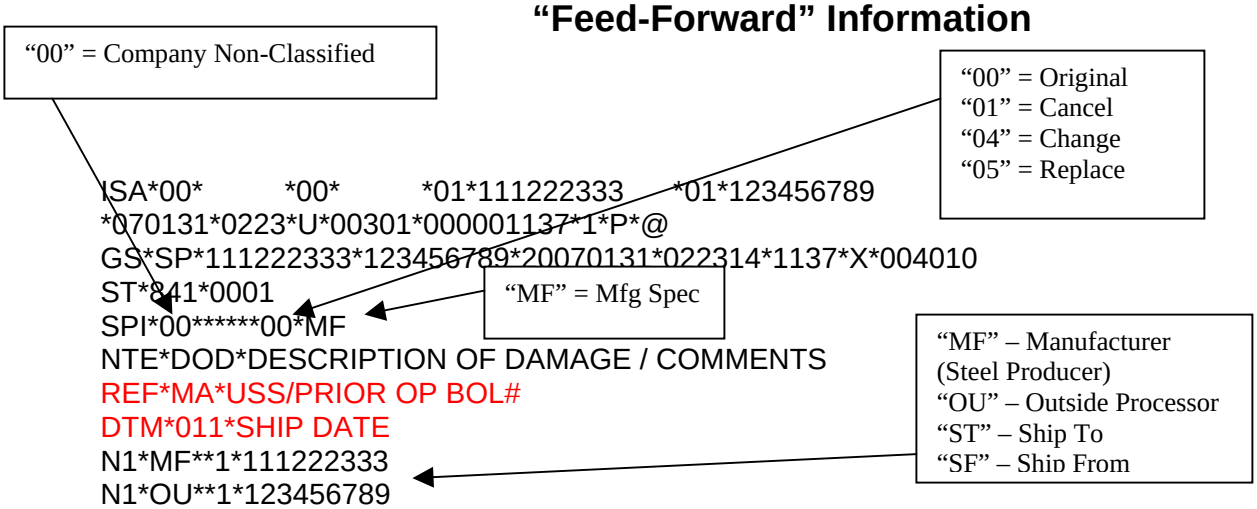
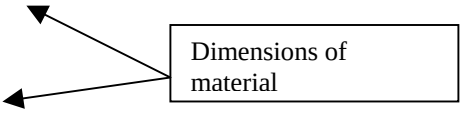
Draft 6/18/07

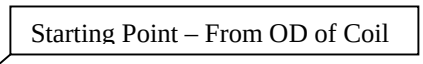
AISI – OP Committee
841 Specification/Technical Information
ASC X12 – Version 004010
Typical 841 To Outside Processor For
"Feed-Forward" Information

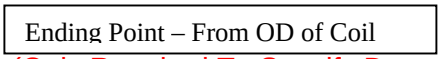


ISA*00* *00* *01*111222333 *01*123456789
*070131*0223*U*00301*000001137*1*P*@
GS*SP*111222333*123456789*20070131*022314*1137*X*004010
ST*841*0001
SPI*00******00*MF
NTE*DOD*DESCRIPTION OF DAMAGE / COMMENTS
REF*MA*USS/PRIOR OP BOL#
DTM*011*SHIP DATE
N1*MF**1*111222333
N1*OU**1*123456789
N1*ST**1*333333333
N!*SF**1*555666777

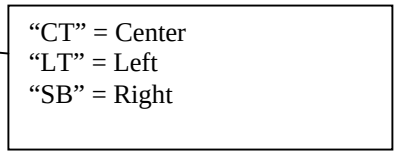
HL*1**I*1 (Item Coil/Lift - #1) (Required)
SPI*ZZ
LIN**VO*MILL ORDER #*VN*MILL ORDER ITEM #*HN*HEAT #*SN*MASTER COIL ID*BP*PART #
MSG*COIL ALREADY REJECTED BY QA
MSG*CUT OUT DEFECT. SAVE SAMPLE FOR LATER TESTING (Freeform Corrective Action)
MSG*REVERSE SURFACE – PRIME SIDE OUT
PID*S**ST*01***67 (Material 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

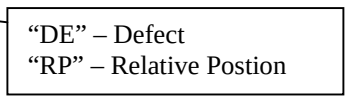






HL*2*1*F (Location of Damage – 1st)
PID*S*DAC*ST*354*SLIVERS**73
MEA*RN*LN*150*FT*1125*1275*46**FR (46=Estimated) English
MEA*RN*LN*45*LM*343*388*46**FR (46=Estimated) Metric
MEA*DE*WD*20*ED*****CT
MEA*DE*WD*508*MM*****CT





(Only Required To Specify Damage & Location)

HL*3*1*F (Location of Damage – 2nd)
PID*S*DAC*ST*354*SLIVERS**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*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

Test Requirement

Number of Test Samples

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

Test Info:
"02" = Finish Product Specimen
"15" = Charpy A
"01" = Longitudinal
"13" = Center

Test Sample Location – From OD of Coil

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
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

Dimensions of material

Starting Point – From OD of Coil

Ending Point – From OD of Coil

HL*7*1*F (Location of Damage – 1st)6
PID*S*DAC*ST*127*SCRATCHES**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

"CT" = Center
"LT" = Left
"SB" = Right

"DE" – Defect
"RP" – Relative Position

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