

**Properties of symbol table**

Name: Symbols  
 Author:  
 Comment:  
 Created on 04/11/2025 10:11:01 AM  
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 Last filter criterion: All Symbols  
 Number of symbols: 621/621  
 Last Sorting: Address Ascending

Status	Symbol	Address	Data type	Comment
	FB11_TestCart	C 1	COUNTER	Testing Cart ID
	FB11_ProcCart	C 2	COUNTER	Processing Cart ID
	FB11_VisiCart	C 3	COUNTER	Vision Cart ID
	FB11_RoboCart	C 4	COUNTER	Robot Cart ID
	FB11_StorCart	C 5	COUNTER	Storage Cart ID
	FB11_SortCart	C 6	COUNTER	Sorting Cart ID
	Initialization	FB 1	FB 1	Initialization
	Profibus Master	FB 2	FB 2	Profibus Master
	Profibus Robot	FB 3	FB 3	Profibus Robot
	Profibus Storage	FB 4	FB 4	Profibus Storage
	Profibus Handling1	FB 5	FB 5	Profibus Handling1
	Profibus Sorting	FB 6	FB 6	Profibus Sorting
	Profibus Testing	FB 7	FB 7	Profibus Testing
	Profibus Distribution	FB 8	FB 8	Profibus Distribution
	Profibus Handling2	FB 9	FB 9	Profibus Handling2
	Profibus Processing	FB 10	FB 10	Profibus Processing
	Conveyor Control	FB 11	FB 11	Conveyor Control
	Test_Pist_Bck	I 11.2	BOOL	AS-i Piston Back
	Test_Cart_Stat	I 11.4	BOOL	AS-i Cart in station
	Test_Cart_Next	I 11.5	BOOL	AS-i Cart next station
	Test_Optic	I 11.6	BOOL	AS-i Optic sensor
	Test_Count	I 11.7	BOOL	AS-i Count identifier
	Proc_Cart_Stat	I 12.0	BOOL	AS-i Cart in station
	Proc_Cart_Next	I 12.1	BOOL	AS-i Cart next station
	Proc_Optic	I 12.2	BOOL	AS-i Optic sensor
	Proc_Count	I 12.3	BOOL	AS-i Count identifier
	Proc_Pist_Bck	I 13.6	BOOL	AS-i Piston Back
	Visi_Pist_Bck	I 14.2	BOOL	AS-i Piston Back
	Visi_Cart_Stat	I 14.4	BOOL	AS-i Cart in station
	Visi_Cart_Next	I 14.5	BOOL	AS-i Cart next station
	Visi_Optic	I 14.6	BOOL	AS-i Optic sensor
	Visi_Count	I 14.7	BOOL	AS-i Count identifier
	Robo_Cart_Stat	I 15.0	BOOL	AS-i Cart in station
	Robo_Cart_Next	I 15.1	BOOL	AS-i Cart next station
	Robo_Optic	I 15.2	BOOL	AS-i Optic sensor
	Robo_Count	I 15.3	BOOL	AS-i Count identifier
	Robo_Pist_Bck	I 16.6	BOOL	AS-i Piston Back
	Stor_Pist_Bck	I 17.2	BOOL	AS-i Piston Back
	Stor_Cart_Stat	I 17.4	BOOL	AS-i Cart in station
	Stor_Cart_Next	I 17.5	BOOL	AS-i Cart next station
	Stor_Optic	I 17.6	BOOL	AS-i Optic sensor

Status	Symbol	Address	Data type	Comment
	Stor_Count	I 17.7	BOOL	AS-i Count identifier
	Sort_Cart_Stat	I 18.0	BOOL	AS-i Cart in station
	Sort_Cart_Next	I 18.1	BOOL	AS-i Cart next station
	Sort_Optic	I 18.2	BOOL	AS-i Optic sensor
	Sort_Count	I 18.3	BOOL	AS-i Count identifier
	Sort_Pist_Bck	I 19.6	BOOL	AS-i Piston Back
	O_20_On	I 20.0	BOOL	OPC On Button
	O_20_Off	I 20.1	BOOL	OPC Off Button
	O_20_Controller_On	I 20.6	BOOL	OPC Conveyor Controller On
	F_22_Led_On	I 22.0	BOOL	OPC On LED
	F_22_Led_Off	I 22.1	BOOL	OPC Off LED
	F_22_Conveyor	I 22.7	BOOL	OPC Conveyor On
	A_23_CRoute_Out	I 23.6	BOOL	Route Depart (Vision)
	O_24_Cart_Stat	I 24.0	BOOL	OPC Cart in station
	O_24_Cart_Next	I 24.1	BOOL	OPC Cart next station
	O_24_Optic	I 24.2	BOOL	OPC Optic sensor
	O_24_Count	I 24.3	BOOL	OPC Count identifier
	O_24_Pist_Bck	I 24.4	BOOL	OPC Piston Back
	F_24_Release_FB	I 24.5	BOOL	OPC Pin feedback
	C_24_CartDel	I 24.6	BOOL	OPC Cart Delivered
	C_24_CRoute_Out	I 24.7	BOOL	OPC Route Depart
	O_25_Cart_Stat	I 25.0	BOOL	OPC Cart in station
	O_25_Cart_Next	I 25.1	BOOL	OPC Cart next station
	O_25_Optic	I 25.2	BOOL	OPC Optic sensor
	O_25_Count	I 25.3	BOOL	OPC Count identifier
	O_25_Pist_Bck	I 25.4	BOOL	OPC Piston Back
	F_25_Release_FB	I 25.5	BOOL	OPC Pin feedback
	C_25_CartDel	I 25.6	BOOL	OPC Cart Delivered
	C_25_CRoute_Out	I 25.7	BOOL	OPC Route Depart
	O_26_Cart_Stat	I 26.0	BOOL	OPC Cart in station
	O_26_Cart_Next	I 26.1	BOOL	OPC Cart next station
	O_26_Optic	I 26.2	BOOL	OPC Optic sensor
	O_26_Count	I 26.3	BOOL	OPC Count identifier
	O_26_Pist_Bck	I 26.4	BOOL	OPC Piston Back
	F_26_Release_FB	I 26.5	BOOL	OPC Pin feedback
	C_26_CartDel	I 26.6	BOOL	OPC Cart Delivered
	C_26_CRoute_Out	I 26.7	BOOL	OPC Route Depart
	O_27_Cart_Stat	I 27.0	BOOL	OPC Cart in station
	O_27_Cart_Next	I 27.1	BOOL	OPC Cart next station
	O_27_Optic	I 27.2	BOOL	OPC Optic sensor
	O_27_Count	I 27.3	BOOL	OPC Count identifier
	O_27_Pist_Bck	I 27.4	BOOL	OPC Piston Back
	F_27_Release_FB	I 27.5	BOOL	OPC Pin feedback
	C_27_CartDel	I 27.6	BOOL	OPC Cart Delivered
	C_27_CRoute_Out	I 27.7	BOOL	OPC Route Depart
	O_28_Cart_Stat	I 28.0	BOOL	OPC Cart in station
	O_28_Cart_Next	I 28.1	BOOL	OPC Cart next station
	O_28_Optic	I 28.2	BOOL	OPC Optic sensor
	O_28_Count	I 28.3	BOOL	OPC Count identifier
	O_28_Pist_Bck	I 28.4	BOOL	OPC Piston Back

Status	Symbol	Address	Data type	Comment
	F_28_Release_FB	I 28.5	BOOL	OPC Pin feedback
	C_28_CartDel	I 28.6	BOOL	OPC Cart Delivered
	C_28_CRoute_Out	I 28.7	BOOL	OPC Route Depart
	O_29_Cart_Stat	I 29.0	BOOL	OPC Cart in station
	O_29_Cart_Next	I 29.1	BOOL	OPC Cart next station
	O_29_Optic	I 29.2	BOOL	OPC Optic sensor
	O_29_Count	I 29.3	BOOL	OPC Count identifier
	O_29_Pist_Bck	I 29.4	BOOL	OPC Piston Back
	F_29_Release_FB	I 29.5	BOOL	OPC Pin feedback
	C_29_CartDel	I 29.6	BOOL	OPC Cart Delivered
	C_29_CRoute_Out	I 29.7	BOOL	OPC Route Depart
	O_31_Start	I 31.0	BOOL	OPC Start Button
	O_31_Stop	I 31.1	BOOL	OPC Stop Button
	O_31_Reset	I 31.2	BOOL	OPC Reset Button
	O_31_Part_in_Claw	I 31.6	BOOL	OPC Part in Robot Claw
	O_31_Orientation	I 31.7	BOOL	OPC Orientation of Part
	O_32_Sp_Cyl_Bck	I 32.0	BOOL	OPC Spring Cylinder Back
	O_32_Sp_Cyl_Fwd	I 32.1	BOOL	OPC Spring Cylinder Forward
	O_32_Co_Cyl_Bck	I 32.2	BOOL	OPC Cover Cylinder Back
	O_32_Co_Cyl_Fwd	I 32.3	BOOL	OPC Cover Cylinder Forward
	O_32_Sp_PickUp	I 32.4	BOOL	OPC Spring in Pick up position
	O_32_Co_PickUp	I 32.5	BOOL	OPC No Cover in Pick-up position
	O_32_Co_Mag_Empty	I 32.6	BOOL	OPC Cover Magazine Empty
	A_34_Request	I 34.0	BOOL	OPC Request cart
	A_34_No_Cart	I 34.1	BOOL	OPC No Cart at Station
	A_34_Cart_Full	I 34.2	BOOL	OPC Cart Full at Station
	A_34_CRoute_Out	I 34.3	BOOL	OPC Process Finished - Routing
	O_41_Start	I 41.0	BOOL	OPC Start Button
	O_41_Stop	I 41.1	BOOL	OPC Stop Button
	O_41_Key_Pos	I 41.2	BOOL	OPC Key position
	O_41_Reset	I 41.3	BOOL	OPC Reset Button
	O_41_Panel_I4	I 41.4	BOOL	OPC Panel I4 (Outside connection)
	O_41_Panel_I5	I 41.5	BOOL	OPC Panel I5 (Outside connection)
	O_41_Panel_I6	I 41.6	BOOL	OPC Panel I6 (Outside connection)
	O_41_Panel_I7	I 41.7	BOOL	OPC Panel I7 (Outside connection)
	F_43_Led_Start	I 43.0	BOOL	OPC Start LED
	F_43_Led_Reset	I 43.1	BOOL	OPC Reset LED
	F_43_Led_Extra1	I 43.2	BOOL	OPC Extra1 LED
	F_43_Led_Extra2	I 43.3	BOOL	OPC Extra2 LED
	F_43_Panel_O4	I 43.4	BOOL	OPC Panel O4 (Outside connection)
	F_43_Panel_O5	I 43.5	BOOL	OPC Panel O5 (Outside connection)
	F_43_Panel_O6	I 43.6	BOOL	OPC Panel O6 (Outside connection)
	F_43_Panel_O7	I 43.7	BOOL	OPC Panel O7 (Outside connection)
	A_44_Request	I 44.0	BOOL	OPC Request cart
	A_44_No_Cart	I 44.1	BOOL	OPC No Cart at Station
	A_44_Cart_Full	I 44.2	BOOL	OPC Cart Full at Station
	A_44_CRoute_Out	I 44.3	BOOL	OPC Process Finished - Routing
	C_45_Initialization	I 45.0	BOOL	OPC Initialization Ok
	O_50_Part_Reserve	I 50.0	BOOL	OPC Part in reserve position
	O_50_Claw_Cart	I 50.1	BOOL	OPC Claw at cart position

Status	Symbol	Address	Data type	Comment
	O_50_Claw_Del	I 50.2	BOOL	OPC Claw at delivery position
	O_50_Claw_Reserve	I 50.3	BOOL	OPC Claw at reserve position
	O_50_Claw_Low	I 50.4	BOOL	OPC Claw Low
	O_50_Claw_High	I 50.5	BOOL	OPC Claw high
	O_50_Part_in_Claw	I 50.6	BOOL	OPC Part in claw
	O_51_Start	I 51.0	BOOL	OPC Start Button
	O_51_Stop	I 51.1	BOOL	OPC Stop Button
	O_51_Key_Pos	I 51.2	BOOL	OPC Key position
	O_51_Reset	I 51.3	BOOL	OPC Reset Button
	O_51_Panel_I4	I 51.4	BOOL	OPC Panel I4 (Outside connection)
	O_51_Panel_I5	I 51.5	BOOL	OPC Panel I5 (Outside connection)
	O_51_Panel_I6	I 51.6	BOOL	OPC Panel I6 (Outside connection)
	O_51_Panel_I7	I 51.7	BOOL	OPC Panel I7 (Outside connection)
	F_52_Claw_2_Del	I 52.0	BOOL	OPC Moves claw to delivery position
	F_52_Claw_2_Cart	I 52.1	BOOL	OPC Moves claw to cart position
	F_52_Claw_Down	I 52.2	BOOL	OPC Lowers claw
	F_52_Close_Claw	I 52.3	BOOL	OPC Closes claw
	F_53_Led_Start	I 53.0	BOOL	OPC LED Start
	F_53_Led_Reset	I 53.1	BOOL	OPC LED Reset
	F_53_Led_Extra1	I 53.2	BOOL	OPC LED Extra 1
	F_53_Led_Extra2	I 53.3	BOOL	OPC LED Extra 2
	F_53_Panel_O4	I 53.4	BOOL	OPC Panel O4 (Outside connection)
	F_53_Panel_O5	I 53.5	BOOL	OPC Panel O5 (Outside connection)
	F_53_Panel_O6	I 53.6	BOOL	OPC Panel O6 (Outside connection)
	F_53_Panel_O7	I 53.7	BOOL	OPC Panel O7 (Outside connection)
	A_54_Request	I 54.0	BOOL	OPC Release cart - Sorting
	A_54_No_Cart	I 54.1	BOOL	OPC Request cart
	A_54_Cart_Full	I 54.2	BOOL	OPC Cart Delivered
	A_54_CRoute_Out	I 54.3	BOOL	OPC Process Finished - Routing
	C_55_Initialization	I 55.0	BOOL	OPC Initialization Routine
	C_55_PD_Sort	I 55.1	BOOL	OPC Part Delivered to Sorting
	O_60_SPart	I 60.0	BOOL	OPC Part sensor
	O_60_SInd	I 60.1	BOOL	OPC Inductive sensor (metallic)
	O_60_SPhoto	I 60.2	BOOL	OPC Photoelectric (color) sensor
	O_60_Part_Pass	I 60.3	BOOL	OPC Part has passed the identify
	O_60_SL1_Bck	I 60.4	BOOL	OPC Lever1 back position
	O_60_SL1_Fwd	I 60.5	BOOL	OPC Lever1 forward position
	O_60_SL2_Bck	I 60.6	BOOL	OPC Lever2 back position
	O_60_SL2_Fwd	I 60.7	BOOL	OPC Lever2 forward position
	O_61_Start	I 61.0	BOOL	OPC Start Button
	O_61_Stop	I 61.1	BOOL	OPC Stop Button
	O_61_Key_Pos	I 61.2	BOOL	OPC Key position
	O_61_Reset	I 61.3	BOOL	OPC Reset Button
	O_61_Panel_I4	I 61.4	BOOL	OPC Panel I4 (Outside connection)
	O_61_Panel_I5	I 61.5	BOOL	OPC Panel I5 (Outside connection)
	O_61_Panel_I6	I 61.6	BOOL	OPC Panel I6 (Outside connection)
	O_61_Panel_I7	I 61.7	BOOL	OPC Panel I7 (Outside connection)
	F_62_Conveyor	I 62.0	BOOL	OPC Conveyor on
	F_62_P1	I 62.1	BOOL	OPC Pushes Lever 1 forward
	F_62_P2	I 62.2	BOOL	OPC Pushes Lever 2 forward

Status	Symbol	Address	Data type	Comment
	F_62_Identify	I 62.3	BOOL	OPC Identify pin
	F_63_Led_Start	I 63.0	BOOL	OPC LED Start
	F_63_Led_Reset	I 63.1	BOOL	OPC LED Reset
	F_63_Led_Extra1	I 63.2	BOOL	OPC LED Extra 1
	F_63_Led_Extra2	I 63.3	BOOL	OPC LED Extra 2
	F_63_Panel_O4	I 63.4	BOOL	OPC Panel O4 (Outside connection)
	F_63_Panel_O5	I 63.5	BOOL	OPC Panel O5 (Outside connection)
	F_63_Panel_O6	I 63.6	BOOL	OPC Panel O6 (Outside connection)
	F_63_Panel_O7	I 63.7	BOOL	OPC Panel O7 (Outside connection)
	C_65_Initialization	I 65.0	BOOL	OPC Initialization Routine
	C_65_ID_1	I 65.1	BOOL	OPC Identified - Bit 1
	C_65_ID_2	I 65.2	BOOL	OPC Identified - Bit 2
	C_65_Part_Sorted	I 65.3	BOOL	OPC Part Sorted
	O_70_SInductive	I 70.0	BOOL	OPC Inductive sensor (metallic)
	O_70_SPart	I 70.1	BOOL	OPC Part in elevator
	O_70_SStation	I 70.2	BOOL	OPC Station through
	O_70_SPart_Height	I 70.3	BOOL	OPC Part height sensor
	O_70_Elev_High	I 70.4	BOOL	OPC Elevator in high position
	O_70_Elev_Low	I 70.5	BOOL	OPC Elevator in low position
	O_70_Pist_Back	I 70.6	BOOL	OPC Eject piston in back position
	O_71_Start	I 71.0	BOOL	OPC Start Button
	O_71_Stop	I 71.1	BOOL	OPC Stop Button
	O_71_Key_Pos	I 71.2	BOOL	OPC Key position
	O_71_Reset	I 71.3	BOOL	OPC Reset Button
	O_71_Panel_I4	I 71.4	BOOL	OPC Panel I4 (Outside connection)
	O_71_Panel_I5	I 71.5	BOOL	OPC Panel I5 (Outside connection)
	O_71_Panel_I6	I 71.6	BOOL	OPC Panel I6 (Outside connection)
	O_71_Panel_I7	I 71.7	BOOL	OPC Panel I7 (Outside connection)
	F_72_Elev_Down	I 72.0	BOOL	OPC Lowers elevator
	F_72_Elev_Up	I 72.1	BOOL	OPC Rises elevator
	F_72_Eject_Part	I 72.2	BOOL	OPC Eject parts
	F_72_Air_On	I 72.3	BOOL	OPC Turns on air (slide)
	F_73_Led_Start	I 73.0	BOOL	OPC LED Start
	F_73_Led_Reset	I 73.1	BOOL	OPC LED Reset
	F_73_Led_Extra1	I 73.2	BOOL	OPC LED Extra 1
	F_73_Led_Extra2	I 73.3	BOOL	OPC LED Extra 2
	F_73_Panel_O4	I 73.4	BOOL	OPC Panel O4 (Outside connection)
	F_73_Panel_O5	I 73.5	BOOL	OPC Panel O5 (Outside connection)
	F_73_Panel_O6	I 73.6	BOOL	OPC Panel O6 (Outside connection)
	F_73_Panel_O7	I 73.7	BOOL	OPC Panel O7 (Outside connection)
	A_74_Request	I 74.0	BOOL	OPC Request cart
	A_74_No_Cart	I 74.1	BOOL	OPC No Cart at Station
	A_74_Cart_Full	I 74.2	BOOL	OPC Cart Full at Station
	A_74_CRoute_Out	I 74.3	BOOL	OPC Process Finished - Routing
	A_74_CRoute_In80	I 74.4	BOOL	OPC Cart Arrived - Routing
	C_75_Initialization	I 75.0	BOOL	OPC Initialization Routine
	C_75_ID_Delivery1	I 75.1	BOOL	OPC Identified Delivery - Bit 1
	C_75_ID_Delivery2	I 75.2	BOOL	OPC Identified Delivery - Bit 2
	C_75_Part_Del	I 75.3	BOOL	OPC Part Delivered
	C_75_RQ_Part_Del	I 75.4	BOOL	OPC Requested Part Delivered

Status	Symbol	Address	Data type	Comment
	C_75_RQ_Wrong	I 75.5	BOOL	OPC Requested Wrong Part
	C_75_Identified80	I 75.6	BOOL	OPC Identified Delivery
	C_75_Request80	I 75.7	BOOL	OPC Requested Delivery
	O_80_Mag_Full	I 80.0	BOOL	OPC Magazine full
	O_80_Pist_Back	I 80.1	BOOL	OPC Piston in back position
	O_80_Pist_Fwd	I 80.2	BOOL	OPC Piston in forward position
	O_80_Part_Stuck	I 80.3	BOOL	OPC Part stuck in arm
	O_80_Arm_Mag	I 80.4	BOOL	OPC Arm in magazine position
	O_80_Arm_Del	I 80.5	BOOL	OPC Arm in delivery (elevator) position
	O_80_Mag_Empty	I 80.6	BOOL	OPC Magazine Empty
	O_81_Start	I 81.0	BOOL	OPC Start Button
	O_81_Stop	I 81.1	BOOL	OPC Stop Button
	O_81_Key_Pos	I 81.2	BOOL	OPC Key position
	O_81_Reset	I 81.3	BOOL	OPC Reset Button
	O_81_Panel_I4	I 81.4	BOOL	OPC Panel I4 (Outside connection)
	O_81_Panel_I5	I 81.5	BOOL	OPC Panel I5 (Outside connection)
	O_81_Panel_I6	I 81.6	BOOL	OPC Panel I6 (Outside connection)
	O_81_Panel_I7	I 81.7	BOOL	OPC Panel I7 (Outside connection)
	F_82_Pist_Adv	I 82.0	BOOL	OPC Pushes part out of the magazine
	F_82_Suction_On	I 82.1	BOOL	OPC Suction On
	F_82_Suction_Off	I 82.2	BOOL	OPC Suction Off
	F_82_Arm_2_Del	I 82.3	BOOL	OPC Moves arm to delivery (elevator)
	F_82_Arm_2_Mag	I 82.4	BOOL	OPC Moves arm to magazine
	F_83_Led_Start	I 83.0	BOOL	OPC LED Start
	F_83_Led_Reset	I 83.1	BOOL	OPC LED Reset
	F_83_Led_Extra1	I 83.2	BOOL	OPC LED Extra 1
	F_83_Led_Extra2	I 83.3	BOOL	OPC LED Extra 2
	F_83_Panel_O4	I 83.4	BOOL	OPC Panel O4 (Outside connection)
	F_83_Panel_O5	I 83.5	BOOL	OPC Panel O5 (Outside connection)
	F_83_Panel_O6	I 83.6	BOOL	OPC Panel O6 (Outside connection)
	F_83_Panel_O7	I 83.7	BOOL	OPC Panel O7 (Outside connection)
	C_85_Initialization	I 85.0	BOOL	OPC Initialization Routine
	C_85_Part_Del	I 85.1	BOOL	OPC Part Delivered
	C_85_Part_Mag	I 85.2	BOOL	OPC Part in Magazine
	O_90_Part_Reserve	I 90.0	BOOL	OPC Part in reserve position
	O_90_Claw_Del	I 90.1	BOOL	OPC Claw at delivery position
	O_90_Claw_Reserve	I 90.2	BOOL	OPC Claw at reserve position
	O_90_Claw_Cart	I 90.3	BOOL	OPC Claw at cart position
	O_90_Claw_Low	I 90.4	BOOL	OPC Claw Low
	O_90_Claw_High	I 90.5	BOOL	OPC Claw high
	O_90_Part_in_Claw	I 90.6	BOOL	OPC Part in claw
	O_91_Start	I 91.0	BOOL	OPC Start Button
	O_91_Stop	I 91.1	BOOL	OPC Stop Button
	O_91_Key_Pos	I 91.2	BOOL	OPC Key position
	O_91_Reset	I 91.3	BOOL	OPC Reset Button
	O_91_Panel_I4	I 91.4	BOOL	OPC Panel I4 (Outside connection)
	O_91_Panel_I5	I 91.5	BOOL	OPC Panel I5 (Outside connection)
	O_91_Panel_I6	I 91.6	BOOL	OPC Panel I6 (Outside connection)
	O_91_Panel_I7	I 91.7	BOOL	OPC Panel I7 (Outside connection)
	F_92_Claw_2_Cart	I 92.0	BOOL	OPC Feedback Moves claw to cart position

Status	Symbol	Address	Data type	Comment
	F_92_Claw_2_Del	I 92.1	BOOL	OPC Feedback Moves claw to delivery position
	F_92_Claw_Down	I 92.2	BOOL	OPC Feedback Lowers claw
	F_92_Close_Claw	I 92.3	BOOL	OPC Feedback Closes claw
	F_93_Led_Start	I 93.0	BOOL	OPC Feedback LED Start
	F_93_Led_Reset	I 93.1	BOOL	OPC Feedback LED Reset
	F_93_Led_Extra1	I 93.2	BOOL	OPC Feedback LED Extra 1
	F_93_Led_Extra2	I 93.3	BOOL	OPC Feedback LED Extra 2
	F_93_Panel_O4	I 93.4	BOOL	OPC Feedback Panel O4 (Outside connection)
	F_93_Panel_O5	I 93.5	BOOL	OPC Feedback Panel O5 (Outside connection)
	F_93_Panel_O6	I 93.6	BOOL	OPC Feedback Panel O6 (Outside connection)
	F_93_Panel_O7	I 93.7	BOOL	OPC Feedback Panel O7 (Outside connection)
	A_94_Request	I 94.0	BOOL	OPC Request cart
	A_94_No_Cart	I 94.1	BOOL	OPC No Cart at Station
	A_94_Cart_Full	I 94.2	BOOL	OPC Cart Full at Station
	A_94_CRoute_Out	I 94.3	BOOL	OPC Process Finished - Routing
	C_95_Initialization	I 95.0	BOOL	OPC Initialization Routine
	C_95_PD_Proc	I 95.1	BOOL	OPC Part Delivered to Processing
	C_95_PD_Cart	I 95.2	BOOL	OPC Part Delivered to Cart
	O_100_PInit_Pos	I 100.0	BOOL	OPC Part in initial position
	O_100_PDrill_Pos	I 100.1	BOOL	OPC Part in drill position
	O_100_PTest_Pos	I 100.2	BOOL	OPC Part in test position
	O_100_SDrill_High	I 100.3	BOOL	OPC Drill in high position
	O_100_SDrill_Low	I 100.4	BOOL	OPC Drill in low position
	O_100_RT_Sensor	I 100.5	BOOL	OPC Rotating table sensor
	O_100_PTest_Ok	I 100.6	BOOL	OPC Test Ok
	O_101_Start	I 101.0	BOOL	OPC Start Button
	O_101_Stop	I 101.1	BOOL	OPC Stop Button
	O_101_Key_Pos	I 101.2	BOOL	OPC Key position
	O_101_Reset	I 101.3	BOOL	OPC Reset Button
	O_101_Panel_I4	I 101.4	BOOL	OPC Panel I4 (Outside connection)
	O_101_Panel_I5	I 101.5	BOOL	OPC Panel I5 (Outside connection)
	O_101_Panel_I6	I 101.6	BOOL	OPC Panel I6 (Outside connection)
	O_101_Panel_I7	I 101.7	BOOL	OPC Panel I7 (Outside connection)
	F_102_Drill_On	I 102.0	BOOL	OPC Turns drill on
	F_102_RT_On	I 102.1	BOOL	OPC Moves rotating table
	F_102_Drill_Down	I 102.2	BOOL	OPC Lowers drill
	F_102_Drill_Up	I 102.3	BOOL	OPC Raises drill
	F_102_Drill_Pin	I 102.4	BOOL	OPC Advances drill pin
	F_102_Test_Pin	I 102.5	BOOL	OPC Advances test pin
	F_103_Led_Start	I 103.0	BOOL	OPC LED Start
	F_103_Led_Reset	I 103.1	BOOL	OPC LED Reset
	F_103_Led_Extra1	I 103.2	BOOL	OPC LED Extra 1
	F_103_Led_Extra2	I 103.3	BOOL	OPC LED Extra 2
	F_103_Panel_O4	I 103.4	BOOL	OPC Panel O4 (Outside connection)
	F_103_Panel_O5	I 103.5	BOOL	OPC Panel O5 (Outside connection)
	F_103_Panel_O6	I 103.6	BOOL	OPC Panel O6 (Outside connection)
	F_103_Panel_O7	I 103.7	BOOL	OPC Panel O7 (Outside connection)
	C_105_Initialization	I 105.0	BOOL	OPC Initialization OK
	C_105_Part_Ready	I 105.1	BOOL	OPC Part Ready for Transport
	C_105_Test_Ok	I 105.2	BOOL	OPC Test Ok

Status	Symbol	Address	Data type	Comment
	C_105_Test_Fail	I 105.3	BOOL	OPC Test Fail
	On	I 124.0	BOOL	Botão On
	Off	I 124.1	BOOL	Botão Off
	Controller_On	I 124.6	BOOL	Controladora Ligada
	C_86_Mag_Parts	IB 86	BYTE	OPC Number of Existing Parts in Magazine
	C_87_RQ_MParts	IB 87	BYTE	OPC Number of Parts Still Needed in Counted Mode
	FB2_OPC_UA	M 0.0	BOOL	OPC UA Dedicated
	FB2_Open_Test_Pin	M 0.1	BOOL	FB2 Open Testing Pin
	FB2_Open_Proc_Pin	M 0.2	BOOL	FB2 Open Processing Pin
	FB2_Open_Visi_Pin	M 0.3	BOOL	FB2 Open Vision Pin
	FB2_Open_Robot_Pin	M 0.4	BOOL	FB2 Open Robot Pin
	FB2_Open_Stor_Pin	M 0.5	BOOL	FB2 Open Storage Pin
	FB2_Open_Sort_Pin	M 0.6	BOOL	FB2 Open Sorting Pin
	FB11_Test	M 1.0	BOOL	FB11 Request Cart at Testing
	FB11_Test_Proc	M 1.1	BOOL	FB11 Opens path from Processing
	FB11_Test_Visi	M 1.2	BOOL	FB11 Opens path from Vision
	FB11_Test_Robot	M 1.3	BOOL	FB11 Opens path from Robot
	FB11_Test_Stor	M 1.4	BOOL	FB11 Opens path from Storage
	FB11_Test_Sort	M 1.5	BOOL	FB11 Opens path from Sorting
	FB11_Test_Conv	M 1.6	BOOL	FB11 Activates Conveyor
	FB11_Test_Cart	M 1.7	BOOL	FB11 Verifies Cart ID
	FB11_Proc	M 2.0	BOOL	FB11 Request Cart at Processing
	FB11_Proc_Visi	M 2.1	BOOL	FB11 Opens path from Vision
	FB11_Proc_Robot	M 2.2	BOOL	FB11 Opens path from Robot
	FB11_Proc_Stor	M 2.3	BOOL	FB11 Opens path from Storage
	FB11_Proc_Sort	M 2.4	BOOL	FB11 Opens path from Sorting
	FB11_Proc_Test	M 2.5	BOOL	FB11 Opens path from Testing
	FB11_Proc_Conv	M 2.6	BOOL	FB11 Activates Conveyor
	FB11_Proc_Cart	M 2.7	BOOL	FB11 Verifies Cart ID
	FB11_Visi	M 3.0	BOOL	FB11 Request Cart at Vision
	FB11_Visi_Robot	M 3.1	BOOL	FB11 Opens path from Robot
	FB11_Visi_Stor	M 3.2	BOOL	FB11 Opens path from Storage
	FB11_Visi_Sort	M 3.3	BOOL	FB11 Opens path from Sorting
	FB11_Visi_Test	M 3.4	BOOL	FB11 Opens path from Testing
	FB11_Visi_Proc	M 3.5	BOOL	FB11 Opens path from Processing
	FB11_Visi_Conv	M 3.6	BOOL	FB11 Activates Conveyor
	FB11_Visi_Cart	M 3.7	BOOL	FB11 Verifies Cart ID
	FB11_Robot	M 4.0	BOOL	FB11 Request Cart at Robot
	FB11_Robot_Stor	M 4.1	BOOL	FB11 Opens path from Storage
	FB11_Robot_Sort	M 4.2	BOOL	FB11 Opens path from Sorting
	FB11_Robot_Test	M 4.3	BOOL	FB11 Opens path from Testing
	FB11_Robot_Proc	M 4.4	BOOL	FB11 Opens path from Processing
	FB11_Robot_Visi	M 4.5	BOOL	FB11 Opens path from Vision
	FB11_Robot_Conv	M 4.6	BOOL	FB11 Activates Conveyor
	FB11_Robot_Cart	M 4.7	BOOL	FB11 Verifies Cart ID
	FB11_Stor	M 5.0	BOOL	FB11 Request Cart at Storage
	FB11_Stor_Sort	M 5.1	BOOL	FB11 Opens path from Sorting
	FB11_Stor_Test	M 5.2	BOOL	FB11 Opens path from Testing
	FB11_Stor_Proc	M 5.3	BOOL	FB11 Opens path from Processing
	FB11_Stor_Visi	M 5.4	BOOL	FB11 Opens path from Vision

Status	Symbol	Address	Data type	Comment
	FB11_Stor_Robot	M 5.5	BOOL	FB11 Opens path from Robot
	FB11_Stor_Conv	M 5.6	BOOL	FB11 Activates Conveyor
	FB11_Stor_Cart	M 5.7	BOOL	FB11 Veryfies Cart ID
	FB11_Sort	M 6.0	BOOL	FB11 Request Cart at Sorting
	FB11_Sort_Test	M 6.1	BOOL	FB11 Opens path from Testing
	FB11_Sort_Proc	M 6.2	BOOL	FB11 Opens path from Processing
	FB11_Sort_Visi	M 6.3	BOOL	FB11 Opens path from Vision
	FB11_Sort_Robot	M 6.4	BOOL	FB11 Opens path from Robot
	FB11_Sort_Stor	M 6.5	BOOL	FB11 Opens path from Storage
	FB11_Sort_Conv	M 6.6	BOOL	FB11 Activates Conveyor
	FB11_Sort_Cart	M 6.7	BOOL	FB11 Veryfies Cart ID
	FB11_Conv_Error	M 7.0	BOOL	FB11 Conveyor activation error
	FB11_Cart_Selected	M 7.1	BOOL	FB11 Cart chossen for transport
	FB3_CartDel	M 7.2	BOOL	FB3 Delay for Cart
	FB3_ED1	M 7.3	BOOL	FB3 Edge Detection
	I/O_FLT1	OB 82	OB 82	I/O Point Fault 1
	PROG_ERR	OB 121	OB 121	Programming Error
	Cart_Test	Q 11.0	BOOL	AS-i Release cart - Testing
	Cart_Proc	Q 13.4	BOOL	AS-i Release cart - Processing
	Cart_Vision	Q 14.0	BOOL	AS-i Release cart - Vision
	Cart_Robot	Q 16.4	BOOL	AS-i Release cart - Robot
	Cart_Storage	Q 17.0	BOOL	AS-i Release cart - Storage
	Cart_Sort	Q 19.4	BOOL	AS-i Release cart - Sorting
	I_20_Led_On	Q 20.0	BOOL	OPC On LED
	I_20_Led_Off	Q 20.1	BOOL	OPC Off LED
	I_20_Conveyor	Q 20.7	BOOL	OPC Conveyor On
	A_23_CRoute_In	Q 23.6	BOOL	Route Arrive (Vision)
	I_24_Cart_Test	Q 24.0	BOOL	OPC Release cart Testing
	C_24_Request	Q 24.1	BOOL	OPC Request cart
	C_24_CRoute_In	Q 24.2	BOOL	OPC Route Arrive
	I_25_Cart_Proc	Q 25.0	BOOL	OPC Release cart Processing
	C_25_Request	Q 25.1	BOOL	OPC Request cart
	C_25_CRoute_In	Q 25.2	BOOL	OPC Route Arrive
	I_26_Cart_Visi	Q 26.0	BOOL	OPC Release cart Vision
	C_26_Request	Q 26.1	BOOL	OPC Request cart
	C_26_CRoute_In	Q 26.2	BOOL	OPC Route Arrive
	I_27_Cart_Robo	Q 27.0	BOOL	OPC Release cart Robot
	C_27_Request	Q 27.1	BOOL	OPC Request cart
	C_27_CRoute_In	Q 27.2	BOOL	OPC Route Arrive
	I_28_Cart_Stor	Q 28.0	BOOL	OPC Release cart Storage
	C_28_Request	Q 28.1	BOOL	OPC Request cart
	C_28_CRoute_In	Q 28.2	BOOL	OPC Route Arrive
	I_29_Cart_Sort	Q 29.0	BOOL	OPC Release cart Sorting
	C_29_Request	Q 29.1	BOOL	OPC Request cart
	C_29_CRoute_In	Q 29.2	BOOL	OPC Route Arrive
	I_30_Led_Start	Q 30.0	BOOL	OPC Start LED
	I_30_Led_Reset	Q 30.1	BOOL	OPC Reset LED
	I_30_Led_Extra1	Q 30.2	BOOL	OPC Special Function 1
	I_30_Led_Extra2	Q 30.3	BOOL	OPC Special Function 2
	I_30_Spring_Cyl	Q 30.4	BOOL	OPC Spring Cylinder

Status	Symbol	Address	Data type	Comment
	I_30_Cover_Cyl	Q 30.5	BOOL	OPC Cover Cylinder
	C_30_Robot1	Q 30.6	BOOL	OPC Robot Function 1
	C_30_Robot2	Q 30.7	BOOL	OPC Robot Function 2
	F_33_Led_Start	Q 33.0	BOOL	OPC Start LED
	F_33_Led_Reset	Q 33.1	BOOL	OPC Reset LED
	F_33_Led_Extra1	Q 33.2	BOOL	OPC Special Function 1
	F_33_Led_Extra2	Q 33.3	BOOL	OPC Special Function 2
	F_33_Spring_Cyl	Q 33.4	BOOL	OPC Spring Cylinder
	F_33_Cover_Cyl	Q 33.5	BOOL	OPC Cover Cylinder
	A_34_Cart_Stat	Q 34.0	BOOL	OPC Cart in station
	A_34_Cart_Next	Q 34.1	BOOL	OPC Cart near next station
	A_34_Optic	Q 34.2	BOOL	OPC Optic sensor on station
	A_34_Count	Q 34.3	BOOL	OPC Cart count identifier
	A_34_Pist_Bck	Q 34.4	BOOL	OPC Piston in back position
	A_34_Release_FB	Q 34.5	BOOL	OPC Pin release feedback
	A_34_CRoute_In	Q 34.6	BOOL	OPC Cart Arrived - Routing
	C_35_Part_Del	Q 35.0	BOOL	OPC Part Delivered
	I_41_Led_Start	Q 41.0	BOOL	OPC Start LED
	I_41_Led_Reset	Q 41.1	BOOL	OPC Reset LED
	I_41_Led_Extra1	Q 41.2	BOOL	OPC Extra1 LED
	I_41_Led_Extra2	Q 41.3	BOOL	OPC Extra2 LED
	I_41_Panel_O4	Q 41.4	BOOL	OPC Panel O4 (Outside connection)
	I_41_Panel_O5	Q 41.5	BOOL	OPC Panel O5 (Outside connection)
	I_41_Panel_O6	Q 41.6	BOOL	OPC Panel O6 (Outside connection)
	I_41_Panel_O7	Q 41.7	BOOL	OPC Panel O7 (Outside connection)
	C_42_Profibus	Q 42.0	BOOL	OPC Profibus Ok
	A_44_Cart_Stat	Q 44.0	BOOL	OPC Cart in station
	A_44_Cart_Next	Q 44.1	BOOL	OPC Cart near next station
	A_44_Optic	Q 44.2	BOOL	OPC Optic sensor on station
	A_44_Count	Q 44.3	BOOL	OPC Cart count identifier
	A_44_Pist_Bck	Q 44.4	BOOL	OPC Piston in back position
	A_44_Release_FB	Q 44.5	BOOL	OPC Pin release feedback
	A_44_CRoute_In	Q 44.6	BOOL	OPC Cart Arrived - Routing
	C_45_Start	Q 45.0	BOOL	OPC Start Procedure
	C_45_StorePart	Q 45.1	BOOL	OPC Store Part
	C_45_RetrievePart	Q 45.2	BOOL	OPC Retrieve Part
	I_50_Claw_2_Del	Q 50.0	BOOL	OPC Moves claw to delivery position
	I_50_Claw_2_Cart	Q 50.1	BOOL	OPC Moves claw to cart position
	I_50_Claw_Down	Q 50.2	BOOL	OPC Lowers claw
	I_50_Close_Claw	Q 50.3	BOOL	OPC Closes claw
	I_51_Led_Start	Q 51.0	BOOL	OPC Start LED
	I_51_Led_Reset	Q 51.1	BOOL	OPC Reset LED
	I_51_Led_Extra1	Q 51.2	BOOL	OPC Extra1 LED
	I_51_Led_Extra2	Q 51.3	BOOL	OPC Extra2 LED
	I_51_Panel_O4	Q 51.4	BOOL	OPC Panel O4 (Outside connection)
	I_51_Panel_O5	Q 51.5	BOOL	OPC Panel O5 (Outside connection)
	I_51_Panel_O6	Q 51.6	BOOL	OPC Panel O6 (Outside connection)
	I_51_Panel_O7	Q 51.7	BOOL	OPC Panel O7 (Outside connection)
	C_52_Profibus	Q 52.0	BOOL	OPC Profibus Ok
	A_54_Cart_Stat	Q 54.0	BOOL	OPC Cart in station

Status	Symbol	Address	Data type	Comment
	A_54_Cart_Next	Q 54.1	BOOL	OPC Cart near next station
	A_54_Optic	Q 54.2	BOOL	OPC Optic sensor on station
	A_54_Count	Q 54.3	BOOL	OPC Cart count identifier
	A_54_Pist_Bck	Q 54.4	BOOL	OPC Piston in back position
	A_54_Release_FB	Q 54.5	BOOL	OPC Pin release feedback
	A_54_CRoute_In	Q 54.6	BOOL	OPC Cart Arrived - Routing
	C_55_Start	Q 55.0	BOOL	OPC Start Arm Movement
	C_55_Cart2Del	Q 55.1	BOOL	OPC Cart to Delivery Mode
	I_60_Conveyor	Q 60.0	BOOL	OPC Conveyor on
	I_60_P1	Q 60.1	BOOL	OPC Pushes Lever 1 forward
	I_60_P2	Q 60.2	BOOL	OPC Pushes Lever 2 forward
	I_60_Identify	Q 60.3	BOOL	OPC Identify pin
	I_61_Led_Start	Q 61.0	BOOL	OPC Start LED
	I_61_Led_Reset	Q 61.1	BOOL	OPC Reset LED
	I_61_Led_Extra1	Q 61.2	BOOL	OPC Extra1 LED
	I_61_Led_Extra2	Q 61.3	BOOL	OPC Extra2 LED
	I_61_Panel_O4	Q 61.4	BOOL	OPC Panel O4 (Outside connection)
	I_61_Panel_O5	Q 61.5	BOOL	OPC Panel O5 (Outside connection)
	I_61_Panel_O6	Q 61.6	BOOL	OPC Panel O6 (Outside connection)
	I_61_Panel_O7	Q 61.7	BOOL	OPC Panel O7 (Outside connection)
	C_62_Profibus	Q 62.0	BOOL	OPC Profibus Ok
	C_65_RBS_Output	Q 65.0	BOOL	OPC Red-Black-Silver Output
	C_65_RSB_Output	Q 65.1	BOOL	OPC Red-Silver-Black Output
	C_65_BRS_Output	Q 65.2	BOOL	OPC Black-Red-Silver Output
	C_65_BSR_Output	Q 65.3	BOOL	OPC Black-Silver-Red Output
	C_65_SRB_Output	Q 65.4	BOOL	OPC Silver-Red-Black Output
	C_65_SBR_Output	Q 65.5	BOOL	OPC Silver-Black_Red Output
	I_70_Elev_Down	Q 70.0	BOOL	OPC Lowers elevator
	I_70_Elev_Up	Q 70.1	BOOL	OPC Rises elevator
	I_70_Eject_Part	Q 70.2	BOOL	OPC Eject parts
	I_70_Air_On	Q 70.3	BOOL	OPC Turns on air (slide)
	I_71_Led_Start	Q 71.0	BOOL	OPC Start LED
	I_71_Led_Reset	Q 71.1	BOOL	OPC Reset LED
	I_71_Led_Extra1	Q 71.2	BOOL	OPC Extra1 LED
	I_71_Led_Extra2	Q 71.3	BOOL	OPC Extra2 LED
	I_71_Panel_O4	Q 71.4	BOOL	OPC Panel O4 (Outside connection)
	I_71_Panel_O5	Q 71.5	BOOL	OPC Panel O5 (Outside connection)
	I_71_Panel_O6	Q 71.6	BOOL	OPC Panel O6 (Outside connection)
	I_71_Panel_O7	Q 71.7	BOOL	OPC Panel O7 (Outside connection)
	C_72_Profibus	Q 72.0	BOOL	OPC Profibus Ok
	A_74_Cart_Stat	Q 74.0	BOOL	OPC Cart in station
	A_74_Cart_Next	Q 74.1	BOOL	OPC Cart near next station
	A_74_Optic	Q 74.2	BOOL	OPC Optic sensor on station
	A_74_Count	Q 74.3	BOOL	OPC Cart count identifier
	A_74_Pist_Bck	Q 74.4	BOOL	OPC Piston in back position
	A_74_Release_FB	Q 74.5	BOOL	OPC Pin release feedback
	A_74_CRoute_In	Q 74.6	BOOL	OPC Cart Arrived - Routing
	I_75_RQ_Delivery1	Q 75.0	BOOL	OPC Requested Delivery - Bit 1
	I_75_RQ_Delivery2	Q 75.1	BOOL	OPC Requested Delivery - Bit 2
	C_75_Identified	Q 75.2	BOOL	OPC Identified Delivery

Status	Symbol	Address	Data type	Comment
	C_75_Requested	Q 75.3	BOOL	OPC Requested Delivery
	I_80_Pist_Adv	Q 80.0	BOOL	OPC Pushes part out of the magazine
	I_80_Suction_On	Q 80.1	BOOL	OPC Suction On
	I_80_Suction_Off	Q 80.2	BOOL	OPC Suction Off
	I_80_Arm_2_Del	Q 80.3	BOOL	OPC Moves arm to delivery (elevator)
	I_80_Arm_2_Mag	Q 80.4	BOOL	OPC Moves arm to magazine
	I_81_Led_Start	Q 81.0	BOOL	OPC Start LED
	I_81_Led_Reset	Q 81.1	BOOL	OPC Reset LED
	I_81_Led_Extra1	Q 81.2	BOOL	OPC Extra1 LED
	I_81_Led_Extra2	Q 81.3	BOOL	OPC Extra2 LED
	I_81_Panel_O4	Q 81.4	BOOL	OPC Panel O4 (Outside connection)
	I_81_Panel_O5	Q 81.5	BOOL	OPC Panel O5 (Outside connection)
	I_81_Panel_O6	Q 81.6	BOOL	OPC Panel O6 (Outside connection)
	I_81_Panel_O7	Q 81.7	BOOL	OPC Panel O7 (Outside connection)
	C_82_Profibus	Q 82.0	BOOL	OPC Profibus Ok
	C_85_Start	Q 85.0	BOOL	OPC Start Production
	C_85_Single	Q 85.1	BOOL	OPC Single Mode
	C_85_Continuous	Q 85.2	BOOL	OPC Continuous Mode
	C_85_Counted	Q 85.3	BOOL	OPC Counted Mode
	I_90_Claw_2_Cart	Q 90.0	BOOL	OPC Moves claw to cart position
	I_90_Claw_2_Del	Q 90.1	BOOL	OPC Moves claw to delivery position
	I_90_Claw_Down	Q 90.2	BOOL	OPC Lowers claw
	I_90_Close_Claw	Q 90.3	BOOL	OPC Closes claw
	I_91_Led_Start	Q 91.0	BOOL	OPC Start LED
	I_91_Led_Reset	Q 91.1	BOOL	OPC Reset LED
	I_91_Led_Extra1	Q 91.2	BOOL	OPC Extra1 LED
	I_91_Led_Extra2	Q 91.3	BOOL	OPC Extra2 LED
	I_91_Panel_O4	Q 91.4	BOOL	OPC Panel O4 (Outside connection)
	I_91_Panel_O5	Q 91.5	BOOL	OPC Panel O5 (Outside connection)
	I_91_Panel_O6	Q 91.6	BOOL	OPC Panel O6 (Outside connection)
	I_91_Panel_O7	Q 91.7	BOOL	OPC Panel O7 (Outside connection)
	C_92_Profibus	Q 92.0	BOOL	OPC Profibus Ok
	A_94_Cart_Stat	Q 94.0	BOOL	OPC Cart in station
	A_94_Cart_Next	Q 94.1	BOOL	OPC Cart near next station
	A_94_Optic	Q 94.2	BOOL	OPC Optic sensor on station
	A_94_Count	Q 94.3	BOOL	OPC Cart count identifier
	A_94_Pist_Bck	Q 94.4	BOOL	OPC Piston in back position
	A_94_Release_FB	Q 94.5	BOOL	OPC Pin release feedback
	A_94_CRoute_In	Q 94.6	BOOL	OPC Cart Arrived - Routing
	C_95_Start	Q 95.0	BOOL	OPC Strat Arm Movement
	C_95_Cart2Del	Q 95.1	BOOL	OPC Cart to Delivery Mode
	C_95_Del2Cart	Q 95.2	BOOL	OPC Delivery to Cart Mode
	I_100_Drill_On	Q 100.0	BOOL	OPC Turns drill on
	I_100_RT_On	Q 100.1	BOOL	OPC Moves rotating table
	I_100_Drill_Down	Q 100.2	BOOL	OPC Lowers drill
	I_100_Drill_Up	Q 100.3	BOOL	OPC Raises drill
	I_100_Drill_Pin	Q 100.4	BOOL	OPC Advances drill pin
	I_100_Test_Pin	Q 100.5	BOOL	OPC Advances test pin
	I_101_Led_Start	Q 101.0	BOOL	OPC Start LED
	I_101_Led_Reset	Q 101.1	BOOL	OPC Reset LED

Status	Symbol	Address	Data type	Comment
	I_101_Led_Extra1	Q 101.2	BOOL	OPC Extra1 LED
	I_101_Led_Extra2	Q 101.3	BOOL	OPC Extra2 LED
	I_101_Panel_O4	Q 101.4	BOOL	OPC Panel O4 (Outside connection)
	I_101_Panel_O5	Q 101.5	BOOL	OPC Panel O5 (Outside connection)
	I_101_Panel_O6	Q 101.6	BOOL	OPC Panel O6 (Outside connection)
	I_101_Panel_O7	Q 101.7	BOOL	OPC Panel O7 (Outside connection)
	C_102_Profibus	Q 102.0	BOOL	OPC Profibus Ok
	C_105_Start	Q 105.0	BOOL	OPC Test Only Mode
	C_105_Test	Q 105.1	BOOL	OPC Test Only Mode
	C_105_TestDrill	Q 105.2	BOOL	OPC Test and Drill Mode
	C_105_Rotation	Q 105.3	BOOL	OPC Rotate the Table only
	Led_On	Q 124.0	BOOL	Led On
	Led_Off	Q 124.1	BOOL	Led Off
	Conveyor	Q 124.7	BOOL	Conveyor
	A_32_RoboCartID	QB 32	BYTE	Robot Cart ID
	A_43_StorCartID	QB 43	BYTE	Storage Cart ID
	A_53_SortCartID	QB 53	BYTE	Sorting Cart ID
	A_73_TestCartID	QB 73	BYTE	Testing Cart ID
	C_83_RQ_Parts	QB 83	BYTE	Rq Parts - C_85_Counted
	A_73_ProcCartID	QB 93	BYTE	Processing Cart ID
	C_103_RQ_Turns	QB 103	BYTE	Rq Turns - C-105_Rotation
	FB11_Cart_Test_Timer	T 1	TIMER	
	FB11_Cart_Proc_Timer	T 2	TIMER	
	FB11_Cart_Visi_Timer	T 3	TIMER	
	FB11_Cart_Robo_Timer	T 4	TIMER	
	FB11_Cart_Stor_Timer	T 5	TIMER	
	FB11_Cart_Sort_Timer	T 6	TIMER	
	FB3_CartDelay1	T 7	TIMER	OPC Cart Delay
	FB3_CartDelay2	T 8	TIMER	OPC Cart Delay
	FB2_VisionRoute	T 9	TIMER	OPC Cart Route