# COMPLETE PRODUCTION WORK ORDER PACKAGE

**ROOT / MAIN: WO-2026-000016  SELECTED BOM: BOM-000004 / Rev.0**

Contains full frozen details for MAIN + every nested Child BOM Work Order.

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## WORK ORDER / BOM RELATIONSHIP INDEX

| Level | Work Order | Parent | Parent Operation | Product / BOM | Qty | Status |
|---|---|---|---|---|---|---|
| MAIN | WO-2026-000016 | | ROOT | BCL1 N-N000-0001-1250005Y \| BOM-000004 | 1000 kg | PLANNED |

## PRODUCTION / MANUFACTURING SEQUENCE - PRODUCE FROM DEEPEST CHILD TO MAIN

| Prod Seq | Level | Work Order | Parent | Parent Operation | Product / BOM | Qty |
|---|---|---|---|---|---|---|
| 1 | MAIN | WO-2026-000016 | | FINAL / MAIN | BCL1 N-N000-0001-1250005Y \| BOM-000004 | 1000 kg |

| | |
|---|---|
| 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.

**MAIN**

**MAIN / STAGE 1**

**WO-2026-000016**

BOM-000004

**Rod Breakdown / Wire Drawing**

OP010

**OPERATION TYPE LEGEND**

CONDUCTOR / STRANDING

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-2026-000016

**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: 1000 kg Customer: |

WO Date/Time: 2026-09-28 10:16:00

**MAIN WO BARCODE**

WO-2026-000016-MAIN-000017

## WORK ORDER DETAILS

| | | | |
|---|---|---|---|
| **Selected BOM** | BOM-000004 / Rev.0 | **Status / Priority** | PLANNED / NORMAL |
| **WO Role / Level** | MAIN / L0 | **Parent WO** | |
| **Parent Operation** | -- | **Frozen Snapshot** | v1 |
| **Standard / Voltage** | IEC | **Core / Section** | mm2 |
| **Factory** | | **Department** | |
| **Work Centre** | | **Responsible** | |
| **Order / Due** | 2026-09-28 | **Planned Start** | |
| **WO Created Date / Time** | 2026-09-28 10:16:00 | **PDF Generated Date / Time** | 2026-11-20 03:19:24 |

## 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-2026-000016-010-OP010-24

## PLANNED PRODUCTION

| Start | Finish | Input Qty | Output Qty | Speed | Setup | Duration | Semi-Finished Output |
|---|---|---|---|---|---|---|---|
| | | **1000 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 | **1010** | kg | | 1% | |

## OP 10 - OPERATOR / QC SIGN-OFF

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