

Cure Schedules for BlazeMaster® CPVC

BlazeMaster® CPVC pipe and fittings are lightweight, flexible and join together using a quick, one-step solvent cement process. For a successful installation, follow manufacturer's recommended cure times for pressure, pipe size and temperature. The following cure schedules assume that the pipe and fittings are dry. If water is present, cure times will increase.

Cure Schedules for New Systems

225 PSI (1552 KPA) Test Pressure (Maximum)

Ambient Temperature During Cure Period
 (Use this table for all cut-ins)

| Pipe Size | 60°F to 120°F (16°C to 49°C) | 40°F to 59°F (4°C to 15°C) | 0°F to 39°F (-18°C to 4°C) |
|-------------------------------------|---------------------------------|-------------------------------|-------------------------------|
| 3/4" (20 mm) | 1 hr. | 4 hrs. | 48 hrs. |
| 1" (25 mm) | 1 1/2 hrs. | 4 hrs. | 48 hrs. |
| 1 1/4" and 1 1/2" (32 and 40 mm) | 3 hrs. | 32 hrs. | 10 days |
| 2" (50 mm) | 8 hrs. | 48 hrs. | Note 1 |
| 2 1/2" and 3" (65 and 80 mm) | 24 hrs. | 96 hrs. | Note 1 |

200 PSI (1379 KPA) Test Pressure (Maximum)

Ambient Temperature During Cure Period

| Pipe Size | 60°F to 120°F (16°C to 49°C) | 40°F to 59°F (4°C to 15°C) | 0°F to 39°F (-18°C to 4°C) |
|-------------------------------------|---------------------------------|-------------------------------|-------------------------------|
| 3/4" (20 mm) | 45 mins. | 1 1/2 hrs. | 24 hrs. |
| 1" (25 mm) | 45 mins. | 1 1/2 hrs. | 24 hrs. |
| 1 1/4" and 1 1/2" (32 and 40 mm) | 1 1/2 hrs. | 16 hrs. | 120 hrs. |
| 2" (50 mm) | 6 hrs. | 36 hrs. | Note 1 |
| 2 1/2" and 3" (65 and 80 mm) | 8 hrs. | 72 hrs. | Note 1 |

Note 1: For these sizes, the solvent cement can be applied at temperatures below 40°F (4°C). However, the sprinkler system temperature must be raised to a temperature of 40°F (4°C) or above and allowed to cure per the above recommendations prior to pressure testing.

Follow manufacturer's instructions on pressure testing. Fill lines slowly and bleed the air from the system prior to pressure testing.

100 PSI (690 KPA) Test Pressure (Maximum)

Ambient Temperature During Cure Period

| Pipe Size | 60°F to 120°F (16°C to 49°C) | 40°F to 59°F (4°C to 15°C) | 0°F to 39°F (-18°C to 4°C) |
|----------------|---------------------------------|-------------------------------|-------------------------------|
| 3/4" (20 mm) | 15 mins. | 15 mins. | 30 mins. |
| 1" (25 mm) | 15 mins. | 30 mins. | 30 mins. |
| 1 1/4" (32 mm) | 15 mins. | 30 mins. | 2 hrs. |

Cure Schedules for Existing Systems

Cut-ins: Minimum Cure Prior to Pressure Testing

Ambient Temperature During Cure Period

| Pipe Size | 60°F to 120°F (16°C to 49°C) | 40°F to 59°F (4°C to 15°C) | 0°F to 39°F (-18°C to 4°C) |
|-------------------------------------|---------------------------------|-------------------------------|-------------------------------|
| 3/4" (20 mm) | 1 hr. | 4 hrs. | 48 hrs. |
| 1" (25 mm) | 1 1/2 hrs. | 4 hrs. | 48 hrs. |
| 1 1/4" and 1 1/2" (32 and 40 mm) | 3 hrs. | 32 hrs. | 10 days |
| 2" (50 mm) | 8 hrs. | 48 hrs. | Note 2 |
| 2 1/2" and 3" (65 and 80 mm) | 24 hrs. | 96 hrs. | Note 2 |

Note 2: Solvent cement can be applied at temperatures below 40°F (4°C) for pipe 2 inches in size and larger. However, the temperature of the system must be raised to 40°F (4°C) or higher and allowed to cure per the above recommendations prior to pressure testing. When bringing cement, pipe or fittings in from the outside, be sure they are brought up to room temperature before using the 60°F (16°C) to 120°F (49°C) cure schedule.



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