

HEAT TREAT SPECS	
SPECS	
SAE J-81	THREAD ROLLING SCREWS
SAE J-78	SELF DRILLING TAPPING SREWS
SAE J-121	DECARBURIZATION IN HARDENED AND TEMPERED UNIFIED THREAED FASTENERS
SAEJ-121M	DECARBURIZATION IN HARDENED AND THREADED FASTENERS
SAE J-429	MECHANICAL AND MATERIAL REQUIREMENTS FOR EXTERNALLY THREADED FASTENERS
SAE J-423	METHODS OF MEASURING CASE DEPTH
SAE J1199	MECHANICAL AND MATERIAL REQUIREMENTS FOR EXTERNALLY THREADED FASTENERS
CHRYSLER MS-3517	
CHRYSLER MS-6149	
FORD ES-21001-S100	
FORD ESS-M1A170-B	
GM 500M	
GM 6010M	
GM6171M	
INDUCTION SPECS	
SAE J-1237	
GM 6202	
MS 8253	
WD 952	

Finish	Salt Spray Hours		Chrysler	Ford	G.M.
	White	Red			
Standard Clear Chromate over zinc (trivalent)	8	Comm. 32 .0002 56 .0003 96 .0005 120	PS-4220 Codes: 0, 15, 30, 50 PS 79	WSDM1P85-A1, A2, A3 WSB- M10P10-A1	GM4345M Codes: 3/K32/8 6K56/8 9K96/8 12K120/8
Yellow Chromate over zinc	48	.0002 96 .0003 120 .0005 144	PS-4220 Codes: 0, 15, 30, 50 PS 79	WSDM1P85-A1, A2, A3 WSB- M10P10-A3	GM4345M Codes: 6D96/48 9D120/48 12D144/48
Olive Drab over zinc	96	.0002 144 .0003 168 .0005 192	PS-4220 Codes: 0, 15, 30, 50 PS 79	WSDM1P85-A1, A2, A3 WSB- M10P10-A5	GM4345M Codes: 6D144/96 9D168/96 12D192/96
Black Chromate over zinc	24	.0002 24 .0003 56 .0005 96	PS-4220 Codes: 0, 15, 30, 50 PS 79	WSDM1P85-A1, A2, A3 WSB- M10P10-A2	
Olive Drab and Black Dye over zinc	96	.0002 144 .0003 168 .0005 192	PS-4220 Codes: 0, 15, 30, 50 PS 79	WSDM1P85-A1, A2, A3 WSB- M10P10-A2	GM4345M Codes: 6D144/96 (black) 9D168/96 (black) 12D192/96 (black)
Blue, Green, Red or Golden Brown Dye over zinc					
Phos & Polyseal With Oil	n/a	168			GM6174M
Phos & Polyseal No Oil	n/a	96			GM6174M (no oil)
Dry Phos & Electropolyseal II (E-coat) With Oil	n/a	168	PS-7902 Method A (240 hrs red)		GM6047M
Dry Phos & Electropolyseal II (E-coat) (no oil)	n/a	96	PS-7902 Method B		GM6047M (no oil)
GM7153M	120	240			GM7153M
<i>For Reference Only: This information is based on our experience and available specifications, and is, to the best of our knowledge, true and accurate. However, since the conditions for use and handling of products are beyond our control, we make no guarantee or warranty, express or implied, regarding the information, the use, handling, storage or possession of the products, or the application of any process described herein or the results sought to be obtained. Nothing herein shall be construed as a recommendation to use any product in violation of any patent rights.</i>					
rev 12/22/05 gf					

PHOSPHATE AND RELATED FINISHES

Finish	Salt Spray Hours		Chrysler	Ford	G.M.
	White	Red			
Phos/Oil	n/a	72	PS-80	S-2	GM4435M, Code A
Phos/Oil Dry-to-touch	n/a	48	PS-80, Spin Dry	S-58	
Phos/Wax	n/a	48	PS-80, No Oil, Plus Wax	S-58	GM4435M, Code E
Dry Phos	n/a	0	PS-80 Unoiled	WSD-M3P35- A1	GM4435M, Code D
Phos & Polyseal With Oil	n/a	168			GM6174M
Phos & Polyseal No Oil	n/a	96			GM6174M (no oil)
Dry Phos & Electropolyseal II (E-coat) With Oil	n/a	168	PS-7902 Method A (240 hrs red)		GM6047M
Dry Phos & Electropolyseal II (E-coat) (no oil)	n/a	96	PS-7902 Method B		GM6047M (no oil)
Clean Only	n/a	n/a			
Clean & Oil	n/a	n/a			
Clean & Macugard	n/a	n/a			
Clean & Wax	n/a	n/a			

For Reference Only: This information is based on our experience and available specifications, and is, to the best of our knowledge, true and accurate. However, since the conditions for use and handling of products are beyond our control, we make no guarantee or warranty, express or implied, regarding the information, the use, handling, storage or possession of the products, or the application of any process described herein or the results sought to be obtained. Nothing herein shall be construed as a recommendation to use any product in violation of any patent rights.

Finish	Color	Salt Spray Hours		Trivalent	Chrome-free	Torque/Tension Capabilities	Receptive To Locking	Applicable Specs
		White	Red					
Standard Clear Chromate	Clear	5	Up to 120	yes		No	Yes	Chrysler PS-4220 & PS-79 GM4345M Ford WSD-M1P85-A1, A2, A3 & WSB-M10P10-A1
NoKRoM C	Clear	96	500		Yes	Yes	To be determined during sample processing	
Corrosil (boron conversion)	Clear	48	120		Yes	No	No	Delphi DX551200: subcode DX551215 (including Suffix "F")
Trichromax 120	Clear	120	500	Yes		Yes	To be determined during sample processing	GMW3044 (pending approval) Delphi DX551200: DX551207 DX551209 DX551212 DX551213 DX551225 DX551232 DX551233 DX551236 DX551237 DX551240 DX551245 Ford S-437 (pending approval)
Unicote C 120	Clear	120	500	Yes		Yes	Yes	
Trichromax C Ultra		500	1000	Yes		Yes	To be determined during sample processing	
NoKRoM Y 120	Yellow	120	500		Yes	Yes	To be determined during sample processing	Delphi DX551200: subcode DX551216
Unicote Y 120	Yellow	120	500	Yes		No	Yes	
NoKRoM Black Paint	Black	120	500		Yes	No	Yes	Delphi DX551200: subcodes DX551241 DX551242 DX551243 DX551253
NoKRoM Black	Black	72	500		Yes	No	To be determined during sample processing	GMW3044 (pending approval)
Trichromax Black 120	Black	120	500	Yes		Yes	To be determined during sample processing	
GM6138M	Black	48 none; 144 10%	500	Yes		No	Yes	GM6138M
GMW4205	Black	48 none; 144 10%	480		Yes	Yes	Yes	GMW4205

For Reference Only: This information is based on our experience and available specifications, and is, to the best of our knowledge, true and accurate. However, since the conditions for use and handling of products are beyond our control, we make no guarantee or warranty, express or implied, regarding the information, the use, handling, storage or possession of the products, or the application of any process described herein or the results sought to be obtained. Nothing herein shall be construed as a recommendation to use any product in violation of any patent rights.

Finish	Salt Spray Hours		Chrysler	Ford	G.M.
	White	Red			
Dacromet 320® and No Topcoat	n/a	500		WSD-M21P13-A1	
Dacromet 320® with Dacroseal	n/a	1000			GM6173M
Dacromet 320® and Plus Topcoat	n/a	1000	PS-5873	WSD-M21P13-A2	GM6173M
Dacromet 320® and Plus L or XL Topcoat	n/a	1000	PS-5873 L	WSD-M21P13-A3 (S301)	
Dacromet 320® and Black Topcoat	n/a	500		WSD-M21P13-A2 (black)	GM6173M (black)
Dacromet 320® and Dacrokote® 107 or 135	n/a	500	PS-5873 (black)		
Dacromet 320® and E-coat	n/a	240			GM6173M & GM6047M
Geomet® "P"	n/a	720	PS-5873 P	WSS-M21P39-A2 WSS-M21P36-A5	GM6173M
Geomet® L	n/a	720	PS-5873P PS-5873 L		GMW 14
Geomet® ML	n/a	720		WSS-M21P39-A1 (S-438) WSS-M21P36-A4	GMW3359
Geomet® with Geoblack® 137	n/a	480			GMW3359
Geomet® with Geoblack® 147	n/a	480	PS-9904 PS-9904 S	WSS-M21P39-A3	GMW 14
Dichromax® ZNBL-O Black	500	1000			
Dichromax® ZNY-500 Yellow	150	500			
Dichromax® ZNCL Clear	150	500	PS-8814		
Dichromax® ZNBL-C Black	150	500			
GM6138M (trivalent)	48 none; 144 10%	500			GM6138M
GMW4205 (chrome-free)	48 none; 144 10%	480			GMW4205

Trivalent & Chrome-free Finishes: See separate sheet

For Dacromet and Geomet processes there are many more specifications that this product meets please feel free to access the Metal coatings web site at WWW.Metalcoatings.com

Finish	Salt Spray Hours		Chrysler	Ford	G.M.
	White	Red			
Zinc/Nickel & Chromate and E-coat	240	500	PS-7187 (PS-8955 & PS-7902 B)		GM6280M & GM6047M

Trivalent & Chrome-free Finishes: See separate sheet