

# IHLE FABRICATIONS LLC<sup>®</sup>

## INSTALLATION INSTRUCTIONS

### CLEAN GRAIN RETURN GRAIN LINER

### CASE IH<sup>®</sup> FLAGSHIP SERIES



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.



#### TOOLS NEEDED

Welder  
Rivet Gun  
Drill  
3/16" Drill Bit  
Locking C-Clamps  
Wire Cutters

#### ITEMS INCLUDED

2 Liner Pieces

THANK YOU FOR YOUR BUSINESS

PH: 515-329-8050

WWW.IHLEFABRICATIONS.COM

4780 NW 158TH AVE.  
POLK CITY, IA 50226

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Trough does not need to be removed, liners may be installed by pulling the augers and removing the bottom doors in order to work underneath the combine. We recommend installing the liners this way but another option would be to remove the self-leveling pan / sieves.

**Step 1:** Remove the augers and the doors.

**Step 2:** Scrape or clean off any leftover dirt or debris to ensure the liners can sit flush with the trough.

**Step 3:** Use wire cutters to separate the inner door from the rest of the liners

**Step 4:** Insert liners in the trough, they will only fit one way.

**Step 5:** Clamp the liners in place, tight to the housing.

**Step 6:** Fully weld each end of the liner to the trough to prevent grain from sifting between the liner and the housing.

**Step 7:** Stitch weld the center of the liner, around the door cut-outs

**Step 8:** When liner is secured, drill holes for the rivets using a 3/16" drill bit. Drill the holes into original trough using the pre-punched holes in the liners.

**Step 9:** Rivet the liner in place using rivets provided.

**Step 10:** Clamp the door cut out tight to the door housing.

**Step 11:** Stitch weld around the entirety of the door liner to secure it to the trough. **NOTE:** In order to properly fit the door, slight grinding may be needed.

**QUESTIONS?**

REACH OUT TO OUR TEAM