



1300 Sumner Avenue  
Cleveland, Ohio 44115-2851  
Phone: 216-241-7333 • Fax: 216-241-0105  
E-mail: [dasma@dasma.com](mailto:dasma@dasma.com)

## Rolling Steel Door Paint Wear

### Introduction

A common occurrence with rolling steel door products, under normal usage of such products, is the wearing away of the painted surface of the curtain. This condition occurs as the result of the curtain repeatedly coiling upon itself, and then repeatedly uncoiling, upon the opening and closing of a rolling steel door. The wear may appear as horizontal lines, mars or abrasions on the faces of the individual slats in the curtains.

### Degree of Paint Wear

The degree to which paint may wear away from rolling steel door curtain surfaces varies depending on factors such as:

- Curtain configuration
- Curtain finish
- Door size
- Environmental conditions
- Frequency of use

### Methods to Reduce Paint Wear

Rolling steel door manufacturers use different methods to reduce paint wear for steel curtains, in order to both limit the degree of paint wear and provide a highly aesthetic manufactured product. Two methods commonly used are:

1. Roll coat paint system. A galvanized steel coil goes through a three-step process. The coil is cleaned and treated, a primer coat is applied and baked, and a top coat is applied and baked. The painted steel coil is slit to the proper width and passed through a roll former mill to produce slats.
2. Powder coat. A galvanized steel coil, or a roll coat-painted steel coil, is roll formed to produce slats. Then the slats are coated with thermosetting resin and baked.

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**Note: Technical Data Sheets are information tools only and should not be used as substitutes for instructions from individual manufacturers. Always consult with individual manufacturers for specific recommendations for their products and check the applicable local regulations.**

This Technical Data Sheet was prepared by the members of DASMA's Rolling Door Division Technical Committee. DASMA is a trade association comprising manufacturers of rolling doors, fire doors, grilles, counter shutters, sheet doors, and related products; upward-acting residential and commercial garage doors; operating devices for garage doors and gates, sensing devices, and electronic remote controls for garage doors and gate operators; as well as companies that manufacture or supply either raw materials or significant components used in the manufacture and installation of the Active Members' products.

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The degree of wear for the above finishes varies with the quality of the galvanized coating, and with the thickness and characteristics of the paint or resin.

### **Field Painting**

Field painted curtains will show surface wear marks sooner than such wear on roll coated or powder coated curtains. Field painted finishes are typically applied after product installation in an uncontrolled environment. The door curtain manufacturer should be consulted prior to applying any finish to a rolling steel door curtain in order to determine the compatibility of the field applied coating with the original curtain finish. Professional application and adequate air-drying are essential.

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