



JAGUAR / LAND ROVER (WITH JAGUAR ENGINE) 4.0/4.2/4.4/5.0L M10x1.5 HEAD BOLT THREAD REPAIR

FITS:

2000-2002 Jaguar S-Type 4.0 V8
2003-2007 Jaguar S-Type 4.2 V8
2005-2007 Jaguar Super V8
1998-2007 Jaguar Vanden Plas
2009-2012 Jaguar XF

2010-2012 Jaguar XFR
2011-2012 Jaguar XJ
1998-2007 Jaguar XJ8
1998-2007 Jaguar XJR
2007-2012 Jaguar XK

2006-2009 RANGE ROVER SPORT 4.4L / 4.2L
1997-2006 Jaguar XK8
2000-2012 Jaguar XKR
2010-2011 RANGE ROVER SPORT 5.0L
2006-2009 RANGE ROVER 4.4L / 4.2L

NOTE: THE NEWER 5.0L ENGINES (S/N's 11122107525 AND UP) AND 3.0 V6'S HAVE M11X1.5 THREADS. USE KIT #1010B FOR THESE APPLICATIONS.

21 M10x1.5 Modified inserts are supplied in this kit (Requires 20 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 2-5/8in. 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 old bolt may be stretched out of pitch.
2. Drill the holes a minimum of 4 ¼” (108mm) deep to remove factory threads (may need to go 4½” [115mm] on the 5.0L). 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. Install the inserts 2”- 2¼” (51-57mm) deep from the deck surface (see page 4, figure 4 of the Installation Guide). To accomplish this, you will need to thread the holes with 4in. (102mm) of full threads from the deck surface. A 6in extension tap is included in this kit. Always start by threading the hole with the standard length 3 flute Spiral Point tap, and thread the hole about 3 inches deep. Short taps are stronger than extension taps since they twist less. Then carefully thread to the final depth with the extension tap. The 4 flute bottom tap will not be used for application.

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 M12X1.5 and 7/16-14.