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SPECIFICATION FOR SPOONS, STAINLESS STEEL

(Second Revision)

(Incorporating Amendment No. 1)

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

Price Group 3

Indian Standard

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Indian Standard

SPECIFICATION FOR SPOONS, STAINLESS STEEL

(Second Revision)

0. FOREWORD

0.1 This Indian Standard (Second Revision) was adopted by the Indian Standards Institution on 29 January 1982, after the draft finalized by the Cutlery Sectional Committee had been approved by the Consumer Products and Medical Instruments Division Council.

0.2 This standard was first published in 1957, and was subsequently revised in 1964 to cover soup spoons in place of egg spoons and to incorporate Metric Units. In view of the experience gained through its implementation by the industry as well as the consumers during past years a number of suggestions were received. This second revision incorporates manufacturing tolerances for dimensions and certain other modifications necessary for the effective implementation of the standard.

0.3 This standard deals with the requirements for spoons made of stainless steel. Designs other than those covered by this standard are also popular with certain users to suit aesthetic requirements. In such cases, it is recommended that the spoons may be made according to the designs of individual users but other provisions of this standard shall apply to guide the manufacturer and the purchaser. An important aspect of table cutlery is that the different items in a set, such as spoons, forks and knives should match in shape and appearance. This factor is to be borne in mind by the manufacturers when supplying cutlery in sets.

0.4 This edition 3.1 incorporates Amendment No. 1 (June 1988). Side bar indicates modification of the text as the result of incorporation of the amendment.

0.5 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS : 2-1960*. The number of significant places retained in the rounded-off value should be the same as that of the specified value in this standard.

*Rules for rounding off numerical values (*revised*).

1. SCOPE

1.1 This standard covers the requirements for the following types of spoons made of stainless steel by forging or pressing or a combination of two processes:

a) Serving spoon, large;

b) Serving spoon;

c) Dessert spoon;

d) Tea spoon, large;

e) Tea spoon, small;

f) Coffee spoon;

g) Soup spoon;

h) Mustard spoon; and

j) Salt spoon.

2. MATERIAL

2.1 The stainless steel used for the manufacture of spoons shall conform to Designation 07Cr18Ni9 of IS : 1570 (Part V)-1972* or IS : 5522-1978†.

3. DESIGNATION

3.1 The designation of a spoon shall indicate:

a) Type of spoon, and

b) Number of this standard.

Example:

A serving spoon made of stainless steel shall be designated as:

Serving Spoon, SS IS : 990

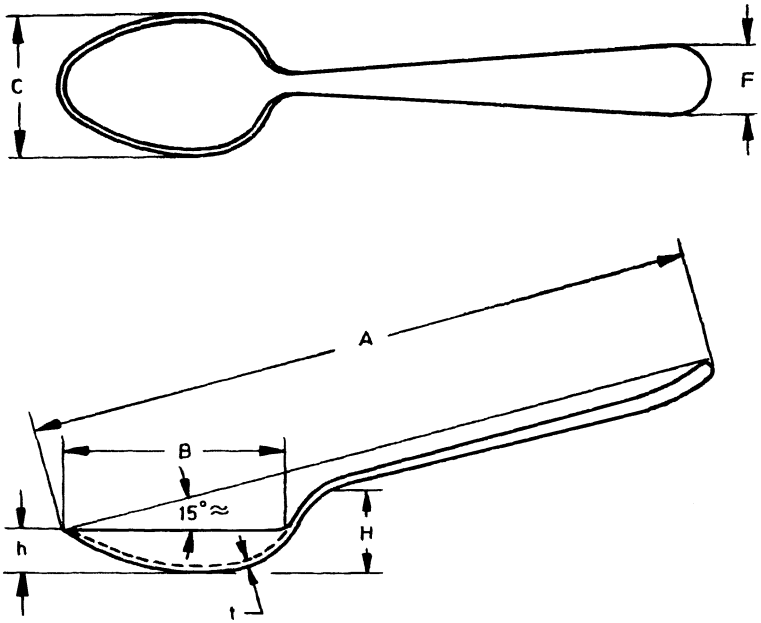
4. DIMENSIONS

4.1 The spoons shall conform to the dimensions given in Fig. 1 to 4. The spoons may have decorative designs on the upper region of the handle subject to agreement between the manufacturer and the purchaser.

NOTE — When spoons are required to be supplied in sets alongwith forks and knives, the design of the handles and general appearance of the items in a set shall match.

*Schedules for wrought steels: Part V Stainless and heat-resisting steels.

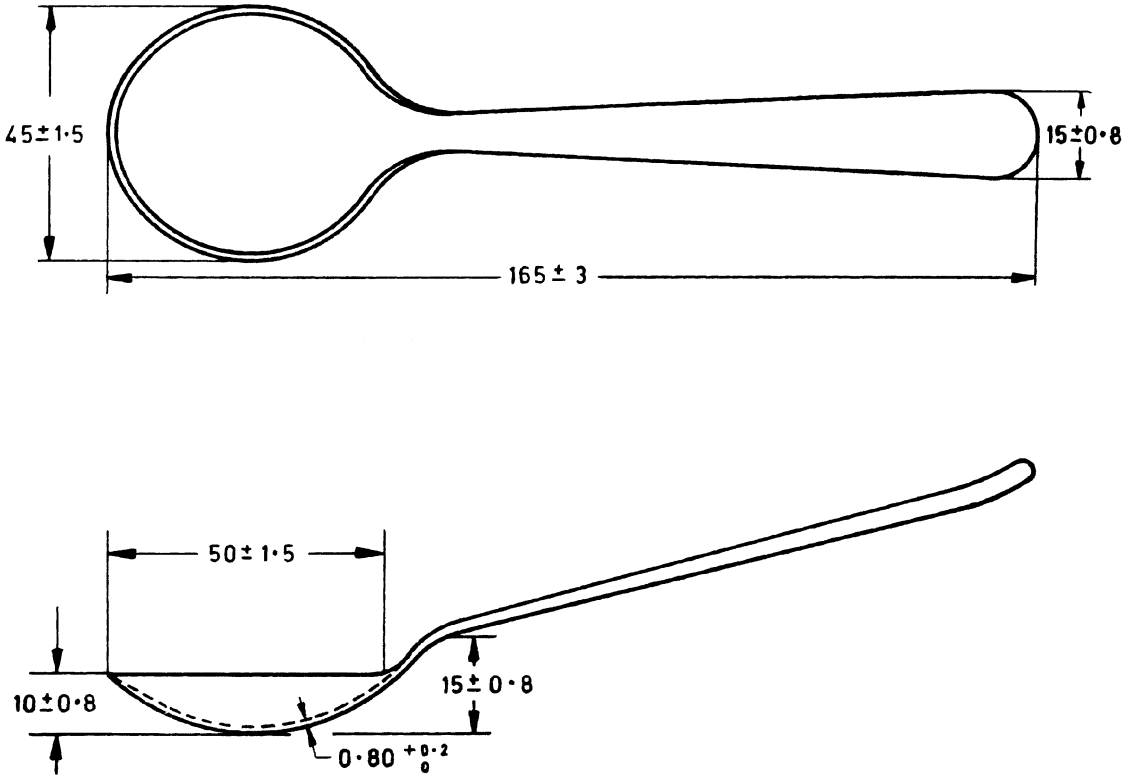
†Specification for stainless steel sheet and coils.



SIZE	*A* ± 3.0	*B* ± 1.5	*C* ± 1.5	*h* ± 0.8	*F* ± 0.8	*H* ± 0.8	*t* + 0.2 − 0.0
Serving spoon, large	275	90	54	16	28	20	1.25
Serving spoon	210	70	45	12	18	18	0.80
Dessert spoon	180	62	40	11	16	15	0.80
Tea spoon, large	160	54	33	10.5	16	14	0.80
Tea spoon, small	135	46	30	10	13	13	0.80
Coffee spoon	110	36	22	6	11	10	0.80

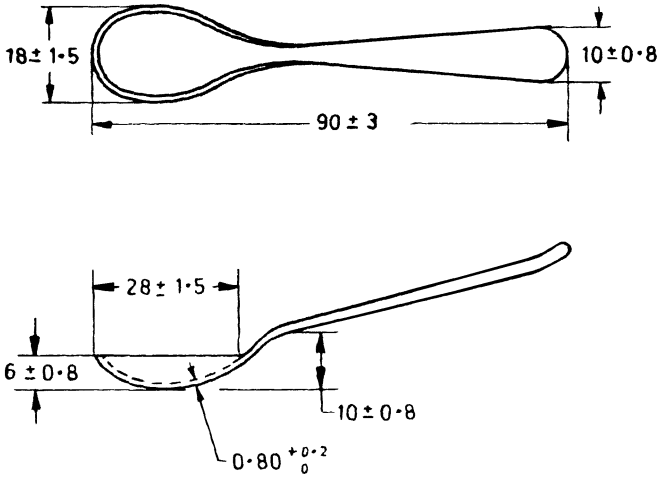
All dimensions in millimetres.

FIG. 1 SERVING, DESSERT, TEA AND COFFEE SPOONS



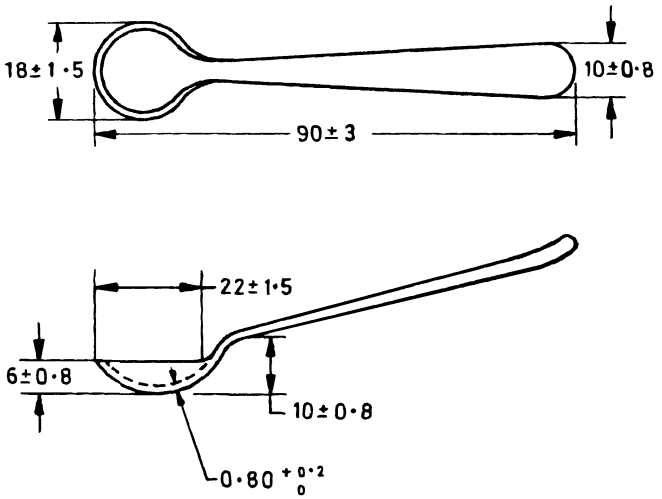
All dimensions in millimetres.

FIG. 2 SOUP SPOON



All dimensions in millimetres.

FIG. 3 MUSTARD SPOON



All dimensions in millimetres.

FIG. 4 SALT SPOON

5. MANUFACTURE, WORKMANSHIP AND FINISH

5.1 The spoons shall be forged and/or pressed to shape in one piece. Spoons shall be free from burrs, seams, cracks and other manufacturing defects. All edges shall be well rounded. The handle and the bowl shall be in proper alignment. The spoons shall be finished smooth and polished all over.

6. TESTS

6.1 Staining Test — The spoon, when dipped for 16 h in each of the following solutions, shall not show any sign of staining after removal from each solution at the end of above period:

a) Ten grams of analytical grade acetic acid conforming to IS : 695-1975* dissolved in distilled water conforming to IS : 1070-1977† to make 100 ml, and

b) Five grams of pure sodium chloride conforming to IS : 4408-1967‡ dissolved in distilled water to make 100 ml.

6.2 Bending Test — The spoon shall be clamped at middle of the handle in a vice. It shall be bent around a mandrel (having diameter equal to 2 × thickness of the handle approximately) through 180° over the handle. There shall be no cracking or breakage.

6.3 Load Test — The spoon shall be held tightly from its handle end and supported in the middle of the length in such a way that the handle is approximately horizontal. A load of 25 N (2.5 kgf) in case of forged handle and 15 N (1.5 kgf) in case of pressed handle, flat shall then be applied by the extreme end of the bowl for two minutes, and then removed. There shall not be a permanent set of more than 1 mm.

7. MARKING

7.1 Each spoon shall be legibly and indelibly marked by stamping on the underside of the handle with the letters 'stainless steel' or 'SS' and manufacturer's name or initials or trade-mark. The marking shall be as far away from the neck as convenient.

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*Specification for acetic acid (*second revision*).

†Specification for water for general laboratory use (*second revision*).

‡Specification for sodium chloride, analytical reagent.

7.1.1 The spoons may also be marked with the ISI Certification Mark.

NOTE — The use of the ISI Certification Mark is governed by the provisions of the Indian Standards Institution (Certification Marks) Act and the Rules and Regulations made thereunder. The ISI Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well-defined system of inspection, testing and quality control which is devised and supervised by ISI and operated by the producer. ISI marked products are also continuously checked by ISI for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the ISI Certification Mark may be granted to manufacturers or processors, may be obtained from the Indian Standards Institution.

8. SAMPLING

8.1 The number of spoons to be selected from a lot for ascertaining conformity to this specification shall be as agreed to between the manufacturer and the purchaser. A suitable sampling scheme and criteria for conformity for spoons are given in Appendix A.

9. PACKING

9.1 The spoons shall be wrapped in soft tissue paper or wax paper and packed in cartons. The number of spoons to be packed in one carton shall be at the discretion of the manufacturer. The cartons shall bear the type and number of spoons packed, the name of the manufacturer and the country of manufacturer.

9.2 The spoons may also be wrapped in polythene bags.

APPENDIX A

(*Clause* 8.1)

SAMPLING SCHEME AND CRITERIA FOR CONFORMITY FOR SPOONS

A-1. SCALE OF SAMPLING

A-1.1 Lot — In any consignment, all spoons of the same type of handle, shape and size manufactured from the same material under relatively similar conditions of manufacture shall be grouped together to constitute a lot.

A-1.2 For ascertaining the conformity to the requirement of this specification, the tests shall be conducted separately for each lot.

A-1.3 The number of spoons to be selected from a lot for ascertaining conformity with the requirements of this specification shall be

according to col 2 of Table 1. The spoons in the sample shall be selected at random from the lot. If the spoons are packed in cartons, as a first step at least 25 percent of the cartons shall be selected at random and then from each selected carton, equal number of spoons shall be taken out at random so as to make the required sample size.

A-2. NUMBER OF TESTS AND CRITERIA FOR CONFORMITY

A-2.1 The spoons selected at random according to **A-1.3** shall be examined for the requirements of **4.1** and **5.1**. A spoon failing to satisfy any one or more of these requirements shall be regarded as defective. The lot shall be considered as conforming to the requirements of **4.1** and **5.1** if the number of defective spoons in the sample does not exceed the number given in col 3 of Table 1.

TABLE 1 SCALE OF SAMPLING AND PERMISSIBLE NUMBER OF DEFECTIVES

(*Clause* A-1.3)

No. of Spoons in a Lot	Sample Size	Permissible Number of Defective Spoons	Sub-Sample Size	Permissible Number of Defective Spoons
(1)	(2)	(3)	(4)	(5)
Up to 50	5	0	2	0
51 ,, 150	13	1	4	0
151 ,, 500	32	3	6	0
501 ,, 1 000	50	5	8	0
1 001 ,, 3 000	80	7	12	1
3 001 ,, 10 000	125	10	16	1
10 001 ,, and above	200	14	20	2

A-2.2 If the lot conforms to the requirements of **4.1** and **5.1**, a sub-sample of size given in col 4 of Table 1 shall be taken from the spoons selected as in **A-1.3**. Each of the spoons in the sub-sample shall be tested for the requirements of **6.1**, **6.2** and **6.3**. A spoon not satisfying any one or more of the requirements of **6.1**, **6.2** and **6.3** shall be regarded as defective. The lot shall be considered to conform to the requirements of **6.1**, **6.2** and **6.3** if the number of defectives in the sub-sample does not exceed the number given in col 5 of Table 1.

Bureau of Indian Standards

BIS is a statutory institution established under the *Bureau of Indian Standards Act*, 1986 to promote harmonious development of the activities of standardization, marking and quality certification of goods and attending to connected matters in the country.

Review of Indian Standards

Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the latest issue of 'BIS Catalogue' and 'Standards : Monthly Additions'.

This Indian Standard has been developed by Technical Committee : CPDC 6 and amended by CPDC 34

Amendments Issued Since Publication

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