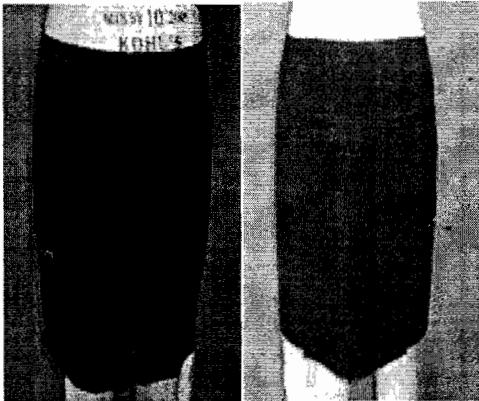


福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-128S	款式說明 LADIE SKIRT 订单 3.400	制表人: THAO	日期: 2016/04/27	文件編號:
參考雷同款:			照片 	
生產車縫時間:2077	特車組時間 100	總時間: 2177		
生產出數: 13.87	特車組出數 288.0	IE 總出數: 13.23		

PPIC 主管:


 4/8

FLOW CHART OF G16-128S

W.BAND*4

- 34" 62. SEW EDGE*2
(CHAIN STITCH)
25" 63. MARK BAND*2
40" 64. JOIN CENTER W.BAND*4
5" 65. PRESS SEAM OPEN
18" 66. TRIM BAND
4" 64. PRESS ELASTIC BAND
3" 65. MARK+ CUT ELASTIC
BAND*1
8" 66. CLOSE OPEN ELASTIC
35" 67. TACK ELASTIC TO
UPPER W.BAND(CHAIN STITCH)
30" 68. 1/16 STITCH UPPER
W.BAND
22" 69. PRESS UPPER W.BAND
30" 70. SERGE UNDER W.BAND
18" 71. TACK W.BAND 1 EDGE

FRONT

- 30" 1. MARK FRONT*3
14" 2. MARK FACING F.PANEL SEAM*2+PKT SMALL
POSITION AT RIGHT
7" 3. PRESS MEX PKT SMALL*1 (AT RIGHT)
9" 4. TACK BAG TO FACING*1
21" 5. SET BESOM*1 PKT SMALL AT RIGHT
(MACH)(MATCHED STRIPE)
10" 6. SET BESOM*1(HAND)
16" 7. CLOSE 2EDGE*1
8" 8. PRESS PKT OPEN*1
8" 9. TACK BAG TO BESOM*1
6" 10. SEFETY 1 EDGE BAG*1
15" 11. 1/16STITCH LIP 3UPPER*1
9" 12. TACK PKT OPEN*1
4" 13. TACK OVER LOCK BACK PKT*2*2
14" 14. PRESS MEX PKT OPEN*2
36" 15. JOIN PKT OPEN*2, NOTCH
17" 16. PRESS PKT OPEN*2
34" 17. TOPSTITCH PKT OPEN*2(DOUBLE)
24" 18. TOPSTITCH BAG*2, MARK(OUTSIDE)(DOUBLE)
26" 19. TACK PKT OPEN UPPER AND UNDER
36" 20. TACK PKT TO BAND AND SEAM
40" 21. JOIN F.PANEL SEAM*2(SEFETY)
45" 22. TOPSTITCH F.PANEL SEAM*2(DOUBLE)
40" 48. SEFETY OUT SEAM*2
18" 49. PRESS F.BTM
5" 50. MARK ATTACK PKT SIDE POSITION*1
7" 51. PRESS MEX PKT OPEN*1
4" 52. SERGE 1EDGE BAG*1
25" 53. SET BESOME*1(MACH)
13" 54. SET BESOME*1(HAND)
26" 55. CLOSE 2EDGE*2
15" 56. PRESS PKT OPEN*1
24" 57. SET ZIPPER(STITCH UNDER EDGE*1)
14" 58. TACK BAG PKT+TACK 2EDGE
18" 59. JOIN BAG*1(SEFETY)
24" 60. STITCH 3EDGE UPPER*1
18" 61. TACK"SW" FRONT PKT*4
70" 72. SET W.BAND, MARK
15" 73. PRESS. W.BAND AFTER SET
65" 81. SET LINING W.BAND
24" 82. TACK LBL AT BAND*2
78" 83. CREAK STITCH UNDER W.BAND(CHAIN STITCH)
18" 84. TACK LBL AT OUTSEAM*2
72" 85. FOLDSTITCH BTM
74" 86. TRIM&TURN

BACK BODY*1

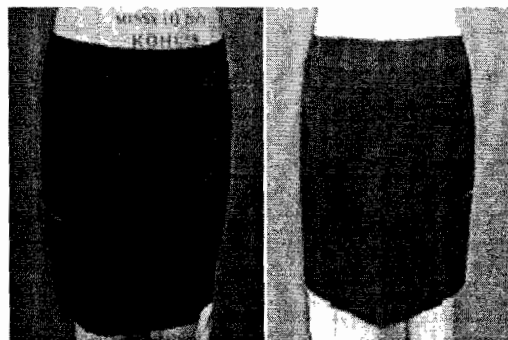
- 30" 23. MARK BACK*3
14" 24. SERGE VENT BACK*3
24" 25. 1/14FOLDSTITCH VENT INSIDE*2
12" 26. JOIN 1EDGE CLOSE BENT
30" 27. CLOSE VENT INSIDE*2, TURN
20" 28. CREASE B.BTM+VENT
9" 30. TACK VENT 1EDGE
40" 31. JOIN B.PANEL SEAM(SEFETY)
45" 32. TOPSTITCH B.PANEL SEAM*2(DOUBLE)
14" 33. CLOSE VENT, MARK*2
10" 34. MARK PKT POSITION*2
14" 35. PRESS MEX PKT OPEN*2
54" 36. SET BESOME(MACH)
25" 37. SET BESOME(HAND)
40" 38. CLOSE PKT OPEN*2
17" 40. PRESS PKT OPEN*2
25" 41. STITCH UNDER 1EDGE
18" 42. TACK BAG PKT*2
35" 43. SEFETY BAG*2
36" 44. 1/16STITCH LIP 3UPPER*2
18" 45. TACK PKT OPEN*2
18" 46. TACK OVER LOCK BACK PKT*4
22" 47. TACK BAG PKT TO BAND*2

LINING

- 18" 74. MARK LINING
48" 75. CLOSE PLEAT*4
26" 76. O/L 4T OUT SEAM
18" 77. O/L 4T IN SEAM
42" 78. O/L 4T FRONT RISE*BACK
RISE(JOIN RISE FACING)
70" 79. FOLDSTITCH BTM(KANSAI)
18" 80. PRESS

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	958	
DOUBLE	148	
CHAIN STITCH	108	
KANSAI	70	
SPECIAL	315	100
PRESS	203	
HAND	275	0
AMOUNT	2077	100
OUTPUT PCS	13.87	288.0
TOTAL TIME	2177	TOTAL OUTPUT 13.23



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

STYLE NO: AP16-128S
DATE: 2016/04/27

TAIPEI IE OUTPUT:
VN IE OUTPUT: 13.87

# step Mã	Step name Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời	price Đơn giá	out put Sản	使用配 件及其
01	Mark front*3	SD TT*3	C	HAND	30	222.6	960	
02	Mark facing F.panel seam*2+pkt small position at right	SD đáp sườn TT*2+vị trí túi nhỏ*1	C	HAND	14	103.9	2057	
03	Press mex pkt small at right	Là mex vào vị trí túi*1	B	PRESS	7	55.8	4114	
04	Tack bag to facing*1	Ghim lót vào đáp*1	B	SINGLE	9	71.7	3200	
05	Set besom*1 pkt small at right(mach)(matched stripe)	Bổ túi bằng máy*1, đặt coi*1(túi nhỏ)	B	SPECIAL	21	167.4	1371	
06	Set besom*1(hand)	Bổ túi bằng tay*1	C	HAND	10	74.2	2880	
07	Close 2edge*1	Chặn 2 đầu coi túi nhỏ*1	A	SINGLE	16	133.9	1800	
08	Press pkt small open*1	Là miệng coi túi nhỏ*1	B	PRESS	8	63.8	3600	
09	Tack bag to besome*1	Ghim lót túi vào coi*1	B	SINGLE	8	63.8	3600	
10	Safety 1edge bag*1	VS 5C 1 bên cạnh túi*1	B	SW	6	47.8	4800	
11	1/16stitch lip 3 upper*1	Mí 3 cạnh coi túi*1	A	SINGLE	15	125.6	1920	
12	Tack pkt open*2	Ghim miệng túi*2	B	SINGLE	9	71.7	3200	
13	Tack over lock back pkt*2*2	Chặn đầu vs túi*1	B	SINGLE	4	31.9	7200	
14	Press mex pkt open*2	Là mex miệng túi TT*2	B	PRESS	14	111.6	2057	
15	Join pkt open*2,notch	Cán chập miệng túi*2,bấm góc	B	SINGLE	36	286.9	800	
16	Press pkt open*2	Là miệng túi trước*2	B	PRESS	17	135.5	1694	
17	Topstitch pkt open*2(double)	Điều miệng túi 2kim*2	B	DOUBLE	34	271.0	847	
18	Topstitch bag*2,mark(outside)(double)	Điều dít túi 2kim*2,SD(bên ngoài)	B	DOUBLE	24	191.3	1200	
19	Tack pkt open upper and under	Ghim miệng túi trên dưới*2	B	SINGLE	26	207.2	1108	
20	Tack pkt to band and seam	Ghim túi trên cạp+sườn 1 đoạn	B	SINGLE	36	286.9	800	
21	Join F.panel seam*2(safety)	Cán chập sườn TT*2(VS 5C)	B	SW	40	318.8	720	
22	Topstitch F.panel seam*2(double)	Điều sườn TT 2kim*2	B	DOUBLE	45	358.7	640	
23	Safety outseam	VS 5c dọc váy	B	SW	42	334.7	686	
24	Crease f.btm	Là gấp gấu TT	B	PRESS	18	143.5	1600	
25	Mark attack pkt side position*1	Sd vị trí dán túi sườn*1	C	HAND	5	37.1	5760	
26	Press mex pkt side*1	Là mex vào vị trí túi*1	B	PRESS	7	55.8	4114	
27	Serge upper bag*1	VS 3C đầu lót túi*1	B	SW	4	31.9	7200	
28	Set besome*2(mach)	Bổ túi bằng máy*1(ghim coi)	B	SPECIAL	25	199.3	1152	
29	Set besome*2(hand)	Bổ túi bằng tay*2	C	HAND	13	96.5	2215	
30	Close 2edge*2	Chặn 2 đầu coi túi*1	A	SINGLE	26	217.6	1108	
31	Press besome*2	Là miệng coi túi*1	B	PRESS	15	119.6	1920	
32	Set zipper(stitch under edge*1)	Kê khóa*1(mí cạnh dưới)	A	SINGLE	24	200.9	1200	
33	Tack bag pkt+tack 2edge	Cán lót túi*2+ghim 2 đầu	B	SINGLE	14	111.6	2057	
34	Join bag*1(safety)	Quay lót túi(vs 5c)	B	SW	18	143.5	1600	
35	Stitch 3edge upper*1	Mí 3 cạnh coi túi*1	A	SINGLE	24	200.9	1200	
36	Tack "sw" front pkt*2*2	Chặn đầu vạt sổ lót túi*2*2	B	SINGLE	18	143.5	1600	
37	Set w.band,mark	Tra cạp,sd	A	SINGLE	70	585.9	411	
38	Press w.band after set	Là chân cạp sau tra	B	PRESS	14	111.6	2057	
39	Set lining w.band	Lồng lót cạp	A	SINGLE	60	502.2	480	
40	Tack lbi at band*2	Ghim móc cạp*2	B	SINGLE	24	191.3	1200	
41	Creak stitch under w.band	Mí chân cạp lộn khe	A	CHAIN STITCH	78	652.9	369	
42	Tack LBL at out seam*2	Ghim móc sườn*2	B	SINGLE	18	143.5	1600	
43	Foldstitch btm	Gập điều gấu	A	SINGLE	72	602.6	400	
X2	Trim&turn	Cắt chỉ,lộn váy	C	HAND	74	549.1	389	
	Back Body*3	Thân sau*3						
A01	Mark back*3	SD TS*3	C	HAND	30	222.6	960	
A02	Serge vent back*3	VS 3C sè sau*2	B	SW	14	111.6	2057	
A03	1/4 Foldstitch vent inside*2(single machine)	Gập điều sè trong 1kim*2 1/4	B	SINGLE	24	191.3	1200	
A04	Join 1edge close vent	Cán chập 1 đoạn để chặn sè	B	SINGLE	12	95.6	2400	
A05	Close vent inside*2,turn	Chặn gấu sè trong*2,lộn	B	SINGLE	30	239.1	960	

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

STYLE NO: AP16-128S
DATE: 2016/04/27

TAIPEI IE OUTPUT:
VN IE OUTPUT: 13.87

# step Mã	Step name Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời	price Đơn giá	out put Sản	使用配 件及其
A06	Crease B.btm+vent	B		PRESS	20	159.4	1440	
A07	Tack vent 1edge	B		SINGLE	9	71.7	3200	
A08	Join B.panel seam*2(Safety)	B		SW	40	318.8	720	
A09	Topstitch B.panel seam*2(double)	B		DOUBLE	45	358.7	640	
A10	Close vent,mark	B		SINGLE	14	111.6	2057	
A11	Mark pkt open position*2	C		HAND	10	74.2	2880	
A12	Press mex pkt open*2	B		PRESS	14	111.6	2057	
A13	Set besom*2(mach)	B		SPECIAL	54	430.4	533	
A14	Set besom*2(hand)	C		HAND	25	185.5	1152	
A15	Close pkt open*2	A		SINGLE	40	334.8	720	
A16	Press pkt open*2	B		PRESS	17	135.5	1694	
A17	Stitch under 1edge*2	B		SINGLE	25	199.3	1152	
A18	Tack bag pkt*2	B		SINGLE	18	143.5	1600	
A19	Safety bag*2	B		SW	35	279.0	823	
A20	1/16stitch lip 3upper*2	A		SINGLE	36	301.3	800	
A21	Tack pkt open*2	B		SINGLE	18	143.5	1600	
A22	Tack over lock back pkt*2*2	B		SINGLE	18	143.5	1600	
A23	Tack bag pkt to band*2	B		SINGLE	22	175.3	1309	
	W.band*4	Cấp*4						
B01	Join edge*2	B		SINGLE	34	271.0	847	
B02	Mark band*2	C		HAND	25	185.5	1152	
B03	Join center w.band*2*2	B		SINGLE	40	318.8	720	
B04	Press seam open	B		PRESS	9	71.7	3200	
B05	Trim w.band	C		HAND	18	133.6	1600	
B06	Press elastic band	B		PRESS	4	31.9	7200	
B07	Mark+cut elastic band*1	C		HAND	3	22.3	9600	
B08	Close elastic band	B		SINGLE	8	63.8	3600	
B09	Tack elastic to w.band	B		SINGLE	35	279.0	823	
B10	1/16stitch upper w.band	B		CHAIN STITCH	30	239.1	960	
B11	Press upper w.band	B		PRESS	22	175.3	1309	
B12	Serge under band	B		SW	30	239.1	960	
B13	Tack w.band 1 edge	B		SINGLE	18	143.5	1600	
	Lining	Lót						
C01	Mark lining	C		HAND	18	133.6	1600	
C02	Close pleat*2*2	B		SINGLE	48	382.6	600	
C03	O/L 4T out seam	B		SW	26	207.2	1108	
C04	O/L 4T in seam	B		SW	18	143.5	1600	
C05	O/L 4T front rise& back rise	B		SW	42	334.7	686	
C06	Foldstitch btm(kansai)	B		KANSAI	70	557.9	411	
C07	Press	B		PRESS	17	135.5	1694	
TOTAL					2177	17383.8	13.23	



Position	GENERAL	SPECIAL			
Single	958				
Kansai	70				
Double	148				
Special	315	100			
Chain stitch	108				
Press	203				
Hand	275	0			
Amount	2077	100			
Output pcs	13.87	288.0			
Total time	2177		total out put		13.23