

TABLE 2
Joint Cure Schedule

Temperature Range of Pipe and Fittings during assembly and cure		Minimum Joint Set Time, hrs. (Sept 12)	Minimum Cure Time before testing, hrs. (Step 14)		Minimum Time before putting system into service at 80 psi/160°F (71°C), hrs.
			Pipe Size		
			1/2 - 1 in. (12.7-25.4 mm)	1-1/4 - 2 in. (32-51 mm)	
°F	°C				
60-100	16-38	1/2	1	2	24
40-60	4-16	1	2	4	48

TABLE 3
8 Feet per Second

Pipe Size	Pipe GPM	Sch. 40 Ft.* FU	FV** FU	Pipe GPM	Sch. 80 Ft.* FU	FV** FU	Tubing GPM	SDR 11 Ft.* FU	FV** FU
1/2	8	9	--	6	7	--	5	6	--
3/4	13	19	--	11	15	--	10	13	--
1	22	33	--	18	26	--	17	24	--
1-1/4	37	74	5	32	55	15	25	42	8
1-1/2	51	129	50	44	104	36	35	66	20
2	81	295	170	74	245	124	59	170	73

*Flush Tank Fixture Units

**Flush Valve Fixture Units

Table 3 (Metric)
2.4 Meters per Second

Pipe Size	Pipe L/min	Sch. 40 Ft.* FU	FV** FU	Pipe L/min	Sch. 80 Ft.* FU	FV** FU	Tubing L/min	SDR 11 Ft.* FU	FV** FU
12.7	30.3	9	--	22.7	7	--	18.9	6	--
19.1	49.2	19	--	41.6	15	--	37.9	13	--
25.4	83.3	33	--	68.1	26	--	64.3	24	--
32	140.0	74	5	121.1	55	15	94.6	42	8
38	193.0	129	50	166.5	104	36	132.5	66	20
51	306.6	295	170	280.1	245	124	223.3	170	73

*Flush Tank Fixture Units

**Flush Valve Fixture Units

markings shall be readily visible for inspection.

2.9.7 Testing. Air testing is prohibited.

2.10 Sizing

2.10.1 Method. Piping shall be sized in accordance with UPC Section 610.0. When Appendix A is applicable, use Chart 1 or 2 as appropriate. Flow velocities shall be limited to a maximum of 8 feet per second (2.4 m/s). See Table 3. [UPC 610.1]

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