

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
2. **Collision Repair**
3. **Repair Instructions**
- 4.

Body Side Outer Panel Replacement

Materials

- Sheet Molded Compound (SMC) Sheet Molded Compound (SMC) Panel Bonding

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 side door opening frame is made of (SMC), and is bonded to the rear structure. Sheet Molded Compound (SMC) Panel Bonding
6. Disable the SIR system. SIR Disabling and Enabling.
7. Remove all related panels and components.
8. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
9. Click here for full size
10. Note:

Do not use open flame.
11. Note:

Heat slowly and focus heat on panel being replaced.
12. Note:

Excessive prying force may damage surrounding structure.
13. Note:

The width, height and location of structure adhesive dollops for installation.
14. Apply heat to release adhesive (1).
15. Click here for full size
16. Apply heat to release adhesive (1).
17. Click here for full size
18. Note:

Excessive prying force may damage attaching panels.
19. Remove side door opening frame (1) from vehicle.

20. Note:

The location of adhesive for installation.

21. Note:

Do not damage body structure when removing adhesive.

22. Remove remaining adhesive from body structure.

Installation Procedure

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

2. Note:

Temporarily install replacement part.

3. Position side door opening frame on vehicle using three-dimensional measuring equipment.

4. Remove side door opening frame (1) from vehicle.

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

6. Note:

Shims may be necessary to achieve proper panel alignment. Use care to keep shims out of adhesive path.

7. Note:

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

8. Note:

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

9. Note:

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

10. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding

11. Note:

Duplicate width, height and location of structure adhesive dollops as noted in removal.

12. Apply dollops of structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding

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

14. Note:

Duplicate width, height and location of structure adhesive dollops as noted in removal.

15. Apply dollops of structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding

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

17. Apply a consistent bead structural adhesive (1) 10 mm (3/8) in diameter to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding

18. Apply a consistent bead structural adhesive (2) 16 mm (5/8) in diameter to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations.

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

20. Note:

Refer to adhesive manufacturer's recommendations for cure times. Sheet Molded Compound (SMC) Panel Bonding

21. Note:

Ensure side door opening frame has seated throughout the adhesive path.

22. Install side door opening frame (1) on vehicle and clamp into place.
23. Remove excess adhesive.
24. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
25. Paint the repaired area. Basecoat/Clearcoat Paint Systems.
26. Install all related panels and components.
27. Enable the SIR System. SIR Disabling and Enabling.

mcx30.com