

2022 CHEVROLET CORVETTE SERVICE MANUAL

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1. **Body Repair**
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Rear Rail Replacement (Suspension Support Convertible)

Materials

- Structural 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 rear rail suspension support is cast aluminumAluminum
6. Note:

Left shown, right similar.
7. Disable the SIR system. SIR Disabling and Enabling.
8. Remove all related panels and components.
9. Remove rear compartment panel frame. Rear Compartment Panel Frame Replacement
10. Remove load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side
11. Remove rear window panel reinforcement. Rear Window Panel Reinforcement Replacement
12. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
13. Click here for full size
14. Remove flow drill screws (1). [10X] Fastener Specifications
15. Click here for full size
16. 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 apartFailure to follow the precautions may lead to vehicle damage or personal injury.
17. Apply heat to release adhesive (1).

18. [Click here for full size](#)
19. Apply heat to release adhesive (1).
20. [Click here for full size](#)
21. Remove rear rail suspension support (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. Note:
If attaching to new parts, drill pilot holes (5.4mm) for service flow drill screws (M6) as necessary. Fastener Specifications
4. Position rear rail suspension support (1) on vehicle using 3-dimensional measuring equipment and clamp into place.
5. Remove rear rail suspension support (1) from vehicle.
6. [Click here for full size](#)
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. Note:
Only remove E-coat where adhesive will be applied.
11. Note:
Ensure all bare metal is covered.
12. Note:
Suspension support shown for clarity.
13. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
14. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
15. [Click here for full size](#)
16. Note:
Suspension support shown for clarity.
17. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
18. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

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

20. Install rear rail suspension support (1) on vehicle and clamp into place.

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

22. Note:

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

23. Install flow drill screws (1). [10X] Fastener Specifications

24. Note:

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

25. Install flow drill screws (1). [1X] Fastener Specifications

26. Remove excess adhesive.

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

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

29. Install rear window panel reinforcement. Rear Window Panel Reinforcement Replacement

30. Install load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side

31. Install rear compartment panel frame. Rear Compartment Panel Frame Replacement

32. Install all related panels and components.

33. Enable the SIR System. SIR Disabling and Enabling