

ICS 90.140.70
CCS Q 31

JC

**BUILDING MATERIALS INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

JC/T 932-2013

**Drainage fittings for sanitary wares
(English Translation)**

Issued on: April 25, 2013

Implemented on: September 1, 2013

**Issued by: Ministry of Industry and Information Technology of the
People's Republic of China**

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1 Scope

This standard specifies the terms and definitions, materials, technical requirements, inspection methods, inspection rules, marking, packaging, transportation and storage of drainage fittings for sanitary wares (hereinafter referred to as "waste fitting").

This standard is applicable to the waste fitting products such as wash basin, washing-tank, bath-tub, bidet, shower room and urinal, which are connected to gravity drainage pipe.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 197-2003 General purpose metric screw threads-Tolerances

GB/T 1176 Specification for cast copper alloys

GB/T 1527 Drawn tube of copper and copper alloys

GB/T 2828.1

Sampling procedures for inspection by attributes - Part 1.

Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

GB/T 2829-2002 Sampling procedures and tables for periodic inspection by attributes (Apply to inspection of process stability)

GB/T 6461-2002

Methods for Corrosion Testing of Metallic and Other Inorganic
Coatings on Metallic Substrates - Rating of Test Specimens and
Manufactured Articles Subjected to Corrosion Tests

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

waste fitting the device between sanitary ware and building drainage pipe in the drainage system, and used for control and transport waste water from the bottom of sanitary ware to drainage pipes of building. Waste fitting is composed of drainage elbow, connection and sealing parts.

3.2

trap the device between the main part of waste fitting and drainage pipe of building, used for drainage and preventing from smell return.

3.3

overflow the device assisting drainage of excessive water when the water level exceeds the critical water level of the device matching the waste fitting.

4 Materials

4.1

The materials of casting copper parts shall meet the requirements of GB 1176. It may also be made of other copper materials that guarantee the technical requirements.

4.2

The copper pipe shall meet the requirements of GB/T 1527.

4.3

The plastic materials shall meet the requirements of GB 12670, GB 12671 and GB 12672.

5.1 Requirements for connection dimension

The dimension of connection of waste fitting shall meet the requirements of Annex A.

5.2 Processing and assembling

5.2.1

The exterior surface of metal parts of product shall be free from defects such as sand hole, shrinkage cavity, crack and air hole.

5.3 Appearance

5.3.1

The cuspidal edge, flash and burr of the exterior surface of product shall be cleared off.

5.3.2

The polished external surface texture shall be consistent in direction, harmonious and free from curly grain.

5.3.3

The visible plated-surface shall be uniform, and free from phenomenon such as peeling, exfoliation, foaming and un-plated.

5.3.4

After the waste fitting is subjected to acetic acid-salt spray test for 24h according to 6.3.4; the visible plating-layer under the installation and use state and the invisible plating-layer shall not be lower than the requirements for Grade 9 and Grade 6 of appearance rating (RA) in Table 1 of GB/T 6461-2002 respectively.

5.4.2 Part of plastic pipe

The wall thickness of plastic pipe and pipe fitting shall not be less than 1.57mm.

5.5 Trap seal

Trap seal of waste fitting with trap shall not be less than 50 mm.

5.6 Stability of water sealing

Test the waste fitting with trap according to the method in 6.6 and the trap seal after test shall not be less than 50 mm.

5.7.2 Flow performance

Conduct test according to the method in 6.7.2; the flow performance of waste fitting shall not be lower than the requirements of Table 1.

5.7.3 Overflow performance

5.7.3.1

Test is conducted according to the method in according to 6.7.3; the flow of waste fitting shall not be lower than the requirements of Table 2.

5.8 Bearing performance

For test conducted according to the method in 6.8, the significant surface of waste fitting matching bath-tub and shower room shall be free from crack, and the deformation amount shall not be greater than 3%.

5.9 Service life

After 10 000 cycles of service life test according to the method in 6.9, the product shall be free from significant defect, and convenient for disassembly, and free from the defects that affect the use function; after service life test, test is conducted according to 5.2.4. The change of test result shall not exceed $\pm 20\%$, and shall meet the requirements of 5.7.1.

5.10.3 Dotty impact

For test conducted according to the method in 6.10.3, the surface of waste fitting shall be free from significant damage.

6.1 Test on requirements for connection dimension

The test on dimension of connection of waste fitting shall be conducted with Vernier caliper with precision of 0.02 mm or test equipment with equivalent precision.

6.2 Test on processing and assembling test

6.2.5

The assembly test of waste fitting shall be conducted by hand-feeling.

6.3 Test on appearance

6.3.1

Inspect the appearance of product visually.

6.3.2

Visual inspection shall be carried out on the polished surface of product under natural scattered light or white light without reflected light. The illuminance is not lower than 300 lx.