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## Bolt Driving Station Control

Additional internal memory:

Tag	Data Type	
Run	BOOL	On while station running
Int_Reset	BOOL	Internal reset
Step_1 to Step_11	BOOL	Step-in-progress bits
In_Tmr	TIMER	Times engage cyl for bringing in pallet
Raise_Tmr	TIMER	Times raise of pallet
Push_Tmr	TIMER	Times push of bolts
Motor_Tmr	TIMER	Times air motor rotation
Lower_Tmr	TIMER	Times lower of pallet
Out_Tmr	TIMER	Times engage cyl for allowing out pallet

Start/stop and initial start. During reset, prevent start









