

SOLVENT WELD CURE TIMES

Set Up & Curing Times

The set up/cure time is dependent on several factors. The pipe size, socket fit, ambient temperature, relative humidity, solvent cement used and the system operating pressure should all be considered when determining set up/cure times.

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.

Pipe Diameter	Temperature during assembly			
	60° to 100°F	40° to 60°F	20° to 40°F	0° to 20°F
½" to 1¼"	2 minutes	5 minutes	8 minutes	10 minutes
1½" to 3"	5 minutes	10 minutes	12 minutes	15 minutes
4" to 5"	15 minutes	30 minutes	1 hour	2 hours
6" to 8"	30 minutes	90 minutes	3 hours	6 hours

Contact Oatey Technical Services for set up times for pipe larger than 8" diameter.

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

Average Number of Joints Per Quart of Solvent Cement

Pipe Diameter	½"	¾"	1"	1¼"	1½"	2"	3"	4"	6"	8"
Number of Joints	325	250	150	125	90	70	50	30	10	8

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

Average Joint Cure Times for PVC, ABS and CPVC Solvent Cements

PVC & ABS					
Pipe Diameter		Temperature during assembly and cure period			
		60° to 100°F	40° to 60°F	20° to 40°F	0° to 20°F
½" to 1¼"	Up to 180 psi	15 min	20 min	30 min	Please contact Oatey Technical Services for cure time information
	180 psi +	4 hours	8 hours	36 hours	
1½" to 3"	Up to 180 psi	30 min	45 min	60 min	
	180 psi +	8 hours	16 hours	3 days	
4" to 5"	Up to 180 psi	2 hours	4 hours	36 hours	
	180 psi +	12 hours	24 hours	4 days	
6" to 8"	Up to 180 psi	8 hours	16 hours	3 days	
	180 psi +	24 hours	48 hours	9 days	

CPVC					
Pipe Diameter		Temperature during assembly and cure period			
		60° to 100°F	40° to 60°F	20° to 40°F	0° to 20°F
½" to 1¼"	Up to 180 psi	1 hour	2 hours	Please contact Oatey Technical Services for cure time information	
	180 psi +	6 hours	12 hours		
1½" to 3"	Up to 180 psi	2 hours	4 hrs		
	180 psi +	12 hours	24 hours		
4" to 5"	Up to 180 psi	6 hours	12 hours		
	180 psi +	18 hours	36 hours		
6" to 8"	Up to 180 psi	8 hours	16 hours		
	180 psi +	24 hours	48 hours		

Contact Oatey Technical Services for cure times for pipe larger than 8" diameter.

This data is applicable only for new piping installations and not recommended for repair or cut-ins on hot and cold water distribution systems. Please contact Oatey Technical Service for recommendations on Cure Times for such applications.

DO NOT test PVC and CPVC piping systems with compressed air or gas.

NOTES: Cure schedule is the time required before pressure testing the system
 - This chart can be used as a guideline to determine joint cure
 - Cure times stated are for conditions with relative humidity of 60% or less
 + In damp or humid weather, allow 50% additional cure time