

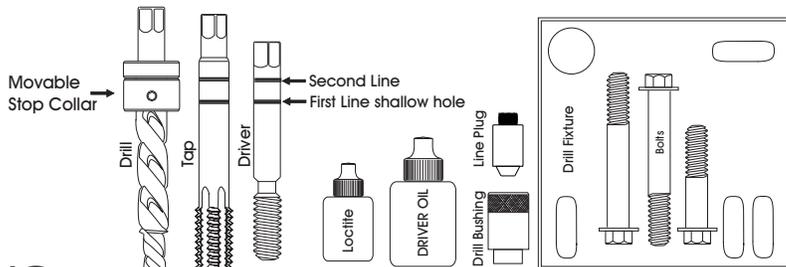
**REPAIRS:**

1996-2000 Civic  
1988-1991 Civic/CRX  
1992-1995 Civic / Del sol

# TIME-SERT®

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

## HONDA D16 HEAD BOLT M10x1.25 THREAD REPAIR P/N 4160



- Tools needed:  
 Drill fixture  
 Drill bushing  
 Bolts Long (2)  
 Bolt short (1)  
 Step drill  
 Tap  
 Insert driver  
 Alignment plug  
 Movable Collar  
 Inserts (Qty 10)  
 Loctite  
 Driver oil

### - WARNING -

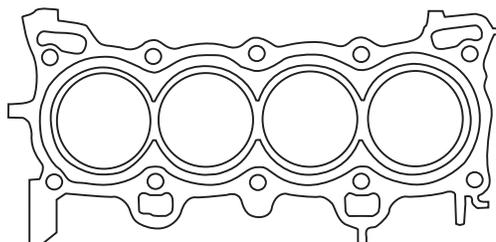
Cutting tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.

### 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.



Shallow hole  
29mm Depth  
Use 41605 Collar

## INSTRUCTIONS

FOR THE REPAIR OF THE (1) 29mm SHALLOW HOLE, USE THE MOVABLE STOP COLLAR ON THE DRILL AND STOP AT THE FIRST LINE ON THE TAP AND DRIVER.

FOR THE REPAIR OF THE (9) 44mm DEEP HOLES, REMOVE THE STOP COLLAR P/N 41605 FROM THE DRILL AND STOP AT SECOND LINE OF THE TAP AND DRIVER

### STEP 1

PLACE LARGEST HOLE IN DRILL FIXTURE OVER THE HOLE TO BE REPAIRED. PLACE LINE PLUG IN LARGEST HOLE TO ALIGN WITH DAMAGED HOLE. DO NOT FORCE LINE PLUG INTO HOLE. USE 2 BOLTS AND TIGHTEN TO SECURE FIXTURE IN PLACE. PLATE CAN BE FLIPPED OVER FOR CORRECT ALIGNMENT. REMOVE ALINEMENT PLUG.

### STEP 2

PLACE DRILL BUSHING IN FIXTURE PLATE.

USE A SUITABLE DRILL MOTOR AND STEP DRILL THE HOLE UNTIL THE APPROPRIATE STOP COLLAR ON THE DRILL LINES UP WITH THE TOP OF THE DRILL BUSHING. THIS WILL REQUIRE REMOVING DRILL AND BUSHING SEVERAL TIMES TO CLEAR CHIPS. CLEAN OUT ALL CHIPS. WATCH CAREFULLY THAT THE CORE DRILL IS GOING STRAIGHT! 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)

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 !

USE INSERT DRIVER OIL (DO NOT USE Wd40.)

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 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 can lead to thread failure.