

PVC Cement Set & Cure Times



Set Time

The initial set time is the recommended waiting period before handling newly assembled joints. After initial set, the joints will withstand the stresses of normal installation. However, a badly misaligned installation will cause excessive stresses in the joint, pipe and fittings.

Average Set Times

Temperature Range	Pipe Sizes 15 to 32mm	Pipe Sizes 40 to 50mm	Pipe Sizes 65 to 200mm	Pipe Sizes 250 to 375mm
15°C - 37°C	2 minutes	5 minutes	30 minutes	2 hours
4°C - 15°C	5 minutes	10 minutes	2 hours	8 hours
-17°C - 4°C	10 minutes	15 minutes	12 hours	24 hours

Cure Time

The cure time is the recommended waiting period before pressurising newly assembled joints.

Average Set Times

Relative Humidity 60% or Less	Pipe Sizes 15 to 32mm		Pipe Sizes 40 to 50mm	
Temperature Range During Assembly & Cure Periods	Up to 160 PSI	160 PSI to 260 PSI	Up to 160 PSI	160 PSI to 260 PSI
15°C - 37 °C	15 minutes	6 hours	30 minutes	12 hours
4°C - 15°C	20 minutes	12 hours	45 minutes	24 hours
-17°C to 4°C	30 minutes	48 hours	1 hour	96 hours

Relative Humidity 60% or Less	Pipe Sizes 65mm to 200mm		Pipe Sizes 250mm to 375mm
Temperature Range During Assembly & Cure Periods	Up to 160 PSI	160 PSI to 260 PSI	Up to 160 PSI
15°C - 37 °C	1.5 hours	24 hours	48 hours
4°C - 15°C	4 hours	48 hours	96 hours
-17°C to 4°C	72 hours	8 days	8 days

N.B. In damp or humid weather, allow 50% more cure time. The cure schedules shown are suggested as guides only. They are based on laboratory test data and should not be taken to be the recommendations of all cement manufacturers. Individual solvent cement manufacturer's recommendations for the cement being used should be followed.

Helpful Tip - PVC Glue Roller Applicator



PVC SOLVENT APPLICATORS - Refer to SECTION D28 of the Waterworks Catalogue

SCA150

150mm Roller Applicator

6520-1

150mm Replacement Roller - 2 Pack

PVC glue roller applicator and replacement pack available for larger joints increasing from 150mm.
Allows you to apply cement and primer more evenly and faster.

Guide for estimating the number of joints per size

Estimated Quantities of Solvent Cement

A variety of conditions can affect the amount of solvent cement required for making reliable joints. These include pipe size, tolerances, socket depths as well as installation conditions and type of cement used. Fitting sockets are tapered for proper assembly, which produces a slight gap at the socket entrance when installed with pipe. As pipe sizes increase, heavier bodied cements should be used for increase gap fitting capabilities. It is best to use liberal amounts of solvent cement since insufficient cement use is one of the most common reasons for joint failure. The following information on cement usage is a recommendation only and other factors or unanticipated conditions may be encountered. Quantities are based on use with average socket lengths.

Estimated Number of Joints Per One Litre of Solvent Cement

Fitting Size (mm)	15	20	25	32	40	50	65	80
Joints per 1L	300	200	125	140	90	60	50	40

Fitting Size (mm)	100	150	200	250	300	350	400
Joints per 1L	30	10	5	2-3	1-2	0.75	1.25



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