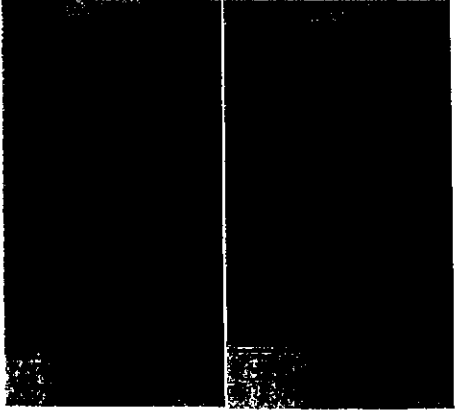


福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-271P	款式說 LADIES PANTS 订单 8.600	制表人 THAO	日期: 2016/04/10	文件編號:
參考雷同款:				
生產車縫時間 1792	特車組 109	總時間:1901		
生產出數:16.07	特車組出 264.22	IE 總出數:15.10		

PPIC 主管:

茲核定IE出數如下:	
衣車縫 16.41 件	掛車縫 _____ 件
身整件 15 件	裡整件 _____ 件
全車縫 _____ 件	核: _____
件整件 _____ 件	簽: _____

10/2/10/04

FLOW CHART OF G16-271P

FRONT

BACK BODY*2

W.BAND*2

14" 42 JOIN BAND BEFORE PRESS

22" 43 CREASE W.BAND*2

28" 44 MARK BAND*2

24" 45 JOIN BAND*2

10" 46 MARK HOLE*2

20" 47 SEW HOLE*2

35" 48 SEW LBL SIZE TO ID, TACK
LBL AT BAND

7" 49 PRESS ELASTIC

10" 50 MARK, CUT ELASTIC

18" 51 CLOSE ELASTIC

40" 52 TACK ELASTIC TO W.BAND

35" 1 MARK FRONT+PKT POSITION*2

7" 2 MARK FACING*2

18" 3 SERGE BESOM*2+FACING*2

12" 4 CREASE BESOM*2

18" 5 STITCH FACING TO BAG*2

14" 6 PRESS MEX PKT OPEN*2

36" 7 JOIN BAG TO FRONT*2

40" 8 FOLDSTITCH BESOM TO PKT OPEN*2

17" 9 PRESS PKT OPEN*2

30" 10 TACK PKT UPPER AND UNDER*2

30" 11 JOIN BAG*2

9" 12 TURN*2

30" 13 TOPSTITCH BAG*2

22" 14 TACK BAG TO PKT TO SEAM+TACK BAND

60" 30 SEFETY OUT SEAM

18" 31 TACL LBL A OUTSEAM*2

30" 32 PRESS OUTSEAM

70" 33 ATTACH TOPSTITCH CORDING TO OUTSEAM(DOUBLE)

70" 34 ATTACH TOPSTITCH CORDING TO BACK(DOUBLE)

5" 35 SERGE FLY

23" 36 JOIN FLY+TACK FRONT RISE

38" 37 SEFETY FRONT+BACK RISE

15" 38 CREASE FLY+FRONT AND BACK RISE

49" 39 STITCH FRONT+BACK RISE+STITCH FLY

38" 40 TOPSTITCH FLY

50" 41 SEFETY INSEAM

75" 53 SET W.BAND.MARK

14" 54 TACK CORDING BAND

7" 55 MARK+ CUT CORDING*1

35" 56 INSERT CORDING

5" 57 TACL LBL AT BAND*1

82" 58 1/16 FOLD STITCH UNDER W.BAND
(CHAIN STITCH)

70" 59 TOPSTITCH BAND UPPER+UNDER(DOUBLE)

70" 60 FOLDSTITCH BTM(DOUBLE)

65" 61 TRIM THREAD

25" 001 BARACK B.PKT*4

35" 15 MARK BACK+PKT POSITION*2

18" 16 SERGE FACING*

14" 17 PRESS PLEAT*1 FUSE PKT*2

54" 18 SET BESOM*2(MACH)

25" 19 SET BESOM*2(HAND)

40" 20 CLOSE 2 EDGE*2

17" 21 PRESS PKT OPEN*2

22" 22 STITCH EDGE UNDER

44" 23 STITCH PKT FACING TO BAG*1.MARK

45" 24 JOIN BAG*2

9" 25 TURN BAG*2

45" 26 TOPSTITCH BAG*

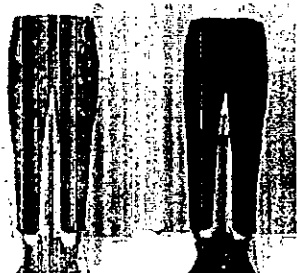
36" 27 1/16 STITCH AT PKT TIP 3 UNDER*2

18" 28 TACK PKT OPEN*2

18" 29 TACK BAG TO W.BAND

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	752	
DOUBLE	268	
CHAIN STITCH	160	
SPECIAL	189	99
PROCESS	158	
HAND	265	10
AMOUNT	1792	109
OUTPUT PCS	1607	264.22
TOTAL TIME	1991	TOTAL OUTPUT 15.1



SEWING OPERATION LIST

STYLE NO: G16-271P

4/10/2016

TAIPEI IE OUTPUT:

VN IE OUTPUT:

16.07

# 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 + pkt position*2	SD TT*2 + vị trí túi*2	C		HAND	35	259.7	823	
02	Mark facing*2	SD đắp túi TT*2	C		HAND	7	51.9	4114	
03	Serge besom+facing*2	VS 3C cơi *2+đắp túi*2	B		SW	18	143.5	1600	
04	Crease besom *2	Là gấp cơi*2	B		PRESS	12	95.6	2400	
05	Stitch facing to bag*2	Mí đắp vào lót*2	B		SINGLE	18	143.5	1600	
06	Press mex pkt*2	Là mex miệng túi*2	B		PRESS	14	111.6	2057	
07	Join bag to front*2	Cán lót vào TT	B		SINGLE	36	286.9	800	
08	Foldstitch besom to pkt open*2	Gập mí cơi vào miệng túi*2	B		SINGLE	40	318.8	720	
09	Press pkt open*2	Là miệng túi trước*2	B		PRESS	17	135.5	1694	
10	Tack pkt to upper and under*2	Ghim miệng túi trên dưới *2	B		SINGLE	30	239.1	960	
11	Join bag*2	Quay lót túi*2	B		SINGLE	30	239.1	960	
12	Turn bag*2	Lộn túi*2	C		HAND	9	66.8	3200	
13	1/4Topstitch bag*2	Điều dít túi 1/4*2	B		SINGLE	30	239.1	960	
14	Tack bag pkt to seam+tack band+seam	Ghim túi trên cạp+sườn	B		SINGLE	22	175.3	1309	
15	Safety out seam	VS 5C dọc quần	B		SW	60	478.2	480	
16	Tack lbi at outseam*2	Ghim móc sườn*2	B		SINGLE	18	143.5	1600	
17	Press outseam	Là lật dọc quần	B		PRESS	30	239.1	960	
18	Attach topstitch cording to outseam(double)	Dán điều dây viền trắng vào dọc quần*2	B		DOUBLE	70	557.9	411	
19	Attach topstitch cording to back(double)	Dán điều dây viền trắng vào TS*2(2kim)	B		DOUBLE	70	557.9	411	
20	Serge fly	VS 3C moi	B		SW	5	39.9	5760	
21	Join fly+tack front rise	Cán chập moi+ghim đứng TT	B		SINGLE	23	183.3	1252	
22	Safety front +back rise	VS 5C đứng TT+TS	B		SW	38	302.9	758	
23	Crease fly+front and back rise	Là gấp moi +đứng TT+TS	B		PRESS	15	119.6	1920	
24	Stitch front +back rise+stitch fly	Mí đứng TT+TS+mí moi	B		SINGLE	49	390.5	588	
25	Topstitch fly	Điều moi 1kim	B		SINGLE	38	302.9	758	
26	Safety inseam	VS 5C giằng quần	B		SW	50	398.5	576	
27	Set band,mark	Tra cạp,sd	A		Chain stitch	75	629.3	384	
28	Tack cording band	Cán dây cạp	B		SINGLE	14	111.6	2057	
29	Mark ,cut cording*1	SD ,cắt dây cạp*1	C		HAND	7	51.9	4114	
30	Insert cording	Luồn dây	C		HAND	35	259.7	823	
31	Tack lbi at band*1	Ghim móc vào cạp*1	B		SINGLE	5	39.9	5760	
32	Foldstitch band under(chainstitch)	Gập điều chân cạp dưới	A		Chain stitch	85	713.2	339	
33	Topstitch band upper+under(double)	Điều cạp trên+dưới(2kim)	A		DOUBLE	63	528.6	457	
34	Foldstitch btm*2(double)	Gập điều gấu *2	A		DOUBLE	65	545.4	443	
XZ	Trim thread	Cắt chỉ	C		HAND	65	482.3	443	
002	Bartack B.pkt*4	Di bộ túi sau*4	B		SPECIAL	25	199.3	1152	
	Back body*2	Thân sau*2					FALSE	#DIV/0!	
A01	Mark back+pkt position*2	SD TS*2+vị trí túi*2	C		HAND	35	259.7	823	
A02	Serge pkt facing*2*2	VS 3C đắp túi*2*2	B		SW	18	143.5	1600	

SEWING OPERATION LIST

STYLE NO: G16-271P
4/10/2016TAIPEI IE OUTPUT:
VN IE OUTPUT: 16.07

# 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
A03	Press mex pkt*2	Là mex vào vị trí túi*2	B		PRESS	14	111.6	2057	
A04	Set besom*2(mach)(matched stripe)	Bổ túi bằng máy*2	B		SPECIAL	54	430.4	533	
A05	Set besom*2(hand)	Bổ túi bằng tay*2	C		HAND	25	185.5	1152	
A06	Close 2edge*2	Chặn 2 đầu coi túi*2	A		SINGLE	40	335.6	720	
A07	Press pkt open*2	Là miệng coi túi sau*2	B		PRESS	17	135.5	1694	
A08	Stitch 1edge under*2	Mí cạnh dưới*2	B		SINGLE	22	175.3	1309	
A09	Stitch pkt facing to bag*2*2	Mí đắp túi vào lót*2*2, sd	B		SINGLE	44	350.7	655	
A10	Join bag	Quay tròn túi(máy chêm)	B		SINGLE	45	358.7	640	
A11	Turn	Lộn túi TS*2	C		HAND	9	66.8	3200	
A12	1/4topstitch bag	Điều đáy túi 1/4	B		SINGLE	45	358.7	640	
A13	Stitch 3lip upper*2	Mí 3 cạnh coi túi trên	A		SINGLE	36	302.0	800	
A14	Tack bag to w.band	Ghim túi trên cạp	B		SINGLE	18	143.5	1600	
A15	Tack pkt open*2	Ghim kín miệng túi*2	B		SINGLE	18	143.5	1600	
	W.band*2	Cạp*2					FALSE	#DIV/0!	
B01	Join band befor press	Cán cạp đi ép,thảo	B		SINGLE	14	111.6	2057	
B02	Crease w.band*2	Là gấp cạp*2	B		PRESS	22	175.3	1309	
B03	Mark band*2	SD cạp*2	C		HAND	28	207.8	1029	
B04	Join band*2	Cán giữa cạp*2	B		SINGLE	24	191.3	1200	
B05	Press join*2	Là rẽ giữa cạp*2	B		PRESS	10	79.7	2880	
B06	Mark hole*2	SD đục lỗ cạp*2	C		HANDSCL	10	74.2	2880	
B07	Sew hole*2	Bổ khuy lỗ*2	B		SPECIAL	20	159.4	1440	
B08	Sew lbl size to ID,tack lbl at band,mark	Máy móc size vào móc ID,ghim móc vào cạp sd	B		SINGLE	35	279.0	823	
B09	Press elastic*1	Là chun cạp	B		PRESS	7	55.8	4114	
B10	Mark, cut elastic*1	SD, cắt chun cạp*1	C		HAND	10	74.2	2880	
B11	Close elastic*2	Cán chun cạp 2 lần	B		SINGLE	18	143.5	1600	
B12	Tack elastic to band	Ghim chun vào cạp	B		SINGLE	40	318.8	720	
TOTAL						1901	15,153	15.1	

Position	GENERAL	SPECIAL			
Single	752				
Double	268				
Chain stitch	160				
Special	189	99			
Press	158				
Hand	265	10			
Amount	1792	109			
Output (pcs)	16.07	264.22			
Total time	1901		total out put time		15.1

製表人: THAO

製造單號: G16-271P

車縫出數及使用機器預估表

訂單數量

8600

客戶: WHBM

各線均量

部門別	工段內容	工時 / 秒										備註
		平車	切修車	雙針車	拷邊車	開袋機	雞眼機	3本車	打結車	燙工	手工	
前片*2	劃號.燙襯									18	30	
袋貼*2袋布*2	拷3線.固定袋貼*2	23			10							
	袋底暗線&切修		35								12	
袋口貼*2	機燙.劃號									12	11	
袋布*4	袋口暗線.固定袋口貼暗明線.固定袋口上下.袋底明線	153	32									
鈕貼*1	拷3線.固定鈕貼	18			9							
後片*2	劃號.燙袋口襯									18	42	
袋貼*2袋布*2	拷3線.固定袋貼	23			10							
袋條*2	拷3線.開袋(機開袋+平車部分含袋底暗明線).袋口打結*4	262	60			52			28		12	
	外浪5線拷合.燙股&燙下襠	69			64					61		
鑲邊貼條*4	機燙.劃號.雙針貼條夾縫			163						36	38	
	內浪5線拷合.燙股				52					38		
	前後浪5線拷合.明線一道.彎鈕牌	81			42							
	車商標	33										
褲腰*2	機燙.劃號									14	16	
	接縫*2.開股	25								13		
	釘雞眼*2含記號						32				10	
	上褲腰.固定橡筋含剪	142										
	褲腰落極縫明線夾橡筋.雙針車飾線	108		78								
	折下襠車3本飾線							69				
	修線.穿繩										108	
腰繩*1	車腰繩	40										
	合計全件車縫工時	977	127	241	187	52	32	69	28	210	279	2202
	以一條線38人計,預估車台數量	16.9	2.2	4.2	3.2	0.9	0.6	1.2	0.5	3.6	4.8	38.0
	全件車縫出數 / 件											15.04

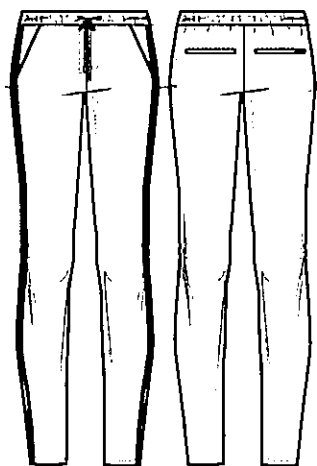
專特車工時: 184

車縫工時(不含專特車):

2018

車縫出數(不含專特車):

16.41



製表: 王愛卿 2016/10/5