National Marine Fisheries Service
TED Technology Transfer Program
P.O. Drawer 1207
Pascagoula, MS 39568-1207

TED CONSTRUCTION AND INSTALLATION

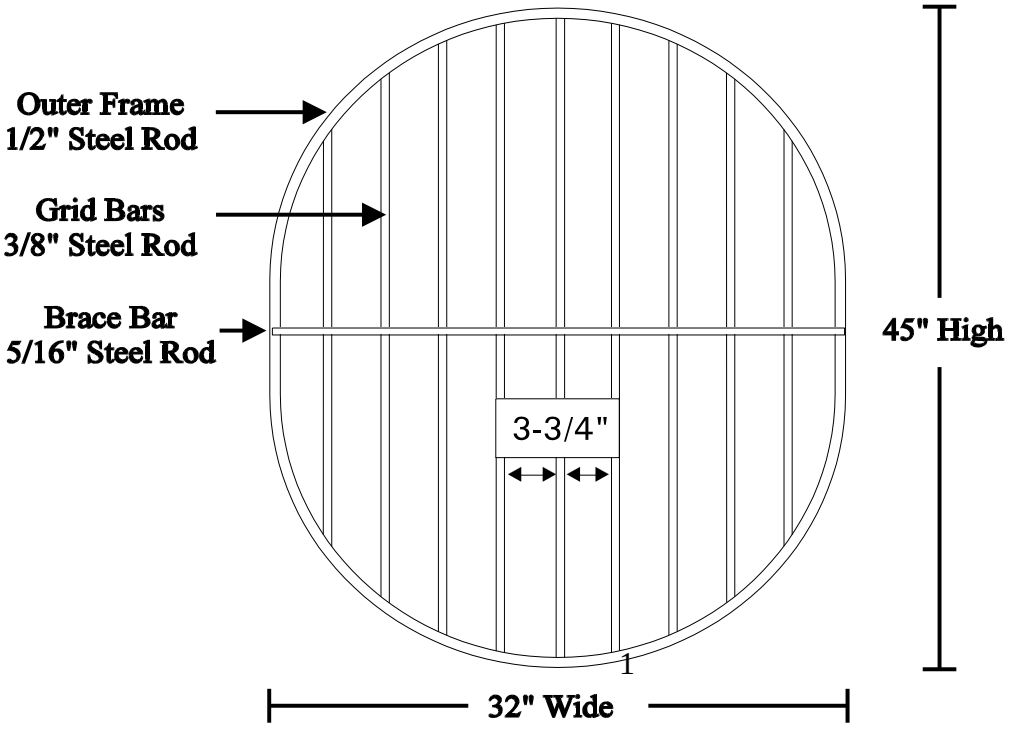
"Standard Steel TED"

1. CONSTRUCTION OF THE FRAME (FIG. 1)

A single oval frame is constructed of 1/2-inch cold rolled steel 45-inches in height by 32-inches in width. The grid bars are constructed of 3/8-inch cold rolled steel and are welded to the inside of the frame 3-3/4 inches apart (4-1/8 inch centers).

Across the center of the frame and attached to each vertical grid bar is a brace bar constructed of 5/16-inch cold rolled steel. The brace bar should extend behind the face of the grid 2-1/2 to 3-inches. The brace bar gives added strength to the device.

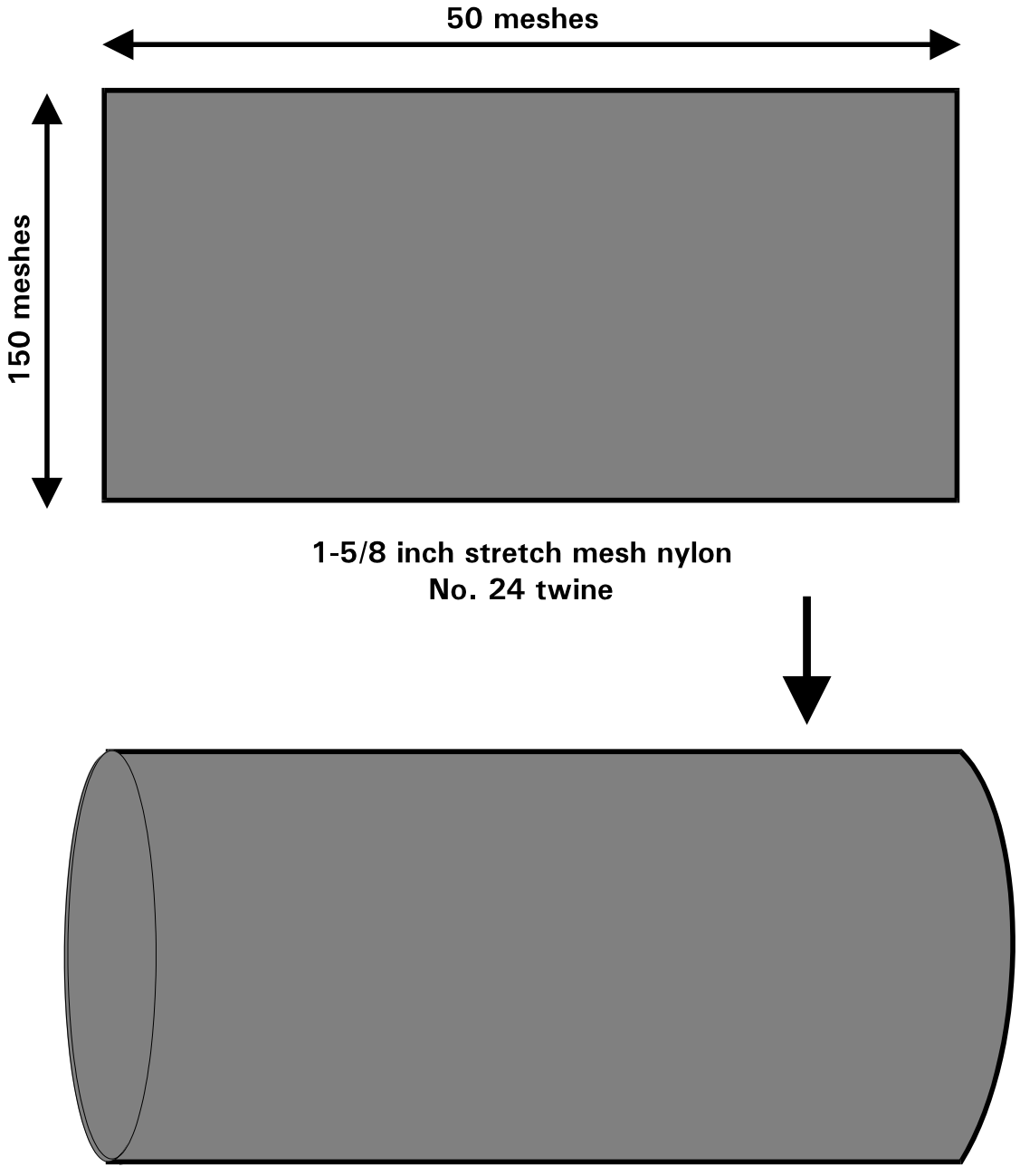
All metal in the device should be hot dipped galvanized.



2. INSTALLATION OF THE FRAME IN THE WEBBING EXTENSION

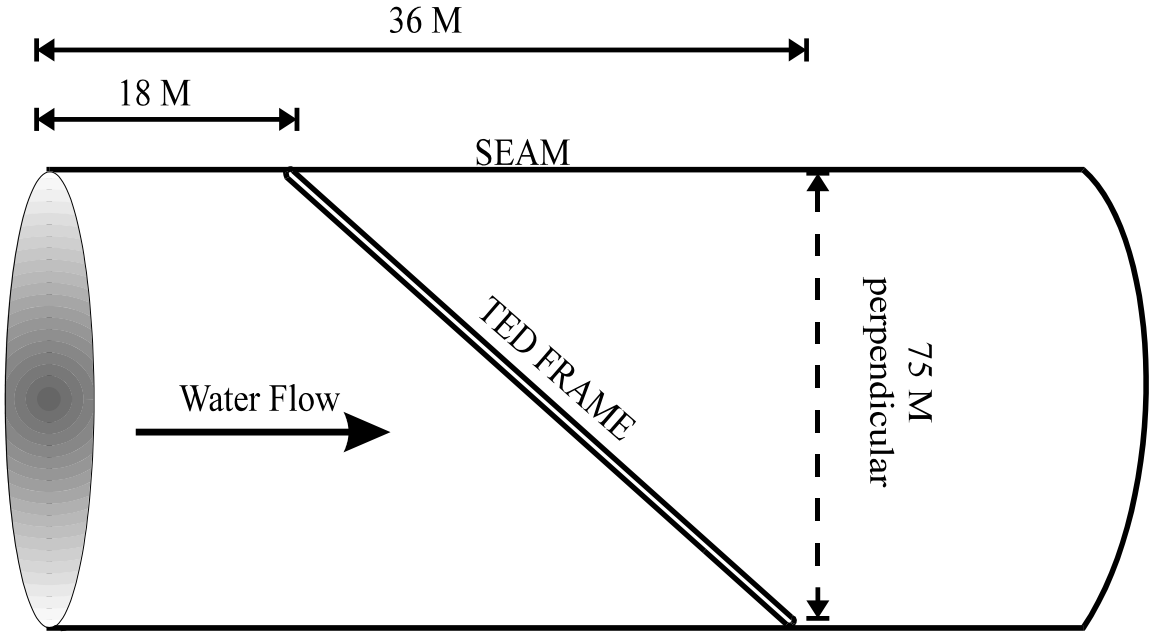
A. CONSTRUCTING THE TRAWL EXTENSION (FIG. 2)

The trawl extension is constructed from a single piece of 1-5/8 inch stretch mesh nylon webbing, No. 24 twine, 150 meshes wide by 50 meshes deep. Form a tube from the extension webbing by sewing the 50 mesh size sides of the piece together.



3. <u>OBTAINING THE CORRECT GRID ANGLE (FIG. 3)</u>

Slide the TED frame into the extension. Lace a metal hoop into each end of the extension. Using the metal hoops, stretch the extension tube so it is taut and the extension seam is positioned along the top. Starting at the leading edge of the extension, count back 18 meshes along the seam and attach the top center of the TED frame to the webbing. In order to find the bottom center attachment point for the frame, (opposite end of the center grid bar) count 36 meshes along the top seam from the leading edge of the extension. From this point count 75 meshes perpendicular from the seam to arrive at the bottom center attachment point. The sides of the device are then sewn evenly from the top attachment point to the bottom attachment point.

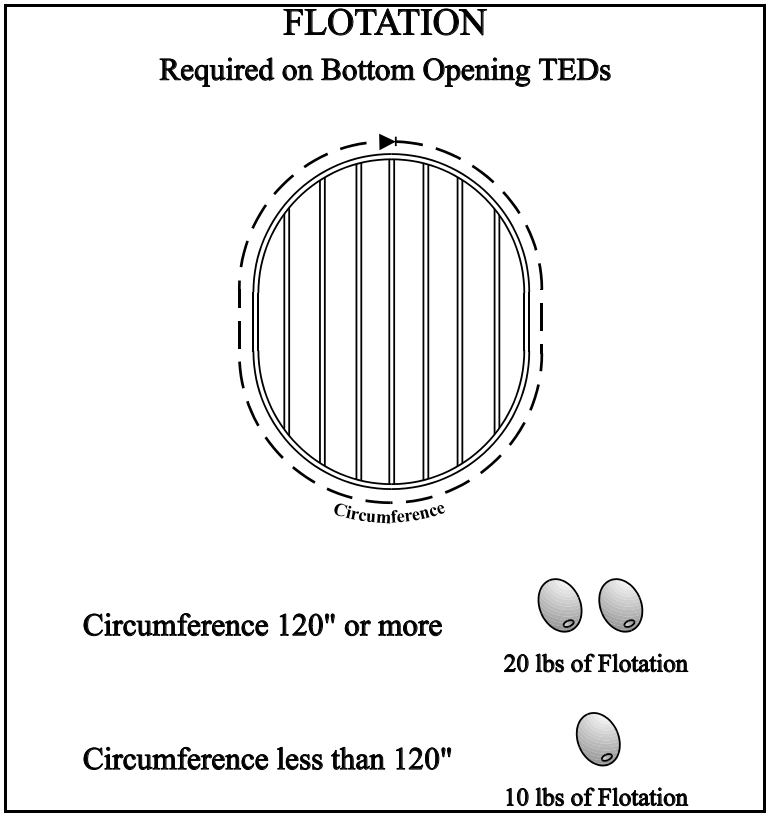


4. **Cutting the exit hole** (see options for **Escape Openings**)

5. **Chafing gear and floatation**

To prevent chafing of the webbing around the TED, a 40 ft section of 1/2 inch polypropylene rope is laced around the frame through every other mesh.

Attach one (2) 7 inch X 9 inch floats (10 lbs floatation ea.) to the outside of the TED for weight compensation and stabilization of the device.



6. For further information on **Funnels, Chafing Webbing, Rib Lines** etc. refer to **Allowable Modifications**

NOTE: SUBSTITUTION OF MATERIALS SPECIFIED IN THESE INSTRUCTIONS, ESPECIALLY WEBBING SIZE, COULD RESULT IN UNSATISFACTORY PERFORMANCE OF THE DEVICE.