



# **BMW M10X1.5 HEAD BOLT THREAD REPAIR. FITS: 99-06 3 & 5 SERIES, X3, X5, Z3 AND Z4, 2.5L, 2.8L & 3.0L L6 M52, M54 & M56 ALUMINUM ENGINE BLOCKS**

**17 M10x1.5 inserts are supplied in this kit (Requires 14 for this application)**

**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 BMW head bolts and the tall head bolt spacer with the recessed end of the spacer facing up (see *FIGURE 1A*).  
(The spacer and jig together simulate the thickness of the cylinder head).**
- 2. Drill and tap the holes the entire length of the original hole depths.**
- 3. Install the inserts .200”(5mm) deep below the deck surface (see page 4, figure 4 of the Installation guide).**

*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.*