

IHLE FABRICATIONS LLC[®]

INSTALLATION INSTRUCTIONS

TRANSITION CONE LINER

CASE IH[®] LEGACY &
MIDRANGE SERIES

P/N: IF11L0075K (73399565R)

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 steel. Enjoy the benefits of guaranteed toughness in our products made with Hardox[®] Wear Plate.



TOOLS NEEDED

Impact Wrench
Die Grinder + Burr Bits
Vice Grips
Line up Punches
Vane Kit
Welder

ITEMS INCLUDED

4 Liner Pieces
50 Nuts
50 Bolts
7 Vanes

THANK YOU FOR YOUR BUSINESS

PH: 515-329-8050

WWW.IHLEFABRICATIONS.COM

4780 NW 158TH AVE.
POLK CITY, IA 50226

INSTALLATION INSTRUCTIONS

TRANSITION CONE LIP LINER

Step 1: Align rear lip on the cone flange. Ensure the wide end of the punched holes is towards the outside of the flange. Line the lips in the center at the two holes which are closer together. Clamp in between the holes.

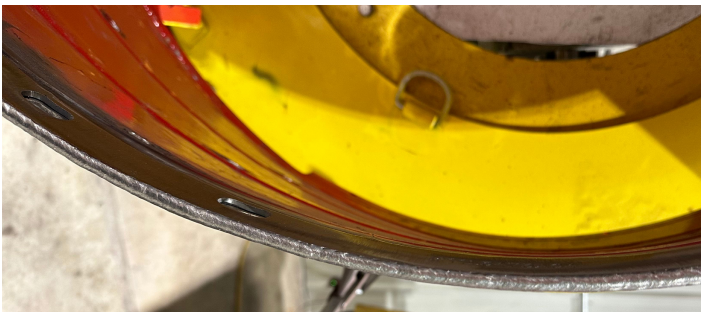
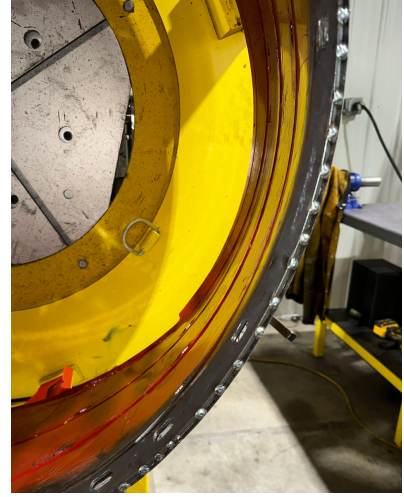
Step 2: Clamp the lip starting from the center going out with as many clamps as necessary to secure the lip to the cone, ensure there are no gaps.

Step 3: Tack weld between each clamp. Approximately every 1"-2".

Step 4: Remove clamps and repeat step 1-4 with the second lip.

Step 5: Fully weld along the entire outside of the lip and flange to secure in place.

Step 6: Fully weld along the entire inside of the lip.



QUESTIONS?

REACH OUT TO OUR TEAM

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TRANSITION CONE LINER

After the Lip Liners are fully welded to the cone, install the rest of the Legacy Transition Cone Liner.

NOTE: When installing the liner into the new cone it may need to be trimmed down using a cutting wheel. There may be a small gap where the two-piece liner meets in the cone, gaps may vary based on the wear of the transition cone.

Step 1: Place one half of the liner in the cone, use the line up punches to align the liner in the cone and loosely bolt it into place. (Only bolt the top 3 holes in each vane line.)

Step 2: Repeat Step 1 with the second half of the liner

Step 3: Ensure the fit is correct, tighten bolts previously placed.
Note: If either half overlaps, cut the overlap off using a grinder and cut off wheel, while it is in place.

Step 4: Remove all of the bolts from one vane line.

Step 5: Place a vane inside the cone. Begin to bolt it in place loosely starting in the center, working your way out. Once all bolts are in place, you can tighten each bolt, again starting in the center, working outward. Repeat this process for every vane. **DO NOT** fully tighten the lip bolts.

Step 6: When the cone is in combine, attached to the cage, tighten the lip bolts.

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