COMPLETE PRODUCTION WORK ORDER PACKAGE

ROOT / MAIN: WO-2026-000119 SELECTED BOM: BOM-000010 / Rev.0

Contains full frozen details for MAIN + every nested Child BOM Work Order.
PDF Generated: 2026-11-20 05:24:56

WORK ORDER / BOM RELATIONSHIP INDEX

Level	Work Order	Parent	Parent Operation	Product / BOM	Qty	Status
MAIN	WO-2026-000119		ROOT	C1 1000 02X05BB5LYYGDC0Y | BOM-000010	2000 m	PLANNED
L1	WO-2026-000120	WO-2026-000119	10 OP090 Cabling / Lay-up	> S1001 01B5YLY070B5YYYA22 | BOM-000008	2030 m	PLANNED
L2	WO-2026-000121	WO-2026-000120	10 OP060 Insulation Extrusion	> > BCL5 U-S000-0027-0250A04Y | BOM-000006	2030 kg	PLANNED
L3	WO-2026-000122	WO-2026-000121	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg	PLANNED
L4	WO-2026-000123	WO-2026-000122	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg	PLANNED
L3	WO-2026-000124	WO-2026-000121	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg	PLANNED
L4	WO-2026-000125	WO-2026-000124	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg	PLANNED
L3	WO-2026-000126	WO-2026-000121	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg	PLANNED
L4	WO-2026-000127	WO-2026-000126	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg	PLANNED
L1	WO-2026-000128	WO-2026-000119	10 OP090 Cabling / Lay-up	> S1001 01B5YLY070B5YYYA22 | BOM-000008	2030 m	PLANNED
L2	WO-2026-000129	WO-2026-000128	10 OP060 Insulation Extrusion	> > BCL5 U-S000-0027-0250A04Y | BOM-000006	2030 kg	PLANNED
L3	WO-2026-000130	WO-2026-000129	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg	PLANNED
L4	WO-2026-000131	WO-2026-000130	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg	PLANNED
L3	WO-2026-000132	WO-2026-000129	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg	PLANNED
L4	WO-2026-000133	WO-2026-000132	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg	PLANNED
L3	WO-2026-000134	WO-2026-000129	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg	PLANNED
L4	WO-2026-000135	WO-2026-000134	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg	PLANNED

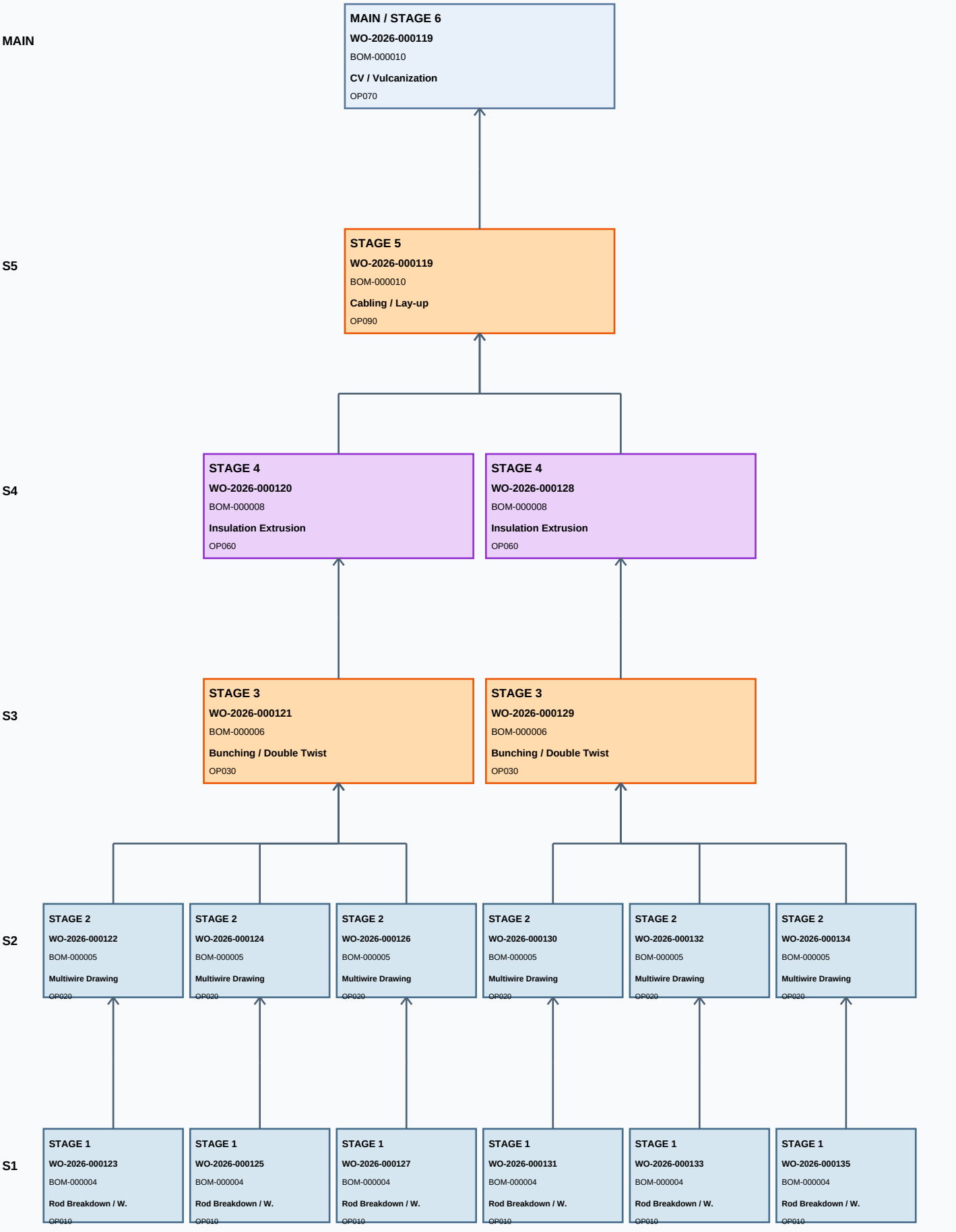
PRODUCTION / MANUFACTURING SEQUENCE - PRODUCE FROM DEEPEST CHILD TO MAIN

Prod Seq	Level	Work Order	Parent	Parent Operation	Product / BOM	Qty
1	L4	WO-2026-000123	WO-2026-000122	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg
1	L4	WO-2026-000125	WO-2026-000124	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg
1	L4	WO-2026-000127	WO-2026-000126	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg
1	L4	WO-2026-000131	WO-2026-000130	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg
1	L4	WO-2026-000133	WO-2026-000132	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg
1	L4	WO-2026-000135	WO-2026-000134	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	679.373265 kg
2	L3	WO-2026-000122	WO-2026-000121	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg
2	L3	WO-2026-000124	WO-2026-000121	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg
2	L3	WO-2026-000126	WO-2026-000121	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg
2	L3	WO-2026-000130	WO-2026-000129	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg
2	L3	WO-2026-000132	WO-2026-000129	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg
2	L3	WO-2026-000134	WO-2026-000129	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	676.666599 kg
3	L2	WO-2026-000121	WO-2026-000120	10 OP060 Insulation Extrusion	BCL5 U-S000-0027-0250A04Y | BOM-000006	2030 kg
3	L2	WO-2026-000129	WO-2026-000128	10 OP060 Insulation Extrusion	BCL5 U-S000-0027-0250A04Y | BOM-000006	2030 kg
4	L1	WO-2026-000120	WO-2026-000119	10 OP090 Cabling / Lay-up	S1001 01B5YLY070B5YYYA22 | BOM-000008	2030 m
4	L1	WO-2026-000128	WO-2026-000119	10 OP090 Cabling / Lay-up	S1001 01B5YLY070B5YYYA22 | BOM-000008	2030 m
5	MAIN	WO-2026-000119		FINAL / MAIN	C1 1000 02X05BB5LYYGDC0Y | BOM-000010	2000 m

1.	**Production Stage 1 = ALL Work Orders on the deepest hierarchy level. They may be produced in parallel.**
2.	**After every Work Order in a stage is completed, move one level upward to the next Production Stage.**
3.	**The MAIN Work Order is the final stage and starts after all required child/semi-finished stages are completed.**

VISUAL WORK ORDER / BOM HIERARCHY

Real operation flow: parallel BOM branches merge at the consuming process, then continue as ONE line.



OPERATION TYPE LEGEND

- CONDUCTOR / STRANDING
- CABLING / LAY-UP (BUKUM)
- INSULATION EXTRUSION
- PROCESS

Parallel inputs converge into ONE consuming operation. After the merge, the route continues as ONE process line. MAIN = actual final operation.

MAIN WORK ORDER **ROOT OF SELECTED BOM TREE**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000119

PRODUCT

C1 1000 02X05BB5LYYGDC0Y | H07RN-F 2X2.5 mm2

Qty: 2000 m Customer: |

WO Date/Time: 2026-10-04 15:01:21

MAIN WO BARCODE

WO-2026-000119-MAIN-000120

WORK ORDER DETAILS

Selected BOM	BOM-000010 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	MAIN / L0	**Parent WO**	
Parent Operation	--	**Frozen Snapshot**	v1
Standard / Voltage	450/750	**Core / Section**	2 / 2.5 mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:21	**PDF Generated Date / Time**	2026-11-20 05:24:56

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000010 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000010 / Rev.0	**OP090 | Cabling / Lay-up**	F02-M03 | Rigid Strander	|
20	BOM-000010 / Rev.0	**OP070 | CV / Vulcanization**	F03-M08 | Outer Sheathing Line	|

OP 10 - OP090 | Cabling / Lay-up

BOM: BOM-000010 / Rev.0 Source Seq: 10

Machine: F02-M03 | Rigid Strander Work Centre: |

Speed: 144 m/min

Setup: 34324 min Scrap: 0%

WO-2026-000119-010-OP090-130

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		2000 m	**m**	**144 m/min**	34324 min	131 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Lay Type	**234324**				
Lay Direction	**234324**				
Minimum Lay Length	**23432**	4324	234		
Nominal Lay Length					
Maximum Lay Length					
Lay Ratio			234		
Minimum Diameter					
Nominal Diameter					
Maximum Diameter					
Filler Cord Count					
Filler Cord Diameter					
Dummy Core Count					
Dummy Core Diameter					
Filler Cord Material					
Filler Cord Weight					
Yarn Material					
Yarn Weight					
Color and Number Sequence					

Process Type	**4324**				
Material Standard	**234**				
Color					
Color Masterbatch Ratio (%)				%	
Color Masterbatch Type					
Input Diameter					
Manufacturing Wall Thickness (mm)				mm	
Manufacturing Minimum Wall Thickness (mm)				mm	
Manufacturing Maximum Wall Thickness (mm)				mm	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)	**234**		234	mm	
Standard Minimum Diameter					
Standard Maximum Diameter	**42**	4234			42334
Material Weight (kg/km)			4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Assembly OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21	BOM-000008 / Rev.0	1015 m	2030 m	**WO-2026-000120**	NEXT: WO-2026-000119 -> WO-2026-000120
S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21	BOM-000008 / Rev.0	1015 m	2030 m	**WO-2026-000128**	NEXT: WO-2026-000119 -> WO-2026-000128

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

OP 20 - OP070 | CV / Vulcanization

BOM: BOM-000010 / Rev.0 Source Seq: 20

Machine: F03-M08 | Outer Sheathing Line Work Centre: |

Speed: 45 m/min

Setup: 4545 min Scrap: 1%

WO-2026-000119-020-OP070-131

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		2000 m	**1000 m**	**45 m/min**	4545 min	4545 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Process Type					
Material Standard					
Color					
Color Masterbatch Ratio (%)				%	

Color Masterbatch Type					
Catalyst Ratio (%)				%	
Insulation Input Diameter					
Nominal Wall Thickness (mm)				mm	
Minimum Point Wall Thickness (mm)				mm	
Maximum Point Wall Thickness (mm)				mm	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)				mm	
Insulation Resistance (M?.km)				Mohm/km	
Standard Minimum Diameter					
Standard Maximum Diameter					
Material Weight (kg/km)				kg/km	
Insulation Marking					
Note					
Tensile Strength / Elongation Values					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Curing Pressure				bar	
Curing Temperature				?C	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Hot Set Elongation				%	

RAW MATERIALS / COMPONENTS - OP 20 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
CMP-RUB-002	CPE Rubber Sheathing Compound	100	**210**	kg		5%	

OP 20 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 1 **PARENT WO-2026-000119 / OP 10 OP090 Cabling / Lay-up**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000120

PRODUCT

S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21

Qty: 2030 m Customer: |

WO Date/Time: 2026-10-04 15:01:21

MAIN WO BARCODE

WO-2026-000120-MAIN-000121

WORK ORDER DETAILS

Selected BOM	BOM-000008 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000119
Parent Operation	10 | OP090 Cabling / Lay-up	**Frozen Snapshot**	v1
Standard / Voltage		**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:21	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000119 / OP 10 OP090

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000008 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000008 / Rev.0	**OP060 | Insulation Extrusion**	F02-M04 | XLPE Insulation Line	|

OP 10 - OP060 | Insulation Extrusion

BOM: BOM-000008 / Rev.0 Source Seq: 10

Machine: F02-M04 | XLPE Insulation Line Work Centre: |

Speed: 100 m/min

Setup: 45 min Scrap: 5%

WO-2026-000120-010-OP060-132

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		2030 m	**1000 m**	**100 m/min**	45 min	23 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Process Type					
Material Standard					
Color					
Color Masterbatch Ratio (%)				%	
Color Masterbatch Type					
Catalyst Ratio (%)				%	
Anti-Rodent Additive Ratio (%)				%	
Anti-Termite Additive Ratio (%)				%	
Flame-Retardant Additive Ratio (%)				%	
Foaming Additive Ratio (%)				%	
Nominal Wall Thickness (mm)				mm	
Minimum Point Wall Thickness (mm)				mm	
Nominal Diameter (mm)				mm	
Minimum Diameter (mm)				mm	
Maximum Diameter (mm)				mm	
Manufacturing Wall Thickness (mm)				mm	
Manufacturing Minimum Wall Thickness (mm)				mm	

Manufacturing Maximum Wall Thickness (mm)				mm	
Material Weight (kg/km)				kg/km	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)				mm	
Insulation Input Diameter					
Maximum Point Wall Thickness (mm)				mm	
Insulation Resistance (M?.km)				Mohm/km	
Standard Minimum Diameter					
Standard Maximum Diameter					
Insulation Marking					
Note					
Tensile Strength / Elongation Values					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Extruder Zone Temperatures				?C	
Head Temperature				?C	
Screw Speed				rpm	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Minimum Thickness				mm	
Spark Test Voltage				kV	
Insulated Core OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL5 U-S000-0027-0250A04Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | Unilay concentric EU | S Left | 27 x 0.25 mm | Lay 16D | 1.5 mm2	BOM-000006 / Rev.0	1000 kg	2030 kg	**WO-2026-000121**	NEXT: WO-2026-000120 -> WO-2026-000121

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 2 **PARENT WO-2026-000120 / OP 10 OP060 Insulation Extrusion**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000121

PRODUCT

BCL5 U-S000-0027-0250A04Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
Unilay concentric EU | S Left | 27 x 0.25
mm | Lay 16D | 1.5 mm2
Qty: 2030 kg Customer: |
WO Date/Time: 2026-10-04 15:01:21

MAIN WO BARCODE

WO-2026-000121-MAIN-000122

WORK ORDER DETAILS

Selected BOM	BOM-000006 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000120
Parent Operation	10 | OP060 Insulation Extrusion	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:21	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000120 / OP 10 OP060

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000006 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000006 / Rev.0	**OP030 | Bunching / Double Twist**	F03-M05 | Cabling Machine	|

OP 10 - OP030 | Bunching / Double Twist

BOM: BOM-000006 / Rev.0 Source Seq: 10
Machine: F03-M05 | Cabling Machine Work Centre: |

Speed: 232323 m/min
Setup: 3434324 min Scrap: 55555%

WO-2026-000121-010-OP030-133

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		2030 kg	**m**	**232323 m/min**	3434324 min	234324 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ADSAD**				
Construction	**SADSAD**				
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction					
Diameter					
Nominal Lay Length					
Maximum Lay Length					
Theoretical Conductor Resistance					
Maximum Conductor Resistance					
Maximum Standard Resistance					
Material Weight (kg/km)				kg/km	
Note	**AD**				
Lay Type					
Minimum Lay Length					
Lay Ratio					
Minimum Diameter					

Nominal Diameter					
Maximum Diameter					
Filler Cord Count					
Filler Cord Diameter					
Dummy Core Count					
Dummy Core Diameter					
Filler Cord Material					
Filler Cord Weight					
Yarn Material	**DASD**				
Yarn Weight					
Color and Number Sequence					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Bow / Rotor Speed				rpm	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL5 N-N000-0009-0250007Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2	BOM-000005 / Rev.0	333.3333 kg	676.666599 kg	**WO-2026-000122**	NEXT: WO-2026-000121 -> WO-2026-000122
BCL5 N-N000-0009-0250007Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2	BOM-000005 / Rev.0	333.3333 kg	676.666599 kg	**WO-2026-000124**	NEXT: WO-2026-000121 -> WO-2026-000124
BCL5 N-N000-0009-0250007Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2	BOM-000005 / Rev.0	333.3333 kg	676.666599 kg	**WO-2026-000126**	NEXT: WO-2026-000121 -> WO-2026-000126

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000121 / OP 10 OP030 Bunching / Double Twist**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000122

PRODUCT

BCL5 N-N000-0009-0250007Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2

Qty: 676.666599 kg Customer: |

WO Date/Time: 2026-10-04 15:01:21

MAIN WO BARCODE

WO-2026-000122-MAIN-000123

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000121
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:21	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000121 / OP 10 OP030

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000005 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000005 / Rev.0	**OP020 | Multiwire Drawing**	F03-M02 | Fine Wire Drawing Machine	|

OP 10 - OP020 | Multiwire Drawing

BOM: BOM-000005 / Rev.0 Source Seq: 10

Machine: F03-M02 | Fine Wire Drawing Machine Work Centre: |

Speed: 33333 m/min

Setup: 545 min Scrap: 1%

WO-2026-000122-010-OP020-134

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		676.666599 kg	**m**	**33333 m/min**	545 min	30 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ERSDF**				
Construction	**DSF**				
Conductor Stranding Type					
Layer Diameters for Rolling	**4534**	4544			
Lay Direction					
Diameter		4	44		
Nominal Lay Length			44		
Maximum Lay Length					
Theoretical Conductor Resistance		44	6		
Maximum Conductor Resistance		4	4		
Maximum Standard Resistance					
Material Weight (kg/km)	**4**	4	4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed	**12**	8	15	m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Wire Diameter	**8768**	6767	6767	mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2	BOM-000004 / Rev.0	1004 kg	679.373265 kg	**WO-2026-000123**	NEXT: WO-2026-000122 -> WO-2026-000123

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 4 **PARENT WO-2026-000122 / OP 10 OP020 Multiwire Drawing**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000123

PRODUCT

BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2

Qty: 679.373265 kg Customer: |

WO Date/Time: 2026-10-04 15:01:21

MAIN WO BARCODE

WO-2026-000123-MAIN-000124

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000122
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:21	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000122 / OP 10 OP020

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000004 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000004 / Rev.0	**OP010 | Rod Breakdown / Wire Drawing**	F03-M01 | Rod Breakdown Machine	|

OP 10 - OP010 | Rod Breakdown / Wire Drawing

BOM: BOM-000004 / Rev.0 Source Seq: 10

Machine: F03-M01 | Rod Breakdown Machine Work Centre: |

Speed: 4 m/min

Setup: 30 min Scrap: 1%

WO-2026-000123-010-OP010-135

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		679.373265 kg	**1000 kg**	**4 m/min**	30 min	15 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**copper**				
Construction					
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction	**33**				
Diameter	**33**	5	333		
Nominal Lay Length			33		
Maximum Lay Length	**3**		3		
Theoretical Conductor Resistance	**3**		3		
Maximum Conductor Resistance	**3**	3			
Maximum Standard Resistance	**3**		3		
Material Weight (kg/km)	**3**		3	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Inlet Diameter	**333**	33	33	mm	
Outlet Diameter	**3**	3		mm	

Line Speed	**3333**	33	3	m/min	
Annealer Current	**333**	3	33	A	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor Resistance	**33**	3	33	ohm/km	
Wire Diameter	**333333**	33333	3	mm	

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
BCL1 N-N000-0001-8000012Y	Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 8 mm | Lay NOT | 50 mm2	1000	**686.166998**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000121 / OP 10 OP030 Bunching / Double Twist**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000124

PRODUCT

BCL5 N-N000-0009-0250007Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2

Qty: 676.666599 kg Customer: |

WO Date/Time: 2026-10-04 15:01:21

MAIN WO BARCODE

WO-2026-000124-MAIN-000125

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000121
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:21	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000121 / OP 10 OP030

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000005 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000005 / Rev.0	**OP020 | Multiwire Drawing**	F03-M02 | Fine Wire Drawing Machine	|

OP 10 - OP020 | Multiwire Drawing

BOM: BOM-000005 / Rev.0 Source Seq: 10

Machine: F03-M02 | Fine Wire Drawing Machine Work Centre: |

Speed: 33333 m/min

Setup: 545 min Scrap: 1%

WO-2026-000124-010-OP020-136

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		676.666599 kg	**m**	**33333 m/min**	545 min	30 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ERSDF**				
Construction	**DSF**				
Conductor Stranding Type					
Layer Diameters for Rolling	**4534**	4544			
Lay Direction					
Diameter		4	44		
Nominal Lay Length			44		
Maximum Lay Length					
Theoretical Conductor Resistance		44	6		
Maximum Conductor Resistance		4	4		
Maximum Standard Resistance					
Material Weight (kg/km)	**4**	4	4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed	**12**	8	15	m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Wire Diameter	**8768**	6767	6767	mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2	BOM-000004 / Rev.0	1004 kg	679.373265 kg	**WO-2026-000125**	NEXT: WO-2026-000124 -> WO-2026-000125

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 4 **PARENT WO-2026-000124 / OP 10 OP020 Multiwire Drawing**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000125

PRODUCT

BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2

Qty: 679.373265 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000125-MAIN-000126

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000124
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000124 / OP 10 OP020

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000004 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000004 / Rev.0	**OP010 | Rod Breakdown / Wire Drawing**	F03-M01 | Rod Breakdown Machine	|

OP 10 - OP010 | Rod Breakdown / Wire Drawing

BOM: BOM-000004 / Rev.0 Source Seq: 10

Machine: F03-M01 | Rod Breakdown Machine Work Centre: |

Speed: 4 m/min

Setup: 30 min Scrap: 1%

WO-2026-000125-010-OP010-137

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		679.373265 kg	**1000 kg**	**4 m/min**	30 min	15 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**copper**				
Construction					
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction	**33**				
Diameter	**33**	5	333		
Nominal Lay Length			33		
Maximum Lay Length	**3**		3		
Theoretical Conductor Resistance	**3**		3		
Maximum Conductor Resistance	**3**	3			
Maximum Standard Resistance	**3**		3		
Material Weight (kg/km)	**3**		3	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Inlet Diameter	**333**	33	33	mm	
Outlet Diameter	**3**	3		mm	

Line Speed	**3333**	33	3	m/min	
Annealer Current	**333**	3	33	A	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor Resistance	**33**	3	33	ohm/km	
Wire Diameter	**333333**	33333	3	mm	

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
BCL1 N-N000-0001-8000012Y	Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 8 mm | Lay NOT | 50 mm2	1000	**686.166998**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000121 / OP 10 OP030 Bunching / Double Twist**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000126

PRODUCT

BCL5 N-N000-0009-0250007Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2

Qty: 676.666599 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000126-MAIN-000127

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000121
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000121 / OP 10 OP030

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000005 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000005 / Rev.0	**OP020 | Multiwire Drawing**	F03-M02 | Fine Wire Drawing Machine	|

OP 10 - OP020 | Multiwire Drawing

BOM: BOM-000005 / Rev.0 Source Seq: 10

Machine: F03-M02 | Fine Wire Drawing Machine Work Centre: |

Speed: 33333 m/min

Setup: 545 min Scrap: 1%

WO-2026-000126-010-OP020-138

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		676.666599 kg	**m**	**33333 m/min**	545 min	30 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ERSDF**				
Construction	**DSF**				
Conductor Stranding Type					
Layer Diameters for Rolling	**4534**	4544			
Lay Direction					
Diameter		4	44		
Nominal Lay Length			44		
Maximum Lay Length					
Theoretical Conductor Resistance		44	6		
Maximum Conductor Resistance		4	4		
Maximum Standard Resistance					
Material Weight (kg/km)	**4**	4	4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed	**12**	8	15	m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Wire Diameter	**8768**	6767	6767	mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2	BOM-000004 / Rev.0	1004 kg	679.373265 kg	**WO-2026-000127**	NEXT: WO-2026-000126 -> WO-2026-000127

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 4 **PARENT WO-2026-000126 / OP 10 OP020 Multiwire Drawing**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000127

PRODUCT

BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2

Qty: 679.373265 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000127-MAIN-000128

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000126
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000126 / OP 10 OP020

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000004 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000004 / Rev.0	**OP010 | Rod Breakdown / Wire Drawing**	F03-M01 | Rod Breakdown Machine	|

OP 10 - OP010 | Rod Breakdown / Wire Drawing

BOM: BOM-000004 / Rev.0 Source Seq: 10

Machine: F03-M01 | Rod Breakdown Machine Work Centre: |

Speed: 4 m/min

Setup: 30 min Scrap: 1%

WO-2026-000127-010-OP010-139

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		679.373265 kg	**1000 kg**	**4 m/min**	30 min	15 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**copper**				
Construction					
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction	**33**				
Diameter	**33**	5	333		
Nominal Lay Length			33		
Maximum Lay Length	**3**		3		
Theoretical Conductor Resistance	**3**		3		
Maximum Conductor Resistance	**3**	3			
Maximum Standard Resistance	**3**		3		
Material Weight (kg/km)	**3**		3	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Inlet Diameter	**333**	33	33	mm	
Outlet Diameter	**3**	3		mm	

Line Speed	**3333**	33	3	m/min	
Annealer Current	**333**	3	33	A	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor Resistance	**33**	3	33	ohm/km	
Wire Diameter	**333333**	33333	3	mm	

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
BCL1 N-N000-0001-8000012Y	Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 8 mm | Lay NOT | 50 mm2	1000	**686.166998**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 1 **PARENT WO-2026-000119 / OP 10 OP090 Cabling / Lay-up**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000128

PRODUCT

S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21

Qty: 2030 m Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000128-MAIN-000129

WORK ORDER DETAILS

Selected BOM	BOM-000008 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000119
Parent Operation	10 | OP090 Cabling / Lay-up	**Frozen Snapshot**	v1
Standard / Voltage		**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000119 / OP 10 OP090

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000008 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000008 / Rev.0	**OP060 | Insulation Extrusion**	F02-M04 | XLPE Insulation Line	|

OP 10 - OP060 | Insulation Extrusion

BOM: BOM-000008 / Rev.0 Source Seq: 10

Machine: F02-M04 | XLPE Insulation Line Work Centre: |

Speed: 100 m/min

Setup: 45 min Scrap: 5%

WO-2026-000128-010-OP060-140

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		2030 m	**1000 m**	**100 m/min**	45 min	23 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Process Type					
Material Standard					
Color					
Color Masterbatch Ratio (%)				%	
Color Masterbatch Type					
Catalyst Ratio (%)				%	
Anti-Rodent Additive Ratio (%)				%	
Anti-Termite Additive Ratio (%)				%	
Flame-Retardant Additive Ratio (%)				%	
Foaming Additive Ratio (%)				%	
Nominal Wall Thickness (mm)				mm	
Minimum Point Wall Thickness (mm)				mm	
Nominal Diameter (mm)				mm	
Minimum Diameter (mm)				mm	
Maximum Diameter (mm)				mm	
Manufacturing Wall Thickness (mm)				mm	
Manufacturing Minimum Wall Thickness (mm)				mm	

Manufacturing Maximum Wall Thickness (mm)				mm	
Material Weight (kg/km)				kg/km	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)				mm	
Insulation Input Diameter					
Maximum Point Wall Thickness (mm)				mm	
Insulation Resistance (M?.km)				Mohm/km	
Standard Minimum Diameter					
Standard Maximum Diameter					
Insulation Marking					
Note					
Tensile Strength / Elongation Values					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Extruder Zone Temperatures				?C	
Head Temperature				?C	
Screw Speed				rpm	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Minimum Thickness				mm	
Spark Test Voltage				kV	
Insulated Core OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL5 U-S000-0027-0250A04Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | Unilay concentric EU | S Left | 27 x 0.25 mm | Lay 16D | 1.5 mm2	BOM-000006 / Rev.0	1000 kg	2030 kg	**WO-2026-000129**	NEXT: WO-2026-000128 -> WO-2026-000129

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 2 **PARENT WO-2026-000128 / OP 10 OP060 Insulation Extrusion**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000129

PRODUCT

BCL5 U-S000-0027-0250A04Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
Unilay concentric EU | S Left | 27 x 0.25
mm | Lay 16D | 1.5 mm2
Qty: 2030 kg Customer: |
WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000129-MAIN-000130

WORK ORDER DETAILS

Selected BOM	BOM-000006 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000128
Parent Operation	10 | OP060 Insulation Extrusion	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000128 / OP 10 OP060

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000006 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000006 / Rev.0	**OP030 | Bunching / Double Twist**	F03-M05 | Cabling Machine	|

OP 10 - OP030 | Bunching / Double Twist

BOM: BOM-000006 / Rev.0 Source Seq: 10
Machine: F03-M05 | Cabling Machine Work Centre: |

Speed: 232323 m/min
Setup: 3434324 min Scrap: 55555%

WO-2026-000129-010-OP030-141

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		2030 kg	**m**	**232323 m/min**	3434324 min	234324 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ADSAD**				
Construction	**SADSAD**				
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction					
Diameter					
Nominal Lay Length					
Maximum Lay Length					
Theoretical Conductor Resistance					
Maximum Conductor Resistance					
Maximum Standard Resistance					
Material Weight (kg/km)				kg/km	
Note	**AD**				
Lay Type					
Minimum Lay Length					
Lay Ratio					
Minimum Diameter					

Nominal Diameter					
Maximum Diameter					
Filler Cord Count					
Filler Cord Diameter					
Dummy Core Count					
Dummy Core Diameter					
Filler Cord Material					
Filler Cord Weight					
Yarn Material	**DASD**				
Yarn Weight					
Color and Number Sequence					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Bow / Rotor Speed				rpm	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL5 N-N000-0009-0250007Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2	BOM-000005 / Rev.0	333.3333 kg	676.666599 kg	**WO-2026-000130**	NEXT: WO-2026-000129 -> WO-2026-000130
BCL5 N-N000-0009-0250007Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2	BOM-000005 / Rev.0	333.3333 kg	676.666599 kg	**WO-2026-000132**	NEXT: WO-2026-000129 -> WO-2026-000132
BCL5 N-N000-0009-0250007Y | Bare Copper | IEC | Round/Bunch | IEC 60028 Class 5 | NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2	BOM-000005 / Rev.0	333.3333 kg	676.666599 kg	**WO-2026-000134**	NEXT: WO-2026-000129 -> WO-2026-000134

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000129 / OP 10 OP030 Bunching / Double Twist**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000130

PRODUCT

BCL5 N-N000-0009-0250007Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2

Qty: 676.666599 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000130-MAIN-000131

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000129
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000129 / OP 10 OP030

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000005 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000005 / Rev.0	**OP020 | Multiwire Drawing**	F03-M02 | Fine Wire Drawing Machine	|

OP 10 - OP020 | Multiwire Drawing

BOM: BOM-000005 / Rev.0 Source Seq: 10

Machine: F03-M02 | Fine Wire Drawing Machine Work Centre: |

Speed: 33333 m/min

Setup: 545 min Scrap: 1%

WO-2026-000130-010-OP020-142

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		676.666599 kg	**m**	**33333 m/min**	545 min	30 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ERSDF**				
Construction	**DSF**				
Conductor Stranding Type					
Layer Diameters for Rolling	**4534**	4544			
Lay Direction					
Diameter		4	44		
Nominal Lay Length			44		
Maximum Lay Length					
Theoretical Conductor Resistance		44	6		
Maximum Conductor Resistance		4	4		
Maximum Standard Resistance					
Material Weight (kg/km)	**4**	4	4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed	**12**	8	15	m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Wire Diameter	**8768**	6767	6767	mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2	BOM-000004 / Rev.0	1004 kg	679.373265 kg	**WO-2026-000131**	NEXT: WO-2026-000130 -> WO-2026-000131

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 4 **PARENT WO-2026-000130 / OP 10 OP020 Multiwire Drawing**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000131

PRODUCT

BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2

Qty: 679.373265 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000131-MAIN-000132

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000130
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000130 / OP 10 OP020

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000004 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000004 / Rev.0	**OP010 | Rod Breakdown / Wire Drawing**	F03-M01 | Rod Breakdown Machine	|

OP 10 - OP010 | Rod Breakdown / Wire Drawing

BOM: BOM-000004 / Rev.0 Source Seq: 10

Machine: F03-M01 | Rod Breakdown Machine Work Centre: |

Speed: 4 m/min

Setup: 30 min Scrap: 1%

WO-2026-000131-010-OP010-143

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		679.373265 kg	**1000 kg**	**4 m/min**	30 min	15 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**copper**				
Construction					
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction	**33**				
Diameter	**33**	5	333		
Nominal Lay Length			33		
Maximum Lay Length	**3**		3		
Theoretical Conductor Resistance	**3**		3		
Maximum Conductor Resistance	**3**	3			
Maximum Standard Resistance	**3**		3		
Material Weight (kg/km)	**3**		3	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Inlet Diameter	**333**	33	33	mm	
Outlet Diameter	**3**	3		mm	

Line Speed	**3333**	33	3	m/min	
Annealer Current	**333**	3	33	A	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor Resistance	**33**	3	33	ohm/km	
Wire Diameter	**333333**	33333	3	mm	

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
BCL1 N-N000-0001-8000012Y	Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 8 mm | Lay NOT | 50 mm2	1000	**686.166998**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000129 / OP 10 OP030 Bunching / Double Twist**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000132

PRODUCT

BCL5 N-N000-0009-0250007Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2

Qty: 676.666599 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000132-MAIN-000133

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000129
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000129 / OP 10 OP030

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000005 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000005 / Rev.0	**OP020 | Multiwire Drawing**	F03-M02 | Fine Wire Drawing Machine	|

OP 10 - OP020 | Multiwire Drawing

BOM: BOM-000005 / Rev.0 Source Seq: 10

Machine: F03-M02 | Fine Wire Drawing Machine Work Centre: |

Speed: 33333 m/min

Setup: 545 min Scrap: 1%

WO-2026-000132-010-OP020-144

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		676.666599 kg	**m**	**33333 m/min**	545 min	30 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ERSDF**				
Construction	**DSF**				
Conductor Stranding Type					
Layer Diameters for Rolling	**4534**	4544			
Lay Direction					
Diameter		4	44		
Nominal Lay Length			44		
Maximum Lay Length					
Theoretical Conductor Resistance		44	6		
Maximum Conductor Resistance		4	4		
Maximum Standard Resistance					
Material Weight (kg/km)	**4**	4	4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed	**12**	8	15	m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Wire Diameter	**8768**	6767	6767	mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2	BOM-000004 / Rev.0	1004 kg	679.373265 kg	**WO-2026-000133**	NEXT: WO-2026-000132 -> WO-2026-000133

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 4 **PARENT WO-2026-000132 / OP 10 OP020 Multiwire Drawing**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000133

PRODUCT

BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2

Qty: 679.373265 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000133-MAIN-000134

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000132
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000132 / OP 10 OP020

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000004 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000004 / Rev.0	**OP010 | Rod Breakdown / Wire Drawing**	F03-M01 | Rod Breakdown Machine	|

OP 10 - OP010 | Rod Breakdown / Wire Drawing

BOM: BOM-000004 / Rev.0 Source Seq: 10

Machine: F03-M01 | Rod Breakdown Machine Work Centre: |

Speed: 4 m/min

Setup: 30 min Scrap: 1%

WO-2026-000133-010-OP010-145

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		679.373265 kg	**1000 kg**	**4 m/min**	30 min	15 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**copper**				
Construction					
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction	**33**				
Diameter	**33**	5	333		
Nominal Lay Length			33		
Maximum Lay Length	**3**		3		
Theoretical Conductor Resistance	**3**		3		
Maximum Conductor Resistance	**3**	3			
Maximum Standard Resistance	**3**		3		
Material Weight (kg/km)	**3**		3	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Inlet Diameter	**333**	33	33	mm	
Outlet Diameter	**3**	3		mm	

Line Speed	**3333**	33	3	m/min	
Annealer Current	**333**	3	33	A	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor Resistance	**33**	3	33	ohm/km	
Wire Diameter	**333333**	33333	3	mm	

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
BCL1 N-N000-0001-8000012Y	Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 8 mm | Lay NOT | 50 mm2	1000	**686.166998**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000129 / OP 10 OP030 Bunching / Double Twist**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000134

PRODUCT

BCL5 N-N000-0009-0250007Y | Bare Copper |
IEC | Round/Bunch | IEC 60028 Class 5 |
NOT | NOT | 9 x 0.25 mm | Lay NOT | 6 mm2

Qty: 676.666599 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000134-MAIN-000135

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000129
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000129 / OP 10 OP030

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000005 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000005 / Rev.0	**OP020 | Multiwire Drawing**	F03-M02 | Fine Wire Drawing Machine	|

OP 10 - OP020 | Multiwire Drawing

BOM: BOM-000005 / Rev.0 Source Seq: 10

Machine: F03-M02 | Fine Wire Drawing Machine Work Centre: |

Speed: 33333 m/min

Setup: 545 min Scrap: 1%

WO-2026-000134-010-OP020-146

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		676.666599 kg	**m**	**33333 m/min**	545 min	30 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**ERSDF**				
Construction	**DSF**				
Conductor Stranding Type					
Layer Diameters for Rolling	**4534**	4544			
Lay Direction					
Diameter		4	44		
Nominal Lay Length			44		
Maximum Lay Length					
Theoretical Conductor Resistance		44	6		
Maximum Conductor Resistance		4	4		
Maximum Standard Resistance					
Material Weight (kg/km)	**4**	4	4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed	**12**	8	15	m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Wire Diameter	**8768**	6767	6767	mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2	BOM-000004 / Rev.0	1004 kg	679.373265 kg	**WO-2026-000135**	NEXT: WO-2026-000134 -> WO-2026-000135

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
-	No material line stored for this operation.						

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign

CHILD WORK ORDER - LEVEL 4 **PARENT WO-2026-000134 / OP 10 OP020 Multiwire Drawing**

THIS SECTION CONTAINS THE COMPLETE FROZEN BOM / ROUTING / PARAMETERS / MATERIALS FOR THIS WORK ORDER.

PRODUCTION WORK ORDER
WO-2026-000135

PRODUCT

BCL1 N-N000-0001-1250005Y | Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 1.25 mm | Lay NOT | 2.5 mm2

Qty: 679.373265 kg Customer: |

WO Date/Time: 2026-10-04 15:01:22

MAIN WO BARCODE

WO-2026-000135-MAIN-000136

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000134
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 15:01:22	**PDF Generated Date / Time**	2026-11-20 05:24:56

WORK ORDER NOTES

Generated from parent WO-2026-000134 / OP 10 OP020

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000004 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000004 / Rev.0	**OP010 | Rod Breakdown / Wire Drawing**	F03-M01 | Rod Breakdown Machine	|

OP 10 - OP010 | Rod Breakdown / Wire Drawing

BOM: BOM-000004 / Rev.0 Source Seq: 10

Machine: F03-M01 | Rod Breakdown Machine Work Centre: |

Speed: 4 m/min

Setup: 30 min Scrap: 1%

WO-2026-000135-010-OP010-147

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		679.373265 kg	**1000 kg**	**4 m/min**	30 min	15 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Material Type	**copper**				
Construction					
Conductor Stranding Type					
Layer Diameters for Rolling					
Lay Direction	**33**				
Diameter	**33**	5	333		
Nominal Lay Length			33		
Maximum Lay Length	**3**		3		
Theoretical Conductor Resistance	**3**		3		
Maximum Conductor Resistance	**3**	3			
Maximum Standard Resistance	**3**		3		
Material Weight (kg/km)	**3**		3	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Inlet Diameter	**333**	33	33	mm	
Outlet Diameter	**3**	3		mm	

Line Speed	**3333**	33	3	m/min	
Annealer Current	**333**	3	33	A	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Conductor Resistance	**33**	3	33	ohm/km	
Wire Diameter	**333333**	33333	3	mm	

RAW MATERIALS / COMPONENTS - OP 10 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
BCL1 N-N000-0001-8000012Y	Bare Copper | IEC | Round/Bunch | IEC 60228 Class 1 | NOT | NOT | 1 x 8 mm | Lay NOT | 50 mm2	1000	**686.166998**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

Operator / Sign	Actual Start / Stop	Actual Output / Scrap	QC / Supervisor / Sign