Rockwell Automation is a member of the Association for Packaging and Processing Technologies (PMMI) – a trade association made up of more than 700 member companies that manufacture packaging, processing and packaging-related converting machinery, commercially-available packaging machinery components, containers and materials in the United States, Canada and Mexico.

PMMI members are the industry-leading solutions providers on your processing and packaging supply chain, and PMMI resources help you connect with them.

To learn more about packaging and processing, visit PMMI at: www.pmmi.org/

To access more information on the Rockwell Automation solutions in the Food and Beverage industry, visit us at: www.rockwellautomation.com/global/industries/food/overview.page

Table of contents
Food and Beverage Industry Safety Guide

- Safety Perspectives .............................................. 3
- Safety Maturity .................................................. 4
- Safety Life Cycle ................................................. 5
- Applicable Safety Standards ................................. 6

Machines in Food and Beverage Industry:

- Beverage Material Handling .................................. 7
- Bottle Blowing ....................................................... 8
- Bottle Cleaning ..................................................... 9
- Bottle Feeding ...................................................... 10
- Bottle Filling ....................................................... 11
- Bottle Capping ..................................................... 12
- Bottle Labeling ..................................................... 13
- Beverage Case Packing ....................................... 14
- Box Taping and Labeling ..................................... 15
- Palletizing .......................................................... 16
- Shrink Wrapping ................................................ 17
- Food Material Handling ....................................... 18
- Mixing .............................................................. 19
- Chopping/Auger ................................................ 20
- Extruding .......................................................... 21
- Baking .............................................................. 22
- Cooling ............................................................ 23
- Vertical Form, Fill, and Seal ............................... 24
- Flow Wrapping .................................................. 25
- Weigh Checking .................................................. 26
- Food Case Packing ............................................. 27
- De-palletizing ..................................................... 28

Food and Beverage Industry Safety Guide | 2
Every day, 6,300 people die as a result of occupational accidents or work-related diseases – more than 2.3 million deaths per year. The economic burden of poor occupational safety and health practices is estimated at 4% of global Gross Domestic Product each year.

The benefits of optimizing safety extend far beyond fewer injuries or fines. Companies that approach safety holistically can improve productivity, gain efficiencies and experience improved employee morale – while also protecting their brand reputation.

Safety affects a wide range of topics including supply chain disruptions, sustainability and resilience, and compliance. Numerous studies show that best-in-class manufacturers – the top 20% – achieve 5%-7% higher OEE, 2%-4% less unscheduled downtime, and have less than half the injury rate of average performers. They achieve this level of performance by taking a comprehensive approach that includes developing a great safety culture, providing safety and engineering processes and procedures, and investing in technology that helps protect workers on the plant floor.

A holistic approach to safety, beginning with a comprehensive assessment of your current condition, is an important first step in determining improvement opportunities. Rockwell Automation developed a 10 Step Holistic Safety Program to help drive consistent implementation of safety programs. Utilizing standardized approaches and tools to evaluate, assess and mitigate risk are key to driving consistent implementation. We use the Safety Maturity Index™ (SMI) to benchmark individual plant performance to identify improvement opportunities and use standardized audit and assessment methods to evaluate compliance.

We also provide a range of tools to help you justify the return on investment, and design your safety system. These tools include:

• Safety Automation Builder – Free software tool to help simplify machinery safety design and validation. Streamlines safety system design, implementation and validation, helping you improve compliance and reduce costs by guiding you through the development of your safety system, including safety system layout, product selection, and safety analysis to help you meet machinery safety Performance Level (PL) requirements as outlined by global standard (EN) ISO 13849-1.

• Pre-engineered Safety Function Documents – Provide detailed information outlining the functionality, performance, and products required for each safety function.

• Safety Accelerator Toolkit – Provides a range of capabilities to accelerate your design process.

• Safety ROI calculator – Quantify the savings and productivity gains from safety investments for improved safety, reduced claims, improved productivity, and other issues unique to safety applications.

This guide focuses primarily on the technical issues on common machinery used in the Food and Beverage industries to help improve safety and productivity. It provides a general overview of machinery used, where safety is typically applied, how productivity can be improved, and links to specific safety functions found on each machine.
Safety Maturity

Best-in-class manufacturers practice the 3 ‘C’s to improve safety and productivity.

To support this holistic, comprehensive view of safety, Rockwell Automation has introduced the Safety Maturity Index™ (SMI). The SMI is a comprehensive measurement of performance in safety culture, compliance processes and procedures, and capital investments in safety technologies. It helps companies understand their current level of performance and steps they can take to improve safety and profitability.

Culture
Safety culture represents company and worker behavior and is generally indicative of the broader company culture.

Compliance
Safety compliance represents company procedures. Environmental, Health and Safety (EH&S) and Engineering Departments must collaborate on EH&S, Compliance (both EH&S and Engineering) and Capital (Engineering).

Capital
Safety capital represents company technology, vital to both safety and productivity. Studies show that 74% of best-in-class manufacturers use integrated safety technologies to improve diagnostics and reduce unscheduled downtime. Integrated solutions can be connected to plant-wide information systems, giving plant operators visibility into metrics such as downtime reports, and machinery and line efficiency.

Did you know?
74% of best-in-class companies use integrated safety technologies to improve diagnostics and reduce unscheduled downtime.

Best-in-class companies...
- Make use of the most advanced safety tools available to reduce machine design and validation time
- Take a holistic approach to safety resulting in increased machine safety, efficiency and productivity
- Stay on top of legislation changes with support from industry accredited safety consultants

Download the Safety Maturity Index Evaluator Tool: www.mpisecure.com/portals/toolkits/rockwell/login.aspx
Safety Life Cycle

Follow the Safety Life Cycle to reduce time to design, develop, and deliver your safety solutions.

What is the Safety Life Cycle?
The Safety Life Cycle helps maximize productivity and improve safety by identifying the steps required to assess and mitigate machinery risks.

The steps of the Safety Life Cycle include:

1. **Perform a hazard or risk assessment**
   Identify hazards and estimate the associated risk.

2. **Determine the functional safety system requirements**
   Evaluate safeguarding options based on industry acceptable solutions and select mitigation techniques.

3. **Design and Verify the system**
   Design system architecture, document safety circuit design and procure materials.

4. **Install and Validate the system**
   Verify systems are operating within defined parameters and applicable standards have been satisfied.

5. **Maintain and Improve the system**
   Verify that system requirements operate within specified parameter for production and safety preventative maintenance and system upgrades.

Did you know?
78% of Food and Beverage industry respondents view investments in capabilities, innovation, and efficiency as fundamental to growth.

Best-in-class companies...
- Solve safety problems encountered in manufacturing settings by designing solutions that integrate safety and machine functionality.
- Follow the concepts outlined in the Safety Life Cycle throughout the life of their machines and safety systems.

To see how we can help you with your machine safety requirements, visit us at:
www.marketing.rockwellautomation.com/safety

To access more information on the Safety Life Cycle as well as other safety tools, review the profile below:
Applicable Safety Standards

Type C standards are industry-specific standards.

- EN/ISO12100 – Basic concepts, general principles for the design of safety systems
- ISO13849 Parts 1 & 2 – Safety related parts of control systems
- ISO13850 – Emergency stop devices, functional aspects
- IEC62061 – Functional safety of safety related electrical, electronic and programmable electronic control systems
- ANSI B11.0 - Safety of Machinery – General Requirements and Risk Assessment
- ANSI B11.19 - Performance Criteria for Safeguarding
- ANSI/RIA 15.06 – Safety Requirements for Industrial Robots and Robot Systems
- ANSI Z224.1 – Control of Hazardous Energy
- ANSI NFPA 70 – US National Electrical Code
- ANSI NFPA 70E – Electrical Safety Requirements
- ANSI NFPA 79 – Electrical Standard for Industrial Machinery
- ANSI PPMI B155.1 – Safety Requirements for Packaging Machinery
- EN415 Parts 1-10 – Safety Requirements for Packaging Machinery

Did you know?

Injuries in Food and Beverage manufacturing represent around 25% of all manufacturing injuries reported.

Best-in-class companies...

- Use a safety life-cycle approach that includes machinery safety assessments
- Develop functional specifications to determine the best safety solutions for their machines

To access more information on the Safety Life Cycle as well as other safety tools, visit us at:
www.marketing.rockwellautomation.com/safety
Browse our free design tools helping you to reduce application development time and cost at:
Productivity improvements in material handling systems can be achieved by using safety contactors, drives and motion control systems utilizing advanced technologies like safe speed, safe direction, safe position and zone control to allow for safe operator interaction with machinery.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing
- Protected Entry

**Safety Functions**
Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

**Did you know?**
62% of manufacturers see productivity increases as vital to growth targets.

**Note:** This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Bottle Blowing
Machine Safety Guide

Productivity improvements on bottle blowing machines can be achieved using safety solutions like door interlock switches, emergency stop buttons and enabling switches for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and safe position that allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical
- Thermal
- Liquid

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing
- Protected Entry

**Note:** This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

**Safety Functions:** Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

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- Safety Functions

**Safety Offering**
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- Lock Out/Tag Out Services
- Safety Training
- Safety Products

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Bottle Cleaning

Safety

Productivity improvements on bottle cleaning machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical
- Liquid

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

**Safety Functions:** Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
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- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products
Productivity improvements on bottle cleaning machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical
- Liquid

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing

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- Safety Products

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Bottle Filling
Machine Safety Guide

Productivity improvements on bottle filling machines can be achieved using safety solutions like door interlock switches, guard-locking switches, light curtains, safety mats, enabling switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion or safe direction to do minor adjustments and minor servicing activities.

Machine Hazards
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical
- Liquid

Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

Safety Offering
- Scalable Assessment Services
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- Safety Training
- Safety Products

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**Bottle Capping**  
**Machine Safety Guide**

Productivity improvements on bottle capping machines can be achieved using safety solutions like door interlock switches, guard-locking switches, enabling switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion or safe direction to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical
- Liquid

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing
- Enabling

**Note:** This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

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**Safety Functions:** Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
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- Safety Functions

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- Safety Products

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Bottle Labeling
Machine Safety Guide

Productivity improvements on bottle labeling machines can be achieved using safety solutions like door interlock switches, guard-locking switches, enabling switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

Machine Hazards
- Pinch
- Cut
- Puncture
- Entanglement
- Rotating
- Entrapment
- Electrical

• Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing
- Enabling

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
• Safety Automation Builder
• Safety Accelerator Toolkit
• Safety Functions

Safety Offering
• Scalable Assessment Services
• Lock Out/Tag Out Services
• Safety Training
• Safety Products

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Beverage Case Packing

Machine Safety Guide

Productivity improvements on bottle labeling machines can be achieved using safety solutions like door interlock switches, guard-locking switches, enabling switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Puncture
- Entanglement
- Rotating
- Entrapment
- Electrical

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

**Safety Functions**: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

*Note:* This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Box Taping and Labeling
Machine Safety Guide

Productivity improvements on box taping and labeling machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. An advanced technique that might enhance productivity is safe-speed to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

Machine Hazards
- Pinch
- Cut
- Entanglement
- Rotating
- Electrical

Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
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- Safety Functions

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- Safety Training
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Palletizing
Machine Safety Guide

Productivity improvements on palletizing systems can be achieved using safety solutions like door interlock switches, guard-locking switches, light curtains, pneumatic and hydraulic dump valves and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

Machine Hazards
- Pinch
- Cut
- Crush
- Entanglement
- Entrapment
- Electrical
- Fall

• Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

Safety Offering
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Shrink Wrapping
Machine Safety Guide

Productivity improvements on shrink wrapping systems can be achieved using safety solutions like door interlock switches, guard-locking switches, light curtains, safety mats, enabling switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. An advanced technique that might enhance productivity is safe-speed control to allow operators and technicians to interact with the machine while it is in slow motion or safe direction to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Entrapment
- Rotating
- Electrical
- Suffocation

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing

**Safety Functions:** Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

**Note:** This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Food Material Handling

Machine Safety Guide

Productivity improvements in material handling systems can be achieved by using safety contactors, drives and motion control systems utilizing advanced technologies like safe speed, safe direction, safe position and zone control to allow for safe operator interaction with machinery.

Machine Hazards
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical

Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing
- Protected Entry

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

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Safety Offering
- Scalable Assessment Services
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- Safety Training
- Safety Products

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Mixing  
Machine Safety Guide

Productivity improvements on mixing machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. An advanced technique that might enhance productivity is safe-speed control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

**Safety Relays and PLCs**
(Typically in control rooms)

**VFD with Safety Capability**

**Door Interlocks**

**Safe Speed Monitoring**

**Emergency Stop**

**Safety Functions**: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
- Safety Automation Builder
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- Safety Functions

**Safety Offering**
- Scalable Assessment Services
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- Safety Training
- Safety Products

**Note**: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Chopping/Auger Machine Safety Guide

Productivity improvements on chopping and auger machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. An advanced technique that might enhance productivity is safe-speed control to allow operators and technicians to clean while the machine is in slow motion.

Machine Hazards
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical

Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
- Safety Automation Builder
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Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Extruding
Machine Safety Guide

Productivity improvements on extruding machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

Machine Hazards
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical

Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

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Productivity improvements on ovens can be achieved using safety solutions like door interlock switches, emergency stop buttons and pull-cords for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. An advanced technique that might enhance productivity and reduce scrap is safe-speed that allows the machine to operate at a safe speed for minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical
- Thermal

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Protected Entry

**Safety Functions:** Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

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- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

*Note:* This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Productivity improvements on cooling tunnels can be achieved using safety solutions like door interlock switches, emergency stop buttons and pull-cords for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. An advanced technique that might enhance productivity and reduce scrap is safe-speed that allows the machine to operate at a safe speed for minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical
- Thermal

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

**Safety Functions**: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

*Note:* This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Vertical Form, Fill and Seal
Machine Safety Guide

Productivity improvements on vertical form, fill and seal machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

Machine Hazards
• Pinch
• Cut
• Entanglement
• Rotating
• Entrapment
• Electrical
• Liquid

Methods for Reducing Risk
• Emergency Stop
• Access Control
• Speed Control
• Energy Isolation

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
• Safety Automation Builder
• Safety Accelerator Toolkit
• Safety Functions

Safety Offering
• Scalable Assessment Services
• Lock Out/Tag Out Services
• Safety Training
• Safety Products

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Flow Wrapping
Machine Safety Guide

Productivity improvements on horizontal flow wrapper machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Entanglement
- Rotating
- Entrapment
- Electrical

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

*Note:* This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

**Safety Functions:** Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

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To learn more about safety products and solutions from Rockwell Automation, visit us at: [www.marketing.rockwellautomation.com/safety](http://www.marketing.rockwellautomation.com/safety)
Weigh Checking Machine Safety Guide

Productivity improvements on weigh checking machines can be achieved using safety solutions like door interlock switches and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. An advanced technique that might enhance productivity is safe-speed control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

Machine Hazards
- Pinch
- Cut
- Entanglement
- Entrapment
- Electrical

Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

Safety Offering
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
Food Case Packing
Machine Safety Guide

Productivity improvements on case packing machines can be achieved using safety solutions like door interlock switches, light curtains and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity is safe-speed and zone control which allows operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

**Machine Hazards**
- Pinch
- Cut
- Puncture
- Entanglement
- Crush
- Entrapment
- Electrical

**Methods for Reducing Risk**
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation

**Safety Functions:** Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

**Safety Design and Development Tools**
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

**Safety Offering**
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

*Note:* This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.
De-palletizing
Machine Safety Guide

Productivity improvements on de-palletizer systems can be achieved using safety solutions like door interlock switches, guard-locking switches, light curtains, pneumatic and hydraulic dump valves and emergency stop buttons for routine, repetitive and integral job tasks to reduce the need to lock-out and tag-out machinery. Some advanced techniques that might enhance productivity are safe-speed and zone control to allow operators and technicians to interact with the machine while it is in slow motion to do minor adjustments and minor servicing activities.

Machine Hazards
- Pinch
- Cut
- Crush
- Entanglement
- Crush
- Entanglement
- Entrapment
- Electrical
- Fall

Methods for Reducing Risk
- Emergency Stop
- Access Control
- Speed Control
- Energy Isolation
- Presence Sensing

Note: This is a generic machine overview. Each machine must be assessed to determine the actual hazards that exist.

Safety Functions: Pre-engineered machine safety application solutions that allow you to develop safety systems quickly, efficiently, and accurately. Typical content includes operational description, electrical drawings, bill of material, PLC code and relay configuration instructions, and SISTEMA verification calculation.

Safety Design and Development Tools
- Safety Automation Builder
- Safety Accelerator Toolkit
- Safety Functions

Safety Offering
- Scalable Assessment Services
- Lock Out/Tag Out Services
- Safety Training
- Safety Products

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