



SOLVENT CEMENTED PIPE JOINTS INITIAL SET SCHEDULE, CURE SCHEDULE AND CEMENT USAGE TABLE

INITIAL SET SCHEDULE: The initial set schedule is the necessary time to allow before the joint can be carefully handled. After initial set, the joint will withstand the stresses of a normal installation. In damp or humid weather or chemical applications, allow a minimum of 50% more set time.

AVERAGE INITIAL SET SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS

TEMPERATURE RANGE	PIPE SIZES ½" to 1 ¼"	PIPE SIZES 1 ½" to 2"	PIPE SIZES 2 ½" to 8"	PIPE SIZES 10" to 15"	PIPE SIZES 15" +
60° - 100°F	2 minutes	5 minutes	30 minutes	2 hours	4 hours
40° - 60°F	5 minutes	10 minutes	2 hours	8 hours	16 hours
0° - 40°F	10 minutes	15 minutes	12 hours	24 hours	48 hours

JOINT CURE SCHEDULE: The cure schedule is the necessary time to allow before pressurizing newly assembled joints. Follow the schedule carefully. In damp or humid weather or chemical applications, allow a minimum of 50% more cure time.

AVERAGE JOINT CURE SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS

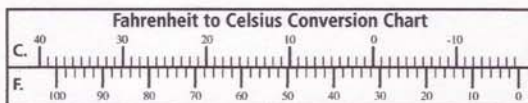
RELATIVE HUMIDITY 60% or LESS	CURE TIME PIPE SIZES ½" to 1 ¼"		CURE TIME PIPE SIZES 1 ½" to 2"		CURE TIME PIPE SIZES 2 ½" to 8"		CURE TIME PIPE SIZES 10" to 15"	CURE TIME PIPE SIZES 15" +
TEMPERATURE RANGE DURING ASSEMBLY AND CURE PERIODS	UP TO 160 PSI	ABOVE 160 to 370 PSI	UP TO 160 PSI	ABOVE 160 to 315 PSI	UP TO 160 PSI	ABOVE 160 to 315 PSI	UP TO 100 PSI	UP TO 100 PSI
60° - 100°F	15 mins.	6 hrs.	30 mins.	12 hrs.	1½ hrs.	24 hrs.	48 hrs.	72 hrs.
40° - 60°F	20 mins.	12 hrs.	45 mins.	24 hrs.	4 hrs.	48 hrs.	96 hrs.	6 days
0° - 40°F	30 mins.	48 hrs.	1 hr.	96 hrs.	72 hrs.	8 days	8 days	14 days

AVERAGE NUMBER OF JOINTS / QT. OF WELD-ON CEMENTS

PIPE DIAMETER	½"	¾"	1"	1 ½"	2"	3"	4"	6"	8"	10"	12"	15"	18"
NO. OF JOINTS	300	200	125	90	60	40	30	10	5	2-3	1-2	¾	½

FOR PRIMER: Double the number of joints shown for cement.

The schedules and tables shown are estimates based on our laboratory tests. Due to the many variables in the fields, these figures should be used as a general guide only.



NOMINAL BORE INCHES TO MILLIMETER CONVERSION																	
inch	½"	¾"	1"	1¼"	1½"	2"	2½"	3"	4"	6"	8"	10"	12"	14"	18"	24"	30"
mm	15	20	25	32	40	50	65	80	100	150	200	250	300	350	450	600	750

**WARNING: IPS WELD-ON PRODUCTS MUST NEVER BE USED IN PVC OR CPVC SYSTEMS
USING OR BEING TESTED BY COMPRESSED AIR OR GASES**