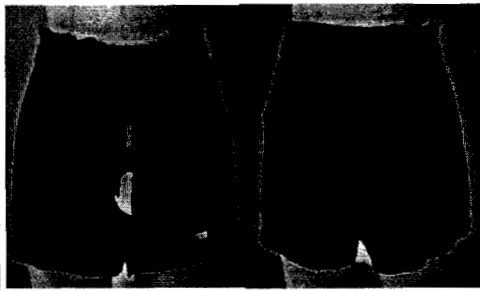


福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G15-061 The same 15-060&15-063	款式說明 LADIE PANTS 订单 3325	制表人: HUONG	日期: 2015/03/16	文件編號:
參考雷同款:			照片	
生產車縫時間:1841	特車組時間: 219	總時間: 2060		
生產出數: 15.64	特車組出數:131.5	IE 總出數: 13.98		

PPIC 主管:

[Handwritten signature]
3/16

FLOW CHART OF G15-061P**W.BAND*4**

- 47" 42. MARK SHELL BAND*2+LINING*3
6" 43. PRESS ELASTIC BAND*1
8" 44. MARK+ CUT ELASTIC *1
47" 45. CREASE UPPER SHELL BAND*3+LINING*3
28" 46. CREASE UNDER LINING W.BAND*3
52" 47. JOIN CENTER BAND*2*2+TRIM
9" 48. PRESS SEAM OPEN
32" 49. CLOSE & TURN UPPER W.BAND*2+STITCH
17" 50. TRIM W.BAND
18" 51. TACK W.BAND 1 EDGE
18" 52. MARK SNAP HOOK&EYE
36" 53. SNAP HOOK&EYE*4

ZIPPER FACING*2

- 4" 34. MARK BACK+PLEAT*2
9" 35. CLOSE 1 EDGE, TURN
12" 36. CREASE ZIPPER FACING*1
5" 37. TACK ZIPPER FACING OPEN
6" 38. SERGE*2
12" 39. TACK ZIPPER TO ZIPPER FACING

FRONT

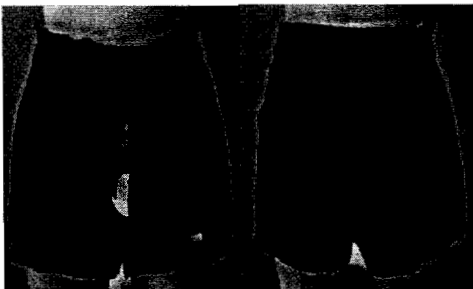
- 17" 1. MARK FRONT+ PKT POSITION*2
17" 2. FUSE MEX*2
32" 3. SEW EDGE*2(TEMPLATE)
16" 4. 1/16STITCH PKT OPEN*2
16" 5. PRESS PKT OPEN*2
17" 6. 1/4TOPSTITCH PKT OPEN*2
24" 7. TACK PKT AT UNDER&UPPER
40" 8. JOIN BAG*2(SEFETY)
18" 9. TACK "SW" PKT*2
17" 10. SERGE AT FRONT RISE
34" 26. TACK OUT SEAM(SINGLE MACHINE)
16" 27. SEFETY OUT SEAM
26" 28. PRESS OUT SEAM+CREASE BTM
12" 29. SEFETY INSEAM
18" 30. TACK FRONT&BACK RISE(SINGLE MACHINE)
30" 31. SEFTEY FRONT&BACK RISE
25" 32. JOIN FLY, STITCH
20" 33. PRESS FLY+PRESS FORWARD IN SEAM+BACK RISE
45" 40. SET ZIPPER, STITCH
38" 41. TOPSTITCH FLY+CLOSE*2
89" 54. SET W.BAND, MARK+CLOSE 2EDGE, TURN
35" 55. SEW LBL AT SIZE TO LBL AT MAIN+TACK LBL AT HAND
36" 56. TACK ELASTIC TO W.BAND
86" 57. WAIST TUNNED STITCH(AT UPPER W.BAND)
94" 58. 1/16STITCH UNDER W.BAND
92" 59. 1/16STITCH BTM
12" 60. TACK LBL AT OUT SEAM*1
36" 66. INSERT CORDING W.BAND
10" 67. CLOSE STITCH UPPER W.BAND*1
52" 68. TRIM THREAD
20" 001. BARTACK FRONT PKT*4
35" 002. BARTACK BACK PKT*4+RISE*1

BACK BODY*2

- 16" 11. MARK BACK+PLEAT*2
24" 12. CLOSE PLEAT*2
14" 13. MARK PKT POSITION*2
24" 14. PRESS PLEAT+FUSE MEX*2
6" 15. SERGE PKT FACING*2
54" 16. SET BESOM*2(MACH)
25" 17. SET BESOM*2(HAND)
36" 18. CLOSE 2EDGE
17" 19. PRESS PKT OPEN*2
25" 20. TACK BAG+TACK PKT FACING TO B
36" 21. STITCH UNDER EDGE*2+MARK+ TACK BAG TO W.BAND
38" 22. SEFETY BAG*2
35" 23. 1/16STITCH AT LIP 3 UNDER
17" 24. TACK PKT OPEN*2
34" 25. TACK OVER LOCK BACK PKT*2*2

CORDING W.BAND*1

- 24" 61. CREASE CORDING W.BAND(FUSE)
12" 62. MARK 2EDGE CORDING W.BAND
36" 63. CLOSE 2EDGE, TURN
32" 64. PRESS CORDING W.BAND
110" 65. 1/16STITCH AROUND CORDING W.BAND

**POSITION TIME TABLE**

POSITION	GENERAL	SPECIAL
SINGLE	1170	
KANSAI	0	
DOUBLE	0	
SPECIAL	169	201
PRESS	254	
HAND	248	18
AMOUNT	1841	219
OUTPUT PCS	15.64	131.5
TOTAL TIME	2060	TOTAL OUTPUT 13.98

FORMOSTAR GARMENT (VIETNAM) CO., LTD

SEWING OPERATION LIST

STYLE NO: AP15-061P

DATE: 2015/03/16

TAIPEI IE OUTPUT:

VN IE OUTPUT: 15.64

W step Mã công đoạn	Step name Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	cut part Số lượng	使用配件 及其他
	Thân trước, mẫu chính							
01	Mark front+pkt position*2	SD TT+vị trí túi*2	C	HAND	17	141.1	1694	
02	Fuse mex*2	Là mex vào vị trí túi*2	B	PRESS	17	149.6	1694	
03	Sew edge*2(template)	Cán miệng túi*2(theo mẫu)	B	SPECIAL	32	281.6	900	
04	1/16stitch pkt open	Mí lằng cường miệng túi 1/16	B	SINGLE	16	140.8	1800	
05	Press pkt open*2	Là miệng túi*2	B	PRESS	16	140.8	1800	
06	1/4 topstitch pkt open	Điều miệng túi 1/4	B	SINGLE	17	149.6	1694	
07	Tack pkt at under&upper	Ghim miệng túi trên dưới	B	SINGLE	24	211.2	1200	
08	Join bag*2(safety)	Quây lót túi(vs 5c)	B	SW	40	352.0	720	
09	Tack"sw" pkt*2	Chặn đầu VS túi*2	B	SINGLE	18	158.4	1600	
10	Serge at front rise	VS 3C đứng trước	B	SW	17	149.6	1694	
11	Tack out seam(single machine)	Cán dọc quần 1 kim	B	SINGLE	34	299.2	847	
12	Safety out seam	vs 5c dọc quần	B	SW	16	140.8	1800	
13	Press out seam+crease btm	Là lật dọc quần+là gấp gấu	B	PRESS	26	228.8	1108	
14	Safety in seam	VS 5C dăng quần	B	SW	12	105.6	2400	
15	Tack front&back rise(single machine)	Ghim đối đứng TT+TS máy 1kim	B	SINGLE	18	158.4	1600	
16	Safety front& back rise	VS 5C đứng TT+TS	B	SW	34	299.2	847	
17	Join fly, stitch	Cán chập moi+mí	B	SINGLE	25	220.0	1152	
18	Press fly+press forward in seam, back rise	Là moi+giăng+đứng TT+TS	B	PRESS	20	176.0	1440	
19	Set zipper, stitch	Trạ khóa, mí+ghim đứng TT	A	SINGLE	45	418.5	640	
20	Topstitch fly+close*2	Điều moi khóa 1kim+chặn moi*2	B	SINGLE	38	334.4	758	
21	Set w.band, mark+close 2edge, turn	Trạ cạp, sd+chặn 2 đầu cạp, lộn	A	SINGLE	89	827.7	324	
22	Sew lbl at rise to lbl at main+tack lbl at bag	Máy móc size vào móc chính+ghim móc cạp	B	SINGLE	35	308.0	823	
23	Tack elastic to w.band	Ghim chun vào bản cạp+chặn chun	B	SINGLE	36	316.8	800	
24	Waist tunned stitch (at upper w.band)	Chập điều 2 bản cạp đường trên	B	SINGLE	86	756.8	335	
25	1/16Stitch under w.band	Gập mí chân cạp 1/16	A	SINGLE	94	874.2	306	
26	1/16foldstitch btm	Gập điều gấu	B	SINGLE	92	809.6	313	
27	Tack lbl at out seam*1	Ghim móc sườn*1	B	SINGLE	12	105.6	2400	
28	Insert cording w.band	Luồn dây nút quần	C	HAND	36	298.8	800	
29	Close stitch upper w.band 1"	Chặn mí đầu cạp trên 1"	B	SINGLE	10	88.0	2880	
XZ	Trim thread	Cắt chỉ	C	HAND	52	431.6	554	
001	Bartack front pkt*4	Di bộ túi trước*2*2	B	SPECIAL	20	176.0	1440	
002	Bartack back pkt*4+rise*1	Di bộ túi sau*4+đứng*1	B	SPECIAL	35	308.0	823	
	Zipper facing*2	Đáp khóa*2						
A01	Mark zipper facing*1	SD đáp khóa	C	HAND	4	33.2	7200	
A03	Close 1 edge, turn	Chặn 1 đầu đáp khóa, lộn	B	SINGLE	9	79.2	3200	
A02	Crease zipper facing*1	Là gấp đáp khóa	B	PRESS	12	105.6	2400	
A04	Tack zipper facing open	Ghim miệng đáp khóa	B	SINGLE	5	44.0	5760	
A05	Serge*2	VS 3C đáp khóa*2	B	SW	6	52.8	4800	
A06	Tack zipper to zipper facing	Ghim khóa vào đáp khóa+ghim vs chỉ	B	SINGLE	12	105.6	2400	
	Back body*2	Thân sau*2						
B01	Mark back, pleat*2	SD TS, ly*2	C	HAND	16	132.8	1800	
B02	Close pleat*2	Máy ly TS*2	B	SINGLE	24	211.2	1200	
B03	Mark pkt position*2	SD vị trí túi sau*2	C	HAND	14	116.2	2057	
B04	Press pleat+fuse mex*2	Là ly+là mex vào vị trí túi*2	B	PRESS	24	211.2	1200	
B05	Serge pkt facing*2	VS 3C đáp túi*2	B	SW	6	52.8	4800	
B06	Set besom*2(machine)	Bỏ túi bằng máy*2	B	SPECIAL	54	475.2	533	
B07	Set besom*2(hand)	Bỏ túi bằng tay*2	C	HAND	25	207.5	1152	
B08	Close 2edge*2	Chặn 2 đầu cạp túi*2	B	SINGLE	36	316.8	800	
B09	Press pkt open*2	Là miệng cạp túi sau*2	B	PRESS	17	149.6	1694	
B10	Tack bag*2+tack pkt facing to bag	Ghim lót*2+ghim đáp túi vào lót	B	SINGLE	25	220.0	1152	
B11	Stitch under edge*2+mark+tack bag to w.b	Mí cạnh dưới+sd, ghim lót túi trên cạp	B	SINGLE	36	316.8	800	
B12	Safety bag*2	Quây lót túi(vs 5c)	B	SW	38	334.4	758	
B13	1/16stitch lip 3 under	Mí 3 cạnh cạp túi	A	SINGLE	35	325.5	823	
B14	Tack pkt open*2	Ghim miệng túi*2	B	SINGLE	17	149.6	1694	

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

STYLE NO: AP15-061P

DATE: 2015/03/16

TAIPEI IE OUTPUT:

VN IE OUTPUT: 15.64

Step Mã công	Step name Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	output Sản lượng	使用配件 及其他
B15	Tack over lock back pkt*2*2	B		SINGLE	34	299.2	847	
	<i>W.band*6</i>							
	<i>Cạp*6</i>							
C01	Mark shell band*3+lining*3	C		HAND	47	390.1	613	
C02	Press elastic band*1	B		PRESS	6	52.8	4800	
C03	Mark+cut elastic*1	C		HAND	8	66.4	3600	
C04	Crease upper shell band*3+lining*3	B		PRESS	47	413.6	613	
C05	Crease under lining w.band*3	B		PRESS	28	246.4	1029	
C06	Join center band*2*2+trim	B		SINGLE	52	457.6	554	
C07	Press seam open	B		PRESS	9	79.2	3200	
C08	Close&turn upper w.band*2+stitch*2	B		SINGLE	32	281.6	900	
C09	Trim w.band	C		HAND	17	141.1	1694	
C10	Tack w.band 1 edge	B		SINGLE	18	158.4	1600	
C11	Mark snap hook&eye*4	C		HANDSCL	18	149.4	1600	
C12	Snap hook&eye*4	B		SPECIAL	36	316.8	800	
	<i>Cording w.band*1</i>							
	<i>Dây rút cạp*1</i>							
D01	Crease cording w.band(fuse)	B		SPECIAL	24	211.2	1200	
D02	Mark 2 edge cording w.band	C		HAND	12	99.6	2400	
D03	Close 2edge,turn	B		SINGLE	36	316.8	800	
D04	Press cording w.band	B		PRESS	32	281.6	900	
D05	1/16stitch around cording w.band	B		SINGLE	110	968.0	262	
TOTAL					2060	18126.5	13.98	



Position	GENER AI	SPECIAL			
single	1170				
Kansai	0				
special	169	201			
Chain stich	0				
press	254				
hand	248	18			
amount	1841	219			
output pcs	15.64	131.5			
total time	2060		total out put		13.98

製表人: Huong