



Brampton, Ontario 1-800-975-5568  
www.tristarcoatings.com

# 1K PRIMER/TOPCOAT SOLVENT BASED

## INDUSTRIAL AND COMMERCIAL COATING SYSTEMS

The Starester™, Stardry™, Starcryl™ and Starbake™ products provide you with a durable coating at the upper performance range of 1K technology. Formulations can be adjusted by the factory to improve hide, adhesion, mar resistance, flexibility (to reduce chipping), dry time, etc. Every product can also be supplied in a unicoat (corrosion resistance) or reduced (more solvent) ready to spray formulation.

### PRIMERS

#### **Starbake™ 320 Baking Primer**

An alkyd melamine baking primer with excellent spraying characteristics. The combined primer/topcoat film can be baked at once by allowing the primer to flash off for 3 minutes prior to topcoat application.

#### **Stardry™ 300 Anti-Corrosive Primer**

A **high build hybrid** alkyd primer selected for superior adhesion and corrosion resistance (1000 hrs. Bonderite ASTM117). Sandable following morning without "gumming" the abrasive. **Formulated to tolerate up to several months outdoor storage** prior to application of topcoat. Early scratch resistance for shop and shipping protection. No recoat window limitation. Unlike typical alkyd primers, resists lifting from substrate or wrinkling when topcoated with certain formulations. Also excellent as a sandwich coat over alkyd when topcoated with a 2K product.

### TOPCOATS

#### **Stardry™ 310 Topcoat (Fast Air Dry)**

An alkyd enamel with very fast dry (10min or less dry to touch) and recoat (15 min - 4 hrs) times for improved productivity. Also, available in hybrid acrylic formulation Stardry™ 210 for UV/Outdoor durability, as well as resistance to yellowing.

#### **Starbake™ 330 Topcoat Baking Enamel**

A modified alkyd-melamine baking enamel providing a hard mar resistant finish with excellent water and oil resistance. Cure is 10 min @ 300°F.

#### **Stardry™ 340 Topcoat (High Performance Air Dry)**

A **high build, high performance** hybrid alkyd enamel providing greatly improved adhesion, mar resistance and chemical resistance. No recoat window limitation.

#### **Stardry™ 360 Topcoat (Air Dry)**

A superior modified alkyd enamel with fast dry (15 -30 min. dry to touch) and recoat (15 min -4 hrs) times providing a hard and tough protective coating.

#### **Starcryl™ 380 Acrylic Topcoat (Baking High Solids)**

An **outstanding indoor/outdoor finish** for metal substrate providing exceptional chemical resistance (**200 MEK double rubs**). Product can be cured at temperatures as low as 230°F. High solids formulation with **VOC rating of 2.9 lbs./USG** (Approx. ½ of conventional alkyds).

#### **Starcryl™ 390 Acrylic Topcoat (Air Dry)**

A **high build** acrylic enamel formulated to provide superior **outdoor durability** on metal and concrete surfaces. Excellent UV resistance. Metal substrate must be primed.

#### **Touch-up Aerosol Spray Cans (13 oz.)**

Available in indoor (alkyd) or outdoor (acrylic) 1K formulations. Colour / gloss matched as required. Ideal for customer touch-up after product shipment and installation.

Providing Outstanding  
Finish and Durability  
to Your Products.

ISO 9001 : 2000 REGISTERED

# Product Characteristics

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## PRIMERS

Product Series	Corrosion Resistance	Chemical Resistance	Adhesion on (CRS)	UV Resistance	Weather Resistance	Hardness Scratch Resistance	Flexibility & Impact Resistance	Dry to Touch	Dry Thorough	Recoat Window
Starbake™ 320	Good	Fair	Excellent	N/A	N/A	Good	Fair	10 min. Bake	10 min. Bake	Before or after bake
Stardry™ 300	Excellent	Good	Excellent	N/A	N/A	Good	Fair	15 min.	30-60 min.	Anytime

## TOPCOAT

Starbake™ 330	Fair	Fair	Excellent	Fair	Fair	Excellent	Fair	10 min. Bake	10 min. Bake	Before or after bake
Stardry™ 310	Fair	Poor	Good	Poor	Poor	Fair	Poor	3-5 min.	15-30 min.	15 min. - 4 hrs.
Stardry™ 210 (Alkyd Acrylic Modified)	Fair	Poor	Good	Good	Fair	Fair	Poor	3-5 min.	15-30 min.	15 min. - 4 hrs.
Stardry™ 360	Fair	Fair	Excellent	Good	Good	Good	Fair	30-60 min.	2-4 hrs.	15 min. - 4 hrs.
Stardry™ 340	Excellent	Good	Excellent	Fair	Fair	Excellent	Fair	3-5 min.	20-40 min.	Anytime
Starcryl™ 380	Excellent	Excellent	Excellent	Excellent	Excellent	Excellent	Excellent	10-20 min. Bake	10-20 min. Bake	Before or after bake
Starcryl™ 390	Fair	Good	Poor (Needs Primer)	Excellent	Excellent	Good	Poor	15-30 min.	1-2 hrs.	15-60 min.

**Dry Times** are average rule of thumb test results based on 25°C ambient application/dry temperatures at 50% RH with typical spray booth air flow.

**Full Cure:** 7-14 days. Unless otherwise noted under recoat window, paint will wrinkle when recoated if not fully cured.

**Theoretical Coverage:** Approx. 400 to 600 sq.ft. @ 1 mil DFT per USG, depending on formulation. (Exception: Starcryl™ 380 @ approx. 900 sq.ft. @ 1 mil DFT per USG.

**Corrosion Resistance:** Any topcoat can be upgraded by ordering a unicoat formulation as a compromise to applying a primer.

**Reducers:** SB12 Lacquer Thinner/Solvent Cleaner, S1 Xylene (slower than SB12). **Exceptions:** Starcryl 380 use S100 - Starcryl Fast Reducer or S11 Starcryl Medium Fast Reducer (flash point > 100°F). **Packaging:** Drums (48 USG), Pails (5 USG) & Cans (1 USG).

### Sq. Ft. Coverage per US Gallon

To determine estimated volumes required multiply theoretical sq. ft. coverage by transfer efficiency of spray equipment divided by D.F.T. Applied D.F.T. of primers and topcoats average between 0.6 to 1.5 mil per coat. Final film build, including primer (if applied) generally recommended at 1.0 to 3.5 mils D.F.T..

### Typical Transfer Efficiency of Equipment

Typical Transfer Efficiency of Equipment					
Conventional	Air Assisted	Airless	HVLP	Electrostatic	Brush Roller
20-30%	50-70%	50-60%	40-60%	60-80%	95% plus

Formulations can be adjusted at the factory to facilitate performance and or productivity gains for specific applications. Dry times, adhesion properties, hiding, etc. can all be reformulated. Tristar is committed to field support.