

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
2. **Collision Repair**
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Floor Panel Number 3 Cross Bar Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR3 8X) Fastener Specifications
- Structural Rivet (CR1 8X) Fastener Specifications
- Structural Rivet (CR2 4X) 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 3 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. [Click here for full size](#)
12. **Note:**

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

Record the number and location of spot welds for installation of structural countersunk rivets.
14. Using 6.7 mm (17/64) drill bit remove spot welds (1). [12X]
15. [Click here for full size](#)
16. **Note:**

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

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

18. Using 6.7 mm (17/64) drill bit remove spot welds (1). [8X]
19. [Click here for full size](#)
20. 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.

21. Apply heat to release adhesive (1).
22. [Click here for full size](#)
23. Remove floor panel number 3 cross bar (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 floor panel number 3 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) hole used for structural countersunk 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). [12X]

8. Note:

Prepare rivet holes for countersunk structural rivet.

9. Using countersink cutting tool, countersink the holes (1). [12X] Special Tools

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

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

12. Note:

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

13. Drill 6.7 mm (17/64) holes (1). [8X]

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

15. Remove floor panel number 3 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. Install floor panel number 3 cross bar (1) on vehicle and clamp into place.

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

27. Install structural countersunk rivets (1). [CR1 8X]Fastener Specifications

28. Install structural countersunk rivets (2). [CR2 4X]Fastener Specifications

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

30. Install structural rivets (1). [SR3 8X]Fastener Specifications

31. Remove excess adhesive.

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

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

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

35. Install front floor panel. Front Floor Panel Replacement

36. Install all related panels and components.

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