



# HONDA/ACURA “K” SERIES DOHC M11X1.5 HEAD BOLT THREAD REPAIR:

FITS:

2002-2012 Honda/Acura

(Head bolts have a critical length of 152mm)

**K20A2, K20A3, K20Z1, K20Z3, K23A1,  
K24A1, K24 A2, K24A4, K24A8, K24Z1**

2006-2015 Honda/Acura

(Head bolts have a critical length of 182mm)

**K24Z2, K24Z3, K24Z6, K24Z7,  
K24W1, K24W9, K24Y2**

This repair is designed to be used with OEM head bolts specific for your engine type or ARP® head stud kit #208-4701. ARP® stud kit #208-4701 will work with the NS300L™ kit on all “K” series engines as long as the inserts are installed 1.44” (36mm) as specified in step 3.

11 M11x1.5 Modified inserts are supplied in this kit (Requires 10 for this application)

**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.

**\*\*\* 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.*

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) with the recessed end 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.
2. Drill the holes the entire length of the original hole depths (aprox. 4½” or 114mm), making sure to remove all factory threads.
3. The inserts are to be installed about 1.44” (36mm) deep below the deck surface on all “K” series blocks (see page 4, figure 4 of the Installation Guide). To accomplish this, you will need to thread the holes about 3¼ ” (82mm), deep from the deck surface. **Go 6ft lbs less than the factory torque specifications on the first pass on engines that require the head bolts with a critical length of 182mm since the inserts are installed approximately 1¼ in. shallower than the factory threads in these engines. This does not apply to engines requiring head bolt with a critical length of 152mm or when ARP® head studs are used.**

*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 M10x1.5, M10x1.25, M11x1.25, M11x2.0, M12x1.5, M12x1.75 and 7/16-14. If your thread size is not listed, please contact us at 717-880-1888.*