

(API5-138) 7-1006 女裝風衣外套尺寸跳法 Full Measurement Chart -- Updated 2015/05/25

SIZE	6	6 #	6 #	容許 差	尺寸 法	量法
胸圍 Chest	18	18 1/8	18 1/4	±1/2	1	AH下1"平量(半圍) 1" Below Armhole Flat (half)
腰圍 Waist	17 5/8	17 1/4	17 1/8	±1/2	1	ANP下15"平量(半圍) 15" Below ANP Flat (half)
下擺 Bottom Hem	22 1/2	22 1/2	22 1/2	±1/2	1	平量(半圍) Flat (half)
肩寬 Shoulder Width	15	14 7/8	14 7/8	±1/4	1/2	彎量(半圍) Curve (half)
前片袖窿 Front Armhole	9 1/4	9 1/8	9	±1/4	1/2	彎量(半圍) Curve (half)
上臂寬 Bicep Width	6 3/4	6 3/4	6 5/8	±1/8	貴司建議 Suggestion	AH下1"平量(半圍) 1" Below Armhole Flat (half)
前身長 Front Body Length	33	32 1/2	32 1/2	±3/8	3/4	SNP→前中下擺水平線垂直量 Horizontal Straight From HPS to Hem
領寬 Neck Width	6 1/4	6	6 1/4	±1/8	1/4	SNP→SNP平量 Flat
前領深 Front Neck Drop	3 3/4	✓	✓	±1/8	1/4	SNP→前中領接線垂直量 SNP->Straight From Center Front Neck Seam
後領深 Back Neck Drop	7/8	✓	✓	x	x	SNP→後中領接線垂直量 SNP->Straight From Center Back Neck Seam
領擺高 Back Collar Stand Height	1 3/8	✓	✓	x	x	
後領高 Back Neck Height	2 3/8	✓	✓	x	x	後中量 From Center Back
領尖 Collar Point	2 3/4	✓	✓	x	x	
腰帶長 Belt Length	64 3/8	64 1/4	64 1/4	x	貴司建議 Suggestion	
腰帶尖長 Belt Point Length	65 1/4	65 1/4	65 1/4	x	貴司建議 Suggestion	
腰帶寬 Belt Width	2	✓	✓	x	x	
袖長 Sleeve Length	23 1/2	23 1/8	23 1/2	±1/8	1/4	兩點量 2 Point
袖口寬 Sleeve Opening	5 1/4	5 1/4	5 1/4	±1/8	1/4	平量(半圍) Flat (half)

() ORIGINAL () REVISSED NO. 3

Y Y () ESTIMATED () NEGOTIATED

OTHERS () Updated Full

Measurement Chart

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: G15-258P,257P	款式說明 订单 : 2,400	制表人: NGA	日期: 2015/08/04	文件編號:
參考雷同款:			照片	
生產車縫時間:2308	特車組時間: 235	總時間: 2543		
生產出數: 12.48	特車組出數:122.6	IE 總出數: 11.3		

PPIC 主管:

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FLOW CHART OF G15-258P,257P**W.BAND*5**

- 32" 55. MARK BAND*5
 35" 56. PRESS UPPER BAND
 12" 57. JOIN CENTER W.BAND*1
 6" 58. PRESS SEAM OPEN
 20" 59. TRIM W.BAND
 65" 60. JOIN UPPER W. BAND*2
 17" 61. MARK HOOK&EYE*2
 30" 62. SNAP HOOK&EYE*2
 24" 63. TACK W.BAND 1 EDGE
 24" 64. SEW LBL AT ZISE TO LBL MAIN
 26" 65. SEW LBL AT BAND*2

FRONT

- 36" 1. MARK FRONT+PKT POSITION*2
 28" 2. SERGE PKT FACING*2*2
 15" 3. MARK PKT FACING*2
 36" 4. JOIN PKT OPEN*2
 (TACK BESOM+ BAG)
 20" 5. MARK PKT OPEN*2
 26" 6. 1/16 STITCH PKT OPEN*2
 17" 7. PRESS PKT OPEN*2
 22" 8. TACK BAG TO PKT FACING*2
 (SMALL PKT FACING)
 36" 9. TACK BAG TO PKT FACING*2
 (BIG PKT FACING)
 32" 10. TACK PKT TO UPPER& UNDER*2
 46" 11. JOIN BAG*2
 54" 12. TURN+TOPSTICH BAG*2
 26" 13. TACK PKT OPEN*2+TACK BAG TO
 ZIPPER POSITION*2
 22" 14. SERGE FRONT*2(ONLY IN SEAM)
 38" 33. TACK OUT SEAM*2(SEAM TO
 BAG SEAM TO WW.BAND)
 58" 34. SEFETY OUT SEAM*2
 20" 35. PRESS OUT SEAM
 56" 36. JOIN INSEAM*2(CHAIN STICH)
 16" 37. PRESS SEAM INSEAM
 36" 38. SERGE FRONT*2&BACK RISE*2
 46" 39. JOIN FRONT&BACK RISE(CHAIN STICH)
 16" 40. TACH CHAIN STICH AT RISE*2+BTN*2
 32" 41. JOIN FLY,STITCH
 23" 42. CREASE FLY,PRESS BACK RISE,INSEAM
 54" 50. SET ZIPPER+TACK RISE 1 EDGE
 45" 51. TOPSTITCH FLY+CLOSE*2
 12" 52. JOIN BELT LOOP+TRIM
 7" 53. MARK+ CUT BELT LOOP*5
 54" 54. SET BELT LOOP*5, MARK
 105" 66. SET W.BAND, MARK
 85" 67. CLOSE 2EDGE BAND+TURN
 120" 68. CRACK STICH UNDER W.BAND
 65" 69. CLOSE BELT LOOP*5
 21" 70. SERGE BTM
 65" 71. BLIND BTM
 110" 72. TRIM THREAD
 QC
 8" 001. MARK HOLE AT BAND*1 POSITION
 16" 002. SEW HOLE*1+SNAP BTN*1
 24" 003. MARK HOLE BACK PKT+BTN POSITION*2
 36" 002. SEW HOLE*2+BTN*2

BACK BODY*2

- 35" 15. MARK BACK+PLEAT*2
 24" 16. CLOSE PLEAT*2
 28" 17. SERGE BACK BODY(ONLY IN SEAM)
 13" 18. MARK PKT POSITION*2
 24" 19. PRESS PLEAT+FUSE PKT*2
 20" 20. SERGE PKT FACING*2*2
 54" 21. SET BESOM*2(MACH)
 21" 22. 1/16 STICH PKT OPEN*2(AT
 INSIDE SEAM)
 25" 23. SET BESOM(HAND)
 38" 24. CLOSE 2EDGE*2
 17" 25. PRESS PKT OPEN*2
 18" 26. MARK BAG*2
 36" 27. JOIN PKT FACING TO BAG*2*2
 32" 28. TACK BESOM TO BAG*2
 48" 29. JOIN BAG
 65" 30. TURN+1/4 TOPSTICH BAG
 54" 31. STITCH AT PKT LIP 3 UNDER*2+
 CLOSE 2EDGE BAG*2*2
 17" 32. TACK BAG TO W.BAND

ZIPPER FACING*2

- 14" 43. SEW EDGE*1
 10" 44. TRIM&TURN
 17" 45. PRESS
 12" 46. 1/16 STITCH
 5" 47. SERGE ZIPPER FACING
 6" 48. PIPING FLY*1
 14" 49. TACK ZIPPER TO
 ZIPPER FACING

POSITION TIME
TABLE

POSITIO N	GENERA L	SPECIAL
SINGLE CHAIN STITCH	1494	
DOUBLE	0	
SPECIAL	231	156
PRESS	140	
HAND	341	79
AMOUNT	2308	235
OUTPUT PCS	12.48	122.55
TOTAL TIME	2543	TOTAL OUTPUT 11.3

FORMOSTAR GARMENT (VIETNAM) CO., LTD

SEWING OPERATION LIST

STYLE NO: G15-258P

DATE: 2015/08/03

TAIPEI IE OUTPUT:

VN IE OUTPUT:

12.48

# OP NO Mã công	Operation Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件 及其他
01	Mark front& +pkt posititon*2	SD TT+vị trí túi TT*2	C	HAND	36	298.8	800	
02	Serge pkt facing*2*2	VS 3C đáp túi*2*2	B	SW	28	246.4	1029	
03	Mark pkt facing*2	SD đáp túi*2	C	HAND	15	124.5	1920	
04	Join pkt open*2(tack bag+besom)	Cán chắp miệng túi*2(mẫu)	B	SPECIAL	36	316.8	800	
05	Mark pkt open*2	SD miệng túi*2	C	HAND	20	166.0	1440	
06	1/16Stitch pkt open*2	Mì tăng cường miệng túi trong	B	SINGLE	26	228.8	1108	
07	Press pkt open*2	Là miệng túi trước*2	B	PRESS	17	149.6	1694	
08	Tack bag to pkt facing*2(small pkt facing)	Cán lót vào đáp túi*2(đáp nhỏ)	B	SINGLE	22	193.6	1309	
09	Tack bag to pkt facing*2(big pkt facing)	Dán đáp vào lót túi*2(đáp to)	B	SINGLE	36	316.8	800	
10	Tack pkt to upper and under*2	Ghim miệng túi trên dưới*2	B	SINGLE	32	281.6	900	
11	Join bag*2	Quay tròn đít túi*2	B	SINGLE	46	404.8	626	
12	Turn+1/4topstitch bag*2	Lộn+Điều đít túi 1/4	B	SINGLE	54	475.2	533	
13	Tack pkt open*2+tack bag to zipper position	Ghim kín miệng túi z+ghim lót vào khóa môi	B	SINGLE	32	281.6	900	
14	Serge front*2(only in in seam*2)	VS 3C xung quanh TT*2(chỉ vắt sổ giăng)	B	SW	28	246.4	1029	
15	Tack out seam*2(seam to bag seam to w.ba	Ghim sườn một đoạn(cạnh túi)	B	SINGLE	38	334.4	758	
16	sefety outseam*2	VS 5 chỉ dọc quần	B	SW	65	572.0	443	
17	Press out seam	Là dọc quần	B	PRESS	20	176.0	1440	
18	Join inseam*2(chain stitch)	Cán chắp giăng quần*2(chỉ tết)	B	CHAIN STITCH	56	492.8	514	
19	Press seam inseam	Là rế giăng quần	B	PRESS	16	140.8	1800	
20	Serge front&back rise*2	VS 3C đứng TT*2+TS*2	B	SW	36	316.8	800	
21	Join front&back rise	Chấp đứng TT+TS (chỉ tết)	B	CHAIN STITCH	46	404.8	626	
22	Tack chain stitch at rise*2+btn*2	Chặn lại mũi chỉ tết đứng*2+gấu*2	B	SINGLE	16	140.8	1800	
23	Join fly, stitch	Cán chắp moi+mí	B	SINGLE	32	281.6	900	
24	Crease fly+press back rise	Là gập moi+là đứng TT+TS	B	PRESS	23	202.4	1252	
25	Set zipper+tack rise 1 edge	Tra khóa+ghim đứng trước 1 đoạn	A	SINGLE	54	502.2	533	
26	Topstitch fly+close *2	Điều moi khóa 1 kim+chặn moi*2	B	SINGLE	45	396.0	640	
27	Join belt loop+trim	Cán đĩa+chém+máy đĩa	B	SINGLE	12	105.6	2400	
28	Mark+cut belt loop*5	SD+cắt đĩa*5	C	HAND	7	58.1	4114	
29	Set belt loop*5,mark	Tra đĩa,sd*5	B	SINGLE	54	475.2	533	
30	Set w.band,mark	Tra cạp,sd	A	SINGLE	105	976.5	274	
31	Close 2 edge band+turn	Chặn 2 đầu cạp +lộn	B	SINGLE	85	748.0	339	
32	Crack Stitch under w.band	Mì chân cạp lọt khe	B	SINGLE	120	1056.0	240	
33	Close belt loop*5	Chặn đĩa trên,dưới*5*2	B	SINGLE	65	572.0	443	
34	Serge btm	VS 3C gấu	B	SW	21	184.8	1371	
35	Blind btm	Vắt gấu quần	B	SINGLE	65	572.0	443	
36	Mark hole at band*1 posititon	SD thừa khuyết cạp*1	C	HANDSCL	8	66.4	3600	
37	Sew hole*1+snap btn*1	Thùa khuyết*1+đinh cúc*1	B	SPECIAL	16	140.8	1800	
B19	Mark hole back pkt+btn position*2	SD vị trí bỏ khuyết+cúc túi sau	C	HANDSCL	24	199.2	1200	
B20	Sew hole*2+btn*2	Bỏ khuyết+đinh cúc túi sau	B	SPECIAL	36	316.8	800	
XZ	Trim thread	Cắt chỉ	C	HAND	110	913.0	262	
	Zipper facing*2	Đáp khóa+môi*2						
A01	Sew edge*1	Cán chắp đáp khóa bìa mẫu	B	SPECIAL	14	123.2	2057	
A02	Trim&turn	Gột,lộn đáp khóa	C	HAND	10	83.0	2880	
A03	Press	Là đáp khóa 2 bên	B	PRESS	17	149.6	1694	
A04	1/16stitch	Mì đáp khóa	B	SINGLE	12	105.6	2400	
A05	Serge zipper facing	VS 3C đáp khóa	B	SW	5	44.0	5760	
A06	Piping fly	Cuốn viền moi	B	SINGLE	6	52.8	4800	
A07	Tack zipper to zipper facing	Ghim khóa vào đáp khóa+chặn vs khóa	B	SINGLE	14	123.2	2057	
	Back body*2	Thân sau*2						
B01	Mark back+pleat*2	SD TS+ly TS*2	C	HAND	35	290.5	823	
B02	Close pleat*2	Máy ly TS*2	B	SINGLE	24	211.2	1200	
B03	Serge back*2(only in seam*2)	VS 3C TS*2	B	SW	28	246.4	1029	
B04	Mark pkt position*2	SD vị trí túi sau*2	C	HAND	13	107.9	2215	
B05	Press pleat+Fuse pkt*2	Là ly+mex vào vị trí túi*2	B	PRESS	24	211.2	1200	
B06	Serge pkt facing*2*2	VS 3C đáp túi*2*2	B	SW	20	176.0	1440	
B07	Set besom*2(mach)	Bỏ túi bằng máy*2	B	SPECIAL	54	475.2	533	
B08	1/16Stitch pkt open*2(at inside seam)	Mì tăng cường coi túi bên trong	B	SINGLE	21	184.8	1371	
B09	Set besom*2(hand)	Bỏ túi bằng tay*2	C	HAND	25	207.5	1152	
B10	Close 2edge*2	Chặn 2 đầu coi túi*2	A	SINGLE	38	353.4	758	
B11	Press pkt open*2	Là miệng coi túi sau*2	B	PRESS	17	149.6	1694	
B12	Mark bag*2	SD lót*2	C	HAND	18	149.4	~1600	
B13	Join pkt facing to bag*2*2	Cán đáp túi vào lót*2*2	B	SINGLE	36	316.8	800	

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SEWING OPERATION LIST

STYLE NO: G15-258P

DATE: 2015/08/03

TAIPEI IE OUTPUT:

VN IE OUTPUT:

12.48

# OP NO Mã công	Operation Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件 及其他
B14	Tack besom to bag*2	Ghim cơi vào lót*2	B	SINGLE	32	281.6	900	
B15	Join bag*2	Quay tròn đít túi	B	SINGLE	48	422.4	600	
B16	Turn+1/4topstitch bag*2	lộn+Diều đít túi 1/4	B	SINGLE	65	572.0	443	
B17	1/16 stitch at pkt lip 3 under*2+close 2 edge	Mí 3 cạnh cơi túi+chặn 2 góc lót túi	A	SINGLE	54	502.2	533	
B18	Tack bag to w.band*2	Ghim túi trên cạp	B	SINGLE	17	149.6	1694	
	W.band*5	Cạp*5						
C01	Mark w.band*2	SD cạp*2	C	HAND	32	265.6	900	
C06	Press upper w.band	Là sống cạp	B	PREES	35	308.0	823	
C02	Join center w.band*1	Cán giữa cạp*1	B	SINGLE	12	105.6	2400	
C03	Press seam open	Là rẽ cạp	B	PRESS	6	52.8	4800	
C04	Trim band	Chém sửa cạp (môt lá ngoài)	C	HAND	20	166.0	1440	
C05	Join upper w.band	Cán cháp sống cạp	B	SINGLE	65	572.0	443	
C07	Mark hook&eye*2	SD đính khuy móc cạp*2*2	C	HANDSCL	17	141.1	1694	
C08	Hook&eye*2*2	Đính khuy móc*2*2	C	HANDSCL	30	249.0	960	
C13	Tack w.band 1edge	Ghim cạp 1 đường	B	SINGLE	26	228.8	1108	
C09	Sew lbl at zise to lbl main,sew lbl at band	Máy móc cỡ vào móc chính	B	SINGLE	24	211.2	1200	
C10	Sew lbl at w.band*2	Máy móc vào cạp*2	B	SINGLE	26	228.8	1108	
TOTAL					2543	22294	11.3	



Position	GENER AI	SPECIAL			
Single	1494				
Double	0				
Chain stitch	102				
Special	231	156			
Press	140				
Hand	341	79			
Amount	2308	235			
Output (pcs)	12.48	122.55			
Total time	2543		Total out put		11.3

製表人 HUONG