



# **POLARIS M11X1.25 HEAD BOLT THREAD REPAIR. FITS: ALL POLARIS SPORTSMAN & SCRAMBLER 850 & 1000 MODELS**

10 M11x1.25x1¼” inserts 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.

1. Mount the drill/tap jig following the instructions on pages 3&4 by using one of the Polaris head bolts along with the tall pacer (recessed end of the tall spacer facing downward). See *FIGURE 1A*. (*The spacers and jig together simulate the thickness of the cylinder head*).
2. Drill the holes the entire length of the original hole depth (aprox. 4” deep).
3. Install the inserts about 2” (51mm) deep below the deck (gasket) surface. See page 4, figure 4. To accomplish this, you will need to thread the holes about ¾” (83mm) deep.

**NOTE:** If using custom studs rather than OEM head bolts, the inserts will need to be installed 2.450” (62mm) deep. This will also require our 6 inch extension tap.

*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, M11x1.5, M11X2.0, M12X1.25, M12x1.5, M12X1.75 and 7/16-14.*