REPAIRS:

THIS KIT WILL REPAIR M11x1.5 THREADS THAT START 41mm & 60mm FROM THE TOP OF THE BLOCK.

TIME-SERT®

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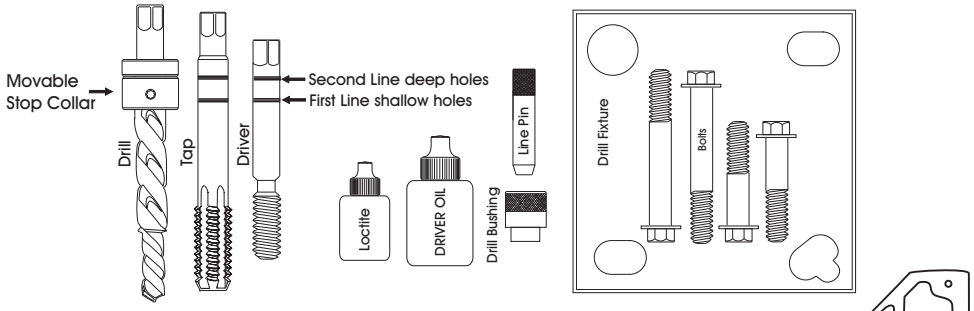
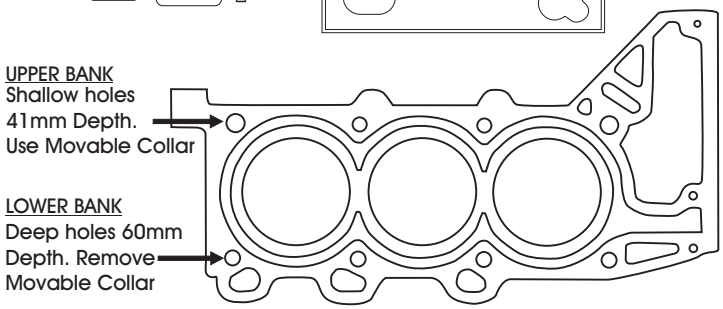
M11x1.5 HEAD BOLT PREMIUM V6 "PV6" THREAD REPAIR P/N 6001



Tools needed:	Part no.
Drill fixture	56111
Drill bushing	J-42385-302
Line Pin	J-42385-303
Bolts Long (2)	J-42385-604
Bolt short (2)	J-42385-503
Step drill	J-42385-601
Tap	J-42385-602
Insert driver	J-42385-603
Movable Collar	J-42385-605
Inserts (Qty 8)	11155
loctite	6020
Driver oil	6010



- WARNING -

Cutting tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.

CUTTING FLUID

A Cutting fluid is necessary for drilling and tapping. (WD40)

DRILL MOTOR

The use of a half inch drill motor is recommended for drilling.

INSTRUCTIONS

FOR THE REPAIR OF THE (4) 41mm UPPER BANK SHALLOW HOLE, USE THE MOVABLE STOP COLLAR ON THE DRILL AND STOP AT THE FIRST LINE ON THE TAP AND DRIVER.

FOR THE REPAIR OF THE (4) 60mm LOWER BANK DEEP HOLES, REMOVE THE STOP COLLAR P/N J-42385-605 FROM THE DRILL AND STOP AT SECOND LINE OF THE TAP AND DRIVER

STEP 1

PLACE LARGEST HOLE IN DRILL FIXTURE OVER THE HOLE TO BE REPAIRED. PLACE DRILL BUSHING IN FIXTURE THEN PLACE LINE PIN IN BUSHING TO ALIGN WITH DAMAGED HOLE. DO NOT FORCE LINE PIN INTO HOLE. USE BOLTS AND TIGHTEN TO SECURE FIXTURE IN PLACE. PLATE CAN BE FLIPPED OVER FOR CORRECT ALIGNMENT. REMOVE ALINEMENT PIN.

STEP 2 (USE WD40 for Drilling)

USE A SUITABLE DRILL MOTOR AND STEP DRILL THE HOLE UNTIL THE APPROPRIATE STOP COLLAR ON THE DRILL LINES UP WITH THE TOP OF THE DRILL BUSHING. THIS WILL REQUIRE REMOVING DRILL AND BUSHING SEVERAL TIMES TO CLEAR CHIPS. CLEAN OUT ALL CHIPS. WATCH CAREFULLY THAT THE CORE DRILL IS GOING STRAIGHT! THIS IS VERY IMPORTANT.

NOTE: If drill bushing turns while drilling hole, Remove drill and drill bushing, Clean out all chips.
We recommend using a long air nozzle 6" or longer to blow out all chips.

STEP 3 (USE WD40 for tapping)

TAP THROUGH THE DRILL BUSHING UNTIL THE APPROPRIATE GROOVE ON THE TAP LINES UP WITH THE TOP OF THE DRILL BUSHING. THIS WILL REQUIRE REMOVING THE TAP AND BUSHING SEVERAL TIMES TO CLEAR CHIPS. CLEAN ALL CHIPS USING BRAKE OR CONTACT CLEANER THAT WILL NOT LEAVE AN OILY RESIDUE, THE HOLE MUST BE CLEAN AND DRY. USE A FLASHLIGHT TO INSPECT THE HOLE FOR CHIPS AND CLEANLINESS.

STEP 4

REMOVE DRILL FIXTURE FOR THE FINAL STEP !

USE INSERT DRIVER OIL (DO NOT USE Wd40.)

OIL THE THREADS OF THE INSERT DRIVER. SCREW AN INSERT ONTO THE DRIVER, APPLY A SMALL AMOUNT OF LOCTITE 266 ON THE BOTTOM OUTSIDE THREADS OF THE INSERT AND SCREW THE INSERT INTO THE PREPARED HOLE. WHEN THE HEAD OF THE INSERT IS SEATED THE DRIVER WILL TIGHTEN UP, USE A LITTLE MORE POWER TO SCREW THE DRIVER THROUGH THE INSERT, UNTIL THE APPROPRIATE GROOVE OF THE DRIVER LINES UP WITH THE TOP OF THE BLOCK.
REMOVE INSERT DRIVER, REPAIR IS COMPLETE.

Check for the latest torque specifications before assembling the engine. Improper torque of the head can lead to thread failure.