

2022 CHEVROLET CORVETTE SERVICE MANUAL

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Roof Front Header Panel Replacement

Materials

- Structural Adhesive Aluminum Panel Bonding
- Structural Rivet (SR2 2X) Fastener Specifications
- Structural Rivet (CR1 2X) Fastener Specifications
- Structural Rivet (CR2 6X) Fastener Specifications
- Structural Rivet (CR3 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:

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

The roof front header panel assembly contains stamped 6000 series aluminum. Aluminum
7. Disable the SIR system. [SIR Disabling and Enabling](#)
8. Remove all related panels and components.
9. Remove the sealers and anti-corrosion materials from the repair area as necessary. [Anti-Corrosion Treatment and Repair](#)
10. [Click here for full size](#)
11. Note:

Drill through top two layers only as shown.
12. Remove spot welds (1). [\[6X\] Fastener Specifications](#)
13. [Click here for full size](#)
14. Note:

Drill through first layer only as shown.
15. Remove spot welds (1). [\[6X\] 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 roof front header panel assembly (1) from vehicle.
21. Note:

Do not damage body structure when removing adhesive.

22. Remove remaining adhesive from body structure.

Installation Procedure

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

Temporarily install replacement part.

3. Position roof front header panel assembly (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 used for structural 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). [12X] Fastener Specifications
8. [Click here for full size](#)
9. Note:

Prepare rivet holes for countersunk structural rivets.

10. Using countersink cutting tool, countersink rivet holes (1). [10x]
11. [Click here for full size](#)
12. Remove roof front header panel assembly (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. Install roof front header panel assembly (1) on vehicle and clamp into place.
23. [Click here for full size](#)
24. Note:

Install structural rivets from direction shown.

25. Install countersunk structural blind rivets (1). [CR1 2X] Fastener Specifications
26. Install countersunk structural blind rivets (1). [CR2 6x] Fastener Specifications
27. Install countersunk structural blind rivets (1). [CR3 2X] Fastener Specifications
28. [Click here for full size](#)
29. Note:

Install structural rivets from direction shown.

30. Install structural blind rivets (1). [SR2 2X] Fastener Specifications
31. Remove excess adhesive.
32. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
33. Seal tops of countersunk rivets before applying windshield adhesive.
34. Paint the repaired area. Basecoat/Clearcoat Paint Systems
35. Install all related panels and components.
36. Enable the SIR System. SIR Disabling and Enabling