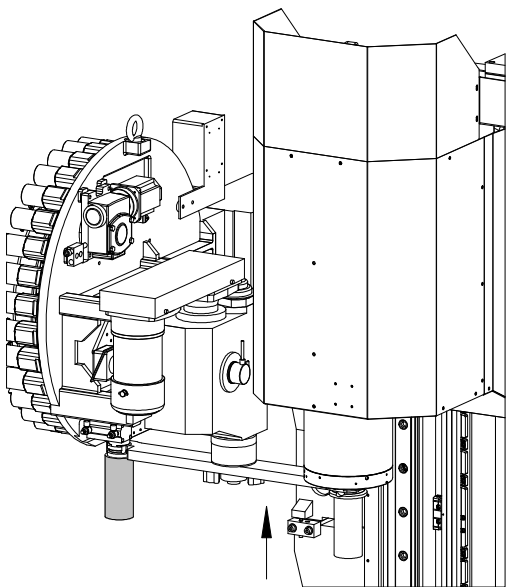


⑦ATC arm rotates CCW direction by 180°.



⑧ATC arm moves up and spindle tool is clamped.