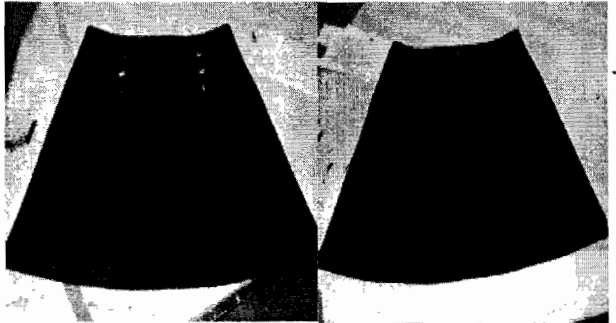


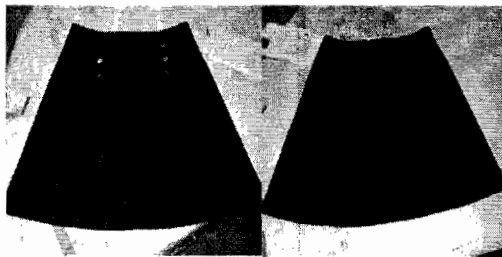
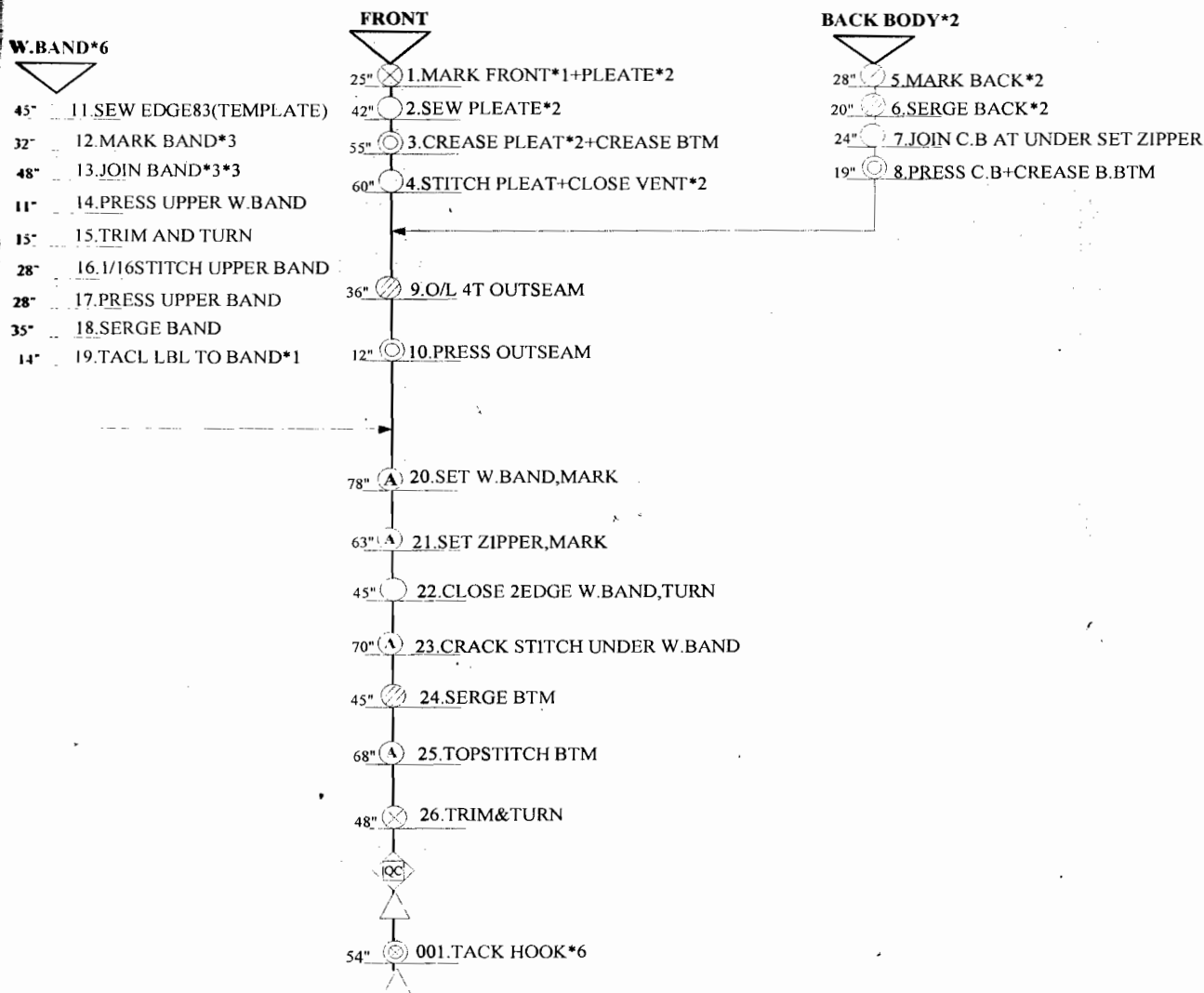
福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-136S	款式說明 LADIE SKIRT 订单 1.200	制表人: THAO	日期: 2016/05/09	文件編號:
參考雷同款:			照片	
生產車縫時 間:944	特車組時間 99	總時間: 1043		
生產出數: 30.51	特車組出數 290.9	IE 總出數: 27.61		

PPIC 主管:

15/5/9

FLOW CHART OF G16-136S

POSITION TIME TABLE

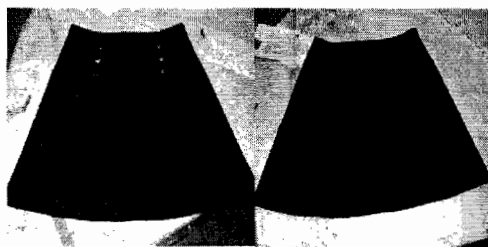
POSITION	GENERAL	SPECIAL
SINGLE	540	
CHAIN STITCH	0	
SPECIAL	136	45
PRESS	120	
HAND	148	54
AMOUNT	944	99
OUTPUT PCS	30.51	290.9
TOTAL TIME	1043	TOTAL OUTPUT 27.61

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

STYLE NO: G16-136S
DATE: 2016/04/20

TAIPEI IE OUTPUT:
VN IE OUTPUT: 30.51

工段號碼 Mã công	工段名稱 Tên công đoạn		等級 Cấp	合縫記號	使用機器	時間 Thời gian	金額 Đơn giá	日產量 Sàn lượng	使用配件 及其他
01	Mark front+pleat position*2	SD TT*1+vị trí ly*2	C		HAND	25	207.5	1,152	
02	Sew pleat*2	May ly TT*2	B		SINGLE	42	369.6	686	
03	Crease pleat*2+crease F.btm	Là gấp ly TT*2+ là gấp gấu	B		PRESS	55	484.0	524	
04	Stitch pleat+close vent*2	Mí ly TT*2+chặn sê*2	B		SINGLE	60	528.0	480	
05	O/L 4T out seam	VS 4c dọc váy	B		SW	36	316.8	800	
06	Press outseam	Là lật dọc váy	B		PRESS	12	105.6	2,400	
07	Set w.band	Tra cạp,sd	A		SINGLE	78	725.4	369	
08	Set zipper,mark	Tra khóa ,sd	A		SINGLE	63	585.9	457	
09	Close 2edge+turn	Chặn hai đầu cạp +lộn	B		SINGLE	45	396.0	640	
10	Crack stitch under w.band	Mí chân cạp lộn khe	A		SINGLE	70	651.0	411	
11	Serge btm	VS 3 chỉ gấu	B		SW	45	396.0	640	
12	Topstitch btm	Điều gấu	A		SINGLE	68	632.4	424	
001	Tack hook*6	Đinh cúc*6	B		HAND SCL	54	475.2	533	
XZ	Trim thread	Cắt chỉ	C		HAND	48	398.4	600	
	Back body*2	Thân sau*2							
A01	Mark back*2	SD TS *2	C		HAND	28	232.4	1,029	
A02	Serge back*2	VS 3C TS*2	B		SW	20	176.0	1,440	
A03	Join C.B at under set zipper	Cán chắp giữa TS *1	B		SINGLE	24	211.2	1,200	
A04	Press C.B +crease B.btm	Là rẽ giữa sau, gấp gấu TS	B		PRESS	19	167.2	1,516	
	W.band*6	Cạp*6							
B01	Sew edge*3(template)	Cán chắp sống cạp*3(bìa mẫu)	B		SPECIAL	45	396.0	640	
B02	Mark band*3	SD cạp *3	C		HAND	32	265.6	900	
B03	Join band*3*3	Cán cạp trong*3+cạp ngoài*3	B		SINGLE	48	422.4	600	
B04	Press band	Là rẽ cạp	B		PRESS	18	158.4	1,600	
B05	Trim and turn	Chém sửa cạp	C		HAND	15	124.5	1,920	
B06	1/16Stitch upper band	Mí sống cạp 1/16	B		SINGLE	28	246.4	1,029	
B07	Press upper band	Là sống cạp	B		PRESS	16	140.8	1,800	
B08	Serge band	VS 3C cạp	B		SW	35	308.0	823	
B09	Tack lbl to band*1	May móc vào cạp*1	B		SINGLE	14	123.2	2,057	
Total						1043	9,243.9	27.61	



Position	GENERAL	SPECIAL			
Single	540				
Chain stitch	0				
Special	136	45			
Press	120				
Hand	148	54			
Amount	944	99			
Output pcs	30.51	290.9			
Total time	1043		Total out put Tổng		27.61