



**PRODUCT DESCRIPTION:**

Weld-On® P-68 ECO PRIMER™ is a code compliant, THF-free primer with 30% lower solvent emission rate and significantly reduced odorous fumes than the current products in the market – resulting in an improved workplace environment for pipe installers.

The P-68 ECO PRIMER is a clear or purple, ultra low VOC, fast acting primer that rapidly softens and dissolves the joining surfaces of PVC and CPVC pipe and fittings prior to the application of solvent cement.

**APPLICATION:**

Weld-On P-68 ECO PRIMER is suitable for use on all types, classes and schedules of PVC and CPVC pipe and fittings. The use of P-68 ECO PRIMER helps prepare and soften the joining surfaces, allowing the Weld-On solvent cement to better solvent-weld and make the joint well-fused.

**SPECIFICATION:**

COLOR:	CLEAR or PURPLE
SPECIFIC GRAVITY:	0.857 ± 0.04
BROOKFIELD VISCOSITY:	Water-thin
VOC CONTENT:	≤ 398 g/L
SHELF-LIFE:	3 Years

**STANDARD & CERTIFICATION:**

- Meets ASTM F656
- Meets 2023 SCAQMD Rule 1168/316A – low VOC regulations
- Credit can be earned per LEED® (Leadership in Energy and Environmental Design), IEQ Credit 4.1.
- Certified by NSF International to NSF/ANSI Standard 14 and 61 for use on potable water applications
- Purple primer only – certified by NSF International to the Uniform Plumbing Code



**AVAILABILITY:**

Stock #	Size / Cap Type	Color	Units / Case	Lbs / Case	Cubic Feet / Case	UPC BARCODE
14838	Gallon with narrow-mouth screw cap	Clear	6	49	1.07	0 12181 14838 9
14839	Quart with dauber cap	Clear	12	25	0.67	0 12181 14839 6
14840	Pint with dauber cap	Clear	12	13	0.36	0 12181 14840 2
14843	Gallon with narrow-mouth screw cap	Purple	6	49	1.07	0 12181 14843 3
14844	Quart with dauber cap	Purple	12	25	0.67	0 12181 14844 0
14845	Pint with dauber cap	Purple	12	13	0.36	0 12181 14845 7

**P-68 Primer stock # transitioning to P-68 ECO Primer:**

US: P-68 → P-68 ECO Clear #10207 gallon / #10209 quart / #10211 pint. P-68 → P-68 ECO Purple #10208 gallon / #10210 quart / #10212 pint  
 Canada: P-68 → P-68 ECO Clear #12207 gallon / #12208 quart / #12209 pint. P-68 → P-68 ECO Purple #12674 gallon / #12485 quart / #12486 pint



**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 product.

**QUALITY ASSURANCE:**

Weld-On P-68 ECO 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 plastic piping system using or being tested by compressed air or gases; including air-over-water booster. Do not use in conjunction with 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 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 ECO 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.