

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
2. **Collision Repair**
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Rocker Outer Panel Reinforcement Replacement - Rear

Materials

- Structure Adhesive Aluminum Panel Bonding
- Structure Rivet (SR3 2X) 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:

3 Dimensional fixturing equipment required for installation.
6. Note:

The rocker outer panel reinforcement is 6000 series stamped aluminum sheet. 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 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). [10X] Fastener Specifications
13. [Click here for full size](#)
14. Note:

Drill through top layer only.
15. Note:

Record the number and location of spot welds for installation of structural rivets.
16. Remove spot welds (1). [2X]
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 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.

19. Apply heat to release adhesive (1).

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

21. Note:

Excessive prying force may damage surrounding structure.

22. Remove rocker outer panel reinforcement (1).

23. Note:

Do not damage body structure when removing adhesive.

24. Remove remaining adhesive from mating surfaces on body structure.

Installation Procedure

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

2. Note:

Temporarily install replacement part.

3. Position rocker outer panel reinforcement (1) on vehicle using three-dimensional measuring equipment and clamp into place.

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

5. Note:

6.7 mm (17/64") hole used for rivet installation.

6. Drill 6.7 mm (17/64") holes (1). [2X]

7. Remove rocker outer panel reinforcement (1).

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

9. Note:

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

10. Note:

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

11. Note:

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

12. Note:

Only remove E-coat where adhesive will be applied.

13. Note:

Ensure all bare metal is covered.

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

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

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

17. Install rocker outer panel reinforcement (1).

18. [Click here for full size](#)
19. Install structural rivets (SR3). [2X] 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. [10X] Fastener Specifications
23. Remove excess adhesive.
24. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair
25. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
26. Paint the repaired area. Basecoat/Clearcoat Paint Systems.
27. Install all related panels and components.
28. Enable the SIR System. SIR Disabling and Enabling.

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