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CEYLON STANDARD 69: 1969

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Ceylon Standard specification for wrought aluminium utensils

ලංකා ප්‍රමිති කාර්යාංශය
BUREAU OF CEYLON STANDARDS

CEYLON STANDARD SPECIFICATION FOR WROUGHT ALUMINIUM UTENSILS

C. S. 69: 1969

(Attached AMD 44)

Gr.5

BUREAU OF CEYLON STANDARDS
53, Dharmapala Mawatha,
COLOMBO 3.

Ceylon Standards are subject to periodical revision in order to accommodate the progress made by industry. Suggestions for improvement will be recorded and brought to the notice of the committees to which the revisions are entrusted.

This Standard does not purport to include all the necessary provisions of a contract.

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CEYLON STANDARD SPECIFICATION FOR WROUGHT ALUMINIUM UTENSILS

FOREWORD

This Ceylon Standard Specification has been prepared by the Drafting Committee on Aluminium hollow-ware. It was approved by the Mechanical Engineering Divisional Committee of the Bureau of Ceylon Standards and was authorised for adoption and publication by the Council of the Bureau on 4th March, 1969.

In this specification two sets of dimensional tables have been provided, one in the Inch-Pound System and the other in the Metric System. The dimensions given in the Metric System are not the equivalents of the corresponding dimensions in the Inch-Pound System but are metric standards that are nearest to the inch dimensions.

Since the useful life of utensils depends not only on the quality of metal used but also on the wall thicknesses, special attention has been given to this aspect.

This specification covers only a few of the utensils used in Ceylon. Further specifications will be issued later to cover other items.

In the preparation of this standard, the Indian, British and Federal specifications were consulted and the assistance gained therefrom is acknowledged.

1. SCOPE

This Specification covers the requirements, quality of material and the wall thickness of some wrought aluminium utensils commonly used for domestic purposes.

2. NOMENCLATURE

Figures 1 to 11 illustrate the utensils covered by this specification. These figures also indicate the manner in which the size of the utensils is to be designated namely by diameter D, depth H or capacity V as appropriate.

3. DESIGN

3·1 The figures illustrate the general shape of the articles described in this specification, but these should not be considered as indicative of definite designs. Utensils shall, however, generally conform to the drawings given herein.

3·2 Each utensil shall be so designed and balanced, that when empty, it shall rest firmly on its base and be stable when placed on a horizontal surface.

4. MATERIAL

Aluminium utensils shall be fabricated from material complying with the requirements of C.S. 68 1969 — Ceylon Standard Specification for Wrought Aluminium Sheet and Strip used in the manufacture of Utensils.

5. WORKMANSHIP

5·1 The utensils shall be free from distortion, cracks, wrinkles, burrs and sharp or raw edges.

5·2 **Handles**

Handles when fitted shall be of aluminium or of other suitable material. Where a stem handle is used it shall be securely fastened to the utensil by not less than three solid aluminium rivets. Handles may also be fitted by screwing to cast bosses. The chemical composition of the rivets shall conform to that of either grade I or grade II wrought aluminium specified in C.S. 68 1969 — Wrought aluminium sheet and strip used in the manufacture of utensils. Handles shall be so shaped and positioned as to provide a comfortable hand grip. When loop handles are used there shall be sufficient hand clearance.

5.2.2 Handles shall be sufficiently strong to support a weight in the utensil, uniformly distributed and equal to three times its water capacity without visible permanent deformation of the handle or utensil.

5.2.3 Saucepans of capacity 6 pints (3.3 litres) and over shall be fitted with an additional support diametrically opposite the main handle.

5.2.4 The lids, where necessary, shall be fitted with a knob or handle made of moulded thermosetting or phenolic plastic material securely attached centrally to the lid.

6. DIMENSIONAL CHARACTERISTICS

6·1 The nominal thickness of the material, the permissible reduction therefrom, diameter and capacity or depth (in the case of the steamer) of the different utensils shall be as given in Tables 2, 3, 4, 5 and 6 or Tables 2M, 3M, 4M, 5M, and 6M.

6·2 The nominal thickness of the material shall be the thickness at the place where little or no work has been done. In checking the reduction in thickness, measurements shall be made at the thinnest place but excluding flanges or sharp corners.

6·3 The capacities specified shall be interpreted to permit a tolerance of $\pm$ 10 per cent.

7. SAMPLING

7·1 Utensils of the same type, diameter and capacity or depth (in the case of the steamer) shall be grouped together to constitute a lot.

7·2 Samples shall be drawn at random in accordance with Table 1.

TABLE 1 — SCALE OF SAMPLING

Size of lot	Size of sample
Up to 25	2
26 to 50	3
51 to 100	4
101 to 200	5
201 and over	5 + one for every additional 200 or part thereof but not exceeding 30

8. EXAMINATION AND TESTS

8·1 Utensils drawn as in Clause 7 shall be examined for the following:

(a) Diameter and capacity or depth,

(b) Thickness of material,

(c) Freedom from defects described in Clause 5.1,

(d) Compliance with the requirements of Clause 5.2 — Handles.

8·2 The sample drawn as in Clause 7 shall be tested for chemical composition of the material of construction.

9. CONFORMITY TO STANDARD

9·1 Any utensil wihich fails to satisfy the general requirements of this standard in any of the above characteristics shall be considered as not conforming to this standard.

9·2 If any of the samples taken as in Clause 7 fails to satisfy the requirements of this specification, the lot represented by the sample shall be deemed not to comply with this specification.

10. MARKING

Each utensil shall be marked in a clear and permanent manner with the manufacturer's name or registered trade mark.

TABLE 2 DIMENSIONS OF FRYING-PANS, SAUCEPANS, STEW-PANS AND MILK-PANS

Inch-Pound System

Article	Ref. to Fig No.	Nominal diameter D	Nominal capacity V	Nominal thickness of material*		Maximum permissible reduction in thickness (Clause 6.2)	Length of handle min.
				Vessel	lid		
		in	pints	in	in	in	in
Frying-pan	1	7	—	0·048	—	0·012	6
		9, 10	—	0·064	—	0·016	8
Saucepan with lid	2	6	3	0·048	0·036	0·012	6
		7	5				
		8	6·5				
		9	10	0·064	0·048	0·016	6½
		10	12				
Stew-pan with lid	3	6	3½	0·048	0·036	0 012	two loop handles
		7	5				
		8	7				
		9, 10	9, 12	0·064	0·048	0·016	
Milk-pan	4	5	1	0·036	—	0·008	6
		6	2				
		7	3				

* The tolerance on nominal thickness shall be as given in the Appendix.

TABLE 3. DIMENSIONS OF POTS, PANS, BOWLS AND BASINS

Inch–Pound System

Article	Ref. to Fig. No.	Nominal diameter D in	Nominal capacity V pints	Nominal thickness of material* vessel in	Nominal thickness of material* lid in	Maximum Permissible reduc ion in thickness (Clause 6.2) in
Pot with or without lid	5	5	1	0·036	0·028	0·008
		7	3½			
		8	5½			
		9	8	0·048	0·036	0·012
		10½	14			
		12	18			
		13	22			
Pan with or without lid	6	5⅓	2	0·036	0·028	0·008
		6½	2½			
		6¾	3			
		7¼	3½			
		8	4½			
		10	9½	0·048	0·036	0·012
Bowl	7	6	1⅓	0·036	—	0·008
		7	2½			
		8	3½			
		9	4½			
Basin	8a & 8b	12	10	0·036	—	0·008
		14	15	0·048	—	0·012
		20	37			

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 4. DIMENSIONS OF PLATES
Inch Pound System

Article	Ref. to Fig. No.	Nominal diameter D in	Nominal thickness of material* in	Maximum permissible reduction in thickness (Clause 6.2) in
Plate	9 10	8 10	0·036	0·008

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 5. DIMENSIONS OF MUGS
Inch-Pound System

Article	Ref. to Fig. No.	Nominal diameter D in	Nominal Capacity V pints	Nominal thickness of material* in	Thickness of handle in	Maximum permissible reduction in thickness (Clause 6.2) in
Mug	10	3 3½	½ 1	0·036	0·064	0·008

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 6. DIMENSIONS OF STEAMERS
Inch-Pound System

Article	Ref. to Fig. No.	Nominal Dia. D in	Depth exclusive of lid H in	Diameters of step-down perforated base in	Nominal thickness of material* vessel in	 lid in	Maximum permissible reduction in thickness (Clause 6.2) in
Steamer	11	8 8	5 7¼	8,7,6	0·036	0·028	0·008

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 2M. DIMENSIONS OF FRYING-PANS, SAUCEPANS, STEW-PANS & MILK PANS.

Metric System

Article	Ref. to Fig. No.	Nominal Diameter D mm	Nominal capacity V litres	Nominal thickness of material* vessel mm	Nominal thickness of material* lid mm	Maximum permissible reduction in thickness (Clause 6.2) mm	Length of handle min. mm
Frying-pan	1	175	—	1·25	—	0·315	150
		225 250	—	1·60	—	0·400	200
Saucepan with lid	2	150	1·75	1·25	0·90	0·315	150
		175	2·75				
		200	3·75				
		225	5·75	1·60	1·25	0·400	165
		250	6·75				
Stew-pan with lid	3	150	2·00	1·25	0·90	0·315	two loop handle
		175	2·75				
		200	4·00				
		225	5·00	1·60	1·25	0·400	
		250	6·75				
Milk-pan	4	125	0·50	0·90	—	0·200	150
		150	1·25				
		175	1·75				

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 3M. DIMENSIONS OF POTS, PANS, BOWLS AND BASINS.

Metric System

Article	Ref. to Fig. No.	Nominal diameter D mm	Nominal capacity V litres	Nominal thickness of material*		Maximum permissible reduction in thickness (Clause 6.2) mm
				Vessel mm	lid mm	
Pot with or without lid	5	125	0·50	0·90	0·70	0·200
		175	2·00			
		200	3·00			
		225	4·50	1·25	0·90	0·315
		265	8·00			
		300	10·25			
		325	12·50			
Pan with or without lid	6	140	1·25	0·90	0·70	0·200
		165	1·50			
		170	1·75			
		180	2·00			
		200	2·50			
		250	5·50	1·25	0·90	0·315
Bowl	7	150	0·75	0·90	—	0·200
		175	1·50			
		200	2·00			
		225	2·50		—	
Basin	8a & 8b	300	5·75	0·90	—	0·200
		350	8·50	1·25	—	0·315
		500	20·00			

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 4M. DIMENSIONS OF PLATES
Metric System

Article	Ref. to Fig. No.	Nominal Diameter D mm	Nominal thickness of material* mm	Maximum permissible reduction in thickness (Clause 6.2) mm
Plate	9	200 225	0·90	0·200

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 5M. DIMENSIONS OF MUGS
Metric System

Articles	Ref. to Fig. No.	Nominal diameter D mm	Nominal capacity V litres	Nominal thickness of material* mm	Thickness of handle mm	Maximum permissible reduction in thickness (Clause 6.2) mm
Mug	10	75 90	0·25 0·50	0·90	1·60	0·200

* The tolerance on the nominal thickness shall be as given in the Appendix.

TABLE 6M. DIMENSIONS OF STEAMERS
Metric System

Article	Ref. to Fig. No.	Nominal Dia. D mm	Depth exclusive of lid H mm	Diameters of step down perforated base mm	Nominal thickness of material*		Maximum permissible reduction in thickness (Clause 6.2) mm
					vessel mm	lid mm	
Steamer	11	200 200	125 180	200, 175, 150	0·90	0·70	0·200

* The tolerance on the nominal thickness shall be as given in the Appendix

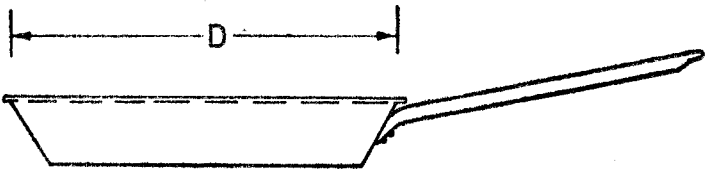

FIG.1.— FRYING-PAN

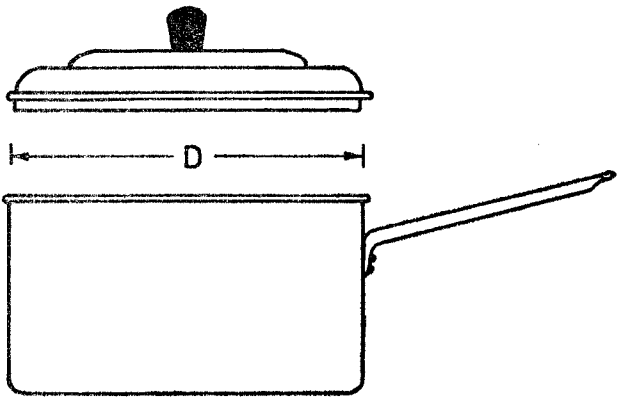

FIG.2.— SAUCEPAN

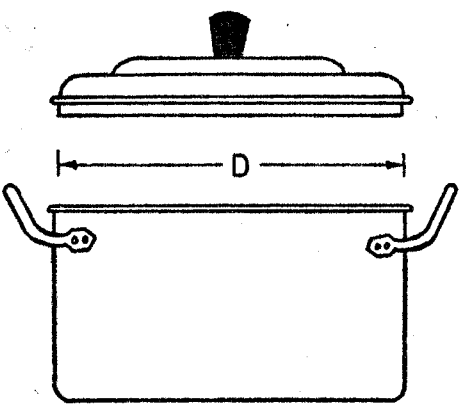

FIG 3.— STEW-PAN

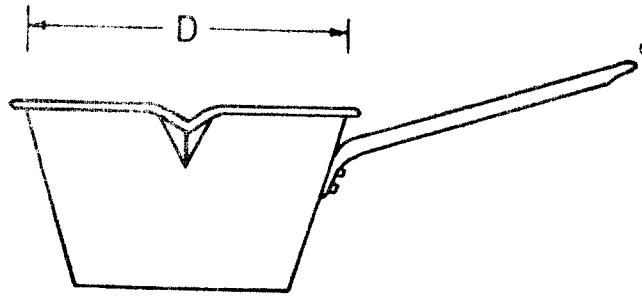

FIG. 4.— MILK - PAN

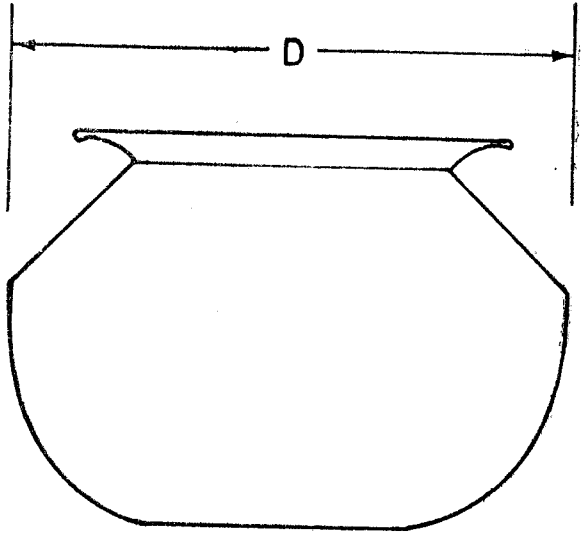

FIG. 5.— POT

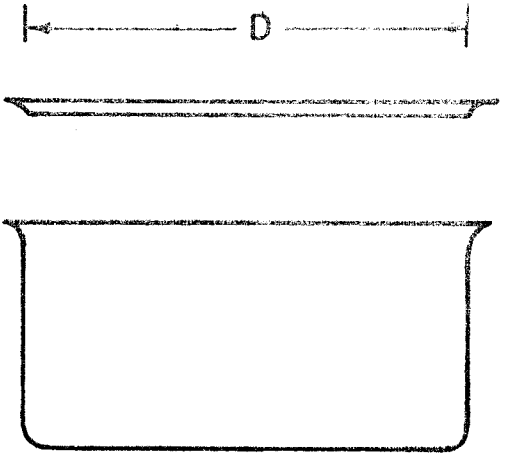

FIG. 6 — PAN

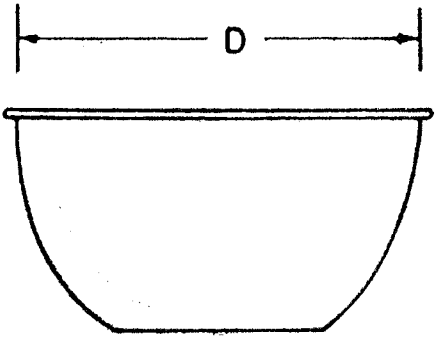

FIG. 7 — BOWL

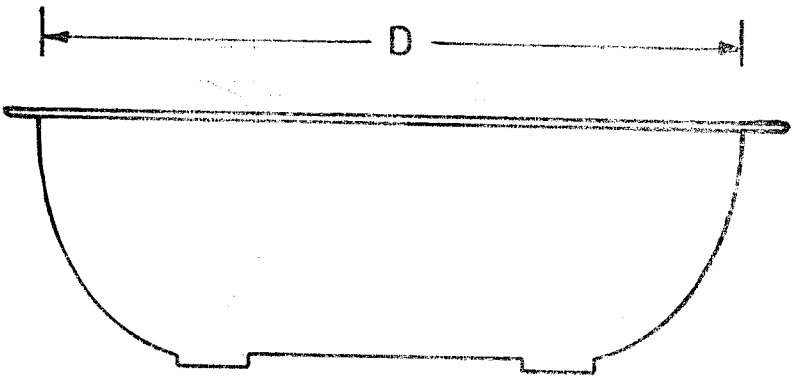

FIG. 8a.— BASIN

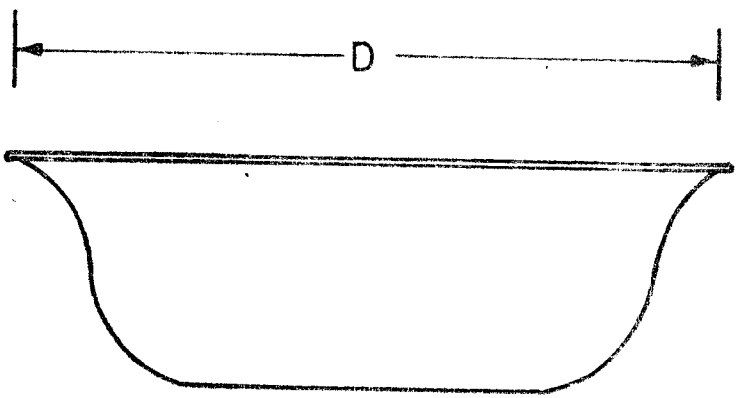

FIG. 8b.— BASIN

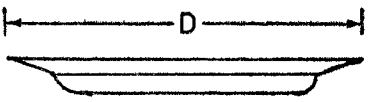

FIG. 9.— PLATE

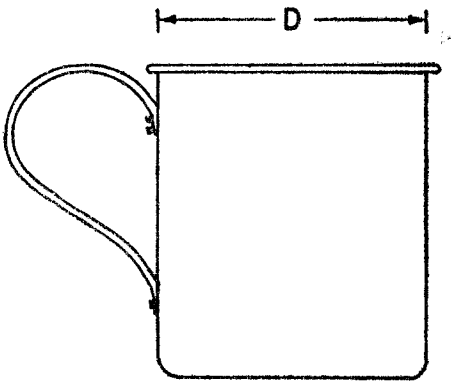

FIG. 10.— MUG

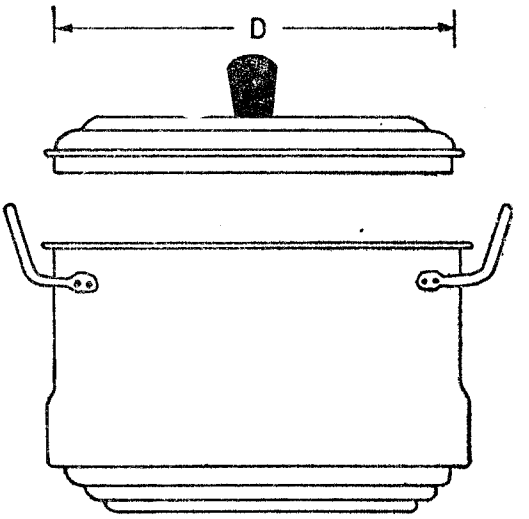

FIG. 11.— STEAMER

APPENDIX

The tolerance on the thickness of sheet shall be as given in Tables A-1 and A-1M below.

TABLE A-1. TOLERANCE ON THICKNESS OF SHEET

Inch-Pound System

Nominal Thickness in	Tolerance	
	Plus in	Minus in
0·028	0·002	0·002
0·036	0·002	0·003
0·048	0·003	0 003
0·064	0·003	0·004
0·072	0·003	0·004

TABLE A-1M. TOLERANCE OF THICKNESS OF SHEET

Metric System

Nominal Thickness mm	Tolerance	
	Plus mm	Minus mm
0·70	0·05	0·05
0·90	0·05	0·08
1·25	0·08	0·08
1·60	0·08	0·10
1·80	0·08	0·10

AMENDMENT NO. 1 APPROVED ON 1981-07-28.

CS 69:1969 SPECIFICATION FOR WROUGHT ALUMINIUM UTENSILS

FOREWORD

Delete the second paragraph and substitute the following:

'All the values of this standard are given in SI units'.

Page 6

Clause 5.2.3

Delete '6 pints (3.3 litres)' and substitute '3.3 litres'.

Clause 6.1

Delete 'Or Tables 2M, 3M, 4M, 5M, and 6M'.

TABLE 2

Delete the whole table.

TABLE 3

Delete the whole table.

TABLE 4

Delete the whole table.

TABLE 5

Delete the whole table.

TABLE 6

Delete the whole table.

TABLE 2M - Dimensions of frying-pans, saucepans, stew-pans & milk-pans

In the heading delete 'Table 2M' and substitute 'TABLE 2' and delete 'Metric System' in the third line.

TABLE 3M - Dimensions of pots, pans bowls and basins

In the heading delete 'Table 3M' and substitute TABLE 3' and delete 'Metric System' in the third line.

TABLE 4M - Dimensions of plates

In the heading delete 'Table 4M' and substitute 'TABLE 4' and delete 'Metric System' in the second line.

TABLE 5M - Dimensions of mugs

In the heading delete 'Table 5M' and substitute 'TABLE 5' and delete 'Metric System' in the second line.

TABLE 6M - Dimensions of steamers

In the heading delete 'Table 6M' and substitute 'TABLE 6' and delete 'Metric System' in the second line.

APPENDIX

Delete the words 'Table A - 1 and A -1M below' and substitute 'Table A - 1' below'.

TABLE A - 1

Delete the whole table.

TABLE A - 1M

In the heading delete 'TABLE A - 1M' and substitute 'TABLE A - 1' and delete 'Metric System' in the third line.

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