

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Front Compartment Side Rail Bracket Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 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 front compartment side rail bracket is 5000 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 the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
10. Click here for full size
11. Remove bolts (1). [2X]
12. Remove flow drill screws (2). [4X] Fastener Specifications
13. Click here for full size
14. Note:

Record the number and location of spot welds for installation of structure rivets.
15. Note:

Do not damage or cut attaching panels and reinforcements.
16. Remove spot welds (1). [2X]
17. Click here for full size
18. 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.

19. Apply heat to release adhesive (1).
20. [Click here for full size](#)
21. Remove front compartment side rail bracket (1) from vehicle.
22. Note:
Do not damage body structure when removing adhesive.
23. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)
2. Note:
Temporarily install replacement part.
3. Position front compartment side rail 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 structure 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. Remove front compartment side rail bracket (1) from vehicle.
10. [Click here for full size](#)
11. Note:
Accurate and timely assembly methods must be used in order to meet proper bonding requirements.
12. Note:
Dry fit all parts with proper clamping devices prior to final assembly to ensure full understanding of the assembly process.
13. Note:
When using adhesive, ensure all necessary tools and materials are in place prior to final assembly.
14. Note:
Only remove E-coat where adhesive will be applied.
15. Note:
Ensure all bare metal is covered.
16. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
17. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
18. [Click here for full size](#)
19. Install front compartment side rail bracket (1) on vehicle and clamp into place.

20. Install flow drill screws (2). [4X] Fastener Specifications

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

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

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

23. Note:

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

24. Install flow drill screws (2). [4X] Fastener Specifications

25. Install bolts (1) 9N-m (6.64 lb ft) [2X].

26. Remove excess adhesive.

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

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

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

30. Install all related panels and components.

31. Enable the SIR System. SIR Disabling and Enabling

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