

CADON PLATING COMPANY PROCESSING CAPABILITIES

GENERAL MOTORS CORPORATION

GM 4345M / GM4344M -ZINC PLATING ELECTRO AND MECHANICAL

SUFFIX TO BASIC #	MINIMUM THICKNESS IN MICRONS	SUPPLEMENTAL TREATMENT	TYPICAL APPEARANCE	CORROSION PROTECTION		TYPICAL TURN AROUND TIME
				HRS TO WHITE	HRS TO RED	
3U24/0 6U48/0 9U72/0 12U96/0 15U120/0	3 6 9 12 15	NONE (BRIGHT)	NO REQUIREMENT	- - - - -	24 48 72 96 120	48-72 HOURS 48-72 HOURS 48-72 HOURS 48-72 HOURS 48-72 HOURS
3K32/8 6K56/8	3 6	PASSIVATION OR CONVERSION COATING	BRIGHT	8 8	32 56	48-72 HOURS 48-72 HOURS
9K96/0 12K120/0 15K144/0	9 12 15		CLEAR OR BLUE IRRIDESCENT	- - -	96 120 144	48-72 HOURS 48-72 HOURS 48-72 HOURS
3D72/48 6D96/48 9D120/48 12D144/48	3 6 9 12		BRIGHT OR IRRIDESCENT YELLOW	48 48 48 48	72 96 120 144	48-72 HOURS 48-72 HOURS 48-72 HOURS 48-72 HOURS
6D120/72 9D144/72 10D192/96 12D168/72	6 9 10 12		YELLOW GOLD OR BRONZE	72 72 96 72	120 144 192 168	48-72 HOURS 48-72 HOURS 48-72 HOURS 48-72 HOURS
6D144/96 9D168/96 12D192/96	6 9 12		OLIVE DRAB	96 96 96	144 168 192	48-72 HOURS 48-72 HOURS 48-72 HOURS
12D240/0	12		YELLOW BROWN OR OLIVE DRAB	-	240	48-72 HOURS
9B0/72 15B0/144	9 15		DECORATIVE BLACK	- -	72 144	48-72 HOURS

COMMENTS ON 4345M/4344M- THIS SPECIFICATION ALSO INCLUDES MECHANICAL ZINC PLATING. THE CODE "M" IS PLACED IN THE SUFFIX IMMEDIATELY FOLLOWING THE THICKNESS SPECIFICATION. OTHER SUPPLEMENTAL TREATMENTS ARE SPECIFIED ON THE DRAWINGS SUCH AS WAX, OIL, LUBRICANT, ETC. **BAKED PARTS REQUIRE AN ADDITIONAL 24 HOURS.**

GM 4435M-PHOSPHATE COATINGS

GM SPEC #	SUFFIX	COATING THICKNESS	SUPPLEMENTAL COATING	SALT SPRAY REQUIREMENT	COMMON NAME	TYPICAL TURN AROUND TIME
GM4435M	CODE A	1100 g/dm ² minimum	OIL	72 HRS TO RED	PHOS & OIL	24-48 HOURS
GM4435M	CODE B	1100 g/dm ² minimum	PAINT	72 HRS TO RED	PHOS & PAINT	96-120 HOURS
GM4435M	CODE D	1100 g/dm ² minimum	NONE	NONE	DRY PHOS	24-48 HOURS

SPECIAL NOTE: CHLORINATED OILS AND WAXES, PARAFINS, SILICATES, CARBONIZED OILS AND FATS, AND CALCIUM COMPOUNDS WILL CAUSE CLEANING AND FINISH PROBLEMS AND SHOULD NOT BE USED IN THE MANUFACTURING PROCESS.

GM-6173M-DACROMET

CORROSION PROTECTION COATING CONSISTING OF AN AQUEOUS SOLUTION CONTAINING ZINC PLATLETS, CHROMATES AND PROPRIETARY ORGANIC MATERIAL. A TOP COAT SEALER IS THEN APPLIED. THIS SEAL MAY BE PIGMENTED BLUE, BLACK ETC., OR CLEAR. CORROSION RESISTANCE OF 240 MIN. HRS TO RED RUST CAN BE EXPECTED. 48-72 HOUR TURN AROUND

SPECIAL NOTE: THIS SPECIFICATION IS CURRENTLY IN DRAFT REVISION. THIS REVISION WILL CALL FOR THREE LEVELS OF LUBRICITY, THEY ARE AS FOLLOWS:
 LEVEL 1-2 COATS OF DACROMET & 1 COAT OF PLUS LEVEL 2-2 COATS OF DACROMET & 1 COAT OF PLUS L LEVEL 3-2 COATS OF DACROMET & 1 COAT OF PLUS XL

GM-7113M-

CORROSION PROTECTION, NON OILY COATING CONSISTING OF ZINC PLATING, CHROMATING, AND AN ALUMINUM RICH ORGANIC TOP COAT THIS APPLICATION IS DESIGNED FOR EXTENSIVE CORROSION PROTECTION, 400HRS MINIMUM TO RED RUST CAN BE EXPECTED WITH THIS APPLICATION. THIS COATING ALSO PROVIDES EXCELLENT GALVANIC CORROSION RESISTANCE BETWEEN STEEL AND ALUMINUM. PARTS COATED IN THIS APPLICATION ARE SUBJECT TO TORQUE TENSION TESTING REQUIREMENTS. 48-72 HOUR TURN AROUND

GM-7114M- (GM-7114-CF, Chrome Free Version)

CORROSION PROTECTION COATING CONSISTING OF ZINC PHOSPHATE COATING, A ZINC ENRICHED INORGANIC RESIN, AND AN ALUMINUM RICH ORGANIC TOP COAT. THIS APPLICATION IS DESIGNED TO BE FREE FROM HYDROGEN EMBRITTELEMENT AS WELL AS HAVE EXTENSIVE CORROSION RESISTANCE. CORROSION PROTECTION OF 400 HRS MINIMUM TO RED RUST CAN BE EXPECTED WITH THIS APPLICATION. THIS COATING ALSO PROVIDES EXCELLENT GALVANIC CORROSION RESISTANCE BETWEEN STEEL AND ALUMINUM. PARTS COATED IN THIS APPLICATION ARE SUBJECT TO TORQUE TENSION TESTING REQUIREMENTS. THIS APPLICATION IS NOT RECOMMENDED FOR RECESSED PARTS. 48-72 HOUR TURN AROUND

HEX CHROME FREE SPECIFICATIONS

GMW-3044

Hex Chrome Free Electro-Zinc Specifications:

Codes	Thickness (micrometers)	Post treatments	Salt Spray Resistance Base MetalCorrosion	White Corrosion
3U24/0	3	None	24	-
6U48/0	6	None	48	-
9U72/0	9	None	72	-
15U120/0	15	None	96	-
12U96/0	12	None	120	-
9K96/24	9	Clear Conversion Coating	96	24
15K240/24	15	Clear Conversion Coating	240	24
15K360/120X	8	Clear Conversion Coating & Sealer	360	120
8K240/120X	15	Clear Conversion Coating & Sealer	240	120

ALSO APPROVED FOR SUFFIX G WHICH INCLUDES INTEGRATED LUBE.
TRI-VALENT BLACK CHROMATE APPROVAL IS FORTH-COMING

GMW-3179

Hex Chrome Free Phosphate Specifications:

Suffix	Thickness Range (g/m2)	Supplemental Coating	Salt Spray Hours	White Corrosion
Code A	4-8	Protective Oil Compound	24	-
Code W	4-8	Protective Wax Coat	1	-
Code D	4-8	None	24	-

Hex Chrome Free Paint Coating Specifications:

GM-6174M-POLYSEAL

HEX CHROME FREE CORROSION PROTECTION COATING DESIGNED TO BE FREE OF HYDROGEN EMBRITTLEMENT, HAVE EXTENDED CORROSION PROTECTION, AND A DECORATIVE BLACK FINISH. THE PROCESS CONSISTS OF A ZINC PHOSPHATE COATING, CHROME SEAL, ORGANIC COATING AND EMULSIFIABLE OIL. CORROSION PROTECTION OF 168 HRS MINIMUM CAN BE EXPECTED WITH THIS COATING 48-72 HOUR TURN AROUND

GM 6431M

HEX CHROME FREE CORROSION PROTECTION COATING CONSISTING OF A PHOSPHATE BASE COAT, AND A SINGLE PAINT COAT DESIGNED FOR UNDERBODY AND NON-VISIBLE APPLICATIONS. THIS COATING HAS EXCELLENT TORQUE CONSISTENCY AND PROVIDES UP TO 400 HOURS RESISTANCE. PRESENTLY USED ON U-BOLTS.

GMW 3359

Hex Chrome Free Non-Electrolytically Applied Zinc Rich Coating

CORROSION PROTECTIVE COATING THAT IS TWO COATS OR THREE COATS OF PAINT OVER A PHOSPHATE BASE COAT OR SHOT BLASTED METAL PARTS BASED ON APPROVED PROPRIETARY ZINC RICH CHEMICALS THAT OFFERS 144 HR TO <5% WHITE CORROSION AND 480 HRS TO NO RED RUST. INTEGRAL TOPCOAT SEALER/LUBE OFFERS EXCELLENT TORQUE CONSISTENCY.

GMW 4707

Hex Chrome Free Electro-Zinc, Chromite and Magni Top Coat

Corrosion Protective Coating That is Electro-Zinc Based, Thick Layered Trivalent Chromate and The Magni B-18 Top Coat provides excellent corrosion protection and consistent torque. This coating is commonly specified for nut and nut/ bracket applications.

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.