



# TOYOTA/SCION 1.8L 2ZRFE ENGINE M10x1.5 HEAD BOLT THREAD REPAIR

*15 M10X1.5 inserts are supplied in this kit (requires 10)*

*Fits:*

2008 - 2014 TOYOTA/SCION 1.8L 2ZRFE DOHC

**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, which can cause 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 2-5/8in. 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 bolt may be stretched out of pitch.
2. When drilling the holes, make sure to remove all factory threads. To do so, you will need to drill approximately 3¼ in. (83 mm) deep from the deck surface. Failure to remove all original threads 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. Install inserts 1½ in. (38mm) deep from the deck surface (gasket surface-see page 4, figure 4 of the Installation Guide). To accomplish this, you will need to thread the holes about 2¾ in. (70mm) deep.

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