

**GENERAL DESCRIPTION:**

WELD-ON® P-68™ 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.

Detailed directions on making solvent cemented joints are printed on the container label. An installation DVD/CD covering solvent cementing is available. It not only describes the basic principles of solvent cementing, but also covers the handling, storage and use of our products. It is highly recommended that the installer review the instructions supplied by the pipe and fitting manufacturer.

**NOTE:** WELD-ON solvent cements must never be used in a CPVC system using or being tested by compressed air or gases; including air-over-water booster.

**AVAILABILITY:**

WELD-ON Both WELD-ON P-68 clear and purple primers 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 Purple Only** - 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: 0.841 ± 0.040  
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.

**SHIPPING:****For One Liter and Above**

Proper Shipping Name: Flammable Liquid  
n.o.s. (Acetone, Methyl Ethyl Ketone)  
Hazard Class: 3  
Identification Number: UN 1993  
Packing Group: II  
Label Required: Flammable Liquid

**For Less than One Liter**

Proper Shipping Name: Consumer Commodity  
Hazard Class: ORM-D

**SAFETY AND ENVIRONMENTAL PRECAUTIONS:**

This product is flammable and considered a hazardous material. In conformance with the Federal Hazardous Substances Labeling Act, the following hazards and precautions are given. Purchasers who repackage this product must also conform to all local, state and federal labeling, safety and other regulations. VOC emissions do not exceed 550 grams per liter.

**DANGER: EXTREMELY FLAMMABLE. VAPOR HARMFUL.  
MAY BE HARMFUL IF SWALLOWED. MAY IRRITATE SKIN OR EYES.**

Keep out of reach of children. Do not take internally. Keep away from heat, spark, open flame and other sources of ignition. Vapors may ignite explosively. Solvent cement vapors are heavier than air and may travel to source(s) of ignition at or near ground or lower level(s) and flash back. Keep container closed when not in use. Store between 40°F (5°C) and 110°F (44°C). Avoid breathing of vapors. Use only in well-ventilated area. If confined or partially enclosed, use forced ventilation. When necessary, use local exhaust ventilation to remove harmful airborne contaminants from employee breathing zone and to keep contaminants below 25 ppm TWA. Atmospheric levels must be maintained below established exposure limits contained in Section II of the Material Safety Data Sheet (MSDS). If airborne concentrations exceed those limits, use of a NIOSH approved organic vapor cartridge respirator with full face-piece is recommended. The effectiveness of an air-purifying respirator is limited. Use it only for a single short-term exposure. For emergency and other conditions where short-term exposure guidelines may be exceeded, use an approved positive pressure self-contained breathing apparatus. Do not smoke, eat or drink while working with this product. Avoid contact with skin, eyes and clothing. May cause eye injury. Protective equipment such as gloves, goggles and impervious apron should be used. Carefully read Material Safety Data Sheet and follow all precautions. Do not use this product for other than intended use.

“SARA Title III Section 313 Supplier Notification”: This product contains toxic chemicals subject to the reporting requirements of Section 313 of the Emergency Planning and Community Right-to-Know Act (EPCRA) of 1986 and of 40CFR372. This information must be included in all MSDS that are copied and distributed for this material.

**FIRST AID:**

- Inhalation: If overcome with vapors, remove to fresh air. If not breathing, give artificial respiration. If breathing is difficult, give oxygen. Call physician.
- Eye Contact: Flush with plenty of water for 15 minutes and call a physician.
- Skin Contact: Wash skin with plenty of soap and water for at least 15 minutes. If irritation develops, get medical attention.
- Ingestion: If swallowed, give 1 or 2 glasses of water or milk. Do not induce vomiting. Contact physician or poison control center immediately.

**SPECIAL PRECAUTION:**

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 and CPVC 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.

**IMPORTANT NOTE:**

This product is intended for use by skilled individuals at their own risk. These suggestions and data are based on information we believe to be reliable. Installers should verify for themselves that they can make satisfactory joints under varying conditions. Toward this end, it is highly desirable that they receive personal instruction from trained instructors or competent, experienced installers. Contact IPS® Corporation or your supplier for additional information or instructions.

**WARRANTY:**

IPS® Corporation (“IPS Corp.”) warrants that all new IPS Corp. products shall be of good quality and free from defects in material and workmanship for the shelf life as indicated on the product. If any IPS Corp. product becomes defective, or fails to conform to our written limited warranty under normal use and storage conditions, then IPS Corp. will, without charge, replace the nonconforming product. However, this limited warranty shall not extend to, nor shall IPS Corp. be responsible for, damages or loss resulting from accident, misuse, negligent use, improper application, or incorporation of IPS Corp. products into other products. In addition, any repackaging of IPS Corp. products also shall void the limited warranty. IPS Corp. 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. Please refer to our standard IPS Corp. Limited Warranty for additional provisions.



455 W. Victoria Street  
Compton, CA 90220 U.S.A.  
Tel: 310.898.3300  
Fax: 310.898.3392

500 Distribution Parkway  
Collierville, TN 38017 U.S.A.  
Tel: 901.853.5001  
Fax: 901.853.5008

Customer Service: 800.888.8312  
[www.ipscorp.com](http://www.ipscorp.com)

