



DODGE/CHRYSLER 2.7L 24 VALVE V6 DOHC M11X1.5 HEAD BOLT THREAD REPAIR:

2005–2010 CHRYSLER 300 2.7L 24 VALVE DOHC VIN Code "R"
1998-2004 CHRYSLER CONCORDE 2.7L 24 VALVE DOHC VIN Code "R"
2001–2010 CHRYSLER SEBRING 2.7L 24 VALVE DOHC VIN Code "R,T,D,U"
2008-2010 DODGE AVENGER 2.7L 24 VALVE FLEX DOHC VIN Code "R,T"
2006–2010 DODGE CHARGER 2.7L 24 VALVE DOHC VIN Code "R"
1998–2004 DODGE INTREPID 2.7L 24 VALVE DOHC VIN Code "R"
2005–2008 DODGE MAGNUM 2.7L 24 VALVE DOHC VIN Code "R"
2001-2006 DODGE STRATUS 2.7L 24 VALVE DOHC VIN Codes "R,T,U"

17 M11x1.5 inserts are supplied in this kit (Requires 16 for this application)

***PLEASE READ THE INSTRUCTIONS FOR THE CADILLAC NORTHSTAR
PROVIDED IN THE KIT IN THEIR ENTIRETY BEFORE PROCEEDING.***

******DO NOT RE-USE OLD HEAD 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.

The instructions supplied in the kit for the Cadillac Northstar should be followed for repairing the Dodge/Chrysler 2.7L with the following exceptions:

1. When mounting the drill/tap jig, follow the instructions on pages 3&4 using the TALL spacer provided (1½in. diameter x 2.62in. Long) with the recessed end facing upward. If it is necessary to mount the jig to a hole that has just been repaired, make sure to use a new head bolt. Old head bolts may be stretched out of pitch causing them to tighten prematurely in the new insert.
2. Drill the holes the entire length of the original hole depths (aprox. 3¾" or 95mm), making sure to remove all factory threads.
3. The inserts are to be installed about 1.25in (32mm) deep below the deck surface (see page 4, figure 4). To accomplish this, you will need to thread the holes about 3in. (76mm), deep from the deck surface.

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 M10x1.5, M10x1.25, M11x1.25, M12x1.5 and 7/16-14