

福星制衣越南廠 制衣工程 IE 出數核定流程表

由越南廠的 IE 人員，依據上線款式，製作工程表及時間初估表。

經越南廠生產部會商研究後，由生產主管提出效率建議與工程改善說明。並簽字
經越南廠總經理核實後，將文件呈送臺北公司做最後核可。

依臺北公司核可之 IE 數據後，作為越南廠的效率評估與績效獎金標準。

款式: G15-030P	款式說明 订单 : 61100	制表人: HUONG	日期: 2015/01/03	文件編號:
參考雷同款:			照片	
生產車縫時間: 2277	特車組時間: 223	總時間: 2500		
生產出數: 12.65	特車組出數: 129.15	IE 總出數: 11.5		
生產線主管意見與建議:			初步審核出數:	
總經理核實與建議:			核實出數:	
臺北公司最後核定與說明:			最後核定出數:	

PPIC 主管:

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1/04

FLOW CHART OF G15-030P

W.BAND*5

- 35" 60. MARK BAND*5
36" 61. JOIN CENTER W.BAND*3
52" 62. JOIN UPPER W.BAND
12" 63. FUSE MEX BAND*1
5" 64. MARK HOOK&EYE*2
14" 65. SEW HOOK&EYE*2
2" 66. WRAP HOOK&EYE*2
44" 67. JOIN BAND LINING+JOIN EDGE BAND(AT RIGHT)
18" 68. SEW CORDING AT W.BAND
25" 69. 1/16STITCH UPPER W.BAND
38" 70. PRESS SEAM OPEN, PRESS UPPER BAND
18" 71. TRIM&TURN
18" 72. TACK W.BAND 1 EDGE
17" 73. PIPING UNDER W.BAND
35" 74. SEW LBL AT ZISE TO LBL MAIN, SEW LBL AT BAND
13" 75. PRESS PIPING

FRONT

- 35" 1. MARK FRONT+PKT POSITION*3
16" 2. SERGE PKT FACING*2*2
20" 3. MARK PKT FACING*2+PKT POSITION*1
27" 4. SET BESOM*1(MACH)(PKT SMALL)
14" 5. SET BESOM*1(HAND)
16" 6. CLOSE 2EDGE*1
3" 7. SERGE BESOM OPEN*1
7" 8. PRESS BESOM OPEN
36" 9. TACK BAG+1/16STITCH AROUND PKT SMALL*1
32" 10. JOIN BAG+BESOM TO PKT OPEN(TEMPLATE)
40" 11. NOTCH & CLOSE EDGE*2
18" 12. PRESS PKT OPEN*2
28" 13. 1/16STITCH PKT OPEN*2
38" 14. TACK PKT FACING TO BAG*2*2
36" 15. TACK PKT FACING TO FRONT*2 (TACK BAG AT W.BAND&OUT SEAM)
38" 16. JOIN BAG*2, TURN+TOPSTITCH BAG*2
17" 17. TACK PKT OPEN*2
32" 18. SERGE AROUND FRONT*2*2
44" 37. JOIN OUT SEAM(CHAIN STITCH MACHINE)
8" 38. SERGE BTM
44" 39. CLOSE VENT AT HEM, TURN
27" 40. PRESS VENT, OUT SEAM+CREASE BTM
50" 41. D/N TOPSTITCH OUT SEAM
36" 42. JOIN IN SEAM*2 (CHAIN STITCH MACHINE)
15" 43. PRESS SEAM INSEAM
17" 44. SERGE FRONT&BACK RISE
38" 45. JOIN FRONT&BACK RISE
21" 46. JOIN FLY, STITCH
18" 47. CREASE FLY, PRESS BACK RISE, INSEAM
35" 54. SET ZIPPER, STITCH
35" 55. TOPSTITCH FLY+CLOSE*2
9" 56. SEW BELT LOOP*5
5" 57. MARK+ CUT BELT LOOP*5
38" 58. SET BELT LOOP*5, MARK
24" 59. AVOI STRETCHABLE AROUND W.BAND
92" 76. SET W.BAND, MARK
86" 77. 1/16FOLDSTITCH UNDER W.BAND
35" 78. 1/16STITCH UPPER W.BAND
58" 79. CLOSE BELT LOOP*5*2
22" 80. TACK LBL AT OUT SEAM*2
48" 81. BLIND BTM
90" 82. TRIM THREAD
8" 001. MARK HOLE AT BAND*1 POSITION
12" 002. SEW HOLE*1
8" 003. BARTACK PKT*4+BELT LOOP*5*2

BACK BODY*4

- 32" 19. MARK ALL BACK BODY
60" 20. SERGE ALL PART BACK*4*2
44" 21. JOIN B. PANEL SEAM*2
40" 22. D/N TOPSTITCH B. PANEL SEAM*2
13" 23. MARK PKT POSITION*2
17" 24. FUSE PKT*2
16" 25. SERGE PKT FACING*2*2
54" 26. SET BESOM*2(MACH)
25" 27. SET BESOM*2(HAND)
36" 28. CLOSE 2EDGE*2
17" 29. PRESS PKT OPEN*2
18" 30. STITCH UNDER EDGE*2
38" 31. JOIN PKT FACING TO BAG*2*2
18" 32. MARK BAG*2
60" 33. JOIN BAG, TURN
40" 34. 1/4TOPSTITCH BAG
35" 35. 1/16STITCH AT PKT LIP 3 UNDER*2
30" 36. TACK BAG AT W.BAND+TACK PKT OPEN

ZIPPER FACING*2

- 15" 48. SEW EDGE(TEMPLATE)
10" 49. TRIM&TURN
7" 50. PRESS
12" 51. 1/16STITCH
13" 52. PIPING*2
12" 53. TACK ZIPPER TO ZIPPER FACING



POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1585	
DOUBLE	90	
PITCH STITCH	0	
SPECIAL	152	210
PRESS	151	
HAND	299	13
AMOUNT	2277	223
OUTPUT PCS	12.65	129.15
TOTAL TIME	2500	TOTAL OUTPUT 11.5

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W.BAND*5

- 35" 60. MARK BAND*5
36" 61. JOIN CENTER W.BAND*3
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13" 75. PRESS PIPING

FRONT

- 35" 1. MARK FRONT+PKT POSITION*3
16" 2. SERGE PKT FACING*2*2
20" 3. MARK PKT FACING*2+PKT POSITION*1
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14" 5. SET BESOM*1(HAND)
16" 6. CLOSE 2EDGE*1
3" 7. SERGE BESOM OPEN*1
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36" 15. TACK PKT FACING TO FRONT*2 (TACK BAG AT W.BAND&OUT SEAM)
38" 16. JOIN BAG*2, TURN+TOPSTITCH BAG*2
17" 17. TACK PKT OPEN*2
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60" 20. SERGE ALL PART BACK*4*2
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13" 23. MARK PKT POSITION*2
17" 24. FUSE PKT*2
16" 25. SERGE PKT FACING*2*2
54" 26. SET BESOM*2(MACH)
25" 27. SET BESOM*2(HAND)
36" 28. CLOSE 2EDGE*2
17" 29. PRESS PKT OPEN*2
18" 30. STITCH UNDER EDGE*2
38" 31. JOIN PKT FACING TO BAG*2*2
18" 32. MARK BAG*2
60" 33. JOIN BAG, TURN
40" 34. 1/4TOPSTITCH BAG
35" 35. 1/16STITCH AT PKT LIP 3 UNDER*2
30" 36. TACK BAG AT W.BAND+TACK PKT OPEN

ZIPPER FACING*2

- 15" 48. SEW EDGE(TEMPLATE)
10" 49. TRIM&TURN
7" 50. PRESS
12" 51. 1/16STITCH
13" 52. PIPING*2
12" 53. TACK ZIPPER TO ZIPPER FACING



POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1585	
DOUBLE	90	
PITCH STITCH	0	
SPECIAL	152	210
PRESS	151	
HAND	299	13
AMOUNT	2277	223
OUTPUT PCS	12.65	129.15
TOTAL TIME	2500	TOTAL OUTPUT 11.5

STYLE NO: G15-030P

DATE: 2015/01/03

TAIPEI IE OUTPUT:

VN IE OUTPUT: 12.65

# OP NO Mã	Operation Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件 及其他
01	Mark front& pkt position*3	SD TT+vị trí túi*3	C	HAND	35	259.7	823	
02	Serge pkt facing*2*2	VS 3C gấp túi*2*2	B	SW	16	127.5	1800	
03	Mark pkt facing*2+pkt position*1	SD gấp túi trước*2,vị trí túi*1+góc miệng túi	C	HAND	20	148.4	1440	
04	Set besom*1(pkt small)(mach)	Bỏ túi bằng máy*1(túi nhỏ)	B	SPECIAL	27	215.2	1067	
05	Set besom*1(hand)	Bỏ túi bằng tay*1	B	HAND	14	111.6	2057	
06	Close 2 edge	Chặn 2 đầu coi túi	B	SINGLE	16	127.5	1800	
07	Serge besom open*1	VS 3C miệng coi túi nhỏ*1	B	SW	3	23.9	9600	
08	Press besom*1	Là miệng coi túi *1	B	PRESS	7	55.8	4114	
09	Tack bag+1/16stitch around small	Ghim lót+Mi xung quanh miệng túi*1	B	SINGLE	36	286.9	800	
10	Join bag+besom to pkt open(temp)	Cán lót+coi túi vào miệng túi(quay mẫu)	B	SINGLE	32	255.0	900	
11	Notch&close edge*2	Bấm góc cạnh túi*2+cán tiếp miệng túi 1 đoạn+chặn	B	SINGLE	40	318.8	720	
12	Press pkt open*2	Là miệng túi trước*2	B	PRESS	18	143.5	1600	
13	1/16stitch pkt open*2	Mi miệng coi túi 1/16*2	B	SINGLE	28	223.2	1029	
14	Tack pkt facing to bag*2*2	Ghim gấp vào lót*2*2	B	SINGLE	38	302.9	758	
15	Tack pkt facing to front*2(tack fac)	Ghim gấp vào thân(ghim trên cạp+sườn)	B	SINGLE	36	286.9	800	
16	Join bag,turn,topstitch bag*2	Cán lót túi,lộn,điều lót*2	B	SINGLE	38	302.9	758	
17	Tack pkt open*2	Ghim miệng túi*2	B	SINGLE	17	135.5	1694	
18	Serge around front*2*2	VS 3C xung quanh TT*2*2	B	SW	32	255.0	900	
19	Join outseam*2,check	Cán chập dọc quần*2,ktra miệng túi	B	CHAIN STITCH	44	350.7	655	
20	Serge btm	VS 3C gấu quần	B	SW	8	63.8	3600	
21	Close vent at hem,turn	Chặn gấu sê quần,lộn*2*2	B	SINGLE	44	350.7	655	
22	Press vent+out seam+crease btm	Là sê quần+là dọc+gấp gấu	B	PRESS	27	215.2	1067	
23	D/N topstitch outseam*2	Điều dọc quần 2kim	B	DOUBLE	50	398.5	576	
24	Join inseam*2	Cán chập giằng quần*2	B	CHAIN STITCH	36	286.9	800	
25	Press seam inseam	Là rê giằng quần	B	PRESS	15	119.6	1920	
26	Serge front&back rise*2	VS 3C đứng TT+TS*2	B	SW	17	135.5	1694	
27	Join front&back rise	Chấp đứng TT+TS	B	CHAIN STITCH	38	302.9	758	
28	Join fly, stitch	Cán chập moi+mi	B	SINGLE	21	167.4	1371	
29	Crease fly+press back rise	Là gấp moi+là đứng TT+TS	B	PRESS	18	143.5	1600	
30	Set zipper to body, stitch	Trạ khóa,sd	A	SINGLE	35	293.0	823	
31	Topstitch fly+close *2	Điều moi khóa 1 kim+chặn moi*2	B	SINGLE	35	279.0	823	
32	Sew belt loop*5	Máy đĩa*5	B	KANSAI	9	71.7	3200	
33	Mark+cut belt loop*5	SD+cắt đĩa*5	C	HAND	5	37.1	5760	
34	Set belt loop*5,mark	Trạ đĩa,sd*5	B	SINGLE	38	302.9	758	
35	avoi stretchable around w.band	Ghim chống bải vòng cạp 1 đường	B	SINGLE	24	191.3	1200	
36	Set w.band,mark	Trạ cạp,sd	A	SINGLE	92	770.0	313	
37	1/16Foldstitch under w.band	Gấp mi chân cạp 1/16	A	CHAIN STITCH	86	719.8	335	
38	1/16Stitch upper w.band	Mi sống cạp 1/16	B	SINGLE	35	279.0	823	
39	Close belt loop*5	Chặn đĩa trên,dưới*5*2	B	SINGLE	58	462.3	497	
40	Tack lbl at outseam*2	Ghim,mác sườn*2	B	SINGLE	22	175.3	1309	
41	Blind btm	Vắt gấu quần	B	SINGLE	48	382.6	600	
XZ	Trim thread	Cắt chỉ	C	HAND	90	667.8	320	
001	Mark hole at band*1 position	SD thừa khuyết cạp*1	C	HANDSCL	8	59.4	3600	
002	Sew hole*1	Thừa khuyết*1	B	SPECIAL	12	95.6	2400	
003	Bar tack pkt*3*2	Đi bộ túi*2*2+bộ đĩa*5*2	B	SPECIAL	88	701.4	327	
	Pkt facing*3	Đáp khóa*3						
A01	Sew edge*1	Cán chập gấp khóa bìa mẫu	B	SPECIAL	15	119.6	1920	
A02	Trim&turn	Gột,lộn gấp khóa	C	HAND	10	74.2	2880	
A03	Press	Là gấp khóa	B	PRESS	7	55.8	4114	
A04	1/16stitch	Mi gấp khóa	B	SINGLE	12	95.6	2400	
A05	Piping *2	Cuộn viền gấp khóa*2	B	SINGLE	13	103.6	2215	
A06	Tack zipper to zipper facing	Ghim khóa vào gấp khóa+chặn viền khóa	B	SINGLE	12	95.6	2400	
	Back body*4	Thân sau*2*2						
B01	Mark all back body	SD các phần TS	C	HAND	32	237.4	900	
B02	Serge all part back *4*2	VS 3C các phần TS*4*2	B	SW	60	478.2	480	
B03	Join B.panel seam*2	Cán chập sườn TS*2(chỉ tết)	B	CHAIN STITCH	44	350.7	655	
B04	D/N Topstitch B.panel seam*2	Điều 2 kim 1/4 sườn TS*2	B	DOUBLE	40	318.8	720	
B05	Mark pkt position*2	SD vị trí túi sau*2	C	HAND	13	96.5	2215	
B06	Fuse pkt*2	Là mép vào vị trí túi*2	B	PRESS	17	135.5	1694	
B07	Serge pkt facing*2*2	VS 3C gấp túi*2*2	B	SW	16	127.5	1800	
B08	Set besom*2(mach)	Bỏ túi bằng máy*2	B	SPECIAL	54	430.4	533	
B09	Set besom*2(hand)	Bỏ túi bằng tay*2	B	HAND	25	199.3	1152	

SEWING OPERATION LIST

STYLE NO: G15-030P

DATE: 2015/01/03

TAIPEI IE OUTPUT:

VN IE OUTPUT: 12.65

# OP NO MA	Operation Tên công đoạn		Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件及其他
B10	Close 2edge*2	Chặt 2 đầu cơi túi*2	B		SINGLE	36	286.9	800	
B11	Press pkt open*2	Là miệng cơi túi sau*2	B		PRESS	17	135.5	1694	
B12	Stitch under pkt*2	Mỉ cạnh dưới*2	B		SINGLE	18	143.5	1600	
B13	Join pkt facing to bag*2*2	Cán dập túi vào lót*2*2	B		SINGLE	38	302.9	758	
B14	Mark bag*2	SD lót*2	C		HAND	18	133.6	1600	
B15	Join bag,tum	Quay tròn túi(máy chêm),lộn	B		SINGLE	80	478.2	480	
B16	1/4topstitch bag	Đường dây túi 1/4	B		SINGLE	40	318.8	720	
B17	1/16 stitch at pkt lip 3 under*2	Mỉ 3 cạnh cơi túi*2	B		SINGLE	35	279.0	823	
B18	Tack bag to w.band+tack pkt open	Ghìm túi trên cạp+ghìm miệng túi	B		SINGLE	30	239.1	960	
	W.band*5	Cạp*5							
C01	Mark*5	SD cạp *5	C		HAND	35	259.7	823	
C02	Join center w.band*3	Cán giữa cạp*3(cạp chính*2,cạp lót*1)	B		SINGLE	36	286.9	800	
C03	Join upper w.band	Cán chập sống cạp	B		SINGLE	52	414.4	554	
C04	Fuse mex band*1	Là mex đầu cạp vuông	B		PRESS	12	95.6	2400	
C05	Mark hook&eye*2	SD đính khuy cạp*2	C		HANDSCL	5	37.1	5760	
C06	Sew hook&eye*2	Đính khuy cạp*2	B		SPECIAL	14	111.6	2057	
C07	Wrap hook&eye*2	Bọc khuy cạp*2	B		HAND	2	15.9	14400	
C08	Join band lining+join edge band(at	Cán cạp lót+quay 1 đầu cạp bên phải,lộn	B		SINGLE	44	350.7	655	
C09	Sew cording at w.band	Máy dây sống cạp	B		SINGLE	18	143.5	1600	
C10	1/16 stitch upper w.band	Mỉ tăng cường sống cạp	B		SINGLE	25	199.3	1152	
C11	Press seam+upper w.band	Là rẽ cạp+cạp sống cạp	B		PRESS	38	302.9	758	
C12	Trim&tum	Chêm sửa cạp(máy chêm)	C		SINGLE	18	133.6	1600	
C13	Tack w.band 1edge	Ghìm cạp 1 đường	B		SINGLE	18	143.5	1600	
C14	Piping under w.band	Quấn viền chân cạp	B		SINGLE	17	135.5	1694	
C15	Sew lbl at zise to lbl main,sew lbl a	Máy móc cỡ vào móc chính,máy móc cạp	B		SINGLE	35	279.0	823	
C16	Press piping	Là chân cạp viền	B		PRESS	13	103.6	2215	
TOTAL						2500	19851	11.5	



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Single	1585				
Double	90				
Special	152	210			
Press	151				
Hand	299	13			
Amount	2277	223			
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Total time	2500		Total out put		11.5

製表人: HUONG