



2016-2021 GM 1.4, 1.5, 2.0 DOHC 16 VALVE M10X1.5 HEAD BOLT THREAD REPAIR, Kit #1025

FITS:

CHEVY

CRUZE, EQUINOX, TERRAIN

BUICK ENCORE

ENGINE CODES: L3A, LE2, LFV, LV7

VIN: 5, A, M, T

(Factory head bolts for this engine should be about 110mm long)

(11 M10X1.5X31mm long inserts 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.

****WE RECOMMEND OEM HEAD BOLTS WITH THIS REPAIR****

1. When mounting the drill/tap jig, follow the instructions on pages 3&4. Using the tall spacer with the recessed end facing upward, along with a head bolt and smaller diameter alignment pin. 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.
Note: The additional larger diameter Alignment Pin will not be used for this application.
2. Drill the holes the entire length of the original hole depths which is about 1.95” (50mm), making sure to remove all factory threads.
3. Install the inserts .360” (9mm) deep from the deck surface to the top of the insert. (see page 4, figure 4 of the Installation Guide). To accomplish this, you will need to thread the hole about 1.6” (40mm).

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, M11x2.0, M12x1.25, M12x1.5, M12x1.75 and 7/16-14.