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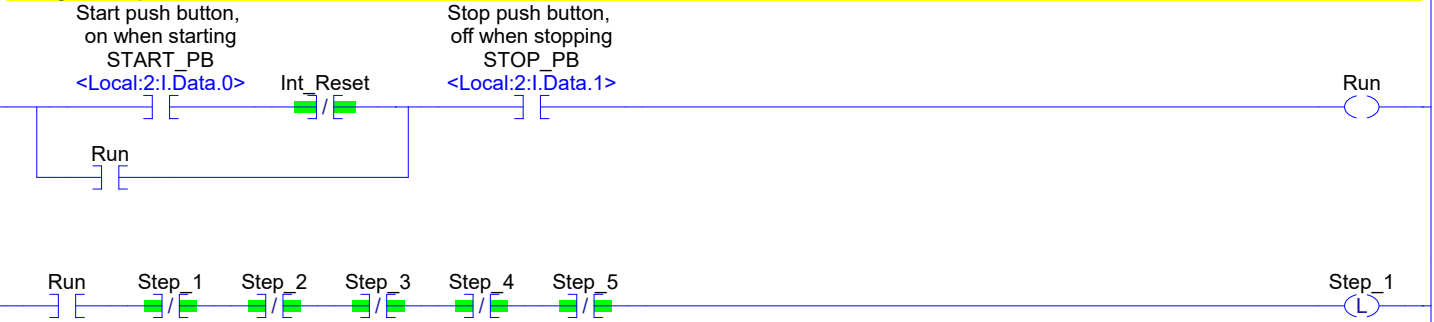
Transfer Station Control

Additional internal memory:

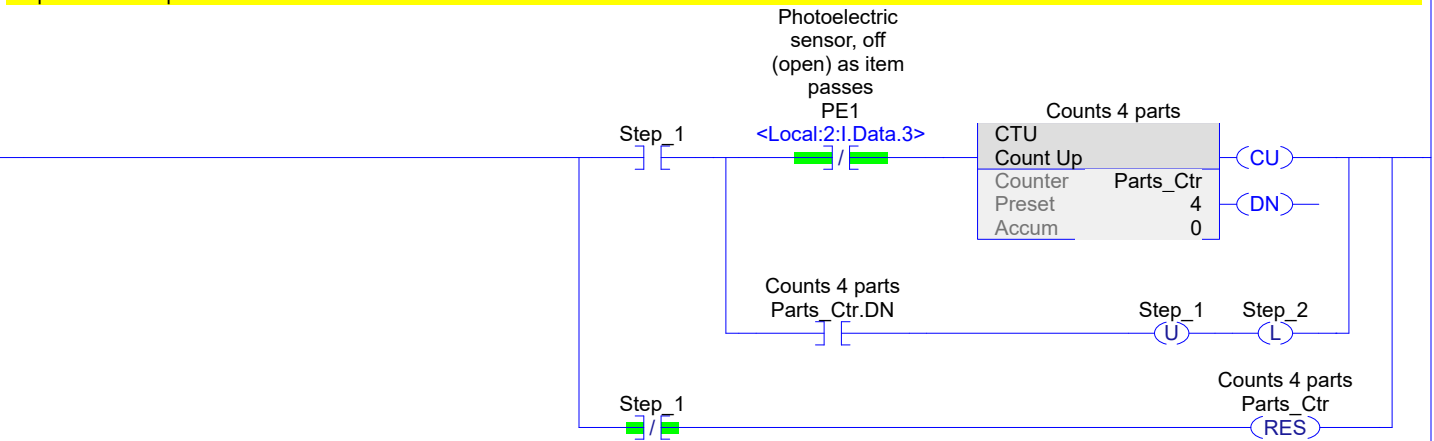
Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_5	BOOL	Step-in-progress bits
Raise_Tmr	TIMER	Times moving up
Parts_Ctr	COUNTER	Counts parts

Start/stop and initial start.

During restart prevent start.



Step 1 Wait for 4 parts



Step 2 Move up

