

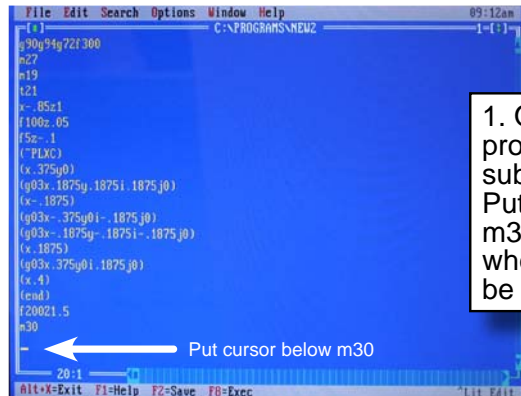
To Add Previously Saved Sub-routines to Any Program File

If you create the sub-routine file on **desktop computer**:

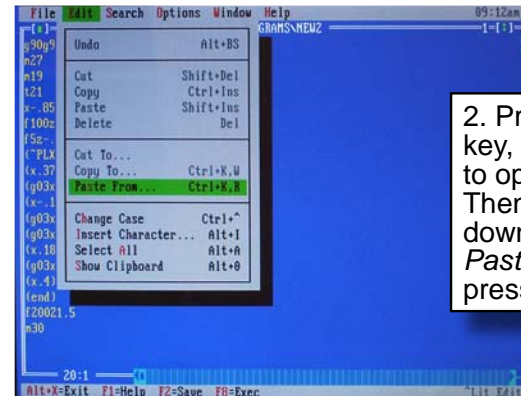
1. Write sub-routine, or copy from an existing program. (For Zip-Loader programs, you can copy the sub-routines from the *barload* sample program).
2. Edit it as required to be generic for most of the bar jobs you run.
3. Save it to a usb stick as *extsub* or any eight character name you care to use.
4. Put the usb stick in your OmniTurn, set power on (or reboot if machine is already on).

5. Drop to DOS (Press Ctrl-C at "OmniTurn CNC" screen).
6. At K:\CNC> prompt type COPY D:\filename C:\PROGRAMS then press enter. (*filename* is whatever you named the subroutine file).
7. To add the subroutines to any program file, open the file in the OmniTurn editor, and follow the four steps below.

If you create the sub-routine file on the **OmniTurn**, see next page for preliminary instructions.



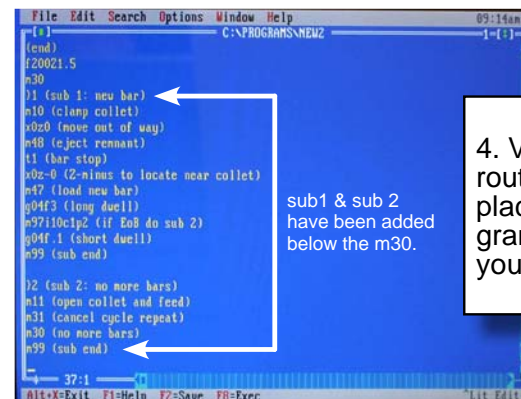
1. Open any ZipLoader program file that needs subroutines. Put cursor below the m30 block. (This is where subroutines will be placed).



2. Press and hold Alt key, then press E key to open Edit dialog box. Then press S or use down arrow to highlight Paste From. Then press Enter.



3. Type the name of the program file that has the sub-routines you want to add, then press Enter.



4. Verify that the sub-routines have been placed into your program files, then save your program file.

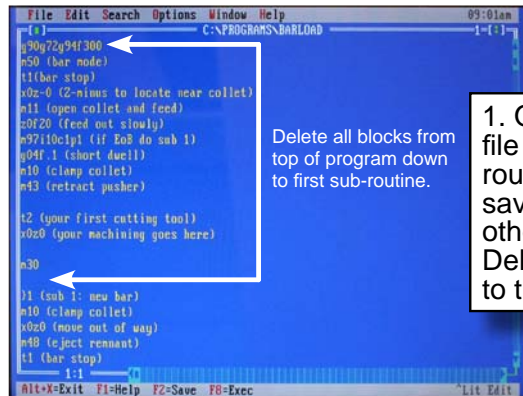
To Save Sub-routine File Using the OmniTurn Editor

These instructions assume you are **working at the OmniTurn**, not at a desktop computer.

1. Open any program file that has the sub-routines you want to save and use with other programs. Delete all blocks down to the first sub-routine.
2. After delete, only the sub-routines remain in the program.
3. Press and hold Alt key, then press A to open "Save As" dialog box. Then press Enter.

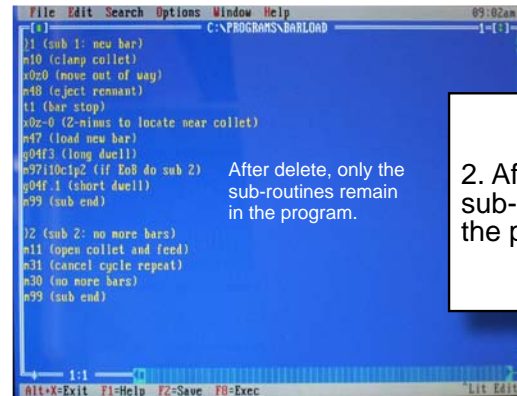
4. Type C:\RUNFILES\filename, where filename is the name of your ziploader sub-routines program. Then press enter to save.
5. Exit the editor.
6. Set your OmniTurn off, then on, and go to instructions on previous page to add these sub-routines to other program files.

If you create the sub-routine file on a **desktop computer**, see previous page for instructions.



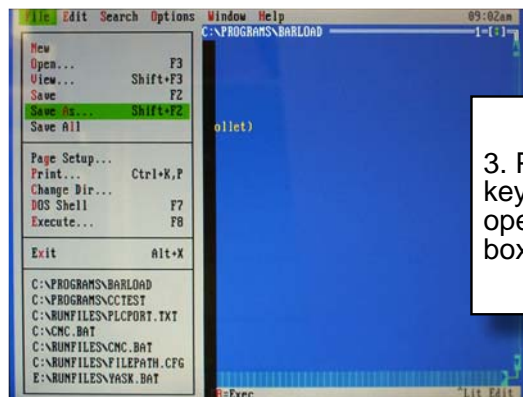
Delete all blocks from top of program down to first sub-routine.

1. Open any program file that has the sub-routines you want to save and use with other Programs. Delete all blocks down to the first sub-routine.



After delete, only the sub-routines remain in the program.

2. After delete, only the sub-routines remain in the program.



3. Press and hold Alt key, then press A to open "Save As" dialog box. Then press Enter.



4. Type C:\RUNFILES\filename, where filename is the name of your ziploader sub-routines program. Then press enter to save.
5. Exit the editor.
6. Set your OmniTurn off, then on, and go to instructions on previous page to add these sub-routines to other program files.