How to manually change the CW and CCW speed

1. Switch to **Auto Mode**

2. Program → File Manager → New File → Input the Name → Hit OK

3. Key in the following

   M3 S300   ← S300 is the spindle speed you want. Format: S _ _ _
   G4 X3000
   M30

4. Make sure the top of screen shows the current file name you edit

5. Hit cycle start

6. The spindle will rotate at the speed of **300** for about three second

7. Done

Note:

if machine is powered off, the 300 rpm memory will lost. What you need to do is open the file name you created on step 2, make sure the top of screen shows the current file name and then hit cycle start.