

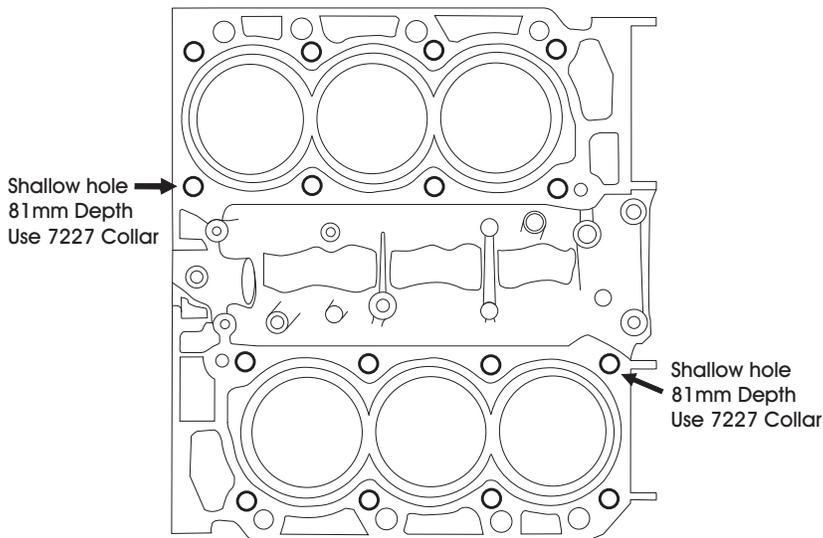
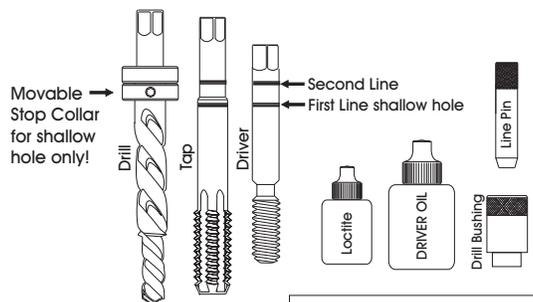
REPAIRS: 1999-2005 ODYSSEY
 2003-2005 PILOT
 1998-2005 ACCORD V6
 1997-2003 3.0-3.2 CL
 1999-2005 3.2TL
 2001-2005 MDX
 2005 RL

TIME-SERT®

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

Tools needed:	Part no.
Drill fixture	56111
Drill bushing	7224
Alignment pin	7225
Bolts (3)	7226
Movable Collar	7227
Step drill	7221
Tap	7222
Insert driver	7223
Inserts (Qty 16)	12159
Loctite	6020
Driver oil	6010

HONDA ODYSSEY HEAD BOLT M12x1.5 THREAD REPAIR P/N 7220



- 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.

INSTRUCTIONS

FOR THE REPAIR OF THE (2) 81mm 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 (14) 91mm DEEP HOLES, REMOVE THE STOP COLLAR 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 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 (USE WD40 for Drilling)

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.