

Average Handling/Set Up Times For PVC/CPVC Solvent Cements

Handling/Set Up Time is the time required prior to handling the joint. In damp or humid weather, allow 50% additional time.

| Temperature During assembly | Pipe Diameter ½" to 1-¼" | Pipe Diameter 1-½" to 3" | Pipe Diameter 4" to 5" | Pipe Diameter 6" to 8" | Pipe Diameter 10" to 16" | Pipe Diameter 18"+ |
|-----------------------------|--------------------------|--------------------------|------------------------|------------------------|--------------------------|--------------------|
| 60° - 100°F | 2 minutes | 5 minutes | 15 minutes | 30 minutes | 2 hours | 4 hours |
| 40° - 60°F | 5 minutes | 10 minutes | 30 minutes | 90 minutes | 8 hours | 16 hours |
| 20° - 40°F | 8 minutes | 12 minutes | 60 minutes | 3 hours | 12 hours | 24 hours |
| 0° - 20°F | 10 minutes | 15 minutes | 2 hours | 6 hours | 24 hours | 48 hours |

These figures should be used only as a general guide. Conditions in the field may vary.

Average Number of Joints per Quart of Solvent Cement

| Pipe Diameter | ½" | ¾" | 1" | 1-¼" | 1-½" | 2" | 3" | 4" | 6" | 8" | 10" | 12" | 15" | 18" |
|------------------|-----|-----|-----|------|------|----|----|----|----|----|-----|-----|-----|-----|
| Number Of Joints | 350 | 275 | 200 | 175 | 150 | 80 | 60 | 40 | 20 | 10 | 6 | 3 | 1 | ½ |

These figures are estimates based on laboratory testing. Conditions in the field may vary.

Lap Shear Strength Value

| | CPVC | ABS | PVC |
|----------|-----------|-----------|-----------|
| 2 hours | > 250 psi | n/a | > 250 psi |
| 16 hours | > 500 psi | n/a | > 500 psi |
| 48 hours | n/a | > 800 psi | n/a |
| 72 hours | > 900 psi | n/a | > 900 psi |

Average Joint Cure Times For PVC/CPVC Solvent Cements

Joint cure time is the time required before pressure testing the system. In damp or humid weather allow 50% additional cure time.

| Relative Humidity 60% or less | Pipe Diameter ½" to 1-¼" | | Pipe Diameter 1-½" to 3" | | Pipe Diameter 4" to 5" | | Pipe Diameter 6" to 8" | | Pipe Diameter 10" to 16" | Pipe Diameter 18"+ |
|-------------------------------|--------------------------|-----------|--------------------------|-----------|------------------------|-----------|------------------------|-----------|--------------------------|--------------------|
| | Up to 180 psi | 180 psi + | Up to 180 psi | 180 psi + | Up to 180 psi | 180 psi + | Up to 180 psi | 180 psi + | Up to 100 psi | Up to 100 psi |
| 60° - 100°F | 1 Hour | 6 Hours | 2 Hours | 12 Hours | 6 Hours | 18 Hours | 8 Hours | 24 Hours | 24 Hours | 36 Hours |
| 40° - 60°F | 2 Hours | 12 Hours | 4 Hours | 24 Hours | 12 Hours | 36 Hours | 16 Hours | 48 Hours | 48 Hours | 72 Hours |
| 20° - 40°F | 6 Hours | 36 Hours | 12 Hours | 72 Hours | 36 Hours | 4 Days | 3 Days | 9 Days | 8 Days | 12 Days |
| 0° - 20°F | 8 Hours | 48 Hours | 16 Hours | 96 Hours | 48 Hours | 8 Days | 4 Days | 12 Days | 10 Days | 14 Days |

This chart can be used as a guideline to determine joint cure time.

These figures should be used only as a general guide. Conditions in the field may vary.

