



1. Description

This procedure describes methods for masking in preparation for refinishing. Inspection and evaluation requirements are also included.



2. Purpose

The purpose of this procedure is to provide industry-accepted requirements for performing high-quality masking. This procedure is intended for use by professionals who are qualified through training and experience.



3. Referenced Documents

The following documents are considered part of this procedure by reference.

3.1 Procedures

- HM01 Hazardous Materials
- PS01 Personnel Safety

3.2 Other Information

- Equipment-specific information
- Product-specific information
- Vehicle-specific repair information



4. Equipment And Material Requirements

4.1 Equipment

The use of this equipment is included in this procedure:

- masking dispensers
- liquid masking spray system

4.2 Masking Materials

The use of these masking materials is included in this procedure:

- masking paper
- masking tape
- plastic masking and covers
- wheel covers
- liquid masking
- heavy-duty masking materials
- fine line tape
- molding lift tape
- foam tape
- back-masking tape

Masking materials must be designed for automotive use.



5. Damage Analysis

5.1 General Damage

To obtain proper adhesion and prevent bridging of the paint film, some parts may have to be lifted or removed in the area to be refinished.



6. Personnel Safety

6.1 General Safety

General safety information is in **PS01**.

6.2 Safety With Masking Materials

Wear proper safety equipment when using liquid masking materials. Follow the product maker's recommendations.



7. Environmental Safety

7.1 Hazardous Materials

Used masking materials must be disposed of properly because they may be considered hazardous waste. Hazardous material safety information is in **HM01**.



8. Vehicle Protection

8.1 Temperature When Taping

For proper tape performance, do not apply or remove masking tape when the temperature is below 16° C (60° F).

8.2 Areas To Be Masked

Except for the area to be refinished and adjacent panels needed for blending, the vehicle should be masked, covered, or protected from overspray. Protect the refinish area from contamination by masking areas such as these:

- wheel openings, wheels, and tires
- engine compartment
- trunk
- panel gaps
- door jambs
- cowl vent panel



9. Repair Procedure

9.1 Masking Tape

To mask a surface using masking tape:

- 1. Clean the repair area with the proper wax and grease remover, as recommended by the paint maker.
- 2. Make sure the surface to be taped is clean, dry, and free of dust.
- 3. Apply the tape by pressing it down firmly. Do not stretch the tape while applying it.

9.2 Masking Paper Or Plastic

To mask a surface using masking paper or plastic:

- 1. Apply masking materials as required to protect the vehicle. Follow the paint maker's recommendations. Avoid pleats or pockets, which may collect dust. If a fold is unavoidable, seal it closed.
Note: Avoid contaminating the surface by removing all masking materials used during the repair and surface preparation processes. Apply clean masking materials before applying final topcoats.
- 2. Allow room for blending the finish when masking around spot repairs.

9.3 Liquid Masking

To mask a surface using liquid masking:

- 1. Clean the repair area with the proper wax and grease remover, as recommended by the paint maker.
- 2. Clean and dry the vehicle.
- 3. Protect the area to be painted.
- 4. Apply the liquid masking, following the product maker's recommendations.
Notes: Do not apply liquid masking materials to oxidized paint surfaces. Avoid contaminating the surface by removing all masking materials used during the repair and surface preparation processes. Apply clean masking materials before applying final topcoats.

9.4 Removal Of Masking Materials

To remove masking materials:

- 1. Remove masking materials as soon as possible. Follow the paint maker's recommendations to avoid damaging the refinished area.
- 2. Liquid masking materials can be removed with soap and water. Follow the product maker's recommendations and local environmental regulations to determine the correct disposal method.



10. Use Of Recycled (Salvage) Parts

Does not apply.



11. Inspection And Testing

11.1 Inspection Of Masked Areas

Inspect masked areas for these conditions:

- non-refinish areas properly protected from overspray
- masking materials not covering the surface to be refinished
- masking materials properly applied to prevent creating an exposed paint edge
- tape pressed down firmly
- masking material and tape lapped with no gaps
- no loose pleats, pockets, or folds