

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
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Underbody Center Cross Sill Reinforcement Replacement

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 underbody center cross sill reinforcement is 5000 series stamped aluminum sheet. Aluminum
6. Note:

Three dimensional measuring 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. Remove left load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Left Side
11. Remove right load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Right Side
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. Note:

Record the number, location and length of aluminum MIG welds for installation.
15. Note:

Do not damage body structure when removing adhesive.
16. Remove MIG welds (1) from underbody center cross sill reinforcement using a cut off wheel or equivalent tool. [2X]
17. Click here for full size
18. Note:

Record the number, location and length of aluminum MIG welds for installation.
19. Note:

Do not damage body structure when removing adhesive.
20. Remove MIG welds (1) from underbody center cross sill reinforcement using a cut off wheel or equivalent tool. [1X]

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

Record the number, location and length of aluminum MIG welds for installation.

23. Note:

Do not damage body structure when removing adhesive.

24. Remove MIG welds (1) from underbody center cross sill reinforcement using a cut off wheel or equivalent tool. [3X]
25. [Click here for full size](#)
26. Remove underbody center cross sill reinforcement (1) from vehicle.

Installation Procedure

1. [Click here for full size](#)
2. Clean and prepare all welded mating surfaces.
3. Install underbody center cross sill reinforcement (1) on vehicle using three-dimensional measuring equipment and clamp into place.
4. [Click here for full size](#)
5. Note:

Duplicate the number, location and length of aluminum MIG welds as noted in removal.

6. Install MIG welds (1) using Pulse MIG welder. [2X]
7. [Click here for full size](#)
8. Note:

Duplicate the number, location and length of aluminum MIG welds as noted in removal.

9. Install MIG welds (1) using Pulse MIG welder. [1X]
10. [Click here for full size](#)
11. Note:

Duplicate the number, location and length of aluminum MIG welds as noted in removal.

12. Install MIG welds (1) using Pulse MIG welder. [3X]
13. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
14. Paint the repaired area. Basecoat/Clearcoat Paint Systems
15. Install left load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Left Side
16. Install right load floor panel rear cross bar. Load Floor Panel Rear Cross Bar Replacement - Right Side
17. Install all related panels and components.
18. Enable the SIR System. SIR Disabling and Enabling