

### **DC9040C Carbide Cutter Adjustment**

If you are changing from an “FC9040” cutting wheel to a DC9040 style wheel (carbide, coated or HSS) you will need to change the X home number after installation. The DC style cutter does not have a counterbore like the FC cutter does.

In versions 7 of Genericode/Autocode or higher, the software will make this adjustment automatically. Start by writing down the X home number in the Setup section of the program. If an FC9040 cutter is on the machine, go through the cutter change procedure in the software following all instructions. Once the change is done, the X home number should be 342 less than it originally was (if your X home was 12500, it will now be 12158). If you changed from a coated to carbide, there should be no adjustment necessary. If the X home has not been changed properly in the software, simply subtract 342 from the original X home number and your machine should cut properly.