

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Dash Upper Extension Panel Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 8X) 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 windshield frame header front panel is 6000 series stamped aluminum sheet. Aluminum
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 damage or cut attaching panels and reinforcements
11. **Note:**

Record the number and location of spot welds for installation of structural rivets.
12. Remove spot welds (1). [2X]
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 flow drill screws.
16. Remove spot welds (1). [2X]
17. [Click here for full size](#)
18. **Note:**

Do not damage or cut attaching panels and reinforcements

19. Note:

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

20. Remove spot welds (1). [2X]

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

22. Note:

Do not damage or cut attaching panels and reinforcements

23. Note:

Record the number and location of spot welds for installation of flow drill screws.

24. Remove spot welds (1). [2X]

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

26. 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.

27. Apply heat to release adhesive (1).

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

29. Apply heat to release adhesive (1).

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

31. Apply heat to release adhesive (1).

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

33. Apply heat to release adhesive (1).

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

35. Remove front windshield frame header front panel (1) from vehicle.

36. Note:

Do not damage body structure when removing adhesive.

37. Remove remaining adhesive from body structure.

Installation Procedure

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

2. Note:

Temporarily install replacement part.

3. Position front windshield frame header front 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) hole used for structural 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). [2X]

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

9. Note:

The 5.4 mm (7/32) hole used for flow drill screw.

10. Note:

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

11. Drill 5.4 mm (7/32) holes (1). [2X] Fastener Specifications

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

13. Note:

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

14. Note:

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

15. Drill 6.7 mm (17/64) holes (1). [2X]

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

17. Note:

The 5.4 mm (7/32) hole used for flow drill screw.

18. Note:

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

19. Drill 5.4 mm (7/32) holes (1). [2X] Fastener Specifications

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

21. Remove front windshield frame header front panel (1) from vehicle.

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

23. Note:

Enlarge the 5.4 mm (7/32) hole to 7.0 mm (9/32) as a clearance hole for the flow drill screw.

24. Drill 7.0 mm (9/32) holes (1). [2X] Fastener Specifications

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

26. Note:

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

27. Note:

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

28. Note:

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

29. Note:

Only remove E-coat where adhesive will be applied.

30. Note:

Ensure all bare metal is covered.

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

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

recommendations. Aluminum Panel Bonding

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

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

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

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

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

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

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

40. Install front windshield frame header front panel (1) on vehicle and clamp into place.

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

42. Install structural rivets (1). [SR2 2X]Fastener Specifications

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

44. Note:

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

45. Install flow drill screw (1). [M6 2X]Fastener Specifications

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

47. Install structural rivets (1). [SR2 2X]Fastener Specifications

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

49. Note:

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

50. Install flow drill screw (1). [M6 2X]Fastener Specifications

51. Remove excess adhesive.

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

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

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

55. Install all related panels and components.

56. Enable the SIR System. SIR Disabling and Enabling.