

# DisboCOR 860 Schutzprimer



Fast drying, water-resistant and weldable primer coat for metall surfaces

## Product Description

Field of Application	As primer and shop primer for corrosion protection of iron and steel constructions. Add thinner (approx. 20 % DisboADD 995) for use as a very fast drying, weldable primer. Also useable on galvanized surfaces and suitable old coatings.
Material Properties	<ul style="list-style-type: none"> <li>■ 1-component anticorrosive primer coat</li> <li>■ solvent containing, free of lead</li> <li>■ fast drying</li> <li>■ can be coated with a wide variety of paints</li> <li>■ when thinned usable as a welding primer</li> <li>■ usable as shop primer</li> </ul>
Material Base / Vehicle	combined synthetic resin
Packaging/Package Size	<ul style="list-style-type: none"> <li>■ 1 kg</li> <li>■ 6 kg</li> <li>■ 15 kg</li> </ul>
Colours	light grey (approx. RAL 7047)
Storage	Cool, dry and frost-protected. Originally closed container 18 months storage-stable. At lower temperature please store the material at 20 °C prior to handling.
Technical Data	<ul style="list-style-type: none"> <li>■ Density: 1.5 kg/l</li> <li>■ Flash point: 24 °C</li> <li>■ Solids content: volume solids 45 % (DIN EN ISO 3233-2)</li> <li>■ Temperature resistance: dry up to 80 °C</li> </ul>

## Application

Suitable Substrates	<ul style="list-style-type: none"> <li>■ steel</li> <li>■ galvanized surfaces</li> <li>■ suitable old coatings</li> <li>■ stainless steel, aluminium</li> </ul>
Substrate Preparation	The surface has to be dry and free of fat, oil, dirt and dust.



<p>Preparation of Material</p> <p>Method of Application</p>	<ul style="list-style-type: none"> <li>■ <b>steel:</b> For highly corrosive environment, grid blasting Sa 2½ (DIN EN ISO 8501-1) to surface profile medium (G) (ISO 8501-1). For lower corrosivity (e. g. indoor without condensing water and low corrosive impact) surface to be prepared by very thorough hand and power tool cleaning St 3 (DIN EN ISO 8501-1).</li> <li>■ <b>galvanized steel:</b> remove white rust and other contamination by grinding (abrasive paper or pad), ammonia-water solution containing wetting agent or sweep blasting (DIN EN ISO 12944-4). Corroded spots have to be very thoroughly hand and power tool cleaned PSt 3 (DIN EN ISO 8501-1).</li> <li>■ <b>old coatings:</b> Compatible old coatings can be overcoated after suitable surface preparation and adequate adhesion. When in doubt, a coating test area is recommended. Good adhering coatings have to be cleaned and roughened. Corroded spots should be grid blasted PSa 2 ½ (DIN EN ISO 8501-1) or very thoroughly hand and power tool cleaned PSt 3 (DIN EN ISO 8501-1). Alternatively old coatings can be prepared by water jetting until compatibel, well adhering coatings or rough steel surface to Wa 2½ (ISO 8501-4), flash rust grade M.</li> </ul> <p>Badly adhering coatings must be removed completely by grid blasting Sa 2½, hand and power tool cleanind St 3 (both DIN EN ISO 8501-1) or water jetting Wa 2½ (ISO 8501-4), flash rust grade M.</p> <ul style="list-style-type: none"> <li>■ <b>stainless steel, aluminium:</b> Remove all native and foreign impurities. Surface are to be sweep blasted (DIN EN ISO 12944-4).</li> </ul> <p>Stirr well before use, if required thinner DisboADD 995 can be used.</p>
<p>Layer Thickness</p>	<ul style="list-style-type: none"> <li>■ brush</li> <li>■ roller</li> <li>■ airless spray application (spray nozzle pressure 200 bar, nozzle size 0.20 - 0.25 mm respectively 0.008 - 0.010 inch)</li> </ul> <p>If used as weldable primer, approx. 20 % DisboADD 995 shall be added before application. For weldable primer spray application is preferred.</p> <ul style="list-style-type: none"> <li>■ dry film thickness: 30 µm, equals 67 µm wet</li> <li>■ dry film thickness: 60 µm, equals 135 µm wet</li> <li>■ as weldable primer: 15 µm, equals 40 µm wet (thinned with 20 % DisboADD 995)</li> </ul>
<p>Surface Coating System</p>	<ul style="list-style-type: none"> <li>■ <b>prime coat:</b> 1 - 2 x DisboCOR 860 Schutzprimer</li> </ul> <p>As weldable primer thinned with 20 % DisboADD 995: 1 x DisboCOR 860 Schutzprimer</p> <ul style="list-style-type: none"> <li>■ <b>top coat:</b> 1 - 2 x DisboCOR 863 ProtectOne EG or DisboCOR 864</li> </ul> <p>Alternatively 1 - 2 x DisboCOR 875 2K-PU Finish EG or DisboCOR 876 2K-PU Finish (please refer to chapter waiting time)</p>
<p>Consumption</p>	<ul style="list-style-type: none"> <li>■ theoretical: 0,10 kg/m² for 30 µm DFT 0.20 kg/m² for 60 µm DFT</li> <li>■ practical: approx. 0.12 - 0.15 kg/m² for 30 µm DFT approx. 0.24 - 0.30 kg/m² for 30 µm DFT</li> </ul>
<p>Application Conditions</p>	<p>Consumptions are indicative values depending on surface conditions and application method. Exact values can be determined by testing areas.</p> <p>Do not apply below 5 °C and above 80 % rel. humidity. Substrate temperature shall be continuously 3 K above the dew point. Inside buildings good ventilation is required.</p>
<p>Waiting Time</p>	<p>6 hours (at 23 °C and 30 µm DFT) between coatings of DisboCOR 860 Schutzprimer.</p> <p>Depending on thickness and ambient temperature after 12 - 24 hours overcoatable with: DisboCOR 863 ProtectOne EG or DisboCOR 864 ProtectOne</p> <p>After 3 days overcoatable with DisboCOR 875 2K-PU Finish EG or DisboCOR 876 2K-PU Finish.</p>
<p>Drying/Drying Time</p>	<p>Drying time is depending on temperature and drying-conditions. Before overcoating, any inherent or foreign impurities must be removed. After longer time periods recoating can be done after suitable surface preparation.</p> <p>At 30 µm DFT and 23 °C:</p> <ul style="list-style-type: none"> <li>■ drying grade 1 (dust dry): 15 min.</li> <li>■ drying grade 4 (dry to handle): 25 min.</li> </ul>
<p>Tool Cleaning</p>	<p>As weldable primer, the drying time shortens due to the thinner layer thickness. At higher thicknesses drying time extends.</p> <p>Complete drying and hardening idepends on drying conditions (e. g. temperature, humidity etc.) and can require 1 - 2 weeks.</p> <p>Equipment and tools are to be cleaned wit DisboADD 995.</p>

## Advice

Special Risks (Hazard Note) / Safety Advice (Status as at Date of Publication)

Only for professional applications.

Flammable liquid and vapor. Causes skin irritation. Causes serious eye irritation. May cause respiratory irritation. May cause damage to organs through prolonged or repeated exposure. Toxic to aquatic life with long lasting effects. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Do not breathe vapours/ spray. Do not get in eyes, on skin, or on clothing. Use only outdoors or in a well-ventilated area. Avoid release to the environment. In case of fire: Use dry sand, dry chemical or alcohol-resistant foam to extinguish. **Contains:** xylene. Warning! Hazardous respirable droplets may be formed when sprayed. Do not breathe spray or mist.

Disposal

Materials and all related packaging must be disposed of in a safe way in accordance with the full requirements of the local, regional, national and international authorities.

EU limit value for the VOC content

EU limit value for the VOC content of this product (category A/i): 500 g/l (2010). This product contains max. 500 g/l VOC.

Giscode

BSL60

Customer Service Centre

Declaration of ingredients according to VdL directive 01 (Germany): alkyd resin, barium sulphate, silicates, titanium dioxide, zinc phosphate, mineral pigments / fillers, calcium carbonate, inorganic colored pigments, aromatics, aliphatics, additives.

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### Technical Information No. 860 · Issue: June 2023

All suggestions and application instructions herein are based on our latest technical experience. Due to the wide variety of individual project conditions, we cannot be held responsible for their content. These instructions do not release the purchaser/ applicator from his responsibility to determine the suitability of the product in consideration of the project characteristics. These instructions are to be considered void when a new edition is released. Our general conditions of sale and delivery in their latest edition apply. This document is a translation of our German Technical Information No.860 · DisboCOR 860  
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