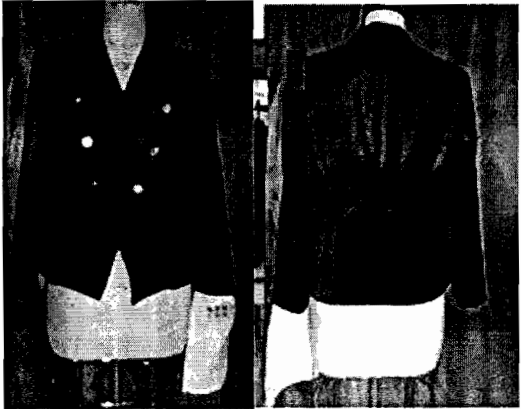


福星制衣越南廠 制衣工程 IE 出數核定流程表

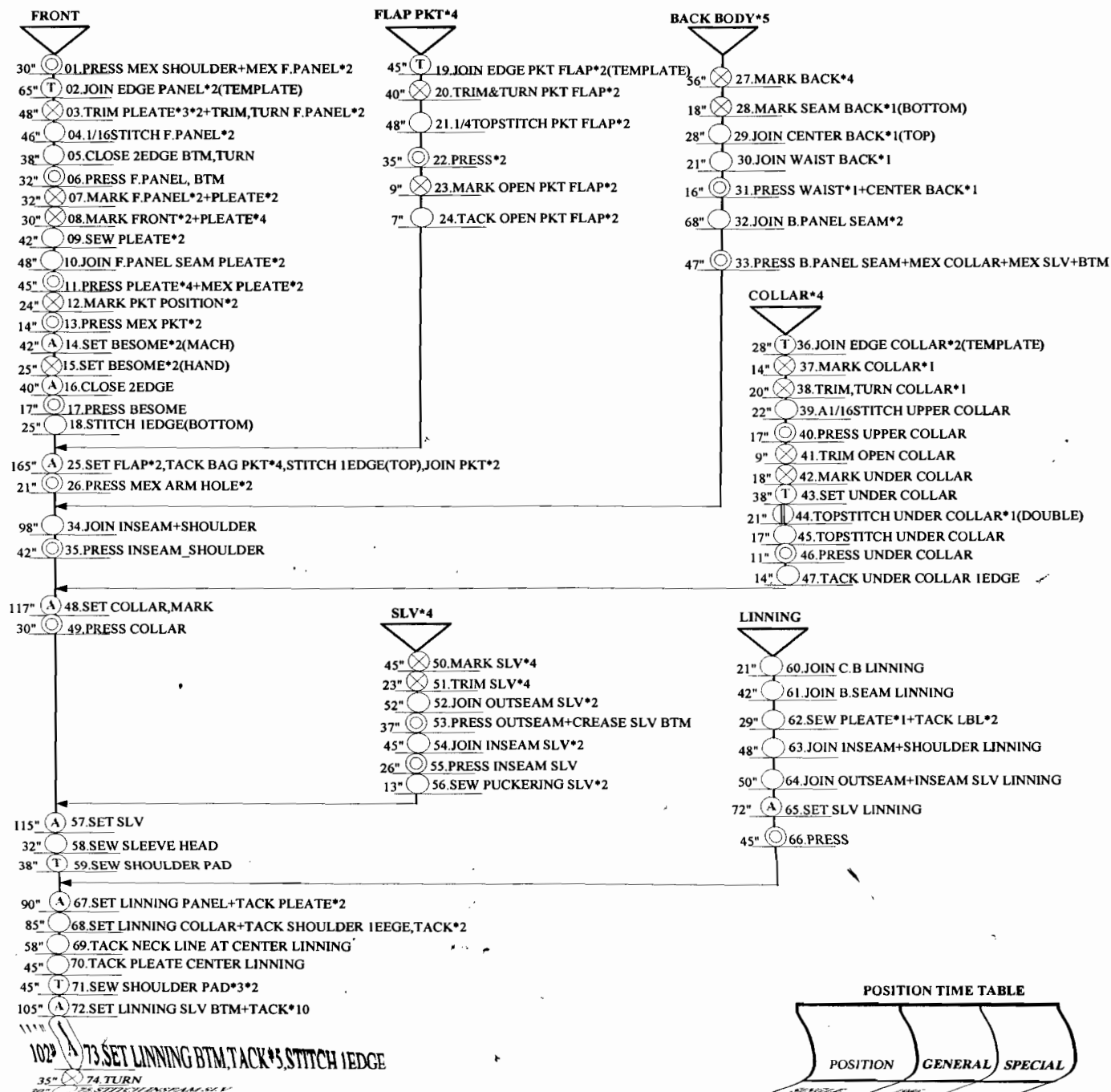
1. 由越南廠的 IE 人員，依據上線款式，製作工程表及時間初估表。
2. 經越南廠生產部會商研究後，由生產主管提出效率建議與工程改善說明。並簽字
3. 經越南廠總經理核實後，將文件呈送臺北公司做最後核可。
4. 依臺北公司核可之 IE 數據後，作為越南廠的效率評估與績效獎金標準。

款式: G16-180B	款式說明 LADIE JACKET 订单 13.875	制表人 THAO	日期: 2016/06/20	文件編號:
參考雷同款:				
生產車縫時間 2933	特車組 30	總時間:3243		
生產出數: 9.82	特車組出 92.9	IE 總出數: 8.8		

PPIC 主管:



FLOW CHART OF G16-180B



POSITION TIME TABLE

POSITION	GENERAL	SPECIAL

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

STYLE N G16-180B
DATE: 20/6/2016

TAIPEI IE OUTPUT:
VN IE OUTPUT:

9.82

工段號碼 Mã công	工段名稱 Tên công đoạn	等級 Cấp	合縫記号	使用機器	時間 Thời gian	金額 Đơn giá	日產量 Sản lượng	使用 配件 及其
	<i>Front body</i>							
	<i>Thân trước</i>							
01	Press mex shoulder+mex F. panel*2	C		HAND	30	222.6	960	
02	Join edge panel*2(template)	B		SPECIAL	65	518.1	443	
03	Trim pleat*3*2+trim,turn F. panel*2	C		HAND	48	356.2	600	
04	1/16Stitch F. panel *2	B		SINGLE	46	366.6	626	
05	Close 2edge btm+turn	B		SINGLE	38	302.9	758	
06	Press F.panel,btm	B		PRESS	32	255.0	900	
07	Mark F. panel *2+pleat*2	C		HAND	32	237.4	900	
08	Mark front*2+pleat*2*2	C		HAND	30	222.6	960	
09	Sew pleate*2	B		SINGLE	42	334.7	686	
10	Join F.panel seam pleat*2(bottom)	B		SINGLE	48	382.6	600	
11	Press pleat*4+,mex pleat*2	B		PRESS	45	358.7	640	
12	Mark pkt position*2	C		HAND	24	178.1	1200	
13	Press mex at pkt*2	B		PRESS	14	111.6	2057	
14	Set besom*2(mach)	B		SPECIAL	42	334.7	686	
15	Set besom*2(hand)	C		HAND	25	185.5	1152	
16	Close 2edge*2	A		SINGLE	40	334.8	720	
17	Press besom*2	B		PRESS	17	135.5	1694	
18	Stitch 1edge*2	B		SINGLE	25	199.3	1152	
19	Set pkt flap,tack bag pkt*4,stitch 1 edge(top),join pkt*2	A		SINGLE	165	1381.1	175	
20	Press mex arm hole*2	B		PRESS	21	167.4	1371	
21	Join inseam+shoulder	B		SINGLE	98	781.1	294	
22	Press inseam+shoulder	B		PRESS	42	334.7	686	
23	Set collar,mark	A		SINGLE	117	979.3	246	
24	Press collar	B		SINGLE	30	239.1	960	
25	Set siv	A		SINGLE	115	962.6	250	
26	Sew sleeve head	B		SINGLE	32	255.0	900	
27	Sew shoulder pad	B		SPECIAL	38	302.9	758	
28	Set lining panel+tack pleat*2	A		SINGLE	90	753.3	320	
29	Set lining collar+tack shoulder1edge,tack*2	B		SINGLE	85	677.5	339	
30	Tack neckline at center lining	B		SINGLE	58	462.3	497	
31	Tack pleate center lining*2	B		SINGLE	45	358.7	640	
32	Sew shoulder pad*3*2	C		HAND SCL	45	333.9	640	
33	Set lining siv btm+tack*10	A		SINGLE	105	878.9	274	
34	Set lining btm,tack*5,stitch 1edge	A		SINGLE	102	853.7	282	
35	Turn	C		HAND	35	259.7	823	
36	Stitch inseam siv	B		SINGLE	30	239.1	960	
XZ	Trim thread	C		HAND	85	630.7	339	
001	Mark hole*3	C		HAND SCL	19	141.0	1516	
002	Sew hole*3,bartack*3	B		SPECIAL	28	223.2	1029	
	<i>Flap pkt*4</i>							
	<i>Nắp túi*4</i>							
A01	Join edge pkt flap*2(template)	B		SPECIAL	45	358.7	640	
A02	Trim&turn pkt flap*2	C		HAND	40	296.8	720	
A03	1/4Topstitch pkt flap*2	B		SINGLE	48	382.6	600	
A04	Press*2	B		PRESS	35	279.0	823	
A05	Mark open pkt flap*2	C		HAND	9	66.8	3200	
A06	Tack open pkt flap*2	B		SINGLE	7	55.8	4114	
	<i>Back body*5</i>							
	<i>Thân sau*5</i>							
	Mark back*4							
	Thân trên							

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

STYLE N G16-180B
DATE: 20/6/2016

TAIPEI IE OUTPUT:
VN IE OUTPUT:

9.82

工段號碼 Mã công	工段名稱 Tên công đoạn	等級 Cấp	合縫記号	使用機器	時間 Thời gian	金額 Đơn giá	日產量 Sản lượng	使用 配件及基
B06	Join B.panel seam*2	Can chắp sườn TS*2	B	SINGLE	68	542.0	424	
B07	Press B.panel seam+mex at collar+mex slv+btm	Là rẽ sườn+méch vòng cổ TS, là méch vn TS+gấp gấu	B	PRESS	47	374.6	613	
	Slv*4	Tay*4						
C01	Mark slv*4	SD tay*4	C	HAND	45	333.9	640	
C02	Trim slv*4	Chém tay*4	C	HAND	23	170.7	1252	
C03	Join outseam slv*2	Can chắp sườn tay*2	B	SINGLE	52	414.4	554	
C04	Press outseam+crease slv btm	Là rẽ sườn tay + gấp tay	B	PRESS	37	294.9	778	
C05	Join inseam slv*2	Quay tròn tay	B	SINGLE	45	358.7	640	
C06	Press inseam slv	Là rẽ quay tròn tay	B	PRESS	26	207.2	1108	
C07	Sew puckering slv*2	Máy dùm tay	B	SINGLE	13	103.6	2215	
	Collar*4	Cổ*4						
D01	Join edge collar*2(template)	Can chắp sống cổ *2(bìa mẫu)	B	SPECIAL	28	223.2	1029	
D02	Mark collar*1	SD cổ*1	C	HAND	14	103.9	2057	
D03	Trim,turn collar*1	Chém Sửa, lộn cổ	C	HAND	20	148.4	1440	
D04	1/16Stitch upper collar*1	Mí sống cổ tăng cường	B	SINGLE	22	175.3	1309	
D05	Press upper	Là sống cổ	B	PRESS	17	135.5	1694	
D06	Trim collar open*1	Chém miệng cổ	C	HAND	9	66.8	3200	
D07	Mark under collar*2	SD chân cổ*2	C	HAND	18	133.6	1600	
D08	Set under collar*2	Tra chân cổ	A	SINGLE	38	318.1	758	
D09	Topstitch under collar*1(double)	Điều chân cổ 2 kim*1	B	DOUBLE	21	167.4	1371	
D10	Topstitch under collar*1	Điều chân cổ 1 kim*1	B	SINGLE	17	135.5	1694	
D11	Press under collar*2	Là chân cổ*2	B	PRESS	11	87.7	2618	
D12	Tack under collar 1edge	Ghim chân cổ 1 đoạn	B	SINGLE	14	111.6	2057	
	Lining	Lót						
E01	Join C.B lining	Can chắp giữa sau lót	B	SINGLE	21	167.4	1371	
E02	Join B.seam lining	Can chắp sườn TS lót	B	SINGLE	42	334.7	686	
E03	Sew pleat*1+tack lbl*2	Máy ly TS*1+ghim mác*2	B	SINGLE	29	231.1	993	
E04	Join inseam+shoulder lining	Can chắp sườn+ vai lót	B	SINGLE	48	382.6	600	
E05	Join outseam +inseam slv lining	Can chắp sống tay, tròn tay lót	B	SINGLE	50	398.5	576	
E06	Set slv lining	Tra tay lót	A	SINGLE	72	602.6	400	
E07	Press	Là lót	B	PRESS	45	358.7	640	
	TOTAL				3243	25,841	8.88	



作業別 Công đoạn	車縫(秒) Chuyên may	穿車(秒) Chuyên môn		
Single	1946			
Double	21			
Special	0	246		
Press	405			
Hand	561	64		
Amount	2933	310		
Output	9.82	92.9		
Total	3243		Out	8.88