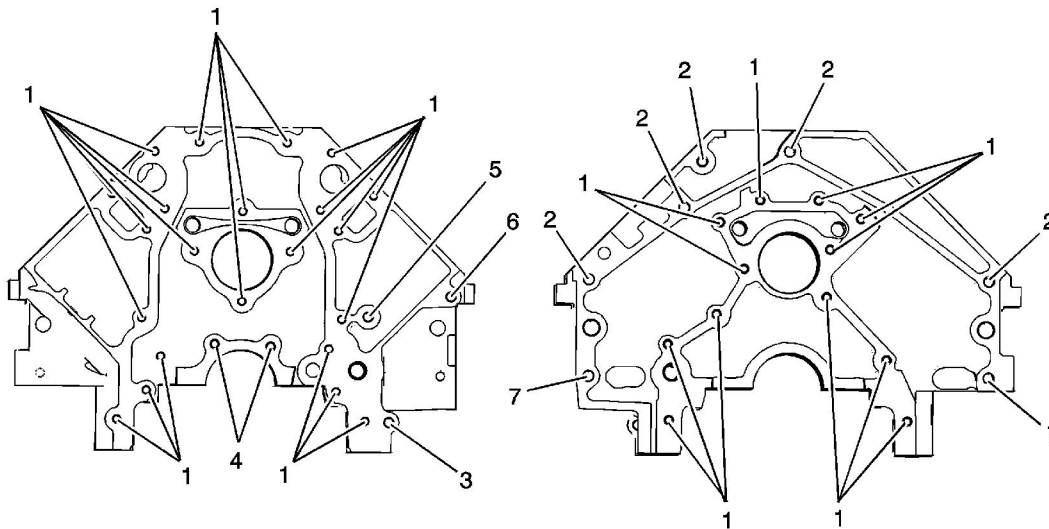


## Thread Repair Specifications

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- Table 3: [Engine Block - Top/Bottom Views](#)
- Table 4: [Cylinder Head - Top/End Views](#)
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### Engine Block - Front/Rear Views



#### Engine Block - Front/Rear Views

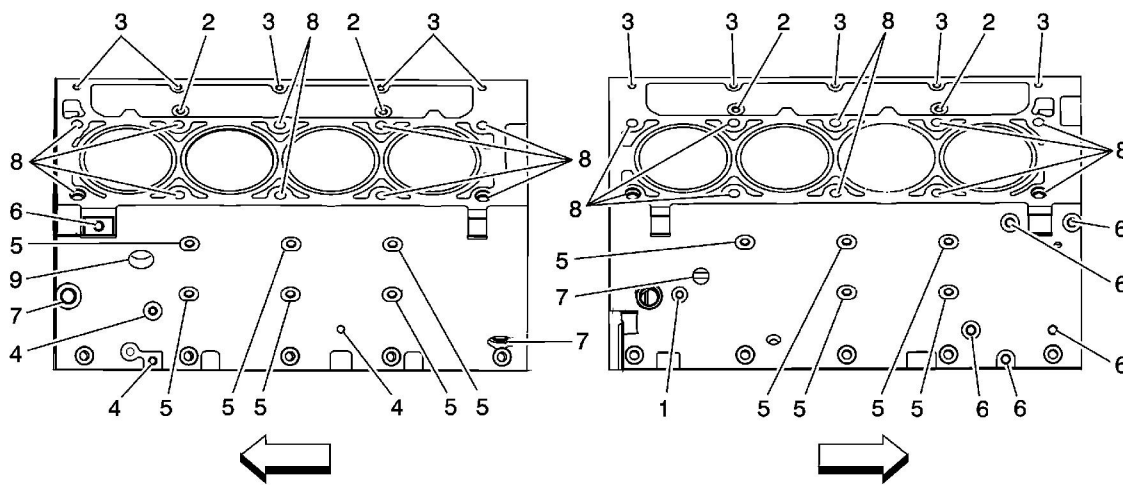
Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth - Maximum mm (in)	Tap Depth - Maximum mm (in)
J 42385-								
1	M8 x 1.25	210	206	207	208	209	22.5 (0.885)	17.5 (0.688)
2	M10 x 1.5	215	211	212	213	214	27.5 (1.08)	22.0 (0.866)
3	M10 x 1.5	215	211	212	213	214	Thru	Thru

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4	M8 x 1.25	210	206	207	208	209	Thru	Thru
5	M10 x 1.5	215	211	212	213	214	25.0 (0.984)	19.5 (0.767)
6	M10 x 1.5	215	211	212	213	214	32.5 (1.279)	25.0 (0.984)
7	M10 x 1.5	215	211	212	213	214	Thru	Thru

Bolt hole 6 is drilled and tapped for aluminum block applications only.

### Engine Block - Left/Right Side Views



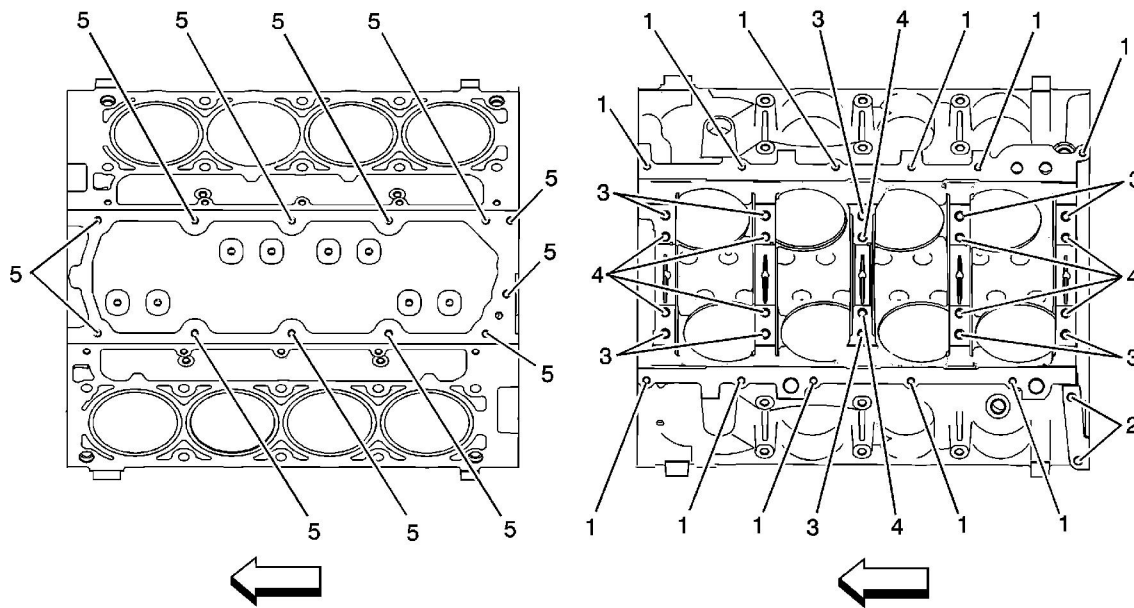
### Engine Block - Left/Right Side Views

Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth - Maximum mm (in)	Tap Depth - Maximum mm (in)
J 42385-								
1	M8 x 1.25	210	206	207	208	209	22.5 (0.885)	17.5 (0.688)
2	M6 x 1.0	205	201	202	203	204	22.5 (0.885)	15.0 (0.688)
3	M8 x 1.25	210	206	207	208	209	28.5 (1.122)	23.0 (0.905)
4	M8 x 1.25	210	206	207	208	209	21.5 (0.846)	16.0 (0.629)
5	M10 x 1.25	215	211	212	213	214	29.0 (1.141)	23.0 (0.905)
6	M10 x 1.5	215	211	212	213	214	27.0 (1.062)	21.5 (0.846)
7	M16 x 1.5	N/A	N/A	N/A	N/A	N/A	N/A	N/A

8	M11 x 2.0	108	105	N/A	106	107	69.0 (2.72)	60.0 (2.36)
9	M28 x 1.25	N/A	N/A	N/A	N/A	N/A	N/A	N/A

Bolt hole 8 has a 30 mm (1.18 in) counterbore included in the 69.0 mm (2.72 in) drill depth. Use sleeve J 42385-315 with the drill and tap.

### Engine Block - Top/Bottom Views

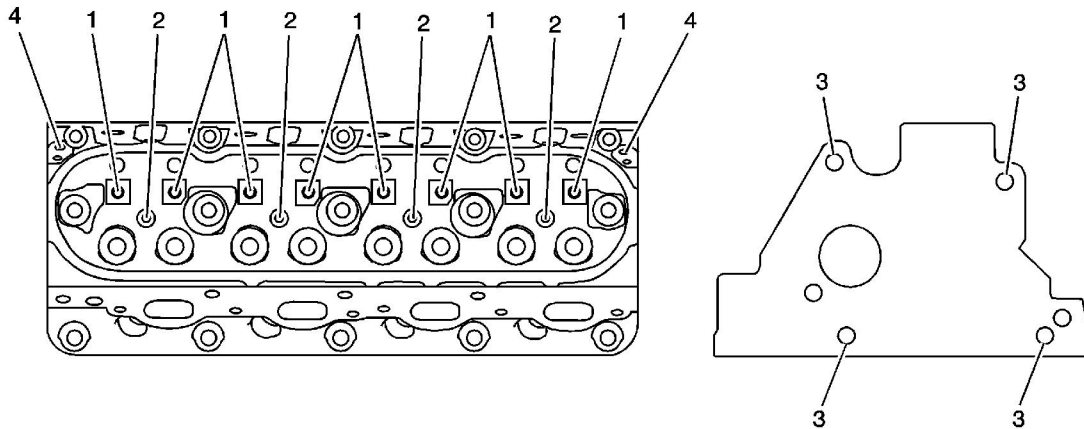


### Engine Block - Top/Bottom Views

Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth - Maximum mm (in)	Tap Depth - Maximum mm (in)
J 42385-								
1	M8 x 1.25	210	206	207	208	209	22.5 (0.885)	17.5 (0.688)
2	M10 x 1.5	215	211	212	213	214	42.5 (1.67)	37.0 (1.45)
3	M10 x 2.0	104	101	N/A	102	103	31.0 (1.22)	25.5 (1.0)
4	M10 x 2.0	104	101	N/A	102	103	53.5 (2.10)	44.0 (1.73)
5	M8 x	210	206	207	208	209	26.5 (1.043)	19.0 (0.748)

	1.25						
<ul style="list-style-type: none"> <li>• Bolt hole 2 has an 11.5 mm (0.452 in) counterbore included in the 42.5 mm (1.67 in) drill depth. Use sleeve J 42385-311 with the drill and tap.</li> <li>• Bolt hole 3 has a 1.5 mm (0.059 in) counterbore included in the 31.0 mm (1.22 in) drill depth. Use sleeve J 42385-316 with the drill and tap.</li> <li>• Bolt hole 4 has a 20.5 mm (0.807 in) counterbore included in the 53.5 mm (2.10 in) drill depth.</li> </ul>							

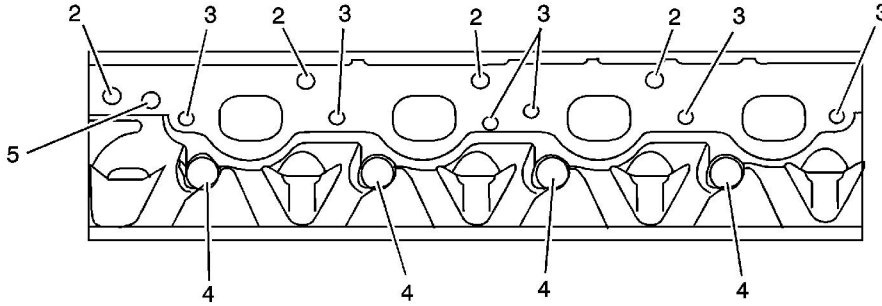
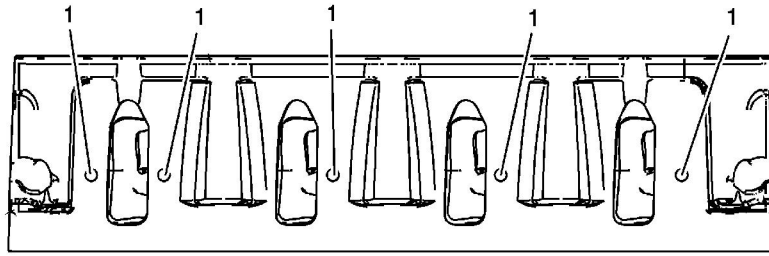
### Cylinder Head - Top/End Views



### Cylinder Head - Top/End Views

Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth - Maximum mm (in)	Tap Depth - Maximum mm (in)
J 42385-								
1	M8 x 1.25	210	206	207	208	209	26.5 (1.04)	19.0 (0.784)
2	M6 x 1.0	205	201	202	203	204	20.05 (0.789)	16.05 (0.632)
3	M10 x 1.5	215	211	212	213	214	28.0 (1.10)	20.0 (0.787)
4	M6 x 1.0	205	201	202	203	204	22.5 (0.885)	15.0 (0.688)

### Cylinder Head - Intake/Exhaust Side Views



**Cylinder Head - Intake/Exhaust Side Views**

Hole	Thread Size	Insert	Drill	Counterbore Tool	Tap	Driver	Drill Depth - Maximum mm (in)	Tap Depth - Maximum mm (in)
J 42385-								
1	M6 x 1.0	205	201	202	203	204	Thru	Thru
2	M10 x 1.5	215	211	212	213	214	28.0 (1.10)	20.0 (0.787)
3	M8 x 1.25	210	206	207	208	209	21.0 (0.826)	16.0 (0.629)
4	M14 x 1.25	N/A	N/A	N/A	N/A	N/A	N/A	N/A
5	M12 x 1.5	N/A	N/A	N/A	N/A	N/A	N/A	N/A