



















Mr.Engineer - Proper Method

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<i>Code</i>	MSSASO003							
<i>Title</i>	Twin Needle Side Seam L/S							
<i>Description</i>		<table style="width: 100%; border: none;"> <tr> <td style="width: 70%;"><i>Manual Time (Sec.)</i></td> <td style="text-align: right;">31.5</td> </tr> <tr> <td><i>Machine Time (Sec.)</i></td> <td style="text-align: right;">23.5</td> </tr> <tr> <td><i>Total Time (Sec.)</i></td> <td style="text-align: right;">55.0</td> </tr> </table>	<i>Manual Time (Sec.)</i>	31.5	<i>Machine Time (Sec.)</i>	23.5	<i>Total Time (Sec.)</i>	55.0
<i>Manual Time (Sec.)</i>	31.5							
<i>Machine Time (Sec.)</i>	23.5							
<i>Total Time (Sec.)</i>	55.0							

No.	Code	Description		# Stitches
1	AS2H	Place shirt to table		
2	AS2H - MAP2	Place shirt to machine		
3	MAP2			
4	MAP2 - PPL2	Locate to folder		
5	PPL2 - MAP2	Regrasp hem ends & slide into folder		
6	MAP2			
7	MAP2 - PPL1	Locate to needle point		
8	MS1A	Sew to hold		
9	MS1A - AM2P	Align		
10	AM2P			
11	AM2P - S43LA	Sew to under arm		41.0
12	S43LA			55.0
13	S43LA			55.0
14	S43LA			55.0
15	S43LA - AM2P	Align		52.0
16	AM2P			
17	AM2P - S8HA	Sew across under arm		8.0
18	S8HA			32.0
19	AM2P	Align at end		8.0
20	AM2P			
21	AM2P - S47LA	Sew of end		11.0
22	S47LA			56.0
23	S47LA			56.0
24	S47LA			56.0
25	S47LA			56.0

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No.	Code	Description	# Stitches
26	S47LA - PPAL	Ventura cutter	49.0
27	AS2H	Place shirt to table	
28	AS2H		
29	AS2H - MAP2	Place shirt to machine	
30	MAP2		
31	MAP2 - PPL2	Locate to folder	
32	PPL2 - MAP2	Regrasp hem ends & slide into folder	
33	MAP2		
34	MAP2 - PPL1	Locate to needle point	
35	MS1A	Sew to hold	
36	MS1A - AM2P	Align	
37	AM2P		
38	AM2P - S43LA	Sew to under arm	47.0
39	S43LA		55.0
40	S43LA		55.0
41	S43LA		55.0
42	S43LA - AM2P	Align	46.0
43	AM2P		
44	AM2P - S8HA	Sew across under arm	11.0
45	S8HA		32.0
46	AM2P	Align at end	5.0
47	AM2P		
48	AM2P - S47LA	Sew of end	17.0
49	S47LA		56.0
50	S47LA		56.0
51	S47LA		56.0
52	S47LA		56.0
53	S47LA - PPAL	Ventura cutter	43.0
54	E - AS2H	Aside	
55	AS2H		