COMPLETE PRODUCTION WORK ORDER PACKAGE

ROOT / MAIN: WO-2026-000046 SELECTED BOM: BOM-000006 / Rev.0

Contains full frozen details for MAIN + every nested Child BOM Work Order.
PDF Generated: 2026-11-20 00:16:29

WORK ORDER / BOM RELATIONSHIP INDEX

Level	Work Order	Parent	Parent Operation	Product / BOM	Qty	Status
MAIN	**WO-2026-000046**		ROOT	BCL5 U-S000-0027-0250A04Y | BOM-000006	55555 kg	PLANNED
L1	**WO-2026-000047**	WO-2026-000046	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	18518.331482 kg	PLANNED
L2	**WO-2026-000048**	WO-2026-000047	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	18592.404808 kg	PLANNED
L1	**WO-2026-000049**	WO-2026-000046	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	18518.331482 kg	PLANNED
L2	**WO-2026-000050**	WO-2026-000049	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	18592.404808 kg	PLANNED
L1	**WO-2026-000051**	WO-2026-000046	10 OP030 Bunching / Double Twist	> BCL5 N-N000-0009-0250007Y | BOM-000005	18518.331482 kg	PLANNED
L2	**WO-2026-000052**	WO-2026-000051	10 OP020 Multiwire Drawing	> > BCL1 N-N000-0001-1250005Y | BOM-00000	18592.404808 kg	PLANNED

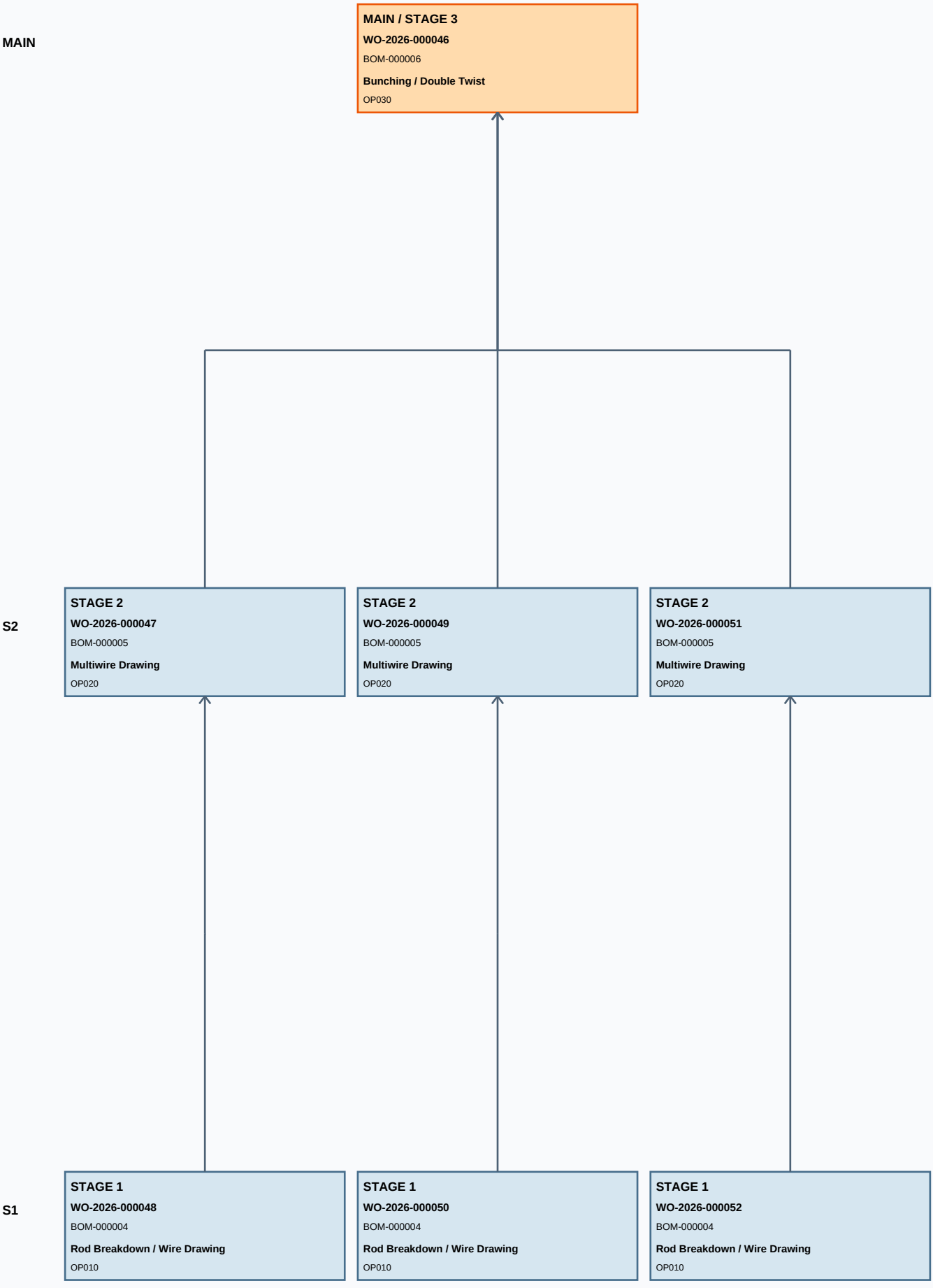
PRODUCTION / MANUFACTURING SEQUENCE - PRODUCE FROM DEEPEST CHILD TO MAIN

Prod Seq	Level	Work Order	Parent	Parent Operation	Product / BOM	Qty
1	L2	**WO-2026-000048**	WO-2026-000047	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	18592.404808 kg
1	L2	**WO-2026-000050**	WO-2026-000049	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	18592.404808 kg
1	L2	**WO-2026-000052**	WO-2026-000051	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	18592.404808 kg
2	L1	**WO-2026-000047**	WO-2026-000046	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	18518.331482 kg
2	L1	**WO-2026-000049**	WO-2026-000046	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	18518.331482 kg
2	L1	**WO-2026-000051**	WO-2026-000046	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	18518.331482 kg
3	MAIN	**WO-2026-000046**		FINAL / MAIN	BCL5 U-S000-0027-0250A04Y | BOM-000006	55555 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-2026-000046

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: 55555 kg Customer: |

WO Date/Time: 2026-09-28 12:52:34

MAIN WO BARCODE

WO-2026-000046-MAIN-000047

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 12:52:34	**PDF Generated Date / Time**	2026-11-20 00:16:29

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-2026-000046-010-OP030-54

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		55555 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	18518.331482 kg	**WO-2026-000047**	NEXT: WO-2026-000046 -> WO-2026-000047
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	18518.331482 kg	**WO-2026-000049**	NEXT: WO-2026-000046 -> WO-2026-000049
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	18518.331482 kg	**WO-2026-000051**	NEXT: WO-2026-000046 -> WO-2026-000051

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-2026-000046 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000047

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: 18518.331482 kg Customer: |

WO Date/Time: 2026-09-28 12:52:34

MAIN WO BARCODE

WO-2026-000047-MAIN-000048

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000046
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 12:52:34	**PDF Generated Date / Time**	2026-11-20 00:16:29

WORK ORDER NOTES

Generated from parent WO-2026-000046 / 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-2026-000047-010-OP020-55

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		18518.331482 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	18592.404808 kg	**WO-2026-000048**	NEXT: WO-2026-000047 -> WO-2026-000048

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-2026-000047 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000048

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: 18592.404808 kg Customer: |

WO Date/Time: 2026-09-28 12:52:34

MAIN WO BARCODE

WO-2026-000048-MAIN-000049

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000047
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 12:52:34	**PDF Generated Date / Time**	2026-11-20 00:16:29

WORK ORDER NOTES

Generated from parent WO-2026-000047 / 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-2026-000048-010-OP010-56

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		18592.404808 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	**18778.328856**	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-2026-000046 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000049

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: 18518.331482 kg Customer: |

WO Date/Time: 2026-09-28 12:52:34

MAIN WO BARCODE

WO-2026-000049-MAIN-000050

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000046
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 12:52:34	**PDF Generated Date / Time**	2026-11-20 00:16:29

WORK ORDER NOTES

Generated from parent WO-2026-000046 / 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-2026-000049-010-OP020-57

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		18518.331482 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	18592.404808 kg	**WO-2026-000050**	NEXT: WO-2026-000049 -> WO-2026-000050

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-2026-000049 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000050

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: 18592.404808 kg Customer: |

WO Date/Time: 2026-09-28 12:52:35

MAIN WO BARCODE

WO-2026-000050-MAIN-000051

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000049
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 12:52:35	**PDF Generated Date / Time**	2026-11-20 00:16:29

WORK ORDER NOTES

Generated from parent WO-2026-000049 / 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-2026-000050-010-OP010-58

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		18592.404808 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	**18778.328856**	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-2026-000046 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000051

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: 18518.331482 kg Customer: |

WO Date/Time: 2026-09-28 12:52:35

MAIN WO BARCODE

WO-2026-000051-MAIN-000052

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000046
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 12:52:35	**PDF Generated Date / Time**	2026-11-20 00:16:29

WORK ORDER NOTES

Generated from parent WO-2026-000046 / 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-2026-000051-010-OP020-59

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		18518.331482 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	18592.404808 kg	**WO-2026-000052**	NEXT: WO-2026-000051 -> WO-2026-000052

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-2026-000051 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000052

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: 18592.404808 kg Customer: |

WO Date/Time: 2026-09-28 12:52:35

MAIN WO BARCODE

WO-2026-000052-MAIN-000053

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000051
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 12:52:35	**PDF Generated Date / Time**	2026-11-20 00:16:29

WORK ORDER NOTES

Generated from parent WO-2026-000051 / 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-2026-000052-010-OP010-60

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		18592.404808 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	**18778.328856**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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