

# 2022 CHEVROLET CORVETTE SERVICE MANUAL

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## Rear Window Panel Reinforcement Replacement (Convertible)

### Materials

- Structural Adhesive Aluminum Panel Bonding
- Countersunk Structural Blind Rivet (CR1 2X) Fastener Specifications
- Countersink Cutting Tool 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 rear window panel reinforcement is 5000 series aluminum sheet. Aluminum
6. Note:  
  
Left shown, right similar.
7. Note:  
  
Three dimensional measuring equipment required for installation.
8. Disable the SIR system. SIR Disabling and Enabling
9. Remove all related panels and components.
10. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
11. [Click here for full size](#)
12. Remove flow drill screws (1). [6X] Fastener Specifications
13. Note:  
  
Record the number and location of spot welds for installation of structural rivets.
14. Note:  
  
Do not damage or cut attaching panels and reinforcements.
15. Remove spot welds (1). [2X] Fastener Specifications
16. [Click here for full size](#)
17. 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.

18. Apply heat to release adhesive (1).
19. [Click here for full size](#)
20. Remove upper part of rear window panel reinforcement (1) from vehicle.
21. [Click here for full size](#)
22. Note:

Do not damage body structure when removing adhesive.

23. Using reciprocating saw or equivalent tool cut through rear window panel reinforcement extrusion at marked locations (1).
24. Remove mid-section of rear window panel reinforcement (2).
25. [Click here for full size](#)
26. Note:

Do not damage body structure when removing adhesive.

27. Using reciprocating saw or equivalent tool cut through rear window panel reinforcement extrusion at marked locations (1).
28. Remove section of rear window panel reinforcement (2).
29. Note:

Do not damage body structure when removing adhesive.

30. Remove remaining adhesive from body structure.
31. [Click here for full size](#)
32. Apply heat to release adhesive (1).
33. [Click here for full size](#)
34. Remove section of rear window panel reinforcement (1).
35. [Click here for full size](#)
36. Note:

Do not damage body structure when removing adhesive.

37. Using reciprocating saw or equivalent tool cut through rear window panel reinforcement extrusion at marked locations (1).
38. Remove section of rear window panel reinforcement (2).
39. [Click here for full size](#)
40. Apply heat to release adhesive (1).
41. Remove sections of rear window panel reinforcement brace plate (2).
42. [Click here for full size](#)
43. Apply heat to release adhesive (1).
44. [Click here for full size](#)
45. Remove remaining section of rear window panel reinforcement extrusion (1).
46. Note:

Do not damage body structure when removing adhesive.

47. Remove remaining adhesive from body structure.

## Installation Procedure

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

Temporarily install replacement part.

3. Position rear window panel reinforcement (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. If attaching to new back body pillar lower reinforcement, drill 5.4 mm pilot holes (1) for service flow drill screws. [4X] Fastener Specifications

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

9. Note:

Prepare rivet holes for countersunk structural rivet.

10. Using countersink cutting tool, countersink the surface of the holes (2). [2X] Special Tools

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

12. Remove rear window panel reinforcement (1) from vehicle.

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

14. Note:

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

15. Note:

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

16. Note:

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

17. Note:

Only remove E-coat where adhesive will be applied.

18. Note:

Ensure all bare metal is covered.

19. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

20. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

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

22. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding

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

24. Install rear window panel reinforcement (1) on vehicle and clamp into place.

24. Install rear window panel reinforcement (1) on vehicle and clamp into place.

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

26. Note:

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

27. Install flow drill screws (1). [4X] Fastener Specifications

28. Note:

Install fasteners from direction shown.

29. Install countersunk structural rivet (2). [CR1 2X] Fastener Specifications

30. Remove excess adhesive.

31. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair

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

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

34. Install all related panels and components.

35. Enable the SIR System. SIR Disabling and Enabling

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