

# AVERAGE JOINT SET & CURE SCHEDULES FOR AQUARISE® SOLVENT CEMENT

Average Joint SET Schedule For AquaRise Solvent Cement\*\*

Temperature Range	Pipe Sizes 1/2" to 1-1/4"	Pipe Sizes 1-1/2" to 2"	Pipe Sizes 2-1/2" to 4"
60° – 100 °F (15° – 38 °C)	2 minutes	5 minutes	30 minutes
40° – 60 °F (5° – 15 °C)	5 minutes	10 minutes	2 hours

**Note:** Initial set schedule is the necessary time to allow before the joint can be carefully handled.

\*\* Due to the many variables in the field, these figures are to be used as a general guide only.

Average Joint CURE Schedule For AquaRise Solvent Cement\*\*<sup>1</sup>

Relative Humidity 60% or Less	Cure Time Pipe Sizes 1/2" to 1-1/4"		Cure Time Pipe Sizes 1-1/2" to 2"		Cure Time Pipe Sizes 2-1/2" to 4"	
	Up to 160 psi	Above 160 psi	Up to 160 psi	Above 160 psi	Up to 160 psi	Above 160 psi
Temperature Range during assembly and cure periods						
60° – 100 °F (15° – 38 °C)	15 min	6 hrs	30 min	12 hrs	1-1/2 hrs	24 hrs
40° – 60 °F (5° – 15 °C)	20 min	12 hrs	45 min	24 hrs	4 hrs	48 hrs

**Note:** Joint cure schedule is the necessary time to allow before pressurizing the system. In damp or humid weather allow 50% more cure time.

\*\* Due to the many variables in the field, these figures are to be used as a general guide only.

<sup>1</sup>Pressure values shown in this table indicate the maximum test pressure of the piping system. The system should not be pressurized at all until this cure time has elapsed.

## NOTICE

The values provided in these charts are for guidance only and do not necessarily reflect the actual return to service time required for every situation. Installers must allow for additional time where possible when returning AquaRise systems to hot water service.