



## THIS KIT REPAIRS THE FOLLOWING VOLVO 4.4L DOHC ENGINES WITH M11x1.5 THREADS:

2005 - 2011 XC90 V8 4.4L 4414CC 269CU. IN. DOHC GAS NATURALLY ASPERATED

2007 -2010 S80 V8 4.4L 4414CC 269CU. IN. DOHC GAS NATURALLY ASPERATED

*(21 M11x1.5 modified 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.

**\*\*\* 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 short spacer provided (1½in. diameter x 1.25in. Long). It may be necessary to add a couple of washers to the bolt along with the short spacer if mounting the jig to a hole that has just been 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. Drill the holes the entire length of the original hole depths (aprox. 2.75” or 70mm), making sure to remove all factory threads.
3. The inserts are to be installed ½ in. (13mm) 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 2¼ in. to 2½ 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, M10x1.5, M11x1.25, M11x2.0 M12x1.5, M12x1.75 and 7/16-14.*