```
                        ┌─────────────┐
                        │ Start Tool  │
                        │ Change      │
                        └──────┬──────┘
                               ↓
                        ┌─────────────┐
                        │ Spindle Off │
                        └──────┬──────┘
                               ↓
                ┌──────────────────────────────┐
                │ Move Z Axis To Home Position  │
                └───────────────┬──────────────┘
                                ↓
                ┌──────────────────────────────────┐
                │ Rotated spindle to zero mark encoder │
                └─────────────────┬────────────────┘
                                  ↓
                ┌──────────────────────────────┐
                │ Movement magazine to spindle  │
                └───────────────┬──────────────┘
                                ↓
                ┌──────────────────────────────┐
                │ Unclamping collet chuck       │
                └───────────────┬──────────────┘
                                ↓
        ┌──────────────────────┐        ┌─────────────────────────┐
        │ Rise Z axis 150 mm    │──────→ │ Availability control tool │
        └──────────────────────┘        └───────────┬─────────────┘
```

- **Rise Z axis 150 mm** → **Availability control tool**
  - No → **Rotation magazine, search necessary collet chuck**
  - Yes → **Movement magazine to back** → **Error**

- **Rotation magazine, search necessary collet chuck** → **Rotated spindle to zero mark encoder** → **Drops Z axis 150 mm** → **Clamping collet chuck** → **Availability control tool**
  - No → **Movement magazine to back** → **Error**
  - Yes → **Movement magazine to back** → **Finish Tool Change**

Intputs	
1	control of clamping
2	control of pressing
3	availability control tool
4	rotation control of magazine
5	the first position
6	Control movement magazine to spindle
7	Control movement magazine to back
Outputs	
1	motor of clamping and pressing
2	motor rotation magazine
3	motor movement magazine