



Product Data

Rust-Ex Pro-Poxy I Primer PIE Series (730)

Description: Excalibur's **PIE 730 Pro-Poxy I Primer** is a vinyl modified, two component, polyamide cured primer that forms a hard and tough coating and exhibits excellent impact and abrasion resistance. It also has good resistance to fresh water, sea water, crude oil, splashes of mineral oil, aliphatic solvents and a wide range of chemicals.

Recommended Uses: As a high build primer or intermediate coat in heavy duty paint systems. Also for repaint and maintenance work on hatch covers, decks, cargo holds etc. when the performance of an epoxy coating is required but the usual high demands to surface preparation cannot be obtained.

PHYSICAL CONSTANTS *(Subject to normal manufacturing tolerances)*

Finish: Semi-gloss
Color / Shade: Red & Gray
Components: 2 (Two)
Mixing Ratio: 1:1 Base to Activator
Volume Solids: 42% / US gallon **mixed** (depending on color)

Dry Time @77° F. and 55% RH:	Surface Temperature	To Touch	Tack Free / Overcoat	Dry Hard	Fully Cured	Pot Life
	35° F (2° C)	4 hours	8 hours	24 hours	10 days	16 hours
	50° F (10° C)	2 hours	4 hours	20 hours	8 days	12 hours
	70° F (21° C)	1 hour	2 hours	9 hours	7 days	8 hours
	90° F (32° C)	45 minutes	1 hour	12 hours	5 days	4 hours

For faster dry times or low temperature applications, use Excalibur's Epoxy Accelerator.

Theoretical Coverage: 334 sq. ft. / US gallon @ 2 mils DFT (no loss)
Recommended DFT: 2.0 - 4.0 mils minimum or according to specification
Shelf Life: 24 months when stored indoors @ 75° F. (24° C.)
Storage Temp: 45° - 110° F. (7° - 43° C.)
Clean Up: Excalibur's R-020 Epoxy Reducer
VOC: 3.261 lbs. / US gallon **mixed** (depending on color)



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Surface Preparation: Remove all oil, grease and other contaminants by washing with solvent or surface cleaner/degreaser in accordance with SSPC-SP1. Allow to dry prior to painting. For minimum surface preparation, Hand Tool or Power Tool clean to remove all loose rust, paint, dirt, etc. in accordance with SSPC-SP2. For optimum performance, commercial blast with a 1-2 mil blast profile.

Application Conditions:

Surface Condition	Surface Temperature	Ambient Temperature	Humidity
Normal	60°-85° F (16°-29° C)	60°-90° F (16°-32° C)	0-80%
Minimum	35° F (2° C)	35° F (2° C)	0%
Maximum	125° F (52° C)	110° F (43° C)	90%

Surface temperature **MUST** be 5° above the dew point to avoid condensation which can cause flash rusting and interfere with adhesion.

Application Equipment: Airless or Assisted Airless • Roller • Brush (touch-up only)

Mixing Instructions: Mix 1 (one) Part B (PIE Activator) with 1 (one) Part A (PIE Color). Stir thoroughly making sure no pigment remains on the bottom of the can and the color is uniform. DO NOT mix more material than will be used within the pot life time, approx. 8 hours. **These products are weighed while being packaged for accuracy. Mixing a partial kit is not recommended.**

Thinning: N/A

Packaging:	1 Gallon Kit	Approx. Shipping Weight:	11.50 lbs. / 5.27 kg
	5 Gallon Kit	Approx. Shipping Weight:	57.00 lbs. / 26.14 kg

Compatibility: If unsure about the compatibility of this product with other commodities, please contact an Excalibur technical service representative at 877-392-2542.

PRECAUTIONS

***** SAFETY ***** Packings are provided with applicable safety labels which should be observed. In addition, national and local regulations should be followed.

As a general rule, inhalation of solvent vapors or paint mist and contact of liquid paint with skin and eyes should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory skin and eye protection are always recommended when painting. See complete Material & Safety Data Sheets for detailed health hazards and safety information.

DISCLAIMER and LIMITATION OF LIABILITY

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