



How To Change Axis Travel Direction

This guide goes over changing the direction of travel of each axis on a WorkBee CNC Machine.

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A screenshot of a web browser window. The address bar shows "192.168.1.41/Files/System" with a "Not secure" warning. The page title is "0:/sys/customconfig.g". The content is a text file with G-code configuration settings. The code includes comments for adding custom settings, configuring endstops (M574), setting active low endstops, disabling jog commands when not homed (M564), and configuring drives (M569) for axes X, Y, Z, and S. The drive settings are configured to go forwards for all axes.

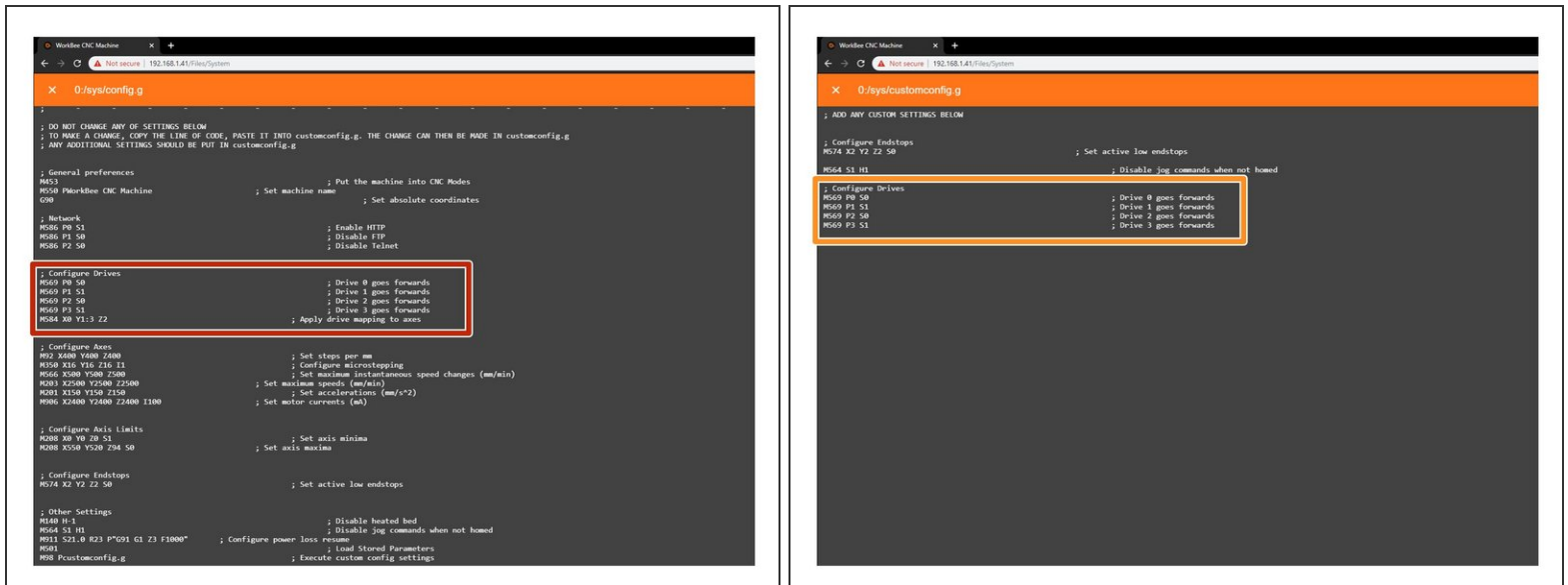
```
; ADD ANY CUSTOM SETTINGS BELOW

; Configure Endstops
M574 X2 Y2 Z2 S0                ; Set active low endstops

M564 S1 H1                      ; Disable jog commands when not homed

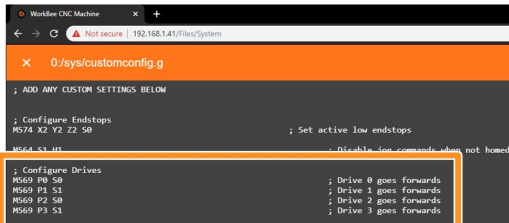
; Configure Drives
M569 P0 S0                      ; Drive 0 goes forwards
M569 P1 S1                      ; Drive 1 goes forwards
M569 P2 S0                      ; Drive 2 goes forwards
M569 P3 S1                      ; Drive 3 goes forwards
```

Step 1 — Open Config.g File



- Under File Management open System - Config.g and Copy the Configure Drives information.
- Return back to system and open Customconfig.g and paste in the Configure Drive Lines.

Step 2 — Change Drive Direction.



```
; ADD ANY CUSTOM SETTINGS BELOW

; Configure Endstops
M574 X2 Y2 Z2 S0          ; Set active low endstops
M564 X1 Y1 Z1             ; Disable ion commands when not homed

; Configure Drives
M569 P0 S0                ; Drive 0 goes forwards
M569 P1 S1                ; Drive 1 goes forwards
M569 P2 S0                ; Drive 2 goes forwards
M569 P3 S1                ; Drive 3 goes forwards
```

i Drive 0 is the X-Axis. Drive 1 is the left hand Y-Axis Motor. Drive 2 is the Z-Axis Motor. Drive 3 is the right hand Y-Axis Motor.

- To change the X-Axis Travel direction, change Drive 0 S Value from 0 to 1 (Or vice versa)
- To change the Y-Axis Travel direction, change Drive 1 & 3 S Value from 0 to 1 (Or vice versa)
- To change the Z-Axis Travel direction, change Drive 2 S Value from 0 to 1 (Or vice versa)

i Click Save to enable the Changes and Restart using the Emergency Stop Button displayed in the Workbee Control Interface.

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