

2017 MFA Time Standards Manual

The Time Standards Manual was developed in 1996 by the Marine Fabricators Association (MFA), a division of the Industrial Fabrics Association International, to serve as a benchmark shop owners can use to set fabrication times, with which they can generate competitive labor costs. The manual is an ongoing project that will grow and change organically in response to the ever-changing marine industry.

Please be aware that this manual was developed by experts in the industry, and that the times stated for each project are averages. Individual times may differ depending on experience and technique. We suggest that each shop log its average project times so that it is able to quote its customers as accurately as possible.





2017 MFA TIME STANDARDS MANUAL

HOW IT WORKS

Your input is crucial

The accuracy of this manual depends on input from industry experts. To suggest changes, modifications or additions for the next manual, please contact:

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The manual features exterior categories and upholstery categories. Marine canvas and upholstery is a custom-oriented business, so each product category features a base set of times that changes according to the various sizes of the project.

The manual also indicates re-cover estimates on tops by classifying frames and tops into separate categories. For a complete frame and top, simply add the times for both categories. For a re-cover job, use the times for the top only.

Example Project

PLEASE NOTE: The category timetables do not include any of the options listed at the end of the category. Why? The list of times to cover every possible product combination would quickly fill up a dictionary, and then some. To estimate the total time for a custom product, you must add the time from the product table to the times of each of the options at the bottom of the list. Here's an example:

Product

This bimini top on a sailboat requires a split mount to get around the winches. There are two back-stays going through the top, the customer wants two sailing windows, and the beam is 9 feet wide. The customer also wants the top to be 96 inches long from front to back. To clear the winches, you also must put a dog leg in one of the two main bows. Finally, the customer wants a zip-off cover for winter storage.

Estimate example

As you can see from this example, the options list offers the key to getting accurate total hours for each custom product.

Frame

1-inch stainless steel frame;	
4-bow bimini with a 9-foot beam	3 hours
Options: Split mount	0.75 hours
Dog-leg for one bow	0.5 hours
TOTAL FRAME HOURS	4.25 hours

Top

4-bow bimini top with	
10-foot beam	7 hours
Options: Zipper pockets	2 hours
2-stay cutout	3 hours
2 sailing windows	
= 2 x 1.50 hours	3 hours
Storage boot	1.5 hours
TOTAL TOP TIME	16.50 hours

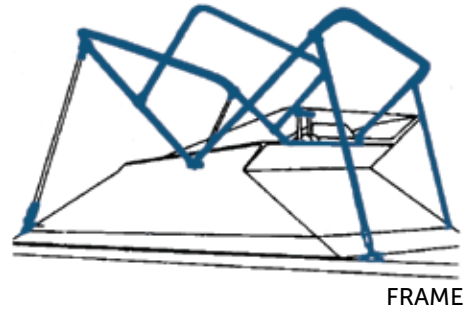
TOTAL JOB TIME	20.75 hours
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According to the manual, the average marine fabricator would require 20.75 hours to complete this project. This total includes the time it takes to complete each of the following tasks:

- give the estimate
- design the product
- order the materials
- receive and pay for the materials
- bend the frame
- mount and fit the top
- cut the top out
- sew the top up
- install the top
- bill and collect the money

» FRAME

1-INCH STAINLESS FRAME		*These times include the design, bending, assembly and installation of the frame onto the boat. They do not include any of the options listed below, nor do they include the actual fit of the top.		
Beam (In Feet)	7'	9'	10.5'	13.5'
1-bow	1.5 hrs.	1.5 hrs.	1.75 hrs.	2.5 hrs.
2-bow	2 hrs.	2.25 hrs.	2.5 hrs.	4 hrs.
3-bow	2.5 hrs.	2.75 hrs.	3 hrs.	5 hrs.
4-bow	3 hrs.	3.25 hrs.	3.5 hrs.	5 hrs.
5-bow	3.5 hrs.	3.75 hrs.	4 hrs.	6 hrs.
7/8-INCH FRAME				
1-bow	1.25 hrs.			
2-bow	2 hrs.			
3-bow	3 hrs.			
4-bow	4.5 hrs.			
OPTIONS				
Rigid supports (one pair)	1 hr.			
Through-bolt mounts	0.75 hr.			
Severe angle mounts	2 hrs.			
Dog-leg bow	0.5 hr.			
Split mount	0.75 hr.			
Grab rail	0.5 hr.			



» ATTACHED BIMINI

*An attached bimini is any top supported by framework and attached to either the boat, a radar arch or another top at one end. The times and materials listed here are for a base product with no zipper pockets, enclosure zippers, or any other option		listed below. This does not include convertible tops. These times are for the canvas top only; they do not include manufacturing the frame or installing the frame on the boat.		
Beam (In Feet)	7'	9'	10.5'	13.5'
1-bow	4.5 hrs.	5 hrs.	5.5 hrs.	7 hrs.
2-bow	5.5 hrs.	6 hrs.	7 hrs.	9 hrs.
3-bow	6 hrs.	7.5 hrs.	9 hrs.	12 hrs.
4-bow	7.5 hrs.	9 hrs.	10.5 hrs.	13.5 hrs.
OPTIONS				
Beam (In Feet)	7'	9'	10.5'	13.5'
Zipper removal of attachment	1 hr.	1.25 hrs.	1.5 hrs.	1.75 hrs.
Straps (one pair)	0.5 hr.			
For odd-shaped arch:	Add 1.5 hrs.			
Zipper Pockets				
1-bow	0.33 hr.	0.5 hr.	0.6 hr.	0.75 hr.
2-bow	0.49 hr.	0.6 hr.	0.75 hr.	1 hr.
3-bow	0.6 hr.	0.75 hr.	1 hr.	1.25 hrs.
4-bow	0.75 hr.	1 hr.	1.25 hrs.	1.5 hrs.



» BIMINI TOP

*A bimini top is any top supported by framework at both ends. The times and materials listed here are for a base product with no zipper pockets, enclosure zippers, or any other option listed

below. These times are for manufacture of the canvas top only; they do not include manufacturing the frame or installing the frame on the boat.

Beam Width (In Feet)	7'	9'	10.5'	13.5'
2-bow	5 hrs.	5.25 hrs.	6.5 hrs.	7 hrs.
3-bow	6 hrs.	6.25 hrs.	7 hrs.	8 hrs.
4-bow	7 hrs.	8 hrs.	10 hrs.	13 hrs.
5-bow	8 hrs.	9 hrs.	11 hrs.	14 hrs.

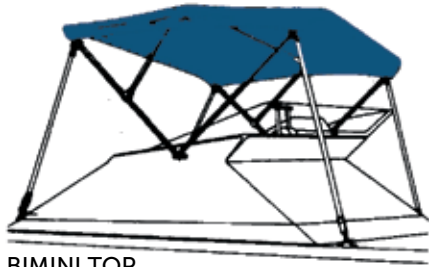
OPTIONS

Beam Width (In Feet)	7'	9'	10.5'	13.5'
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Zipper Pockets

2-bow	1 hr.	1.25 hrs.	1.5 hrs.	1.75 hrs.
3-bow	1.75 hrs.	1.5 hrs.	1.75 hrs.	2 hrs.
4-bow	2 hrs.	2.25 hrs.	2.5 hrs.	2.75 hrs.
5-bow	2.5 hrs.	2.25 hrs.	2.5 hrs.	2.75 hrs.

MORE OPTIONS

Straps (one pair)	0.5 hr.	
1 stay cutout	2 hrs.	
2 stay cutouts	3 hrs.	
Sailing window with cover	1.5 hrs.	
Storage boot	1.5 hrs.	

BIMINI TOP

» CONNECTORS

*A connector is any fabric product typically fastened at both ends via zippers or hardware that connect between two top products or between a top product and the boat. Length is limited to one

width of fabric. A connector can be between a bimini and an arch or windshield, or between a dodger and a bimini.

Beam Width (In Feet)	7'	9'	10'	13.5'
Canvas connector	4 hrs.	4.25 hrs.	4.5 hrs.	6 hrs.
Clear connector	5 hrs.	5.25 hrs.	5.5 hrs.	7 hrs.

» CONVERTIBLE TOP

*A convertible top is any top supported by framework that attaches to a windshield on the front edge. Times and materials listed are for a base product with no zipper pockets, enclosure

zippers, or any options. The times do not include manufacturing or installing the frame; they are for the canvas top only.

Beam Width (In Feet)	7'	9'	10.5'	13.5'
2-bow	7 hrs.	7 hrs.	9.5 hrs.	12.5 hrs.
3-bow	8 hrs.	8 hrs.	10.5 hrs.	14 hrs.

OPTIONS

Zipper walk-through	2 hrs.
Front panel clear insert	3 hrs.
Straps (one pair)	0.5 hr.



Beam Width (In Feet)	7'	9'	10.5'	13.5'
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Zipper Pockets

2-bow	1 hr.	1.25 hrs.	1.5 hrs.	1.75 hrs.
3-bow	1.75 hrs.	1.5 hrs.	1.75 hrs.	2 hrs.

BIMINI OPTION

Beam Width (In Feet)	7'	9'	10.5'	13.5'
Converts to a bimini	2 hrs.	2.5 hrs.	3 hrs.	3.5 hrs.

» STRUCTURED TOP/TEE TOP/BUGGY TOP

*These products consist of laced and banded tops on large welded structures of boats. Figures include the top only and not

the supporting structure, and are for a basic top without cutouts or any other options.

LACE-ON TOP

Length Of Top (In Feet)	6'	9'	12'	15'	18'
1 pass/width	4.5 hrs.	5 hrs.	5.5 hrs.	6.5 hrs.	8 hrs.
2 passes/widths	6.75 hrs.	7.25 hrs.	8 hrs.	8.5 hrs.	9.25 hrs.

BANDED TOP (fastened via trim, not lacing)

Length Of Top (In Feet)	6'	9'	12'	15'	18'
1 pass/width	6.5 hrs.	7 hrs.	7.5 hrs.	8 hrs.	8.5 hrs.
2 passes/widths	10 hrs.	11 hrs.	12 hrs.	13 hrs.	14 hrs.
3 passes/widths	12 hrs.	13 hrs.	14 hrs.	15 hrs.	16 hrs.

OPTIONS

Antenna mount	0.5 hr.
Radar mount on top (not including electrical)	1.5 hrs.

Cutout

Easy	0.5 hr.
Average	0.75 hr.
Difficult	1–2 hrs.

Reinforcing patch

Small	0.25 hr.
Medium	0.5 hr.
Large	1 hr.
Separate fitted panels	1.5 hrs.
U-zipper climb-through	2 hrs.



» TRADITIONAL DODGER

*These figures are for the cover of a dodger only. They do not include the frame structure times or any of the options listed

below. The roll-up front center window is standard on all dodgers.

Beam Width (In Feet)	4'	9'	10.5'	13.5'
2-bow	12.5 hrs.	14.5 hrs.	15.5 hrs.	18 hrs.
3-bow	15 hrs.	16 hrs.	17 hrs.	19 hrs.

CALIFORNIA DODGER

Beam Width (In Feet)	4'	9'	10.5'	13.5'
2-bow	15.5 hrs.	17.5 hrs.	18.5 hrs.	21 hrs.
3-bow	18 hrs.	19 hrs.	20 hrs.	22 hrs.

OPTIONS

Aft grabrail	1 hr.
Side grabrail	1 hr.
Aft zipper flap	0.5 hr.
Rope cutout	0.25–0.50 hrs.
Chafe patch	0.75–1.5 hrs.
Removable front	1.5 hrs.
Porthole window	0.75 hr.
Wing windows	1 hr.
Window covers	
Full-forward	1.5 hrs.
Individual	0.75 hr.
Zipper	1 hr.
Center grabrail	3 hrs.
Cellphone pockets	0.5 hr.



TRADITIONAL DODGER

» SPRAYHOOD

*Although these products usually are found on center-console boats, they recently have grown more common on bowrider-style boats. The labor figures are for the canvas top with a small

roll-up window in the front center, and do not include the frame structure. The basic times are for a standard product and do not include any options.

Mount Beam (In Feet)	4'	6'	8'	10'
2-bow	8 hrs.	9 hrs.	11 hrs.	12.5 hrs.
3-bow	9 hrs.	10 hrs.	12 hrs.	13.5 hrs.

OPTIONS

Mount Beam (In Feet)	4'	6'	8'	10'
Privacy drop	3 hrs.	3.5 hrs.	4 hrs.	4.5 hrs.
Privacy drop screens	1 hr.			
Front screen	1.5 hrs.			
3-piece enclosure zippers	1 hr.			
Sprayhood boot	1.5 hrs.			
Panoramic window	1.5 hrs.			



SPRAYHOOD

» AFT COVER

*An aft cover typically attaches to the aft edge of a top and angles down to close in the aft cockpit of the boat. It can be

attached with zippers or hardware to the flap of the forward top. The basic times do not include any of the options listed below.

Length (In Feet)	7'	9'	12'
2 passes	5 hrs.	6 hrs.	7.5 hrs.
3 passes	6 hrs.	7 hrs.	8.5 hrs.
4 passes	7 hrs.	8 hrs.	9.5 hrs.
5 passes	8 hrs.	9 hrs.	10.5 hrs.

OPTIONS

Window	1.5 hrs.
Window cover	1 hr.
Cutout	
Easy	0.25 hr.
Medium	0.5 hr.
Difficult	1 hr.
Zipper-off wings	2 hrs.
Reinforcing patch	
Small	0.25 hr.
Medium	0.5 hr.
Large	1 hr.

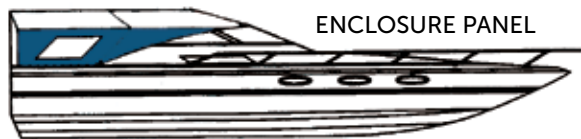


» ENCLOSURE PANEL

*Most enclosures can be classified into two levels of fabrication quality. A typical economy enclosure has binding, and the edges have fabric only on the outside. The deluxe enclosure panel is

covered on the inside and outside with clear vinyl sandwiched between the borders. Times for the enclosure panel do not include any of the options listed below.

Single Standard Panel (3- to 4-Foot Wide)		OPTIONS	
Economy	2.5 hrs.	U-zipper	
Deluxe	3 hrs.	Standard	1 hr.
Wide Panel (5- to 7-Foot Wide)		Large	1.5 hrs.
Economy	2.75 hrs.	Long Panel	
Deluxe	3.5 hrs.	Canvas lower half	0.5 hr.
Side Curtains Standard (27 by 54 Inches)		Clear lower half	1.5 hrs.
Economy	1.5 hrs.	Windshield panel	
Deluxe	3 hrs.	Canvas	1.5 hrs.
Large (48 by 84 Inches)		Clear	2.75 hrs.
Economy	1.75 hrs.	Cutout	
Deluxe	3.5 hrs.	In Canvas	0.75 hr.
		In Clear	1 hr.
		Screen Option	1 hr.
		Privacy Cover	
		Standard	0.75 hr.
		Wide	1 hr.
		Enclosure Cover	0.75 hr.



» MOORING AND TRAVEL COVER

★ Mooring and travel covers cover the entire boat all the way to the rubrail. A mooring cover, however, usually is fastened with fasteners,

while a travel cover attaches via a drawstring and tie-downs. The basic times do not include any of the options listed below.

Length (In Feet)	9'	15'	18'	21'	24'	27'	30'	30'+
2 passes	6 hrs.	7 hrs.	8 hrs.	9 hrs.	10 hrs.	11 hrs.	12 hrs.	13 hrs. +
3 passes	12 hrs.	13 hrs.	14 hrs.	15 hrs.	16 hrs.	17 hrs.	18 hrs.	19 hrs. +
4 passes	14 hrs.	15 hrs.	16 hrs.	17 hrs.	18 hrs.	19 hrs.	20 hrs.	20 hrs. +

OPTIONS

Length (In Feet)	9'
Reinforcing patch	
Small	0.25 hr.
Medium	0.5 hr.
Large	1 hr.
Cutout	
Easy	0.5 hr.
Difficult	1.5 hr.
Mooring pole assembly	0.25 hr.
Pulpit and bow rail	3 hrs.
Bow rail only	2 hrs.
Fitted panel	1.5 hrs.



MOORING AND TRAVEL COVER

» FLYBRIDGE COVER

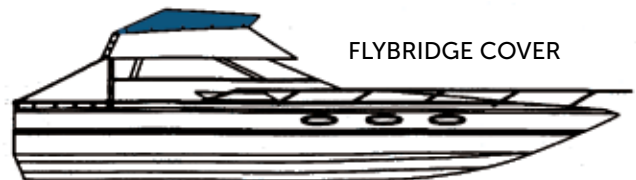
Length (In Feet)	6'	9'	12'	15'	18'
8' width	5 hrs.	6.5 hrs.	8 hrs.	9 hrs.	10 hrs.
10' width	6 hrs.	7.5 hrs.	9 hrs.	10.5 hrs.	12 hrs.
15' width	7.5 hrs.	9 hrs.	10.5 hrs.	12 hrs.	14 hrs.
20' width	9 hrs.	10.5 hrs.	12 hrs.	14 hrs.	16 hrs.

OPTIONS

Length (In Feet)	8'	10'	12'	15'	18'
Separate fitted panels	2 hrs.	2.25 hrs.	2.5 hrs.	3 hrs.	4 hrs.

MORE OPTIONS

Mooring pole assembly	0.25 hr.
Cutout	
Easy	0.5 hr.
Medium	1.25 hrs.
Difficult	1.75–2.5 hrs.
Reinforcing patch	
Small	0.25 hr.
Medium	0.5 hr.
Large	1 hr.



FLYBRIDGE COVER

» STANDARD COCKPIT COVER

*This product is divided into three classifications: standard cockpit covers, over-the-windshield covers and sportfishing

cockpit covers. The time figures are for a basic product without any of the options listed below.

Length (In Feet)	6'	9'	12'	15'	18'
2 passes	5 hrs.	6.75 hrs.	7.5 hrs.	8.5 hrs.	9.5 hrs.
3 passes	6.5 hrs.	8 hrs.	9 hrs.	10 hrs.	11 hrs.

OVER-THE-WINDSHIELD COVER

Length (In Feet)	6'	9'	12'	15'	18'
2 passes	6.75 hrs.	8.75 hrs.	9.5 hrs.	10.5 hrs.	11.5 hrs.
3 passes	9 hrs.	10 hrs.	11 hrs.	12 hrs.	13 hrs.

SPORTFISHING COVER

Length (In Feet)	6'	9'	12'	15'	18'
2 passes	6.5 hrs.	7 hrs.	7.25 hrs.	8 hrs.	8.5 hrs.
3 passes	7.5 hrs.	8 hrs.	8.25 hrs.	9 hrs.	9.5 hrs.
4 passes	8.5 hrs.	9 hrs.	9.25 hrs.	10 hrs.	10.5 hrs.

DETACHED WINGS (sportfish only)

Length (In Feet)	6'	9'	12'	15'	18'
Beam Length	–	4 hrs.	4.5 hrs.	5.5 hrs.	6.5 hrs.

OPTIONS

Cutout	1 hr.
Mooring pole	0.15 hr.
Reinforcing patch	
Easy	0.25 hr.
Medium	0.5 hr.
Difficult	1.5 hr.
Reinforcing patch	
Small	0.18 hr.
Medium	0.33 hr.
Large	0.5 hr.



STANDARD COCKPIT COVER

» WINDSHIELD COVER

*The time figures are for a basic cover with none of the options listed below.

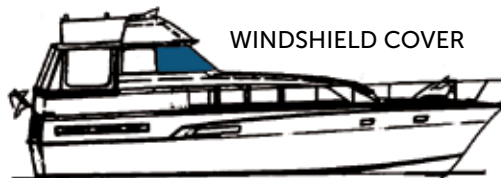
Length (In Feet)	2'	4'	6'	9'	12'	15'
1 pass	1.75 hrs.	2 hrs.	2.75 hrs.	3.5 hrs.	4.25 hrs.	4.5 hrs.
2 passes	3.25 hrs.	3.5 hrs.	4 hrs.	4.75 hrs.	5.5 hrs.	5.75 hrs.

OPTIONS

Length (In Feet)	2'	4'	6'	9'	12'	15'
Curved Window	0.16 hr.	0.33 hr.	0.3 hr.	0.66 hr.	0.83 hr.	1 hr.

Cutout

Easy	0.25 hr.
Medium	0.5 hr.
Difficult	1 hr.



WINDSHIELD COVER

CONSOLE COVER

*The standard console cover times shown below do not include any of the options listed. The sizes have been standardized to simplify the product category.

L x W x H (Feet)	HRS.
Small - 3' x 3' x 3.5'	3 hrs.
Medium - 5' x 5' x 5'	4 hrs.
Large - 6' x 6' x 6'	5.5 hrs.
Extra large > 6' x 6' x 6'	7+ hrs.

OPTIONS

Zipper release	1 hr.
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Cutout

Easy	0.25 hr.
Medium	0.75 hr.
Difficult	1.5 hrs.

Lined

Easy	0.5 hr.
Medium	0.75 hr.
Difficult	1 hr.

CHAIR COVER

Chair cover with drawstring	2.25 hrs.
Chair cover with fitted zipper	2.75 hrs.
Double-wide chair with drawstring	2.75 hrs.
Double-wide chair with fitted zipper	3.0 hrs.
Back-to-back	3.5 hrs.
Fighting chair with footrest	3.75 hrs.

OPTIONS

If pattern exists	-0.75 hrs.
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HATCH COVER

L" X W" (Inches)	HRS.
Small - 18" X 18"	0.75 hr.
Medium - 24" X 24"	1 hr.

OPTIONS

Install snaps	0.5 hr.
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FENDER COVER

Small	0.75 hr.
Medium	1 hr.
Large	1.25 hrs.
Extra large	1.75 hrs.

OPTIONS

Fitted ends with zipper	1 hr.
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MOTOR COVER

Small	1-50 Hp.	1.5 hrs.
Medium	50-100 Hp.	2 hrs.
Large	100 Hp. +	2.5 hrs.

OPTIONS

If pattern exists	-0.75 hr.
Lined	0.5 hrs.

INSTRUMENT COVER

All-canvas

Small	0.5 hr.
Medium	0.75 hr.
Large	1 hr.

Canvas with clear vinyl

Small	0.75 hr.
Medium	1 hr.
Large	1.25 hrs.

COMPANIONWAY COVER

Small	1.75 hrs.
Medium	2 hrs.
Large	3 hrs.
Extra large	3.5+ hrs.

WINCH COVER

Small	0.75 hr.
Medium	1 hr.
Large	1.25 hrs.
Extra large	1.5+ hrs.

PEDESTAL COVER

Small	0.75 hr.
Medium	1 hr.
Large	1.25 hrs.
Extra large	1.5+ hrs.

MAST BOOT

This is an aesthetic boot only; it is not the actual sealing boot.

Small	1.25 hrs.
Medium	1.5 hrs.
Large	2 hrs.

JIB BAG

Small	1.5 hrs.
Medium	2.5 hrs.
Large	3.5 hrs.
Extra large	4.0+ hrs.

WEATHER CURTAINS

Life-line panels	0.25 hr. per ft.
Lace or snap-on	0.5 hr. per ft.
Pocket and bar	1 hr. per ft.

Note: Add time for horizontal curves.

» SAIL COVER

*This sail cover is fastened in the front by a zipper and has fasteners along its lower border. The material may be cut out of a width of fabric (which is flipped over for the other half

of the sail cover). Headboard reinforcing is included in the times. The basic times do not include the options listed below.

Length (In Feet)	6'	9'	12'	15'	18'	24'	24'+
	4 hrs.	4.5 hrs.	5 hrs.	5.25 hrs.	5.5 hrs.	5.75 hrs.	6–8 hrs.

OPTIONS

Cutout	0.75 hr.	Reinforcing patch	
Vang skirt	1–2.5 hrs.	Small	0.25 hr.
Closed end on boom	0.5 hr.	Medium	0.5 hr.
Winch boot	0.75 hr.	Large	1 hr.

» CUSHIONS AND SEATINGS

*TIME INCLUDES: Cutting and sewing only. For options for cushions and seating, see page 42.

PLAIN BOXED

2'x2' Standard	2'x4' Medium	2'x6' Large	4'x6' XLarge	5'x7' XXLarge
Less than 1.5 hrs.	1.5 hrs.	3 hrs.	4 hrs.	5 hrs.

KNEE RISE

2'x2' Standard	2'x4' Medium	2'x6' Large	4'x6' XLarge	5'x7' XXLarge
2 hrs.	3 hrs.	4 hrs.	5 hrs.	5 hrs.

SEGMENTED TOP

2'x2' Standard	2'x4' Medium	2'x6' Large	4'x6' XLarge	5'x7' XXLarge
3.5 hrs.	4 hrs.	4.5 hrs.	5 hrs.	6 hrs.

ROLLED FRONT

2'x2' Standard	2'x4' Medium	2'x6' Large	4'x6' XLarge	5'x7' XXLarge
2 hrs.	2.5 hrs.	3 hrs.	3.5 hrs.	4.5 hrs.

V-BERTH CUSHIONS

5 to 7 feet long	More than 4 hrs.
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COCKPIT BUMPERS

Recover Existing	.5-hour per foot
New (including wood or plastic)	.5-hour per foot

UPHOLSTERED PANELS

Recover Existing	.5-hour per square foot
All New	.5-hour per square foot

UPHOLSTERED HELM CHAIR

Recover Existing	4–6 hrs.
All New	6–7 hrs.

BACK-TO-BACK SEAT

Recover Existing	8.25 hrs.
All New	11-13 hrs.

CORNER LOUNGE

Recover Existing	8 hrs.
All New	8 hrs.

BUCKET-STYLE-SEAT

Recover Existing	4–5 hrs.
All New	6–7 hrs.

LOUNGE BENCH SEAT

Recover Existing	7.5 hrs.
All New	10.5 hrs.

OPTIONS FOR CUSHIONS & SEATING

Add patterning time
Add extra time for graphics and/or difficult graphics
Add .25 hrs. to 1 hr. per cushion for welt / piping
Add 2.5 hrs. for each new radius cornerboard
Add 25% to labor times for fabrics that require a pattern match
Add .25 hr. for normal-style cutouts
Add .5 hr. for each beveled side
Add .5 to 1 hr. if cutting new foam
Add 2.5 hrs. for each new radius cornerboard
All New does not include difficult frame-building
Add time for installation
Add time for taking out staples and re-stapling

» GLOSSARY OF UPHOLSTERY TERMS

STRETCHER, TACK STRIP,

LISTING, PULL: Strip of material sewn into a seam on top of cushion, then sewn or stapled to the bottom of cushion to create and keep a shape in the cushion.

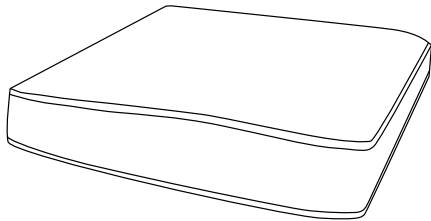
WELT, PIPING: Cord wrapped with a strip of material and sewn into a seam for strength or decorative purposes.

KNEE RISE CUSHION: Seat cushion that has a section typically 6-7" deep and 1" higher than the rest of the cushion located along the front edge.

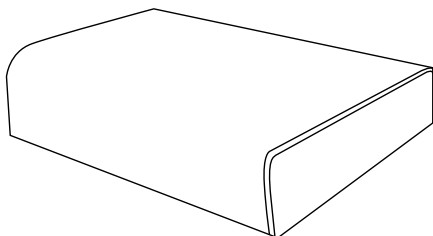
ACCORD CLOTH, DUST CLOTH: Lightweight material used to make patterns on foam for cushions or seats.

ROLL & PLEAT, TUCK & ROLL: Technique for sewing strips of vinyl together and to 1/2" foam at the same time to create a quilted stripe pattern. Similar to heat seamed roll n pleat.

BOX CUSHION



WATERFALL, BULLNOSE FRONT



TOP SEW: Seam allowance is turned to one side of the seam, then stitched to the cushion panel or boxing. Stitching is typically 1/8" or 1/4" from seam.

DOUBLE TOP, BUTTERFLY SEAM: Seam allowance is split. Each seam allowance is top sewn to each side of the seam. Typically 1/8" or 1/4" from seam.

FRENCH SEAM: Sew the seam wrong sides together, trim the seam allowance, then sew the same seam right sides together. (Used in fitted sheets.)

BOX CUSHION: The cushion is identified by a panel all around the cushion.

WATERFALL, BULLNOSE FRONT: A waterfall front or bull nose has a rolled front, or has fabric rolled over the edge with no seam.

» OTHER ACCESSORIES

*TIME INCLUDES: Cutting and sewing only.

HEADLINER

One hour per linear yard of fabric.

Note: Add extra time for unusual or difficult preparations and trim.

HULL LINER

One hour per linear yard of fabric.

Note: Add extra time for unusual or difficult preparations and trim.

CARPET RUNNERS

One hour per linear yard of fabric.

Note: Add extra time for steps and hatches

FURNITURE SLIPCOVERS

Barrel chair	4 hrs.
L-shaped couch	10 hrs.

FURNITURE REUPHOLSTERY

Barrel chair	8-12 hrs.
Simple barstool seat	1 hr.
Couch	16-20 hrs.
L-shaped couch	16-20 hrs.

CORNICES

Recover Existing	.25-hour per foot
All New	.50-hour per foot

Note: Add extra time for pattern-matching and difficult shapes.

Note: Add extra time for pleated and chirred faces.

DRAPERIES

Flat using tapes	.50-hour per foot of width
Pleated top	.75-hour per foot of width
Pleated top and bottom	1 hour per foot of width
Angle-pleated panel top	3 hrs.
Angle-pleated panel top and bottom	6 hrs.

Note: Add extra time for curved panels, cutouts and accent trims

BEDDING ACCESSORIES

	Twin	Queen or V-Berth
Throw-style spread	2.5 hrs.	4 hrs.
Fitted spread	3 hrs.	3.5 hrs.
Pillow sham	1.5 hrs.	2 hrs.
Fitted sheets set	2 hrs.	2 hrs.
Altered mattress pad	2 hrs.	2.5 hrs.

Note: Add extra time for difficult shapes, cutouts and inside corners.

Note: Deduct .75 hrs. from spread times if panels are already matched and sewn.

Note: Add extra time for fancy or detailed trimmings.