COMPLETE PRODUCTION WORK ORDER PACKAGE

ROOT / MAIN: WO-2026-000017 SELECTED BOM: BOM-000006 / 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-2026-000017**		ROOT	BCL5 U-S000-0027-0250A04Y | BOM-000006	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-2026-000017**		FINAL / MAIN	BCL5 U-S000-0027-0250A04Y | BOM-000006	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-2026-000017

BOM-000006

Bunching / Double Twist

OP030

OPERATION TYPE LEGEND

CABLING / LAY-UP (BUKUM)

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-2026-000017

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: 1000 kg Customer: |
WO Date/Time: 2026-09-28 11:22:50

MAIN WO BARCODE

WO-2026-000017-MAIN-000018

WORK ORDER DETAILS

Selected BOM	BOM-000006 / 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	F03 | Alexandria Marine Cable Plant	**Department**	
Work Centre		**Responsible**	
Order / Due	2026-09-28	**Planned Start**	
WO Created Date / Time	2026-09-28 11:22:50	**PDF Generated Date / Time**	2026-11-20 03:13:59

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-2026-000017-010-OP030-25

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1000 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	

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