

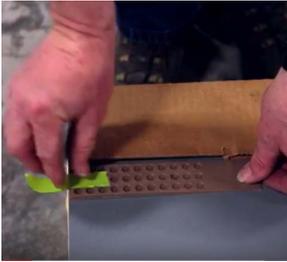
Proper Jobsite Storage of Steel Doors & Frames and Field Application of Primer and Topcoat



Standards As Tough As Steel.™

A video demonstration of these procedures can be viewed at www.steeldoor.org.

Jobsite Storage



Proper jobsite storage and handling is critical to maintain the integrity of doors and frames.

- The product should be stored in dry and covered area.
- Do not use non-vented plastic or canvas shelter. These can cause a humidity chamber that causes blistering or rust.
- Unpack doors or frames from the pallet and stand them upright on wood runners. Use at least a 1/4" inch composite or wood shim between units for air flow. The units should be stored at least 4" above the ground.
- Leave cardboard packaging until installation.
- Do not have more than five units in a stack. Small groups minimize the likelihood of damage due to excess handling.
- Make sure the opening numbers are visible for ease of locating the proper units for each opening.



Field Preparation for Topcoat

Steel Door Institute member's doors and frames are factory prime painted to comply with the performance requirements in ANSI A250.10. The primer is not designed to be the final layer of protection and should always be painted soon after installation. Low gloss solvent based paints are recommended. We do not recommend using water-based paints such as latex unless a quality rust inhibitive primer is applied before the top coat.

Field Preparation for Topcoat

1. Read the paint specification requirements and the paint manufacturer's instructions.
2. Check if the packaging is wet and inspect the surface for rust.
3. If there is rust, the material should be sanded and re-primed with a suitable direct to metal (DTM) primer with rust inhibitors.
4. Inspect the products for dents and scratches.



Removing Dents:

1. Sand off the primer around the dent and surrounding area to bare metal with 80 grit sand paper.
2. Mix the two component plastic body filler as directed.





3. Apply mixture to dented area.
4. After filler has cured thoroughly, sand to a smooth surface with 100 grit sand paper.
5. Finish with 240 or 300 grit sandpaper and wipe so the surface is clean and dry.
6. Apply a rust inhibitive primer over the entire repair area and let dry for 24 hours before finish painting.

Repairing Scratches:

1. Sand to bare metal with 300 grit sand paper.
2. Wipe clean.
3. Touch up the area with a rust inhibitive primer and let dry.

Topcoat Application

1. Verify that the top coat has a rust inhibitor or use a barrier primer.
2. Sand the door or frame surfaces lightly with number 300 or 320 emery cloth or steel wool.
3. Wipe the dust off the door or frame with a clean cloth.
4. Apply the paint with a sprayer, roller, or brush per the paint manufacturer's recommendations.



NOTES:

- √ Doors with welded internal reinforcements, such as stiffeners, may show through the topcoat. These are not manufacturing defects. Show through can be mitigated by using low gloss topcoats.
5. It may take 24 hours or more before the paint is fully cured, depending on the temperature and humidity.

The procedures in this manual are only guidelines. Please follow all applicable building codes, standards, and accepted practices specific to your geographic location. For more information or to watch the video, visit www.steeldoor.org.



Standards As Tough As Steel.™