

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Rear Window Panel Reinforcement Replacement (Coupe)

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR1 5X) Fastener Specifications
- Structural Rivet (SR3 3X) 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 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 rear rail suspension support. Rear Rail Replacement
11. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair
12. Click here for full size
13. Remove flow drill screws (1). [15X] Fastener Specifications
14. Remove cross bar bolt (2). [1X] Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side
15. Note:

Record the number and location of spot welds for installation of structural rivets.
16. Note:

Do not damage or cut attaching panels and reinforcements.

17. Remove spot welds (1). [8X] 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 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.

20. Apply heat to release adhesive (1).

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

22. Remove upper part of rear window panel reinforcement (1) from vehicle.

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

24. Note:

Record the number and location of spot welds for installation of structural rivets.

25. Note:

Do not damage or cut attaching panels and reinforcements.

26. Remove spot welds (1). [3X] Fastener Specifications

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

28. Note:

Do not damage or cut attaching panels and reinforcements.

29. Using cutoff wheel or equivalent tool cut through rear window panel reinforcement at marked locations (1).

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

31. Apply heat to release adhesive (1).

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

33. Remove lower part of rear window panel reinforcement (1) from vehicle.

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

35. Note:

Do not damage or cut attaching panels and reinforcements.

36. Using cutoff wheel or equivalent tool cut through rear window panel reinforcement at marked locations (1).

37. Remove inner part of rear window panel reinforcement (1) from vehicle.

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

39. Apply heat to release adhesive (1).

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

41. Remove remaining rear window panel reinforcement (1) from vehicle.

42. Note:

Do not damage body structure when removing adhesive.

43. 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. Drill 6.7 mm (17/64) holes (1) for structural blind rivet. [8X] Fastener Specifications

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

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

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

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

12. Note:

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

13. Note:

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

14. Note:

Only remove E-coat where adhesive will be applied.

15. Note:

Ensure all bare metal is covered.

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

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

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

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

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

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

22. Install flow drill screws (1). [12X] Fastener Specifications

23. Install cross bar bolt (2). [1X] Load Floor Panel Rear Cross Bar Replacement - Left Side or Load Floor Panel Rear Cross Bar Replacement - Right Side

24. Note:

Install fasteners from direction shown.

25. Install structural rivet (3). [SR1 5X] Fastener Specifications

26. Install structural rivet (4). [SR3 3X] Fastener Specifications

27. Remove excess adhesive.
28. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair
29. Install rear rail suspension support. Rear Rail Replacement
30. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
31. Seal tops of countersunk rivets before applying windshield adhesive.
32. Paint the repaired area. Basecoat/Clearcoat Paint Systems
33. Install all related panels and components.
34. Enable the SIR System. SIR Disabling and Enabling

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