

# INSTRUCTIONS FOR DEEP HOLE ALUMINUM HEAD M14X1.25 SPARK PLUG HOLE REPAIR KIT

For deep reach plug holes as well as standard depth M14x1.25 plug holes, except Ford DOHC Triton 4.6L and 5.4L motors 1996-2004.

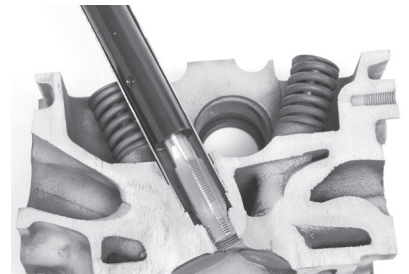


- |   |                         |
|---|-------------------------|
| 1. Long Tap Holder  | 65020                   |
| 2. Set Screw (2 pcs.)   | 66160                   |
| 3. Swedger Handle   | 65100                   |
| 4. Drill/Tap  | 65010                   |
| 5. Swedger  | 65040                   |
| 6. Insert Installer   | 65090                   |
| 7. Short Tap Holder   | 65070                   |
| 8. Threaded Inserts<br>5/16" (1 pc.)<br>7/16" (2 pcs.)<br>11/16" (3 pcs.) | 65080<br>65060<br>65030 |

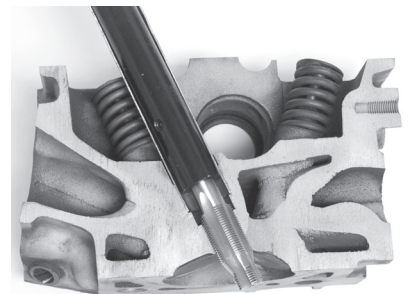


**IMPORTANT: All valves must be closed.  
Kit is to be used with the head removed from the vehicle.**

1. Insert Drill/Tap (4) into Long Tap Holder (1) and secure with Set Screw (2). Short Tap Holder (7) can be used when extra length is not needed.



2. Use 3/8" square drive and turn assembly clockwise. Make sure Drill/Tap starts in hole properly and is not angled so hole is drilled properly. Narrow threaded end will pull drill and tap into the head. Make sure to fully tap the new hole.



(Continued)

3. Lubricate threads on Insert Installer (6) to prevent thread lock. Select proper length Threaded Insert (8) and thread completely onto Insert Installer. Knurled end should be up. Make sure insert will not shield spark plug electrode.
4. Apply a bead of fast setting thread locker (not included) toward the bottom of the insert. Using 3/8" square drive, screw the insert clockwise into the new hole until snug. The Installer is wider than the insert and will stop when fully inserted.  
**IMPORTANT: Be sure to allow the thread locker to set before removing the Installer by turning counter-clockwise.**
5. Thread Swedger (5) onto Swedger Handle (3). Swedger is hardened so it can be used without the handle when extra reach is not needed.
6. Place Swedger or Swedger Assembly in hole and strike with hammer to expand knurl on top of new insert. Do not over-swedge.
7. To remove swedger, tap gently on the side of the handle or use pliers to twist swedger loose in hard-to-reach areas.
8. Use M14x1.25 thread chaser (part 20020 not provided) after swedging. Install spark plug to manufacturer's recommended torque. It align up with the other plugs.  
*(The threads have been replaced for the plug on the right in the photo.)*

