COMPLETE PRODUCTION WORK ORDER PACKAGE

ROOT / MAIN: WO-2026-000068 SELECTED BOM: BOM-000010 / Rev.0

Contains full frozen details for MAIN + every nested Child BOM Work Order.
PDF Generated: 2026-11-20 03:17:40

WORK ORDER / BOM RELATIONSHIP INDEX

Level	Work Order	Parent	Parent Operation	Product / BOM	Qty	Status
MAIN	WO-2026-000068		ROOT	C1 1000 02X05BB5LYYGDC0Y | BOM-000010	1000 m	PLANNED
L1	WO-2026-000069	WO-2026-000068	10 OP090 Cabling / Lay-up	> S1001 01B5YLY070B5YYYA22 | BOM-000008	1015 m	PLANNED
L2	WO-2026-000070	WO-2026-000069	10 OP060 Insulation Extrusion	> > BCL5 U-S000-0027-0250A04Y | BOM-000006	1015 kg	PLANNED
L3	WO-2026-000071	WO-2026-000070	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg	PLANNED
L4	WO-2026-000072	WO-2026-000071	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg	PLANNED
L3	WO-2026-000073	WO-2026-000070	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg	PLANNED
L4	WO-2026-000074	WO-2026-000073	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg	PLANNED
L3	WO-2026-000075	WO-2026-000070	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg	PLANNED
L4	WO-2026-000076	WO-2026-000075	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg	PLANNED
L1	WO-2026-000077	WO-2026-000068	10 OP090 Cabling / Lay-up	> S1001 01B5YLY070B5YYYA22 | BOM-000008	1015 m	PLANNED
L2	WO-2026-000078	WO-2026-000077	10 OP060 Insulation Extrusion	> > BCL5 U-S000-0027-0250A04Y | BOM-000006	1015 kg	PLANNED
L3	WO-2026-000079	WO-2026-000078	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg	PLANNED
L4	WO-2026-000080	WO-2026-000079	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg	PLANNED
L3	WO-2026-000081	WO-2026-000078	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg	PLANNED
L4	WO-2026-000082	WO-2026-000081	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg	PLANNED
L3	WO-2026-000083	WO-2026-000078	10 OP030 Bunching / Double Twist	> > > BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg	PLANNED
L4	WO-2026-000084	WO-2026-000083	10 OP020 Multiwire Drawing	> > > > BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg	PLANNED

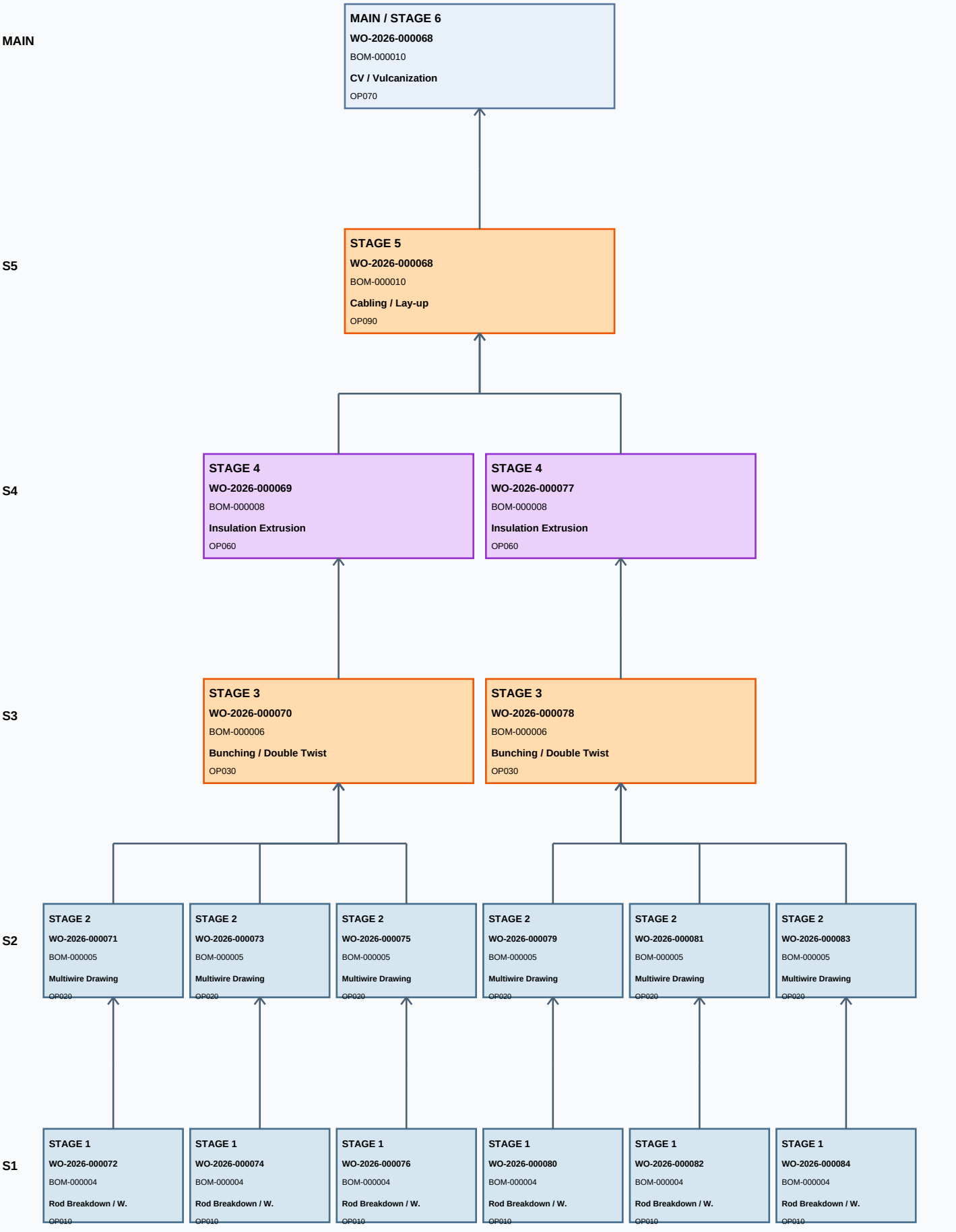
PRODUCTION / MANUFACTURING SEQUENCE - PRODUCE FROM DEEPEST CHILD TO MAIN

Prod Seq	Level	Work Order	Parent	Parent Operation	Product / BOM	Qty
1	L4	WO-2026-000072	WO-2026-000071	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg
1	L4	WO-2026-000074	WO-2026-000073	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg
1	L4	WO-2026-000076	WO-2026-000075	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg
1	L4	WO-2026-000080	WO-2026-000079	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg
1	L4	WO-2026-000082	WO-2026-000081	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg
1	L4	WO-2026-000084	WO-2026-000083	10 OP020 Multiwire Drawing	BCL1 N-N000-0001-1250005Y | BOM-000004	339.686633 kg
2	L3	WO-2026-000071	WO-2026-000070	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg
2	L3	WO-2026-000073	WO-2026-000070	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg
2	L3	WO-2026-000075	WO-2026-000070	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg
2	L3	WO-2026-000079	WO-2026-000078	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg
2	L3	WO-2026-000081	WO-2026-000078	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg
2	L3	WO-2026-000083	WO-2026-000078	10 OP030 Bunching / Double Twist	BCL5 N-N000-0009-0250007Y | BOM-000005	338.3333 kg
3	L2	WO-2026-000070	WO-2026-000069	10 OP060 Insulation Extrusion	BCL5 U-S000-0027-0250A04Y | BOM-000006	1015 kg
3	L2	WO-2026-000078	WO-2026-000077	10 OP060 Insulation Extrusion	BCL5 U-S000-0027-0250A04Y | BOM-000006	1015 kg
4	L1	WO-2026-000069	WO-2026-000068	10 OP090 Cabling / Lay-up	S1001 01B5YLY070B5YYYA22 | BOM-000008	1015 m
4	L1	WO-2026-000077	WO-2026-000068	10 OP090 Cabling / Lay-up	S1001 01B5YLY070B5YYYA22 | BOM-000008	1015 m
5	MAIN	WO-2026-000068		FINAL / MAIN	C1 1000 02X05BB5LYYGDC0Y | BOM-000010	1000 m

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-2026-000068

PRODUCT

C1 1000 02X05BB5LYYGDC0Y | H07RN-F 2X2.5 mm2

Qty: 1000 m Customer: |

WO Date/Time: 2026-10-04 14:27:05

MAIN WO BARCODE

WO-2026-000068-MAIN-000069

WORK ORDER DETAILS

Selected BOM	BOM-000010 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	MAIN / L0	**Parent WO**	
Parent Operation	--	**Frozen Snapshot**	v1
Standard / Voltage	450/750	**Core / Section**	2 / 2.5 mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:05	**PDF Generated Date / Time**	2026-11-20 03:17:40

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000010 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000010 / Rev.0	**OP090 | Cabling / Lay-up**	F02-M03 | Rigid Strander	|
20	BOM-000010 / Rev.0	**OP070 | CV / Vulcanization**	F03-M08 | Outer Sheathing Line	|

OP 10 - OP090 | Cabling / Lay-up

BOM: BOM-000010 / Rev.0 Source Seq: 10

Machine: F02-M03 | Rigid Strander Work Centre: |

Speed: 144 m/min

Setup: 34324 min Scrap: 0%

WO-2026-000068-010-OP090-76

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1000 m	**m**	**144 m/min**	34324 min	131 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Lay Type	**234324**				
Lay Direction	**234324**				
Minimum Lay Length	**23432**	4324	234		
Nominal Lay Length					
Maximum Lay Length					
Lay Ratio			234		
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					
Yarn Weight					
Color and Number Sequence					

Process Type	**4324**				
Material Standard	**234**				
Color					
Color Masterbatch Ratio (%)				%	
Color Masterbatch Type					
Input Diameter					
Manufacturing Wall Thickness (mm)				mm	
Manufacturing Minimum Wall Thickness (mm)				mm	
Manufacturing Maximum Wall Thickness (mm)				mm	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)	**234**		234	mm	
Standard Minimum Diameter					
Standard Maximum Diameter	**42**	4234			42334
Material Weight (kg/km)			4	kg/km	
Note					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Assembly OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21	BOM-000008 / Rev.0	1015 m	1015 m	**WO-2026-000069**	NEXT: WO-2026-000068 -> WO-2026-000069
S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21	BOM-000008 / Rev.0	1015 m	1015 m	**WO-2026-000077**	NEXT: WO-2026-000068 -> WO-2026-000077

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

OP 20 - OP070 | CV / Vulcanization

BOM: BOM-000010 / Rev.0 Source Seq: 20

Machine: F03-M08 | Outer Sheathing Line Work Centre: |

Speed: 45 m/min

Setup: 4545 min Scrap: 1%

WO-2026-000068-020-OP070-77

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1000 m	**1000 m**	**45 m/min**	4545 min	4545 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Process Type					
Material Standard					
Color					
Color Masterbatch Ratio (%)				%	

Color Masterbatch Type					
Catalyst Ratio (%)				%	
Insulation Input Diameter					
Nominal Wall Thickness (mm)				mm	
Minimum Point Wall Thickness (mm)				mm	
Maximum Point Wall Thickness (mm)				mm	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)				mm	
Insulation Resistance (M?.km)				Mohm/km	
Standard Minimum Diameter					
Standard Maximum Diameter					
Material Weight (kg/km)				kg/km	
Insulation Marking					
Note					
Tensile Strength / Elongation Values					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Curing Pressure				bar	
Curing Temperature				?C	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Hot Set Elongation				%	

RAW MATERIALS / COMPONENTS - OP 20 ONLY

Material Code	Material Name	BOM Qty	WO Required	Unit	Role	Scrap %	Notes
CMP-RUB-002	CPE Rubber Sheathing Compound	100	**105**	kg		5%	

OP 20 - OPERATOR / QC SIGN-OFF

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

CHILD WORK ORDER - LEVEL 1 **PARENT WO-2026-000068 / OP 10 OP090 Cabling / Lay-up**

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

PRODUCTION WORK ORDER
WO-2026-000069

PRODUCT

S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21

Qty: 1015 m Customer: |

WO Date/Time: 2026-10-04 14:27:05

MAIN WO BARCODE

WO-2026-000069-MAIN-000070

WORK ORDER DETAILS

Selected BOM	BOM-000008 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000068
Parent Operation	10 | OP090 Cabling / Lay-up	**Frozen Snapshot**	v1
Standard / Voltage		**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:05	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000068 / OP 10 OP090

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000008 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000008 / Rev.0	**OP060 | Insulation Extrusion**	F02-M04 | XLPE Insulation Line	|

OP 10 - OP060 | Insulation Extrusion

BOM: BOM-000008 / Rev.0 Source Seq: 10

Machine: F02-M04 | XLPE Insulation Line Work Centre: |

Speed: 100 m/min

Setup: 45 min Scrap: 5%

WO-2026-000069-010-OP060-78

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1015 m	**1000 m**	**100 m/min**	45 min	23 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Process Type					
Material Standard					
Color					
Color Masterbatch Ratio (%)				%	
Color Masterbatch Type					
Catalyst Ratio (%)				%	
Anti-Rodent Additive Ratio (%)				%	
Anti-Termite Additive Ratio (%)				%	
Flame-Retardant Additive Ratio (%)				%	
Foaming Additive Ratio (%)				%	
Nominal Wall Thickness (mm)				mm	
Minimum Point Wall Thickness (mm)				mm	
Nominal Diameter (mm)				mm	
Minimum Diameter (mm)				mm	
Maximum Diameter (mm)				mm	
Manufacturing Wall Thickness (mm)				mm	
Manufacturing Minimum Wall Thickness (mm)				mm	

Manufacturing Maximum Wall Thickness (mm)				mm	
Material Weight (kg/km)				kg/km	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)				mm	
Insulation Input Diameter					
Maximum Point Wall Thickness (mm)				mm	
Insulation Resistance (M?.km)				Mohm/km	
Standard Minimum Diameter					
Standard Maximum Diameter					
Insulation Marking					
Note					
Tensile Strength / Elongation Values					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Extruder Zone Temperatures				?C	
Head Temperature				?C	
Screw Speed				rpm	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Minimum Thickness				mm	
Spark Test Voltage				kV	
Insulated Core OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
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	BOM-000006 / Rev.0	1000 kg	1015 kg	**WO-2026-000070**	NEXT: WO-2026-000069 -> WO-2026-000070

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-2026-000069 / OP 10 OP060 Insulation Extrusion**

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

PRODUCTION WORK ORDER
WO-2026-000070

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: 1015 kg Customer: |
WO Date/Time: 2026-10-04 14:27:05

MAIN WO BARCODE

WO-2026-000070-MAIN-000071

WORK ORDER DETAILS

Selected BOM	BOM-000006 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000069
Parent Operation	10 | OP060 Insulation Extrusion	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:05	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000069 / OP 10 OP060

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-2026-000070-010-OP030-79

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1015 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	338.3333 kg	**WO-2026-000071**	NEXT: WO-2026-000070 -> WO-2026-000071
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	338.3333 kg	**WO-2026-000073**	NEXT: WO-2026-000070 -> WO-2026-000073
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	338.3333 kg	**WO-2026-000075**	NEXT: WO-2026-000070 -> WO-2026-000075

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 3 **PARENT WO-2026-000070 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000071

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: 338.3333 kg Customer: |

WO Date/Time: 2026-10-04 14:27:05

MAIN WO BARCODE

WO-2026-000071-MAIN-000072

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000070
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:05	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000070 / 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-2026-000071-010-OP020-80

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		338.3333 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	339.686633 kg	**WO-2026-000072**	NEXT: WO-2026-000071 -> WO-2026-000072

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 4 **PARENT WO-2026-000071 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000072

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: 339.686633 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000072-MAIN-000073

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000071
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000071 / 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-2026-000072-010-OP010-81

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		339.686633 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	**343.083499**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000070 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000073

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: 338.3333 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000073-MAIN-000074

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000070
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000070 / 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-2026-000073-010-OP020-82

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		338.3333 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	339.686633 kg	**WO-2026-000074**	NEXT: WO-2026-000073 -> WO-2026-000074

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 4 **PARENT WO-2026-000073 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000074

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: 339.686633 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000074-MAIN-000075

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000073
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000073 / 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-2026-000074-010-OP010-83

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		339.686633 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	**343.083499**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000070 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000075

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: 338.3333 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000075-MAIN-000076

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000070
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000070 / 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-2026-000075-010-OP020-84

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		338.3333 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	339.686633 kg	**WO-2026-000076**	NEXT: WO-2026-000075 -> WO-2026-000076

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 4 **PARENT WO-2026-000075 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000076

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: 339.686633 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000076-MAIN-000077

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000075
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000075 / 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-2026-000076-010-OP010-85

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		339.686633 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	**343.083499**	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-2026-000068 / OP 10 OP090 Cabling / Lay-up**

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

PRODUCTION WORK ORDER
WO-2026-000077

PRODUCT

S1001 01B5YLY070B5YYYA22 | Single | H07RN-F | - | 0.5 | Bare bunched class 5 | YOK | P-EPR | YOK | 0,7 | B | YOK | Y | YOK | NO CLOUR | EN 50525-2-21

Qty: 1015 m Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000077-MAIN-000078

WORK ORDER DETAILS

Selected BOM	BOM-000008 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L1	**Parent WO**	WO-2026-000068
Parent Operation	10 | OP090 Cabling / Lay-up	**Frozen Snapshot**	v1
Standard / Voltage		**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000068 / OP 10 OP090

THIS WORK ORDER - PRODUCT TREE / BOM SEQUENCE

1.	**BOM-000008 / Rev.0**

THIS WORK ORDER - ROUTING / OPERATION SEQUENCE

WO Seq	Source BOM	Operation	Machine	Work Centre
10	BOM-000008 / Rev.0	**OP060 | Insulation Extrusion**	F02-M04 | XLPE Insulation Line	|

OP 10 - OP060 | Insulation Extrusion

BOM: BOM-000008 / Rev.0 Source Seq: 10

Machine: F02-M04 | XLPE Insulation Line Work Centre: |

Speed: 100 m/min

Setup: 45 min Scrap: 5%

WO-2026-000077-010-OP060-86

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1015 m	**1000 m**	**100 m/min**	45 min	23 min	

TECHNICAL / ENGINEERING PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Process Type					
Material Standard					
Color					
Color Masterbatch Ratio (%)				%	
Color Masterbatch Type					
Catalyst Ratio (%)				%	
Anti-Rodent Additive Ratio (%)				%	
Anti-Termite Additive Ratio (%)				%	
Flame-Retardant Additive Ratio (%)				%	
Foaming Additive Ratio (%)				%	
Nominal Wall Thickness (mm)				mm	
Minimum Point Wall Thickness (mm)				mm	
Nominal Diameter (mm)				mm	
Minimum Diameter (mm)				mm	
Maximum Diameter (mm)				mm	
Manufacturing Wall Thickness (mm)				mm	
Manufacturing Minimum Wall Thickness (mm)				mm	

Manufacturing Maximum Wall Thickness (mm)				mm	
Material Weight (kg/km)				kg/km	
Manufacturing Nominal Diameter (mm)				mm	
Manufacturing Minimum Diameter (mm)				mm	
Manufacturing Maximum Diameter (mm)				mm	
Insulation Input Diameter					
Maximum Point Wall Thickness (mm)				mm	
Insulation Resistance (M?.km)				Mohm/km	
Standard Minimum Diameter					
Standard Maximum Diameter					
Insulation Marking					
Note					
Tensile Strength / Elongation Values					

PRODUCTION PROCESS PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Extruder Zone Temperatures				?C	
Head Temperature				?C	
Screw Speed				rpm	
Line Speed				m/min	

QUALITY / TEST PARAMETERS

Parameter	Required / Target	Min	Max	Unit	Remarks
Minimum Thickness				mm	
Spark Test Voltage				kV	
Insulated Core OD				mm	

CHILD BOM / NEXT WORK ORDER(S) FROM THIS OPERATION

Child Product	Child BOM	Qty/Output	WO Required	Generated Child WO	Relationship
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	BOM-000006 / Rev.0	1000 kg	1015 kg	**WO-2026-000078**	NEXT: WO-2026-000077 -> WO-2026-000078

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-2026-000077 / OP 10 OP060 Insulation Extrusion**

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

PRODUCTION WORK ORDER
WO-2026-000078

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: 1015 kg Customer: |
WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000078-MAIN-000079

WORK ORDER DETAILS

Selected BOM	BOM-000006 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L2	**Parent WO**	WO-2026-000077
Parent Operation	10 | OP060 Insulation Extrusion	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000077 / OP 10 OP060

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-2026-000078-010-OP030-87

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		1015 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	338.3333 kg	**WO-2026-000079**	NEXT: WO-2026-000078 -> WO-2026-000079
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	338.3333 kg	**WO-2026-000081**	NEXT: WO-2026-000078 -> WO-2026-000081
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	338.3333 kg	**WO-2026-000083**	NEXT: WO-2026-000078 -> WO-2026-000083

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 3 **PARENT WO-2026-000078 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000079

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: 338.3333 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000079-MAIN-000080

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000078
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000078 / 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-2026-000079-010-OP020-88

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		338.3333 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	339.686633 kg	**WO-2026-000080**	NEXT: WO-2026-000079 -> WO-2026-000080

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 4 **PARENT WO-2026-000079 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000080

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: 339.686633 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000080-MAIN-000081

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000079
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000079 / 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-2026-000080-010-OP010-89

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		339.686633 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	**343.083499**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000078 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000081

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: 338.3333 kg Customer: |

WO Date/Time: 2026-10-04 14:27:06

MAIN WO BARCODE

WO-2026-000081-MAIN-000082

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000078
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:06	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000078 / 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-2026-000081-010-OP020-90

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		338.3333 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	339.686633 kg	**WO-2026-000082**	NEXT: WO-2026-000081 -> WO-2026-000082

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 4 **PARENT WO-2026-000081 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000082

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: 339.686633 kg Customer: |

WO Date/Time: 2026-10-04 14:27:07

MAIN WO BARCODE

WO-2026-000082-MAIN-000083

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000081
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:07	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000081 / 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-2026-000082-010-OP010-91

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		339.686633 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	**343.083499**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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

CHILD WORK ORDER - LEVEL 3 **PARENT WO-2026-000078 / OP 10 OP030 Bunching / Double Twist**

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

PRODUCTION WORK ORDER
WO-2026-000083

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: 338.3333 kg Customer: |

WO Date/Time: 2026-10-04 14:27:07

MAIN WO BARCODE

WO-2026-000083-MAIN-000084

WORK ORDER DETAILS

Selected BOM	BOM-000005 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L3	**Parent WO**	WO-2026-000078
Parent Operation	10 | OP030 Bunching / Double Twist	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:07	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000078 / 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-2026-000083-010-OP020-92

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		338.3333 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	339.686633 kg	**WO-2026-000084**	NEXT: WO-2026-000083 -> WO-2026-000084

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 4 **PARENT WO-2026-000083 / OP 10 OP020 Multiwire Drawing**

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

PRODUCTION WORK ORDER
WO-2026-000084

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: 339.686633 kg Customer: |

WO Date/Time: 2026-10-04 14:27:07

MAIN WO BARCODE

WO-2026-000084-MAIN-000085

WORK ORDER DETAILS

Selected BOM	BOM-000004 / Rev.0	**Status / Priority**	PLANNED / NORMAL
WO Role / Level	CHILD / L4	**Parent WO**	WO-2026-000083
Parent Operation	10 | OP020 Multiwire Drawing	**Frozen Snapshot**	v1
Standard / Voltage	IEC	**Core / Section**	mm2
Factory		**Department**	
Work Centre		**Responsible**	
Order / Due	2026-10-04	**Planned Start**	
WO Created Date / Time	2026-10-04 14:27:07	**PDF Generated Date / Time**	2026-11-20 03:17:40

WORK ORDER NOTES

Generated from parent WO-2026-000083 / 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-2026-000084-010-OP010-93

PLANNED PRODUCTION

Start	Finish	Input Qty	Output Qty	Speed	Setup	Duration	Semi-Finished Output
		339.686633 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	**343.083499**	kg		1%	

OP 10 - OPERATOR / QC SIGN-OFF

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