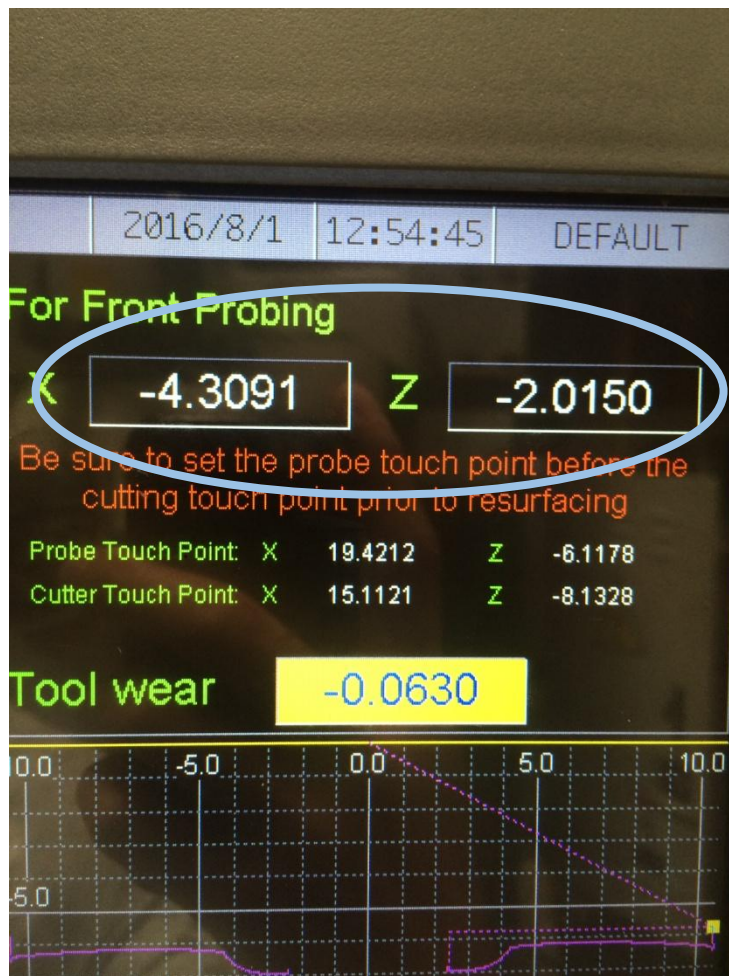


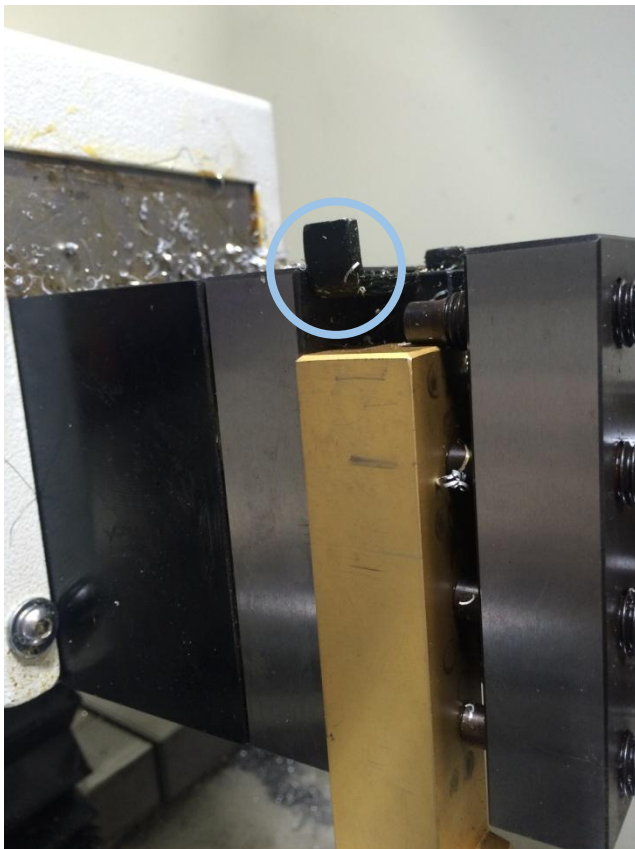
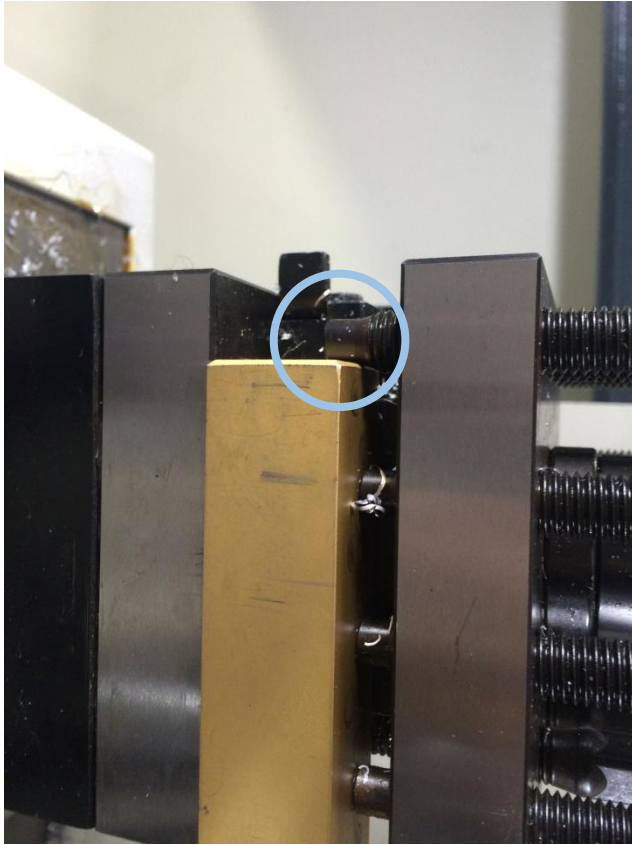
## How to replace tool holder or insert without resetting the offset value.

### Tool Holder Change

Step 1: Write down the X and Z numbers on a piece of paper.



Step 2: Use a reference point to ensure the correct tool placement after being taken out. In this example we used one of the metal posts as a stopper instead of sliding out the metal back plate as shown in the second photo.



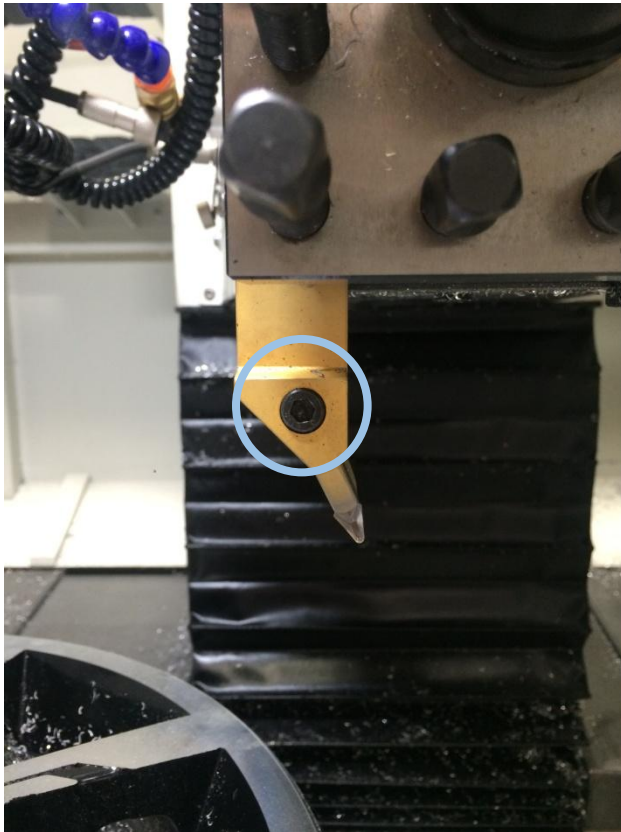
Step 3: Once you are ready to place your tool back, you may place the tool holder in the four point posts. put the back of your tool holder on the reference point and type in the X and Z values that you saved on to the monitor.

## Insert Change

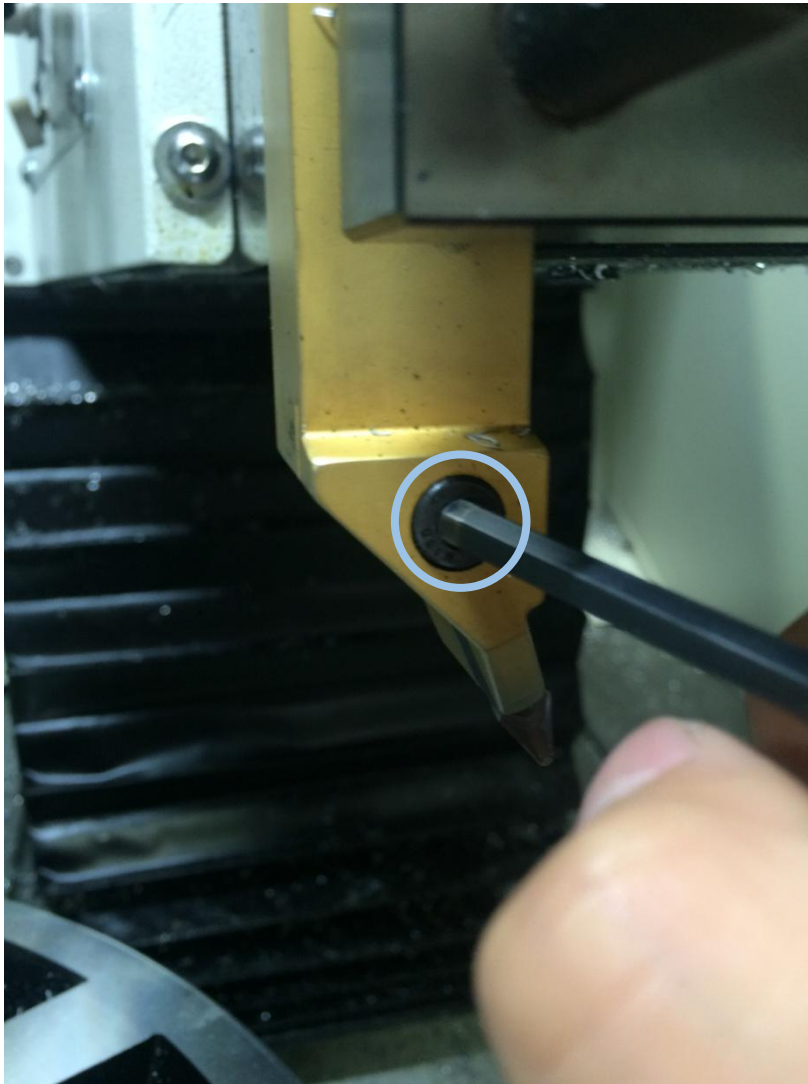
Tools Needed:

3/16 in Hex Tool

Carbide/Diamond Insert



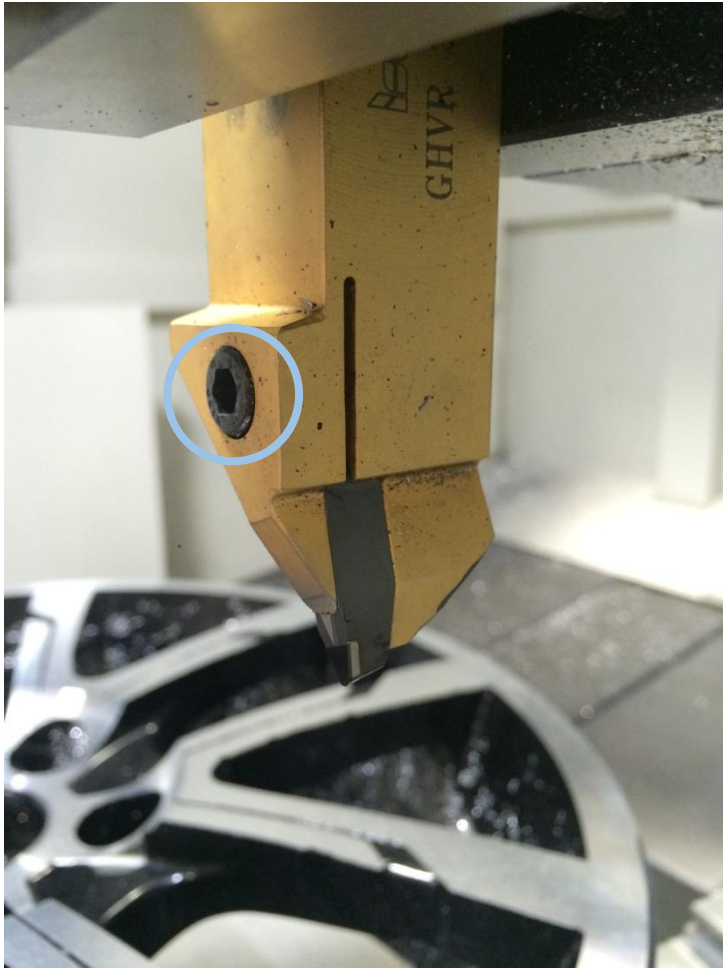
Step 1: Locate set screw on Tool Holder



Step 2: Unscrew set screw with 3/16 in hex tool to remove unwanted insert



Step 3: Place new Diamond/Carbide insert into Tool Holder.



Step 4: Tighten set screw and make sure insert fits correctly.