Changing parameters to allow 12V output from the board: (This is only necessary to use machine supplied 12V DC Power to run the new 0-10V external CNC Speed controller on the model PM-728V-T models shipped before November, 2020, up to and including serial number 194823. All machines after this number have the 12V DC connection turned on by default)

Step 1: Make sure that all power to the machine is off, and it is disconnected from any power source.

Step 2: Remove the (4) Socket head cap screw that are securing the main drive board to the electrical box, as shown below. Leave the wiring connected, but pull the board back slightly so it looks like this.
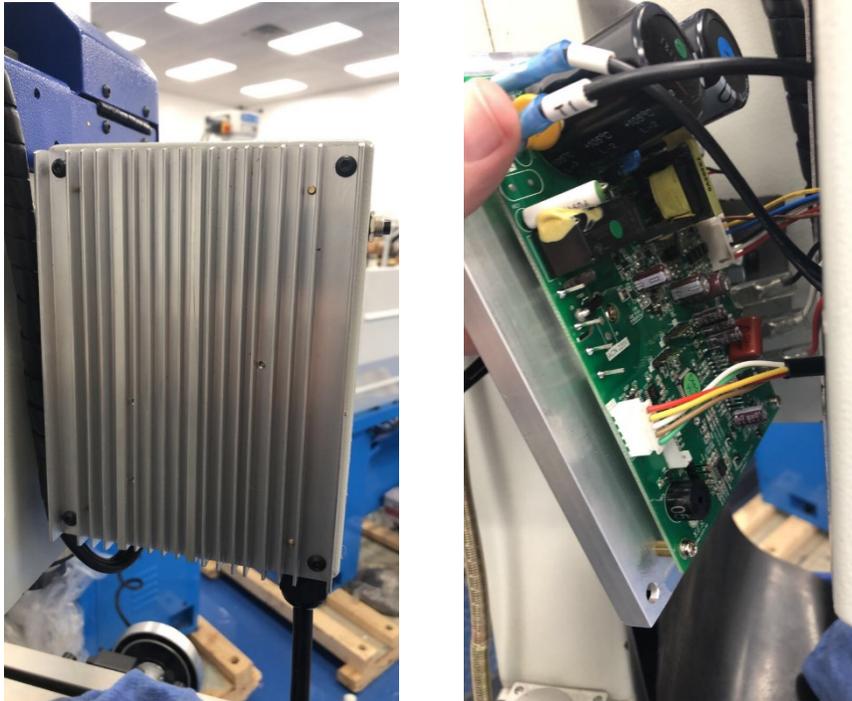
Step 3: Plug the programmer wire in to the connection as shown below.

Step 4: Make sure the FWD/REV switch is in the OFF position, and the E Stop is out

Step 5: Press the Green Power Button, the display and the programmer should light up as shown below.

Step 7: When the programmer is powered up and you have completed the steps above:

1. Press the Mode/ESC button one time; the programmer will display F_000
2. Press the up arrow until the right most digit is 8
3. Press the left arrow once
4. Press the up arrow until the next digit turns to 8 (so you have F_088)
5. Now press Enter
6. You will see a single digit, either a 1, or a 0. Use the up or down arrow to change this digit to 0.
7. Press Enter
8. Press Mode/ESC
9. Press the red Stop button on the machine, and allow it to power down.
10. Disconnect power from the machine, unplug the programmer from the board, and re-install the board on to the electrical box.
11. You have completed the necessary change

 (Click this video link for a visual on how to do these steps)
https://youtu.be/Kzi9lXNZ15g

Step 8: If you wanted to verify the power connection with a meter, this will be your 12 Volt connection shown below. Warning: Only do this step if you are familiar with electricity, as this would need to be completed when the machine is powered up. This would be 12V DC Power. BE CAREFUL not to short out the probes to each other when checking this, or you may damage the board.