

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: G16-125P	款式說明 LADIE PANST 订单 6.325	制表人 THAO	日期: 2016/06/13	文件編號:
參考雷同款:				
生產車縫時間 1305	特車組時 0	總時間: 1305		
生產出數: 22.07	特車組出數 0	IE 總出數: 22.07		

PPIC 主管:

15
26
13

茲核定IE出數如下:			
衣車縫	21.2	件	掛車縫
身整件	20.7	件	裡整件
全車縫		件	核
件整件		件	簽

6/15/2016

FLOW CHART OF G16-125P**FRONT**

- 40" (X) 1. MARK FRONT*2+PKT POSITTON*2
 14" (O) 2. PRESS MEX AT PKT OPEN*2
 38" (O) 3. JOIN PKT OPEN*2
 22" (O) 4. 1/16STITCH PKT OPEN*2
 17" (O) 5. PRESS PKT OPEN*2
 40" (O) 6. TOPSTITCH PKT OPEN*2(COVER STITCH)
 32" (O) 7. TACK PKT OPEN UPPER+UNDER
 25" (X) 8. SEFETY PKT BAG*2
 9" (O) 9. CLOSE "SW" PKT*2
 25" (O) 10. TACK PUCKERING F.SEAM
 BOTTOM IEDGE*2
 40" (X) 11. MARK BACK*2
 60" (X) 12. SEFETY OUTSEAM
 35" (X) 13. SERGE INSEAM
 70" (O) 14. TOPSTITCH OUTSEAM(COVER STITCH)
 50" (X) 15. SEFETY INSEAM
 36" (X) 16. SEFETY FRONT+BACK RISE
 48" (O) 17. TOPSTITCH FRONT+BACK RISE(COVER STITCH)
 30" (O) 26. SEW CORDING
 15" (X) 27. MARK,CUT CORDING*1
 75" (A) 28. SET W.BAND.MARK
 28" (X) 29. INSERT CORDING
 36" (X) 30. SERGE UNDER BAND
 28" (O) 31. SEW LBL AT SIZE TO LBL AT MAIN+TACK LBL AT W.BAND
 65" (A) 32. TOPSTITCH BAND BOTTOM(COVER STITCH)
 8" (O) 33. PRESS ELASTIC BTM*2
 12" (X) 34. MARK+CUT ELASTIC BAND*1
 22" (O) 35. CLOSE ELASTIC OPEN*2
 23" (O) 36. TACK ELASTIC TO BTM*2.
 68" (A) 37. FOLDSTITCH BTM
 24" (O) 38. SEW LBL AT SIZE TO LBL AT MAIN+TACK LBL AT OUTSEAM
 85" (X) 39. TRIM THREAD

**W.BAND*2**

- 35" (X) 18. MARK W.BAND*2
 32" (O) 19. JOIN BAND*2
 17" (O) 20. PRESS JOIN *2
 6" (O) 21. PRESS ELASTIC*1
 13" (X) 22. MARK+CUT ELASTIC BAND*1
 22" (O) 23. CLOSE ELASTIC OPEN*2
 35" (O) 24. TACK ELASTIC TO BAND
 18" (O) 25. TACK W.BAND IEDGE



POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	441	
COVER STITCH	223	
CHAIN STITCH	75	
SPECIAL	242	0
PRESS	56	
HAND	268	0
AMOUNT	1305	0
OUTPUT PCS	22.07	0
TOTAL TIME	1305	TOTAL OUTPUT 22.07

STYLE NO: G16-125
DATE: 2016-06-13

SEWING OPERATION LIST

TAIPEI IE OUTPUT:
VN IE OUTPUT: 22.07

NO Mã cáo	Operation Tên công đoạn	Grade Cấp	合縫記號	Operation	Time Thời gian	price Đơn	out put Sản lượng	使用配件 及其他
01	Mark front+pkt position*2	SD TT+vị trí túi*2	C	HAND	40	296.8	720	
02	Press mex pkt open*2	Là mex miệng túi*2	B	PRESS	14	111.6	2057	
03	Join pkt open*2	Cán chập miệng túi*2	B	SINGLE	38	302.9	758	
04	1/16Stitch pkt open*2	Mí miệng túi trong*2	B	SINGLE	22	175.3	1309	
05	Press pkt open*2	Là miệng túi*2	B	PRESS	17	135.5	1694	
06	Topstitch pkt open*2(cover stitch)	Điều miệng túi*2	B	COVER STITCH	40	318.8	720	
07	Tack pkt open upper+under	Ghim miệng túi trên dưới	B	SINGLE	32	255.0	900	
08	Safety pkt bag*2	VS SC đít túi*2	B	SW	25	199.3	1152	
09	Close"sw" pkt*2	Chặn đầu túi*2	B	SINGLE	9	71.7	3200	
10	Sew puckering F,seam bottom 1edge*2	Máy dúm sườn TT dưới*2	B	SINGLE	25	199.3	1152	
11	Mark back body*2	SD TS*2	B	HAND	40	318.8	720	
12	Safety outseam*2	VS SC dọc quần	B	SW	60	478.2	480	
13	Serge btm	VS 3C gấu quần	B	SW	35	279.0	823	
14	Topstitch outseam(cover stitch)	Điều dọc quần	B	COVER STITCH	70	557.9	411	
15	Safety Inseam	VS SC dằng quần	B	SW	50	398.5	576	
16	Safety front+back rise	VS SC đứng TT+TS	B	SW	36	286.9	800	
17	Topstitch front+back rise	Điều đứng TT+TS	B	COVER STITCH	48	382.6	600	
18	Tack cording	Cán dây rút*1	B	SINGLE	30	239.1	960	
19	Mark, cut cording*1	SD, cắt dây*1	C	HAND	15	111.3	1920	
20	Set w.band, mark	Trạ cạp, sd	A	CHAIN STITCH	75	627.8	384	
21	Insert cording	Luồn dây cạp	C	HAND	28	207.8	1029	
22	Serge under band	VS 3C chân cạp	B	SW	36	286.9	800	
23	Sew lbl at size to lbl at main+tack lbl at w.band	Ghim móc size vào móc ID+ghim móc vào cạp	B	SINGLE	28	223.2	1029	
24	Topstitch band bottom(cover stitch)	Điều vòng cạp dưới	A	COVER STITCH	65	544.1	443	
25	Press elastic btm	Là chun gấu*2	B	PRESS	8	63.8	3600	
26	Mark+cut elastic band*1	SD+cắt chun gấu*2	C	HAND	12	89.0	2400	
27	Close elastic open*2	Chặn miệng chun gấu*2	B	SINGLE	22	175.3	1309	
28	Tack elastic to btm*2	Ghim chun vào gấu*2	B	SINGLE	24	191.3	1200	
29	Foldstitch btm	Gập điều gấu	A	SINGLE	74	619.4	389	
30	Sew lbl at size to lbl at main+tack lbl at out seam	Ghim móc size vào móc ID+ghim móc sườn	B	SINGLE	24	191.3	1200	
XZ	Trim & turn	Cắt chỉ	C	HAND	85	630.7	339	
	W.band*2	Cạp*2				FALSE	#DIV/0!	
A01	Mark band*2	SD cạp*2	C	HAND	35	259.7	823	
A02	Join band *2	Cán cạp *2	B	SINGLE	32	255.0	900	
A03	Press join*2	Là đường cán*2	B	PRESS	17	135.5	1694	
A04	Press elastic band*1	Là chun cạp*1	B	PRESS	6	47.8	4800	
A05	Mark+cut elastic band*1	SD+cắt chun cạp*1	C	HAND	13	96.5	2215	
A06	Close elastic open*2	Cán chun cạp 2 lần	B	SINGLE	22	175.3	1309	
A07	Tack elastic to band	Ghim chun vào cạp	B	SINGLE	35	279.0	823	
A08	Tack w.band ledge	Ghim cạp 1 đường	B	SINGLE	18	143.5	1600	
TOTAL					1305	10361	22.1	



Position	GENERAL	SPECIAL			
Single	441				
Cover stitch	223				
Chain Stitch	75				
Special	242	0			
Press	56				
Hand	268	0			
Amount	1305	0			
Output (pc)	22.07	#DIV/0!			
Total Time	1305		Total out put		22.07

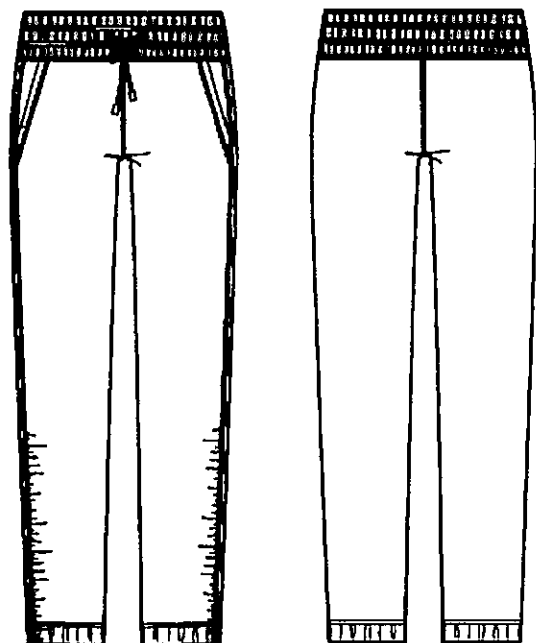
製表人: THAO

製造單號: G16-125P

車縫出數及使用機器預估表

客戶: CHICOS

部門別	工段內容	工時 / 秒									備註
		平車	切修車	拷邊車	橡筋車	3本車	一字洞	打結車	燙工	手工	
前片*2	劃號.縮碎褶	45								30	
袋布*4	袋口暗線.壓倒邊.燙.3本車飾線.固定袋口上下.袋底拷5線	125		35		29			18		
後片*2	劃號									25	
	外浪暗線一段.外浪5線拷合.3本車飾線.燙下襠	56		54		79			27		
	內浪.前後浪5線拷合.燙股.前後浪車3本飾線			96		46			42		
	下襠拷3線			27							
橡筋	固定含剪	16									
褲腰*1	燙對折.劃號.鎖一字洞*2.接縫*1.開股	13					21		26	21	
	夾橡筋車3本飾線.3本飾線車合口					114					
	上褲腰.拷3線	77		28							
	車商標	36									
	褲腰3本車飾線					69					
	固定橡筋含剪.捲下襠夾橡筋	123									
	修線.穿腰繩									102	
	全件鉚釘記號*2									12	
	合計全件車縫工時	491	0	239	0	337	21	0	113	190	1391
	以一條線38人計,預估車台數量	13.4	0.0	6.5	0.0	9.2	0.6	0.0	3.1	5.2	38.0
	全件車縫出數/ 件										20.70



專特車工時: 33 車縫工時(不含專特車): 1358
 車縫出數(不含專特車): 21.20

製表: 王愛卿 2016/6/15