

SOCKET FUSION TIME (*(Heater Face at 500°*

PIPE SIZE	HEATING TIME (sec)
1/2" CTS	9-10
3/4" CTS	9-10
1" CTS	14-16
1-1/4" CTS	14-16
1/2" IPS	9-10
3/4" IPS	12-14
1" IPS	15-17
1-1/4" IPS	18-21
1-1/2" IPS	20-23
2" IPS	24-28
3" IPS	28-32
4" IPS	32-37

CYCLES
° F)
HOLDING TIME (sec)
30
30
30
30
30
30
40
40
40
40
50
50