

Product Data

Rust-Ex Epoxy/Tank Liner PIE 745 HS Series

Description: **PIE 745 HS Series Epoxy/Tank Liner** is a higher solids version of PIE-745 formulated for use as a surface tolerant, high solids, low VOC epoxy that is designed for a variety of uses in the industrial market that requires chemical resistance in medium to severe environments. May also be used in immersion services for water and salt water. Dries to a flexible, abrasion resistant semi-gloss finish.

Recommended Uses: Can be used as an intermediate coat over zinc rich or as a primer to protect structural steel, tanks and piping from severe industrial environments. May be topcoated with a wide variety of enamels, polyurethanes or vinyls.

PHYSICAL CONSTANTS *(Subject to normal manufacturing tolerances)*

Finish: Semi-gloss
Color / Shade: Light Gray, Coral
Components: 2 (Two)
Mixing Ratio: 1:1 Base to Activator
Volume Solids: 80 % ± 2 / 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	12 hours
	50° F (10° C)	2 hours	4 hours	20 hours	8 days	8 hours
	70° F (21° C)	1 hour	2 hours	16 hours	7 days	4 hours
	90° F (32° C)	45 minutes	1 hour	12 hours	5 days	2 hours

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

Theoretical Coverage: 428 sq. ft. / US gallon @ 3 mils DFT (no loss)
Recommended DFT: 3.0 - 6.0 mils minimum. For most immersion applications, 8-12 mils DFT 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: 1.29 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, SSPC SP 6 with a 1.5-2.5 mil blast profile. Profile is dictated by total mil thickness of desired coating system. For immersion services, SP-5, white metal blast is always recommended for optimum durability and life cycle.

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:

Conventional spray with .070" I. D. nozzle/needle and proper air cap. Airless pray with a 30:1 pump or larger with .015"-.021" tip and working pressures of 2,000 - 2,300 psi. Air assit airless may also be utilized. Brush an roll as needed.

Mixing Instructions:

Mix 1 (one) Part B (PIE Activator) with 1 (one) Part A (PIE Base). 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. 4 hours. **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:

2 Gallon Kit	Approx. Shipping Weight:	23.00 lbs.
10 Gallon Kit	Approx. Shipping Weight:	116.00 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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