



INTERIM Q-STANDARD FOR CUTLERY ver. 1

Document Number: AA-981428-1

Purpose

Purpose of this document is to clarify quality acceptance criteria for cutlery segment in interim period.

Review of the interim standard will be held in November 2013. Permanent standard will be released December 1st 2013. Damages such as scratches, friction marks, jig marks etc derived from internal damage can and should be avoided.

1. General

Material: shall follow what described in TED;

Hardness: shall follow what described in TED;

Roughness: shall follow what described in TED;

2. Defect classification:

Critical: any defects which are either hazard to users, no function or violate local regulation/laws;

Major: Any defects which cause serious customer dissatisfaction, return of goods, or functionally imperfection;

Remark: Any non-conformance which may dissatisfy the customer but not affect immediate purchasing decision;

Below Tolerances are valid only for REWORKED Item, which will be marked with specific dates at mp.

	High	Medium	Low	BTI
1 centre displacement at length				
<180mm	±1.0mm	±1.5mm	±2.0mm	±2.5mm
<250mm	±1.5mm	±2.0mm	±2.5mm	±3.0mm
>250mm	±1.5mm	±2.5mm	±3.0mm	±3.5mm
2 Allowed deviation dimension at nominal value				
<0.8mm	NOT ALLOWED	NOT ALLOWED	NOT ALLOWED	NOT ALLOWED
>0.9mm-<1.5mm	±0.2mm	±0.2mm	±0.2mm	±0.2mm
>1.5mm-<6.0mm	±0.3mm	±0.5 mm	±0.7mm	±1.0mm
>6.0mm-<50.0mm	±0.5mm	±0.7mm	±1.0mm	±1.2mm
>50.0mm-<120.0mm	±0.7mm	±1.0mm	±1.2mm	±1.5mm
>120.0mm-<250.0mm	±1.0mm	±1.2mm	±1.5mm	±2.0mm
>250.0mm-<500.0mm	±2.0mm	±2.2mm	±2.7mm	±3.0mm
3Bowl tip and neck	±0.5mm	±2.0mm	±2.5mm	±3.0mm



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Sampling plan

Size (cm)	Inspection method	QTY/Pallet	Pallet Qty	Sampling qty	Remarks [remark unit*]			Major defect		Critical defect	
					OK	Increase sampling	Reject/ Full inspection	OK	Reject/ Full inspection	OK	Reject/ Full inspection
S20	Normal	202	8	12 set	4 set	5 set	6 set	0 pcs	1 pcs	0 pcs	1 pcs
	Increase sampling			12 set	4 set		5 set				
	Total			24 set	9 set		10 set				
S60	Normal	144	4	8 set	4 set	5 set	6 set	0 pcs	1 pcs	0 pcs	1 pcs
	Increase sampling			8 set	4 set		5 set				
	Total			16 set	9 set		10 set				
S24	Normal	220	6	10 set	4 set	5 set	6 set	0 pcs	1 pcs	0 pcs	1 pcs
	Increase sampling			10 set	4 set		5 set				
	Total			20 set	9 set		10 set				
S6 Spoon /fork	Normal	156	30	20 set	4 set	5 set	6 set	0 pcs	1 pcs	0 pcs	1 pcs
	Increase sampling			20 set	4 set		5 set				
	Total			40 set	9 set		10 set				
S6 knife	Normal	1800	3	25 set	4 set	5 set	6 set	0 pcs	1 pcs	0 pcs	1 pcs
	Increase sampling			25 set	4 set		5 set				
	Total			50 set	9 set		10 set				

* Remarks calculation:

- S6 – the 1 remark set: consumer box with 1-2 remark items. If 3 remarks in one consumer box calculate as 1 **major** defect.
- S20 – the 1 remark set: consumer box with 1-3 remarks items. If 4 remarks in one consumer box calculate as 1 **major** defect.
- S24 – the 1 remark set: consumer box with 1-4 remarks items. If 5 remarks in one consumer box calculate as 1 **major** defect.



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d) S60 - the 1 remark set: consumer box with 1-10 remarks items. If 11 remarks in one consumer box calculate as 1 **major** defect.

3. SURFACE DEFECTS CRITERION

Non -conformance	position	description	Defect		Remarks
			critical	major	
Sharp edge	All surface except the blade with serration part of knife	The R shall refer to the approved sample and pass the sharp edge tester based on EN71.	√		
Sharp prong	Fork prong end	Refer to the reference sample and drawing. Must be a flat surface on top with safe edge.	√		
Rust	All	<p>Knife: According to section 7.1 in ISO 8442-2 Fork: Evaluation of grinded surfaces in between prong According to section 7.1 in ISO 8442-2 (3h) Other surface of fork/spoon: IOS-MAT-0066</p> <p><u>Supplier responsible for the rust caused by poor workmanship.</u></p> <p><i>Definition of poor workmanship:</i> <i>Roughness and rough edges</i> <i>Deep scratches</i> <i>Poor polishing</i> <i>Cracks</i> <i>Press marks</i></p>	√		
Cut surface	Cut surface between prongs	<p>Finish and bright grinded surface on full length with small variation or uneven profile, refer to reference samples, remark (interim accepted)</p> <p>Large variation then above that may influenced corrosion resistance – major</p>		√	√
Crack marks	All	No crack marks are allowed	√		



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Roughness	knife neck	On the neck area, refer to approved samples, for other areas, according to specification.		√	√
	Spoon/fork neck			√	√
	Other areas			√	√
Wax remain	blade surface	no more than 2 spots≤0.5mm allowed, several spots<0.3mm allowed			√
	knife handle surface				√
	knife edge				√
	teeth of knife	no more than 2 spots≤0.5mm allowed			√
	Spoon & fork handle	no more than 2 spots≤0.5mm allowed, several spots<0.3mm allowed			√
	Spoon & fork top				√
					√
	fork teeth	no more than 2 spots≤0.5mm allowed			√
Friction mark	all over	more than 5mmx5mm marks on A surface or two marks less than 5mmx5mm from 70cm far away obvious: remark (less than above interim accepted)			√
Pin holes	Spoon bowl front side/fork head front side/knife blade	Visible from one 70cm distance, major;		√	
	All other parts	Front: no more than 3 pin hole no larger than 0.3mm allowed, as long as overall appearance is not compromised, (interim accepted) Back: one pin hole no larger than 0.6mm or up to 3 pin holes no larger than 0.3mm are allowed(interim accepted) Front/back: more than 3 holes no larger than 0.6 or multiple pin holes equal a bad surface – (interim remark)			√
Scratch	all over	70cm distance, visible scratches that is not repetitive and deep, longer than 2 cm (interim remark). Less than above (interim acceptable)			√
Deep scratch		If the scratch can be detected by nail, major.		√	
Logo clear	spoon & fork	70cm distance: -if any word totally unreadable, major; -if some part of word removed, but still readable,		√	√



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		remark.			
Crack	all over	not allowed	√		
Over polishing	all over	not allowed, refer to approved sample		√	

4. REMARKS

During interim period remarks **marked yellow** in point no.5 are within **acceptance criteria**. We must underline that **these surfaces must** be clean after the ultra sonic bath (no oil, polishing wax remaining) in order to retain the corrosion properties.