



# HONDA/ACURA HEAD BOLT THREAD REPAIR FOR “B” SERIES 1.6/1.7/1.8/2.0L WITH M11X1.5 THREADS

( M11X1.5 Modified inserts. 11 are supplied in this kit)

**Note:** The inserts for these engines are modified and have the first 1/2” of thread removed from inside the insert to allow for the proper start depth of the internal thread.

**\*\*\*DO NOT RE-USE OLD HEAD BOLTS\*\*\***

*The threads on the old head bolts are often stretched out of pitch from torquing, causing them to tighten prematurely in the new inserts.*

**IMPORTANT!** Please read the “*UNIVERSAL INSTALLATION GUIDE*” provided in the kit in their entirety before proceeding. Details specific to repairing this engine regarding drilling & tapping depths along with insert installation depths are provided below.

1. When mounting the drill/tap jig, follow the instructions on pages 3&4 using the tall spacer provided (1½in. diameter x 2-5/8in. Long), with the recessed end facing upward along with one of the shorter head bolts made for the engine being repaired. If it is necessary to mount the jig to a hole that has just been repaired, make sure to use a new head bolt, otherwise an old head bolt may tighten up prematurely in the new insert since the threads of the old bolt may be stretched out of pitch.
2. Depending on the engine, some “B” series engines have a thread start depth of 57mm and some have a thread start depth of 47mm. Check the depth to the start of the threads from the deck surface before drilling to determine which “B” series engine you are repairing. All 10 holes should be the same depth.
3. Drill the holes the entire length of the original hole depths, making sure to remove all factory threads.

If the factory threads start at 57mm deep, install the inserts 42mm deep from the deck surface to the top of the insert. To accomplish this, thread the holes about 86mm deep. It may be necessary to use a 11mm-12point socket to drive the tap to the correct depth.

If the factory threads start at 47mm deep, install the inserts 34mm deep. To accomplish this, thread the holes about 78mm deep (see page 4, figure 4 of the Installation Guide).

*Note: This kit is universal for many other engines as well since the outside thread size of the insert does not change. Inserts are also available with internal threads of M10x1.25, M10x1.5, M11x1.25, M12X1.25, M12X1.5, M12X1.75 and 7/16-14.*