Tabelle 1: Ground Truth - Variable Exclusions

Component	Variable 1	Variable 2	Reason
Rotary Indexing Table	TableInPosition	NOT(TableRotating)	The table cannot be in position and rotating at the same time.
	TableAutomatic	TableManual	The rotary indexing table cannot be in both automatic and manual mode simultaneously.
Station 1	LinearBack1	LinearFront1	The linear unit cannot be in both the rear and front positions simultaneously.
	HandlingUp1	HandlingDown1	The gripper cannot be in both the upper and lower positions simultaneously.
	ClampOpen1	ClampClosed1	The gripper clamp cannot be both open and closed at the same time.
	PartInSingulation1	PartEntered1	Test-part cannot be in both upper singulation and transfer area.
	PreSingulationUp1	PreSingulationDown1	Singulation cannot be in both upper and lower positions simultaneously.
	SingulationDown1	SingulationUp1	Singulation cannot be in both lower and upper position simultaneously.
Station 2	PressingUp2	PressingDown2	The piston cannot be in both the upper and lower positions simultaneously.
Station 3	ClampingUp3	ClampingDown3	Clamping cannot be in both the upper and lower

			positions simultaneously.
	PlungerUp3	PlungerDown3	The plunger cannot be in both the upper and lower positions simultaneously.
	TriggerBack3	TriggerFront3	The trigger cannot be in both the rear and front positions simultaneously.
Station 5	TriggerBack5	TriggerFront5	The trigger cannot be in both the rear and front positions simultaneously.
	ClampingUp5	ClampingDown5	Clamping cannot be in both the upper and lower positions simultaneously.
	PlungerUp5	PlungerDown5	The plunger cannot be in both the upper and lower positions simultaneously.
	ContactingBack5	ContactingFront5	Contacting cannot be in both the rear and front positions simultaneously.
Station 6	StampBack6	StampFront6	The stamp cannot be in both the rear and front positions simultaneously.
Station 7	LinearBack7	LinearFront7	The linear unit cannot be in both the rear and front positions simultaneously.
	HandlingUp7	HandlingDown7	The gripper cannot be in both the upper and lower positions simultaneously.
	ClampOpen7	ClampClosed7	The gripper clamp cannot be both open and closed at the same time.

	LinearInPos7	LinearBack7; LinearFront7;	The linear unit cannot be in both a bod position and front/rear positions simultaneously.
	LinearUnitForward7	LinearUnitBack7	The linear unit cannot be driven forward and backward simultaneously.