

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

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 rear rail suspension support is cast aluminum. 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 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
11. Remove load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Right Side
12. Remove rear window panel reinforcement. Rear Window Panel Reinforcement Replacement
13. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
14. [Click here for full size](#)
15. Remove flow drill screws (1). [9X] Fastener Specifications
16. [Click here for full size](#)
17. Remove flow drill screws (1). [1X] Fastener Specifications
18. [Click here for full size](#)
19. **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 200Â°C (392Â°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.

20. Apply heat to release adhesive (1).
21. [Click here for full size](#)
22. Apply heat to release adhesive (1).
23. [Click here for full size](#)
24. Apply heat to release adhesive (1).
25. [Click here for full size](#)
26. Apply heat to release adhesive (1).
27. [Click here for full size](#)
28. Remove rear rail suspension support (1) from vehicle.
29. Note:

Do not damage body structure when removing adhesive.

30. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)
2. Note:

Temporarily install replacement part.

3. Position rear rail suspension support (1) on vehicle using 3-dimensional measuring equipment and clamp into place.
4. Remove rear rail suspension support (1) from vehicle.
5. [Click here for full size](#)
6. Note:

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

7. Note:

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

8. Note:

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

9. Note:

Only remove E-coat where adhesive will be applied.

10. Note:

Ensure all bare metal is covered.

11. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations.
Aluminum Panel Bonding
12. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
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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 rear rail suspension support (1) on vehicle 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). [9X] 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). [1X] 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 rear window panel reinforcement. Rear Window Panel Reinforcement Replacement
34. Install load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Left Side
35. Install load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Right Side
36. Install rear compartment panel frame. Rear Compartment Panel Frame Replacement
37. Install all related panels and components.
38. Enable the SIR System. SIR Disabling and Enabling