



Painting Instructions for Commercial Hollow Metal Doors and Frames

Overview

This document provides clear, practical, industry-standard instructions for properly finishing commercial hollow metal doors and frames. These steps ensure durability, adhesion, and a professional appearance.

1. Understand the Factory Primer

- Hollow metal doors and frames are shipped with a **shop-applied primer**, not a finish coat.
- The primer protects the steel during shipping and installation.
- A **finish coat is required** for long-term protection and appearance.

2. Recommended Finish Paint

- Use **low-gloss, oil-based enamel** for finish coats.
- **Do NOT use water-based paints** (latex, acrylic, PVA), as they may cause adhesion issues or flash rusting.

3. Surface Preparation

A. Clean the Surface

- Remove dust, grease, fingerprints, and jobsite contaminants.
- Use a mild cleaning solution or solvent cleaner.

B. Light Sanding

- Scuff-sand the primer with medium-grit sandpaper to promote adhesion.

C. Remove or Mask Hardware

- Remove hinges, locks, closers, and other hardware when possible.
- If removal isn't feasible, mask thoroughly.

D. Protect Surrounding Areas

- Tape off adjacent walls, floors, and glass.

4. Painting Procedure

A. Spot-Prime Bare Metal

- If any areas are scratched to bare steel, apply a compatible primer before painting.

B. Apply Finish Coats

- Apply **two coats** of high-quality oil-based enamel.
- Brush, roller, or spray application is acceptable depending on the desired finish.

C. Drying and Recoat Times

- Follow the paint manufacturer's recommended drying intervals between coats.

5. Frames

- Follow the same preparation and painting steps as doors.
- Frames often require additional masking due to adjacent surfaces.

Key Takeaways

- Factory primer is **not** a finish coat.
- Use **oil-based enamel** for best results.
- Proper cleaning, sanding, and masking are essential.
- Apply **two finish coats** for durability.