Name	Value	Data Type	Scope
counter_debouncer1	0	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

counter_debouncer1 - Station3_Program/S3_Logic - *41(ONS)

counter_debouncer2	0	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

counter_debouncer2 - Station3_Program/S3_Logic - *42(ONS)

counter_debouncer3	0	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

counter_debouncer3 - Station3_Program/S3_Logic - *43(ONS)

Current_State	0	DINT	Station3_Program
Constant	No		
External Access:	Read/Write		

Current_State - Station3_Program/S3_FaultCheck - 0(EQU), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU)
Current_State - Station3_Program/S3_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)
Current_State - Station3_Program/S3_Outputs - 0(NEQ), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU)

drop_lift	0	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

drop_lift - Station3_Program/S3_Logic - *6(OTE)
drop_lift - Station3_Program/S3_Outputs - 1(XIO)

Height_accepted_bit	0	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

Height_accepted_bit - Station3_Program/S3_Logic - 5(XIC), 6(XIO)
Height_accepted_bit - Station3_Program/Station3_HeightCheck_Subroutine - *0(OTE)

Height_rejected_bit	0	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

Height_rejected_bit - Station3_Program/S3_Logic - 6(XIC)
Height_rejected_bit - Station3_Program/Station3_HeightCheck_Subroutine - *1(OTE)

Move_Done_Bit	0	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

Move_Done_Bit - Station3_Program/S3_Logic - *14(OTU), 13(XIC)
Move_Done_Bit - Station3_Program/Station3_Black_Sorting_Subroutine - *1(OTE)
Move_Done_Bit - Station3_Program/Station3_Metal_Sorting_Subroutine - *2(OTE)
Move_Done_Bit - Station3_Program/Station3_Red_Sorting_Subroutine - *1(OTE)

Next_State	0	DINT	Station3_Program
Constant	No		
External Access:	Read/Write		

Next_State - Station3_Program/S3_FaultCheck - 0(EQU), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU), 6(EQU), 7(EQU)
Next_State - Station3_Program/S3_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)
Next_State - Station3_Program/S3_Outputs - 0(NEQ), 1(EQU), 2(EQU), 3(EQU), 4(EQU), 5(EQU)

Pick_Move_Done	1	BOOL	Station3_Program
Constant	No		
External Access:	Read/Write		

Pick_Move_Done (Continued)
Pick_Move_Done - Station3_Program/S3_Logic - *11(OTU), 10(XIC)
Pick_Move_Done - Station3_Program/Station3_Move_To_Pick_Spot - *2(OTE)

S3_ArmAir	0	BOOL	Station3_Program

   AliasFor: Remote_IO_3:5:O.0(C)
   Base Tag: Remote_IO_3:O.Data[5].0(C)
   Constant   No
   External Access: Read/Write
   S3_ArmAir - Station3_Program/S3_Outputs - *3(OTE)

S3_ArmSenExt	0	BOOL	Station3_Program

   AliasFor: Remote_IO_3:1:I.1(C)
   Base Tag: Remote_IO_3:I.Data[1].1(C)
   Constant   No
   External Access: Read/Write
   S3_ArmSenExt - Station3_Program/S3_FaultCheck - 3(XIO)
   S3_ArmSenExt - Station3_Program/S3_Inputs - 11(XIC)

S3_ArmSenRet	1	BOOL	Station3_Program

   AliasFor: Remote_IO_3:1:I.2(C)
   Base Tag: Remote_IO_3:I.Data[1].2(C)
   Constant   No
   External Access: Read/Write
   S3_ArmSenRet - Station3_Program/S3_FaultCheck - 7(XIO)
   S3_ArmSenRet - Station3_Program/S3_Inputs - 12(XIC)

S3_ArmVacc	0	BOOL	Station3_Program

   AliasFor: Remote_IO_3:5:O.1(C)
   Base Tag: Remote_IO_3:O.Data[5].1(C)
   Constant   No
   External Access: Read/Write
   S3_ArmVacc - Station3_Program/S3_Outputs - *4(OTE)

S3_Cap_Lift_Bit	0	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   S3_Cap_Lift_Bit - Station3_Program/S3_Inputs - *2(OTE)
   S3_Cap_Lift_Bit - Station3_Program/S3_Logic - 3(XIC), 31(XIC), 32(XIC), 33(XIC)

S3_CapSen_Lift	0	BOOL	Station3_Program

   AliasFor: Remote_IO_3:2:I.5(C)
   Base Tag: Remote_IO_3:I.Data[2].5(C)
   Constant   No
   External Access: Read/Write
   S3_CapSen_Lift - Station3_Program/S3_Inputs - 2(XIC)

S3_CapSen_Pick	0	BOOL	Station3_Program

   AliasFor: Remote_IO_3:2:I.2(C)
   Base Tag: Remote_IO_3:I.Data[2].2(C)
   Constant   No
   External Access: Read/Write
   S3_CapSen_Pick - Station3_Program/S3_Inputs - 6(XIC)

S3_Conveyor_Delay_timer		TIMER	Station3_Program

   Constant   No
   External Access: Read/Write
   S3_Conveyor_Delay_timer - Station3_Program/S3_Logic - *34(TON)

S3_Conveyor_Delay_timer.DN	0	BOOL	

   S3_Conveyor_Delay_timer.DN - Station3_Program/S3_Logic - 7(XIC)

S3_ConvMotor	0	BOOL	Station3_Program

   AliasFor: Remote_IO_3:6:O.3(C)
   Base Tag: Remote_IO_3:O.Data[6].3(C)

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S3_ConvMotor (Continued)
Constant	No
External Access:	Read/Write

*S3_ConvMotor - Station3_Program/S3_Outputs - *2(OTE)*

S3_CylAir   0   BOOL   Station3_Program
AliasFor:	Remote_IO_3:5:O.2(C)
Base Tag:	Remote_IO_3:O.Data[5].2(C)
Constant	No
External Access:	Read/Write

*S3_CylAir - Station3_Program/S3_Outputs - *5(OTE)*

S3_Cylinder_extend_bit   0   BOOL   Station3_Program
Constant	No
External Access:	Read/Write

*S3_Cylinder_extend_bit - Station3_Program/S3_Inputs - *13(OTE)*
S3_Cylinder_extend_bit - Station3_Program/S3_Logic - 16(XIC), 8(XIC)

S3_CylSenExt   0   BOOL   Station3_Program
AliasFor:	Remote_IO_3:2:I.3(C)
Base Tag:	Remote_IO_3:I.Data[2].3(C)
Constant	No
External Access:	Read/Write

S3_CylSenExt - Station3_Program/S3_FaultCheck - 4(XIO)
S3_CylSenExt - Station3_Program/S3_Inputs - 13(XIC)

S3_CylSenRet   1   BOOL   Station3_Program
AliasFor:	Remote_IO_3:2:I.4(C)
Base Tag:	Remote_IO_3:I.Data[2].4(C)
Constant	No
External Access:	Read/Write

S3_CylSenRet - Station3_Program/S3_FaultCheck - 5(XIO)

S3_Elevator_Delay_timer   TIMER   Station3_Program
Constant	No
External Access:	Read/Write

*S3_Elevator_Delay_timer - Station3_Program/S3_Logic - *30(TON)*

S3_Elevator_Delay_timer.DN   0   BOOL

S3_Elevator_Delay_timer.DN - Station3_Program/S3_Logic - 4(XIC)

S3_Gantry_Arm_Extended_Bit   0   BOOL   Station3_Program
Constant	No
External Access:	Read/Write

*S3_Gantry_Arm_Extended_Bit - Station3_Program/S3_Inputs - *11(OTE)*
S3_Gantry_Arm_Extended_Bit - Station3_Program/S3_Logic - 11(XIC), 14(XIC)

S3_Gantry_Arm_Retracted_Bit   1   BOOL   Station3_Program
Constant	No
External Access:	Read/Write

*S3_Gantry_Arm_Retracted_Bit - Station3_Program/S3_Inputs - *12(OTE)*
S3_Gantry_Arm_Retracted_Bit - Station3_Program/S3_Logic - 12(XIC), 15(XIC)

S3_HeightSen   11   INT   Station3_Program
AliasFor:	Remote_IO_3:4:I.Ch0Data(C)
Base Tag:	Remote_IO_3:4:I.Ch0Data(C)
Constant	No
External Access:	Read/Write

S3_HeightSen - Station3_Program/Station3_HeightCheck_Subroutine - 0(GRT), 0(LES), 1(GRT), 1(LES)

S3_Ind_Lift_Bit   0   BOOL   Station3_Program
Constant	No
External Access:	Read/Write

*S3_Ind_Lift_Bit - Station3_Program/S3_Inputs - *3(OTE)*
S3_Ind_Lift_Bit - Station3_Program/S3_Logic - 31(XIC), 32(XIO), 33(XIO)

S3_IndSen_Lift   0   BOOL   Station3_Program
  AliasFor: Remote_IO_3:2:I.6(C)
  Base Tag: Remote_IO_3:I.Data[2].6(C)
  Constant   No
  External Access: Read/Write
  S3_IndSen_Lift - Station3_Program/S3_Inputs - 3(XIC)

S3_Lift_Drop_timer   TIMER   Station3_Program
  Constant   No
  External Access: Read/Write
  *S3_Lift_Drop_timer - Station3_Program/S3_Logic - *37(TON)*
  S3_Lift_Drop_timer.DN   0   BOOL
  S3_Lift_Drop_timer.DN - Station3_Program/S3_FaultCheck - 4(XIC)
  S3_Lift_Drop_timer.DN - Station3_Program/S3_Outputs - 5(XIC)

S3_Lift_Rise_timer   TIMER   Station3_Program
  Constant   No
  External Access: Read/Write
  *S3_Lift_Rise_timer - Station3_Program/S3_Logic - *35(TON)*
  S3_Lift_Rise_timer.DN   0   BOOL
  S3_Lift_Rise_timer.DN - Station3_Program/S3_Logic - 5(XIC), 6(XIC)

S3_LiftAir   0   BOOL   Station3_Program
  AliasFor: Remote_IO_3:5:O.3(C)
  Base Tag: Remote_IO_3:O.Data[5].3(C)
  Constant   No
  External Access: Read/Write
  *S3_LiftAir - Station3_Program/S3_Outputs - *1(OTE)*

S3_LiftSen_Bottom   1   BOOL   Station3_Program
  AliasFor: Remote_IO_3:1:I.0(C)
  Base Tag: Remote_IO_3:I.Data[1].0(C)
  Constant   No
  External Access: Read/Write
  S3_LiftSen_Bottom - Station3_Program/S3_FaultCheck - 6(XIO)
  S3_LiftSen_Bottom - Station3_Program/S3_Inputs - 14(XIC)

S3_LiftSen_Bottom_Bit   1   BOOL   Station3_Program
  Constant   No
  External Access: Read/Write
  *S3_LiftSen_Bottom_Bit - Station3_Program/S3_Inputs - *14(OTE)*
  S3_LiftSen_Bottom_Bit - Station3_Program/S3_Logic - 16(XIC)

S3_LiftSen_Top   0   BOOL   Station3_Program
  AliasFor: Remote_IO_3:2:I.0(C)
  Base Tag: Remote_IO_3:I.Data[2].0(C)
  Constant   No
  External Access: Read/Write
  S3_LiftSen_Top - Station3_Program/S3_Inputs - 5(XIC)

S3_LimSw_X1   0   BOOL   Station3_Program
  AliasFor: Remote_IO_3:7:O.3(C)
  Base Tag: Remote_IO_3:O.Data[7].3(C)
  Constant   No
  External Access: Read/Write
  S3_LimSw_X1 - Station3_Program/S3_FaultCheck - 9(XIC), 9(XIO)
  *S3_LimSw_X1 - Station3_Program/S3_Outputs - *7(OTE)*

S3_LimSw_X2   0   BOOL   Station3_Program
  AliasFor: Remote_IO_3:7:O.2(C)
  Base Tag: Remote_IO_3:O.Data[7].2(C)
  Constant   No
  External Access: Read/Write
  S3_LimSw_X2 - Station3_Program/S3_FaultCheck - 9(XIC), 9(XIO)

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S3_LimSw_X2 (Continued)
*S3_LimSw_X2 - Station3_Program/S3_Outputs - *6(OTE)*

S3_LimSw_Y1	0	BOOL	Station3_Program

AliasFor: Remote_IO_3:7:O.0(C)
Base Tag: Remote_IO_3:O.Data[7].0(C)
Constant   No
External Access: Read/Write
S3_LimSw_Y1 - Station3_Program/S3_FaultCheck - 8(XIC), 8(XIO)
*S3_LimSw_Y1 - Station3_Program/S3_Outputs - *9(OTE)*

S3_LimSw_Y2	0	BOOL	Station3_Program

AliasFor: Remote_IO_3:7:O.1(C)
Base Tag: Remote_IO_3:O.Data[7].1(C)
Constant   No
External Access: Read/Write
S3_LimSw_Y2 - Station3_Program/S3_FaultCheck - 8(XIC), 8(XIO)
*S3_LimSw_Y2 - Station3_Program/S3_Outputs - *8(OTE)*

S3_LimSwX1_Status	0	BOOL	Station3_Program

Constant   No
External Access: Read/Write
*S3_LimSwX1_Status - Station3_Program/S3_Logic - *23(OTU)*
S3_LimSwX1_Status - Station3_Program/S3_Outputs - 7(XIC)
*S3_LimSwX1_Status - Station3_Program/Station3_Black_Sorting_Subroutine - *0(OTE)*
*S3_LimSwX1_Status - Station3_Program/Station3_Metal_Sorting_Subroutine - *0(OTE)*

S3_LimSwX2_Status	0	BOOL	Station3_Program

Constant   No
External Access: Read/Write
*S3_LimSwX2_Status - Station3_Program/S3_Logic - *23(OTU)*
S3_LimSwX2_Status - Station3_Program/S3_Outputs - 6(XIC)
*S3_LimSwX2_Status - Station3_Program/Station3_Move_To_Pick_Spot - *0(OTE)*

S3_LimSwY1_Status	0	BOOL	Station3_Program

Constant   No
External Access: Read/Write
*S3_LimSwY1_Status - Station3_Program/S3_Logic - *23(OTU)*
S3_LimSwY1_Status - Station3_Program/S3_Outputs - 9(XIC)
*S3_LimSwY1_Status - Station3_Program/Station3_Metal_Sorting_Subroutine - *1(OTE)*
*S3_LimSwY1_Status - Station3_Program/Station3_Red_Sorting_Subroutine - *0(OTE)*

S3_LimSwY2_Status	0	BOOL	Station3_Program

Constant   No
External Access: Read/Write
*S3_LimSwY2_Status - Station3_Program/S3_Logic - *23(OTU)*
S3_LimSwY2_Status - Station3_Program/S3_Outputs - 8(XIC)
*S3_LimSwY2_Status - Station3_Program/Station3_Move_To_Pick_Spot - *1(OTE)*

S3_Opt_Lift_Bit	1	BOOL	Station3_Program

Constant   No
External Access: Read/Write
*S3_Opt_Lift_Bit - Station3_Program/S3_Inputs - *4(OTE)*
S3_Opt_Lift_Bit - Station3_Program/S3_Logic - 31(XIC), 32(XIC), 33(XIO)

S3_OptSen_Lift	1	BOOL	Station3_Program

AliasFor: Remote_IO_3:2:I.1(C)
Base Tag: Remote_IO_3:I.Data[2].1(C)
Constant   No
External Access: Read/Write
S3_OptSen_Lift - Station3_Program/S3_Inputs - 4(XIC)

S3_OrangeLED	0	BOOL	Station3_Program

AliasFor: Remote_IO_3:6:O.1(C)

S3_OrangeLED (Continued)
    Base Tag: Remote_IO_3:O.Data[6].1(C)
    Constant   No
    External Access: Read/Write
    S3_OrangeLED - Station3_Program/S3_Outputs - *10(OTE)

S3_Part_Pick_Ready_Bit	0		BOOL	Station3_Program

    Constant   No
    External Access: Read/Write
    S3_Part_Pick_Ready_Bit - Station3_Program/S3_FaultCheck - 2(XIO)
    S3_Part_Pick_Ready_Bit - Station3_Program/S3_Inputs - *6(OTE)
    S3_Part_Pick_Ready_Bit - Station3_Program/S3_Logic - 9(XIC)

S3_Part_Top_Elevator_Bit	0		BOOL	Station3_Program

    Constant   No
    External Access: Read/Write
    S3_Part_Top_Elevator_Bit - Station3_Program/S3_FaultCheck - 0(XIO)
    S3_Part_Top_Elevator_Bit - Station3_Program/S3_Inputs - *5(OTE)
    S3_Part_Top_Elevator_Bit - Station3_Program/S3_Logic - 5(XIC), 6(XIC)

S3_ProxSen_X1	0		BOOL	Station3_Program

    AliasFor: Remote_IO_3:1:I.3(C)
    Base Tag: Remote_IO_3:I.Data[1].3(C)
    Constant   No
    External Access: Read/Write
    S3_ProxSen_X1 - Station3_Program/S3_Inputs - 9(XIC)

S3_ProxSen_X3	1		BOOL	Station3_Program

    AliasFor: Remote_IO_3:1:I.5(C)
    Base Tag: Remote_IO_3:I.Data[1].5(C)
    Constant   No
    External Access: Read/Write
    S3_ProxSen_X3 - Station3_Program/S3_Inputs - 10(XIC)

S3_ProxSen_Y1	0		BOOL	Station3_Program

    AliasFor: Remote_IO_3:1:I.7(C)
    Base Tag: Remote_IO_3:I.Data[1].7(C)
    Constant   No
    External Access: Read/Write
    S3_ProxSen_Y1 - Station3_Program/S3_Inputs - 7(XIC)

S3_ProxSen_Y2	1		BOOL	Station3_Program

    AliasFor: Remote_IO_3:1:I.6(C)
    Base Tag: Remote_IO_3:I.Data[1].6(C)
    Constant   No
    External Access: Read/Write
    S3_ProxSen_Y2 - Station3_Program/S3_Inputs - 8(XIC)

S3_RedLED	0		BOOL	Station3_Program

    AliasFor: Remote_IO_3:6:O.2(C)
    Base Tag: Remote_IO_3:O.Data[6].2(C)
    Constant   No
    External Access: Read/Write
    S3_RedLED - Station3_Program/S3_Logic - *24(OTE)

S3_START	0		BOOL	Station3_Program

    AliasFor: Remote_IO_3:2:I.7(C)
    Base Tag: Remote_IO_3:I.Data[2].7(C)
    Constant   No
    External Access: Read/Write
    S3_START - Station3_Program/S3_Inputs - 1(XIC)

S3_start_bit	0		BOOL	Station3_Program

    Constant   No

S3_start_bit (Continued)
   External Access: Read/Write
   *S3_start_bit - Station3_Program/S3_Inputs - *1(OTE)*
   S3_start_bit - Station3_Program/S3_Logic - 2(XIC)

S3_StartLED	0	BOOL	Station3_Program

   AliasFor: Remote_IO_3:6:O.0(C)
   Base Tag: Remote_IO_3:O.Data[6].0(C)
   Constant   No
   External Access: Read/Write
   S3_StartLED - HMI_Program/MainRoutine - 3(XIC)
   *S3_StartLED - Station3_Program/S3_Outputs - *0(OTE)*

S3_STOP	1	BOOL	Station3_Program

   AliasFor: Remote_IO_3:3:I.0(C)
   Base Tag: Remote_IO_3:I.Data[3].0(C)
   Constant   No
   External Access: Read/Write
   S3_STOP - HMI_Program/MainRoutine - 3(XIC)
   S3_STOP - Station3_Program/S3_Inputs - 0(XIC)

S3_stop_bit	1	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   *S3_stop_bit - Station3_Program/S3_Inputs - *0(OTE), 1(XIC)*
   S3_stop_bit - Station3_Program/S3_Logic - 22(XIO)
   S3_stop_bit - Station3_Program/S3_Outputs - 2(XIC), 6(XIC), 7(XIC), 8(XIC), 9(XIC)

S3_X1_Bit	0	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   *S3_X1_Bit - Station3_Program/S3_Inputs - *9(OTE)*
   S3_X1_Bit - Station3_Program/Station3_Black_Sorting_Subroutine - 0(XIO), 1(XIC)
   S3_X1_Bit - Station3_Program/Station3_Metal_Sorting_Subroutine - 0(XIO), 2(XIC)

S3_X3_Bit	1	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   *S3_X3_Bit - Station3_Program/S3_Inputs - *10(OTE)*
   S3_X3_Bit - Station3_Program/Station3_Move_To_Pick_Spot - 0(XIO), 2(XIC)

S3_Y1_Bit	0	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   *S3_Y1_Bit - Station3_Program/S3_Inputs - *7(OTE)*
   S3_Y1_Bit - Station3_Program/Station3_Metal_Sorting_Subroutine - 1(XIO), 2(XIC)
   S3_Y1_Bit - Station3_Program/Station3_Red_Sorting_Subroutine - 0(XIO), 1(XIC)

S3_Y2_Bit	1	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   *S3_Y2_Bit - Station3_Program/S3_Inputs - *8(OTE)*
   S3_Y2_Bit - Station3_Program/Station3_Move_To_Pick_Spot - 1(XIO), 2(XIC)

TB_ONS1	0	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   *TB_ONS1 - Station3_Program/S3_Logic - *18(ONS)*

TB_ONS2	0	BOOL	Station3_Program

   Constant   No
   External Access: Read/Write
   *TB_ONS2 - Station3_Program/S3_Logic - *19(ONS)*

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wheel_colour	1	DINT	Station3_Program

    Constant   No
    External Access: Read/Write
    *wheel_colour - Station3_Program/S3_Logic - *31(MOV), *32(MOV), *33(MOV), 38(EQU), 39(EQU), 40(EQU), 41(EQU), 42(EQU), 43(EQU), 6(EQU)*
    wheel_colour - Station3_Program/S3_Outputs - 1(EQU)