

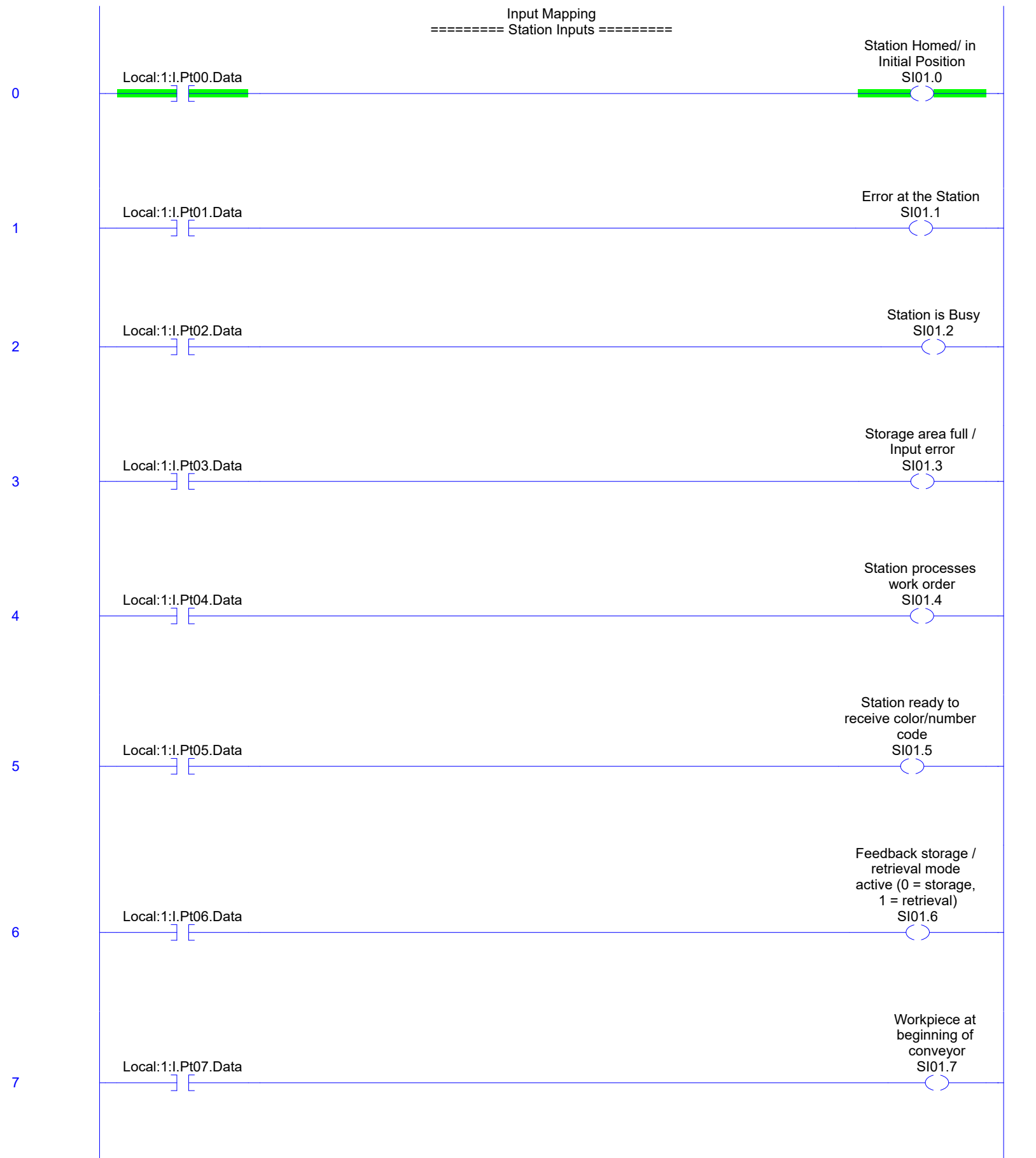
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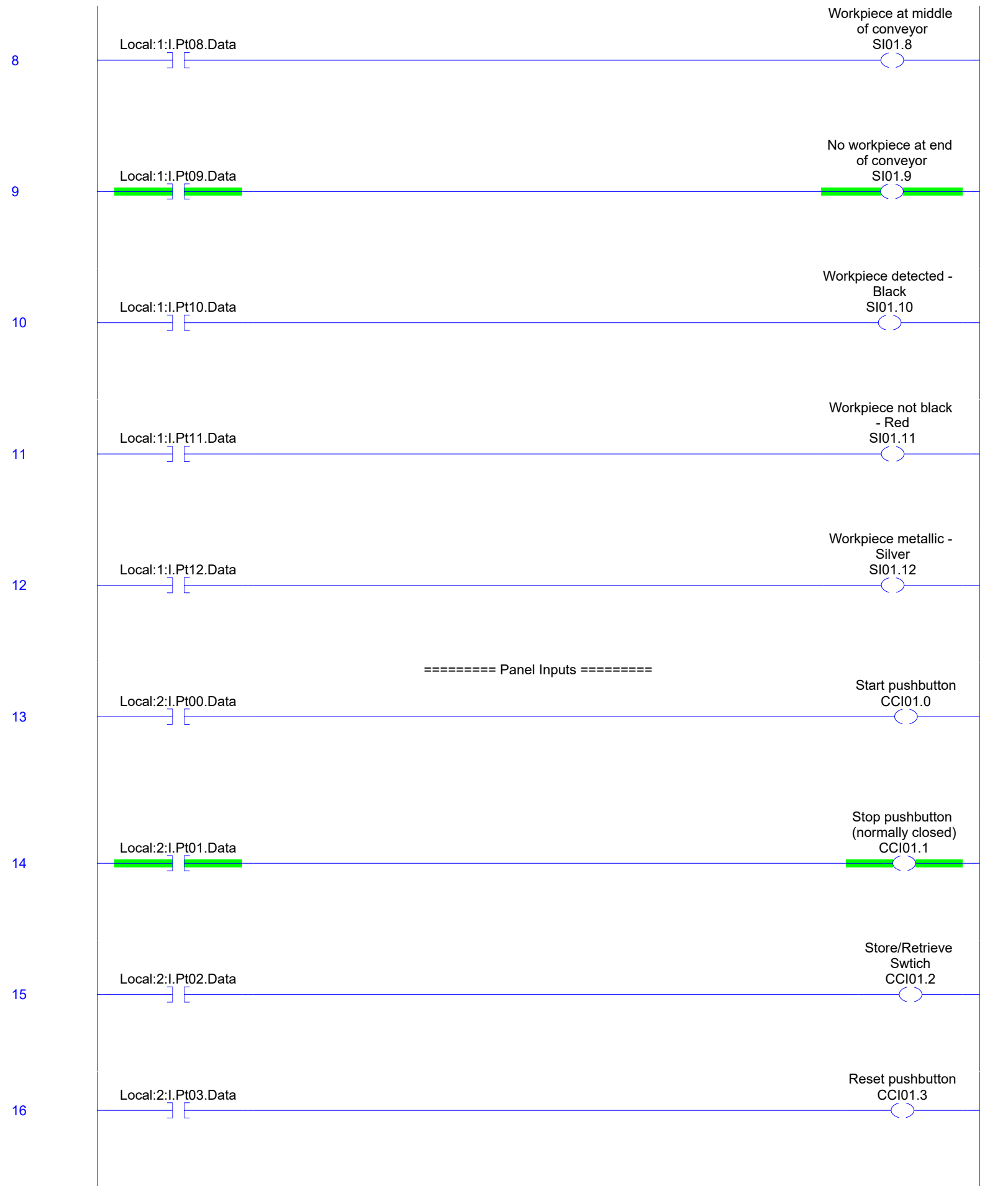
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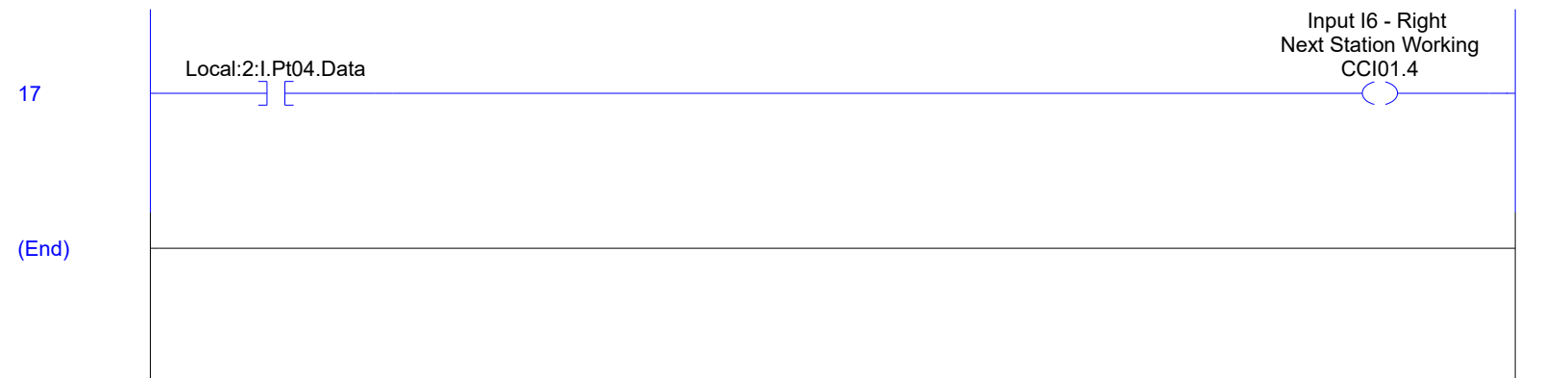
Name	Alias For	Base Tag	Data Type	Value	Description	External Access	Style	Constant
[-] BAND_01			FBD_BOOLE AN_AND	{...}		Read/Write		No
[-] BAND_02			FBD_BOOLE AN_AND	{...}		Read/Write		No
[-] BAND_03			FBD_BOOLE AN_AND	{...}		Read/Write		No
[-] BAND_04			FBD_BOOLE AN_AND	{...}		Read/Write		No
[-] BIT			DINT	1		Read/Write	Decimal	No
[-] BIT.0			BOOL	1	Station Ready Bit	Read/Write	Decimal	No
[-] BIT.1			BOOL	0	Start Station	Read/Write	Decimal	No
[-] BIT.2			BOOL	0	E-Stop Bit	Read/Write	Decimal	No
[-] BIT.3			BOOL	0	Reset Bit	Read/Write	Decimal	No
[-] BIT.4			BOOL	0	Color Hold Bit	Read/Write	Decimal	No
[-] BIT.5			BOOL	0	Finished Retrieve Mode	Read/Write	Decimal	No
[-] BNOT_01			FBD_BOOLE AN_NOT	{...}		Read/Write		No
[-] BNOT_02			FBD_BOOLE AN_NOT	{...}		Read/Write		No
[-] BOR_01			FBD_BOOLE AN_OR	{...}		Read/Write		No
[-] BOR_02			FBD_BOOLE AN_OR	{...}		Read/Write		No
[-] BOR_03			FBD_BOOLE AN_OR	{...}		Read/Write		No
[-] BOR_04			FBD_BOOLE AN_OR	{...}		Read/Write		No
[-] BOR_05			FBD_BOOLE AN_OR	{...}		Read/Write		No
[-] CCI01			DINT	32770		Read/Write	Decimal	No
[-] CCI01.0			BOOL	0	Start pushbutton	Read/Write	Decimal	No
[-] CCI01.1			BOOL	1	Stop pushbutton (normally closed)	Read/Write	Decimal	No
[-] CCI01.2			BOOL	0	Store/Retrieve Swtich	Read/Write	Decimal	No
[-] CCI01.3			BOOL	0	Reset pushbutton	Read/Write	Decimal	No
[-] CCI01.4			BOOL	0	Input I6 - Right Next Station Working	Read/Write	Decimal	No
[-] CCO01			DINT	5		Read/Write	Decimal	No
[-] CCO01.0			BOOL	1	Indicator light Start on	Read/Write	Decimal	No
[-] CCO01.1			BOOL	0	Indicator light (Reset)	Read/Write	Decimal	No
[-] CCO01.2			BOOL	1	Ind Light (Q1)	Read/Write	Decimal	No
[-] CCO01.3			BOOL	0	Ind Light (Q2)	Read/Write	Decimal	No

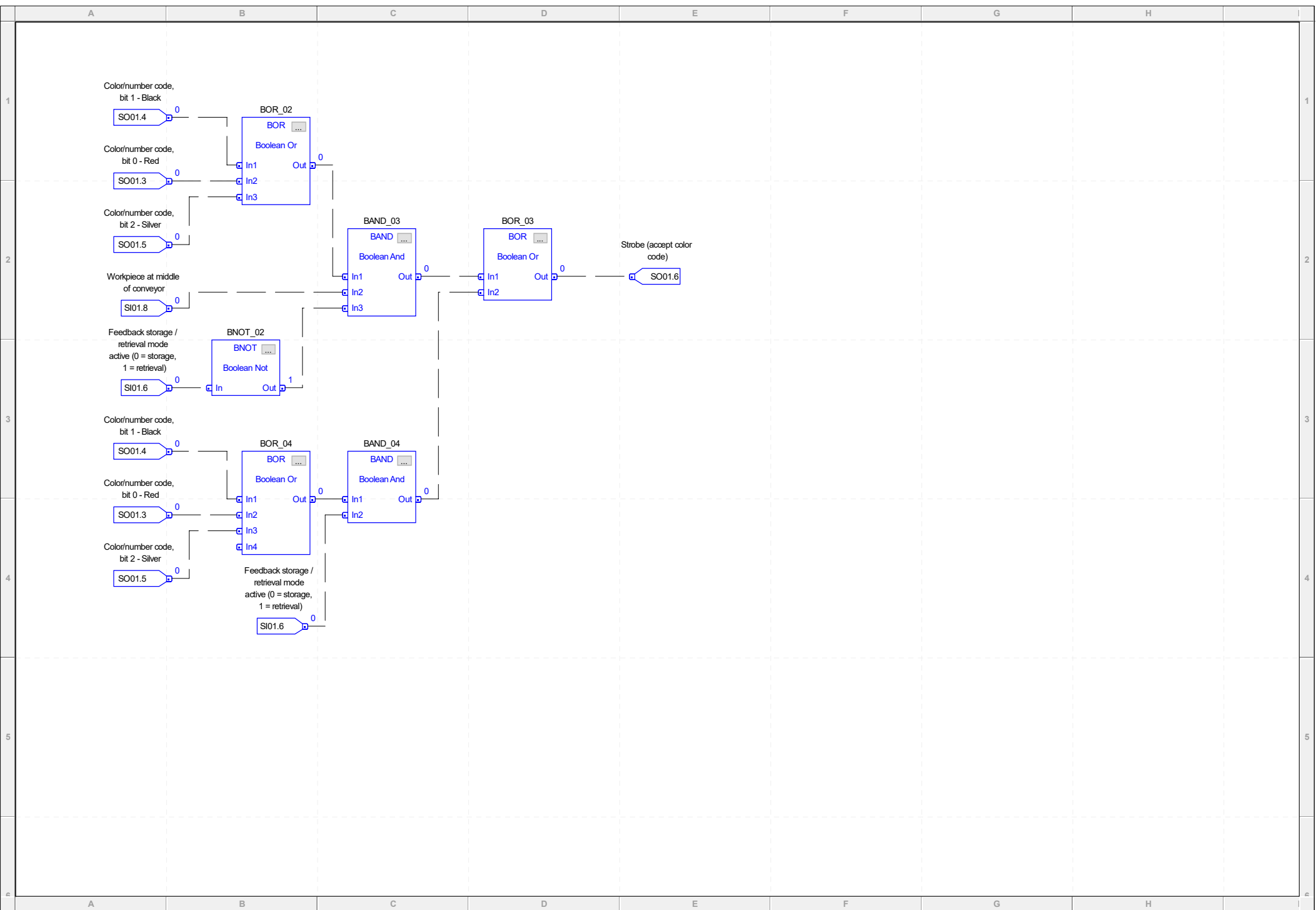
Name	Alias For	Base Tag	Data Type	Value	Description	External Access	Style	Constant
	CCO01.4		BOOL		0 Output (Q4) - Station Working - Left Panel	Read/Write	Decimal	No
	CCO01.5		BOOL		0 Output (Q5) - Left Panel	Read/Write	Decimal	No
	CCO01.6		BOOL		0 Output (Q6) - Left Panel	Read/Write	Decimal	No
	CCO01.7		BOOL		0 Output (Q7) - Right Panel	Read/Write	Decimal	No
[-] ONS			DINT	2		Read/Write	Decimal	No
	ONS.1		BOOL	1	First Time Run Shot	Read/Write	Decimal	No
	ONS.2		BOOL	0	Retrieve Finished Shot	Read/Write	Decimal	No
[-] SI01			DINT	513		Read/Write	Decimal	No
	SI01.0		BOOL	1	Station Homed/ in Initial Position	Read/Write	Decimal	No
	SI01.1		BOOL	0	Error at the Station	Read/Write	Decimal	No
	SI01.2		BOOL	0	Station is Busy	Read/Write	Decimal	No
	SI01.3		BOOL	0	Storage area full / Input error	Read/Write	Decimal	No
	SI01.4		BOOL	0	Station processes work order	Read/Write	Decimal	No
	SI01.5		BOOL	0	Station ready to receive color/number code	Read/Write	Decimal	No
	SI01.6		BOOL	0	Feedback storage / retrieval mode active (0 = storage, 1 = retrieval)	Read/Write	Decimal	No
	SI01.7		BOOL	0	Workpiece at beginning of conveyor	Read/Write	Decimal	No
	SI01.8		BOOL	0	Workpiece at middle of conveyor	Read/Write	Decimal	No
	SI01.9		BOOL	1	No workpiece at end of conveyor	Read/Write	Decimal	No
	SI01.10		BOOL	0	Workpiece detected - Black	Read/Write	Decimal	No
	SI01.11		BOOL	0	Workpiece not black - Red	Read/Write	Decimal	No
	SI01.12		BOOL	0	Workpiece metallic - Silver	Read/Write	Decimal	No
[-] SO01			DINT	256		Read/Write	Decimal	No
	SO01.0		BOOL	0	Home the station	Read/Write	Decimal	No
	SO01.1		BOOL	0	Reset error	Read/Write	Decimal	No
	SO01.2		BOOL	0	Mode 0 = place in storage, Mode 1 = remove from storage	Read/Write	Decimal	No
	SO01.3		BOOL	0	Color/number code, bit 0 - Red	Read/Write	Decimal	No
	SO01.4		BOOL	0	Color/number code, bit 1 - Black	Read/Write	Decimal	No
	SO01.5		BOOL	0	Color/number code, bit 2 - Silver	Read/Write	Decimal	No
	SO01.6		BOOL	0	Strobe (accept color code)	Read/Write	Decimal	No

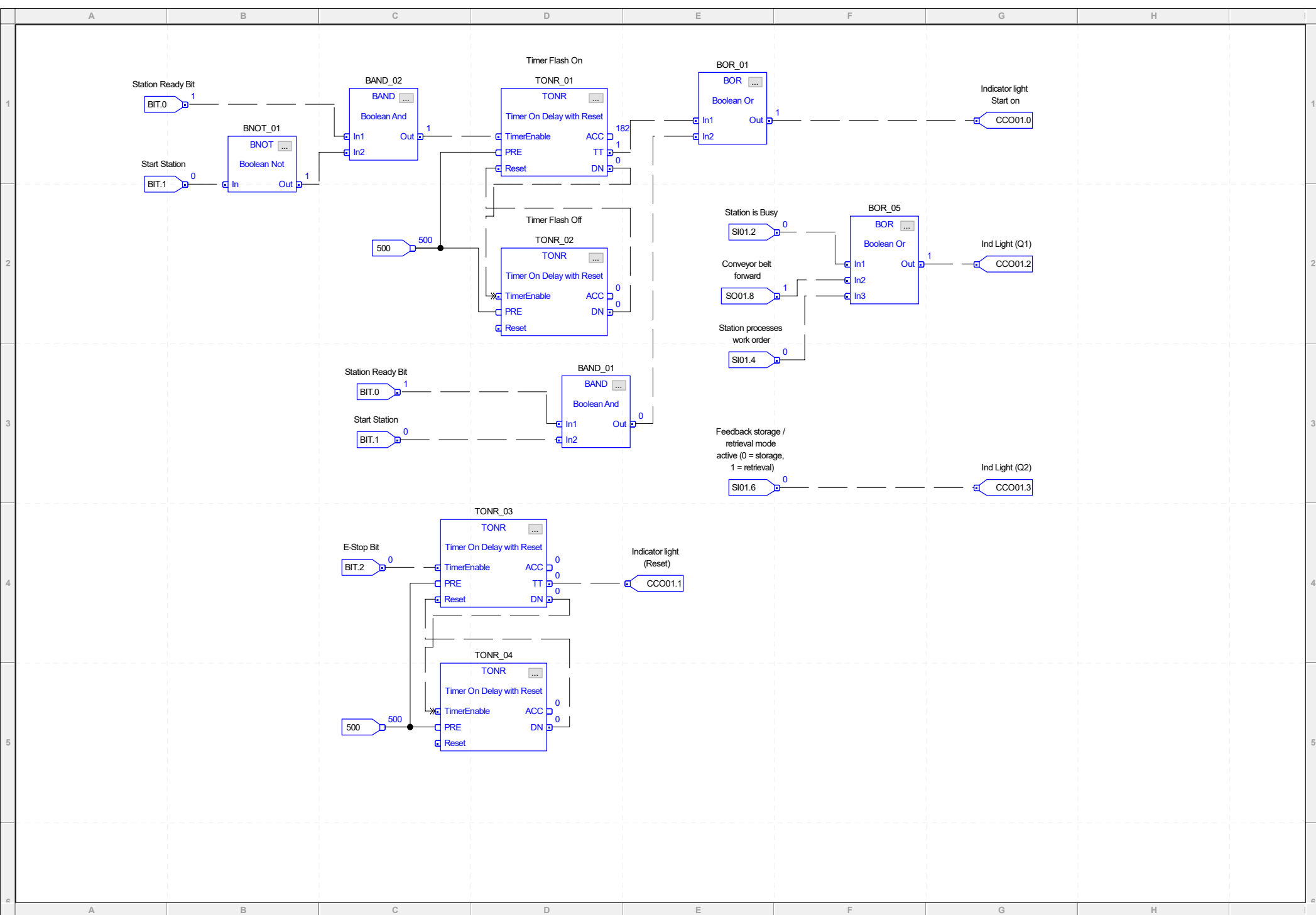
Name	Alias For	Base Tag	Data Type	Value	Description	External Access	Style	Constant
SO01.7 SO01.8 SO01.9			BOOL	0	Enable automatic mode (EnAuto)	Read/Write	Decimal	No
			BOOL	1	Conveyor belt forward	Read/Write	Decimal	No
			BOOL	0	Conveyor belt in reverse	Read/Write	Decimal	No
TIMER_BLACK			TIMER	{...}		Read/Write		No
TIMER_CAP			TIMER	{...}	Timer to Release Cap	Read/Write		No
TIMER_RED			TIMER	{...}		Read/Write		No
TIMER_SILVER			TIMER	{...}		Read/Write		No
TONR_01			FBD_TIMER	{...}	Timer Flash On	Read/Write		No
TONR_02			FBD_TIMER	{...}	Timer Flash Off	Read/Write		No
TONR_03			FBD_TIMER	{...}		Read/Write		No
TONR_04			FBD_TIMER	{...}		Read/Write		No

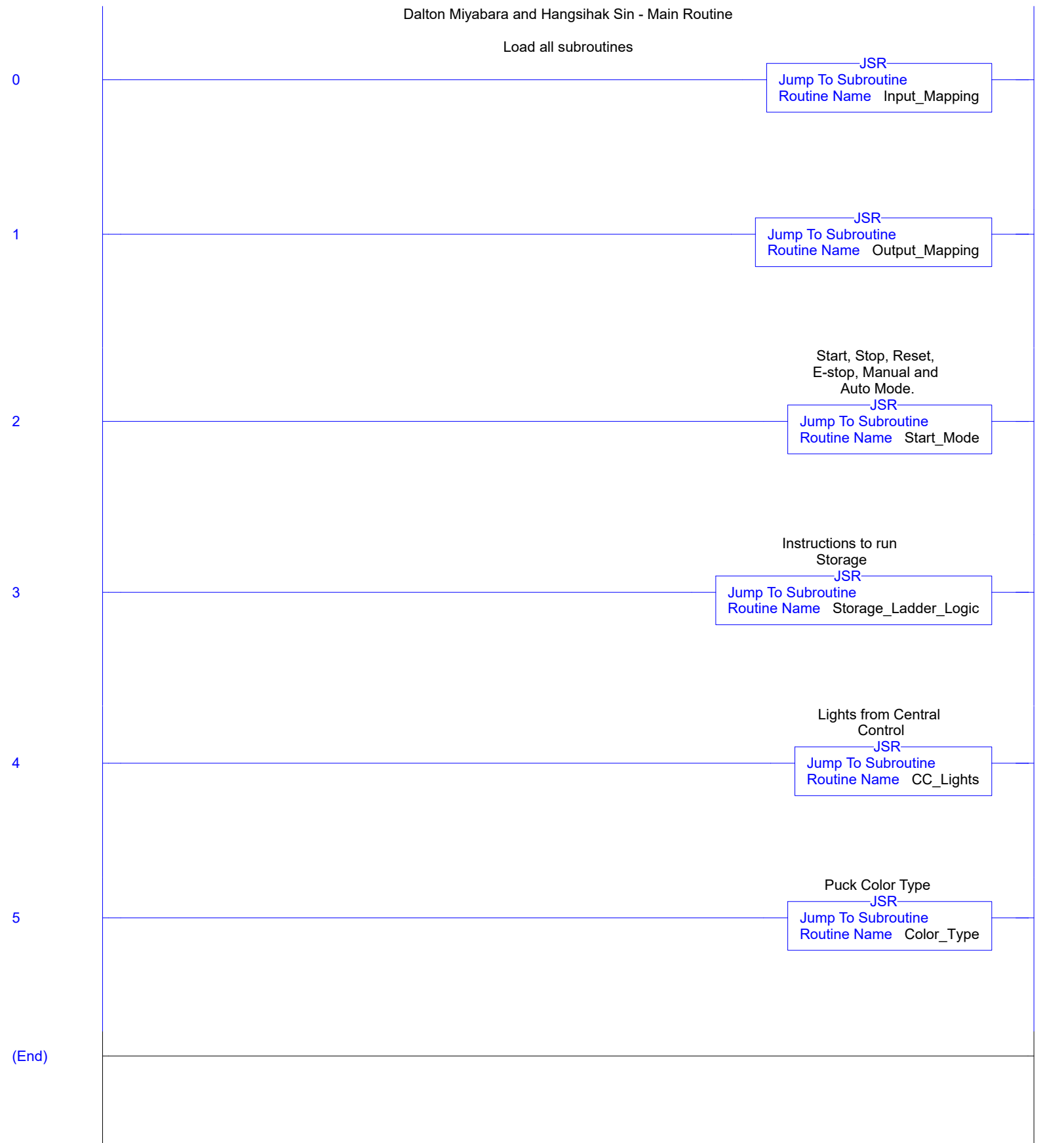




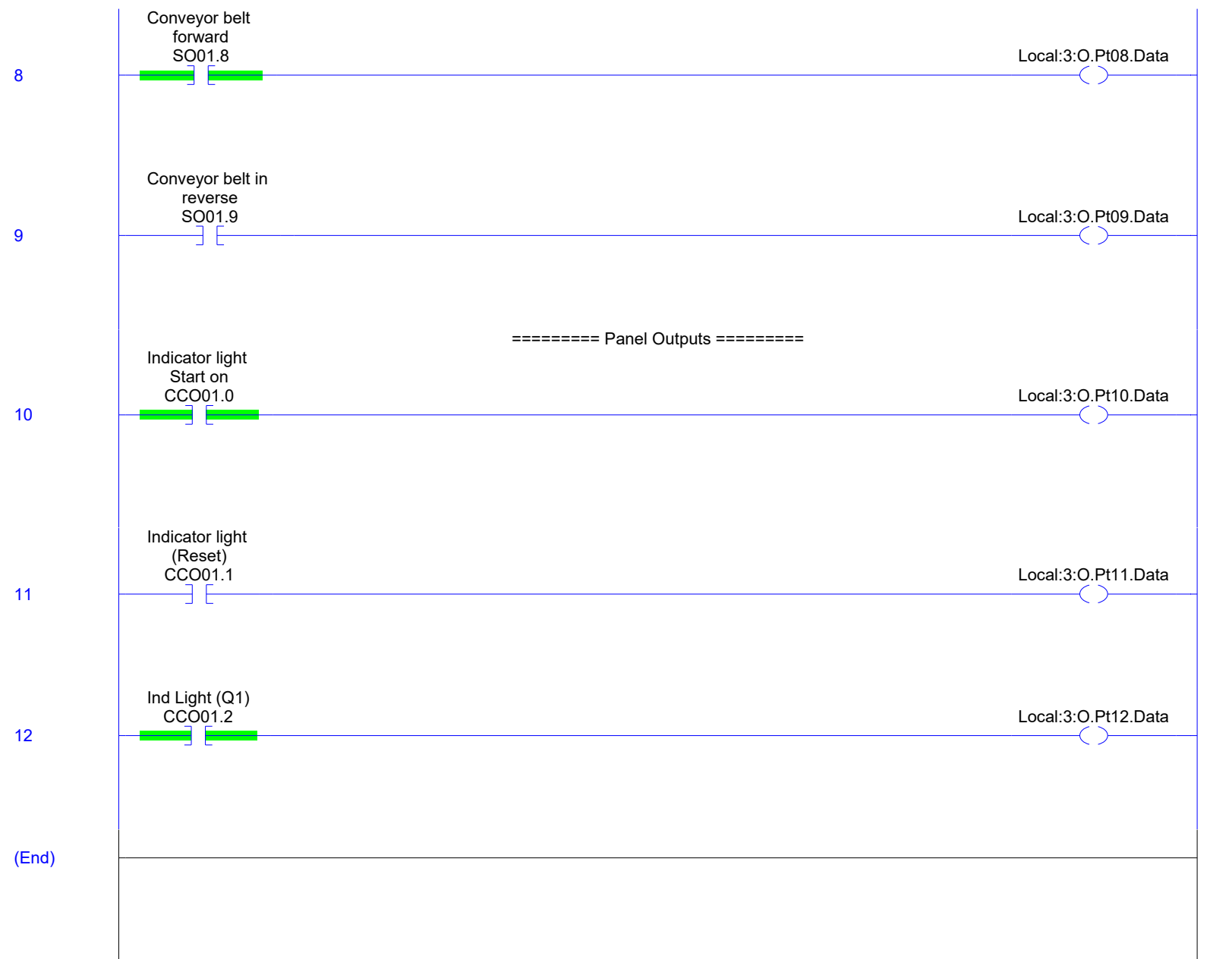


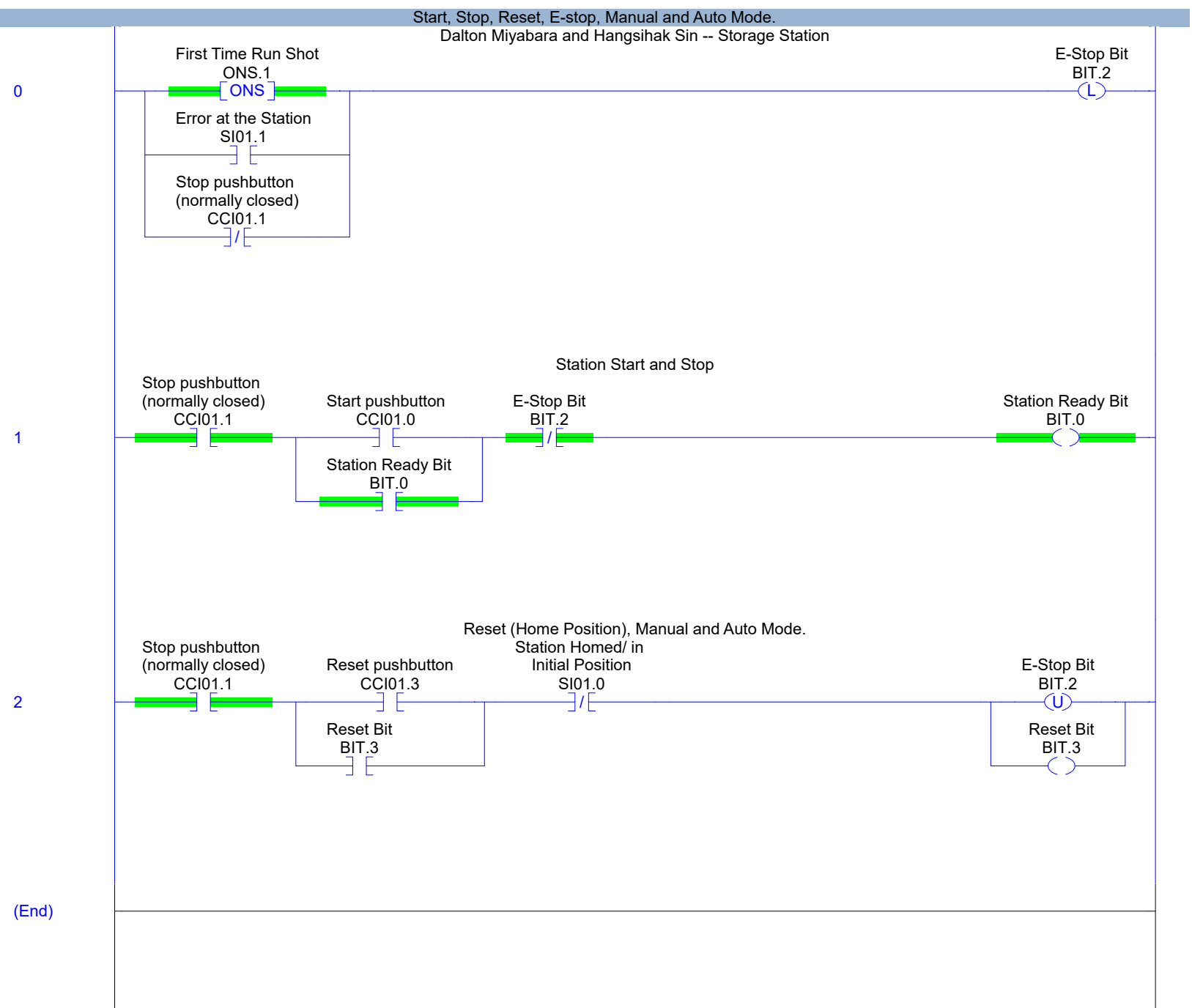


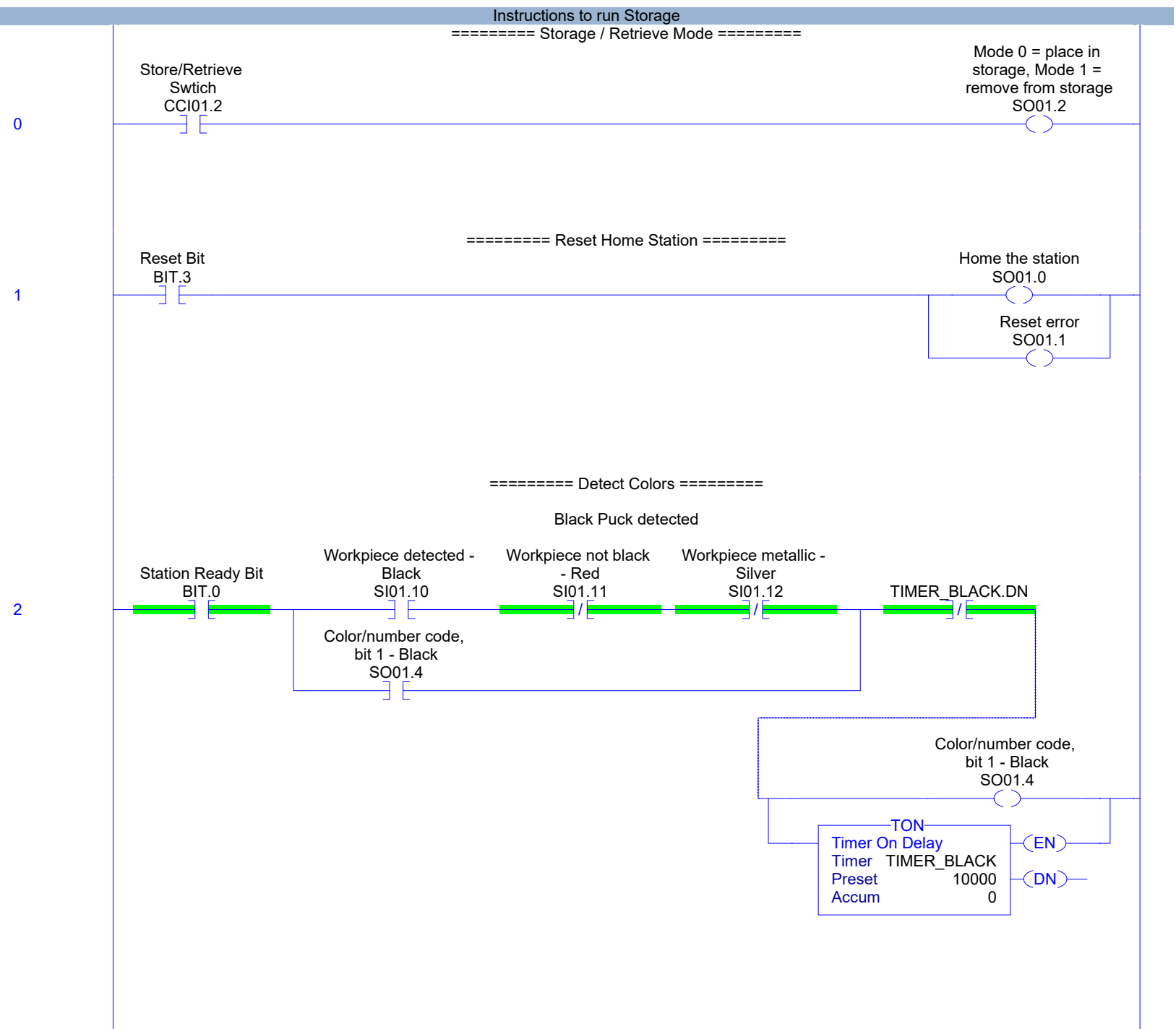


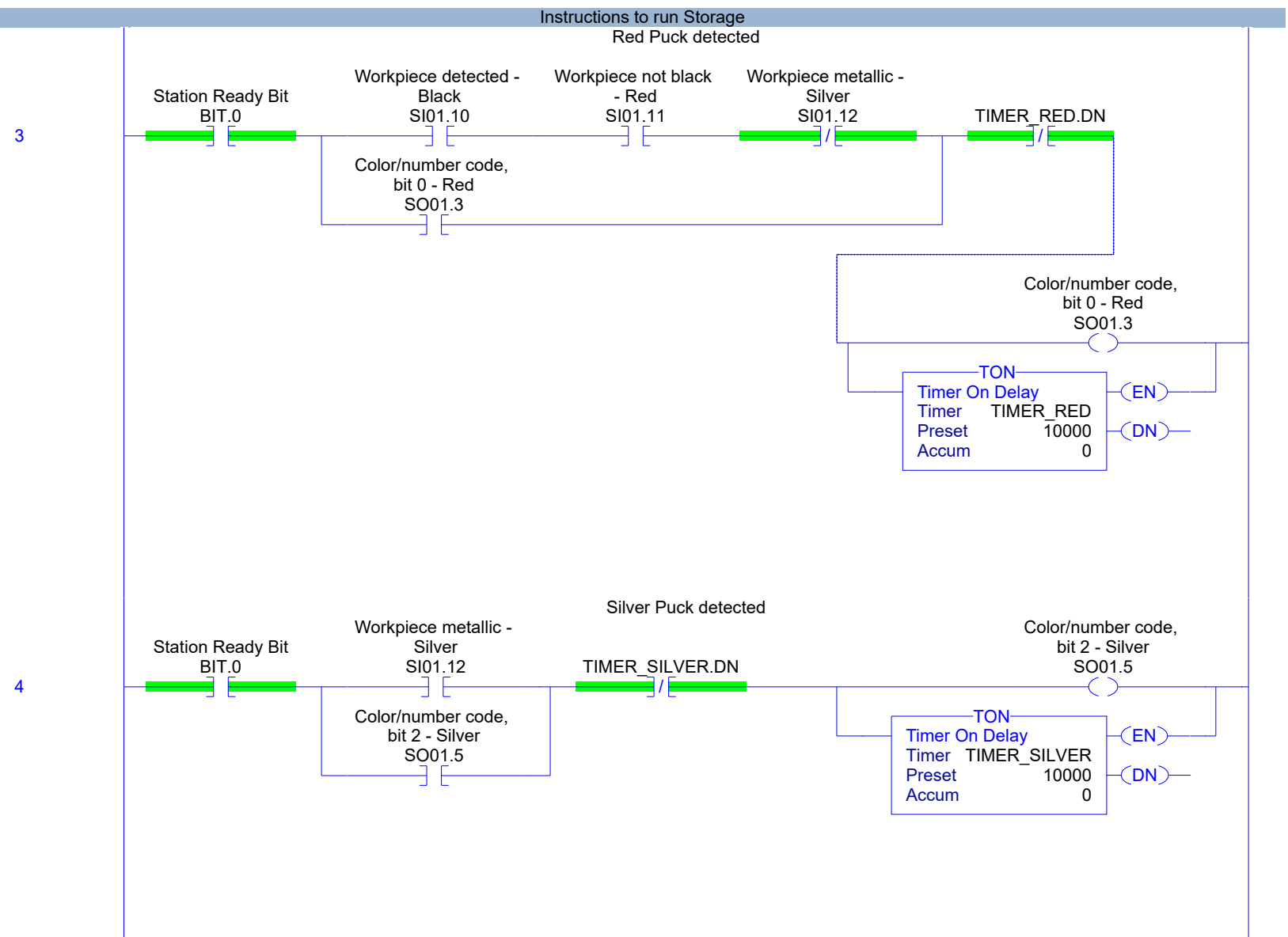


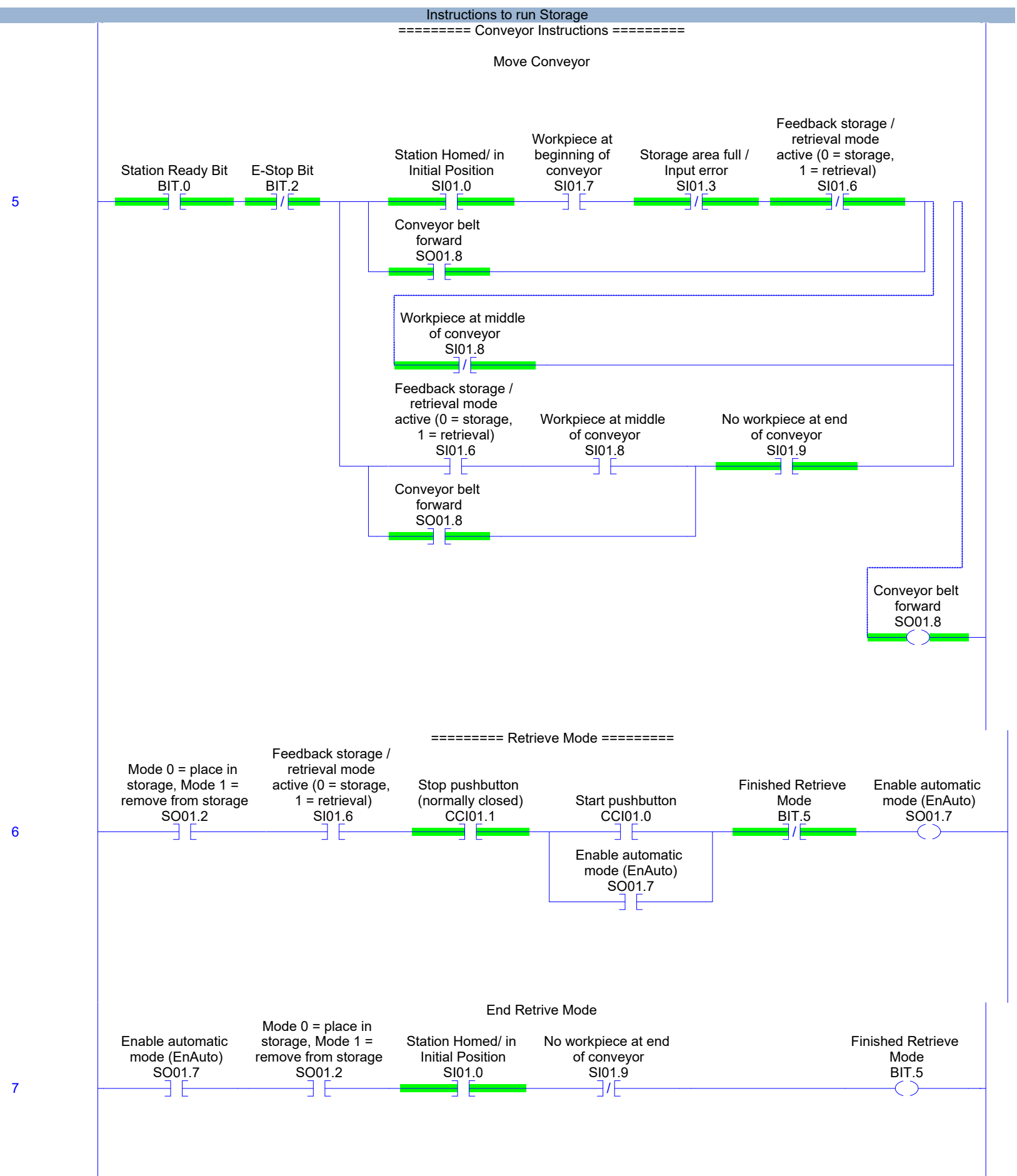












Instructions to run Storage	
(End)	