

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

1. **Body Repair**
2. **Collision Repair**
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Underbody Rear Brace Bracket Replacement

Materials

- Structural 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:

The underbody rear brace is 6000 series aluminum sheet. Aluminum
6. Note:

Left shown, right similar.
7. Note:

Three dimensional measuring equipment required for installation.
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). [3X] Fastener Specifications
13. Click here for full size
14. Remove flow drill screws (1). [2X] Fastener Specifications
15. Click here for full size
16. 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.

17. Apply heat to release adhesive (1).
18. [Click here for full size](#)
19. Apply heat to release adhesive (1).
20. [Click here for full size](#)
21. Remove underbody rear brace (1) from vehicle.
22. Note:
Do not damage body structure when removing adhesive.
23. Remove remaining adhesive from body structure.

Installation Procedure

1. [Click here for full size](#)
2. Note:
Temporarily install replacement part.
3. Position underbody rear brace (1) on vehicle using three-dimensional measuring equipment and clamp into place.
4. [Click here for full size](#)
5. Note:
Production flow drill screws may be reused if original screw holes are present in attaching components.
6. If attaching to new components, drill 5.4 mm pilot holes (1) for service flow drill screws (M6). [3X]
7. [Click here for full size](#)
8. Drill 5.4 mm pilot holes (1) for service flow drill screws (M6). [2X] Fastener Specifications
9. [Click here for full size](#)
10. Remove underbody rear brace (1) from vehicle.
11. [Click here for full size](#)
12. Note:
Accurate and timely assembly methods must be used in order to meet proper bonding requirements.
13. Note:
Dry fit all parts with proper clamping devices prior to final assembly to ensure full understanding of the assembly process.
14. Note:
When using adhesive, ensure all necessary tools and materials are in place prior to final assembly.
15. Note:
Only remove E-coat where adhesive will be applied.
16. Note:
Ensure all bare metal is covered.
17. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
18. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
19. [Click here for full size](#)
20. Position underbody rear brace (1) on vehicle and clamp into place.

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

22. Note:

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

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

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

25. Note:

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

26. Install flow drill screws (1). [2X] Fastener Specifications

27. Remove excess adhesive.

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

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

30. Install all related panels and components.

31. Enable the SIR System. SIR Disabling and Enabling

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