

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
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Body Hinge Pillar Outer Panel Reinforcement Replacement

Materials

- Structure Adhesive Aluminum Panel Bonding
- Structure Rivet (SR3 8X) Fastener Specifications
- Structure Rivet (SR4 2X) 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 body lock pillar reinforcement is a 6000 Series Aluminum Extrusion. Aluminum
6. **Note:**

Three dimensional fixturing equipment required for installation.
7. **Note:**

Left shown, right similar.
8. Disable the SIR system. SIR Disabling and Enabling
9. Remove all related panels and components.
10. Remove side door opening frame. Side Door Opening Frame Replacement
11. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
12. [Click here for full size](#)
13. **Note:**

Record the number and location of flow drill screws.
14. Remove flow drill screws (1). [18X] Fastener Specifications
15. [Click here for full size](#)
16. Using die grinder remove corner of composite dash panel (1).
17. Remove flow drill screw (2). [1X]
18. [Click here for full size](#)
19. **Note:**

Do not damage or cut attaching panels and reinforcements.

20. Note:

Record the number and location of spot welds for installation of structural rivets.

21. Remove spot welds (1). [10X]

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

23. 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 apart

Failure to follow the precautions may lead to vehicle damage or personal injury.

24. Apply heat to release adhesive (1).

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

26. Note:

Excessive prying force may damage surrounding structure.

27. Remove body lock pillar lower reinforcement (1) from vehicle.

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

29. Inspect structural baffle (1) and replace if damaged.

30. Note:

Do not damage body structure when removing adhesive.

31. Remove remaining adhesive from body structure.

Installation Procedure

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

2. Note:

Temporarily install replacement part.

3. Position body hinge pillar outer panel (1) on vehicle using 3-dimensional measuring equipment and clamp into place.

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

5. Note:

The 6.7 mm (17/64") hole used for rivet installation.

6. Drill 6.7 mm (17/64") holes (1). [10x] Fastener Specifications

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

8. Note:

Locate pilot holes for flow drill screws at center of hole on attaching panels.

9. Drill 4.0 mm (5/32) pilot holes (1). [19X]

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

11. Remove body hinge pillar outer panel from vehicle.

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

13. Note:

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

14. Note:

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

15. Note:

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

16. Note:

Only remove E-coat where adhesive will be applied.

17. Note:

Ensure all bare metal is covered.

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

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

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

21. Apply structural adhesive (1) to mating surfaces on structural baffle according to adhesive manufacturer's recommendations.
Aluminum Panel Bonding

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

23. Install body hinge pillar outer panel (1) on vehicle and clamp into place.

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

25. Install structural rivets (1) [SR3 8X]

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

27. Install structural rivets (1) [SR4 2X]

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

29. Note:

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

30. Install flow drill screws (1). [19X] Fastener Specifications

31. Remove excess adhesive.

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

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

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

35. Note:

Seal holes on panel to prevent water intrusion.

36. Install round sealing sticker (1) over holes in door hinge areas. [4X] [GM # 15856530]

37. Install foil-backed butyl patch (2) over gauge holes. [3X] [GM # 15896823]

38. Install side door opening frame. Side Door Opening Frame Replacement

39. Install all related panels and components.

40. Enable the SIR System. SIR Disabling and Enabling