

Name	Value	Data Type	Scope
counter_debouncer1	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>counter_debouncer1 - Station1_Program/SI_Logic - *41(ONS)</i>			
counter_debouncer2	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>counter_debouncer2 - Station1_Program/SI_Logic - *42(ONS)</i>			
counter_debouncer3	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>counter_debouncer3 - Station1_Program/SI_Logic - *43(ONS)</i>			
Current_State	0	DINT	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>Current_State - Station1_Program/SI_FaultCheck - 0(EQU), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU)</i>			
<i>Current_State - Station1_Program/SI_Logic - *0(MOV), *1(MOV), *18(MOV), *19(MOV), 1(NEQ), 10(EQU), 11(EQU), 12(EQU), 13(EQU), 14(EQU), 15(EQU), 16(EQU), 2(EQU), 28(EQU), 29(EQU), 3(EQU), 30(EQU), 31(EQU), 32(EQU), 33(EQU), 34(EQU), 35(EQU), 36(EQU), 37(EQU), 38(EQU), 39(EQU), 4(EQU), 40(EQU), 41(EQU), 42(EQU), 43(EQU), 5(EQU), 6(EQU), 7(EQU), 8(EQU), 9(EQU)</i>			
<i>Current_State - Station1_Program/SI_Outputs - 0(NEQ), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU)</i>			
drop_lift	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>drop_lift - Station1_Program/SI_Logic - *6(OTE)</i>			
<i>drop_lift - Station1_Program/SI_Outputs - 1(XIO)</i>			
Height_accepted_bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>Height_accepted_bit - Station1_Program/SI_Logic - 5(XIC), 6(XIO)</i>			
<i>Height_accepted_bit - Station1_Program/Station1_HeightCheck_Subroutine - *0(OTE)</i>			
Height_rejected_bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>Height_rejected_bit - Station1_Program/SI_Logic - 6(XIC)</i>			
<i>Height_rejected_bit - Station1_Program/Station1_HeightCheck_Subroutine - *1(OTE)</i>			
Move_Done_Bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>Move_Done_Bit - Station1_Program/SI_Logic - *14(OTU), 13(XIC)</i>			
<i>Move_Done_Bit - Station1_Program/Station1_Black_Sorting_Subroutine - *1(OTE)</i>			
<i>Move_Done_Bit - Station1_Program/Station1_Metal_Sorting_Subroutine - *2(OTE)</i>			
<i>Move_Done_Bit - Station1_Program/Station1_Red_Sorting_Subroutine - *1(OTE)</i>			
Next_State	0	DINT	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>Next_State - Station1_Program/SI_FaultCheck - 0(EQU), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU)</i>			
<i>Next_State - Station1_Program/SI_Logic - *0(MOV), *10(MOV), *11(MOV), *12(MOV), *13(MOV), *14(MOV), *15(MOV), *16(MOV), *18(MOV), *19(MOV), *2(MOV), *25(MOV), *3(MOV), *4(MOV), *5(MOV), *6(MOV), *7(MOV), *8(MOV), *9(MOV), 1(MOV), 1(NEQ), 28(EQU), 29(EQU), 30(EQU), 31(EQU), 32(EQU), 33(EQU), 34(EQU), 35(EQU), 36(EQU), 37(EQU), 38(EQU), 39(EQU), 40(EQU), 41(EQU), 42(EQU), 43(EQU)</i>			
<i>Next_State - Station1_Program/SI_Outputs - 0(NEQ), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU)</i>			
Pick_Move_Done	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		

Pick_Move_Done (Continued)			
<i>Pick_Move_Done - Station1_Program/S1_Logic - *11(OTU), 10(XIC)</i>			
<i>Pick_Move_Done - Station1_Program/Station1_Move_To_Pick_Spot - *2(OTE)</i>			
S1_ArmAir	0	BOOL	Station1_Program
AliasFor:	Remote_IO:5:O.0(C)		
Base Tag:	Remote_IO:O.Data[5].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ArmAir - Station1_Program/S1_Outputs - *3(OTE)</i>			
S1_ArmSenExt	0	BOOL	Station1_Program
AliasFor:	Remote_IO:1:I.1(C)		
Base Tag:	Remote_IO:I.Data[1].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ArmSenExt - Station1_Program/S1_FaultCheck - 3(XIO)</i>			
<i>S1_ArmSenExt - Station1_Program/S1_Inputs - 11(XIC)</i>			
S1_ArmSenRet	1	BOOL	Station1_Program
AliasFor:	Remote_IO:1:I.2(C)		
Base Tag:	Remote_IO:I.Data[1].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ArmSenRet - Station1_Program/S1_FaultCheck - 7(XIO)</i>			
<i>S1_ArmSenRet - Station1_Program/S1_Inputs - 12(XIC)</i>			
S1_ArmVacc	0	BOOL	Station1_Program
AliasFor:	Remote_IO:5:O.1(C)		
Base Tag:	Remote_IO:O.Data[5].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ArmVacc - Station1_Program/S1_Outputs - *4(OTE)</i>			
S1_Cap_Lift_Bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Cap_Lift_Bit - Station1_Program/S1_Inputs - *2(OTE)</i>			
<i>S1_Cap_Lift_Bit - Station1_Program/S1_Logic - 3(XIC), 31(XIC), 32(XIC), 33(XIC)</i>			
S1_CapSen_Lift	1	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.5(C)		
Base Tag:	Remote_IO:I.Data[2].5(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_CapSen_Lift - Station1_Program/S1_Inputs - 2(XIC)</i>			
S1_CapSen_Pick	0	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.2(C)		
Base Tag:	Remote_IO:I.Data[2].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_CapSen_Pick - Station1_Program/S1_Inputs - 6(XIC)</i>			
S1_Conveyor_Delay_timer		TIMER	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Conveyor_Delay_timer - Station1_Program/S1_Logic - *34(TON)</i>			
S1_Conveyor_Delay_timer.DN	0	BOOL	
<i>S1_Conveyor_Delay_timer.DN - Station1_Program/S1_Logic - 7(XIC)</i>			
S1_ConvMotor	0	BOOL	Station1_Program
AliasFor:	Remote_IO:6:O.3(C)		
Base Tag:	Remote_IO:O.Data[6].3(C)		

S1_ConvMotor (Continued)			
Constant	No		
External Access:	Read/Write		
<i>S1_ConvMotor - Station1_Program/S1_Outputs - *2(OTE)</i>			
S1_CylAir	0	BOOL	Station1_Program
AliasFor:	Remote_IO:5:O.2(C)		
Base Tag:	Remote_IO:O.Data[5].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_CylAir - Station1_Program/S1_Outputs - *5(OTE)</i>			
S1_Cylinder_extend_bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Cylinder_extend_bit - Station1_Program/S1_Inputs - *13(OTE)</i>			
<i>S1_Cylinder_extend_bit - Station1_Program/S1_Logic - 16(XIC), 8(XIC)</i>			
S1_CylSenExt	0	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.3(C)		
Base Tag:	Remote_IO:I.Data[2].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_CylSenExt - Station1_Program/S1_FaultCheck - 4(XIO)</i>			
<i>S1_CylSenExt - Station1_Program/S1_Inputs - 13(XIC)</i>			
S1_CylSenRet	1	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.4(C)		
Base Tag:	Remote_IO:I.Data[2].4(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_CylSenRet - Station1_Program/S1_FaultCheck - 5(XIO)</i>			
S1_Elevator_Delay_timer		TIMER	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Elevator_Delay_timer - Station1_Program/S1_Logic - *30(TON)</i>			
S1_Elevator_Delay_timer.DN	0	BOOL	
<i>S1_Elevator_Delay_timer.DN - Station1_Program/S1_Logic - 4(XIC)</i>			
S1_Gantry_Arm_Extended_Bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Gantry_Arm_Extended_Bit - Station1_Program/S1_Inputs - *11(OTE)</i>			
<i>S1_Gantry_Arm_Extended_Bit - Station1_Program/S1_Logic - 11(XIC), 14(XIC)</i>			
S1_Gantry_Arm_Retracted_Bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Gantry_Arm_Retracted_Bit - Station1_Program/S1_Inputs - *12(OTE)</i>			
<i>S1_Gantry_Arm_Retracted_Bit - Station1_Program/S1_Logic - 12(XIC), 15(XIC)</i>			
S1_HeightSen	15	INT	Station1_Program
AliasFor:	Remote_IO:4:I.Ch0Data(C)		
Base Tag:	Remote_IO:4:I.Ch0Data(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_HeightSen - Station1_Program/Station1_HeightCheck_Subroutine - 0(GRT), 0(LES), 1(GRT), 1(LES)</i>			
S1_Ind_Lift_Bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Ind_Lift_Bit - Station1_Program/S1_Inputs - *3(OTE)</i>			
<i>S1_Ind_Lift_Bit - Station1_Program/S1_Logic - 31(XIC), 32(XIO), 33(XIO)</i>			

S1_IndSen_Lift	0	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.6(C)		
Base Tag:	Remote_IO:I.Data[2].6(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_IndSen_Lift - Station1_Program/S1_Inputs - 3(XIC)</i>			
S1_Lift_Drop_timer		TIMER	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Lift_Drop_timer - Station1_Program/S1_Logic - *37(TON)</i>			
S1_Lift_Drop_timer.DN	0	BOOL	
<i>S1_Lift_Drop_timer.DN - Station1_Program/S1_FaultCheck - 4(XIC)</i>			
<i>S1_Lift_Drop_timer.DN - Station1_Program/S1_Outputs - 5(XIC)</i>			
S1_Lift_Rise_timer		TIMER	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Lift_Rise_timer - Station1_Program/S1_Logic - *35(TON)</i>			
S1_Lift_Rise_timer.DN	0	BOOL	
<i>S1_Lift_Rise_timer.DN - Station1_Program/S1_Logic - 5(XIC), 6(XIC)</i>			
S1_LiftAir	0	BOOL	Station1_Program
AliasFor:	Remote_IO:5:O.3(C)		
Base Tag:	Remote_IO:O.Data[5].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_LiftAir - Station1_Program/S1_Outputs - *1(OTE)</i>			
S1_LiftSen_Bottom	1	BOOL	Station1_Program
AliasFor:	Remote_IO:1:I.0(C)		
Base Tag:	Remote_IO:I.Data[1].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_LiftSen_Bottom - Station1_Program/S1_FaultCheck - 6(XIO)</i>			
<i>S1_LiftSen_Bottom - Station1_Program/S1_Inputs - 14(XIC)</i>			
S1_LiftSen_Bottom_Bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_LiftSen_Bottom_Bit - Station1_Program/S1_Inputs - *14(OTE)</i>			
<i>S1_LiftSen_Bottom_Bit - Station1_Program/S1_Logic - 16(XIC)</i>			
S1_LiftSen_Top	0	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.0(C)		
Base Tag:	Remote_IO:I.Data[2].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_LiftSen_Top - Station1_Program/S1_Inputs - 5(XIC)</i>			
S1_LimSw_X1	0	BOOL	Station1_Program
AliasFor:	Remote_IO:7:O.3(C)		
Base Tag:	Remote_IO:O.Data[7].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_LimSw_X1 - Station1_Program/S1_FaultCheck - 9(XIC), 9(XIO)</i>			
<i>S1_LimSw_X1 - Station1_Program/S1_Outputs - *7(OTE)</i>			
S1_LimSw_X2	0	BOOL	Station1_Program
AliasFor:	Remote_IO:7:O.2(C)		
Base Tag:	Remote_IO:O.Data[7].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_LimSw_X2 - Station1_Program/S1_FaultCheck - 9(XIC), 9(XIO)</i>			

S1_LimSw_X2 (Continued)			
<i>S1_LimSw_X2 - Station1_Program/S1_Outputs - *6(OTE)</i>			
S1_LimSw_Y1	0	BOOL	Station1_Program
AliasFor:	Remote_IO:7:O.0(C)		
Base Tag:	Remote_IO:O.Data[7].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_LimSw_Y1 - Station1_Program/S1_FaultCheck - 8(XIC), 8(XIO)</i>			
<i>S1_LimSw_Y1 - Station1_Program/S1_Outputs - *9(OTE)</i>			
S1_LimSw_Y2	0	BOOL	Station1_Program
AliasFor:	Remote_IO:7:O.1(C)		
Base Tag:	Remote_IO:O.Data[7].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_LimSw_Y2 - Station1_Program/S1_FaultCheck - 8(XIC), 8(XIO)</i>			
<i>S1_LimSw_Y2 - Station1_Program/S1_Outputs - *8(OTE)</i>			
S1_LimSwX1_Status	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_LimSwX1_Status - Station1_Program/S1_Logic - *23(OTU)</i>			
<i>S1_LimSwX1_Status - Station1_Program/S1_Outputs - 7(XIC)</i>			
<i>S1_LimSwX1_Status - Station1_Program/Station1_Black_Sorting_Subroutine - *0(OTE)</i>			
<i>S1_LimSwX1_Status - Station1_Program/Station1_Metal_Sorting_Subroutine - *0(OTE)</i>			
S1_LimSwX2_Status	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_LimSwX2_Status - Station1_Program/S1_Logic - *23(OTU)</i>			
<i>S1_LimSwX2_Status - Station1_Program/S1_Outputs - 6(XIC)</i>			
<i>S1_LimSwX2_Status - Station1_Program/Station1_Move_To_Pick_Spot - *0(OTE)</i>			
S1_LimSwY1_Status	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_LimSwY1_Status - Station1_Program/S1_Logic - *23(OTU)</i>			
<i>S1_LimSwY1_Status - Station1_Program/S1_Outputs - 9(XIC)</i>			
<i>S1_LimSwY1_Status - Station1_Program/Station1_Metal_Sorting_Subroutine - *1(OTE)</i>			
<i>S1_LimSwY1_Status - Station1_Program/Station1_Red_Sorting_Subroutine - *0(OTE)</i>			
S1_LimSwY2_Status	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_LimSwY2_Status - Station1_Program/S1_Logic - *23(OTU)</i>			
<i>S1_LimSwY2_Status - Station1_Program/S1_Outputs - 8(XIC)</i>			
<i>S1_LimSwY2_Status - Station1_Program/Station1_Move_To_Pick_Spot - *1(OTE)</i>			
S1_Opt_Lift_Bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Opt_Lift_Bit - Station1_Program/S1_Inputs - *4(OTE)</i>			
<i>S1_Opt_Lift_Bit - Station1_Program/S1_Logic - 31(XIC), 32(XIC), 33(XIO)</i>			
S1_OptSen_Lift	1	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.1(C)		
Base Tag:	Remote_IO:I.Data[2].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_OptSen_Lift - Station1_Program/S1_Inputs - 4(XIC)</i>			
S1_OrangeLED	0	BOOL	Station1_Program
AliasFor:	Remote_IO:6:O.1(C)		

S1_OrangeLED (Continued)			
Base Tag:	Remote_IO:O.Data[6].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_OrangeLED - Station1_Program/S1_Outputs - *10(OTE)</i>			
S1_Part_Pick_Ready_Bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Part_Pick_Ready_Bit - Station1_Program/S1_FaultCheck - 2(XIO)</i>			
<i>S1_Part_Pick_Ready_Bit - Station1_Program/S1_Inputs - *6(OTE)</i>			
<i>S1_Part_Pick_Ready_Bit - Station1_Program/S1_Logic - 9(XIC)</i>			
S1_Part_Top_Elevator_Bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Part_Top_Elevator_Bit - Station1_Program/S1_FaultCheck - 0(XIO)</i>			
<i>S1_Part_Top_Elevator_Bit - Station1_Program/S1_Inputs - *5(OTE)</i>			
<i>S1_Part_Top_Elevator_Bit - Station1_Program/S1_Logic - 5(XIC), 6(XIC)</i>			
S1_ProxSen_X1	0	BOOL	Station1_Program
AliasFor:	Remote_IO:1:I.3(C)		
Base Tag:	Remote_IO:I.Data[1].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ProxSen_X1 - Station1_Program/S1_Inputs - 9(XIC)</i>			
S1_ProxSen_X3	1	BOOL	Station1_Program
AliasFor:	Remote_IO:1:I.5(C)		
Base Tag:	Remote_IO:I.Data[1].5(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ProxSen_X3 - Station1_Program/S1_Inputs - 10(XIC)</i>			
S1_ProxSen_Y1	0	BOOL	Station1_Program
AliasFor:	Remote_IO:1:I.7(C)		
Base Tag:	Remote_IO:I.Data[1].7(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ProxSen_Y1 - Station1_Program/S1_Inputs - 7(XIC)</i>			
S1_ProxSen_Y2	1	BOOL	Station1_Program
AliasFor:	Remote_IO:1:I.6(C)		
Base Tag:	Remote_IO:I.Data[1].6(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_ProxSen_Y2 - Station1_Program/S1_Inputs - 8(XIC)</i>			
S1_RedLED	1	BOOL	Station1_Program
AliasFor:	Remote_IO:6:O.2(C)		
Base Tag:	Remote_IO:O.Data[6].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_RedLED - Station1_Program/S1_Logic - *24(OTE)</i>			
S1_START	0	BOOL	Station1_Program
AliasFor:	Remote_IO:2:I.7(C)		
Base Tag:	Remote_IO:I.Data[2].7(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_START - Station1_Program/S1_Inputs - 1(XIC)</i>			
S1_start_bit	0	BOOL	Station1_Program
Constant	No		

S1_start_bit (Continued)			
External Access:	Read/Write		
<i>S1_start_bit - Station1_Program/S1_Inputs - *1(OTE)</i>			
<i>S1_start_bit - Station1_Program/S1_Logic - 2(XIC)</i>			
S1_StartLED	0	BOOL	Station1_Program
AliasFor:	Remote_IO:6:O.0(C)		
Base Tag:	Remote_IO:O.Data[6].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_StartLED - HMI_Program/MainRoutine - 1(XIC)</i>			
<i>S1_StartLED - Station1_Program/S1_Outputs - *0(OTE)</i>			
S1_STOP	1	BOOL	Station1_Program
AliasFor:	Remote_IO:3:I.0(C)		
Base Tag:	Remote_IO:I.Data[3].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S1_STOP - HMI_Program/MainRoutine - 1(XIC)</i>			
<i>S1_STOP - Station1_Program/S1_Inputs - 0(XIC)</i>			
S1_stop_bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_stop_bit - Station1_Program/S1_Inputs - *0(OTE), 1(XIC)</i>			
<i>S1_stop_bit - Station1_Program/S1_Logic - 22(XIO)</i>			
<i>S1_stop_bit - Station1_Program/S1_Outputs - 2(XIC), 6(XIC), 7(XIC), 8(XIC), 9(XIC)</i>			
S1_X1_Bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_X1_Bit - Station1_Program/S1_Inputs - *9(OTE)</i>			
<i>S1_X1_Bit - Station1_Program/Station1_Black_Sorting_Subroutine - 0(XIO), 1(XIC)</i>			
<i>S1_X1_Bit - Station1_Program/Station1_Metal_Sorting_Subroutine - 0(XIO), 2(XIC)</i>			
S1_X3_Bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_X3_Bit - Station1_Program/S1_Inputs - *10(OTE)</i>			
<i>S1_X3_Bit - Station1_Program/Station1_Move_To_Pick_Spot - 0(XIO), 2(XIC)</i>			
S1_Y1_Bit	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Y1_Bit - Station1_Program/S1_Inputs - *7(OTE)</i>			
<i>S1_Y1_Bit - Station1_Program/Station1_Metal_Sorting_Subroutine - 1(XIO), 2(XIC)</i>			
<i>S1_Y1_Bit - Station1_Program/Station1_Red_Sorting_Subroutine - 0(XIO), 1(XIC)</i>			
S1_Y2_Bit	1	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>S1_Y2_Bit - Station1_Program/S1_Inputs - *8(OTE)</i>			
<i>S1_Y2_Bit - Station1_Program/Station1_Move_To_Pick_Spot - 1(XIO), 2(XIC)</i>			
TB_ONS1	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>TB_ONS1 - Station1_Program/S1_Logic - *18(ONS)</i>			
TB_ONS2	0	BOOL	Station1_Program
Constant	No		
External Access:	Read/Write		
<i>TB_ONS2 - Station1_Program/S1_Logic - *19(ONS)</i>			

wheel_colour	2	DINT	Station1_Program
Constant	No		
External Access:	Read/Write		
wheel_colour - Station1_Program/S1_Logic - *31(MOV), *32(MOV), *33(MOV), 38(EQU), 39(EQU), 40(EQU), 41(EQU), 42(EQU), 43(EQU), 6(EQU)			
wheel_colour - Station1_Program/S1_Outputs - 1(EQU)			