BMW GROUP
Corporate Communications

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BMW Group opens high-voltage battery assembly plant in Woodruff and marks the start of fully electric vehicle production in the US

Plant Woodruff begins assembly of Gen6 high-voltage batteries for electric vehicles assembled at Plant Spartanburg – Fourth site in Gen6 production network to start series production – Efficient production using AI and VR – Highest quality standards through consistent zero-defect approach – Local for Local: only 15 miles from Spartanburg vehicle plant

Woodruff, South Carolina, USA. The BMW Group officially opened its new Plant Woodruff in South Carolina today, marking the start of series production. The facility will supply sixth-generation (Gen6) high-voltage batteries for installation in the new BMW iX5 and future electric vehicles at BMW Group Plant Spartanburg, which is located just 15 miles away. The iX5 is BMW's first fully electric model to be assembled in the United States. "Electromobility is our most important growth area. That is why we are systematically electrifying our portfolio, with the US playing a key role: By 2030, we will be assembling at least six fully electric models at Plant Spartanburg," says **Raymond Wittmann, Member of the Board of Management of BMW AG, responsible for Production.** "The start of series production of Gen6 high-voltage batteries in Woodruff is therefore much more than the successful launch of a new site: it lays the foundation for the first-ever series production of fully electric BMW vehicles at Plant Spartanburg and on the American continent. This marks the beginning of the next chapter in the success story of the largest plant in our global production network." Following Debrecen (Hungary), Irlbach-Straßkirchen (Germany) and Shenyang (China), Woodruff is the fourth site in the BMW Group production network to begin series production of Gen6 high-voltage batteries. With AI-supported production processes, digital twins and virtual reality applications, the new plant is setting industry standards for the assembly of high-voltage batteries.

Henry McMaster, Governor of South Carolina: "BMW continues to deliver on its commitments to South Carolina. Just a few years ago, I stood on this site with BMW leadership to break ground on this facility. Today, we are seeing that investment come to life and marking another milestone in BMW's commitment to South Carolina. BMW has been a strong partner

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to our state, and this latest investment reinforces what we have built together and the opportunities ahead."

Robert Engelhorn, President and CEO of BMW Manufacturing Co., LLC in Spartanburg: "We said we would begin assembling fully electric BMW vehicles in the US by the end of 2026 – and we are delivering on that commitment. With today's opening of Plant Woodruff, we are further expanding our footprint in South Carolina and strengthening the close integration of battery and vehicle production. High-voltage batteries assembled at this state-of-the-art facility will power the next generation of fully electric BMW X models from Plant Spartanburg."

Local for local: Five Gen6 high-voltage battery sites

Assembly of the Gen6 high-voltage batteries takes place at five new facilities, which the BMW Group built close to its vehicle plants, in line with its "local for local" principle. In addition to Woodruff, four more state-of-the-art high-voltage battery assembly plants have also been built: Debrecen (Hungary), Irlbach-Straßkirchen (Germany), Shenyang (China) and San Luis Potosí (Mexico). Gen6 high-voltage batteries have been series produced in Debrecen, Hungary, since October 2025. Plants Irlbach-Straßkirchen and Shenyang began series production in October 2026. Plant San Luis Potosí will follow in 2027. "With the opening of our Woodruff plant, we are expanding our global Gen6 network: high-voltage battery assembly is now in place in Europe, Asia and North America. This creates a key prerequisite for assembling fully electric Neue Klasse vehicles on three continents," says Wittmann. "The rapid establishment of our Gen6 sites demonstrates the strength of our production network: we share know-how across locations and industrialize our new battery technology worldwide at speed. In doing so, we combine the strength of our global network with regional manufacturing, in line with our 'Local for Local' principle."

Intelligent production for maximum quality

The BMW Group has established state-of-the-art, intelligent and efficient production processes for its in-house developed Gen6 high-voltage battery. The new cylindrical round cells are integrated directly into the high-voltage battery, based on the "cell-to-pack" principle. All production steps are continuously monitored inline and comprehensively documented in real time. AI assistants and agents developed in-house analyse this data and, together with more than 300 employees and 250 robots at Plant Woodruff, help ensure zero-defect battery production. At the same time, the extensive use of artificial intelligence enhances Overall Equipment Effectiveness (OEE) in

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production. Well before commissioning, digital twins of production and virtual reality applications support planning and employee training.

Training in a virtual factory

All production staff at Plant Woodruff complete a VR training program developed on site. Within a virtual factory, they can practice real manufacturing operations under realistic conditions. This virtual environment replicates the plant's production lines in meticulous detail. The training helps employees develop an understanding of relevant processes and builds confidence in operating the equipment before they use it for the first time in actual production.

From start of construction to series production in just over three years

Following the official groundbreaking in June 2023, construction of the new plant began in September 2023. Just one year later, in September 2024, while construction was still under way, installation of the manufacturing equipment began, with the first test and pre-series batteries rolling off the assembly line in summer 2025. "With today's opening of Plant Woodruff, we demonstrate how quickly we can scale a new battery concept to industrial production," said **Rich Everly, Vice President Responsible for Manufacturing at BMW Group Plant Woodruff**. "The key factor here is the interaction between a skilled and committed team and the continuous sharing of experience within the production network."

Gen6 battery cells with reduced carbon footprint

The Gen6 battery cells for the BMW iX5 include a high proportion of secondary materials in their cobalt, lithium and nickel content. Renewable energy is also used in the production of anode and cathode materials, as well as in cell manufacturing. Compared with the Gen5 cell used in the BMW iX, CO_2e emissions have been reduced by around 28 percent per watt-hour. Plant Woodruff does not use any fossil fuels during normal operations, while the site's industrial trucks are powered by hydrogen.

How the BMW Group assembles its Gen6 high-voltage batteries

The BMW Group sources battery cells for its high-voltage batteries from leading cell manufacturers. The highest technical standards apply. Upon receipt of goods, additional

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measurements – such as voltage checks – are carried out. This is followed by so-called cell clustering, where the battery cells are connected to coolers. This step ensures optimal insulation and cooling of the cells. The cell clusters and cell contact system are then laser-cleaned and welded with pinpoint precision. The in-line inspection continuously monitors each weld seam in real time, while an innovative foaming process ensures that all elements are protected as a mechanical unit. The hardened foam guarantees the safety, stability and durability of the high-voltage battery. The housing is then closed, sealed and riveted. In the final assembly step, the Energy Master – the central control unit – is installed onto the high-voltage battery. Finally, each high-voltage battery undergoes a 100% end-of-line inspection. From Woodruff, the high-voltage batteries are transported to Plant Spartanburg, located just 15 miles away.

Questions and answers

Why is the BMW Group assembling high-voltage batteries in Woodruff?
The site’s proximity to BMW Group Plant Spartanburg is a major advantage. The Gen6 high-voltage batteries assembled in Woodruff are transported only 15 miles to Spartanburg, where they are installed in the new BMW iX5, the first fully electric vehicle assembled in the United States. In this way, the BMW Group is implementing its “local for local” principle and closely integrating battery and vehicle production in South Carolina.

Will battery cells also be produced in Woodruff?
No. In Woodruff, supplied battery cells are assembled into Gen6 high-voltage batteries. The BMW Group sources the battery cells from leading cell manufacturers, which manufacture them to the company's specifications. At the plant, the cells are inspected and then integrated

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directly into the high-voltage battery, based on the “cell-to-pack” principle. The BMW Group maintains its product and process expertise for battery cells through its own competence centres in Bavaria.

What role do AI and automation play in production?

All production steps are monitored inline and documented in real time. AI assistants and agents developed in-house analyze the data generated in this way, support production processes and ensure quality. More than 300 employees and around 250 robots work together at Plant Woodruff. Each high-voltage battery also undergoes a 100-percent end-of-line inspection.

What are the advantages of Gen6 battery technology?

The new round cells offer more than 20 percent higher energy density than the previous cell generation. Charging times are reduced by up to 30 percent and range is 30 percent higher – even more in certain models.

Over what period did the BMW Group build Plant Woodruff?

Following the groundbreaking in June 2023, construction of the plant began in September 2023. Just one year later, while construction was still under way, installation of the manufacturing equipment commenced. Production of the first test and pre-series batteries began in summer 2025. The official inauguration marks the start of series production. This means just over three years elapsed between the start of construction and the start of series production.

If you have any questions, please contact:

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The BMW Group

With its four brands, BMW, MINI, Rolls-Royce and BMW Motorrad, the BMW Group is the world's leading premium manufacturer of automobiles and motorcycles and also provides premium financial services. The BMW Group production network comprises over 30 production sites worldwide; the company has a global sales network in more than 140 countries.

In 2025, the BMW Group sold 2.46 million passenger vehicles and more than 202,500 motorcycles worldwide. The profit before tax in the financial year 2025 was € 10.2 billion on revenues amounting to € 133.5 billion. As of 31 December 2025, the BMW Group had a workforce of 154,540 employees.

The economic success of the BMW Group has always been based on long-term thinking and responsible action. Sustainability is a key element of the BMW Group's corporate strategy and covers all products – from the supply chain through production to the end of their useful life.

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