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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.





