



THIS KIT REPAIRS THE FOLLOWING: LAND ROVER 3.9/4.0/4.2/4.6L ENGINE CODE “D” WITH 7/16-14 THREADS:

1994-2002 3.9/4.0 ENGINE CODES 3.9D & 4.0D

1994-1995 4.2L ENGINE CODE 42D

1996-2004 4.6L ENGINE CODE 46D

(7/16-14 inserts, qty. 21 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 TALL spacer provided (1½in. diameter x 2.62in. Long) with the recessed end 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, 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. 1.5” or 38mm), making sure to remove all factory threads.
3. The inserts are to be installed about 3/32” (2-3mm) deep below the deck surface (see page 4, figure 4 of the Installation Guide). To accomplish this, you will need to thread the holes about 1-3/8” (35mm), 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 M10x1.5, M10x1.25, M11x1.25, M11x1.5, M11x2.0, M12x1.25, M12x1.5, and M12x1.75.