

MACHINE POLISHING WITH BAR ROUGE

A Step-by-Step Guide to the "Mirror Shine"

EQUIPMENT and SUPPLIES NEEDED



POLISHING WHEELS:

- AWO - Orange Airway
- AWB - Blue Baron Airway
- AWY - Fast Cut Airway
- AWY - Yellow Airway
- AWG - Green Airway
- AWP - Purple Airway
- AWW - White Airway Untreated



BAR ROUGE COMMONLY USED:

- 87 Stainless - Very Heavy Cutting
- Brown Tripoli - Primary Cutting
- Green Chrome - Secondary Cutting
- White Chrome - Final Finish



SAFETY FIRST:

Always use safety flanges with any buffing wheel that has a metal center plate



COTTON MUSLIN BUFFS:

- 30 - Ply 3/8" Stitching
- 40 - Ply 3/8" Stitching
- 50 - Ply 3/8" Stitching
- 60 - Ply 3/8" Stitching



VARIABLE SPEED SANDER / GRINDER MACHINE: 0 - 6,000 RPM



PRO-40 PERFECTION METAL POLISH and MICRO FIBER POLISHING TOWELS

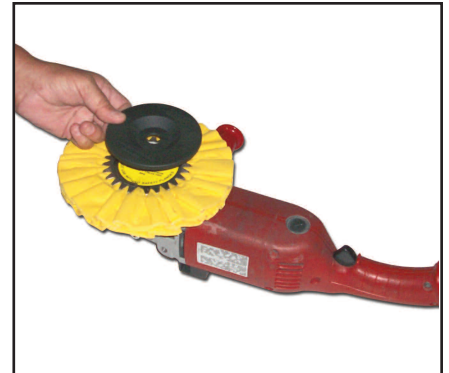
*** Safety Flanges are MANDATORY when using Airway Buffing Wheels.**



Lay the sander/grinder on a flat surface. Make sure the machine is unplugged from any electrical current. Place one of the flanges, face down onto the spindle (Zephyr logo facing toward the machine).



Place the Airway Buffing Wheel on the spindle on top of the first flange. (Zephyr Airway Buffing Wheels have a decal on the steel center plate that should face up).



Next, place the second flange onto the spindle on top of the Airway Buffing Wheel. (The Zephyr logo should be facing up).



Secure with the lock washer and nut. During operation, periodically check the tightness of the nut. **DO NOT OVERTIGHTEN.**



Zephyr Airway Buffing Wheels are marked with the recommended RPM that should not be exceeded.



For Safety, always wear a respirator and face shield or goggles.

STANDARD SERIES ROUGE

87 STAINLESS

This rouge is designed for very heavy cutting. It contains 320 grit emery for a smooth, even cut. Try it with one of Zephyr's heavy cutting airway buffing wheels. For Iron, steel, aluminum and stainless.

TR-2 BROWN TRIPOLI

Zephyr's Tripoli bar rouge is the industries standard for Primary cutting. Use with one of our medium to heavy cutting airway buffing wheels for great cutting action. For Iron, steel, aluminum and stainless.

GREEN CHROME ROUGE

This rouge is used for secondary cutting and semi final finish. Use with one of Zephyr's medium to light cutting airway buffing wheels or all cotton buffing wheels for a semi final finish.

WHITE CHROME ROUGE

This quality rouge is used for final finish high lustre shine. Used with one of Zephyr's final finish airway buffing wheels or all cotton buffing wheels, for a beautiful shine.

PLATINUM SERIES FINISHING ROUGE

MAX RED

Use this High end Jewelers rouge for show quality results. Use with our all cotton buffing wheels or our flannel wheels. For aluminum and stainless.

BLUE MOON

This is another high end jeweler's rouge that can put a show quality shine to any polishing project you are working on. Use with our all cotton buffing wheels or our flannel wheels. For aluminum and stainless.

SLATE

This unique rouge is designed for both cut and color. Try one of Zephyr's light cutting airway buffing wheels and/or the all cotton buffing wheels for beautiful shine.

WHITE LIGHTNING

This rouge was designed for stainless steel. Use with our all cotton buffing wheels or the flannel wheels for a beautiful shine. For stainless.

MOSS

This jeweler's rouge was designed for **very** fine coloring. Use with the all cotton wheel or the flannel wheels for a mirror shine. For aluminum and stainless.

Step 1: Primary Cutting



For safety purposes, hold the rouge bar down firmly on the ground with your foot. Touch the rouge bar with the outside edge of the rotating buffing wheel until rouge adheres to the wheel. The rouge bar should be placed on white paper or cloth to keep it clean.

Start at one end of the fuel tank. You may need to start with our **87-Stainless** for very heavy cutting, but for most applications, start with the **Brown Tripoli** and one of the suggested Airway Buffing Wheels shown below.

Suggested Polishing Wheels



- AWO - Orange Airway (Heavy Cutting)
- AWB - Blue Baron Airway (Heavy Cutting)
- AWY - Fast Cut Airway (Primary Cutting)
- AWY - Yellow Airway (Primary Cutting)



The shine is created by letting the buffing compound do the cutting and polishing, not by how much pressure is applied against the metal surface. Polish your fuel tank by sections. Start from the top or bottom. Use a smooth left to right polishing motion. Make several passes to create a clean shine, using overlapping motion.

Step 2: Secondary Cutting



For safety purposes, hold the rouge bar down firmly on the ground with your foot. Touch the rouge bar with the outside edge of the rotating buffing wheel until rouge adheres to the wheel. The rouge bar should be placed on white paper or cloth to keep it clean.



After primary cutting is complete, move to the secondary cutting process. Replace the cutting wheel and use one of the suggested Buffing Wheels shown below, with Green Chrome Rouge. Use the same basic motion and direction as the Primary Cutting Process.



Pay attention to the buffing wheel. If the polishing compound appears to be caking on the edge, use a buffing wheel “rake” to clean excess compound from the wheel. This will lessen the possibility of scratching the polishing surface.



Suggested Buffing Wheels

AWG - Hall Green Airway
AWP - Purple Airway
AWW - White Airway



Remember, the shine is created by letting the buffing compound do the cutting and polishing, not by how much pressure is applied against the metal surface. Polish your fuel tank by sections. Start from the top or bottom. Use a smooth left to right polishing motion. Make several passes to create a clean shine, using overlapping motion.

Step 3: Final Finish

Now you are ready to bring out the “mirror shine” in the polishing process. For this step, you need **Zephyr’s White Airway Untreated** or **Cotton Muslin Buffs** in **30, 40, 50, or 60 ply**. Follow same process as Step 1 and Step 2. For the final finish you will want to use **White Chrome Rouge**, or try Zephyr’s new **Platinum Series Finishing Rouge**. Contact a Zephyr Distributor for pricing.



Platinum Series Finishing Rouge

Max Red
Blue Moon
Slate
White Lightning
Moss Green

All items shown are just a sample of Buffing and Polishing products available from Zephyr. Please contact a Zephyr Distributor or visit zephyrpro40.com for our complete product line.

Step 4: Final Wipe Down



After cutting and finishing, the tank is still dusty and pores filled with caked oxidation residue. To remove without marring finish, apply liquid **PRO-40 Perfection Metal Polish** with **Micro Fiber Towel**. Rub until surface becomes dark. Let dry and wipe off to a clean brilliant shine with a soft, dry **Micro Fiber Towel**.

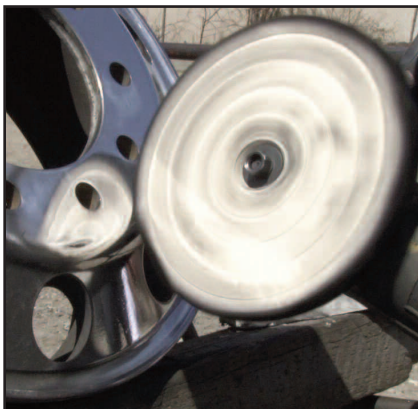
ALUMINUM WHEEL POLISHING

WHEEL POLISHING with BAR ROUGE



If your wheels are heavily oxidized and require more than routine maintenance light polishing, then follow the process outlined below.

Follow the same process as shown in Steps 1 & 2. Depending on how oxidized your wheels are will determine which step you will need to start with (Primary Cutting or Secondary Cutting). Try to always start with the least severe, and if that is not enough cut, you can always move to the more aggressive wheels and rouge. This way it will save you time and effort. Always observe the same safety precautions when using buffing wheels and rouge bars.



Now you can bring out the “mirror shine” by using **Zephyr’s White Airway Untreated or Cotton Muslin Buffs in 30, 40, 50, or 60 ply**. Also use White Chrome Rouge or Zephyr’s Platinum Series Finishing Rouge. Refer to Step 3: Final Finish, and follow the same process.

For the final wipe down, use **PRO-40 Perfection Metal Polish** and **Micro Fiber Towels**. Follow the same process as shown in Step 4: Final Wipe Down. You can also use the steps outlined in “Proper Maintenance for Ultimate Shine”.



PROPER MAINTENANCE for ULTIMATE SHINE

ADDITIONAL SUPPLIES and EQUIPMENT NEEDED



VARIABLE SPEED
Cordless Drill/Driver



2" Round End Shank-Mounted Goblet Buff
3" Round End Shank-Mounted Goblet Buff
4" Round End Shank-Mounted Goblet Buff
8" Extender for Shank-Mounted Buffs



You will need an open container to hold a small amount of Zephyr Pro-40 Metal Polish.



When attached to a Round End Shank-Mounted Goblet Buff, the 8" Extender will help you get into "tight" places for polishing. Unscrew the short shank and remove it from the Goblet Buff. Replace it with the 8" Extender.



Mount the Goblet Buff, with attached Extender, to the variable speed cordless Drill/Driver. The Extender will fit 1/4" and 3/8" chucks.

THE POLISHING PROCESS

It's easy to maintain a "mirror finish" at any time! For comparison, two different wheel styles are shown in these steps.

First, pour a small amount of **PRO-40 Perfection Metal Polish** into the small container, then dip the **Goblet Buff** into the polishing solution.



The 8" Extender has an inner shaft that spins inside of the black outer sleeve. You can hold the outer sleeve while the shaft and **Goblet Buff** are spinning. This will make it easier to "aim and control" the **Goblet Buff** where you want it while you are buffing.



The shine is optimized by letting the metal polish do the work. Use smooth back and forth overlapping motions. Continue to dip the **Goblet Buff** into the polishing solution, as needed.

After polish dries, snap in a second **Goblet Buff** to polish to a "mirror shine".

