



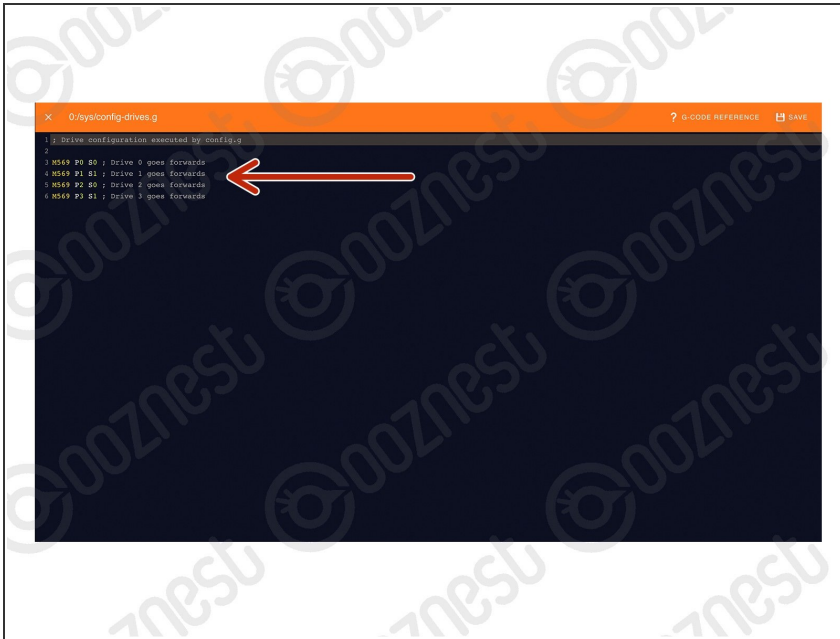
How To Change Axis Travel Direction

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A screenshot of a terminal window with an orange title bar. The title bar contains a close button, the file path '0:/sys/config-drives.g', and two buttons: '? G-CODE REFERENCE' and 'SAVE'. The terminal content shows a series of G-code commands for configuring four drives. Line 1 is a comment. Lines 2-6 are G569 commands for drives 0, 1, 2, and 3 respectively, all set to 'S0' (forwards).

```
1 ; Drive configuration executed by config.g
2
3 M569 P0 S0 ; Drive 0 goes forwards
4 M569 P1 S1 ; Drive 1 goes forwards
5 M569 P2 S0 ; Drive 2 goes forwards
6 M569 P3 S1 ; Drive 3 goes forwards
```

Step 1 — Change Axis Travel Direction



- Under File Management > System click on 'config-drives.g'
 - Drive 0 is the X-Axis. Drive 1 is the Left Y-Axis. Drive 2 is the Z-Axis Motor. Drive 3 is the Right Y-Axis.
 - To change an axis travel direction, change the S value from 0 to 1, or vice versa.
 - Save the file.
- ⚠ Press the software emergency stop in the top right corner to restart the controller.

Thanks for following the guide. Any issues, please contact us!