

# DisboCOR 864 ProtectOne



Anticorrosive primer and top coat for metal surfaces, free from aromatic compounds

## Product Description

Field of Application	Robust and weather resistant primer and top coat for steel or galvanized steel structures. Thixotropic formulation enables high thicknesses per coat. Specially designed for recoating of existing paints, e. g. steel constructions, lanterns, wall and ceiling linings, grinder masts and external tank surfaces.
Material Properties	<ul style="list-style-type: none"> <li>■ high solid and free of aromatic compounds</li> <li>■ high build and high elasticity</li> <li>■ resistant against condensing water and industrial atmosphere</li> <li>■ high color and chalking stability without embrittlement</li> <li>■ complete system (1-pot) with active anti-corrosive pigments and barrier effect</li> <li>■ particularly suitable for recoating of old coatings</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> <li>■ 32 kg</li> </ul>
Colours	According to RAL-, NCS- and 3D-System PLUS-color chart
Gloss Level	silk-matt
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: approx. 1.45 kg/l (depending on color shade)</li> <li>■ Flash point: approx. 40 °C</li> <li>■ Solids content: volume solids approx. 60 % (DIN EN ISO 3233-2) (depending on colour shade)</li> <li>■ Temperature resistance: dry up to 60 °C</li> </ul>
Chemical resistance	Very good resistance against industrial atmosphere, condensation water and temporary exposure to sea water, salt, diluted acids and caustic solutions. Not enough resistant against permanent exposure to alcohols, fat oils, fuels, mineral oils etc., but occasionally exposure from splashes are fine. Not for permanent exposure to water.



## 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	<p>The surface has to be dry and free of fat, oil, dirt and dust.</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 (i. g. indoor without condensing water and low corrosive impact) surface preparation 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 are to be very thoroughly hand and power tool cleaned PSt3 (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 are to be cleaned and roughened. Corroded spots must be grid blasted PSt 2 ½ (DIN EN ISO 8501-1) or very thoroughly hand and power tool cleaned PSt 3 (DIN EN ISO 8501-1).</li> <li>■ Alternatively old coatings can be prepared by water jetting until compatibel, well adhearing coatings or rough steel surface to Wa 2½ (ISO 8501-4), flash rust grade M. Bad adhearing coatings must be removed completely by grid blasting Sa 2½, hand and power tool cleaning to St 3 (both DIN EN ISO 8501-1) or water jetting Wa 2½ (ISO 8501-4), flash rust grade M.</li> <li>■ <b>stainless steel, aluminium:</b> Remove all native and foreign impurities. Surface is to be sweep blasted (DIN EN ISO 12944-4).</li> </ul>
Preparation of Material	Stirr well before use, if required thinner DisboADD 996 can be used.
Method of Application	<ul style="list-style-type: none"> <li>■ Brush</li> <li>■ Roller</li> <li>■ Airless spray application (spray nozzle pressure 220 bar, nozzle size 0.25 - 0.35 mm respectively 0.010 - 0.014 inch)</li> </ul> <p>For airless spray application up to 5 % DisboADD 996 can be added, depending on the dry film thickness and application conditions.</p>
Layer Thickness	dry film thickness: 80 µm, equals 130 µm wet
Surface Coating System	<ul style="list-style-type: none"> <li>■ <b>steel:</b> Prime Coat: 1 x DisboCOR 860 Schutzprimer, DisboCOR 863 ProtectOne EG, DisboCOR 864 ProtectOne or 1 x DisboCOR 870 2K-EP Zinkstaub (if grid blasted Sa 2 ½) Top coat: 2 x DisboCOR 864 ProtectOne</li> <li>■ <b>galvanized steel:</b> 1 - 2 x DisboCOR 864 ProtectOne</li> <li>■ <b>old coatings:</b> 1 - 2 x DisboCOR 864 ProtectOne</li> <li>■ <b>aluminium, stainless steel:</b> 1 - 2 x DisboCOR 864 ProtectOne</li> </ul>
Consumption	<ul style="list-style-type: none"> <li>■ theoretical: 0.20 kg/m² for 80 µm DFT</li> <li>■ practical: approx. 0.24 - 0.30 kg/m² for 80 µm DFT</li> </ul> <p>Consumptions are indicative values depending on surface conditions and application method. Exact values can be determined by testing areas.</p>
Application Conditions	Do not apply below 5 °C and above 85 % rel. humidity. Substrate temperature must continuously be 3 K above the dew point. Inside buildings good ventilation is required.
Waiting Time	<p>Between prime and top coat and between several top coats: at least 1 day, at temperatures between 5 °C and 10 °C up to 2 days.</p> <p>Drying time 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>
Drying/Drying Time	<p>At 80 µm DFT and 23 °C:</p> <ul style="list-style-type: none"> <li>■ dry grade 1 (dust dry): 4 - 5 Std.</li> <li>■ dry grade 4 (dry to handle): 8 - 12 Std.</li> </ul> <p>At higher thicknesses drying time extends. Complete drying and hardening is depending on drying conditions (e. g. temperature, humidity etc.) and can require 1 - 2 weeks.</p>
Tool Cleaning	Equipment and tools are to be cleaned wit DisboADD 996.

Advice

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

■ **White basis:** Flammable liquid and vapor. Causes serious eye irritation. May cause drowsiness or dizziness. 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:** Naphtha (petroleum), hydrotreated heavy; Low boiling point hydrogen treated naphtha, naphtha (petroleum), hydrodesulphurized heavy; Low boiling point hydrogen treated naphtha, 2-methoxy-1-methylethyl acetate, butan-1-ol. Contains bis(1,2,2,6,6-pentamethyl-4-piperidyl) sebacate, methyl 1,2,2,6,6-pentamethyl-4-piperidyl sebacate. May produce an allergic reaction. Warning! Hazardous respirable droplets may be formed when sprayed. Do not breathe spray or mist.

■ **Transparent basis:** Flammable liquid and vapor. Causes serious eye irritation. May cause drowsiness or dizziness. 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:** Naphtha (petroleum), hydrotreated heavy; Low boiling point hydrogen treated naphtha, naphtha (petroleum), hydrodesulphurized heavy; Low boiling point hydrogen treated naphtha, butan-1-ol, 2-methoxy-1-methylethyl acetate. Contains bis(1,2,2,6,6-pentamethyl-4-piperidyl) sebacate, methyl 1,2,2,6,6-pentamethyl-4-piperidyl sebacate. May produce an allergic reaction.

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. 360 g/l VOC.

Giscode

BSL60

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