



### **Pre- Production**

- Selections are designed according to customer or International requirements.
- Molds are made in an internal workshop that uses the latest technology and is equipped with the best machines operated by trained engineers and technicians.
- Suitable material selection for each design.

### **Production**

#### **Material Preparation**

- Production starts with cutting stainless steel coils into sheets.

#### **Blanking**

- The outer contour of the piece is cut by a process referred to as blanking.

#### **Rolling**

- Through a series of rolling operations, these blanks are graded or rolled to the correct thickness and shapes required by the manufacturer's flatware patterns.

#### **Bowl Stamping**

- By means of a stamping press, bowls are given their shape.

#### **Cutting bowl outline**

- The rolled blanks are placed in the press by an operator to remove the excess metal and to fashion the shape of the bowl. This trimming must ensure an accurate fit of the pieces into the stamping dies.

#### **Stamping the pattern**

- The next step is the forming of the pattern. Each pattern has its own hardened steel dies used for the front and back patterns. These are carefully set in the stamping press by die chuck. The metal is stamped into every tiny detail of the ornamentation in the die, embossing the pattern on the piece.

#### **Special steps—knives, spoons, and forks**

- Special steps are necessary for the creation of knives, spoons, forks, and hollow-ware pieces. To make the hollow handle for a knife, two strips of metal are formed according to a certain shape, they are soldered together, buffed and polished until the seam is no longer visible. The blade and handle are permanently joined by means of powerful cement, which bonds with great strength and durability.

- In the case of spoons, after the pattern has been embossed upon the front and back of the handle, the bowl of the spoon is formed by using a powerful press and accurate steel dies.

- The forming of fork prongs is a similar process to that of the forming of the spoon's bowl, but the operation takes place before the pattern is applied to the handle. After a fork is cut according to a certain outline, it is pierced and tined. The tines are pieced out, and the small piece of metal that holds the tip of the tines together is removed in another operation after the pattern has been applied.

### **Buffing and sand polishing**

- The knives, forks and spoons are then buffed, polished and inspected. Depending on the pattern, special finishing processes can give silver-plated and sterling silver pieces a bright, mirror-like finish, a soft, satiny glow, or sand blast matt finish.

### **Quality Control**

Final inspection checks the pieces for burs, scratches, rough polishing quality between a fork's tines, discoloration, or any other flaws that might have occurred when the pieces were stamped, shaped and polished.

### **Final Steps**

- The flat-ware is packed according to customers' requests and to ensure the delivery of the cutlery in the same condition as they left the factory..
- The products are Classified and stored.
- The products are Shipped to customers