

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Rear Compartment Panel Frame Replacement (Coupe)

Materials

- Structural Adhesive Sheet Molded Compound (SMC) 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 rear compartment panel frame is made of (SMC), and is bonded to the rear structure. Sheet Molded Compound (SMC) Panel Bonding
6. Disable the SIR system. SIR Disabling and Enabling.
7. Remove all related panels and components.
8. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
9. Click here for full size
10. Note:

Do not use open flame.
11. Note:

Heat slowly and focus heat on panel being replaced.
12. Note:

Excessive prying force may damage surrounding structure.
13. Apply heat to release adhesive (1).
14. Click here for full size
15. Apply heat to release adhesive (1).
16. Click here for full size
17. Apply heat to release adhesive (1).
18. Click here for full size
19. Note:

Excessive prying force may damage attaching panels.

20. Remove rear compartment panel frame (1) from vehicle.
21. Note:
The location of adhesive for installation.
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 rear compartment panel frame on vehicle using three-dimensional measuring equipment.
4. Remove rear compartment panel frame from vehicle.
5. Click here for full size
6. Note:
Shims may be necessary to achieve proper panel alignment. Use care to keep shims out of adhesive path.
7. Note:
Accurate and timely assembly methods must be used in order to meet proper bonding requirements.
8. Note:
Dry fit all parts with proper clamping devices prior to final assembly to ensure full understanding of the assembly process.
9. Note:
When using adhesive, ensure all necessary tools and materials are in place prior to final assembly.
10. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding
11. Apply a consistent bead structural adhesive (1) 11 mm (7/16) in diameter to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding
12. Click here for full size
13. Note:
Ensure structure adhesive around rear seat upper beam (1) and roof bow (2) form a consistent bead.
14. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding
15. Apply a consistent bead structural adhesive (3) 11 mm (7/16) in diameter to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Sheet Molded Compound (SMC) Panel Bonding
16. Click here for full size
17. Note:
Refer to adhesive manufacturer's recommendations for cure times.
18. Note:
Ensure rear compartment panel frame has seated throughout the adhesive path.
19. Install rear compartment panel frame (1) on vehicle and clamp into place.
20. Remove excess adhesive.
21. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair

22. Paint the repaired area. Basecoat/Clearcoat Paint Systems.
23. Install all related panels and components.
24. Enable the SIR System. SIR Disabling and Enabling.

mcx30.com