HEAVY DUTY
MEDIUM SET GRAY PVC CEMENT

Oatey Heavy Duty Medium Set Gray PVC Cement is designed to have a thicker viscosity and medium set time for use with large diameter pipe and in commercial applications.

HEAVY DUTY BRAND
The newest formulation from the top solvent cement manufacturer in the world.

HEAVY DUTY BOND
Superior gap filling properties and bond strength.

For use on PVC pipe up to 18" (non-pressure) and 12" (pressure).

HEAVY DUTY CEMENT
Oatey Heavy Duty Medium Set Gray Cement allows for more working time on large diameter pipe.

Check out Oatey's full line of Solvent Cements, Primers and Cement Accessories on Oatey.com.

Product Number	Size	Description	Carton Qty.	UPC
32262	16 oz	Heavy Duty Medium Set Gray PVC Cement	24	038753322629
32263	32 oz	Heavy Duty Medium Set Gray PVC Cement	12	038753322636
32264	1 gl	Heavy Duty Medium Set Gray PVC Cement	6	038753322643

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Average Joint Cure Times for Oatey PVC Solvent Cements

Pipe Diameter		Temperature during assembly and cure period			
		60° to 100°F 16° to 38°C	**40° to 60°F** 4° to 16°C	**20° to 40°F** -7° to 4°C	**0° to 20°F** -18° to -7°C
1/2" to 1-1/4" 13 to 32mm	Up to 180 psi	15 min	20 min	30 min	60 min
	180 psi +	4 hours	8 hours	36 hours	48 hours
1-1/2" to 3" 40 to 80mm	Up to 180 psi	30 min	45 min	60 min	Please contact Oatey Technical Services for cure time information
	180 psi +	8 hours	16 hours	3 days	
4" to 5" 100 to 125mm	Up to 180 psi	2 hours	4 hours	36 hours	
	180 psi +	12 hours	24 hours	4 days	
6" to 8" 150 to 200mm	Up to 180 psi	8 hours	16 hours	3 days	
	180 psi +	24 hours	48 hrs	9 days	
10" to 16" 250 to 400mm	Up to 100 psi	24 hours	48 hrs	8 days	
18" or more 460mm or more	Up to 100 psi	36 hours	3 days	12 days	

This data is applicable only for new piping installations and not recommended for repair or cut-ins on hot and cold water distribution systems. Please contact Oatey Technical Service for recommendations on cure times for such applications.

DO NOT test PVC piping systems with compressed air or gas.

Notes: Cure schedule is the time required before pressure testing the system.
- This chart can be used as a guideline to determine joint cure
- Cure times stated are for conditions with relative humidty of 60% or less
- In damp or humid weather allow 50% additional cure time

Average Handling/Set-Up Times for PVC Solvent Cements

Handling/Set-Up Time is the time required prior to handling the joint. In damp or humid weather, allow 50% additional time.

Temperature during assembly	Pipe Diameter 1/2" to 1-1/4"	Pipe Diameter 1-1/2" to 3"	Pipe Diameter 4" to 5"	Pipe Diameter 6" to 8"	Pipe Diameter 10" to 16"	Pipe Diameter 18"+
60º to 100ºF	2 minutes	5 minutes	15 minutes	30 minutes	2 hours	4 hours
40º to 60ºF	5 minutes	10 minutes	30 minutes	90 minutes	8 hours	16 hours
20º to 40ºF	8 minutes	12 minutes	60 minutes	3 hours	12 hours	24 hours
0º to 20ºF	10 minutes	15 minutes	2 hours	6 hours	24 hours	48 hours

These figures should only be used as a general guide. Conditions in the field may vary.

Average Number of Joints Per Quart of Solvent Cement

Pipe Diameter	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	3"	4"	6"	8"	10"	12"	15"	18"
Number of Joints	325	250	150	125	90	70	50	30	10	8	3	2	3/4	1/2

These figures are estimates based on laboratory testing. Conditions in the field may vary.

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