

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																								
ITEM - 659L		LINE -21		Buyer		RALPH LAUREN		Revision No. ____1____		Date		14/07/22		Planned Efficiency		70%								
STYLE :		211926604001		TAILORS		42		MACHINE SAM		40.92		TARGET (100%)		493										
BUYER :		RALPH LAUREN		HELPERS		13		MANUAL SAM		8.04		TARGET (80%)		394										
DESC :		STRIPES SHIRT		CHECKERS		2		TOTAL SAM		48.96		PCS/ MC (80%)		9										
ORD QTY :		3650						TAKT TIME (SEC)		1.17														
SI No	OPERATION DESCRIPTION	SMV	Targ/ Hr	Operator	Grade	Machine Type	# of Work Stn	MACHINE MAKE	M/C Model Number	UBT	Spring	Needle Plate	Presser Foot	Gauge	Mach ne RPM	Folder/ Guide	FEED DOG	NEEDLE TYPE	NEEDLE SIZE	SPI	THREAD (TEX)	NEEDL E	Bobbin/ looper	REMARKS
1	COLLAR RUN STITCH BY PROFILE	0.60	100	Y	B	SNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	ROLLER		2500		TEFFLON	DBX1	11	14-15	40	40		
2	COLLAR MARJIN TRIM & TURN	0.32	188	Y	B	SNEC	0.5	SIRUBA		Self Trim & Check	Medium duty		STND	GUAGE 1/4	2500		STND							
3	COLLAR & BAND PRESS	0.74	31	N		H	1.0																	
4	BAND HEM WITH INTER LINING	0.42	143	Y	A	SNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	SP18 CR 3/16		2500		TEFFLON	DBX1	11	14-15	40	40		
5	COLLAR TOP STITCH	0.42	143	Y	A	SNLS	0.5	JACK		Self Trim & Check	Medium duty	E-12	SP18 CR 1/4		2500		FINE	DBX1	11	14-15	60	40		
6	COLLAR & BAND & READY MARJIN TRIM	0.45	133	Y	B	SNEC	1.0	SIRUBA		Self Trim & Check	Medium duty		STND	GUAGE 1/4	2500		STND							
7	COLLAR INTER LINING ATTACH	0.36	167	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	STND		2500		FINE	DBX1	11	14-15	40	40		
8	COLLAR BAND ATTACH WITH PICK MAKING	0.36	167	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	STND		2500	ACRYLIC GUIDE	FINE	DBX1	11	14-15	40	40		
9	COLLAR FINAL RE-PRESS	0.57	105	N		H	1.0																	
10	CUFF HEM BY WATER SOLUBLE	0.55	109	Y	B	SNLS	0.5	BRO		Self Trim & Check	Medium duty	E-12	SP18 CR3/8		2500		FINE	DBX1	11	14-15				
11	CUFF MARGIN TRIM	0.30	200	Y	B	SNEC	0.5	SIRUBA		Self Trim & Check	Medium duty		STND	GUAGE 1/4	2500		STND							
12	CUFF RUN STITCH BY PROFILE	1.00	60	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty		ROLLER		2500		TEFFLON	DBX1	11	14-15	40	40		
13	CUFF TURN & FINAL PRESS	0.55	109	N		H	1.0																	
14	FUSING PASTE AT SLEEVE SLIT AREA AND MARK	0.55	109	N		H	1.0																	
15	SLEEVE PLACKET MARK, MATCH & PRESS	0.65	92	N		H	1.0																USE SCISSOR	
16	SLEEVE BOTH PLACKET ATTACH	0.75	80	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	STND		2500		FINE	DBX1	11	14-15	40	40		
17	SLEEVE BOTH PLACKET CUT AND EDGE STITCH	0.65	92	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	CR1/32 E		2500		FINE	DBX1	11	14-15	60	40		
18	SLEEVE BUTTON PLACKET CUT & HEM FINISH & KAJ PLACKET FINISH	0.93	65	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	CR1/32		2500		FINE	DBX1	11	14-15	60	40	USE SCISSOR	
19	SLEEVE TEMPLE MAKING & KAJ PLACKET EDGE STITCH	1.25	48	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	CR1/32		2500		TEFFLON	DBX1	11	14-15	40	40		
20	LOOP MAKING	1.25	48	Y	B	SNLS	0.5	BRO		Self Trim & Check	Medium duty	E-12	CL 1/32		2500		FINE	DBX1	11	14-15	60	40		
21	BACK YOKE BOX MAKING WITH LOOP ATTACH	0.70	86	Y	B	SNLS	0.5	JACK		Self Trim & Check	Medium duty	E-12	CR1/32		2500	ACRYLIC GUIDE	FINE	DBX1	11	14-15	40	40		
22	BACK YOKE ATTACH WITH EDGE STITCH	0.95	63	Y	B	SNLS	1.0	BRO		Self Trim & Check	Medium duty	E-12	CR1/32		2500	ACRYLIC GUIDE	FINE	DBX1	11	14-15	60	40		
23	BACK YOKE OIL	0.68	88	Y	B	3THOL	0.5	YAMATO		Self Trim & Check	Medium duty		STND		2500		FINE	DCX27	11	14-15	40	40		
24	FRONT PLACKET TRIM	0.32	188	Y	B	SNEC	0.5	SIRUBA		Self Trim & Check	Medium duty		STND	GUAGE 1/8	2500		STND							
25	MAIN LABEL MAKE MARK AND ATTACH	0.70	86	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	CR1/32		2500		TEFFLON	DBX1	11	14-15	40	24		
26	KAJ PLACKET PRESS AND HEM PRESS	0.65	92	N		H	1.0																	
27	KAJ PLACKET ATTACH BY WATER SOLUBLE (ONE SIDE)	0.30	200	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	CR1/32		2500	ACRYLIC GUIDE	FINE	DBX1	11	14-15				
28	KAJ PLACKET SECOND SIDE PASTE BY SNCS AND TOP	0.55	109	Y	B	SNCS	1.0	JACK		Self Trim & Check	Medium duty		SP18 CR1/4		2500		FINE	TVX3	14	14-15	40	40		
29	BUTTON PLACKET HEM	0.50	120	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	CL1/32		2500	ADJUSTING GUIDE	FINE	DBX1	11	14-15	40	40		
30	FRONT AND BACK MATCH AND BALANCING MARK	0.45	133	N		H	1.0																	
31	SHOULDER ATTACH & TOP STITCH	1.07	56	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	CR1/32		2500	ACRYLIC GUIDE	FINE	DBX1	11	14-15	60	40		
32	POCKET INSIDE FUSING PASTE & POCKET PRESS	0.45	133	N		H	1.0																	
33	POCKET HEM + NECK STAY STICH	0.45	133	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	CL 1/32	CORNER GUIDE	2500		FINE	DBX1	11	14-15	40	40		
34	POCKET PROFILE	0.60	100	Y	B	SNLS	0.5	BRO		Self Trim & Check	Medium duty	E-12	ROLLER		2500		TEFFLON	DBX1	11	14-15	40	40		
35	POCKET MARGIN TRIM	0.32	188	Y	B	SNEC	0.5	JUKI		Self Trim & Check	Medium duty		STND	GUAGE 1/4	2500		STND							
36	POCKET MARK AND MATCH	0.45	133	N		H	1.0																	
37	POCKET ATTACH	0.65	71	Y	B	DNLS	2.0	JUKI-SIRUBA		Self Trim & Check	Medium duty	E-12	STND	GUAGE 3/16	2500		FINE	DPX5	11	14-15	60	40		
38	FLAP MARK WITH STRIPE MATCH	0.45	133	N		H	1.0																	
39	FLAP PROFILE	0.60	100	Y	B	SNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	ROLLER		2500		TEFFLON	DBX1	11	14-15	40	40		
40	FLAP MARGIN TRIM	0.60	100	Y	B	SNEC	0.5	SIRUBA		Self Trim & Check	Medium duty		STND	GUAGE 1/4	2500		FINE	DBX1	11	14-15				
41	FLAP ROUND STAY STITCH	0.85	71	Y	B	SNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	STND		2500		FINE	DPX5	11	14-15	40	40		
42	FLAP TOP STITCH	0.85	71	Y	B	DNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	STND	GUAGE 3/16	2500		FINE	DPX5	11	14-15	60	40		
43	FLAP ATTACH	1.07	56	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	CR1/32		2500		FINE	DBX1	11	14-15	60	40		
44	FLAP FINISH	0.85	71	Y	B	DNLS	1.0	SIRUBA		Self Trim & Check	Medium duty	E-12	STND	GUAGE 3/16	2500		FINE	DPX5	11	14-15	60	40		
45	INLINE CHECK POINT	0.40	150	N		CHECKER	1.0																	
46	SLEEVE MARK AND MATCH	0.40	150	N		H	1.0																	
47	SLEEVE ATTACH WITH HEM	1.10	56	Y	B	SNLS	2.0	JUKI		Self Trim & Check	Medium duty	E-12	SP18 CR 1/4		2500		FINE	DBX1	11	14-15	60	40		
48	SLEEVE INSIDE FINISH BY (DNLS)	0.85	71	Y	B	DNLS	1.0	SIRUBA		Self Trim & Check	Medium duty	E-12	STND	GUAGE 3/8	2500		FINE	DPX5	11	14-15	40	40		
49	ARMHOLE TOP	0.85	71	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	SP18 CR3/8		2500		FINE	DBX1	11	14-15	60	40		
50	SIDE & BOTTOM TRIM	0.50	120	Y	B	OIL	1.0	JUKI		Self Trim & Check	Medium duty				2500		REGULAR	DCX27						
51	SIDE ATTACH WITH HEM	1.20	50	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	SP18CR 5/16		2500		FINE	DBX1	11	14-15	40	40		
52	WASH CARE LABEL ATTACH + SLEEVE OPENING PLEAT MAKING	0.45	133	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	STND		2500		FINE	DBX1	11	14-15	40	40		
53	SIDE TOP (FOA)	1.00	60	Y	B	FOA	1.0	BRO		Self Trim & Check	Medium duty		STND	GUAGE 3/16	2500		FINE	TVX64	14	14-15	60	40		
54	CUFF MARK AND MATCH +COLLAR MARK & MATCH (INSERT IN POCKET)	0.40	150	N		H	1.0																	
55	CUFF ATTACH	0.68	88	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	STND		2500		FINE	DBX1	11	14-15	40	40		
56	CUFF INSIDE OIL	0.68	88	Y	B	3THOL	0.5	JUKI		Self Trim & Check	Medium duty		STND		2500		FINE	DCX27	11	14-15	40	40		
57	CUFF FINISH	0.72	83	Y	B	SNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	CL 1/32		2500		TEFFLON	DBX1	11	14-15	60	40		
58	CUFF TOP STITCH	0.55	109	Y	B	SNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	SP18 CL3/8		2500		FINE	DBX1	11	14-15	60	40		
59	CUFF OPENING TOP	0.75	80	Y	B	SNLS	0.5	JUKI		Self Trim & Check	Medium duty	E-12	CR 3/16E		2500		FINE	DBX1	11	14-15	60	40		
60	COLLAR ATTACH BY WIS THREAD	0.96	63	Y	B	SNLS	1.0	JUKI		Self Trim & Check	Medium duty	E-12	STND		2500		FINE	DBX1	11	14-15				
61	COLLAR PRESS	0.30	200	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	CR1/32		2500	ACRYLIC GUIDE	FINE	DBX1	11	14-15	60	40		
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	BOTTOM FINISH	1.05	39	Y	B	SNLS	1.0	JACK		Self Trim & Check	Medium duty	E-12	CR 1/4E		2500		FINE	DBX1	11	14-15	60	40		
64	THEARD CUTTING	0.55	109	N		H	1.0																	

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Document Code: SEW.OB				Revision Level: 1 SEW.OB.1			Document Version:		
Item No.	346B	Style No.		588984			Buy	Old Navy	
Revision No. _____		Date		Planned Efficiency		70%		Item No.	346B
OPERATION BULLETIN- FINISHING				TARGET :	650	Pcs/ Day			
STYLE :				#REF!		OLD NAVY			
DESC :				Emb Top	SAM	4.90			
SL	OPERATION DESCRIPTION	SMV	Tgt/Hr (100%)	MACHINE TYPE	MPWR REQD	REMARKS			
1	Initial pressing	0.5	120	Tabel	1				
2	Initial checking	1.0	60	Tabel	2				
3	Final pressing	1.0	60	Tabel	2				
4	Final checking	1.0	60	Tabel	2				
5	Measurement check	1.0	60	Tabel	2				
6	Tagging	0.20	300	Tabel	0.5				
7	Id checking	0.20	300	Tabel	0.5				
TOTAL		4.90		TOTAL	10				

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	Item No.	346B	Style No.		588984			Buyer	Old Navy
	Revision No. _____		Date		Planned Efficiency		70%		Item No. 346B
		FINISHING PROCESS 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)					
	1	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			
	7	300		Id checking		0.5		Tabel			