



Average Handling / Set-up Times⁺

Handling / Set-up time is the time required prior to handling the joint carefully. In damp or humid weather, allow 50% additional cure time.						
Temperature While Joining	Pipe Diameter 1/2" to 1 1/4" 15 mm to 32 mm	Pipe Diameter 1 1/2" to 2" 40 mm to 50 mm	Pipe Diameter 2 1/2" to 5" 65 mm to 125 mm	Pipe Diameter 6" to 8" 150 mm to 200 mm	Pipe Diameter 10" to 16" 250 mm to 375 mm	Pipe Diameter 16"+ 400 mm
16 °C - 38 °C (60 °F - 100 °F)	2 minutes	5 minutes	25 minutes	30 minutes	2 hours	4 hours
5 °C - 16 °C (40 °F - 60 °F)	5 minutes	10 minutes	50 minutes	2 hours	8 hours	16 hours
-18 °C - 5 °C (0 °F - 40 °F)	10 minutes	15 minutes	4 hours	10 hours	24 hours	48 hours

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

Average Joint Cure Times⁺⁺

Joint Cure Time is the time required before pressure testing the system. In damp or humid weather, allow 50% additional cure time.								
Relative Humidity 60% or Less	Pipe Diameter 1/2" to 1 1/4" 15 mm to 32 mm		Pipe Diameter 1 1/2" to 2" 40 mm to 50 mm		Pipe Diameter 2 1/2" to 8" 65 mm to 200 mm		Pipe Diameter 10" to 15" 250 mm to 375 mm	Pipe Diameter 16"+ 400 mm
Temperature While Joining and Curing	up to 145 psi / 10 bar	145 to 363 psi / 10 to 25 bar	up to 145 psi / 10 bar	145 to 363 psi / 10 to 25 bar	up to 145 psi / 10 bar	145 to 363 psi / 10 to 25 bar	up to 100 psi / 7 bar	up to 100 psi / 7 bar
16 °C - 38 °C (60 °F - 100 °F)	15 min	6 hrs	30 min	12 hrs	1½ hrs	24 hrs	48 hrs	72 hrs
5 °C - 16 °C (40 °F - 60 °F)	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs	96 hrs	6 days
-18 °C - 5 °C (0 °F - 40 °F)	30 min	48 hrs	1 hour	96 hrs	72 hrs	8 days	8 days	14 days

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

Average Number of Joints per Quart Can^{*}

Pipe Nominal Size	ASTM	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	18
	ISO (DIN)	20	25	32	40	50	63	75	90	110	160	200	250	315	350	450
Number of Joints		300	200	125	105	90	60	50	40	30	10	6	2-3	1-2	3/4	1/2

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

Pipe Size Equivalent Chart

ASTM	1/2	3/4	1	1 1/4	1 1/2	2	2 1/2	3	4	6	8	10	12	14	18
ISO (DIN)	20	25	32	40	50	63	75	90	110	160	200	250	315	350	450

Fahrenheit to Celsius Conversion Chart

