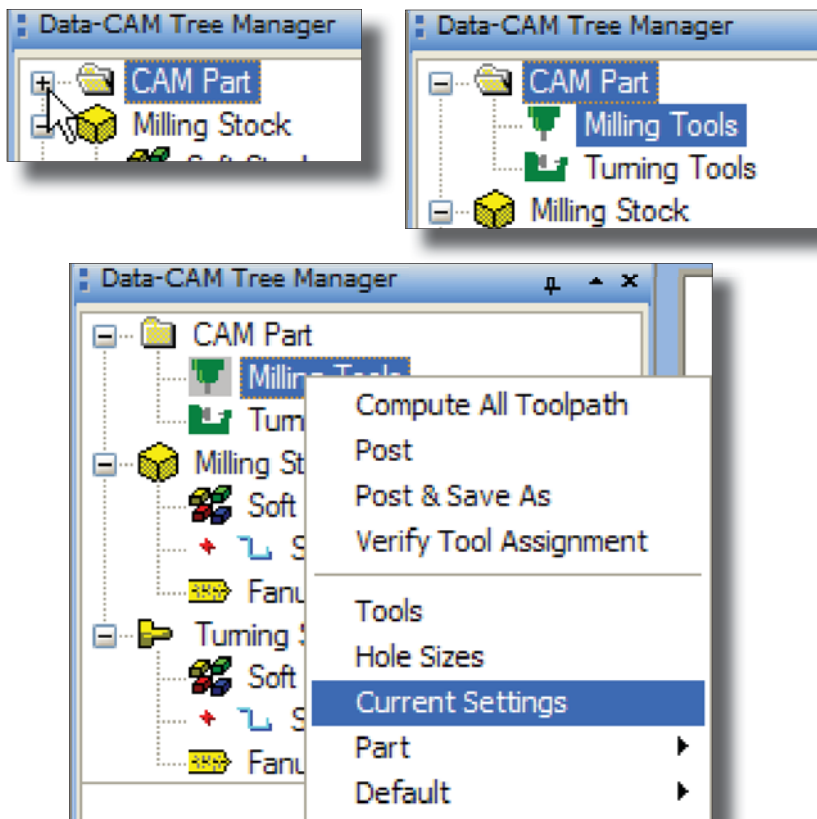


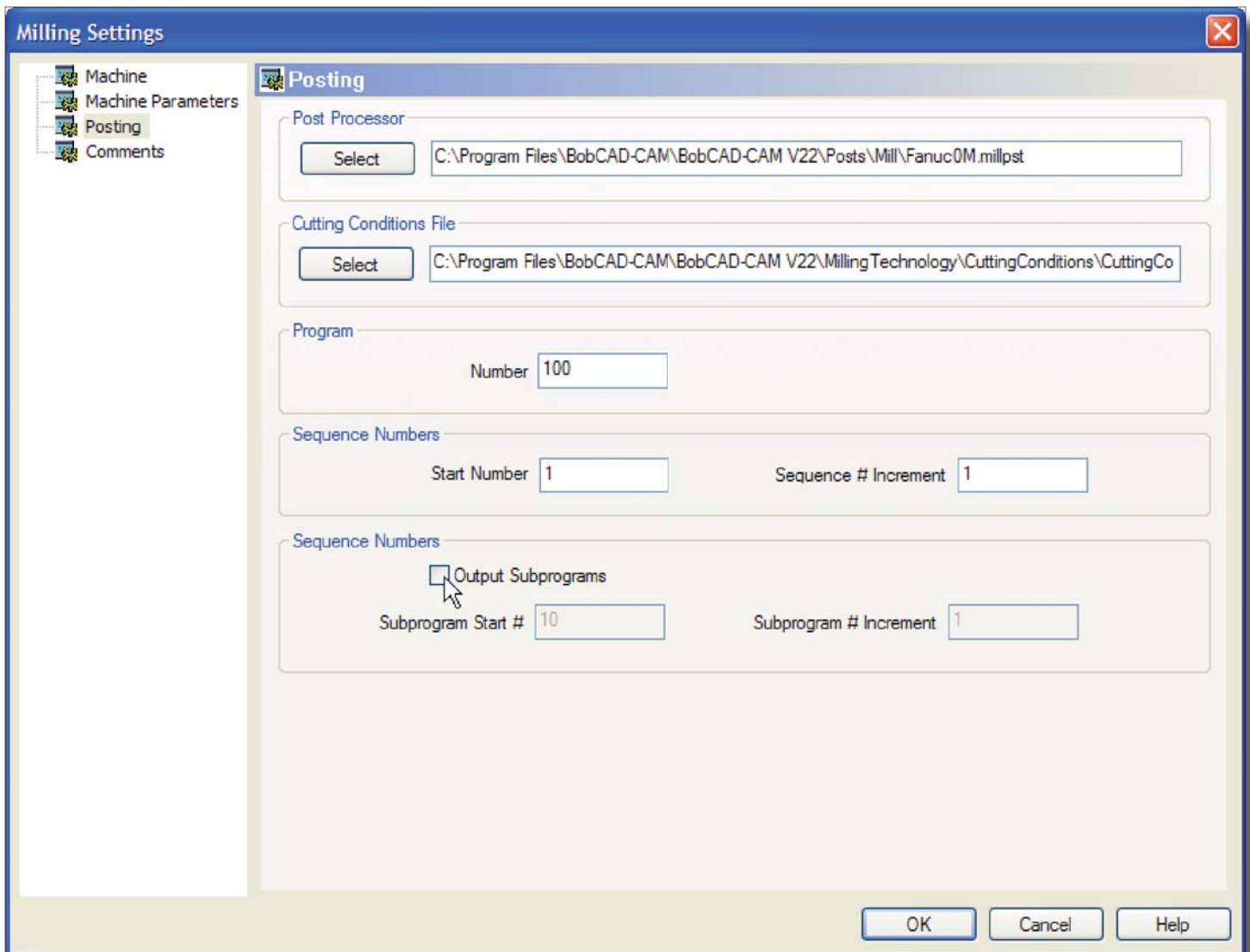
## FAQ #4: How do I turn off subprograms?

Not all machine controllers may accept subprograms (or subroutines) in G-code. Even for similar makes and models, this ability occasionally depends on the company who served as the OEM (Original Equipment Manufacturer). If you find that BobCAD-CAM V22 outputs subroutines and your controller will not accept them, follow these simple steps to disable them.

**Step 1.** Left click on the + icon next to **CAM Part** in the **CAM Tree** tab of the **Data-CAM Tree Manager**. Underneath it will appear **Milling Tools** and **Turning Tools**. Right click the one that is appropriate, and from the drop-down menu, choose **Current Settings**.



The **Milling Settings** (or **Turning Settings**, if you chose **Turning Tools**) box will appear as on the next page.



**Step 2.** Click on **Posting** from the tree to the left. Click on the **Output Subprograms** checkbox as above to uncheck it. Click **OK** to accept the new setting.

**Step 3.** Repost the NC program. There should be no subprograms in the code.