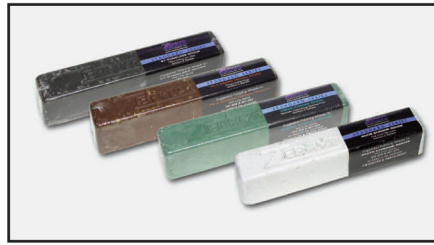


# Machine Polishing with Bar Rouge Requires:



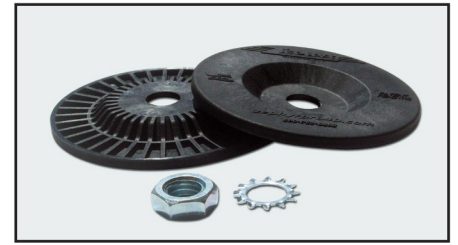
## **POLISHING WHEELS:**

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



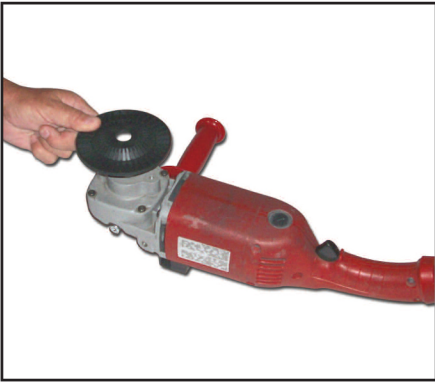
## **VARIABLE SPEED**

SANDER / GRINDER  
MACHINE: 0 - 6,000 RPM



PRO-40 PERFECTION  
METAL POLISH and MICRO  
FIBER POLISHING TOWELS

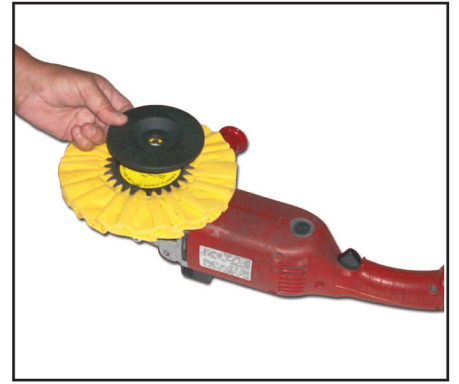
## Safety Flanges:



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.

Polishing With Rouge Bars:

## ***STANDARD SERIES ROUGE***

**The 87 Stainless Rouge Bar** is used for heavy cutting iron, steel, aluminum and stainless.

**Brown Tripoli Rouge Bar** is used for primary cutting stainless and aluminum.

**The Green Chrome Rouge Bar** is used for secondary cutting, semi-final finish, stainless and aluminum.

**The White Chrome Rouge Bar** is used for final finish, high lustre, stainless and aluminum.

## ***PLATINUM SERIES FINISHING ROUGE***

**Max Red Rouge Bar** is used for final-finish show quality, aluminum and stainless.

**Blue Moon Rouge Bar** is used for final coloring, stainless and aluminum.

**Slate Rouge Bar** is used for cut and coloring, stainless and aluminum.

**White Lightning Rouge Bar** is used for cut and coloring, stainless.

**Moss Rouge Bar** is used for very fine coloring or final finish, stainless, aluminum, brass or copper.

## Polishing Your Fuel Tank:

### ***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  
AWP - Pink Poly 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](http://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**.

## Polishing Your Wheels:



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”.



## Rules For Ultimate Shine:



**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  
5" 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. Also shown here are the 2", 3", and 4" Round End Shank-Mounted Goblet Buffs.



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".

