

**SECTION 23 21 13****HYDRONIC PIPING****PART 1 - GENERAL****1.1 DESCRIPTION**

- A. Water piping to connect HVAC equipment, including the following:
  - 1. Heating hot water and drain piping.
  - 2. Extension of domestic water make-up piping.

**1.2 RELATED WORK**

- A. Section 01 00 00, GENERAL REQUIREMENTS.
- B. Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, and SAMPLES.
- C. Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION: General mechanical requirements and items, which are common to more than one section of Division 23.
- D. Section 23 07 11, HVAC, PLUMBING, and BOILER PLANT INSULATION: Piping insulation.
- E. Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC: Temperature and pressure sensors and valve operators.
- F. Section 23 25 00, HVAC WATER TREATMENT.

**1.3 QUALITY ASSURANCE**

- A. Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION, which includes welding qualifications.
- B. Submit prior to welding of steel piping a certificate of Welder's certification. The certificate shall be current and not more than one year old.
- C. For mechanical pressed sealed fittings, only tools of fitting manufacturer shall be used.
- D. For mechanical pressed sealed fittings, only tools of fitting manufacturer shall be used.
- E. All grooved joint couplings, fittings, valves, and specialties shall be the products of a single manufacturer. Grooving tools shall be the same manufacturer as the grooved components.
  - 1. All castings used for coupling housings, fittings, valve bodies, etc., shall be date stamped for quality assurance and traceability.

**1.4 SUBMITTALS**

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Manufacturer's Literature and Data:
  - 1. Pipe and equipment supports. **Submit calculations for variable spring and constant support hangers.**
  - 2. Pipe and tubing, with specification, class or type, and schedule.
  - 3. Pipe fittings, including miscellaneous adapters and special fittings.
  - 4. Flanges, gaskets and bolting.
  - 5. Grooved joint couplings and fittings.
  - 6. Valves of all types.
  - 7. Strainers.
  - 8. Flexible connectors for water service.
  - 9. Pipe alignment guides.
  - 10. Expansion joints.
  - 11. Expansion compensators.
  - 12. All specified hydronic system components.
  - 13. Water flow measuring devices.
  - 14. Gages.
  - 15. Thermometers and test wells.
  - 16. Electric heat tracing systems.
  - 17. Seismic bracing details for piping.
- C. Submit the welder's qualifications in the form of a current (less than one year old) and formal certificate.
- D. Coordination Drawings: Refer to Article, SUBMITTALS of Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.
- E. As-Built Piping Diagrams: Provide drawing as follows for chilled water, condenser water, and heating hot water system and other piping systems and equipment.
  - 1. One wall-mounted stick file with complete set of prints. Mount stick file in the chiller plant or control room along with control diagram stick file.
  - 2. One complete set of reproducible drawings.
  - 3. One complete set of drawings in electronic Autocad and pdf.

**1.5 APPLICABLE PUBLICATIONS**

- A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the

basic designation only American National Standards Institute, Inc.

B. American Society of Mechanical Engineers/American National Standards Institute, Inc. (ASME/ANSI):

1. B1.20.1-83(R2006) Pipe Threads, General Purpose (Inch)
2. B16.4-06 Gray Iron Threaded Fittings B16.18-01 Cast Copper Alloy Solder joint Pressure fittings
3. B16.23-02 Cast Copper Alloy Solder joint Drainage fittings
4. B40.100-05 Pressure Gauges and Gauge Attachments

C. American National Standards Institute, Inc./Fluid Controls Institute (ANSI/FCI):

1. 70-2-2006 Control Valve Seat Leakage

D. American Society of Mechanical Engineers (ASME):

1. B16.1-98 Cast Iron Pipe Flanges and Flanged Fittings
2. B16.3-2006 Malleable Iron Threaded Fittings: Class 150 and 300
3. B16.4-2006 Gray Iron Threaded Fittings: (Class 125 and 250)
4. B16.5-2003 Pipe Flanges and Flanged Fittings: NPS ½ through NPS 24 Metric/Inch Standard
5. B16.9-07 Factory-Made Wrought Butt Welding Fittings
6. B16.11-05 Forged Fittings, Socket-Welding and Threaded
7. B16.18-01 Cast Copper Alloy Solder Joint Pressure Fittings
8. B16.22-01 Wrought Copper and Bronze Solder-Joint Pressure Fittings
9. B16.24-06 Cast Copper Alloy Pipe Flanges and Flanged Fittings
10. B16.39-06 Malleable Iron Threaded Pipe Unions
11. B16.42-06 Ductile Iron Pipe Flanges and Flanged Fittings
12. B31.1-08 Power Piping

E. American Society for Testing and Materials (ASTM):

1. A47/A47M-99 (2004) Ferritic Malleable Iron Castings
2. A53/A53M-07 Standard Specification for Pipe, Steel, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless
3. A106/A106M-08 Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service
4. A126-04 Standard Specification for Gray Iron Castings for Valves, Flanges, and Pipe Fittings
5. A183-03 Standard Specification for Carbon Steel Track Bolts and Nuts
6. A216/A216M-08 Standard Specification for Steel Castings, Carbon, Suitable for Fusion Welding, for High Temperature Service
7. A234/A234M 07 Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperature Service

8. A307-07 Standard Specification for Carbon Steel Bolts and Studs, 60,000 PSI Tensile Strength
9. A536-84 (2004) Standard Specification for Ductile Iron Castings
10. 615/A 615M-08 Deformed and Plain Carbon Steel Bars for Concrete Reinforcement
11. A653/A 653M-08 Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy Coated (Galvannealed) By the Hot-Dip Process
12. B32-08 Standard Specification for Solder Metal
13. B62-02 Standard Specification for Composition Bronze or Ounce Metal Castings
14. B88-03 Standard Specification for Seamless Copper Water Tube
15. B209 07 Aluminum and Aluminum Alloy Sheet and Plate
16. C177 04 Standard Test Method for Steady State Heat Flux Measurements and Thermal Transmission Properties by Means of the Guarded Hot Plate Apparatus
17. C478-09 Precast Reinforced Concrete Manhole Sections
18. C533 07 Calcium Silicate Block and Pipe Thermal Insulation
19. C552 07 Cellular Glass Thermal Insulation
20. D 3350-08 Polyethylene Plastics Pipe and Fittings Materials
21. C591-08 Unfaced Preformed Rigid Cellular Polyisocyanurate Thermal Insulation
22. D1784 08 Rigid Poly (Vinyl Chloride) (PVC) Compounds and Chlorinated Poly (Vinyl Chloride) (CPVC) Compounds
23. D1785 06 Poly (Vinyl Chloride) (PVC) Plastic Pipe, Schedules 40, 80 and 120
24. D2241 05 Poly (Vinyl Chloride) (PVC) Pressure Rated Pipe (SDR Series)
25. F439-06 Standard Specification for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80
26. F441/F441M-02 Standard Specification for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe, Schedules 40 and 80
27. F477-08 Elastomeric Seals Gaskets) for Joining Plastic Pipe

F. American Water Works Association (AWWA):

1. C110/08 Ductile Iron and Grey Iron Fittings for Water
2. C203 02 Coal Tar Protective Coatings and Linings for Steel Water Pipe Lines Enamel and Tape Hot Applied

G. American Welding Society (AWS):

1. B2.1-02 Standard Welding Procedure Specification

H. Copper Development Association, Inc. (CDA):

1. CDA A4015-06 Copper Tube Handbook

I. Expansion Joint Manufacturer's Association, Inc. (EJMA):

1. EMJA-2003 Expansion Joint Manufacturer's Association Standards, Ninth Edition
  - J. Manufacturers Standardization Society (MSS) of the Valve and Fitting Industry, Inc.:
    1. SP-67-02a Butterfly Valves
    2. SP-70-06 Gray Iron Gate Valves, Flanged and Threaded Ends
    3. SP-71-05 Gray Iron Swing Check Valves, Flanged and Threaded Ends
    - ?. SP-80-08 Bronze Gate, Globe, Angle and Check Valves
    4. SP-85-02 Cast Iron Globe and Angle Valves, Flanged and Threaded Ends
    5. SP-110-96 Ball Valves Threaded, Socket-Welding, Solder Joint, Grooved and Flared Ends
    6. SP-125-00 Gray Iron and Ductile Iron In-line, Spring Loaded, Center-Guided Check Valves
  - K. National Sanitation Foundation/American National Standards Institute, Inc. (NSF/ANSI):
    1. 14-06 Plastic Piping System Components and Related Materials
    2. 50-2009a Equipment for Swimming Pools, Spas, Hot Tubs and other Recreational Water Facilities - Evaluation criteria for materials, components, products, equipment and systems for use at recreational water facilities
    3. 61-2008 Drinking Water System Components - Health Effects
  - L. Tubular Exchanger Manufacturers Association: TEMA 9th Edition, 2007
- 1.6 SPARE PARTS**
- A. For mechanical pressed sealed fittings provide tools required for each pipe size used at the facility.

## **PART 2 - PRODUCTS**

### **2.1 PIPE AND EQUIPMENT SUPPORTS, PIPE SLEEVES, AND WALL AND CEILING PLATES**

- A. Provide in accordance with Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.

### **2.2 PIPE AND TUBING**

- A. Heating Hot Water, , and Vent Piping:
  1. Copper water tube option: ASTM B88, Type K or L, hard drawn.
- B. Extension of Domestic Water Make-up Piping: ASTM B88, Type K or L, hard drawn copper tubing.

## C. Cooling Coil Condensate Drain Piping:

1. From air handling units: Copper water tube, ASTM B88, Type M

D. Pipe supports, including insulation shields, for above ground piping:  
Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.**2.3 FITTINGS FOR COPPER TUBING**

## A. Joints:

1. Solder Joint: Joints shall be made up in accordance with recommended practices of the materials applied. Apply 95/5 tin and antimony on all copper piping. Contractor's Option: Mechanical press sealed fittings, double pressed type, NSF 50/61 approved, with EPDM (ethylene propylene diene monomer) non-toxic synthetic rubber sealing elements for up to 65 mm (2-1/2 inch) and below are optional for above ground water piping only.
2. Mechanically formed tee connection in water and drain piping: Form mechanically extracted collars in a continuous operation by drilling pilot hole and drawing out tube surface to form collar, having a height of not less than three times the thickness of tube wall. Adjustable collaring device shall insure proper tolerance and complete uniformity of the joint. Notch and dimple joining branch tube in a single process to provide free flow where the branch tube penetrates the fitting.

## B. Bronze Flanges and Flanged Fittings: ASME B16.24.

## C. Fittings: ANSI/ASME B16.18 cast copper or ANSI/ASME B16.22 solder wrought copper.

**2.4 DIELECTRIC FITTINGS**

- A. Provide where copper tubing and ferrous metal pipe are joined.
- B. 50 mm (2 inches) and Smaller: Threaded dielectric union, ASME B16.39.
- C. 65 mm (2 1/2 inches) and Larger: Flange union with dielectric gasket and bolt sleeves, ASME B16.42.
- D. Temperature Rating, 99 degrees C (210 degrees F).
- E. Contractor's option: On pipe sizes 2" and smaller, screwed end brass ball valves **or dielectric nipples** may be used in lieu of dielectric unions.

**2.5 SCREWED JOINTS**

- A. Pipe Thread: ANSI B1.20.
- B. Lubricant or Sealant: Oil and graphite or other compound approved for the intended service.

**2.6 VALVES**

- A. Asbestos packing is not acceptable.
- B. All valves of the same type shall be products of a single manufacturer.
- C. Provide chain operators for valves 150 mm (6 inches) and larger when the centerline is located 2400 mm (8 feet) or more above the floor or operating platform.
- D. Shut-Off Valves:
  - 1. Ball Valves (Pipe sizes 2" and smaller): MSS-SP 110, screwed or solder connections, brass or bronze body with chrome-plated ball with full port and Teflon seat at [2760 kPa (400 psig)][4140 kPa (600 psig)] working pressure rating. Provide stem extension to allow operation without interfering with pipe insulation.
  - 2. Butterfly Valves (Pipe Sizes 2-1/2" and larger): Provide stem extension to allow 50 mm (2 inches) of pipe insulation without interfering with valve operation. MSS-SP 67, flange lug type or grooved end rated 1205 kPa (175 psig) working pressure at 93 degrees C (200 degrees F). Valves shall be ANSI Leakage Class VI and rated for bubble tight shut-off to full valve pressure rating. Valve shall be rated for dead end service and bi-directional flow capability to full rated pressure. Not permitted for direct buried pipe applications.
    - a. Body: Cast iron, ASTM A126, Class B. Malleable iron, ASTM A47 electro-plated, or ductile iron, ASTM A536, Grade 65-45-12 electro-plated.
    - b. Trim: Bronze, aluminum bronze, or 300 series stainless steel disc, bronze bearings, 316 stainless steel shaft and manufacturer's recommended resilient seat. Resilient seat shall be field replaceable, and fully line the body to completely isolate the body from the product. A phosphate coated steel shaft or stem is acceptable, if the stem is completely isolated from the product.
    - c. Actuators: Field interchangeable. Valves for balancing service shall have adjustable memory stop to limit open position.
      - 1) Valves 150 mm (6 inches) and smaller: Lever actuator with minimum of seven locking positions, except where chain wheel is required.
      - 2) Valves 200 mm (8 inches) and larger: Enclosed worm gear with handwheel, and where required, chain-wheel operator.
      - 3) Gate Valves (Contractor's Option in lieu of Ball or Butterfly Valves):
        - a) 50 mm (2 inches) and smaller: MSS-SP 80, Bronze, 1034 kPa (150 psig), wedge disc, rising stem, union bonnet.
        - b) 65 mm (2 1/2 inches) and larger: Flanged, outside screw and yoke. MSS-SP 70, iron body, bronze mounted, 861 kPa (125 psig) wedge disc.
- E. Globe and Angle Check Valves:
  - 1. Globe Valves

- a. 50 mm (2 inches) and smaller: MSS-SP 80, bronze, 1034 kPa (150 lb.) Globe valves shall be union bonnet with metal plug type disc.
  - b. 65 mm (2 1/2 inches) and larger: 861 kPa (125 psig), flanged, iron body, bronze trim, MSS-SP-85 for globe valves.
2. Angle Valves:
- a. 50 mm (2 inches) and smaller: MSS-SP 80, bronze, 1034 kPa (150 lb.) Angle valves shall be union bonnet with metal plug type disc.
  - b. 65 mm (2 1/2 inches) and larger: 861 kPa (125 psig), flanged, iron body, bronze trim, MSS-SP-85 for angle.

F. Check Valves

1. Swing Check Valves:
  - a. 50 mm (2 inches) and smaller: MSS-SP 80, bronze, 1034 kPa (150 lb.), 45 degree swing disc.
  - b. 65 mm (2 1/2 inches) and larger: 861 kPa (125 psig), flanged, iron body, bronze trim, MSS-SP-71 for check valves.
2. Non-Slam or Silent Check Valve: Spring loaded double disc swing check or internally guided flat disc lift type check for bubble tight shut-off. Provide where check valves are shown in chilled water and hot water piping. Check valves incorporating a balancing feature may be used.
  - a. Body: MSS-SP 125 cast iron, ASTM A126, Class B, or steel, ASTM A216, Class WCB, or ductile iron, ASTM 536, flanged, grooved, or wafer type.
  - b. Seat, disc and spring: 18-8 stainless steel, or bronze, ASTM B62. Seats may be elastomer material.

G. Water Flow Balancing Valves: For flow regulation and shut-off. Valves shall be line size rather than reduced to control valve size.

1. **Ball or Globestyle valve.**
2. A dual purpose flow balancing valve and adjustable flow meter, with bronze or cast iron body, calibrated position pointer, valved pressure taps or quick disconnects with integral check valves and preformed polyurethane insulating enclosure.
3. Provide a readout kit including flow meter, readout probes, hoses, flow charts or calculator, and carrying case.

H. Automatic Balancing Control Valves: Factory calibrated to maintain constant flow (plus or minus five percent) over system pressure fluctuations of at least 10 times the minimum required for control. Provide standard pressure taps and four sets of capacity charts. Valves shall be line size and be one of the following designs:

1. Gray iron (ASTM A126) or brass body rated 1205 kPa (175 psig) at 93 degrees C (200 degrees F), with stainless steel piston and spring.
2. Brass or ferrous body designed for 2067 kPa (300 psig) service at 121 degrees C (250 degrees F), with corrosion resistant, tamper proof, self-cleaning piston/spring assembly that is easily removable for inspection or replacement.
3. Combination assemblies containing ball type shut-off valves, unions,



flow regulators, strainers with blowdown valves and pressure temperature ports shall be acceptable.

4.

- I. Manual Radiator/Convactor Valves: Brass, packless, with position indicator.

## **2.7 FLEXIBLE CONNECTORS FOR WATER SERVICE**

### **A. Flanged Spool Connector:**

- 1. Single arch or multiple arch type. Tube and cover shall be constructed of chlorobutyl elastomer with full faced integral flanges to provide a tight seal without gaskets. Connectors shall be internally reinforced with high strength synthetic fibers impregnated with rubber or synthetic compounds as recommended by connector manufacturer, and steel reinforcing rings.
- 2. Working pressures and temperatures shall be as follows:
  - a. Connector sizes 50 mm to 100 mm (2 inches to 4 inches), 1137 kPa (165psig) at 121 degrees C (250 degrees F).
  - b. Connector sizes 125 mm to 300 mm (5 inches to 12 inches), 965 kPa (140 psig) at 121 degrees C (250 degrees F).
- 3. Provide ductile iron retaining rings and control units.

### **B. Mechanical Pipe Couplings:**

- 1. See other fittings specified under Part 2, PRODUCTS.

## **2.8 HYDRONIC SYSTEM COMPONENTS**

### **A.**

- B. Automatic Air Vent Valves (where shown): Cast iron or semi-steel body, 1034 kPa (150 psig) working pressure, stainless steel float, valve, valve seat and mechanism, minimum 15 mm (1/2 inch) water connection and 6 mm (1/4 inch) air outlet. Air outlet shall be piped to the nearest floor drain.

## **PART 3 - EXECUTION**

### **3.1 GENERAL**

- A. The drawings show the general arrangement of pipe and equipment but do not show all required fittings and offsets that may be necessary to connect pipes to equipment, fan-coils, coils, radiators, etc., and to coordinate with other trades. Provide all necessary fittings, offsets and pipe runs based on field measurements and at no additional cost to the government. Coordinate with other trades for space available and relative location of HVAC equipment and accessories to be connected on ceiling grid. Pipe location on the drawings shall be altered by contractor where necessary to avoid interferences and clearance difficulties.

- B. Store materials to avoid excessive exposure to weather or foreign materials. Keep inside of piping relatively clean during installation and protect open ends when work is not in progress.
- C. Support piping securely. Refer to PART 3, Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION. Install heat exchangers at height sufficient to provide gravity flow of condensate to the flash tank and condensate pump.
- D. Install piping generally parallel to walls and column center lines, unless shown otherwise on the drawings. Space piping, including insulation, to provide 25 mm (one inch) minimum clearance between adjacent piping or other surface. Unless shown otherwise, slope drain piping down in the direction of flow not less than 25 mm (one inch) in 12 m (40 feet). Provide eccentric reducers to keep bottom of sloped piping flat.
- E. Locate and orient valves to permit proper operation and access for maintenance of packing, seat and disc. Generally locate valve stems in overhead piping in horizontal position. Provide a union adjacent to one end of all threaded end valves. Control valves usually require reducers to connect to pipe sizes shown on the drawing. Install butterfly valves with the valve open as recommended by the manufacturer to prevent binding of the disc in the seat.
- F. Offset equipment connections to allow valving off for maintenance and repair with minimal removal of piping. Provide flexibility in equipment connections and branch line take-offs with 3-elbow swing joints where noted on the drawings.
- G. Tee water piping runouts or branches into the side of mains or other branches. Avoid bull-head tees, which are two return lines entering opposite ends of a tee and exiting out the common side.
- H. Provide manual or automatic air vent at all piping system high points and drain valves at all low points. Install piping to floor drains from all automatic air vents.
- I. Connect piping to equipment as shown on the drawings. Install components furnished by others such as:
  - 1. Water treatment pot feeders and condenser water treatment systems.
  - 2. Flow elements (orifice unions), control valve bodies, flow switches, pressure taps with valve, and wells for sensors.
- J. Thermometer Wells: In pipes 65 mm (2-1/2 inches) and smaller increase the pipe size to provide free area equal to the upstream pipe area.
- K. Firestopping: Fill openings around uninsulated piping penetrating floors or fire walls, with firestop material. For firestopping insulated piping refer to Section 23 07 11, HVAC, PLUMBING, and BOILER PLANT INSULATION.
- L. Where copper piping is connected to steel piping, provide dielectric connections.

### 3.2 PIPE JOINTS

- A. Welded: Beveling, spacing and other details shall conform to ASME B31.1 and AWS B2.1. See Welder's qualification requirements under "Quality Assurance" in Section 23 05 11, COMMON WORK RESULTS FOR HVAC and STEAM GENERATION.
- B. Screwed: Threads shall conform to ASME B1.20; joint compound shall be applied to male threads only and joints made up so no more than three threads show. Coat exposed threads on steel pipe with joint compound, or red lead paint for corrosion protection.
- C. Mechanical Joint: Pipe grooving shall be in accordance with joint manufacturer's specifications. Lubricate gasket exterior including lips, pipe ends and housing interiors to prevent pinching the gasket during installation. Lubricant shall be as recommended by coupling manufacturer.
- D. 125 Pound Cast Iron Flange (Plain Face): Mating flange shall have raised face, if any, removed to avoid overstressing the cast iron flange.
- E. Solvent Welded Joints: As recommended by the manufacturer.

### 3.3 LEAK TESTING ABOVEGROUND PIPING

- A. Inspect all joints and connections for leaks and workmanship and make corrections as necessary, to the satisfaction of the VA. Tests may be either of those below, or a combination, as approved by the VA.
- B. An operating test at design pressure, and for hot systems, design maximum temperature.
- C. A hydrostatic test at 1.5 times design pressure. For water systems the design maximum pressure would usually be the static head, or expansion tank maximum pressure, plus pump head. Factory tested equipment (convertors, exchangers, coils, etc.) need not be field tested. Isolate equipment where necessary to avoid excessive pressure on mechanical seals and safety devices.

### 3.4 FLUSHING AND CLEANING PIPING SYSTEMS

- A. Water Piping: Also reference Section 23 25 00 HVAC WATER TREATMENT for water treatment for refill of the existing heating hot water system.
  - 1. Initial flushing: Remove loose dirt, mill scale, metal chips, weld beads, rust, and like deleterious substances without damage to any system component. Provide temporary piping or hose to bypass coils, control valves, exchangers and other factory cleaned equipment unless acceptable means of protection are provided and subsequent inspection of hide-out areas takes place. Isolate or protect clean system components, including pumps and pressure vessels, and remove any component which may be damaged. Open all valves, drains, vents and strainers at all system levels. Remove plugs, caps, spool pieces, and components to facilitate early debris discharge from system. Sectionalize system to obtain debris carrying velocity of 1.8 m/S

(6 feet per second), if possible. Connect dead-end supply and return headers as necessary. Flush bottoms of risers. Install temporary strainers where necessary to protect down-stream equipment. Supply and remove flushing water and drainage by various type hose, temporary and permanent piping and Contractor's booster pumps. Flush until clean as approved by the VA.

2. Cleaning: Using products supplied in Section 23 25 00, HVAC WATER TREATMENT, circulate systems at normal temperature to remove adherent organic soil, hydrocarbons, flux, pipe mill varnish, pipe joint compounds, iron oxide, and like deleterious substances not removed by flushing, without chemical or mechanical damage to any system component. Removal of tightly adherent mill scale is not required. Keep isolated equipment which is "clean" and where dead-end debris accumulation cannot occur. Sectionalize system if possible, to circulate at velocities not less than 1.8 m/S (6 feet per second). Circulate each section for not less than four hours. Blow-down all strainers, or remove and clean as frequently as necessary. Drain and prepare for final flushing.
3. Final Flushing: Return systems to conditions required by initial flushing after all cleaning solution has been displaced by clean make-up. Flush all dead ends and isolated clean equipment. Gently operate all valves to dislodge any debris in valve body by throttling velocity. Flush for not less than one hour.

### 3.5 WATER TREATMENT

- A. Close and fill system as soon as possible after final flushing to minimize corrosion.
- B. Charge systems with chemicals as described in Section 23 25 00, HVAC Water Treatment. Utilize this activity, by arrangement with the VA, for instructing VA operating personnel.

### 3.6 OPERATING AND PERFORMANCE TEST AND INSTRUCTION

- A. Refer to PART 3, Section 23 05 11, COMMON WORK RESULTS FOR HVAC AND STEAM GENERATION.
- B. Adjust red set hand on pressure gages to normal working pressure.

- - - E N D - - -