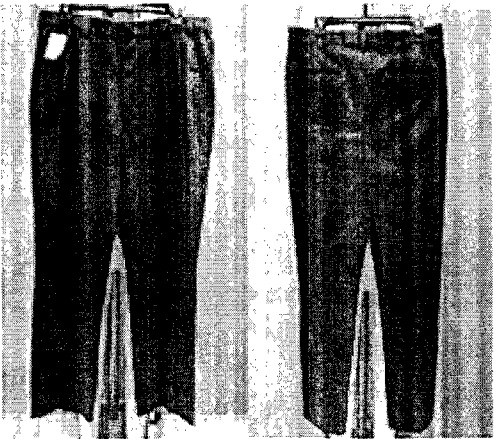


福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-262P	款式說 LADIES PANTS 订单 6.940	制表人 THAO	日期: 2016/09/08	文件編號:
參考雷同款:				
生產車縫時間 2104	特車組 1118	總時間:2222		
生產出數:13.69	特車組出 244.07	IE 總出數: 13.0		

PPIC 主管:

15/9/16

FLOW CHART OF G16-262P**W.BAND*4**

- 22" 51. MARK*2
8" 52. MARK HOLE AT BAND*1 POSITION
14" 53. SEW HOLE*1
30" 54. JOIN 1EDGE*2 (TEMPLE)
38" 55. JOIN W.BAND*3 (TACK 1EDGE+CLOSE, TURN (AT LEFT))
24" 56. PRESS JOIN+CREASE
22" 57. 1/16 STITCH UPPER BAND
18" 58. PRESS UPPER BAND

FRONT

- 40" 1. MARK FRONT+PKT POSITION*2
50" 2. SEW PLEATE*2*2
32" 3. PRESS PLEAT*4+MEX PKT*2
20" 4. SERGE FACING*2*2
52" 5. STITCH+TACK BAG TO FACING*4
22" 6. JOIN PKT OPEN*2 (TACK BAG+BESOM)
22" 7. 1/16 STITCH PKT OPEN*2
17" 8. PRESS PKT OPEN
42" 9. JOIN BAG*2
10" 10. TURN*2
38" 11. TOPSTITCH BAG*2
35" 12. TACK PKT UPPER AND UNDER*2
26" 13. TACK BAG TO PKT TO SEAM+TACK BAND
24" 14. SERGE FRONT+BACK RISE

BACK BODY*2

- 40" 15. MARK BACK+PLEAT*2*2
48" 16. CLOSE PLEAT*2*2
20" 17. SERGE FACING*4
13" 18. MARK PKT POSITION*2
28" 19. PRESS PLEATE*4+FUSE PKT*2
54" 20. SET BESOM*2 (MACH)
25" 21. SET BESOM*2 (HAND)
40" 22. CLOSE 2EDGE*2
17" 23. PRESS PKT OPEN*2
22" 24. STITCH 1EDGE UNDER
50" 25. STITCH PKT FACING TO BAG*4, MARK
46" 26. JOIN BAG*2
11" 27. TURN BAG*2
50" 28. STITCH BAG*2
36" 29. 1/16 STITCH AT PKT LIP 3 UNDER*2
22" 30. TACK PKT OPEN*2
18" 31. TACK BAG TO W.BAND

- 60" 32. SEFETY OUT SEAM
25" 33. PRESS INSEAM
24" 34. SERGE BTM
65" 35. STITCH OUTSEAM
50" 36. SEFETY INSEAM
20" 37. PRESS INSEAM
55" 38. 1/4 TOPSTITCH INSEAM
47" 39. JOIN FRONT+BACK RISE (CHAIN STITCH)
23" 40. JOIN FLY, STITCH
15" 41. CREASE FLY+RISE

ZIPPER FACING*2

- 12" 42. CLOSE 1EDGE ZIPPER FACING
7" 43. TURN*1
12" 44. PRESS
15" 45. SERGE ZIPPER FACING+FLY
16" 46. TACK ZIPPER TO ZIPPER FACING+CLOSE

- 38" 47. SET ZIPPER, MARK
16" 48. JOIN BELT LOOP+SEW BELT LOOP*8
8" 49. MARK+ CUT BELT LOOP*8
55" 50. SET BELT LOOP*8, MARK
31" 59. SET W.BAND, MARK
13" 60. TURN AFTER SET W.BAND
25" 61. CLOSE 1EDGE BAND+TURN (AT RIGHT)
10" 62. TACK LBL SIZE AT W.BAND*1
82" 63. 1/16 FOLD STITCH UNDER W.BAND
45" 64. TOPSTITCH FLY+CLOSE*2
63" 65. CLOSE BELT LOOP*8*2
14" 66. TACK LBL AT OUT SEAM*2
70" 67. BLIND BTM
90" 68. TRIM THREAD



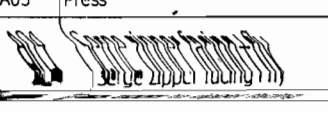
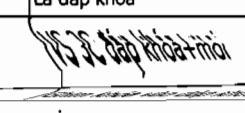
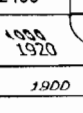
POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	1341	
KANSAI	16	
CHAIN STITCH	47	
SPECIAL	213	110
PRESS	208	
HAND	279	8
AMOUNT	2104	118
OUTPUT PCS	13.69	244.07
TOTAL TIME	2222	TOTAL OUTPUT 13

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

STYLE NO: G16-262P
DATE: 2016-09-08

TAIPEI IE OUTPUT:
VN IE OUTPU 13.69

# OP NO Mã công đoạn	Operation Tên công đoạn		Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sàn lượng	使用配件及 其他
01	Mark front+pkt posititon*2	SD TT+vị trí túi*2	C		HAND	40	296.8	720	
02	Sew pleate*2*2	May lỵ TT*2*2	B		SINGLE	50	398.5	576	
03	Press pleat*4+mex pkt*2	Là lỵ*4+mex miệng túi TT*2	B		PRESS	32	255.0	900	
04	Serge facing*2*2	VS 3C đắp túi*2*2	B		SW	20	159.4	1440	
05	Stitch bag to facing*2*2	Mí lót vào đắp túi*4	B		SINGLE	52	414.4	554	
06	Join pkt open*2(tack bag+besom)	Can chắp miệng túi*2(đặt cơi+lót)	B		SINGLE	42	334.7	686	
07	1/16Stitch pkt open*2	Mí tăng cường miệng túi ngoài*2	B		SINGLE	22	175.3	1309	
08	Press pkt open*2	Là miệng túi trước*2	B		PRESS	17	135.5	1694	
09	Join bag*2	Quay lót túi*2	B		SINGLE	42	334.7	686	
10	Turn bag*2	Lộn túi*2	C		HAND	10	74.2	2880	
11	1/4Topstitch bag*2	Điều đít túi 1/4*2	B		SINGLE	38	302.9	758	
12	Tack pkt to upper and under*2	Ghim miệng túi trên dưới *2	B		SINGLE	35	279.0	823	
13	Tack bag pkt to seam+tack band+seam	Ghim túi trên cạp+sườn	B		SINGLE	26	207.2	1108	
14	Serge front+back rise	VS 3C đứng TT+TS	B		SW	24	191.3	1200	
15	Safety out seam	VS 5C dọc quần	B		SW	60	478.2	480	
16	Press outseam	Là lật dọc quần	B		PRESS	25	199.3	1152	
17	Serge btm	VS 3C gấu	B		SW	24	191.3	1200	
18	Stitch outseam	Mí dọc quần	B		SINGLE	65	518.1	443	
19	Safetyinseam	VS 5C giàng quần	B		SW	50	398.5	576	
20	Press inseam	Là lật giàng quần	B		PRESS	20	159.4	1440	
21	1/4Topstitch inseam*2	Điều giàng quần 1/4*2	B		SINGLE	55	438.4	524	
22	Join front+back rise(chain stitch)	Chấp đứng TT+TS(chỉ tết)	B		CHAIN STITCH	47	374.6	613	
23	Join fly, stitch	Can chắp moi+mí	B		SINGLE	23	183.3	1252	
24	Crease fly, rise	Là gập moi, là đứng	B		PRESS	15	119.6	1920	
25	Set zipper, mark	Tra khóa, sd	A		SINGLE	38	318.1	758	
26	Join belt loop+sew belt loop*8	Can đĩa+máy đĩa*8	B		KANSAI	16	127.5	1800	
27	Mark+cut belt loop*8	SD+cắt đĩa*8	C		HAND	8	59.4	3600	
28	Set belt loop*8, mark	Tra đĩa, sd*8	B		SINGLE	55	438.4	524	
29	Set w.band, mark	Tra cạp, sd	A		SINGLE	81	678.0	356	
30	Trim after set w.band	Chém cạp sau khi tra	C		HAND	13	96.5	2215	
31	Close 1 edge band+turn(at right)	Chặn đầu cạp, lộn (bên phải)	B		SINGLE	25	199.3	1152	
32	Tack lbl size at w.band*1	Ghim mác vào cạp*1	B		SINGLE	10	79.7	2880	
33	1/16Foldstitch under w.band	Gập mí/16 chân cạp	A		SINGLE	82	686.3	351	
34	Topstitch fly+close fly*2	Điều moi khóa 1 kim+chặn moi*2	B		SINGLE	45	358.7	640	
35	Close belt loop*8*2	Chặn đĩa trên, dưới*8*2	B		SINGLE	63	502.1	457	
36	Tack lbl at outseam*1	Ghim mác sườn*1	B		SINGLE	14	111.6	2057	
37	Foldstitch btm	Vắt gấu	A		SINGLE	70	585.9	411	
XZ	Trim thread	Cắt chỉ	C		HAND	90	667.8	320	
	Zipper facing*2	Đắp khóa*2					FALSE	#DIV/0!	
A01	Join zipper facing*2	Can chắp đắp khóa(bìa mẫu)	B		SPECIAL	12	95.6	2400	
A02	Turn	Lộn đắp khóa	C		HAND	7	51.9	4114	
A03	Press	Là đắp khóa	B		PRESS	12	95.6	2400	
									
					SINGLE	16	127.5	1800	

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

STYLE NO: G16-262P
DATE: 2016-09-08

TAIPEI IE OUTPUT:
VN IE OUTPU 13.69

# OP NO Mã công đoạn	Operation Tên công đoạn		Grade Cấp	合縫記號	使用機器	time Thời gian	price Đơn giá	out put Sàn lượng	使用配件及 其他
	Back body*2	Thân sau*2					FALSE	#DIV/0!	
B01	Mark back+pleat*2*2	SD TS+ly TS*2*2	C		HAND	40	296.8	720	
B02	Close pleat*2*2	May ly TS*2*2	B		SINGLE	48	382.6	600	
B03	Serge facing*2*2	VS 3C đáp túi sau*2*2	B		SW	20	159.4	1440	
B04	Mark pkt position*2	SD vị trí túi sau*2	C		HAND	13	96.5	2215	
B05	Press pleat*4+Fuse pkt*2	Là ly*4+mex vào vị trí túi*2	B		PRESS	28	223.2	1029	
B06	Set besom*2(mach)	Bổ túi bằng máy*2	B		SPECIAL	54	430.4	533	
B07	Set besom*2(hand)	Bổ túi bằng tay*2	C		HAND	25	185.5	1152	
B08	Close 2edge*2	Chặn 2 đầu coi túi*2	A		SINGLE	40	334.8	720	
B09	Press pkt open*2	Là miệng coi túi sau*2	B		PRESS	17	135.5	1694	
B10	Stitch 1edge under	Mí cạnh dưới*2	B		SINGLE	22	175.3	1309	
B11	Stitch pkt facing to bag*2*2,mark	Mí đáp túi vào lót*2*2,sd	B		SINGLE	50	398.5	576	
B12	Join bag,turn	Quây tròn túi	B		SINGLE	46	366.6	626	
B13	Turn bag*2	Lộn túi*2	C		HAND	11	81.6	2618	
B14	Stitch bag*2	Mí đáy túi*2	B		SINGLE	50	398.5	576	
B15	1/16 stitch at pkt lip 3 under*2	Mí 3 cạnh coi túi*2	A		SINGLE	36	301.3	800	
B16	Tack pkt open*2	Ghim kín miệng túi*2	B		SINGLE	22	175.3	1309	
B17	Tack bag to w.band	Ghim túi trên cạp	B		SINGLE	18	143.5	1600	
	W.band*4	Cạp*4					FALSE	#DIV/0!	
C01	Mark band*2	SD cạp *2	C		HAND	22	163.2	1309	
C02	Mark hole at band*1 posititon	SD thừa khuyết cạp*2	C		HANDSCL	8	59.4	3600	
C03	Sew hole*1	Thừa khuyết*2	B		SPECIAL	14	111.6	2057	
C04	Join 1edge(temple)	Cán chập sống cạp*2(theo mẫu)	B		SPECIAL	30	239.1	960	
C05	Join w.band *3+close 1edge(at left)	Cán cạp*3+cán sống 1 đoạn+chấn 1 đầu cán trái	B		SINGLE	38	302.9	758	
C06	Press join+ crease band(at inside)	Là rẽ*1+là gấp cạp trong	B		PRESS	24	191.3	1200	
C07	1/16Stitch upper band	Mí sống cạp 1/16	B		SINGLE	22	175.3	1309	
C08	Press upper band	Là sống cạp	B		PRESS	18	143.5	1600	
TOTAL						2222	17690	13.0	



Position	GENERAL	SPECIAL		
Single	1341			
Chain Stitch	47			
Kansai	16			
Special	213	110		
Press	208			
Hand	279	8		
Amount	2104	118		
Output (pcs)	13.69	244.07		
Total time	2222		Total out out	13.0