

福星制衣越南廠 制衣工程 IE 出數核定流程表

1. 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。
2. 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
3. 經越南廠總經理核實後，將文件呈送臺北公司做最後核可。
4. 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: G15-031P		款式說明 LADIE PANT		制表人: YEN 日期: 2015/01/13		文件編號:	
參考雷同款:		生產車縫時間: 2359		特車組時間: 109		總時間: 2468	
生產出數: 12.21		特車組出數: 244.22		IE 總出數: 11.7		 照片	
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:

1/3
2/13

DATE: 2015/01/12

VA IE OUTPUT:

12.21

[illegible]

POSITION	GENERAL	SPECIAL				
Single	1510					
SW	327					
Special	0	109				
Press	165					
Hand	357					
Amount	2359	109				
Output (pcs)	12.21	264.22				
Total time	2468		Total			11.7



NAME: Y 蛋 蛋

FORMOSTAR GARMENT (VIETNAM) CO., LTD
SEWING OPERATION LIST

STYLE NO: G15-031P

DATE: 2016/01/12

TAIPEI IE OUTPUT:
VN IE OUTPUT: 12.21

# OP	NO	Operation Tên công đoạn	Grade	Chức năng	Đơn vị	Time	Price	Out put	及其他
	01	Mark front pkt position 3	C		HAND	28	231.3	1028	
	02	Trim front	C		HAND	15	123.9	1920	
	03	Serge pkt facing 2 2	B		SW	16	140.3	1800	
	04	Mark besom 2	C		hand	12	89.1	2400	
	05	Join bag+besom to pkt open(temp)	B		SPECIAL	32	280.6	900	
	06	Notch&close edge 2	B		SINGLE	40	350.8	720	
	07	Press pkt open 2	B		PRESS	18	157.9	1600	
	08	1/16stitch pkt open 2	B		SINGLE	28	245.6	1029	
	09	Tack pkt facing to bag 2 2	B		SINGLE	18	157.9	1600	
	10	Tack besom at lining	B		SINGLE	18	157.9	1600	
	11	Join bag,turn,lopstitch bag 2	B		SINGLE	28	245.6	1029	
	12	Turn , stitch a round pkt 2	B		SINGLE	32	280.6	900	
	13	Tack pkt open 2	B		SINGLE	17	148.1	1694	
	14	Serge around front 2 2	B		SW	32	280.6	900	
	15	Join chain stitch outseam 2,check	B		PRESS	20	175.4	1440	
	16	Press seam outseam	B		PRESS	44	385.9	655	
	17	Join chain stitch inseam 2	B		CHAIN STITCH	38	315.7	800	
	18	Close chain stitch	B		SINGLE	25	219.3	1152	
	19	Press seam inseam	B		PRESS	15	131.6	1920	
	20	Serge front&back rise 2	B		SW	17	148.1	1694	
	21	Join front&back rise	B		CHAIN STITCH	38	333.3	758	
	22	Join fly, stitch	B		SINGLE	21	184.2	1371	
	23	Crease fly+press back rise	B		PRESS	18	157.9	1600	
	24	Set zipper to body, stitch	A		SINGLE	35	325.5	823	
	25	Topstitch fly+close 2	B		SINGLE	35	307.0	823	
	26	Set lining w.band	A		SINGLE	60	558.0	480	
	27	Set zipperat lining, tack lining rise	A		SINGLE	62	576.6	465	
	28	Set w.band,mark	A		SINGLE	85	780.5	339	
	29	Trim w.band	C		HAND	20	165.2	1440	
	30	Stitch under w.band	A		SINGLE	86	789.8	335	
	31	Join piping at btm 2	B		SINGLE	40	350.8	720	
	32	Blind btm	B		SW	48	421.0	600	
	33	Press btm	B		PRESS	20	175.4	1440	
	34	Sew btm tape, mark, cut	B		SINGLE	23	201.7	1,252	
	XZ	Trim thread	C		HAND	80	743.4	320	
		Zipper facing 3							
	A01	Sew edge 1	B		SPECIAL	25	219.3	1152	
	A02	Trim&turn	C		HAND	10	82.6	2880	
	A03	Press	B		PRESS	7	61.4	4114	
	A04	1/16stitch	B		SINGLE	12	105.2	2400	
	A05	Serge 3T zip facing, fly	B		SW	13	114.0	2215	
	A06	Tack zipper to zipper facing	B		SINGLE	12	105.2	2400	
		Back body 4							
	B01	Mark 2, pleat 4	C		HAND	38	297.4	800	
	B02	Trim bk	C		HAND	20	165.2	1440	
	B03	Serge all part back 2	B		SW	60	528.2	480	
	B04	Sew pleat 4	B		SINGLE	48	421.0	600	
	B05	Fuse pkt 2, press pleat	B		PRESS	17	148.1	1694	
	B06	Mark pkt position 2	B		HAND	13	114.0	2215	
	B07	Serge pkt facing 2 2	B		SW	16	140.3	1800	
	B08	Set besom 2(mach)	B		SPECIAL	0	0.0	#DIV/0!	
	B09	Set besom 2(hand)	B		HAND	30	263.1	960	
	B10	Close 2edge 2	B		SINGLE	38	333.3	758	
	B11	Stitch under pkt 2	B		SINGLE	18	157.9	1600	
	B12	Press pkt open 2	B		PRESS	20	175.4	1440	
	B13	Join pkt facing to bag 2 2	B		SINGLE	38	333.3	758	
	B14	Mark bag 2	C		HAND	18	148.7	1600	
	B15	Join bag,turn	B		SINGLE	40	350.8	720	
	B16	1/4topstitch bag	B		SINGLE	30	263.1	960	
	B17	Tack bag to w.band+tack pkt oper	B		SINGLE	30	263.1	960	