



SUBARU SOHC & DOHC ENGINE M11x1.25 HEAD BOLT THREAD REPAIR

FITS:

1999-2015 1.8L THRU 2.5L EJ SOHC ENGINES:
1996-2012 2.0L THRU 2.5L EJ DOHC TURBO ENGINES

17 M11x1.25x44.5mm Modified inserts are supplied in this kit (Requires 12 for this application)
If using ARP® studs, please contact us prior to installing inserts as modified inserts may be required.

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 2.625in. Long). The recessed end should face downward for SOHC engines along with a head bolt made for the SOHC engine being repaired. The recessed end of the spacer should be facing upward for DOHC engines along with the head bolt for the DOHC engine. This is due to the SOHC and DOHC engines having different length head bolts (due to different head thicknesses). 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 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 bolts 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. The inserts are to be installed 1.500in. (38mm) deep from the deck surface (see page 4, figure 4 of the Installation Guide), regardless if it is a SOHC or DOHC engine. To accomplish this, you will need to thread the holes about ¾in. deep from the deck surface. It may be necessary to use a 11mm-12point socket to drive the tap to the correct depth.

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