

## Change rear tool post to front

1. Press F1 [Set up] - F3 [Config], type: 137 enter - F2 [Machine] - F2 [Motor] .  
High light X axis, go to the number and swap the number under Limit and Home (Negative and Positive).  
Change direction Y to N (or N to Y).  
After that, press F10 [Save].
2. Parameter 1 changes from 0 to 1.  
F1 [Set up] - F3 [Config.] (137 enter) - F3 Parameter, go to parameter 1 and change to value 1. Press F10 [Save].
3. Change spindle direction:  
Turn off power - Open cover inverter in the electrical cabinet, swap the wires FWD and REV.( black and white wires).