

Australian Standard™

**Wood processing machinery—Safety**

**Part 6: Finishing machinery—Surface  
planing and thicknessing machines**

This Australian Standard was prepared by Committee SF-007, Guarding of Woodworking Machinery. It was approved on behalf of the Council of Standards Australia on 8 February 2005.  
This Standard was published on 9 March 2005.

---

The following are represented on Committee SF-007:

Australian Chamber of Commerce and Industry  
Australian Industry Group  
Australian Woodworking Industry Suppliers Association  
Construction, Forestry, Mining and Energy Union  
Department for Administrative and Information Services, S.A.  
Department of Consumer and Employment Protection, W.A.  
Department of Infrastructure, Energy and Resources (Tasmania)  
Furniture Teachers Advisory Group  
National Distribution Union, New Zealand  
Safety Institute of Australia  
Tasmanian Forest Industries Training Board  
Victorian Association of Forest Industries  
Victorian WorkCover Authority

---

### **Keeping Standards up-to-date**

Standards are living documents which reflect progress in science, technology and systems. To maintain their currency, all Standards are periodically reviewed, and new editions are published. Between editions, amendments may be issued. Standards may also be withdrawn. It is important that readers assure themselves they are using a current Standard, which should include any amendments which may have been published since the Standard was purchased.

Detailed information about Standards can be found by visiting the Standards Web Shop at [www.standards.com.au](http://www.standards.com.au) and looking up the relevant Standard in the on-line catalogue.

Alternatively, the printed Catalogue provides information current at 1 January each year, and the monthly magazine, *The Global Standard*, has a full listing of revisions and amendments published each month.

Australian Standards™ and other products and services developed by Standards Australia are published and distributed under contract by SAI Global, which operates the Standards Web Shop.

We also welcome suggestions for improvement in our Standards, and especially encourage readers to notify us immediately of any apparent inaccuracies or ambiguities. Contact us via email at [mail@standards.org.au](mailto:mail@standards.org.au), or write to the Chief Executive, Standards Australia, GPO Box 5420, Sydney, NSW 2001.

---

*This Standard was issued in draft form for comment as DR 01145.*

Australian Standard™

**Wood processing machinery—Safety**

**Part 6: Finishing machinery—Surface  
planing and thickening machines**

Originated as part of AS CZ10—1960.  
Previous edition AS 1473—1991.  
Revised and redesignated in part as AS 1473.6—2005.

**COPYRIGHT**

© Standards Australia

All rights are reserved. No part of this work may be reproduced or copied in any form or by any means, electronic or mechanical, including photocopying, without the written permission of the publisher.

Published by Standards Australia GPO Box 5420, Sydney, NSW 2001, Australia  
ISBN 0 7337 6521 1

## PREFACE

This Standard was prepared by the Australian members of the Joint Standards Australia/Standards New Zealand Committee SF-007, Guarding of Woodworking Machinery as a revision, in part, of AS 1473–1991, *Guarding and safe use of woodworking machinery*. After consultation with stakeholders in both countries, Standards Australia and Standards New Zealand decided to develop this Standard as an Australian Standard rather than an Australian/New Zealand Standard.

It is one of a series dealing with the safety of woodworking machinery, which have been developed following requests from regulatory authorities for a new edition of the Standard. Other Standards in the series are the following.

## AS

- 1473.1 Woodprocessing machinery—Safety, Part 1: Primary timber milling machinery
- 1473.2 Woodprocessing machinery—Safety, Part 2: Finishing machinery—Common requirements
- 1473.3 Woodprocessing machinery—Safety, Part 3: Finishing machinery—Circular sawing machines
- 1473.4 Woodprocessing machinery—Safety, Part 4: Finishing machinery—Bandsawing machines
- 1473.5 Woodprocessing machinery—Safety, Part 5: finishing machinery—Moulding machines and routers with rotating tool

In common with many other Standards dealing with safeguarding of machinery, the Committee agreed to base the series on a number of drafts and published Standards emanating from the European Community. This Standard is therefore based upon three published Standards, DIN EN 859:1997, *Safety of woodworking machines, Handfed surface planing machines*, DIN EN 860:1997, *Safety of woodworking machines, One-side thickness planing machines* and DIN EN 861:1997, *Safety of woodworking machines, surface planing and thicknessing machines*.

This Standard specifies the requirements which are unique to surface planing machines thicknessing machines and machines combining both functions. The requirements which are common to all wood processing machines are specified in AS 1473.2 *Wood processing machines—Safety, Part 2: Finishing machinery—Common requirements* and this Standard should be read in conjunction with that Standard.

Statements expressed in mandatory terms in footnotes to tables are deemed to be requirements of this Standard.

The term ‘normative’ has been used in this Standard to define the application of the appendix to which it applies. A ‘normative’ appendix is an integral part of a Standard.

## CONTENTS

	<i>Page</i>
SECTION 1 SCOPE AND GENERAL	
1.1 SCOPE .....	4
1.2 OBJECTIVE.....	4
1.3 APPLICATION .....	4
1.4 REFERENCED DOCUMENTS .....	4
1.5 DEFINITIONS .....	5
SECTION 2 REQUIREMENTS FOR HAND-FED SURFACE PLANING MACHINES	
2.1 SCOPE OF SECTION .....	12
2.2 DESIGN OF KNIVES AND CUTTERBLOCKS .....	12
2.3 WORKPIECE SUPPORTS AND GUIDES .....	12
2.4 PREVENTION OF ACCESS TO MOVING PARTS .....	16
2.5 SAFE WORK METHODS.....	22
SECTION 3 THICKNESS PLANING MACHINES	
3.1 SCOPE OF SECTION .....	31
3.2 PROVISION OF EMERGENCY STOP .....	31
3.3 DESIGN OF KNIVES AND CUTTERBLOCKS .....	31
3.4 ANTI-KICKBACK DEVICE .....	31
3.5 PREVENTION OF ACCESS TO MOVING PARTS .....	33
3.6 GUARDING OF INTEGRATED FEED MACHINES .....	33
3.7 GUARDING OF DRIVES.....	34
3.8 CHARACTERISTICS OF GUARDS AND SAFETY DEVICES.....	34
3.9 EMISSION OF CHIPS, DUST AND GASES .....	34
3.10 SAFE WORKING PRACTICE.....	34
SECTION 4 COMBINED SURFACE PLANING AND THICKNESSING MACHINES	
4.1 SCOPE OF SECTION .....	36
4.2 PROVISION OF EMERGENCY STOP .....	36
4.3 DESIGN OF KNIVES AND CUTTERBLOCKS .....	36
4.4 ANTI-KICKBACK DEVICE .....	36
4.5 WORKPIECE SUPPORTS AND GUIDES .....	38
4.6 SURFACING TABLE REQUIREMENTS .....	38
4.7 THICKNESSING TABLE REQUIREMENTS.....	41
4.8 PREVENTION OF ACCESS TO MOVING PARTS .....	42
4.9 CHARACTERISTICS OF GUARDS AND SAFETY DEVICES.....	46
4.10 EMISSION OF CHIPS, DUST AND GASES .....	46
APPENDICES	
A TABLE LIP RESISTANCE TESTS .....	47
B TESTS FOR GUARDS FOR PLANING MACHINES.....	51
C KICKBACK TEST FOR THICKNESSING MACHINES SAFETY DEVICES .....	52

## STANDARDS AUSTRALIA

**Australian Standard**  
**Wood processing machinery—Safety****Part 6: Finishing machinery—Surface planing and thicknessing machines**

## SECTION 1 SCOPE AND GENERAL

**1.1 SCOPE**

This Standard specifies additional requirements for the design, manufacture, safeguarding and use of surface planing and thicknessing machines used in the manufacture of components for furniture, joinery and the like. It is to be read in conjunction with AS 1473.2, which contains general requirements.

**1.2 OBJECTIVE**

The objective of this Standard is to provide designers, manufacturers, suppliers and users of surface planing and surface thicknessing machinery with the means of minimizing the risks to the health and safety of persons working with them.

**1.3 APPLICATION**

This Standard is intended for those who design, manufacture, supply, install, use, maintain or modify surface planing and thicknessing machinery.

Alternative methods of providing safety to those given may be used provided that the level of safety offered by the alternative is at least equivalent to that provided by the methods given in this Standard.

Some regulatory authorities have specific requirements relating to the forms that guarding may take and to the order in which guarding techniques may be considered. Users of this Standard should therefore make themselves aware of any specific requirements in the jurisdiction where the machinery will be used.

**1.4 REFERENCED DOCUMENTS**

The following documents are referred to in this Standard:

## AS

- |        |   |
|--------|---|
| 1473   | Wood processing machinery—Safety                |
| 1473.2 | Part 2: Finishing machinery—Common requirements |
| 4024   | Safeguarding of machinery                       |
| 4024.1 | Part 1: General principles                      |

## ISO

- |      |  |
|------|--|
| 7568 | Woodworking machines—Thickness planing machines with rotary cutterblock for one-side dressing—Nomenclature and acceptance conditions |
| 7571 | Woodworking machines—Surface planing machines with cutterblock for one-side dressing—Nomenclature and acceptance conditions          |