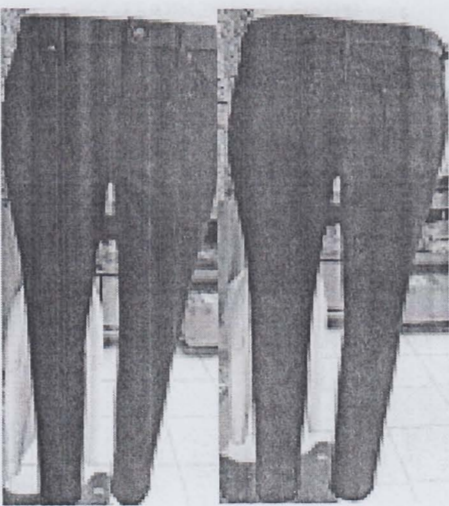
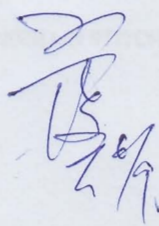


福星制衣越南廠 制衣工程 IE 出數核定流程表

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: G16-164P	款式說明 LADIE PANST 订单 26.292	制表人 THAO	日期: 2016/06/09	文件編號:
參考雷同款:				
生產車縫時間 2071	特車組時 310	總時間: 2381		
生產出數: 13.91	特車組出數 92.90	IE 總出數: 12.1		

PPIC 主管:



ITEM	QTY	UNIT	TIME
1	1	MIN	10
2	1	MIN	10
3	1	MIN	10
4	1	MIN	10
5	1	MIN	10
6	1	MIN	10
7	1	MIN	10
8	1	MIN	10
9	1	MIN	10
10	1	MIN	10
TOTAL	10	MIN	100

FLOW CHART OF G16-164P**W.BAND*5**

- 42" (T) 39. JOIN BAND*3 (TEMPLE)
 45" (X) 40. MARK BAND*3
 48" (O) 41. JOIN BAND CENTER*1
 (INSIDE)+BAND OUTSIDE
 17" (O) 42. PRESS JOIN*3
 21" (X) 43. TRIM BAND
 32" (O) 44. CREASE UNDER
 BAND (INSIDE)
 24" (O) 45. TACK UNDER
 BAND 1EDGE
 24" (O) 46. PRESS BAND

FRONT

- 40" (X) 1. MARK FRONT+PKT POSITION*2
 20" (X) 2. MARK PKT FACING*2+ATTACK PKT
 POSITION SMALL*1
 15" (O) 3. FOLDSTITCH PKT OPEN*1
 15" (O) 4. CREASE AROUND PKT*1 (SMALL)
 32" (O) 5. ATTACK TOPSTITCH PKT*1 (SMALL)
 35" (O) 6. SEFETY PKT FACING TO PKT OPEN*2
 14" (O) 7. PRESS SEFETY
 35" (O) 8. TOPSTITCH PKT OPEN*2 (DOUBLE)
 24" (O) 9. TACK PKT TO SEAM+BAND
 17" (O) 10. SERGE FRONT RISE
 54" (O) 22. SEFETY INSEAM
 58" (O) 23. 1/8. TOPSTITCH INSEAM
 64" (O) 24. SEFETY INSEAM
 34" (O) 25. STITCH OUTSEAM 1EDGE (UPPER)
 17" (O) 26. TACK FRONT RISE 1EDGE
 23" (O) 31. JOIN FLY, STITCH
 42" (A) 32. SET ZIPPER FACING, SMALL
 36" (O) 33. SEFETY FRONT+BACK RISE
 42" (O) 34. TOPSTITCH FRONT+BACK RISE (DOUBLE)
 32" (O) 35. TOPSTITCH FLY (DOUBLE)+CLOSE
 20" (O) 36. JOIN BELT LOOP*5+SEW BELT LOOP*5
 5" (X) 37. MARK+ CUT BELT LOOP*5
 54" (O) 38. SET BELT LOOP*5, MARK
 105" (A) 47. SET W. BAND, MARK
 32" (O) 48. TACK LBL AT W. BAND*2
 18" (O) 49. PRESS ESCLASTIC
 12" (X) 50. MARK+ CUT ESCLASTIC*1
 24" (O) 51. CLOSE ESCLASTIC*2EDGE
 46" (O) 52. TACK ESCLASTIC TO BAND
 65" (O) 53. CLOSE 2EDGE BAND+TURN
 150" (A) 54. 1/16 STITCH UNDER BAND+UPPER BAND*2 (CHAIN STITCH)
 65" (O) 55. CLOSE BELT LOOP UPPER+UNDER*5*2
 75" (A) 56. FOLDSTITCH HEM
 24" (O) 57. SEW LBL AT SIZE TO LBL
 AT MAIN+TACK LBL AT W. BAND
 90" (X) 58. TRIM THREAD

BACK BODY*4

- 45" (X) 11. MARK BACK UPPER*2+ATTACK PKT POSITION
 20" (X) 12. MARK BACK UNDER*2
 14" (X) 13. MARK BACK FACING YOKE*2
 24" (O) 14. SERGE BACK UPPER*2+SERGE BACK UNDER*2
 35" (O) 15. FOLDSTITCH PKT OPEN*2
 36" (O) 16. CREASE AROUND PKT*2
 120" (A) 17. ATTACK TOPSTITCH PKT*2 (DOUBLE)
 26" (O) 18. JOIN FACING YOKE TO BACK (SEFETY)
 28" (O) 19. TOPSTITCH FACING YOKE TO BACK (DOUBLE)
 34" (O) 20. JOIN BACK UPPER+BACK UNDER
 16" (O) 21. PRESS JOIN*2

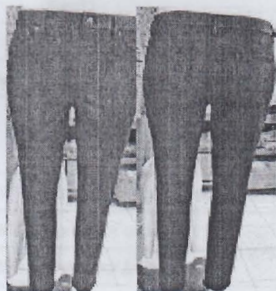
ZIPPER FACING*2

- 12" (T) 27. JOIN ZIPPER FACING*2
 5" (X) 28. TRIM & TURN
 10" (O) 29. PRESS
 14" (O) 30. STITCH ZIPPER FACING

- 120" (O) 001. SEW F. PKT HOLE*5+B. PKT*4
 35" (O) 002. SEW HOLE BAND*1+BTN*1
 101" (O) 003. BARTACK FLY*1+BELT LOOP*5*2

POSITION TIME TABLE

POSITION	GENERAL	SPECIAL
SINGLE	925	
KANSAI	20	
DOUBLE	289	
CHAIN STITCH	150	
SPECIAL	244	310
PRESS	126	
HAND	317	0
AMOUNT	2071	310
OUTPUT PCS	13.91	92.90
TOTAL TIME	2381	TOTAL OUTPUT 12.1



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

STYLE NO: G16-164
DATE: 2016-06-09

TAIPEI IE OUTPUT:
VN IE OUTPUT: 13.91

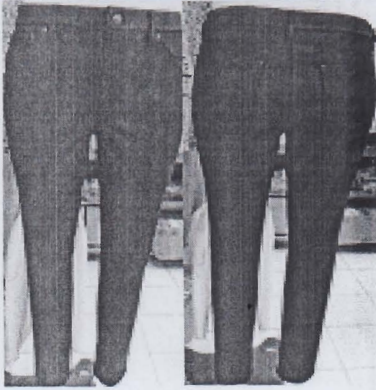
# of NO Mã công	Operation Tên công đoạn		Grade Cấp	合縫記號	Operation	time Thời gian	price Đơn	out put Sản lượng	使用配件 及其他
01	Mark front+pkt position*2	SD TT+vị trí túi*2	C		HAND	40	296.8	720	
02	Mark pkt facing *2+attack pkt position small*1	SD đắp túi trước*2+vị trí dán túi nhỏ*1	C		HAND	20	148.4	1440	
03	Foldstitch pkt open*1(small)	Gập diều miệng túi nhỏ*1	B		SINGLE	15	119.6	1920	
04	Crease around pkt*1(small)	Là gập xung quanh túi nhỏ*1	B		PRESS	15	119.6	1920	
05	Attack topstitch pkt*1(small)	Dán diều túi nhỏ*1(2kim)	A		DOUBLE	32	267.8	900	
06	Safety pkt facing to pkt open*2	VS 5c kẹp đắp túi vào miệng túi*2	B		SW	35	279.0	823	
07	Press safety	Là lật đường vs	B		PRESS	14	111.6	2057	
08	Topstitch pkt open*2(double)	Diều miệng túi*2(2kim)	B		DOUBLE	35	279.0	823	
09	Tack pkt to seam+band	Ghim túi trên sườn+cạp	B		SINGLE	24	191.3	1200	
10	Serge front rise	VS 3C đứng TT	B		SW	17	135.5	1694	
11	Safety inseam	VS 5C dăng quần	B		SW	54	430.4	533	
12	1/8Topstitch inseam	Diều dăng quần 1/8*2	B		SINGLE	58	462.3	497	
13	Safety out eam*2	VS 5C dọc quần*2	B		SW	64	510.1	450	
14	Stitch outseam 1edge(upper)	Mí dọc quần 1đoạn cạnh túi	B		SINGLE	34	271.0	847	
15	Tack front rise 1edge	Ghim đứng TT 1 đoạn	B		SINGLE	17	135.5	1694	
16	Join fly,stitch	Cán chắp moi+mí	B		SINGLE	23	183.3	1252	
17	Set zipper facing,mark	Tra đắp khóa,sd	A		SINGLE	42	351.5	686	
18	Safety front+ back rise	VS 5C đứng TT+TS	B		SW	36	286.9	800	
19	Topstitch front+back rise(double)	Diều đứng TT+TS(2kim)	B		DOUBLE	42	334.7	686	
20	Topstitch fly(double)+close	Diều moi 2kim(2kim)+chặn moi	B		DOUBLE	32	255.0	900	
21	Join belt loop+sew belt loop*5	Cán đĩa+máy đĩa*5	B		KANSAI	20	159.4	1440	
22	Mark+cut belt loop*5	SD+cắt đĩa*5	C		HAND	5	37.1	5760	
23	Set belt loop*5,mark	Tra đĩa,sd*5	B		SINGLE	54	430.4	533	
24	Set w.band,mark	Tra cạp,sd	A		SINGLE	105	878.9	274	
25	Tack lbl at w.band*2	Ghim móc cạp*2	B		SINGLE	34	271.0	847	
26	Press elastic*1	Là chun cạp*1	B		PRESS	18	143.5	1600	
27	Mark+cut elastic*1	SD+ cắt chun cạp*1	C		HAND	12	89.0	2400	
28	Close elastic*2edge	Chặn chun cạp 2đầu	B		SINGLE	24	191.3	1200	
29	Tack elastic to band	Ghim chun vào cạp	B		SINGLE	46	366.6	626	
30	Close 2edge band+turn	Chặn 2 đầu cạp +lộn	B		SINGLE	65	518.1	443	
31	Topstitch w.band upper+under	Diều vòng cạp trên+dưới	A		CHAIN STITCH	150	1255.5	192	
32	Close belt loop upper+under*5*2	Chặn đĩa trên dưới*5*2	B		SINGLE	65	518.1	443	
33	Foldstitch btm	Gập diều gấu	A		SINGLE	75	627.8	384	
34	Sew lbl at size to lbl at main+tack lbl at out seam	Ghim móc size vào móc ID+ghim móc sườn	B		SINGLE	24	191.3	1200	
XZ	Trim &turn	Cắt chỉ	C		HAND	90	667.8	320	
001	Sew F.pkt hole*5+B.pkt*4	Bổ khuy cúc miệng túi TT*5+túi sau*4	B		SPECIAL	120	956.4	240	
002	Sew hole band*1+btn*1	Bổ khuy*1+đính cúc cạp*1	B		SPECIAL	35	279.0	823	
003	Bartack fly*1+belt loop*5*2	Di bộ moi*1+đắp khóa*1+đĩa*5*2	B		SPECIAL	101	805.0	285	
	Zipper facing*2	Đắp khóa*2					FALSE	#DIV/0!	
A01	Join zipper facing*1(temple)	Cán chắp đắp khóa*1(bìa mẫu)	B		SPECIAL	12	95.6	2400	
A02	Turn*1	Lộn đắp khóa	C		HAND	5	37.1	5760	
A03	Press*1	Là đắp khóa	B		PRESS	10	79.7	2880	
A04	Serge zipper facing+fly	VS 3C đắp khóa+moi	B		SW	14	111.6	2057	
	Back body*4	Thân sau*4					FALSE	#DIV/0!	
B01	Mark back upper*2+attack pkt position*2	SD TS trên*2+vị trí dán túi*2	C		HAND	45	333.9	640	
B02	Mark back under*2	SD TS dưới*2	C		HAND	20	148.4	1440	
B03	Mark back facing yoke *2	SD đắp cầu mông TS*2	C		HAND	14	103.9	2057	
B04	Serge back upper*2+Serge back under*2	VS 3C TS trên*2+VS 3C TS dưới*2	B		SW	24	191.3	1200	

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

STYLE NO: G16-164
DATE: 2016-06-09

TAIPEI IE OUTPUT:
VN IE OUTPUT: 13.91

# of NO Mã công	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
B05	Foldstitch pkt open*2	Gập diều miệng túi*2	B		SINGLE	35	279.0	823	
B06	Crease around pkt*2	Là gập xung quanh túi*2	B		PRESS	36	286.9	800	
B07	Attack topstitch pkt*2(double)	Dán diều túi sau*2(2kim)	A		DOUBLE	120	1004.4	240	
B08	Join facing yoke to back(Safety)	Can chắp đáy cầu mông TS(VS 5C)	B		SINGLE	26	207.2	1108	
B09	Topstitch facing yoke to back*2(double)	Diều đáy cầu mông TS*2(2kim)	B		DOUBLE	28	223.2	1029	
B10	Join back upper+back under	Can chắp TS trên+TS dưới	B		SINGLE	34	271.0	847	
B11	Press join*2	Là rẽ đường can chắp*2	B		PRESS	16	127.5	1800	
	W.band*5	Cạp bo*5					FALSE	#DIV/0!	
C01	Join band*3(temple)	Can chắp sống cạp*2(theo mẫu)	B		SPECIAL	42	334.7	686	
C02	Mark band*3	SD cạp*3	C		HAND	45	333.9	640	
C03	Join band center*1(inside)+band outside*2	Can cạp trong*1+cạp ngoài*2	B		SINGLE	48	382.6	600	
C04	Press join*3	Là đường can*3	B		PRESS	17	135.5	1694	
C05	Trim band	Chém sửa sống cạp	C		HAND	21	155.8	1371	
C06	Crease under band(inside)	Là gập chân cạp trong	B		PRESS	32	255.0	900	
C07	Tack under band 1edge	Ghim cạp 1 đường	B		SINGLE	21	167.4	1371	
C08	Press band	Là sống cạp	B		PRESS	24	191.3	1200	
TOTAL						2381	19012	12.1	



Position	GENERAL	SPECIAL			
Single	925				
Kansai	20				
Double	289				
Chain Stitch	150				
Special	244	310			
Press	126				
Hand	317	0			
Amount	2071	310			
Output (pcs)	13.91	92.90			
Total time	2381		Total out put		12.1

製表人: THAO