

Table 15 – Frame & Suspension Finish Chart

Due to the methods and processes of manufacturing and variety of metals types used, natural finishes will vary. These include cast iron, cast aluminum, forged, stamped, hot rolled and extruded. See the process chart to determine the manufacturing process. Those parts formed with heat and remained unfinished have a blue-gray scale that formed when the steel heated. In some cases, such as brake calipers, machining occurred after paint. Thus, there are painted and natural machined surfaces on the same part. The part is listed under the category, which covers the majority of the surface.

Most small parts and brackets for the frame were hanging or conveyor dip-painted causing them to have paint runs and accumulation on the lowest edges of the part.

All cotter keys are natural. When installed, the short leg or prong of the cotter pin is against the part and the longer prong is easily accessible for bending. This bend may be either 90 or 180 degrees, depending on the application. Typical assembly did not shorten cotter pins. Throughout the Chassis Section, there are many illustrations of how the cotter pins bend. As an example, see Fig. Ch. 12.1.

Process

DC = die cast	E = extruded	F = forged
HR = hot rolled	M = machined	CR = cold rolled
S = stamped	SC = sand cast	W = welded assembly

Natural Finish

front springs (HR)	ball joints (F & S)
front & rear spindles (F)	tie-rod ends (F)
tie rod sleeves & clamps (S & CR)	steering relay rod (F)
stabilizer shafts (F)	some upper inner control arm shafts (F)
Idler arm (F)	axle tubes (E)
washers bolted to upper inner control arm bushings (S)	drive shaft (E)
rear end yokes (F)	rear strut rods (F)
rear spring outer bolt, nut & washers (S)	brake rotors (SC)
washers on control arms & trailing arms (S)	axle flanges (F)
universal-joint components (F)	

Gray Finish

shock absorbers, blue gray rear spring, primer grey (HR)

Plated

brake dust shields (S) unpolished zinc	underbody heat shields (s) gray phosphate
fuel tank (S & W) galvanized	clutch cross shaft (W) unpolished zinc
large washers on top of front shocks (S) gray phosphate	
front brake caliper mounting brackets (S) dull cadmium dichromate	

Low Gloss Black

brake calipers (SC)	p/s valve assembly (SC)
rear brake caliper mounting brackets (SC)	stabilizer shaft (F)

Semigloss black

radiator (S)	alternator & AIR braces (S)
air-conditioning brackets (S & SC)	upper & lower control arms (S)
trailing arms (S & W)	upper & lower inner control-arm shafts (f)
bumper brackets (S)	front crossmember assembly (S & W)
undercar brackets (S)	p/s piston (SC)

Gloss black

power-brake booster (S)	fan (S)
-------------------------	---------