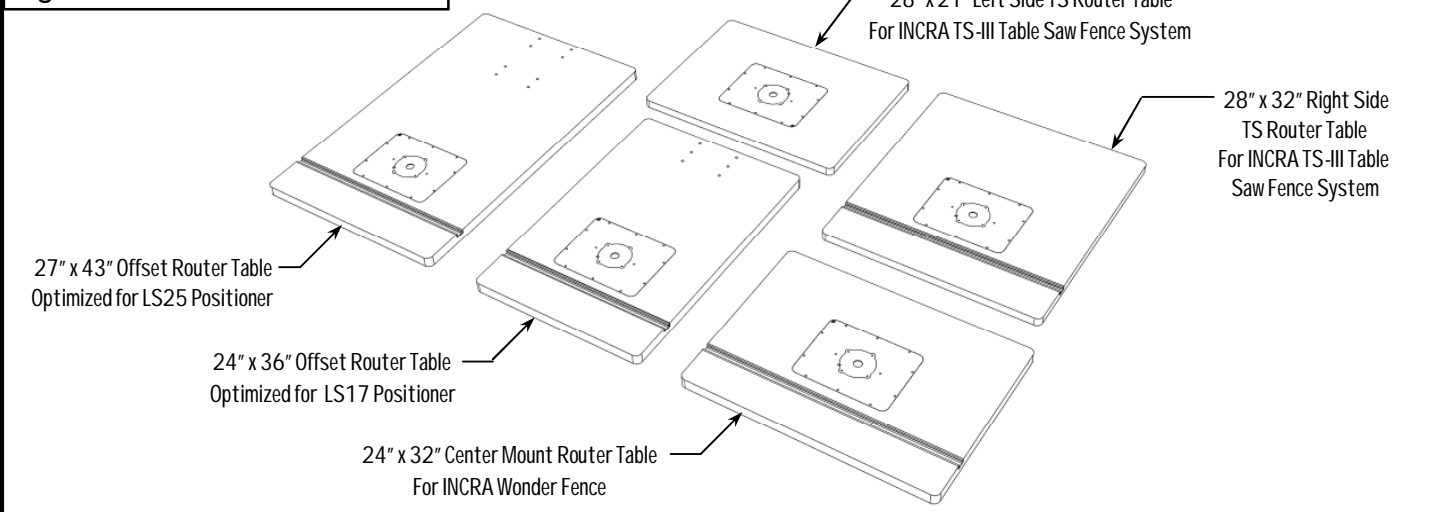


# INCRA Router Tables & MagnaLOCK Plates

Fig. 1 INCRA Router Tables



## Step 1. Install Magna-LOCK plate in router cutout.

Rotate the cam screw in one corner with the 1/8" hex key until the head clears the inside of the plate recess **AND** the head is **JUST BELOW** the top surface of the plate, **Fig. 2A**. Now orient the plate as shown in **Fig. 2**, and lower it into the table. **DO NOT** tighten the cam screw yet.

## Step 2. Adjust plate levelers for INCRA tables.

Using the 5/32" hex key, adjust the (10) 5/16-18 x 1/2 socket head screws to level the plate flush with the top surface of the router table, **Fig. 3**.

## Step 2A. Adjust plate levelers for Non-INCRA tables.

First install the (10) 1/4-20 x 3/8 socket set screws in the plate. Then, using the 1/8" hex key, adjust all (10) of these set screws to level the plate flush with the top surface of the router table, **Fig. 3A**.

## Step 3. Lock plate in table.

Turn the cam screw clockwise to firmly lock plate in the table, **Fig. 4**. Only light clamping pressure is needed to immobilize plate. **Do not over tighten**. Be sure the cam screw is below the surface of the plate, but not so far down that it is bottomed out.

Fig. 2 Install plate

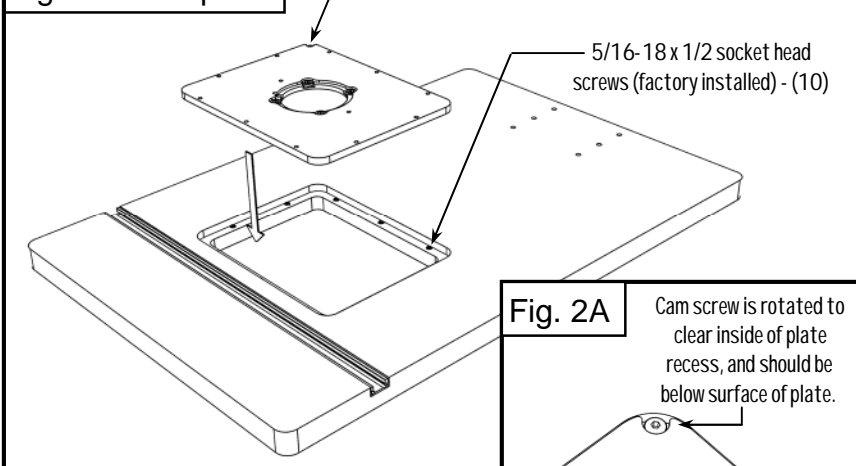


Fig. 3 Level plate  
INCRA router tables

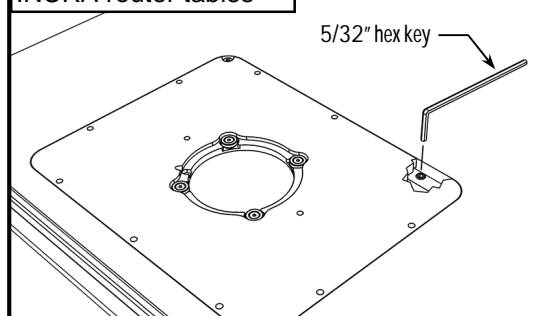


Fig. 3A Level plate  
Non-INCRA router tables

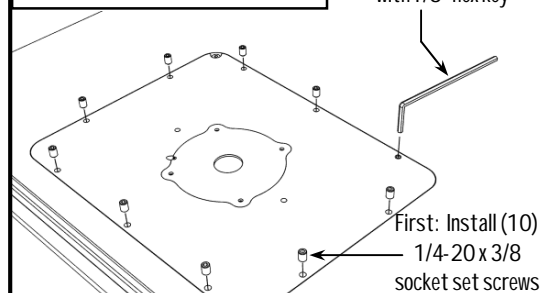
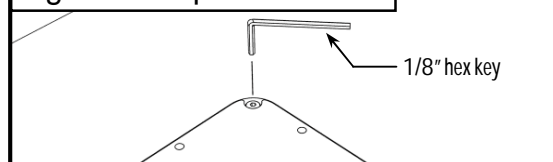


Fig. 4 Lock plate in table



**INCRA**<sup>®</sup>  
www.incra.com

Made in America by:  
Taylor Design Group, Inc.  
PO Box 810262  
Dallas, TX 75381  
Phone: 972-242-9975

**CAUTION:** Always keep hands safely clear of the router bit when installing or changing ring inserts.

#### Step 4. Install Magna-LOCK Ring Insert.

Orient the ring insert relative to the router plate as shown in **Fig. 5** and **Fig. 6**, then lower into the plate recess. The (4) rare earth magnets are extremely powerful, and the ring insert will SNAP into place.

**TIP:** The insert is keyed to fit only one way. If it doesn't align on the first try, flip it over and try again.

#### Step 5. Adjust ring levelers.

With the ring insert in place, insert the 3/32" hex key into the four adjustment holes, and adjust as needed to level the insert flush with the top surface of the plate, **Fig. 6**.

To remove the ring insert, slide the 3/32" hex key under the access hole, and lift up, **Fig. 6A**.

**DO NOT** push downward on the hex key to remove the insert, because this can mar the surface of the router plate. Lift upwards instead.

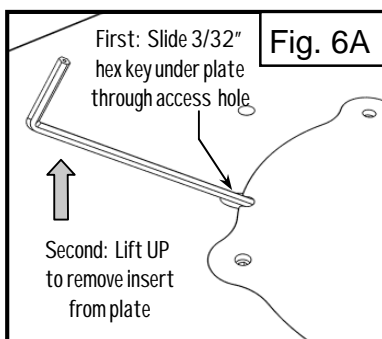


Fig. 5 Install Magna-LOCK ring insert

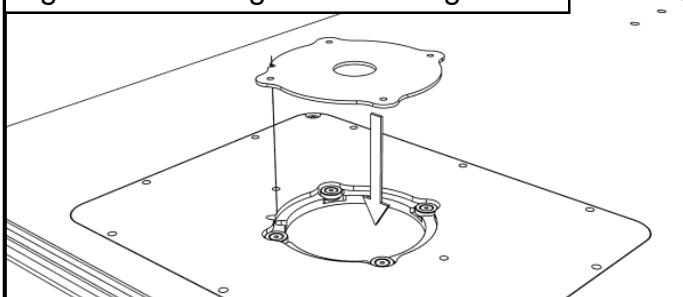
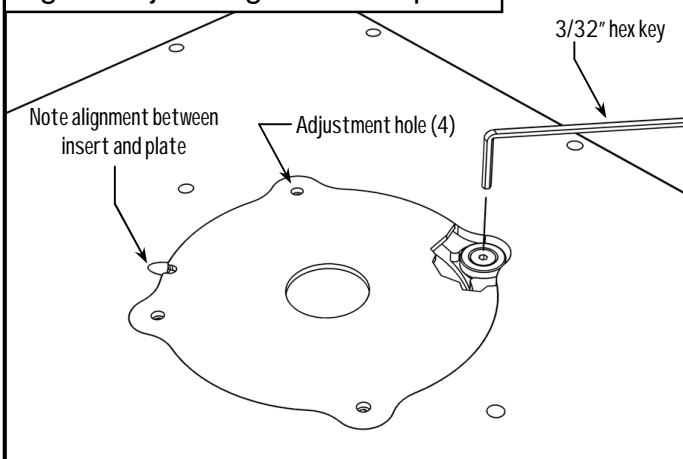


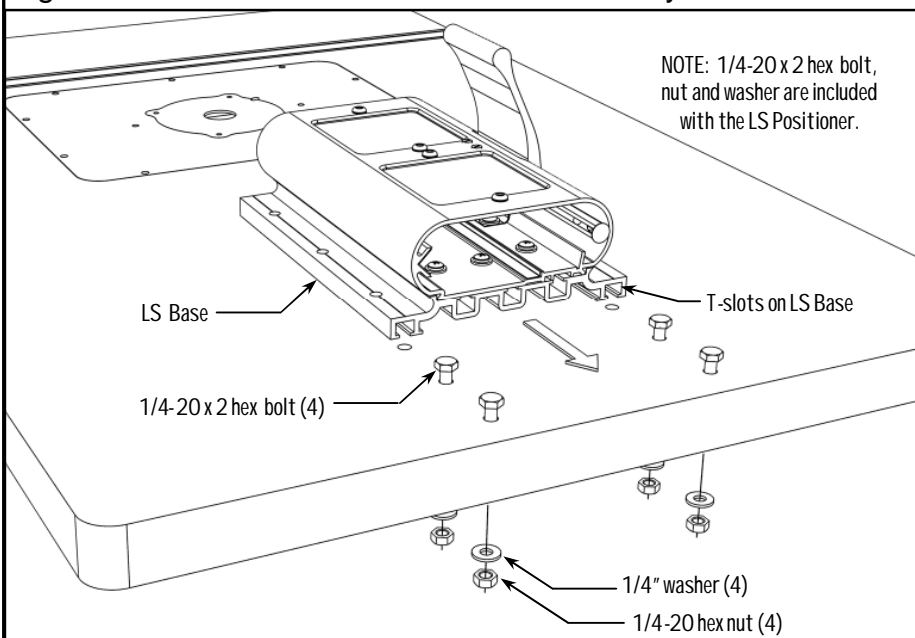
Fig. 6 Adjust ring flush with plate



#### Step 6. Install LS Positioner.

Unlock the LS Positioner carriage clamp and carefully slide the carriage out of the LS Base. Install the (4) 1/4-20 x 2 hex bolts, 1/4" washers and 1/4-20 hex nuts supplied with the LS Positioner in the holes provided in your INCR A Router Table as shown in **Fig. 7**. Now slide the two T-slots on the LS Base over the heads of the bolts. Refer to page 5 of your LS Positioner owners manual to determine the final position of the LS Base relative to the center of the router collet. Square the base to your table edge, and securely tighten the fasteners.

Fig. 7 Install LS Positioner on INCR A offset style router tables



**LS Base Positioning Note:** The 24" x 36" offset router table has been optimized for the LS17 Positioner. The 27" x 43" offset table has been optimized for the LS25 Positioner. To achieve the maximum positioning range available from either model, use the 2 sets of mounting holes farthest away from the router cutout as shown in **Fig. 7**. When properly located, the LS Base will overhang the

edge of the table by about 5", which is permissible as long as all 4 hex bolts are securely captured in the T-slots. The extra mounting holes that are closer to the router cutout are provided to allow installation of the LS Positioner closer to the router cutout if desired. These extra mounting holes on the 27" x 43" table also allow the LS17 Positioner to be installed within range of the router on this larger table.