

CADON PLATING COMPANY PROCESSING CAPABILITIES

DAIMLER CHRYSLER CORPORATION

PS CODE	DESCRIPTION	COATING THICKNESS	CORROSION RESISTANCE		COMMENTS	TURN AROUND
			WHITE	RED		
PS-79/ PS 1536 PS 4220 ----- PS-79 CODE 0 PS-79 CODE 15 PS-79 CODE 30 PS-79 CODE 50 PS-4220 CODE 0 PS-4220 CODE 15 PS-4220 CODE 30 PS-4220 CODE 50 PS-1536 CODE 25 PS-1536 CODE 50	ZINC ELECTROPLATE ZINC ELECTROPLATE ZINC ELECTROPLATE ZINC ELECTROPLATE-BAKE ZINC ELECTROPLATE-BAKE ZINC ELECTROPLATE-BAKE ZINC ELECTROPLATE-BAKE MECHANICAL ZINC MECHANICAL ZINC MECHANICAL ZINC	MICRONS/ INCHES COVERAGE/COVERAGE 4/.00015 8/.00030 13/.00050 COVERAGE/COVERAGE 4/.00015 8/.00030 13/.00050 COVERAGE/COVERAGE 6/.00025 13/.00050	X X X X X X X X X X	0 24 56 69 0 24 56 96 0 56 96	PS-PLATING GENERAL PRODUCT PLATING SPECIFICATIONS FOR IRON & STEEL FASTENERS THESE SPECIFICATIONS ARE OFTEN COMBINED WITH PS-1207 FOR CHROMATE CONVERSION COATINGS	TYPICAL TURN AROUND FOR ELECTRO-PLATING IS 48-72 HOURS. ADD 24 HOURS FOR PS-4220(BAKE). MECHANICAL PLATING TURN AROUND IS ALSO 48-72 HOURS
PS-80 PS-80 DRY PS-4764-BLACK PS-4947-COLORED	ZINC PHOSPHATING & OIL ZINC PHOS -NO OIL BLACK PHOSPHATE PHOS + COLORED TRACERS	1000 mg/sq ft 1000 mg/sq ft 1000 mg/sq ft 1000 mg/sq ft	X X X X	72 X 72 72	NO ACID CLEANING FOR SPRING STEEL	PHOSPHATE TURN AROUND IS 24-48 HOURS. FOR TRACERS, 96-120 HOURS
PS-5873 PS-5873 BLACK PS-5873	DACROMET DACROMET + BLACK TOPCOAT DACROMET PLUS L	NOT TO ADVERSELY AFFECT FUNCTION	X X X	400 400 400	NON HYDROGEN EMBRITTELEMENT INDUCING COATING SUITABLE FOR SMALL FERROUS PARTS	48-72 HOURS
PS 7626 PS 7626 BLACK	ZINC PHOSPHATE & DORRFLAKE BLACK TOPCOAT	MIN 12.5 MICRON/.0005 in NOT TO ADVERSELY AFFECT FUNCTION	X X	400 400	HAND LOAD LICENSE ONLY	48-72 HOURS
PS 9705	Zinc Plate, Bake, Chromate, & Organic Paint	7.5 micron minimum	240	500	NOT RECOMMENDED FOR WASHERS	72-120 HOURS
PS-1207	CHROMATE CONVERSION COATS FOR ZINC	CLEAR, BRIGHT YELLOW BLACK BRONZE OLIVE DRAB	6 24 24 72 72	SEE PS-PLATTING	COLORED DYES MAY BE APPLIED PER THE DRAWING. CADON IS CAPABLE OF RUNNING BLUE, BLACK, RED, GREEN. PARTS CHROMATED TO CODE 0 PLATING HAVE NO SALT SPRAY REQUIREMENT	In Conjunction with Plating Times
PS-4764	BLACK PHOSPHATE & OIL	1100 mg/sq dm	X	72	MUST BE UNIFORM BLACK & DRY TO TOUCH	24-48 HOURS

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PS-8814	ZINC PLATE, YELLOW CHROMATE, & LEACHANT SEAL	PER PS-PLATING	96	500	COMMONLY REFERED TO AS: JS-500, SUPERSEAL, OR PAVCOAT SUPERSEAL.	76-92 HOURS
PS-9295	ZINC PLATE, CHROMATE, & DORRLTECH	PER PS PLATING & 5MICROM COATING	NA	400	ALUMINUM RICH TOP COAT DESIGNED FOR TUBE NUTS, CLIPS, & STAMPINGS	48-72 HOURS
PS-8956M	MECHANICAL ZINC TIN, YELLOW CHROMATE, & LEACHANT SEAL	CODE 30/00030min CODE 40/00040 min.	120 120	200 250	PRIMARILY FOR, BUT NOT LIMITED TO, ELECTRICAL GROUNDINGS AND CONDUCTIVE COMPONENTS	48-72 HOURS
PS-9500	EMBRITTLEMENT RELIEF BAKING	NA	NA	NA	CADON PLATING BAKES UNDER THE GUIDANCE OF THIS SPECIFICATION	+ 24 HOURS

TURN AROUND TIMES ARE REFERED TO AS "TYPICAL". UNDER CERTAIN CIRCUMSTANCES ARRANGEMENTS CAN BE MADE TO EXPEDITE PROCESSING. CALL CADON FOR AVAILABILITY FOR ANY EMERGENCY PROCESSING NEEDS. WE WILL DO OUR BEST TO MEET ANY CUSTOMER'S EMERGENCY PROCESSING REQUIREMENTS.