

Stripped or damaged oversized head & barrel bolt or cap screws.

Here is a scenario that may help you should you strip the head bolts in your barrel and head, especially if you already have oversize cap screws or bolts. We had previously changed the 6mm standard cap screws that came with the 210cc engine to 8mm. These had subsequently become damaged and not enough meat was left to safely place oversize new ones in. What we did was to drill and tap the existing holes out to 11mm. We took a steel bolt to fit, drilled a hole down the centre of it (8mm), screwed it in and tightened. Ground off the head flush and polished smooth. This now meant that the 8mm head bolts could now screw into a steel insert making any subsequent damage minimal.

Below: Re-drilling old holes in barrel to fit 11mm bolt



Drilling & tapping new 11mm holes in barrel

Below: Centralising bolt insert in lathe to drill and tap new hole through the centre which will accommodate 8mm head cap screws.





Inserting bolts with new thread through the centre into new holes drilled and tapped and lock-tighted into barrel.



Cutting heads off inserts.



Grinding bolt inserts flat.





Grinding smooth with fine grained sand paper



Finally smoothing off all roughness with fine grained paper.