

# STANDARD FINISHING PROCEDURES

## RECOMMENDED CYCLE WITH RANDOM ORBITAL POLISHER

| SUGGESTED TOOLS                                                                                                                                                                                    | SKORPIO E<br>Brushless Sander<br>Cod: RX256A                                                                                             | LHR21 Mark V<br>Dual-Action Polisher<br>Cod: LHR21V                                                                                                                                                    | Random orbital                                                                                                                                                                                                                                                                       |                                                                                                                                                                                        |                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                      |                                                                                                  |
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| STEP 1<br>TEXTURE REMOVAL                                                                                                                                                                          | STEP 2<br>SANDING MARKS<br>REFINEMENT                                                                                                    | OPTIONAL STEP<br>POLISHING<br>PREPARATION                                                                                                                                                              | COMPOUNDING                                                                                                                                                                                                                                                                          | CLEANING                                                                                                                                                                               | POLISHING                                                                                                                                                                   | OPTIONAL STEP<br>ULTRA-FINISHING                                                                                                                                                                                                                                                                                                     |                                                                                                  |
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|                                                                                                                                                                                                    | <b>PROCTU</b><br>Film Abrasive Disc<br>P1200 - Ø150mm<br><br>                                                                            | <b>WET&amp;DRYFINISH</b><br>Foam Abrasive Disc<br>P1500 - Ø150mm<br><br>                                                                                                                               | <b>WET&amp;DRYFINISH</b><br>Foam Abrasive Disc<br>P3000 - Ø150mm<br><br>                                                                                                                                                                                                             | <b>MARINE XC-300</b><br>Fast-Cut Compound<br><b>D-A WOOL COARSE</b><br>Polishing Pad<br><br>                                                                                           | <b>REVEAL LITE</b><br>Residue Remover<br><b>YELLOW MICROFIBER</b><br>Cloth<br><br>                                                                                          | <b>MARINE XF-500</b><br>Fine Polish<br><b>D-A FOAM FINE</b><br>Polishing Pad<br><br>                                                                                                                                                                                                                                                 | <b>MARINE XF-600</b><br>Ultra-Fine Polish<br><b>D-A FOAM ULTRA-FINE</b><br>Polishing Pad<br><br> |
| This step is aimed to remove orange peel and texture. Useful if there are areas of the hull that have an excess of texture that doesn't meet expectation or doesn't match the rest of the surface. | Refines the sanding marks created by P1200, preparing the surface for polishing or for an additional, optional, sanding step with P3000. | Minimizes the sanding marks to make the polishing easier and faster. This step is intended as optional and is recommended specifically for darker colors where also minor defects are clearly visible. | First step of polishing, it's done with a cutting compound and an aggressive wool pad. Sometimes, on white colors, when a random orbital polisher is used, this step could be enough to get a good finish, but a second step could always be recommended to get a swirl free finish. | Although RUPES compound don't contain intentional filters, some ingredients could fill minor swirls, so a cleaning step is always good to make sure that marks don't appear over time. | Second step of polishing is good to refine the surface after compounding. The purposes are multiple: getting a swirl free finish, increase the gloss, get a cleaner finish. | The last step is optional and recommended in those situations where a set value of gloss or haze is requested and the inspector is going to measure the gloss. If, after the polishing step, that set value is not met yet, this step will increase the gloss, make the color deeper, create a better aspect to the overall surface. |                                                                                                  |

## RECOMMENDED CYCLE WITH ROTARY POLISHER

| SUGGESTED TOOLS                                                                                                                                                                                    | SKORPIO E<br>Brushless Sander<br>Cod: RX256A                                                                                             | BigFoot LH19E<br>Rotary Polisher<br>Cod: LH19E                                                                                                                                                         | Rotary                                                                                                                                                                                               |                                                                                                                                                                                        |                                                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                      |                                                                                                            |
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| STEP 1<br>TEXTURE REMOVAL                                                                                                                                                                          | STEP 2<br>SANDING MARKS<br>REFINEMENT                                                                                                    | OPTIONAL STEP<br>POLISHING<br>PREPARATION                                                                                                                                                              | COMPOUNDING                                                                                                                                                                                          | CLEANING                                                                                                                                                                               | POLISHING                                                                                                                                                                   | OPTIONAL STEP<br>ULTRA-FINISHING                                                                                                                                                                                                                                                                                                     |                                                                                                            |
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|                                                                                                                                                                                                    | <b>PROCTU</b><br>Film Abrasive Disc<br>P1200 - Ø150mm<br><br>                                                                            | <b>WET&amp;DRYFINISH</b><br>Foam Abrasive Disc<br>P1500 - Ø150mm<br><br>                                                                                                                               | <b>WET&amp;DRYFINISH</b><br>Foam Abrasive Disc<br>P3000 - Ø150mm<br><br>                                                                                                                             | <b>MARINE XC-300</b><br>Fast-Cut Compound<br><b>CUT&amp;FINISH WOOL</b><br>Polishing Pad<br><br>                                                                                       | <b>REVEAL LITE</b><br>Residue Remover<br><b>YELLOW MICROFIBER</b><br>Cloth<br><br>                                                                                          | <b>MARINE XF-500</b><br>Fine Polish<br><b>ROTARY FOAM FINE</b><br>Polishing Pad<br><br>                                                                                                                                                                                                                                              | <b>MARINE XF-600</b><br>Ultra-Fine Polish<br><b>ROTARY FOAM WAFFLE</b><br>Ultra-Fine Polishing Pad<br><br> |
| This step is aimed to remove orange peel and texture. Useful if there are areas of the hull that have an excess of texture that doesn't meet expectation or doesn't match the rest of the surface. | Refines the sanding marks created by P1200, preparing the surface for polishing or for an additional, optional, sanding step with P3000. | Minimizes the sanding marks to make the polishing easier and faster. This step is intended as optional and is recommended specifically for darker colors where also minor defects are clearly visible. | First step of polishing, it's done with a cutting compound and an aggressive wool pad. A second step is normally recommended to minimize the holograms that many times could appear after this step. | Although RUPES compound don't contain intentional filters, some ingredients could fill minor swirls, so a cleaning step is always good to make sure that marks don't appear over time. | Second step of polishing is good to refine the surface after compounding. The purposes are multiple: getting a swirl free finish, increase the gloss, get a cleaner finish. | The last step is optional and recommended in those situations where a set value of gloss or haze is requested and the inspector is going to measure the gloss. If, after the polishing step, that set value is not met yet, this step will increase the gloss, make the color deeper, create a better aspect to the overall surface. |                                                                                                            |

## PRODUCTS DESCRIPTIONS

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| The LHR21 Mark V Dual-Action Polisher is the evolution of Mark III, delivering premium results with improved precision. Designed for reduced vibration and noise, it features a new gear system to enhance balance, performance, and durability. | The BigFoot LH19E Rotary Polisher is a lightweight, compact tool with high torque, great ergonomics, and easy-to-use control. It includes an electronic speed dial, progressive trigger, dual gear reduction, and a nine-meter cord for flexibility in tasks. | The PROCTU Film Abrasive Disc is made of ceramic grains and PET backing for efficient sanding, even scratches removal, and long life. A steerage layer improves dust removal, reduces clogging, and enhances performance during dry sanding on metal and automotive surfaces. | The WET&DRYFINISH Foam Abrasive Disc uses ceramic grains and PET backing for efficient sanding, fast material removal, and long life. It offers excellent flexibility and control. An anti-dog coating and porous foam reduce dust buildup and conform well to curves for dry sanding applications. | The MARINE XC-300 Fast-Cut Compound removes P1200/P1500 sanding marks fast, restoring gloss on gelcoat and paint, especially after sanding. Perfect for marine professionals and boatyards, it delivers high-end results on yachts and boats during restoration or final polishing. | The MARINE XF-500 Fine Polish enhances gloss on gelcoat and paint, especially after sanding. Perfect for OEMs, boatyards, and detailers, it ensures high-end results on yachts and boats during restoration or final polishing. | The D-A WOOL COARSE Polishing Pad removes heavy defects quickly, using short wool fibers to create a smooth, consistent, and smooth finish. The blue foam adapts to curves and reduces drag, offering smooth, controlled handling on contoured marine surfaces. | The CUT & FINISH WOOL Polishing Pad uses premium-grade merino wool for strong cutting, consistent, and great efficiency. The blue foam adapts to curves and reduces drag, offering smooth, controlled handling on contoured marine surfaces. | The D-A FOAM FINE Polishing Pad removes moderate defects and restores gloss with smooth cutting, consistent, and great efficiency. The foam structure offers comfort, heat buildup, and ensures consistent results on marine and painted surfaces. | The ROTARY FOAM FINE Polishing Pad removes fine imperfections, removes light haze, and creates a smooth surface after final correction stages. Ideal for wax or sealant application, it ensures soft contact, even product spread, and safe use on delicate marine finishes. | The D-A FOAM ULTRA-FINE Polishing Pad removes fine imperfections, removes light haze, and creates a smooth surface after final correction stages. Ideal for wax or sealant application, it ensures soft contact, even product spread, and safe use on delicate marine finishes. | The ROTARY FOAM WAFFLE ULTRA-FINE Polishing Pad removes fine imperfections, removes light haze, and creates a smooth surface after final correction stages. Ideal for wax or sealant application, it ensures soft contact, even product spread, and safe use on delicate marine finishes. | The REVEAL LITE Residue Remover is formulated to eliminate residues, waxes, and contaminants before final polishing. It ensures a clean surface for inspection or protection, improving adhesion of coatings, sealants, or waxes on marine finishes. | The YELLOW MICROFIBER Cloth offers premium quality and short knap, ideal for safely removing imperfections from surfaces. It ensures high absorbency, low lint, and soft contact, perfect for final finishing on gelcoat, paint, or marine clear coats. |