

## PAINTING SPECIFICATION

# G90 GALVANIZED STEEL DOORS & FRAMES

Hollow Metal Doors & Frames - Customer Finish Guide

G90 galvanized steel has a smoother spangled zinc surface. It provides corrosion protection, but requires extra surface preparation to achieve proper paint adhesion. Primer is required.

### QUICK PROCESS

Clean + scuff sand  
Pretreat recommended  
Primer required + two coats

## RECOMMENDED PAINTING STEPS / [shop-friendly guide](#)

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### SURFACE PREPARATION

- Remove oils, dirt, and contaminants using mineral spirits, xylene, or a commercial solvent cleaner.
- Lightly scuff sand with 180-220 grit sandpaper or a Scotch-Brite pad to create tooth for adhesion.
- For large surfaces, a sweep blast may be used. If an alkaline cleaner is used, rinse thoroughly and allow to dry completely.

2

### PRETREATMENT (RECOMMENDED)

- Phosphate pretreatment, either iron phosphate or zinc phosphate, is strongly recommended to improve primer and paint adhesion.
- For factory finishing, pretreatment is standard practice.
- For jobsite touch-up, this step may be skipped if not practical.

3

### PRIMER

- Primer is required for G90 galvanized steel before finish painting.
- Acceptable primers include wash primer/self-etching primer, 2-part epoxy primer, or DTM acrylic primer.
- Apply 1-2 uniform coats, allowing full drying per manufacturer instructions.

REQUIRED

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### FINISH PAINT

- Apply two coats of finish paint over the primer.
- Suitable finishes include alkyd enamel for interior use, acrylic DTM enamel for general use, or 2K polyurethane/urethane for exterior or high-traffic applications.
- Allow proper drying and curing times between coats before handling or installation.

### SUMMARY

Unlike Galvanneal steel, G90 galvanized requires primer due to its smoother spangled zinc surface. Preparation involves cleaning, light sanding, and ideally phosphate pretreatment.

### BEST PRACTICE

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