COMPLETE PRODUCTION WORK ORDER PACKAGE

ROOT / MAIN: WO-2026-000039 SELECTED BOM: BOM-000006 / Rev.0

Contains full frozen details for MAIN + every nested Child BOM Work Order.
PDF Generated: 2026-11-20 03:06:21

WORK ORDER / BOM RELATIONSHIP INDEX

Level	Work Order	Parent	Parent Operation	Product / BOM	Qty	Status
MAIN	**WO-2026-000039**		ROOT	BCL5 U-S000-0027-0250A04Y | BOM-000006	777777 kg	PLANNED
L1	**WO-2026-000040**	WO-2026-000039	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	259258.974074 kg	PLANNED
L2	**WO-2026-000041**	WO-2026-000040	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	260296.00997 kg	PLANNED
L1	**WO-2026-000042**	WO-2026-000039	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	259258.974074 kg	PLANNED
L2	**WO-2026-000043**	WO-2026-000042	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	260296.00997 kg	PLANNED
L1	**WO-2026-000044**	WO-2026-000039	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	259258.974074 kg	PLANNED
L2	**WO-2026-000045**	WO-2026-000044	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	260296.00997 kg	PLANNED

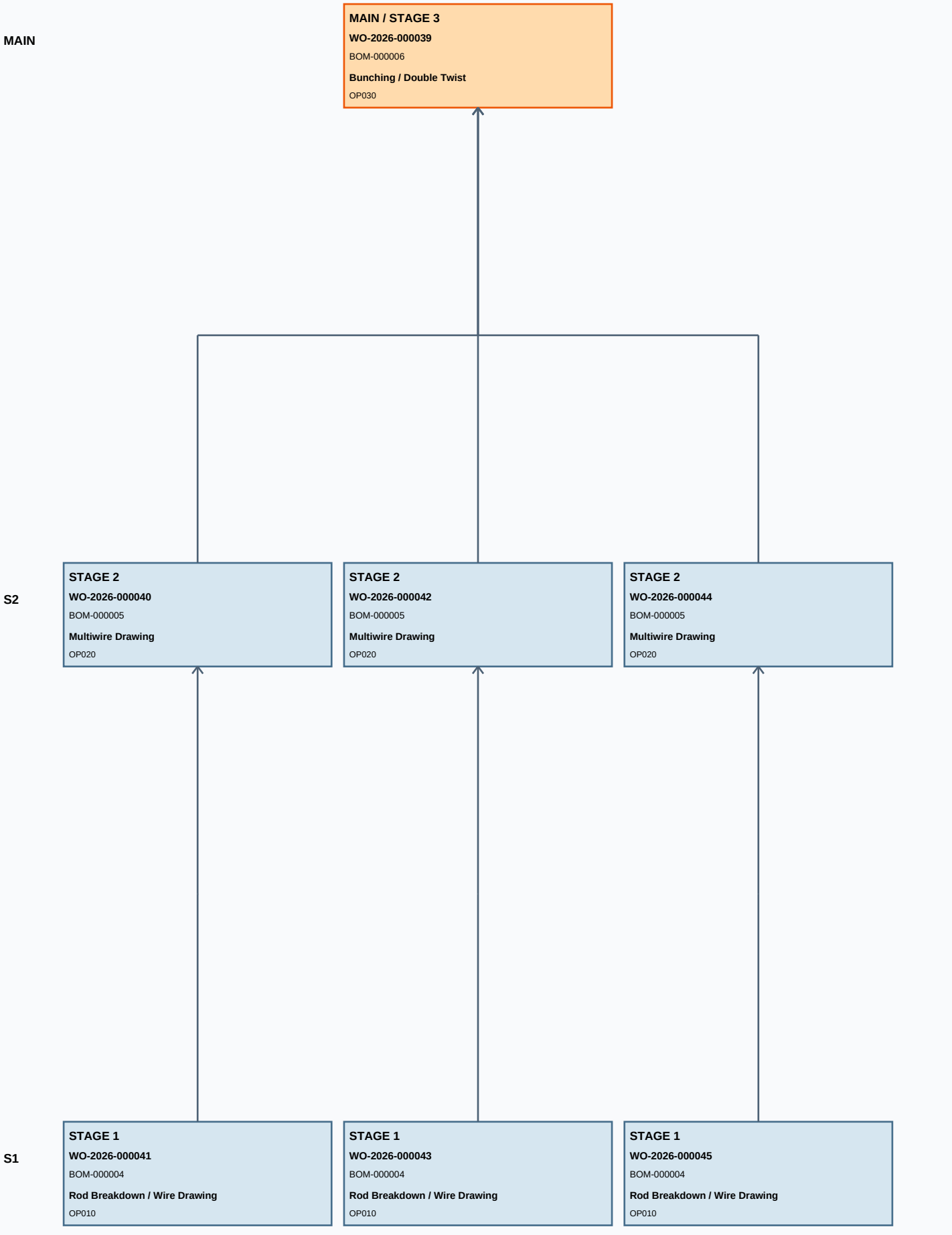
PRODUCTION / MANUFACTURING SEQUENCE - PRODUCE FROM DEEPEST CHILD TO MAIN

Prod Seq	Level	Work Order	Parent	Parent Operation	Product / BOM	Qty
1	L2	**WO-2026-000041**	WO-2026-000040	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	260296.00997 kg
1	L2	**WO-2026-000043**	WO-2026-000042	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	260296.00997 kg
1	L2	**WO-2026-000045**	WO-2026-000044	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	260296.00997 kg
2	L1	**WO-2026-000040**	WO-2026-000039	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	259258.974074 kg
2	L1	**WO-2026-000042**	WO-2026-000039	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	259258.974074 kg
2	L1	**WO-2026-000044**	WO-2026-000039	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	259258.974074 kg
3	MAIN	**WO-2026-000039**		FINAL / MAIN	BCL5 U-S000-0027-0250A04Y | BOM-000006	777777 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.



OPERATION TYPE LEGEND

CONDUCTOR / STRANDING

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-2026-000039

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: 777777 kg Customer: |
WO Date/Time: 2026-09-28 12:39:33

MAIN WO BARCODE

WO-2026-000039-MAIN-000040

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 12:39:33	**PDF Generated Date / Time**	2026-11-20 03:06:21

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-2026-000039-010-OP030-47

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		777777 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	259258.974074 kg	**WO-2026-000040**	NEXT: WO-2026-000039 -> WO-2026-000040
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	259258.974074 kg	**WO-2026-000042**	NEXT: WO-2026-000039 -> WO-2026-000042
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	259258.974074 kg	**WO-2026-000044**	NEXT: WO-2026-000039 -> WO-2026-000044

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-2026-000039 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000040

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: 259258.974074 kg Customer: |

WO Date/Time: 2026-09-28 12:39:33

MAIN WO BARCODE

WO-2026-000040-MAIN-000041

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000039
Parent Operation	10 | OP030 Bunching / Double Twist	**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 12:39:33	**PDF Generated Date / Time**	2026-11-20 03:06:21

WORK ORDER NOTES

Generated from parent WO-2026-000039 / 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-2026-000040-010-OP020-48

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		259258.974074 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	260296.00997 kg	**WO-2026-000041**	NEXT: WO-2026-000040 -> WO-2026-000041

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-2026-000040 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000041

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: 260296.00997 kg Customer: |

WO Date/Time: 2026-09-28 12:39:33

MAIN WO BARCODE

WO-2026-000041-MAIN-000042

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000040
Parent Operation	10 | OP020 Multiwire Drawing	**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 12:39:33	**PDF Generated Date / Time**	2026-11-20 03:06:21

WORK ORDER NOTES

Generated from parent WO-2026-000040 / 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-2026-000041-010-OP010-49

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		260296.00997 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	**262898.97007**	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-2026-000039 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000042

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: 259258.974074 kg Customer: |

WO Date/Time: 2026-09-28 12:39:34

MAIN WO BARCODE

WO-2026-000042-MAIN-000043

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000039
Parent Operation	10 | OP030 Bunching / Double Twist	**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 12:39:34	**PDF Generated Date / Time**	2026-11-20 03:06:21

WORK ORDER NOTES

Generated from parent WO-2026-000039 / 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-2026-000042-010-OP020-50

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		259258.974074 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	260296.00997 kg	**WO-2026-000043**	NEXT: WO-2026-000042 -> WO-2026-000043

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-2026-000042 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000043

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: 260296.00997 kg Customer: |

WO Date/Time: 2026-09-28 12:39:34

MAIN WO BARCODE

WO-2026-000043-MAIN-000044

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000042
Parent Operation	10 | OP020 Multiwire Drawing	**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 12:39:34	**PDF Generated Date / Time**	2026-11-20 03:06:21

WORK ORDER NOTES

Generated from parent WO-2026-000042 / 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-2026-000043-010-OP010-51

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		260296.00997 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	**262898.97007**	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-2026-000039 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000044

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: 259258.974074 kg Customer: |

WO Date/Time: 2026-09-28 12:39:34

MAIN WO BARCODE

WO-2026-000044-MAIN-000045

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000039
Parent Operation	10 | OP030 Bunching / Double Twist	**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 12:39:34	**PDF Generated Date / Time**	2026-11-20 03:06:21

WORK ORDER NOTES

Generated from parent WO-2026-000039 / 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-2026-000044-010-OP020-52

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		259258.974074 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	260296.00997 kg	**WO-2026-000045**	NEXT: WO-2026-000044 -> WO-2026-000045

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-2026-000044 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000045

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: 260296.00997 kg Customer: |

WO Date/Time: 2026-09-28 12:39:34

MAIN WO BARCODE

WO-2026-000045-MAIN-000046

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000044
Parent Operation	10 | OP020 Multiwire Drawing	**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 12:39:34	**PDF Generated Date / Time**	2026-11-20 03:06:21

WORK ORDER NOTES

Generated from parent WO-2026-000044 / 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-2026-000045-010-OP010-53

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		260296.00997 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	**262898.97007**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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