SET TIMES – CURE SCHEDULES – PRODUCT YIELD FOR PVC CEMENTS

During the initial setting of the cement (approximately 2 minutes) the joint should not be moved or disturbed. The cure schedules below are suggested guidelines only based on past field experience and laboratory testing and should not be taken as absolutes. Numerous factors, such as application conditions and specific cement used affect the actual cure rates, which may be faster or slower than the times indicated.

1. SET TIMES

AVERAGE INITIAL SET TIMES FOR SLUYTER PVC/CPVC SOLVENT CEMENTS

Temperature Range	Pipe Sizes ½" to 1¼"	Pipe Sizes 1½" to 2"	Pipe Sizes 2½" to 8"	Pipe Sizes 10" to 15"	Pipe Sizes 15"+
15° to 40°C	2 min	5 min	30 min	2 hrs	4 hrs
5° to 15°C	5 min	10 min	2 hrs	8 hrs	16 hrs
-16° to 5°C	10 min	15 min	12 hrs	24 hrs	48 hrs

- In damp or humid weather allow 50% more set time; extended set times are required for chemical applications.
- Important – The initial set schedule is the necessary time needed before the joint can be carefully handled.

2. JOINT CURE SCHEDULE

AVERAGE JOINT CURE SCHEDULE FOR SLUYTER PVC/CPVC SOLVENT CEMENTS

Relative Humidity 60% or Less	Cure Time Pipe Sizes ½" to 1¼"		Cure Time Pipe Sizes 1½" to 2"		Cure Time Pipe Sizes 2½" to 8"		Cure Time Pipe Sizes 10" to 15"	Cure Time Pipe Sizes 15"+
Temperature Range During Assembly and Cure Periods	up to 160 psi	160-370 psi	up to 160 psi	160-315 psi	up to 160 psi	160-315 psi	up to 100 psi	up to 100 psi
15° to 40°C	15 min	6 hrs	30 min	12 hrs	1½ hrs	24 hrs	48 hrs	72 hrs
5° to 15°C	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
-16° to 5°C	30 min	48 hrs	1 hr	96 hrs	72 hrs	8 days	8 days	14 days

- In damp or humid weather allow 50% more cure time; extended cure times are required for chemical applications.
- Important -Joint cure schedule is the necessary time needed before pressurizing system.

3. ESTIMATED CEMENT REQUIREMENTS

AVERAGE NUMBER OF JOINTS PER LITRE OF SLUYTER CEMENT

Pipe Diameter	1/2"	3/4"	1"	1½"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	300	200	125	90	60	40	30	10	5	2-3	1-2	3/4	1/2

4. ESTIMATED PRIMER REQUIREMENTS

AVERAGE NUMBER OF JOINTS PER LITRE OF SLUYTER PRIMER

Pipe Diameter	1/2"	3/4"	1"	1½"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	600	400	250	180	120	80	60	20	10	4-6	2-4	1½	1

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