

2022 CHEVROLET CORVETTE SERVICE MANUAL

- **SEARCH**

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

Underbody Side Rail Rear Extension Replacement

Materials

- Structure 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 side rail rear extension is 6000 series stamped aluminum sheet. Aluminum
6. Note:

Left shown, right similar.
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. Remove flow drill screws (2). [7X] Fastener Specifications
12. Click here for full size
13. 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 apartFailure to follow the precautions may lead to vehicle damage or personal injury.
14. Apply heat to release adhesive (1).
15. Click here for full size
16. Remove underbody side rail rear extension (1) from vehicle.
17. Note:

Do not damage body structure when removing adhesive.

18. Remove remaining adhesive from body structure.

Installation Procedure

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

Temporarily install replacement part.

3. Position underbody side rail rear extension (1) on vehicle using 3-dimensional measuring equipment and clamp into place.
4. Remove underbody side rail rear extension (1) from vehicle.
5. [Click here for full size](#)
6. Note:

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

7. Note:

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

8. Note:

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

9. Note:

Only remove E-coat where adhesive will be applied.

10. Note:

Ensure all bare metal is covered.

11. Clean and prepare mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
12. Apply structural adhesive (1) to mating surfaces on structure and replacement part according to adhesive manufacturer's recommendations. Aluminum Panel Bonding
13. [Click here for full size](#)
14. Install underbody side rail rear extension (1) on vehicle.
15. [Click here for full size](#)
16. Note:

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

17. Install flow drill screws (2). [7X] Fastener Specifications
18. Remove excess adhesive.
19. Seal structural rivets with seam sealer. Anti-Corrosion Treatment and Repair
20. Apply the sealers and anti-corrosion materials to the repair area as necessary. Anti-Corrosion Treatment and Repair
21. Paint the repaired area. Basecoat/Clearcoat Paint Systems
22. Install all related panels and components.
23. Enable the SIR System. SIR Disabling and Enabling