

INDUSTRIAL AND COMMERCIAL COATING SYSTEMS

The **Starpoxy™** primers provide exceptional adhesion and anti corrosion properties. Long term durability projects the quality you build into your products.

STARPOXY™ 420/430/439/470/480

A series of two component polyamide curing epoxy primers providing excellent adhesion and highly superior corrosion and chemical resistant properties. Highly enhanced by their ease of application and long pot life. The non-sanding recoat window for the Starpoxy™ 400 series primers is 36 to 48 hours. Thereafter, sanding may be required for proper adhesion. For improved finish, all formulations can be sanded the following morning without "gumming" the abrasive. Available in full range of colours to accommodate topcoat hide.

SUBSTRATE PREPARATION

All surfaces must be clean, dry, and free from loose and peeling paint, dirt, grease, mildew, rust, oil and other surface contamination. Sand all glossy, rough and patched surfaces. Prime complete substrate if necessary or patch prime exposed areas. The life of a coating depends as much on the degree of surface preparation as on the subsequent coating system. Ferrous Metal, Galvanized Steel, Aluminum should be prepared in accordance with SSPC-SP2/3 minimum. For further information see SSPC Publication 98-01 Surface Preparation Specifications.

STARPOXY™ 439 (Zinc Rich)

Tristar's zinc rich epoxy primer (439P8102), unlike conventional zinc rich primers formulated with zinc dust, uses zinc flake. The advantages of zinc flake include ease of application similar to our 430/480 epoxies providing a smooth surface with metallic like grey finish, exceptional adhesion to substrate including intercoat adhesion and finally, improved corrosion resistance. The product should be used where superior corrosion protection is required on either sandblasted steel or cold rolled steel. It can be used as the sole primer or as a base primer to Starpoxy™ 480. Unlike conventional zinc dust primers which require continuous agitation to avoid settling, Tristar's product can be left to stand for 3 to 5 hours without settling, thus improving productivity.

STARPOXY™ 420 (Aluminum Substrate)

The 420 series is a chromated formulation primarily for the aerospace industry. Ready to spray at 1:1 mix ratio, it delivers over 3000 hours of corrosion protection on treated aluminum at 0.5 to 0.8 mil DFT with excellent chemical resistance. The outstanding adhesion and anti corrosion performance on both aluminum and steel substrate can also be exploited in industrial applications.

STARPOXY™ 430

The 430 series is chromate-free. One version is designed for aerospace composites. The balance of the 430 series is suitable for industrial and commercial applications requiring average film builds of 1.5-3.0 mil DFT.

STARPOXY™ 480 (High Build)

The 480 series is an extremely versatile high build version of 430 allowing the applicator to apply as little as 1.0 mil or as much as 10 mil plus (DFT) without runs or sags. Just keep building with multiple passes to your desired film thickness. Unsurpassed user friendly spray characteristics.

STARPOXY™ 470 (High Solids)

A High Solids (VOC compliant) epoxy primer similar in performance and ease of application to the 480 series. The High Solids formulation allows for more quick film builds with the same ease of application and next day sanding when required without "gumming" the abrasive. Also available in chromated version similar to Starpoxy™ 420.

Product Characteristics

Product Series	Approx. % Solids By Volume Mixed	Catalyst	Mix Ratio	VOC lbs/USG	Pot Life	Induction Period	Dry To Touch	Dry Through	Recoat Window
Starpoxy™ 420 (Chromated)	28	420C0078	1 to 1	5.13	10 hrs.	15-30 min.	< 15 min.	< 2 hrs.	< 48 hrs.
Starpoxy™ 430	34	430C0035	1 to 1	4.60	10 hrs.	15-30 min.	< 30 min.	< 2 hrs.	< 48 hrs.
Starpoxy™ 480 (430 Base)	37	480C2808 HB*	1 to 1	4.60	10 hrs.	15-30 min.	< 30 min.	< 2 hrs.	< 48 hrs.
Starpoxy™ 439 (Zinc Rich)	33	480C2808 HB*	2 to 1	5.40	8 hrs. (Agitate every 3-5 hrs.)	15-30 min.	< 30 min.	< 2 hrs.	< 48 hrs.
Starpoxy™ 470	53	470C7686	3 to 1	3.80	8 hrs.	15-30 min.	< 30 min.	< 2 hrs.	< 48 hrs.
Starpoxy™ 470 (Chromated)	55	470C7236	2 to 1	2.80	8 hrs.	15-30 min.	< 15 min.	< 2 hrs.	< 48 hrs.

Full Cure: 7-14 days.

Shelf Life: Unopened 12 months.

Recoat Window: Outside of recoat window, adhesion may be compromised. Consult Tristar.

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

Starpoxy™ Reducers SB42 - Slow SB43 - Medium SB48 - Fast	Reducers generally not required. Addition of reducer will better level the coating producing a smoother surface finish.
	Note: For brush/roll applications, use slow reducer only.

Sq. Ft. Coverage per US Gallon					
To determine estimated volumes required multiply theoretical sq. ft. coverage (as above) by transfer efficiency of spray equipment divided by D.F.T. Total applied D.F.T. of primers averages between 0.8 to 3.5 mils. Coarse substrate may require more.					
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

Substrate
Aluminum
Steel
Most compos
Fiberglass
Concrete
Most Vinyls
Wood
Drywall

Pro
4th digi
A - addit
C - catal
H - high
S - semi
L - low g
M - meta
P - prim

Formulations performance and Pot life, dry tim reformulated.

CUSTOM PAINT SOLUTIONS THAT LAST!