18.3, measuring equipment in accordance with the EN 61557 series is applicable. NOTE For other tests as required by this standard measuring equipment in accordance with relevant IEC or European Standards should be used.		P

EN 60204-1			
Clause	Requirement - Test	Result - Remark	Verdict

ZA	**ANNEX ZA, Normative references to IEC standards (normative)**	P
	Normative references to international publications with their corresponding European publications The following referenced documents are indispensable for the application 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. NOTE When an international publication has been modified by common modifications, indicated by (mod), the relevant EN/HD applies.	—

ZZ	**ANNEX ZZ, Essential requirements EC directives (informative)**	**P**
	Coverage of Essential Requirements of EC Directives This European Standard has been prepared under a mandate given to CENELEC by the European Commission and the European Free Trade Association and within its scope the standard covers only the following essential requirements out of those given in Annex I of the EC Directive 98/37/EC: – 1.1.2 – 1.2 – 1.5.1 – 1.5.4 – 1.6.3 (for isolation of electrical supplies of machinery) – 1.6.4 (for access to electrical equipment) – 1.7.0 – 1.7.1 – 1.7.2 (for residual risks of an electrical nature) – 1.7.4(c) Compliance with this standard provides one means of conformity with the specified essential requirements of the Directive concerned. WARNING: Other requirements and other EC Directives may be applicable to the products falling within the scope of this standard.	—

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-Appendix 1: For requirement of EN ISO 12100:2010

EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
6	Risk reduction		-
6.1	General		-
	The objective of risk rduction can be achieved by the elimination of hazards, or by separately or simultaneously reducing each of the two elements that determine the associated risk: -severity of harm from the hazard under consideration -probability of occurrence of that harm All protective measures intended for reaching this objective shall be applied in the following sequence, referred to as the three-step method(see also Figures 1 and 2)		P
6.2	Inherently safe design measures		-
6.2.1	General		-
	Inherently safe design measures are the first and most important step in the risk reduction process because protective measures inherent to the characteristics of the machine are likely to remain effective,whereas experience has shown that even well-designed safeguarding may fail or be violated and information for use may not be followed.		P
	Inherently safe design measures are achieved by avoiding hazards or reducing risks by a suitable choice of design features of the machine itself and/or interaction between the exposed persons and the machine. NOTE See 6.3 for safeguarding and complementary measures that can be used to achieve the risk reduction objectives in the case where inherently safe design measures are not sufficient (see 6.1 for the three-step method).		P
6.2	Consideration of geometrical factors and physical aspects		-
6.2.2.1	Geometrical factors such factors include the following.		-

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	a) The form of machinery is designed to maximize direct visibility of the working areas and hazard zones from the control position—reducing blind spots, for example—and choosing and locating means of indirect vision where necessary(mirrors, etc.) so as to take into account the characteristics of humanvision, particularly when safe operation requires permanent direct control by the operator, for example: -the travelling and working area of mobile machines; -the zone of movement of lifted loads or of the carrier of machinery for lifting persons: -the area of contact of the tool of a hand-held or hand-guided machine with the material being worked. The design of the machine shall be such that, from the main control position, the operator is able to ensure that there are no exposed persons in the danger zones.		P
	b) The form and the relative location of the mechanical components parts: for instance, crushing and shearing hazards are avoided by increasing the minimum gap between the moving parts, such that the part of the body under consideration can enter the gap safely, or by reducing the gap so that no part of the body can enter it (see ISO 13854 and ISO 13857).		P
	c) Avoiding sharp edges and corners, protruding parts: in so far as their purpose allows, accessible parts of the machinery shall have no sharp edges, no sharp angels, no rough surfaces, no protruding parts likely to cause injury, and no openings which can“trap”parts of the body or clothing. In particular, sheet metal edges shall be deburred, flanged or trimmed, and open ends of tubes which can cause a“trap”shall be capped.		P
	d) The form of the machine is designed so as to achieve a suitable working position and provide accessible manual controls (actuators).		P
6.2.2.2	Physical aspects		-
	Such aspects include the following:		-
	a) limiting the actuating force to a sufficiently low value so that the actuated part does not generate a mechanical hazard;		P
	b)limiting the mass and/or velocity of the movable elements, and hence their kinetic energy;		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	- c) limiting the emissions by acting on the characteristics of the source using measures for reducing 1)noise emission at source (see ISO/TR 11688-1), 2)the emission of vibration at source, such as redistribution or addition of mass and changes of process parameters [for example, frequency and/or amplitude of movements (for hand-held and hand-guided machinery, see CR 1030-1)], 3)the emission of hazardous substances, including the use of less hazardous substances or dust-reducing processes (granules instead of powders, milling instead of grinding), and 4)radiation emissions including, for example, avoiding the use of hazardous radiation sources, limiting the power of radiation to the lowest level sufficient for the proper functioning of the machine, designing the source so that the beam is concentrated on the target, increasing the distance between the source and the operator or providing for remote operation of the machinery [measures for reducing emission of non-ionizing radiation are given in 6.3.4.5 (see also EN 12198-1 and EN 12198-3)].		P
6.2.3	Taking into account the general technical knowledge regarding machine design This general technical knowledge can be derived from technical specifications for design (e.g. standards, design codes, calculation rules).These should be used to cover :		-
	a) mechanical stresses such as		-
	-stress limitation by implementation of correct calculation, construction and fastening methods as regards, e.g. bolted assemblies, welded assemblies		P
	-stress limitation by overload prevention, (e.g. "fusible" plugs, pressure-limiting valve, breakage points, torque-limiting devices);		P
	- avoiding fatigue in elements under variable stresses（notably cyclic stresses）;		P
	- static and dynamic balancing of rotating elements;		P
	b) materials and their properties such as		-
	- resistance to corrosion, ageing, abrasion and wear;		P
	- hardness, ductility, brittleness;		P
	- homogeneity		P
	- toxicity		P
	- flammability		P
	c) emission values for:		-
	- noise;		P
	- vibration;		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	- hazardous substances;		P
	- radiation.		P
	When the reliability of particular components or assemblies is critical for safety (e.g. ropes, chains, lifting accessories for lifting loads or persons), stress values shall be multiplied by appropriate working coefficients.		P
6.2.4	Choice of an appropriate technology		-
	One or more hazards can be eliminated or risks reduced by the choice of the technology to be used in certain applications, e. g.:		-
	a)on machines intended for use in explosive atmospheres: -fully pneumatic or hydraulic control system and machine actuators: -"intrinsically safe" electrical equipment (see IEC60079-11)		N/A
	b)for particular products to be processed such as a solvent:equipment assuring that the temperature will remain far below the flash point.		N/A
	c)alternative equipment to avoid high noise level,e.g.: -electrical instead of pneumatic equipment - in certain conditions,water cutting instead of mechanical equipment.		N/A
6.2.5	Applying the principle of the positive mechanical action		-
	Positive mechanical action is achieved when a moving mechanical component inevitably moves another component along with it,either by direct contact or via rigid elements. An example of this positive opening operation of switching devices in an electrical circuit (see IEC 60947-5-1 and ISO 14119)		P
6.2.6	Provisions for stability		-
	Machines shall be designed to have sufficient stability to allow them to be used safely in their specified conditions of use.		P
	Factors to be taken into account include		-
	-geometry of the base; -weight distribution,including loading; -dynamic forces due to movements of parts of the machine itself,or of elements held by the machine which may result in an overturning moment; -vibration		P
	-oscillations of the centre of gravity;		N/A
	-characteristics of the supporting surface in case of traveling or installation on different sites (e.g.ground conditions,slope);		P
	-external forces (e.g.wind pressure,manual forces)		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	Stability shall be considered in all phases of the life of the machine,including handling, traveling,installation,use,de-commissioning and dismantling.		P
	Other protective measures for stability relevant to safeguarding are given in 6.3.2.6		P
6.2.7	Provision for maintainability		-
	When designing a machine,the following maintainability factors shall be taken into account:		-
	-accessibility,taking into account the environment and the human boby measurements,including the dimensions of the working clothes and tools used;		P
	-ease of handling,taking into account human capabilities;		P
	-limitation of the number of special tools and equipment;		P
6.2.8	Observing ergonomic principles		-
	Ergonomic principles shall be taken into account in designing machinery to reduce mental or physical stress and strain of the operator.		P
	These principles shall be considered when allocating functions to operator and machine(degree of automation) in the basic design.		P
	Account shall be taken of body sizes likely to be found in the intended user population, strengths and postures, movement amplitudes, frequency of cyclic actions (see ISO 10075 and ISO 10075-2)		P
	All elements of the “operator-machine” interface such as controls, signaling or data display elements, shall be designed to easily understood so that clear and unambiguous interaction between the operator and the machine is possible.(see EN 614-1, ISO 6385, EN 13861 and IEC 61310-1)		P
	Designer’s attention is especially drawn to following ergonomic aspects of machine design		-
	a)Avoiding stressful postures and movements during use of the machine(e.g.by providing facilities to adjust the machine to suit the various operators).		P
	b) Designing machines, and more especially hand-held and mobile machines to enable them to be operated easily taking into account human effort, actuation of controls and hand, arm and leg anatomy.		P
	c) Limit as far as possible noise, vibration and thermal effects such as extreme temperatue		P
	d) Avoid linking the operator’s working rhythm to an automatic succession of cycles.		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	e) Providing local lighting on or in the machine for the illumination of the working area and of adjusting, setting-up, and frequent maintenance zones when the design features of the machine and/or its guards render the ambient lighting inadequate. Flicker, dazzling, shadows and stroboscopic effects shall be avoided if they can cause a risk. If the position of the lighting source has to be adjusted, its location shall be such that it does not cause any risk to persons making the adjustment.		N/A
	f) Select, locate and identify manual controls(actuators) so that		-
	- they are clearly visible and identifiable and appropriately marked where necessary(see 6.4.4)		P
	- they can be safely operated without hesitation or loss of time and without ambiguity(e.g. a standard layout of controls reduces the possibility of error when an operator changes from a machine to another one of similar type having the same pattern of operation)		P
	-their location(for push-buttons) and their movement (for levers and handwheels) are consistent with their effect (see IEC 61310-3)		P
	Where a control is designed and constructed to perform several different actions, namely where there is no one-to-one correspondence (e.g. keyboards), the action to be performed shall be clearly displayed and subject to confirmation where necessary.		N/A
	Controls shall be so arranged that their layout, travel and resistance to operation are compatible with the action to be performed, taking account of ergonomic principles.		P
	Constraints due to the necessary or foreseeable use of personal protective equipment(such as footwear, gloves)shall be taken into account.		P
	g)Select, design and locate indicators, dials and visual display units so that		-
	-they fit within the parameters and characteristics of human perception		P
	-information displayed can be detected, identified and interpreted conveniently, i.e. long lasting, distinct, unambiguous and understandable with respect to the operator’s requirements and the intended use;		P
	-the operator is able to perceive them form the control position		P
6.2.9	Preventing electrical hazard		-
	For the design of the electrical equipment of machines IEC 60201-1 gives general provisions, especially in clause 6 for protection against electric shock.		P

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EN ISO 12100:2010			
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	For requirements related to specific machines, see corresponding IEC standards(e.g. series of IEC 61029, IEC 60745, IEC 60335).		N/A
6.2.10	Preventing and hydraulic hazards		-
	Pneumatic and hydraulic equipment of machinery shall be designed so that:		-
	-the maximum rated pressure cannot be exceeded in the circuits(e.g. by means of pressure limiting devices)		P
	-no hazard results from pressure surges or rises, pressure losses or drops or losses of vacuum;		P
	-no hazardous fluid jet or sudden hazardous movement of the hose (whiplash)results from leakage or component failures;		N/A
	-air receivers, air reservoirs or similar vessels(e.g. in gas loaded accumulators)comply with the design rules for these elements;		P
	-air elements of the equipment, and especially pipes and hoses, be protected against harmful external effects;		P
	-as far as possible, reservoirs and similar vessels (e.g. in gas loaded accumulators)are automatically depressurized when isolating the machine from its power supply (see 6.3.5.4) and, if it is not possible, means are provided for their isolation, local depressurizing and pressure indication (see also ISO 14118, clause 5)		P
	- all elements which remain under pressure after isolation of machine from its power supply be provided with clearly identified exhaust devices, and a warning label drawing attention to the necessity of depressurizing those elements before any setting or maintenance activity on the machine. See also ISO 4413 and ISO 4414		P
6.2.11	Applying inherently safe design measures to control system		-
6.2.11.1	General		-
	The design measures of the control system shall be chosen so that their safety-related performance privides a sufficient amount of risk reduction (see ISO 13849-1 or IEC 62061)		P
	The correct measures of the control systems can avoid unforeseen and potentially hazardous machine behaviour.		P
	-an unsuitable design or modification (accidental or deliberate) of the control system logic;		P
	- a temporary or permanent defect or a failure of one or several components of the control system;		P
	- a variation or a failure in the power supply of the control system;		P
	- inappropriate selection, design and location of the control devices;		N/A

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EN ISO 12100:2010			
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	Typical examples of hazardous machine behaviour are:		-
	- unintended/unexpected start-up (see ISO 14188)		P
	- uncontrolled speed change;		P
	- failure to stop moving parts;		P
	- dropping or ejection of a mobile part of the machine or of a workpiece clamped by the machine;		P
	- machine action resulting from inhibition (defeating or failure) of protective devices		P
	In order to prevent hazardoues machine behaviour and to achieve safety functions, the design of control systems shall comply with the principles and methods presented in this subclause 6.2.11 and in 6.2.12.		P
	These principles and methods shall be applied singly or in combination as appropriate to the circumstances (see ISO 13849-1 and EN 60204-1 and IEC 62061).		P
	Control systems shall be designed to enable the operator to interact with the machine safely and easily; this requires one or several of the following solutions;		-
	-systematic analysis of start and stop conditions;		P
	-provision for specific operating modes (e.g. start-up after normal stop. restart after cycle interruption or after emergency stop. removal of the workpieces contained in the machine, operation of a part of the machine in case of a failure of a machine element)		P
	-clear display of the faults;		P
	-measures to prevent accidental generation of unexpected start commands (e.g. shrouded start device) likely to cause dangerous machine behaviour (see ISO 14118 figure 1)		P
	-maintained stop commands (e.g. interlock) to prevent restarting that could result in dangerous machine behaviour (see ISO 14118:2000,figure 1)		P
	An assembly of machines may be divided into several zones for emergency stopping, for stopping as a result of protective devices and/or for isolation and energy dissipation.		N/A
	The different zones shall be clearly defined and it shall be obvious which parts of the machine belong to which zone.		N/A

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EN ISO 12100:2010			
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	Likewise it shall be obvious which control devices (e.g. emergency stop devices, supply disconnecting devices) and/or protective devices belong to which zone.		N/A
	The interfaces between zones shall be designed such that no function in one zone creates hazards in another zone which has been stopped for an intervention.		N/A
	Control systems shall be designed to limit the movements of parts of the machinery, the machine itself, or workpieces and/or loads held by the machinery, to the safe design parameters (e.g. range, speed, acceleration, deceleration, load capacity). Allowance shall be made for dynamic effects (e.g. the swinging of loads).		N/A
	For example:		-
	-the traveling speed of mobile pedestrian controlled machinery other than remote-controlled shall be compatible with walking speed.		N/A
	-the range, speed, acceleration and deceleration of movements of the person-carrier and carrying vehicle for lifting persons shall be limited to non-hazardous values, taking into account the total reaction time of the operator and the machine.		N/A
	-the range of movements of parts of machinery for lifting loads shall be kept within specified limits.		N/A
	When machinery is designed to use synchronously different elements which can also be used independently the control system shall be designed to prevent risks due to lack of synchronization.		N/A
6.211.2	Starting of internal power source/switching on an external power supply.		-
	The starting of an internal power source or switching-on of an external power supply shall not result in a hazardous situation. For example: -starting the internal combustion engine shall not lead to movement of a mobile machine; -connection to mains electricity supply shall not result in the starting of working parts of a machine. See EN 60204-1, 7.5 (see also Annexes A and B).		P
6.2.11.3	Starting/stopping of a mechanism		-
	The primary action for starting or accelerating the movement of a mechanism should be performed by Page from state 0 to state 1(if state 1 represents the highest energy state)		P
	The primary action for stopping or slowing down should be performed by removal or reduction of voltage or fluid pressure, or, if binary logic elements are considered, by Page from state 1 to 0 (if state 1 represents the highest energy state).		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	When, in order for the operator to maintain permanent control of deceleration, this principle not observed(e.g. a hydraulic braking vice of a self-propelled mobile machine),the machine shall be equipped with a means of slowing and stopping in case of failure of the main braking system		P
6.2.11.4	Restart after power interruption		-
	If it may generate a hazard,the spontaneous restart of a machine when it is re—energized alter power interruption shall be prevented (e.g. by use of a self-maintained relay, contactor or valve).		P
6.2.11.5	Interruption of power supply situations resulting from interruption or excessive fluctuation of the power supply. At least the following requirements shall be met:		P
	-the stopping function of the machinery shall remain；		P
	-all devices whose permanent operation is required for safety shall operation an effective way to maintain safety(e.g. locking, clamping devices,cooling or heating devices, power-assisted steering of self-propelled mobile machinery);		P
	-parts of machinery or workpieces and/or loads held by machinery which are liable to move as a result of potential energy shall be retained for the time necessary to allow them to be safely lowered		P
6.2.11.6	Use of automatic monitoring		-
	Automatic monitoring is intended to ensure that a safety function(s) implemented by a protective measure do(es) not fail to be performed if the ability of a component or an element to perform its function is diminished ,or if the process conditions are		P
	Automatic monitoring either detects a fault immediately or carries out periodic checks so that a fault is detected before the next demand upon the safety function.		P
	In either case, the protective measure can be initiated immediately or delayed until a specific event occurs (e.g. the beginning of the machine cycle) The protective measures may be, e.g.:		P
	-the stopping of the hazardous process；		P
	-preventing the re-start of this process after the first stop following the failure;		P
	-the triggering of an alarm		N/A
6.2.11.7	Safety functions implemented by programmable electronic control systems		P
6.2.11.7.1	General		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	A control system including programmable electronic equipment(e.g. programmable controllers)can be used to implement safety functions machinery		P
	equipment(e.g. programmable controllers) can be used to implement safety functions machinery		P
	The design of the programmable electronic control system shall be such that the probability of random hardware failures and the likelihood of systematic failures that can adversely affect the performance of the safety—related control function(s)are sufficiently low		P
	Where a programmable electronic control system performs a monitoring function, the system behaviour on detection of a fault shall be considered(see also IEC 6I 508 series for further guidance)		P
	The programmable electronic control system should be installed and validated to ensure that the specified performance(e.g. safety integrity level(SIL)in IEC 6I 508 series)for each safety function has been achieved		P
	Validation comprises testing an analysis(e.g. static,dynamic or failure analysis)to show that all parts interact correctly to perform the safety function and that unintended functions do not occur		P
6.2.11.7.2	Hardware aspects		-
	The hardware(including e.g. sensors, actuators,logic solvers)shall be selected (and/or designed)and installed to meet both the functional and performance requirements of the safety function(s)to be performed, in particular,by means of:		P
	-architectural constraints(e.g. the configuration of the system, its ability to tolerate faults，its behaviour on detection of a fault)：		P
	-selecting (and/or designing) equipment and devices with an appropriate probability of dangerous random hardware failure;		P
	Incorporating measures and techniques within the hardware to avoid systematic failures and control systematic faults.		P
6.2.11.7.3	Software aspects		-
	The software (incfuding internal operating software(or system sofiware) and application software) shall be designed so as to satisfy the performance specification for the safety functions (see also IEC 61508-3)		P
	Application software		-
	Application software should not be re-programmable by the user.		N/A

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EN ISO 12100:2010			
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	This may be achieved by use of embedded software in a non re-programmable memory (e.g. micro-controller, application specific integrated circuit (ASIC)		N/A
	When the application requires reprogramming by the user, the access o the software dealing with safety functions should be restricted e.g. by : -locks; -Pwords for the authorized persons		N/A
6.2.11.8	Principles relating to manuai control		-
	a)Manual control devices shall be designed and located according to the relevant ergonomic principles given in 6.2.8		P
	b)A stop control device shall be placed near each start control device. Where the start /stop function is performed by means of a hold-to-run control, a separate stop control device shali be provided when a risk can result from the hold-to-run control device failing to deliver a stop command when released.		P
	c) Manual controls shall be located out of reach of the danger zones (see IEC 61310-3), except for certain controls where, of necessity, they are located within a danger zone, such as emergency stop or teach pendant.		P
	d)Whhenever possible. control devices and control positions shall be located so that the operator is able to observe the working area or hazard zone.		P
	The driver of a ride-on mobile machine shall be able to actuate all control devices required to operate the machine from the driving position, except for functions which can be controlled more safely from other positions.		N/A
	On machinery intended for lifting persons, controls for lifting and lowering and, if appropriate, for moving the carrier, shall generally be located in the carrier. If safe operation requires controls to be situated outside the carrier, the operator in the carrier shall be provided with the means of preventing hazardous movements.		N/A
	e) if it is possible to start the same hazardous element by means of several controls, the control circuit shall be so arranged that only one control is effective at a given time. This applies especially to machines which can be manually controlled unit (teach pendant, for instance), with which the operator may enter danger zones.		N/A
	f) Control actuators shall be designed or guarded so that their effect, where a risk is involved, cannot occur without intentional operation (see ISO 9355-1 and ISO 447)		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	g) For machine functions whose safe operation depends on permanent, direct control by the operator, measures shall be taken to ensure the presence of the operator at the control position, e.g. by the design and location of control devices.		P
	g) For machine functions whose safe operation depends on permanent, direct control by the operator, measures shall be taken to ensure the presence of the operator at the control position, e.g. by the design and location of control devices.		P
	h) For cableless control an automatic stop shall be performed when correct control signals are not received, including loss of communication(see EN 60204-1)		N/A
6.2.11.9	Control mode for setting, teaching, process changeover, fault-finding, cleaning or maintenance		N/A
	Where, for setting, teaching, process changeover, fault-finding, cleaning or maintenance of machinery, a guard has to displaced or removed and /or a protective device has to be disabled, and where it is necessary for the purpose of these operations for the machinery or part of the machinery to be put in operation, safety of the operator shall be achieved using a specific control mode which simultaneously:		N/A
	-disables all other control modes;		N/A
	-permits operation of the hazardous elements only by continuous actuation of an enabling device, a hold-to-run control device or a two – hand control device;		N/A
	-permits operation of the hazardous elements only in reduced risk conditions (e.g. reduced speed, reduced power/force, step-operation, e. g. with a limited movement control device)		N/A
	Prevents any operation of hazardous functions by voluntary or involuntary action on the machine’s sensors.		N/A
	This control mode shall be associated with one or more of following measures:		N/A
	-restriction of access to the danger zone as far as possible.		N/A
	-emergency stop control within immediate reach of the operator;		N/A
	Portable control unit(teach pendant)and/or local controls allowing sight of the controlled elements.(see IEC60204-1:9.2.4)		N/A
6.2.11.10	Selection of control and operating modes		-

EN ISO 12100:2010			
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	If machinery has been designed and built to allow for its use in several control or operating modes requiring different protective measures and /or work procedures(e.g. to allow for adjustment, setting, maintenance, inspection),it shall be fitted with a mode selector which can be locked in each position.		N/A
	Each position of the selector shall be clearly identifiable and shall exclusively allow one control or operating mode.		N/A
	The selector may be replaced by another selection means which restricts the use of certain functions of the machinery to certain categories of operators(e.g. access codes for certain numerically controlled functions).		N/A
6.211.11	Applying measures achieve electromagnetic Compatibility(EMC)		-
	For guidance on electromagnetic compatibility, see IEC60204-1, and IEC61000-6 series		N/A
6.2.11.12	Provision of diagnostic systems to aid fault-finding		-
	Diagnostic systems to aid fault finding should be included in the control system so that there is no need to disable any protective measures		N/A
6.2.12	Minimizing the probability of failure of safety functions		-
6.2.12.1	General		-
	Safety of machinery is not only dependent on the reliability of the control systems but also on the reliability of all parts of the machine. The continued operation of the safety functions is essential for the safe use of the machine. This can be achieved by:		P
6.2.12.2	Use of reliable components		-
	“Reliable component”means components which are capable of withstanding all disturbances and stresses associated with the usage of the equipment in the conditions of intended use (including the environmental conditions),for the period of time or the probability of operations fixed for the use, with a low probability of failures generating a hazardous malfunctioning of the machine. Components shall be selected taking into account all factors mentioned above(see also 6.213		P
6.2.12.3	Use of“oriented failure mode”components		-
	“Oriented failure mode”components or systems are those in which the predominant failure mode is known in advance and which can be used so that such a failure leads to a non-hazardous alteration of the machine function		N/A
	The use of such components should always be considered particularly in cases where redundancy is (see 6.2.12.4)not employed		N/A

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EN ISO 12100:2010			
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6.2.12.4	Duplication(or redundancy)of components or subsystems		N/A
	In the design of safety-related parts of the machine, duplication(or redundancy) of components may be used so that if one component fails, another component(or other components) continue(s) to perform its(their) function, thereby ensuring that the safety function remains available		N/A
	In order to allow the proper action to be initiated, omponent failure shall be preferably detected by automatic monitoring (see 6.2.1 1.6) or in some circumstances by regular inspection,		N/A
	provided that the inspection interval is shorter than the expected lifetime of the components.		N/A
	Diversity of design and/or technology can be used to avoid common cause failures (e.g. from electromagnetic disturbance) or common mode failures.		N/A
6.2.13	Limiting exposure to hazards through reliability of quipment		-
	Increased reliability of all component parts of machinery reduces the frequency of incidents requiring rectification, thereby reducing exposure to hazards.		P
	This applies to power systems (operative part) as well as to control systems, to safety functions as well as to other functions of machinery.		P
	Safety-critical components (as e.g. certain sensors) with known reliability shall be used.		P
	The elements of guards and of protective services shall be particularly reliable, as their failure can expose persons to hazards, and also as poor reliability would encourage attempts to defeat them.		P
6.2.14	Limiting exposure to hazards through mechanization or automation of loading(feeding) /unloading (removal) operations		-
	Mechanization and automation of machine loading/unloading operations and more generally of handling operations (of work pieces, materials, substances) limit the risk generated by these operations by reducing the exposure of persons to hazards at the operating points.		P
	Automation can be achieved e.g. by robots, handling devices. transfer mechanisms, air blast equipment.		P
	Mechanization can be achieved, e.g. by feeding slides, push rods, hand-operated indexing tables.		P
	While automatic feeding and removal devices have much to offer in preventing accidents to machine operators, they can create danger when any faults are being rectified.		P

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EN ISO 12100:2010			
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	Care shall be taken to ensure that the use of these devices does not introduce further hazards (e.g. trapping, crushing) between the devices and parts of the machine or workpieces/materials being processed.		P
	Suitable safeguards (see 6.3) shall be provided if this cannot be ensured.		P
	Automatic feeding and removal devices with their own control systems and the control systems of the associated machine shall be interconnected after thoroughly studying how all safety functions are performed in all control and operation modes of the whole equipment.		P
6.2.15	Limiting exposure to hazards through location of the setting and maintenance points outside of danger zones.		P
	The need for access to danger zones shall be minimized by locating maintenance, lubrication and setting points outside these zones.		P
6.3	Safeguarding and complementary protective measures		-
6.3.1	General		-
	Guards and protective devices shall be used to protect persons whenever inherently safe design does not reasonably make it possible either to remove hazards or to sufficiently reduce risks. Complementary protective measures involving additional equipment (e.g. emergency stop equipment)may have to be implemented.		P
	The different kinds of' guards and protective devices are defined in 3.27 and 3.28.		P
	Certain safeguards may be used to avoid exposure to more than one hazard (e.g. a fixed guard preventing access to a zone where a mechanical hazard is present being used to reduce noise level and collect toxic emissions)		P
6.3.2	Selection and implementation of guards and protective devices		-
6.3.2.1	General		-
	This subclause gives guidelines for the selection and the implementation of guards and protective devices the primary purpose of which is to protect persons against hazard generated by moving parts, according to the nature of those parts(see figure 4)and to the need for access to the danger zone(s)		P
	The exact choice of a safeguard for a particular machine shall be made on the basis of the risk assessment for that machine		P
	In selecting an appropriate safeguard for a particular type of machinery or hazard zone, it shall be borne in mind that a fixed guard is simple and shall be used where access of an operation (operation without any malfunction) of the machinery.		P

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EN ISO 12100:2010			
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	As the need for frequency of access increase this inevitably leads to the fixed guard not being replaced		P
	This requires the use of an alternative protective measure (movable interlocking guard, sensitive protective equipment.)		P
	A combination of safeguards may sometimes be required. For example, where, in conjunction with a fixed guard, a mechanical loading(feeding) device is used to feed a workpiece into a machine, thereby removing the need for assess to the primary hazard zone, a trip device may be requiring hazard between the secondary drawing-in or shearing hazard between the mechanical loading(feeding) device, when reachable, and the fixed guard.		N/A
	Consideration shall be given enclosure of control positions or intervention zones to provide combined protection against several hazards which may include:		P
	- hazards from falling or ejected objects(e.g. falling object protection structure)		P
	- emission hazards(e.g. protection against noise, vibration, radiation , harmful substances)		P
	- hazards due to the environment(e.g. protection against heat, cold, foul weather)		P
	- hazards due to tipping over or rolling over of machinery(e.g. roll-over or tip-over protection structure)		P
	The design of such enclosed work stations(e.g. cabs and cabins) shall take into account ergonomic principles concerning visibility,lighting, atmospheric conditions, access, posture.		P
6.3.2.2	Where access to the hazard zone is not required during normal operation		-
	Where access to the hazard zone is not required during normal operation of the machinery, safeguard should be selected fiom the following:		-
	a) fixed guard (see also ISO 14120)		P
	b) interlocking guard with or without guard locking (see also 6.3.3.2.3, ISO 14119, ISO 14120);		P
	c) self-closing guard (see ISO 14120, 3.3.2)		N/A
	d) sensitive protective equipment, e.g. electro-sensitive protective equipment (see IEC 61496) or pressure sensitive mat (see ISO 13856)		N/A
6.3.2.3	Where access to the hazard zone is required during normal operation		-
	Where access to the hazard zone is required during normal operation of the machinery , safeguards should be selected fiom the following:		-

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EN ISO 12100:2010			
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	a)interlocking guard with or without guard locking (see also ISO 14119, ISO 14120 and 6.3.3.2.3 of this standard);		Not appficable.
	b)sensitive protective equipment, e.g electro-sensitive protective equipment (see IEC 61496)		N/A
	c)two-hand control device (see ISO 13851)		N/A
6.3.2.4	Where access to the hazard zone is required for machine setting, teaching, process changeover, fault finding, cleaning or maintenance.		-
	As far as possible, machines shall be designed so that the safeguards provided for the protection of the production operator may ensure also the protection of personnel in charge of setting, teaching, process Changeover, fault finding, cleaning or maintenance without hindering them in performing their task.		N/A
	Such tasks shall be identified and considered in the risk assessment as parts of the use of the machine (see 5.2)		N/A
6.3.2.5	Selection and implementation of sensitive protective equipment		-
6.3.2.5.1	Setection		-
	Due to the great diversity ofthe technologies on which their detection function is based, all types of sensitive protective equipment are far from being equally suitable for safety applications.		N/A
	The following provisions are intended to provide the designer with criteria for selecting , for each application, the most suitable device(s).		N/A
	Types of sensitive protective equipment include, e.g.:		-
	- light curtains;		N/A
	- scanning devices as, e.g. laser scanners;		N/A
	- pressure sensitive mats;		N/A
	- trip bars, trip wires.		N/A
	Sensitive protective equipment can be used:		-
	- for tripping purposes;		N/A
	- for presence sensing;		N/A
	- for both tripping and presence sensing		N/A
	- to re-initiate machine operation, a practice which is subject to stringent conditions.		N/A
	The following characteristics of the machinery, among others, can preclude the sole use of sensitive protective equipment:		N/A
	- tendency for the machinery to eject materials or component parts;		N/A
	- necessity to guard against emissions (noise, radiation, dust, etc.)		N/A
	- erratic or excessive machine stopping time;		N/A
	-inability of a machine to stop part-way through a cycle.		N/A

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EN ISO 12100:2010			
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6.3.2.5.2	Implementation		-
	consideration should be given to :		-
	a) size, characteristics and positioning of the detection zone (see ISO 13855, which deals with the positioning of some types of sensitive protective equipment)		N/A
	b)reaction of the device to fault conditions (see IEC 61496 for electro-sensitive protective equipment)		N/A
	c)possibility of circumvention		N/A
	d)detection capability and its variation over the course of time (e.g. as a result of its susceptibility to different environmental conditions such as the presence of reflecting surfaces, other artificial light sources, sunlight or impurities in the air.		N/A
	sensitive protective equipment shall be integrated in the operative part and associated with the control system of the machine so that :		-
	- a command is given as soon as a person or part of a person is detected ;		N/A
	- the withdrawal of the person or part of a person detected does not, by itself, restart the hazardous machine function(s);therefore, the command given by the sensitive protective equipment shall be maintained by the control system until a new command is given ;		N/A
	- restarting the hazardous machine function(s) results from the voluntary actuation , by the operator, of a control device placed outside the hazard zone , where this zone can be observed by the operator ;		N/A
	-the machine cannot operate during interruption of the detection function of the sensitive protective equipment,except during muting phases ;		N/A
	- the position and the shape of detection field prevents,possibly together with fixed guards , a person or part of a person from entering the hazard zone ,or being present in it , without being detected .		N/A
6.3.2.5.3	Additional requirements for sensitive protective equipment when used for cycle initiation .		-

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Clause	Requirement + Test	Result - Remark	Verdict
	In this exceptional application, starting of the machine cycle is initiated by the withdrawal of a person or of the detected part of a person from the sensing field of the sensitive protective equipment , without any additional start command , hence deviating from the general requirement given in the second point of the dashed list in 6.3.2.5.2, above .After switching on the power supply ,or when the machine has been stopped by the tripping function of the sensitive protective equipment , the machine cycle shall be initiated only by voluntary actuation of a start control .		N/A
	Cycle initiation by sensitive protective equipment shall be subject to the following conditions :		-
	a)only active optoelectronic protective devices (AOPDs) complying with IEC 61496 series shall be used ;		N/A
	b) the requirements for an AOPD used as a tripping and presence-sensing device (see IEC 61496) are satisfied -in particular, location, minimum distance (see ISO 13855),detection capability, reliability and monitoring of control and braking systems;		N/A
	c) the cycle time of machine is short and the facility to re-initiate the machine upon clearing of the sensing field is limited to a period commensurate with a single normal cycle;		N/A
	d) entering the sensing field of the AOPD(s) or opening interlocking guards is the only way to enter the hazard zone;		N/A
	e) if there is more than one AOPD safeguarding the machine, only one of the AOPD(s) is capable of cycle re-initiation;		N/A
	f) with regard to the higher risk resulting from automatic cycle initiation, the AOPD and the associated control system comply with a higher safety-related performance than under normal conditions.		N/A
6.3.2.6	Protective measures for stability		-
	If stability cannot be achieved by inherently safe design measures such as weight distribution(see 4.6), it will be necessary to maintain it by protective measures such as the use of :		-
	- anchorage bolts;		P
	- locking devices		N/A
	- movement limiters or mechanical stops;		N/A
	- acceleration or deceleration limiters;		N/A
	- load limiters;		N/A

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	- alarms warning of the approach to stability or tipping limits;		N/A
6.3.2.7	Other protective devices		-
	When a machine requires continuous control by the operator(e. g. mobile machines, Dumpling making machines) and an error of the operator can generate a hazardous situation, this machine shall be equipped with the necessary devices to enable the operation to remain within specified limits, in particular		N/A
	- when the operator has insufficient visibility of the hazard zone;		N/A
	- when the operator lacks knowledge of the actual value of a safety-related parameter (e. g. a distance, a speed, the mass of a load, the angle of a slope)		N/A
	-when hazards may result form operation other then		N/A
	those controlled by the operator;		-
	The necessary devices include:		-
	- devices for limiting parameters of movement (distance, angle, velocity , acceleration)		N/A
	- overloading and moment limiting devices:		N/A
	- devices to prevent collisions or interference with other machines;		N/A
	-device for preventing hazards to pedestrian operators of mobile machinery or other pedestrians:		N/A
	- torque limiting devices, breakage points to prevent excessive stress of components and assemblies;		N/A
	- devices for limiting pressure. temperature;		N/A
	- devices for monitoring emissions;		N/A
	- devices prevent operation in the absence of the operator at the control position;		N/A
	- device to prevent lifting operations unless stabilizers are in place;		N/A
	- devices to ensure that components are in a safe position before traveling;		N/A
	Automatic protective measures triggered by such devices which take operation of the machinery out of the control of the operator (e.g. automatic stop of hazardous movement) should be preceded or accompanied by a warning signal to enable the operator to take appropriate action (see 6.4.3)		N/A
6.3.3	Requirements for the design of guards and protective devices		-
6.3.3.1	General requirements		-

EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	Guards and protective devices shall be designed to be suitable for the intended use taking into account mechanical and other hazards involved. Guards and protective devices shall be compatible with the working environment of the machine and designed so that they cannot be easily defeated. They shall provide the minimum possible interference with activities during operation and other phases of machine life, in order to reduce any incentive to defeat them.		P
	Guards and protective devices shall :		-
	- be of robust construction.		P
	- not give rise to any additional hazard;		P
	-not be easy to by-P or render non-operational;		P
	-be located at an adequate distance from the danger zone (see ISO 13857 and ISO 13855).		P
	-cause minimum obstruction to the view of the production process:		P
	-enable essential work to be carried out on installation and/or replacement of tools and also for maintenance by allowing access only to the area where the work has to be done, if possible without the guard or protective device having to be moved;		P
	For openings in the guards see ISO 13857		P
6.3.3.2	Requirements for fixed guards		-
6.3.3.2.1	Functions of guards		-
	The functions that guards can achieve are:		P
	-prevention of access to the space enclosed by guard and/or . -containment/capture of materials, workpieces, chips, liquids which may be ejected or dropped by the machine and reduction of emissions(noise, radiation, hazardous substances such as dust, fumes, gases)which may be generated by the machine.		P
	Additionally, they may need to have particular propertied relating to electricity, temperature, fire, explosion, vibration. visibility(see ISO 14120) and operator position ergonomics(e.g. usability, operator's movements, posture, repetitive movements).		P
6.3.3.2.2	Requirements for fixed guards		-
	Fixed guards shall be securely held in place:		-
	- either permanently (e.g. by welding) -or by means of fasteners (screws, nuts) making removal/opening impossible without using tools; they should not remain closed without their fasteners (see ISO 14120)		P
6.3.3.2.3	Requirements for movable guards		-

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	a)movable guards which provide protection against hazards generated by moving transmission parts shall:		-
	-as far as possible remain fixed to the machinery or other structure (generally by means of hinges or guides) when open;		P
	-be interlocking guards (with guard locking when necessary) (see ISO 14119)		N/A
	b) movable guards against hazards generated by non-transmission moving parts shall be designed and associated with the machine control system so that;		-
	- moving parts cannot start up while they are within the operator's reach and the operator cannot reach moving parts once they have start up; this can be achieved by interlocking guards, with guard locking when necessary.		P
	- they can be adjusted only by an intentional action, such as the use of tool or a key;		P
	-they absence or failure of one of their components prevents starting of the moving parts or stops them; this can be achieved by automatic monitoring (see 4.11.6)		P
6.3.3.2.4	Requirements for adjustable guards		-
	Adjustable guards may only be used where the hazard zone cannot for operational reasons be completely enclosed;		N/A
	They shall:		-
	-be designed so that the adjustment remains fixed during a given operation		N/A
	-be readily adjustable without the use of tools;		N/A
6.3.3.2.5	Requirements for interlocking guards with a start function (control guards)		N/A
	An interlocking guard with a start function may be used provided that		N/A
	- all requirements for interlocking guards are satisfied (see ISO 14119)		N/A
	- the cycle time of the machine is short		N/A
	-the maximum opening time of the guard is present to a low value (e.g. equal to the cycle time). When this time is exceeded, the hazardous function(s) cannot be initiated by the closing of the interlocking guard with a tart function and resetting is necessary before restarting the machine.		N/A
	- the dimensions or shape of the machine do not allow a person, or part of a person, to stay in the hazard zone or between the hazard zone and the guard while the guard is closed (see ISO 14120)		N/A
	- all other guards whether fixed (removable type) or movable are interlocking guards;		N/A

EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	-the interlocking device associated with the interlocking guard with a start function is designed in such a way – e.g. by duplication of position detectors and use of automatic monitoring (see 4.11.6)- that its failure cannot lead to an unintended/unexpected start-up;		N/A
	-the guard is securely held open(e.g. by a spring or counterweight)such that it cannot initiate a start while falling by its own weight;		N/A
6.3.3.2.6	Hazards from guards		-
	Care shall be taken to prevent hazards which might be generated by:		-
	- the guard construction (e.g. sharp edges or corners, material);		P
	- the movements of the guards (shearing or crushing zones generated by power-operated guards and by heavy guards which are liable to fall)		P
6.3.3.3	Technical characteristics of protective devices		-
	Protective devices shall be selected or designed and connected to the control system so as to ensure correct implementation of their safety function (s) is ensured.		P
	Protective devices shall be selected on the basis of their having met the appropriate product standard (for example, IEC 61496 for active optoelectronic protective devices) or shall be designed according to one or several of the principles formulated in ISO 13849-1 or IEC62061.		P
	Protective devices shall be installed and connected to the control system so that they cannot be easily defeated.		P
6.3.3.4	Provisions for alternative types of safeguards.		-
	Provisions should be made to facilitate the fitting of alternative types of safeguards on machinery where it is known that this fitting will be necessary because the work to be done on it will vary.		N/A
6.3.4	Safeguarding for reducing emissions		-
6.3.4.1	General		-
	If the measures for the reduction of emissions at source mentioned in 6.2.2.2 are not adequate, the machine shall be provided with additional protective measures (see 6.3.4.2 to 6.3.4.5).		P
6.3.4.	Noise		-
	Additional protective measures include, for example: -enclosures (see ISO 15667) -screens fitted to the machine; -silencers (see ISO 14163)		P
6.3.4.3	Vibration		-

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	Additional protective measures include, for example, damping devices for vibration isolation between the source and the exposed person such as resilient mounting or suspended seats.		P
	For measures for vibration isolation of stationary industrial machinery see EN 1299		P
6.3.4.4	Hazardous substances		-
	Additional protective measures include, for example:		-
	-encapsulation of the machine (enclosure with negative pressure);		N/A
	- local exhaust ventilation with filtration.		N/A
	- wetting with liquids;		N/A
	- special ventilation in the area of the machine (air curtains , cabins for operators)		N/A
6.3.4.5	Radiation		-
	Additional protective measures include, for example:		-
	- use of filtering and absorption;		N/A
	- use of attenuating screens or guards		N/A
6.3.5	Complementary protective measures		-
6.3.5.1	General		-
	Protective measures which are neither inherently safe design measures, nor safeguarding (implementation of guards and/or protective devices),nor information for use may have to be implemented as required by the intended use and the reasonably foreseeable misuse of the machine. Such measures include, but are not limited to, the ones dealt with in 6.3.5.2 to 6.3.5.6		P
6.3.5.2	Components and elements to achieve the emergency stop function		-
	If following a risk assessment, a machine needs to be fitted with components and elements to achieve an emergency stop function to enable actual or impending emergency situations to be averted, the following requirements apply:		-
	-the actuators shall be clearly identifiable, clearly visible and readily accessible		P
	-the hazardous process shall be stopped as quickly as possible without creating additional hazards. If this is not possible or the risk cannot be reduced, it should be questioned whether implementation of an emergency stop function is the best solution;		P
	-the emergency stop control shall trigger or permit the triggering of certain safeguard movements where necessary.		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	Once active operation of the emergency stop device has ceased following an emergency stop command, the effect of this command shall be sustained until it is rest.		P
	This reset shall be possible only at that location where the emergency stop command has been initiated. The reset of the device shall not restart the machinery, but only permit restarting.		P
	More details for the design and selection of electrical components and elements to achieve the emergency stop function are provided in EN 60204 series.		P
6.3.5.3	Measures for the escape and rescue of trapped persons-		-
	Measures for the escape and rescue of trapped persons may consist e.g. of:		-
	-escape routes and shelters in installations generating operator-trapping hazards		N/A
	-arrangements for moving some elements by hand, after an emergency stop		N/A
	-arrangements for reversing the movement of some elements		N/A
	- anchorage points for descender devices;		N/A
	-means of communication to enable trapped operators to call for help		N/A
6.3.5.4	Measures for isolation and energy dissipation		-
	Especially with regard to their maintenance and repair, machines shall be equipped with the technical means to achieve the isolation from power supply(ies) and dissipation of stored energy as a result of following actions:		-
	a) isolating(disconnecting,separating)the machine(or defined parts of the machine) from all power supplies;		P
	b) locking (or otherwise securing) all the isolating units in the isolating position;		P
	dissipating or , if this is not possible or practicable, restraining (containing) any stored energy which may give rise to a hazard;		P
	verifying, by means of a safe working procedure, that the actions taken according to a), b) and c) above have produced the desired effect.		P
	See ISO 14118, clause 5 and EN 60204-1: 5.5 and 5.6		P
6.3.5.5	Provisions for easy and safe handling of machines and their heavy component parts		P
	Machines and their component parts which cannot be moved or transported by hand shall be provided or capable of being provided with suitable attachment devices for transport by means of lifting gear.		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	These attachments may be, among others,		P
	standardized lifting appliances with slings, hooks,eyebolts, or tapped holes for appliance fixing;		P
	appliances for automatic grabbing with a lifting hook when attachment is not possible from the ground.		P
	guiding grooves for machines to be transported by a fork truck;		N/A
	lifting gear and appliances integrated into the machine.		N/A
	Parts of machinery which can be removed manually in operation shall be provided with means for their safe removal and replacement; (See also 6.4.4c item 3).		P
6.3.5.6	Measures for safe access to machinery		-
	Machinery shall be so designed as to enable operation and all routine tasks relating to setting and/or maintenance, to be carried out,as far as possible, by a person remaining at ground level.		P
	Where this is not possible, machines shall have built-in platforms, stairs or other facilities to provide safe access for those tasks ,but care should be taken to ensure that such platforms or stairs do not give access to danger zones of machinery.		N/A
	The walking areas shall be made from materials which remain as slip resistant as practicable under working conditions and, depending on the height from the ground , suitable guard-rails(see ISO14122-3)shall be provided.		N/A
	In large automated installations, particular attention shall be given to safe means of access such as walkways, conveyor bridges or crossover points.		N/A
	Means of access to parts of machinery located at a height shall be provided with collective means of protection against falls(e.g. guard-rails for stairways, stepladders and platforms and/or safety cages for ladders)		N/A
	As necessary, anchorage points for personal protective equipment against falls from a height shall also be provided(e.g. in carriers of machinery for lifting persons or with elevating control stations)		N/A
	Openings shall whenever possible open towards a safe position, They shall be designed to prevent hazards due to unintended opening.		N/A
	The necessary aids for access shall be provided(e.g. steps, handholds).Control devices shall be designed and located to prevent their being used as aids for access.		N/A

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	When machinery for lifting goods and/or persons includes landings at fixed levels, these shall be equipped with inter locking guards preventing falls when the platform is not present at the level.		N/A
	Movement of the lifting platform shall be prevented while the guards are open.		N/A
	For detailed provisions see ISO 14122.		N/A
	Information for use		-
6.4	General requirements		-
6.4.1	Drafting information for use is an integral part of the design of a machine(see figure2).		P
6.4.1.1	Information of use consists of communication links, such as texts, words, signs, signals, symbols or diagrams, used separately or in combination to convey information to the user. It is directed to professional and/or non-professional users.		P
6.4.1.2	Information shall be provided to the user about the intended use of the machine, taking into account, notably, all its operating modes.		-
	The information shall contain all directions required to ensure safe and correct use of the machine. With this in view, it shall inform and warn the user about residual risk.		P
	The information shall indicate, as appropriate,		-
	- the need for training,		P
	- the need for personal protective equipment,		P
	- the possible need for additional guards devices (see Figure 2, Footnote d).		P
	It shall not exclude uses of the machine that can reasonably be expected from its designation and description and shall also warn about the risk which would result from using the machine in other ways than the ones described in the information, especially considering its reasonably foreseeable misuse.		P
6.4.1.3	Information for use shall cover, separately or in combination, transport, assembly and installation, commissioning, use of the machine (setting, teaching/programming or process changeover, operation, cleaning, fault-finding and maintenance) and, if necessary, dismantling, disabling and scrapping.		P
6.4.2	Location and nature of the information for use		-
	Depending on the risk , the time when the information is needed by the user and the machine design , it shall be decided whether the information – or parts thereof – are to be given:		P

EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	- in /on the machine itself (see 6.3 and 6.4.4)		P
	-in accompanying documents (in particular instruction handbook , see 6.4.5)		P
	- on the packaging		P
	- by other means such as signals and warnings outside the machine.		P
	Standardized phrases shall be considered where important messages such as warnings need to be given (see also IEC 62079)		P
6.4.3	Signals and warning devices		-
	Visual signals (e.g. flashing lights) and audible signals (e.g. sirens) may be used to warn of an impending hazardous event such as machine start-up or overspeed.		P
	Such signals may also be used to warn the operator before the triggering of automatic protective measures (see last paragraph of 5.2.7)		P
	It is essential that these signals:		-
	- be emitted before the occurrence of the hazardous event;		P
	- be unambiguous;		P
	- be clearly perceived and differentiated from all other signals used; - be clearly recognized by the operator and other persons.		P
	The warning devices shall be designed and located such that checking is easy.		P
	The information for use shall prescribe regular checking of warning devices.		P
	The attention of designers is drawn to the risks from “sensorial saturation” which results from too many visual and/or acoustic signals, which may also lead to defeating the warning devices.		P
6.4.4	Markings, signs (pictograms), written warnings		-
	Machinery shall bear all markings which are necessary:		-
	a) for its unambiguous identification, at least - name and address of the manufacturer; - designation of series or type; - serial number, if any.		P
	b) in order to indicate its compliance with mandatory requirements;		-
	- marking; -written indications (e.g. for machines intended for use in potentially explosive atmosphere)		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	c) for its safe use, e.g. :		-
	- maximum speed of rotating parts; - maximum diameter of tools; -mass (expressed in kilograms) of the machine itself and/or of removable parts - maximum working load; - necessity of wearing personal protective equipment; - guard adjustment data; - frequency of inspection.		P
	Information printed directly on the machine should be permanent and remain legible throughout the expected life of the machine.		P
	Signs or written warnings only saying “danger” shall not be used.		P
	Readily understandable signs (pictograms) should be used in preference to written warnings.		P
	Signs and pictograms should only be used if the are understood in the culture in which the machinery is to be used.		P
	Markings shall comply with recognized standards (see ISO 2972, ISO 7000, particularly for pictograms, symbols, colours) See EN 60204 series as regards marking of electrical equipment.		P
6.4.5	Accompanying documents (in particular, instruction handbook)		-
6.4.5.1	Contents		-
	The instruction handbook or other written instructions (e.g. on the packaging) shall contain among others:		-
	a) information relating to transport, handling and storage of the machine e.g. :		P
	- storage conditions for the machine;		P
	-dimensions , mass value(s), position of the centre (s) of gravity;		P
	-indications for handling (e.g. drawings indicating application points for lifting equipment)		P
	b) information relating to installation and commissioning of the machine, e.g.		-
	- fixing/anchoring and vibration dampening requirements		P
	- assembly and mounting conditions;		P
	- space needed for use and maintenance;		P
	- permissible environmental conditions (e.g. temperature, moisture, vibration, electromagnetic radiation);		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	-instructions for connecting the machine to power supply (particularly about protection against electrical overloading);		P
	- advice about waste removal /disposal;		P
	-if necessary, recommendations about protective measures which have to be taken by the user; e.g. additional safeguards, safety distances, safety signs and signals.		P
	c) information relating to the machine itself, e.g. :		-
	-detailed description of the machine, its fittings, its guards and/or protective devices;		P
	-comprehensive range of applications for which the machine is intended, including prohibited usages, if any , taking into account variations of the original machine if appropriate.		P
	-diagrams (especially schematic representation of safety functions);		P
	- data about noise and vibration generated by the machine, about radiation, gases, vapours, dust emitted by it, with reference to the measuring methods used.		P
	-technical documentation about electrical equipment (see EN 60204 series)		P
	-documents attesting that the machine complies with mandatory requirements;		P
	d)information relating to the use of the machine, e.g. about:		P
	- intended use; - description of manual controls (actuators); - setting and adjustment; - modes and means for stopping (especially emergency stop) - risks which could not be eliminated by the protective measures taken by the designer; - particular risks which may be generated by certain applications, by the use of certain fittings, and about specific safeguards which are necessary for such applications. -reasonably foreseeable misuse and prohibited usages; - fault identification and location , repair, and re-starting after an intervention; - personal protective equipment which need to be usd and training required.		P
	e) information for maintenance e.g.		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	-nature and frequency of inspections for safety functions; -instructions relating to maintenance operations which require a definite technical knowledge or particular skills and hence should be carried out exclusively by skilled persons (e.g. maintenance staff, specialists) - instructions relating to maintenance actions (e.g. replacement of parts) which do not require specific skills and hence may be carried out by users (e.g. operators) -drawings and diagrams enabling maintenance personnel to carry out their task rationally (especially fault-finding tasks) f) information relating to de-commissioning , dismantling and disposal; g) information for emergency situations , e.g. : - type of fire-fighting equipment to be used. - warning about possible emission or leakage of harmful substance(s), and if possible, indication of means to fight their effects.		P
	h) maintenance instructions provided for skilled persons (second dash in e))and maintenance instructions provided for unskilled persons (third dash in e)), that should appear clearly separated from each other.		P
6.4.5.2	Production of the instruction handbook		P
	a) type and size of print shall ensure the best possible legibility. Safety warnings and/or cautions should be emphasized the use of colours, symbols and/or large print.		P
	b) information for use shall be given in the language(s) of the country in which the machine will be used for the first time and in the original version. If more than one language are to be used, each language should be readily distinguished from the other(s), and efforts should be made to keep the translated text and the relevant illustration together.		P
	c) whenever helpful to the understanding, text should be supplemented with written details enabling, for instance, manual controls (actuators) to be located and identified; they should not be separated from the accompanying text and should follow sequential operations.		P
	d) consideration should be given to presenting information in tabular form where this will aid understanding.Tables should be adjacent to the relevant text.		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	e) the use of colours should be considered, particularly in relation to components requiring quick identification.		P
	f) when information for use is lengthy, a table of contents and/or an index should be given.		P
	g) safety-relevant instructions which involve immediate action should be provided in a form readily available to the operator.		P
6.4.5.3	Drafting and editing information for use		-
	a) relationship to model : the information shall clearly relate to the specific model of machine and, if necessary, other appropriate identification (for example, by serial number).		P
	b) communicate principles : when information for use is being prepared, the communication process “see-think-use” should be followed in order to achieve the maximum effect and should follow sequential operations. The questions “how ?” and “why ?” should be anticipated and the answers provided.		P
	c) information for use shall be as simple and as brief as possible, and should be expressed in consistent terms and units with a clear explanation of unusual technical terms.		P
	d) when it is foreseen that a machine will be put to non-professional use, the instructions should be written in a form that is readily understood by the non-professional users. If personal protective equipment is required for the safe use of the machine, clear advice should be given, e.g. on the packaging as well as on the machine, so that this information is prominently displayed at the point of sale.		P
	e) durability and availability of the documents : documents giving instructions for use should be produced in durable form (i.e. they should be able to survive frequent handling by the user). It may be useful to mark them “keep for future reference”. Where information for use is kept in electronic form (e.g. CD, DVD, tape) information on safety-related issues that need immediate action shall always be backed up with a hand copy that is readily available.		P
7	Documentation of risk assessment and risk reduction		-
	The documentation shall demonstrate the procedure that has been followed and the results that have been achieved. This includes, when relevant, documentation		-
	a)the machinery for which the risk assessment has been made (for example, specifications, limits, intended use);		P
	b) any relevant assumptions that have been made (loads, strengths, safety factors, etc.);		P

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EN ISO 12100:2010			
Clause	Requirement + Test	Result - Remark	Verdict
	c) the hazards and hazardous situations identified and the hazardous events considered in the risk assessment		P
	d) the information on which risk assessment was based (see 5.2):		P
	1) the data used and the sources (accident histories, experience gained from risk reduction applied to similar machinery, etc.);		P
	2) the uncertainty associated with the data used and its impact on the risk assessment;		P
	e) the risk reduction objectives to be achieved by protective measures;		P
	f) the protective measures implemented to eliminate identified hazards or to reduce risk;		P
	g) residual risks associated with the machinery;		P
	h) the result of the risk assessment (see Figure 1);		P
	i) any forms completed during the risk assessment.		P

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3.4 Noise test report

According to the EC Machinery Directive 2006/42/EC

TABLE OF CONTENTS

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Ⅰ: Introduction

In general this test report for the Haiqing injection molding machine and its relative decoiler made by Shenzhen Huasheng Testing Technology Co., Ltd. carried out in accordance with the clause 1.7.4 of Machinery Directive and some relative requirements described as following.

1.1 Normative references

Emission sound power levels are measured in accordance with 85 EN ISO 11202:2009. Sound power levels are measured in accordance with the enveloping surface measuring method shown in EN ISO 3746: 2009.

1.2 Types of Noise level

The international standard mentioned above is applicable to the noise source of any type & size except for the machinery with very tall and/or very long size. It is found appropriate for this machinery to use this standard during the testing of noise level.

1.3 Test environment

The testing was carried out to the machine located inside factory with the appropriate control of background noise.

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Ⅱ: Test Instructions

Equipment No.	Equipment's name	Model	specification	Last time calibrate	Next time calibrate	manufacturer
HK1125	Sound level meter	AWA56100	30~130Db 20~12.5kH A,C,Z weiging	Dec.03.2023	Dec.02.2024	Hangzhou Aihua Equipment CO,.LTD

Photographs of the test instruments

Sound level meter

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Ⅲ: Microphone Positions & Machinery Conditions

3.1 Microphone Positions

When measuring the sound power level the microphone position is set up according to EN ISO 3746:2009, The position on the top of machine is omitted to keep the inspector from dangerous situation. Such a procedure is acceptable by the ISO/TC 43 technical committee.

When measuring the sound emission level the microphone position is set up according to BS EN ISO1120-2009.

3.2 Machinery Conditions

The new machine with features described above has been provided for the test.

Ⅳ:Test Results

Noise Test Report

According to	**EN ISO 3746:2009, BS EN ISO 11202:2009**		
Ambient temperature	**23.3**℃	Humidity	**47%**
The measurement distance d		**1m**	

Sound Power Level Test Report

Testing condition		**Running**	
Position 1	73.7dB	Position 5	74.1dB
Position 2	73.7 dB	Position 6	74.1 dB
Position 3	74.0 dB	Position 7	73.8 dB
Position 4	74.2dB	Position 8	74.0 dB
Average 1 to 4	73.9dB	Average 5 to 8	74.0 dB
Background noise		73.5 dB	
Corrections for background noise		0 d B	
The environment correction		6.6 dB	
Sound pressure level		70.0 dB	
Sound power level		70.0 dB	

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Attachment: Photos of the product:

----------End of report----------

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