SHAHI EXPORTS PRIVATE LIMITED eration Bulletin with Technical Data Sheet and Line Layout Document Code: SEW.OB Document Version: SEW.OB.1 ITEM - 659L LINE -21 Revision No. 1 Buver 14/07/22 Planned Efficiency 21192660400 TAILORS MACHINE SAM TARGET (100%) STYLE 42 40.92 493 BUYER RALPH LAUREN HELPERS MANUAL SAM 8.04 TARGET (80%) 394 DESC CTDIDE CUIDT CHECKEDS 2 TOTAL CAM 40.00 PCS/ MC (80%) ORD OTY TAKT TIME (SEC) 3650 1.17 THREAD (TEX) # of Work Statn MACHINE MAKE M/C Mode SPI NEEDL Bobbin/ SINo OPERATION DESCRIPTION SMV Targ/ Hr Operator Grade Machine Type FEED DOG Spring Needle Plate Presser Foot ne RPM TYPE SIZE 14-15 40 40 COLLAR RUN STITCH BY PROFILE DBX1 E-12 COLLAR MARJIN TRIM & TURN 0.32 188 Self Trim & Check STND GUAGE 1/A 2500 STND COLLAR & BAND P BAND HEM WITH INTER LINING 0.42 143 2500 DBX1 11 14-15 40 40 SNLS JUKI Self Trim & Check E-12 SP18 CR 3/16 TEFFLON Medium duty 5 COLLAR TOP STITCH 143 SNLS 0.5 Self Trim & Check E-12 SP18 CR 1/4 Medium duty 6 COLLAR & RAND & READY MAR IIN TRIM 0.45 133 SNEC 10 SIRUBA Self Trim & Check STND GUAGE 1/4 2500 STND COLLAR INTER LINING ATTACH 0.36 167 SNLS 1.0 JUKI Self Trim & Check Medium duty F-12 STND 2500 FINE DBX1 11 14-15 40 40 8 COLLAR BAND ATTACH WITH PICK MAKING SNLS Self Trim & Check 0.36 167 1.0 JUKI Medium duty E-12 STND 2500 FINE DBX1 11 14-15 40 40 10 CUFF HEM BY WATER SOLUBLE 0.55 109 SNLS 0.5 PPO Solf Trim & Chock Medium duty F-12 SP18 CR3/8 2500 FINE DBX1 11 14-15 11 CUFF MARGIN TRIM 0.30 200 SNEC 0.5 SIRUBA Self Trim & Check Medium duty STND GUAGE 1/4 2500 STND CUFF RUN STITCH BY PROFILE Self Trim & Check DBX1 11 14-15 40 40 1.00 IIIKI Medium duty ROLLER 2500 TEFFLON CHOING DACTE AT CLEEVE OF IT ADEA AND MADE 0.55 USE SCISSOR SLEEVE PLACKET MARK, MATCH & PRESS 16 SLEEVE BOTH PLACKET ATTACH 0.75 1.0 Self Trim & Check E-12 STND FINE DBX1 11 14-15 40 40 SNLS JUKI Medium duty 2500 SLEEVE BOTH PLACKET CUT AND EDGE STITCH 0.65 SNLS JUK Self Trim & Check E-12 CR1/32 E 2500 FINE DBX1 14-15 60 10 CLEEV DITTON DI ACKET CLIT 8 DEM CINICU 8 MA I DI ACKET CINICU 0.02 65 SNLS 1.0 IACK Solf Trim & Chock Medium duty F-12 CD4/22 2500 EINE DDV1 14 15 60 HEE SCIESOR 2500 19 SLEEVE TEMPLE MAKING & KALLPLACKET EDGE STITCH 1.25 SNIS 1.0 IIIKI Salf Trim & Chack Medium duty F-12 CR1/32 TEFFI ON DRY1 14-15 40 20 LOOP MAKING 1.25 SNLS BRO Self Trim & Check Medium duty E-12 CL 1/32 2500 FINE DBX1 14-15 60 21 BACK YOKE BOX MAKING WITH LOOP ATTACH 0.70 0.5 Self Trim & Chec 2500 ACRYLIC GUIDE E-12 22 BACK YOKE ATTACH WITH EDGE STITCH 0.05 62 CMIC 10 PPO Solf Trim & Chock Modium dut E 42 CD4/22 2500 ACRYLIC CHIDE CINIC DDV1 44 14 15 60 40 23 BACK YOKE O/I Salf Trim & Chack 0.68 3ТНО VAMATO Medium duty STND 2500 FINE DCX27 11 14-15 40 40 FRONT PLACKET TRIN 0.32 SIRUBA Self Trim & Check STND 2500 STND SNEC Medium duty MAIN LABLE MAKE MARK AND ATTACH 0.70 JUKI Self Trim & Check CR1/32 DBX1 11 14-15 40 24 TEFFLON 27 KAJ PLACKET ATTACH BY WATER SOLUBLE ( ONE SIDE ) CR1/32 ACRYLIC GUIDE 0.30 200 SNLS 1.0 JACK Self Trim & Check Medium duty E-12 2500 FINE DBX1 11 14-15 0.55 JACK Self Trim & Check SP18 CR1/4 TVX3 14 14-15 40 40 29 BUTTON PLACKET HEM F-12 11 14-15 40 0.50 120 SNLS 1.0 JACK Self Trim & Check Medium duty CL1/32 2500 ADJUSTING GUIDE FINE DBX1 30 SHOULDER ATTACH & TOP STITCH 1.07 56 Y B SNLS 1.0 JACK Self Trim & Check F-12 CR1/32 2500 ACRYLIC GUIDE FINE DBX1 11 14-15 60 40 Medium duty CORNER 33 POCKET HEM + NECK STAY STICH Y B Self Trim & Check 11 14-15 40 40 0.45 SNLS 1.0 JUKI F-12 CL 1/32 2500 DBX1 133 Medium duty FINE GUIDE 34 POCKET PROFILE 0.60 100 SNLS 0.5 PPO Self Trim & Check Medium duty E-12 ROLLER 2500 TEFFLON DBX1 11 14-15 40 POCKET MARGIN TRIN 0.32 188 SNEC 0.5 IIIKI Self Trim & Check Medium duty STND GUAGE 1/4 2500 STND Salf Trim & Chack 39 FLAP PROFILE 0.60 100 R SNIS 0.5 IIIKI Medium duty F-12 POLLER 2500 TEFFI ON DRY1 11 14-15 40 40 FLAP MARGIN TRI 0.60 SNEC SIRUBA Self Trim & Check 100 Medium duty STND FINE DBX1 14-15 FLAP ROUND STAY STITCH 0.85 SNLS Self Trim & Check STND DPX5 14-15 40 42 FLAP TOP STITCH 0.05 0.5 Self Trim & Check E-12 STND GUAGE 3/16 2500 DPX5 11 14-15 60 43 FLAP FINISH 0.85 71 Y B DNLS 1.0 SIRUBA Self Trim & Check Medium duty F-12 STND GUAGE 3/16 2500 FINE DPX5 11 14-15 60 40 0.40 150 N 47 SLEEVE INSIDE FINISH BY (DNLS) GUAGE 3/8 2500 0.85 DNLS SIRUBA Self Trim & Check Medium duty F-12 STND FINE DPX5 14-15 40 E-12 Medium duty 50 SIDE & BOTTOM TRIF 0.50 120 O/L JUKI Salf Trim & Charl 2500 PEGIII AR DCX27 F-12 11 14-15 40 51 SIDE ATTACH WITH HEA 1 20 50 SNIS 10 IIIKI Solf Trim & Chack Medium duty SP18CR 5/16 2500 FINE DRY1 40 WASH CARE LABEL ATTACH + SLEEVE OPENING PLEAT MAKING Self Trim & Check 0.45 133 SNLS E-12 FINE DBX1 14-15 40 1.0 JACK Medium duty STND 2500 11 CUFF ATTACH 0.68 88 Υ В SNLS 1.0 JUKI Self Trim & Check Medium duty E-12 STND 2500 FINE DBX1 11 14-15 40 40 CUFF INSIDE O/L Self Trim & Check 0.68 3THOL JUKI DCX27 14-15 40 40 STND 2500 DBX1 58 CUFF TOP STITCH 0.55 109 SNLS 0.5 IIIKI Salf Trim & Chack Medium duty F-12 SP18 CL 3/8 2500 FINE DRY1 11 14-15 60 Medium duty CUFF OPENING TO 0.75 80 SNLS 0.5 JUKI Self Trim & Check F-12 CR 3/16E 2500 FINE DBX1 11 14-15 60 COLLAR ATTACH BY W/S THREAD 0.96 63 SNLS 1.0 Self Trim & Check E-12 2500 DBX1 JUKI STND 14-15 62 BOTTOM HEM & PLACKET END TEMPLE MAKING 1.00 60 Y B SNLS 1.0 JUKI Self Trim & Check Medium duty E-12 CR1/32 2500 F501 1/4 TEFFLON DBX1 11 14-15 40 40 63 0.55 109 N BUTTON 109 Y B 2500 11 14-15 30 30 66 KAJ MAKING 0.55 0.0 JUKI Self Trim & Check Medium duty E-12 STND FINE DPX5 HOLE 67 BUTTON ATTACH Y B DPX5 11 14-15 30 30 0.75 80 0.0 Self Trim & Check F-12 STND 2500 JUKI Medium duty FINE HOLE 68 MACHINERY SUMMARY DETAILS SPECIAL MACHINERY DETAILS CUTTING MANPOWER PER LINE TAILORS Machine Type # of M/C's Machine Type # of M/C's NON OPERATR N SINGLENEEDLE LOCK STITCH CUTTING LAVERS CHECKERS SNLS SINGLE NEEDLE EDGE CUTTER CUTTING CUTTER DNIS DOUBLE NEEDLE LOCK STITCH NUMBERING SINGLE NEEDLE CHAIN STITCH CHECKER SNCS FOA FEED OF ARM 17 TOTAL

27101													$\overline{}$	$\overline{}$
3THOL		1												
BUTTON M/C		0						RED	CRITICAL OPERATION	W/S#:				
BARTACK		0						GREEN	INSPECTION POINT	W/S # :				
Н		13						LT BLUE	HELPER OPERATION	W/S#:				
CHECKER		2						YELLOW	TRIMMING OPERATION	W/S # :				
Total Machines		57		Total Machines	44									
IE EXECUTIVE	EXECUTIVE PRODUCTION MANAGER PRODUCTION MANAGER CHARGES PRODUCTION MANAGER TECHNICAL MANAGER													

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		Docu	ment Code: SEV	V.OB Document Ver	sion: SEW.OB.1		Revision	n Level: 1						
Item No.	297D		Style No.		#594336			Buyer	BRF	S				
Revision			Date	26/05/22	Planned		70%		Item No.	297D				
			OLD NAV	/Y SEWING LIN	E LAYOUT									
			STYLE:	#594336										
				CENTRALIZED										
		_												
		1	#REF!		#REF!	2			CRITICAL OP	FRATION				
		3	#REF!		#REF!	4			GIATIOAL GI	LIGHTON				
									INSPECTIO	N POINT				
		5	#REF!		#REF!	6								
									MANUAL OP	ERATION				
		7	#REF!		#REF!	8			HELPER OP	FRATION				
		9	#REF!		#REF!	10			HELI ER OF	LIGHTON				
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## SHAHI EXPORTS PRIVATE LIMITED **Document Title: Operation Bulletin with Technical Data Sheet and Line Layout Document Code: SEW.OB Revision Level: 1 Document Version:** SEW.OB.1 Buy Item 346B Style No. **Old Navy** 588984 346 Revision No. **Date** Planned Efficiency 70% Item No. **OPERATION BULLETIN-FINISHING TARGET:** 650 Pcs/ Day STYLE: #REF! **OLD NAVY DESC:** SAM 4.90 **Emb Top** Tgt/Hr **MPWR MACHINE TYPE OPERATION DESCRIPTION SMV REMARKS** SL (100%) **REQD** Tabel 0.5 120 Initial pressing Tabel 1.0 60 2 Initial checking 2 Tabel 3 Final pressing 1.0 60 2 Tabel 1.0 60 2 Final checking 4 Tabel 60 2 Measurement check 1.0 5 Tabel 300 6 Tagging 0.20 0.5 Tabel 300 7 0.20 0.5 Id checking **TOTAL** 4.90 **TOTAL** 10

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Doc	cument Code: SEW.OB	Layout	D	ocument							
Item	346B	Style No.	588984		Buyer	Old I	Navy				
Revisi	on No	Date	Planned	70%		Item No.	346B				
		FINISHING PROCESS	S FLOW CHART								
	STYLE:	#REF!	TARGET (Pcs/ Day) :	650							
	FINISHING SAM:	4.90	PCS/ HEAD :	65							
	TTL MANPOWER :	10									
	Target/ Hr	Operation Sequence	Manpower	EQUIPMENT/ MACHINE							
		DESPATCH (WASH WISE ISSUE)									
	120	Initial pressing	1	Tabel							
	2 60	Initial checking	2	Tabel							

3	60	Final pressing	2	Tabel	
4	60	Final checking	2	Tabel	
5	60	Measurement check	2	Tabel	
6	300	Tagging	0.5	Tabel	
	300	ld checking	0.5	Tabel	
7	300	id checking	0.5	iabei	