Typical 841 To Outside Processor For “Feed-Forward” Information

ISA*00*  "00"  *01*111222333  "01"123456789  
*070131*0223*U'00301*000001137*1'T*  
GS*SP*111222333*123456789*20070131*022314*1137*X*004010  
ST*841*0001  
SPI*00*******00  "MF“ = Mfg Spec  
NTE*DOD*DESCRIPTION OF DAMAGE / COMMENTS  
REF*MA*USS/PRIOR OP BOL#  
DTM*011*SHIP DATE  
N1*MF**1*111222333  
N1*OU**1*123456789  
N1*ST**1*333333333  
N!*SF**1*555666777  
HL*1*1*I*1  (Item Coil/Lift - #1)  (Required)  
SPI*ZZ  
LIN**VO**MILL ORDER #*VN**MILL ORDER ITEM #*HN**HEAT #*SN**MASTER COIL ID*BP*PART #  
MSG*COIL ALREADY REJECTED BY QA  
MSG*CUT OUT DEFECT. SAVE SAMPLE FOR LATER TESTING (Freeform Corrective Action)  
MSG*REVERSE SURFACE – PRIME SIDE OUT  
PID*S**ST*01***67  (Material Classification)  01=Prime  
PID*S**ST*1***68  (Material Status – QA)  1=Ready To Ship, 6=Hold For Test  
PID*S**ST*73***20B  Incoming Coil winding/surface Orientation (73 = Prime Side Down/In  
PID*S**ST*34***22  Edge Designation (34 = Mill Edge)  
MEA*PD**WD*53.7402*ED  
MEA*PD**WD*1365*MM  
MEA*PD**TH*.0606*ED  
MEA*PD**TH*1.54*MM  
MEA*PD**LN*2799*LF  
MEA*PD**LN*833*LM  
MEA*PD**WT*31820*LB  
MEA*PD**WT*14433*KG  
REF*SE*CURRENT MATERIAL ID  
HL*2*1*I*F  (Location of Damage – 1st)  
PID*S**DAC*ST*354*SLIVERS**73  
MEA*RN**LN*150*FT*1125*1275*46**FR  (46=Estimated) English  
MEA*RN**LN*45*LM*343*388*46**FR  (46=Estimated) Metric  
MEA*DE**WD*20*ED*****CT  
MEA*DE**WD*508*MM*****CT  
HL*3*1*I*F  (Location of Damage – 2nd)  
PID*S**DAC*ST*354*SLIVERS**73  
MEA*RN**LN*75*FT*1500*1575*46**FR  

“00” = Company Non-Classified  
“01” = Original  
“04” = Change  
“05” = Replace  
“MF” = Manufacturer  
(Steel Producer)  
“OU” = Outside Processor  
“ST” – Ship To  
“SF” – Ship From  

Dimensions of material  
Starting Point – From OD of Coil  
Ending Point – From OD of Coil  
“CT” = Center  
“LT” = Left  
“SB” = Right  

“DE” – Defect  
“RP” – Relative Postion
HL*4*1*F (Location of Damage – 3rd.)
PID*S*DAC*ST*354*SLIVERS**73
MEA*RN*LN*75*FT*1925*2000*46**FR
MEA*RN*LN*23*LM*586*609*46**FR
MEA*DE*WD*15*ED*****CT
MEA*DE*WD*381*MM*****CT

HL*5*1*F (Location of Damage – 4th)
PID*S*DAC*ST*354*SLIVERS**73
MEA*RN*LN*50*FT*2400*2450*46**FR
MEA*RN*LN*15*LM*731*746*46**FR
MEA*DE*WD*15*ED*****CT
MEA*DE*WD*381*MM*****CT

CID**69  (69 = Physical Test)
TMD**ST*163***BEND TEST***32B
PSD*02**4*PC*15*01*13
MSG*SAMPLE 12” X WIDTH
MSG*HOLD PENDING TEST RESULTS
MEA*RN*LN**FT*2400****FR

HL*6**I*1  (Item Coil/Lift - #2)
SPI*ZZ
LIN**VO*MILL ORDER #*VN*MILL ORDER ITEM #*HN*HEAT #*SN*MASTER COIL ID*BP*PART #
MSG*COIL ALREADY REJECTED BY QA
MSG*CUT OUT DEFECT.  SAVE SAMPLE FOR LATER TESTING
MSG*REVERSE SURFACE – PRIME SIDE OUT

Test Requirement
Number of Test Samples

Test Sample Location – From OD of Coil

Dimensions of material

Starting Point – From OD of Coil

Ending Point – From OD of Coil

“CT” = Center
“LT” = Left
“SB” = Right
HL*8*6*F (Location of Damage – 2nd)
PID*S*DAC*ST*127*SCRATCHES**73
MEA*RN*LN*75*FT*1500*1575*46**FR
MEA*RN*LN*23*LM*457*480*46**FR
MEA*DE*WD*15*ED*****CT
MEA*DE*WD*381*MM*****CT

HL*9*6*F (Location of Damage – 3rd.)
PID*S*DAC*ST*127*SCRATCHES**73
MEA*RN*LN*75*FT*1925*2000*46**FR
MEA*RN*LN*23*LM*586*609*46**FR
MEA*DE*WD*15*ED*****CT
MEA*DE*WD*381*MM*****CT

CID**69  (69 = Physical Test)
TMD**ST*163***BEND TEST***32B
PSD*02**4*PC*15*01*13
MSG*SAMPLE 12" X WIDTH
MSG*HOLD PENDING TEST RESULTS
MEA*RN*LN**FT*2400****FR

SE*38*0001
GE*1*1137
IEA*1*000001137