

2022 CHEVROLET CORVETTE SERVICE MANUAL

- [SEARCH](#)

1. [Body Repair](#)
2. [Collision Repair](#)
3. [Repair Instructions](#)
- 4.

Body Lock Pillar Inner Panel Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 1X) Fastener Specifications
- Countersunk Structural Blind Rivet (CR1 12X) Fastener Specifications
- Countersunk Structural Blind Rivet (CR3 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 inner panel is 5000 series aluminum sheet. Aluminum
6. Note:

Left shown, right similar.
7. Note:

Three dimensional measuring equipment required for installation.
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 body lock pillar outer Body Lock Pillar Outer Panel Replacement
12. Remove rocker panel inner reinforcement. Rocker Inner 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. Remove flow drill screws (1). [2X] Fastener Specifications
16. Note:

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

Do not damage or cut attaching panels and reinforcements.

18. Remove spot welds (1). [2X] Fastener Specifications

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

20. Note:

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

21. Note:

Do not damage or cut attaching panels and reinforcements.

22. Remove spot welds (1). [15X] Fastener Specifications

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

24. 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.

25. Apply heat to release adhesive (1).

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

27. Apply heat to release adhesive (1).

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

29. Remove body lock pillar inner panel (1) from vehicle.

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 lock pillar inner panel (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:

Drill holes in the original spot weld location as noted in removal.

7. Drill 6.7 mm (17/64) holes (1) for countersink structural blind rivets. [2X] Fastener Specifications

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

9. Note:

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

10. Note:

Drill holes in the original spot weld location as noted in removal.

11. Drill 6.7 mm (17/64") holes (1) for countersink structural blind rivets. [9X] Fastener Specifications
12. Drill 6.7 mm (17/64") holes (2) for countersink structural blind rivets. [3X] Fastener Specifications
13. Drill 6.7 mm (17/64") holes (3) for countersink structural blind rivets. [1X] Fastener Specifications

14. Note:

Prepare rivet holes for countersunk structural rivets.

15. Using countersink cutting tool, countersink holes (2). [3X]

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

17. Note:

Prepare rivet holes for countersunk structural rivets.

18. Using countersink cutting tool, countersink holes (1). [11X]

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

20. Remove body lock pillar inner panel (1) from vehicle.

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

22. Note:

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

23. Note:

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

24. Note:

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

25. Note:

Only remove E-coat where adhesive will be applied.

26. Note:

Ensure all bare metal is covered.

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

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

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

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

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

32. Install body lock pillar inner panel (1) on vehicle and clamp into place.

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

34. Note:

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

35. Install flow drill screws (1). [2X] Fastener Specifications

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

37. Note:

Install fasteners from direction shown.

38. Install structural rivet (1). [SR2 1X]
39. Install countersunk structural blind rivet (2). [CR1 1X] Fastener Specifications
40. Install countersunk structural blind rivet (3). [CR3 2X] Fastener Specifications
41. [Click here for full size](#)
42. Note:

Install fasteners from direction shown.

43. Install countersunk structural blind rivet (1). [CR1 11X] Fastener Specifications
44. Remove excess adhesive.
45. Install rocker panel inner reinforcement. [Rocker Inner Panel Reinforcement Replacement](#)
46. Install body lock pillar outer [Body Lock Pillar Outer Panel Replacement](#)
47. Install side door opening frame. [Side Door Opening Frame Replacement](#)
48. Apply the sealers and anti-corrosion materials to the repair area as necessary. [Anti-Corrosion Treatment and Repair](#)
49. Seal tops of countersunk rivets before applying windshield adhesive.
50. Paint the repaired area. [Basecoat/Clearcoat Paint Systems](#)
51. Install all related panels and components.
52. Enable the SIR System. [SIR Disabling and Enabling](#)