

# ANSI B11.6 – 2022

American National Standard –

## ***Safety Requirements for Manual Turning Machines (Lathes) with or without Automatic Control***

ANSI-Accredited Standards Developer and Secretariat:



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APPROVED:

**8 MARCH 2022**

by the American National Standards Institute  
Board of Standards Review



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## FOREWORD

**(This Foreword is not a part of the requirements of this ANSI B11.6-2022 American National Standard)**

The primary objective of this standard is to eliminate or control hazards to personnel associated with manual turning machines with or without automatic control by establishing requirements for the construction, operation and maintenance of these machines. To accomplish this objective, responsibilities have been assigned to the supplier (e.g., manufacturer, rebuilder, reconstructor, installer, integrator), the user and personnel in the working environment.

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

Manual turning machines and associated equipment technologies are continuously evolving. This standard reflects the most commonly used and time-tested state of the art at the time of its approval. The inclusion or omission of language relative to any evolving technology, either in the requirements or explanatory areas of this standard, in no way infers acceptance or rejection of such technologies.

Inquiries with respect to the application or the substantive requirements of this standard, and suggestions for its improvement, are welcomed and should be sent to the B11 Standards, Inc., POB 690905, Houston, Texas 77269, USA, Attention: B11 Secretariat.

### Effective Date

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

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

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

### Context (how to read/use this document)

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

### Inquiries

Inquiries with respect to the application or the substantive requirements of this standard, and suggestions for its improvement are welcomed, and should be sent to [cfelinski@b11standards.org](mailto:cfelinski@b11standards.org).

## Development

This standard was processed and submitted for ANSI approval by the B11 Standards Development Committee (B11 SDC) on safety standards for machines. Committee approval of this standard does not necessarily imply that all committee members voted for its approval. At the time this standard was approved as an American National Standard, the ANSI B11 SDC was composed of the following member organizations:

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

### Organizations Represented

Aluminum Extruders Council  
American Society of Safety Professionals  
Association for Advancing Automation  
Association For Manufacturing Technology  
Assoc. for Packaging & Processing Technology  
The Boeing Company  
Bridgestone  
Canadian Standards Association  
Deere & Co.  
Euchner  
Exponent  
FDR Safety  
Fortress Safety  
Honda Development & Manufacturing of America  
General Motors Corporation  
Grantek System Integration  
IDEM Safety  
Komatsu America Industries  
Liberty Mutual  
MAG Automotive  
Metal Powder Industries Federation  
National Institute for Occupational Safety & Health  
Occupational Safety & Health Administration  
Omron Scientific Technologies Incorporated  
Pilz Automation Safety, LP  
Plastics Industry Association  
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Presence–sensing Device Manufacturers Assn.  
Rockwell Automation  
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The B11.6 Subcommittee which revised the 2001 standard, had the following members:

Name	Company	Title
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John F. Bloodgood, PE	JFB Enterprises	Secretary
Tony Bratkovich, PE	AMT	
Lance Chandler	Boeing	
Dennis Coleman	Southwestern	
James Cordier	Hardinge	
Joe Felicijan	Clausing Industrial	
James Hoffman	Cincinnati-Milacron	
Roger Hopkins	Delphi Harrison	
Kent Johnson	Deere & Co.	
William Riley	U.S. Navy	
Carl Sharak	Liberty Mutual	

Since the last revision of B11.6, the format/style and even some content elements within the ANSI B11 series have evolved. This current revision has maintained many of those same safety requirements and in several instances, updated requirements up-to-date standards of safety practices and technology while updating the format of the standard to the modern B11 standards structure. Additionally, the ANSI B11 series of standards now incorporates the integration of a stratified approach using “**types**” of standards (i.e., type-A, type-B and type-C standards – see a more detailed explanation of this approach in the Introduction). ANSI B11.6 is considered a type-C standard and is intended to be used (at a minimum) in conjunction with the type-A ANSI B11.0 and type-B ANSI B11.19 (see the B11 documents list on page xi).

The Subcommittee which developed this current revision of ANSI B11.6 had the following members:

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



## Explanation of the format, and ANSI B11 conventions

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

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

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

### B11 conventions:

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

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

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

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

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

## Introduction

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

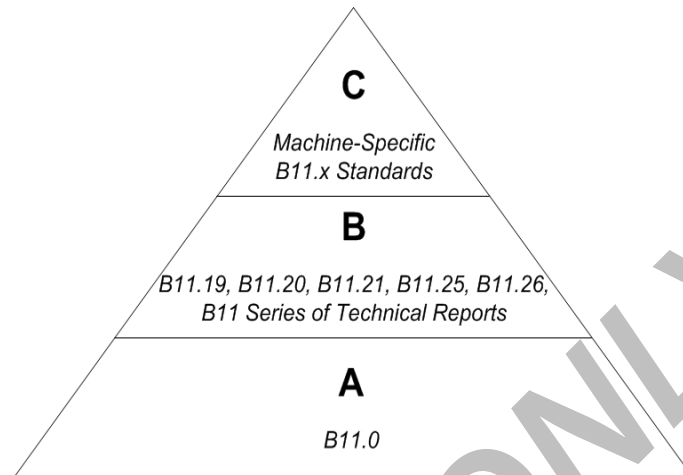
The purpose of the ANSI B11 series of machinery safety standards is to devise and propose ways to eliminate or minimize risks of the potential hazards associated with the required tasks. This can be accomplished either by an appropriate machine design or by restricting personnel or other individuals'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

## Organization and Application of B11 Documents

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

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

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



**Figure 1 — Organization of the B11 Series of Documents**

An overview of each clause of this standard is provided below (clauses 1 through 3 are not shown in Figure 2, for clarity).

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

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

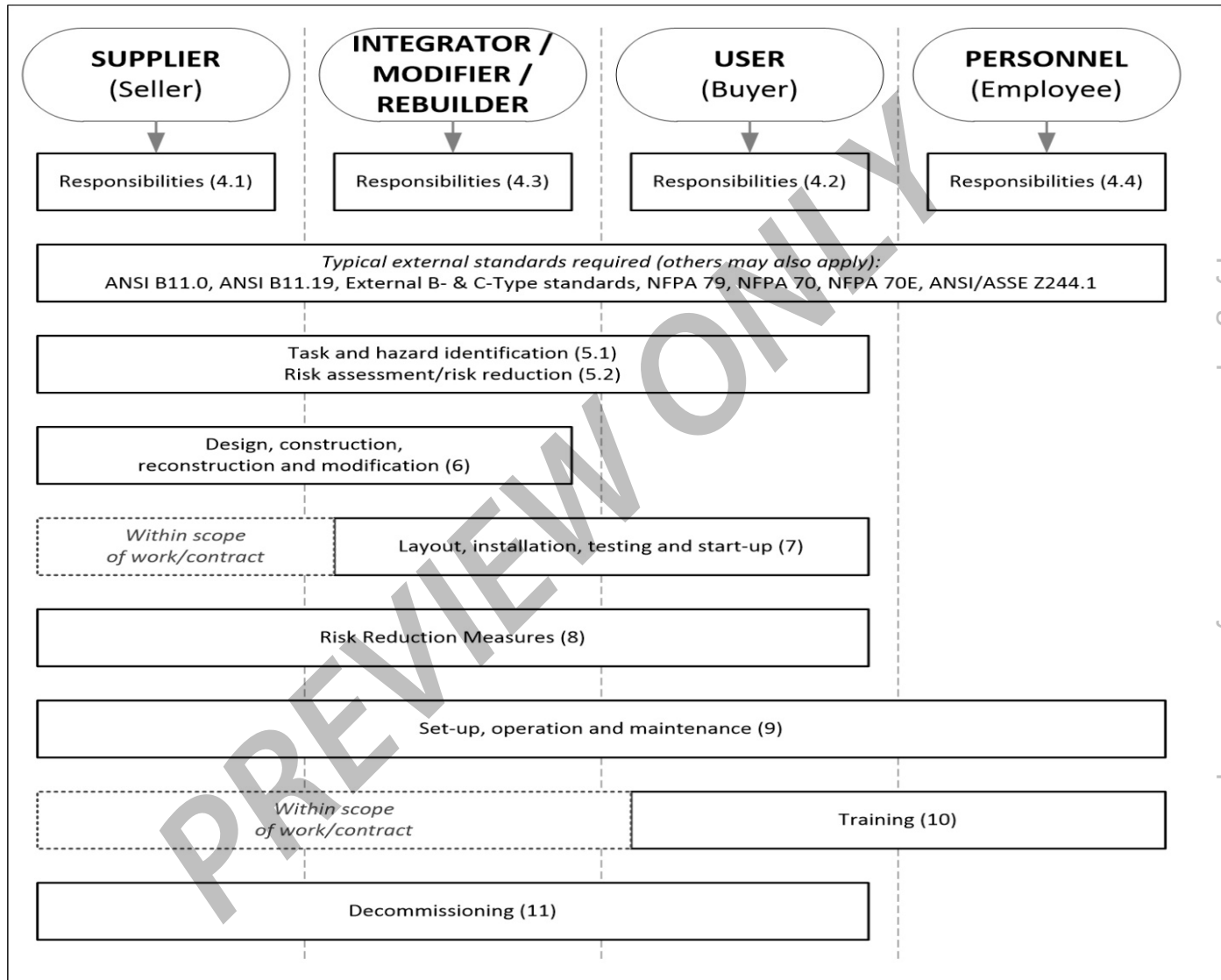


Figure 2 – Typical clause layout of B11 base standards showing the various responsibilities

**Notes for Column Headings in Figure 2:**

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

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

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

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

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

### LIST of the ANSI B11 SERIES of SAFETY STANDARDS and TECHNICAL REPORTS

#	Condensed TITLE / TOPIC	YEAR	TYPE
B11.0	Safety of Machinery	2020	A
B11.1	Mechanical Power Presses	2009 (R20)	C
B11.2	Hydraulic & Pneumatic Power Presses	2013	C
B11.3	Power Press Brakes	2022	C
B11.4	Shears	2003 (R20)	C
B11.5	Ironworkers	1988 (R20)	C
B11.6	Manual Turning Machines (Lathes) w/ or w/o Auto Control	2022	C
B11.7	Cold Headers and Cold Formers	1995 (R20)	C
B11.8	Manual Milling, Drilling, & Boring Machines	2021	C
B11.9	Grinding Machines	2010 (R20)	C
B11.10	Sawing Machines	2003 (R20)	C
B11.11	Gear and Spline Cutting Machines	2001 (R12)	C
B11.12	Roll Forming and Roll Bending Machines	2005 (R20)	C
B11.13	Single & Multiple-Spindle Automatic Bar and Chucking Machines	1992 (R20)	C
B11.14	Withdrawn (Coil Slitting Machines; combined into B11.18)	(1996)	C
B11.15	Bar, Pipe, Tube and Shape Bending Machines	2022	C
B11.16	Powder / Metal Compacting Presses	2014 (R20)	C
B11.17	Horizontal Hydraulic Extrusion Presses	2004 (R20)	C
B11.18	Machines Processing or Slitting Coiled or Non-Coiled Metal	2006 (R20)	C
B11.19	Performance Requirements for Risk Reduction Measures (Safeguarding)	2019	B
B11.20	Integration of Machinery into a System	2017	B
B11.21	Machine Tools Using Lasers for Processing Materials	2006 (R20)	B
B11.22	Turning Centers and Automatic Numerically Controlled Turning Machines	2002 (R20)	C
B11.23	Machining Centers & CNC Milling, Drilling & Boring Machines	2002 (R20)	C
B11.24	Transfer Machines	2002 (R20)	C
B11.25	Large Machines	2015 (R20)	B
B11.26	Functional Safety for Equipment / Machine Control Systems	2018	B
B11.27	Electro-Discharge Machines	2020	C
B11.TR1	Ergonomics	2016	B
B11.TR2	Metal Working Fluids	1997 (R16)	B
B11.TR3	Withdrawn (Risk Assessment / Risk Reduction Guide)	(2000 R15)	B
B11.TR4	Selection of Programmable Electronic Systems (PES/PLC)	2004 (R15)	B
B11.TR5	Noise Measurement	2006	B
B11.TR6	Withdrawn (Safety Control Systems for Machines)	(2010)	B
B11.TR7	Integration of Lean and Safety	2007 (R17)	B
B11.TR8	Guide to Inspection of Risk Reduction Measures	2022	B
B11.TR9	Cybersecurity	2019	B
B11.TR10	Guidance on Artificial Intelligence into Machinery Safety Applications	2020	B
ANSI/ISO 12100	Safety of machinery (identical adoption of ISO 12100-2010)	2012	A



## STANDARD REQUIREMENTS

## EXPLANATORY INFORMATION

*American National Standard –*

***Safety Requirements for Manual Turning Machines (Lathes)  
with or without Automatic Control***

## STANDARDS REQUIREMENTS

## EXPLANATORY INFORMATION

(Not part of the requirements of this American National Standard ANSI B11.6-2022 – *Safety Requirements for Manual Turning Machines (Lathes) with or without Automatic Control*.)

**1 Scope**

This standard specifies safety requirements for the design, construction, operation and maintenance (including installation, dismantling, and transport) of the general class of manually controlled horizontal and vertical spindle turning machines. Machines covered by this standard are intended to work metals and other man-made materials. This standard also applies to devices that are integral to the machine.

These machines may have automatic capability but may not be equipped with automatic part handling or bar-feed mechanisms nor automatic tool changing systems. This standard does not apply to NC Turning Machines where manual control is used only to set the machine for automatic production.

Manual turning machines utilize manually initiated steps to produce a part by rotating the workpiece against a stationary tool(s) such that the cutting force is from the workpiece and not the tool.

**Note** – The terms machine and machining as used throughout this standard mean turning machine.

**E1**

These machines are commonly referred to as “lathes.”

Generally, chucks are not considered to be part of the machine.

See ANSI B11.22 for the safety requirements for Turning Centers and Automatic NC Turning Machines, and ANSI B11.13 for the safety requirements for Single- and Multiple-Spindle Automatic Bar and Chucking Machines.

**2 Normative references**

The following normative documents contain provisions that, through reference in this text, constitute provisions of this American National Standard. At the time of publication, the editions indicated were valid. All normative documents are subject to revision, and parties to agreements subject to this American National Standard should apply the most recent editions of the normative documents listed below.

ANSI B11.0-2020, *Safety of Machinery*