

APPENDIX E INTERCOAT ABRASION

Intercoat abrasion ensures proper adhesion between coats of finish by creating a “profile” or “tooth” known as a mechanical bond. By removing raised grain and irregularities in prior coats, it also assists in achieving a smooth, even appearance after the final coat has dried. Fresh coats of finish may chemically bond without intercoat abrasion. Always follow the finish manufacturer’s recommendation.

- Use multiple angles for a visual inspection of imperfections such as debris, lap marks, drips or swirl marks. Remember, strong light highlights imperfections.
- Hand inspect to determine the extent of the problem. Then use a scraper and/or sandpaper to remove imperfections, and finish by hand rubbing with an abrasive pad.
- Sweep and vacuum. It is essential to start with an absolutely clean floor.
- Using the finish manufacturer’s recommended abrasive, hand abrade all edges or corners where the buffer will not reach.
- Clean the floor thoroughly as before.
- Load the buffer with a steel wool pad, screen or abrasive pad with self-adhering sandpaper strips, as recommended by the manufacturer.
- Abrade the floor by running a buffer with the grain, or for parquet in the long direction of the room, overlapping passes by ½ the buffer width. Run the buffer smoothly to avoid leaving swirl marks.
- Vacuum and tack with a clean cloth, wet with a solvent compatible with the finish system.

Tacking Solvent Chart	
Water-borne urethane	water
Oil-modified urethane	mineral spirits
Moisture-cured urethane	xylene or water
Conversion varnish	denatured alcohol or water

- Apply the next coat of the finish system as directed by the finish manufacturer.