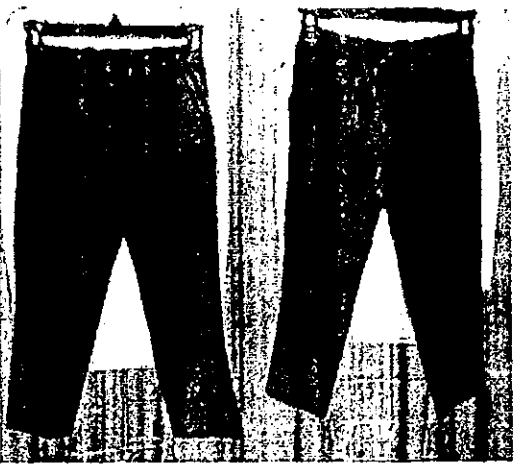


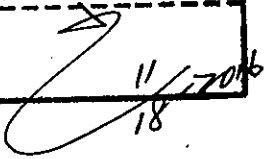
福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-299P	款式說 LADIES PANTS 订单 5000	制表人 THAO	日期: 2016/11/18	文件編號:
參考雷同款: The same G16-143P				
生產車縫時間 1387	特車組 84	總時間: 1471		
生產出數: 20.76	特車組出 342.86	IE 總出數: 19.6		

PPIC 主管: _____

茲核定IE出數如下:			
衣車縫	20.8	掛車縫	_____件
身整件	19.56	裡整件	_____件
全車縫	_____件	核	_____
件整件	_____件	簽	_____



FLOW CHART OF G16-299P

FRONT

- 35" 1. MARK FRONT*2+PKT POSITION*2
 7" 2. MARK FACING*2
 20" 3. SERGE FACING*2*2
 50" 4. STITCH FACING TO BAG*2*2
 42" 5. JOIN PKT OPEN*2
 38" 6. FOLDSTITCH PKT OPEN*2(DOUBLE)
 17" 7. PRESS PKT OPEN*2
 38" 8. JOIN BAG*2
 9" 9. TURN*2
 38" 10. 1/4 TOPSTITCH BAG*2
 45" 11. TACK PKT TO UPPER AND UNDER+TACK TO BAND AND OUTSEAM
 7" 12. SERGE FLY
 28" 13. JOIN FRONT RISE+FLY
 15" 14. SERGE FRONT RISE
 28" 15. CREASE FLY+CREASE BAND
 30" 16. TOPSTITCH FRONT RISE(DOUBLE)+STITCH FLY
 38" 17. TOPSTITCH FLY(DOUBLE)
 55" 24. SEFETY OUT SEAM
 24" 25. TACK LBL AT OUTSEAM*1
 60" 26. TOPSTITCH OUTSEAM*2(DOUBLE)
 25" 27. TACK FRONT+BACK RISE 1EDGE
 50" 28. SEFETY INSEAM
 4" 29. MARK HOLE*2
 8" 30. BARTACK HOLE*2
 12" 31. PRESS ESLASTIC
 10" 32. MARK, CUT ESLASTIC*1
 18" 33. CLOSE ESLASTIC*2
 50" 34. TACK ESLASTIC TO W.BAND
 50" 35. TACK 2EDGE, LBL SIZE AT BAND
 70" (A) 36. FOLDSTITCH W.BAND UPPER+UNDER(CHAIN STITCH)
 6" 37. MARK, CUT CORDING*1
 26" 38. INSERT CORDING
 22" 39. CLOSE 2EDGE CORDING
 68" (A) 40. FOLDSTITCH BTM*2
 70" 41. TRIM THREAD
 6" 001. BOTTOM HOLE*1
 72" 002. BARTACK F.PKT*4+B.PKT*4+FLY*2

BACK*2

- 40" 18. MARK BACK+PKT POSITION*2
 38" 19. EQLDSTITCH PKT OPEN*2
 40" 20. CREASE AROUND PKT*2
 95" (A) 21. 1/16STITCH AT PKT LIP 3UPPER*2
 30" 22. SEFETY BACK RISE
 35" 23. TOPSTITCH BACK RISE



POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	536	
DOUBLE	304	
CHAIN STITCH	70	
SPECIAL	177	80
PRESS	97	
HAND	203	4
AMOUNT	1387	84
OUTPUT	113 NO	
OUTPUT	113 NO	

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

STYLE NO: G16-299P
DATE: 2016-11-18

TAIPEI IE OUTPUT:
VN IE OUTPUT: 20.76

# 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+pkt posititon*2	SD TT+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 facing*2*2	VS 3C đắp túi*2*2	B		SW	20	159.4	1440	
04	Stitch facing to bag*2*2	Mí đắp vào lót*2*2	B		SINGLE	50	398.5	576	
05	Join pkt open*2	Cán chập miệng túi*2	B		SINGLE	42	334.7	686	
06	Topstitch pkt open*2(double)	Điều miệng túi 2kim*2	B		DOUBLE	38	302.9	758	
07	Press pkt open*2	Là miệng túi trước*2	B		PRESS	17	135.5	1694	
08	Join bag*2	Quay lót túi*2	B		SINGLE	38	302.9	758	
09	Turn bag*2	Lộn túi*2	C		HAND	9	66.8	3200	2
10	1/4Topstitch bag*2	Điều đít túi 1/4*2	B		SINGLE	38	302.9	758	1
11	Tack pkt to upper and under*2+tack to band,seam	Ghim miệng túi trên dưới*2, ghim trên cạp+sườn	B		SINGLE	45	358.7	640	
12	Serge fly	VS 3C moi	B		SW	7	55.8	4114	
13	Join front rise+fly	Cán chập moi+dùng TT	B		SINGLE	28	223.2	1029	
14	Serge front rise	VS 3C đứng TT	B		SW	15	119.6	1920	
15	Crease fly+crease band	Là gấp moi+là gấp lá cạp	B		PRESS	28	223.2	1029	
16	Topstitch front rise(double)	Điều đứng TT 2kim	B		DOUBLE	32	255.0	900	
17	Topstitch fly(double)	Điều moi 2kim	B		DOUBLE	38	302.9	758	
18	Safety out seam	VS 5C dọc quần	B		SW	55	438.4	524	
19	Tack lbl at outseam	Ghim mác sườn*1	B		SINGLE	24	191.3	1200	
20	Topstitch outseam*2(double)	Điều dọc quần 2kim*2	B		DOUBLE	60	478.2	480	
21	Tack front+back rise 1edge	Ghim đứng 1đoạn TT+TS	B		SINGLE	25	199.3	1152	
22	Safety inseam	VS 5C giàng quần	B		SW	50	398.5	576	
23	Mark hole*2	SD đục lỗ cạp*2	C		HANDSCL	4	29.7	7200	
24	Sew hole*2	Bổ khuy lỗ*2	B		SPECIAL	8	63.8	3600	
25	Press elastic	Là chun cạp	B		PRESS	12	95.6	2400	
26	Mark, cut elastic*1	SD, cắt chun cạp*1	C		HAND	10	74.2	2880	
27	Close elastic*2	Cán chun cạp 2lần	B		SINGLE	18	143.5	1600	
28	Tack elastic to w.band, tack lbl at band	Ghim chun vào cạp	B		SINGLE	50	398.5	576	
29	Tack 4edge, lbl at at band	Ghim 4 điểm vào cạp+ghim mác*1	B		SINGLE	50	398.5	576	
30	Mark, cut cording	SD, cắt dây*1	C		HAND	6	44.5	4800	
31	Insert cording	Luồn dây	C		HAND	26	192.9	1108	
32	Close 2edge cording	Chặn đầu dây*2	B		SINGLE	22	175.3	1309	
33	Foldstitch under w.band(chain stitch)+topstitch band	Gấp điều chân cạp+điều cạp trên,dưới(máy 3kim)	A		CHAIN STITCH	70	585.9	411	
34	Foldstitch btm*2	Gấp điều gấu *2	A		SINGLE	68	569.2	424	
XZ	Trim thread	Cắt chỉ	C		HAND	70	519.4	411	
001	Boltone hole*1	Định cúc cạp*1	B		HAND SCL	6	47.8	4800	
002	Bartack F.pkt*4+B.pkt*4+fly*2	Đi bọ miệng túi TT*4+miệng túi TS*4+moi*2	B		SPECIAL	72	573.8	400	

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

STYLE NO: G16-299P
DATE: 2016-11-18

TAIPEI IE OUTPUT:
VN IE OUTPI 20.76

OP VO Mã	Operation Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn	out put Sàn lượng	使用配 件及其他
	<i>Back body*2</i>					FALSE	#DIV/0!	
	<i>Thân sau*2</i>							
101	Mark back+pkt posititon*2	C		HAND	40	296.8	720	
102	Foldstitch pkt open*2	B		SINGLE	38	302.9	758	
103	Crease around pkt*2	B		PRESS	40	318.8	720	
104	Attack topstitch pkt*2(double)	A		DOUBLE	95	795.2	303	
105	Safety back rise	B		SW	30	239.1	960	
106	Topstitch back rise	B		DOUBLE	35	279.0	823	
TOTAL					1471	11703	19.58	



Position	GENERA	SPECIAL			
Single	542				
Double	298				
Chain Stitch	70				
Special	177	80			
Press	97				
Hand	203	4			
Amount	1387	84			
Output (pcs)	20.76	342.86			
Total time	1471		Total Out out		19.6

表人: THIAO

製造單號: G16-299P (童褲)

車縫出數及使用機器預估表

訂單數量 5000

客戶 : NET

各線均量

部門別	工段內容	工時 / 秒										備註
		平車	鎖鏈車	切修車	雙針車	拷邊車	開袋機	一字洞	打結車	燙工	手工	
前片*2	劃號										31	
袋貼*4袋布*	拷3線.固定袋貼*4.袋底暗線.翻	42		35		20					12	
	開袋(袋口暗線.燙.雙針明線.固定袋口上下.袋底明線)	84		30	39					18		
口袋*2	燙折邊.固定活折*4	32								36		
	雙針貼袋.袋口打結*4	48			85				24			
	前浪暗線.拷3線.燙.前浪雙針明線.彎鈕牌&飾線	71				12				8		
	前片打結*5(前袋*4.鈕牌*2)								29			
後片*2	劃號										36	
口袋*2	捲袋口.燙折邊	36								54		
	雙針貼袋.袋口打結*4				120				24			
	後浪5線拷合.雙針明線				28	26						
	外浪5線拷合.雙針明線.燙下襠				52	50				24		
	內浪5線拷合.燙股					47				28		
	車商標	36										
	燙折邊.鎖一字洞*2含記號							14		36	10	
	接褲腰橡筋&剪.固定橡筋	46										
	捲褲腰鎖鏈明線3道(夾橡筋)		203									加羅拉
	捲下襠	72										
	修線.穿棉繩										96	
	合計工時	467	203	65	324	155	0	14	77	204	185	1694
	以一條線60人計,預估車台數量	16.5	7.2	1.4	11.5	5.5	0.0	0.5	2.7	7.2	6.6	59.1
	預估出數/ 件											19.56



專特車工時: 101 車縫工時(不含專特車): 1593
 車縫出數(不含專特車): 20.80

製表: 王愛卿 2016/11/18