1. Remove the cover

2. New DRO cable
3. Remove cable head cover and becomes like the below picture

4. Tape it up
5. New DRO cable through the hole

6. Tape the new DRO cable head with old DRO cable
7. Open cable track on the top (about 4 pieces)

8. Pull the old DRO cable up so new DRO cable head will go up too.
9. Need a person stands next to electrical box and pull old DRO cable

10. New DRO cable head will be seen. Remove the tape between new DRO cable head and old DRO cable. Pull new DRO cable head more and connect the cable head to on the circuit board. Tape the old DRO cable and pull it out from top.
11. Layout

12. Remove one screw on linear encoder
13. Remove the upper screw. Release the lower screw.

14. Remove fours screws on the bottom of the linear encoder
15. Remove old reader head

16. Remove four screws on new reader head
17. Install new reader head

18. Make sure the encoder side and reader side is parallel.
19. Job finished. It takes around 40 minutes.