

BUTT FUSION TIME CYCLE GUIDELINES			
PIPE SIZE	440°F HEATING TIME (sec)	500°F HEATING TIME (sec)	HOLDING TIME (sec)
* 1/2" CTS	15-18	6-7	50
* 3/4" CTS	16-19	8-10	50
* 1" CTS	18-22	14-17	50
* 1-1/4" CTS	20-24	16-19	50
* 1/2" IPS	16-19	8-10	50
* 3/4" IPS	18-22	14-17	50
* 1" IPS	20-24	16-19	50
1-1/4" IPS	35-42	18-22	70
1-1/2" IPS	50-60	26-31	90
2" IPS	55-66	28-34	90
3" IPS	65-78	30-36	120
4" IPS	75-90	35-42	120
6" IPS	105-126	55-66	180
8" IPS & larger	Visual	Visual	Cool To Touch