



Injector Hold Down Thread Repair

Part #: AGA-IHDTR-K



1. Guide Tool
2. Install Tool
3. Inserts
4. Tap
5. Reamer



Please read before performing task!!!

Use extreme caution when performing this procedure to ensure that no debris can fall into the combustion chambers of the engine or can contaminate the high pressure fuel system. Frequently use shop air to blow away any metal debris and always inspect the surrounding area. Ensure all ports/holes are covered using injector line caps, clean shop towels or tape. All metal shavings in the area need to be cleared from the area before removing the guide tool.



Warning: Safety glasses are mandatory while perform this repair from start to finish.

1: Install guide tool into both injector holes simultaneously.

Tighten the hand knobs while pushing down.



2: Install drill guide into guide tool.

Lubricate drill/reamer with oil (WD40 or similar).

Start drilling. During drilling process, pull drill/reamer out every few seconds to blow the reamer and the hole clean with compressed air.

Repeat until drill/reamer has reached bottom of hole.

Note: The drill/reamer will stop drilling at the bottom of hole.



3: Verify that the hole has reach bottom by measuring on top of guide tool to bottom of hole (as pictured).

Make sure you are measuring the new hole and not previous hole in center.

The new hole should now measure between 56mm and 57mm deep.

54.5mm is minimal acceptable depth.



4: If measuring hole depth without the drill guide installed (as shown in picture), the depth of the hole should now measure between 18mm and 19mm deep.

16.5mm is minimal acceptable depth.



Note: Hole is not complete in this picture. The center hole is still remaining.

The drill/reamer has not reached the bottom.



Note: Hole is completely drilled in this picture.

The drill/reamer has reached the bottom.

Old center hole is removed.

The hole should now measure between 18mm and 19mm deep. 16.5mm is minimal acceptable depth.



5: Apply oil to tap, insert tapping tool into guide tool and push down firmly while turning clockwise with 10mm hex socket.



6: During the tapping cycle, remove the tap and blow tap and hole clean with compressed air. Repeat until hole is fully tapped.



7: Remove guide tool and inspect hole for debris and oil.

If necessary, clean hole with brake cleaner, alcohol or similar.

Hole must be dry and clean before installing the insert.



8: Push insert onto install tool. Apply red Loctite onto outer diameter threads **ONLY**.



9: Install the threaded insert with the tool until the shoulder of install tool makes contact with the cylinder head.

Caution!

Hand tighten only! Do not use excessive force.

Pull the install tool straight up and out.



10: Observe that the threaded insert is below the cylinder head surface.

Allow the red Loctite to set for 30 minutes before installing the injector hold down bolt and bracket.

The repair procedure is complete.