



ISUZU/HONDA/ACURA 3.2L/3.5L ENGINE HEAD BOLT THREAD REPAIR KIT WITH M11X1.5 THREADS.

FITS:

92-04 ISUZU 3.2L SOHC/DOHC ENG. CODE 6VD1
98-03 ISUZU 3.5L DOHC ENG. CODE 6VE1
96-97 ACURA SLX 3.2L SOHC ENG. CODE 6VD1
98-99 ACURA SLX 3.5L DOHC ENG. CODE 6VE1
94-97 HONDA PASSPORT 3.2L SOHC ENG. CODE 6VD1
98-02 HONDA PASSPORT 3.2L DOHC ENG. CODE 6VD1

17 M11x1.5 Modified inserts are supplied in this kit (Requires 16 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.

*** **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 2.62in. Long). The recessed end of the tall spacer should be facing upward. If it is necessary to mount the jig to a hole that has just been repaired, make sure to use a new head bolt. Old head bolts may be stretched out of pitch causing them to tighten prematurely in the new insert.
2. Drill the holes a minimum of 3½ inches (89mm) deep from the deck surface, making sure to remove all factory threads.
3. The inserts are to be installed 1¼ inches (32mm) deep below the deck surface. To accomplish this, you will need to thread the holes about 3 inches (76mm), deep from 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 M10x1.5, M10x1.25, M11x1.25, M11x2.0, M12x1.25, M12x1.5, M12x1.75 and 7/16-14