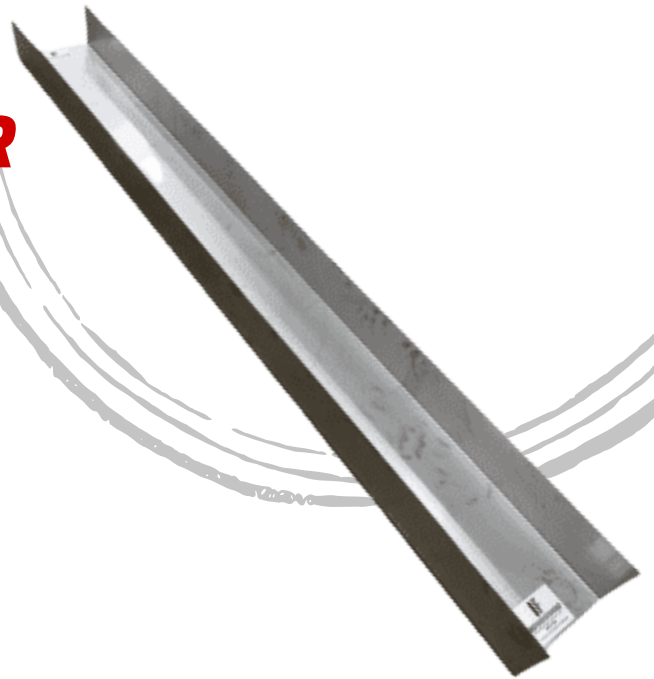


IHLE FABRICATIONS LLC[®]

INSTALLATION INSTRUCTIONS

GRAIN ELEVATOR LINER

CNH[®] FLAGSHIP & MIDRANGE



P/N: IF1114152K (73399534R) |
IF1114178K (73399535R) | IF1124178K
(73399536R) | IF1124179K (73399537R)
| IF31D4178K (73399540R)

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

Drill
3/8 Drill Bit
Impact Driver
Welder
Locking C-Clamps

ITEMS INCLUDED

Liner

THANK YOU FOR YOUR BUSINESS

PH: 515-329-8050

INSTALLATION INSTRUCTIONS

GRAIN ELEVATOR LINER

Step 1: Remove the elevator chain.

Step 2: Remove the elevator and the elevator head.

Step 3: For machines with a moisture sensor, locate the moisture sensor hole and cut out corresponding spot in the liner, if there is not already a hole provided.

Step 4: Mark holes on the upside of the clean grain elevator as shown on the liner on page two. Once holes are marked in correct positions, drill the holes with 3/8th bit and remove the burrs. **NOTE:** Drill the elevator **ONLY**. Do **NOT** drill the liner.

Step 5: Grind smooth over penetration of welds from the inside of the elevator. Shown on page 4.

Step 6: Inspect the center divider, it should be square with the liner, without waves. Any imperfections should be addressed accordingly to ensure it is level.

Step 7: Slide the liner in from the bottom of the elevator. The back of the liner should be flush against the divider.

Step 8: Press the liner against the divider as tight as possible, using a bottle jack or Porta Power as well as a 2x4. Clamp the top and the bottom.

Step 9: Plug weld the holes that were previously drilled.

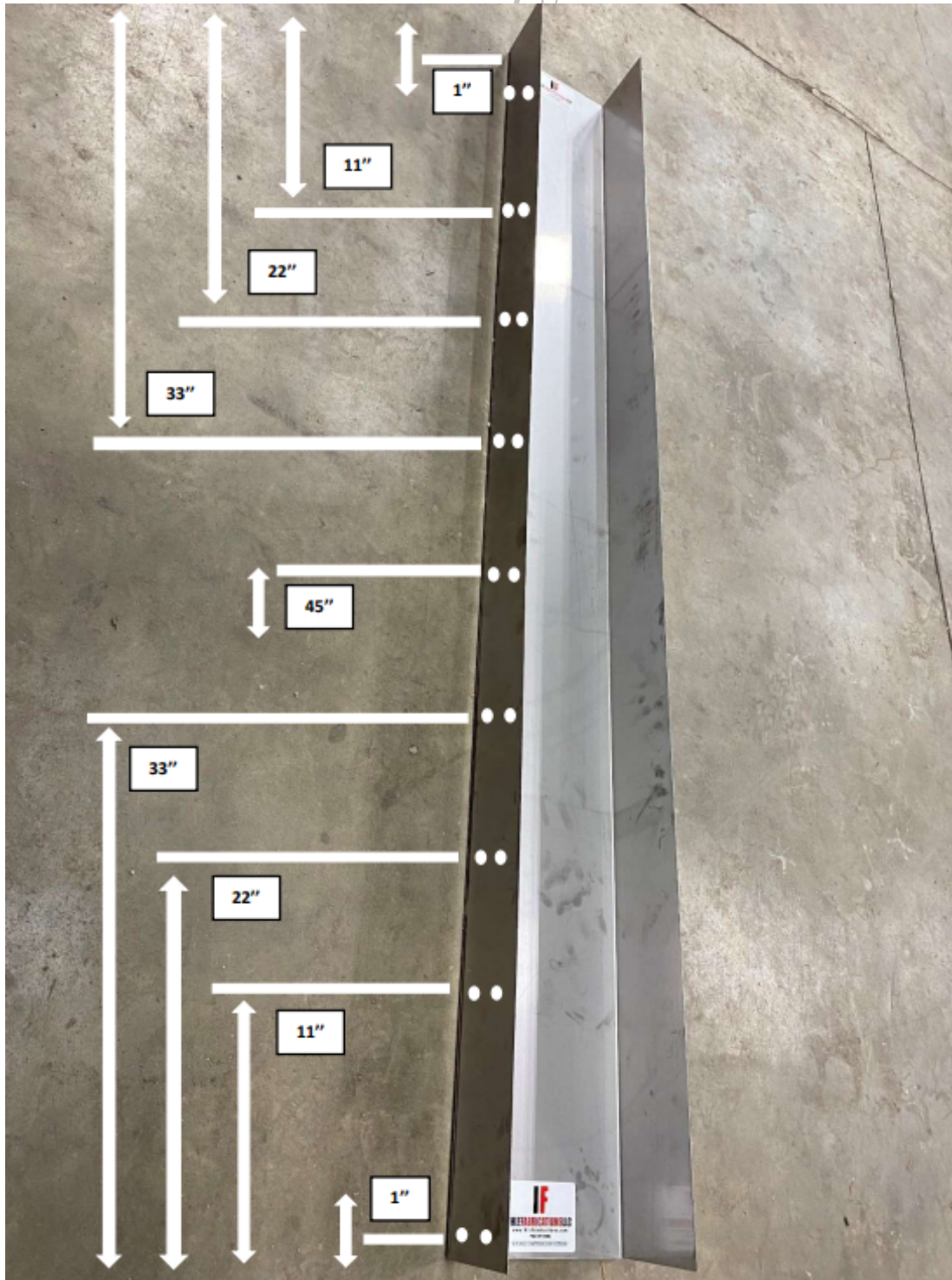
Step 10: Weld the top and bottom of the liner solid to prevent grain from getting in between the liner and the housing.



Note: If step 10 is not completed, this may cause a chain to catch & warranty will be void.

QUESTIONS?

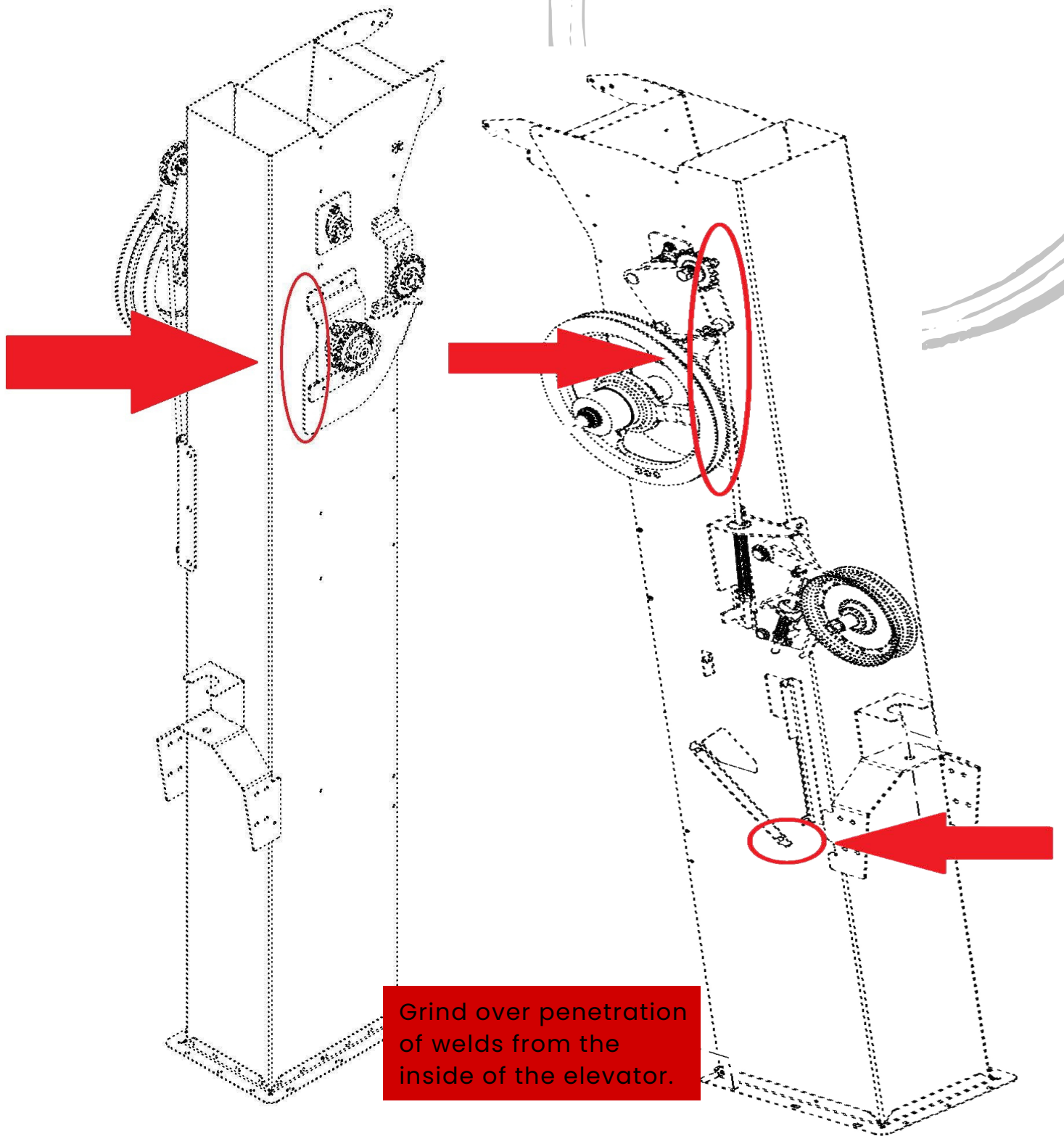
REACH OUT TO OUR TEAM



NOTE: Do **NOT** drill holes in the liner, this picture is just for reference where to drill the OEM elevator.

QUESTIONS?

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QUESTIONS?

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