

# 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:<br>G16-147P<br>-164P | 款式說明 LADIE PANST<br>订单 39.512 + 26292 | 制表人 THAO     | 日期: 2016/06/16                                                                      | 文件編號: |
| 參考雷同款: The same G16-164P |                                       |              |  |       |
| 生產車縫時間 2071              | 特車組 310                               | 總時間: 2381    |                                                                                     |       |
| 生產出數: 13.91              | 特車組出 92.90                            | IE 總出數: 12.1 |                                                                                     |       |

PPIC 主管:

6/16

|             |             |
|-------------|-------------|
| 茲核定IE出數如下:  |             |
| 衣車縫 12.7 件  | 掛車縫 _____ 件 |
| 身整件 14.7 件  | 裡整件 _____ 件 |
| 全車縫 _____ 件 | 核: _____    |
| 件整件 _____ 件 | 簽: _____    |

FLOW CHART OF G16-147P

## W.BAND\*5

- 42" 39 JOIN BAND\*3(TEMPLE)  
45" 40 MARK BAND\*3  
48" 41 JOIN BAND CENTER\*1  
(INSIDE)+BAND OUTSIDE  
17" 42 PRESS JOIN\*3  
21" 43 TRIM BAND  
32" 44 CREASE UNDER  
BAND(INSIDE)  
24" 45 TACK UNDER  
BAND IEDGE  
24" 46 PRESS BAND

## FRONT

- 40" 1 MARK FRONT+PKT POSITION\*2  
20" 2 MARK PKT FACING\*2+ATTACK PKT  
POSITION SMALL\*1  
15" 3 FOLDSTITCH PKT OPEN\*1  
15" 4 CREASE AROUND PKT\*1(SMALL)  
32" 5 ATTACK TOPSTITCH PKT\*1(SMALL)  
35" 6 SEFETY PKT FACING TO PKT OPEN\*2  
14" 7 PRESS SEFETY  
35" 8 TOPSTITCH PKT OPEN\*2(DOUBLE)  
24" 9 TACK PKT TO SEAM+BAND  
17" 10 SERGE FRONT RISE  
54" 22 SEFETY INSEAM  
58" 23 1/8 TOPSTITCH INSEAM  
64" 24 SEFETY INSEAM  
34" 25 STITCH OUTSEAM IEDGE(UPPER)  
17" 26 TACK FRONT RISE IEDGE  
23" 31 JOIN FLY,STITCH  
42" 32 SET ZIPPER FACING,SMALL  
36" 33 SEFETY FRONT+BACK RISE  
42" 34 TOPSTITCH FRONT+BACK RISE(DOUBLE)  
32" 35 TOPSTITCH FLY(DOUBLE)+CLOSE  
20" 36 JOIN BELT LOOP\*5+SEW BELT LOOP\*5  
5" 37 MARK+CUT BELT LOOP\*5  
54" 38 SET BELT LOOP\*5,MARK  
105" 47 SET W.BAND,MARK  
32" 48 TACK LBL AT W.BAND\*2  
18" 49 PRESS ESLASTIC  
12" 50 MARK+CUT ESLASTIC\*1  
24" 51 CLOSE ESLASTIC\*2EDGE  
46" 52 TACK ESLASTIC TO BAND  
65" 53 CLOSE 2EDGE BAND+TURN  
150" 54 1/16STITCH UNDER BAND+UPPER BAND\*2(CHAIN STITCH)  
65" 55 CLOSE BELT LOOP-UPPER+UNDER\*5\*2  
75" 56 FOLDSTITCH HEM  
24" 57 SEW LBL AT SIZE TO LBL  
AT MAIN+TACK LBL AT W.BAND  
90" 58 TRIM THREAD

## BACK BODY\*4

- 45" 11 MARK BACK UPPER\*2+ATTACK PKT POSITION  
20" 12 MARK BACK UNDER\*2  
14" 13 MARK BACK FACING YOKE\*2  
24" 14 SERGE BACK UPPER\*2+SERGE BACK UNDER\*  
35" 15 FOLDSTITCH PKT OPEN\*2  
36" 16 CREASE AROUND PKT\*2  
120" 17 ATTACK TOPSTITCH PKT\*2(DOUBLE)  
26" 18 JOIN FACING YOKE TO BACK(SEFETY)  
28" 19 TOPSTITCH FACING YOKE TO BACK(DOUBLE)  
34" 20 JOIN BACK UPPER+BACK UNDER  
16" 21 PRESS JOIN\*2

## ZIPER FACING\*2

- 12" 27 JOIN ZIPPR FACING\*2  
5" 28 TRIM&TURN  
10" 29 PRESS  
14" 30 STITCH ZIPPER FACING

- 120" 001 SEW F.PKT HOLE\*5+B.PKT\*4  
35" 002 SEW HOLE BAND\*1+BTN\*1  
101" 003 BARTACK FLY\*1+BELT LOOP\*5\*2

POSITION TIME TABLE

| POSITION     | GENERAL | SPECIAL           |
|--------------|---------|-------------------|
| SINGLE       | 925     |                   |
| KANSAI       | 20      |                   |
| DOUBLE       | 289     |                   |
| CHAIN STITCH | 150     |                   |
| SPECIAL      | 244     | 310               |
| PRESS        | 126     |                   |
| HAND         | 317     | 0                 |
| AMOUNT       | 2071    | 310               |
| OUTPUT PCS   | 13.91   | 92.90             |
| TOTAL TIME   | 2381    | TOTAL OUTPUT 12.1 |



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

STYLE NO: G16-147  
DATE: 2016-06-16

TAIPEI IE OUTPUT:  
VN IE OUTPUT: 13.91

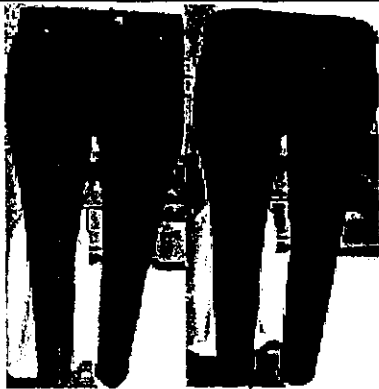
| NO<br>Mã<br>công<br>việc | Operation Tên công đoạn                             |                                         | Grade<br>Cấp | 合 縫 記 號 | Operation    | time<br>Thời<br>gian | price<br>Đơn | out put<br>Sàn<br>lượng | 使用配件<br>及其他 |
|--------------------------|-----------------------------------------------------|-----------------------------------------|--------------|---------|--------------|----------------------|--------------|-------------------------|-------------|
| 01                       | Mark front+pkt position*2                           | SD TT+vị trí túi*2                      | C            |         | HAND         | 40                   | 296.8        | 720                     |             |
| 02                       | Mark pkt facing *2+attack pkt position small*1      | SD đáp túi trước*2+vị trí dán túi nhỏ*1 | C            |         | HAND         | 20                   | 148.4        | 1440                    |             |
| 03                       | Foldstitch pkt open*1(small)                        | Gập điều miệng túi nhỏ*1                | B            |         | SINGLE       | 15                   | 119.6        | 1920                    |             |
| 04                       | Crease around pkt*1(small)                          | Là gấp xung quanh túi nhỏ*1             | B            |         | PRESS        | 15                   | 119.6        | 1920                    |             |
| 05                       | Attack topstitch pkt*1(small)                       | Dán điều túi nhỏ*1(2kim)                | A            |         | DOUBLE       | 32                   | 267.8        | 900                     |             |
| 06                       | Safety pkt facing to pkt open*2                     | VS 5c kẹp đáp túi vào miệng túi*2       | B            |         | SW           | 35                   | 279.0        | 823                     |             |
| 07                       | Press safety                                        | Là lật đường vs                         | B            |         | PRESS        | 14                   | 111.6        | 2057                    |             |
| 08                       | Topstitch pkt open*2(double)                        | Điều miệng túi*2(2kim)                  | B            |         | DOUBLE       | 35                   | 279.0        | 823                     |             |
| 09                       | Tack pkt to seam+band                               | Ghim túi trên sườn+cạp                  | B            |         | SINGLE       | 24                   | 191.3        | 1200                    |             |
| 10                       | Serge front rise                                    | VS 3C đứng TT                           | B            |         | SW           | 17                   | 135.5        | 1694                    |             |
| 11                       | Safety inseam                                       | VS 5C dăng quần                         | B            |         | SW           | 54                   | 430.4        | 533                     |             |
| 12                       | 1/8Topstitch inseam                                 | Điều dăng quần 1/8*2                    | B            |         | SINGLE       | 58                   | 462.3        | 497                     |             |
| 13                       | Safety out eam*2                                    | VS 5C dọc quần*2                        | B            |         | SW           | 64                   | 510.1        | 450                     |             |
| 14                       | Stitch outseam 1edge(upper)                         | Mí dọc quần 1đoạn cạnh túi              | B            |         | SINGLE       | 34                   | 271.0        | 847                     |             |
| 15                       | Tack front rise 1edge                               | Ghim đứng TT 1 đoạn                     | B            |         | SINGLE       | 17                   | 135.5        | 1694                    |             |
| 16                       | Join fly,stitch                                     | Cán chắp moi+mí                         | B            |         | SINGLE       | 23                   | 183.3        | 1252                    |             |
| 17                       | Set zipper facing,mark                              | Tra đáp khóa,sd                         | A            |         | SINGLE       | 42                   | 351.5        | 686                     |             |
| 18                       | Safety front+ back rise                             | VS 5C đứng TT+TS                        | B            |         | SW           | 36                   | 286.9        | 800                     |             |
| 19                       | Topstitch front+back rise(double)                   | Điều đứng TT+TS(2kim)                   | B            |         | DOUBLE       | 42                   | 334.7        | 686                     |             |
| 20                       | Topstitch fly(double)+close                         | Điều moi 2kim(2kim)+chặn moi            | B            |         | DOUBLE       | 32                   | 255.0        | 900                     |             |
| 21                       | Join belt loop+sew belt loop*5                      | Cán đĩa+máy đĩa*5                       | B            |         | KANSAI       | 20                   | 159.4        | 1440                    |             |
| 22                       | Mark+cut belt loop*5                                | SD+cắt đĩa*5                            | C            |         | HAND         | 5                    | 37.1         | 5760                    |             |
| 23                       | Set belt loop*5,mark                                | Tra đĩa,sd*5                            | B            |         | SINGLE       | 54                   | 430.4        | 533                     |             |
| 24                       | Set w.band,mark                                     | Tra cạp,sd                              | A            |         | SINGLE       | 105                  | 878.9        | 274                     |             |
| 25                       | Tack lbl at w.band*2                                | Ghim móc cạp*2                          | B            |         | SINGLE       | 34                   | 271.0        | 847                     |             |
| 26                       | Press elastic*1                                     | Là chun cạp*1                           | B            |         | PRESS        | 18                   | 143.5        | 1600                    |             |
| 27                       | Mark+cut elastic*1                                  | SD+ cắt chun cạp*1                      | C            |         | HAND         | 12                   | 89.0         | 2400                    |             |
| 28                       | Close elastic*2edge                                 | Chặn chun cạp 2đầu                      | B            |         | SINGLE       | 24                   | 191.3        | 1200                    |             |
| 29                       | Tack elastic to band                                | Ghim chun vào cạp                       | B            |         | SINGLE       | 46                   | 366.6        | 626                     |             |
| 30                       | Close 2edge band+turn                               | Chặn 2 đầu cạp +lộn                     | B            |         | SINGLE       | 65                   | 518.1        | 443                     |             |
| 31                       | Topstitch w.band upper+under                        | Điều vòng cạp trên+dưới                 | A            |         | CHAIN STITCH | 150                  | 1255.5       | 192                     |             |
| 32                       | Close belt loop upper+under*5*2                     | Chặn đĩa trên dưới*5*2                  | B            |         | SINGLE       | 65                   | 518.1        | 443                     |             |
| 33                       | Foldstitch btm                                      | Gập điều gấu                            | A            |         | SINGLE       | 75                   | 627.8        | 384                     |             |
| 34                       | 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         | 90                   | 667.8        | 320                     |             |
| 001                      | Sew F.pkt hole*5+8.pkt*4                            | Bổ khuy cúc miệng túi TT*5+túi sau*4    | B            |         | SPECIAL      | 120                  | 956.4        | 240                     |             |
| 002                      | Sew hole band*1+btm*1                               | Bổ khuy*1+đính cúc cạp*1                | B            |         | SPECIAL      | 35                   | 279.0        | 823                     |             |
| 003                      | Bartack fly*1+belt loop*5*2                         | Di bộ moi*1+đáp khóa*1+đĩa*5*2          | B            |         | SPECIAL      | 101                  | 805.0        | 285                     |             |
|                          | <b>Zipper facing*2</b>                              | <b>Đáp khóa*2</b>                       |              |         |              |                      | FALSE        | #DIV/0!                 |             |
| A01                      | Join zipper facing*1(temple)                        | Cán chắp đáp khóa*1(bia mẫu)            | B            |         | SPECIAL      | 12                   | 95.6         | 2400                    |             |
| A02                      | Turn*1                                              | Lộn đáp khóa                            | C            |         | HAND         | 5                    | 37.1         | 5760                    |             |
| A03                      | Press*1                                             | Là đáp khóa                             | B            |         | PRESS        | 10                   | 79.7         | 2880                    |             |
| A04                      | Serge zipper facing+fly                             | VS 3C đáp khóa+moi                      | B            |         | SW           | 14                   | 111.6        | 2057                    |             |
|                          | <b>Back body*4</b>                                  | <b>Thân sau*4</b>                       |              |         |              |                      | FALSE        | #DIV/0!                 |             |
| B01                      | Mark back upper*2+attack pkt position*2             | SD TS trên*2+vị trí dán túi*2           | C            |         | HAND         | 45                   | 333.9        | 640                     |             |
| B02                      | Mark back under*2                                   | SD TS dưới*2                            | C            |         | HAND         | 20                   | 148.4        | 1440                    |             |
| B03                      | Mark back facing yoke *2                            | SD đáp cầu mông TS*2                    | C            |         | HAND         | 14                   | 103.9        | 2057                    |             |
| B04                      | Serge back upper*2+Serge back under*2               | VS 3C TS trên*2+VS 3C TS dưới*2         | B            |         | SW           | 24                   | 191.3        | 1200                    |             |
| B05                      | Foldstitch pkt open*2                               | Gập điều miệng túi*2                    | B            |         | SINGLE       | 35                   | 279.0        | 823                     |             |
| B06                      | Crease around pkt*2                                 | Là gấp xung quanh túi*2                 | B            |         | PRESS        | 36                   | 286.9        | 800                     |             |

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

STYLE NO: G16-147  
DATE: 2016-06-16

TAIPEI IE OUTPUT:  
VN IE OUTPUT: 13.91

| NO<br>Mã<br>cấp | Operation Tên công đoạn                   |                                 | Grade<br>Cấp | 合縫記號 | Operation | time<br>Thời<br>gian | price<br>Đơn | out put<br>Sản<br>lượng | 使用配件<br>及其他 |
|-----------------|-------------------------------------------|---------------------------------|--------------|------|-----------|----------------------|--------------|-------------------------|-------------|
| B07             | Attack topstitch pkt*2(double)            | Dán điều túi sau*2(2kim)        | A            |      | DOUBLE    | 120                  | 1004.4       | 240                     |             |
| B08             | Join facing yoke to back(Safety)          | Cán chắp đáy cầu móng TS(VS 5C) | B            |      | SINGLE    | 26                   | 207.2        | 1108                    |             |
| B09             | Topstitch facing yoke to back*2(double)   | Điều đáy cầu móng TS*2(2kim)    | B            |      | DOUBLE    | 28                   | 223.2        | 1029                    |             |
| B10             | Join back upper+back under                | Cán chắp TS trên+TS dưới        | B            |      | SINGLE    | 34                   | 271.0        | 847                     |             |
| B11             | Press join*2                              | Là rẽ đường cán chắp*2          | B            |      | PRESS     | 16                   | 127.5        | 1800                    |             |
|                 | <b>W.band*5</b>                           | <b>Cạp bo*5</b>                 |              |      |           |                      | FALSE        | #DIV/0!                 |             |
| C01             | Join band*3(temple)                       | Cán chắp sống cạp*2(theo mẫu)   | B            |      | SPECIAL   | 42                   | 334.7        | 686                     |             |
| C02             | Mark band*3                               | SD cạp*3                        | C            |      | HAND      | 45                   | 333.9        | 640                     |             |
| C03             | Join band center*1(inside)+band outside*2 | Cán cạp trong*1+cạp ngoài*2     | B            |      | SINGLE    | 48                   | 382.6        | 600                     |             |
| C04             | Press join*3                              | Là đường cán*3                  | B            |      | PRESS     | 17                   | 135.5        | 1694                    |             |
| C05             | Trim band                                 | Chém sửa sống cạp               | C            |      | HAND      | 21                   | 155.8        | 1371                    |             |
| C06             | Crease under band( inside)                | Là gấp chân cạp trong           | B            |      | PRESS     | 32                   | 255.0        | 900                     |             |
| C07             | Tack under band 1edge                     | Ghim cạp 1 đường                | B            |      | SINGLE    | 21                   | 167.4        | 1371                    |             |
| C08             | Press band                                | Là sống cạp                     | B            |      | PRESS     | 24                   | 191.3        | 1200                    |             |
| <b>TOTAL</b>    |                                           |                                 |              |      |           | 2381                 | 19012        | 12.1                    |             |



|                 |         |         |                  |  |      |
|-----------------|---------|---------|------------------|--|------|
| Position        | GENERAL | SPECIAL |                  |  |      |
| Single          | 925     |         |                  |  |      |
| Kansai          | 20      |         |                  |  |      |
| Double          | 289     |         |                  |  |      |
| Chain<br>Stitch | 150     |         |                  |  |      |
| Special         | 244     | 310     |                  |  |      |
| Press           | 126     |         |                  |  |      |
| Hand            | 317     | 0       |                  |  |      |
| Amount          | 2071    | 310     |                  |  |      |
| Output<br>(pcs) | 13.91   | 92.90   |                  |  |      |
| Total<br>time   | 2381    |         | Total<br>out put |  | 12.1 |

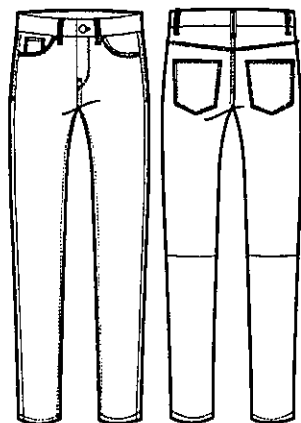
製表人: THAO

製造單號: G16-147.164P

## 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     | 鎖鍊車 | 模板車 | 切修車 | 雙針車 | 拷邊車 | 耳子車 | 鎖眼車 | 打結車 | 燙工  | 手工  |       |
| 前片*2   | 劃號.前浪拷3線                              |        |     |     |     |     | 16  |     |     |     |     | 38  |       |
| 小袋*1   | 捲袋口.燙折邊                               | 16     |     |     |     |     |     |     |     |     | 15  |     |       |
| 假袋貼*2  | 劃號.雙針貼小袋                              |        |     |     |     | 40  |     |     |     |     |     | 13  |       |
|        | 接袋貼暗線.拷3線.雙針明線                        | 39     |     |     |     | 30  | 19  |     |     |     |     |     |       |
|        |                                       |        |     |     |     |     |     |     |     |     |     |     |       |
| 後片*4   | 劃號.橫切拷3線.橫切開暗線.開股                     | 39     |     |     |     |     | 28  |     |     |     | 16  | 48  |       |
| YOKE*2 | 劃號.接YOKE5線拷合.雙針明線                     |        |     |     |     | 35  | 29  |     |     |     |     | 19  |       |
|        | 貼袋記號                                  |        |     |     |     |     |     |     |     |     |     | 30  |       |
| 口袋*2   | 雙針捲袋口.燙折邊.切修                          |        |     |     | 23  | 38  |     |     |     |     | 52  |     |       |
|        | 雙針貼口袋                                 |        |     |     |     | 110 |     |     |     |     |     |     |       |
|        | 內浪5線拷合.明線一道                           | 65     |     |     |     |     | 61  |     |     |     |     |     |       |
|        | 外浪5線拷合.燙股.明線一段.打結*2                   | 39     |     |     |     |     | 64  |     |     |     | 42  |     |       |
|        | 前後浪5線拷合.雙針明線                          |        |     |     |     | 42  | 36  |     |     |     |     |     |       |
| 鈕牌*2   | 暗線&切修.翻燙.拷3線                          |        |     |     | 12  |     | 14  |     |     |     | 10  | 6   |       |
|        | 前浪暗線.接鈕貼.壓明線.雙針彎鈕牌.打結*3(鈕牌*1外浪*2)     | 106    |     |     |     | 36  |     |     |     | 18  |     |     |       |
| 腰耳*5   | 車腰耳*5.固定腰耳*5含記號及剪                     | 54     |     |     |     |     |     | 20  |     |     |     | 21  |       |
|        |                                       |        |     |     |     |     |     |     |     |     |     |     |       |
| 褲腰*3+2 | 模板暗線*2.劃號*3.接縫*3.合後褲腰暗線.切修.修翻燙&開股.燙折邊 | 63     |     | 35  | 18  |     |     |     |     |     | 101 | 69  |       |
|        | 車商標                                   | 36     |     |     |     |     |     |     |     |     |     |     |       |
|        | 縮縫橡筋含剪.燙.折固定兩端                        | 74     |     |     |     |     |     |     |     |     | 18  |     |       |
|        | 上褲腰.固定橡筋.固定商標                         | 147    |     |     |     |     |     |     |     |     |     |     |       |
|        | 褲腰上下鎖鏈明線一道                            |        | 205 |     |     |     |     |     |     |     |     |     |       |
|        | 固定腰耳上端*5.腰耳打結*5*2                     | 63     |     |     |     |     |     |     |     | 76  |     |     |       |
|        | 捲下襠                                   | 72     |     |     |     |     |     |     |     |     |     |     |       |
|        | 修線                                    |        |     |     |     |     |     |     |     |     |     | 90  |       |
|        |                                       |        |     |     |     |     |     |     |     |     |     |     |       |
|        | 全件鎖眼打結*1含記號*1+1+鉚釘*7                  |        |     |     |     |     |     |     | 15  | 9   |     | 33  |       |
|        |                                       |        |     |     |     |     |     |     |     |     |     |     |       |
|        | 合計全件車縫工時                              | 813    | 205 | 35  | 53  | 331 | 266 | 20  | 15  | 103 | 254 | 367 | 2462  |
|        | 以一條線38人計,預估車台數量                       | 12.5   | 3.2 | 0.5 | 0.8 | 5.1 | 4.1 | 0.3 | 0.2 | 1.6 | 3.9 | 5.7 | 38.0  |
|        | 全件車縫出數/ 件                             |        |     |     |     |     |     |     |     |     |     |     | 11.70 |



專特車工時: 206 車縫工時(不含專特車) 2256

車縫出數(不含專特車) 12.77

製表: 王愛卿 2016/6/27