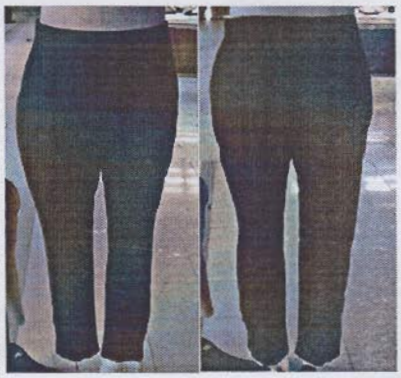
福星制衣越南廠 制衣工程 IE 出數核定流程表

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。

<table>
<tr><td>款式:
G15-272P</td><td colspan="2">款式說明 LADIE PANTS
订单 7650</td><td>制表人:
HUONG</td><td>日期: 2015/08/14</td><td>文件編號:</td></tr>
<tr><td colspan="4">參考雷同款:</td><td colspan="2" rowspan="4">照片
  </td></tr>
<tr><td>生產車縫時間:1565</td><td>特車組時間:26</td><td colspan="2">總時間: 1591</td></tr>
<tr><td>生產出數: 18.40</td><td>特車組出數:1107.69</td><td colspan="2">IE 總出數: 18.1</td></tr>
</table>

PPIC 主管:

CUSTOMER : CH

2015/08/14
HUONG

FLOW CHART OF G15-272P

RIB BAND*1

- 15" 31.MARK RIB BAND*1
- 18" 32.JOIN CENTER RIB BAND*1
- 6" 33.PRESS ESLASTIC BAND
- 13" 34.MARK+CUT ESLASTIC BAND
- 12" 35.CLOSE OPEN ESLASTIC
- 68" 36.TACK ESLASTIC TO RIB BAND+STITCH*8
- 32" 37.PRESS SEAM+PRESS UPPER W.BAND
- 23" 38.TACK W.BAND 1EDGE

FRONT PKT*2

- 12" 5.SEREG BAG*2
- 26" 6.JOIN PKT OPEN*2
- 18" 7.PRESS PKT OPEN
- 32" 8.1/4D/NTOPSTITCH PKT OPEN(CHAIN STITCH)
- 12" 9.SHIRRING*2
- 36" 10.CRAESE AROUNG PKT*2

FRONT

- 38" 1.MARK FRONT*2*2
- 48" 2.SEFETY F.PANEL SEAM*2
- 44" 3.1/4D/N TOPSTITCH F.PANEL SEAM
- 22" 4.MARK PKT POSITION*2
- 68" A 11.ATTACK STITCH F.PKT*2
- 18" 12.TACK PKT TO OUT SEAM
- 23" 13.JOIN FLY
- 17" 14.SERGE FLY
- 30" 15.TOPSTITCH FLY
- 54" 19.SEFETY OUT SEAM*2
- 72" 26.CLOSE TOPSTITCH BTM TAB+MARK*2
- 46" 27.SEFETY INSEAM*2
- 24" 28.TACK RISE 1 EDGE
- 34" 29.SEFETY FRONT&BACK RISE
- 38" 30.D/N TOPSTITCH BACK RISE
- 72" A 39.SET W.BAND,MARK(CHAIN STITCH)
- 56" 40.TACK UNDER W.BAND OPEN
- 27" 41.SERGE UNDER W.BAND
- 18" 42.TACK LBL AT W.BAND*2
- 67" 43.1/4D/N TOPSTITCH UNDER W.BAND(CHAIN STITCH)
- 22" 44.SEW LBL AT SIZE TO LBL AT MAIN+TACK LBL AT OUT SEAM*2
- 78" 45.FOLDSTITCH HEM
- 90" 46.TRIM THREAD
- QC

BACK BODY*2*2

- 38" 16.MARK BACK*2*2
- 48" 17.SEFETY B.PANEL SEAM*2
- 44" 18.1/4D/N TOPSTITCH B.PANEL SEAM

BTM TAB*2

- 22" 20.CREASE TAB BTM*2
- 20" 21.CLOSE 2 EDGE*2
- 12" 22.TRIM&TURN
- 52" 23.STITCH& TOPSTITCH BTM TAB*2
- 8" 24.MARK HOLE*2
- 18" 25.SEW HOLE+BARTACK*2

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	640	
CHAIN STITCH	183	
DOUBLE	114	
SPECIAL	286	18
PRESS	114	
HAND	228	8
AMOUNT	1565	26
OUPUT PCS	18.40	1107.69
TOTAL TIME	1591	TOTAL OUTPUT 18.1

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

STYLE NO: G15-272P
DATE: 2015/08/14

TAIPEI IE OUTPUT:
VN IE OUTPUT: 18.40

# OP NO Mã	Operation Tên công đoạn		Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn	out put Sản lượng	使用配件及其他
01	Mark front*2*2	SD TT*2*2	C		HAND	38	282.0	737	
02	Sefety F.panel seam*2	VS 5c sườn TT*2	B		SW	48	382.6	583	
03	1/4topstitch F.panel seam*2	Diễu sườn TT 2kim 1/4	B		CHAIN STITC	44	350.7	636	
04	Mark pkt position*2	SD vị trí túi*2	C		HAND	22	163.2	1273	
05	Attack stitch F.pkt*2	Mí dán túi TT*2 1/16	A		SINGLE	68	569.2	412	
06	Tack pkt to out seam	Ghim túi trên sườn	B		SINGLE	18	143.5	1556	
07	Join fly	Can chắp đoạn moi giả	B		SINGLE	23	183.3	1217	
08	Serge fly	VS 3C moi	B		SW	17	135.5	1647	
09	Topstitch fly	Diễu moi 1kim	B		SINGLE	30	239.1	933	
10	Sefety out seam*2	VS 5C dọc quần *2	B		SW	54	430.4	519	
11	Close topstitch btm tab+mark	Chặn diễu cá gấu +sd	B		SINGLE	72	573.8	389	
12	Sefety inseam*2	VS 5C giàng quần*2	B		SW	46	366.6	609	
13	Tack rise 1edge	Ghim cố định đũng 1 đoạn	B		SINGLE	24	191.3	1167	
14	Sefety front + back rise	VS 5C đũng TT+TS	B		SW	34	271.0	824	
15	D/N Topstitch back rise	Diễu đũng 2kim	B		DOUBLE	38	302.9	737	
16	Set w.band,mark	Tra cạp, SD(chỉ tết)	A		CHAIN STITCH	72	602.6	389	
17	Tack under w.band open	Ghim miệng chân cạp	B		SINGLE	56	446.3	500	
18	Serge under w.band	VS 3C chân cạp	B		SW	27	215.2	1037	
19	Tack lbl w.band*2	Ghim mác vào cạp*2	B		SINGLE	18	143.5	1556	
20	1/4 topstitch under w.band	Diễu chân cạp 2 kim 1/4	A		CHAIN STITC	67	560.8	418	
21	Sew lbl at size to lbl at main+tack lbl	Ghim mác size vào mác ID+ghim mác sườn	B		SINGLE	22	175.3	1309	
22	Foldstitch hem	Diễu gấp gấú 1 inch	B		SINGLE	78	621.7	359	
XZ	Trim thread	Cắt chỉ	C		HAND	90	667.8	311	
	Front pkt*2	***Túi TT*2***							
A01	Serge bag*2	VS 3C cơi túi*2	B		SW	12	95.6	2333	
A02	Join pkt open*2	Can chắp miệng túi*2	B		SINGLE	26	207.2	1077	
A03	Press pkt open*2	Là miệng túi trước*2	B		PRESS	18	143.5	1556	
A04	1/4D/N Topstitch pkt open	Diễu miệng túi 2kim 1/4	B		DOUBLE	32	255.0	875	
A05	Shirring *2	May dúm đít túi*2	B		SINGLE	12	95.6	2333	
A06	Crease around pkt*2	Là gấp túi xung quanh*2	B		PRESS	36	286.9	778	
		Cá gấu*2							
B01	Crease btm tab*2	Là gập cá gấu*2(máy ép)	B		PRESS	22	175.3	1273	
B02	Close 2 edge*2	Chặn 2 đầu cá gấu*2(đầu nhọn)	B		SINGLE	20	159.4	1400	
B03	Trim&turn	Chém+Lộn 2 đầu cá gấu	C		HAND	12	89.0	2333	
B04	Stitch&topstitch tab btm*2	Mí diễu cá gấu*2	B		SINGLE	52	414.4	538	
B05	Mark hole *2	SD vị trí bổ khuy*2	C		HANDSCL	8	59.4	3500	
B06	sew hole+bartack*2	Bổ khuy+di bọ*2	B		SPECIAL	18	143.5	1556	
	Back body*4	***Thân sau*4***							
C01	Mark back*2*2	SD TS*2*2	C		HAND	38	282.0	737	

FORMOSTAR GARMENT (VIETNAM) CO., LTD
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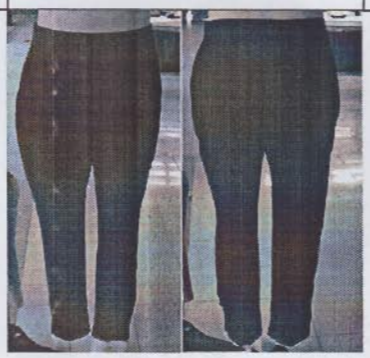
VN IE OUTPUT: 18.40

C02	Sefety B.panel seam*2	VS 5C sườn TS*2	B		SW	48	382.6	583	
C03	1/4D/N Topstitch B.panel seam*2	Diễu sườn TS 2 kim 1/4*2	B		DOUBLE	44	350.7	636	
	Rib band*1	***Cạp bo*1***							
D01	Mark rib band*1	SD bo cạp*1	C		HAND	15	111.3	1867	
D02	Join center rib band*1	Can giữa bo cạp*1	B		SINGLE	18	143.5	1556	
D03	Press eslastic band	Là chun cạp	B		PRESS	6	47.8	4667	
D04	Mark++cut eslastic band	SD+cắt chun cạp*1	C		HAND	13	96.5	2154	
D05	Close open eslastic	Chặn miệng chun cạp	B		SINGLE	12	95.6	2333	
D06	Tack eslastic to rib bad+stitch*8	Ghim chun vào bo cạp+mí 2 đường	B		SINGLE	68	542.0	412	
D07	Press seam+press upper w.band	Là rẽ can cạp+là sống cạp	B		PRESS	32	255.0	875	
D08	Tack w.band 1 edge	Ghim cạp 1 đường	B		SINGLE	23	183.3	1252	
						1591	**12633**	**18.1**	



Position	**General**	**Special**			
Single	640				
Chain stitch	183				
Double	114				
Special	286	18			
Press	114				
Hand	228	8			
Amount	1565	26			
Output (pcs)	18.40	1107.69			
Total time	1591		Total out put		18.1

製表人HUONG