

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Floor Panel Tunnel Panel Reinforcement Bracket Replacement (Extension)

Materials

- Structure Adhesive Aluminum 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 floor panel tunnel reinforcement extension is 7000 series aluminum extrusion. Aluminum
6. Note:

Three dimensional measuring equipment required for installation.
7. Note:

Left show, right similar.
8. Disable the SIR system. SIR Disabling and Enabling.
9. Remove all related panels and components.
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. Remove flow drill screws (1). [1X] Fastener Specifications
13. Click here for full size
14. Remove flow drill screws (1). [2X] Fastener Specifications
15. Click here for full size
16. Note:

Do not damage or cut attaching panels and reinforcements.
17. Measure and mark cut line (1) on floor panel tunnel reinforcement extension leaving approximately 25 mm (1 in) of original assembly.
18. Using reciprocating saw or equivalent tool cut through floor panel tunnel reinforcement extension at marked location (1).
19. Click here for full size
20. Remove cut off portion of floor panel tunnel reinforcement extension (1) from vehicle.

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

Do not damage or cut attaching panels and reinforcements.

23. Measure and mark cut line (1) on floor panel tunnel reinforcement extension leaving approximately 13 mm (1/2") of original assembly.
24. Using a cut off wheel or equivalent tool cut through floor panel tunnel reinforcement extension at marked location (1).
25. Measure and mark cut line (2) on floor panel tunnel reinforcement extension along inner lower edge of assembly.
26. Using a cut off wheel or equivalent tool cut through floor panel tunnel reinforcement extension at marked location (2).
27. [Click here for full size](#)
28. Remove cut out portion of floor panel tunnel reinforcement extension (1) from vehicle.
29. [Click here for full size](#)
30. 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.

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. Note:

Excessive prying force may damage surrounding structure.

36. Remove remaining floor panel tunnel reinforcement extension (1) from vehicle.
37. Note:

Do not damage body structure when removing adhesive.
38. 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 extension (1) on vehicle using three-dimensional measuring equipment and clamp into place.
4. [Click here for full size](#)
5. Note:

Locate pilot holes for flow drill screws at center of hole on attaching panels.
6. Drill 4.0 mm (5/32") pilot holes. [1X] Fastener Specifications
7. [Click here for full size](#)
8. Note:

Locate pilot holes for flow drill screws at center of hole on attaching panels.

9. Drill 4.0 mm (5/32") pilot holes. [2X] Fastener Specifications
10. [Click here for full size](#)
11. Remove floor panel tunnel reinforcement extension (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. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
22. [Click here for full size](#)
23. Install floor panel tunnel reinforcement extension (1) on vehicle using three dimensional fixturing equipment and clamp into place.
24. [Click here for full size](#)
25. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.
26. Install flow drill screws (1). [1X] Fastener Specifications
27. [Click here for full size](#)
28. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.
29. Install flow drill screws (1). [2X] Fastener Specifications
30. Remove excess adhesive.
31. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
32. Paint the repaired area. Basecoat/Clearcoat Paint Systems
33. Install all related panels and components.
34. Enable the SIR System. SIR Disabling and Enabling