



SOLVENT CEMENT AVERAGE INITIAL SET AND CURE TIMES

Average Initial Set Schedule For Weld-On® PVC/CPVC Solvent Cements **

TEMPERATURE RANGE	MAX PIPE SIZE	1/2 - 1 1/4 IN (20 - 40 MM)	1 1/2 - 2 IN (50 - 63 MM)	2 1/2 - 8 IN (75 - 200 MM)	10 - 15 IN (250 - 380 MM)	15+ IN (380+ MM)
60° - 100° F (16° - 38° C)		2 MINS	5 MINS	30 MINS	2 HRS	4 HRS
40° - 60° F (5° - 16° C)		5 MINS	10 MINS	2 HRS	8 HRS	16 HRS
0° - 40° F (-18° - 5° C)		10 MINS	15 MINS	12 HRS	24 HRS	48 HRS

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	MAX PIPE SIZE	1/2 - 1 1/4 IN (20 - 40 MM)	1 1/2 - 2 IN (50 - 63 MM)	2 1/2 - 8 IN (75 - 200 MM)	10 - 15 IN (250 - 380 MM)	15+ IN (380+ MM)			
Temperature range during assembly and cure periods		up to 160 psi/ 11 Bar	160 to 370 psi/ 11 to 26 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 160 psi/ 11 Bar	160 to 315 psi/ 11 to 22 Bar	up to 100 psi/7 Bar	up to 100 psi/7 Bar
60° - 100° F (16° - 38° C)		15 MIN	6 HRS	30 MIN	12 HRS	1 1/2 HRS	24 HRS	48 HRS	72 HRS
40° - 60° F (5° - 16° C)		20 MIN	12 HRS	45 MIN	24 HRS	4 HRS	48 HRS	96 HRS	6 DAYS
0° - 40° F (-18° - 5° C)		30 MIN	48 HRS	1 HRS	96 HRS	72 HRS	8 DAYS	8 DAYS	14 DAYS

Note: Joint cure schedule is the necessary time to allow before pressurizing system. In damp or humid weather allow 50% more cure time.

**These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a reference only.

Average Number of Joints/Quart (1Kg) of Weld-On® Cement*

PIPE DIAMETERS	1/2" or 20mm	3/4" or 25mm	1" or 32mm	1 1/2" or 50mm	2" or 63mm	3" or 90mm	4" or 110mm	6" or 160mm	8" or 200mm	10" or 250mm	12" or 315mm	15" or 380mm	18" or 450mm
NUMBER OF JOINTS	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2

Note (for Primer): Double the number of joints shown for cement.

*These figures are estimates based on testing done under laboratory conditions. Field working conditions can vary significantly. This chart should be used as a reference only.

Pipe Size Equivalent Chart - Inches/Millimeters

INCH	1/2"	3/4"	1"	1 1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"	24"	30"
MM.	20	25	32	50	63	90	110	160	200	250	315	380	450	600	800

Product Shelf Life

WELD-ON PRODUCT	SHELF LIFE
Primers / Cleaners	3 Years
PVC Solvent Cements	3 Years
CPVC Solvent Cements	2 Years

Fahrenheit To Celsius Conversion Chart

