COMPLETE PRODUCTION WORK ORDER PACKAGE

ROOT / MAIN: WO-2026-000032 SELECTED BOM: BOM-000006 / Rev.0

Contains full frozen details for MAIN + every nested Child BOM Work Order.
PDF Generated: 2026-11-20 00:17:28

WORK ORDER / BOM RELATIONSHIP INDEX

Level	Work Order	Parent	Parent Operation	Product / BOM	Qty	Status
MAIN	**WO-2026-000032**		ROOT	BCL5 U-S000-0027-0250A04Y | BOM-000006	4444 kg	PLANNED
L1	**WO-2026-000033**	WO-2026-000032	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	1481.333185 kg	PLANNED
L2	**WO-2026-000034**	WO-2026-000033	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	1487.258518 kg	PLANNED
L1	**WO-2026-000035**	WO-2026-000032	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	1481.333185 kg	PLANNED
L2	**WO-2026-000036**	WO-2026-000035	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	1487.258518 kg	PLANNED
L1	**WO-2026-000037**	WO-2026-000032	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	1481.333185 kg	PLANNED
L2	**WO-2026-000038**	WO-2026-000037	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	1487.258518 kg	PLANNED

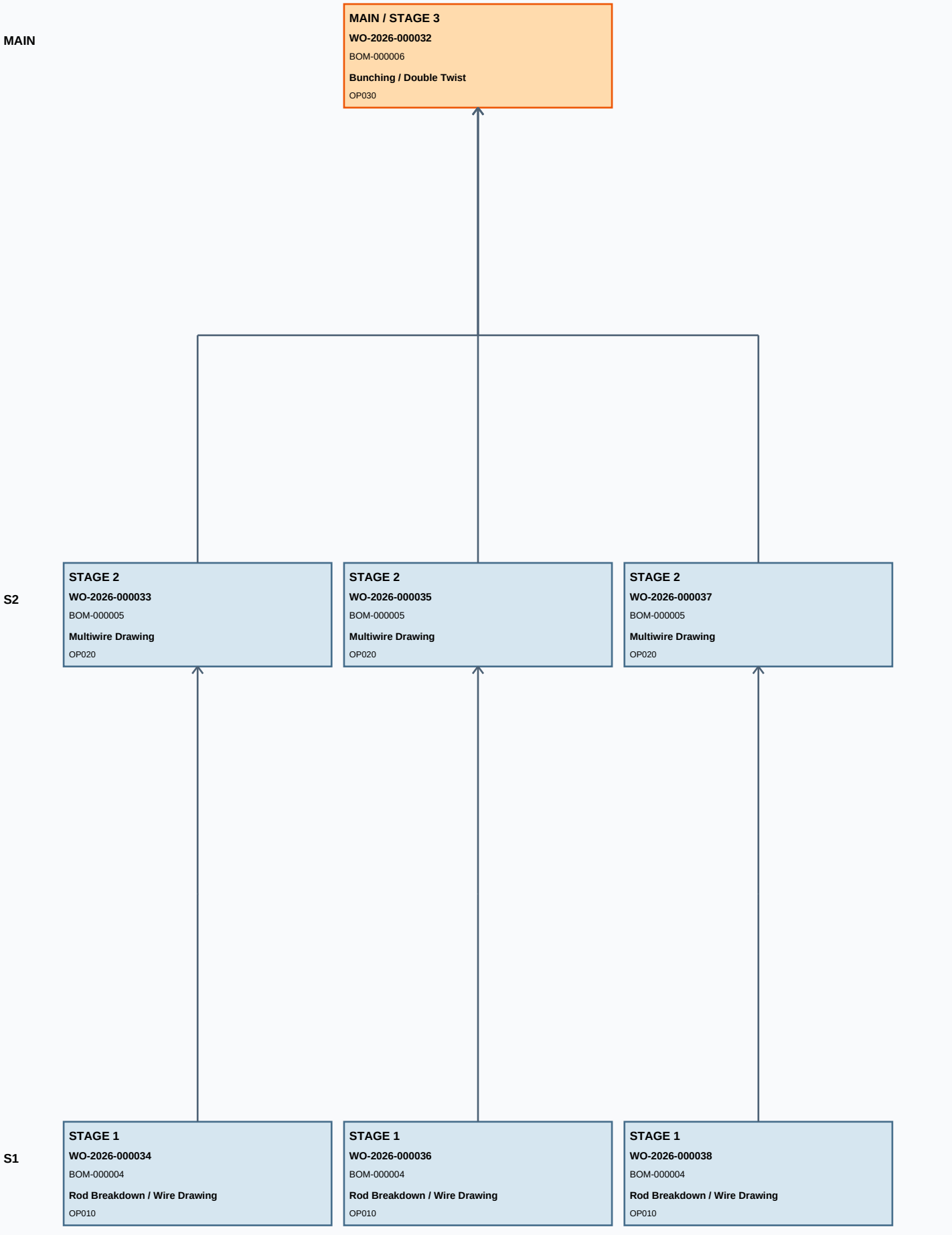
PRODUCTION / MANUFACTURING SEQUENCE - PRODUCE FROM DEEPEST CHILD TO MAIN

Prod Seq	Level	Work Order	Parent	Parent Operation	Product / BOM	Qty
1	L2	**WO-2026-000034**	WO-2026-000033	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	1487.258518 kg
1	L2	**WO-2026-000036**	WO-2026-000035	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	1487.258518 kg
1	L2	**WO-2026-000038**	WO-2026-000037	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	1487.258518 kg
2	L1	**WO-2026-000033**	WO-2026-000032	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	1481.333185 kg
2	L1	**WO-2026-000035**	WO-2026-000032	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	1481.333185 kg
2	L1	**WO-2026-000037**	WO-2026-000032	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	1481.333185 kg
3	MAIN	**WO-2026-000032**		FINAL / MAIN	BCL5 U-S000-0027-0250A04Y | BOM-000006	4444 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.



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-2026-000032

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: 4444 kg Customer: |
WO Date/Time: 2026-09-28 12:13:09

MAIN WO BARCODE

WO-2026-000032-MAIN-000033

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		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-09-28	**Planned Start**	
WO Created Date / Time	2026-09-28 12:13:09	**PDF Generated Date / Time**	2026-11-20 00:17:28

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-2026-000032-010-OP030-40

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		4444 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	1481.333185 kg	**WO-2026-000033**	NEXT: WO-2026-000032 -> WO-2026-000033
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	1481.333185 kg	**WO-2026-000035**	NEXT: WO-2026-000032 -> WO-2026-000035
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	1481.333185 kg	**WO-2026-000037**	NEXT: WO-2026-000032 -> WO-2026-000037

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 1 **PARENT WO-2026-000032 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000033

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: 1481.333185 kg Customer: |

WO Date/Time: 2026-09-28 12:13:09

MAIN WO BARCODE

WO-2026-000033-MAIN-000034

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000032
Parent Operation	10 | OP030 Bunching / Double Twist	**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 12:13:09	**PDF Generated Date / Time**	2026-11-20 00:17:28

WORK ORDER NOTES

Generated from parent WO-2026-000032 / 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-2026-000033-010-OP020-41

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1481.333185 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	1487.258518 kg	**WO-2026-000034**	NEXT: WO-2026-000033 -> WO-2026-000034

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-2026-000033 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000034

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: 1487.258518 kg Customer: |

WO Date/Time: 2026-09-28 12:13:09

MAIN WO BARCODE

WO-2026-000034-MAIN-000035

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000033
Parent Operation	10 | OP020 Multiwire Drawing	**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 12:13:09	**PDF Generated Date / Time**	2026-11-20 00:17:28

WORK ORDER NOTES

Generated from parent WO-2026-000033 / 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-2026-000034-010-OP010-42

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1487.258518 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	**1502.131103**	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-2026-000032 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000035

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: 1481.333185 kg Customer: |

WO Date/Time: 2026-09-28 12:13:09

MAIN WO BARCODE

WO-2026-000035-MAIN-000036

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000032
Parent Operation	10 | OP030 Bunching / Double Twist	**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 12:13:09	**PDF Generated Date / Time**	2026-11-20 00:17:28

WORK ORDER NOTES

Generated from parent WO-2026-000032 / 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-2026-000035-010-OP020-43

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1481.333185 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	1487.258518 kg	**WO-2026-000036**	NEXT: WO-2026-000035 -> WO-2026-000036

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-2026-000035 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000036

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: 1487.258518 kg Customer: |

WO Date/Time: 2026-09-28 12:13:09

MAIN WO BARCODE

WO-2026-000036-MAIN-000037

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000035
Parent Operation	10 | OP020 Multiwire Drawing	**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 12:13:09	**PDF Generated Date / Time**	2026-11-20 00:17:28

WORK ORDER NOTES

Generated from parent WO-2026-000035 / 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-2026-000036-010-OP010-44

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1487.258518 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	**1502.131103**	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-2026-000032 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000037

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: 1481.333185 kg Customer: |

WO Date/Time: 2026-09-28 12:13:09

MAIN WO BARCODE

WO-2026-000037-MAIN-000038

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000032
Parent Operation	10 | OP030 Bunching / Double Twist	**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 12:13:09	**PDF Generated Date / Time**	2026-11-20 00:17:28

WORK ORDER NOTES

Generated from parent WO-2026-000032 / 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-2026-000037-010-OP020-45

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1481.333185 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	1487.258518 kg	**WO-2026-000038**	NEXT: WO-2026-000037 -> WO-2026-000038

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-2026-000037 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000038

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: 1487.258518 kg Customer: |

WO Date/Time: 2026-09-28 12:13:10

MAIN WO BARCODE

WO-2026-000038-MAIN-000039

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000037
Parent Operation	10 | OP020 Multiwire Drawing	**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 12:13:10	**PDF Generated Date / Time**	2026-11-20 00:17:28

WORK ORDER NOTES

Generated from parent WO-2026-000037 / 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-2026-000038-010-OP010-46

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1487.258518 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	**1502.131103**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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