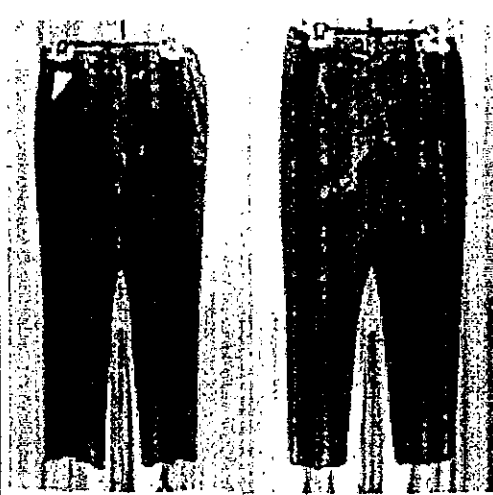


福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-263P	款式說 LADIES PANTS 订单 3.470	制表人 THAO	日期: 2016/09/08	文件編號:
參考雷同款:				
生產車縫時間 1722	特車組 64	總時間:1786		
生產出數:16.72	特車組出 450.00	IE 總出數: 16.1		

PPIC 主管:

茲核定IE出數如下:			
衣車縫	16.75件	掛車縫	____件
身整件	____件	裡整件	____件
全車縫	____件	核	____
件整件	____件	簽	____

9/10

9/10

FLOW CHART OF G16-263PW.BAND*4

- 22" 37. MARK*2
8" 38. MARK HOLE AT BAND*1 POSITION
14" 39. SEW HOLE*1
10" 40. JOIN 1 EDGE*2 (TEMPLE)
38" 41. JOIN W.BAND*3 (TACK 1 EDGE+CLOSE, TURN (AT LEFT))
4" 42. PRESS JOIN+CREASE
22" 43. 1/16 STITCH UPPER BAND
18" 44. PRESS UPPER BAND

FRONT

- 40" 1. MARK FRONT+PKT POSITION*2
50" 2. SEW PLEATE*2*2
32" 3. PRESS PLEAT*4+MEX PKT*2
14" 4. SERGE FACING*2*2
52" 5. STITCH+TACK BAG TO FACING*4
42" 6. JOIN PKT OPEN*2 (TACK BAG+BESOM)
22" 7. 1/16 STITCH PKT OPEN*2
17" 8. PRESS PKT OPEN
42" 9. JOIN BAG*2
10" 10. TURN*2
38" 11. TOPSTITCH BAG*2
35" 12. TACK PKT UPPER AND UNDER*2
26" 13. TACK BAG TO PKT TO SEAM+TACK BAND
24" 14. SERGE FRONT+BACK RISE

BACK BODY*2

- 40" 15. MARK BACK+PLEAT*2*2
48" 16. CLOSE PLEAT*2*2
18" 17. PRESS PLEATE*4

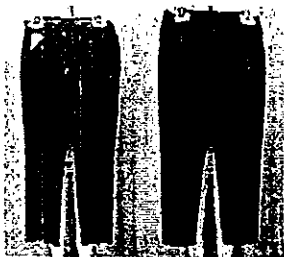
- 60" 18. SEFETY OUT SEAM
25" 19. PRESS INSEAM
24" 20. SERGE BTM
65" 21. STITCH OUTSEAM
50" 22. SEFETY INSEAM
20" 23. PRESS INSEAM
55" 24. 1/4 TOPSTITCH INSEAM
47" 25. JOIN FRONT+BACK RISE (CHAIN STITCH)
23" 26. JOIN FLY, STITCH
15" 27. CREASE FLY+RISE

ZIPPER FACING*2

- 12" (T) 28. CLOSE 1 EDGE ZIPPER FACING
7" 29. TURN*1
12" 30. PRESS
15" 31. SERGE ZIPPER FACING+FLY
16" 32. TACK ZIPPER TO ZIPPER FACING+CLOSE

- 38" (A) 33. SET ZIPPER, MARK
16" 34. JOIN BELT LOOP+SEW BELT LOOP*8
8" 35. MARK+ CUT BELT LOOP*8
55" 36. SET BELT LOOP*7, MARK

- 81" (A) 45. SET W.BAND, MARK
113" 46. TURN AFTER SET W.BAND
25" 47. CLOSE 1 EDGE BAND+TURN (AT RIGHT)
10" 48. TACK LBL SIZE AT W.BAND*1
82" (A) 49. 1/16 FOLD STITCH UNDER W.BAND
45" 50. TOPSTITCH FLY+CLOSE*2
63" 51. CLOSE BELT LOOP*8*2
14" 52. TACK LBL AT OUT SEAM*2
70" (A) 53. BLIND BTM
90" 54. TRIM THREAD



POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1057	
KANSAI	16	
CHAIN STITCH	47	
SPECIAL	191	56
PRESS	181	
HAND	230	8
AMOUNT	1722	64
OUTPUT PCS	16.72	450.00
TOTAL TIME	1786	TOTAL OUTPUT 16.1

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

STYLE NO: G16-263P
DATE: 2016-09-08

TAIPEI IE OUTPUT:
VN IE OUTPUT 16.72

OP NO Mã công đoạn	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+vj trí túi*2	C		HAND	40	296.8	720	
02	Sew pleate*2*2	Máy ly TT*2*2	B		SINGLE	50	398.5	576	
03	Press pleat*4+mex pkt*2	Là ly*4+mex miệng túi TT*2	B		PRESS	32	255.0	900	
04	Serge facing*2*2	VS 3C đắp túi*2*2	B		SW	18	143.5	1600	
05	Stitch bag to facing*2*2	Mí lót vào đắp túi*4	B		SINGLE	52	414.4	554	
06	Join pkt open*2(tack bag+besom)	Cán chập miệng túi*2(đặt coi+lót)	B		SINGLE	42	334.7	686	
07	1/16Stitch pkt open*2	Mí tăng cường miệng túi ngoài*2	B		SINGLE	22	175.3	1309	
08	Press pkt open*2	Là miệng túi trước*2	B		PRESS	17	135.5	1694	
09	Join bag*2	Quay lót túi*2	B		SINGLE	42	334.7	686	
10	Turn bag*2	Lộn túi*2	C		HAND	10	74.2	2880	
11	1/4Topstitch bag*2	Điều dít túi 1/4*2	B		SINGLE	38	302.9	758	
12	Tack pkt to upper and under*2	Ghim miệng túi trên dưới *2	B		SINGLE	35	279.0	823	
13	Tack bag pkt to seam+tack band+seam	Ghim túi trên cạp+sườn	B		SINGLE	26	207.2	1108	
14	Serge front+back rise	VS 3C đứng TT+TS	B		SW	24	191.3	1200	
15	Safety out seam	VS 5C dọc quần	B		SW	60	478.2	480	
16	Press outseam	Là lật dọc quần	B		PRESS	25	199.3	1152	
17	Serge btm	VS 3C gấu	B		SW	24	191.3	1200	
18	Stitch outseam	Mí dọc quần	B		SINGLE	65	518.1	443	
19	Safetyinseam	VS 5C giàng quần	B		SW	50	398.5	576	
20	Press inseam	Là lật giàng quần	B		PRESS	20	159.4	1440	
21	1/4Topstitch inseam*2	Điều giàng quần 1/4*2	B		SINGLE	55	438.4	524	
22	Join front+back rise(chain stitch)	Chấp dững TT+TS(chỉ tết)	B		CHAIN STITCH	47	374.6	613	
23	Join fly, stitch	Cán chập moi+mí	B		SINGLE	23	183.3	1252	
24	Crease fly, rise	Là gấp moi, là dững	B		PRESS	15	119.6	1920	
25	Set zipper, mark	Tra khóa, sd	A		SINGLE	38	318.1	758	
26	Join belt loop+sew belt loop*8	Cán đĩa+máy đĩa*8	B		KANSAI	16	127.5	1800	
27	Mark+cut belt loop*8	SD+cắt đĩa*8	C		HAND	8	59.4	3600	
28	Set belt loop*8, mark	Tra đĩa, sd*8	B		SINGLE	55	438.4	521	
29	Set w.band, mark	Tra cạp, sd	A		SINGLE	81	678.0	356	
30	Trim after set w.band	Chém cạp sau khi tra	C		HAND	13	96.5	2215	
31	Close 1 edge band+turn(at right)	Chặn đầu cạp, lộn (bên phải)	B		SINGLE	25	199.3	1152	
32	Tack lbl size at w.band*1	Ghim móc vào cạp*1	B		SINGLE	10	39.7	2880	
33	1/16Foldstitch under w.band	Gập mí/16 chân cạp	A		SINGLE	82	686.3	351	
34	Topstitch fly+close fly*2	Điều moi khóa 1 kim+chặn moi*2	B		SINGLE	45	358.7	640	
35	Close belt loop*8*2	Chặn đĩa trên, dưới*8*2	B		SINGLE	63	502.1	457	
36	Tack lbl at outseam*1	Ghim móc sườn*1	B		SINGLE	14	111.6	2057	
37	Foldstitch btm	Vắt gấu	A		SINGLE	70	585.9	411	
XZ	Trim thread	Cắt chỉ	C		HAND	90	667.8	320	
	Zipper facing*2	Đắp khóa*2					FALSE	#DIV/0!	
A01	Join zipper facing*2	Cán chập đắp khóa(bia mẫu)	B		SPECIAL	12	95.6	2400	
A02	Turn	Lộn đắp khóa	C		HAND	7	51.9	4114	
A03	Press	Là đắp khóa	B		PRESS	12	95.6	2400	
A04	Serge zipper facing+fly	VS 3C đắp khóa+moi	B		SW	15	119.6	1920	
A05	Tack zipper to zipper facing	Ghim khóa vào đắp khóa	B		SINGLE	16	127.5	1800	
	Back body*2	Thân sau*2					FALSE	#DIV/0!	

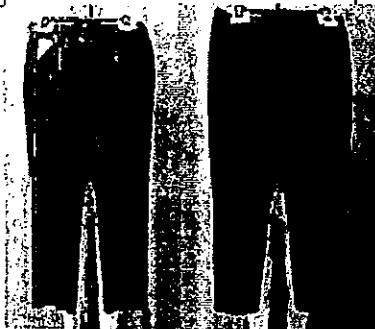
61.00

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

STYLE NO: G16-263P
DATE: 2016-09-08

TAIPEI IE OUTPUT:
VN IE OUTPUT 16.72

FOP NO Mã công đoạn	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
	<i>W.band*4</i>	<i>Cạp*4</i>					FALSE	#DIV/0!	
C01	Mark band*2	SD cạp *2	C		HAND	22	163.2	1309	
C02	Mark hole at band*1 posititon	SD thừa khuyết cạp*2	C		HANDSCL	8	59.4	3600	
C03	Sew hole*1	Thừa khuyết*2	B		SPECIAL	14	111.6	2057	
C04	Join 1edge(temple)	Cán chập sống cạp*2(theo mẫu)	B		SPECIAL	30	239.1	960	
C05	Join w.band *3+close 1edge(at left)	Cán cạp*3+cán sống 1 đoạn+chấn 1 đầu cạp trái	B		SINGLE	38	302.9	758	
C06	Press join+ crease band	Là rẻ*1+là gấp cạp trong	B		PRESS	24	191.3	1200	
C07	1/16Stitch upper band	Mí sống cạp 1/16	B		SINGLE	22	175.3	1309	
C08	Press upper band	Là sống cạp	B		PRESS	18	143.5	1600	
TOTAL						1786	14212	16.1	



Position	GENERAL	SPECIAL			
Single	1057				
Chain					
Stitch	47				
Kansai	16				
Special	191	56			
Press	181				
Hand	230	8			
Amount	1722	64			
Output (pcs)	16.72	450.00			
Total time	1786		total out put		16.1

製表人: THAO _____

製造單號: G16-263P

車縫出數及使用機器預估表 訂單數量 3470

客戶：漢翔

各線均量

[illegible]

製造單號: G16-263P

車縫出數及使用機器預估表

訂單數量

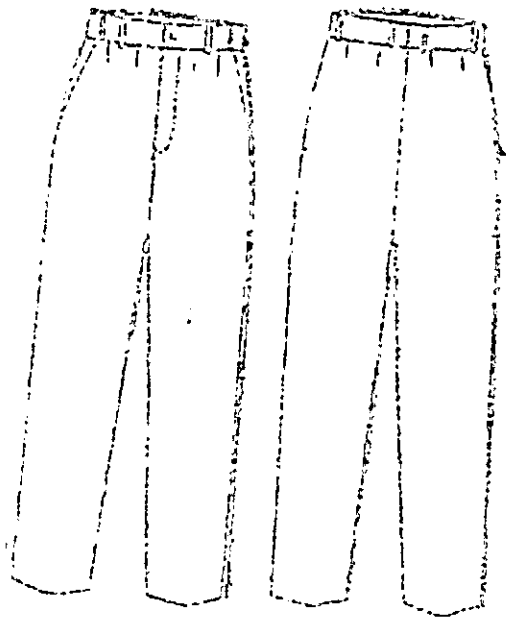
3470

客戶 : 漢翔

各線均量

部門別	工段內容	工時 / 秒													備註
		平車	模板車	切修車	雙針車	拷邊車	開袋機	盲縫車	耳子車	褲鉤機	打結車	燙工	手工		
	合計全件車縫工時	1115	15	103	75	200	0	65	32	31	75	171	273	2155	
	以一條線38人計,預估車台數量	19.7	0.3	1.8	1.3	3.5	0.0	1.1	0.6	0.5	1.3	3.0	4.8	38.0	
	全件車縫出數/ 件														13.37

專特車工時： 177 車縫工時(不含專特車)： 1978
車縫出數(不含專特車)： 16.75



製表 王愛卿 2016/9/12