

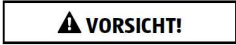


Product specific requirements: 109. Baking Forms

Version: 3.0
Last update: 07.04.2022

Material	Products	Remark
Glass/ Porcelain/ Ceramic/ Metall	Not applicable for: ceese fondu, products from silicon	-



No	Parameter	Methods	Reference	Requirement
General requirements				
1	Workmanship	In House	-	Product and its components has to meet the requirements on design and quality according to information offered by producer. No damages on material: - Without major defects - Without components missing, deformed or fractured - Without hardware missing - smoothly filed / grounded - Without loose components or loosened fastening where rigidity is required - With proper and uniform adhesion in wooden parts - Without flash and consistent in size, color and form for plastic parts - Even in color & clarity
2	Design	EN 13834: 2020, clause 6.1 (construction)	-	The item shall be free from sharp edges, mechanical squeezing and shearing points. Free from burrs, splinters or sharp edge: - Without pits or burrs and weld smoothly filed / grounded - Without scratches, dents, cracks, marred - With finished edges and seams - Evenly aligned in seams and components
3	Labelling	EN 13834: 2020, clause 10 (product information)	SR 817.023.21/ 2001/95/EC	The name or trade name and the address or registered office of the party that is responsible for placing the materials or articles on the market a) Product identification information b) General safety c) Warning and safety instructions. d) Operating or care instructions e) Special instructions and precautions on how to use the final product if necessary - in a clearly visible place; - in easily readable and indelible writing; - in at least one official language (GE/IT/FR). Place: Directly on the product or packaging or label or on a leaflet.
4	Instruction manual	In House	SR 817.023.21	Special instructions and precautions on how to use the final product (if necessary) clear, easy to understand and sufficient
5	Warning & Instruction manual	In House	SR 817.023.21	Wearing Gloves for your Safety De: Tragen Sie geeignete Handschuhe, wenn Sie mit heißen Flüssigkeiten gearbeitet haben. Verletzungsgefahr! Speisen bzw. die Behältnisse werden u.U. sehr heiß. Es besteht Verbrennungsgefahr. - Verwenden Sie unbedingt Topflappen oder hitzebeständige Handschuhe, wenn Sie die Speisen aus dem Garraum nehmen.   
6	Claim Verification	In House	-	Must comply with all claims (including accessories, if any).
Chemical requirements				
Metals and alloys				
7	Lead/ Cadmium/ Arsen	ICP-MS	SR 817.023.21	< 0,05 % Lead < 0,01% Cadmium < 0,03% Arsen;
8	Lead	ICP-MS	SR 814.81	Allowed alloy of brass (messing); Lead total content < 0,5%
9	Tin	ICP-MS	SR 817.023.21	Products from Tin (min. 97 % Tin); < 0,05 % Lead < 0,01% Cadmium
10	Tin as Alloy	ICP-MS	SR 817.023.21	Sn 99,85 % < 0,01 % Lead < 0,01% Cadmium

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11	Specific Metall Release	EN 13130 / ICP and ICP-MS	Not regulated in CH Manor requirement to follow Resolution CM/Res (2013)9	Highly recommended to follow requirements to 21 Elements according to CM/RES (2013)9 Resolution CM/Res (2013)9 on metals and alloys used in food contact materials and articles: <table border="1"> <thead> <tr> <th>No</th> <th>W</th> <th>Element (food)</th> <th>SRL (mg/kg)</th> </tr> </thead> <tbody> <tr><td>1</td><td></td><td>Aluminium</td><td>5</td></tr> <tr><td>2</td><td></td><td>Antimony</td><td>0.04</td></tr> <tr><td>3</td><td></td><td>Arsenic</td><td>0.002</td></tr> <tr><td>4</td><td></td><td>Barium</td><td>1.2</td></tr> <tr><td>5</td><td></td><td>Beryllium</td><td>0.01</td></tr> <tr><td>6</td><td></td><td>Cadmium</td><td>0.005</td></tr> <tr><td>7</td><td></td><td>Chromium</td><td>0.250</td></tr> <tr><td>8</td><td></td><td>Cobalt</td><td>0.02</td></tr> <tr><td>9</td><td></td><td>Copper</td><td>4</td></tr> <tr><td>10</td><td></td><td>Iron</td><td>40</td></tr> <tr><td>11</td><td></td><td>Lead</td><td>0.010</td></tr> <tr><td>12</td><td></td><td>Lithium</td><td>0.048</td></tr> <tr><td>13</td><td></td><td>Manganese</td><td>1.8</td></tr> <tr><td>14</td><td></td><td>Mercury</td><td>0.003</td></tr> <tr><td>15</td><td></td><td>Molybdenum</td><td>0.12</td></tr> <tr><td>16</td><td></td><td>Nickel</td><td>0.14</td></tr> <tr><td>17</td><td></td><td>Silver</td><td>0.08</td></tr> <tr><td>18</td><td></td><td>Thallium</td><td>0.0001</td></tr> <tr><td>19</td><td></td><td>Tin</td><td>100</td></tr> <tr><td>20</td><td></td><td>Vanadium</td><td>0.01</td></tr> <tr><td>21</td><td></td><td>Zinc</td><td>5</td></tr> </tbody> </table>	No	W	Element (food)	SRL (mg/kg)	1		Aluminium	5	2		Antimony	0.04	3		Arsenic	0.002	4		Barium	1.2	5		Beryllium	0.01	6		Cadmium	0.005	7		Chromium	0.250	8		Cobalt	0.02	9		Copper	4	10		Iron	40	11		Lead	0.010	12		Lithium	0.048	13		Manganese	1.8	14		Mercury	0.003	15		Molybdenum	0.12	16		Nickel	0.14	17		Silver	0.08	18		Thallium	0.0001	19		Tin	100	20		Vanadium	0.01	21		Zinc	5
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12	Sensory test	DIN 10955	(EU) 1935/2004	< 3																																																																																								
Ceramics and Glass, Enamel																																																																																												
13	Lead and Cadmium	EN 1388 7086-1 (24 hours at 22 ° C to 4 % acetic acid)	SR 817.023.21 BedGgstV 84/500/EEC (EU) 69/493/ EWG Mandatory confirmation about the compliance for all products	In CH Regulated: for hollow articles deeper than >25mm; Lead - 4,0 mg/L; Cadmium - 0,3 mg/L; for big products, cookware, backing form>3L: Lead – 1,5 mg/L; Cadmium - 0,1 mg/L Remark: (Limits for main product & lid together)																																																																																								
14	Lead and Cadmium (additional requirements)	EN 1388 7086-1	Not regulated in CH Annex 4/ BedGgstV 84/500/EEC	For microwave (recommended): Lead – 0,5 mg/L Cadmium - 0,25 mg/L																																																																																								
Paints and varnishes																																																																																												
15	Lead (Pb), total content	DIN EN ISO 11885, ICP-OES	SR 817.023.21	n.d. in coating 100 mg/kg																																																																																								
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11	Specific Migration of elements	EN 13130	(EU) Nr. 10/2011	Limits according to VO (EU) Nr. 10/2011																																																																																								
12	Formaldehyd	In-House Method	BfR LI Recommendations (Germany) (Mandatory) testing conditions: (2h/100°C)	Limits according to (EU) Nr. 10/2011 <15 mg/kg																																																																																								
13	Chrom	In-House Method		< 0,02 mg/dm2 (in extract)																																																																																								
14	Lithium	In-House Method		Limits according to (EU) Nr. 10/2011 Content on Lithiumoxid < 2,1 % < 0,5 mg/dm2																																																																																								
15	Phenol substances	In-House Method		< 0,05 mg/dm2																																																																																								
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17	Organically bound nitrogen	In-House Method		< 0,02 mg/dm2																																																																																								
18	Emulgatoren (PFOS)	In-House Method		< 0,05 mg/dm2																																																																																								
19	Color Release	In-House Method		Color release																																																																																								
20	Overall Migration	EN 1186		Simulance B, fat substitutes, OM5																																																																																								

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Product specific requirements				
FUNCTIONAL TESTS				
27	Hygiene	Actual Use	-	All surfaces intended to come into contact with food shall be easily cleanable under normal circumstances.
28	Stability Test (Applicable to Free-standing Items)	Actual Use	-	Stability (Applicable to Free-standing Items) - under 10° inclined surface fully fulfilled with water: Still stable, does not wobble when placed on a flat supporting surface.
29	Snap Fit Lid (If Applicable)	Actual Use	-	Shall fit securely to the body of the sample. Shall remain at the body of the sample under 30° inclined surface
30	Leakage Test (If applicable)	Actual Use	-	On the horizontal table fully filled with cold water with 0,5% soap liquid, and maintained for 24hrs. No leakage occurrence.
PHYSICAL CHARACTERISTICS				
31	Volume or Capacity (L or lq. oz) (Applicable If Claimed)	Standard Measure	-	Points of measurement of any claimed dimensions, shall be made clear. Real capacity > claimed.
32	Overall Dimensions (cm & inches) (Applicable If Claimed)	Standard Measure	-	- Base diameter + 20/+25mm or -5/ -10mm as claimed - All other diameter +/-5mm
33	Base Thickness (Applicable If Claimed)	Standard Measure	-	- Base thickness > 85% of claimed thickness
34	Handle Strength	Actual Use	-	Twice heavier as claimed (or full capacity x 1,5 times) for 30 Min. No breakage or adverse effects.
PERFORMANCE TESTING				
35	Dishwashing durability (If Applicable)	EN 12875-1	-	Except silver-plated, aluminium and cast iron unless claimed to be dishwasher safe. 125 cycles according to the care instruction if any. No breakage or adverse effects. Load in bottom rack unless claimed top loading only. If failure, must include warning label on package.
36	Hand Wash durability (if dishwasher is not applicable)	In-House Method	-	After cleaning the article in hot, soap 0,5% liquid water (40±5) °C 10 times. followed by rinse in cold water. Slight discoloration allowed, no damage.
37	Temperature distribution	In-House Method	-	Spread flour on the ground and put in oven at 180 °C for apr. 15 min (depends on oven). Shall be not hot spot, equal distribution of heat over 70% surface.
38	Heat Resistance Test	EN 13834: 2020, clause 6.1.9 (heat resistance)	-	t: 250 °C or claimed max t + 20 °C; Duration: 1 hour. Then cool down to room t Slight crack occurs on surface, but still no function loss.
39	Oven Test	EN 13834: 2020	-	Baking food in an oven at 180±15 °C with reference to EN 13834. Slight scaling on the on-glaze decorations. Or food may stick on the surface or in the corners.

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40	Effects Of Cold	In House Method	-	No failure after filling up with water and frozen at 5 °C for 24 hours.
41	Thermal Shock	EN 13834: 2020, clause 6.1.8 (thermal shock)	-	Simulate temperature changes with reference to EN 13834 Shall withstand the thermal shock. No crack on surface allowed, no function loss: Oven Safe: Δt50, of not less than 180±15 °C, 3 times
42	Resistance To Corrosion	ISO 9227	-	After 24 hours in 5% salt spray (fog) after 6 h staying empty, there shall be no major discoloration in appearance or any major corrosion that would affect the overall product performance. Little change & slight discoloration - possible.
43	Non-stick coating	Visual	-	Without scratches, dents, cracks, marred or discolored surface
44	Non-stick coating	EN 13834: 2020	-	5 times backing by 180±15 °C with cake (with butter)
45	Non stick properties (with carbonized milk)	NF D 21 511 (point 3.3.1)	-	PTFE coating: at least cotation 2 Easy to remove from the mold form.
46	Cross cut test	EN 13834: 2020, clause 8.2.1 (cross-cut adhesion test for non-stick coating)	-	With a cross cut test device 6 cuts on the surface of baking dishes: Characteristic Value 1
47	Abrasion resistance	British Standard 7069:1988, A.1	-	500 cycles no peeling, no exposure of base metal, no trace of test foods
48	Thermal Shock	EN 1183; ISO 2747 for Email	-	Shall withstand the thermal shock according to ISO 2747 for Email, Slight crack on surface allowed, but still no function loss: Oven Safe: Δt50, of not less than 180±15 °C ISO 2747 for enamel coating, the minimum acceptable failure temperature shall be 250 °C (EN 13834: 2020, clause 8.3.3)
49	Stain Resistance	In House Method	-	No objectionable stain by beverages and cooking mediums after 4 hours placement: Beverages: black tea Cooking medium: oil, ketchup, vinegar (where applicable)
50	Extreme Heating in Microwave (if microwave safe)	With reference to EN 15284:2007	-	Keep the product in water at room temperature 20-25 °C for 1 hour. After short period heating of empty sample (according to Norm)- no deformation, no breakage as in Table 1 of EN 15284:2007 occurs
51	Microwave Safe (if microwave safe)	In-House Method	-	Fill with pastry for cake. Lid not fixed to the container, 800W until cake is completely ready. Shall withstand 3 cycles of microwave heating. No visible adverse effect compared with untreated tableware. handles – no discoloration, no damage.