

ABSTRACT

Tools (T) are classified into small type tools (ST) that can pass through the space between a pair of grippers (9) in its open position and large type tools (LT) that cannot pass through the space between the pair of grippers (9) in the open position, when the headstock (5) supporting a spindle (4) holding a tool (T) is moved to a position corresponding to a tool change position. When the next tool to be used is of the small type (ST), the tool is moved through a standby position (P) to the tool change position (Q) during a machining operation using the tool on the spindle (4), the headstock (5) is moved to the position corresponding to the tool change position in response to a tool changing instruction and a predetermined tool changing operation is carried out. When the next tool is of the large type (LT), the next tool is positioned and held at the standby position (P) during a machining operation, the headstock (5) is moved to the position corresponding to the tool change position, the next tool is moved to the tool change position and the tool changing operation is carried out.