

Aluminium hollowware utensils — Specification

Part 1:

Aluminium cooking pots (suffuria) and lids

PUBLIC REVIEW DRAFT

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Part 1:

Aluminium cooking pots (suffuria) and lids

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Foreword

This Kenya Standard was prepared by Cutlery and Table Metal Hollowware Technical Committee under the guidance of the Standards Projects Committee, and it is in accordance with the procedures of the Kenya Bureau of Standards.

The fourth revision is undertaken to cater for heavy duty, the large sized cooking pots which are suitable for commercial, institutional and communities use. This ensures safe use by consumers through specifying chemical composition of the materials suitable for food preparation and storage. The standard shall ensure harmonization of differing dimensions of aluminium cooking pots and lids currently in the domestic market.

The material used in the manufacture of suffuria and lids shall comply with the requirements of KS 460¹

¹⁾ Specification for uncoated aluminium plate, sheet and strip for hollow-ware cooking utensils.
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Aluminium hollowware utensils — Specification

Part 1:

Suffuria and lids

1 Scope

This Kenya Standard specifies the materials, construction and the preferred sizes of domestic aluminium cooking pots (suffuria) and the lids.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

KS 460 *Kenya Standard Specification for uncoated aluminium plate, sheet and strip for hollow-ware cooking utensils.*

3 Definitions

For the purposes of this standard, the following definitions shall apply:

3.1 Suffuria

a cooking-pot with flange, which has been deep drawn from aluminium blanked circle

3.2 lid

aluminium blanked circle pressed as a cover for the suffuria

3.3 flange

protruding circular part at the top of the shell for ease of handling

3.4 shell

a straight cylindrical body of the suffuria

3.5 aluminium blanked circle

a circular aluminium raw material, which is cut to the required size for production of suffurias and lids.

4 Dimensions

4.1 Thickness

The dimensions and tolerances of suffuria shall be as illustrated in Table 1 and Figure 1.

4.2 The thickness t of a suffuria shall be 0.6 mm (minimum).

4.3 The thickness of a suffuria manufactured from the range given in 3.2 shall not vary by more than $\pm 5\%$.

4.4 The base diameter, D_1 , shall be 170 mm minimum and consecutive sizes shall comply with the requirements of Clause 6.

4.5 The minimum flange diameter, D_2 , shall be 200 mm. Where there is no flange one or more strong handles secured by aluminum rivets shall be provided.

4.6 Lids

The diameter of the suffuria lid D_3 shall be $D_2 + 4.0$ mm minimum as illustrated in Figure 1.

4.7 Height

The minimum height h of suffurias shall be 79 mm.

4.8 The minimum blank size shall be 310 mm.

Table 1 — Dimensions of suffuria body in millimetres and tolerances

Dimensions in millimeters.

Suffuria number	Blank size	Diameter of suffuria D_1	Tolerance	Flange diameter D_2	Tolerance	Height h	Tolerance	Volume litres	Thickness t (min.)
12	310	170		200		80		1.8	0.60
13	330	180	± 2.0	210	± 2.0	90	± 2.0	2.3	
14	360	190		220		100		2.8	
15	380	210		240		105		3.6	
16	410	225		255		110		4.5	
17	430	240	± 2.5	270	± 2.5	115	± 3.0	5.3	0.6
18	460	250		280		120		6.0	
19	480	265		295		125		7.0	
20	510	280		320		130		8.0	
21	530	290	± 2.5	330	± 2.5	150	± 3.0	10.0	0.6
22	560	305		345		165		12.0	
23	580	320		360		175		14.0	
24	610	340		380		165		15.0	
25	640	355	± 3.0	395	± 3.0	170	± 4.0	17.0	1
26	660	370		410		175		19.0	
27	690	380		420		185		21.0	
28	710	395		435		195		24.0	
29	740	405	± 3.0	445	± 3.5	200	± 5.0	26.0	1
30	760	420		460		215		30.0	
31	790	430		480		220		32.0	
32	810	455	± 3.5	505	± 3.5	225	± 5.0	36.5	
33	840	465		515		230		39.0	
34	860	480		530		240		43.0	1.4
35	890	495		545		245		47.0	
36	910	520		570		250		53.0	
38	990	550		580		285		70.0	
40	1040	580		610		295		80.0	
42	1090	605	±3.5	640	±3.5	315	±6.0	90.0	3.0
48	1220	700		750		345		130.0	
50	1270	735		785		355		150.0	
52	1350	760		810		380		170.0	

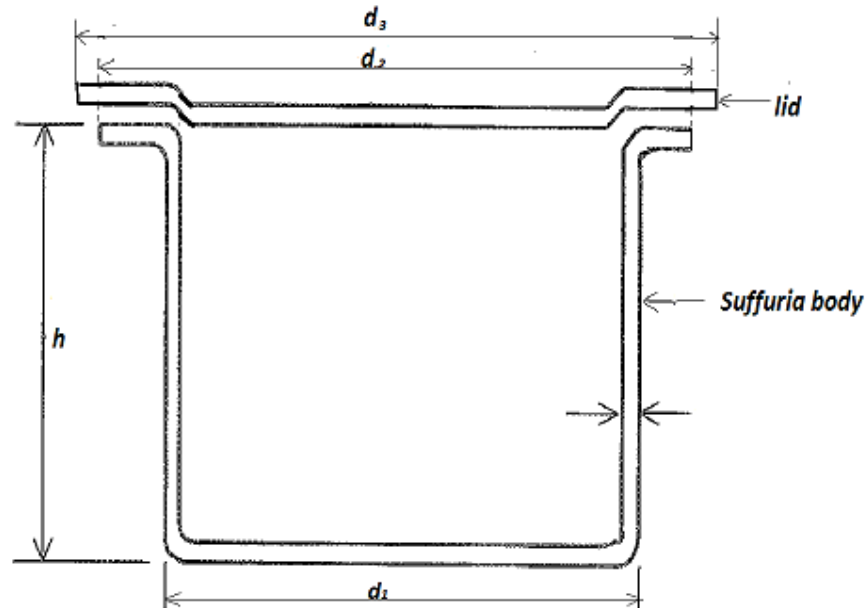


Figure 1 — Typical shape of suffuria with lid

5 Material requirements

The chemical composition of material used in the manufacture of suffuria and lid shall be in accordance with Table 2 and the other requirements shall comply with the requirements to KS 460¹⁾.

Table 2 — Chemical Composition of wrought aluminium and aluminium alloys for manufacture of cooking pots

Composition Element	Composition limits are in %
Aluminium (Al), min.	98.00
Copper, max.	0.1
Iron (Fe), max.	0.95
Silicon (Si), max.	0.95
Manganese (Mn), max.	0.1
Zinc (Zn), max.	0.2
Titanium (Ti), max.	0.2
Magnesium (Mg), max.	0.2
Lead (Pb), max.	0.005
Note: The sum of the composition of all the elements on testing shall be 100 %.	

¹⁾ Specification for uncoated aluminium plate, sheet and strip for hollow-ware cooking utensils.
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6 Construction requirements

6.1 Suffuria Bodies

The manufacturing process shall leave the bodies of the suffuria smooth, free from cracks, splits, scratch lines and free from other defects both inside and outside. No defects shall be made good by filling or patching. The base of cooking pots shall be flat as illustrated in Figure 1 and maybe of a concave curvature as illustrated in Figure 2.

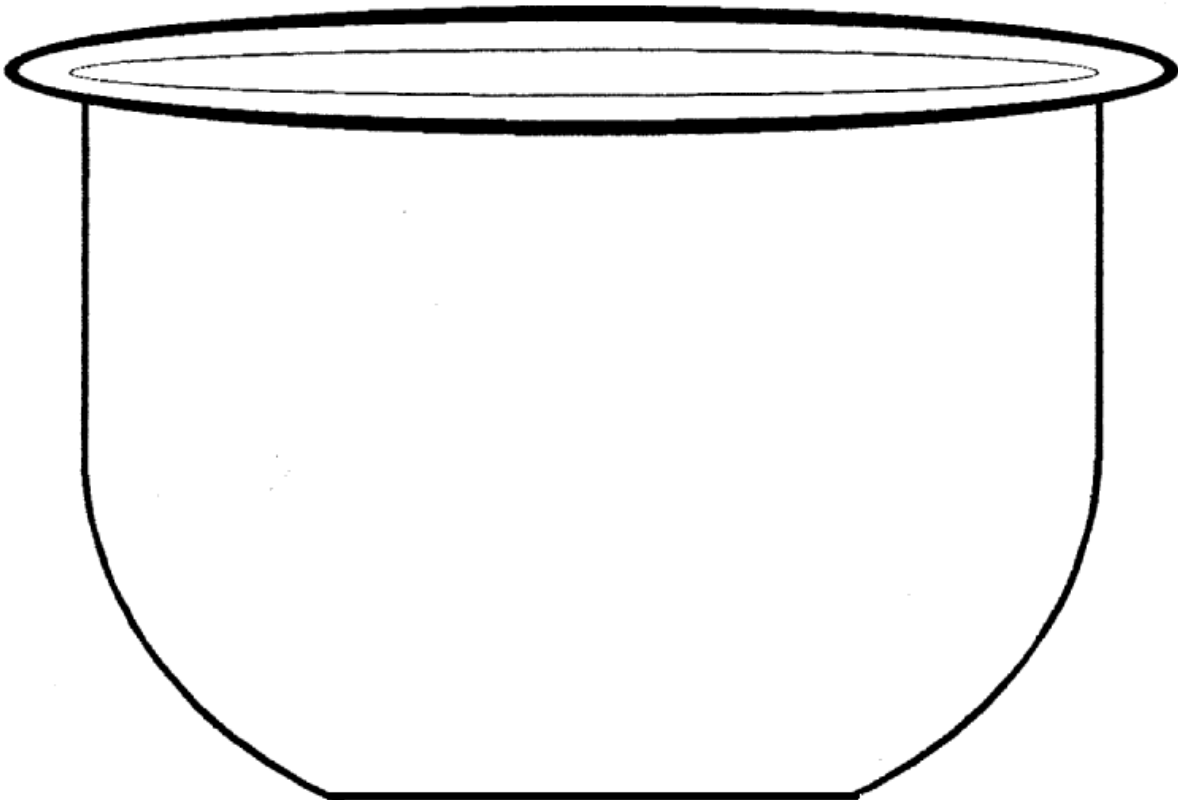


Figure 2 — Typical shape of a curved bottom cooking pot

5.2 Lids

Lids shall be of a similar material to that of the bodies of the suffuria and shall comply with requirements specified in Clause 4. The nominal thickness of metal before forming shall be 0.6 mm to 3.0 mm. Lids shall be shaped in such a way that when placed on the suffuria they will cover the suffuria properly and be easy to handle. Lids shall have a flange and sink inside the body. The flange, skirts or any curves shall be left open enough for them to be cleaned thoroughly.

6 Nesting

Suffuria of consecutive sizes shall fit freely, one inside another. All nested cooking pots shall be of the same gauge/thickness. Cooking pots of different thickness shall not be packed in any given set

7 Finish

The articles shall have a smooth surface, no sharp edges and be thoroughly clean.

8 Marking and packaging

8.1 Marking

Every suffuria shall be legibly and permanently marked externally on the body side with the following particulars:

- a) The manufacturer's name and/or trade mark; and
- b) Country of origin "Made in Kenya" .

8.2 Packaging

8.2.1 Suffuria of consecutive sizes shall fit freely one inside another and packed in a suitable package so as to protect them from damage during handling, storage and transportation. Cooking pots of same thickness shall be packed in any given set.

8.2.2 Every package shall be legibly and permanently marked with the following:

- a) manufacturer's name and/ or trade mark;
- b) address;
- c) description of product i.e. "Suffuria" or "Suffuria with Lids", "Suffuria size";
- d) content in sets and thickness (gauge); and
- e) batch number.