

SET UP & CURE TIMES FOR ABS SOLVENT CEMENT

Three grades of ABS Solvent Cements

PRODUCT	SET AND CURE TIMES (3 being the fastest)
ABS 66Y Premium Solvent Cement	3
ABS 55Y Standard Grade Solvent Cement	2
ABS 55Y-LV Low VOC Solvent Cement	1

Set and cure times

The initial set between the pipe and the fitting takes place in a matter of minutes, and joints can therefore safely be handled in a very short time. However, the joint needs to cure before it can be used.

The time taken to achieve this depends upon a number of factors:-

- The type of ABS cement selected
- The tightness of fit
- The ambient temperature and humidity
- The size and length of the pipe and fittings, in relation to the installation. An upright large diameter, long length installation may require the assembly to be held in place longer than a horizontal assembly.

Joints will cure faster on tighter fitting assemblies in drier, warmer, conditions, whereas looser fit joints made in cooler and humid conditions will cure slower.

It is recommended that joints be left for 24 hours to cure before use, while large sizes 10" and 12" require a minimum of 48 hours. Where this is not possible, consideration may be given to the above factors before determining when joints are put into service.

Large diameter jointing

Solvent cement jointing on pipe sizes 6" and larger is a two-person operation. To ensure that solvent cements are applied at the correct speed they should be simultaneously applied to both pipe and fitting. The number one factor for joint failures, is applying too little cement. Applying a thorough coating of cement is critical at these sizes, to ensure a good weld and to ease the pipe into the fitting.

Set up time

Without taking into consideration, the temperature, pipe size and factors mentioned above, the following table should only be used as an approximate guide.

-1° C to 10° C	5 – 6 minutes
10° C to 21° C	3 – 4 minutes
21° C to 32° C	1 – 2 minutes

