<?xml version="1.0" ?>

- <Data>
  - <CTL_ORDERS>
    - <!--
        There can be multiple Order entries
        -->
    - <Order Order_Number="XXXXXXXXXXXXXXXXXXXX" 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>XXXXXXXXXXXXXXXXXXXX</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
        -->
<Customer_Name>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</Customer_Name>
- <!--
  Character 30
  -->
<Address1>XXXXXXXXX . . . XXXXX</Address1>
- <!--
  Character 250
  -->
<Address2>XXXXXXXXX . . . XXXXX</Address2>
- <!--
  Character 250
  -->
<City>XXXXXXXXX . . . XXXXX</City>
- <!--
  Character 250
  -->
<State>XX</State>
- <!--
  Character 2
  -->
<Zip>XXXXXXXXXXXX</Zip>
- <!--
  Character 10
  -->
<Country>XXX</Country>
- <!--
  Character 3
  -->
<Delivery_Phone>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</Delivery_Phone>
- <!--
  Character 30
  -->
<Email>XXXXXXXXX . . . XXXXX</Email>
- <!--
  Character 250
  -->
<Instructions>XXXXXXXXX . . . XXXXX</Instructions>
- <!--
  Character 250
  -->
  </Customer>
- <Routing>
  <Staging_Bay>XXXXXXXXXXXX</Staging_Bay>
  - <!--
    Character 10
    -->
  <Loading_Dock>XXXXXXXXXXXX</Loading_Dock>
  - <!--
    Character 10
    -->
  <Truck_Number>XXXXXXXXXXXX</Truck_Number>
- <!-- Character 12
  -->
  </Routing>
- <Scheduling>
  <Required_Date>9999-99-99</Required_Date>
  - <!-- CCYY-MM-DD format
  -->
  </Required_Date>
- <Schedule_Date>9999-99-99</Schedule_Date>
  - <!-- CCYY-MM-DD format
  -->
  </Schedule_Date>
  - <!-- CCYY-MM-DD format
  -->
  </Hold_Status>
  - <!-- Character 1
  -->
  </Hold_Status>
  - <!-- T if true or F if false
  -->
  </Scheduling>
- <Order_User_Data>
  <Order_User1>XXXXXXXXX . . . XXXXX</Order_User1>
  - <!-- Character 250
  -->
  </Order_User1>
  <Order_User2>XXXXXXXXX . . . XXXXX</Order_User2>
  - <!-- Character 250
  -->
  </Order_User2>
  <Order_User3>XXXXXXXXX . . . XXXXX</Order_User3>
  - <!-- Character 250
  -->
  </Order_User3>
  <Order_User4>XXXXXXXXX . . . XXXXX</Order_User4>
  - <!-- Character 250
  -->
  </Order_User4>
  <Order_User5>XXXXXXXXX . . . XXXXX</Order_User5>
  - <!-- Character 250
  -->
  </Order_User5>
  </Order_User_Data>
- <Order_Based_Marking>
  - <!-- use either format names or print commands not both
  -->
  </Order_Based_Marking>
  <Tag_Format_Name_O>XXXXXXXXXXXX</Tag_Format_Name_O>
  - <!-- Character 12
  -->
  </Tag_Format_Name_O>
  <Part_Format_Name_O>XXXXXXXXXXXX</Part_Format_Name_O>
- <!-- Character 12 -->
  <Tag_Print_Command_O>XXXXXXXXX . . . XXXXX</Tag_Print_Command_O>
- <!-- Character 250 -->
  <Part_Print_Command_O>XXXXXXXXX . . . XXXXX</Part_Print_Command_O>
- <!-- Character 250 -->
  </Order_Based_Marking>
- <Bundles>
  - <!-- There can be multiple Bundle entries -->
  - <!-- Material code is a required entry -->
    - <!-- Product code is a required entry -->
      - <!-- Bundle number is a required entry -->
        - <!-- Character 15 -->
          <Bundle_Code>XXXXXXXXXXXXXXXXXXXX</Bundle_Code>
- <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>XXXXXXXXXXXXXXXXXXXX</Color>
- <!-- Character 15 -->
<Type>XXXXXXXXXX</Type>
- <!--
Character 10
-->
<Cover>999.999</Cover>
  <Matl_Description>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</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>
- <Product_Profile COMM_Group="9" Machine_ID="99">
  - <!--
The optional product profile elements can be populated here for each
-->
  - <!--
bundle or once in the CTL PRODUCTS section
-->
  - <!--
COMM_Group is a required entry default is 0
-->
  - <!--
Character 1
-->
  - <!--
Machine_ID is a required entry
-->
  - <!--
Character 2
-->
<Product_Group>XXXXXXXXXXXXXXXXX</Product_Group>
  - <!--
Character 15
-->
<Description>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</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
  -->  
  - <!--
    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>XXXXXXXXX . . . XXXXX</Bundle_User1>
  - <!--
    Character 250
  -->
  <Bundle_User2>XXXXXXXXX . . . XXXXX</Bundle_User2>
  - <!--
    Character 250
  -->
  <Bundle_User3>XXXXXXXXX . . . XXXXX</Bundle_User3>
  - <!--
    Character 250
  -->
  <Bundle_User4>XXXXXXXXX . . . XXXXX</Bundle_User4>
  - <!--
    Character 250
  -->
  <Bundle_User5>XXXXXXXXX . . . XXXXX</Bundle_User5>
  - <!--
    Character 250
  -->
</Bundle_User_Data>
- <Bundle_Based_Marking>
  - <!--
    use either format names or print commands not both
  -->
  <Tag_Format_Name_B>XXXXXXXXXXXX</Tag_Format_Name_B>
  - <!--
    Character 12
  -->
  <Part_Format_Name_B>XXXXXXXXXXXX</Part_Format_Name_B>
  - <!--
    Character 12
  -->
<Tag_Print_Command_B>
  XXXXXXXXXXX . . . XXXXX</Tag_Print_Command_B>
- <!--
  Character 250
-->

<Part_Print_Command_B>
  XXXXXXXXXXX . . . XXXXX</Part_Print_Command_B>
- <!--
  Character 250
-->
  </Bundle_Based_Marking>
- <Items>
  - <!--
    There can be multiple Item entries
  -->
  - <Item Item_ID="XXXXXXXXXXXXXXXXXXXXXXXXX" 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>
  - <!--
Hole offset is required if hole count mode is T

<Message>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</Message>

- <!--
  Character 40
-->

- <Item_User_Data>
  <Item_User1>XXXXXXXXXX ... XXXXX</Item_User1>
  - <!--
    Character 250
  -->
  <Item_User2>XXXXXXXXXX ... XXXXX</Item_User2>
  - <!--
    Character 250
  -->
  <Item_User3>XXXXXXXXXX ... XXXXX</Item_User3>
  - <!--
    Character 250
  -->
  <Item_User4>XXXXXXXXXX ... XXXXX</Item_User4>
  - <!--
    Character 250
  -->
  <Item_User5>XXXXXXXXXX ... XXXXX</Item_User5>
  - <!--
    Character 250
  -->
  </Item_User_Data>

- <Item_Based_Marking>
  - <!--
    use either format names or print commands not both
  -->
  <Tag_Format_Name_I>XXXXXXXXXXXX</Tag_Format_Name_I>
  - <!--
    Character 12
  -->
  <Part_Format_Name_I>XXXXXXXXXXXX</Part_Format_Name_I>
  - <!--
    Character 12
  -->
  <Tag_Print_Command_I>XXXXXXXXX ... XXXXX</Tag_Print_Command_I>
  - <!--
    Character 250
  -->
  <Part_Print_Command_I>XXXXXXXXX ... XXXXX</Part_Print_Command_I>
  - <!--
    Character 250
  -->
  </Item_Based_Marking>

- <Punching Part_Number="XXXXXXXXXXXXXXXXXXXXXXXXXXXXXX" Part_Option="X">
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
  -->
  - <!--
    Shape_or_Macro="X" Shape_Macro_Name="XXXXXXXXXXXXXXXXXX"
    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
 -->
- <!--
  shape elements are required to define shape
Diameter or length and width are required

if not a macro

There can be multiple Material entries

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>XXXXXXXXXXXXXXXXXXXX</COLOR>

Character 20

<TYPE>XXXXXXXXXXXX</TYPE>

Character 10
<COVER>999.999</COVER>

 MATL_DESCRIPTION><XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX
 </MATL_DESCRIPTION>
- <!--
 Character 40
 -->
</LBS_PER_FT>999.999</LBS_PER_FT>
</COST_PER_LB>9999.999</COST_PER_LB>
</NORMAL_LENGTH>99999.999</NORMAL_LENGTH>
- <!--
 Average length of a coil of this material
 -->
</REORDER>99999</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
 -->
- <!--
Character 1
--> 
- <!--
Machine ID is a required entry
--> 
- <!--
Character 2
--> 
<PRODUCT_GROUP>XXXXXXXXXXXXXXXXX</PRODUCT_GROUP>
- <!--
Character 15
--> 
<PREFERRED_MACHINE>X</PREFERRED_MACHINE>
- <!--
  T if true or F if false
 -->
- <!--
  Character 1
 -->
<DESCRIPTION>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</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="XXXXXXXXXXXXX" CUSTOMER_NAME="XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX">
- <!--
  Action is a required entry
 -->
- Character 1
- Character 11
- Character 30
- Customer code is a required entry
- Customer name is a required entry
- Character 250
- Character 250
- Character 250
- Character 250
- Character 250
- Character 2
- Character 10
- Character 3
- <ADDRESS1>XXXXXXXXXX . . . XXXXX</ADDRESS1>
- Character 250
- <ADDRESS2>XXXXXXXXXX . . . XXXXX</ADDRESS2>
- Character 250
- <CITY>XXXXXXXXXX . . . XXXXX</CITY>
- Character 250
- <STATE>XX</STATE>
- Character 2
- <ZIP>XXXXXXXXXX</ZIP>
- Character 10
- <COUNTRY>XXX</COUNTRY>
- Character 3
- <DELIVERY_PHONE>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</DELIVERY_PHONE>
- <!--
  Character 30
  -->

<EMAIL>XXXXXXXXX . . . XXXXX</EMAIL>
- <!--
  Character 250
  -->

<INSTRUCTIONS>XXXXXXXXX . . . XXXXX</INSTRUCTIONS>
- <!--
  Character 250
  -->

</CUSTOMER>
</CUSTOMERS>
- <CTL_PUNCHING>
- <!--
  There can be multiple Punching entries
  -->

- <PUNCHING PART_NUMBER="XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX" PRODUCT_GROUP="XXXXXXXXXXXXXXX" PART_OPTION="X">
  - <!--
    Part number is required
    -->
  - <!--
    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
    -->
  - <!--
    Character 1
    -->

  - <!--
    Product Group is required
    -->
There can be multiple Punch entries

- `<PUNCH SHAPE_OR_MACRO="X"
  SHAPE_MACRO_NAME="XXXXXXXXXXXXXXXXXXXXXXXXX"
  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="XXXXXXXXXXXXXXXXXX"
      material_code="XXXXXXXXXXXXXXXXXX" 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
    -->
<reorder>999999</reorder>
-
  Minimum desired inventory of this material to be maintained

<Heat_Number>XXXXXXXXXXXXXXXX</Heat_Number>
-
  Character 20

<Supplier_Code>XXXXXXXXXXXXXXXX</Supplier_Code>
-
  Character 16

<Supplier_Name>XXXXXXXXXXXXXXXXXXXXXXXXXXXXXX</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>99999.999</Start_Weight>
<NonExempt_Scrap>99999.999</NonExempt_Scrap>
<Exempt_Scrap>99999.999</Exempt_Scrap>
<Other_Adjustments>99999.999</Other_Adjustments>
</COIL>
</COILS>
</Data>