

Specification for table cutlery with non-metallic handles

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Committees responsible for this British Standard

The preparation of this British Standard was entrusted to Technical Committee CW/17, Cutlery and table holloware, upon which the following bodies were represented:

- Association of British Cutlers and Allied Trades
- British Cutlery and Silverware Association
- CESA — The Association of Catering Equipment Manufacturers and Importers
- Consumer Policy Committee of BSI
- Cutlery and Allied Trades Research Association
- Institute of Trading Standards Administration
- National Centre of Tribology
- National Federation of Self-Employed and Small Businesses Ltd.

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Foreword

This revision of BS 5577 has been prepared by Technical Committee CW/17. It partially replaces BS 5577:1984 which is withdrawn. This new edition now only applies to cutlery with non-metallic handles. Cutlery with metallic handles is covered by BS EN ISO 8442-2:1998.

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Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 13 and a back cover.

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1 Scope

This British Standard specifies material and performance requirements for cutlery with non-metallic handles intended for use at the dining table. It includes knives, forks, spoons, carving sets, ladles and other serving pieces.

Requirements are specified for stainless steel cutlery and silver-plated nickel-silver or silver-plated stainless steel cutlery. This standard does not cover cutlery wholly made of precious metals, aluminium, non-stainless steel or that made entirely of plastics, nor does it cover gold-plated or chromium-plated cutlery except for chromium-plated sharpening steels. However, cutlery incorporating sterling silver caps and ferrules or unplated nickel-silver rivets and caps are within the scope of this standard.

Composition limits are specified for steels and non-ferrous metals for cutlery.

Requirements are specified for non-metal handles made from the more commonly used materials (see 4.2.4), but not those made from exotic materials such as ivory or mother-of-pearl. The standard includes requirements for cutlery with non-metal handles for use in a dishwashing machine.

In the case of silver-plated cutlery, three minimum average thicknesses are specified, first, second and third class, with decreasing thickness of the silver deposit.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this British Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. For undated references, the latest edition of the publication referred to applies.

BS EN 10109-1, *Metallic materials — Hardness test — Rockwell test (scales A, B, C, D, E, F, G, H, K) and Rockwell superficial test (scales 15 N, 30 N, 45 N, 15 T, 30 T and 45 T)*.

BS EN ISO 2177, *Metallic coatings — Measurement of coating thickness — Coulometric method by anodic dissolution*.

BS EN ISO 1463, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method*.

BS EN ISO 3543, *Metallic and non-metallic coatings — Measurement of thickness — Beta backscatter method*.

BS EN ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*.

BS 498, *Specification for rasps and engineers' files*.

BS 2782-1:Method 120C, *Determination of the 1/10 Vicat softening temperature of thermoplastics*.

BS 1006, *Methods of test for colour fastness of textiles and leather*.

ISO 4481:1977, *Cutlery and flatware — Nomenclature*.

ISO 3497, *Metallic coatings — Measurement of coating thickness — X-ray spectrometric methods*.

3 Definitions

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

3.1

items of frequent use

pieces of cutlery regularly used at the dining table such as: coffee or teaspoon; soup spoon; dessert spoon; menu spoon; table spoon; dessert fork; menu fork; fish-eating fork; table fork; dessert knife; menu knife; fish-eating knife; table knife

3.2

items of infrequent use

pieces of cutlery which are occasionally used at the dining table. These items are defined in ISO 4481:1977 and exclude those listed in 3.1

3.3

significant surfaces

parts of cutlery in contact with a flat horizontal surface upon which they are laid; for spoons, forks and ladles this will be the convex face, i.e. their bowls or fork prongs are uppermost; for knives both sides are regarded as having significant surfaces

3.4

unsharpened knives

knives that do not have a sharpened blade because they are intended for use with soft foods such as fish, butter, tart and cake and whose blades are therefore not made of martensitic stainless steel

4 Materials and their applications

4.1 General

Table cutlery shall be made from materials that enable the finished cutlery to meet the performance requirements of clause 7 and shall be in accordance with 4.2 and 4.2.4 as appropriate.

4.2 Metals

4.2.1 The composition of metal parts of steel table cutlery shall be as given in Table 1.

The composition of nickel-silver for spoons, forks, ladles, unsharpened knives, carving forks, sharpening steels, caps, ferrules and rivets shall be as follows:

- Cu: 60.0 % min.;
- Ni: 9.0 % min.;
- Mn: 0.50 % max.;
- Fe: 0.30 % max.;
- Pb: 0.05 % max.;
- Total impurities 0.50 % max.;
- Zn remainder.

Silver coatings, caps and ferrules shall have a minimum silver content of 92,5 %.

NOTE Some of the British Standard materials that meet the relevant composition requirements are given in annex A.

4.2.2 Any parts of table cutlery made of nickel-silver (copper-zinc-nickel-alloy) shall be silver-plated in accordance with clause 6 except that caps and rivets made from nickel-silver as specified in 4.2.1 need not be plated.

4.2.3 Any parts of cutlery made of stainless steel and silver-plated shall be in accordance with clause 6.

NOTE The non-stainless steel parts of sharpening steels may be chromium-plated.

4.2.4 Non-metal handles shall be made of plastics, wood, wood-plastics laminates, impregnated wood, ceramics or stag horn or any material such that the finished cutlery conforms to the relevant performance requirements of clause 7. Handles which are superficially protected by paint, varnish lacquer or a similar coating shall meet the requirements of clause 7.