

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: G15-033S	款式說明 LADIE SKIRTS 订单 1777 件	制表人: HUONG	日期: 2015/02/24	文件編號:
經同款:			照片	
生產車縫時間:1456	特車組時間: 240	總時間: 1696		
生產出數: 19.78	特車組出數:120.0	IE 總出數: 16.98		

PPIC 主管:


2/24

FLOW CHART OF G15-033S

W.BAND*4

- 25" 11. MARK BAND*4
 28" 12. JOIN UNDER SET ZIPPER+TACK LBL*2
 18" 13. CREASE UNDER W.BAND*2
 17" 14. JOIN CENTER BAND*2+TRIM
 17" 15. SEW CORDING TAPE
 AT UPPER W.BAND
 18" 16. 1/16STITCH
 UPPER W.BAND
 17" 17. TRIM W.BAND
 33" 18. PRESS SEAM+
 PRESS UPPER W.BAND
 35" 19. TACK ZISE LBL AT MAIN LBL,
 SEW LBL AT BAND
 18" 20. TACK W.BAND I EDGE

FRONT

- 35" 1. MARK FRONT*4
 24" 2. SERGE OUT SEAM*2*2
 38" 3. SEFTEY ALL PART FRONT*3
 30" 4. 1/16STITCH ALL PART FRONT*3
 15" 8. JOIN OUT SEAM(CHAIN STICTH
 MACHINE AT LEFT)
 17" 9. JOIN OUT SEAM(SEFETY AT RIGHT)
 48" 10. PRESS SEAM+CREASE BTM
 62" 21. SET W.BAND, MARK
 5" 22. PRESS ZIPPER
 56" 23. SET ZIPPER, MARK
 5" 24. PIPING AT ZIPPER END
 70" 32. SET LINING AT W.BAND
 34" 33. CLOSE 2EDGE BAND, MARK, TURN
 78" 34. SET LINING TO ZIPPER, CLOSE
 74" 35. CREACK STITCH UNDER BAND
 35" 36. SERGE BTM
 92" 37. BLIND BTM
 18" 38. SEW BTM TAPE+MARK+CUT*2
 40" 39. TACK TAPE*2
 60" 40. TRIM & TURN
 QC
 240" 001. TACK HOOK&EYE

BACK BODY*4

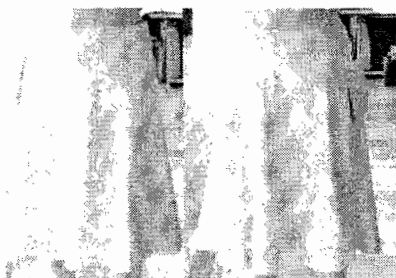
- 35" 5. MARK ALL BACK*4
 38" 6. SEFETY ALL PART BACK*3
 30" 7. 1/16STITCH ALL PART BACK*3

LINING

- 16" 25. SERGE AT SET ZIPPER
 22" 26. JOIN UNDER SET
 ZIPPER+TACK LBL*2
 36" 27. SEFETY ALL PART FRONT*3
 36" 28. SEFETY ALL PART BACK*3
 24" 29. SEFETY OUT SEAM
 107" 30. FOLDSTITCH BTM
 35" 31. PRESS

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1220	
CHAIN STITCH	42	
DOUBLE	168	
SPECIAL	163	0
PRESS	145	
HAND	255	252
AMOUNT	1993	252
OUPUT PCS	14.45	114.3
TOTAL TIME	2245	TOTAL OUTPUT 12.83



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

STYLE NO: AP15-033S
DATE: 2015/02/24

TAIPEI IE OUTPUT:
VN IE OUTPUT: 19.78

# step Mã	Step name Tên công đoạn	Grade Cấp	合縫記 號	使用機器	time Thời	price Đơn giá	out put Sản	使用配件 及其他
	Thân trước, mẫu chính							
01	Mark front*4	SD TT*4	C	HAND	35	259.7	823	
02	Serge out seam*2*2	VS 3C sườn*2*2	B	SW	24	191.3	1200	
03	Safety all part front*3	VS 5C các phần TT*3	B	SW	38	302.9	758	
04	1/16stitch all part front*3	Mí 1/16 các phần TT*3	B	SINGLE	30	239.1	960	
05	Join out seam(chain stitch machine at	Cán chắp dọc váy 1 bên bằng chỉ tết	B	CHAIN STITCH	15	119.6	1920	
06	Join out seam(safety at right)	Cán chắp dọc váy 1 bên VS 5C	B	SW	17	135.5	1694	
07	Press seam open+crease btm	Là dọc váy+là gấp gấu	B	PRESS	48	382.6	600	
08	Set w.band,mark	Tra cấp,sd	A	SINGLE	62	518.9	465	
09	Press zipper	Là khóa	B	PRESS	5	39.9	5760	
10	Set zipper,mark	Tra khóa,sd	A	SINGLE	56	468.7	514	
11	Piping at zipper end	Cuốn viền đuôi khóa	B	SINGLE	5	39.9	5760	
12	Set lining w.band	Lồng lót cấp	B	SINGLE	70	557.9	411	
13	Close 2 edge band,mark,turn	Chặn 2 đầu cấp,sd,lộn	B	SINGLE	34	271.0	847	
14	Set lining zipper,close	Lồng lót khóa,chặn	A	SINGLE	78	652.9	369	
15	Creack stitch under band	Mí chân cấp lót khe	B	SINGLE	74	589.8	389	
16	Serge btm	VS 3C gấu váy	B	SW	35	279.0	823	
17	Blind btm	Vắt gấu váy	B	SINGLE	92	733.2	313	
18	Sew btm tape+mark+cut*2	Máy dây gấu+sd+cắt,buộc*2	B	SINGLE	18	143.5	1600	
19	Tack tape*2	Ghim dây gấu*2	B	SINGLE	40	318.8	720	
XZ	Trim&turn	Cắt chỉ,lộn váy	C	HAND	60	445.2	480	
001	Tack hook&eye	Khâu khuy móc	C	HANDSCL	240	1780.8	120	
	Back body*4	Thân sau*4						
A01	Mark back*4	SD TS*4	C	HAND	35	259.7	823	
A02	Safety all part back*3	VS 5C các phần TS*3	B	SW	38	302.9	758	
A03	1/16stitch all part back*3	Mí 1/16 các phần TS*3	B	SINGLE	30	239.1	960	
	W.band*4	Cạp*4						
B01	Mark band*4	SD cạp*4	C	HAND	25	185.5	1152	
B02	Sew edge*2	Cán chắp sống cạp*2	B	SINGLE	28	223.2	1029	
B03	Crease under w.band*2	Là gấp chân cạp*2	B	PRESS	18	143.5	1600	
B04	Join center band*2+trim	Cán cạp*2+cán sống 1 đoạn+sén sửa	B	SINGLE	17	135.5	1694	
B05	Sew cording tape upper w.band	Máy dây bunn sống cạp	B	SINGLE	17	135.5	1694	
B06	1/16stitch upper w.band	Mí sống cạp 1/16	B	SINGLE	18	143.5	1600	
B07	Trim w.band	Chém sửa cạp	C	HAND	17	126.1	1694	
B08	Press upper w.band	Là sống cạp+là rê cán cạp	B	PRESS	33	263.0	873	
B09	Tack zise lbl at main lbl,sew lbl at band	Máy móc cỡ vào móc chính,máy móc ẹp,SD	B	SINGLE	35	279.0	823	
B10	Tack w.band 1 edge	Ghim cạp 1 đường	B	SINGLE	18	143.5	1600	
	Lining	Lót						
C01	Serge at set zipper	VS 3C đoạn tra khóa	B	SW	16	127.5	1800	
C02	Join under set zipper+tack lbl*2	Cán dưới khóa 1 đoạn+ghim móc	B	SINGLE	22	175.3	1309	
C03	Safety all part front*3	VS 5C các phần TT lót*3	B	SW	36	286.9	800	
C04	Safety all part back*3	VS 5C các phần TS lót*3	B	SW	36	286.9	800	
C05	Safety out soam	VS 5C dọc váy lót	B	SW	24	191.3	1200	
C06	1 foldstitch btm	Gập đều gấu lót	B	SINGLE	107	852.8	269	
C07	Press	Là lót	B	PRESS	35	279.0	823	
TOTAL					1681	13249.4	17.13	



Position	GENER	SPECIAL			
single	866				
Kansai	0				
special	264	0			
Chain stitch	15				
press	139				
hand	172	240			
amount	1456	240			
output pcs	19.78	120.0			
total time	1696		total out put		16.98

製表人: Huong