

2022 CHEVROLET CORVETTE SERVICE MANUAL

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1. **Body Repair**
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Rear Seat Back Body Panel Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 16X) 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 rear seat back body panel contains stamped 5000 series 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 the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
10. [Click here for full size](#)
11. **Note:**

Drill through first layer only as shown.
12. **Note:**

Remove laser weld through top layer only using belt sander or equivalent tool.
13. Remove spot welds (1). [5X] Fastener Specifications
14. Remove laser welds (2). [3X]
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 apart

Failure 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. Note:

Excessive prying force may damage surrounding structure.

20. Remove rear seat back body panel assembly (1) from vehicle.

21. Note:

Do not damage body structure when removing adhesive.

22. Remove remaining adhesive from body structure.

Installation Procedure

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

2. Note:

Temporarily install new rear seat back body panel assembly.

3. Position and clamp rear seat back body panel assembly (1) on vehicle.

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

5. Note:

Structural blind rivets and structural adhesive will replace laser welds.

6. Drill 6.7 mm holes (1) for structural blind rivets. [11X] Fastener Specifications

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

8. Drill 6.7 mm holes (1) for structural blind rivets. [5X] Fastener Specifications

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

10. Remove rear seat back body panel assembly.

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

12. Note:

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

13. Note:

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

14. Note:

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

15. Note:

Only remove E-coat where adhesive will be applied.

16. Note:

Ensure all bare metal is covered.

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. Position rear seat back body panel (1) on vehicle.

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

Install rivets from direction shown.

23. Install structural blind rivets (1). [SR2 11X] Fastener Specifications

24. [Click here for full size](#)
25. Note:

Install rivets from direction shown.

26. Install structural blind rivets (1). [SR2 5X] Fastener Specifications
27. Remove excess adhesive.
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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