

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
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Floor Panel Tunnel Panel Reinforcement Bracket Replacement (Center Upper)

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (CR1 2X) Fastener Specifications
- Countersink Cutting Tool 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 floor panel tunnel reinforcement bracket is 6000 series aluminum sheet. Aluminum
6. Disable the SIR system. SIR Disabling and Enabling.
7. Remove all related panels and components.
8. Remove dash panel. Dash Panel Replacement
9. Remove front tunnel reinforcement.
10. Remove front tunnel brace.
11. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
12. [Click here for full size](#)
13. Remove flow drill screws (1). [9X] Fastener Specifications
14. [Click here for full size](#)
15. **Note:**

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

Do not damage or cut attaching panels and reinforcements.
17. Remove spot welds (1). [2X]
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. Remove floor panel tunnel reinforcement bracket (1) from vehicle.
23. Note:
Do not damage body structure when removing adhesive.
24. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)
2. Note:
Temporarily install replacement part.
3. Position floor panel tunnel reinforcement bracket (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 countersunk 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) for countersunk structural blind rivets. [2X] Fastener Specifications
8. Note:
Prepare rivet holes for countersunk structural rivets.
9. Using countersink cutting tool, countersink holes (1). [2X] Special Tools
10. [Click here for full size](#)
11. Remove floor panel tunnel reinforcement bracket (1) from vehicle.
12. [Click here for full size](#)
13. Note:
Accurate and timely assembly methods must be used in order to meet proper bonding requirements.
14. Note:
Dry fit all parts with proper clamping devices prior to final assembly to ensure full understanding of the assembly process.
15. Note:
When using adhesive, ensure all necessary tools and materials are in place prior to final assembly.
16. Note:
Only remove E-coat where adhesive will be applied.
17. Note:
Ensure all bare metal is covered.

18. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
19. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
20. [Click here for full size](#)
21. Install floor panel tunnel reinforcement bracket (1) on vehicle and clamp into place.
22. [Click here for full size](#)
23. Note:

Install fasteners from direction shown.
24. Install countersunk structural blind rivets (1). [CR1 2X]
25. [Click here for full size](#)
26. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.
27. Install flow drill screws (1). [9X] Fastener Specifications
28. Remove excess adhesive.
29. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
30. Seal structural rivets with seam sealer.
31. Paint the repaired area. Basecoat/Clearcoat Paint Systems
32. Install all related panels and components.
33. Enable the SIR System. SIR Disabling and Enabling