

ANSI B11.7–2020

an American National Standard –

Safety Requirements for Cold Headers and Cold Formers



B11 Standards, Inc.
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Houston, TX 77269, USA

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by the American National Standards Institute
Board of Standards Review



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TABLE of CONTENTS	Page #
Foreword	vi
Effective Date	vi
Context (how to read/use this document)	vi
Inquiries	vi
Development	vii
Introduction	ix
1 Scope, purpose, and application	1
1.1 Scope	1
1.2 Purpose	1
2 Normative references	2
2.1 Informative references	3
3 Definitions	4
4 Responsibilities	5
4.1 Supplier responsibilities	5
4.2 User responsibilities	6
4.3 Integrator, modifier or rebuilder responsibilities	6
4.4 Personnel responsibilities	7
5 Risk assessment process	7
6 Design and construction	9
6.1 General	9
6.2 Header controls	9
6.3 Description of modes of operation	9
6.3.1 <i>Run operating mode</i>	9
6.3.2 <i>Jog operating mode</i>	9
6.4 Electrical equipment	9
6.4.1 <i>Voltage</i>	10
6.4.2 <i>Grounding and shielding</i>	10
6.5 Pneumatic and hydraulic systems	10
6.5.1 <i>Stopping header operations</i>	10
6.5.2 <i>Interrupting pressure supply</i>	10
6.5.3 <i>Filtering and separating</i>	10
6.5.4 <i>Compatibility</i>	10
6.5.5 <i>Hydro-pneumatic accumulators and air receivers</i>	11
6.5.6 <i>Working Pressure</i>	11
6.6 Fluctuation in or interruption of energy sources	11
6.7 Isolation of energy sources	11
6.8 Stored energy	11
6.9 External interferences	12
6.10 Control component failure protection (control reliability)	12
6.11 Header initiation	13
6.12 Stop functions	13
6.12.1 <i>General</i>	13
6.12.2 <i>Emergency stop</i>	14
6.12.3 <i>Normal stop</i>	15
6.13 Operator control stations	15
6.14 Manually operated control devices	15
6.14.1 <i>General</i>	15
6.14.2 <i>Means for limiting access to control devices</i>	15
6.14.3 <i>Control designation</i>	16

6.14.4	Stop control devices	16
6.14.5	Emergency stop devices.....	16
6.14.6	Jog control devices.....	16
6.14.7	Run control devices.....	16
6.14.8	Foot control devices.....	16
6.14.9	Two-hand controls	17
6.14.10	Brakes.....	17
6.15	Indicators	17
7	Layout, installation, testing and start-up	17
7.1	General.....	17
7.2	Layout.....	18
7.3	Installation.....	19
7.3.1	Floor loading.....	19
7.3.2	Anchoring.....	19
7.3.3	Electrical requirements for installation.....	19
7.3.4	Hazardous energy control.....	19
7.3.5	Lighting	20
7.4	Testing and start-up	20
8	Risk reduction measures	21
8.1	Guards.....	21
8.2	Interlocked guards.....	21
8.3	Safeguarding devices.....	21
8.3.1	General	21
8.3.2	Presence sensing devices.....	21
8.3.3	Two-hand control.....	22
8.4	Awareness devices	22
8.4.1	Awareness barriers.....	22
8.4.2	Awareness signals.....	22
8.5	Safe work practices.....	22
8.6	Safeguarding during operation.....	22
8.6.1	Run mode.....	22
8.6.2	Set-up or jog mode	23
8.6.3	Hand feed, single cycle.....	23
8.6.4	Hand feed tools	23
8.7	Span of control.....	23
8.7.1	Layout analysis.....	23
8.7.2	Level of safety performance.....	25
8.7.3	Identification	25
9	Setup, operation and maintenance	25
9.1	General.....	25
9.2	Machine set-up procedures	26
9.3	Operation	26
9.3.1	Perimeter identification	27
9.4	Tool set-up.....	27
9.4.1	Turnover bar.....	27
9.4.2	Tool lubrication	27
9.4.3	Safety block device.....	27
9.5	Maintenance	28
9.5.1	General	28
9.5.2	Maintenance inspections	29
9.6	Supervision	30
9.7	Hazardous energy control.....	31
9.8	Initiation of normal operations.....	31
9.9	Safety signs	31
9.10	Personal protective equipment (PPE)	31

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10 Training.....**31**

 10.1 General..... 31

 10.2 Training elements..... 32

 10.2.1 Training programs 33

 10.3 Operator training 34

 10.4 Maintenance personnel training..... 34

 10.5 Supervisor training 34

 10.6 Retraining 34

11 Decommissioning process.....**34**

 11.1 Supplier responsibilities..... 34

 11.2 User responsibilities 35

 11.3 Modifier responsibilities 35

 11.4 Decommissioning task..... 36

 11.5 Control of hazardous energy 36

 11.6 Layout..... 36

Annex A – Figures**37**

Annex B – Performance of the safety-related function(s).....**50**

Annex C – Training**51**

LIST OF FIGURES

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

Figure 2 – Nomenclature for typical cold header (operator's side).....**37**

Figure 3 – Nomenclature for typical cold header (internal view – camshaft side).....**38**

Figure 4 – High-Speed Bolt-Making Machine.....**39**

Figure 5 – Large cold former.....**40**

Figure 6 – Larger cold former**41**

Figure 7 – Toggle header (enclosure removed).....**42**

Figure 8 – Two–die, three–punch cold header.....**43**

Figure 9 – Bearing cold header (ball and/or roller).....**44**

Figure 10 – Micro former**45**

Figure 11 – Formax boltmaker**46**

Figure 12 – Formax header.....**47**

Figure 13a – Single die – die block (example).....**48**

Figure 13b – Multi die – die block (example).....**48**

Figure 14 – Examples of hand feeding tools.....**49**

Figure 15 – Example of turnover bar**49**

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Foreword

(This Foreword is not part of American National Standard B11.7-2020)

The primary objective of this standard is to eliminate or control the risk of injuries to personnel associated with cold headers and cold formers by establishing requirements for the machine's construction, care and use. To accomplish this objective, responsibilities have been assigned to the supplier (manufacturer, rebuilder, modifier) as well as to personnel in the working environment.

Reducing the risk of injury at the point-of-operation is the single most important factor in the elimination of point-of-operation injuries. A production system consists of the cold headers and cold formers as one component, feeding methods (including part or scrap removal) as a second component, and the third component consists of the risk reduction measures (safeguarding) implemented at the point-of-operation.

The safeguarding of cold headers and cold formers is complicated by the wide variety of operations and operating conditions, the variations in size, speed, and type of cold header/cold former used; the size and kind of pieces to be worked; the required accuracy of the finished work; the skill of operators; the length of run; and the method of material feeding and part and scrap removal. Because of these varying factors in the operations and in the workplace, a wide variety of point-of-operation risk reduction methods (guards and devices) has been covered in this standard.

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

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 the B11 Standards, Inc. POB 690905, Houston, TX 77069 - Attention: B11 Secretariat.

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

Name of Representative

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Aluminum Extruders Council	Melvin Mitchell, CSP	Bradley Wyatt, CSP
American Society of Safety Professionals	Ted Sberna, Sr.	Anne Mathias, PE
Association For Manufacturing Technology	Russ Bensman	Alan Metelsky, FS Eng
The Boeing Company	Rhiannon McPherson	Mark Ellingson / Steven Thomas
Bridgestone	Kenji Furukawa, FS Eng	Joey Hinson, FS Eng
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FDR Safety	Michael Taubitz	Joe Wolfsberger
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Grantek	Adam Killian, ASP, FS Eng	Jeff Winter, CSP, FS Eng
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Sub-Zero Group	Chad Pierce, CSP	Bill Lawrie
Toyota Motor Manufacturing North America	Chip Boertlein	

The B11.7 Subcommittee which revised the 1995 standard, had the following members:

John E. Fatzinger, Chairman	Richard J. Cazal	Vince Palese
Frank W. Akstens, Secretary	Mike Kanda	Jesse Robinett
	John Kenny, Jr.	William E. Ruxton
	Paul H. Langenderfer	Ronald P. Tomallo, Jr.
	Richard McClellan	Bernard Thiteca

Since the last revision of B11.7, 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 B11.7 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 B11.7 had the following members:

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

Explanation of the format, and ANSI B11 conventions

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

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

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

B11 conventions:

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

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

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

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

Introduction

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

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

Organization and Application of B11 Documents

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

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

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

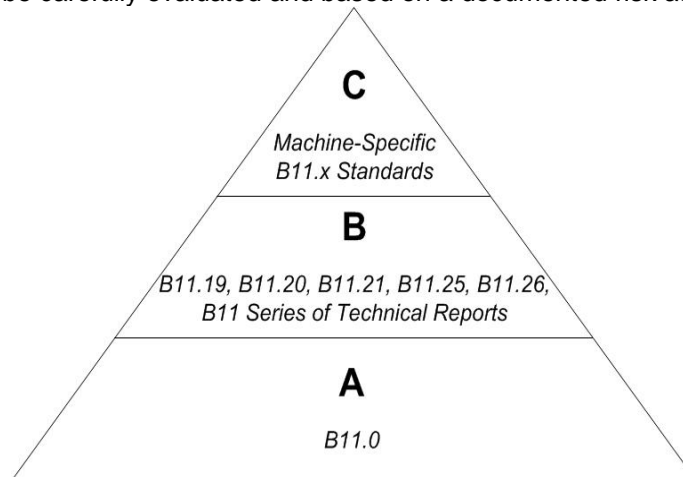


Figure 1 — Organization of the B11 Series of Documents

An overview of each clause of this standard is provided below.

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

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

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

#	SHORT TITLE / TOPIC	YEAR	TYPE
B11.0	Safety of Machinery	2020	A
B11.1	Mechanical Power Presses	2009 (R20)	C
B11.2	Hydraulic & Pneumatic Power Presses	2013 (R20)	C
B11.3	Power Press Brakes	2012 (R20)	C
B11.4	Shears	2003 (R20)	C
B11.5	Ironworkers	1988 (R20)	C
B11.6	Manual Turning Machines w/ or without Auto Control	2001 (R20)	C
B11.7	Cold Headers and Cold Formers	2020	C
B11.8	Manual Milling, Drilling, & Boring Machines	2001 (R20)	C
B11.9	Grinding Machines	2010 (R20)	C
B11.10	Sawing Machines	2003 (R20)	C
B11.11	Gear and Spline Cutting Machines	2001 (R12)	C
B11.12	Roll Forming and Roll Bending Machines	2005 (R20)	C
B11.13	Single & Multiple-Spindle Automatic Bar and Chucking Machines	2020	C
B11.14	<i>Withdrawn</i> (Coil Slitting Machines; combined into B11.18)	(1996)	C
B11.15	Pipe, Tube and Shape Bending Machines	2001 (R20)	C
B11.16	Powder / Metal Compacting Presses	2014 (R20)	C
B11.17	Horizontal Hydraulic Extrusion Presses	2004 (R20)	C
B11.18	Machines Processing or Slitting Coiled or Non-Coiled Metal	2006 (R20)	C
B11.19	Performance Requirements for Risk Reduction Measures (Safeguarding)	2019	B
B11.20	Integration of Machinery into a System	2017	B
B11.21	Machine Tools Using Lasers for Processing Materials	2006 (R20)	B
B11.22	Turning Centers and Automatic Numerically Controlled Turning Machines	2002 (R20)	C
B11.23	Machining Centers & CNC Milling, Drilling & Boring Machines	2002 (R20)	C
B11.24	Transfer Machines	2002 (R20)	C
B11.25	Large Machines	2015 (R20)	B
B11.26	Functional Safety for Equipment / Machine Control Systems	2018	B
B11.27	Electro-Discharge Machines	2020	C
B11.TR1	Ergonomics	2016	B
B11.TR2	Metal Working Fluids	1997 (R16)	B
B11.TR3	<i>Withdrawn</i> (Risk Assessment / Risk Reduction Guide)	(2000 R15)	B
B11.TR4	Selection of Programmable Electronic Systems (PES/PLC)	2004 (R15)	B
B11.TR5	Noise Measurement	2006	B
B11.TR6	<i>Withdrawn</i> (Safety Control Systems for Machines)	(2010)	B
B11.TR7	Integration of Lean and Safety	2007 (R17)	B
B11.TR8	Sustainable Safety Systems Through Inspection of Risk Reduction Measures	202x	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 Cold Headers and Cold Formers

(Not part of this American National Standard — Safety Requirements for Cold headers and cold formers B11.7-2020)

1 Scope, purpose, and application

1.1 Scope

The requirements of this standard apply only to those mechanically powered machines commonly referred to as cold headers and cold formers, which perform many operations such as shearing, heading, upsetting, extruding, trimming, forming, cold working, or warm forming material by means of tools and dies.

This type of equipment generally has the slide in a horizontal position. Included are pointers and roll formers when they become an integral part of the basic machine.

Note – In the context of this standard, the term “header” refers to cold headers and cold formers.

1.2 Purpose

This standard provides performance requirements for the design, construction, installation, operation, and maintenance of the risk reduction measures

E1.2

The requirements of this standard are aimed at reducing the risk of injuries to operating, maintenance, and other personnel who are working on, or adjacent to, a header, and minimizing accidental damage to equipment.

The standard is not intended to establish requirements for personal protective equipment that may be needed for specific operations.

The requirements of this standard apply to:

- cold header;
- cold former;
- ball header;
- tubular rivet header;
- roller header;
- progressive headers;
- bolt making machines;
- parts formers;
- Formax¹headers / boltmakers;
- toggle header;
- Micro Former²;
- cold nut former;
- warm former;
- other similar machines.

See Figures 3–16 for examples of some of the types of headers covered by this standard.

¹ tradename

² tradename