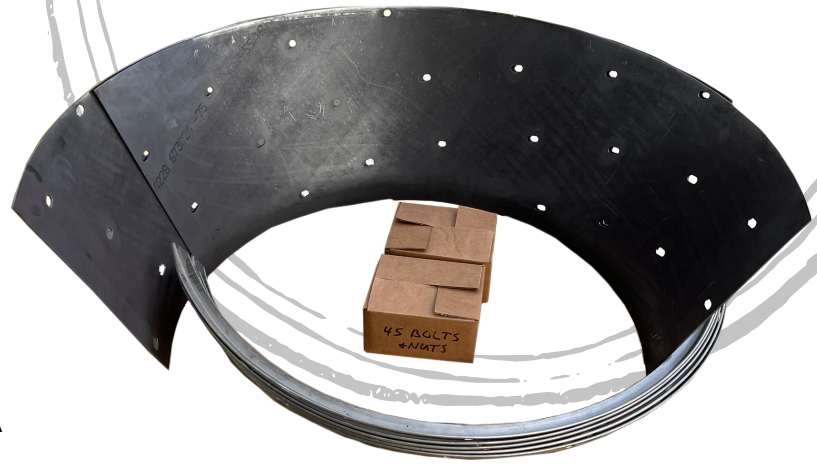


# IHLE FABRICATIONS LLC<sup>®</sup>

## INSTALLATION INSTRUCTIONS

### TRANSITION CONE LINER

CASE IH<sup>®</sup> FLAGSHIP



**P/N: IF1445475K (73399566R)**  
**| IF11244758F (73399584R)**

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<sup>®</sup>

### WEAR PLATE

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



#### TOOLS NEEDED

- Impact Wrench
- Die Grinder + Burr Bits
- 15mm Socket

#### ITEMS INCLUDED

- 3 Liner Pieces
- 47 Nuts
- 47 Bolts
- 5 Vanes

**THANK YOU FOR YOUR BUSINESS**

**PH: 515-329-8050**

[WWW.IHLEFABRICATIONS.COM](http://WWW.IHLEFABRICATIONS.COM)

4780 NW 158TH AVE.  
POLK CITY, IA 50226

## INSTALLATION INSTRUCTIONS

### LIP LINER - (73399584R)

**Step 1:** Clamp the lip liner to the existing lip, starting in the center working to one side.

**Step 2:** Tack weld the side that is clamped tight.

**Step 3:** Repeat step 1& 2 for the opposite side.

**Step 4:** Fully Weld around the entire lip starting with each end, then fully weld the outside/ bottom, and finish with the inside.

**Step 5:** Gind inside weld so there are no obstructions when installing.

### 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.

**When facing the Transition Cone, the notch in the cone liner should be at 11 O'clock. Seams should be at 12 & 6 O'clock.**

**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 tighten the lip bolts.

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

**QUESTIONS?**

**REACH OUT TO OUR TEAM**