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INTERNATIONAL ASSOCIATION OF PLUMBING AND MECHANICAL OFFICIALS

MATERIAL AND PROPERTY STANDARD

FOR

FABRICATED STAINLESS STEEL WATER CLOSETS OR URINALS

IAPMO PS 61-2006a

1. PURPOSE

- 1.1** The purpose of this standard is to provide minimum criteria for construction of water closets or urinals fabricated of stainless steel. Its purpose is to serve as a guide for producers, distributors, architects, engineers, contractors, installers, inspectors, and users; to promote understanding regarding materials and the manufacture of; and to provide for identifying fabricated stainless steel water closets or urinals that conform with this standard.
- 1.2** The provisions of this standard are not intended to prevent the use of any alternate material or method of construction provided any such alternate meets the intent and requirements of this document and changes are amended to this standard.

2. SCOPE

- 2.1** This standard covers definitions, dimensions and tolerances, general requirements, marking, strength and performance tests for such products.

3. REFERENCE STANDARDS

- 3.1** All standards referenced herein shall be the current edition of that standard.

ASME A112.19.2 Vitreous China Plumbing Fixtures and Hydraulic
Requirements for Water Closets and Urinals

4. DEFINITIONS

- 4.1 Water Closet or Urinal.** A plumbing water closet or urinal designed for use in a prison, public use, or vandal prone environment.

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- 4.2 Full Flushing Rim Urinals.** A urinal that will facilitate multiple users simultaneously which contains a flushing devices to fully wash the rim and walls of the unit and is designed for use in public restroom such as in stadiums or arenas

5. GENERAL REQUIREMENTS

- 5.1 Metal Thickness.** The minimum metal thickness after fabrication shall be:
- (a) Vertical surfaces, 0.559 mm (0.022 in.);
 - (b) Corners, 0.508 mm (0.020 in.); and
 - (c) Horizontal surfaces, 0.635 mm (0.025 in.).
- 5.1.1** Tubular components shall be sixteen (16) gage (0.063 in.) thickness or greater.
- 5.2 Material Types.** Fabricated water closets or urinals shall be constructed of the following types of stainless steel: 302, 304 or 316.
- 5.3** All seams shall be integrally welded, ground and polished to blend with adjacent surfaces.
- 5.4** All exposed fastners shall be of the tamper resistant variety which require specially modified tools to install and remove.
- 5.5 Blemishes And Defects.** Water Closets or urinal shall be free from ridges or wrinkles, cut or die marks, pinholes, metal flaws, dents, depressions, raised portions, or spotweld marks. Seamweld joints shall not be prominent.
- 5.6 Warpage Tolerances For All Units.** Warpage of any edge or surface that is set against a wall or floor, or that is set into cabinets or countertops, shall not exceed 1/16 inch per foot.
- 5.6.1** Warpage of any edge or surface other than those specified in Section 5.6 shall not exceed 3/32 inch per foot.
- 5.6.2** Total warpage shall not exceed 3/8 inch for any linear dimension.
- 5.7 Drain Hole.** Drain hole in multi-urinal units shall be a minimum of 1 1/2 inch in diameter.
- 5.8** When water closets are supplied with an integral drinking fountain or lavatory, the units shall comply with the applicable requirements in ASME A112.19.2.

6. STATIC LOAD TEST REQUIREMENTS

- 6.1 Load On Wall Hung Units.** There shall be no permanent visible damage to unit when inspected after testing in accordance with Section 7.7 in ASME A112.19.2.

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