

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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Step 1 — Open Config.g File

| O Wolfer OK Malore X + | Weinlifer Chil Machine X + |
|--|--|
| ← → C A Not secure 192.160.1.41/7/lou/System | ← → C A Not secure 192.158.1.41/Filey/Sjytem |
| × 0:/sys/config.g | × 0:/sys/customconfig.g |
| ; DO NOT CHANGE ANY OF SETTINGS BELOW | ; ADD ANY CUSTOM SETTINGS BELOM |
| ; TO MAKE A CHANKE, COPY THE LINE OF CODE, PASTE IT INTO customconfig.g. THE CHANGE CAN THEN BE MADE IN customconfig.g ; ANY ADDITIONAL SETTINGS SHOULD BE PUT IN customconfig.g | ; Configure Endstops 16574 X2 Y2 Z2 50 ; Set active low endstops |
| ; General preferences ; Put the machine into CNC Modes | H664 S1 H1 ; Disable jog commands when not homed |
| NOSO PMorkBee OK Machine ; Set machine name 690 ; Set absolute coordinates | PG60 PG 50 ; Drive 0 goes forwards NG69 P1 51 ; Drive 1 goes forwards |
| ; Network N556 P0 51 ; Enable HTTP N556 P1 50 ; Disable FTP | H669 P3 S1 ; Drive 3 goes forwards |
| MS86 P2 50 ; Disable Telnet | |
| ; Configure Drives 1956 PP 50 ; Drive 0 goes forwards 1959 PI 51 ; Drive 1 goes forwards | |
| ₩569 P2 50 ; Drive 2 goes forwards ₩569 P3 51 ; Drive 3 goes forwards ₩564 100 Y1-1 72 ; dealul drive manifest for aves | |
| A find human base | |
|) Configure Axes NO2 X400 V400 Z400 ; Set steps per mm NO50 X16 Y16 Z16 I1 ; Configure microstepping | |
| 1966 X300 1930 Z300 ; 5 et maximum instantaneous speed changes (mm/min) 1828 X2500 12500 Z2500 ; 5 et maximum speeds (mm/min) 1921 X15 V157 Z150 : 5 et accelerations (mm/s²2) | |
| M506 X2400 Y2400 I100 ; Set motor currents (m4) | |
| ; Configure Axis Limits M208 X0 YO 20 51 ; Set axis minima | |
| M208 X550 Y520 294 50 ; Set axis maxima | |
| ; Configure Endstops 16574 X2 Y2 Z2 S0 ; Set active low endstops | |
| ; Other Settings | |
| MS64 51 H1 ; Disable log commands when not homed M511 521.0 R23 P*691 G1 Z3 F1000* ; Configure power loss resume | |
| NSO1 ; Load Stored Parameters NSB Pcustomconfig.g ; Execute custom config settings | |
| | |

- 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.

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Step 2 — Change Drive Direction.

| ; ADD ANY CUSTOM SETTINGS BELOW | | |
|--|--|--|
| : Configure Endstops | | |
| 1574 X2 Y2 Z2 S0 | ; Set active low endstops | |
| ; Configure Drives 1569 P8 58 1569 P1 51 1569 P3 50 1569 P3 51 | ; Drive 0 goes forwards ; Drive 1 goes forwards ; Drive 2 goes forwards ; Drive 2 goes forwards | |
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- 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)
- 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!

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