



99-02 OLDSMOBILE 3.5L LX5 V6 ENGINE M11X1.5 HEAD BOLT THREAD REPAIR

*17 M11x1.5 Modified inserts are supplied in this kit (Requires 16 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). The recessed end of the tall spacer should be facing upward for the lower bank holes and downward for the upper bank holes. 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. 3¾”- 4” or 95mm – 102mm upper and lower holes), making sure to remove all factory threads.
3. The upper bank inserts are to be installed about 1 inch (25.4mm) deep below the deck surface. To accomplish this, you will need to thread the upper bank holes about 2¾ inches (70mm), deep from the deck surface (see page 4, figure 4 of the Installation Guide).  
The lower bank holes are to be installed 1½ inches (38mm) minimum below the deck surface (see page 4, figure 4 of the Installation Guide). To accomplish this, you will need to thread the lower bank holes about 3¼ inches (83mm) minimum, deep from the deck surface.

*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*