

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Rocker Panel Replacement (Assembly)

Materials

- Structural Adhesive Aluminum Panel Bonding
- Countersunk Structural Rivet (CR1 5X) Fastener Specifications
- Countersunk Structural Rivet (CR2 1X) 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 rocker panel is a 7000 series aluminum extrusion. Aluminum

6. **Note:**

Three dimensional fixturing equipment required for installation.

7. **Note:**

Left shown, right similar.

8. Disable the SIR system. SIR Disabling and Enabling

9. Remove all related panels and components.

10. 7 Remove side door opening frame. Side Door Opening Frame Replacement

11. 6 Remove body hinge pillar outer panel reinforcement. Body Hinge Pillar Outer Panel Reinforcement Replacement

12. 5 Remove front inner hinge pillar body. Front Inner Hinge Pillar Body Replacement

13. 4 Remove rocker outer panel reinforcement rear. Rocker Outer Panel Reinforcement Replacement - Rear

14. 3 Remove body lock pillar outer panel. Body Lock Pillar Outer Panel Replacement

15. 2 Remove body lock pillar inner panel. Body Lock Pillar Lower Reinforcement Replacement

16. 1 Remove rocker inner panel reinforcement. Rocker Inner Panel Reinforcement Replacement

17. Remove the sealers and anti-corrosion materials from the repair area as necessary. Anti-Corrosion Treatment and Repair

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

19. Remove flow drill screws (1). [4X] Fastener Specifications

20. [Click here for full size](#)
21. Remove flow drill screws (1). [6X] Fastener Specifications
22. [Click here for full size](#)
23. Remove flow drill screws (1). [8X] Fastener Specifications
24. [Click here for full size](#)
25. Remove flow drill screws (1). [4X] Fastener Specifications
26. [Click here for full size](#)
27. Note:

Drill through top layer only.

28. Remove spot welds (1). [2X] Fastener Specifications
29. [Click here for full size](#)
30. Note:

Drill through top layer only.

31. Remove spot welds (1). [3X] Fastener Specifications
32. Note:

Drill through top layer only.

33. Drill through spot weld (2) using 6.7 mm (17/64") drill bit. [1X] Fastener Specifications
34. [Click here for full size](#)
35. 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.

36. Note:

Excessive prying force may damage surrounding structure.

37. Apply heat to release adhesive (1).
38. [Click here for full size](#)
39. Locate cut lines (1) and cut completely through rocker panel.
40. Remove rocker mid-section (2).
41. [Click here for full size](#)
42. Locate cut line (1) and cut completely through rocker panel.
43. Locate cut lines (2) and cut through rocker panel to first cut (1).
44. Remove outer rocker section (3).
45. [Click here for full size](#)
46. 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.

47. Note:

Excessive prying force may damage surrounding structure.

48. Apply heat to release adhesive (1).

49. Remove middle rocker panel section (2).

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

51. Note:

Excessive prying force may damage surrounding structure.

52. Locate cut lines (1) and cut through rocker panel.

53. Apply heat to release adhesive (2).

54. Remove rocker panel outer section (3).

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

56. Note:

Excessive prying force may damage surrounding structure.

57. Apply heat to release adhesive (1).

58. Remove rocker panel outer section (2).

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

60. Note:

Excessive prying force may damage surrounding structure.

61. Locate cut lines (1) and cut through rocker panel.

62. Remove rocker panel outer section (2).

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

64. Note:

Excessive prying force may damage surrounding structure.

65. Apply heat (1) to release adhesive

66. Remove rocker panel front section assembly (2).

67. Note:

Do not damage body structure when removing adhesive.

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

Installation Procedure

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

2. Note:

Temporarily install new rocker panel assembly.

3. Position rocker panel assembly (1) on vehicle using three dimensional fixturing equipment.

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

5. Note:

Drill pilot holes at locations of clearance holes.

6. Drill 4 mm (5/32") pilot holes (1) for flow drill screws if attaching. [6X] Fastener Specifications

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

8. Note:

Drill pilot holes at locations of clearance holes.

9. Drill 4 mm (5/32") pilot holes (1) for flow drill screws. [8X] Fastener Specifications

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

11. Drill 4 mm (5/32") pilot holes (1) for flow drill screws. [8X] Fastener Specifications

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

13. Drill 4 mm pilot holes (1) for flow drill screws. [4X]

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

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

16. Drill 6.7 mm holes (1) for structural blind rivets. [4X] Fastener Specifications

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

18. Note:

Prepare rivet hole for countersunk structural rivets.

19. Using countersink cutting tool, countersink holes (1). [6X] Special Tools

20. Remove rocker panel assembly.

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

22. Note:

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

23. Note:

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

24. Note:

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

25. Note:

Only remove E-coat where adhesive will be applied.

26. Note:

Ensure all bare metal is covered.

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

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

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

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

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

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

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

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

recommendations. Aluminum Panel Bonding

35. [Click here for full size](#)
36. Position rocker panel assembly (1) on vehicle using three dimensional fixturing equipment.
37. [Click here for full size](#)
38. Install countersunk structural blind rivets (1). [CR1 5X] Fastener Specifications
39. Install countersunk structural blind rivets (2). [CR2 1X] Fastener Specifications
40. [Click here for full size](#)
41. Note:

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

42. Install flow drill screws. [6X] Fastener Specifications
43. [Click here for full size](#)
44. Install flow drill screws. [4X] Fastener Specifications
45. [Click here for full size](#)
46. Install flow drill screws. [4X] Fastener Specifications
47. [Click here for full size](#)
48. Install flow drill screws. [8X] Fastener Specifications
49. Remove excess adhesive.
50. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
51. Seal countersunk and structural rivets with seam sealer. Anti-Corrosion Treatment and Repair
52. Paint the repaired area. Basecoat/Clearcoat Paint Systems
53. Install rocker inner panel reinforcement. Rocker Inner Panel Reinforcement Replacement
54. Install body lock pillar inner panel. Body Lock Pillar Lower Reinforcement Replacement
55. Install body lock pillar outer panel. Body Lock Pillar Outer Panel Replacement
56. Install rocker outer panel reinforcement rear. Rocker Outer Panel Reinforcement Replacement - Rear
57. Install front inner hinge pillar body. Front Inner Hinge Pillar Body Replacement
58. Install body hinge pillar outer panel reinforcement. Body Hinge Pillar Outer Panel Reinforcement Replacement
59. Install side door opening frame. Side Door Opening Frame Replacement
60. Install all related panels and components.
61. Enable the SIR System. SIR Disabling and Enabling