

**GENERAL DESCRIPTION:**

Weld-On® P-68™ Primer is a low VOC emission, non-bodied, fast acting, primer. The strong action of P-68 primer rapidly softens and dissolves the joining surfaces of PVC and CPVC pipe and fittings. Available in clear and purple; the latter allows easy identification when used on the joining surfaces.

**APPLICATION:**

Weld-On P-68 Primer, when used in conjunction with appropriate WELD-ON solvent cements, will make consistently strong, well-fused joints. It is essential that the joining surfaces of pipe and fittings be softened and remains softened prior to assembly. The main function of the primer is to expedite the penetration and softening of the surfaces. Its rate of penetration into the joining surfaces is more rapid than that of solvent cement alone. P-68 primer is suitable for use with all types, classes and schedules of PVC and CPVC pipe and fittings.

**AVAILABILITY:**

Both Weld-On P-68 Primer, clear and purple colors, are available in ¼ pint (118 ml), ½ pint (237 ml), pint (473 ml), quart (946 ml) and gallon (3.785 l) metal cans. For detailed information on containers and applicators, see our current Price List.

**STANDARDS AND CERTIFICATION LISTINGS:**

- Meets ASTM F 656 Standard
- Meets SCAQMD Rule 1168/316A
- Compliant with LEED® (Leadership in Energy and Environmental Design). When using this Weld-On low VOC product, credit can be claimed for LEED Green Building Rating System - Indoor Environmental Quality.
- Listed by NSF International for compliance with ASTM F 656, NSF/ANSI Standard 14, and NSF/ANSI Standard 61 for use on potable water, drain, waste, vent and sewer applications.
- Weld-On P-68 Primer, purple color only, is listed by IAPMO for compliance with ASTM F 656 and applicable sections of the latest edition of the Uniform Plumbing Code®.

**SPECIFICATIONS:**

COLOR: Clear or Purple  
SPECIFIC GRAVITY: 0.842 ± 0.04  
BROOKFIELD VISCOSITY: Water Thin

**SHELF LIFE:**

3 years in tightly sealed containers. The date code of manufacture is stamped on the bottom of the container. Stability of the product is limited by the evaporation of the solvent when the container is opened. Adding of solvents is not recommended and may significantly change the properties of the primer.

**QUALITY ASSURANCE:**

Weld-On P-68 Primer is carefully evaluated to assure that consistent high quality is maintained. Fourier transform infrared spectroscopy, gas chromatography, and additional in depth testing ensures each batch is manufactured to exacting standards. A batch identification code is stamped on each can and assures traceability of all materials and processes used in manufacturing this product.

**SPECIAL PRECAUTION:**

Weld-On solvent cements must never be used in PVC piping system using or being tested by compressed air or gases; including air-over-water booster. If using in conjunction with flue gas ventilation systems, review the recommendations of the HVAC manufacturer's equipment related to installation and venting. Note that such recommendations may only refer to ASTM standards addressing installation of PVC pipe and fittings, and not to the use of PVC pipe and fittings in flue gas ventilation systems. Also review the technical information available from manufacturers of PVC pipe and fittings concerning the use of their products in flue gas ventilation systems.

Do not use a dry granular calcium hypochlorite as a disinfecting material for water purification in potable water piping systems. The introduction of granules or pellets of calcium hypochlorite with PVC solvent cements and primers (including their vapors) may result in a violent chemical reaction if a water solution is not used. It is advisable to purify lines by pumping chlorinated water into the piping system – this solution will be nonvolatile. Furthermore, dry granular calcium hypochlorite should not be stored or used near solvent cements and primers.



This product is intended for use by skilled individuals at their own risk. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Detailed directions on making solvent cemented joints are printed on the container label. It is highly recommended that the installer review the instructions supplied by the pipe and fitting manufacturer.

*Refer to the current Weld-On P-68 Primer Safety Data Sheet for additional safety precautions, first-aid, storage, handling, transportation and disposal information.*

**WARRANTY:**

Weld-On Adhesives, Inc., warrants to all original purchasers of Weld-On products that all new Weld-On products shall be of good quality and free from defects in material and workmanship for the product's shelf life. If any Weld-On product becomes defective, or fails to conform to this written limited warranty under normal use and storage conditions, and if the original purchaser complies with the terms of this limited warranty, then Weld-On will, without charge, replace the nonconforming product.

This limited warranty shall extend to all products manufactured and sold by Weld-On. However, this limited warranty shall not extend to, nor shall Weld-On be responsible for, damages or loss resulting from accident, misuse, negligent use, improper application, or incorporation of Weld-On products into other products. In addition, any repackaging of Weld-On products also shall void the limited warranty provided herein.

Any defective Weld-On products shall be replaced pursuant to the terms of this limited warranty by returning the defective product, with transportation charges prepaid, to Weld-On at the following address:

Weld-On Adhesives, Inc.  
Attn: Customer Service  
455 West Victoria Street  
Compton, CA 90220

Any implied warranty in connection with any Weld-On product hereby is limited in duration to the period of this limited warranty. Weld-On shall not be responsible for, nor does this limited warranty extend to, consequential damage, or incidental damage or expense, including without limitation, injury to persons or property or loss of use. This limited warranty is in lieu of all other express warranties of Weld-On, and Weld-On does not assume, nor does it authorize any person to assume on its behalf, any other obligation or liability.