

CURE TIME AND SET TIME – ASTM Guideline

(Relative Humidity 60% or Less) Temperature during assembly or cure time	Pipe Sizes ½" to 1 ¼"		Pipe Sizes 1 ½" to 3"		Pipe Sizes 4" to 8"		Pipe Sizes 10" to 16"	Pipe Sizes 16" and Larger
	Up to 180 psi	180 psi Plus	Up to 180 psi	180 psi Plus	Up to 180 psi	180 psi Plus	Up to 100 psi	Up to 100 psi
16°C to 38°C	1 Hours	6 Hours	2 Hours	12 Hours	8 Hours	16 Hours	24 Hours	36 Hours
4°C to 16°C	2 Hours	12 Hours	4 Hours	24 Hours	16 Hours	48 Hours	48 Hours	72 Hours
4°C and Lower	8 Hours	48 Hours	16 Hours	96 Hours	4 Days	12 Days	10 Days	14 Days

- Cure time is time required before pressure testing the system
- In damp and humid weather allow 50% additional cure time
- These figures should only be used as a general guide. Conditions in field may vary

Set time is time required before handling the assembly. Set time should not be confused with cure time.