

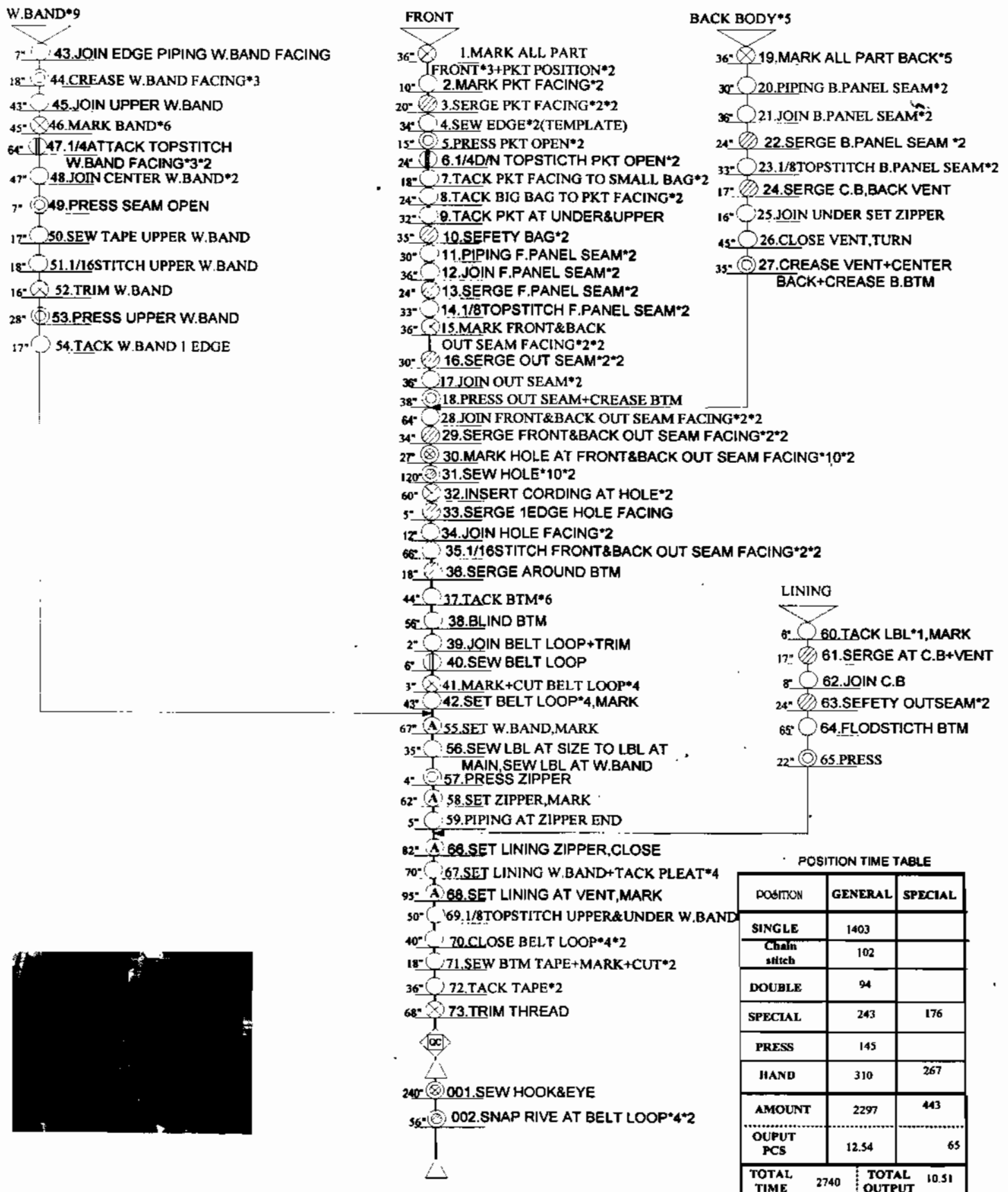
福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G15-065S	款式說明 LADIE SKIRTS 订单 11248	制表人: HUONG	日期: 2015/03/21	文件編號:
參考雷同款:			照片 	
生產車縫時間:2297	特車組時間: 443	總時間: 2740		
生產出數: 12.54	特車組出數:65	IE 總出數: 10.51		

PPIC 主管:

 3/21

FLOW CHART OF G15-065S

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

STYLE NO: AP15-0868

TAIPEI IE OUTPUT:

DATE: 2016/03/21

VN IE OUTPUT: 12.54

	Step name Tên công đoạn	Grade Cấp	合機記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件 及其他
	Thân trước, mẫu chính							
01	Mark all part front*3+pkt position*2	C		HAND	36	267.1	800	
02	Mark pkt facing*2	C		HAND	10	74.2	2880	
03	Serge pkt facing*2*2	B		SW	20	159.4	1440	
04	Sew edge*2(template)	B		SINGLE	34	271.0	847	
05	Press pkt open*2	B		PRESS	15	119.6	1920	
06	1/4D/N Topstitch pkt open*2	B		DOUBLE	24	191.3	1800	
07	Tack pkt facing to small bag*2	B		SINGLE	18	143.5	1600	
08	Tack big bag to pkt facing*2	B		SINGLE	24	191.3	1200	
09	Tack pkt at under&upper	B		SINGLE	32	255.0	900	
10	Safety bag*2	B		SINGLE	36	279.0	823	
11	Piping F.panel seam*2	B		SW	30	239.1	960	
12	Join F.panel seam*2	B		SINGLE	36	286.9	800	
13	Serge F.panel seam*2	B		SW	24	191.3	1200	
14	1/8 topstitch F.panel seam*2	B		CHAIN STITCH	33	263.0	873	
15	Mark front&back panel seam facing*2*2	C		HAND	36	267.1	800	
16	Serge out seam*2*2	B		SW	30	239.1	960	
17	Join out seam*2	B		CHAIN STITCH	36	286.9	800	
18	Press out seam+crease btm	B		PRESS	38	302.9	758	
19	Join front&back out seam facing*2*2	B		SINGLE	64	510.1	450	
20	Serge front&back out seam facing*2*2	B		SW	34	271.0	847	
21	Mark hole at front &back out seam facing	C		HANDSCL	27	200.3	1067	
22	Sew hole*10*2	B		SPECIAL	120	958.4	240	
23	Insert cording at hole*2	C		HAND	60	445.2	480	
24	Serge 1 edge hole facing	B		SW	5	39.9	5760	
25	Join hole facing	B		SINGLE	12	95.6	2400	
26	1/16stitch front&back out seam facing*2*2	B		SINGLE	68	526.0	436	
27	Serge around btm	B		SW	18	143.5	1600	
28	Tack btm*6	B		SINGLE	44	350.7	655	
29	Bind btm	B		SINGLE	56	446.3	514	
30	Join belt loop+trim	B		SINGLE	2	15.9	14400	
31	Sew bel loop	B		DOUBLE	6	47.8	4800	
32	Mark+cut belt loop*4	C		HAND	3	22.3	9600	
33	Set belt loop*4,mark	B		SINGLE	43	342.7	670	
34	Set w.band,mark	A		SINGLE	67	560.8	430	
35	Sew bel at zise to bel main,sew bel at band	B		SINGLE	35	279.0	823	
36	Press zipper	B		PRESS	4	31.9	7200	
37	Set zipper,mark	A		SINGLE	62	518.9	465	
38	Piping at zipper end	B		SINGLE	5	39.9	5760	
39	Set lining zipper,close	A		SINGLE	62	686.3	351	
40	Set lining w.band+tack pleat*4	B		SINGLE	70	557.9	411	
41	Set lining at vent,mark	A		SINGLE	95	795.2	303	
42	1/8topstitch upper&under w.band	B		SINGLE	50	398.5	576	
43	Close belt loop*4*2	B		SINGLE	40	318.8	720	
44	Sew btm tape+mark+cut*2	B		SINGLE	18	143.5	1600	
45	Tack tape*2	B		SINGLE	36	286.9	800	
x2	Trim&turn	C		HAND	68	504.6	424	
001	Sew hook&eye	C		HANDSCL	240	1780.8	120	
002	Snap rive at belt loop*4*2	B		SPECIAL	56	446.3	514	
	Back body*5							
	Thân sau*5							
a01	Mark all part back*5	C		HAND	36	267.1	800	
a02	Piping B.panel seam*2	B		SINGLE	30	239.1	960	
a03	Join B.panel seam*2	B		SINGLE	36	286.9	800	
a04	Serge B.panel seam*2	B		SW	24	191.3	1200	
a05	1/8 topstitch B.panel seam*2	B		CHAIN STITCH	33	263.0	873	
a06	Serge C.B,back vent	B		SW	17	135.5	1694	
a07	Join under set zipper	B		SINGLE	16	127.5	1800	
a08	Close vent,turn	B		SINGLE	45	358.7	640	

STYLE NO: AP15-055S

TAIPEI IE OUTPUT:

DATE: 2015/03/21

VN IE OUTPUT: 12.54

	Step name Tên công đoạn	Grade Cấp	合機記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件及其他
a09	Cresae vent+center back+cresae b.btm	Là gấp sẽ sau+là rẽ giữa sau+là gấp gấu sau	B		PRESS	35	279.0	823
	W.band*9	Cạp *9						
B01	Join edge piping w.band facing	Cán viền cạp giữa đi ép	B		SINGLE	7	55.8	4114
B02	Cresae piping w.band facing*3	Là gấp viền bản cạp giữa(máy ép)	B		PRESS	18	143.5	1600
B03	Join upper w.band	Cán chắp sống cạp	B		SINGLE	43	342.7	670
B04	Mark band*6	SD cạp*6	C		HAND	45	333.9	640
B05	1/4 Attack topstitch piping w.band facing*	Đán mí đắp bản cạp giữa 2 đường*3*2(2kim)	B		DOUBLE	64	510.1	450
B06	Join center w.band*2	Cán giữa cạp+cán sống 1 đoạn	B		SINGLE	47	374.6	613
B07	Press seam open	Là rẽ đường cán cạp	B		PRESS	7	55.8	4114
B08	Sew tape upper w.band	Máy dây sống cạp	B		SINGLE	17	135.5	1694
B09	1/16stitch upper w.band	Mí lằng cường sống cạp 1/16	B		SINGLE	18	143.5	1600
B10	Trim w.band	Chém sửa cạp	C		HAND	16	118.7	1800
B11	Press upper w.band	Là gấp sống cạp	B		PRESS	28	223.2	1029
B12	Tack w.band 1 edge	Ghim cạp 1 đường	B		SINGLE	17	135.5	1694
	Lining	Lót						
c01	Tack lbt*1,mark	Ghim móc lót,ad	B		SINGLE	8	47.8	4800
c02	Serge at C.B+vent	VS 3C giữa sau+sẻ sau	B		SW	17	135.5	1694
c03	Join C.B	Cán chắp giữa sau	B		SINGLE	8	63.8	3600
c04	Safety outseam*2	VS 5C sườn*2	B		SW	24	191.3	1200
c05	Foldstitch btm	Điều gấp gấu lót	B		SINGLE	65	518.1	443
c06	Press	Là lót	B		PRESS	22	175.3	1309
						2740	21642.9	10.51



Position	GENER	SPECIAL			
single	1403				
Chain stitch	102				
double	94				
special	243	176			
press	145				
hand	310	287			
amount	2297	443			
output pcs	12.54	65.0			
total time	2740		total out put		10.51

Huong