

2022 CHEVROLET CORVETTE SERVICE MANUAL

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Back Body Pillar Lower Reinforcement Replacement (Convertible)

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 8X) Fastener Specifications
- Service Flow Drill Screws (M6 17X) Fastener Specifications

Removal Procedure

1. [Click here for full size](#)
2. **Warning:**

Refer to Approved Equipment for Collision Repair Warning
3. **Warning:**

Refer to Collision Sectioning Warning
4. **Warning:**

Refer to Glass and Sheet Metal Handling Warning
5. **Note:**

The back body pillar lower reinforcement is an aluminum extrusion. Aluminum
6. **Note:**

Three dimensional measuring equipment required for installation.
7. Disable the SIR system. SIR Disabling and Enabling.
8. Remove all related panels and components.
9. Remove quarter outer panel. Quarter Outer Panel Replacement - Left Side or Quarter Outer Panel Replacement - Right Side
10. Remove rear compartment panel frame. Rear Compartment Panel Frame Replacement
11. Remove load floor panel rear cross bars. Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side
12. Remove rear window panel reinforcement. Rear Window Panel Reinforcement Replacement
13. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
14. [Click here for full size](#)
15. **Note:**

Left shown, right similar.
16. Remove flow drill screws (1). [4X] Fastener Specifications
17. [Click here for full size](#)
18. Remove flow drill screws (1). [7X] Fastener Specifications
19. [Click here for full size](#)

20. Remove flow drill screws (1). [6X] Fastener Specifications
21. [Click here for full size](#)
22. Using reciprocating saw or equivalent tool cut through back body pillar lower reinforcement at marked locations (1).
23. Remove section of back body pillar lower reinforcement (2).
24. [Click here for full size](#)
25. Warning:

Refer to Aluminum Panel Warning.
26. Note:

Left shown, right similar.
27. Note:

Use even pulling strokes to control cut.
28. Note:

Do not damage or cut attaching panels and reinforcements.
29. Using belt sander or similar tool, cut through remaining portion of back body pillar lower reinforcement (1) to remove laser weld.
30. [Click here for full size](#)
31. Warning:

When separating the aluminum panels during collision repair, be sure to adhere to the following precautions:
 - Do not use an open flame
 - Focus heat onto panel being replaced and do not exceed 200°C (392°F) for 3 consecutive minutes
 - Use care not to damage adjacent panel while prying the panels apartFailure to follow the precautions may lead to vehicle damage or personal injury.
32. Apply heat to release adhesive (1).
33. [Click here for full size](#)
34. Note:

Left shown, right similar.
35. Apply heat to release adhesive (1).
36. Remove remaining back body pillar lower reinforcement from vehicle.
37. Note:

Do not damage body structure when removing adhesive.
38. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)
2. Note:

Temporarily install replacement part.
3. Position back body pillar lower reinforcement (1) on vehicle using three-dimensional measuring equipment and clamp into place.
4. [Click here for full size](#)
5. Note:

The 6.7 mm (17/64) holes are used for rivet installation.

6. Note:

Structural blind rivets in conjunction with structural adhesive will be used in place of laser welds.

7. Drill 6.7 mm (17/64") holes (1) for structural blind rivets. [8X] Fastener Specifications

8. Drill 5.4 mm (13/64") pilot holes (2) for flow drill screws (M6). [7X] Fastener Specifications

9. [Click here for full size](#)

10. Note:

Left shown, right similar.

11. Drill 5.4 mm (13/64") pilot holes (1) for flow drill screws (M6). [4X] Fastener Specifications

12. [Click here for full size](#)

13. Drill 5.4 mm (13/64") pilot holes (1) for service flow drill screws (M6). [6X] Fastener Specifications

14. [Click here for full size](#)

15. Remove back body pillar lower reinforcement (1) from vehicle.

16. [Click here for full size](#)

17. Note:

Accurate and timely assembly methods must be used in order to meet proper bonding requirements.

18. Note:

Dry fit all parts with proper clamping devices prior to final assembly to ensure full understanding of the assembly process.

19. Note:

When using adhesive, ensure all necessary tools and materials are in place prior to final assembly.

20. Note:

Only remove E-coat where adhesive will be applied.

21. Note:

Ensure all bare metal is covered.

22. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations.
Aluminum Panel Bonding

23. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

24. [Click here for full size](#)

25. Install back body pillar lower reinforcement (1) on vehicle and clamp into place.

26. [Click here for full size](#)

27. Note:

Install fasteners from direction shown.

28. Install structural rivet (1). [SR2 8X] Fastener Specifications

29. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.

30. Install service flow drill screws (M6) (2). [7X] Fastener Specifications

31. [Click here for full size](#)

32. Note:

Left shown, right similar.

33. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.

34. Install service flow drill screws (M6) (1). [4X] Fastener Specifications

35. [Click here for full size](#)

36. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.

37. Install flow drill screws (1). [6X] Fastener Specifications

38. Remove excess adhesive.

39. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair

40. Install rear window panel reinforcement. Rear Window Panel Reinforcement Replacement

41. Install load floor panel rear cross bars. Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side

42. Install rear compartment panel frame. Rear Compartment Panel Frame Replacement

43. Install quarter outer panel. Quarter Outer Panel Replacement - Left Side or Quarter Outer Panel Replacement - Right Side

44. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair

45. Paint the repaired area. Basecoat/Clearcoat Paint Systems

46. Install all related panels and components.

47. Enable the SIR System. SIR Disabling and Enabling