

## 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 only be used as a general guide. Conditions in the field may vary.

PVC & ABS		Temperature during assembly and cure period			
Pipe Diameter		60°-100°F 16°-38°C	40°-60°F 4°-16°C	20°-40°F -7°-4°C	0°-20°F -18°-7°C
<b>1/2" to 1-1/4"</b> 13 to 32mm	Up to 180 psi	15 min	20 min	30 min	60 min
	180 psi +	4 hrs	8 hrs	36 hrs	48 hrs
<b>1-1/2" to 3"</b> 40 to 80mm	Up to 180 psi	30 min	45 min	60 min	120 min
	180 psi +	8 hrs	16 hrs	72 hrs	96 hrs
<b>4" to 5"</b> 100 to 125mm	Up to 180 psi	2 hrs	4 hrs	36 hrs	48 hrs
	180 psi +	12 hrs	24 hrs	4 days	8 days
<b>6" to 8"</b> 150 to 200mm	Up to 180 psi	8 hrs	16 hrs	3 days	4 days
	180 psi +	24 hrs	48 hrs	9 days	12 days
<b>10" to 16"</b> 250 to 400 mm	Up to 100 psi	24 hrs	48 hrs	8 days	10 days
	Up to 100 psi	36 hrs	72 hrs	12 days	14 days

CPVC		Temperature during assembly and cure period			
Pipe Diameter		60°-100°F 16°-38°C	40°-60°F 4°-16°C	20°-40°F -7°-4°C	0°-20°F -18°-7°C
<b>1/2" to 1-1/4"</b> 13 to 32mm	Up to 180 psi	1 hr	2 hrs	Please contact Oatey Technical Services for cure time information	
	180 psi +	6 hrs	12 hrs		
<b>1-1/2" to 3"</b> 40 to 80mm	Up to 180 psi	2 hrs	4 hrs		
	180 psi +	12 hrs	24 hrs		
<b>4" to 5"</b> 100 to 125mm	Up to 180 psi	6 hrs	12 hrs		
	180 psi +	18 hrs	36 hrs		
<b>6" to 8"</b> 150 to 200mm	Up to 180 psi	8 hrs	16 hrs		
	180 psi +	24 hrs	48 hrs		
<b>10" to 16"</b> 250 to 400 mm	Up to 100 psi	24 hrs	48 hrs		
	Up to 100 psi	36 hrs	72 hrs		