



## 2001-2005 HONDA/ACURA 1.7L D17A ENGINE M10x1.25 HEAD BOLT THREAD REPAIR

(Factory head bolts for this engine should be 140mm long)

( M10X1.25 Modified inserts. 11 are supplied in this kit)

**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.

**\*\*\**WE RECOMMEND NOT USING AFTERMARKET HEAD BOLTS OR RE-USING OLD ONES*\*\*\***

*The threads on the old head bolts are often stretched out of pitch from torquing, causing them to tighten prematurely in the new inserts. Aftermarket head bolts are often not tempered correctly and or the threads are not formed correctly, causing them to bind in the inserts.*

1. The D17A engine has two different depth of holes which require the inserts to also be installed at two different depths. 9 holes are the same depth and 1 hole has a thread start depth which is about 1/2” deeper than the other 9. The odd hole is typically the corner hole on the intake side, timing pulley end of the block. When mounting the drill/tap jig, follow the instructions on pages 3&4 using the spacers provided along with a factory head bolt. Use the tall spacer with the recessed end facing upward when mounting the jig using one of the 9 holes of the same depth and the short spacer when mounting the jig using the single deeper hole. 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. Drill the holes the entire length of the original hole depths, making sure to remove all factory threads. Failure to do so may cause the head bolt to stub on the old threads as they protrude through the bottom of the insert, causing the head bolt to tighten prematurely before reaching their final depth.
3. Install the 9 inserts of the same depth to 1-1/8” (28mm) deep from the deck surface to the top of the insert. (see page 4, figure 4 of the Installation Guide), and for the single deeper hole, install the insert 1-1/2” (38mm) deep. To accomplish this, you will need to thread the holes about 2-7/8” (73mm) for 9 holes and 3-1/4” (83mm) for the single odd hole.

*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, M11x1.25, M11x1.5, M11x2.0, M12x1.25, M12x1.5, M12x1.75 and 7/16-14.*