

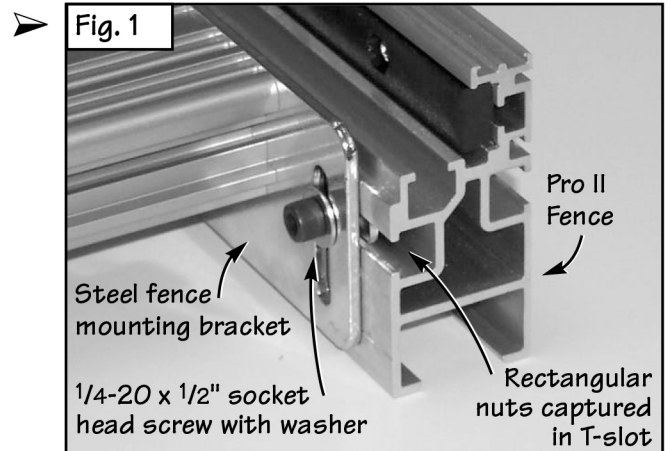
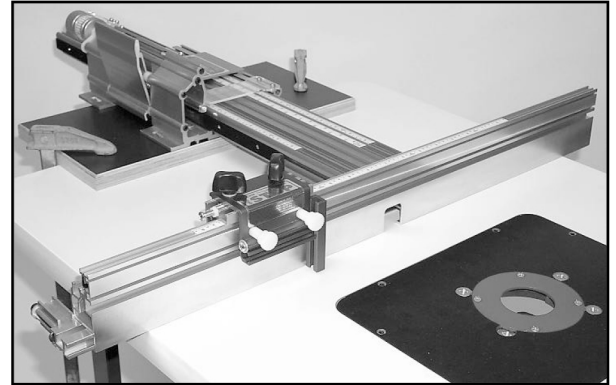
INCRA Pro II Joinery Fence System Upgrade Addendum

You have purchased the Incra Jig Ultra equipped with the new Pro II Joinery Fence System, steel fence mounting bracket and Incra Shop Stop. These components represent an upgrade and are not described in the standard owner's manuals. The following instructions will be used in place of the referenced instructions from the owner's manuals.

Mounting the Incra Pro II Fence

(Replaces *Mounting the Incra Pro Fence to the Incra Jig Ultra or Ultra Lite* from page 4 of the Incra Pro Fence System Owner's Manual and as shown in step 2 from page 4 of the Incra Jig Ultra Owner's Manual.)

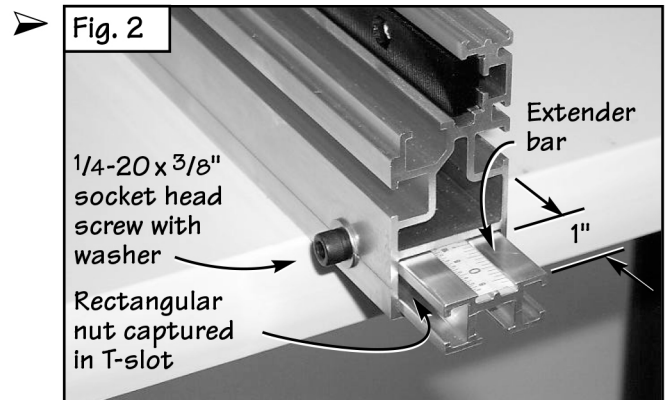
Carefully slide the carriage into the base and pull the carriage clamp up into the locked position. Place a 1/4" washer on each of the (2) 1/4-20 x 1/2" socket head screws and insert through the slotted holes located on the steel fence mounting bracket. Loosely thread on the 1/4-20 rectangular nuts, then slide the nuts into the T-slot located on the rear of the Pro II fence. Position the fence so that the carriage is approximately centered on the fence length and tighten the (2) mounting screws with the supplied hex tool, **Fig. 1**.



Installing the Extender Bar

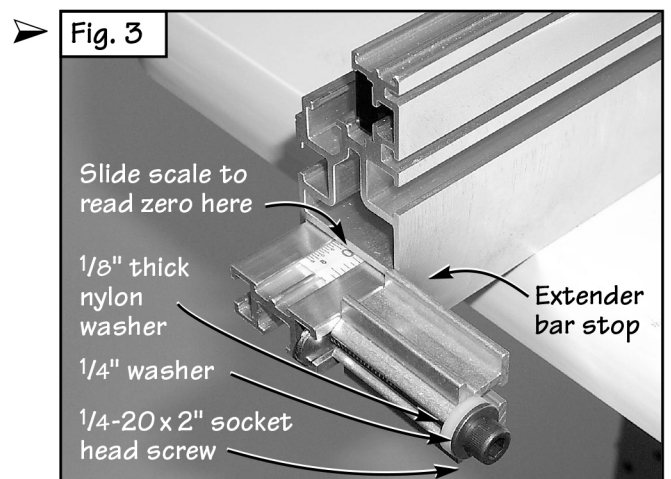
(Replaces *Installing the Extender Bar* from page 6 of the INCRA Pro Fence System Owner's Manual.)

Place a 1/4" washer on the 1/4-20 x 3/8" socket head fastener and insert through one of the holes located at either end of the Pro II fence. Loosely thread on the 1/4-20 rectangular nut and slide the extender bar into the cavity in the fence, capturing the rectangular nut in the T-slot located on the extender bar. The scale on the extender bar should be face up. Slide the extender bar until only about 1" of the bar remains exposed and tighten the fastener, **Fig. 2**.



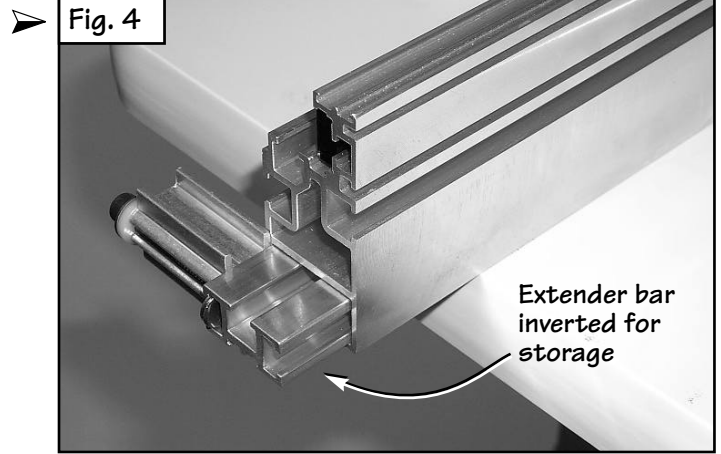
Place a 1/4" washer and a 1/8" thick nylon washer on the 1/4-20 x 2" socket head screw and insert through the extruded hole located on the extender bar stop and loosely thread on the 1/4-20 rectangular nut. Slide the nut into the T-slot located on the front of the extender bar. Slide the extender bar stop until the flat side of the stop contacts the end of the Pro II fence. Tighten the fastener, then slide the scale to read zero at the end of the fence extrusion, **Fig. 3**.

Caution: *Never allow the opposite end of the extender bar to protrude into the cut area.*



TIP

When not in use, the extender bar and stop can be stored in the fence. Just slide the extender bar out, turn it over so that the scale is face down, and insert back into the fence. Tighten the fastener to secure the bar, **Fig. 4**.

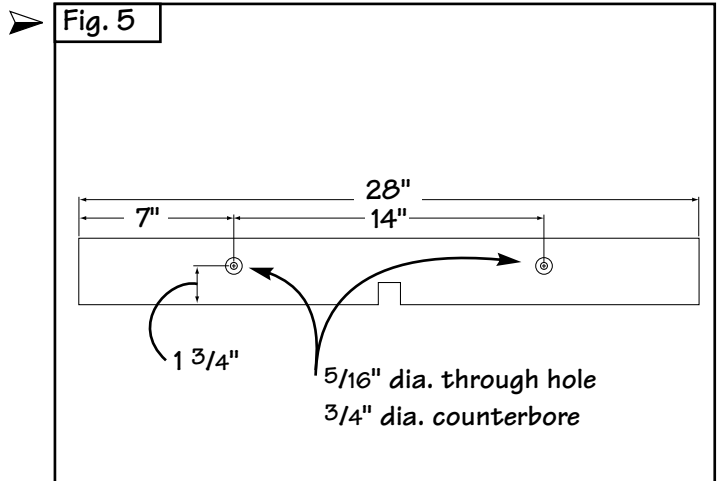


Mounting an Auxiliary Fence to your Pro II Fence.

(Replaces last paragraph on page 8 of the Incra Pro Fence System Owner's Manual.)

To mount the auxiliary fence to your Pro II Fence, you will need (2) 1/4-20 phillips pan head screws, (2) 1/4" flat washers and (2) 1/4-20 hex nuts. The length of the screws should be slightly less than the thickness of the auxiliary fence. Drill two 5/16" through holes in the auxiliary fence in the locations shown in **Fig. 5**. Counterbore the holes with a 3/4" diameter bit.

Adjust the depth of the counterbore so that the screw, when installed in the counterbore with the 1/4" washer, extends 3/8" through the back of the auxiliary fence. Loosely thread on the 1/4-20 hex nuts, then slide the hex nuts into the T-slot located on the front face of the Pro II Fence. Tighten the machine screws to secure the auxiliary fence.



WARRANTY

Taylor Design Group, Inc. warrants this product for one year from date of purchase. We will repair any defects due to faulty material or workmanship, or at our option, replace the product free of charge. Please return the failing component only, postage prepaid, along with a description of the problem to the address below. This warranty does not apply to parts which have been subjected to improper use, alteration, or abuse.

LIFETIME WARRANTY ON POSITIONING RACKS

If an INCRA positioning rack in this tool becomes damaged for ANY reason, Taylor Design Group will replace it free of charge for as long as you own your tool. Return the damaged rack, postage prepaid, and allow 1 to 2 weeks for delivery.

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