

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Rocker Inner Panel Reinforcement Replacement

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:

Three dimensional measuring equipment required for installation.
6. Note:

The rocker inner panel reinforcement is 6000 series aluminum. Aluminum
7. Note:

Left shown, right similar.
8. Disable the SIR system. SIR Disabling and Enabling.
9. Remove all related panels and components.
10. Remove side door opening frame Side Door Opening Frame Replacement
11. Remove body lock pillar lower reinforcement Body Lock Pillar Lower 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). [3X] Fastener Specifications
15. Click here for full size
16. Remove flow drill screws (1). [4X] Fastener Specifications
17. Click here for full size
18. 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.

19. Apply heat to release adhesive (1).
20. [Click here for full size](#)
21. Apply heat to release adhesive (1).
22. [Click here for full size](#)
23. Apply heat to release adhesive (1).
24. [Click here for full size](#)
25. Remove rocker inner panel reinforcement (1) from vehicle.
26. Note:
Do not damage body structure when removing adhesive.
27. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)
2. Note:
Temporarily install replacement part.
3. Position rocker inner panel reinforcement (1) on vehicle using three-dimensional measuring equipment and clamp into place
4. Remove rocker inner panel reinforcement (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
13. [Click here for full size](#)
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. Install rocker inner panel reinforcement (1) on vehicle using three-dimensional measuring equipment and clamp into place

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

18. Note:

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

19. Install flow drill screws (1). [3X] Fastener Specifications

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). [4X] Fastener Specifications

23. Remove excess adhesive.

24. Remove body lock pillar lower reinforcement Body Lock Pillar Lower Reinforcement Replacement

25. Remove side door opening frame Side Door Opening Frame Replacement

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

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

28. Install all related panels and components.

29. Enable the SIR System. SIR Disabling and Enabling

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