



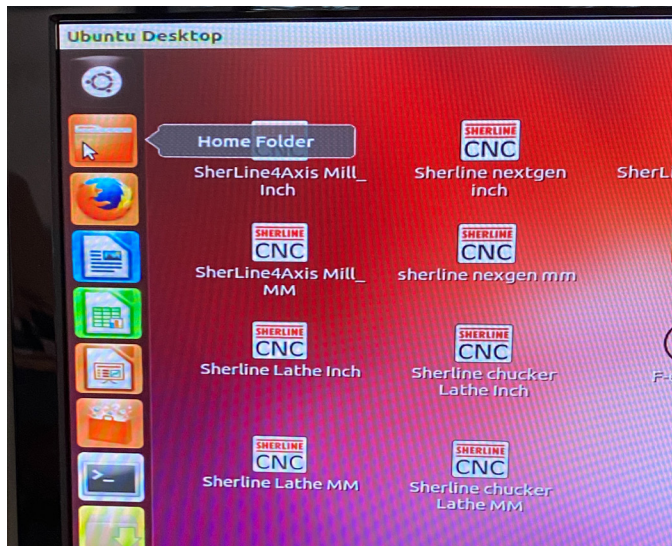
Changing the Jog Direction of CNC Axis Movement

LinuxCNC

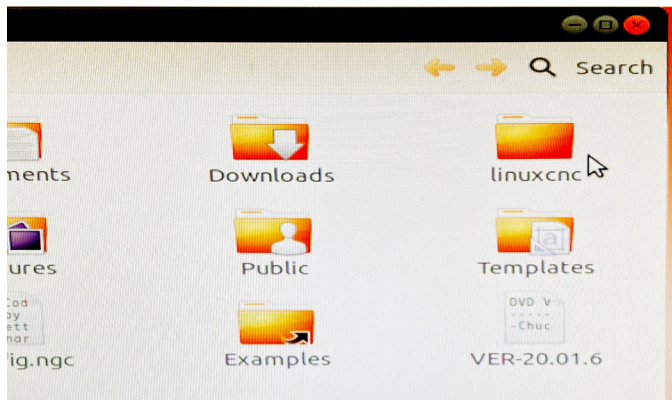
Resetting the .INI file to Change the Jog Direction of an Axis

If an axis really is moving in the wrong direction this means that your .ini file is improperly set. To fix it you will need to open the .ini file in LinuxCNC.

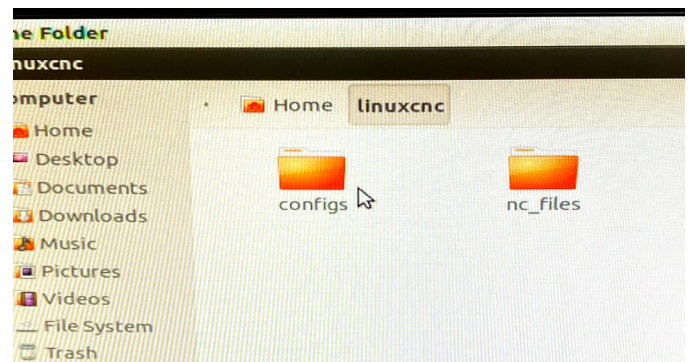
1. Move your cursor to the left side of the screen. This will make icon options appear. Then click on the “Home Folder” icon.



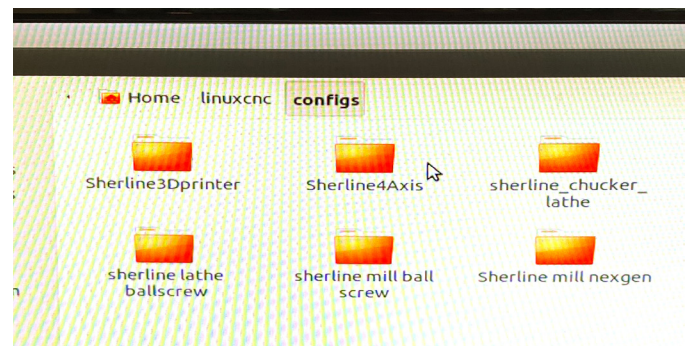
2. Then double click on “Linuxcnc” folder icon.



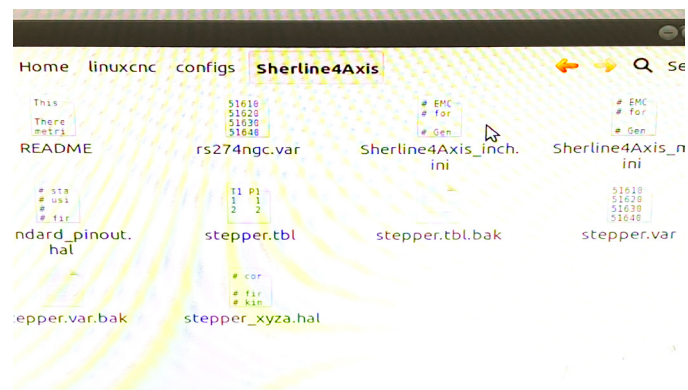
3. Then double click on the “configs” folder icon.



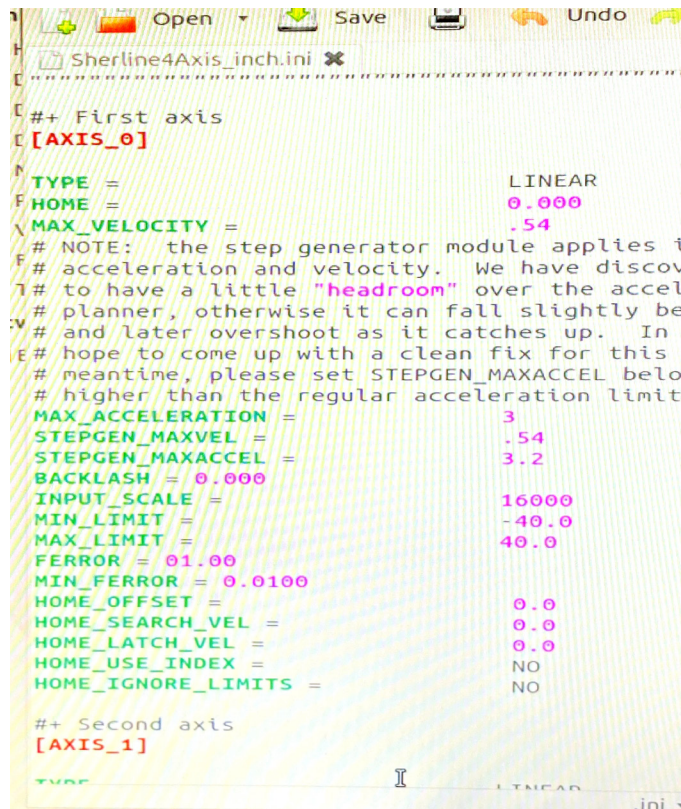
4. Then double click on the related machine. For a mill, you would click on the “Sherline4Axis” folder icon.



5. Then double click on the “Sherline4Axis_Inch.ini” icon.



6. This will open up the INI files for the given machine. Cursor down to the desired axis (in this case the X-axis).



```
Open Save Undo
Sherline4Axis_inch.ini
# First axis
[AXIS_0]
TYPE = LINEAR
HOME = 0.000
MAX_VELOCITY = .54
# NOTE: the step generator module applies i
# acceleration and velocity. We have discov
# to have a little "headroom" over the accel
# planner, otherwise it can fall slightly be
# and later overshoot as it catches up. In
# hope to come up with a clean fix for this
# meantime, please set STEPGEN_MAXACCEL belo
# higher than the regular acceleration limit
MAX_ACCELERATION = 3
STEPGEN_MAXVEL = .54
STEPGEN_MAXACCEL = 3.2
BACKLASH = 0.000
INPUT_SCALE = 16000
MIN_LIMIT = -40.0
MAX_LIMIT = 40.0
FERROR = 01.00
MIN_FERROR = 0.0100
HOME_OFFSET = 0.0
HOME_SEARCH_VEL = 0.0
HOME_LATCH_VEL = 0.0
HOME_USE_INDEX = NO
HOME_IGNORE_LIMITS = NO
# Second axis
[AXIS_1]
TYPE = LINEAR
```

NOTE: The axes are numbered from 0-3. 0 is the X-axis, 1 is the Y-axis, 2 is the Z-axis, & 3 is the A-axis.

The value that you are going to change will either say "INPUT SCALE" or "SCALE." By changing the number vale to the opposite, you will change the direction in which the axis moves. In this case the (16000) would be changed to (-16000) to change the axis direction.

Thank you,
Sherline Products Inc.