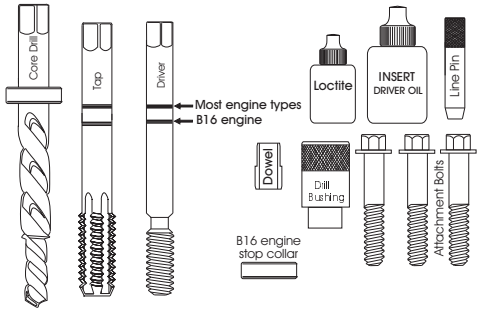
Blocks that should have
a starting thread of 57mm.
1986-2001 Integra
1986-1995 Legend
1991-2005 NSX
1996-2004 RL
Acura LS 1.8
GSR 1.8 may be 47mm
Type "R"1.8
Honda DOCH 1.6

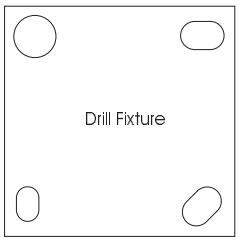
BIG-SERT®

TIME FASTENER COMPANY
5301 unit G Longley lane
Reno Nevada 89511
(800) 423-4070 (775) 829-1026

Honda B16 and similar
blocks that should have
a starting thread of 47mm.
2002-2005 CR-V
2003-2005 Accord L4
2003-2005 Element
1999-2005 Civic SI
2002-2005 RSX

HONDA / ACURA M11x1.5
REPAIR KIT P/N 7111BS





Tools needed:
Drill fixture
Drill bushing
Alignment pin
Bolts
Step drill
Tap
Insert driver
Dowel corner hole
B16 Stop Collar
loctite
Driver oil
Inserts M11x1.5

- 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.

"CHECK YOUR DEPTH OF HOLE AND USE THE APPROPRIATE DEPTH LINES 47mm OR 57mm"

NOTE: For B16 and similar engine blocks, use the B16 spacer on core drill, and go to the first line on tap and insert driver tool. Use with blocks which have a thread depth of approx. 47mm from the top of the deck to the first thread.

STOP

IF HOLE TO BE REPAIRED HAS AN EXISTING "TIME-SERT" INSERT, USE THE DRILL FROM THE TIME-SERT HONDA / ACURA FIRST REPAIR KIT p/n 7111 TO REMOVE THE INSERT BEFORE GOING TO STEP 1 USING THE BIG-SERT TOOLS!
NOTE: DO NOT DRILL OUT HELICOILS WITH OUR COREDRILL, REMOVE HELICOILS MANUALLY. DRILLING OUT HELICOILS WILL DAMAGE CUTTING EDGES OF COREDRILL. THIS COREDRILL p/n 7112 MUST BE ORDERED SEPARATELY.

INSTRUCTIONS

STEP 1

PLACE LARGEST HOLE IN DRILL FIXTURE OVER THE HOLE TO BE REPAIRED. PLACE BUSHING IN FIXTURE, THEN PLACE LINE UP 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.

STEP 2 STOP: IF YOU ARE REPAIRING A B16 OR SIMILAR ENGINE BLOCK PLACE THE B16 SPACER ON CORE DRILL.

USE A SUITABLE DRILL MOTOR AND STEP DRILL THE HOLE UNTIL THE STOP COLLAR ON THE DRILL 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.
We recommend using a long air nozzle 6" or longer to blow out all chips.

STEP 3 (USE WD40 for tapping) NOTE: IF REPAIRING A B16 OR SIMILAR BLOCK GO TO FIRST LINE ON TAP.

TAP THROUGH THE DRILL BUSHING UNTIL THE 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 (DO NOT USE Wd40.)NOTE: IF REPAIRING B16 OR SIMILAR BLOCK GO TO FIRST LINE ON INSERT DRIVER.

OIL THE THREADS OF THE INSERT DRIVER. SCREW AN INSERT ONTO THE DRIVER, APPLY A SMALL AMOUNT OF LOCTITE 266 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 GROOVE OF THE DRIVER LINES UP WITH THE TOP OF THE BLOCK. REMOVE INSERT DRIVER, COMPLETED.

STEP 5 IF YOU ARE REPAIRING TOP CORNER HOLES YOU WILL NEED TO REPLACE THE HEAD ALIGNMENT DOWEL. TAP THE LARGER DIAMETER OF THE DOWEL INTO THE HEAD UNTIL THIS LARGER DIAMETER IS FLUSH WITH THE BLOCK. THE SMALLER DIAMETER SHOULD BE STICKING OUT OF BLOCK APPROXIMATELY 3/8 INCH.

Check for the latest torque specifications, improper torque of the head can lead to thread failure.