



# FORD, LINCOLN, MERCURY, MAZDA V6 2.5/3.0 DOHC DURATEC M10x1.5 HEAD BOLT THREAD REPAIR

## FITS:

95 - 00 FORD CONTOUR 2.5L DOHC V6 24V, VIN CODE "L, G"  
00 - 01 MAZDA MPV 2.5L DOHC V6 24V, ENG.CODE "DURATEC"  
99 - 02 MERCURY COUGAR 2.5L DOHC V6 24V, VIN CODE "L, G"  
95 - 00 MERCURY MYSTIQUE 2.5L DOHC V6 24V, VIN CODE "L"  
01 - 12 FORD ESCAPE 3.0L DOHC V6 24V, VIN CODE "1"  
05 - 07 FORD FIVE HUNDRED 3.0L DOHC V6 24V, ENG.CODE "DURATEC"  
05 - 07 FORD FREESTYLE 3.0L DOHC V6 24V, ENG.CODE "DURATEC"  
06 - 12 FORD FUSION 3.0L DOHC V6 24V, VIN CODE "1"  
96 - 05 FORD TAURUS 3.0L DOHC V6 24V, VIN CODE "S"  
06 LINCOLN ZEPHYR 3.0L DOHC V6 24V, VIN CODE "1"  
06 MAZDA 6 3.0L DOHC V6 24V, ENG.CODE "DURATEC"  
02 - 06 MAZDA MPV 3.0L DOHC V6 24V, ENG.CODE "DURATEC"  
01 - 08 MAZDA TRIBUTE 3.0L DOHC V6 24V, ENG.CODE "DURATEC"  
05 - 09 MERCURY MARINER 3.0L DOHC V6 24V, VIN CODE "1"  
06 - 11 MERCURY MILAN 3.0L DOHC V6 24V, VIN CODE "1"  
05 - 07 MERCURY MONTEGO 3.0L DOHC V6 24V, ENG.CODE "DURATEC"  
96 - 05 MERCURY SABLE 3.0L DOHC V6 24V, VIN CODE "S"

17 M10x1.5 Modified inserts are supplied in this kit (Requires 16 for this application)

**\*\*\* 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.*

**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.

1. When mounting the drill/tap jig, follow the instructions on pages 3&4 using the tall spacer provided (1½in. diameter x 2-5/8in. Long), with the recessed end facing upward along with a head bolt made for the engine being repaired. 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 total depth of the original holes (about 3½” deep). .
3. Install inserts 1½in. (38mm) deep from the deck surface (see page 4, figure 4 of the Installation Guide). To accomplish this, you will need to thread the holes about ¾ in. 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, M11x1.25, M11x1.5, M11x2.0, M12x1.5, M12x1.75 and 7/16-14.*