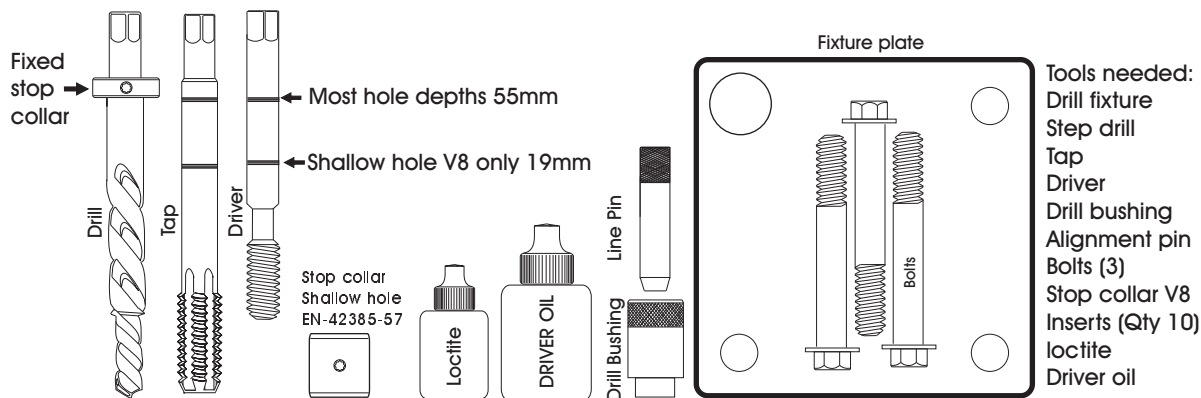
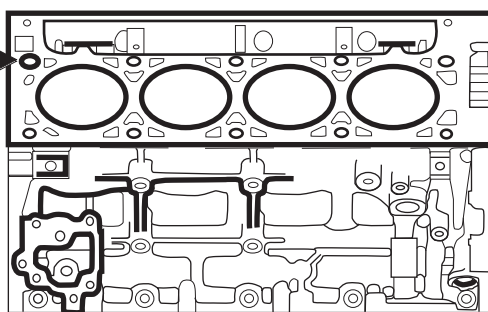


## GEN V HEAD BOLT M12x1.75 THREAD REPAIR KIT P/N EN-42385-50



**NOTE:** A Special Stop collar EN-42385-57 is required on 1 upper left shallow hole on the V8 Block

1 Shallow hole V8 block  
 Use the EN-42385-57 stop collar on core drill if repairing this hole. Use stop collar on bolt as a spacer if attaching fixture plate.



**- WARNING -**  
 Cutting tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.

**CUTTING FLUID**  
 A Cutting fluid is necessary for drilling and tapping. (WD40)

**DRILL MOTOR**  
 The use of a half inch drill motor is recommended for drilling.

### STEP 1

## INSTRUCTIONS

PLACE LARGEST HOLE IN DRILL FIXTURE OVER THE HOLE TO BE REPAIRED. PLACE BUSHING IN FIXTURE, THEN PLACE LINE PIN IN BUSHING TO PICK UP HOLE. DO NOT FORCE PIN INTO HOLE. USE BOLTS AND TIGHTEN TO SECURE FIXTURE IN PLACE. REMOVE LINE PIN **NOTE:** If needing to put attachment bolt in left upper shallow hole V8 block use the stop collar EN-42385-57 on your bolt as a spacer so you can secure the fixture plate properly.

### STEP 2

(USE WD40 for Drilling)

Note: If you are "REPAIRING" the upper left shallow hole V8 Block use stop collar p/n EN-42385-57 on DRILL USE A SUITABLE DRILL MOTOR AND STEP DRILL THE HOLE UNTIL THE APPROPRIATE STOP COLLAR TOUCHES THE TOP OF THE DRILL BUSHING. THIS WILL REQUIRE REMOVING DRILL AND BUSHING SEVERAL TIMES TO CLEAR CHIPS. CLEAN OUT ALL CHIPS. DRILL THE HOLE SLOWLY AND CAREFULLY FOR A STRAIGHT HOLE THIS IS VERY IMPORTANT!

**NOTE:** If drill bushing turns while drilling hole, Remove drill and drill bushing, Clean out all chips using a long air nozzle to reach the bottom of hole.

### STEP 3

(USE WD40 for tapping) **NOTE:** If repairing the upper left Shallow hole V8 Block stop at the first line on the tap.

TAP THROUGH THE DRILL BUSHING UNTIL THE APPROPRIATE GROOVE ON THE TAP LINES UP WITH THE TOP OF THE DRILL BUSHING. THIS WILL REQUIRE REMOVING THE TAP AND BUSHING SEVERAL TIMES TO CLEAR CHIPS. CLEAN ALL CHIPS USING BRAKE OR CONTACT CLEANER THAT WILL NOT LEAVE AN OILY RESIDUE, THE HOLE MUST BE CLEAN AND DRY. USE A FLASHLIGHT TO INSPECT THE HOLE FOR CHIPS AND CLEANLINESS.

### STEP 4

REMOVE DRILL FIXTURE FOR THE FINAL STEP 4.

**USE INSERT DRIVER OIL J-42385-110** **NOTE:** If repairing the upper left Shallow hole V8 Block stop at the first line on the Driver.

**OIL THE THREADS OF THE INSERT DRIVER.** SCREW AN INSERT ONTO THE DRIVER, APPLY A RING OF LOCTITE ON THE BOTTOM OUTSIDE THREADS OF THE INSERT AND SCREW THE INSERT INTO THE PREPARED HOLE. WHEN THE HEAD OF THE INSERT IS SEATED THE DRIVER WILL TIGHTEN UP, USE A LITTLE MORE POWER TO SCREW THE DRIVER THROUGH THE INSERT, UNTIL THE APPROPRIATE GROOVE OF THE DRIVER LINES UP WITH THE TOP OF THE BLOCK. REMOVE INSERT DRIVER, REPAIR IS COMPLETE.

Check for the latest torque specifications before assembling the engine. Improper torque of the head bolts can lead to thread failure.