



# 1985-1995 TOYOTA 2.4L 22R, 22RE, 22REC CAST IRON BLOCK M12X1.25 HEAD BOLT THREAD REPAIR

## FITS:

1985-1995 Toyota 4runner 2.4L 2366CC L4 SOHC (8 VALVE), , VIN R , ENG CODE "22R" , "22RE" , "22REC"

1985-1995 Toyota Pickup 2.4L 2366CC L4 SOHC (8 VALVE), , VIN R , ENG CODE "22R" , "22RE" , "22REC"

1985 Toyota Celica 2.4L 2366CC L4 SOHC (8 VALVE), , VIN R , ENG CODE "22R" , "22RE" , "22REC"

**11 M12x1.25 inserts are supplied in this kit (Requires 10 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 factory head bolts, along with the tall head bolt spacer and the two short spacers stacked together. The tall spacer should be the top spacer with the recessed end facing upward (see *FIGURE 1A*). The three spacers and jig together simulate the thickness of the cylinder head.**
- 2. Drill and tap the holes the entire length of the original hole depths (Approx. 30mm).**
- 3. Install the inserts 1.5mm-2.5mm (.060-.100 inch) 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, M10X1.5, M11x1.25, M11x1.5, M11X2.0, M12x1.25, M12x1.5, M12X1.75 and 7/16-14.*