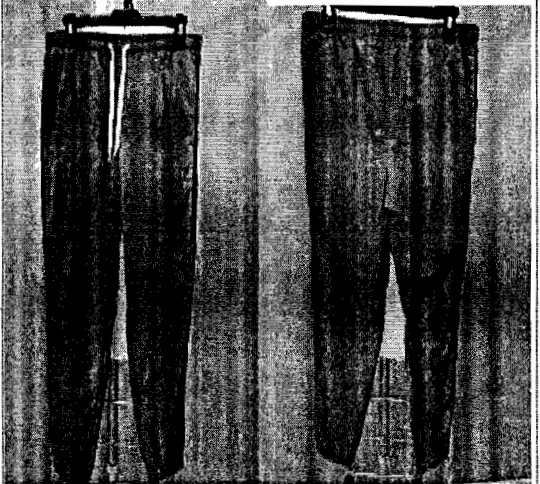


福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-156P	款式說明 LADIE PANTS 订单 3.600	制表人 THAO	日期: 2016/07/26	文件編號:
參考雷同款:				
生產車縫時間 1643	特車組 55	總時間:1698		
生產出數:17.53	特車組出 523.64	IE 總出數: 17.0		

PPIC 主管:

(Handwritten signature)

FLOW CHART OF G16-156P

FRONT

- 40" ⊗ 1. MARK FRONT*2+PKT POSITION*2
 18" ⊗ 2. MARK FRONT SEAM FAING*2*2(SMALL)
 13" ○ 3. JOIN FRONT SEAM FACING*2(SMALL)
 6" ○ 4. PRESS JOIN*2
 65" ⊗ 5. JOIN F. SEAM FACING TO FRONT*2(SEFETY)
 10" ○ 6. CREASE PKT FACING*2
 52" ○ 7. STITCH FACING TO BAG*4
 14" ○ 8. PRESS MEX PKT*2
 42" ○ 9. JOIN PKT OPEN*2(TACK BAG)
 22" ○ 10. 1/16 STITCH PKT OPEN*2
 17" ○ 11. PRESS PKT OPEN*2
 38" ○ 12. 1/4 TOPSTITCH PKT OPEN*2
 35" ○ 13. TACK PKT OPEN UPPER AND UNDER
 32" ⊗ 14. SEFETY PKT*2
 21" ⊗ 15. BARATACT PKT OPEN*2*2
 40" ⊗ 16. MARK BACK BODY*2
 67" ⊗ 17. SEFETY OUTSEAM
 65" ○ 18. STITCH OUTSEAM
 5" ⊗ 19. SERGE FLY*1
 5" ○ 20. PRESS FAKE FLY
 36" ⊗ 21. SEFETY FRONT+BACK RISE
 38" ○ 22. STITCH FRONT+BACK RISE
 36" ○ 23. TOPSTITCH FLY*1
 9" ⊗ 24. BARATACT FLY*1
 55" ⊗ 25. SEFETY INSEAM
 24" ○ 26. TACK SHELL RISE+LINING RISE
 78" A 32. SET LINING W. BAND
 70" A 38. SET W. BAND*1
 12" ○ 39. PRESS ESLASTIC*1
 12" ⊗ 40. MARK, CUT ESLASTIC*1
 18" ○ 41. CLOSE ESLASTIC*2
 45" ○ 42. TACK ESLASTIC TO W. BAND, TACK CORDING*1
 48" ○ 43. TACK ESLASTIC 4EDGE, TACK LBL AT BAND
 42" A 44. 1/16 STITCH W. BAND UPPER(CHAIN STITCH)
 80" A 45. FOLDSTITCH W. BAND UNDER
 8" ○ 46. PRESS ESLASTIC*2
 10" ⊗ 47. MARK+ CUT ESLASTIC*2
 20" ○ 48. CLOSE ESLASTIC*2
 24" ○ 49. TACK ESLASTIC TO BTM*2
 64" A 50. FOLDSTITCH BTM*2
 88" ⊗ 51. THREAD
 QC
 7" ⊗ 001. BARATACT BAND*1

W. BAND*1

- 28" ⊗ 33. MARK BAND*1
 15" ○ 34. JOIN BAND*1
 10" ○ 35. PRESS JOIN*1
 10" ⊗ 36. MARK HOLE*2
 8" ⊗ 37. SEW HOLE*2

LINING*4

- 10" ○ 27. TACK LBL AT SEAM*1
 62" ⊗ 28. O/L 4T OUTSEAM
 36" ⊗ 29. O/L 4T FRONT+TACK RISE
 52" ⊗ 30. O/L 4T INSEAM
 36" ○ 31. O/L 4T INSEAM



POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	757	
KANSAI	0	
DOUBLE	80	
CHAIN STITCH	42	
SPECIAL	410	45
PRESS	118	
HAND	236	10
AMOUNT	1643	55
OUTPUT PCS	17.53	523.64
TOTAL TIME	1698	TOTAL OUTPUT 17.0

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

STYLE NO: G16-156P
DATE: 2016-07-26

TAIPEI IE OUTPUT:
VN IE OUTPUT: 17.53

# OP NO Mã	Operation Tên công đoạn		Grade Cấp	合機記號	Operation	time Thời gian	price Đơn	out put Sản lượng	使用配件 及其他
01	Mark front+pkt position*2	SD TT+vị trí túi*2	C		HAND	40	296.8	720	
02	Mark front seam facing*2*2(small)	SD sườn TT*2*2	C		HAND	18	133.6	1600	
03	Join front seam facing*2(small)	Cán chập 2 sườn TT nhỏ*2	B		SINGLE	13	103.6	2215	
04	Press join*2	Là rẽ đường cán chập*2	B		PRESS	6	47.8	4800	
05	Join F.seam facing to front*2(Safety)	Cán chập sườn nhỏ vào sườn to*2(VS 5C)	B		SW	65	518.1	443	
06	Crease pkt facing*2	Là gấp nếp túi trước*2	B		PRESS	10	79.7	2880	
07	Stitch+Tack bag to facing*4	Mí+ghim lót vào đáy túi*4	B		SINGLE	52	414.4	554	
08	Press mex pkt*2	Là mex miệng túi TT*2	B		PRESS	14	111.6	2057	
09	Join pkt open*2(tack bag+besom)	Cán chập miệng túi*2(đặt coi+lót)	B		SINGLE	42	334.7	686	
10	1/16Stitch pkt open*2	Mí tăng cường miệng túi trong*2	B		SINGLE	22	175.3	1309	
11	Press pkt open*2	Là miệng túi trước*2	B		PRESS	17	135.5	1694	
12	1/4Topstitch pkt open*2	1/4Diều miệng túi*2	B		SINGLE	38	302.9	758	
13	Tack pkt open upper and under	Ghim miệng túi trên dưới *2	B		SINGLE	35	279.0	823	
14	Safety pkt*2	VS 5C dít túi*2	B		SW	32	255.0	900	
15	Baratack front pkt*2*2	Di bộ miệng túi TT*2*2	B		SPECIAL	21	167.4	1371	
16	Mark back body*2	SD TS*2	C		HAND	40	296.8	720	
17	Safety outseam*2	VS 5C dọc quần	B		SW	67	534.0	430	
18	Stitch outseam	Mí dọc quần	B		SINGLE	65	518.1	443	
19	Serge fly	VS 3C moi	B		SW	5	39.9	5760	
20	Press fake fly	Là gấp moi giả	B		PRESS	5	39.9	5760	
21	Safety front +back rise	VS 5C đứng TT+TS	B		SW	36	286.9	800	
22	Stitch front+back rise+stitch fly	Mí đứng TT+TS+mí moi 1kim	B		SINGLE	38	302.9	758	
23	Topstitch fake fly	Diều moi giả	B		SINGLE	36	286.9	800	
24	Baratack fly*1	Di bộ moi*1	B		SPECIAL	9	71.7	3200	
25	Safety inseam	VS 5C dằng quần	B		SW	55	438.4	524	
26	Tack shell rise+lining rise	Ghim giằng đứng chính+đứng lót	B		SINGLE	24	191.3	1200	
27	Set lining w.band	Lồng lót cạp	A		SINGLE	78	652.9	369	
28	Set band,mark	Tra cạp,sd	A		SINGLE	70	585.9	411	
29	Press elastic	Là chun cạp*1	B		PRESS	12	95.6	2400	
30	Mark,cut elastic*1	SD,cắt chun cạp*1	C		HAND	12	89.0	2400	
31	Close elastic*2	Cán chun cạp 2lần	B		SINGLE	18	143.5	1600	
32	Tack elastic to w.band,tack cording*1	Ghim chun vào cạp, ghim dây cạp	B		SINGLE	45	358.7	640	
33	Tack elastic 4edge ,tack lbt at band*1	Ghim 4 điểm vào cạp+ghim móc*1	B		SINGLE	48	382.6	600	
34	1/4Topstitch band under(double)	Diều chân cạp dưới(2kim)	A		DOUBLE	80	669.6	360	
35	1/4Topstitch band upper	Diều cạp trên (1kim)	A		Chain stitch	42	351.5	686	
36	Press elastic	Là chun	B		PRESS	8	63.8	3600	
37	Mark,cut elastic*2	SD,cắt chun gấu*2	C		HAND	10	74.2	2880	
38	Close elastic*2	Cán chun gấu 2lần*2	B		SINGLE	20	159.4	1440	
39	Tack elastic to btm*2	Ghim chun vào gấu 2 điểm*2	B		SINGLE	24	191.3	1200	
40	Foldstitch btm*2	Gấp diều gấu *2	A		SINGLE	64	535.7	450	
XZ	Thread	Cắt chỉ	C		HAND	88	653.0	327	
001	Baratack band*1	Di bộ cạp*1	B		SPECIAL	7	55.8	4114	

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

STYLE NO: G16-156P
DATE: 2016-07-26

TAIPEI IE OUTPUT:
VN IE OUTPUT: 17.53

# OP NO Mã	Operation Tên công đoạn		Grade Cấp	合縫記號	Operation	time Thời gian	price Đơn	out put Sản lượng	使用配件 及其他
	W.band*1	Cạp*1					FALSE	#DIV/0!	
A01	Mark band*1	SD cạp*1	C		HAND	28	207.8	1029	
A02	Join band*1	Cán giữa cạp*1	B		SINGLE	15	119.6	1920	
A03	Press join*1	Là rẽ giữa cạp*1	B		PRESS	10	79.7	2880	
A04	Mark hole*2	SD đục lỗ cạp*2	C		HAND SCL	10	74.2	2880	
A05	Sew hole*2	Bổ khuy lỗ*2	B		SPECIAL	8	63.8	3600	
	Lining*4	Lót*4					FALSE	#DIV/0!	
B01	Tack lbl at seam*1	Ghim mác vào sườn*1, sd	B		SINGLE	10	79.7	2880	
B02	Safety outseam	VS SC dọc quần	B		SW	62	494.1	465	
B03	Safety front +back rise	VS SC đứng TT+TS	B		SW	36	286.9	800	
B04	Safety inseam	VS SC giàng quần	B		SW	52	414.4	554	
B05	Press lining	Là lật dọc, dằng, đứng TT, TS	B		PRESS	36	286.9	800	
TOTAL						1698	13531	17.0	

Positio	GENERA	SPECIAL			
Single	757				
Double	80				
Chain Stitch	42				
Special	410	45			
Press	118				
Hand	236	10			
Amount	1643	55			
Output (pcs)	17.53	523.64			
Total time	1698		Total out put		17.0



製表人: THAO

doc 42
giang 30