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2006 & Newer KIA/HYUNDAI 3.3/3.5/3.8L DOHC V6 M11X1.5 HEAD BOLT THREAD REPAIR

17 inserts are supplied in this kit (16 are required for this application)

IMPORTANT! **Please read the "*UNIVERSAL INSTALLATION GUIDE*" provided in the kit in their entirety before proceeding. Details specific to repairing these engines 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 short spacer provided (1½in. diameter x 1.25in. Long). 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 bolt may be stretched out of pitch.**

2. **Drill the holes 3¼" (83mm) deep from the deck surface which is approximately the total depths of the original holes.**

3. **The inserts are to be installed ¾ - 1 in. (19mm-25mm) deep from the deck surface (see page 4, figure 4). To accomplish this, you will need to thread the holes about 2 ½ in. to 2 ¾ in. deep of full threads from the deck surface using the Three Flute Spiral Point Tap. If you are marking the tap for depth, add about ¼ inch to allow for the tapered end of the tap since the tapered end will not create a full thread. Always make sure that the inserts will thread in to the proper depth before adding Thread Lock. Then remove the insert, add the Thread Lock and reinstall the insert to the proper depth.**
   Note: ***The Four Flute Bottom Tap will not be used for this application since the Three Flute Spiral Point tap is long enough to thread the holes to the proper depth.***

   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, M11X2.0, M12X1.25, M12x1.5, M12X1.75 and 7/16-14.