

# IHLE FABRICATIONS LLC<sup>®</sup>

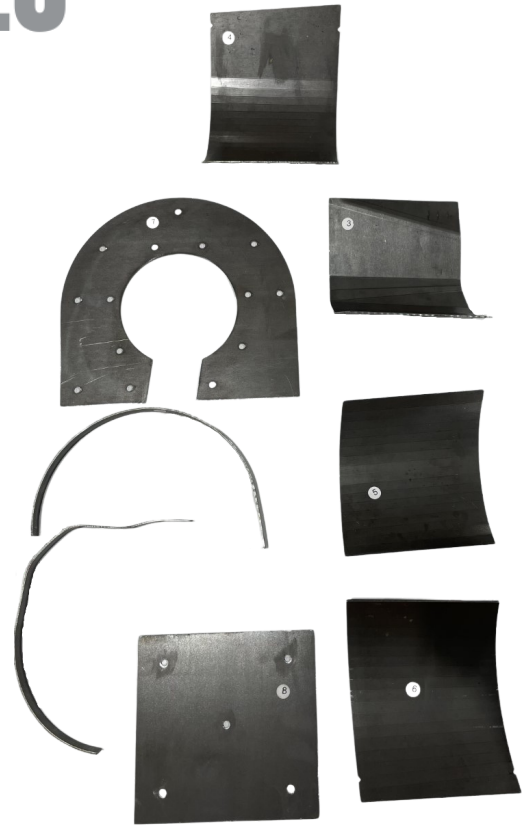
## INSTALLATION INSTRUCTIONS

### CLEAN GRAIN BOOT LINER KIT

CASE IH<sup>®</sup> FLAGSHIP SERIES

**P/N: IF110417BK (73399500R)**

All **Ihle Fabrications** products are made in the USA using the best materials to provide quality auger liner replacement parts. **Ihle Fabrications** a family-owned agriculture and fabrication business and stands behind our craftsmanship.



## HARDOX<sup>®</sup>

WEAR PLATE

Hardox<sup>®</sup> Wear Plate is the world's leading abrasion-resistant (AR) steel. Enjoy the benefits of guaranteed toughness in our products made with Hardox<sup>®</sup> Wear Plate.



#### TOOLS NEEDED

Welder  
Locking C-Clamps  
Grinder  
Silicone/Sealer

#### ITEMS INCLUDED

Liner Pieces (8)

**THANK YOU FOR YOUR BUSINESS**

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**PH: 515-329-8050**

4780 NW 158TH AVE.  
POLK CITY, IA 50226

## INSTALLATION INSTRUCTIONS

### CLEAN GRAIN BOOT LINER KIT

Carefully follow instructions, match all pieces from the kit with the reference numbers on the following pages. **Hash marks etched into the pieces will line up if they are in the correct order.**

**Step 1:** Before welding, ensure each piece is clamped as tight as possible.

**Step 2:** Tack weld each piece, in numbered order.

**Step 3:** When all pieces have been tack welded in place, then fully weld each piece, using high heat.

**Step 4:** Grind all welds smooth to ensure clearance.

**Step 5:** When reinstalling, the foam seal will have to be discarded. Reseal any remaining gap using a CNH (or other preferred) silicone.



Image shows  
completed liner  
installation

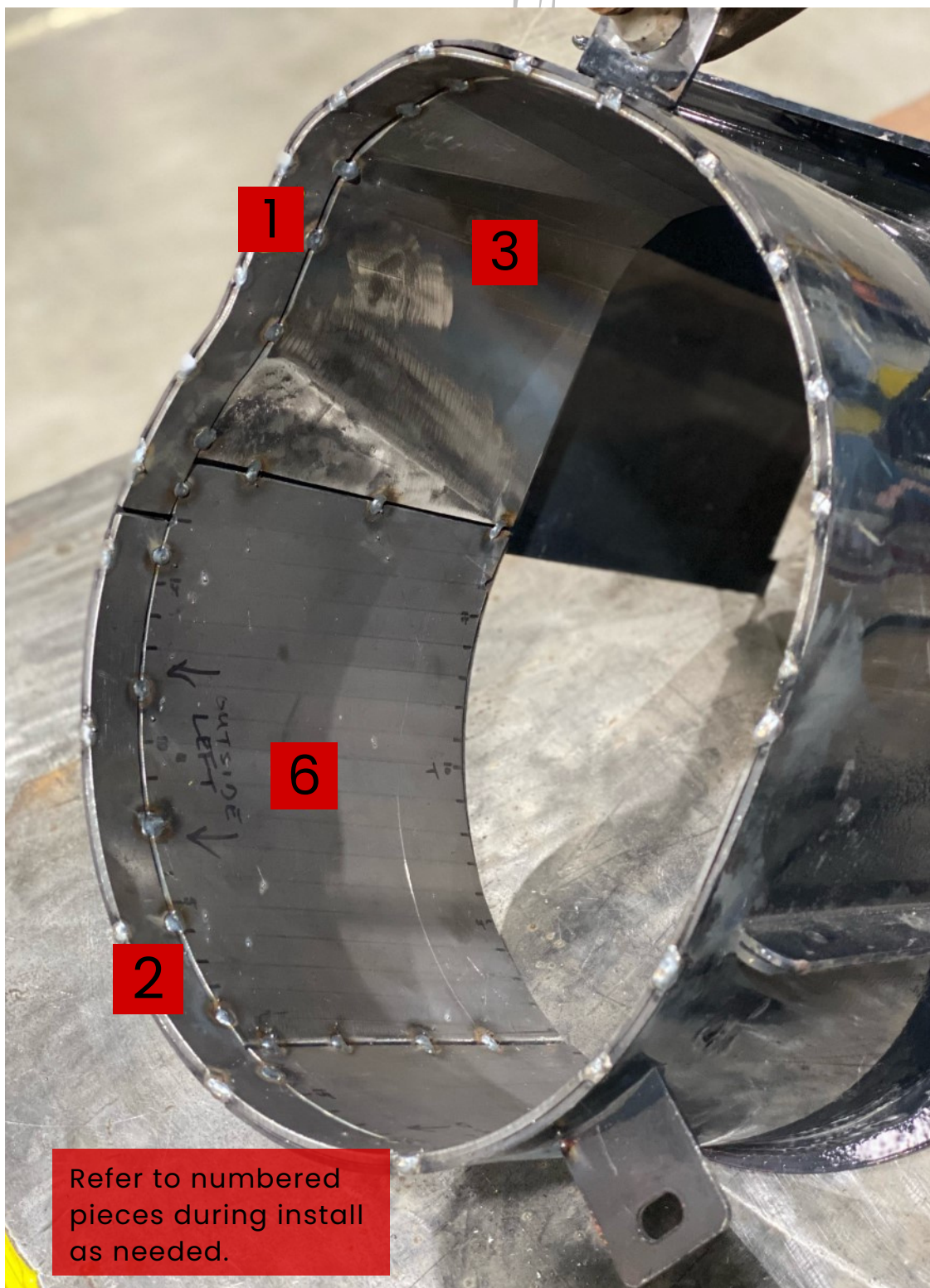
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Refer to numbered pieces during install as needed.

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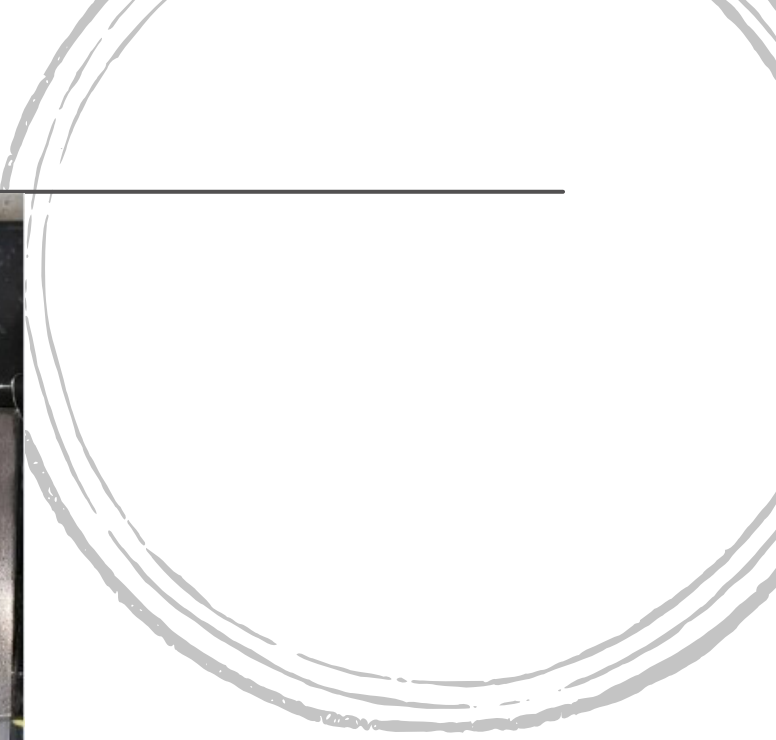
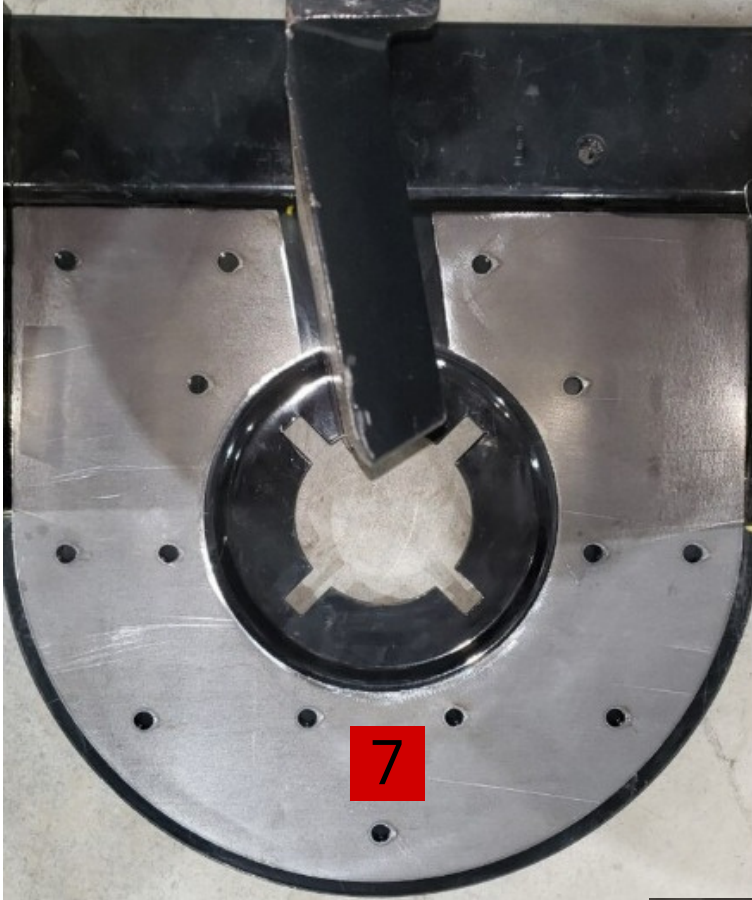




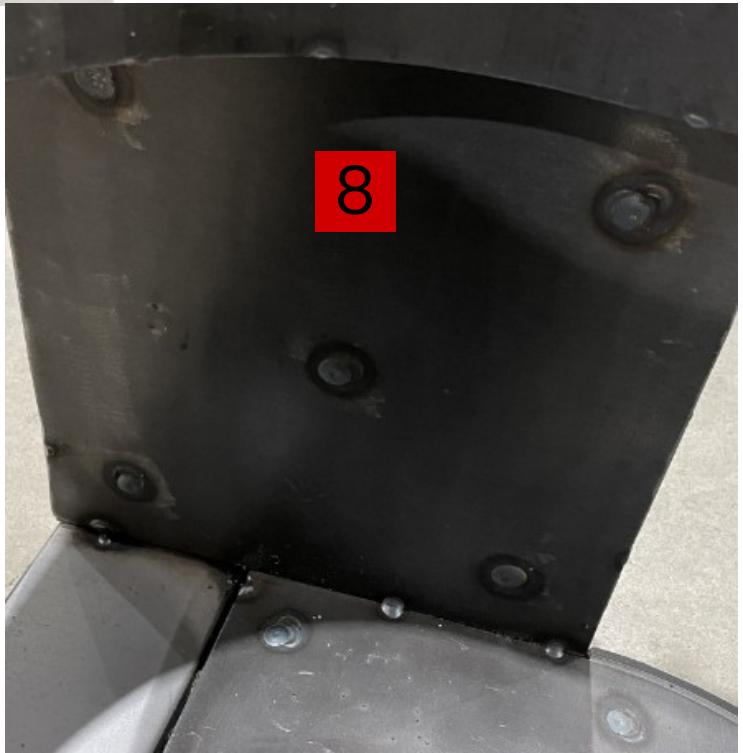
Refer to numbered pieces during install as needed.

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Refer to numbered pieces during install as needed.



**QUESTIONS?**

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Install the top ring flush to the outside of the housing.

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Tack weld top ring on outside only, as shown below.



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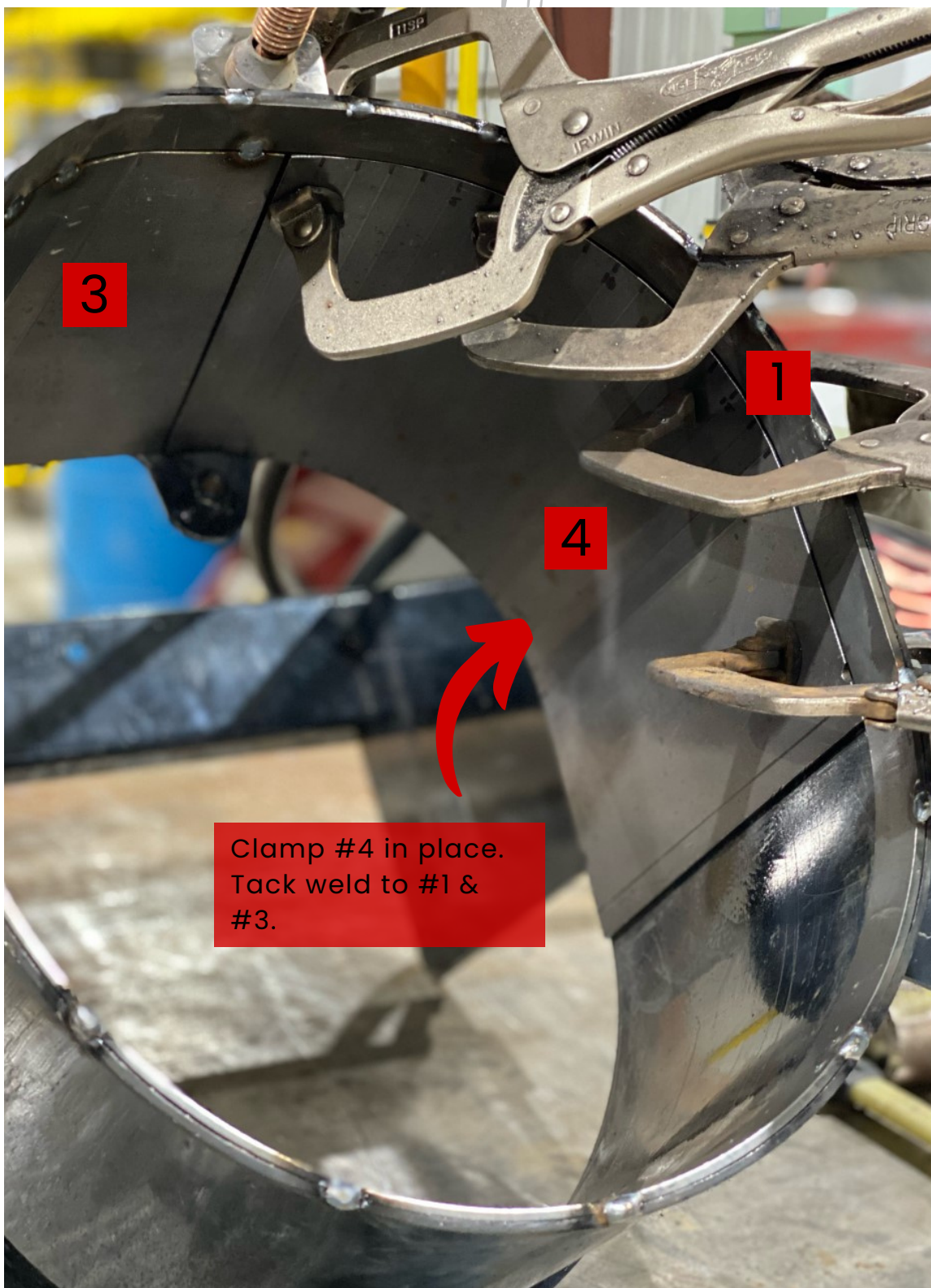
After installing top & bottom rings (#1 & #2) Install #3. Clamp in place, then tack weld to #1. (**DO NOT** tack weld to the housing.)

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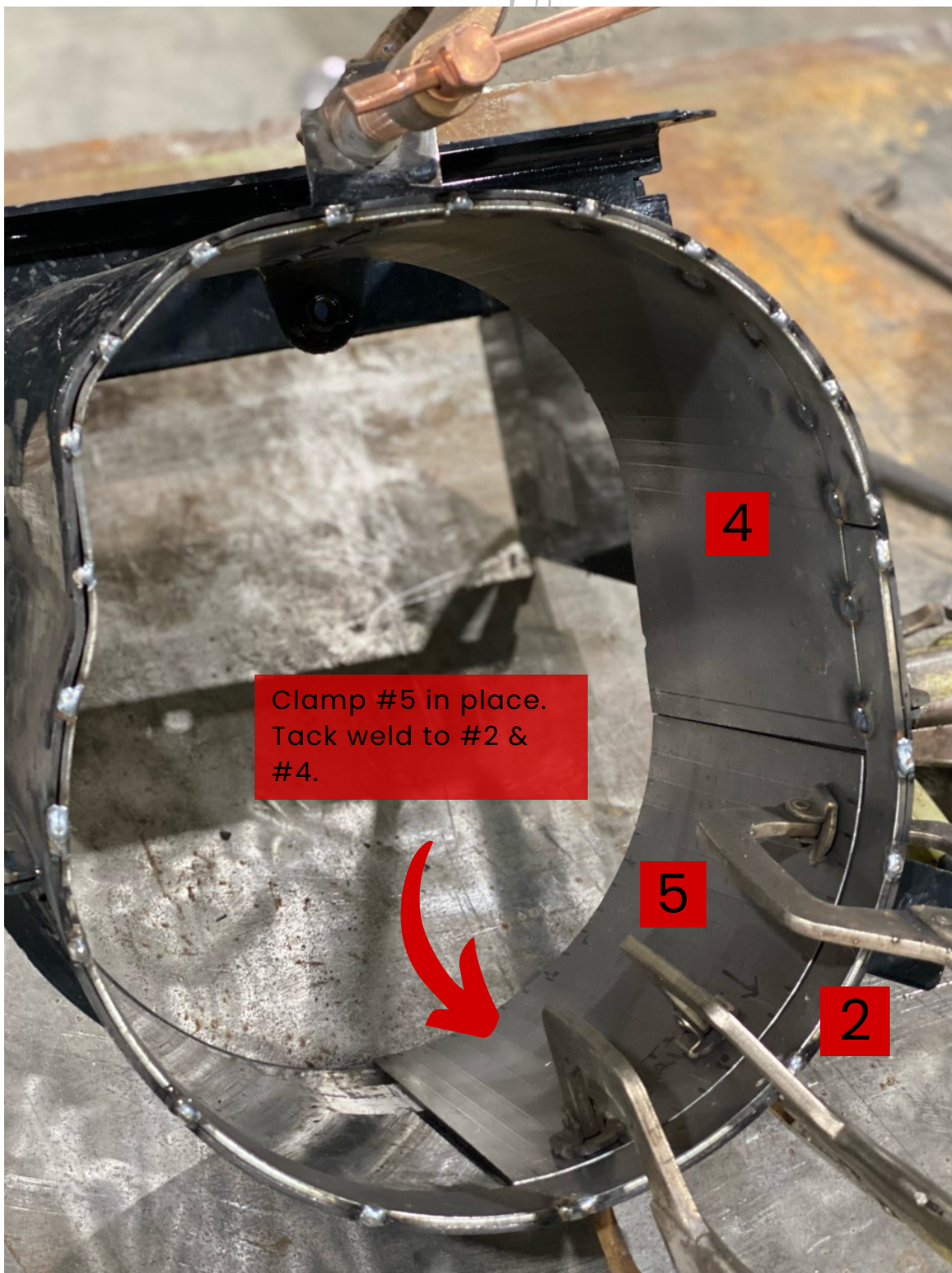
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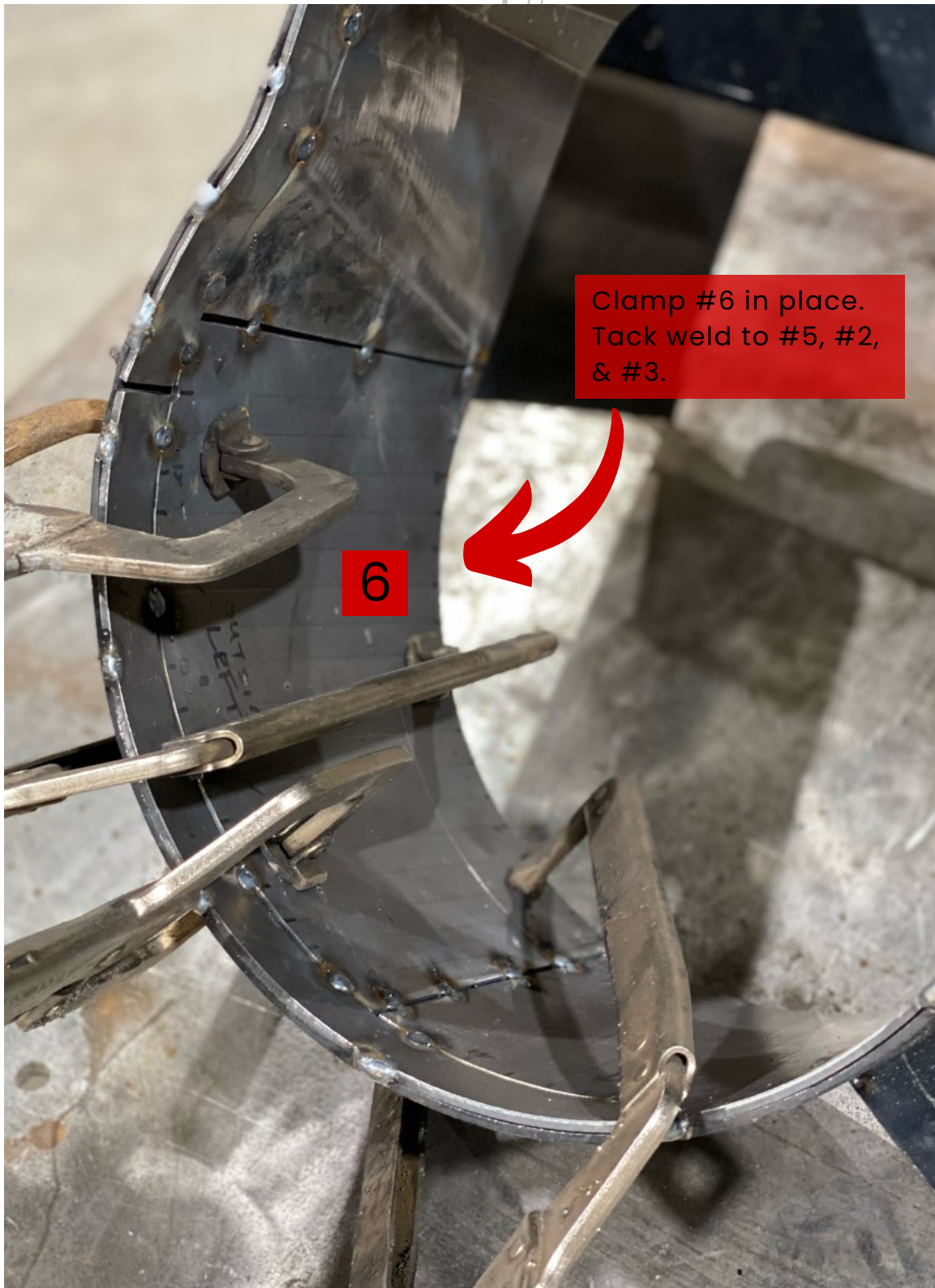


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Clamp #6 in place.  
Tack weld to #5, #2,  
& #3.

6

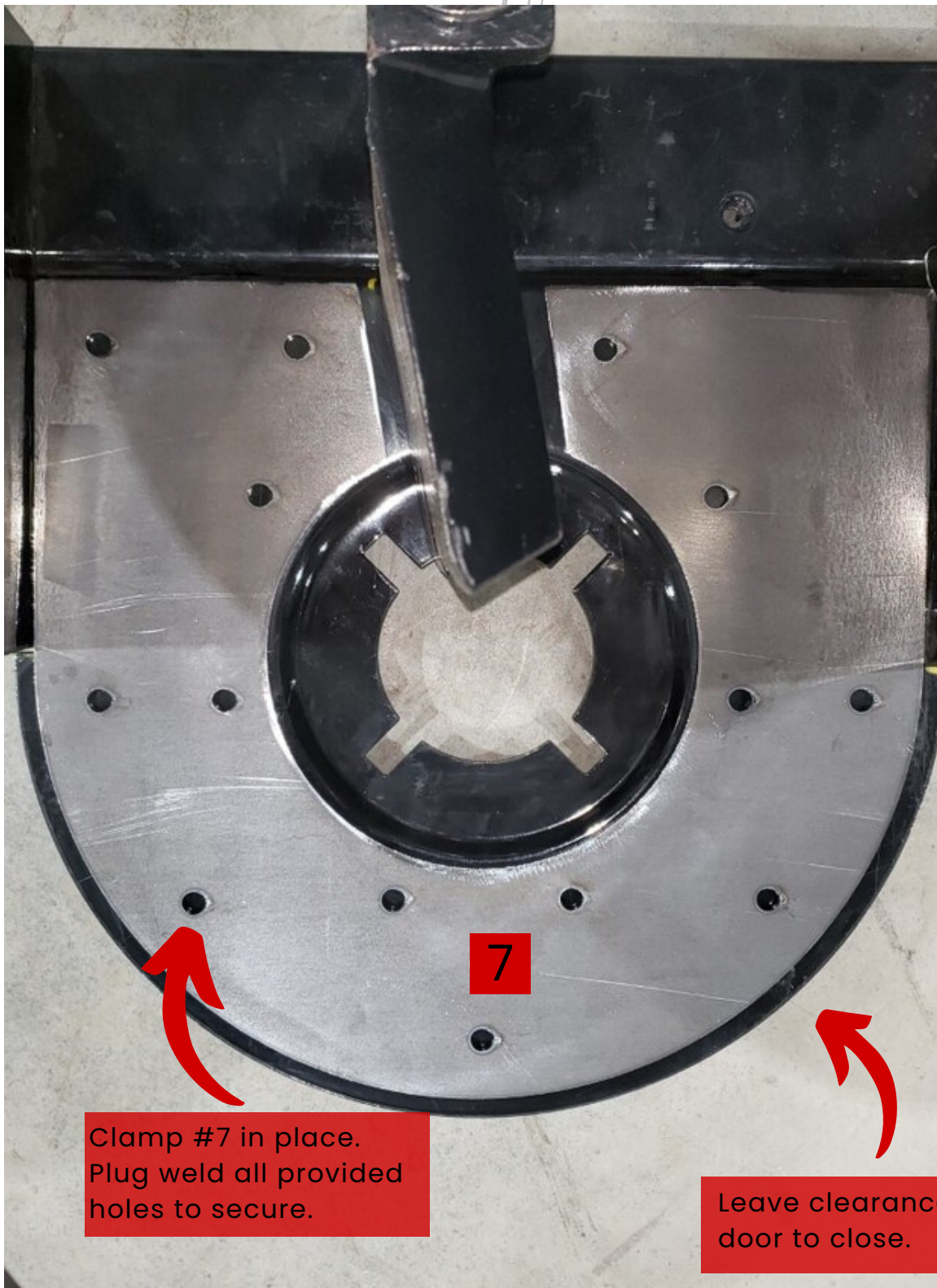
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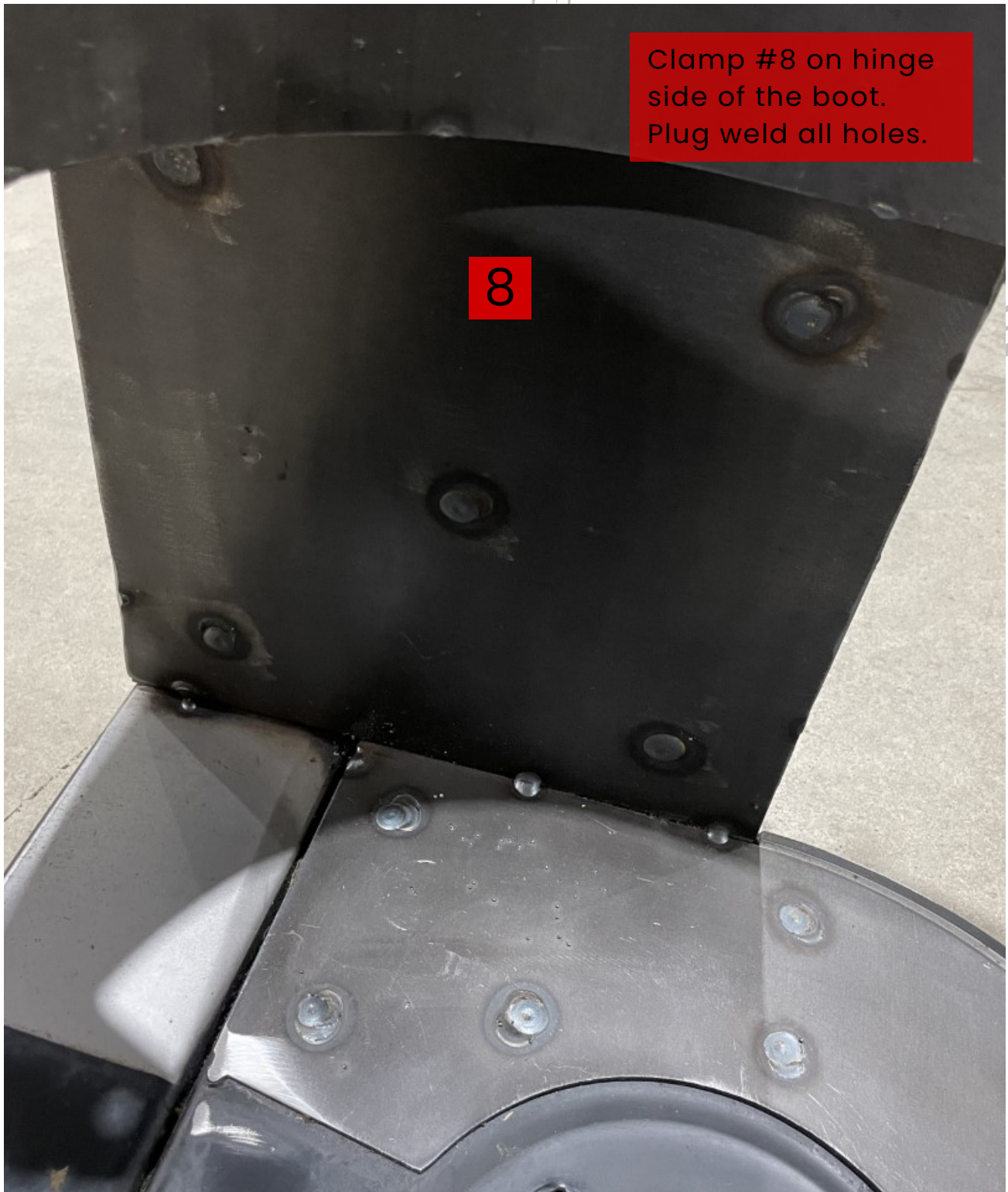


Clamp #7 in place.  
Plug weld all provided  
holes to secure.

Leave clearance for  
door to close.

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