

OMON = 1 flow

Power On

Machine Controller changes output signal OMON from “0” to “1”.

DO: OMON 0→1

Spindle cooling coolant flow starts.

OMON = 0 flow

Power On

Machine Controller changes output signal OMON from “0” to “1”.

“Emergency Stop” switch pressed.

Machine controller changes output signal OMON from “1” to “0”.

DO: OMON 1→0

Spindle cooling coolant flow stops.