



97-2017 HONDA/ACURA 3.0/3.2/3.5/3.7L V6 SOHC 24V HEAD BOLT THREAD REPAIR WITH M12X1.5 THREADS.

FITS ENGINE CODES:

J30A, J32A, J35A, J37A, J35Y, J35Z, JNA1

Caution: There are two different variations of head bolts available for these engines, both of which are the same length (163mm). One variation is a 6 point bolt with a thread length of about 1½” (37mm), and the other is a 12 point bolt with thread length of 3” (78mm). The 12 point bolts with a thread length of 3” must be used with this repair. If you try to use the 6 point bolts with shorter threads, you will run out of threads at assembly since the inserts are installed shallower than the original threads which will give you more thread engagement for maximum strength. The torque specs for the 12 point version should be used with this repair.

17 M12x1.5 inserts are supplied in this kit (Requires 16 for this application)

*****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 2.62in. Long). The recessed end of the tall spacer should be facing upward. If it is necessary to mount the jig to a hole that has just been repaired, make sure to use a new head bolt. Old head bolts may be stretched out of pitch causing them to tighten prematurely in the new insert.

Note: This engine may require the larger diameter alignment pin which will be used with the tap bushing to align the jig over the hole being repaired since the recessed hole above the threads is larger than the drill bushing in some engines. Replace the tap bushing with the drill bushing after aligning the jig before drilling.

2. Drill the holes the total depth of the original holes, making sure to remove all factory threads. One hole will be 10mm shallower than the other seven in each bank. This hole will be an upper row end hole in each bank and will be at opposite ends of the block from each other.
3. The inserts are to be installed 1¼ inch (32mm) deep below the deck surface. To accomplish this, you will need to thread the holes about 3 inches (76mm) deep from the deck surface (see page 4, figure 4 of the Installation Guide). It will not be a problem if you are only able to install the insert 1 inch (25mm) deep in the single shallower hole in each bank

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, M11x1.5, M11x2.0, M12x1.75 and 7/16-14