

## INCRA LS Steel Sub Base Instructions

To adapt the LS17 and LS25 positioners to the TS-LS rail system, it is necessary to remove the aluminum base pedestal from the oval-shaped base housing and replace it with the steel sub base used in the TS-LS Systems.

1. Slide the carriage completely out of the base housing.
2. Remove the cursor panes from their windows in the top of the housing; be aware of the thin washers under the bolt heads.
3. Loosen the (6) Phillips head screws on the floor of the housing and slide the aluminum pedestal off the base housing. Remove and save the rectangular nuts, washers, and screws along with the pedestal.
4. Install the steel sub base using (2) #10-32 x 1/2" Phillips head screws w/washers and (4) #10-32 x 3/8" Phillips head screws w/washers. Use the 1/2" fasteners in the 2 holes nearest to the red cam clamp as shown in the illustration. Tighten all fasteners securely.
5. Carefully reinstall the cursor panes into their windows. The hairline cursor should be in the left-hand window, and the cursor pane should be installed so the hairline itself is on the bottom surface. Do not over tighten.
6. Slide the carriage back into the base housing using the "V"-shaped feature at the front of the housing as a guide. The carriage will slip into the housing very easily when properly aligned.

