

POLYLOK™ Inc.

Innovations in Precast, Drainage
& Wastewater Products



Zabel®
A Division of Polylok Inc.

3 Fairfield Blvd, Wallingford, Connecticut 06492
Office: 1-877-765-9565 Fax: 203-284-8514
email: sales@polylok.com
Web site: www.polylok.com

RE: Polylok recommended procedure for solvent welding PVC pipe to ABS fittings

To Whom It May Concern:

This report documents the procedure used to properly solvent weld (cement) PVC to ABS.

First, it is imperative that both surfaces to be joined must be cleaned with PVC/ABS cleaner. Second, PVC primer should be applied to both surfaces. Third, before the primer is completely dry, PVC cement is to be applied to both surfaces. The surfaces are then joined together until they are "bottomed-out." A twist of at least 90 degrees should now be done. This twisting action allows the cement to partially dissolve both surfaces. Pipe and fitting must be held in final position to prevent "back out."

Polylok has tested this procedure in the laboratory and in the field for 15 years. In the laboratory these solvent welded joints have withstood up to 130 lbs. of pressure. We have not experienced a single failure with our filters or tees when this procedure is followed.

Should you have any questions regarding this procedure or testing, please do not hesitate to contact my office.

Regards,

Charles L. Brix
Vice President of Design & Engineering
Polylok Inc.
3 Fairfield Blvd.
Wallingford, CT 06492
Tel -203-626-6123
Fax -203-284-3495