

SLOVENSKI STANDARD

SIST EN ISO 8442-7:2002

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Materiali in izdelki v stiku z živili - Pribor in namizna posoda - 7. del: Podrobni opis za namizni pribor iz srebra, drugih žlahtnih kovin in njihovih zlitin (ISO 8442-7:2000)

Materials and articles in contact with foodstuffs - Cutlery and table holloware - Part 7: Specification for table cutlery made of silver, other precious metals and their alloys (ISO 8442-7:2000)

Werkstoffe und Gegenstände in Kontakt mit Lebensmitteln -Schneidwaren und Tafelgeräte - Teil 7: Anforderungen für Essbestecke aus Silber, anderen Edelmetallen und deren Legierungen (ISO 8442-7:2000)

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Matériaux et objets en contact avec les denrées alimentaires -Coutellerie et orfèvrerie de table - Partie 7: Spécifications relatives a la coutellerie de table en argent massif, autres métaux précieux et leurs alliages (ISO 8442-7:2000)

Ta slovenski standard je istoveten z: EN ISO 8442-7:2000

ICS:

67.250	Materiali in predmeti v stiku z živili	Materials and articles in contact with foodstuffs
97.040.60	Kuhinjska posoda, jedilni servisi in jedilni pribor	Cookware, cutlery and flatware

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 8442-7

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ICS 67.250; 97.040.60

English version

Materials and articles in contact with foodstuffs - Cutlery and table holloware - Part 7: Specification for table cutlery made of silver, other precious metals and their alloys (ISO 8442-7:2000)

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This European Standard was approved by CEN on 9 April 2000.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION
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Foreword

The text of EN ISO 8442-7:1999 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 January 2001, and conflicting national standards shall be withdrawn at the latest by January 2001.

Attention is drawn to the European Community Directives relative to materials in contact with foodstuffs, in particular Directive 89/109/EEC

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: Specification for sharpness and edge retention test of cutlery
- Part 6: Lightly silver plated table holloware protected by a lacquer
- Part 8: Requirements 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, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This European Standard specifies material and performance requirements for table cutlery made of silver, other precious metals and their alloys (knives with stainless steel blades, forks, spoons, carving sets, ladles and other pieces).

It does not include requirements for design, size, type of finish, blade flexibility, or similar characteristics which are matters of personal choice or which can be readily assessed by the purchaser at the point of sale. No sampling provisions are included in this standard, the requirements specified are applicable for each and every item produced.

2 Normative references

This European Standard incorporates by dated 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 European Standard only when incorporated in it by amendment or revision (including amendments).

ISO 4481: 1977 Cutlery and flatware - Nomenclature

ISO 6508: 1986 Metallic materials - Hardness test - Rockwell test (scales A - B - C - D - E - F - G - H - K)

EN 10088-1: 1995 Stainless Steels, Part 1: List of stainless steels

prEN 1904:1995 Precious metals - Solders used with precious metal jewellery alloys

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3 Terms and definitions

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For the purposes of this European Standard the terms and definitions given in annex of ISO 4481: 1977 apply together with the following.

3.1

unsharpened knives

knives with an unsharpened blade used for cutting soft foods

NOTE They are not made of martensitic stainless steel. Examples are butter knife, fish serving knife, ice cream knife, fish knife, spreading knife, cheese knife.

4 Materials

4.1 General

The table cutlery shall be made of silver, other precious metals and their alloys with a minimum standard of fineness of 800 (expressed in parts per thousand) that enable the finished product to meet all of the performance requirements of this standard and which shall be neither detrimental to health nor have any detrimental organoleptic effects.

4.2 Metals

4.2.1 Silver plating

Any parts of silver table cutlery may be plated with a fine silver coating.

4.2.2 Soldering

Precious metals in an article shall be soldered according to prEN 1904:1995.

4.2.3 Stainless Steels

Knife blades and any parts of the table cutlery, which have to fulfil special requirements e.g. carving items, shall be made of stainless steels according to Table 1.

Table 1 — Stainless steel for table cutlery, limiting requirements

Application	Name	number of materials	structure
Carving items	X6CrMo 17-1	1.4113	ferritic
Knife blades	X20Cr 13	1.4021	martensitic
The chemical composition shall be in accordance with EN 10088-1 : 1995			

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4.3 Non-metals

Non-metal parts of table cutlery may be made of such materials as glass, ceramics, plastics or similar materials provided that the finished cutlery complies with the relevant performance requirements of 4. 1.

5 Construction

5.1 Alignment, uniformity and absence of defects

5.1.1 All surfaces shall be free from cracks, pits and other defects.

5.1.2 All cutlery shall be essentially straight and symmetrical except when the lack of straightness or symmetry is an intentional feature of the design.

5.1.3 Identical items within a batch shall, as far as is practicable, show no significant variation in dimension or form.

5.1.4 All edges, including the edges of spoons, forks, ladles and the insiders of fork prongs, shall be free from burrs and the roughness of blanked edges shall have been removed by a suitable operation.

5.1.5 Table knives shall be balanced such that when the knife is pivoted on its bolster, or at the junction of the handle and blade if no bolster is present, the handle shall be heavier than the blade.

5.1.6 Compliance with the requirements for 5.1.1 to 5.1.5 shall be checked by touch or by visual inspection

5.2 Hollow handles

The seams joining hollow handles together shall be watertight.

5.3 Knife edges

The cutting edge of sharpened table knives shall be either scalloped or serrated or shall be whetted to an included angle not greater than 60 °.

The cutting edges of a carving knife blade shall be whetted to an included angle not greater than 40° and shall not be thicker than 0,46 mm when measured 1 mm from the edge.

6 Precious metal-plating

6.1 Hardness of hard gold coatings

Gold coatings claimed to be hard shall contain 0,2 % minimum Co or Ni or Fe or any other element which increases the hardness.

6.2 Adhesion of precious metal coatings

When tested in accordance with annex A coatings shall show no signs of flaking, blistering or peeling.

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NOTE Alternative methods of determining the adhesion of coatings may be used provided the results obtained are in correlation with those given by ball burnishing.

6.3 Fineness of precious metal coatings

The fineness of precious metal coatings should not be less than 925 ‰.

7 Performance

7.1 Resistance to corrosion

The surfaces of stainless steel parts of table cutlery shall comply with the requirements a) to c) when tested in accordance with the method described in annex B:

- a) no transverse cracks shall have developed and no longitudinal cracks of a length exceeding 1,5 mm shall have developed;
- b) there shall not be more than three pits or zones of intergranular corrosion each having an area greater than a circle of 0,4 mm diameter on the handle, and not more than three pits each having an area greater than a circle of 0,4 mm diameter (0,126 mm²) elsewhere;
- c) there shall be no pits or zones of intergranular corrosion having an area greater than a circle of 0,75 mm (0,442 mm²) on any part.

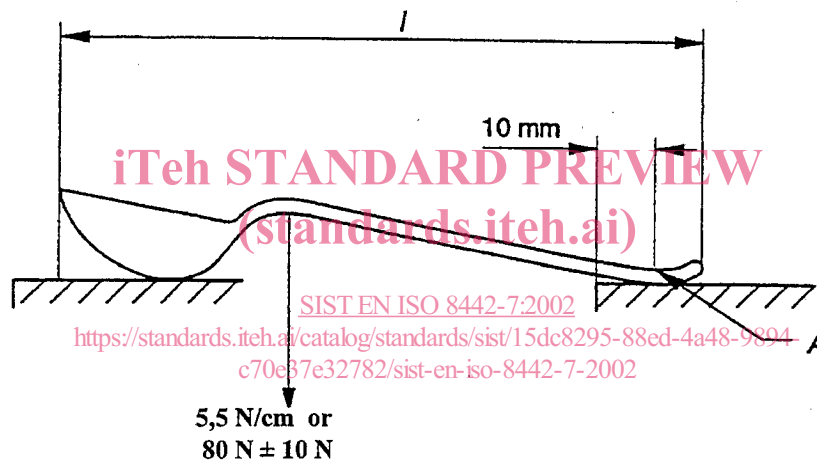
7.2 Strength

7.2.1 Knives with martensitic stainless steel blades

A knife shall not crack or break and shall not acquire a permanent deformation of more than $3^\circ \pm 0,5^\circ$ when tested in accordance with the method described in annex C. In addition, the handle blade joint shall not become loose.

7.2.2 Spoons, forks, ladles and unsharpened knives

An item shall not have a permanent deformation of more than 1mm when tested as follows; an item shall be laid on a plane with the highest point of the handle facing upward. A force shall be applied equivalent to 5,5 N for each centimetre of overall length or $80\text{N} \pm 10\text{N}$ whichever is the lesser for 10 s (see figure 1 for a spoon). During the application of this force the point of rest of the handle (A in figure 1) shall not be more than 10 mm from the edge of the supporting surface.



Key

l length

A point of rest

Figure 1 — Strength test for a spoon