

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: G16-259S	款式說 LADIES SKIRT 订单 600	制表人 THAO	日期: 2016/09/29	文件編號:
參考雷同款:				
生產車縫時間 1709	特車組 30	總時間:1739		
生產出數:16.85	特車組出 960.0	IE 總出數:16.56		

PPIC 主管:



FLOW CHART OF G16-259S**FRONT**

- 35" 1. MARK FRONT*3+PLEATE*2
 30" 2. SEW PLEATE*2
 12" 3. PRESS PLEAT*2
 25" 4. 1/8 TOPSTITCH PLEATE*2
 22" 5. SERGE FRONT*2
 32" 6. PIPING FRONT*2
 54" 7. JOIN FRONT SEAM*2
 38" 8. SERGE FRONT SEAM*2
 50" 9. 1/8 TOPSTITCH FRONT SEAM*2
 28" 10. PRESS SEAM+CREASE BTM

- 50" 24. JOIN OUTSEAM
 24" 25. PRESS OUTSEAM*2
 28" 26. PIPING W. BAND
 55" A 27. SET ZIPPER, MARK
 65" A 28. SET LINING ZIPPER, CLOSE

- 55" A 42. SET W. BAND, MARK
 25" 43. 1/16 STITCH UPPER W. BAND
 20" 44. CREASE UPPER W. BAND
 30" 45. CLOSE 2 EDGE BAND+TURN
 60" A 46. SET LINING VENT, MARK
 25" 47. SERGE AROUND BTM
 65" A 48. BLIND BTM
 18" 49. TACK TAPE*2
 65" 50. TRIM&TURN

- 30" 001. SEW HOLE W. BAND+VENT

BACK BODY*4

- 40" 11. MARK BACK*4+PLEATE*2
 30" 12. SEW PLEATE*2
 12" 13. PRESS PLEATE*2
 25" 14. 1/8 TOPSTITCH PLEATE*2
 42" 15. SERGE BACK*2*2
 30" 16. PIPING BACK*2
 54" 17. JOIN BACK SEAM*2
 38" 18. SERGE BACK SEAM*2
 50" 19. 1/8 TOPSTITCH BACK SEAM*2
 30" 20. JOIN C.B AT UNDER VENT
 48" 21. 1/8 TOPSTITCH C.B+VENT*2
 42" 22. CLOSE, TURN VENT*2
 32" 23. PRESS C.B+VENT+CREASE BTM

LINING

- 18" 29. SERGE C.B ZIPPER+VENT
 12" 30. JOIN 1 EDGE UNDER ZIPPER
 10" 31. TACK LBL AT SEAM*1
 20" 32. SEFTY C.B*1
 32" 33. SEFTY OUTSEAM*
 16" 34. SEW BTM TAPE+MARK+CL
 60" 35. FOLDSTITCH BTM+TACK TAPE*2
 17" 36. PRESS

W. BAND*2(AT INSIDE)

- 22" 37. MARK BAND*1
 8" 38. JOIN BAND*1
 8" 39. PRESS JOIN*1
 30" 40. SEW LBL AT SIZE TO LBL MAIN, SEW LBL AT BAND
 70" A 41. SET LINING W. BAND+TACK PLEAT*4*4

**POSITION TIME TABLE**

POSITION	GENERAL	SPECIAL
SINGLE	1159	
DOUBLE	0	
CHAIN STITCH	0	
KANSAI	0	
SPECIAL	235	0
PRESS	153	
HAND	162	30
AMOUNT	1709	30
OUTPUT PCS	16.85	960.0
TOTAL TIME	1739	TOTAL OUTPUT 16.56

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

6STYLE NO:AP16-259S
DATE: 2016-09-29

TAIPEI IE OUTPUT:
VN IE OUTPUT: 16.85

# step Mã công đoạn	Step name Tên công đoạn		Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件 及其他
01	Mark front*2	SD TT*3+ly*2	C		HAND	35	259.7	800	
02	Sew pleate*2	May ly TT*2	B		SINGLE	30	239.1	933	
03	Press pleate*2	Là ly TT*2	B		PRESS	12	95.6	2333	
04	1/8Topstitch pleate*2	1/8Điều ly TT*2	B		SINGLE	25	199.3	1120	
05	Serge front*2	VS 3C TT*2	B		SW	22	175.3	1273	
06	Piping front*2	Cuốn viền TT*2	B		SINGLE	32	255.0	875	
07	Join front seam*2	Can chập sườn TT*2	B		SINGLE	54	430.4	519	
08	Serge front seam*2	VS 3C sườn TT*2	B		SW	38	302.9	737	
09	1/8Topstitch front seam*2	Điều sườn TT 1/8*2	B		SINGLE	50	398.5	560	
10	Press seam+crease btm	Là sườn TT*2+gấp gấu	B		PRESS	28	223.2	1000	
11	Join out seam*2	Can chập dọc váy*2	B		SINGLE	50	398.5	560	
12	Press out seam*2	Là rẽ dọc váy	B		PRESS	24	191.3	1167	
13	Piping w.band	Cuốn viền cạp	B		SINGLE	28	223.2	1000	
14	Set zipper,mark	Tra khóa,sd	A		SINGLE	50	418.5	560	
15	Piping at zipper end	Cuốn viền đuôi khóa	B		SINGLE	7	55.8	4000	
16	Set lining zipper,close	Lồng lót khóa+chặn viền khóa	A		SINGLE	65	544.1	431	
17	Set w.band,mark	Tra cạp,sd,	A		SINGLE	55	460.4	509	
18	1/16Stitch upper w.band	Mí sống cạp 1/16	B		SINGLE	25	199.3	1120	
19	Crease upper w.band	Là gấp sống cạp	B		PRESS	20	159.4	1400	
20	Close 2edge band+turn	Chặn lộn 2 đầu cạp	B		SINGLE	30	239.1	933	
21	Set lining vent,mark	Lồng lót sê,sd	A		SINGLE	60	502.2	467	
22	Serge around btm	VS 3C xung quanh gấu	B		SW	25	199.3	1120	
23	Blind btm	Vắt gấu váy	A		SINGLE	65	544.1	431	
24	Tack tape*2	Ghim dây gấu *2	B		SINGLE	18	143.5	1556	
XZ	Trim&turn	Cắt chỉ,lộn váy	C		HAND	65	482.3	431	
001	Sew hook&eye*2,vent	Khâu khuy móc cạp *2,sê	C		HAND SCL	30	222.6	933	
	Back body*4	Thân sau*4					FALSE	#DIV/0!	
A01	Mark back*4+ pleate*2	SD TS*4 + ly TS*2	C		HAND	40	296.8	700	
A02	Sew pleate*2	May ly TS*2	B		SINGLE	30	239.1	933	
A03	Press pleate*2	Là ly TS*2	B		PRESS	12	95.6	2333	
A04	1/8Topstitch pleate*2	Điều ly TS 1/8*2	B		SINGLE	25	199.3	1120	
A05	Serge back*2 *2	VS 3C TS*2 *2	B		SW	42	334.7	667	
A06	Piping back*2	Cuốn viền TS*2	B		SINGLE	30	239.1	933	
A07	Join back seam*2	Can chập sườn TS*2	B		SINGLE	54	430.4	519	

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

6STYLE NO:AP16-259S
DATE: 2016-09-29

TAIPEI IE OUTPUT:
VN IE OUTPUT: 16.85

# step Mã công đoạn	Step name Tên công đoạn		Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sản lượng	使用配件 及其他
A08	Serge back searn*2	VS 3C sườn TS*2	B		SW	38	302.9	737	
A09	1/8Topstitch back seam*2	Điều sườn TS 1/8*2	B		SINGLE	50	398.5	560	
A10	Join C.B at under vent	Cán chắp giữa sau	B		SINGLE	30	239.1	933	
A11	Topstitch C.B+vent*2	1/8 Điều giữa sau+sẻ(2lần)	B		SINGLE	48	382.6	583	
A12	Close ,turn vent*2	Chặn ,lộn sẻ TS*2	B		SINGLE	42	334.7	667	
A13	Press C.B+vent+crease btm	Là rẽ giữa sau+gấp gấu+sẻ	B		PRESS	32	255.0	875	
	W.band*2(at inside)	Cạp *2(bên trong)					FALSE	#DIV/0!	
B01	Mark band*2	SD cạp*2	C		HAND	22	163.2	1273	
B02	Join band*1	Cán cạp*1	B		SINGLE	8	63.8	3500	
B03	Press join*1	Là rẽ đường cán*1	B		PRESS	8	63.8	3500	
B04	Sew lbl at zise to lbl main,sew lbl at band	May móc cỡ vào móc chính,may móc vào cạp	B		SINGLE	30	239.1	933	
B05	Set lining w.band+tack pleat*4*4	Lồng lót cạp+ghim lỵ*4*4	A		SINGLE	70	585.9	400	
	Linning	Lót					FALSE	#DIV/0!	
C01	Serge C.B zipper+vent	VS 3C giữa sau lót khóa+sẻ sau	B		SW	18	143.5	1556	
C02	Join 1edge underset zipper	Cán chắp dưới khóa 1 đoạn	B		SINGLE	12	95.6	2333	
C03	Tack lbl at seam*1	Ghim móc vào sườn lót*1	B		SINGLE	10	79.7	2800	
C04	Sefety C.B *1	VS 5C giữa sau lót*1	B		SW	20	159.4	1400	
C05	Sefety outseam*2	VS 5C dọc lót	B		SW	32	FALSE	875	
C06	Sew btm tape+mark+cut*2	May dây gấu, sd, cắt, buộc*2	B		SINGLE	16	127.5	1750	
C07	Foldstitch btm+tack tape*2	Điều gấp gấu lót+đặt dây gấu*2	B		SINGLE	60	478.2	467	
C08	Press	Là lót	B		PRESS	17	135.5	1647	
Total						1739	13645	16.56	
			Position	GENERAL	SPECIAL				
			Single	1159					
			Special	235	0				
			Press	153					
			Hand	162	30				
			Amount	1709	30				
			Output pcs	16.85	960.0				
			Total time	1739		Total out put Tổng		16.56	

製表人: THAO