

# IHLE FABRICATIONS LLC<sup>®</sup>

## INSTALLATION INSTRUCTIONS

### 4 PIECE GRAIN TANK FLOOR LINER

CASE IH<sup>®</sup> LEGACY 1400-2500

P/N: IF1140052F (73399553R)

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  
3/16 Drill Bit  
Rivet Gun  
Silicone/Sealer

#### ITEMS INCLUDED

4 Liner Pieces  
Rivets  
Nuts & Bolts

THANK YOU FOR YOUR BUSINESS

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### 4 PC GRAIN TANK FLOOR LINER

#### Preparing the Combine:

**Step 1:** Remove the bearing and flanges from the right-hand side of the machine.

**Step 2:** Remove drive chain on the left-hand side of the machine.

**Step 3:** Remove 5/16 in flange nuts from around the auger drive end plate.

**Step 4:** From the side, remove augers from machine. (NOTE: auger may be sharp).

**Step 5:** Remove front and rear cross auger covers, ensure they are completely out for full access to grain tank floor. (NOTE: 1400 series has a stand in the middle which will also need to be removed.)

**Step 6:** Remove covers from the grain tank.

**Step 7:** Remove any worn steel that is loose or protruding, you may need to grind or sand smooth in order to install the kit flush with the grain tank bottom.

- Sweep clean auger troughs

**Step 8:** Remove carriage bolts on each end of the trough.

**Step 9:** For 1600 series and later, remove the 2 bolts on the RH side of rear back trough. Remove the 2 bolts on the LH side from the bottom of the front and the rear trough. Remove the 2 bolts behind the unloading auger sump.

**QUESTIONS?**

REACH OUT TO OUR TEAM

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### Installing the Panels:

**Step 1:** The short liner marked 73399553A04 or "Front" fits to the left front auger trough between the grain tank wall and the unloading sump - bolts toward the sump.

**Step 2:** The longer liner marked 73399553A01 or "Front" fits to the front right auger trough, bolt holes toward the sump.

**Step 3:** The short panel marked 73399553A03 or "Rear" fits to the left rear auger trough, between the grain tank and the unloading auger sump, bolts holes toward the sump.

**Step 4:** The longer panel marked 73399553A02 or "Rear" fits to the right rear auger trough, bolts holes toward the sump.

**Step 5:** Insert carriage bolts into correct holes to line up the panels. **Note:** Do NOT tighten the nuts until installation is complete.

**Step 6:** Use a 3/16 drill bit to create holes in the Grain Tank, using the liners as a guide. Secure liner with rivet after each hole is drilled. **NOTE:** Drill and install rivets in a patten around the liner to maintain a tight fit to the auger trough.

**Step 7:** Tighten all bolts.

**Step 8 (Optional):** Use a silicone to seal any and all splices and seams.

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