

Tool unclamping is commanded.

DO: SL01B 0→1  
DO: SL01A 1→0

Solenoid valve SL01B (tool unclamp) is energized.

Hydraulic oil is supplied to rear of hydraulic cylinder  
and the piston moves forward.

DI: LS00 1→0

Piston comes into contact with rear of draw bar  
and draw bar compresses disk spring.

DI: LS601 1→0  
DI: LS602 1→0

Collet closes and release tool holder.

Draw bar pushes tool holder out of spindle taper.

Limit switch LS01 (tool unclamp) changes from “0” to “1”

DI: LS01 0→1

Tool unclamp completed.