



04-PRESENT GM 3.0/3.6L HIGH FEATURE V6 (HFV6) ALUMINUM ENGINES WITH M11X2.0 HEAD BOLT THREADS

(17 M11X2.0 modified inserts are supplied in this kit (16 required) 5/8-11 extension tap is included)

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.

***** WE RECOMMEND USING OEM FACTORY HEAD BOLTS. DO NOT RE-USE OLD 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. After market head bolts are often not tempered correctly and or the threads are not formed correctly, causing them to bind in the inserts.

1. When mounting the drill/tap jig, follow the instructions on pages 3&4 using the short spacer provided (1½in. diameter x 1¼ in. Long), along with one of the head bolts 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 the entire length of the original holes which is about 4.00” (102mm) deep from the deck surface, making sure to remove all of the factory threads.
3. Install inserts 1.850” (47mm) deep from the deck surface to the top of the inserts (see page 4, figure 4 of the Installation Guide), To accomplish this, you will need to thread the holes about 3.350” (85mm) deep from the deck surface. Use the short 3 flute spiral point tap for the first 3”, then tap the last .350” (9mm) with the extension tap. The shorter tap is easier to control due to its shorter length. The 4 flute bottoming tap will not be required for this 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, M10x1.5, M11x1.25, M11x1.5, M12x1.25, M12x1.5, M12x1.75 and 7/16-14.