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**Materials and articles in contact with  
foodstuffs — Cutlery and table holloware —**

**Part 3:**

Requirements for silver-plated table and  
decorative holloware

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*Matériaux et objets en contact avec les denrées alimentaires — Coutellerie  
et orfèvrerie de table —*

*Partie 3: Exigences relatives à l'orfèvrerie de table et décorative en métal  
argenté* [ISO 8442-3:1997](#)

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## Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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International Standard ISO 8442-3 was prepared by the European Committee for Standardization (CEN) in collaboration with ISO Technical Committee TC 186, *Cutlery and table and decorative metal hollow-ware*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement). <https://standards.iteh.ai/catalog/standards/sist/0f607744-43c9-4b10-8fa7-5b9fd3bf50c/iso-8442-3-1997>

ISO 8442 consists of the following parts, under the general title *Materials and articles in contact with foodstuffs — Cutlery and table holloware*:

- *Part 1: Requirements for cutlery for the preparation of food*
- *Part 2: Requirements for stainless steel and silver-plated cutlery*
- *Part 3: Requirements for silver-plated table and decorative holloware*
- *Part 4: Requirements for gold-plated cutlery*

Further parts are proposed with the following titles

- *Part 5: Specific cutting test*
- *Part 6: Lacquered lightly silver-plated table and decorative holloware*

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- *Part 7: Specification for table cutlery made of precious metals and their alloys, especially silver cutlery*
- *Part 8: Specification for silver table and decorative holloware*

Annexes C to K form an integral part of this part of ISO 8442. Annexes A and B are for information only.

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## Foreword

The text of EN ISO 8442-3:1997 has been prepared by Technical Committee CEN/TC 194 “Utensils in contact with food”, the secretariat of which is held by BSI, in collaboration with Technical Committee ISO/TC 186 “Cutlery and table and decorative metal hollow-ware”.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 1998, and conflicting national standards shall be withdrawn at the latest by June 1998.

EN ISO 8442 consists of the following parts:

- Part 1: Requirements for cutlery for the preparation of food
- Part 2: Requirements for stainless steel and silver-plated cutlery
- Part 3 : Requirements for silver-plated table and decorative holloware
- Part 4: Requirements for gold-plated cutlery

Further parts are proposed with the following titles

- Part 5: Specific cutting test
- Part 6: Lacquered lightly silver-plated table and decorative holloware
- Part 7: Specification for table cutlery made of precious metals and their alloys, especially silver cutlery
- Part 8: Specification for silver table and decorative holloware

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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## Introduction

This Standard is based on ISO/TC186 work and is concerned only with the performance of silver-plated table and decorative holloware and does not include requirements for design, size or any other characteristics which are matters of personal choice or which can be readily assessed by the purchaser at point of sale.

Attention is drawn to Directives of the European Community concerning materials and articles in contact with food, in particular to Directives EC 89/109 and EC 90/128.

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## 1 Scope

This part of this Standard specifies material, performance requirements and test methods for silver-plated table and decorative holloware made principally from metals, and intended for use at or upon the dining table.

Composition limits are specified for the basic metals for fabrication of the holloware prior to silver-plating.

This standard applies to decorative items such as vases and trophies and includes such items as jugs, dishes, tea- and coffee-pots, trays and tureens, candlesticks, wine-coolers etc.

Requirements are specified for brass, copper, nickel-silver, pewter and stainless steel holloware with a silver-plated coating and for silver-plated cast attachments thereto.

The thickness levels of silver coatings are specified as first, second and third class, these deposits can also be protected by lacquer.

The standard does not apply to holloware made entirely of precious metals, brass, nickel-silver, pewter, stainless steel or that made from ceramics or glass.

## 2 Normative references

This Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

|                    |  |
|--------------------|--|
| ISO 1463           | Metallic and oxide coatings - Measurement of coating thickness - Microscopical method  |
| ISO 2177           | Metallic coatings - Measurement of coating thickness - Coulometric method by anodic dissolution  |
| ISO 3497           | Metallic coatings - Measurement of coating thickness - X-ray spectrometric methods   |
| ISO 3543           | Metallic and non-metallic coatings - Measurement of thickness - Beta backscatter method  |
| ISO 4481 : 1977    | Cutlery and flatware - Nomenclature  |
| EN ISO 8442-2:1997 | Materials and articles in contact with foodstuffs - Cutlery and table holloware - Part 2: Requirements for stainless steel and silver plated cutlery (ISO 8442-2:1997) |

### 3 Definitions

For the purposes of this Standard the definitions given in ISO 4481:1977 and those from EN ISO 8442-2 : 1997 apply together with the following.

**3.1 table holloware:** Items generally formed into a hollow shape for the containment of food or drink (see annex A).

**3.2 decorative holloware:** Items generally formed into a hollow shape but not performing a purpose with respect to food or drink and including items which may not have a discernible interior surface (see annex A).

**3.3 functional surface:** The exterior surface of table or decorative holloware and trophies or the interior surface of a shallow item of holloware, the surface of which will receive usage equivalent to, or exceeding that, of the exterior.

**3.4 non functional surface:** The surface of an item of holloware which is silver-plated principally for aesthetic reasons e.g. the interiors of coffee-pots and vases or which is silver-plated for use with food or drink but which will receive a minimum of abrasive usage.

**3.5 attachment:** Components of an item of holloware joined to it by a process such as welding, brazing or soldering and comprising such items as handles, knobs, feet, spouts, stems and hinges.

**3.6 load-bearing attachment:** An attachment upon which a force resulting from the support of the mass of the holloware and/or its contents will be applied in normal use and comprising such items as handles, taps, feet, bases, spouts and goblet stems.

**3.7 burrs:** Metal in excess of that required to shape an article and which forms a thin plate at its edges.

**3.8 oven-to-tableware:** Items of holloware suitable for use in an oven or on a hotplate at temperatures of up to 250 °C such as e.g. vegetable dishes, meat flats, gravy boats, soup tureens, entrée dishes.

**3.9 vessel:** An item of holloware specifically intended as a container for food and/or liquid.

**3.10 usable capacity:** The volume of liquid required to fill a vessel to 15 mm ± 1 mm of its rim.

**3.11 popping:** Sudden transformation of an apparently flat surface of an item of holloware from convex to concave when a load is applied to the convex side, usually accompanied by a distinctive sound.

**3.12 normal corrected vision:** The naked eye corrected to normal vision if necessary.

NOTE: This is usually done by the wearing of spectacles.

### 4 Materials

#### 4.1 Metals

**4.1.1** The composition of the metals of fabrication of the holloware shall be as given in table 1.

**4.1.2** Silver coatings shall be a minimum of 98,5 % Ag.



## 4.2 Non-metals

Non-metal parts of silver-plated holloware may be made of such materials as glass, ceramic, bone, horn, vulcanized fibres, plastics, wood, wood-plastics laminates or impregnated wood provided that the finished holloware complies with the relevant performance requirements of clause 6. Non-metal parts of table holloware shall be capable of withstanding washing processes in aqueous solutions at 60 °C.

**Table 1: Basis metals for silver-plated table and decorative holloware, composition limits**

| Materials                  | Chemical composition % <sup>1)</sup> |            |            |            |            |            |            |            |            |            |
|----------------------------|--------------------------------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
|                            | C<br>max.                            | Cr<br>min. | Ni<br>min. | Cu<br>min. | Mn<br>max. | Fe<br>max. | Pb<br>max. | As<br>max. | Sn<br>min. | Zn<br>min. |
| Austenitic stainless steel | 0,10                                 | 17         | 8          |            |            |            |            |            |            |            |
| Ferritic stainless steel   |                                      | 16         | -          |            |            |            |            |            |            |            |
| Nickel-silver (Cu, Ni,Zn)  |                                      |            | 9          | 60         | 0,5        | 0,3        | 0,5        |            |            | balance    |
| Brass(Cu, Zn)              |                                      |            |            | 62         |            |            |            |            |            |            |
| Copper                     |                                      |            |            | 99,4       |            |            | 0,2        | 0,2        |            |            |
| Pewter                     |                                      |            |            |            |            |            | 0,5        |            | 90         |            |
| Alloy <sup>2)</sup>        |                                      |            |            |            |            |            | 0,3        |            |            | balance    |

1) Further chemical compositions are given in EN 10088-1.  
2) For attachments not coming into contact with food only.

## 5 Construction

### 5.1 Silver-plating

#### 5.1.1 General

The requirements for minimum thicknesses of silver coating given in 5.1.2 and 5.1.3 shall not apply to the internal surfaces of: spouts, candelabra or any narrow ribbed sections of an item of holloware.

#### 5.1.2 Average thickness

The average thickness of silver coating on the appropriate surface of each finished item, when measured in accordance with the methods described in annex A (mass of coating) and annex B (area of coating), of EN ISO 8442-2 : 1997 shall not be less than those given in table 2.

NOTE: For routine quality control purposes the average thickness can be determined by a non-destructive technique such as weighing before and after plating or by a statistically significant number of local thickness measurements provided that the technique adopted can be shown to give equivalent results to the specified method.

### 5.1.3 Local thickness

The minimum local thickness of silver coatings on functional and non-functional surfaces (see annex A of EN ISO 8442-2:1997) shall be not less than 60 % of the average thickness deemed to be on the item. Minimum local thickness shall be measured in accordance with one of the methods specified in ISO 2177, ISO 1463, ISO 3543 or ISO 3497.

In cases of dispute the thickness shall be measured by the method described in ISO 1463.

**Table 2: Average thickness of classes of silver-coatings**

| Class of quality | Symbol | Type of holloware    | Min. average thickness |                        |
|------------------|--------|----------------------|------------------------|------------------------|
|                  |        |                      | Functional surface     | Non-functional surface |
| First class      | I      | Table holloware      | 15 µm                  | 3 µm                   |
|                  |        | Decorative holloware | 10 µm                  | 3 µm                   |
| Second class     | II     | Table holloware      | 9 µm                   | 2 µm                   |
|                  |        | Decorative holloware | 6 µm                   | 2 µm                   |
| Third class      | III    | Table holloware      | 5 µm                   | 2 µm                   |
|                  |        | Decorative holloware | 3 µm                   | 2 µm                   |

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## 5.2 Uniformity and absence of defects

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**5.2.1** All surfaces shall be free from cracks and other defects.

**5.2.2** All accessible edges shall be free from burrs and the roughness of blanked edges shall have been removed.

**5.2.3** There shall be no gaps in excess of 0,4 mm between components and seams joining hollow sections together shall be watertight unless required by the design.

**5.2.4** Compliance with the requirements of 5.2.1 to 5.2.3 shall be checked by touch or by visual inspection with normal corrected vision and 5.2.3 with a feeler gauge of appropriate thickness.

## 5.3 Lacquered products

NOTE: If lacquer is applied, attention is drawn to the current food contact regulations.

### 5.3.1 Performance in dishwashers

Subject the test specimens to 50 dishwashing cycles. After dishwashing the lacquer shall be free from white colourations and shall show no signs of looseness, blistering or peeling.

NOTE: A test procedure is being developed.

Slight damage to the lacquer starting at the edge is permissible.

### 5.3.2 Resistance to scratching

After testing in accordance with annex C the lacquer shall exhibit only insignificantly matt stripes.

### 5.3.3 Resistance to ultra-violet radiation

After testing in accordance with annex D the lacquer shall be free from discolouration.

## 6 Performance requirements

### 6.1 Strength under load

#### 6.1.1 Resistance of rectangular and square trays and dishes to twisting

The temporary deflection of a rectangular or square tray or flat dish exceeding 300 mm at its maximum axis shall not exceed 3,5 mm in 100 mm deviation from flat in any diagonal across the surface of the base when tested in accordance with annex E.

#### 6.1.2 Resistance of trays and dishes to popping

A tray or dish shall not exhibit popping when tested in accordance with annex F.

#### 6.1.3 Load strength of vessels

A vessel shall exhibit no visible permanent deformation when tested in accordance with annex G.

### 6.2 Attachment strength

There shall be no breakage, visible deformation or disengagement of any load bearing attachment when it is tested in accordance with annex H.

There shall be no breakage, visible deformation or disengagement of a lid knob or any hinge retaining the lid when a vessel is suspended by the lid knob whilst containing a mass in grams, equal to 1,5 times its usable capacity in millilitres.

### 6.3 Stability

When placed on a hard plane surface an item with feet shall be stable to within the clearance limit given in table 3 and no flat item shall be capable of being spun around by the application of a tangential force.

**Table 3: Stability requirements**

| Overall width of item at its widest axis | Maximum permitted clearance between any foot and a plane surface |
|--|--|
| mm                                       | mm   |
| width ≤ 99                               | 0,25   |
| 99 < width < 150                         | 0,40   |
| width ≥ 150                              | 1,0  |