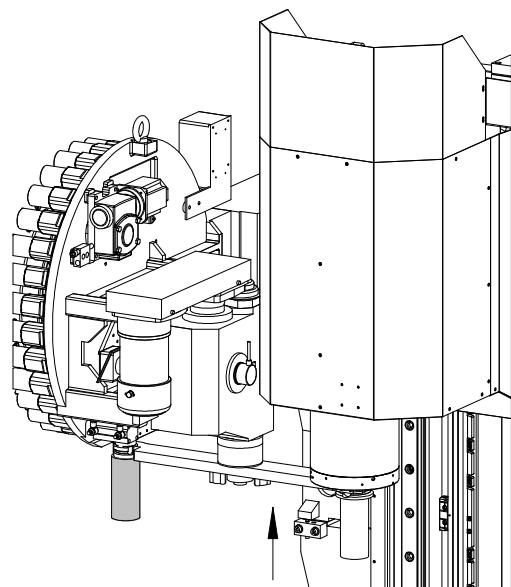


⑦ ATC arm rotates CCW direction by 180°



⑧ ATC arm moves up and spindle tool is clamped