

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Floor Panel Number 2 Cross Bar Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Countersunk Rivet (CR1 2X) Fastener Specifications
- Structural Countersunk Rivet (CR2 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 floor panel number 2 cross bar is 6000 series stamped aluminum sheet. Aluminum
6. **Note:**

Left shown, right similar.
7. Disable the SIR system. SIR Disabling and Enabling.
8. Remove all related panels and components.
9. Remove front floor panel. Front Floor Panel Replacement
10. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
11. Remove flow drill screws (2). [4X] Fastener Specifications
12. [Click here for full size](#)
13. **Note:**

Record the number and location of spot welds for installation of structural countersunk rivets.
14. **Note:**

Do not damage or cut attaching panels and reinforcements.
15. Remove spot welds (1). [2X]
16. [Click here for full size](#)
17. **Note:**

Record the number and location of spot welds for installation of structural countersunk rivets.
18. **Note:**

Do not damage or cut attaching panels and reinforcements.

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

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

21. 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.

22. Apply heat to release adhesive (1).

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

24. Apply heat to release adhesive (1).

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

26. Remove floor panel number 2 cross bar (1) from vehicle.

27. Note:

Do not damage body structure when removing adhesive.

28. Remove remaining adhesive from body structure.

Installation Procedure

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

2. Note:

Temporarily install replacement part.

3. Position floor panel number 2 cross bar (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 used for structural countersunk rivets 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 6.7 mm (17/64") holes used for structural countersunk rivets installation.

10. Note:

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

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

12. Note:

Prepare rivet holes for countersunk structural rivets.

13. Using countersink cutting tool, countersink holes (1). [2X] Special Tools

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

15. Remove floor panel number 2 cross bar (1) from vehicle.

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

17. Note:

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

18. Note:

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

19. Note:

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

20. Note:

Only remove E-coat where adhesive will be applied.

21. Note:

Ensure all bare metal is covered.

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

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

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

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

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

27. Install floor panel number 2 cross bar (1) on vehicle and clamp into place.

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

29. Install structure rivets (1). [CR2 2X] Fastener Specifications

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

31. Install structure rivets (1). [CR1 2X] Fastener Specifications

32. Remove excess adhesive.

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

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

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

36. Install front floor panel. Front Floor Panel Replacement

37. Install all related panels and components.

38. Enable the SIR System. SIR Disabling and Enabling