

# Product Data



**Rust-Ex  
Eco - Pox Primer  
PIE - Series**

**Description:** **PIE - Series** is a economical, highly versatile cross linked epoxy that may be used in a wide variety of applications and industries. It may be used as a traditional primer or as a stand alone primer/finish coat. It has a high solids, low VOC and exhibits excellent corrosion protection, impact and abrasion resistance. It forms a tough, flexible chemical resistant film yet is easy to sand.

**Recommended Uses:** A VOC compliant, high build primer for use as an intermediate coat over zinc rich or as a primer to protect structural steel, tanks, drilling substructures, piping, trailers, separators, etc. from severe industrial environments. Great choice of epoxy primer for OEM manufactures or anyone who is looking for a high performance epoxy to meet demanding production schedules. May also be used for immersion in non-potable water, fresh water or salt water. Consult your Excalibur Representative for other chemicals.

## PHYSICAL CONSTANTS

*(Subject to normal manufacturing tolerances)*

**Finish:** Semi-Gloss  
**Color / Shade:** Red, Gray, Buff  
**Components:** 2 (Two)  
**Mixing Ratio:** 4:1 Base to Activator  
**Volume Solids:** 50% / US gallon **mixed** (depending on color)

Dry Time @77° F. and 55% RH:	Surface Temperature	Dry 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	16 hours	7 days	8 hours
	90° F (32° C)	45 minutes	30 minutes	12 hours	5 days	4 hours

*Dry times may be significantly reduced with the utilization of plural component equipment and/or the reduction of pot life.*

**Theoretical Coverage:** 401 sq. ft. / US gallon @ 2 mils DFT (no loss)  
**Recommended DFT:** 2.0 - 4.0 mils typical or up to 8.0 mils for severe duty applications.  
**Pot Life:** 8 hours at 70°-80° F @ 50% relative humidity  
**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:** 2.769 lbs. / US gallon **mixed** (depending on color)

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## Rust-Ex Eco - Pox Primer PIE - Series

**Surface Preparation:** **Maximum Protection:** Abrasive blast to SA 2½, SSPC-SP-10. Minimum surface profile according to Keane Tator Comparator 2.0 G/S.

**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 adhesion failure. Minimum temperature for curing is 14° F (-10° C). At the freezing point and below, be aware of risk of ice on the surface which will hinder adhesion.

**Application Equipment:** Airless, Assisted Airless, Conventional

**Mixing Instructions:** Mix 4 (four) Parts A (Base) with 1 (one) Part B (Activator). 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. **These products are weighed while being packaged for accuracy. Mixing a partial kit is not recommended.**

**Thinning:** Up to 5% with Excalibur's R-020 Epoxy Reducer

**Packaging:**

<b>1 Gallon Kit</b>	Approx. Shipping Weight:	11.25 lbs.
<b>5 Gallon Kit</b>	Approx. Shipping Weight:	58.00 lbs.

**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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