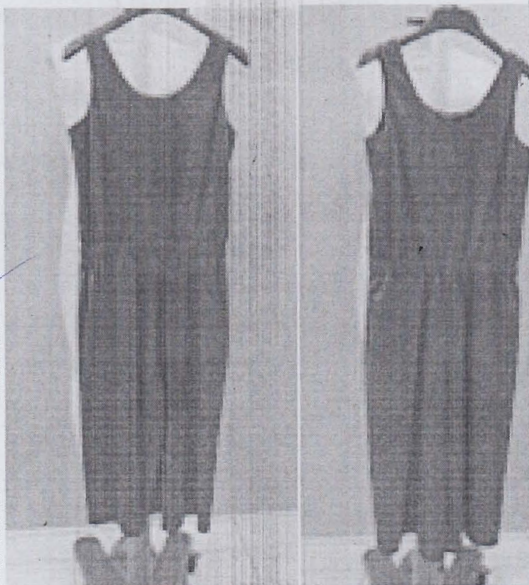
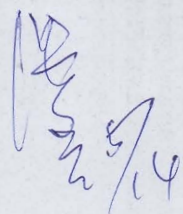


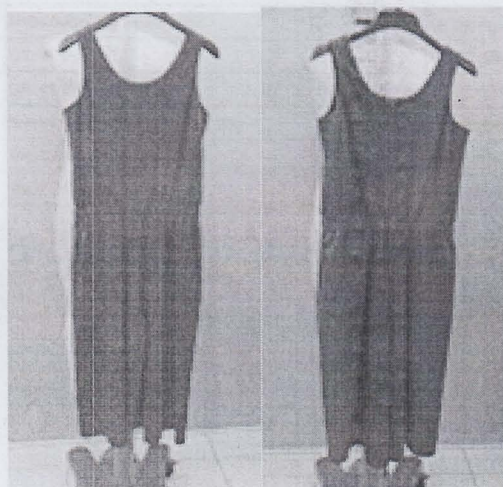
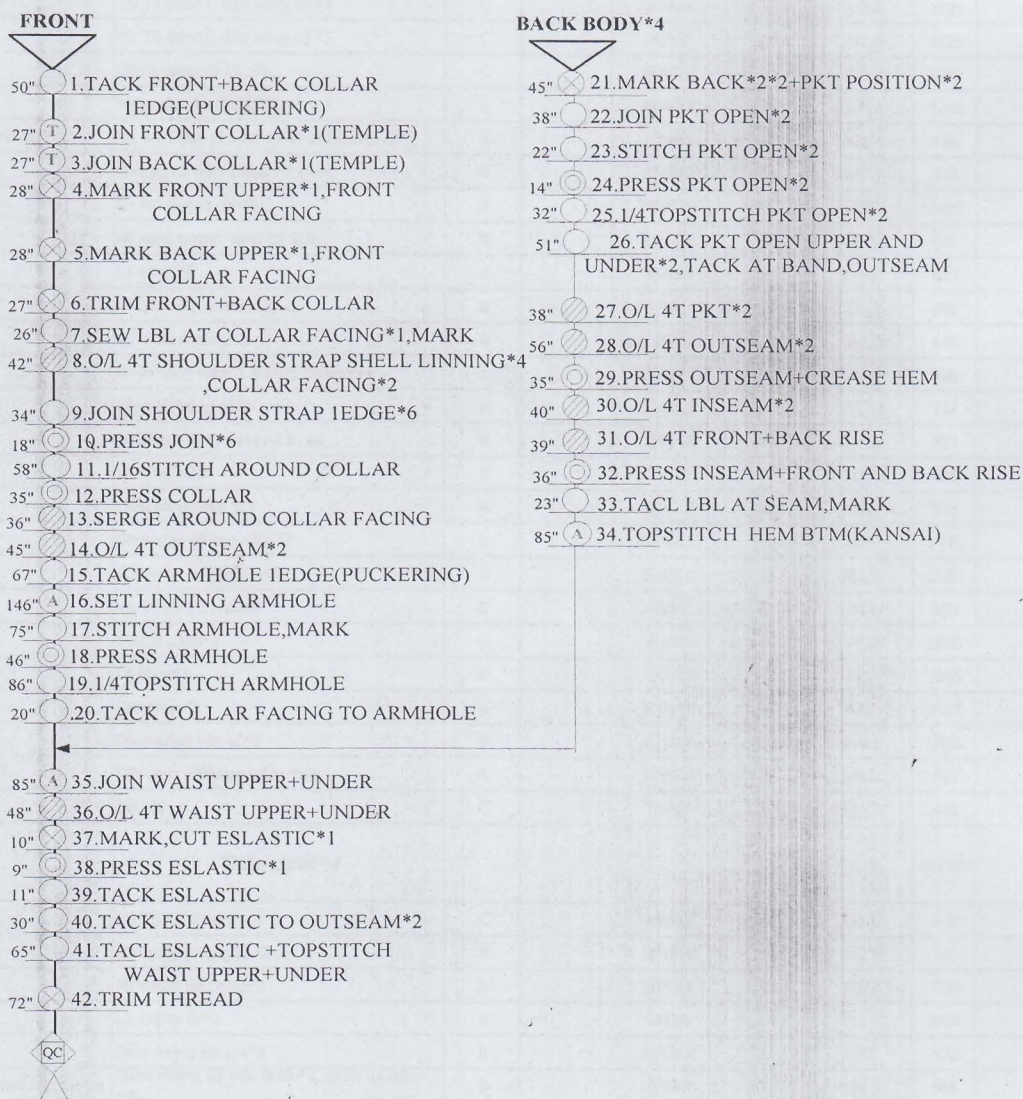
福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-135P	款式說明 LADIE PANST 订单 2.400	制表人: THAO	日期: 2016/05/14	文件編號:
參考雷同款:			照片 	
生產車縫時間:1751	特車組時間 54	總時間: 1805		
生產出數: 16.45	特車組出數 533.33	IE 總出數: 15.90		

PPIC 主管:



FLOW CHART OF G16-135P

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	946	
KANSAI	85	
SPECIAL	344	54
PRESS	193	
HAND	183	0
AMOUNT	1751	54
OUTPUT PCS	16.45	533.33
TOTAL TIME	1805	TOTAL OUTPUT 15.90

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

STYLE NO: G16-135P

DATE: 2016-05-14

TAIPEI IE OUTPUT:

VN IE OUTPUT: 16.45

# OP NO Mã	Operation Tên công đoạn	Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sàn	使用配 件及其他
01	Tack front+back collar 1edge(puckering)	B		SINGLE	50	398.5	576	
02	Join front collar*1(temple)	B		SPECIAL	27	215.2	1067	
03	Join back collar*1(temple)	B		SPECIAL	27	215.2	1067	
04	Mark front upper*1,front collar facing*1	C		HAND	28	207.8	1029	
05	Mark back upper*1,back collar facing*1	C		HAND	28	207.8	1029	
06	Trim front+back collar	C		SINGLE	27	200.3	1067	
07	Sew lbl at collar facing*1,mark	B		SINGLE	26	207.2	1108	
08	O/L 4T shoulder strap shell lining*4, collar facing*2	B		SW	42	334.7	686	
09	Join shoulder strap 1edge*6	B		SINGLE	34	271.0	847	
10	Press join*6	B		PRESS	18	143.5	1600	
11	1/16Stitch around collar(inside)	B		SINGLE	58	462.3	497	
12	Press collar	B		PRESS	35	279.0	823	
13	Serge around collar facing	B		SW	36	286.9	800	
14	O/L 4T outseam*2	B		SW	45	358.7	640	
15	Tack armhole 1edge(puckering)	B		SINGLE	67	534.0	430	
16	Set lining armhole	A		SINGLE	146	1222.0	197	
17	Stitch armhole,mark	B		SINGLE	75	597.8	384	
18	Press armhole	B		PRESS	46	366.6	626	
19	1/4Topstitch armhole	A		SINGLE	86	719.8	335	
20	Tack collar facing to armhole	B		SINGLE	20	159.4	1440	
21	Join waist upper+under	A		SINGLE	85	711.5	339	
22	O/L 4T waist upper+under	B		SW	48	382.6	600	
23	Mark,cut elastic*1	C		HAND	10	74.2	2880	
24	Press elastic*1	B		PRESS	9	71.7	3200	
25	Tack elastic*1	B		SINGLE	11	87.7	2618	
26	Tack elastic to outseam	B		SINGLE	30	239.1	960	
27	Tack elastic+topstitch waist upper+under	A		SINGLE	65	544.1	443	
XZ	Trim thread	C		HAND	72	534.2	400	
	Under body*4					FALSE	#DIV/0!	
A01	Mark back*2*2+pkt position*2	C		HAND	45	333.9	640	
A02	Join pkt open*2	B		SINGLE	38	302.9	758	
A03	Stitch pkt open*2	B		SINGLE	22	175.3	1309	
A04	Press pkt open*2	B		PRESS	14	111.6	2057	
A05	1/4Topstitch pkt open*2	B		SINGLE	32	255.0	900	
A06	Tack pkt open upper and under*2,tack at band,outseam	B		SINGLE	51	406.5	565	
A07	O/L 4T pkt*2	B		SW	38	302.9	758	
A08	O/L 4T out seam*2	B		SW	56	446.3	514	
A09	Press outseam+crease btm	B		PRESS	35	279.0	823	
A10	O/L 4T inseam*2	B		SW	40	318.8	720	
A11	O/L 4T front+back rise	B		SW	39	310.8	738	
A12	Press inseam+front and back rise	B		PRESS	36	286.9	800	
A13	Tack lbl at seam,mark	B		SINGLE	23	183.3	1252	
A14	Topstitch hem(kansai)	A		KANSAI	85	711.5	339	
TOTAL					1805	14457	15.96	

Position	GENERAL	SPECIAL		
Single	946			
Kansai	85			
Special	344	54		
Press	193			
Hand	183	0		
Amount	1751	54		
Output (pcs)	16.45	533.33		
Total time	1805		Total out put Tổng	15.96

