

Specification for

Trade cutlery for use with food

UDC 641.544.22.024 + 672.7

NO COPYING WITHOUT BSI PERMISSION EXCEPT AS PERMITTED BY COPYRIGHT LAW



Document Sharing Hub

Committees responsible for this British Standard

The preparation of this British Standard was entrusted by the Furniture and Household Equipment Standards Committee (FHM/-) to Technical Committee FHM/17 upon which the following bodies were represented:

- British Hotels and Restaurants and Caterers' Association
- British Retailers Association
- Consumer Standards Advisory Committee of BSI
- Crown Suppliers
- Cutlery and Allied Trades Research Association
- Cutlery and Silverware Association
- Institute of Trading Standards Administration
- Local Authorities Management Services and Computer Committee
- Mail Order Traders Association of Great Britain
- Metal Finishing Association
- National Federation of Self-Employed and Small Businesses Ltd.

This British Standard, having been prepared under the direction of the Furniture and Household Equipment Standards Committee, was published under the authority of the Board of BSI and comes into effect on 30 January 1987

© BSI 12-1999

The following BSI references relate to the work on this standard:
Committee reference FHM/17
Draft for comment 85/39106 DC

ISBN 0 580 15623 0

Amendments issued since publication

Amd. No.	Date of issue	Comments
5619	April 1987	Indicated by a sideline in the margin

Contents

	Page
Committees responsible	Inside front cover
Foreword	ii
1 Scope	1
2 Definitions	1
3 Materials and their applications	1
4 Construction	2
5 Performance	2
6 Marking and labelling	4
Appendix A Method of test for corrosion resistance of sterilizable grade cutlery	5
Appendix B Method of test for strength of knives and carving forks	6
Figure 1 — Apparatus for corrosion test	5
Figure 2 — Strength test apparatus for knives and carving forks	6
Figure 3 — Determination of angle of permanent deformation	7
Table 1 — Metals for trade cutlery	1
Table 2 — Test forces for strength and for firmness of handle attachment	3
Publications referred to	Inside back cover

Foreword

This British Standard has been prepared under the direction of the Furniture and Household Equipment Standards Committee. It supersedes BS 4038 which is withdrawn.

BS 4038 was published in 1966 as a specification for cutlery for use by local authorities, hospitals and other public bodies and included requirements for table cutlery. With the publication of the first edition of BS 5577 in 1978 the material and performance requirements of BS 4038 for table cutlery were superseded, and withdrawn by amendment, leaving only standard patterns specified for these items.

This standard deals only with performance requirements for trade cutlery, as it has been established that there is no longer a need to specify standard patterns for cutlery. BS 4038:1966 is therefore withdrawn.

Two grades of trade cutlery are considered in this standard; a “standard” grade and a sterilizable grade. The latter possesses enhanced corrosion resistance and handles of sterilizable material. To distinguish between them, the sterilizable grade is required to be marked with a capital letter “S”.

This standard does not cover features that are matters of personal choice for the user such as the flexibility of knife and spatula blades or requirements for blade sharpness, which is normally individually adjusted by the professional using a sharpening stone or steel.

Methods of test are described in Appendix A and Appendix B.

No meaningful test for the resistance of a trade knife to fracture in use could be developed for this standard. However, it is considered that the possibilities for this can be partially assessed from the appearance of cracks in the initial visual inspection or in the drop testing requirements for knives and, for sterilizable grade items, in the corrosion test.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 8, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

1 Scope

This British Standard specifies material and performance requirements for trade cutlery that is intended for use in the preparation and cooking of food.

Two grades of trade cutlery are specified; a standard grade and a sterilizable grade with corrosion resistant blades, or prongs, and with handles that are capable of withstanding sterilization processes in aqueous solutions at 100 °C.

NOTE The titles of the publications referred to in this standard are listed on the inside back cover.

2 Definitions

For the purposes of this British Standard the following definition applies.

trade cutlery (for use with food)

cutlery that is used professionally by such persons as abattoir workers, butchers, cooks and fishmongers. This includes such items as knives, spatulas, palettes, carving forks and sharpening steels

3 Materials and their applications

3.1 General

Trade cutlery shall be made from materials that enable the finished cutlery to comply with clause 5 and that comply with 3.2 or 3.3 as appropriate.

NOTE Attention is drawn to Statutory Instrument SI 1978 No. 1927 "Materials and Articles in Contact with Food Regulations".

3.2 Metals

The composition of metal parts of trade cutlery shall be as given in Table 1. Metals appropriate for the manufacture of sterilizable grade cutlery shall also be acceptable for the metal parts of standard grade cutlery.

3.3 Non-metals

Non-metal parts of trade cutlery shall be made of plastics, wood, wood-plastics laminates or impregnated wood such that the finished cutlery complies with the relevant requirements of clause 5. Non-metal parts shall not be superficially protected by paint, varnish, lacquer or similar coating.

Table 1 — Metals for trade cutlery

Applications	Standard grade	Sterilizable grader ^b
Knife blades with a cutting edge	Steel containing: 0.60 % minimum carbon 0.035 % maximum sulphur 0.035 % maximum phosphorus	Martensitic stainless steel containing: 12 % minimum chromium 0.40 % minimum carbon 0.030 % maximum sulphur 0.040 % maximum phosphorus
Blades of spatulas and other cutlery without a cutting edge and carving fork prongs	Steel containing: 0.45 % minimum carbon 0.035 % maximum sulphur 0.035 % maximum phosphorus	Austenitic stainless steel containing: 17 % minimum chromium 8 % minimum nickel 0.070 % maximum carbon 0.030 % maximum sulphur 0.045 % maximum phosphorus Martensitic stainless steel containing: 12 % minimum chromium 0.26 % minimum carbon 0.030 % maximum sulphur 0.040 % maximum phosphorus
Sharpening steel blades	Steel containing: 1.10 % minimum carbon 0.035 % maximum sulphur 0.035 % maximum phosphorus	Non-stainless steel containing: 1.10 % minimum carbon 0.030 % maximum sulphur 0.035 % maximum phosphorus and subsequently hard chromium plated
Handle rivets, guards, swivels, shackles and hanging hooks or rings	Steel ^a , brass ^a , bronze ^a , nickel-silver ^a or aluminium alloy	Stainless steel, brass ^a , bronze ^a , nickel-silver or aluminium alloy
Other exposed metal parts of handles	Steel	Stainless steel

^a These may subsequently be chromium plated with an undercoat of nickel and, in the case of steel, copper.

^b These may also be used for the metal parts of standard grade trade cutlery.