

M07/M756 (air blow On) is commanded or air blow is turned On from main operation panel (Function screen).

DO: SL181 0→1

Solenoid valve SL181 (air blow) is energized and air is supplied to tip of Spindle.

Workpiece machining is completed.

Solenoid valve SL181 (air blow) is de-energized and air supply stops.

DO: SL181 1→0