

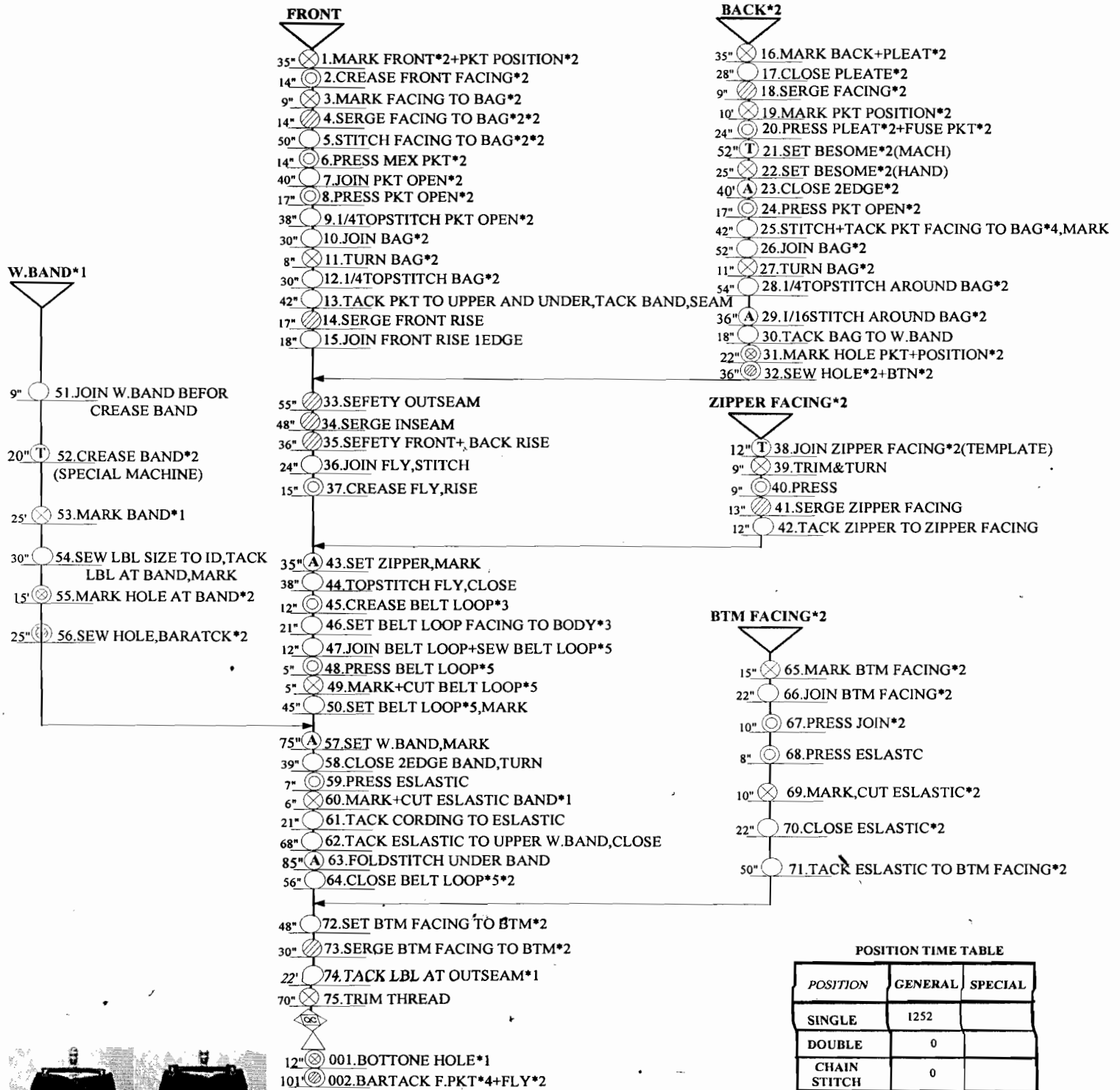
福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-078P	款式說明 LADIE PANTS 订单 2.400	制表人 THAO	日期: 2016/06/24	文件編號:
參考雷同款:				
生產車縫時間 1898	特車組 295	總時間:2193		
生產出數:15.17	特車組出 97.63	IE 總出數: 13.13		

PPIC 主管:

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FLOW CHART OF G16-078P

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1252	
DOUBLE	0	
CHAIN STITCH	0	
SPECIAL	221	246
PRESS	152	
HAND	373	48
HAND	275	49
AMOUNT	1898	295

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

STYLE NO: G16-078P
DATE: 2016-06-24

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VN IE OUTPI 15.17

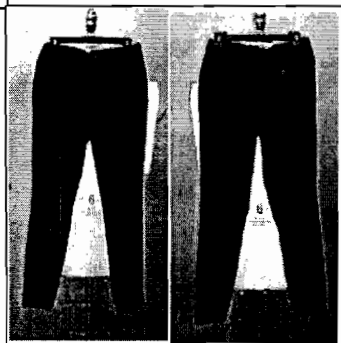
OP NO Mã	Operation Tên công đoạn		Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn	out put Sản lượng	使用配 件及其他
01	Mark front+pkt posititon*2	SD TT+vị trí túi*2	C		HAND	35	259.7	823	
02	Crease facing pkt*2	Là gấp đáp túi trước*2	B		PRESS	14	111.6	2,057	
03	Mark facing *2	SD đáp túi TT*2	C		HAND	9	66.8	3,200	
04	Serge facing*2	VS 3C đáp túi*2	B		SW	14	111.6	2,057	
05	Stitch facing to bag*2*2	Mí đáp vào lót*2*2	B		SINGLE	50	398.5	576	
06	Press mex pkt open*2	Là mex miệng túi trước*2	B		PRESS	14	68.14	111.6	
07	Join pkt open*2	Cán chập miệng túi*2	B		SINGLE	40	318.8	720	
08	Press pkt open*2	Là miệng túi trước*2	B		PRESS	17	135.5	1,694	
09	Topstitch pkt open*2	Điều miệng túi 1/4*2	B		SINGLE	38	302.9	758	
10	Join bag*2	Quay lót túi*2	B		SINGLE	30	239.1	960	
11	Turn bag*2	Lộn túi*2	C		HAND	8	59.4	3,600	
12	1/4Topstitch bag*2	Điều đít túi 1/4*2	B		SINGLE	30	239.1	960	
13	Tack pkt to upper and under*2+tack to band,seam	Ghim miệng túi trên dưới *2, ghim trên cạp+sườn	B		SINGLE	42	334.7	686	
14	Serge front rise	VS 3C đứng TT	B		SW	17	135.5	1,694	
15	Join front rise 1edge	Cán chập đứng TT 1đoạn	B		SINGLE	18	143.5	1,600	
16	Safety out seam	VS 5C dọc quần	B		SW	55	438.4	524	
17	Safety inseam	VS 5C giàng quần	B		SW	48	382.6	600	
18	Safety front&back rise	VS 5C đứng TT+TS	B		SW	35	279.0	823	
19	Join fly, stitch	Cán chập moi+mí	B		SINGLE	24	191.3	1,200	
20	Crease fly, rise	Là gấp moi, là đứng	B		PRESS	15	119.6	1,920	
21	Set zipper, mark	Tra khóa, sd	A		SINGLE	35	293.0	823	
22	Topstitch fly+close	Điều moi khóa 1 kim+chặn moi	B		SINGLE	38	302.9	758	
23	Crease belt loop facing*4	Là gấp đáp đĩa*3	B		PRESS	12	95.6	2,400	
24	Set belt loop facing to body*3	Tra đáp đĩa vào thân*3	B		SINGLE	21	167.4	1,371	
25	Join belt loop+sew belt loop*5	Cán đĩa+máy đĩa*5	B		SINGLE	12	95.6	2,400	
26	Press belt loop*5	Là đĩa*5	B		PRESS	5	39.9	5,760	
27	Mark+cut belt loop*5	SD+cắt đĩa*5	C		HAND	5	37.1	5,760	
28	Set belt loop*5, mark	Tra đĩa, sd*5	B		SINGLE	45	358.7	640	
29	Set w.band, mark	Tra cạp, sd	A		SINGLE	75	627.8	384	
30	Close 2edge band&, turn	Chặn 2 đầu cạp, lộn	B		SINGLE	39	310.8	738	
31	Press elastic band	Là chun cạp	B		PRESS	7	55.8	4,114	
32	Mark+cut elastic band*1	SD+cắt chun cạp*1	C		HAND	6	44.5	4,800	
33	Tack cording to elastic	Ghim dây vào chun	B		SINGLE	21	167.4	1,371	
34	Tack elastic to upper w.band, close	Ghim chun vào sống cạp, chặn	B		SINGLE	68	542.0	424	
35	Foldstitch under w.band	Gấp mí chun cạp	A		SINGLE	85	1,025.74	711.5	
36	Close belt loop*5*2	Chặn đĩa trên, dưới*5*2	B		SINGLE	56	446.3	514	
37	Set btm facing to btm	Tra đáp gấu vào gấu	A		SINGLE	48	401.8	600	
38	Serge btm facing to btm*2	VS 3C đáp gấu vào gấu	B		SW	30	239.1	960	
39	Tack lbl at outseam*1	Ghim móc sườn*1	B		SINGLE	22	175.3	1,309	
XZ	Trim thread	Cắt chỉ	C		HAND	70	519.4	411	
001	Bottom hole*1	Đinh cúc cạp*1	B		HANDSCL	12	95.6	2,400	
002	Barback F.pkt*4+B.pkt*4+Rv*2	Đinh cúc miết túi TT*4+miết túi TT*4+miết túi TT*2	B		HANDSCL	12	95.6	2,400	

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SEWING OPERATION LIST

STYLE NO: G16-078P
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VN IE OUTPI 15.17

# OP NO 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
	Btm facing*2					FALSE	#DIV/0!	
B01	Mark btm facing*2	C		HAND	15	111.3	1,920	
B02	Join btm facing*2	B		SINGLE	22	175.3	1,309	
B03	Press join*2	B		PRESS	10	79.7	2,880	
B04	Press elastic	B		PRESS	8	63.8	3,600	
B05	Mark, cut elastic*2	C		HAND	10	74.2	2,880	
B06	Close elastic*2	B		SINGLE	22	175.3	1,309	
B07	Tack elastic to btm facing*2	B		SINGLE	50	398.5	576	
	Back body*2					FALSE	#DIV/0!	
C01	Mark back+pleat*2	C		HAND	35	259.7	823	
C02	Close pleat*2	B		SINGLE	28	223.2	1,029	
C03	Serge facing*2	B		SW	9	71.7	3,200	
C04	Mark pkt position*2	C		HAND	10	74.2	2,880	
C05	Press pleat*2+Fuse pkt*2	B		PRESS	24	191.3	1,200	
C06	Set besom*2(mach)	B		SPECIAL	52	414.4	554	
C07	Set besom*2(hand)	C		HAND	25	185.5	1,152	
C08	Close 2edge*2	A		SINGLE	40	334.8	720	
C09	Press pkt open*2	B		PRESS	17	135.5	1,694	
C10	Stitch+tack pkt facing to bag*2*2, mark	B		SINGLE	42	334.7	686	
C11	Join bag	B		SINGLE	52	414.4	554	
C12	Turn bag*2	C		HAND	11	FALSE	2,618	
C13	1/4topstitch around bag	B		SINGLE	54	430.4	533	
C14	1/16 stitch at pkt lip 3upper*2	A		SINGLE	36	301.3	800	
C15	Tack bag to w.band	B		SINGLE	18	143.5	1,600	
C16	Mark hole back pkt+btn position	C		HANDSCL	22	163.2	1,309	
C17	Sew hole*2+btn*2	B		SPECIAL	36	286.9	800	
	W.band*1					FALSE	#DIV/0!	
D01	Join w.band before crease band	B		SINGLE	9	71.7	3,200	
D02	Crease band*2(special machine)	B		SPECIAL	20	159.4	1,440	
D03	Mark band*1	C		HAND	25	185.5	1,152	
D04	Sew lbl size to ID, tack lbl at band, mark	B		SINGLE	30	239.1	960	
D05	Mark hole at band*2 position	C		HANDSCL	15	111.3	1,920	
D06	Sew hole&bartack*2	B		SPECIAL	25	199.3	1,152	
TOTAL					2193	17625	13.13	



Position	GENERA	SPECIAL		
Single	1252			
Double	0			
Chain Stitch	0			
Special	221	246		
Press	152			
Hand	273	49		
Amount	1898	295		
Output (pcs)	15.17	97.63		
Total time	2193		Total out put	13.13