Name	Value	Data Type	Scope
HMI_START_ALL	0	BOOL	MultiStation_test
Constant	No		
External Access:	Read/Write		
HMI_START_ALL - Station1_Program/S1_Inputs - 1(XIC)			
HMI_START_ALL - Station2_Program/S2_Inputs - 1(XIC)			
HMI_START_ALL - Station3_Program/S3_Inputs - 1(XIC)			
HMI_START_S1	0	BOOL	MultiStation_test
Constant	No		
External Access:	Read/Write		
HMI_START_S1 - Station1_Program/S1_Inputs - 1(XIC)			
HMI_START_S1_LIGHT	0	BOOL	MultiStation_test
Constant	No		
External Access:	Read/Write		
*HMI_START_S1_LIGHT - HMI_Program/MainRoutine - *1(OTE)*			
HMI_START_S2	0	BOOL	MultiStation_test
Constant	No		
External Access:	Read/Write		
HMI_START_S2 - Station2_Program/S2_Inputs - 1(XIC)			
HMI_START_S2_LIGHT	0	BOOL	MultiStation_test
Constant	No		
External Access:	Read/Write		
*HMI_START_S2_LIGHT - HMI_Program/MainRoutine - *2(OTE)*			
HMI_START_S3	0	BOOL	MultiStation_test
Constant	No		
External Access:	Read/Write		
HMI_START_S3 - Station3_Program/S3_Inputs - 1(XIC)			
HMI_START_S3_LIGHT	0	BOOL	MultiStation_test
Constant	No		
External Access:	Read/Write		
*HMI_START_S3_LIGHT - HMI_Program/MainRoutine - *3(OTE)*			
Remote_IO:1:I	2#0110_0101	SINT	MultiStation_test
AliasFor:	Remote_IO:I.Data[1]		
Base Tag:	Remote_IO:I.Data[1]		
Constant	No		
External Access:	Read/Write		
Remote_IO:1:I.1	0	BOOL	
S1_ArmSenExt - Station1_Program/S1_FaultCheck - 3(XIO)			
S1_ArmSenExt - Station1_Program/S1_Inputs - 11(XIC)			
Remote_IO:1:I.2	1	BOOL	
S1_ArmSenRet - Station1_Program/S1_FaultCheck - 7(XIO)			
S1_ArmSenRet - Station1_Program/S1_Inputs - 12(XIC)			
Remote_IO:1:I.3	0	BOOL	
S1_ProxSen_X1 - Station1_Program/S1_Inputs - 9(XIC)			
Remote_IO:1:I.5	1	BOOL	
S1_ProxSen_X3 - Station1_Program/S1_Inputs - 10(XIC)			
Remote_IO:1:I.6	1	BOOL	
S1_ProxSen_Y2 - Station1_Program/S1_Inputs - 8(XIC)			
Remote_IO:1:I.7	0	BOOL	
S1_ProxSen_Y1 - Station1_Program/S1_Inputs - 7(XIC)			
Remote_IO:2:I	2#0011_0010	SINT	MultiStation_test
AliasFor:	Remote_IO:I.Data[2]		
Base Tag:	Remote_IO:I.Data[2]		
Constant	No		
External Access:	Read/Write		
Remote_IO:2:I.1	1	BOOL	

Remote_IO:2:I (Continued)
S1_OptSen_Lift - Station1_Program/S1_Inputs - 4(XIC)

Remote_IO:2:I.2	0	BOOL	
S1_CapSen_Pick - Station1_Program/S1_Inputs - 6(XIC)			
Remote_IO:2:I.3	0	BOOL	
S1_CylSenExt - Station1_Program/S1_FaultCheck - 4(XIO)			
S1_CylSenExt - Station1_Program/S1_Inputs - 13(XIC)			
Remote_IO:2:I.4	1	BOOL	
S1_CylSenRet - Station1_Program/S1_FaultCheck - 5(XIO)			
Remote_IO:2:I.5	1	BOOL	
S1_CapSen_Lift - Station1_Program/S1_Inputs - 2(XIC)			
Remote_IO:2:I.6	0	BOOL	
S1_IndSen_Lift - Station1_Program/S1_Inputs - 3(XIC)			
Remote_IO:2:I.7	0	BOOL	
S1_START - Station1_Program/S1_Inputs - 1(XIC)			
Remote_IO:3:I	2#0000_0001	SINT	MultiStation_test
AliasFor:	Remote_IO:I.Data[3]		
Base Tag:	Remote_IO:I.Data[3]		
Constant	No		
External Access:	Read/Write		
Remote_IO:4:I		AB:1734_IE2:I:0	MultiStation_test
Constant	No		
External Access:	Read/Write		
Remote_IO:4:I.Ch0Data	15	INT	
S1_HeightSen - Station1_Program/Station1_HeightCheck_Subroutine - 0(GRT), 0(LES), 1(GRT), 1(LES)			
Remote_IO:5:O	2#0000_0000	SINT	MultiStation_test
AliasFor:	Remote_IO:O.Data[5]		
Base Tag:	Remote_IO:O.Data[5]		
Constant	No		
External Access:	Read/Write		
Remote_IO:5:O.1	0	BOOL	
*S1_ArmVacc - Station1_Program/S1_Outputs - *4(OTE)*			
Remote_IO:5:O.2	0	BOOL	
*S1_CylAir - Station1_Program/S1_Outputs - *5(OTE)*			
Remote_IO:5:O.3	0	BOOL	
*S1_LiftAir - Station1_Program/S1_Outputs - *1(OTE)*			
Remote_IO:6:O	2#0000_0100	SINT	MultiStation_test
AliasFor:	Remote_IO:O.Data[6]		
Base Tag:	Remote_IO:O.Data[6]		
Constant	No		
External Access:	Read/Write		
Remote_IO:6:O.1	0	BOOL	
*S1_OrangeLED - Station1_Program/S1_Outputs - *10(OTE)*			
Remote_IO:6:O.2	1	BOOL	
*S1_RedLED - Station1_Program/S1_Logic - *24(OTE)*			
Remote_IO:6:O.3	0	BOOL	
*S1_ConvMotor - Station1_Program/S1_Outputs - *2(OTE)*			
Remote_IO:7:O	2#0000_0000	SINT	MultiStation_test
AliasFor:	Remote_IO:O.Data[7]		
Base Tag:	Remote_IO:O.Data[7]		
Constant	No		
External Access:	Read/Write		
Remote_IO:7:O.1	0	BOOL	
S1_LimSw_Y2 - Station1_Program/S1_FaultCheck - 8(XIC), 8(XIO)			
*S1_LimSw_Y2 - Station1_Program/S1_Outputs - *8(OTE)*			
Remote_IO:7:O.2	0	BOOL	
S1_LimSw_X2 - Station1_Program/S1_FaultCheck - 9(XIC), 9(XIO)			
*S1_LimSw_X2 - Station1_Program/S1_Outputs - *6(OTE)*			
Remote_IO:7:O.3	0	BOOL	

Remote_IO:7:O (Continued)
S1_LimSw_X1 - Station1_Program/S1_FaultCheck - 9(XIC), 9(XIO)
*S1_LimSw_X1 - Station1_Program/S1_Outputs - *7(OTE)*

Remote_IO:I		AB:1734_8SLOT:I:0	MultiStation_test
Constant	No		
External Access:	Read/Write		
Remote_IO:I.Data[1].0	1	BOOL	
S1_LiftSen_Bottom - Station1_Program/S1_FaultCheck - 6(XIO)			
S1_LiftSen_Bottom - Station1_Program/S1_Inputs - 14(XIC)			
Remote_IO:I.Data[1].1	0	BOOL	
S1_ArmSenExt - Station1_Program/S1_FaultCheck - 3(XIO)			
S1_ArmSenExt - Station1_Program/S1_Inputs - 11(XIC)			
Remote_IO:I.Data[1].2	1	BOOL	
S1_ArmSenRet - Station1_Program/S1_FaultCheck - 7(XIO)			
S1_ArmSenRet - Station1_Program/S1_Inputs - 12(XIC)			
Remote_IO:I.Data[1].3	0	BOOL	
S1_ProxSen_X1 - Station1_Program/S1_Inputs - 9(XIC)			
Remote_IO:I.Data[1].5	1	BOOL	
S1_ProxSen_X3 - Station1_Program/S1_Inputs - 10(XIC)			
Remote_IO:I.Data[1].6	1	BOOL	
S1_ProxSen_Y2 - Station1_Program/S1_Inputs - 8(XIC)			
Remote_IO:I.Data[1].7	0	BOOL	
S1_ProxSen_Y1 - Station1_Program/S1_Inputs - 7(XIC)			
Remote_IO:I.Data[2].0	0	BOOL	
S1_LiftSen_Top - Station1_Program/S1_Inputs - 5(XIC)			
Remote_IO:I.Data[2].1	1	BOOL	
S1_OptSen_Lift - Station1_Program/S1_Inputs - 4(XIC)			
Remote_IO:I.Data[2].2	0	BOOL	
S1_CapSen_Pick - Station1_Program/S1_Inputs - 6(XIC)			
Remote_IO:I.Data[2].3	0	BOOL	
S1_CylSenExt - Station1_Program/S1_FaultCheck - 4(XIO)			
S1_CylSenExt - Station1_Program/S1_Inputs - 13(XIC)			
Remote_IO:I.Data[2].4	1	BOOL	
S1_CylSenRet - Station1_Program/S1_FaultCheck - 5(XIO)			
Remote_IO:I.Data[2].5	1	BOOL	
S1_CapSen_Lift - Station1_Program/S1_Inputs - 2(XIC)			
Remote_IO:I.Data[2].6	0	BOOL	
S1_IndSen_Lift - Station1_Program/S1_Inputs - 3(XIC)			
Remote_IO:I.Data[2].7	0	BOOL	
S1_START - Station1_Program/S1_Inputs - 1(XIC)			
Remote_IO:I.Data[3].0	1	BOOL	
S1_STOP - HMI_Program/MainRoutine - 1(XIC)			
S1_STOP - Station1_Program/S1_Inputs - 0(XIC)			

Remote_IO:O		AB:1734_8SLOT:O:0	MultiStation_test
Constant	No		
External Access:	Read/Write		
Remote_IO:O.Data[5].0	0	BOOL	
*S1_ArmAir - Station1_Program/S1_Outputs - *3(OTE)*			
Remote_IO:O.Data[5].1	0	BOOL	
*S1_ArmVacc - Station1_Program/S1_Outputs - *4(OTE)*			
Remote_IO:O.Data[5].2	0	BOOL	
*S1_CylAir - Station1_Program/S1_Outputs - *5(OTE)*			
Remote_IO:O.Data[5].3	0	BOOL	
*S1_LiftAir - Station1_Program/S1_Outputs - *1(OTE)*			
Remote_IO:O.Data[6].0	0	BOOL	
S1_StartLED - HMI_Program/MainRoutine - 1(XIC)			
*S1_StartLED - Station1_Program/S1_Outputs - *0(OTE)*			
Remote_IO:O.Data[6].1	0	BOOL	
*S1_OrangeLED - Station1_Program/S1_Outputs - *10(OTE)*			
Remote_IO:O.Data[6].2	1	BOOL	
*S1_RedLED - Station1_Program/S1_Logic - *24(OTE)*			
Remote_IO:O.Data[6].3	0	BOOL	

Remote_IO:O (Continued)
*S1_ConvMotor - Station1_Program/S1_Outputs - *2(OTE)*

Remote_IO:O.Data[7].0	0	BOOL	
S1_LimSw_Y1 - Station1_Program/S1_FaultCheck - 8(XIC), 8(XIO)			
*S1_LimSw_Y1 - Station1_Program/S1_Outputs - *9(OTE)*			
Remote_IO:O.Data[7].1	0	BOOL	
S1_LimSw_Y2 - Station1_Program/S1_FaultCheck - 8(XIC), 8(XIO)			
*S1_LimSw_Y2 - Station1_Program/S1_Outputs - *8(OTE)*			
Remote_IO:O.Data[7].2	0	BOOL	
S1_LimSw_X2 - Station1_Program/S1_FaultCheck - 9(XIC), 9(XIO)			
*S1_LimSw_X2 - Station1_Program/S1_Outputs - *6(OTE)*			
Remote_IO:O.Data[7].3	0	BOOL	
S1_LimSw_X1 - Station1_Program/S1_FaultCheck - 9(XIC), 9(XIO)			
*S1_LimSw_X1 - Station1_Program/S1_Outputs - *7(OTE)*			

Remote_IO_2:1:I	2#0110_0101	SINT	MultiStation_test
AliasFor:	Remote_IO_2:I.Data[1]		
Base Tag:	Remote_IO_2:I.Data[1]		
Constant	No		
External Access:	Read/Write		
Remote_IO_2:1:I.1	0	BOOL	
S2_ArmSenExt - Station2_Program/S2_FaultCheck - 3(XIO)			
S2_ArmSenExt - Station2_Program/S2_Inputs - 11(XIC)			
Remote_IO_2:1:I.2	1	BOOL	
S2_ArmSenRet - Station2_Program/S2_FaultCheck - 7(XIO)			
S2_ArmSenRet - Station2_Program/S2_Inputs - 12(XIC)			
Remote_IO_2:1:I.3	0	BOOL	
S2_ProxSen_X1 - Station2_Program/S2_Inputs - 9(XIC)			
Remote_IO_2:1:I.5	1	BOOL	
S2_ProxSen_X3 - Station2_Program/S2_Inputs - 10(XIC)			
Remote_IO_2:1:I.6	1	BOOL	
S2_ProxSen_Y2 - Station2_Program/S2_Inputs - 8(XIC)			
Remote_IO_2:1:I.7	0	BOOL	
S2_ProxSen_Y1 - Station2_Program/S2_Inputs - 7(XIC)			

Remote_IO_2:2:I	2#0001_0000	SINT	MultiStation_test
AliasFor:	Remote_IO_2:I.Data[2]		
Base Tag:	Remote_IO_2:I.Data[2]		
Constant	No		
External Access:	Read/Write		
Remote_IO_2:2:I.1	0	BOOL	
S2_OptSen_Lift - Station2_Program/S2_Inputs - 4(XIC)			
Remote_IO_2:2:I.2	0	BOOL	
S2_CapSen_Pick - Station2_Program/S2_Inputs - 6(XIC)			
Remote_IO_2:2:I.3	0	BOOL	
S2_CylSenExt - Station2_Program/S2_FaultCheck - 4(XIO)			
S2_CylSenExt - Station2_Program/S2_Inputs - 13(XIC)			
Remote_IO_2:2:I.4	1	BOOL	
S2_CylSenRet - Station2_Program/S2_FaultCheck - 5(XIO)			
Remote_IO_2:2:I.5	0	BOOL	
S2_CapSen_Lift - Station2_Program/S2_Inputs - 2(XIC)			
Remote_IO_2:2:I.6	0	BOOL	
S2_IndSen_Lift - Station2_Program/S2_Inputs - 3(XIC)			
Remote_IO_2:2:I.7	0	BOOL	
S2_START - Station2_Program/S2_Inputs - 1(XIC)			

Remote_IO_2:3:I	2#0000_0001	SINT	MultiStation_test
AliasFor:	Remote_IO_2:I.Data[3]		
Base Tag:	Remote_IO_2:I.Data[3]		
Constant	No		
External Access:	Read/Write		

Remote_IO_2:4:I		AB:1734_IE2:I:0	MultiStation_test
Constant	No		

Remote_IO_2:4:I (Continued)
External Access: Read/Write
Remote_IO_2:4:I.Ch0Data 68 INT
S2_HeightSen - Station2_Program/Station2_HeightCheck_Subroutine - 0(GRT), 0(LES), 1(GRT), 1(LES)

Remote_IO_2:5:O 2#0000_0000 SINT MultiStation_test
AliasFor: Remote_IO_2:O.Data[5]
Base Tag: Remote_IO_2:O.Data[5]
Constant No
External Access: Read/Write
Remote_IO_2:5:O.1 0 BOOL
*S2_ArmVacc - Station2_Program/S2_Outputs - *4(OTE)*
Remote_IO_2:5:O.2 0 BOOL
*S2_CylAir - Station2_Program/S2_Outputs - *5(OTE)*
Remote_IO_2:5:O.3 0 BOOL
*S2_LiftAir - Station2_Program/S2_Outputs - *1(OTE)*

Remote_IO_2:6:O 2#0000_0000 SINT MultiStation_test
AliasFor: Remote_IO_2:O.Data[6]
Base Tag: Remote_IO_2:O.Data[6]
Constant No
External Access: Read/Write
Remote_IO_2:6:O.1 0 BOOL
*S2_OrangeLED - Station2_Program/S2_Outputs - *10(OTE)*
Remote_IO_2:6:O.2 0 BOOL
*S2_RedLED - Station2_Program/S2_Logic - *24(OTE)*
Remote_IO_2:6:O.3 0 BOOL
*S2_ConvMotor - Station2_Program/S2_Outputs - *2(OTE)*

Remote_IO_2:7:O 2#0000_0000 SINT MultiStation_test
AliasFor: Remote_IO_2:O.Data[7]
Base Tag: Remote_IO_2:O.Data[7]
Constant No
External Access: Read/Write
Remote_IO_2:7:O.1 0 BOOL
S2_LimSw_Y2 - Station2_Program/S2_FaultCheck - 8(XIC), 8(XIO)
*S2_LimSw_Y2 - Station2_Program/S2_Outputs - *8(OTE)*
Remote_IO_2:7:O.2 0 BOOL
S2_LimSw_X2 - Station2_Program/S2_FaultCheck - 9(XIC), 9(XIO)
*S2_LimSw_X2 - Station2_Program/S2_Outputs - *6(OTE)*
Remote_IO_2:7:O.3 0 BOOL
S2_LimSw_X1 - Station2_Program/S2_FaultCheck - 9(XIC), 9(XIO)
*S2_LimSw_X1 - Station2_Program/S2_Outputs - *7(OTE)*

Remote_IO_2:I AB:1734_8SLOT:I:0 MultiStation_test
Constant No
External Access: Read/Write
Remote_IO_2:I.Data[1].0 1 BOOL
S2_LiftSen_Bottom - Station2_Program/S2_FaultCheck - 6(XIO)
S2_LiftSen_Bottom - Station2_Program/S2_Inputs - 14(XIC)
Remote_IO_2:I.Data[1].1 0 BOOL
S2_ArmSenExt - Station2_Program/S2_FaultCheck - 3(XIO)
S2_ArmSenExt - Station2_Program/S2_Inputs - 11(XIC)
Remote_IO_2:I.Data[1].2 1 BOOL
S2_ArmSenRet - Station2_Program/S2_FaultCheck - 7(XIO)
S2_ArmSenRet - Station2_Program/S2_Inputs - 12(XIC)
Remote_IO_2:I.Data[1].3 0 BOOL
S2_ProxSen_X1 - Station2_Program/S2_Inputs - 9(XIC)
Remote_IO_2:I.Data[1].5 1 BOOL
S2_ProxSen_X3 - Station2_Program/S2_Inputs - 10(XIC)
Remote_IO_2:I.Data[1].6 1 BOOL
S2_ProxSen_Y2 - Station2_Program/S2_Inputs - 8(XIC)
Remote_IO_2:I.Data[1].7 0 BOOL
S2_ProxSen_Y1 - Station2_Program/S2_Inputs - 7(XIC)

Remote_IO_2:I (Continued)

Remote_IO_2:I.Data[2].0	0	BOOL
S2_LiftSen_Top - Station2_Program/S2_Inputs - 5(XIC)		
Remote_IO_2:I.Data[2].1	0	BOOL
S2_OptSen_Lift - Station2_Program/S2_Inputs - 4(XIC)		
Remote_IO_2:I.Data[2].2	0	BOOL
S2_CapSen_Pick - Station2_Program/S2_Inputs - 6(XIC)		
Remote_IO_2:I.Data[2].3	0	BOOL
S2_CylSenExt - Station2_Program/S2_FaultCheck - 4(XIO)		
S2_CylSenExt - Station2_Program/S2_Inputs - 13(XIC)		
Remote_IO_2:I.Data[2].4	1	BOOL
S2_CylSenRet - Station2_Program/S2_FaultCheck - 5(XIO)		
Remote_IO_2:I.Data[2].5	0	BOOL
S2_CapSen_Lift - Station2_Program/S2_Inputs - 2(XIC)		
Remote_IO_2:I.Data[2].6	0	BOOL
S2_IndSen_Lift - Station2_Program/S2_Inputs - 3(XIC)		
Remote_IO_2:I.Data[2].7	0	BOOL
S2_START - Station2_Program/S2_Inputs - 1(XIC)		
Remote_IO_2:I.Data[3].0	1	BOOL
S2_STOP - HMI_Program/MainRoutine - 2(XIC)		
S2_STOP - Station2_Program/S2_Inputs - 0(XIC)		

Remote_IO_2:O		AB:1734_8SLOT:O:0	MultiStation_test
Constant	No		
External Access:	Read/Write		
Remote_IO_2:O.Data[5].0	0	BOOL	
*S2_ArmAir - Station2_Program/S2_Outputs - *3(OTE)*			
Remote_IO_2:O.Data[5].1	0	BOOL	
*S2_ArmVacc - Station2_Program/S2_Outputs - *4(OTE)*			
Remote_IO_2:O.Data[5].2	0	BOOL	
*S2_CylAir - Station2_Program/S2_Outputs - *5(OTE)*			
Remote_IO_2:O.Data[5].3	0	BOOL	
*S2_LiftAir - Station2_Program/S2_Outputs - *1(OTE)*			
Remote_IO_2:O.Data[6].0	0	BOOL	
S2_StartLED - HMI_Program/MainRoutine - 2(XIC)			
*S2_StartLED - Station2_Program/S2_Outputs - *0(OTE)*			
Remote_IO_2:O.Data[6].1	0	BOOL	
*S2_OrangeLED - Station2_Program/S2_Outputs - *10(OTE)*			
Remote_IO_2:O.Data[6].2	0	BOOL	
*S2_RedLED - Station2_Program/S2_Logic - *24(OTE)*			
Remote_IO_2:O.Data[6].3	0	BOOL	
*S2_ConvMotor - Station2_Program/S2_Outputs - *2(OTE)*			
Remote_IO_2:O.Data[7].0	0	BOOL	
S2_LimSw_Y1 - Station2_Program/S2_FaultCheck - 8(XIC), 8(XIO)			
*S2_LimSw_Y1 - Station2_Program/S2_Outputs - *9(OTE)*			
Remote_IO_2:O.Data[7].1	0	BOOL	
S2_LimSw_Y2 - Station2_Program/S2_FaultCheck - 8(XIC), 8(XIO)			
*S2_LimSw_Y2 - Station2_Program/S2_Outputs - *8(OTE)*			
Remote_IO_2:O.Data[7].2	0	BOOL	
S2_LimSw_X2 - Station2_Program/S2_FaultCheck - 9(XIC), 9(XIO)			
*S2_LimSw_X2 - Station2_Program/S2_Outputs - *6(OTE)*			
Remote_IO_2:O.Data[7].3	0	BOOL	
S2_LimSw_X1 - Station2_Program/S2_FaultCheck - 9(XIC), 9(XIO)			
*S2_LimSw_X1 - Station2_Program/S2_Outputs - *7(OTE)*			

Remote_IO_3:1:I	2#0110_0101	SINT	MultiStation_test
AliasFor:	Remote_IO_3:I.Data[1]		
Base Tag:	Remote_IO_3:I.Data[1]		
Constant	No		
External Access:	Read/Write		
Remote_IO_3:1:I.1	0	BOOL	
S3_ArmSenExt - Station3_Program/S3_FaultCheck - 3(XIO)			
S3_ArmSenExt - Station3_Program/S3_Inputs - 11(XIC)			
Remote_IO_3:1:I.2	1	BOOL	

Remote_IO_3:1:I (Continued)
S3_ArmSenRet - Station3_Program/S3_FaultCheck - 7(XIO)
S3_ArmSenRet - Station3_Program/S3_Inputs - 12(XIC)

Remote_IO_3:1:I.3	0	BOOL	
S3_ProxSen_X1 - Station3_Program/S3_Inputs - 9(XIC)			
Remote_IO_3:1:I.5	1	BOOL	
S3_ProxSen_X3 - Station3_Program/S3_Inputs - 10(XIC)			
Remote_IO_3:1:I.6	1	BOOL	
S3_ProxSen_Y2 - Station3_Program/S3_Inputs - 8(XIC)			
Remote_IO_3:1:I.7	0	BOOL	
S3_ProxSen_Y1 - Station3_Program/S3_Inputs - 7(XIC)			
Remote_IO_3:2:I	2#0001_0010	SINT	MultiStation_test
AliasFor:	Remote_IO_3:I.Data[2]		
Base Tag:	Remote_IO_3:I.Data[2]		
Constant	No		
External Access:	Read/Write		
Remote_IO_3:2:I.1	1	BOOL	
S3_OptSen_Lift - Station3_Program/S3_Inputs - 4(XIC)			
Remote_IO_3:2:I.2	0	BOOL	
S3_CapSen_Pick - Station3_Program/S3_Inputs - 6(XIC)			
Remote_IO_3:2:I.3	0	BOOL	
S3_CylSenExt - Station3_Program/S3_FaultCheck - 4(XIO)			
S3_CylSenExt - Station3_Program/S3_Inputs - 13(XIC)			
Remote_IO_3:2:I.4	1	BOOL	
S3_CylSenRet - Station3_Program/S3_FaultCheck - 5(XIO)			
Remote_IO_3:2:I.5	0	BOOL	
S3_CapSen_Lift - Station3_Program/S3_Inputs - 2(XIC)			
Remote_IO_3:2:I.6	0	BOOL	
S3_IndSen_Lift - Station3_Program/S3_Inputs - 3(XIC)			
Remote_IO_3:2:I.7	0	BOOL	
S3_START - Station3_Program/S3_Inputs - 1(XIC)			
Remote_IO_3:3:I	2#0000_0001	SINT	MultiStation_test
AliasFor:	Remote_IO_3:I.Data[3]		
Base Tag:	Remote_IO_3:I.Data[3]		
Constant	No		
External Access:	Read/Write		
Remote_IO_3:4:I		AB:1734_IE2:I:0	MultiStation_test
Constant	No		
External Access:	Read/Write		
Remote_IO_3:4:I.Ch0Data	11	INT	
S3_HeightSen - Station3_Program/Station3_HeightCheck_Subroutine - 0(GRT), 0(LES), 1(GRT), 1(LES)			
Remote_IO_3:5:O	2#0000_0000	SINT	MultiStation_test
AliasFor:	Remote_IO_3:O.Data[5]		
Base Tag:	Remote_IO_3:O.Data[5]		
Constant	No		
External Access:	Read/Write		
Remote_IO_3:5:O.1	0	BOOL	
*S3_ArmVacc - Station3_Program/S3_Outputs - *4(OTE)*			
Remote_IO_3:5:O.2	0	BOOL	
*S3_CylAir - Station3_Program/S3_Outputs - *5(OTE)*			
Remote_IO_3:5:O.3	0	BOOL	
*S3_LiftAir - Station3_Program/S3_Outputs - *1(OTE)*			
Remote_IO_3:6:O	2#0000_0000	SINT	MultiStation_test
AliasFor:	Remote_IO_3:O.Data[6]		
Base Tag:	Remote_IO_3:O.Data[6]		
Constant	No		
External Access:	Read/Write		
Remote_IO_3:6:O.1	0	BOOL	
*S3_OrangeLED - Station3_Program/S3_Outputs - *10(OTE)*			

Remote_IO_3:6:O (Continued)			
Remote_IO_3:6:O.2	0	BOOL	
*S3_RedLED - Station3_Program/S3_Logic - *24(OTE)*			
Remote_IO_3:6:O.3	0	BOOL	
*S3_ConvMotor - Station3_Program/S3_Outputs - *2(OTE)*			
Remote_IO_3:7:O	2#0000_0000	SINT	MultiStation_test
AliasFor:	Remote_IO_3:O.Data[7]		
Base Tag:	Remote_IO_3:O.Data[7]		
Constant	No		
External Access:	Read/Write		
Remote_IO_3:7:O.1	0	BOOL	
S3_LimSw_Y2 - Station3_Program/S3_FaultCheck - 8(XIC), 8(XIO)			
*S3_LimSw_Y2 - Station3_Program/S3_Outputs - *8(OTE)*			
Remote_IO_3:7:O.2	0	BOOL	
S3_LimSw_X2 - Station3_Program/S3_FaultCheck - 9(XIC), 9(XIO)			
*S3_LimSw_X2 - Station3_Program/S3_Outputs - *6(OTE)*			
Remote_IO_3:7:O.3	0	BOOL	
S3_LimSw_X1 - Station3_Program/S3_FaultCheck - 9(XIC), 9(XIO)			
*S3_LimSw_X1 - Station3_Program/S3_Outputs - *7(OTE)*			
Remote_IO_3:I		AB:1734_8SLOT:I:0	MultiStation_test
Constant	No		
External Access:	Read/Write		
Remote_IO_3:I.Data[1].0	1	BOOL	
S3_LiftSen_Bottom - Station3_Program/S3_FaultCheck - 6(XIO)			
S3_LiftSen_Bottom - Station3_Program/S3_Inputs - 14(XIC)			
Remote_IO_3:I.Data[1].1	0	BOOL	
S3_ArmSenExt - Station3_Program/S3_FaultCheck - 3(XIO)			
S3_ArmSenExt - Station3_Program/S3_Inputs - 11(XIC)			
Remote_IO_3:I.Data[1].2	1	BOOL	
S3_ArmSenRet - Station3_Program/S3_FaultCheck - 7(XIO)			
S3_ArmSenRet - Station3_Program/S3_Inputs - 12(XIC)			
Remote_IO_3:I.Data[1].3	0	BOOL	
S3_ProxSen_X1 - Station3_Program/S3_Inputs - 9(XIC)			
Remote_IO_3:I.Data[1].5	1	BOOL	
S3_ProxSen_X3 - Station3_Program/S3_Inputs - 10(XIC)			
Remote_IO_3:I.Data[1].6	1	BOOL	
S3_ProxSen_Y2 - Station3_Program/S3_Inputs - 8(XIC)			
Remote_IO_3:I.Data[1].7	0	BOOL	
S3_ProxSen_Y1 - Station3_Program/S3_Inputs - 7(XIC)			
Remote_IO_3:I.Data[2].0	0	BOOL	
S3_LiftSen_Top - Station3_Program/S3_Inputs - 5(XIC)			
Remote_IO_3:I.Data[2].1	1	BOOL	
S3_OptSen_Lift - Station3_Program/S3_Inputs - 4(XIC)			
Remote_IO_3:I.Data[2].2	0	BOOL	
S3_CapSen_Pick - Station3_Program/S3_Inputs - 6(XIC)			
Remote_IO_3:I.Data[2].3	0	BOOL	
S3_CylSenExt - Station3_Program/S3_FaultCheck - 4(XIO)			
S3_CylSenExt - Station3_Program/S3_Inputs - 13(XIC)			
Remote_IO_3:I.Data[2].4	1	BOOL	
S3_CylSenRet - Station3_Program/S3_FaultCheck - 5(XIO)			
Remote_IO_3:I.Data[2].5	0	BOOL	
S3_CapSen_Lift - Station3_Program/S3_Inputs - 2(XIC)			
Remote_IO_3:I.Data[2].6	0	BOOL	
S3_IndSen_Lift - Station3_Program/S3_Inputs - 3(XIC)			
Remote_IO_3:I.Data[2].7	0	BOOL	
S3_START - Station3_Program/S3_Inputs - 1(XIC)			
Remote_IO_3:I.Data[3].0	1	BOOL	
S3_STOP - HMI_Program/MainRoutine - 3(XIC)			
S3_STOP - Station3_Program/S3_Inputs - 0(XIC)			
Remote_IO_3:O		AB:1734_8SLOT:O:0	MultiStation_test
Constant	No		

Remote_IO_3:O (Continued)
External Access: Read/Write
Remote_IO_3:O.Data[5].0 0 BOOL
*S3_ArmAir - Station3_Program/S3_Outputs - *3(OTE)*
Remote_IO_3:O.Data[5].1 0 BOOL
*S3_ArmVacc - Station3_Program/S3_Outputs - *4(OTE)*
Remote_IO_3:O.Data[5].2 0 BOOL
*S3_CylAir - Station3_Program/S3_Outputs - *5(OTE)*
Remote_IO_3:O.Data[5].3 0 BOOL
*S3_LiftAir - Station3_Program/S3_Outputs - *1(OTE)*
Remote_IO_3:O.Data[6].0 0 BOOL
S3_StartLED - HMI_Program/MainRoutine - 3(XIC)
*S3_StartLED - Station3_Program/S3_Outputs - *0(OTE)*
Remote_IO_3:O.Data[6].1 0 BOOL
*S3_OrangeLED - Station3_Program/S3_Outputs - *10(OTE)*
Remote_IO_3:O.Data[6].2 0 BOOL
*S3_RedLED - Station3_Program/S3_Logic - *24(OTE)*
Remote_IO_3:O.Data[6].3 0 BOOL
*S3_ConvMotor - Station3_Program/S3_Outputs - *2(OTE)*
Remote_IO_3:O.Data[7].0 0 BOOL
S3_LimSw_Y1 - Station3_Program/S3_FaultCheck - 8(XIC), 8(XIO)
*S3_LimSw_Y1 - Station3_Program/S3_Outputs - *9(OTE)*
Remote_IO_3:O.Data[7].1 0 BOOL
S3_LimSw_Y2 - Station3_Program/S3_FaultCheck - 8(XIC), 8(XIO)
*S3_LimSw_Y2 - Station3_Program/S3_Outputs - *8(OTE)*
Remote_IO_3:O.Data[7].2 0 BOOL
S3_LimSw_X2 - Station3_Program/S3_FaultCheck - 9(XIC), 9(XIO)
*S3_LimSw_X2 - Station3_Program/S3_Outputs - *6(OTE)*
Remote_IO_3:O.Data[7].3 0 BOOL
S3_LimSw_X1 - Station3_Program/S3_FaultCheck - 9(XIC), 9(XIO)
*S3_LimSw_X1 - Station3_Program/S3_Outputs - *7(OTE)*

S1_Fault_Reset 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_Fault_Reset - Station1_ProgramFaults/S1_Faults - 1(XIC), 13(XIO), 14(XIO), 15(XIO), 16(XIO), 17(XIO), 18(XIO), 19(XIO), 20(XIO), 21(XIO), 22(XIO), 23(XIO)

S1_FaultFlag 1 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_FaultFlag - Station1_Program/S1_Logic - 22(XIC)
S1_FaultFlag - Station1_Program/S1_Outputs - 2(XIO), 6(XIO), 7(XIO), 8(XIO), 9(XIO)
*S1_FaultFlag - Station1_ProgramFaults/S1_Faults - *23(OTE), 23(XIC)*

S1_HMI_ArmAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_HMI_ArmAir - Station1_Program/S1_Outputs - 3(XIC)

S1_HMI_ArmVacc 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_HMI_ArmVacc - Station1_Program/S1_Outputs - 4(XIC)

S1_HMI_ConvMotor 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_HMI_ConvMotor - Station1_Program/S1_Outputs - 2(XIC)

S1_HMI_CylAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_HMI_CylAir - Station1_Program/S1_Outputs - 5(XIC)

S1_HMI_LiftAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_HMI_LiftAir - Station1_Program/S1_Outputs - 1(XIC)

S1_HMI_xNeg 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S1_HMI_xNeg - Station1_Program/S1_Logic - *23(OTU)*
S1_HMI_xNeg - Station1_Program/S1_Outputs - 7(XIC)

S1_HMI_xPos 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S1_HMI_xPos - Station1_Program/S1_Logic - *23(OTU)*
S1_HMI_xPos - Station1_Program/S1_Outputs - 6(XIC)

S1_HMI_yNeg 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S1_HMI_yNeg - Station1_Program/S1_Logic - *23(OTU)*
S1_HMI_yNeg - Station1_Program/S1_Outputs - 9(XIC)

S1_HMI_yPos 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S1_HMI_yPos - Station1_Program/S1_Logic - *23(OTU)*
S1_HMI_yPos - Station1_Program/S1_Outputs - 8(XIC)

S1_TestBenchStateEnter 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_TestBenchStateEnter - Station1_Program/S1_Logic - 18(XIC)

S1_TestBenchStateExit 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S1_TestBenchStateExit - Station1_Program/S1_Logic - 19(XIC)

S2_Fault_Reset 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_Fault_Reset - Station2_ProgramFaults/S2_Faults - 0(XIC), 12(XIO), 13(XIO), 14(XIO), 15(XIO), 16(XIO), 17(XIO), 18(XIO), 19(XIO), 20(XIO), 21(XIO), 22(XIO)

S2_FaultFlag 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_FaultFlag - Station2_Program/S2_Logic - 22(XIC)
S2_FaultFlag - Station2_Program/S2_Outputs - 2(XIO), 6(XIO), 7(XIO), 8(XIO), 9(XIO)
*S2_FaultFlag - Station2_ProgramFaults/S2_Faults - *22(OTE), 22(XIC)*

S2_HMI_ArmAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_HMI_ArmAir - Station2_Program/S2_Outputs - 3(XIC)

S2_HMI_ArmVacc 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_HMI_ArmVacc - Station2_Program/S2_Outputs - 4(XIC)

S2_HMI_ConvMotor 0 BOOL MultiStation_test
Constant No

S2_HMI_ConvMotor (Continued)
External Access: Read/Write
S2_HMI_ConvMotor - Station2_Program/S2_Outputs - 2(XIC)

S2_HMI_CylAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_HMI_CylAir - Station2_Program/S2_Outputs - 5(XIC)

S2_HMI_LiftAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_HMI_LiftAir - Station2_Program/S2_Outputs - 1(XIC)

S2_HMI_xNeg 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S2_HMI_xNeg - Station2_Program/S2_Logic - *23(OTU)*
S2_HMI_xNeg - Station2_Program/S2_Outputs - 7(XIC)

S2_HMI_xPos 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S2_HMI_xPos - Station2_Program/S2_Logic - *23(OTU)*
S2_HMI_xPos - Station2_Program/S2_Outputs - 6(XIC)

S2_HMI_yNeg 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S2_HMI_yNeg - Station2_Program/S2_Logic - *23(OTU)*
S2_HMI_yNeg - Station2_Program/S2_Outputs - 9(XIC)

S2_HMI_yPos 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S2_HMI_yPos - Station2_Program/S2_Logic - *23(OTU)*
S2_HMI_yPos - Station2_Program/S2_Outputs - 8(XIC)

S2_TestBenchStateEnter 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_TestBenchStateEnter - Station2_Program/S2_Logic - 18(XIC)

S2_TestBenchStateExit 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S2_TestBenchStateExit - Station2_Program/S2_Logic - 19(XIC)

S3_Fault_Reset 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_Fault_Reset - Station3_ProgramFaults/S3_Faults - 0(XIC), 12(XIO), 13(XIO), 14(XIO), 15(XIO), 16(XIO), 17(XIO), 18(XIO), 19(XIO), 20(XIO), 21(XIO), 22(XIO)

S3_FaultFlag 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_FaultFlag - Station3_Program/S3_Logic - 22(XIC)
S3_FaultFlag - Station3_Program/S3_Outputs - 2(XIO), 6(XIO), 7(XIO), 8(XIO), 9(XIO)
*S3_FaultFlag - Station3_ProgramFaults/S3_Faults - *22(OTE), 22(XIC)*

S3_HMI_ArmAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write

S3_HMI_ArmAir (Continued)
S3_HMI_ArmAir - Station3_Program/S3_Outputs - 3(XIC)

S3_HMI_ArmVacc 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_HMI_ArmVacc - Station3_Program/S3_Outputs - 4(XIC)

S3_HMI_ConvMotor 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_HMI_ConvMotor - Station3_Program/S3_Outputs - 2(XIC)

S3_HMI_CylAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_HMI_CylAir - Station3_Program/S3_Outputs - 5(XIC)

S3_HMI_LiftAir 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_HMI_LiftAir - Station3_Program/S3_Outputs - 1(XIC)

S3_HMI_xNeg 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S3_HMI_xNeg - Station3_Program/S3_Logic - *23(OTU)*
S3_HMI_xNeg - Station3_Program/S3_Outputs - 7(XIC)

S3_HMI_xPos 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S3_HMI_xPos - Station3_Program/S3_Logic - *23(OTU)*
S3_HMI_xPos - Station3_Program/S3_Outputs - 6(XIC)

S3_HMI_yNeg 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S3_HMI_yNeg - Station3_Program/S3_Logic - *23(OTU)*
S3_HMI_yNeg - Station3_Program/S3_Outputs - 9(XIC)

S3_HMI_yPos 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
*S3_HMI_yPos - Station3_Program/S3_Logic - *23(OTU)*
S3_HMI_yPos - Station3_Program/S3_Outputs - 8(XIC)

S3_TestBenchStateEnter 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_TestBenchStateEnter - Station3_Program/S3_Logic - 18(XIC)

S3_TestBenchStateExit 0 BOOL MultiStation_test
Constant No
External Access: Read/Write
S3_TestBenchStateExit - Station3_Program/S3_Logic - 19(XIC)

StationFaults UDT_Faults[4] MultiStation_test
Constant No
External Access: Read/Write
*StationFaults - Station1_ProgramFaults/S1_Faults - *0(COP), 0(COP)*
StationFaults[0] UDT_Faults
StationFaults[0] - Station1_ProgramFaults/S1_Faults - 1(COP)
StationFaults[0] - Station2_ProgramFaults/S2_Faults - 0(COP)

StationFaults (Continued)
StationFaults[0] - Station3_ProgramFaults/S3_Faults - 0(COP)

StationFaults[0].Fault_Check UDT_FaultCheck
bits to use to check for faults
StationFaults[0].Fault_Check.LiftBtmToTop
0 BOOL
Fault Check for lift to go from bottom to top
StationFaults[0].Fault_Check.LiftCylRetToExt
0 BOOL
Fault Check for cylinder to go from retracted to extended
StationFaults[0].Fault_Check.LiftCylExtToRet
0 BOOL
Fault Check for cylinder to go from extended to retracted
StationFaults[0].Fault_Check.LiftTopToBtm
0 BOOL
Fault Check for lift to go from top to bottom
StationFaults[0].Fault_Check.ConveyorMtr
0 BOOL
Fault Check for conveyor motor ON
StationFaults[0].Fault_Check.LiftToPickup
0 BOOL
Fault Check for object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Check.MtrX
0 BOOL
Fault Check for the motor on the X-Axis to be on
StationFaults[0].Fault_Check.MtrY
0 BOOL
Fault Check for the motor on the Y-Axis to be on
StationFaults[0].Fault_Check.ArmRetToExt
0 BOOL
Fault Check for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Check.ArmExtToRet
0 BOOL
Fault Check for the gantry Arm cylinder to go from extended to retracted
StationFaults[0].Fault_Indicator UDT_FaultIndicators
An UDT containing a list of bits for fault indications
StationFaults[0].Fault_Indicator.LiftBtmToTop
0 BOOL
Fault Indicator for lift to go from bottom to top
StationFaults[0].Fault_Indicator.LiftCylRetToExt
0 BOOL
Fault Indicator for cylinder to go from retracted to extended
StationFaults[0].Fault_Indicator.LiftCylExtToRet
0 BOOL
Fault Indicator for cylinder to go from extended to retracted
StationFaults[0].Fault_Indicator.LiftTopToBtm
0 BOOL
Fault Indicator for lift to go from top to bottom
StationFaults[0].Fault_Indicator.ConveyorMtr
0 BOOL
Fault Indicator for conveyor motor ON
StationFaults[0].Fault_Indicator.LiftToPickup
0 BOOL
Fault Indicator for object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Indicator.MtrX
0 BOOL
Fault Indicator for the motor on the X-Axis to be on
StationFaults[0].Fault_Indicator.MtrY
0 BOOL
Fault Indicator for the motor on the Y-Axis to be on
StationFaults[0].Fault_Indicator.ArmRetToExt
0 BOOL
Fault Indicator for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Indicator.ArmExtToRet

StationFaults (Continued)

0 BOOL

Fault Indicator for the gantry Arm cylinder to go from extended to retracted

StationFaults[0].Fault_Timers UDT_FaultTimers

An UDT containing a list of Timers for fault checking

StationFaults[0].Fault_Timers.LiftBtmToTop

TIMER

Timer for lift to go from bottom to top

StationFaults[0].Fault_Timers.LiftBtmToTop.PRE

5000 DINT

Timer for lift to go from bottom to top

StationFaults[0].Fault_Timers.LiftBtmToTop.ACC

0 DINT

Timer for lift to go from bottom to top

StationFaults[0].Fault_Timers.LiftBtmToTop.EN

0 BOOL

Timer for lift to go from bottom to top

StationFaults[0].Fault_Timers.LiftBtmToTop.TT

0 BOOL

Timer for lift to go from bottom to top

StationFaults[0].Fault_Timers.LiftBtmToTop.DN

0 BOOL

Timer for lift to go from bottom to top

StationFaults[0].Fault_Timers.LiftCylRetToExt

TIMER

Timer for cylinder to go from retracted to extended

StationFaults[0].Fault_Timers.LiftCylRetToExt.PRE

5000 DINT

Timer for cylinder to go from retracted to extended

StationFaults[0].Fault_Timers.LiftCylRetToExt.ACC

0 DINT

Timer for cylinder to go from retracted to extended

StationFaults[0].Fault_Timers.LiftCylRetToExt.EN

0 BOOL

Timer for cylinder to go from retracted to extended

StationFaults[0].Fault_Timers.LiftCylRetToExt.TT

0 BOOL

Timer for cylinder to go from retracted to extended

StationFaults[0].Fault_Timers.LiftCylRetToExt.DN

0 BOOL

Timer for cylinder to go from retracted to extended

StationFaults[0].Fault_Timers.LiftCylExtToRet

TIMER

Timer for cylinder to go from extended to retracted

StationFaults[0].Fault_Timers.LiftCylExtToRet.PRE

2000 DINT

Timer for cylinder to go from extended to retracted

StationFaults[0].Fault_Timers.LiftCylExtToRet.ACC

0 DINT

Timer for cylinder to go from extended to retracted

StationFaults[0].Fault_Timers.LiftCylExtToRet.EN

0 BOOL

Timer for cylinder to go from extended to retracted

StationFaults[0].Fault_Timers.LiftCylExtToRet.TT

0 BOOL

Timer for cylinder to go from extended to retracted

StationFaults[0].Fault_Timers.LiftCylExtToRet.DN

0 BOOL

Timer for cylinder to go from extended to retracted

StationFaults[0].Fault_Timers.LiftTopToBtm

TIMER

Timer for lift to go from top to bottom

StationFaults[0].Fault_Timers.LiftTopToBtm.PRE

5000 DINT

StationFaults (Continued)

Timer for lift to go from top to bottom
StationFaults[0].Fault_Timers.LiftTopToBtm.ACC
0 DINT

Timer for lift to go from top to bottom
StationFaults[0].Fault_Timers.LiftTopToBtm.EN
0 BOOL

Timer for lift to go from top to bottom
StationFaults[0].Fault_Timers.LiftTopToBtm.TT
0 BOOL

Timer for lift to go from top to bottom
StationFaults[0].Fault_Timers.LiftTopToBtm.DN
0 BOOL

Timer for lift to go from top to bottom
StationFaults[0].Fault_Timers.ConveyorMtr
TIMER

Timer for conveyor motor ON
StationFaults[0].Fault_Timers.ConveyorMtr.PRE
10000 DINT

Timer for conveyor motor ON
StationFaults[0].Fault_Timers.ConveyorMtr.ACC
0 DINT

Timer for conveyor motor ON
StationFaults[0].Fault_Timers.ConveyorMtr.EN
0 BOOL

Timer for conveyor motor ON
StationFaults[0].Fault_Timers.ConveyorMtr.TT
0 BOOL

Timer for conveyor motor ON
StationFaults[0].Fault_Timers.ConveyorMtr.DN
0 BOOL

Timer for conveyor motor ON
StationFaults[0].Fault_Timers.LiftToPickup
TIMER

Timer object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Timers.LiftToPickup.PRE
10000 DINT

Timer object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Timers.LiftToPickup.ACC
0 DINT

Timer object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Timers.LiftToPickup.EN
0 BOOL

Timer object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Timers.LiftToPickup.TT
0 BOOL

Timer object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Timers.LiftToPickup.DN
0 BOOL

Timer object to leave lift until it reaches pickup spot
StationFaults[0].Fault_Timers.MtrX
TIMER

Time for the motor on the X-Axis to be on
StationFaults[0].Fault_Timers.MtrX.PRE
30000 DINT

Time for the motor on the X-Axis to be on
StationFaults[0].Fault_Timers.MtrX.ACC
0 DINT

Time for the motor on the X-Axis to be on
StationFaults[0].Fault_Timers.MtrX.EN
0 BOOL

Time for the motor on the X-Axis to be on
StationFaults[0].Fault_Timers.MtrX.TT
0 BOOL

StationFaults (Continued)
Time for the motor on the X-Axis to be on
StationFaults[0].Fault_Timers.MtrX.DN
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[0].Fault_Timers.MtrY
TIMER
Time for the motor on the Y-Axis to be on
StationFaults[0].Fault_Timers.MtrY.PRE
30000 DINT
Time for the motor on the Y-Axis to be on
StationFaults[0].Fault_Timers.MtrY.ACC
0 DINT
Time for the motor on the Y-Axis to be on
StationFaults[0].Fault_Timers.MtrY.EN
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[0].Fault_Timers.MtrY.TT
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[0].Fault_Timers.MtrY.DN
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[0].Fault_Timers.ArmRetToExt
TIMER
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Timers.ArmRetToExt.PRE
5000 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Timers.ArmRetToExt.ACC
0 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Timers.ArmRetToExt.EN
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Timers.ArmRetToExt.TT
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Timers.ArmRetToExt.DN
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[0].Fault_Timers.ArmExtToRet
TIMER
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[0].Fault_Timers.ArmExtToRet.PRE
5000 DINT
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[0].Fault_Timers.ArmExtToRet.ACC
0 DINT
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[0].Fault_Timers.ArmExtToRet.EN
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[0].Fault_Timers.ArmExtToRet.TT
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[0].Fault_Timers.ArmExtToRet.DN
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[1] UDT_Faults
*StationFaults[1] - Station1_ProgramFaults/S1_Faults - *1(COP)*
StationFaults[1].Fault_Check UDT_FaultCheck
bits to use to check for faults
StationFaults[1].Fault_Check.LiftBtmToTop

StationFaults (Continued)

0 BOOL

Fault Check for lift to go from bottom to top

*StationFaults[1].Fault_Check.LiftBtmToTop - Station1_Program/S1_FaultCheck - *0(OTE)*

StationFaults[1].Fault_Check.LiftBtmToTop - Station1_ProgramFaults/S1_Faults - 2(XIC)

StationFaults[1].Fault_Check.LiftCylRetToExt

0 BOOL

Fault Check for cylinder to go from retracted to extended

*StationFaults[1].Fault_Check.LiftCylRetToExt - Station1_Program/S1_FaultCheck - *4(OTE)*

StationFaults[1].Fault_Check.LiftCylRetToExt - Station1_ProgramFaults/S1_Faults - 3(XIC)

StationFaults[1].Fault_Check.LiftCylExtToRet

0 BOOL

Fault Check for cylinder to go from extended to retracted

*StationFaults[1].Fault_Check.LiftCylExtToRet - Station1_Program/S1_FaultCheck - *5(OTE)*

StationFaults[1].Fault_Check.LiftCylExtToRet - Station1_ProgramFaults/S1_Faults - 4(XIC)

StationFaults[1].Fault_Check.LiftTopToBtm

0 BOOL

Fault Check for lift to go from top to bottom

*StationFaults[1].Fault_Check.LiftTopToBtm - Station1_Program/S1_FaultCheck - *6(OTE)*

StationFaults[1].Fault_Check.LiftTopToBtm - Station1_ProgramFaults/S1_Faults - 5(XIC)

StationFaults[1].Fault_Check.ConveyorMtr

0 BOOL

Fault Check for conveyor motor ON

*StationFaults[1].Fault_Check.ConveyorMtr - Station1_Program/S1_FaultCheck - *1(OTE)*

StationFaults[1].Fault_Check.ConveyorMtr - Station1_ProgramFaults/S1_Faults - 6(XIC)

StationFaults[1].Fault_Check.LiftToPickup

0 BOOL

Fault Check for object to leave lift until it reaches pickup spot

*StationFaults[1].Fault_Check.LiftToPickup - Station1_Program/S1_FaultCheck - *2(OTE)*

StationFaults[1].Fault_Check.LiftToPickup - Station1_ProgramFaults/S1_Faults - 7(XIC)

StationFaults[1].Fault_Check.MtrX

0 BOOL

Fault Check for the motor on the X-Axis to be on

*StationFaults[1].Fault_Check.MtrX - Station1_Program/S1_FaultCheck - *9(OTE)*

StationFaults[1].Fault_Check.MtrX - Station1_ProgramFaults/S1_Faults - 8(XIC)

StationFaults[1].Fault_Check.MtrY

0 BOOL

Fault Check for the motor on the Y-Axis to be on

*StationFaults[1].Fault_Check.MtrY - Station1_Program/S1_FaultCheck - *8(OTE)*

StationFaults[1].Fault_Check.MtrY - Station1_ProgramFaults/S1_Faults - 9(XIC)

StationFaults[1].Fault_Check.ArmRetToExt

0 BOOL

Fault Check for the gantry Arm cylinder to go from retracted to extended

*StationFaults[1].Fault_Check.ArmRetToExt - Station1_Program/S1_FaultCheck - *3(OTE)*

StationFaults[1].Fault_Check.ArmRetToExt - Station1_ProgramFaults/S1_Faults - 10(XIC)

StationFaults[1].Fault_Check.ArmExtToRet

0 BOOL

Fault Check for the gantry Arm cylinder to go from extended to retracted

*StationFaults[1].Fault_Check.ArmExtToRet - Station1_Program/S1_FaultCheck - *7(OTE)*

StationFaults[1].Fault_Check.ArmExtToRet - Station1_ProgramFaults/S1_Faults - 11(XIC)

StationFaults[1].Fault_Indicator UDT_FaultIndicators

An UDT containing a list of bits for fault indications

StationFaults[1].Fault_Indicator.LiftBtmToTop

0 BOOL

Fault Indicator for lift to go from bottom to top

*StationFaults[1].Fault_Indicator.LiftBtmToTop - Station1_ProgramFaults/S1_Faults - *13(OTE), 13(XIC), 23(XIC)*

StationFaults[1].Fault_Indicator.LiftCylRetToExt

0 BOOL

Fault Indicator for cylinder to go from retracted to extended

*StationFaults[1].Fault_Indicator.LiftCylRetToExt - Station1_ProgramFaults/S1_Faults - *14(OTE), 14(XIC), 23(XIC)*

StationFaults[1].Fault_Indicator.LiftCylExtToRet

0 BOOL

Fault Indicator for cylinder to go from extended to retracted

*StationFaults[1].Fault_Indicator.LiftCylExtToRet - Station1_ProgramFaults/S1_Faults - *15(OTE), 15(XIC), 23(XIC)*

StationFaults (Continued)
StationFaults[1].Fault_Indicator.LiftTopToBtm
1 BOOL
Fault Indicator for lift to go from top to bottom
*StationFaults[1].Fault_Indicator.LiftTopToBtm - Station1_ProgramFaults/S1_Faults - *16(OTE), 16(XIC), 23(XIC)*
StationFaults[1].Fault_Indicator.ConveyorMtr
0 BOOL
Fault Indicator for conveyor motor ON
*StationFaults[1].Fault_Indicator.ConveyorMtr - Station1_ProgramFaults/S1_Faults - *17(OTE), 17(XIC), 23(XIC)*
StationFaults[1].Fault_Indicator.LiftToPickup
0 BOOL
Fault Indicator for object to leave lift until it reaches pickup spot
*StationFaults[1].Fault_Indicator.LiftToPickup - Station1_ProgramFaults/S1_Faults - *18(OTE), 18(XIC), 23(XIC)*
StationFaults[1].Fault_Indicator.MtrX
0 BOOL
Fault Indicator for the motor on the X-Axis to be on
*StationFaults[1].Fault_Indicator.MtrX - Station1_ProgramFaults/S1_Faults - *19(OTE), 19(XIC), 23(XIC)*
StationFaults[1].Fault_Indicator.MtrY
0 BOOL
Fault Indicator for the motor on the Y-Axis to be on
*StationFaults[1].Fault_Indicator.MtrY - Station1_ProgramFaults/S1_Faults - *20(OTE), 20(XIC), 23(XIC)*
StationFaults[1].Fault_Indicator.ArmRetToExt
0 BOOL
Fault Indicator for the gantry Arm cylinder to go from retracted to extended
*StationFaults[1].Fault_Indicator.ArmRetToExt - Station1_ProgramFaults/S1_Faults - *21(OTE), 21(XIC), 23(XIC)*
StationFaults[1].Fault_Indicator.ArmExtToRet
0 BOOL
Fault Indicator for the gantry Arm cylinder to go from extended to retracted
*StationFaults[1].Fault_Indicator.ArmExtToRet - Station1_ProgramFaults/S1_Faults - *22(OTE), 22(XIC), 23(XIC)*
StationFaults[1].Fault_Timers UDT_FaultTimers
An UDT containing a list of Timers for fault checking
StationFaults[1].Fault_Timers.LiftBtmToTop
TIMER
Timer for lift to go from bottom to top
*StationFaults[1].Fault_Timers.LiftBtmToTop - Station1_ProgramFaults/S1_Faults - *2(TON)*
StationFaults[1].Fault_Timers.LiftBtmToTop.PRE
5000 DINT
Timer for lift to go from bottom to top
StationFaults[1].Fault_Timers.LiftBtmToTop.ACC
0 DINT
Timer for lift to go from bottom to top
StationFaults[1].Fault_Timers.LiftBtmToTop.EN
0 BOOL
Timer for lift to go from bottom to top
StationFaults[1].Fault_Timers.LiftBtmToTop.TT
0 BOOL
Timer for lift to go from bottom to top
StationFaults[1].Fault_Timers.LiftBtmToTop.DN
0 BOOL
Timer for lift to go from bottom to top
StationFaults[1].Fault_Timers.LiftBtmToTop.DN - Station1_ProgramFaults/S1_Faults - 13(XIC)
StationFaults[1].Fault_Timers.LiftCylRetToExt
TIMER
Timer for cylinder to go from retracted to extended
*StationFaults[1].Fault_Timers.LiftCylRetToExt - Station1_ProgramFaults/S1_Faults - *3(TON)*
StationFaults[1].Fault_Timers.LiftCylRetToExt.PRE
5000 DINT
Timer for cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.LiftCylRetToExt.ACC
0 DINT
Timer for cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.LiftCylRetToExt.EN
0 BOOL
Timer for cylinder to go from retracted to extended

StationFaults (Continued)
StationFaults[1].Fault_Timers.LiftCylRetToExt.TT
0 BOOL
Timer for cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.LiftCylRetToExt.DN
0 BOOL
Timer for cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.LiftCylRetToExt.DN - Station1_ProgramFaults/S1_Faults - 14(XIC)
StationFaults[1].Fault_Timers.LiftCylExtToRet
TIMER
Timer for cylinder to go from extended to retracted
*StationFaults[1].Fault_Timers.LiftCylExtToRet - Station1_ProgramFaults/S1_Faults - *4(TON)*
StationFaults[1].Fault_Timers.LiftCylExtToRet.PRE
3000 DINT
Timer for cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.LiftCylExtToRet.ACC
0 DINT
Timer for cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.LiftCylExtToRet.EN
0 BOOL
Timer for cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.LiftCylExtToRet.TT
0 BOOL
Timer for cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.LiftCylExtToRet.DN
0 BOOL
Timer for cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.LiftCylExtToRet.DN - Station1_ProgramFaults/S1_Faults - 15(XIC)
StationFaults[1].Fault_Timers.LiftTopToBtm
TIMER
Timer for lift to go from top to bottom
*StationFaults[1].Fault_Timers.LiftTopToBtm - Station1_ProgramFaults/S1_Faults - *5(TON)*
StationFaults[1].Fault_Timers.LiftTopToBtm.PRE
5000 DINT
Timer for lift to go from top to bottom
StationFaults[1].Fault_Timers.LiftTopToBtm.ACC
0 DINT
Timer for lift to go from top to bottom
StationFaults[1].Fault_Timers.LiftTopToBtm.EN
0 BOOL
Timer for lift to go from top to bottom
StationFaults[1].Fault_Timers.LiftTopToBtm.TT
0 BOOL
Timer for lift to go from top to bottom
StationFaults[1].Fault_Timers.LiftTopToBtm.DN
0 BOOL
Timer for lift to go from top to bottom
StationFaults[1].Fault_Timers.LiftTopToBtm.DN - Station1_ProgramFaults/S1_Faults - 16(XIC)
StationFaults[1].Fault_Timers.ConveyorMtr
TIMER
Timer for conveyor motor ON
*StationFaults[1].Fault_Timers.ConveyorMtr - Station1_ProgramFaults/S1_Faults - *6(TON)*
StationFaults[1].Fault_Timers.ConveyorMtr.PRE
10000 DINT
Timer for conveyor motor ON
StationFaults[1].Fault_Timers.ConveyorMtr.ACC
0 DINT
Timer for conveyor motor ON
StationFaults[1].Fault_Timers.ConveyorMtr.EN
0 BOOL
Timer for conveyor motor ON
StationFaults[1].Fault_Timers.ConveyorMtr.TT
0 BOOL
Timer for conveyor motor ON

StationFaults (Continued)
StationFaults[1].Fault_Timers.ConveyorMtr.DN
0 BOOL
Timer for conveyor motor ON
StationFaults[1].Fault_Timers.ConveyorMtr.DN - Station1_ProgramFaults/S1_Faults - 17(XIC)
StationFaults[1].Fault_Timers.LiftToPickup
TIMER
Timer object to leave lift until it reaches pickup spot
*StationFaults[1].Fault_Timers.LiftToPickup - Station1_ProgramFaults/S1_Faults - *7(TON)*
StationFaults[1].Fault_Timers.LiftToPickup.PRE
10000 DINT
Timer object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Timers.LiftToPickup.ACC
0 DINT
Timer object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Timers.LiftToPickup.EN
0 BOOL
Timer object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Timers.LiftToPickup.TT
0 BOOL
Timer object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Timers.LiftToPickup.DN
0 BOOL
Timer object to leave lift until it reaches pickup spot
StationFaults[1].Fault_Timers.LiftToPickup.DN - Station1_ProgramFaults/S1_Faults - 18(XIC)
StationFaults[1].Fault_Timers.MtrX
TIMER
Time for the motor on the X-Axis to be on
*StationFaults[1].Fault_Timers.MtrX - Station1_ProgramFaults/S1_Faults - *8(TON)*
StationFaults[1].Fault_Timers.MtrX.PRE
30000 DINT
Time for the motor on the X-Axis to be on
StationFaults[1].Fault_Timers.MtrX.ACC
0 DINT
Time for the motor on the X-Axis to be on
StationFaults[1].Fault_Timers.MtrX.EN
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[1].Fault_Timers.MtrX.TT
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[1].Fault_Timers.MtrX.DN
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[1].Fault_Timers.MtrX.DN - Station1_ProgramFaults/S1_Faults - 19(XIC)
StationFaults[1].Fault_Timers.MtrY
TIMER
Time for the motor on the Y-Axis to be on
*StationFaults[1].Fault_Timers.MtrY - Station1_ProgramFaults/S1_Faults - *9(TON)*
StationFaults[1].Fault_Timers.MtrY.PRE
30000 DINT
Time for the motor on the Y-Axis to be on
StationFaults[1].Fault_Timers.MtrY.ACC
0 DINT
Time for the motor on the Y-Axis to be on
StationFaults[1].Fault_Timers.MtrY.EN
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[1].Fault_Timers.MtrY.TT
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[1].Fault_Timers.MtrY.DN
0 BOOL
Time for the motor on the Y-Axis to be on

StationFaults (Continued)
StationFaults[1].Fault_Timers.MtrY.DN - Station1_ProgramFaults/S1_Faults - 20(XIC)
StationFaults[1].Fault_Timers.ArmRetToExt TIMER
Timer for the gantry Arm cylinder to go from retracted to extended
*StationFaults[1].Fault_Timers.ArmRetToExt - Station1_ProgramFaults/S1_Faults - *10(TON)*
StationFaults[1].Fault_Timers.ArmRetToExt.PRE 5000 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.ArmRetToExt.ACC 0 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.ArmRetToExt.EN 0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.ArmRetToExt.TT 0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.ArmRetToExt.DN 0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[1].Fault_Timers.ArmRetToExt.DN - Station1_ProgramFaults/S1_Faults - 21(XIC)
StationFaults[1].Fault_Timers.ArmExtToRet TIMER
Timer for the gantry Arm cylinder to go from extended to retracted
*StationFaults[1].Fault_Timers.ArmExtToRet - Station1_ProgramFaults/S1_Faults - *11(TON)*
StationFaults[1].Fault_Timers.ArmExtToRet.PRE 5000 DINT
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.ArmExtToRet.ACC 0 DINT
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.ArmExtToRet.EN 0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.ArmExtToRet.TT 0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.ArmExtToRet.DN 0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[1].Fault_Timers.ArmExtToRet.DN - Station1_ProgramFaults/S1_Faults - 22(XIC)
StationFaults[2] UDT_Faults
*StationFaults[2] - Station2_ProgramFaults/S2_Faults - *0(COP)*
StationFaults[2].Fault_Check UDT_FaultCheck
bits to use to check for faults
StationFaults[2].Fault_Check.LiftBtmToTop 0 BOOL
Fault Check for lift to go from bottom to top
*StationFaults[2].Fault_Check.LiftBtmToTop - Station2_Program/S2_FaultCheck - *0(OTE)*
StationFaults[2].Fault_Check.LiftBtmToTop - Station2_ProgramFaults/S2_Faults - 1(XIC)
StationFaults[2].Fault_Check.LiftCylRetToExt 0 BOOL
Fault Check for cylinder to go from retracted to extended
*StationFaults[2].Fault_Check.LiftCylRetToExt - Station2_Program/S2_FaultCheck - *4(OTE)*
StationFaults[2].Fault_Check.LiftCylRetToExt - Station2_ProgramFaults/S2_Faults - 2(XIC)
StationFaults[2].Fault_Check.LiftCylExtToRet 0 BOOL
Fault Check for cylinder to go from extended to retracted
*StationFaults[2].Fault_Check.LiftCylExtToRet - Station2_Program/S2_FaultCheck - *5(OTE)*
StationFaults[2].Fault_Check.LiftCylExtToRet - Station2_ProgramFaults/S2_Faults - 3(XIC)
StationFaults[2].Fault_Check.LiftTopToBtm 0 BOOL
Fault Check for lift to go from top to bottom

StationFaults (Continued)
*StationFaults[2].Fault_Check.LiftTopToBtm - Station2_Program/S2_FaultCheck - *6(OTE)*
StationFaults[2].Fault_Check.LiftTopToBtm - Station2_ProgramFaults/S2_Faults - 4(XIC)
StationFaults[2].Fault_Check.ConveyorMtr
0 BOOL
Fault Check for conveyor motor ON
*StationFaults[2].Fault_Check.ConveyorMtr - Station2_Program/S2_FaultCheck - *1(OTE)*
StationFaults[2].Fault_Check.ConveyorMtr - Station2_ProgramFaults/S2_Faults - 5(XIC)
StationFaults[2].Fault_Check.LiftToPickup
0 BOOL
Fault Check for object to leave lift until it reaches pickup spot
*StationFaults[2].Fault_Check.LiftToPickup - Station2_Program/S2_FaultCheck - *2(OTE)*
StationFaults[2].Fault_Check.LiftToPickup - Station2_ProgramFaults/S2_Faults - 6(XIC)
StationFaults[2].Fault_Check.MtrX
0 BOOL
Fault Check for the motor on the X-Axis to be on
*StationFaults[2].Fault_Check.MtrX - Station2_Program/S2_FaultCheck - *9(OTE)*
StationFaults[2].Fault_Check.MtrX - Station2_ProgramFaults/S2_Faults - 7(XIC)
StationFaults[2].Fault_Check.MtrY
0 BOOL
Fault Check for the motor on the Y-Axis to be on
*StationFaults[2].Fault_Check.MtrY - Station2_Program/S2_FaultCheck - *8(OTE)*
StationFaults[2].Fault_Check.MtrY - Station2_ProgramFaults/S2_Faults - 8(XIC)
StationFaults[2].Fault_Check.ArmRetToExt
0 BOOL
Fault Check for the gantry Arm cylinder to go from retracted to extended
*StationFaults[2].Fault_Check.ArmRetToExt - Station2_Program/S2_FaultCheck - *3(OTE)*
StationFaults[2].Fault_Check.ArmRetToExt - Station2_ProgramFaults/S2_Faults - 9(XIC)
StationFaults[2].Fault_Check.ArmExtToRet
0 BOOL
Fault Check for the gantry Arm cylinder to go from extended to retracted
*StationFaults[2].Fault_Check.ArmExtToRet - Station2_Program/S2_FaultCheck - *7(OTE)*
StationFaults[2].Fault_Check.ArmExtToRet - Station2_ProgramFaults/S2_Faults - 10(XIC)
StationFaults[2].Fault_Indicator UDT_FaultIndicators
An UDT containing a list of bits for fault indications
StationFaults[2].Fault_Indicator.LiftBtmToTop
0 BOOL
Fault Indicator for lift to go from bottom to top
*StationFaults[2].Fault_Indicator.LiftBtmToTop - Station2_ProgramFaults/S2_Faults - *12(OTE), 12(XIC), 22(XIC)*
StationFaults[2].Fault_Indicator.LiftCylRetToExt
0 BOOL
Fault Indicator for cylinder to go from retracted to extended
*StationFaults[2].Fault_Indicator.LiftCylRetToExt - Station2_ProgramFaults/S2_Faults - *13(OTE), 13(XIC), 22(XIC)*
StationFaults[2].Fault_Indicator.LiftCylExtToRet
0 BOOL
Fault Indicator for cylinder to go from extended to retracted
*StationFaults[2].Fault_Indicator.LiftCylExtToRet - Station2_ProgramFaults/S2_Faults - *14(OTE), 14(XIC), 22(XIC)*
StationFaults[2].Fault_Indicator.LiftTopToBtm
0 BOOL
Fault Indicator for lift to go from top to bottom
*StationFaults[2].Fault_Indicator.LiftTopToBtm - Station2_ProgramFaults/S2_Faults - *15(OTE), 15(XIC), 22(XIC)*
StationFaults[2].Fault_Indicator.ConveyorMtr
0 BOOL
Fault Indicator for conveyor motor ON
*StationFaults[2].Fault_Indicator.ConveyorMtr - Station2_ProgramFaults/S2_Faults - *16(OTE), 16(XIC), 22(XIC)*
StationFaults[2].Fault_Indicator.LiftToPickup
0 BOOL
Fault Indicator for object to leave lift until it reaches pickup spot
*StationFaults[2].Fault_Indicator.LiftToPickup - Station2_ProgramFaults/S2_Faults - *17(OTE), 17(XIC), 22(XIC)*
StationFaults[2].Fault_Indicator.MtrX
0 BOOL
Fault Indicator for the motor on the X-Axis to be on
*StationFaults[2].Fault_Indicator.MtrX - Station2_ProgramFaults/S2_Faults - *18(OTE), 18(XIC), 22(XIC)*
StationFaults[2].Fault_Indicator.MtrY

StationFaults (Continued)

0 BOOL

Fault Indicator for the motor on the Y-Axis to be on

*StationFaults[2].Fault_Indicator.MtrY - Station2_ProgramFaults/S2_Faults - *19(OTE), 19(XIC), 22(XIC)*

StationFaults[2].Fault_Indicator.ArmRetToExt

0 BOOL

Fault Indicator for the gantry Arm cylinder to go from retracted to extended

*StationFaults[2].Fault_Indicator.ArmRetToExt - Station2_ProgramFaults/S2_Faults - *20(OTE), 20(XIC), 22(XIC)*

StationFaults[2].Fault_Indicator.ArmExtToRet

0 BOOL

Fault Indicator for the gantry Arm cylinder to go from extended to retracted

*StationFaults[2].Fault_Indicator.ArmExtToRet - Station2_ProgramFaults/S2_Faults - *21(OTE), 21(XIC), 22(XIC)*

StationFaults[2].Fault_Timers UDT_FaultTimers

An UDT containing a list of Timers for fault checking

StationFaults[2].Fault_Timers.LiftBtmToTop

TIMER

Timer for lift to go from bottom to top

*StationFaults[2].Fault_Timers.LiftBtmToTop - Station2_ProgramFaults/S2_Faults - *1(TON)*

StationFaults[2].Fault_Timers.LiftBtmToTop.PRE

5000 DINT

Timer for lift to go from bottom to top

StationFaults[2].Fault_Timers.LiftBtmToTop.ACC

0 DINT

Timer for lift to go from bottom to top

StationFaults[2].Fault_Timers.LiftBtmToTop.EN

0 BOOL

Timer for lift to go from bottom to top

StationFaults[2].Fault_Timers.LiftBtmToTop.TT

0 BOOL

Timer for lift to go from bottom to top

StationFaults[2].Fault_Timers.LiftBtmToTop.DN

0 BOOL

Timer for lift to go from bottom to top

StationFaults[2].Fault_Timers.LiftBtmToTop.DN - Station2_ProgramFaults/S2_Faults - 12(XIC)

StationFaults[2].Fault_Timers.LiftCylRetToExt

TIMER

Timer for cylinder to go from retracted to extended

*StationFaults[2].Fault_Timers.LiftCylRetToExt - Station2_ProgramFaults/S2_Faults - *2(TON)*

StationFaults[2].Fault_Timers.LiftCylRetToExt.PRE

5000 DINT

Timer for cylinder to go from retracted to extended

StationFaults[2].Fault_Timers.LiftCylRetToExt.ACC

0 DINT

Timer for cylinder to go from retracted to extended

StationFaults[2].Fault_Timers.LiftCylRetToExt.EN

0 BOOL

Timer for cylinder to go from retracted to extended

StationFaults[2].Fault_Timers.LiftCylRetToExt.TT

0 BOOL

Timer for cylinder to go from retracted to extended

StationFaults[2].Fault_Timers.LiftCylRetToExt.DN

0 BOOL

Timer for cylinder to go from retracted to extended

StationFaults[2].Fault_Timers.LiftCylRetToExt.DN - Station2_ProgramFaults/S2_Faults - 13(XIC)

StationFaults[2].Fault_Timers.LiftCylExtToRet

TIMER

Timer for cylinder to go from extended to retracted

*StationFaults[2].Fault_Timers.LiftCylExtToRet - Station2_ProgramFaults/S2_Faults - *3(TON)*

StationFaults[2].Fault_Timers.LiftCylExtToRet.PRE

3000 DINT

Timer for cylinder to go from extended to retracted

StationFaults[2].Fault_Timers.LiftCylExtToRet.ACC

0 DINT

Timer for cylinder to go from extended to retracted

StationFaults (Continued)

StationFaults[2].Fault_Timers.LiftCylExtToRet.EN
0 BOOL
Timer for cylinder to go from extended to retracted

StationFaults[2].Fault_Timers.LiftCylExtToRet.TT
0 BOOL
Timer for cylinder to go from extended to retracted

StationFaults[2].Fault_Timers.LiftCylExtToRet.DN
0 BOOL
Timer for cylinder to go from extended to retracted
StationFaults[2].Fault_Timers.LiftCylExtToRet.DN - Station2_ProgramFaults/S2_Faults - 14(XIC)

StationFaults[2].Fault_Timers.LiftTopToBtm
TIMER
Timer for lift to go from top to bottom
*StationFaults[2].Fault_Timers.LiftTopToBtm - Station2_ProgramFaults/S2_Faults - *4(TON)*

StationFaults[2].Fault_Timers.LiftTopToBtm.PRE
5000 DINT
Timer for lift to go from top to bottom

StationFaults[2].Fault_Timers.LiftTopToBtm.ACC
0 DINT
Timer for lift to go from top to bottom

StationFaults[2].Fault_Timers.LiftTopToBtm.EN
0 BOOL
Timer for lift to go from top to bottom

StationFaults[2].Fault_Timers.LiftTopToBtm.TT
0 BOOL
Timer for lift to go from top to bottom

StationFaults[2].Fault_Timers.LiftTopToBtm.DN
0 BOOL
Timer for lift to go from top to bottom
StationFaults[2].Fault_Timers.LiftTopToBtm.DN - Station2_ProgramFaults/S2_Faults - 15(XIC)

StationFaults[2].Fault_Timers.ConveyorMtr
TIMER
Timer for conveyor motor ON
*StationFaults[2].Fault_Timers.ConveyorMtr - Station2_ProgramFaults/S2_Faults - *5(TON)*

StationFaults[2].Fault_Timers.ConveyorMtr.PRE
10000 DINT
Timer for conveyor motor ON

StationFaults[2].Fault_Timers.ConveyorMtr.ACC
0 DINT
Timer for conveyor motor ON

StationFaults[2].Fault_Timers.ConveyorMtr.EN
0 BOOL
Timer for conveyor motor ON

StationFaults[2].Fault_Timers.ConveyorMtr.TT
0 BOOL
Timer for conveyor motor ON

StationFaults[2].Fault_Timers.ConveyorMtr.DN
0 BOOL
Timer for conveyor motor ON
StationFaults[2].Fault_Timers.ConveyorMtr.DN - Station2_ProgramFaults/S2_Faults - 16(XIC)

StationFaults[2].Fault_Timers.LiftToPickup
TIMER
Timer object to leave lift until it reaches pickup spot
*StationFaults[2].Fault_Timers.LiftToPickup - Station2_ProgramFaults/S2_Faults - *6(TON)*

StationFaults[2].Fault_Timers.LiftToPickup.PRE
10000 DINT
Timer object to leave lift until it reaches pickup spot

StationFaults[2].Fault_Timers.LiftToPickup.ACC
0 DINT
Timer object to leave lift until it reaches pickup spot

StationFaults[2].Fault_Timers.LiftToPickup.EN
0 BOOL
Timer object to leave lift until it reaches pickup spot

StationFaults (Continued)
StationFaults[2].Fault_Timers.LiftToPickup.TT
0 BOOL
Timer object to leave lift until it reaches pickup spot
StationFaults[2].Fault_Timers.LiftToPickup.DN
0 BOOL
Timer object to leave lift until it reaches pickup spot
StationFaults[2].Fault_Timers.LiftToPickup.DN - Station2_ProgramFaults/S2_Faults - 17(XIC)
StationFaults[2].Fault_Timers.MtrX
TIMER
Time for the motor on the X-Axis to be on
*StationFaults[2].Fault_Timers.MtrX - Station2_ProgramFaults/S2_Faults - *7(TON)*
StationFaults[2].Fault_Timers.MtrX.PRE
30000 DINT
Time for the motor on the X-Axis to be on
StationFaults[2].Fault_Timers.MtrX.ACC
0 DINT
Time for the motor on the X-Axis to be on
StationFaults[2].Fault_Timers.MtrX.EN
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[2].Fault_Timers.MtrX.TT
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[2].Fault_Timers.MtrX.DN
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[2].Fault_Timers.MtrX.DN - Station2_ProgramFaults/S2_Faults - 18(XIC)
StationFaults[2].Fault_Timers.MtrY
TIMER
Time for the motor on the Y-Axis to be on
*StationFaults[2].Fault_Timers.MtrY - Station2_ProgramFaults/S2_Faults - *8(TON)*
StationFaults[2].Fault_Timers.MtrY.PRE
30000 DINT
Time for the motor on the Y-Axis to be on
StationFaults[2].Fault_Timers.MtrY.ACC
0 DINT
Time for the motor on the Y-Axis to be on
StationFaults[2].Fault_Timers.MtrY.EN
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[2].Fault_Timers.MtrY.TT
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[2].Fault_Timers.MtrY.DN
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[2].Fault_Timers.MtrY.DN - Station2_ProgramFaults/S2_Faults - 19(XIC)
StationFaults[2].Fault_Timers.ArmRetToExt
TIMER
Timer for the gantry Arm cylinder to go from retracted to extended
*StationFaults[2].Fault_Timers.ArmRetToExt - Station2_ProgramFaults/S2_Faults - *9(TON)*
StationFaults[2].Fault_Timers.ArmRetToExt.PRE
5000 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[2].Fault_Timers.ArmRetToExt.ACC
0 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[2].Fault_Timers.ArmRetToExt.EN
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[2].Fault_Timers.ArmRetToExt.TT
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended

StationFaults (Continued)

StationFaults[2].Fault_Timers.ArmRetToExt.DN
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[2].Fault_Timers.ArmRetToExt.DN - Station2_ProgramFaults/S2_Faults - 20(XIC)

StationFaults[2].Fault_Timers.ArmExtToRet
TIMER
Timer for the gantry Arm cylinder to go from extended to retracted
*StationFaults[2].Fault_Timers.ArmExtToRet - Station2_ProgramFaults/S2_Faults - *10(TON)*

StationFaults[2].Fault_Timers.ArmExtToRet.PRE
5000 DINT
Timer for the gantry Arm cylinder to go from extended to retracted

StationFaults[2].Fault_Timers.ArmExtToRet.ACC
0 DINT
Timer for the gantry Arm cylinder to go from extended to retracted

StationFaults[2].Fault_Timers.ArmExtToRet.EN
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted

StationFaults[2].Fault_Timers.ArmExtToRet.TT
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted

StationFaults[2].Fault_Timers.ArmExtToRet.DN
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[2].Fault_Timers.ArmExtToRet.DN - Station2_ProgramFaults/S2_Faults - 21(XIC)

StationFaults[3] UDT_Faults
*StationFaults[3] - Station3_ProgramFaults/S3_Faults - *0(COP)*

StationFaults[3].Fault_Check UDT_FaultCheck
bits to use to check for faults

StationFaults[3].Fault_Check.LiftBtmToTop
0 BOOL
Fault Check for lift to go from bottom to top
*StationFaults[3].Fault_Check.LiftBtmToTop - Station3_Program/S3_FaultCheck - *0(OTE)*
StationFaults[3].Fault_Check.LiftBtmToTop - Station3_ProgramFaults/S3_Faults - 1(XIC)

StationFaults[3].Fault_Check.LiftCylRetToExt
0 BOOL
Fault Check for cylinder to go from retracted to extended
*StationFaults[3].Fault_Check.LiftCylRetToExt - Station3_Program/S3_FaultCheck - *4(OTE)*
StationFaults[3].Fault_Check.LiftCylRetToExt - Station3_ProgramFaults/S3_Faults - 2(XIC)

StationFaults[3].Fault_Check.LiftCylExtToRet
0 BOOL
Fault Check for cylinder to go from extended to retracted
*StationFaults[3].Fault_Check.LiftCylExtToRet - Station3_Program/S3_FaultCheck - *5(OTE)*
StationFaults[3].Fault_Check.LiftCylExtToRet - Station3_ProgramFaults/S3_Faults - 3(XIC)

StationFaults[3].Fault_Check.LiftTopToBtm
0 BOOL
Fault Check for lift to go from top to bottom
*StationFaults[3].Fault_Check.LiftTopToBtm - Station3_Program/S3_FaultCheck - *6(OTE)*
StationFaults[3].Fault_Check.LiftTopToBtm - Station3_ProgramFaults/S3_Faults - 4(XIC)

StationFaults[3].Fault_Check.ConveyorMtr
0 BOOL
Fault Check for conveyor motor ON
*StationFaults[3].Fault_Check.ConveyorMtr - Station3_Program/S3_FaultCheck - *1(OTE)*
StationFaults[3].Fault_Check.ConveyorMtr - Station3_ProgramFaults/S3_Faults - 5(XIC)

StationFaults[3].Fault_Check.LiftToPickup
0 BOOL
Fault Check for object to leave lift until it reaches pickup spot
*StationFaults[3].Fault_Check.LiftToPickup - Station3_Program/S3_FaultCheck - *2(OTE)*
StationFaults[3].Fault_Check.LiftToPickup - Station3_ProgramFaults/S3_Faults - 6(XIC)

StationFaults[3].Fault_Check.MtrX
0 BOOL
Fault Check for the motor on the X-Axis to be on
*StationFaults[3].Fault_Check.MtrX - Station3_Program/S3_FaultCheck - *9(OTE)*
StationFaults[3].Fault_Check.MtrX - Station3_ProgramFaults/S3_Faults - 7(XIC)

StationFaults (Continued)

StationFaults[3].Fault_Check.MtrY
0 BOOL
Fault Check for the motor on the Y-Axis to be on
*StationFaults[3].Fault_Check.MtrY - Station3_Program/S3_FaultCheck - *8(OTE)*
StationFaults[3].Fault_Check.MtrY - Station3_ProgramFaults/S3_Faults - 8(XIC)

StationFaults[3].Fault_Check.ArmRetToExt
0 BOOL
Fault Check for the gantry Arm cylinder to go from retracted to extended
*StationFaults[3].Fault_Check.ArmRetToExt - Station3_Program/S3_FaultCheck - *3(OTE)*
StationFaults[3].Fault_Check.ArmRetToExt - Station3_ProgramFaults/S3_Faults - 9(XIC)

StationFaults[3].Fault_Check.ArmExtToRet
0 BOOL
Fault Check for the gantry Arm cylinder to go from extended to retracted
*StationFaults[3].Fault_Check.ArmExtToRet - Station3_Program/S3_FaultCheck - *7(OTE)*
StationFaults[3].Fault_Check.ArmExtToRet - Station3_ProgramFaults/S3_Faults - 10(XIC)

StationFaults[3].Fault_Indicator UDT_FaultIndicators
An UDT containing a list of bits for fault indications

StationFaults[3].Fault_Indicator.LiftBtmToTop
0 BOOL
Fault Indicator for lift to go from bottom to top
*StationFaults[3].Fault_Indicator.LiftBtmToTop - Station3_ProgramFaults/S3_Faults - *12(OTE), 12(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.LiftCylRetToExt
0 BOOL
Fault Indicator for cylinder to go from retracted to extended
*StationFaults[3].Fault_Indicator.LiftCylRetToExt - Station3_ProgramFaults/S3_Faults - *13(OTE), 13(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.LiftCylExtToRet
0 BOOL
Fault Indicator for cylinder to go from extended to retracted
*StationFaults[3].Fault_Indicator.LiftCylExtToRet - Station3_ProgramFaults/S3_Faults - *14(OTE), 14(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.LiftTopToBtm
0 BOOL
Fault Indicator for lift to go from top to bottom
*StationFaults[3].Fault_Indicator.LiftTopToBtm - Station3_ProgramFaults/S3_Faults - *15(OTE), 15(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.ConveyorMtr
0 BOOL
Fault Indicator for conveyor motor ON
*StationFaults[3].Fault_Indicator.ConveyorMtr - Station3_ProgramFaults/S3_Faults - *16(OTE), 16(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.LiftToPickup
0 BOOL
Fault Indicator for object to leave lift until it reaches pickup spot
*StationFaults[3].Fault_Indicator.LiftToPickup - Station3_ProgramFaults/S3_Faults - *17(OTE), 17(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.MtrX
0 BOOL
Fault Indicator for the motor on the X-Axis to be on
*StationFaults[3].Fault_Indicator.MtrX - Station3_ProgramFaults/S3_Faults - *18(OTE), 18(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.MtrY
0 BOOL
Fault Indicator for the motor on the Y-Axis to be on
*StationFaults[3].Fault_Indicator.MtrY - Station3_ProgramFaults/S3_Faults - *19(OTE), 19(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.ArmRetToExt
0 BOOL
Fault Indicator for the gantry Arm cylinder to go from retracted to extended
*StationFaults[3].Fault_Indicator.ArmRetToExt - Station3_ProgramFaults/S3_Faults - *20(OTE), 20(XIC), 22(XIC)*

StationFaults[3].Fault_Indicator.ArmExtToRet
0 BOOL
Fault Indicator for the gantry Arm cylinder to go from extended to retracted
*StationFaults[3].Fault_Indicator.ArmExtToRet - Station3_ProgramFaults/S3_Faults - *21(OTE), 21(XIC), 22(XIC)*

StationFaults[3].Fault_Timers UDT_FaultTimers
An UDT containing a list of Timers for fault checking

StationFaults[3].Fault_Timers.LiftBtmToTop
TIMER
Timer for lift to go from bottom to top
*StationFaults[3].Fault_Timers.LiftBtmToTop - Station3_ProgramFaults/S3_Faults - *1(TON)*

StationFaults (Continued)

StationFaults[3].Fault_Timers.LiftBtmToTop.PRE
5000 DINT
Timer for lift to go from bottom to top

StationFaults[3].Fault_Timers.LiftBtmToTop.ACC
0 DINT
Timer for lift to go from bottom to top

StationFaults[3].Fault_Timers.LiftBtmToTop.EN
0 BOOL
Timer for lift to go from bottom to top

StationFaults[3].Fault_Timers.LiftBtmToTop.TT
0 BOOL
Timer for lift to go from bottom to top

StationFaults[3].Fault_Timers.LiftBtmToTop.DN
0 BOOL
Timer for lift to go from bottom to top
StationFaults[3].Fault_Timers.LiftBtmToTop.DN - Station3_ProgramFaults/S3_Faults - 12(XIC)

StationFaults[3].Fault_Timers.LiftCylRetToExt
TIMER
Timer for cylinder to go from retracted to extended
*StationFaults[3].Fault_Timers.LiftCylRetToExt - Station3_ProgramFaults/S3_Faults - *2(TON)*

StationFaults[3].Fault_Timers.LiftCylRetToExt.PRE
5000 DINT
Timer for cylinder to go from retracted to extended

StationFaults[3].Fault_Timers.LiftCylRetToExt.ACC
0 DINT
Timer for cylinder to go from retracted to extended

StationFaults[3].Fault_Timers.LiftCylRetToExt.EN
0 BOOL
Timer for cylinder to go from retracted to extended

StationFaults[3].Fault_Timers.LiftCylRetToExt.TT
0 BOOL
Timer for cylinder to go from retracted to extended

StationFaults[3].Fault_Timers.LiftCylRetToExt.DN
0 BOOL
Timer for cylinder to go from retracted to extended
StationFaults[3].Fault_Timers.LiftCylRetToExt.DN - Station3_ProgramFaults/S3_Faults - 13(XIC)

StationFaults[3].Fault_Timers.LiftCylExtToRet
TIMER
Timer for cylinder to go from extended to retracted
*StationFaults[3].Fault_Timers.LiftCylExtToRet - Station3_ProgramFaults/S3_Faults - *3(TON)*

StationFaults[3].Fault_Timers.LiftCylExtToRet.PRE
3000 DINT
Timer for cylinder to go from extended to retracted

StationFaults[3].Fault_Timers.LiftCylExtToRet.ACC
0 DINT
Timer for cylinder to go from extended to retracted

StationFaults[3].Fault_Timers.LiftCylExtToRet.EN
0 BOOL
Timer for cylinder to go from extended to retracted

StationFaults[3].Fault_Timers.LiftCylExtToRet.TT
0 BOOL
Timer for cylinder to go from extended to retracted

StationFaults[3].Fault_Timers.LiftCylExtToRet.DN
0 BOOL
Timer for cylinder to go from extended to retracted
StationFaults[3].Fault_Timers.LiftCylExtToRet.DN - Station3_ProgramFaults/S3_Faults - 14(XIC)

StationFaults[3].Fault_Timers.LiftTopToBtm
TIMER
Timer for lift to go from top to bottom
*StationFaults[3].Fault_Timers.LiftTopToBtm - Station3_ProgramFaults/S3_Faults - *4(TON)*

StationFaults[3].Fault_Timers.LiftTopToBtm.PRE
5000 DINT
Timer for lift to go from top to bottom

StationFaults (Continued)

StationFaults[3].Fault_Timers.LiftTopToBtm.ACC
0 DINT
Timer for lift to go from top to bottom

StationFaults[3].Fault_Timers.LiftTopToBtm.EN
0 BOOL
Timer for lift to go from top to bottom

StationFaults[3].Fault_Timers.LiftTopToBtm.TT
0 BOOL
Timer for lift to go from top to bottom

StationFaults[3].Fault_Timers.LiftTopToBtm.DN
0 BOOL
Timer for lift to go from top to bottom
StationFaults[3].Fault_Timers.LiftTopToBtm.DN - Station3_ProgramFaults/S3_Faults - 15(XIC)

StationFaults[3].Fault_Timers.ConveyorMtr
TIMER
Timer for conveyor motor ON
*StationFaults[3].Fault_Timers.ConveyorMtr - Station3_ProgramFaults/S3_Faults - *5(TON)*

StationFaults[3].Fault_Timers.ConveyorMtr.PRE
10000 DINT
Timer for conveyor motor ON

StationFaults[3].Fault_Timers.ConveyorMtr.ACC
0 DINT
Timer for conveyor motor ON

StationFaults[3].Fault_Timers.ConveyorMtr.EN
0 BOOL
Timer for conveyor motor ON

StationFaults[3].Fault_Timers.ConveyorMtr.TT
0 BOOL
Timer for conveyor motor ON

StationFaults[3].Fault_Timers.ConveyorMtr.DN
0 BOOL
Timer for conveyor motor ON
StationFaults[3].Fault_Timers.ConveyorMtr.DN - Station3_ProgramFaults/S3_Faults - 16(XIC)

StationFaults[3].Fault_Timers.LiftToPickup
TIMER
Timer object to leave lift until it reaches pickup spot
*StationFaults[3].Fault_Timers.LiftToPickup - Station3_ProgramFaults/S3_Faults - *6(TON)*

StationFaults[3].Fault_Timers.LiftToPickup.PRE
10000 DINT
Timer object to leave lift until it reaches pickup spot

StationFaults[3].Fault_Timers.LiftToPickup.ACC
0 DINT
Timer object to leave lift until it reaches pickup spot

StationFaults[3].Fault_Timers.LiftToPickup.EN
0 BOOL
Timer object to leave lift until it reaches pickup spot

StationFaults[3].Fault_Timers.LiftToPickup.TT
0 BOOL
Timer object to leave lift until it reaches pickup spot

StationFaults[3].Fault_Timers.LiftToPickup.DN
0 BOOL
Timer object to leave lift until it reaches pickup spot
StationFaults[3].Fault_Timers.LiftToPickup.DN - Station3_ProgramFaults/S3_Faults - 17(XIC)

StationFaults[3].Fault_Timers.MtrX
TIMER
Time for the motor on the X-Axis to be on
*StationFaults[3].Fault_Timers.MtrX - Station3_ProgramFaults/S3_Faults - *7(TON)*

StationFaults[3].Fault_Timers.MtrX.PRE
30000 DINT
Time for the motor on the X-Axis to be on

StationFaults[3].Fault_Timers.MtrX.ACC
0 DINT
Time for the motor on the X-Axis to be on

StationFaults (Continued)
StationFaults[3].Fault_Timers.MtrX.EN
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[3].Fault_Timers.MtrX.TT
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[3].Fault_Timers.MtrX.DN
0 BOOL
Time for the motor on the X-Axis to be on
StationFaults[3].Fault_Timers.MtrX.DN - Station3_ProgramFaults/S3_Faults - 18(XIC)
StationFaults[3].Fault_Timers.MtrY
TIMER
Time for the motor on the Y-Axis to be on
*StationFaults[3].Fault_Timers.MtrY - Station3_ProgramFaults/S3_Faults - *8(TON)*
StationFaults[3].Fault_Timers.MtrY.PRE
30000 DINT
Time for the motor on the Y-Axis to be on
StationFaults[3].Fault_Timers.MtrY.ACC
0 DINT
Time for the motor on the Y-Axis to be on
StationFaults[3].Fault_Timers.MtrY.EN
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[3].Fault_Timers.MtrY.TT
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[3].Fault_Timers.MtrY.DN
0 BOOL
Time for the motor on the Y-Axis to be on
StationFaults[3].Fault_Timers.MtrY.DN - Station3_ProgramFaults/S3_Faults - 19(XIC)
StationFaults[3].Fault_Timers.ArmRetToExt
TIMER
Timer for the gantry Arm cylinder to go from retracted to extended
*StationFaults[3].Fault_Timers.ArmRetToExt - Station3_ProgramFaults/S3_Faults - *9(TON)*
StationFaults[3].Fault_Timers.ArmRetToExt.PRE
5000 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[3].Fault_Timers.ArmRetToExt.ACC
0 DINT
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[3].Fault_Timers.ArmRetToExt.EN
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[3].Fault_Timers.ArmRetToExt.TT
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[3].Fault_Timers.ArmRetToExt.DN
0 BOOL
Timer for the gantry Arm cylinder to go from retracted to extended
StationFaults[3].Fault_Timers.ArmRetToExt.DN - Station3_ProgramFaults/S3_Faults - 20(XIC)
StationFaults[3].Fault_Timers.ArmExtToRet
TIMER
Timer for the gantry Arm cylinder to go from extended to retracted
*StationFaults[3].Fault_Timers.ArmExtToRet - Station3_ProgramFaults/S3_Faults - *10(TON)*
StationFaults[3].Fault_Timers.ArmExtToRet.PRE
5000 DINT
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[3].Fault_Timers.ArmExtToRet.ACC
0 DINT
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[3].Fault_Timers.ArmExtToRet.EN
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted

StationFaults (Continued)
StationFaults[3].Fault_Timers.ArmExtToRet.TT
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[3].Fault_Timers.ArmExtToRet.DN
0 BOOL
Timer for the gantry Arm cylinder to go from extended to retracted
StationFaults[3].Fault_Timers.ArmExtToRet.DN - Station3_ProgramFaults/S3_Faults - 21(XIC)

WheelCount_ALL UDT_WheelCount MultiStation_test
Constant No
External Access: Read/Write
*WheelCount_ALL - HMI_Program/MainRoutine - *0(COP)*
WheelCount_ALL.RED_COUNT.ACC
0 DINT
*WheelCount_ALL.RED_COUNT.ACC - HMI_Program/MainRoutine - *4(CPT)*
WheelCount_ALL.RED_COUNT.ACC - Station1_Program/S1_Logic - 6(GEQ)
WheelCount_ALL.RED_COUNT.ACC - Station1_Program/S1_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.RED_COUNT.ACC - Station2_Program/S2_Logic - 6(GEQ)
WheelCount_ALL.RED_COUNT.ACC - Station2_Program/S2_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.RED_COUNT.ACC - Station3_Program/S3_Logic - 6(GEQ)
WheelCount_ALL.RED_COUNT.ACC - Station3_Program/S3_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.METAL_COUNT.ACC
0 DINT
*WheelCount_ALL.METAL_COUNT.ACC - HMI_Program/MainRoutine - *5(CPT)*
WheelCount_ALL.METAL_COUNT.ACC - Station1_Program/S1_Logic - 6(GEQ)
WheelCount_ALL.METAL_COUNT.ACC - Station1_Program/S1_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.METAL_COUNT.ACC - Station2_Program/S2_Logic - 6(GEQ)
WheelCount_ALL.METAL_COUNT.ACC - Station2_Program/S2_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.METAL_COUNT.ACC - Station3_Program/S3_Logic - 6(GEQ)
WheelCount_ALL.METAL_COUNT.ACC - Station3_Program/S3_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.BLACK_COUNT.ACC
0 DINT
*WheelCount_ALL.BLACK_COUNT.ACC - HMI_Program/MainRoutine - *6(CPT)*
WheelCount_ALL.BLACK_COUNT.ACC - Station1_Program/S1_Logic - 6(GEQ)
WheelCount_ALL.BLACK_COUNT.ACC - Station1_Program/S1_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.BLACK_COUNT.ACC - Station2_Program/S2_Logic - 6(GEQ)
WheelCount_ALL.BLACK_COUNT.ACC - Station2_Program/S2_Outputs - 1(LES), 10(GEQ)
WheelCount_ALL.BLACK_COUNT.ACC - Station3_Program/S3_Logic - 6(GEQ)
WheelCount_ALL.BLACK_COUNT.ACC - Station3_Program/S3_Outputs - 1(LES), 10(GEQ)

WheelCount_Station UDT_WheelCount[4] MultiStation_test
Constant No
External Access: Read/Write
*WheelCount_Station - HMI_Program/MainRoutine - *0(COP), 0(COP)*
WheelCount_Station[0] UDT_WheelCount
WheelCount_Station[0] - HMI_Program/MainRoutine - 0(COP)
WheelCount_Station[1].RED_COUNT
COUNTER
*WheelCount_Station[1].RED_COUNT - Station1_Program/S1_Logic - *42(CTU)*
WheelCount_Station[1].RED_COUNT.ACC
0 DINT
WheelCount_Station[1].RED_COUNT.ACC - HMI_Program/MainRoutine - 4(CPT)
WheelCount_Station[1].RED_COUNT.DN
0 BOOL
WheelCount_Station[1].RED_COUNT.DN - Station1_Program/S1_Logic - 6(XIC)
WheelCount_Station[1].RED_COUNT.DN - Station1_Program/S1_Outputs - 1(XIO), 10(XIC)
WheelCount_Station[1].METAL_COUNT
COUNTER
*WheelCount_Station[1].METAL_COUNT - Station1_Program/S1_Logic - *43(CTU)*
WheelCount_Station[1].METAL_COUNT.ACC
0 DINT
WheelCount_Station[1].METAL_COUNT.ACC - HMI_Program/MainRoutine - 5(CPT)
WheelCount_Station[1].METAL_COUNT.DN

WheelCount_Station (Continued)

0 BOOL

WheelCount_Station[1].METAL_COUNT.DN - Station1_Program/S1_Logic - 6(XIC)
WheelCount_Station[1].METAL_COUNT.DN - Station1_Program/S1_Outputs - 1(XIO), 10(XIC)

WheelCount_Station[1].BLACK_COUNT

COUNTER

*WheelCount_Station[1].BLACK_COUNT - Station1_Program/S1_Logic - *41(CTU)*

WheelCount_Station[1].BLACK_COUNT.ACC

0 DINT

WheelCount_Station[1].BLACK_COUNT.ACC - HMI_Program/MainRoutine - 6(CPT)

WheelCount_Station[1].BLACK_COUNT.DN

0 BOOL

WheelCount_Station[1].BLACK_COUNT.DN - Station1_Program/S1_Logic - 6(XIC)
WheelCount_Station[1].BLACK_COUNT.DN - Station1_Program/S1_Outputs - 1(XIO), 10(XIC)

WheelCount_Station[2].RED_COUNT

COUNTER

*WheelCount_Station[2].RED_COUNT - Station2_Program/S2_Logic - *42(CTU)*

WheelCount_Station[2].RED_COUNT.ACC

0 DINT

WheelCount_Station[2].RED_COUNT.ACC - HMI_Program/MainRoutine - 4(CPT)

WheelCount_Station[2].RED_COUNT.DN

0 BOOL

WheelCount_Station[2].RED_COUNT.DN - Station2_Program/S2_Logic - 6(XIC)
WheelCount_Station[2].RED_COUNT.DN - Station2_Program/S2_Outputs - 1(XIO), 10(XIC)

WheelCount_Station[2].METAL_COUNT

COUNTER

*WheelCount_Station[2].METAL_COUNT - Station2_Program/S2_Logic - *43(CTU)*

WheelCount_Station[2].METAL_COUNT.ACC

0 DINT

WheelCount_Station[2].METAL_COUNT.ACC - HMI_Program/MainRoutine - 5(CPT)

WheelCount_Station[2].METAL_COUNT.DN

0 BOOL

WheelCount_Station[2].METAL_COUNT.DN - Station2_Program/S2_Logic - 6(XIC)
WheelCount_Station[2].METAL_COUNT.DN - Station2_Program/S2_Outputs - 1(XIO), 10(XIC)

WheelCount_Station[2].BLACK_COUNT

COUNTER

*WheelCount_Station[2].BLACK_COUNT - Station2_Program/S2_Logic - *41(CTU)*

WheelCount_Station[2].BLACK_COUNT.ACC

0 DINT

WheelCount_Station[2].BLACK_COUNT.ACC - HMI_Program/MainRoutine - 6(CPT)

WheelCount_Station[2].BLACK_COUNT.DN

0 BOOL

WheelCount_Station[2].BLACK_COUNT.DN - Station2_Program/S2_Logic - 6(XIC)
WheelCount_Station[2].BLACK_COUNT.DN - Station2_Program/S2_Outputs - 1(XIO), 10(XIC)

WheelCount_Station[3].RED_COUNT

COUNTER

*WheelCount_Station[3].RED_COUNT - Station3_Program/S3_Logic - *42(CTU)*

WheelCount_Station[3].RED_COUNT.ACC

0 DINT

WheelCount_Station[3].RED_COUNT.ACC - HMI_Program/MainRoutine - 4(CPT)

WheelCount_Station[3].RED_COUNT.DN

0 BOOL

WheelCount_Station[3].RED_COUNT.DN - Station3_Program/S3_Logic - 6(XIC)
WheelCount_Station[3].RED_COUNT.DN - Station3_Program/S3_Outputs - 1(XIO), 10(XIC)

WheelCount_Station[3].METAL_COUNT

COUNTER

*WheelCount_Station[3].METAL_COUNT - Station3_Program/S3_Logic - *43(CTU)*

WheelCount_Station[3].METAL_COUNT.ACC

0 DINT

WheelCount_Station[3].METAL_COUNT.ACC - HMI_Program/MainRoutine - 5(CPT)

WheelCount_Station[3].METAL_COUNT.DN

0 BOOL

WheelCount_Station[3].METAL_COUNT.DN - Station3_Program/S3_Logic - 6(XIC)
WheelCount_Station[3].METAL_COUNT.DN - Station3_Program/S3_Outputs - 1(XIO), 10(XIC)

WheelCount_Station (Continued)
WheelCount_Station[3].BLACK_COUNT
COUNTER
*WheelCount_Station[3].BLACK_COUNT - Station3_Program/S3_Logic - *41(CTU)*
WheelCount_Station[3].BLACK_COUNT.ACC
0 DINT
WheelCount_Station[3].BLACK_COUNT.ACC - HMI_Program/MainRoutine - 6(CPT)
WheelCount_Station[3].BLACK_COUNT.DN
0 BOOL
WheelCount_Station[3].BLACK_COUNT.DN - Station3_Program/S3_Logic - 6(XIC)
WheelCount_Station[3].BLACK_COUNT.DN - Station3_Program/S3_Outputs - 1(XIO), 10(XIC)