

# IHLE FABRICATIONS LLC<sup>®</sup>

## INSTALLATION INSTRUCTIONS

### CURVED PLATE & CORNER PLATE FOR FRONT FRAME MODULE

#### CASE IH<sup>®</sup> FLAGSHIP SERIES

**P/N: IF1440076F (73399581R) |  
IF1364474F (73399579R)**

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

Grinder  
Welder  
Locking C-Clamps

#### ITEMS INCLUDED

1 Liner Piece

THANK YOU FOR YOUR BUSINESS

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## INSTALLATION INSTRUCTIONS

### CURVED PLATE

**Step 1:** Remove the old, curved plate by using a grinder to cut out welds. Use the grinder to make surface smooth for new welds.

**Step 2:** Place liner in position with the bent corner on your left.

**Step 3:** Ensure the liner is flush with the corner and flush with the top, then tack weld the side of the liner to the frame.

**Step 4:** Tack weld the bottom of the liner to the frame every 6 inches all the way around. \*\*You may need to use clamps to hold the liner tight against the frame as you weld. Keep an eye on the opposite end of the liner, you may need to pull it forward as you tack weld across to make sure it stays lined up with the frame.

**Step 5:** After the liner is tack welded in place, go back across and stitch weld every 6 inches to secure.

**Step 6:** Weld from behind at the corners and in the center of the plate to the notch on the frame.

### CORNER PLATE

**Step 1:** Place 4x7 corner plate against upper left-hand corner of the front frame and trace.

**Step 2:** Use a grinder to cut out along the trace lines.

**Step 3:** Line up new corner plate to the frame and clamp in place

**Step 4:** Tack weld into place

**Step 5:** Fully weld around the edges to secure.

**QUESTIONS?**

REACH OUT TO OUR TEAM