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2002 10 24

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5a (32), (36), (30) (24) - (25), (12) (34) (39), (22) (15), (48) (17), (22) 2), (14) (19), (44) (4)

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6 (20) 90 s100 (20) (18) (18) (20) 3 가 (20)

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s102 (20a) 2 (20b) (24) (20) (20b) (20)

s114 - s116 s104 1 (20a) 2 (20b) (20a) 1 (20a)

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(22l) (11)

s108 (18) (22) (18) (12) (14) (24) (24)

(18) (12) (12) (14) (14)

(24) (12) (14) 가 (24) (14)

(14) (11) (44) s110 s108 s110

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s112 (28) (11) (28) (24)

14) CAD/CAM (18) (11) (11) CAD/CAM(Comp

uter Aided Drafting/CAM) (14) (11)

s114 (28) (11)

. s116 (28) , (12) 2 (20b) (28)  
 (28) , (24) (14)  
 (18)

(28) (axes) (12b) 1  
 (20a) 1 (20a) 2 s118 (20b) 2  
 (13)가 (28) /  
 (paying) s112 s114

1 (20a) 2 (20b) 1 (2  
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 s108-s110 (28) s116 (12)

(24) (24) (10) s108 (24) (12) (14)  
 (14) (22) (12) s110 1 (20a) (24) (17)  
 ( )  
 (24) (14) 가 (22)

8 (34a) 7 (14) 7 (24) (24) (290)  
 (25) (17), (working) (24) (30), (25) (32), (42)  
 ), (43) (39)

(24) s300 (17) (221)  
 (22w) 1 (20a) (24) (11) (22) 1 (20a)

(20a) 가 ,

, 302 (22)(221 22w) 가 가 (12) 가 가  
 (30) (30) 가 가 (22) 가  
 가 , 가 가 가 (40) (12) 가  
 (22) (40) (30)

100((1+x)+(x+x/100))-100/100  
 , x (221 22w)  
 (22) 가 가 (30)

, 8 (221) 8.33% 300  
 9.02389% 302 (301) , 8.33% 8.33  
 % 0.693889% , 8.33%가 가 9.02389%가 가 (30) , 8.33% (12)  
 (14) 가





, Xw , Zl , XI , Sg , ESg , Y , Zw

(40) (14)

#1 -

(22l) - 8.33%; (30l) - 9.02389%

(22w) - 3.12%; (30l) - 3.21734%

(12) 22.88'

(36) 60%

(48w) - 7/12

(48l) - 17/30

$$(14) = 22.88' + [(22.88' \cdot 7/12)(3.21734\%)(60\%)] + [(22.88' \cdot 17/30)(9.02389\%)(60\%)] = 22.88' + .2576 + .7187 = 23.85'$$

(48l, 48w) (14) (30l, 30w)

(25) (48) (15) (36)

(34a) (48l, 48w) 1.0(1 3/20)

(40) (40) (42) (24) (30w, 3)

(34) (12) (14) (24) (34) (2)

가 가 , (18)

가 (24) (36)

(36) (34a 34l)

(36) (34a 34l)

(34a-34l) 36 (34a-34l) 18

(36) (24) 12

8 12 34a-34e . 100% Z%

w/collar X% - Y% #1 - #5 w/body , X% Y%

Z% 100%

ar 34a 60%+40% w/body' #1 w/collar 9 60% 100% , w/coll

ar	34b	'60%+40%	w/body'	#1	w/collar	65%	100%	, w/coll
가,				34a			5%	
ar	34c	'60%+40%	w/body'	#1	w/collar	70%	100%	, w/coll
		301	70%	34a	34b			
			45					
ar	34d	'60%+40%	w/body'	#1	w/collar	75%	100%	, w/coll
c						5%		34
ar	34e	'70%+30%	w/body'	#1	w/collar	70%	100%	, w/coll
			75%	가			34e	
		34a-34e						가
		34a-34e						가
13	17				34f-34j			
A%, B%, C%		#1-3, 5-6	W-A%, L-B%, SL-C%	D%-E%			100%	
					D%, E%			
A%, B%, C%								가
	34f	'80%+20%	100%		#1	W-100%, L		1
		-100%, SL-100%, '		36		80%(D%)+20%(E%)		
	34g	'80%+20%	100%		#2	W-100		
		%, L-100%, SL-95%, .'						
34h	'80%+20%		100%		#3	W-100%, L-100		
	%, SL-90%, .'							
34i	'80%+20%		100%		#5	W-100%, L-100		
	%, SL-75%, .'							
34j	'80%+20%		100%		#6	W-100%, L-100		
	%, SL-60%, .'							

18

18	19				34k-34l			
		#1-2	W-0%*L-0%	L-A%, W-B%, Apex-C%	D%	A%, B%		36
		36		C%				
apex			' From W-0%*L-0%'		A%, B%, C%가		(12)	





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13 17. ,

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$100((1 + x) + (x + x/100)) - 100/100$

( , x )

13 18. ,

가

13 **19.**

가

$$((X\% \times Y\%) \times Sg) + Sg = ESg$$

( , X , Y , Sg , ESg )

13 **20.**

가

$$Sg + (Sg(Zw)(Xw\%)(Y\%)) + (Sg(ZI)(XI\%)(Y\%))$$

( , Xw , ZI , XI Sg , ESg , Y ) , Zw

**21.**

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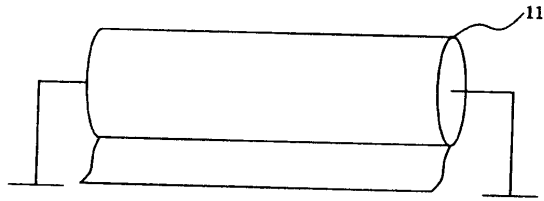
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21 **22.**

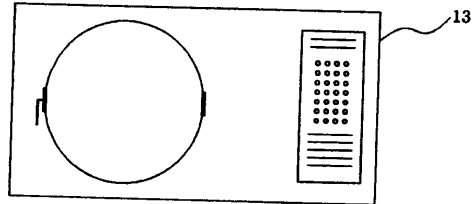
22 **23.**

21 **24.**

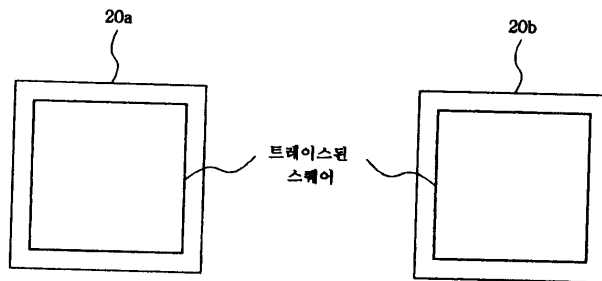
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2

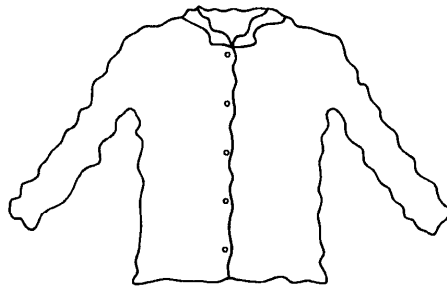


3



4a

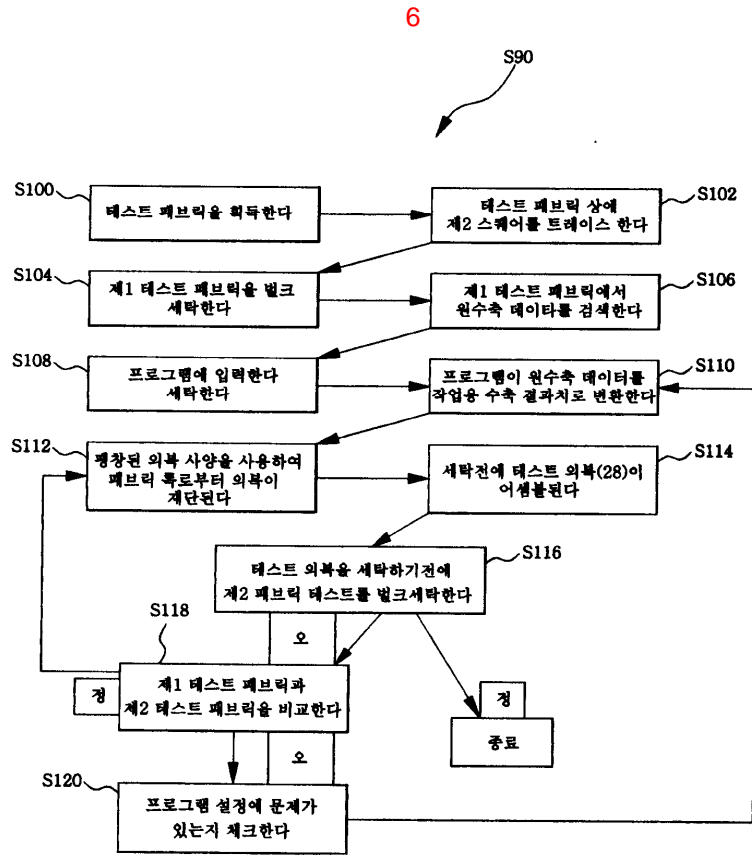
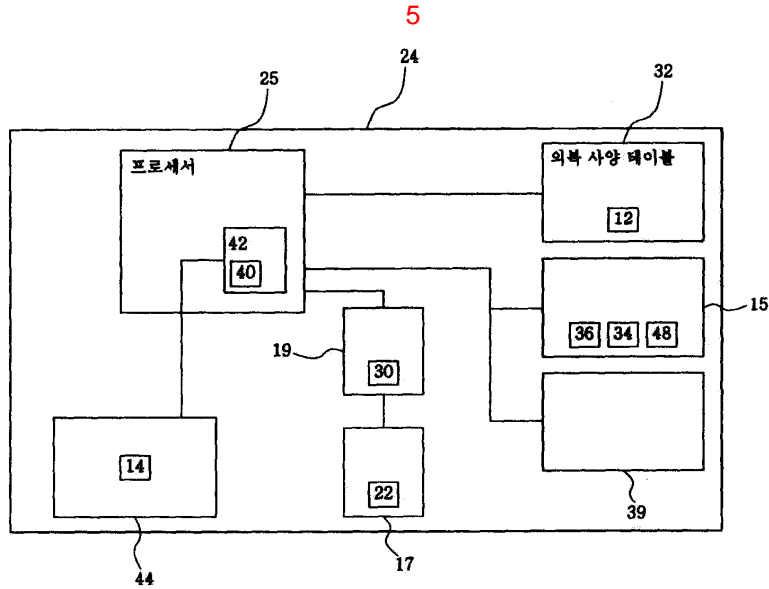
18(14)치수



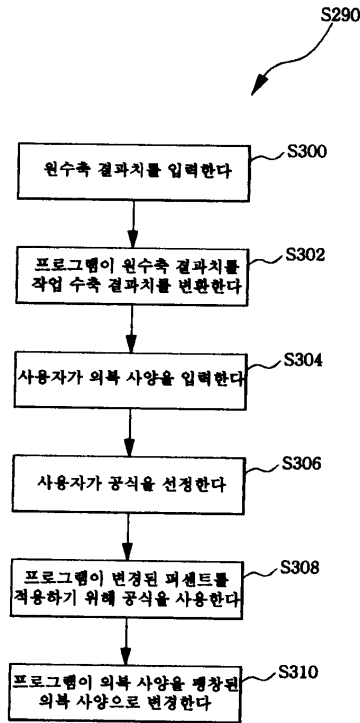
4b

18(12)치수



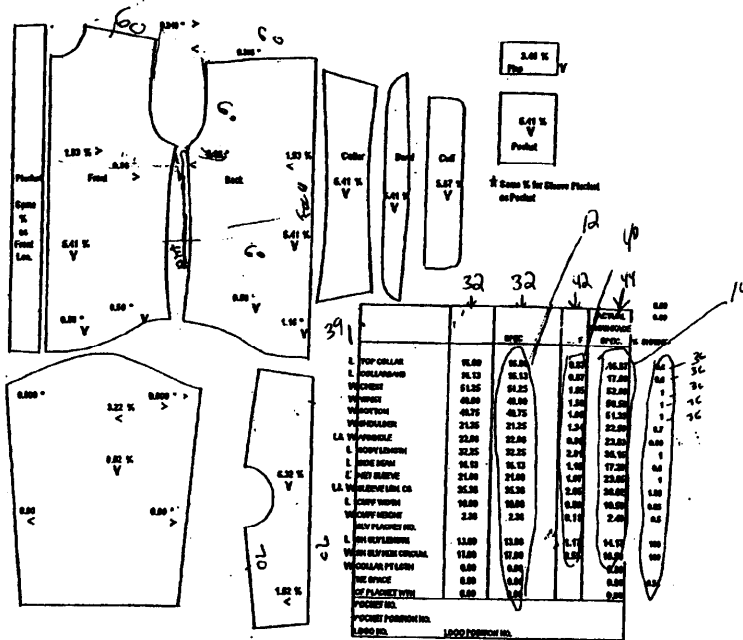


7



8

34A  
MASTER WOVEN SHIRT FORMULA BY BODY AT 60%+40% BREAKDOWN OF 100% SHRINKAGE WOOLLA AND BAWD AT 60%.



WSR to (aw) 22

301 221

ITEM	TYPE	ACTUAL	PERCENT
1. TOP COLLAR	15.00	15.00	100.00
2. BODICE FRONT	34.50	34.50	100.00
3. BODICE BACK	51.50	51.50	100.00
4. SLEEVES	48.00	48.00	100.00
5. WRISTBAND	48.75	48.75	100.00
6. WRISTBAND	21.50	21.50	100.00
7. WRISTBAND	22.50	22.50	100.00
8. WRISTBAND	22.50	22.50	100.00
9. WRISTBAND	16.50	16.50	100.00
10. WRISTBAND	21.00	21.00	100.00
11. WRISTBAND	25.50	25.50	100.00
12. WRISTBAND	19.00	19.00	100.00
13. WRISTBAND	2.00	2.00	100.00
14. WRISTBAND	13.00	13.00	100.00
15. WRISTBAND	12.00	12.00	100.00
16. WRISTBAND	0.00	0.00	0.00
17. WRISTBAND	0.00	0.00	0.00
18. WRISTBAND	0.00	0.00	0.00
19. WRISTBAND	0.00	0.00	0.00
20. WRISTBAND	0.00	0.00	0.00
21. WRISTBAND	0.00	0.00	0.00
22. WRISTBAND	0.00	0.00	0.00
23. WRISTBAND	0.00	0.00	0.00
24. WRISTBAND	0.00	0.00	0.00
25. WRISTBAND	0.00	0.00	0.00
26. WRISTBAND	0.00	0.00	0.00
27. WRISTBAND	0.00	0.00	0.00
28. WRISTBAND	0.00	0.00	0.00
29. WRISTBAND	0.00	0.00	0.00
30. WRISTBAND	0.00	0.00	0.00
31. WRISTBAND	0.00	0.00	0.00
32. WRISTBAND	0.00	0.00	0.00
33. WRISTBAND	0.00	0.00	0.00
34. WRISTBAND	0.00	0.00	0.00
35. WRISTBAND	0.00	0.00	0.00
36. WRISTBAND	0.00	0.00	0.00
37. WRISTBAND	0.00	0.00	0.00
38. WRISTBAND	0.00	0.00	0.00
39. WRISTBAND	0.00	0.00	0.00
40. WRISTBAND	0.00	0.00	0.00
41. WRISTBAND	0.00	0.00	0.00
42. WRISTBAND	0.00	0.00	0.00
43. WRISTBAND	0.00	0.00	0.00
44. WRISTBAND	0.00	0.00	0.00
45. WRISTBAND	0.00	0.00	0.00
46. WRISTBAND	0.00	0.00	0.00
47. WRISTBAND	0.00	0.00	0.00
48. WRISTBAND	0.00	0.00	0.00
49. WRISTBAND	0.00	0.00	0.00
50. WRISTBAND	0.00	0.00	0.00

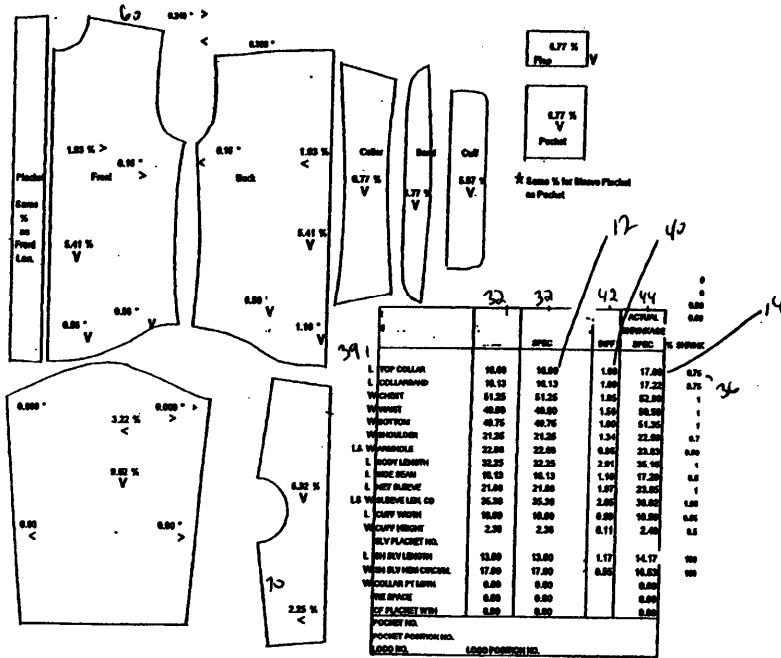






34d

MASTER WOVEN SHIRT FORMULA 64 W/BODY AT 60%+40% BREAKDOWN OF 10% SHRINKAGE W/COLLAR AND BAND AT 75%

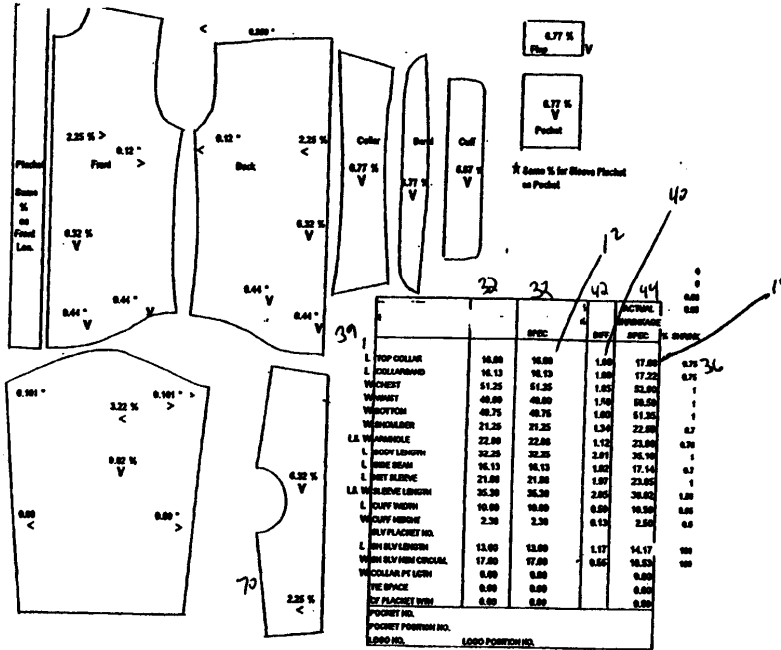


TEST PROCEDURE:  
 WIDTH: 3.125M 3.12  
 LENGTH: 0.8000 0.80  
 301 221

ITEMS	QTY	UNIT	PRICE	TOTAL
FRONT COLLAR	1	PC	16.00	16.00
FRONT CHEST	1	PC	61.25	61.25
FRONT WAIST	1	PC	48.00	48.00
FRONT BOTTOM	1	PC	48.75	48.75
FRONT HANGERS	1	PC	21.25	21.25
FRONT SHOULDER	1	PC	32.00	32.00
FRONT BODY LENGTH	1	PC	32.25	32.25
FRONT SLEEVE HEAD	1	PC	16.13	16.13
FRONT SLEEVE BUNDLE	1	PC	21.00	21.00
FRONT SHOULDER L&L CD	1	PC	35.00	35.00
FRONT SLEEVE WIDTH	1	PC	10.00	10.00
FRONT CUFF WIDTH	1	PC	2.25	2.25
FRONT CUFF LENGTH	1	PC	13.00	13.00
FRONT SLEEVE HEAD CIRCUM	1	PC	17.00	17.00
FRONT COLLAR PT L&R	1	PC	0.00	0.00
FRONT NECK SPACE	1	PC	0.00	0.00
FRONT CUFF CIRCUM	1	PC	0.00	0.00
FRONT POCKET W	1	PC	0.00	0.00
FRONT POCKET L	1	PC	0.00	0.00
FRONT POCKET POSITION W	1	PC	0.00	0.00
FRONT POCKET POSITION L	1	PC	0.00	0.00

34e

MASTER WOVEN SHIRT FORMULA IS BODY AT 70%+30% BREAKDOWN OF 100% SHRINKAGE COLLAR AND BAND AT 70%



TEST PROCEDURE  
NOTE:  
LEADERS

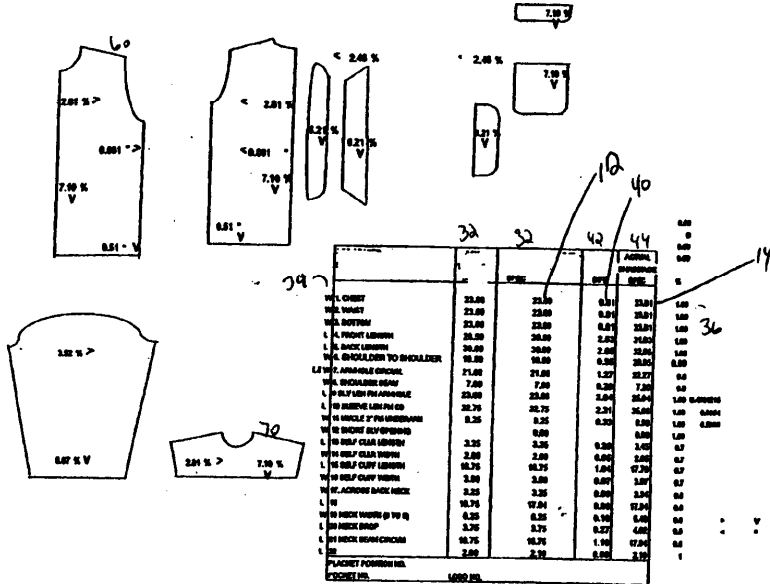
30w 22w  
30l 22l

FORMULA	W	L	SPD	W	L	SPD
POCKET NO.	2.01	0.05	2.70			
SHOULDER (A)	0.17	0.04	0.025			
SHOULDER (B)	0.02	0.10	0.025			
ARMHOLE (A)	7.07	0.07	7.0			
ARMHOLE (B)	10.00	0.01	12.00			
WRIST (A)	10.20	1.20	10			
WRIST (B)	20.07	2.07	22			

FORMULA	W	L	SPD	W	L	SPD
POCKET NO.	11.00	0.70	11.00			
SHOULDER (A)	11.00	0.25	11.00			
SHOULDER (B)	11.00	0.25	11.00			
ARMHOLE (A)	0.07	0.07	0			
ARMHOLE (B)	14.00	0.07	14.0			
WRIST (A)	0.70	0.07	0.02			
WRIST (B)	0.01	0.01	0.0			
WRIST (C)	21.12	2.02	22.10			

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MASTER JKT FORMULA PT M-100% L-100% SL USING 80%+20% BREAKDOWN OR 100% SHRIMPAGE  
 TABLE 1 For 50% 50%LYR=of Color & Col



ITEM	QTY	UNIT PRICE	TOTAL PRICE	PERCENTAGE
FRONT NECK (A)	0.02	0.02	0.00	0.00
P NECK (A)	0.00	0.00	0.00	0.00
SHOULDER (A)	0.00	0.00	0.00	0.00
P ANKLE (A)	0.71	0.71	0.00	0.00
SHOULDER (A)	0.71	0.71	0.00	0.00
FRONT (A)	0.00	0.00	0.00	0.00
WASH (A)	0.00	0.00	0.00	0.00
FRONT (A)	0.00	0.00	0.00	0.00
BACK NECK (A)	0.02	0.02	0.00	0.00
SHOULDER (A)	0.00	0.00	0.00	0.00
P ANKLE (A)	0.00	0.00	0.00	0.00
SHOULDER (A)	0.00	0.00	0.00	0.00
FRONT (A)	0.00	0.00	0.00	0.00
WASH (A)	0.00	0.00	0.00	0.00
FRONT (A)	0.00	0.00	0.00	0.00
W/ L CHEST	23.00	2.00	46.00	100.00
W/ R CHEST	23.00	2.00	46.00	100.00
W/ L FRONT LEGGING	23.00	0.25	5.75	100.00
W/ R FRONT LEGGING	23.00	0.25	5.75	100.00
W/ L BACK LEGGING	23.00	2.00	46.00	100.00
W/ R BACK LEGGING	23.00	2.00	46.00	100.00
W/ L SHOULDER TO SHOULDER	18.00	0.20	3.60	100.00
W/ R SHOULDER TO SHOULDER	18.00	0.20	3.60	100.00
W/ L ANKLE DROOP	7.00	0.20	1.40	100.00
W/ R ANKLE DROOP	7.00	0.20	1.40	100.00
W/ L CUFF PARALLEL	23.00	2.00	46.00	100.00
W/ R CUFF PARALLEL	23.00	2.00	46.00	100.00
W/ L RIB CUFF INTER	2.00	0.00	0.00	0.00
W/ R RIB CUFF INTER	2.00	0.00	0.00	0.00
W/ L RIB CUFF WASH	2.00	0.00	0.00	0.00
W/ R RIB CUFF WASH	2.00	0.00	0.00	0.00
W/ L ACHROX BACK NECK	2.25	0.00	0.00	0.00
W/ R ACHROX BACK NECK	2.25	0.00	0.00	0.00
W/ L NECK HANG UP TO W	0.25	0.00	0.00	0.00
W/ R NECK HANG UP TO W	0.25	0.00	0.00	0.00
W/ L NECK DROP	2.25	0.27	0.61	100.00
W/ R NECK DROP	2.25	0.27	0.61	100.00
W/ L NECK HANG CROWN	18.75	1.10	20.63	100.00
W/ R NECK HANG CROWN	18.75	1.10	20.63	100.00
W/ L PLECKET FORMING KIT	2.00	0.00	0.00	0.00
W/ R PLECKET FORMING KIT	2.00	0.00	0.00	0.00





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MASTER KMT FORMULA 65 W-100% L-100% 4 USNO 80%+20% BREAKDOWN OR 100% PAPERKAGE  
 TABLE 1 For K08 2011 V000 Colbr & Cnt

	32	32	42	44	ADJUST
W L CHEST	23.00	23.00	0.04	23.04	0.00
W L WAIST	23.00	23.00	0.04	23.04	0.00
W L BOTTOM	23.00	23.00	0.04	23.04	0.00
L L FRONT LENGTH	24.00	24.00	2.00	26.00	0.00
L L BACK LENGTH	24.00	24.00	2.00	26.00	0.00
W L SHOULDER TO SHOULDER	18.00	18.00	0.00	18.00	0.00
L L 2 ANGLE CIRCUM	31.00	31.00	1.27	32.27	0.00
W L SHOULDER SEAM	7.00	7.00	0.20	7.20	0.00
L L SLOPE FOR ANGLE	23.00	23.00	1.42	24.42	0.00
L L SLOPE FOR CO	12.70	12.70	1.20	13.90	0.00
W L ANGLE OF THE WRIST	0.25	0.25	0.00	0.25	0.00
W L RIGHT SLY OPENING	0.00	0.00	0.00	0.00	0.00
L L TO SELF CHEST LENGTH	3.25	3.25	0.20	3.45	0.00
W L SELF CHEST WIDTH	2.00	2.00	0.00	2.00	0.00
L L TO SELF CHEST LENGTH	10.70	10.70	1.00	11.70	0.00
W L SELF CHEST WIDTH	3.00	3.00	0.07	3.07	0.00
W L ACROSS BACKSEAM	3.20	3.20	0.00	3.20	0.00
L L CO	10.70	10.70	0.00	10.70	0.00
W L ANGLE WIDTH (L TO R)	0.20	0.20	0.00	0.20	0.00
L L DROPTOP	3.70	3.70	0.27	3.97	0.00
L L RT HOCK SEAM CIRCUM	10.20	10.20	1.00	11.20	0.00
L L CO	0.00	0.00	0.00	0.00	0.00

TEST PROCEDURE	W	L	30w	22w	30l	22l
FRONT CHEST	16.42	0.42				
FRONT LENGTH	0.00	0.00				
SHOULDER (R)	0.00	0.00				
SHOULDER (L)	10.71	0.71				
FRONT (R)	0.00	0.00				
FRONT (L)	0.00	0.00				
FRONT (A)	0.00	0.00				
BACK SEAM (R)	0.00	0.00				
BACK SEAM (L)	0.00	0.00				
BACK SEAM (A)	0.00	0.00				
W L CO	10.70	0.20				
W L ANGLE	0.20	0.20				









2000  
직조된 셔츠 수축 분석 전역 데이터베이스

직조된 셔츠	수축 비례 이크다운	칼 관	세탁시간 (분)	세탁온도 (온도)	패브릭 구성	패브릭 중량	패브릭 마감	세척 형태	카테 고리	간이 레이
A-1	60-40	60			high count 100/2 or above	light	firm to med firm	light emt wash/emt wash /hvy emt wash /silicon wash	A score 0-10	straight 9 D bias 45 D bias
A-2	60-40	70	20-40	30-40	1.5	1.5	1.25	1		
A-3	60-40	75	2.5	2	med count 80s to 100/2	mod	med to med soft	sand wash/enzyme wash/ hlo wash/chemical wash chemical wash/green ball wash	B score 10 to 20	straight 9 D bias 45 D bias
B-1	65-35	65	40-70	45-55	1.5	3	2.5	2		
B-2	65-35	70			low count 55s to 75s	med to heavy	med soft to soft	hvy enzyme wash/hvy stone wash hvy enzyme stone wash/hvy sand wash/ hvy chemical stone/chemical stone wash	C score 20 to 30	straight 9 D bias 45 D bias
B-3	65-35	75	5	4	4.5	4.5	3.75	3		
C-1	70-30	65	7.5	6	30s to 55s	heavy	extra soft	destroy wash/ Ralph lae wash	D score 30 to 37	straight 9 D bias 45 D bias
C-2	70-30	75								
C-3	70-30	80								
D-1	75-25	75	10	8						
D-2	75-25	80								
D-3	75-25	85								
E-1	80-20	75								
E-2	80-20	80								
E-3	80-20	85	12.5	10	7.5		5.25	5		

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작업명	수출 브레이크 디스크용	세탁시간 (분)	세탁 온도 (온도)	세탁량 구성	세탁량 종류	세탁량 시간	세탁 형태	카테 고리
A-1	75 100 75 85	30	30	90	HEAVY	1.5	FROM TO NEW FROM	A
A-2	75 11 11 11	70	70	70	HEAVY	1.5	LOW CARTRIDGE/HEAVY /HEAVY CARTRIDGE /SILICONE IN HEAVY	A
A-3	75 11 11 11	40	45	HEAVY	HEAVY	1.5	1	0/1
A-4	11 11 11 11	40	45	HEAVY	HEAVY	1.5	1	0/1
B-1	80-100 80-20	45	45	75	MED	1.25	SPIND WASH/EXTRA WASH /Bio wash/extra wash /HEAVY WASH/extra wash	B
B-2	11 11 11 11	70	70	70	MED	1.25	SPIND WASH/EXTRA WASH /Bio wash/extra wash /HEAVY WASH/extra wash	B
B-3	11 11 11 11	70	60	90	MED	1.25	SPIND WASH/EXTRA WASH /Bio wash/extra wash /HEAVY WASH/extra wash	B
B-4	11 11 11 11	5	4	3	MED	2.5	SPIND WASH/EXTRA WASH /Bio wash/extra wash /HEAVY WASH/extra wash	B
C-1	85-100 85-20	70	60	55	MED	3	4 WY EXHAUSTIVE WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH	A
C-2	11 11 11 11	70	70	70	MED	3	4 WY EXHAUSTIVE WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH	A
C-3	11 11 11 11	100	75	75	MED	3	4 WY EXHAUSTIVE WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH	A
C-4	11 11 11 11	7.5	6	4.5	MED	3.25	4 WY EXHAUSTIVE WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH/EXTRA WASH	A
D-1	90-100 90-15	100	75	30	HEAVY	4	DESTROY CONTROL	A
D-2	11 11 11 11	70	70	70	HEAVY	4	DESTROY CONTROL	A
D-3	11 11 11 11	100	90	55	HEAVY	4	DESTROY CONTROL	A
D-4	11 11 11 11	10	8	6	HEAVY	4	DESTROY CONTROL	A

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핀즈		0포켓	2포켓	4포켓	세탁 테스트
ABCD	1	1/2"	3/8"	1/4"	2-5
ABCD	2	3/4"	5/8"	9/16"	6-9
ABCD	3	1 1/4"	1 1/16"	7/8"	10-13
ABCD	4	1 3/4"	1 1/2"	1 1/4"	14-17