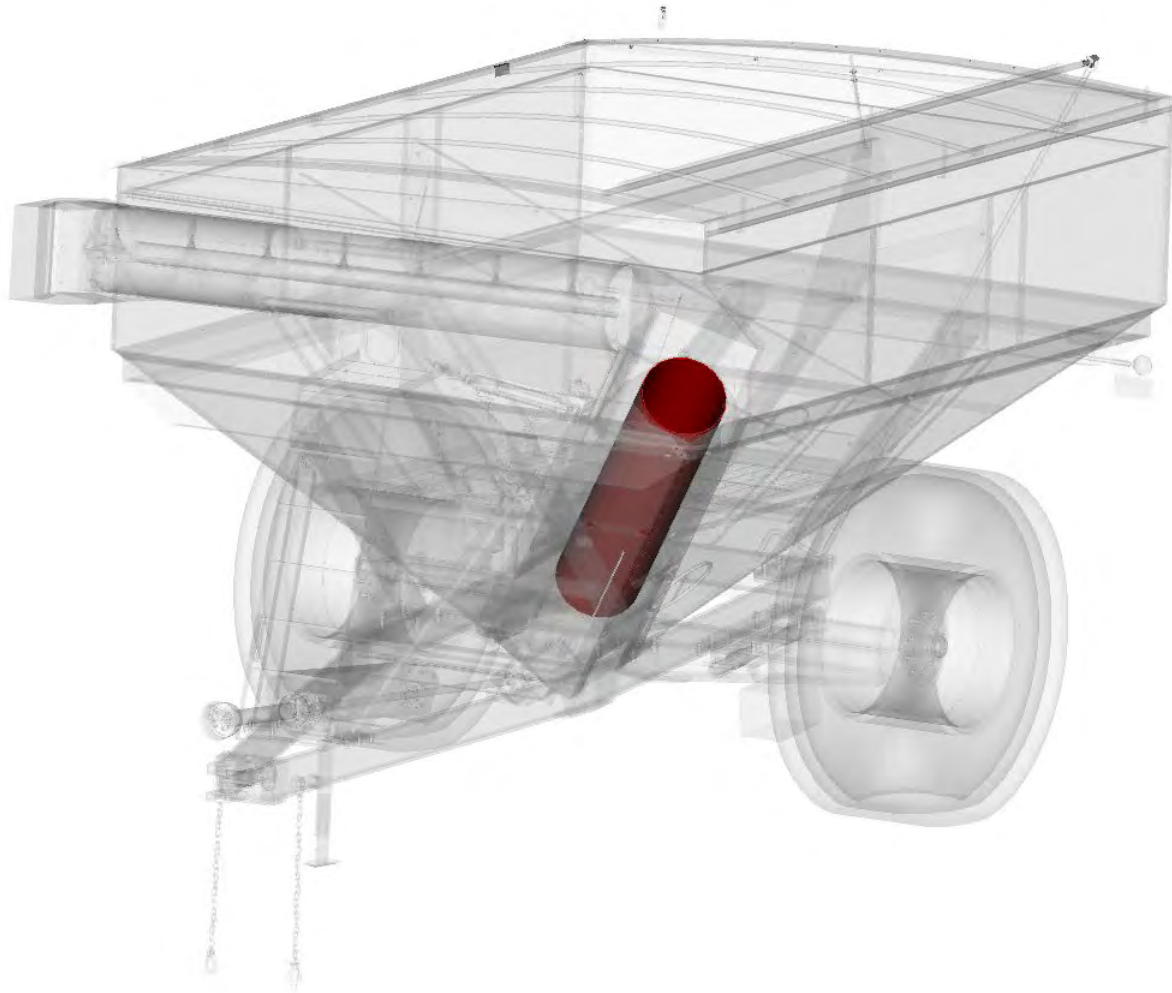




# LOWER AUGER TUBE LINER INSTALLATION



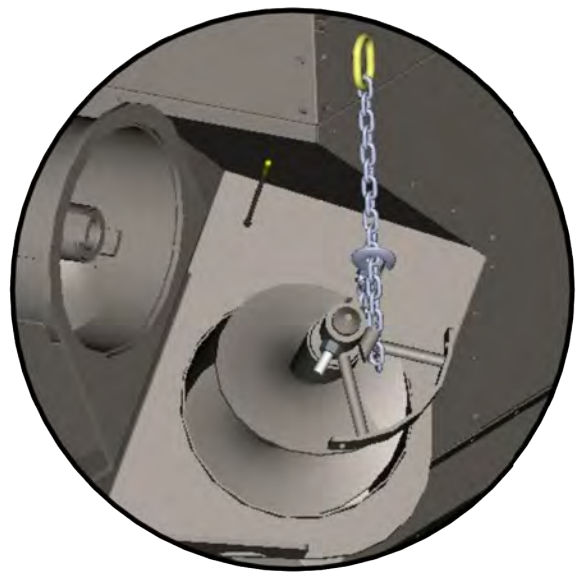
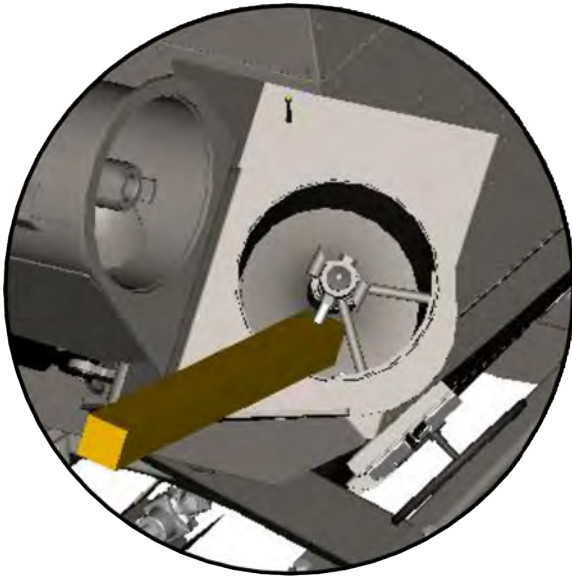
Tools Needed : 9/16 Wrench



Unbolt the Hanger Bushing Assembly. Use a 9/16" wrench to remove the 3/8" x 1-1/4" hex head bolts. Keep the 3/8" bolts and washers, they will be used in a later step.

## Installation

Tools Needed : 4x4 Post,  
Overhead hoist, Chain

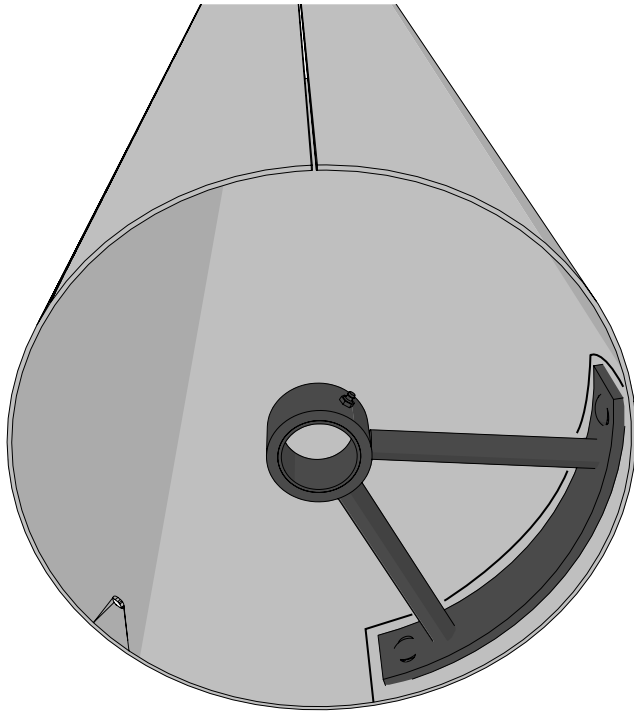


Remove the lower auger. Place one end of a 4x4 post under the threaded end of the drive dog bolt and pry against the outer diameter of the auger tubing to lift the auger off the gearbox shaft. Once lifted above the lower auger housing, attach a chain to the lower auger and a forklift. Slowly raise the lower auger out of the tube. If your forklift will not raise high enough, only go half way up, and regrip. Set the lower auger on the ground out of the way.

Tools Needed : 1-1/2" Wrench

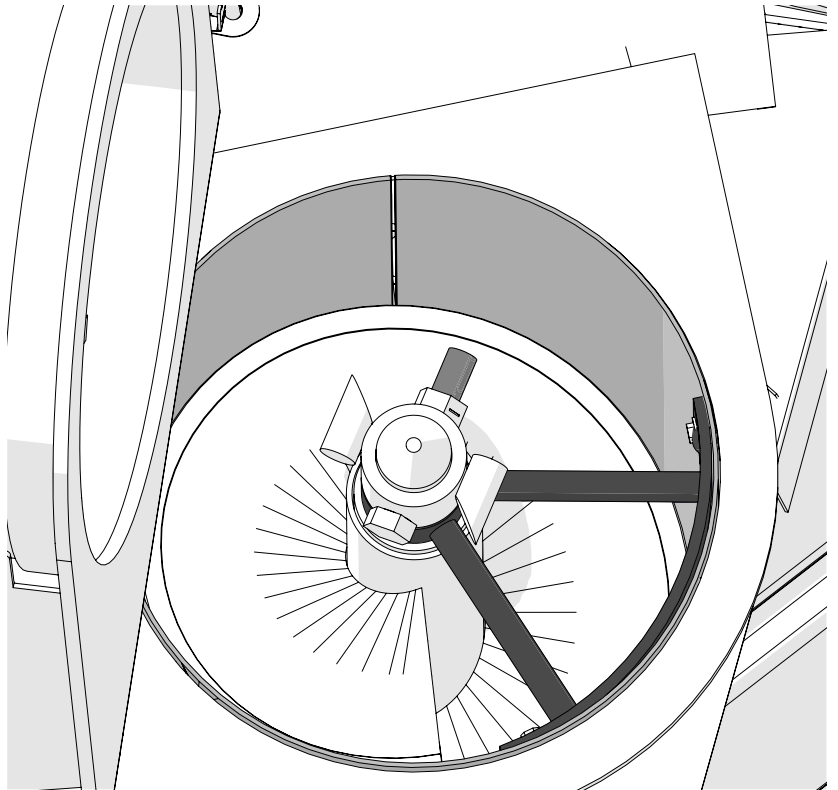
Remove the 1" hex bolt and nut from the lower auger.  
Remove the Drive Dog and the Hanger Bushing Assembly.

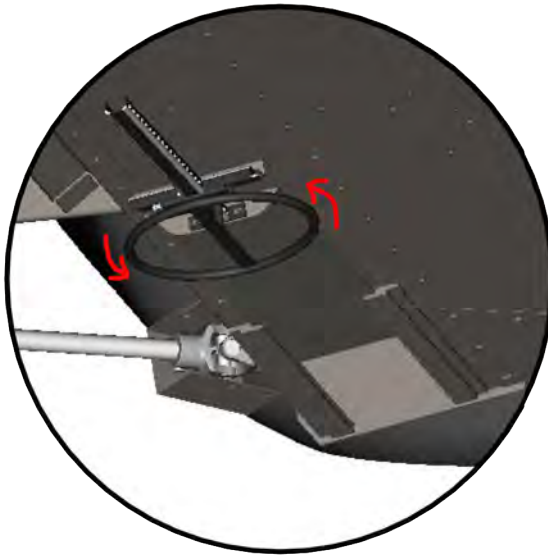




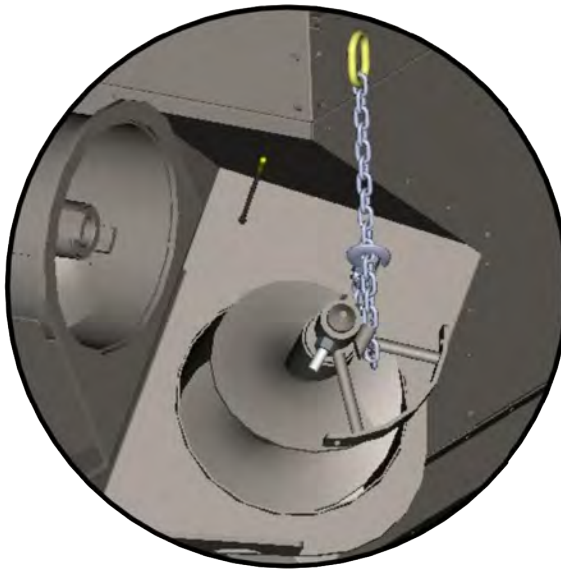
Put the hanger bushing assembly where it will be needed when the liner is installed in the cart (shown below). Trace a line a 1/4" around your auger bushing assembly. Cut around the line. Once cut, remove any burs around the edge that was cut.

Place the replacement liner inside of the tube. Align the top of the liner 1/2" below the top of the tube. Hold the Auger Bushing Assembly in its place. Make sure the liner is placed so that it will not interfere with the reinstallation of the Hanger Bushing Assembly. Grind the welds off of the replacement liner and allow it to expand to the original tube.





Open the cleanout door. Weld top and bottom ends of the liner. Welds should be placed every 6-8 inches with a 1/2" weld. When welding make sure the liner is sitting flush against the original tube. If needed, put pressure on the liner and tack in place before welding.



Reinsert the lower auger and re-bolt the Hanger Bushing Assembly to the existing tube. Use a 9/16" wrench to tighten the 3/8" x 1-1/4" bolts and 3/8" washer.