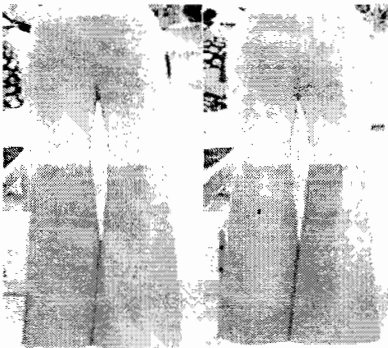


福星制衣越南廠 制衣工程 IE 出數核定流程表

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： G15-078P	款式說明 LADIE PANTS 订单 9984	制表人： HUONG	日期：2015/02/25	文件編號：
參考雷同款：			照片 	
生產車縫時間:2594	特車組時間: 443	總時間: 3037		
生產出數: 11.10	特車組出數:65.01	IE 總出數: 9.5		

PPIC 主管：


 5/2/15

FLOW CHART OF G15-078P

W.BAND*6

- 45" 61. MARK BAND*6
40" 62. JOIN CENTER SHELL
W.BAND*3+LINING BAND*2
9" 63. PRESS SEAM OPEN+
CREASE BAND(AT RIGHT)
52" 64. JOIN PIPING BAND*2
12" 65. MARK HOOK&EYE*2
180" 66. SEW HOOK&EYE*2
65" 67. JOIN EDGE UPPER W.BAND
25" 68. TRIM&TURN W.BAND
18" 69. SEW CORDING
AT W.BAND
23" 70. 1/16STITCH
UPPER W.BAND
33" 71. PRESS UPPER BAND
17" 72. PIPING UNDER W.BAND
11" 73. PRESS PIPING
35" 74. SEW LBL AT ZISE TO LBL
MAIN, SEW LBL AT BAND

LINING

- 12" 49. SERGE AT ZIPPER*2
45" 50. SEFETY OUT SEAM
40" 51. SEFETY INSEAM
10" 52. TACK RISE 1 EDGE
25" 53. SEFETY FRONT
& BACK RISE
62" 54. FOLDSTICHT BTM
26" 55. SEW BTM
TAPE+MARK+CUT*4
65" 56. TACK TAPE*4
30" 57. PRESS

FRONT

- 30" 1. MARK FRONT+PKT POSITION*2
22" 2. SERGE PKT FACING*2*2
12" 3. MARK PKT FACING*2
38" 4. JOIN PKT OPEN*2(TACK
BESOM+BAG)
17" 5. PRESS PKT OPEN
23" 6. 1/8STITCH PKT OPEN*2
18" 7. TACK BAG TO PKT FACING*2
(SMALL PKT FACING)
25" 8. TACK BAG TO PKT FACING*2
(BIG PKT FACING)
25" 9. TACK PKT TO UPPER& UNDER*2
16" 10. TACK PKT TO W.BAND, OUT SEAM
38" 11. SEFETY BAG*2
9" 12. TACK PKT OPEN*2
58" 13. SERGE AROUND FRONT*2*2
85" 32. JOIN OUT SEAM(CHAIN
STITCH MACHINE)
36" 33. PRESS SEAM OPEN+CREASE BTM
20" 34. SERGE BTM
22" 35. SEW CORDING BTM FACING
70" 36. JOIN IN SEAM*2
(CHAIN STITCH MACHINE)
20" 37. SERGE FRONT&BACK RISE
40" 38. JOIN FRONT&BACK RISE
21" 39. JOIN FLY, STITCH
43" 40. CREASE FLY, PRESS BACK RISE, INSEAM
46" 47. SET ZIPPER, STITCH
35" 48. TOPSTITCH FLY+CLOSE*2
70" 49. SET LINING ZIPPER+TACK
75" 59. SET LINING W.BAND&TACK PLEAT*4
25" 60. TRIM UPPER W.BAND
85" 75. SET W.BAND, MARK
110" 76. CREACK STITCH UNDER W.BAND
17" 77. TACK LBL AT OUT SEAM*2
54" 78. BLIND BTM
110" 79. TRIM THREAD
12" 001. MARK HOLE+SNAP AT BAND*1 POSITION
56" 002. BARTACK BACK PKT*4+HOLE*1
171" 003. SEW HOOK&EYE*2

BACK BODY*2

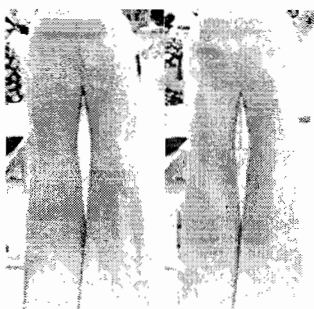
- 32" 14. MARK BACK+PLEAT*2*2
48" 15. CLOSE PLEAT*4
27" 16. PRESS FORWARD PLEATE+FUSE PKT*2
58" 17. SERGE AROUND BACK BODY
20" 18. MARK PKT POSITION*2
22" 19. SERGE PKT FACING*2*2
8" 20. CREASE BESOM*2
14" 21. PIPING BESOM PKT*2
40" 22. SET BESOM TO BACK BODY
25" 23. SET BESOM(HAND)
38" 24. CLOSE 2EDGE*2
17" 25. PRESS PKT OPEN*2
15" 26. MARK BAG*2
40" 27. JOIN PKT FACING TO BAG*2*2
36" 28. 1/16STITCH AT PKT LIP 3 UNDER
35" 29. SEFETY BAG*2
28" 30. TACK 'SW'*2*2
30" 31. TACK BAG TO W.BAND+TACK PKT OPEN

ZIPPER FACING*2

- 12" 41. SEW EDGE*1
11" 42. TRIM&TURN
12" 43. 1/16STITCH
7" 44. PRESS
9" 45. SERGE*2
12" 46. TACK ZIPPER TO
ZIPPER FACING

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1477	
CHAIN STITCH	125	
PITCH STITCH	0	
SPECIAL	404	68
PRESS	238	
HAND	350	375
AMOUNT	2594	443
OUTPUT PCS	11.10	65.01
TOTAL TIME	3037	TOTAL OUTPUT 9.8



SEWING OPERATION LIST

STYLE NO: G15-078P

DATE: 2015/02/25

TAIPEI IE OUTPUT:

VN IE OUTPUT: 11.10

# OP NO Mã công đoạn	Operation Tên công đoạn	Grade Cấp	合縫記號	使用機器	Time Thời gian	Price Đơn giá	out put Sàn lượng
01	Mark front+pkt position*2	SD TT+ vị trí túi*2	C	HAND	30	222.6	960
02	Serge pkt facing*4	VS 3 chỉ đáp túi trước*4	B	SW	22	175.3	1309
03	Mark pkt facing*2	SD đáp túi TT*2	C	HAND	12	89.0	2400
04	Join pkt open*2(tack bag+besom	Can chắp miệng túi (đặt cơ, lót túi)	B	SINGLE	38	302.9	758
05	Press pkt open*2	Là miệng túi trước*2	B	PRESS	17	135.5	1694
06	1/8topstitch pkt open*2	Điều miệng túi 1/8*2	B	SINGLE	23	183.3	1252
07	Tack bag to pkt facing*2(small pk	Can lót vào đáp túi*2 (đáp nhỏ)	B	SINGLE	18	143.5	1600
08	Tack bag to pkt facing*2(big pkt f	Dán đáp vào lót túi*2 (đáp to)	B	SINGLE	25	199.3	1152
09	Tack pkt to upper and under*2	Ghim miệng túi trên dưới*2	B	SINGLE	25	199.3	1152
10	Tack pkt to w.band& out seam	Ghim túi trên cạp, ghim sườn	B	SINGLE	16	127.5	1800
11	Safety bag*2	VS 5 chỉ đáy túi TT*2	B	SW	38	302.9	758
12	Tack pkt open*2	Ghim kín miệng túi,	B	SINGLE	9	71.7	3200
13	Serge around front body	VS 3 chỉ xung quanh TT	B	SW	58	462.3	497
14	Join out seam(chain stitch)	Can chắp dọc chỉ tết	B	CHAIN STITCH	85	677.5	339
15	Press seam open+crease btm	Là rẽ dọc+là gấp gấu	B	PRESS	36	286.9	800
16	Serge btm	VS 3 chỉ gấu	B	SW	20	159.4	1440
17	Join cording btm facing	Máy dây đáp gấu	B	SINGLE	22	175.3	1309
18	Join in seam	Can chắp dằng	B	SINGLE	70	557.9	411
19	Serge front& back rise	VS 3 chỉ đứng TT + TS	B	SW	20	159.4	1440
20	Join front&back rise	Can chắp đứng TT + TS	B	CHAIN STITCH	40	318.8	720
21	Join fly, stitch	Can chắp moi + mí	B	SINGLE	21	167.4	1371
22	Press fly+press in seam+rise	Là moi+ Là dằng, đứng TT + TS	B	PRESS	43	347.7	670
23	Set zipper, stitch	Tra khóa+ mí	A	SINGLE	46	385.0	626
24	Topstitch fly+tack*2	Điều moi, ghim*2	B	SINGLE	35	279.0	823
25	Set lining zipper+tack	Lồng lót khóa, ghim	A	SINGLE	70	585.9	411
26	Set lining w.band&tack pleat*4	Lồng lót cạp chính lót+ghim lỵ*4	A	SINGLE	75	627.8	384
27	Trim upper w.band	Chém cạp trên (thân)	C	HAND	25	185.5	1152
28	Set w.band, mark	Tra cạp, SD	A	SINGLE	85	711.5	339
29	Creack stitch under w.band	Mí cạp lọt khe	A	SINGLE	110	920.7	262
30	Tack lbi at out seam	Máy móc sườn	B	SINGLE	17	135.5	1694
31	Blind btm	Vắt gấu	B	SINGLE	54	430.4	533
32	Mark hole+snap band*1	SD thủng khuyết cạp+cúc	C	HANDSCL	12	89.0	2400
33	Bartack back pkt*4+hole*1	Đi bộ túi sau*4, bổ khuyết cạp, đi bộ*1	B	SPECIAL	56	446.3	514
34	Sew hook&eye*2	Khâu móc cạp*2	C	HANDSCL	171	1,268.8	168
XZ	Trim thread	Cắt chỉ	C	HAND	110	816.2	262
	Zipper*3	Đáp khóa*3					
A01	Sew edge*1	Can chắp đáp khóa	B	SPECIAL	12	95.6	2400
A02	Trim&turn	Sửa lộn đáp khóa	C	HAND	11	81.6	2618
A03	1/16stitch	Mí đáp khóa 1/16*1	B	SINGLE	12	95.6	2400
A04	Press	Là đáp khóa	B	PRESS	7	55.8	4114
A05	Serge*2	VS 3 chỉ đáp khóa+ moi	B	SW	9	71.7	3200
A06	Tack zipper to zipper facing	Ghim khoá vào đáp khoá	B	SINGLE	17	95.6	2400
	Back*2	Thân sau*2					
B01	Mark+pleat*2*2	SD, vị trí lỵ TS*2*2	C	HAND	32	237.4	900
B02	Close pleat*4	Máy lỵ sau*4	B	SINGLE	48	382.6	600
B03	Press pleat*4+fuse*2	Là lỵ*4, mềch túi TS*2	B	PRESS	27	215.2	1067
B04	Serge around back body	VS 3 chỉ xung quanh TS	B	SW	58	462.3	497
B05	Mark pkt position*2	SD bổ túi*2	C	HAND	20	148.4	1440
B06	Serge pkt facing*2*2	VS 3 chỉ đáp túi sau*2*2	B	SW	22	175.3	1309
B07	Cresae besom pkt*2	Là gấp cơ túi*2	B	PRESS	8	63.8	3600
B08	Piping besom pkt*2	Cuốn viền cơ túi*2	B	SINGLE	14	111.6	2057

13

85.2

70

58.2

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

STYLE NO: G15-078P
DATE: 2015/02/25

TAIPEI IE OUTPUT: 11.10
VN IE OUTPUT: 11.10

# OP NO Mã công đoạn	Operation Tên công đoạn	Grade Cấp	合縫記號	使用機器	Time Thời gian	Price Đơn giá	out put Sân lượng
B09	Set besom to back body	B		SINGLE	40	318.8	720
B11	Set besom*2(hand)	C		HAND	25	185.5	1152
B11	Close 2 edge*2	A		SINGLE	38	318.1	758
B12	Press pkt open*2	B		PRESS	17	135.5	1694
B13	Mark bag*2	C		HAND	15	111.3	1920
B14	Join pkt facing to bag*2*2	B		SINGLE	40	318.8	720
B15	1/16 stitch at pkt lip 3 under	B		SINGLE	36	286.9	800
B16	Safety bag*2	B		SW	35	279.0	823
B17	Tack 'sw'*2*2	B		SINGLE	28	223.2	1029
B18	Tack bag to w.band+tack pkt open	B		SINGLE	30	239.1	960
	W.band*6	Cấp*6					
C01	Mark band*6	C		HAND	45	333.9	640
C02	Join center shell band*2+lining band	B		SINGLE	47	334.7	686
C03	Press seam open+crease band(at)	B		PRESS	9	71.7	3200
C04	Join piping band*2	B		SINGLE	52	414.4	554
C05	Mark hook&eye*2	C		HANDSCL	12	89.0	2400
C06	Sew hook&eye*2	B		HANDSCL	180	1434.6	160
C07	Join upper band	B		SINGLE	70	557.9	411
C08	Trim & turn w.band	C		HAND	25	185.5	1152
C09	Sew cording upper band	B		SINGLE	18	143.5	1600
C10	1/16stitch upper w.band	B		SINGLE	23	183.3	1252
C11	Press upper w.band	B		PRESS	33	263.0	873
C12	Join piping under lining w.band	B		SINGLE	17	135.5	1694
C13	Press piping	B		PRESS	11	87.7	2618
C14	Sew lbi at zise to lbi main,sew lbi	B		SINGLE	35	279.0	823
	Lining	Lót quần					
D01	Serge at zipper*2	C		SW	12	89.0	2400
D02	Safety out seam	B		SW	45	358.7	640
D03	Safety in seam	C		SW	40	296.8	720
D04	Tack rise 1 edge	B		SINGLE	10	79.7	2880
D05	Safety front&back rise	C		SW	25	185.5	1152
D06	Foldstitch btm	B		SINGLE	62	494.1	465
D07	Sew btm tape+mark+cut*4	B		SINGLE	26	207.2	1108
D08	Tack tape*4	B		SINGLE	65	518.1	443
D09	Press	B		PRESS	30	239.1	960
	Total				3037	24,032	9.5



Position	GENERAL	SPECIAL			
作业別 Công đoạn	车缝(秒) Chuyên may	穿车(秒) Chuyên môn			
平车作业 Máy thường	1477				
锁链车作业 chỉ tết	125				
特殊车作业 Đặc chủng	404	68			
手工作业 Là	238				
手工作业 Cơ tay*	350	375			
合记工时(秒) Tổng thời gian	2594	443			
出数(件) (SLCN)	11.10	65.01			
总合计时(秒) Tổng công thời gian	3037		Total out put Tổng		9.5

製表人: huong