



Solvent Cements

**LOOK
INSIDE**
for the industry's
most detailed
cure charts



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PVC

PVC piping systems are used for many applications including DWV (Drain, Waste and Vent), potable water systems, process pipe and sewer pipe. It is the most widely used type of plastic pipe. PVC pipe is very durable and can be used for applications up to 140°F.

CPVC

CPVC piping systems are used for a wide range of jobs. Copper tube size (CTS) CPVC pipe is designed for use in hot and cold potable water distribution systems. It can be used for residential applications, hotels and light commercial buildings. CTS pipe is very durable and can be used for applications up to 180°F. Larger diameter Schedule 80 CPVC piping systems can be used for applications up to 200°F. CPVC pipe is specially formulated to handle more corrosive materials and withstand higher internal pressure.

ABS

ABS pipe is primarily used for DWV (drain, waste and vent) applications in North America. ABS pipe is very durable and can be used for applications up to 140°F.

Primer & Cleaners

Primers and cleaners are important pieces of the solvent cementing process and primers are required by building codes for most applications. They help to prepare the pipe and fitting for solvent cementing by cleaning and softening the pipe and fitting making sure that the final joint integrity is maximized. For most cases, a cleaner should be used, followed by a primer and then the solvent cement. Additionally, after application of the primer, the solvent cement should be applied immediately before the primer dries. Note that primers should not be used for ABS pipe and that cleaner should be used in its place.



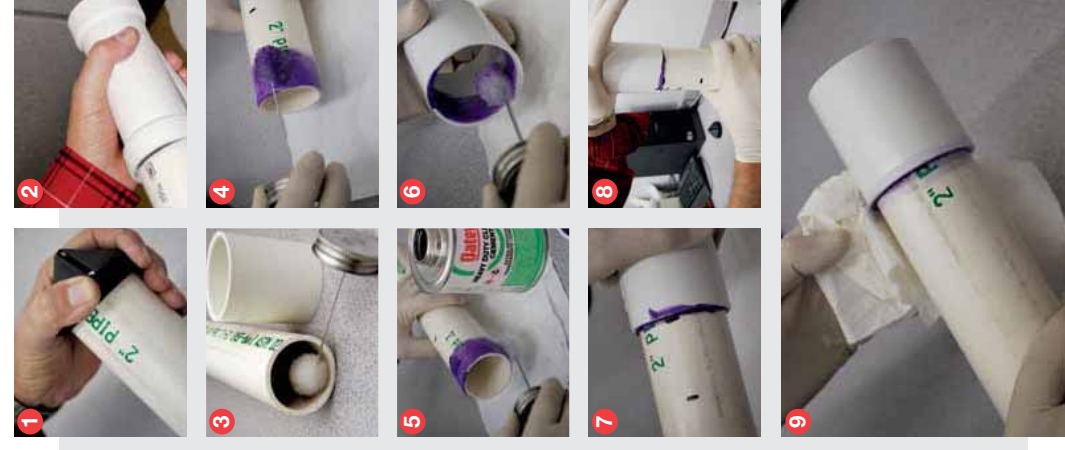
Check out our Solvent Cement App for the iPhone.

Solvent Cement Accessories

Category	Description / Size	Product Number	Carton Qty
Daubers	4oz Can	31299	48
	8oz Can	31309	48
	16oz Can	31310	48
	32oz Can	31312	48
	16/32oz Can	30359	50
	16/32oz can-CPVC	31313	48
	32oz Can	30357	48
	32oz Can	30358	50
	Adjustable	31300	100
	Adjustable	31301	100
Swabs	32oz Can	30354	24
	Wide Mouth Gallon	30356	24
Rollers	Gallon - wide & std mouth	31276	12
	32oz Wide Mouth Can	30351	24
	32oz Can	30352	24
	Wide Mouth Gallon	30353	20
	Gallon - wide & std mouth	31275	12
Brushes	Natural bristle brush	50200	36
	16/32oz Can	31257	48
Empty Cans	4oz Empty Can	31304	24
	8oz Empty Can	31305	24
	16oz Empty Can	31306	24
	32oz Empty Can	31307	12
	Gallon - 2-7/8" mouth	30901	6
	32oz including cap	30367	12
Bevelers	Gallon including cap	30376	6
	Hand Deburring Tool	30363	6
Pipe Puller	Large diameter pipe puller	30365	1
Can Carrier	Dual 32oz Can Carrier	31250	12



How To Solvent Weld



- Prior To Use:**
Read all product labels carefully.
 Stir or shake cement before using. If jelly-like, do not use. Keep container closed when not in use. Avoid eye and skin contact. Wear safety glasses with side shields and wear rubber gloves.
1. Cut pipe ends square, chamfer and clean pipe ends.
 2. Check dry fit of pipe and fitting. Pipe should easily go 1/3 of the way into the fitting. If pipe bottoms, it should be snug.
 3. Use a suitable applicator at least 1/2 the size of the pipe diameter. For larger size pipe systems use a natural bristle brush or roller.
 4. Clean pipe and fitting with a listed primer. (Do not use primer on ABS pipe and fittings. Use Clear Cleaner only)
 5. Apply liberal coat of cement to pipe to the depth of the socket, leave no uncoated surface.
 6. Apply a thin coat of cement to inside of fitting, avoid puddling of cement. Puddling can cause weakening and premature failure of pipe or fitting. Apply a second coat of cement to the pipe.
 7. Assemble parts QUICKLY. Cement must be fluid. If cement surface has dried, recoat both parts.
 8. Push pipe FULLY into fitting using a 1/4 turning motion until pipe bottoms.
 9. Hold pipe and fitting together for 30 seconds to prevent pipe push-out - longer at low temperatures. Wipe off excess.
 10. Allow 15 minutes for good handling strength and 2 hours cure time at temperatures above 60°F before pressure testing up to 180 psi. Longer cure times may be required at temperatures below 60°F or with pipe above 3". DO NOT TEST WITH AIR.
- For specialty cements and chemical applications please see specific product label instructions.

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 1/2" to 1-1/4"	Pipe Diameter 1-1/2" 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.



Average Joint Cure Times for Oatey Solvent Cements

PVC & ABS

Pipe Diameter	Temperature during assembly and cure period	Temperature during assembly and cure period			
		60°-100°F 16°-38°C	40°-60°F 4°-16°C	20°-40°F -7°-4°C	0°-20°F -18°-7°C
1/2" to 1-1/4" 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
1-1/2" to 3" 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
4" to 5" 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
6" to 8" 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
10" to 16" 250 to 400mm	Up to 100 psi	24 hrs	48 hrs	8 days	10 days
	180 psi +	36 hrs	72 hrs	12 days	14 days

CPVC

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

Please contact Oatey Technical Services for cure time information

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

Average Number of Joints Per Quart of Solvent Cement

Pipe Diameter	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	325	250	150	125	90	70	50	30	10	8	3	2	3/4	1/2

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



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