

# IHLEFABRICATIONS<sup>LLC</sup>

## INSTALLATION INSTRUCTIONS

### VERTICAL UNLOAD LINER (5 PIECE)

CASE IH® FLAGSHIP 30, 40, 50 SERIES

P/N: IF1100051K (73399567R)

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® 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

Welder	Impact
Chrome Socket Set	2 x 4
3/8 Ratchets	Porta Power
Breaker Bar with Tilt	Grinder/Scrapper
Ratchet Strap	

#### ITEMS INCLUDED

5 Liner Pieces

THANK YOU FOR YOUR BUSINESS

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## INSTALLATION INSTRUCTIONS

### VERTICAL UNLOAD LINER

**Step 1:** Remove all bolts holding the cast ring in place. **NOTE:** This can be done without completely removing the elbow, but the unload tube and the auger must be removed.

With the elbow folded in, remove half of the bolts holding the cast ring in place, then rotate the elbow out and remove the back half. Ensure the bolts in the plates above the ring are fastened when folding the elbow in or out.

**Step 2:** Remove the gear box from the bottom of the vertical unload.

**Step 3:** Remove the auger by slowly spinning it out of the machine.

**Step 4:** Remove the Gear Box Bracket and the Inspection Door

**Step 5:** Scrape out any debris or dirt that may prevent the liner from sitting flush against the vertical unload.

**Step 6:** Slide in the liner from the bottom – you may need to use a ratchet strap to pull the liner closed to fit into the vertical unload more easily – line up bolt holes before it is completely in as it is much harder to spin once fully inserted.

**Step 7:** Reinstall the cast ring, bolting it back in through the new steel liner.

**Step 8:** Use a Porta Power or several 2 x 4's to push the liner tight and flush against the vertical unload and tack weld the liner in place, then tighten the bolts.

**Step 9:** Fully weld the liner in place so there is no edge exposed.

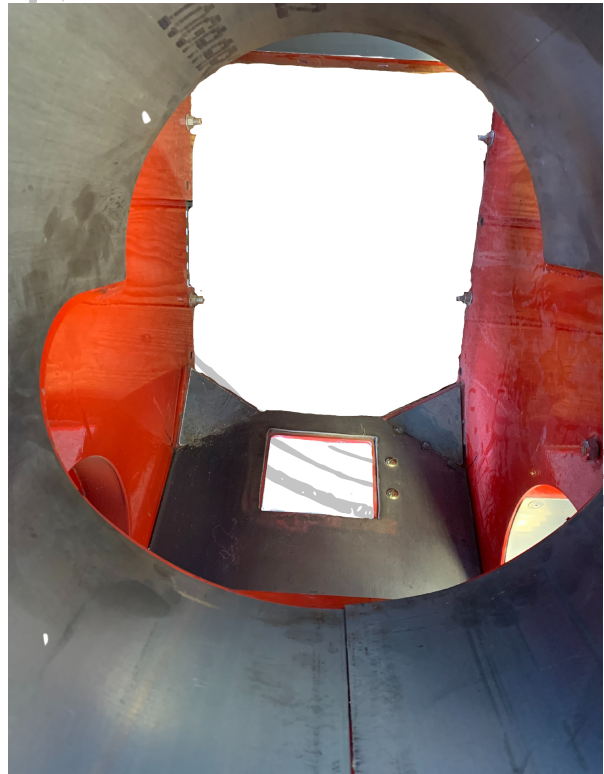
**Step 10:** Fully weld the liner seam together, to protect from grain getting between the liner and the vertical unload.

**Step 11:** Insert the wear plates at the bottom of the grain tank. Line up all remaining pieces, clamp them tight to the machine, then fully weld together.

**Step 12:** Completely reassemble inspection door and gear box.

**QUESTIONS?**

**REACH OUT TO OUR TEAM**



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