

IHLE FABRICATIONS LLC[®]

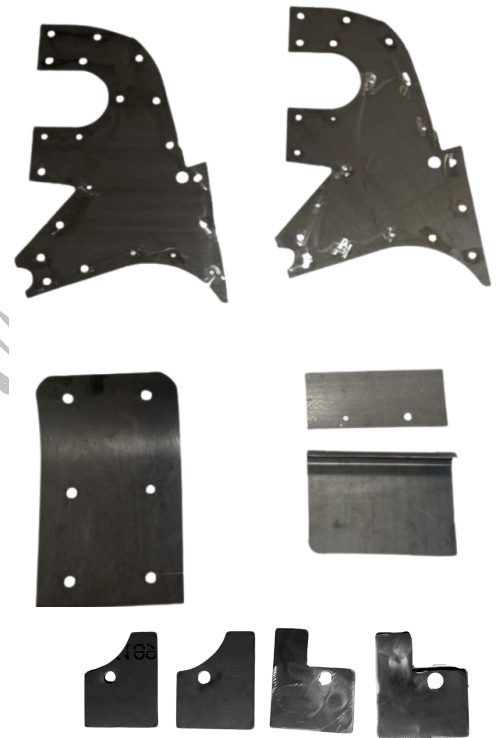
INSTALLATION INSTRUCTIONS

TOP HEAD ELEVATOR LINER 7 PIECE KIT

CASE IH[®] FLAGSHIP SERIES

P/N: IF1124154K (73399556R)

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[®]

WEAR PLATE

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



TOOLS NEEDED

Grinder
Welder
Locking C Clamps

ITEMS INCLUDED

9 Liner Pieces

THANK YOU FOR YOUR BUSINESS

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PH: 515-329-8050

4780 NW 158TH AVE.
POLK CITY, IA 50226

INSTALLATION INSTRUCTIONS

TOP HEAD ELEVATOR LINER

NOTE: This process can be done without removing housing from machine.

Step 1: Line up and clamp each piece in the order shown above and on the following pages.

Step 2: Insert #1 as show below, line it up and clamp it tight to the elevator head. Repeat for #2, #4 & #5. Ensure #4 is flush with the door opening on page 3.

NOTE: If there is a Case reinforcement plate in place of #5, you must remove it prior to installing the liner here.

Step 3: To ensure proper clearance, you will have to grind both sides of the door flush to the hinge, as shown on page 3.

Step 4: Line up part #3 with the door and clamp down. Double check that all parts are lined up and the door works properly.

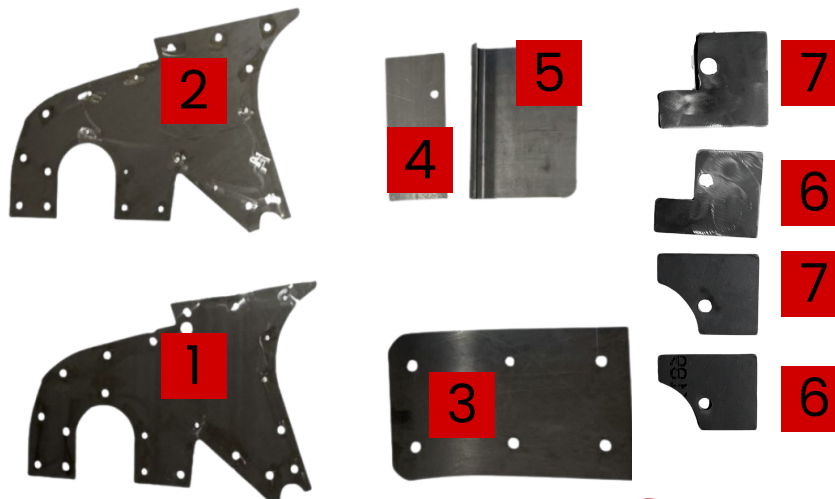
Step 5: Start tack welding the sides of the assembly to hold liners in place.

Step 6: Tack weld all other pieces ensuring everything continues to fit properly and the head is still able to pivot on the housing.

Step 7: After each piece is secure with tack welds, plug weld #1 & 2 through the holes provided.

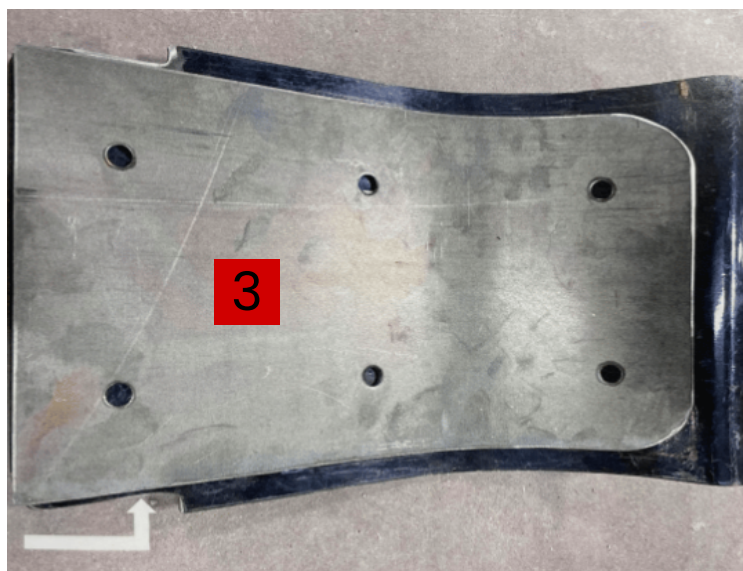
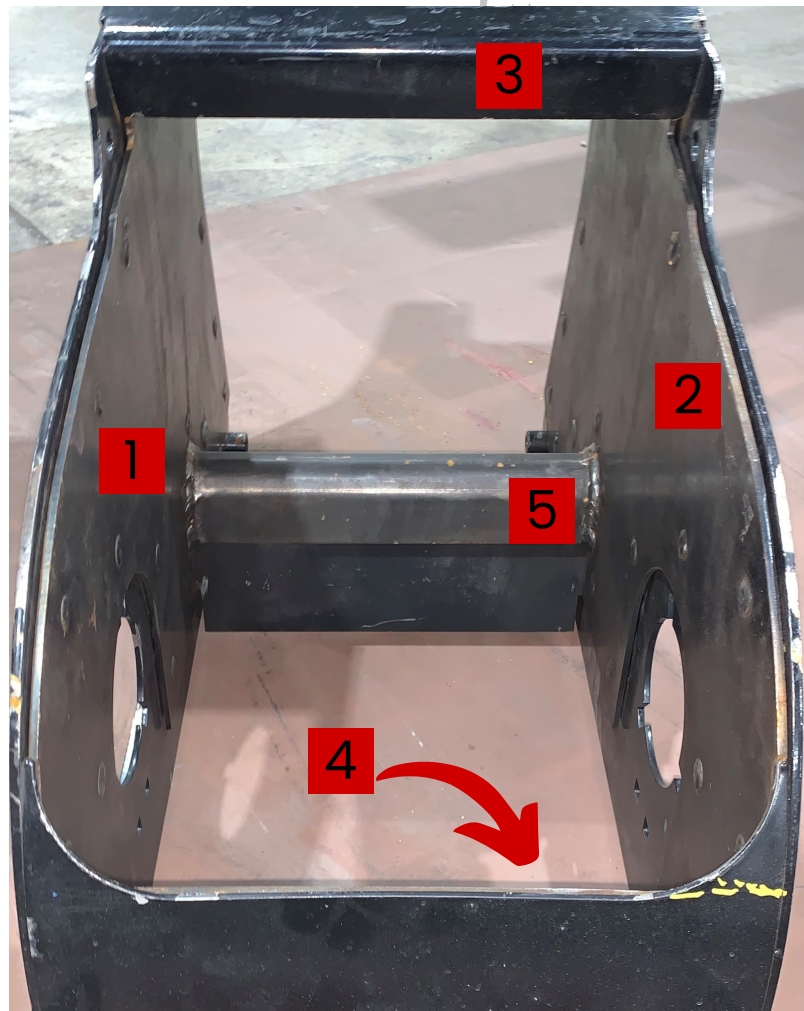
Step 8: Stitch weld #3-5

(Instructions for #6 & #7 found on page 4.)



QUESTIONS?

REACH OUT TO OUR TEAM



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REINFORCEMENT HINGE PLATES

NOTE: When installing the Hinge Pin Plates installer will also need to modify the hinge pin to make it long enough. We recommend welding a washer to one end of the pin and redrilling a hole on the other end to fit the cotter key.

Step 1: Use a clamp to hold the plate tight against the Elevator Head.

Step 2: Stitch Weld along each side, where arrows below indicate.

Step 3: Repeat this for both sides.

NOTE: Depending on the year of the machine you may need the rounded corner or the squared set. Both are provided.



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