WELD-ON: Set Cure Timetable

These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. this chart should be used as a general reference only.
Please note this is for water applications, if a chemical application allow at least two to three times the set and cure times shown.

AVERAGE INITIAL SET SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS				
Temperature Range	Pipe Sizes 1/2" to 1-1/4" 15mm to 32mm	Pipe Sizes 1-1/2" to 2" 40mm to 50mm	Pipe Sizes 2-1/2" to 8" 65mm to 200mm	Pipe Sizes 10" to 15" 225mm - 350mm
16 °C to 38 °C	2 minutes	5 minutes	30 minutes	2 hours
5 °C to 16 °C	5 minutes	10 minutes	2 hours	8 hours
-18 °C to 5 °C	10 minutes	15 minutes	12 hours	24 hours
Note: Initial set schedule is the necessary time to allow before the joint can be carefully handled				
In damp or humid weather allow 50% more set time				

AVERAGE JOINT CURE SCHEDULE FOR WELD-ON PVC/CPVC SOLVENT CEMENTS							
Relative Humidity 60% or Less	Pipe Sizes 1/2" to 1-1/4" 15mm to 32mm		Pipe Sizes 1-1/2" to 2" 40mm to 50mm		Pipe Sizes 2-1/2" to 8" 65mm to 200mm		Pipe Sizes 10" to 15" 225mm - 350mm
Temperature range during assembly and cure periods	up to 11 bar	11 to 26 bar	up to 11 bar	11 to 22 bar	up to 11 bar	11 to 22 bar	up to 7 bar
16 °C to 38 °C	15 min	6 hrs	30 min	12 hrs	1 1/2 hrs	24 hrs	48 hrs
5 °C to 16 °C	20 min	12 hrs	45 min	24 hrs	4 hrs	48hrs	96 hrs
-18 °C to 5 °C	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days
Note: Joint cure schedule is the necessary time to allow before pressurising system							
In damp or humid weather allow 50% more cure time							

Important Note:

The information provided is only for reference and there is no warranty or representation, neither expressed nor implied, that they are free from errors. PAAS shall not be liable for any damages of any kind that may result from the use of this data.