

2022 CHEVROLET CORVETTE SERVICE MANUAL

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1. **Body Repair**
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Intermediate Floor Panel Filler Panel Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 7X) Fastener Specifications
- Countersunk Structural Rivet (CR1 8X) Fastener Specifications
- RPR Makers 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 intermediate floor panel filler panel is 5000 series aluminum sheet. Aluminum
6. **Note:**

Three dimensional measuring equipment required for installation.
7. Disable the SIR system. SIR Disabling and Enabling.
8. Remove all related panels and components.
9. Remove dash panel Dash Panel Replacement
10. Remove front floor panel Front Floor Panel Replacement
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. **Note:**

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

Do not damage or cut attaching panels and reinforcements.
16. Remove spot welds (1). [15X] Fastener Specifications
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 intermediate floor panel filler panel (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 intermediate floor panel filler panel (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 are used for 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. [8X] Fastener Specifications

8. Drill 6.7 mm (17/64) holes (2) for structural blind rivets. [7X] Fastener Specifications

9. Note:

Prepare rivet holes for countersunk structural rivets.

10. Using countersink cutting tool, countersink holes (1). [8X]

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

12. Remove intermediate floor panel filler panel (1) from vehicle.

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

14. Note:

Aluminum body RPR makers are used to mark clearance holes for flow drill screws.

15. Install aluminum body RPR makers (1) on the vehicle. [9X] Special Tools

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

17. Install intermediate floor panel filler panel (1) on vehicle.

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

19. Locate and mark (1) clearance holes using aluminum body RPR makers. [9X]

20. [Click here for full size](#)
21. Remove intermediate floor panel filler panel (1) on vehicle.
22. [Click here for full size](#)
23. Drill 7 mm (9/32) clearance holes on intermediate floor panel filler panel at marked locations (1). [9X]
24. [Click here for full size](#)
25. Note:

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

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

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

Only remove E-coat where adhesive will be applied.
29. Note:

Ensure all bare metal is covered.
30. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
31. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
32. [Click here for full size](#)
33. Install intermediate floor panel filler panel (1) on vehicle.
34. [Click here for full size](#)
35. Note:

Ensure screw is fully seated with a minimum torque of 5N-m (4 lb ft) and not stripped.
36. Install flow drill screws (1). [9X]
37. Note:

Install fasteners from direction shown.
38. Install structural rivets (2). [SR2 7X]
39. Install countersunk structural blind rivets (3). [CR1 2X] Fastener Specifications
40. [Click here for full size](#)
41. Note:

Install fasteners from direction shown.
42. Install countersunk structural blind rivets (1). [CR1 6X] Fastener Specifications
43. Remove excess adhesive.
44. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair
45. Install front floor panel Front Floor Panel Replacement
46. Install dash panel Dash Panel Replacement
47. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
48. Paint the repaired area. Basecoat/Clearcoat Paint Systems

49. Install all related panels and components.

50. Enable the SIR System. SIR Disabling and Enabling

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