



IHLE FABRICATIONS WEAR PARTS GREEN CATALOG

Wear Parts by Ihle Fabrications, LLC were created by farmers and made from high-quality steel. All parts are backed by our 24-Month Warranty.

IHLE FABRICATIONS LLC[®]

Call us or visit our website to order.

ABOUT US

IHLEFABRICATIONSLLC®



RESTORE. PROTECT. REPAIR.

Ihle Fabrications is a farmer-built company in Polk City, IA that is a leading provider in manufacturing agriculture wear parts for combines and other equipment. Started in 2002 on a family farm, Ihle has since grown into a Certified Case IH Reman partner with over 400 implement customers, 300 ag part offerings, 55 employees and four countries in which it sells.

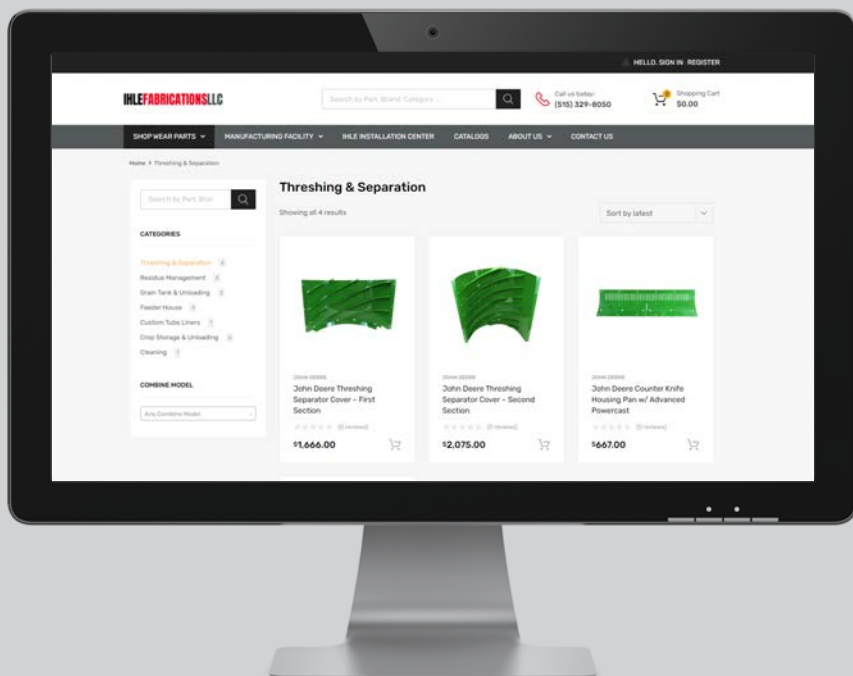
For more information about Ihle Fabrications, visit www.IhleFabrications.com.

Ihle Fabrications manufactures wear parts for all brands, makes and models of combines and grain tanks. To learn more about each of our parts, visit our website at www.IhleFabrications.com.

Ihle parts are made in the USA and with quality wear-resistant materials. Parts are fabricated in our 125,000-square foot manufacturing facility in Central Iowa.



JOHN DEERE



How to Purchase Ihle Fabrications Wear Parts



Scan the QR Code to
start buying your
wear parts now!

BOOST EFFICIENCY & DURABILITY WITH **CUTTING-EDGE** STEEL

Harvesting environments can be very demanding, requiring heavy loads, abrasion, and harsh conditions making the choice of material used in parts essential to the performance and durability of a combine.

Wear Parts by **Ihle Fabrications, LLC** are made for farmers with high-quality steel options including Hardox®, Strenx®, and various stainless-steel grades.

HARDOX® WEAR PLATE

The unmatched strength of Hardox® is an industry leading wear-resistant steel manufactured by SSAB and its key attributes make it an excellent choice for harvesting applications.

Unmatched Strength

Allows for increased load-bearing capacity and structural integrity during intense harvesting operations with a nominal hardness of 500 HBW and a yield strength of approximately 1200 MPa.

Abrasion

Its wear-resistant properties protect combine components from wear, impact, and material loss while extending durability, reducing maintenance costs, and improving overall machine performance.

Reduced Weight

Hardox® is lighter weight than traditional steels, contributing to fuel efficiency, and increased payload capacity.

STRENX® PERFORMANCE STEEL

Strenx®, another high-strength structural steel from SSAB, offers specific benefits for combines.

Exceptional Strength

Exceptional strength of 1100 MPa, provides extraordinary structural integrity and load-bearing capabilities and provides higher resistance to bending, twisting, and other mechanical stresses experienced during harvesting operations.

Formation and Weldability

Strenx® offers ease of fabrication and repair with the ability to be welded using common methods without being affected by high strength and retaining good form.

Optimal Toughness

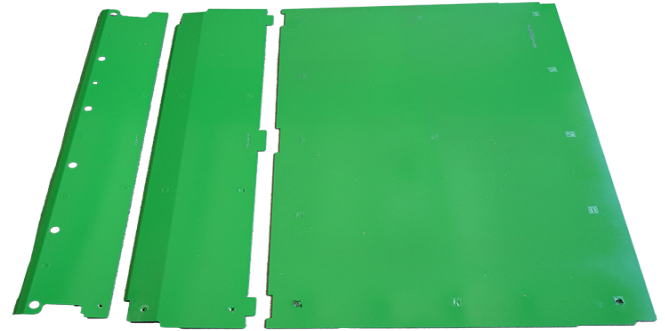
A minimum yield strength of 100 ksi enables it to withstand impacts and shocks inherent in the harvesting environment, ensuring reliable performance and reducing the risk of downtime due to equipment failures or component damage.

By choosing the right steel option for combine components, farmers and Dealerships can enhance productivity, reduce maintenance costs, and achieve optimal results in the field.

Feeder House Liner Kit – 3-Piece Floor Kit

Our John Deere 3-piece feeder house floor kits are available for a variety of combine models. All feeder house floor liners are made with Hardox® 450 wear plate for long lasting wear on your feeder house floor; simply weld on top of the original floor. For fitment of your specific combine, our team will need your serial number and photo of the front of your combine feeder house.

Ihle Part Number	Material	Model Fitment
IF2530000K	Hardox® 450	9660STS, 9670STS, 9760STS, 9770STS, 9860STS, 9870STS, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790



Feeder House Liner - 9600

Our John Deere feeder house floor liner, designed for the 9600 combine model. This feeder house floor is made with Hardox® 450 wear plate for long last wear on your feeder house floor, and simply plug welds to the top of the original floor.

This liner fits John Deere OEM AH159704.

Ihle Part Number	Material	Model Fitment
IF2AH159704L	Hardox® 450	9600, 9610, 9650



Feeder Drum Wear Plate - 6-Piece Kit

Ihle's feeder drum 6-piece wear plates are designed to fit the 10" drum on an OEM and provide additional support where the feeder chain rubs and causes wear on the feeder drum. This part lines John Deere OEM AH216876 to extend the life of your feeder drum.

Ihle Part Number	Material	Model Fitment
IF2AH216876K	Strenx® 110	9670STS, 9770STS, S650, S660, S670, S680, S690, 9670



Feeder Drum Wear Plate - 8-Piece Kit

Made with Strenx® steel, Ihle's 8-piece, 8" diameter feeder drum wear plates are designed to fit the OEM and provide additional support where the feeder chains rub and cause wear on the feeder drum. This part lines John Deere OEM AXE87970 to extend the life of your feeder drum. This part comes as a full kit - 4 sets of wear plates cut in half for a total of 8 pieces.

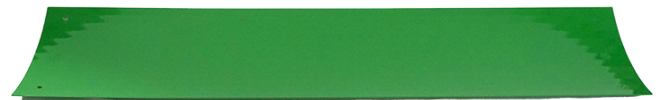
Ihle Part Number	Material	Model Fitment
IF2AXE87970K	Strenx® 110	S7 600, S7 700, S7 800, S7 900, S650, S660, S670, S680, S690, S760, S770, S780, S790



Stone Trap Door Liner Kit

The Stone Trap Door Liner is made with material that is more robust and abrasion resistant. Protect your combine's interior area with our stone trap door liner to catch stones before they enter your combine's feed section. This part lines John Deere OEM AH156157 and AXE60027 to give you longer wear on your door.

Ihle Part Number	Material	Model Fitment
IF2AH156157L	Hardox® 450	9650STS, 9660STS, 9670STS, 9750STS, 9760STS, 9770STS, 9860STS, 9870STS, 9880STS, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790

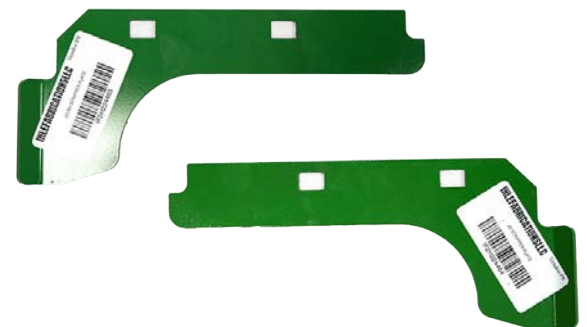


Feeder House Stripper Plate (RH & LH)

Made with Hardox® 500 Tuf, Ihle's feeder house stripper plates are designed to replace the OEM and provide additional support in the John Deere feeder house. These parts are sold individually, but require both the right and left hand stripper plate to fully complete your repair.

This part can line or replace OEM H224463 (RH) and H224464 (LH).

Ihle Part Number	Material	Model Fitment
IF2H224463	Hardox® 500 Tuf	9670STS, 9770STS, 9870STS, S530, S540, S550, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790
IF2H224464	Hardox® 500 Tuf	9670STS, 9770STS, 9870STS, S530, S540, S550, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790

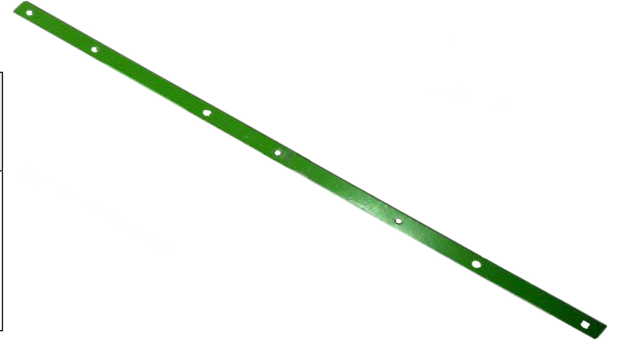


Backup Strip Discharge Accelerator Beater Kit

Sold individually, this John Deere backup strip replaces the OEM on green combines. You can count on our replacement backup strip discharge accelerator beater to take the harshness this threshing piece needs to withstand in your combine.

Replaces OEM H165408.

Ihle Part Number	Material	Model Fitment
IF2H165408	Hardox® 450	9650STS, 9660STS, 9670STS, 9750STS, 9770STS, 9860STS, 9870STS, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790

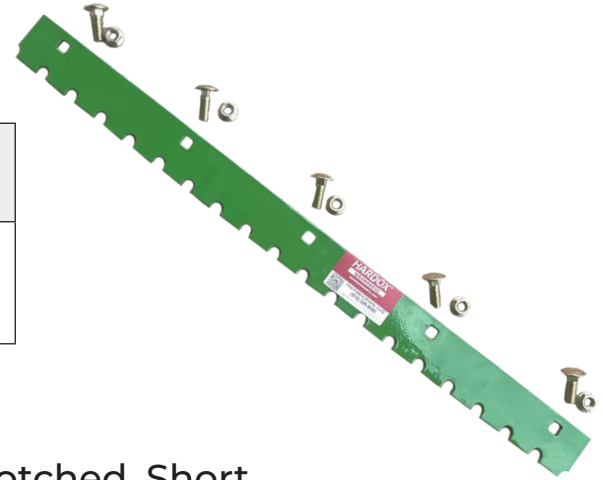


Discharge Beater Wear Strip Kit - Long

Sold individually with hardware, this discharge beater wear strip bar replaces the OEM on green combines. Each wear strip comes with 5 steel square neck carriage bolts and 5 steel serrated flange lock nuts.

Replaces OEM H236284.

Ihle Part Number	Material	Model Fitment
IF2H236284K	Hardox® 500 Tuf	9770STS, S650, S660, S670, 9670



Feeder Accelerator & Discharge Beater Blade - Notched, Short

These notched wear plates are made of Hardox® 500 Tuf for John Deere S Series and STS Series Combines. This kit contains (1) wear plate, (2) M10 x 30 carriage bolts and (2) M10 flanged serrated nuts.

Replaces OEM H165407.

Ihle Part Number	Material	Model Fitment
IF2H165407K	Hardox® 500 Tuf	9470STS, 9560STS, 9570STS, 9650STS, 9660STS, 9670STS, 9770STS, 9860STS, 9870STS, S540, S550, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790



Thresher Return Auger Tube

This combine thresher return auger tube replaces the OEM to help extend the life and durability of your machine.

This part is a replacement for John Deere OEM AXE17790.

Ihle Part Number	Material	Model Fitment
IF2AXE17790K	14 Gauge Mild Steel	S680, S685, S690, S780, S785, S790



NOTES

Threshing Separator Cover - First Section

This Ihle wear part is one of our best sellers. Our replacement rotor door cover for the threshing separator is built from Hardox® 500 Tuf, steel that is 2.5 times harder than the OEM, to enhance protection in this heavy wear area helping your combine last acre after acre.

This part is a replacement for John Deere OEM AH208967 or AH208966.

Ihle Part Number	Material	Model Fitment
IF2AH208967	Hardox® 500 Tuf	9650, 9660, 9670, 9750, 9770, 9860, 9870, 9880, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790



Threshing Separator Cover - First Section Patch

Ihle's liner is an OEM enhancement for your Threshing Separator Cover, First Section. This patch kit for the first section of your separator cover is made of Hardox® 450. Recommended 1 to 3 patches per machine (3 will cover the entire separator cover). Simply cut this part to the size you need to cover your worn out area, or plug weld 3 on the entire cover for added protection.

Lines OEM AH208967 and AH208966.

Ihle Part Number	Material	Model Fitment
IF2AH208967L	Hardox® 450	9650, 9660, 9670, 9750, 9770, 9860, 9870, 9880, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790

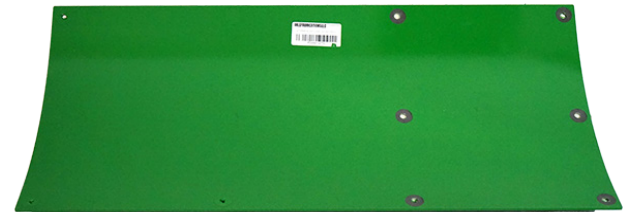


Threshing Separator Cover - Second Section Patch

This wear part is a patch for your combine's OEM Threshing Separator Cover. This second section patch kit is made of Hardox® 450 which means this door can withstand the toughest harvest conditions. Order a quantity of 3 to plug weld onto the entire separator cover, or order 1 or 2 and cut what you need to repair.

Lines OEM AXE10277, AXE24648 and AH233235.

Ihle Part Number	Material	Model Fitment
IF2AXE10277L	Hardox® 450	S680, S685, S690, S780, S785, S790



Ihle Fabrications Parts will carry a 24-month warranty from date of sale (assumed to be the install date) by Ihle to customer.

Visit our website at www.IhleFabrications.com to see full warranty policy details.

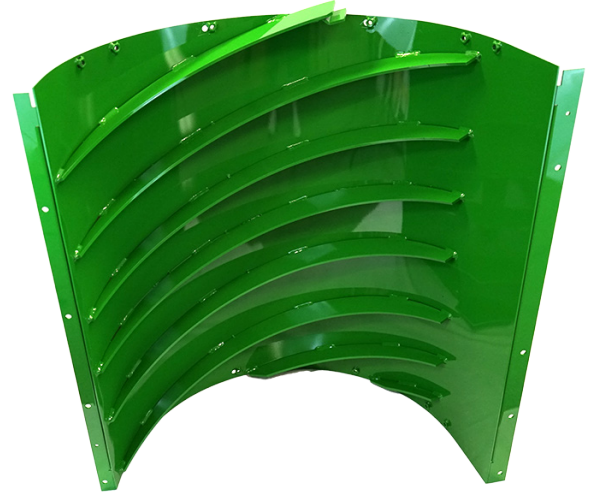
Threshing Separator Cover - Second Section

This wear part is an OEM replacement of the Threshing Separator Cover. This second section is made of Hardox® 500 Tuf, giving this part a thicker shell than the OEM, helping this door to withstand the harshest harvest conditions.

Replaces OEM AXE10277 or AH233235.

Ihle Part Number	Material	Model Fitment
IF2AXE10277	Hardox® 500 Tuf	S680, S685, S690, S780, S785, S790

***This part comes with the hardware needed for installation.**



Threshing Separator Cover - Second Section - Tailings Return

Ihle's newest wear part is an OEM replacement of the Threshing Separator Cover, Section Section with Tailings Return. This second section is made of Hardox® 500 Tuf which means this door is longer lasting than the OEM and can handle the harshest harvest conditions.

Replaces OEM AXE24648 or AXE24647.

Ihle Part Number	Material	Model Fitment
IF2AXE24648	Hardox® 500 Tuf	S680, S685, S690, S780, S785, S790

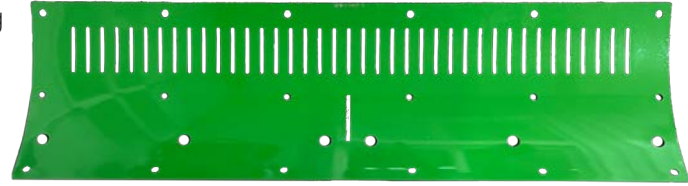
***This part comes with the hardware needed for installation.**



NOTES

Counter Knife Housing Pan w/ Advanced Powercast

Ihle has created a liner for your OEM counter knife housing pan. Made of Hardox® 450, this liner will help extend the life of the residue disposal area of your combine, and plug welds into place for easy installation.



Lines OEM AXE15810.

Ihle Part Number	Material	Model Fitment
IF2AXE15810L	Hardox® 450	S670, S680, S685, S690, S760, S770, S780, S790

Right Hand Separator Rail Cover - Wide

Ihle has created a liner for your threshing section. Our right hand Separator Rail Cover Wide plate is made of Hardox® 450 wear steel, one of the most abrasion resistant material on the market. This part is your first section of replacement rail, helping you get more life out of your combine for less.

Replaces OEM HXE149742.



Ihle Part Number	Material	Model Fitment
IF2HXE149742	Hardox® 450	S530, S540, S550, S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790

Right Hand Separator Rail Cover - Narrow

The right hand separator rail cover - narrow - is the second section of rail replacement in your threshing area. The narrow plate cover is made of Hardox® 450 wear steel, one of the most abrasion resistant material on the market, allowing your combine to go further while spending less.

Replaces OEM HXE149741.



Ihle Part Number	Material	Model Fitment
IF2HXE149741	Hardox® 450	S650, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790

Auger Grain Bed Liner

Shoe Grain Supply Auger Trough Liner Kit

Sold individually, this liner simply lies on top of the OEM and rivets into place to protect your auger trough in the grain bed auger housing area of your combine. 4 liners will completely line your grain bed area.

Lines OEM AH146655.



Ihle Part Number	Material	Model Fitment
IF2AH146655K	14 Gauge Stainless Steel	9510, 9610

***This part comes with the hardware needed for installation.**

Clean Grain & Return Grain

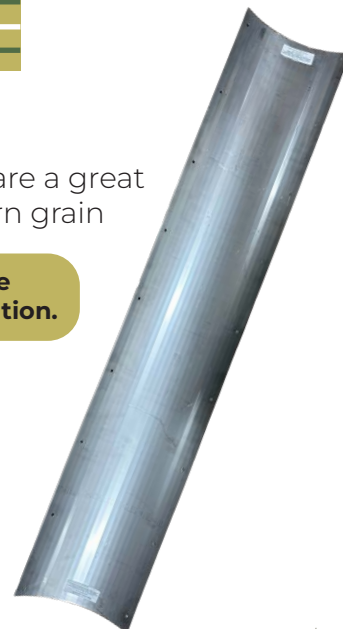
Clean Grain Trough Liner

Seeing a lot of wear or holes in the clean grain return grain system? Ihle's liners are a great option for a quick and low cost repair. Line the inside of the clean grain and return grain troughs with our stainless steel liner.

Lines OEM AXE15954.

***This part comes with the hardware needed for installation.**

Ihle Part Number	Material	Model Fitment
IF2AXE15954K	14 Gauge Stainless Steel	S650, S660, S670, S670HM, S680, S680HM, S690HM, S760, S770, S780, S790



Bubble Ups

Bubble-Up Liner Kit - Extended Length 53-1/4" x 12"

Line your bubble-up auger tube with our easy-to-install Ihle Bubble-Up Liner Kit. Simply remove the auger, slide the steel liner in place and bolt down. Get more combines through your shop without the time, expense and hassle of replacing the entire OEM tube.

Lines OEM AXE56594.

Ihle Part Number	Material	Model Fitment
IF2AXE56594K	12 Gauge Steel	S670, S680, S690, S780, S790



Bubble-Up Liner Kit - Length 45" x 11"

If you're replacing your incline auger, you will want to add this bubble-up liner to your installation process. Give your combine added protection for the next harvest season.

Lines OEM AH219094.

Ihle Part Number	Material	Model Fitment
IF2AH219094K	12 Gauge Steel	9550, 9560STS, 9570STS, 9650, 9650STS, 9660, 9660STS, 9670STS, 9750STS, 9760STS, 9860STS, S650, S660, S670



Bubble-Up Liner Kit - Length 45" x 12"

This bubble-up liner kit was made for the STS and S Series John Deere combines. Bubble up liners help protect your combine's auger tubes from the wear and tear of everyday harvest. Kit instructions and hardware needed for the installation are included.

Lines OEM AXE56593.

Ihle Part Number	Material	Model Fitment
IF2AXE56593K	12 Gauge Steel	9770STS, 9870STS, 9880STS, S670, S680, S690, S760, S770, S780



Bubble-Up Liners

This bubble-up liner kit is easy to install and ready to ship. Help your combine by lining the auger tube with a steel slide-in liner that will extend the life of the OEM.

This liner fits John Deere OEM AH149186 and AH135563.

Ihle Part Number	Material	Model Fitment
IF2AH135563K	12 Gauge Steel	9400, 9500, 9510, 9600, 9610



Grain Tank Liners

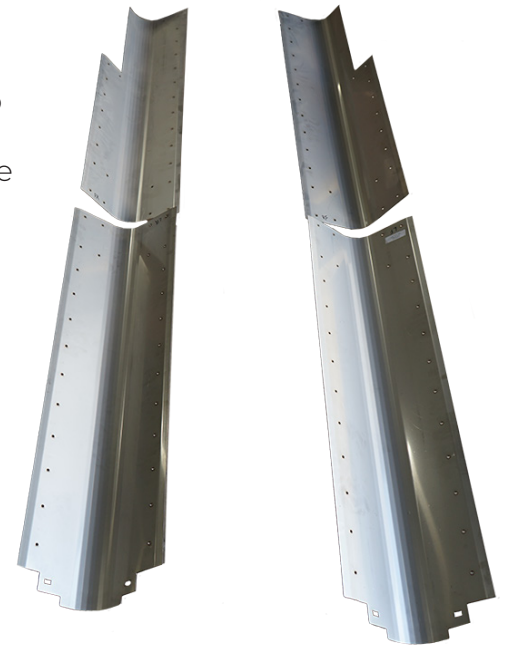
Grain Tank Auger Liner

Line your grain tank with our easy-to-install grain tank liner kit. Built to OEM specifications, this liner rivets in and extends the life of your grain tank by covering up wear and tear, and holes to help your grain storage system work seamlessly.

Replaces OEM AH168093.

Ihle Part Number	Material	Model Fitment
IF2AH168093K	14 Gauge Stainless Steel	9400, 9410, 9450, 9500, 9510, 9550, 9550SH, 9560, 9560SH, 9600, 9610, 9650, 9650CTS, 9660, 9660CTS

***This part comes with the hardware needed for installation.**



STS Grain Tank Floor Liner

Ihle grain tank liners are made of stainless steel which means you do not have to worry about moisture and rotting beneath the floor of your grain tank like you would with a poly liner. Easy to install and built to extend the life of the OEM.

Lines OEM AXE56760.

Ihle Part Number	Material	Model Fitment
IF2AXE56760K	14 Gauge Stainless Steel	9660STS, 9670STS, 9760STS, 9770STS, 9860STS, 9870STS, 9880STS, S650, S660, S670, S670HM, S680, S680HM, S690, S690HM, S550

***This part comes with the hardware needed for installation.**



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Augers

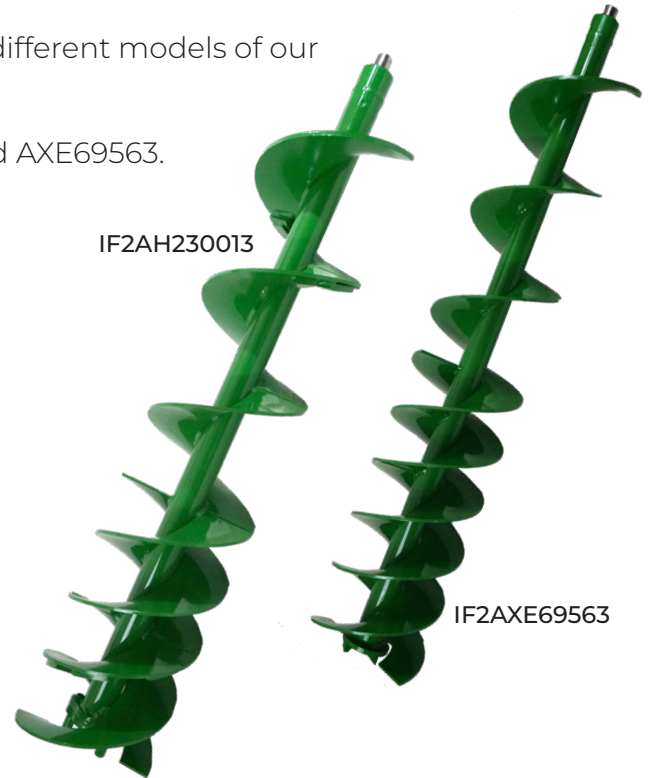
Extended Wear Bubble-Up Auger

Ihle's long anticipated bubble-up auger is ready! This auger is made with Hardox® 450 steel flighting - a material 2.5 times stronger than the OEM for an extended wear life on this heavily relied upon combine part. Pre-balanced before shipping, and comes with Ihle's 24-month warranty, you can count on this Ihle part to keep you up and running this fall.

To accommodate your combine serial number, Ihle offers 3 different models of our bubble-up auger.

This part replaces John Deere OEM AH230013, AH218485 and AXE69563.

Ihle Part Number	Material	Model Fitment
IF2AH230013	Hardox® 450	9770, 9870, S660, S670, S680, S685, S690, S760, S770, S780, S785, S790
IF2AH218485	Hardox® 450	9450, 9550, 9560, 9650, 9660, 9650STS, 9660STS, 9670STS, 9750STS, 9760STS, 9860STS, S650, S660, S670, S680, S685, S690, S760, S770
IF2AXE69563	Hardox® 450	S660, S670, S680, S685, S690, S780, S785, S790



Chopper Outlet

S-7 Series Chopper Outlet Housing Liner Kit

Ihle's chopper outlet housing floor liner kit is more robust, dent and abrasive resistant. Line your John Deere combine chopper outlet housing with our kit. Made of 3 pieces of steel - 2 side liners and 1 large floor liner - this kit will enhance your chopper outlet wear life. Simply plug weld this part to the OEM for easy installation.

This liner fits John Deere OEM AXE78535.

Ihle Part Number	Material	Model Fitment
IF2AXE78535K	Hardox® 450	S760, S770, S780, S785, S790



Innovation in manufacturing fabrication!

Ihle Fabrications employs a dedicated team of professionals at our Central Iowa Facility, who are looking to continuously create innovative solutions to lessen grain loss and extend wear in combines.

We are committed to delivering cutting-edge solutions that are tailored to meet the evolving demands of the agricultural landscape. And with today's economic backdrop, our parts assume greater significance, serving as an indispensable asset for farmers navigating operational challenges.

At Ihle Fabrications, we want to be your trusted ally and partner in the farming community, with a steadfast dedication to advancing agricultural productivity and sustaining affordability.

With that in mind, watch for these and other great wear parts, coming soon ...

John Deere Feed Plate - Narrow Seal (Replaces OEM H173904)

- Threshing area replacement piece made out of stainless steel

Feeder Floor - Full Liner (Replaces OEM H174680)

- Made of Hardox® for better wear than the OEM

Feeder House Floor - RH Side, Wide (Replaces OEM H203561)

- Replacement part for John Deere Feeder House

Feeder House Floor Liner - LH Side (Replaces OEM H212186)

- Replacement part for John Deere Feeder House

Feeder House Floor - Level Land (Lines OEM H214837)

- Front feeder house floor plate replacement

LH Floor Plate (Replaces OEM H203562)

- A direct OEM replacement part made of better steel

Round Bar Concaves - Front (Replaces OEM AXE28955)

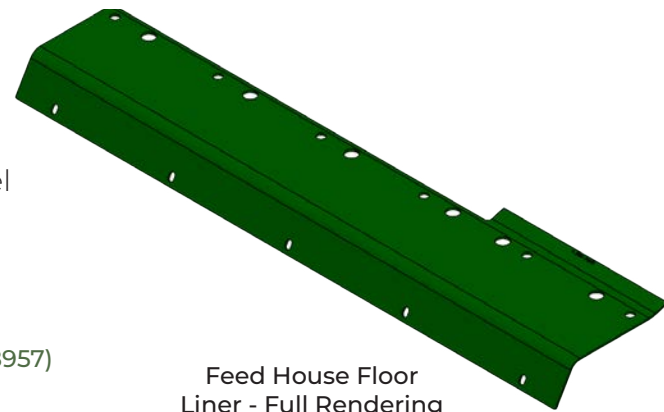
- Concaves made Hardox® tough

Round Bar Concaves - Mid Rear (Replaces OEM AXE28957)

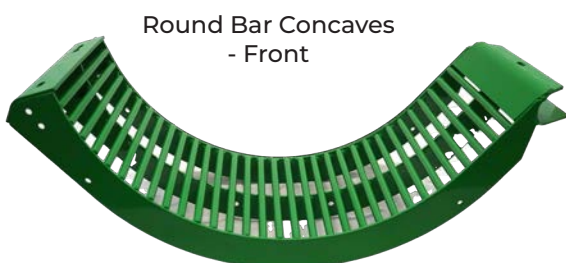
- A direct OEM concave replacement part



Feed Plate - Narrow Seal Rendering



Feed House Floor Liner - Full Rendering



Round Bar Concaves - Front



Round Bar Concaves - Mid Rear



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