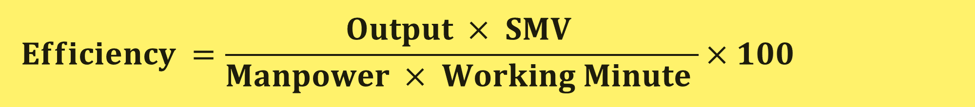
**Sewing Line Efficiency Calculation**



**Output**                        = Number of garments pieces produced in the line

**SMV**                        = Standard Minute Value of the garment

**Manpower**            = Number or the worker worked (Operator + Helper + ironman)

**Working minute**        = Total minute work to produce the garments.

***Example:***

***A sewing line output is 1600 pcs in 9 hours. The workers were 32, the helper was 4 and the ironman was 2 and the garment SMV is 7.32. What is the efficiency of the sewing line?***

***Here,***

**Output**                        = 1600 pcs

**SMV**                        = 7.32

**Manpower**            = 32+4+2 = 38

**Working minute**        = 9 hours = 9 × 60 = 540 minutes

If we put all the value in the efficiency formula we will find the efficiency of that sewing line.

**So, Sewing Line Efficiency = [(1600 × 7.32)/(38 × 540)] × 100 = 57.08%**

**Question:**

**Calculate line efficiency when 5000 garments are stitched by 50 workers in 5hours and it takes 5minute to produce a garment.**

**Question**

Calculate how many pieces of garments can be stitched, when line efficiency is 70%, and 45 workers work for 8hours

Calculate how many workers are required when line efficiency is on average 65%, and 3000 garments need to be produced in 8hours and SAM of product is 7.5min.