

```

    <?xml version="1.0" ?>
- <Data>
- <CTL_ORDERS>
- <!--
  There can be multiple Order entries
  -->
- <Order Order_Number="XXXXXXXXXXXXXXXXXXXXXXX" Order_Action="X">
- <!--
  Order number is a required entry
  -->
- <!--
  Character 20
  -->
- <!--
  Order action is a required entry
  -->
- <!--
  Character 1
  -->
- <!--
  A = Add
  -->
- <!--
  C = Change
  -->
- <!--
  D = Delete no recall
  -->
- <!--
  Q = Sequence
  -->
- <!--
  R = Recall, delete, and return
  -->
- <!--
  X = Recall and delete
  -->
<Work_Order>XXXXXXXXXXXXXXXXXXXXXXX</Work_Order>
- <!--
  Character 20
  -->
- <Customer>
- <!--
  If a customer code is provided, the optional customer elements can be
  populated
  -->
- <!--
  here for each order or once in the CUSTOMERS section
  -->
<Customer_Code>XXXXXXXXXXXX</Customer_Code>
- <!--
  Character 11

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- <!--
  Character 12
  -->
  </Routing>
- <Scheduling>
<Required_Date>9999-99-99</Required_Date>
- <!--
  CCYY-MM-DD format
  -->
<Schedule_Date>9999-99-99</Schedule_Date>
- <!--
  CCYY-MM-DD format
  -->
<Hold_Status>X</Hold_Status>
- <!--
  Character 1
  -->
- <!--
  T if true or F if false
  -->
  </Scheduling>
- <Order_User_Data>
<Order_User1>XXXXXXXXXX . . . XXXXX</Order_User1>
- <!--
  Character 250
  -->
<Order_User2>XXXXXXXXXX . . . XXXXX</Order_User2>
- <!--
  Character 250
  -->
<Order_User3>XXXXXXXXXX . . . XXXXX</Order_User3>
- <!--
  Character 250
  -->
<Order_User4>XXXXXXXXXX . . . XXXXX</Order_User4>
- <!--
  Character 250
  -->
<Order_User5>XXXXXXXXXX . . . XXXXX</Order_User5>
- <!--
  Character 250
  -->
  </Order_User_Data>
- <Order_Based_Marking>
- <!--
  use either format names or print commands not both
  -->
<Tag_Format_Name_O>XXXXXXXXXXXXXXXX</Tag_Format_Name_O>
- <!--
  Character 12
  -->
<Part_Format_Name_O>XXXXXXXXXXXXXXXX</Part_Format_Name_O>

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- <!--
  Character 12
  -->
<Tag_Print_Command_O>XXXXXXXXXX . . . XXXXX</Tag_Print_Command_O>
- <!--
  Character 250
  -->
<Part_Print_Command_O>XXXXXXXXXX . . . XXXXX</Part_Print_Command_O>
- <!--
  Character 250
  -->
  </Order_Based_Marking>
- <Bundles>
- <!--
  There can be multiple Bundle entries
  -->
- <Bundle Material_Code="XXXXXXXXXXXXXXXXXXXXXXXXXX"
  Product_code="XXXXXXXXXXXXXXXXXXXXXXXXXX" Bundle_Number="999">
- <!--
  Material code is a required entry
  -->
- <!--
  Character 20
  -->
- <!--
  Product code is a required entry
  -->
- <!--
  Character 20
  -->
- <!--
  Bundle number is a required entry
  -->
- <!--
  Character 3
  -->
<Bundle_Code>XXXXXXXXXXXXXXXXXX</Bundle_Code>
- <!--
  Character 15
  -->
- <Material>
- <!--
  The optional material elements can be populated here for each
  -->
- <!--
  bundle or once in the CTL_MATERIAL section
  -->
<Gauge>99</Gauge>
<Thickness>9.9999</Thickness>
<Coil_Width>99.999</Coil_Width>
<Color>XXXXXXXXXXXXXXXXXXXXXXXXXX</Color>
- <!--

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<Leg_Height>9999.999</Leg_Height>
- <Hole_Count Mode="X" Hole_Spacing="9999.999" Calculate_Length="X">
- <!--
  Mode is T if true or F if false
  -->
- <!--
  Character 1
  -->
- <!--
  The remaining Hole Count entries required if hole count mode is T
  -->
- <!--
  Calculate_Length is T if true or F if false
  -->
- <!--
  Character 1
  -->
  </Hole_Count>
  </Product_Profile>
- <Bundle_User_Data>
<Bundle_User1>XXXXXXXXXX . . . XXXXXX</Bundle_User1>
- <!--
  Character 250
  -->
<Bundle_User2>XXXXXXXXXX . . . XXXXXX</Bundle_User2>
- <!--
  Character 250
  -->
<Bundle_User3>XXXXXXXXXX . . . XXXXXX</Bundle_User3>
- <!--
  Character 250
  -->
<Bundle_User4>XXXXXXXXXX . . . XXXXXX</Bundle_User4>
- <!--
  Character 250
  -->
<Bundle_User5>XXXXXXXXXX . . . XXXXXX</Bundle_User5>
- <!--
  Character 250
  -->
  </Bundle_User_Data>
- <Bundle_Based_Marking>
- <!--
  use either format names or print commands not both
  -->
<Tag_Format_Name_B>XXXXXXXXXXXXXXXX</Tag_Format_Name_B>
- <!--
  Character 12
  -->
<Part_Format_Name_B>XXXXXXXXXXXXXXXX</Part_Format_Name_B>
- <!--
  Character 12

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-->
<Tag_Print_Command_B>XXXXXXXXXX . . . XXXXXX</Tag_Print_Command_B>
- <!--
  Character 250
  -->
<Part_Print_Command_B>XXXXXXXXXX . . . XXXXXX</Part_Print_Command_B>
- <!--
  Character 250
  -->
  </Bundle_Based_Marking>
- <Items>
- <!--
  There can be multiple Item entries
  -->
- <Item Item_ID="XXXXXXXXXXXXXXXXXXXXXXXXXX" Item_Action="X" Quantity="9999"
  Length="9999.999">
- <!--
  Item ID is a required entry
  -->
- <!--
  Character 22
  -->
- <!--
  Item action is a required entry
  -->
- <!--
  Character 1
  -->
- <!--
  A = Add
  -->
- <!--
  C = Change
  -->
- <!--
  D = Delete
  -->
- <!--
  Quantity is a required entry
  -->
- <!--
  Length is a required entry
  -->
<Hole_Count>9999</Hole_Count>
- <!--
  Hole count is required if hole count mode of
  -->
- <!--
  product profile is T
  -->
<Hole_Offset>9999.999</Hole_Offset>
- <!--

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Part number is required if punching to be performed
-->
- <!--
Character 30
-->
- <!--
Part option is required if punching to be performed
-->
- <!--
Character 1
-->
- <!--
R = Right
-->
- <!--
L = Left
-->
- <!--
A = Alternate
-->
- <!--
M = Mirrored
-->
<Part_Length>9999.999</Part_Length>
- <Punches>
- <!--
The punches elements can be populated here for each
-->
- <!--
item or once in the CTL_PUNCHING section
-->
- <!--
Punches are required if punching to be performed
-->
- <!--
There can be multiple Punch entries
-->
- <Punch Shape_or_Macro="X" Shape_Macro_Name="XXXXXXXXXXXXXXXXXXXXX"
X_Coordinate="9999.999" X_Reference="XX" Y_Coordinate="9999.999"
Y_Reference="XX" Diameter_Length="9999.999" Width="9999.999">
- <!--
Shape_or_Macro is S if SHAPE or M if MACRO
-->
- <!--
Character 1
-->
- <!--
Shape name or macro name is required
-->
- <!--
Character 20
-->

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```
- <!--  
  X Coordinate is required  
  -->  
- <!--  
  X Reference is required  
  -->  
- <!--  
  Character 2  
  -->  
- <!--  
  LE = Leading Edge  
  -->  
- <!--  
  TE = Trailing Edge  
  -->  
- <!--  
  LC = Leading Center  
  -->  
- <!--  
  TC = Trailing Center  
  -->  
- <!--  
  ES = Even Spacing  
  -->  
- <!--  
  SL = Spacing Limit  
  -->  
- <!--  
  KA = Kerf Adjustment  
  -->  
- <!--  
  Y Coordinate is required  
  -->  
- <!--  
  Y Reference is required  
  -->  
- <!--  
  Character 2  
  -->  
- <!--  
  CP = Center Plus  
  -->  
- <!--  
  CM = Center Minus  
  -->  
- <!--  
  PE = Plus Edge  
  -->  
- <!--  
  ME = Minus Edge  
  -->  
- <!--  
  shape elements are required to define shape
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-->
- <!--
  Diameter or length and width are required
-->
- <!--
  if not a macro
-->
  </Punch>
  </Punches>
  </Punching>
  </Item>
  </Items>
  </Bundle>
  </Bundles>
  </Order>
  </CTL_ORDERS>
- <CTL_MATERIALS>
- <!--
  There can be multiple Material entries
-->
- <MATERIAL MATL_ACTION="X" MATERIAL_CODE="XXXXXXXXXXXXXXXXXXXXX">
- <!--
  Matl Action is a required entry
-->
- <!--
  Character 1
-->
- <!--
  A = Add
-->
- <!--
  C = Change leave all unchanged fields blank
-->
- <!--
  D = Delete
-->
- <!--
  Material code is a required entry
-->
- <!--
  Character 20
-->
<GAUGE>99</GAUGE>
<THICKNESS>9.9999</THICKNESS>
<COIL_WIDTH>99.999</COIL_WIDTH>
<COLOR>XXXXXXXXXXXXXXXXXXXXX</COLOR>
- <!--
  Character 20
-->
<TYPE>XXXXXXXXXX</TYPE>
- <!--
  Character 10

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-->
<COVER>999.999</COVER>

  <MATL_DESCRIPTION>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX
  </MATL_DESCRIPTION>
- <!--
  Character 40
  -->
<LBS_PER_FT>999.9999</LBS_PER_FT>
<COST_PER_LB>99999.999</COST_PER_LB>
<NORMAL_LENGTH>99999.999</NORMAL_LENGTH>
- <!--
  Average length of a coil of this material
  -->
<REORDER>999999</REORDER>
- <!--
  Minimum desired inventory of this material to be maintained
  -->
  </MATERIAL>
  </CTL_MATERIALS>
- <CTL_PRODUCTS>
- <!--
  There can be multiple Product Profile entries
  -->
- <PRODUCT_PROFILE PRD_ACTION="X"
  PRODUCT_CODE="XXXXXXXXXXXXXXXXXXXX" COMM_GROUP="9"
  MACHINE_ID="99">
- <!--
  PRD Action is a required entry
  -->
- <!--
  Character 1
  -->
- <!--
  A = Add
  -->
- <!--
  C = Change leave all unchanged fields blank
  -->
- <!--
  D = Delete
  -->
- <!--
  Product code is a required entry
  -->
- <!--
  Character 20
  -->
- <!--
  COMM Group is a required entry default is 0
  -->
- <!--

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Character 1
-->
- <!--
Machine ID is a required entry
-->
- <!--
Character 2
-->
<PRODUCT_GROUP>XXXXXXXXXXXXXXXXXX</PRODUCT_GROUP>
- <!--
Character 15
-->
<PREFERRED_MACHINE>X</PREFERRED_MACHINE>
- <!--
T if true or F if false
-->
- <!--
Character 1
-->
<DESCRIPTION>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</DESCRIPTION>
- <!--
Character 30
-->
<FINISHED_WIDTH>9999.999</FINISHED_WIDTH>
<LEG_HEIGHT>9999.999</LEG_HEIGHT>
- <HOLE_COUNT MODE="X" HOLE_SPACING="9999.999" CALCULATE_LENGTH="X">
- <!--
Mode is T if true or F if false
-->
- <!--
Character 1
-->
- <!--
The remaining Hole Count entries required if hole count mode is T
-->
- <!--
Calculate_Length is T if true or F if false
-->
- <!--
Character 1
-->
</HOLE_COUNT>
</PRODUCT_PROFILE>
</CTL_PRODUCTS>
- <CUSTOMERS>
- <!--
There can be multiple Customer entries
-->
- <CUSTOMER ACTION="X" CUSTOMER_CODE="XXXXXXXXXXXX"
CUSTOMER_NAME="XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX">
- <!--
Action is a required entry

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- <!--
  Character 30
  -->
<EMAIL>XXXXXXXXXX . . . XXXXX</EMAIL>
- <!--
  Character 250
  -->
<INSTRUCTIONS>XXXXXXXXXX . . . XXXXX</INSTRUCTIONS>
- <!--
  Character 250
  -->
  </CUSTOMER>
  </CUSTOMERS>
- <CTL_PUNCHING>
- <!--
  There can be multiple Punching entries
  -->
- <PUNCHING PART_NUMBER="XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX"
  PRODUCT_GROUP="XXXXXXXXXXXXXXXXXX" PART_OPTION="X">
- <!--
  Part number is required
  -->
- <!--
  Character 30
  -->
- <!--
  Part option is required
  -->
- <!--
  Character 1
  -->
- <!--
  R = Right
  -->
- <!--
  L = Left
  -->
- <!--
  A = Alternate
  -->
- <!--
  M = Mirrored
  -->
- <!--
  Product Group is required
  -->
<PART_LENGTH>9999.999</PART_LENGTH>
- <PUNCHES>
- <!--
  Punches are required
  -->
- <!--

```

There can be multiple Punch entries

```
-->
- <PUNCH SHAPE_OR_MACRO="X"
  SHAPE_MACRO_NAME="XXXXXXXXXXXXXXXXXXXXX"
  X_COORDINATE="9999.999" X_REFERENCE="XX" Y_COORDINATE="9999.999"
  Y_REFERENCE="XX" DIAMETER_LENGTH="9999.999" WIDTH="9999.999">
- <!--
  Shape_or_Macro is S if SHAPE or M if MACRO
  -->
- <!--
  Character 1
  -->
- <!--
  Shape name or macro name is required
  -->
- <!--
  Character 20
  -->
- <!--
  X Coordinate is required
  -->
- <!--
  X Reference is required
  -->
- <!--
  Character 2
  -->
- <!--
  LE = Leading Edge
  -->
- <!--
  TE = Trailing Edge
  -->
- <!--
  LC = Leading Center
  -->
- <!--
  TC = Trailing Center
  -->
- <!--
  ES = Even Spacing
  -->
- <!--
  SL = Spacing Limit
  -->
- <!--
  KA = Kerf Adjustment
  -->
- <!--
  Y Coordinate is required
  -->
- <!--
  Y Reference is required
```



```

-->
- <!--
Character 2
-->
- <!--
CP = Center Plus
-->
- <!--
CM = Center Minus
-->
- <!--
PE = Plus Edge
-->
- <!--
ME = Minus Edge
-->
- <!--
Diameter or length and width are required to define shape
-->
</PUNCH>
</PUNCHES>
</PUNCHING>
</CTL_PUNCHING>
- <COILS>
- <!--
There can be multiple Coil entries
-->
- <COIL coil_action="X" Coil_Number="XXXXXXXXXXXXXXXXXXXX"
material_code="XXXXXXXXXXXXXXXXXXXX" Status="X">
- <!--
Coil Action is required
-->
- <!--
Character 1
-->
- <!--
A = Add
-->
- <!--
C = Change leave all unchanged fields blank
-->
- <!--
D = Delete
-->
- <!--
Coil number is required
-->
- <!--
Character 16
-->
- <!--
Material code is required

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```
-->
<reorder>999999</reorder>
- <!--
  Minimum desired inventory of this material to be maintained
  -->
  </material>
<Heat_Number>XXXXXXXXXXXXXXXXXXXX</Heat_Number>
- <!--
  Character 20
  -->
<Supplier_Code>XXXXXXXXXXXXXXXX</Supplier_Code>
- <!--
  Character 16
  -->
<Supplier_Name>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</Supplier_Name>
- <!--
  Character 30
  -->
<PO_Number>XXXXXXXXXX</PO_Number>
- <!--
  Character 10
  -->
<Date_In>99/99/9999</Date_In>
<Date_Out>99/99/9999</Date_Out>
<Start_Length>99999.999</Start_Length>
<Start_Weight>99999.9999</Start_Weight>
<NonExempt_Scrap>99999.999</NonExempt_Scrap>
<Exempt_Scrap>99999.999</Exempt_Scrap>
<Other_Adjustments>99999.999</Other_Adjustments>
  </COIL>
  </COILS>
</Data>
```