

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
2. **Collision Repair**
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Body Lock Pillar Outer Panel Replacement

Materials

- Structure Adhesive Aluminum Panel Bonding
- Structure Rivet (SR2 12X) Fastener Specifications
- Structure Rivet (SR3 3X) Fastener Specifications
- RPR Makers Special Tools

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 outer panel is 6000 series stamped aluminum sheet. Aluminum
6. Note:

Three dimensional fixturing 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 the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
11. [Click here for full size](#)
12. Remove flow drill screws (1). [5X] Fastener Specifications
13. [Click here for full size](#)
14. Note:

Do not damage or cut attaching panels and reinforcements.
15. Note:

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

Drill through top layer only.

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

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

19. 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.

20. Apply heat to release adhesive (1).

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

22. Note:

Excessive prying force may damage attaching panels.

23. Remove body lock pillar outer panel (1) from vehicle.

24. Note:

Do not damage body structure when removing adhesive.

25. 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 outer panel (1) on vehicle using three-dimensional fixturing equipment and clamp into place.

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

5. Note:

The 6.7 mm (17/64) holes used for structure 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). [15x] Fastener Specifications

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

9. Remove body lock pillar outer panel (1) from vehicle.

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

11. Note:

Aluminum body RPR makers are used to mark clearance holes for flow drill screws.

12. Install aluminum body RPR makers on the vehicle. [4X] Special Tools

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

14. Install body lock pillar outer panel on vehicle.

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

16. Locate and mark (1) clearance holes using aluminum body RPR makers. [4X]

17. [Click here for full size](#)
18. Remove body lock pillar outer panel (1) from vehicle.
19. [Click here for full size](#)
20. Drill 7 mm (9/32) clearance holes on body lock pillar outer panel at marked locations (1). [4X]
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. Note:

Left shown, right similar.
28. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding.
29. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
30. [Click here for full size](#)
31. Install body lock pillar outer panel (1) on vehicle using three-dimensional fixturing equipment and clamp into place.
32. [Click here for full size](#)
33. Note:

Install structural rivets in direction shown in illustration.
34. Install structural rivets (1). [SR3 3X]
35. [Click here for full size](#)
36. Note:

Install structural rivets in direction shown in illustration.
37. Install structural rivets (1). [SR2 7X]
38. [Click here for full size](#)
39. Install structural rivets (1). [SR2 5X]
40. [Click here for full size](#)
41. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.
42. Install flow drill screws (1). [5X] Fastener Specifications
43. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
44. Seal structural rivets with seam sealer. 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

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