

PAINTING SPECIFICATION

GALVANNEAL STEEL

DOORS & FRAMES

Hollow Metal Doors & Frames - Customer Finish Guide

Galvanneal steel, as used in Belco Doors products, has a zinc-iron alloy surface that offers excellent paint adhesion and corrosion resistance. Minimal preparation is required compared to cold rolled or standard galvanized steel.

QUICK PROCESS

Solvent wipe > Optional primer
> Two finish coats

RECOMMENDED PAINTING STEPS / shop-friendly guide

1

SURFACE PREPARATION

- Wipe down the door/frame with mineral spirits or an equivalent solvent cleaner to remove oils, dirt, and contaminants.
- Heavy sanding or blasting is not required due to the natural matte texture of Galvanneal.
- If scratches or bare spots exist, lightly sand those areas and wipe clean before proceeding.

2

PRIMER (OPTIONAL)

- Primer is not strictly necessary for Galvanneal steel, but is recommended for long-term durability, especially in exterior or high-traffic environments.
- Recommended: 2-part epoxy primer or DTM (Direct-to-Metal) acrylic primer.
- For interior applications in controlled environments, primer may be omitted.

3

FINISH PAINT

- Apply two coats of finish paint after surface prep and primer, if used.
- Suitable finishes include alkyd enamel, acrylic enamel (waterborne or solvent-based DTM), or 2K urethane/polyurethane for maximum durability.
- Allow proper drying and curing times per manufacturer instructions before handling or installation.

SUMMARY

Preparation requires only a solvent wipe-down. Primer is optional but recommended for durability. Finish coats (alkyd, acrylic, or urethane enamels) should be applied in two coats for optimal adhesion, corrosion resistance, and long service life.

BEST PRACTICE

Follow the coating manufacturer technical data sheet for dry times, recoat windows, and curing requirements.