2023 MARINE FABRICATORS ASSOCIATION'S

TIME STANDARDS MANUAL

The Time Standards Manual was developed in 1996 by the Marine Fabricators Association (MFA), a division of the Advanced Textiles Association (formerly IFAI), to serve as a benchmark that 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.

2023 MFA TIME STANDARDS MANUAL

HOW IT WORKS

This 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 a specific project.

The manual also indicates re-cover estimates on boat 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

The category timetables do not include any of the options listed at the end of each 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. See example to the left:

Product

This bimini top on a sailboat requires a split mount to get around the winches. There are two backstays 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 bimini for easy removal.

According to this 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
- Patterning
- Order the materials
- Receive and pay for the materials
- Bend the frame
- Mount and fit the top
- Cut the top out
- Sew the top
- Install the top
- Bill and collect the money

Considerations Checklist:

These considerations are other product options to take into account when estimating overall time of a custom product. Here are some factors affecting the job time:

- Driving a substantial distance
- Different types of hardware: Common Sense, Lift the Dot, turns, snaps, zippers
- Replacing snaps in boat and installing new hardware
- The material fastener is being drilled into: fiberglass, wood, stainless steel, (stainless steel window), aluminum
- Specialty hardware
- Track installation: Different types of track may take more time
- Track removal: Do you have to remove track?
- Pattern times can vary
- Old versus new design
- Are vents needed?
- Flaps: rain, overlaps, zippers
- Prototyping
- Is there an electrical component involved in the project? Ask boat owner to remove electrical items such as antenna mount, radar mount (not including electrical), before doing the fabrication
- Is the boat going to be on land or in the water? This will change pattern and install.
- Is this a 1-or 2-person job?

ESTIMATE EXAMPLE

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

FRAME

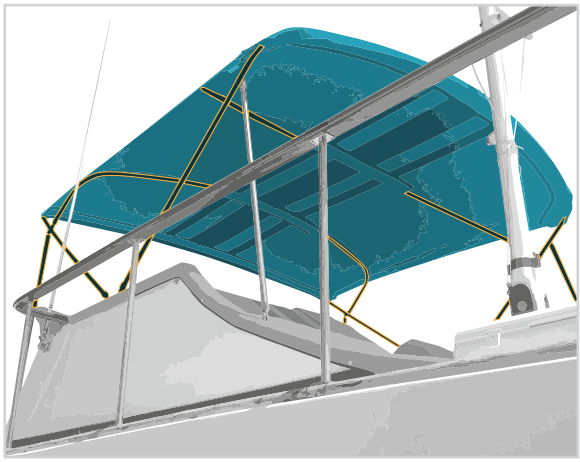
1-inch stainless steel frame	
4-bow bimini with a 9-foot beam	3 hrs.
Options: Split mount	0.75 hr.
Dog-leg for one frame	0.5 hr.
TOTAL FRAME HOURS	4.25 hrs.

TOP

4-bow bimini top with 10-foot beam	7 hrs.
Options: Zipper pockets	2 hrs.
2-stay cutout	3 hrs.
2 sailing windows	
2 x 1.50 hours	3 hrs.
Storage boot	1.5 hrs.
TOTAL TOP TIME	**16.50 hrs.**
TOTAL JOB TIME	**20.75 hrs.**

*Example based on average of 60" goods

FRAME STRUCTURE



» Bimini

1-INCH STAINLESS FRAME

Beam (In Feet)	7'	9'	10.5'	13.5'
1-frame	1.5 hrs.	1.5 hrs.	1.75 hrs.	2.5 hrs.
2-frame	2 hrs.	2.25 hrs.	2.5 hrs.	4 hrs.
3-frame	2.5 hrs.	2.75 hrs.	3 hrs.	5 hrs.
4-frame	3 hrs.	3.25 hrs.	3.5 hrs.	5 hrs.
5-frame	3.5 hrs.	3.75 hrs.	4 hrs.	6 hrs.

OPTIONS

Rigid supports (one pair)	1 hr.
Through-bolt mounts	0.75 hr.
Severe angle mounts	2 hrs.
Dog-leg frame	0.5 hr.
Split mount	0.75 hr.
Grab rail	0.5 hr.

*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: These times include the design, bending, assembly and installation of the frame onto the boat. They do not include any of the options listed, nor do they include any actual fit of the top.

ATTACHED BIMINI

Beam (In Feet)	7'	9'	10.5'	13.5'
1-frame	4.5 hrs.	5 hrs.	5.5 hrs.	7 hrs.
2-frame	7 hrs.	7 hrs.	9.5 hrs.	12.5 hrs.
3-frame	8 hrs.	8 hrs.	10.5 hrs.	14 hrs.
4-frame	9 hrs.	9.5 hrs.	12 hrs.	16 hrs.

OPTIONS

Beam (In Feet)	7'	9'	10.5'	13.5'
Attachment using Zipper and Keder	1	1.25	1.5	1.75
Straps (one pair)	0.5 hr.			
For odd-shaped arch:	Add 1.5 hrs.			

ZIPPER POCKETS

Beam (In Feet)	7'	9'	11'	13+
1-frame	0.5 hr.	0.5 hr.	0.75 hr.	0.75 hr.
2-frame	1 hr.	1 hr.	1.25 hrs.	1.25 hrs.
3-frame	1.5 hrs.	1.5 hrs.	1.75 hrs.	1.75 hrs.

OPTIONS

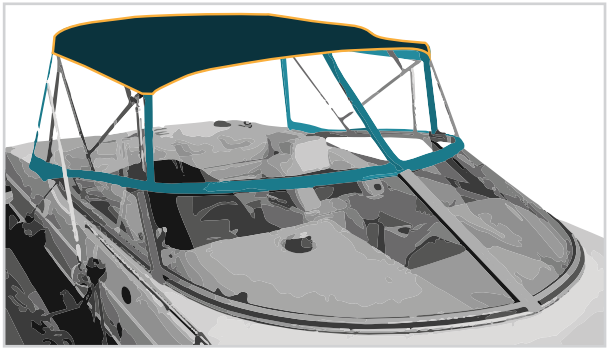
Zipper Walk-Through	2 hrs.
Front Panel Clear Insert	3 hrs.
Straps (one pair)	0.5 hr.

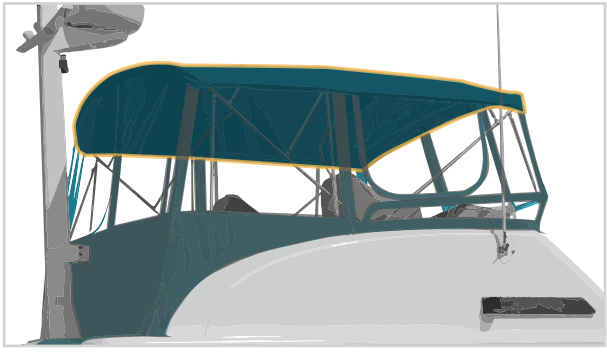
*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: An attached bimini is any top supported by framework and attached to either the boat, a radar arch or another top at one end. 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. 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.

» Attached Bimini and Enclosure

BIMINI TOP





» Bimini and Enclosure

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

ZIPPER POCKETS

Beam (In Feet)	7'	9'	10.5'	13.5'
2-frame	1 hr.	1.25 hrs.	1.5 hrs.	1.75 hrs.
3-frame	1.75 hrs.	1.5 hrs.	1.75 hrs.	2 hrs.
4-frame	2 hrs.	2.25 hrs.	2.5 hrs.	2.75 hrs.
5-frame	2.5 hrs.	2.25 hrs.	2.5 hrs.	2.75 hrs.

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.

*** SEE CONSIDERATIONS ON PAGE 26.

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

DODGER

TRADITIONAL DODGER

Beam Width (In Feet)	4'	6'	8'	10'
2-frame	13.5 hrs.	15.5 hrs.	16.5 hrs.	19 hrs.
3-frame	15 hrs.	17 hrs.	18 hrs.	20 hrs.

CALIFORNIA DODGER

Beam Width (In Feet)	4'	6'	8'	10'
2-frame	17.5 hrs.	19.5 hrs.	20.5 hrs.	23 hrs.
3-frame	18.5 hrs.	20.5 hrs.	21.5 hrs.	24 hrs.

OPTIONS

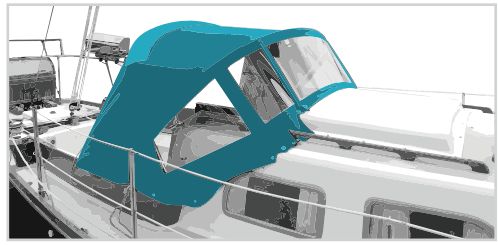
Aft Grabrail	1 hr.
Side Grabrail	1 hr.
Aft Zipper Flap	0.5 hr.
Rope Cutout	0.5 hr.
Chafe Patch	1 hr.
Removable Front	1.5 hrs.
Wing Windows	1 hr.

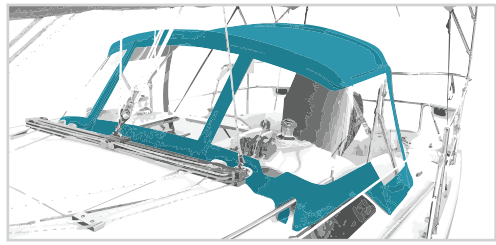
WINDOW COVERS

Full-Forward	1.5 hrs.
Individual	0.75 hr.
Storage Pockets	0.5 hr.

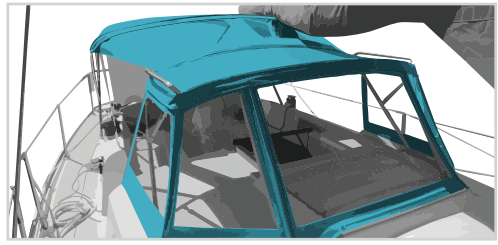
*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: These figures are for the cover of a dodger only. They do not include the frame structure times of any of the options listed. The roll-up front center window is standard on all dodgers.



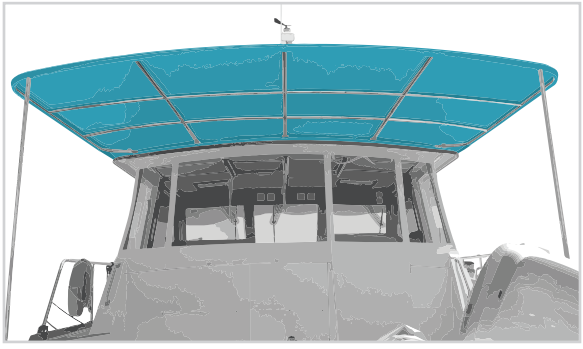


» Traditional Dodgers

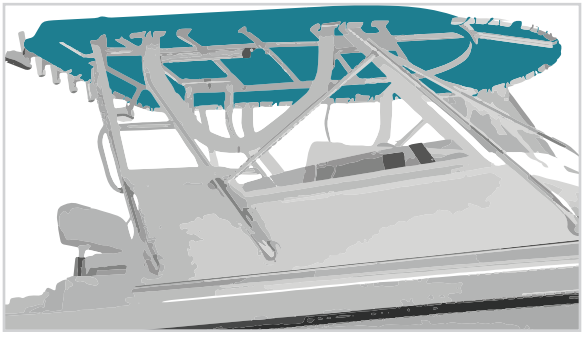


» California Style Dodger with Connector

STRUCTURED TOP/T-TOP/BUGGY TOP



» Banded Style T-Top



» Lace-On T-Top

LACE-ON TOP

Length Of Top (In Feet)	6'	9'	12'	15'	18'
1 width of fabric	4.5 hrs.	5 hrs.	5.5 hrs.	6.5 hrs.	8 hrs.
2 widths of fabric	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 width of fabric	6.5 hrs.	7 hrs.	7.5 hrs.	8 hrs.	8.5 hrs.
2 widths of fabric	10 hrs.	11 hrs.	12 hrs.	13 hrs.	14 hrs.
3 widths of fabric	12 hrs.	13 hrs.	14 hrs.	15 hrs.	16 hrs.

OPTIONS

CUTOUT	
Easy	0.5 hr.
Average	0.75 hr.
Difficult	1.5 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.

*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: 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.

AFT COVER/SLOPING BACK COVER/PALM BEACH COVER

AFT COVER

Length (In Feet)	7'	9'	12'
2 widths of fabric	7 hrs.	8 hrs.	9.5 hrs.
3 widths of fabric	8 hrs.	10 hrs.	12 hrs.
4 widths of fabric	9 hrs.	11 hrs.	13 hrs.

PALM BEACH COVER (Without Wings)

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

ATTACHED WINGS - PER PAIR

Length (In feet)	6'	9'	12'	15'	18'
Beam Length	6 hrs.	8 hrs.	10 hrs.	11 hrs.	12 hrs.

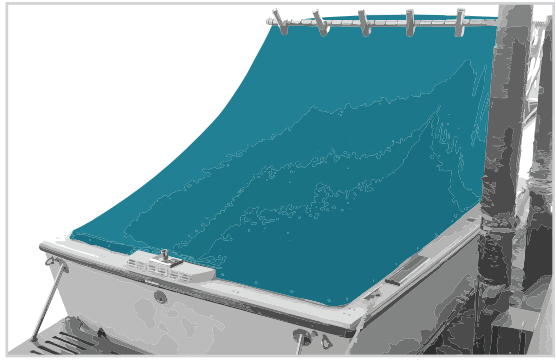
OPTIONS

Window	1 hr.	**Reinforcing patch**	
Window Cover	2 hrs.	Small	0.5 hrs.
Pin and Bungee	2 hrs.	Medium	0.75 hrs.
Zip-off Wings	2.5 hrs.	Large	1 hr.

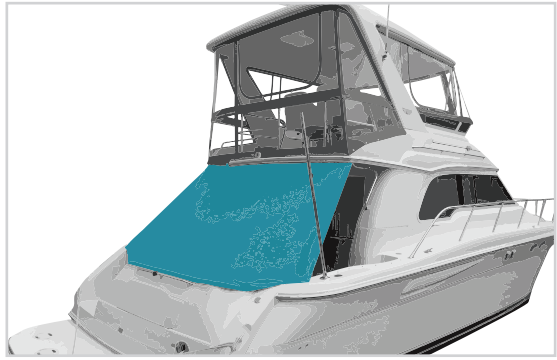
CUTOUT	
Easy	3 hrs.
Medium	1.5 hrs.
Difficult	1.5 hrs.

*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: An aft cover typically attaches to the aft edge of a top and angles down to close in the aft of the boat. It can be attached with zippers, hardware or track. The basic times do not include any of the options listed.



» Aft Cover/Sloping Back Cover/Palm Beach Cover

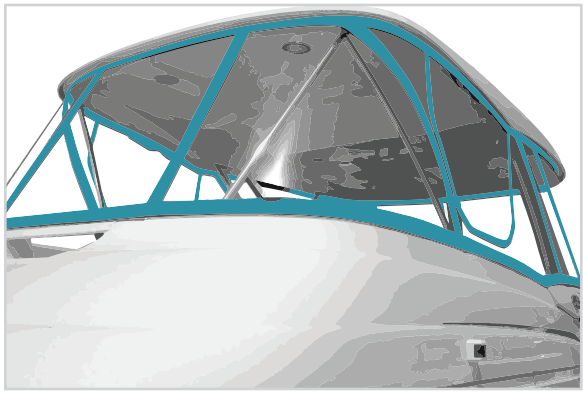


» Aft Cover/Sloping Back Cover/Palm Beach Cover

Note: Palm Beach Cover typically on Sportsfish style boat

ENCLOSURE PANEL

» Bimini Enclosure



» Enclosure

SINGLE STANDARD PANEL (3'—4' WIDE)	
Economy	2.5 hrs.
Deluxe	4 hrs.
WIDE PANEL (5'—7' WIDE)	
Economy	2.75 hrs.
Deluxe	4.5 hrs.
SIDE CURTAINS STANDARD (27"—54")	
Economy	1.5 hrs.
Deluxe	3 hrs.
SIDE CURTAINS LARGE (48"— 84")	
Economy	2 hrs.
Deluxe	4 hrs.

NOTE: 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.

OPTIONS	
U-zipper	
Standard	1 hr.
Large	1.5 hrs.
LONG PANEL	
Canvas lower half	1 hr.
Clear lower half	2 hrs.
Cutout	
In Canvas	0.75 hr.
In Clear	1 hr.
Screen Option	1 hr.
Privacy Cover	
Standard	0.75 hr.
Wide	1 hr.
Venturi	
Standard	0.5 hr.
Wide	0.75 hr.
Clear below	1 hr.
Curved Venturi	
Standard	1 hr.
Wide	1.5 hr.
Clear below	1.75 hrs.
Rigid Enclosure	
Polycarbonate (per window)	1+ hrs.
Acrylic	1+ hrs.

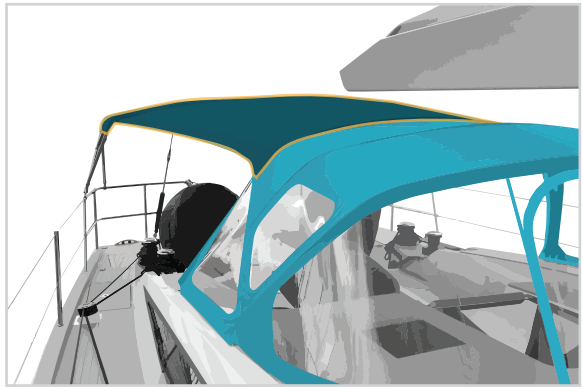
*** SEE CONSIDERATIONS ON PAGE 26.

CONNECTORS

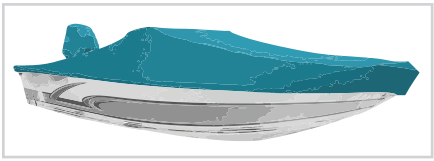
Beam (In Feet)	7'	9'	10.5'	13.5'
Canvas Connector	4 hrs.	4.25 hrs.	4.5 hrs.	6 hrs.
Clear Connector	5 hrs.	5.25 hrs.	5.5 hrs.	7 hrs.

*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: 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.

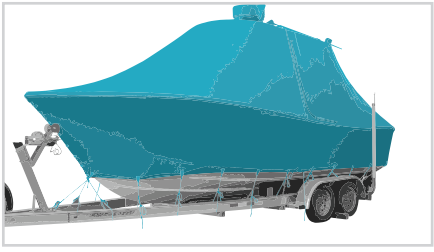


MOORING / TRAVEL / WINTER COVER



» Mooring Cover

» Travel/Storage Cover



» Winter Cover

Length (In Feet)	9'	15'	18'	21'	24'	27'	30'	30'+
2 widths of fabric	6 hrs.	7 hrs.	8 hrs.	9 hrs.	10 hrs.	11 hrs.	12 hrs.	13 hrs. +
3 widths of fabric	12 hrs.	13 hrs.	14 hrs.	15 hrs.	16 hrs.	17 hrs.	18 hrs.	19 hrs. +
4 widths of fabric	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.
Tie Straps (per strap)	0.25 hr.

*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: Mooring and travel covers cover the entire boat all the way to the rub rail. 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.

FLYBRIDGE COVER

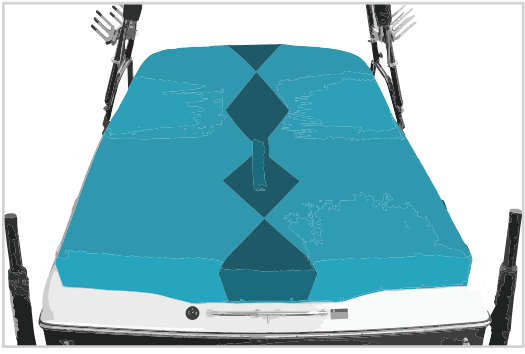
Length (In Feet)	6'	9'	12'	15'	18'
8' width	5 hrs.	6.5 hrs.	8 hrs.	9 hrs.	10 hrs.
10' width	6 hrs.	7.5 hrs.	9 hrs.	10.5 hrs.	12 hrs.
15' width	7.5 hrs.	9 hrs.	10.5 hrs.	12 hrs.	14 hrs.
20' width	9 hrs.	10.5 hrs.	12 hrs.	14 hrs.	16 hrs.
OPTIONS					
Length (In Feet)					
Fitted and Shaped Panels		1.5 hrs.	2.5 hrs.	3 hrs.	4 hrs.
Mooring Pole Assembly		0.25 hr.			
CUTOUT					
Easy		0.5 hr.			
Medium		1.25 hrs.			
Difficult		2.25 hrs.			
REINFORCING PATCH					
Small		0.25 hr.			
Medium		0.5 hr.			
Large		1 hr.			
VENTURI STYLE					
Easy		2 hrs.			
Medium		3 hrs.			
Difficult		4 hrs.			

*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: Flybridge covers are storage covers for when the boat is not in use. They cover the entire flybridge and often use the same hardware as an enclosure. These covers can often have more of a complex shape due to railings and windshields. The basic times do not include any of the options listed.

STANDARD COCKPIT COVER

» Cockpit Cover and Bow Cover



» Accessory Cockpit Cover with Graphics

Length (In Feet)	6'	9'	12'	15'	18'
2 widths of fabric	5 hrs.	6.75 hrs.	7.5 hrs.	8.5 hrs.	9.5 hrs.
3 widths of fabric	6.5 hrs.	8 hrs.	9 hrs.	10 hrs.	11 hrs.
OVER-THE-WINDSHIELD COVER					
Length (In Feet)	**6'**	**9'**	**12'**	**15'**	**18'**
2 widths of fabric	6.75 hrs.	8.75 hrs.	9.5 hrs.	10.5 hrs.	11.5 hrs.
3 widths of fabric	9 hrs.	10 hrs.	11 hrs.	12 hrs.	13 hrs.

OPTIONS	
CUTOUT	
Easy	0.25 hr.
Medium	0.5 hr.
Difficult	1.5 hr.
REINFORCING PATCH	
Small	0.15 hr.
Medium	0.33 hr.
Large	0.5 hr.
BOW COVERS	
Small	3 hrs.
Medium	3.5 hrs.
Large/Xlarge	4 hrs.

*** SEE CONSIDERATIONS ON PAGE 26.

NOTE: This product is divided into two classifications: standard cockpit covers and over-the-windshield covers. The time figures are for a basic product without any of the options listed.

WINDSHIELD COVER

Length (In Feet)	2'	4'	6'	9'	12'	15'
1 width	2 hrs.	2.5 hrs.	3.25 hrs.	4 hrs.	4.75 hrs.	5 hrs.
2 widths	4 hrs.	4.25 hrs.	4.75 hrs.	5.5 hrs.	6.25 hrs.	6.75 hrs.
Each additional seam	0.5 hr.	0.5 hr.	0.5 hr.	0.5 hr.	0.5 hr.	0.5 hr.

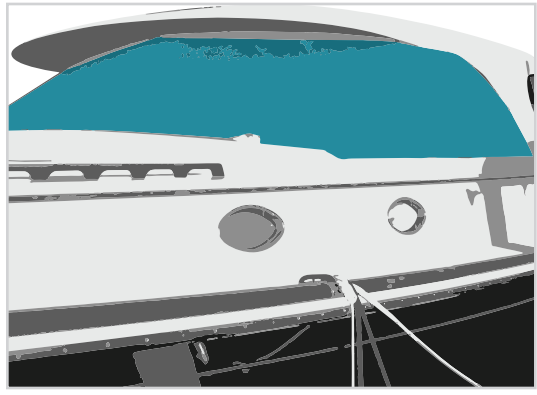
OPTIONS

Length (In Feet)	2'	4'	6'	9'	12'	15'
Curved Window	0.5 hr.	0.5 hr.	0.75 hr.	1 hr.	1.25 hr.	1.5 hr.

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

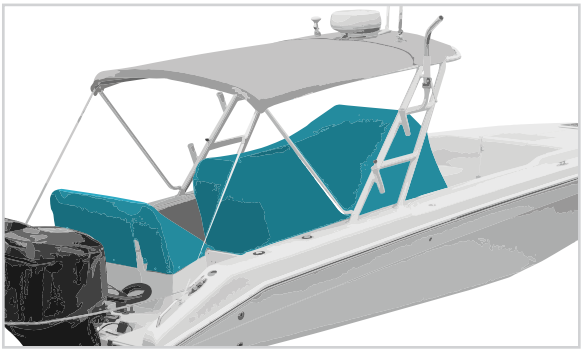
NOTE: The time figures are for a basic cover with none of the options listed.

*** SEE CONSIDERATIONS ON PAGE 26.



» Accessory-Windshield Cover

FULL CONSOLE COVER



» Accessory–Seat and Console Cover

NOTE: 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 ' (In Feet)	HOURS
Small - 3' x 3' x 3.5'	4 hrs.
Medium - 5' x 5' x 5'	5 hrs.
Large - 6' x 6' x 6'	6 hrs.
Extra large > 6' x 6' x 6'	7+ hrs.
OPTIONS	
Zipper release	1 hr.
CUTOUT	
Easy	0.25 hr.
Medium	0.75 hr.
Difficult	1.5 hrs.
LINED	
Easy	0.5 hr.
Medium	1 hr.
Difficult	1.5+ hrs.

ADDITIONAL COVERS

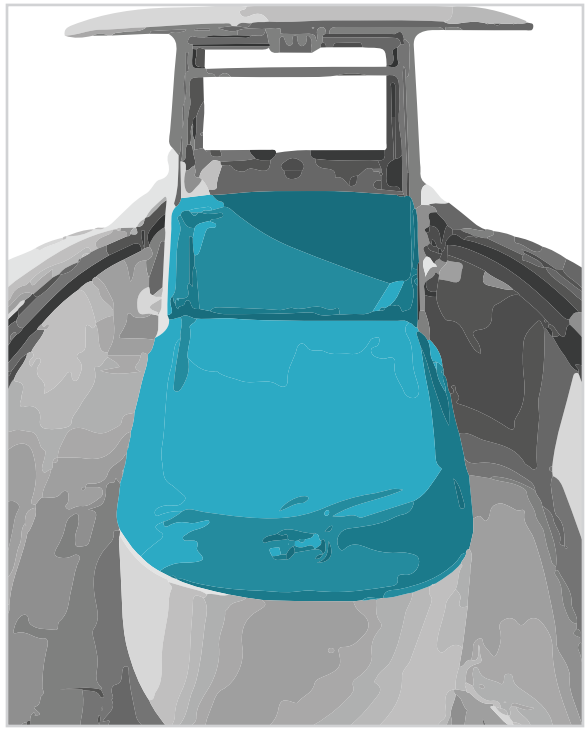
CHAIR COVER / SEAT COVER	HOURS
With Drawstring	3 hrs.
With Fitted Zipper	3.5 hrs.
Double-Wide with Drawstring	4 hrs.
Double-Wide with Fitted Zipper	4.5 hrs.
Back-to-Back	3.5 hrs.
Fighting Chair with Footrest	4.5 hrs.
Leaning Post	4 to 5 hrs.
OPTIONS	

HATCH COVER	
L" X W"	HOURS
Small - 18" X 18"	0.75 hr.
Medium - 24" X 24"	1 hr.
OPTIONS	
Install snaps	0.5 hr.

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.

MOTOR COVER	
Small	4 hrs.
Medium	4.5 hrs.
Large	5 hrs.
OPTIONS	
Lined	1 hr.

*** SEE CONSIDERATIONS ON PAGE 26.



» Accessory–Seat Cover

ADDITIONAL COVERS CONTINUED

BASIC INSTRUMENT COVER	HOURS
Small	1 hr.
Medium	2 hrs.
Large	3 hrs.

COMPANIONWAY COVER	
Small	1 hr.
Medium	2 hrs.
Large	3 hrs.
Extra large	3.5 hrs.

WINCH COVER	
Small	1 hr.
Medium	1.25 hrs.
Large	1.5 hrs.
Extra large	1.75 hrs.

PEDESTAL COVER	
Small	1.5 hrs.
Medium	2.25 hrs.
Large	3 hrs.
Extra large	4.5 hrs.

MAST BOOT	HOURS
Small	1.25 hrs.
Medium	1.5 hrs.
Large	2 hrs.

JIB BAG	
Small	2 hrs.
Medium	2.5 hrs.
Large	3.5 hrs.
Extra large	4 hrs.

WEATHER CURTAINS/LEE CLOTH	
Life-line panels	0.5 hr.
Lace or snap-on	1 hr.
Pocket and bar	1 hr.

NOTE: Add time for horizontal curves.

SAIL COVER

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.	7 hrs.

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

NOTE: 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.

*** SEE CONSIDERATIONS ON PAGE 26.

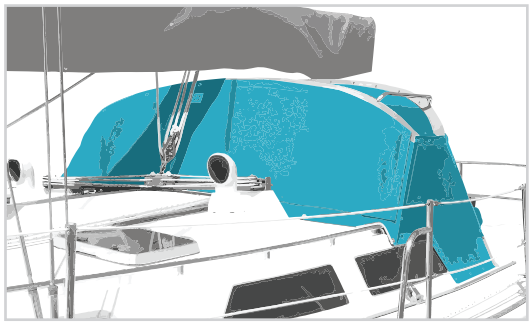
TRACK

Length (In Feet)	8'
Straight	1 hr.
Simple Curve/Bend	1.25 hrs.
Tight Curve/Bend using heat	1.5 hrs.
Aluminum Track	0.75 hr. (Add to the above times.)
Caulking and Sealing	0.25 hr.

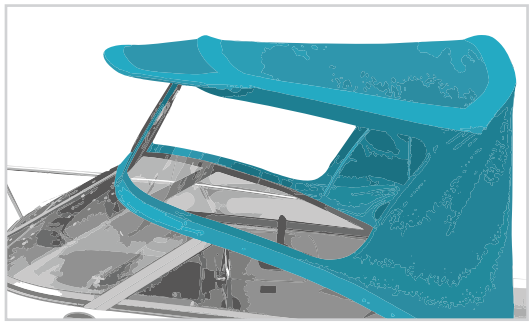
NOTE: Installation of track on boat with one person. Times are based on 8' section. The times consider set-up time on boat.

*** SEE CONSIDERATIONS ON PAGE 26.

ACCESSORIES

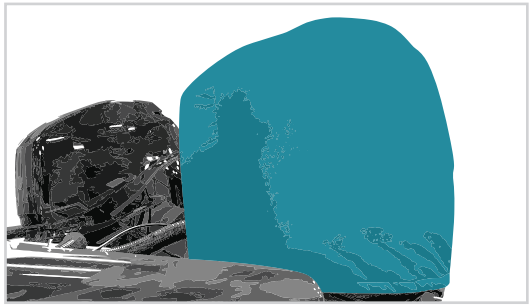


» Accessory–Window Protection for Dodger



» Accessory–Visor for Bimini

NOTE: An accessory is a special item requested by the boat owner to dress up the boat. Sometimes referred to as "boat bling," these add-ons can be either a simple small-ticket item, or a complex piece requiring additional time and skill.



» Accessory–Engine Cover

» Accessory–Sunfly

CUSHIONS AND SEATINGS

PLAIN BOXED (In Feet)

2' x 2' Standard	2' x 4' Medium	2' x 6' Large	4' x 6' XLarge	5' x 7' XXLarge
Less than 1.5 hrs.	1.5 hrs.	3 hrs.	4 hrs.	5 hrs.

KNEE RISE (In Feet)

2' x 2' Standard	2' x 4' Medium	2' x 6' Large	4' x 6' XLarge	5' x 7' XXLarge
2 hrs.	3 hrs.	4 hrs.	5 hrs.	5 hrs.

SEGMENTED TOP (In Feet)

2' x 2' Standard	2' x 4' Medium	2' x 6' Large	4' x 6' XLarge	5' x 7' XXLarge
3.5 hrs.	4 hrs.	4.5 hrs.	5 hrs.	6 hrs.

ROLLED FRONT (In Feet)

2' x 2' Standard	2' x 4' Medium	2' x 6' Large	4' x 6' XLarge	5' x 7' XXLarge
2 hrs.	2.5 hrs.	3 hrs.	3.5 hrs.	4.5 hrs.

NOTE: Time includes cutting and sewing only. For options for cushions and seating, see page 36.

V-BERTH CUSHIONS (In Feet)

5 - 7 feet long	More than 4 hrs.

COCKPIT COAMING PADS AND BOLSTERS

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 AND SEATING
Add patterning time
Add extra time for graphics and/or difficult graphics
Add .25 hr. 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 AND PLEAT, TUCK AND ROLL: Technique for sewing strips of vinyl together and to ½" foam at the same time to create a quilted stripe pattern. Similar to heat sealed roll and pleat.

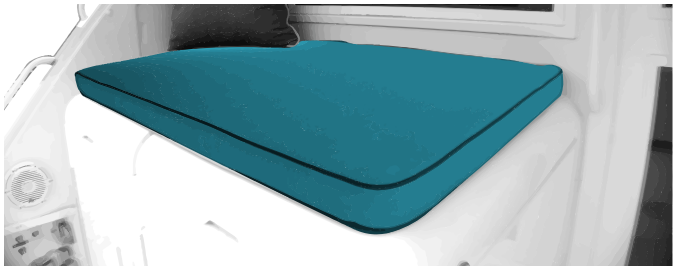
TOP SEW: Seam allowance is turned to one side of the seam, then stitched to the cushion panel or boxing. Stitching is typically 1/8" or ¼" from seam.

DOUBLE TOP, BUTTERFLY SEAM: Seam allowance is split. Each seam allowance is top sewn to each side of the seam. Typically 1/8" or ¼" from seam.

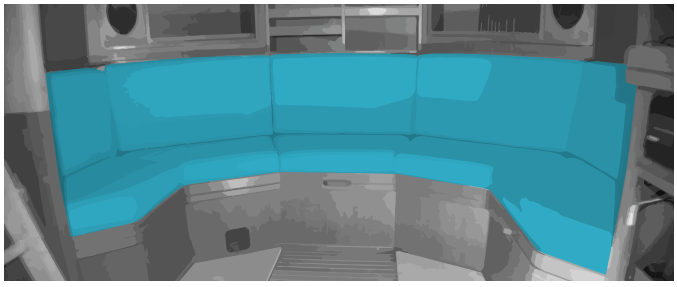
FRENCH SEAM: Sew the seam wrong sides together, trim the seam allowance, then sew the same seam right sides together. (Used in fitted sheets.)

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

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



» Box Cushion



» Waterfall, Bullnose Front

OTHER ACCESSORIES

HEADLINER

NOTE: Time includes cutting and sewing only.

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 shirred 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.