



From the desk of: **Rob Donnellon**

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Saturday, April 25, 2009

Bob Cummins  
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Re: **Galvannealed Information**

Dear Bob:

The following is the information you requested concerning galvannealed steel and the adhesion of paint.

Galvannealed sheet metal is the product of a steel substrate that is hot dipped in a molten zinc bath and conforms to American Society for Testing and Materials (ASTM) A653. As the zinc coated steel exits the coating line, the material goes into an annealing oven to bond the zinc to the steel. During this process the zinc forms a dull gray and porous surface. It is this surface that allows for a strong bond with paint. As long as the surface is kept clean (no oils, solvents etc.) the galvannealed sheets can be readily painted and a strong bond will occur due to the porous, non spangled surface from the annealing process.

Coating weights for galvannealed steel are designated by an "A" and the coating weight follows. Typical coating weights are A40 and A60.

Please let me know if you have any questions

Sincerely,

Rob Donnellon

## STANDARD GALVANNEALED

### FRAMES FOR A SUPERIOR, PAINT READY FRAME

(Meets or exceeds base metal preparations or prime painting requirements for finish painting)

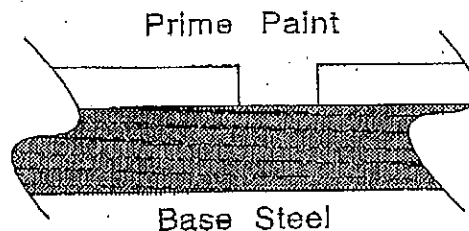
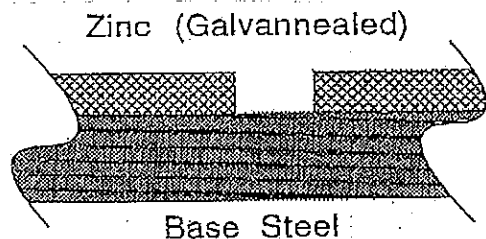
Galvannealed steel is the ideal solution for any steel surface where corrosion or final painting is a problem. In addition to this it also provides economy, long life and durability.

Galvannealed steel, manufactured to ASTM A653 specifications, consists of a base steel sheet, which is zinc coated and heat-treated to strengthen the bond between the process coating and base material.

This galvanized coating combats corrosion in two ways: (1) by providing a barrier between the base steel and the atmosphere, and (2) by corroding galvanically, or sacrificially, to protect the base metal.

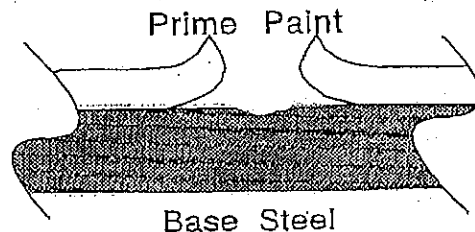
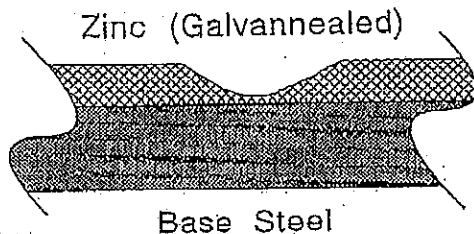
Due to the additional processing of the zinc coating there is no spangle, which is traditionally associated with a galvanized product, instead there is an excellent surface for finish coats of any type of paint (standard prime painting is not required).

Commercial Door & Hardware will provide galvannealed material where availability or specifications dictate. In all cases the intent of the project specifications will be met or exceeded. The finish coat paint adhesion warranty will meet or exceed that of any stated warranty for standard prime painting.



Here's what happens when a scratch occurs on zinc-coated sheet steel. Through galvanic action, the zinc coating sacrifices itself slowly to protect the base steel. This sacrificial action continues as long as any zinc remains in the immediate area.

These illustrations demonstrate what happens when a scratch occurs on painted sheet steel. The exposed steel corrodes and forms a pocket of rust, which lifts the paint film from the metal surface to form a blister. Both the corrosion pit and the blister continue to grow.



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