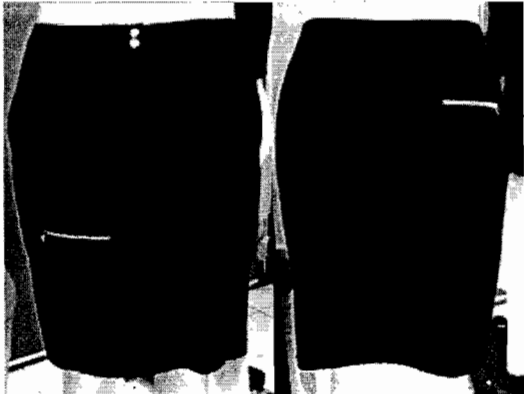


福星制衣越南廠 制衣工程 IE 出數核定流程表

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： G15-279S	款式說明 LADIE SKIRT 订单 1335	制表人： HUONG	日期：2015/10/08	文件編號：
參考雷同款：			照片 	
生產車縫時間:2480	特車組時間:48	總時間: 2528		
生產出數: 11.61	特車組出數:600	IE 總出數: 11.39		

PPIC 主管：


 2015/10/08

FLOW CHART OF G15-279S**ZIPPER
FACING*3**

- 12" 56. SEW EDGE*1
10" 57. TRIM W. BAND
7" 58. PRESS
12" 59. 1/16 STITCH
4" 60. CLOSE ZIPPER FACING OPEN
9" 61. SERGE*2
12" 62. TACK ZIPPER TO
ZIPPER FACING

W. BAND*6

- 45" 66. SEW EDGE*3 (TEMPLATE)
32" 67. MARK BAND*3
26" 68. CREASE UNDER W. BAND*3
38" 69. JOIN CENTER BAND*4
6" 70. PRESS SEAM OPEN
18" 71. TRIM BAND
7" 72. PRESS ELASTIC
20" 73. MARK+ CUT ELASTIC BAND*1
16" 74. TACK ELASTIC BAND 1 EDGE
18" 75. TACK W. BAND 1 EDGE
24" 76. PRESS UPPER W. BAND

FRONT

- 37" 1. MARK FRONT*4+PKT POSITION*2
28" 2. SERGE PKT OPEN*2+OUT
SEAM (FROM TO BAG TO W. BAND)
9" 3. SERGE BAG*2
14" 4. FUSE MEX*2
42" 5. JOIN EDGE PKT OPEN*2, NOTCH
14" 6. 1/16 STITCH PKT OPEN*2 (AT INSIDE)
16" 7. PRESS PKT OPEN*2
36" 8. 1/4 TOPSTITCH PKT OPEN*2
22" 9. TACK BAG TO OUT SEAM
28" 10. SAFETY BAG*2
11" 11. TACK "SW" PKT*2
56" 12. SERGE F. PANEL SEAM*2*2+VENT FACING
17" 13. SERGE AT SET ZIPPER
18" 14. SAFETY CENTER FRONT*1
16" 15. PRESS CENTER FRONT+BTM
28" 16. FOLDSTITCH FRONT BTM (KANSAI)
32" 17. JOIN F. PANEL SEAM*2
18" 18. PRESS F. PANEL SEAM+VENT FACING
52" 19. 1/16 STITCH F. PANEL SEAM*2
30" 20. JOIN OUT SEAM (FROM TO BAG TO W. BAND)
24" 38. SAFETY OUT SEAM
28" 39. PRESS SEAM+CREASE B. BTM
54" 40. FOLDSTITCH BACK BTM (KANSAI)
40" 41. JOIN VENT FACING
9" 42. SERGE BAG ZIPPER*1
13" 43. MARK SET ZIPPER POSITION*1
9" 44. PRESS FUSE AT SET ZIPPER*1
28" 45. SET BESOM*1 (TEMPLATE)
13" 46. SET BESOM*1 (HAND)
18" 47. CLOSE 2 EDGE
9" 48. PRESS BESOM*1
30" 49. SET ZIPPER AT BAG
13" 50. 1/16 STITCH UNDER EDGE
28" 51. JOIN BAG+STITCH LIP 3 UNDER
15" 52. MARK ATTACK TOPSTITCH*2
48" 53. 1/4 D/N TOPSTITCH FRONT PKT*1
23" 54. JOIN FLY. STITCH
6" 55. CREASE FLY
37" 63. SET ZIPPER, STITCH
33" 64. 1/4 D/N TOPSTITCH FLY
7" 65. TACK FLY*2
80" 77. SET W. BAND, MARK
48" 78. TACK ELASTIC TO W. BAND*6 POINT
52" 79. TACK ELASTIC TO EDGE BAND, TURN
76" 89. SET LINING W. BAND, MARK
17" 90. TACK LBL AT W. BAND*2
35" 91. 1/16 STITCH UPPER
W. BAND (CHAIN STITCH)
78" 92. FOLDSTITCH UNDER
W. BAND (CHAIN STITCH)
20" 93. CLOSE CHAINSTITCH EDGE BAND*2*2
18" 94. LBL AT OUT SEAM
68" 95. TRIM THREAD

BACK BODY*2

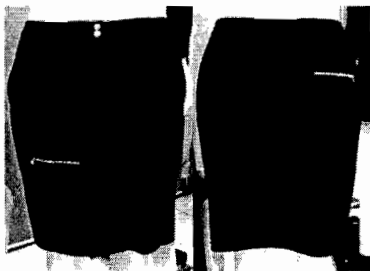
- 30" 21. MARK BACK*3
42" 22. SERGE B. PANEL SEAM*2*2
34" 23. JOIN B. PANEL SEAM*2
14" 24. PRESS B. PANEL SEAM*2
52" 25. 1/16 STITCH B. PANEL SEAM*2
9" 26. SERGE BAG ZIPPER*1
13" 27. MARK SET ZIPPER POSITION*1
9" 28. PRESS FUSE AT SET ZIPPER*1
28" 29. SET BESOM*1 (TEMPLATE)
13" 30. SET BESOM*1 (HAND)
18" 31. CLOSE 2 EDGE
9" 32. PRESS BESOM*1
30" 33. SET ZIPPER AT BAG
13" 34. 1/16 STITCH UNDER EDGE
28" 35. JOIN BAG+STITCH LIP 3 UNDER
15" 36. MARK ATTACK TOPSTITCH*2
48" 37. 1/4 D/N TOPSTITCH BACK PKT*1

LINING

- 12" 80. MARK LINING
48" 81. CLOSE PLEAT*2*2
17" 82. O/L 4T AT ZIPPER & FLY
30" 83. 1/4 TOPSTITCH ZIPPER & FLY
36" 84. O/L 4T OUT SEAM
20" 85. O/L 4T IN SEAM
42" 86. O/L 4T FRONT RISE & BACK F
76" 87. FOLDSTITCH BTM (KANSAI)
18" 88. PRESS

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1182	
CHAIN STITCH	113	
KANSAI	158	
DOUBLE	129	
SPECIAL	364	36
PRESS	233	
HAND	301	12
AMOUNT	2480	48
OUTPUT PCS	11.61	600
TOTAL TIME	2528	TOTAL OUTPUT 11.39



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

STYLE NO: AP15-279S
DATE: 2015/10/08

TAIPEI IE OUTPUT:
VN IE OUTPUT:

Step Mã cấp	Step name Tên công đoạn		Grade Cấp	合縫記號	使用機番	Time Thời gian	price Đơn giá	Output Sản lượng
	<i>Thân trước, mẫu chính</i>							
01	Mark front+pkt*2 position	SD TT*4+vị trí túi trước*2	C		HAND	37	274.5	778
02	Serge pkt open*2+out seam(from to bag	VS 3C miệng túi*2+sườn(từ lót miệng túi đến c	B		SW	28	223.2	1029
03	Serge bag*2	VS 3C 1 cạnh lót túi*2	B		SW	9	71.7	3200
04	Fuse mex*2	Là mex vào vị trí túi*2	B		PRESS	14	111.6	2057
05	Join edge pkt open*2,notch	Quay miệng túi,bấm	B		SINGLE	42	334.7	686
06	1/16stitch pkt open	Mí tăng cường miệng túi	B		SINGLE	14	111.6	2057
07	Press pkt open*2	Là miệng túi*2	B		PRESS	16	127.5	1800
08	1/4 Topstitch pkt open*2	Điều chỉnh miệng túi 1/4	B		SINGLE	36	286.9	800
09	Tack bag to out seam	Ghim lót túi vào cạnh sườn	B		SINGLE	22	175.3	1309
10	Safety bag*2	Quay lót túi(vs 5c)	B		SW	28	223.2	1029
11	Tack"sw" pkt*2	Chặn dàu vs túi	B		SINGLE	11	87.7	2618
12	Serge F.panel seam*2*2+vent facing	VS 3C sườn tt*2*2+ đáp sê sườn	B		SW	56	446.3	514
13	Serge at set zipper	VS 3C đoạn tra khóa	B		SW	17	135.5	1694
14	Safety center front*1	VS 5C giữa TT	B		SW	18	143.5	1600
15	Press center front+btm	Là giữa TT+gấu TT	C		PRESS	16	118.7	1800
16	Foldstitch front btm(kansai)	Gập điều gấu TT(máy kan sai)	B		KANSAI	28	223.2	1029
17	Join F.panel seam*2	Cán chập sườn TT*2	B		SINGLE	32	255.0	900
18	Press F.panel seam+vent facing	Là rẽ sườn TT+là gập sê	B		PRESS	18	143.5	1600
19	1/16stitch F.panel seam*2*2	Mí 1/16 sườn TT*2*2	B		SINGLE	52	414.4	554
20	Join out seam(from to bag to w.band)	Cán chập dọc váy từ lót túi đến cạp	B		SINGLE	30	239.1	960
21	Safety out seam*2	VS 5C dọc váy	B		SW	24	191.3	1200
22	Press seam +crease back btm	Là lật dọc váy+là gấu TS	B		PRESS	28	223.2	1029
23	Foldstitch B. btm	Gập điều gấu 2kim máy kan sai	B		KANSAI	54	430.4	533
24	Join vent facing	Cán chập đáp sê sườn	B		SINGLE	40	318.8	720
25	Serge bag zipper*1	VS 3C lót túi khóa thân trước*1	B		SW	9	71.7	3200
26	Mark set zipper position*1	SD vị trí túi khóa*1	C		HAND	13	96.5	2215
27	Press fuse at set zipper*1	Là mex vào vị trí túi khóa *1	B		PRESS	9	71.7	3200
28	Set besom*1(template)	Bỏ khóa túi bằng bìa mẫu*1(ghim 2 đường)	B		SINGLE	28	223.2	1029
29	Set besom*1(hand)	Bỏ túi bằng tay	C		HAND	13	96.5	2215
30	Close 2edge	Chặn 2 đầu coi túi	A		SINGLE	18	150.7	1600
31	Press besom*1	Là miệng coi túi*1	B		PRESS	9	71.7	3200
32	Set zipper at bag	Tra khóa túi	A		SINGLE	30	251.1	960
33	1/16stitch under edge	Mí cạnh dưới	B		SINGLE	13	103.6	2215
34	Join bag+stitch lip 3 under	Ghim lót+mí 3 cạnh trên	B		SINGLE	28	223.2	1029
35	Mark attack topstitch*1	SD điều ốp túi trước2	C		HAND	15	111.3	1920
36	1/4D/N Attack topstitch back pkt*1	Điều ốp túi trước 2kim 1/4	A		DOUBLE	48	401.8	600
37	Join fly, stitch	Cán chập moi+mí	B		SINGLE	23	183.3	1252
38	Crease fly	Là gập moi+Là gập đoạn tra khóa	B		PRESS	6	47.8	4800
39	Set zipper, stitch	Tra khóa, mí+ghim đúng 1 đoạn	A		SINGLE	37	309.7	778
40	D/N Topstitch fly	Điều moi 2kim 1/4	B		DOUBLE	33	263.0	873
41	Tack fly*2	Ghim moi*2	B		SINGLE	7	55.8	4114
42	Set w.band, mark	Tra cạp, sd	A		SINGLE	80	669.6	360
43	Tack elastic to w.band*6 point	Ghim chun 6 điểm vào cạp	B		SINGLE	48	382.6	600
44	Tack elastic to edge band, turn	Chặn chun 2 điểm vào đầu cạp, lộn	B		SINGLE	52	414.4	554
45	Set lining w.band, mark	Lồng lót cạp, sd	B		SINGLE	76	605.7	379
46	Tack lbl at w.band*2	Ghim mác cạp*2	B		SINGLE	17	135.5	1694
47	1/16stitch upper w.band(chain stitch)	Mí sống cạp 1/16(chỉ tết)	B		CHAIN STITCH	35	279.0	823

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

STYLE NO: AP15-279S
DATE: 2015/10/08

TAIPEI IE OUTPUT:
VN IE OUTPUT:

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	Output Sản lượng
48	Fold stich under w.band(chain stitch)	A		CHAIN STITCH	78	652.9	369
49	Close chain stitch edge band*2*2	B		SINGLE	20	159.4	1440
50	LBL at out seam	B		SINGLE	18	143.5	1600
XZ	Trim&turn	C		HAND	68	504.6	424
001	Mark btn*2*2	C		HANDSCL	12	89.0	2400
002	Snap btn*2*2	B		SPECIAL	36	286.9	800
	Zipper facing*3						
	Đáp khóa*3						
A01	Sew edge*1	B		SINGLE	12	95.6	2400
A02	Trim&turn	C		HAND	10	74.2	2880
A03	Press	B		PRESS	7	55.8	4114
A04	1/16stitch	B		SINGLE	12	95.6	2400
A05	Close zipper facing open	B		SINGLE	4	31.9	7200
A06	Serge*2	B		SW	9	71.7	3200
A07	Tack zipper to zipper facing	B		SINGLE	12	95.6	2400
	Back body*3						
	Thân sau*3						
B01	Mark back*3	C		HAND	30	222.6	960
B02	Serge B.panel seam*2*2	B		SW	42	334.7	686
B03	Join B.panel seam*2	B		SINGLE	34	271.0	847
B04	Press B.panel seam*2	B		PRESS	14	111.6	2057
B05	1/16Stitch B.panel seam*2*2	B		SINGLE	52	414.4	554
B06	Serge bag*1	B		SW	9	71.7	3200
B08	Mark set zipper position*1	C		HAND	13	96.5	2215
B09	Fuse mex*1	B		PRESS	9	71.7	3200
B10	Set besom*1(template)	B		SINGLE	28	223.2	1029
B11	Set besom*1(hand)	C		HAND	13	96.5	2215
B12	Close 2edge*1	A		SINGLE	18	150.7	1600
B13	Press besom*1	B		PRESS	9	71.7	3200
B14	Set zipper	A		SINGLE	30	251.1	960
B15	1/16stitch under edge	B		SINGLE	13	103.6	2215
B16	Tack bag+stitch lip 3under	B		SINGLE	28	223.2	1029
B17	Mark attack topstitch*2	C		HAND	15	111.3	1920
B18	1/8D/N Attack topstitch back pkt*2	A		DOUBLE	48	401.8	600
	W.band*6						
	Cạp*6						
C01	Sew edge*3(template)	B		SINGLE	34	271.0	847
C02	Mark band*6	C		HAND	32	237.4	900
C03	Cresae under w.band*3	B		PRESS	26	207.2	1108
C04	Join band*4	B		SINGLE	42	334.7	686
C05	Press seam open	B		PRESS	28	223.2	1029
C06	Trim band	C		HAND	18	133.6	1600
C07	Press elastic	B		PRESS	6	47.8	4800
C08	Mark+cut elastic band*1	C		HAND	12	89.0	2400
C09	Tack w.band 1edge	B		SINGLE	21	167.4	1371
	Lining						
	Lót						
D01	Mark lining	C		HAND	12	89.0	2400
D02	Close pleat*2*2	B		SINGLE	48	382.6	600
D03	O/L 4T at zipper&fly	B		SW	17	135.5	1694
D04	1/4 Topstitch at zipper&fly	B		SINGLE	20	159.4	1440

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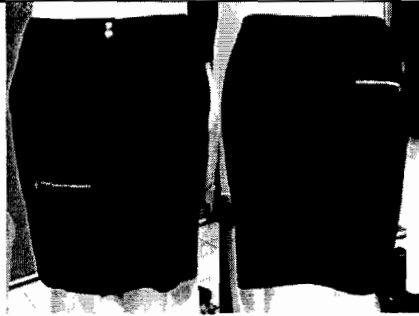
STYLE NO: AP15-279S

DATE: 2015/10/08

TAIPEI IE OUTPUT:

VN IE OUTPUT:

Step Mã công	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
D05	O/L 4T out seam	VS 4C dọc váy	B		SW	36	286.9	800
D06	O/L 4T in seam	VS 4C giăng	B		SW	20	159.4	1440
D07	O/L 4T front rise& back rise	VS 4C đũng TT+TS	B		SW	42	334.7	686
D08	Foldstitch btm(kansai)	May kan sai gấu lót(2kim)	B		KANSAI	76	605.7	379
D09	Press	Là lót	B		PRESS	18	143.5	1600
TOTAL						2528	20122.0	11.39



Position	GENER AI	SPECIAL			
single	1182				
Kansai	158				
Double	129				
special	364	36			
Chain stich	113				
press	233				
hand	301	12			
amount	2480	48			
output pcs	11.61	600.0			
total time	2528		total out put		11.39

製表人: Huong