

Name	Value	Data Type	Scope
<b>counter_debouncer1</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>counter_debouncer1 - Station2_Program/S2_Logic - *41(ONS)</i>			
<b>counter_debouncer2</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>counter_debouncer2 - Station2_Program/S2_Logic - *42(ONS)</i>			
<b>counter_debouncer3</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>counter_debouncer3 - Station2_Program/S2_Logic - *43(ONS)</i>			
<b>Current_State</b>	0	DINT	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>Current_State - Station2_Program/S2_FaultCheck - 0(EQU), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU)</i>			
<i>Current_State - Station2_Program/S2_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 - Station2_Program/S2_Outputs - 0(NEQ), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU)</i>			
<b>drop_lift</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>drop_lift - Station2_Program/S2_Logic - *6(OTE)</i>			
<i>drop_lift - Station2_Program/S2_Outputs - 1(XIO)</i>			
<b>Height_accepted_bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>Height_accepted_bit - Station2_Program/S2_Logic - 5(XIC), 6(XIO)</i>			
<i>Height_accepted_bit - Station2_Program/Station2_HeightCheck_Subroutine - *0(OTE)</i>			
<b>Height_rejected_bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>Height_rejected_bit - Station2_Program/S2_Logic - 6(XIC)</i>			
<i>Height_rejected_bit - Station2_Program/Station2_HeightCheck_Subroutine - *1(OTE)</i>			
<b>Move_Done_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>Move_Done_Bit - Station2_Program/S2_Logic - *14(OTU), 13(XIC)</i>			
<i>Move_Done_Bit - Station2_Program/Station2_Black_Sorting_Subroutine - *1(OTE)</i>			
<i>Move_Done_Bit - Station2_Program/Station2_Metal_Sorting_Subroutine - *2(OTE)</i>			
<i>Move_Done_Bit - Station2_Program/Station2_Red_Sorting_Subroutine - *1(OTE)</i>			
<b>Next_State</b>	0	DINT	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>Next_State - Station2_Program/S2_FaultCheck - 0(EQU), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU)</i>			
<i>Next_State - Station2_Program/S2_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 - Station2_Program/S2_Outputs - 0(NEQ), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU)</i>			
<b>Pick_Move_Done</b>	1	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		

<b>Pick_Move_Done (Continued)</b>			
<i>Pick_Move_Done - Station2_Program/S2_Logic - *11(OTU), 10(XIC)</i>			
<i>Pick_Move_Done - Station2_Program/Station2_Move_To_Pick_Spot - *2(OTE)</i>			
<b>S2_ArmAir</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:5:O.0(C)		
Base Tag:	Remote_IO_2:O.Data[5].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ArmAir - Station2_Program/S2_Outputs - *3(OTE)</i>			
<b>S2_ArmSenExt</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:1:I.1(C)		
Base Tag:	Remote_IO_2:I.Data[1].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ArmSenExt - Station2_Program/S2_FaultCheck - 3(XIO)</i>			
<i>S2_ArmSenExt - Station2_Program/S2_Inputs - 11(XIC)</i>			
<b>S2_ArmSenRet</b>	1	BOOL	Station2_Program
AliasFor:	Remote_IO_2:1:I.2(C)		
Base Tag:	Remote_IO_2:I.Data[1].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ArmSenRet - Station2_Program/S2_FaultCheck - 7(XIO)</i>			
<i>S2_ArmSenRet - Station2_Program/S2_Inputs - 12(XIC)</i>			
<b>S2_ArmVacc</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:5:O.1(C)		
Base Tag:	Remote_IO_2:O.Data[5].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ArmVacc - Station2_Program/S2_Outputs - *4(OTE)</i>			
<b>S2_Cap_Lift_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Cap_Lift_Bit - Station2_Program/S2_Inputs - *2(OTE)</i>			
<i>S2_Cap_Lift_Bit - Station2_Program/S2_Logic - 3(XIC), 31(XIC), 32(XIC), 33(XIC)</i>			
<b>S2_CapSen_Lift</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.5(C)		
Base Tag:	Remote_IO_2:I.Data[2].5(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_CapSen_Lift - Station2_Program/S2_Inputs - 2(XIC)</i>			
<b>S2_CapSen_Pick</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.2(C)		
Base Tag:	Remote_IO_2:I.Data[2].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_CapSen_Pick - Station2_Program/S2_Inputs - 6(XIC)</i>			
<b>S2_Conveyor_Delay_timer</b>		TIMER	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Conveyor_Delay_timer - Station2_Program/S2_Logic - *34(TON)</i>			
<b>S2_Conveyor_Delay_timer.DN</b>	0	BOOL	
<i>S2_Conveyor_Delay_timer.DN - Station2_Program/S2_Logic - 7(XIC)</i>			
<b>S2_ConvMotor</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:6:O.3(C)		
Base Tag:	Remote_IO_2:O.Data[6].3(C)		

<b>S2_ConvMotor (Continued)</b>			
Constant	No		
External Access:	Read/Write		
<i>S2_ConvMotor - Station2_Program/S2_Outputs - *2(OTE)</i>			
<b>S2_CylAir</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:5:O.2(C)		
Base Tag:	Remote_IO_2:O.Data[5].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_CylAir - Station2_Program/S2_Outputs - *5(OTE)</i>			
<b>S2_Cylinder_extend_bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Cylinder_extend_bit - Station2_Program/S2_Inputs - *13(OTE)</i>			
<i>S2_Cylinder_extend_bit - Station2_Program/S2_Logic - 16(XIC), 8(XIC)</i>			
<b>S2_CylSenExt</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.3(C)		
Base Tag:	Remote_IO_2:I.Data[2].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_CylSenExt - Station2_Program/S2_FaultCheck - 4(XIO)</i>			
<i>S2_CylSenExt - Station2_Program/S2_Inputs - 13(XIC)</i>			
<b>S2_CylSenRet</b>	1	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.4(C)		
Base Tag:	Remote_IO_2:I.Data[2].4(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_CylSenRet - Station2_Program/S2_FaultCheck - 5(XIO)</i>			
<b>S2_Elevator_Delay_timer</b>		TIMER	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Elevator_Delay_timer - Station2_Program/S2_Logic - *30(TON)</i>			
<b>S2_Elevator_Delay_timer.DN</b>	0	BOOL	
<i>S2_Elevator_Delay_timer.DN - Station2_Program/S2_Logic - 4(XIC)</i>			
<b>S2_Gantry_Arm_Extended_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Gantry_Arm_Extended_Bit - Station2_Program/S2_Inputs - *11(OTE)</i>			
<i>S2_Gantry_Arm_Extended_Bit - Station2_Program/S2_Logic - 11(XIC), 14(XIC)</i>			
<b>S2_Gantry_Arm_Retracted_Bit</b>	1	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Gantry_Arm_Retracted_Bit - Station2_Program/S2_Inputs - *12(OTE)</i>			
<i>S2_Gantry_Arm_Retracted_Bit - Station2_Program/S2_Logic - 12(XIC), 15(XIC)</i>			
<b>S2_HeightSen</b>	68	INT	Station2_Program
AliasFor:	Remote_IO_2:4:I.Ch0Data(C)		
Base Tag:	Remote_IO_2:4:I.Ch0Data(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_HeightSen - Station2_Program/Station2_HeightCheck_Subroutine - 0(GRT), 0(LES), 1(GRT), 1(LES)</i>			
<b>S2_Ind_Lift_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Ind_Lift_Bit - Station2_Program/S2_Inputs - *3(OTE)</i>			
<i>S2_Ind_Lift_Bit - Station2_Program/S2_Logic - 31(XIC), 32(XIO), 33(XIO)</i>			

<b>S2_IndSen_Lift</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.6(C)		
Base Tag:	Remote_IO_2:I.Data[2].6(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_IndSen_Lift - Station2_Program/S2_Inputs - 3(XIC)</i>			
<b>S2_Lift_Drop_timer</b>		TIMER	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Lift_Drop_timer - Station2_Program/S2_Logic - *37(TON)</i>			
<b>S2_Lift_Drop_timer.DN</b>	0	BOOL	
<i>S2_Lift_Drop_timer.DN - Station2_Program/S2_FaultCheck - 4(XIC)</i>			
<i>S2_Lift_Drop_timer.DN - Station2_Program/S2_Outputs - 5(XIC)</i>			
<b>S2_Lift_Rise_timer</b>		TIMER	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Lift_Rise_timer - Station2_Program/S2_Logic - *35(TON)</i>			
<b>S2_Lift_Rise_timer.DN</b>	0	BOOL	
<i>S2_Lift_Rise_timer.DN - Station2_Program/S2_Logic - 5(XIC), 6(XIC)</i>			
<b>S2_LiftAir</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:5:O.3(C)		
Base Tag:	Remote_IO_2:O.Data[5].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_LiftAir - Station2_Program/S2_Outputs - *1(OTE)</i>			
<b>S2_LiftSen_Bottom</b>	1	BOOL	Station2_Program
AliasFor:	Remote_IO_2:1:I.0(C)		
Base Tag:	Remote_IO_2:I.Data[1].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_LiftSen_Bottom - Station2_Program/S2_FaultCheck - 6(XIO)</i>			
<i>S2_LiftSen_Bottom - Station2_Program/S2_Inputs - 14(XIC)</i>			
<b>S2_LiftSen_Bottom_Bit</b>	1	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_LiftSen_Bottom_Bit - Station2_Program/S2_Inputs - *14(OTE)</i>			
<i>S2_LiftSen_Bottom_Bit - Station2_Program/S2_Logic - 16(XIC)</i>			
<b>S2_LiftSen_Top</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.0(C)		
Base Tag:	Remote_IO_2:I.Data[2].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_LiftSen_Top - Station2_Program/S2_Inputs - 5(XIC)</i>			
<b>S2_LimSw_X1</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:7:O.3(C)		
Base Tag:	Remote_IO_2:O.Data[7].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_LimSw_X1 - Station2_Program/S2_FaultCheck - 9(XIC), 9(XIO)</i>			
<i>S2_LimSw_X1 - Station2_Program/S2_Outputs - *7(OTE)</i>			
<b>S2_LimSw_X2</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:7:O.2(C)		
Base Tag:	Remote_IO_2:O.Data[7].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_LimSw_X2 - Station2_Program/S2_FaultCheck - 9(XIC), 9(XIO)</i>			

<b>S2_LimSw_X2 (Continued)</b>			
<i>S2_LimSw_X2 - Station2_Program/S2_Outputs - *6(OTE)</i>			
<b>S2_LimSw_Y1</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:7:O.0(C)		
Base Tag:	Remote_IO_2:O.Data[7].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_LimSw_Y1 - Station2_Program/S2_FaultCheck - 8(XIC), 8(XIO)</i>			
<i>S2_LimSw_Y1 - Station2_Program/S2_Outputs - *9(OTE)</i>			
<b>S2_LimSw_Y2</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:7:O.1(C)		
Base Tag:	Remote_IO_2:O.Data[7].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_LimSw_Y2 - Station2_Program/S2_FaultCheck - 8(XIC), 8(XIO)</i>			
<i>S2_LimSw_Y2 - Station2_Program/S2_Outputs - *8(OTE)</i>			
<b>S2_LimSwX1_Status</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_LimSwX1_Status - Station2_Program/S2_Logic - *23(OTU)</i>			
<i>S2_LimSwX1_Status - Station2_Program/S2_Outputs - 7(XIC)</i>			
<i>S2_LimSwX1_Status - Station2_Program/Station2_Black_Sorting_Subroutine - *0(OTE)</i>			
<i>S2_LimSwX1_Status - Station2_Program/Station2_Metal_Sorting_Subroutine - *0(OTE)</i>			
<b>S2_LimSwX2_Status</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_LimSwX2_Status - Station2_Program/S2_Logic - *23(OTU)</i>			
<i>S2_LimSwX2_Status - Station2_Program/S2_Outputs - 6(XIC)</i>			
<i>S2_LimSwX2_Status - Station2_Program/Station2_Move_To_Pick_Spot - *0(OTE)</i>			
<b>S2_LimSwY1_Status</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_LimSwY1_Status - Station2_Program/S2_Logic - *23(OTU)</i>			
<i>S2_LimSwY1_Status - Station2_Program/S2_Outputs - 9(XIC)</i>			
<i>S2_LimSwY1_Status - Station2_Program/Station2_Metal_Sorting_Subroutine - *1(OTE)</i>			
<i>S2_LimSwY1_Status - Station2_Program/Station2_Red_Sorting_Subroutine - *0(OTE)</i>			
<b>S2_LimSwY2_Status</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_LimSwY2_Status - Station2_Program/S2_Logic - *23(OTU)</i>			
<i>S2_LimSwY2_Status - Station2_Program/S2_Outputs - 8(XIC)</i>			
<i>S2_LimSwY2_Status - Station2_Program/Station2_Move_To_Pick_Spot - *1(OTE)</i>			
<b>S2_Opt_Lift_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Opt_Lift_Bit - Station2_Program/S2_Inputs - *4(OTE)</i>			
<i>S2_Opt_Lift_Bit - Station2_Program/S2_Logic - 31(XIC), 32(XIC), 33(XIO)</i>			
<b>S2_OptSen_Lift</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.1(C)		
Base Tag:	Remote_IO_2:I.Data[2].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_OptSen_Lift - Station2_Program/S2_Inputs - 4(XIC)</i>			
<b>S2_OrangeLED</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:6:O.1(C)		

<b>S2_OrangeLED (Continued)</b>			
Base Tag:	Remote_IO_2:O.Data[6].1(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_OrangeLED - Station2_Program/S2_Outputs - *10(OTE)</i>			
<b>S2_Part_Pick_Ready_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Part_Pick_Ready_Bit - Station2_Program/S2_FaultCheck - 2(XIO)</i>			
<i>S2_Part_Pick_Ready_Bit - Station2_Program/S2_Inputs - *6(OTE)</i>			
<i>S2_Part_Pick_Ready_Bit - Station2_Program/S2_Logic - 9(XIC)</i>			
<b>S2_Part_Top_Elevator_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Part_Top_Elevator_Bit - Station2_Program/S2_FaultCheck - 0(XIO)</i>			
<i>S2_Part_Top_Elevator_Bit - Station2_Program/S2_Inputs - *5(OTE)</i>			
<i>S2_Part_Top_Elevator_Bit - Station2_Program/S2_Logic - 5(XIC), 6(XIC)</i>			
<b>S2_ProxSen_X1</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:1:I.3(C)		
Base Tag:	Remote_IO_2:I.Data[1].3(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ProxSen_X1 - Station2_Program/S2_Inputs - 9(XIC)</i>			
<b>S2_ProxSen_X3</b>	1	BOOL	Station2_Program
AliasFor:	Remote_IO_2:1:I.5(C)		
Base Tag:	Remote_IO_2:I.Data[1].5(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ProxSen_X3 - Station2_Program/S2_Inputs - 10(XIC)</i>			
<b>S2_ProxSen_Y1</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:1:I.7(C)		
Base Tag:	Remote_IO_2:I.Data[1].7(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ProxSen_Y1 - Station2_Program/S2_Inputs - 7(XIC)</i>			
<b>S2_ProxSen_Y2</b>	1	BOOL	Station2_Program
AliasFor:	Remote_IO_2:1:I.6(C)		
Base Tag:	Remote_IO_2:I.Data[1].6(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_ProxSen_Y2 - Station2_Program/S2_Inputs - 8(XIC)</i>			
<b>S2_RedLED</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:6:O.2(C)		
Base Tag:	Remote_IO_2:O.Data[6].2(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_RedLED - Station2_Program/S2_Logic - *24(OTE)</i>			
<b>S2_START</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:2:I.7(C)		
Base Tag:	Remote_IO_2:I.Data[2].7(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_START - Station2_Program/S2_Inputs - 1(XIC)</i>			
<b>S2_start_bit</b>	0	BOOL	Station2_Program
Constant	No		

<b>S2_start_bit (Continued)</b>			
External Access:	Read/Write		
<i>S2_start_bit - Station2_Program/S2_Inputs - *1(OTE)</i>			
<i>S2_start_bit - Station2_Program/S2_Logic - 2(XIC)</i>			
<b>S2_StartLED</b>	0	BOOL	Station2_Program
AliasFor:	Remote_IO_2:6:O.0(C)		
Base Tag:	Remote_IO_2:O.Data[6].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_StartLED - HMI_Program/MainRoutine - 2(XIC)</i>			
<i>S2_StartLED - Station2_Program/S2_Outputs - *0(OTE)</i>			
<b>S2_STOP</b>	1	BOOL	Station2_Program
AliasFor:	Remote_IO_2:3:I.0(C)		
Base Tag:	Remote_IO_2:I.Data[3].0(C)		
Constant	No		
External Access:	Read/Write		
<i>S2_STOP - HMI_Program/MainRoutine - 2(XIC)</i>			
<i>S2_STOP - Station2_Program/S2_Inputs - 0(XIC)</i>			
<b>S2_stop_bit</b>	1	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_stop_bit - Station2_Program/S2_Inputs - *0(OTE), 1(XIC)</i>			
<i>S2_stop_bit - Station2_Program/S2_Logic - 22(XIO)</i>			
<i>S2_stop_bit - Station2_Program/S2_Outputs - 2(XIC), 6(XIC), 7(XIC), 8(XIC), 9(XIC)</i>			
<b>S2_X1_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_X1_Bit - Station2_Program/S2_Inputs - *9(OTE)</i>			
<i>S2_X1_Bit - Station2_Program/Station2_Black_Sorting_Subroutine - 0(XIO), 1(XIC)</i>			
<i>S2_X1_Bit - Station2_Program/Station2_Metal_Sorting_Subroutine - 0(XIO), 2(XIC)</i>			
<b>S2_X3_Bit</b>	1	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_X3_Bit - Station2_Program/S2_Inputs - *10(OTE)</i>			
<i>S2_X3_Bit - Station2_Program/Station2_Move_To_Pick_Spot - 0(XIO), 2(XIC)</i>			
<b>S2_Y1_Bit</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Y1_Bit - Station2_Program/S2_Inputs - *7(OTE)</i>			
<i>S2_Y1_Bit - Station2_Program/Station2_Metal_Sorting_Subroutine - 1(XIO), 2(XIC)</i>			
<i>S2_Y1_Bit - Station2_Program/Station2_Red_Sorting_Subroutine - 0(XIO), 1(XIC)</i>			
<b>S2_Y2_Bit</b>	1	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>S2_Y2_Bit - Station2_Program/S2_Inputs - *8(OTE)</i>			
<i>S2_Y2_Bit - Station2_Program/Station2_Move_To_Pick_Spot - 1(XIO), 2(XIC)</i>			
<b>TB_ONS1</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>TB_ONS1 - Station2_Program/S2_Logic - *18(ONS)</i>			
<b>TB_ONS2</b>	0	BOOL	Station2_Program
Constant	No		
External Access:	Read/Write		
<i>TB_ONS2 - Station2_Program/S2_Logic - *19(ONS)</i>			

wheel_colour	1	DINT	Station2_Program
Constant	No		
External Access:	Read/Write		
wheel_colour - Station2_Program/S2_Logic - *31(MOV), *32(MOV), *33(MOV), 38(EQU), 39(EQU), 40(EQU), 41(EQU), 42(EQU), 43(EQU), 6(EQU)			
wheel_colour - Station2_Program/S2_Outputs - 1(EQU)			