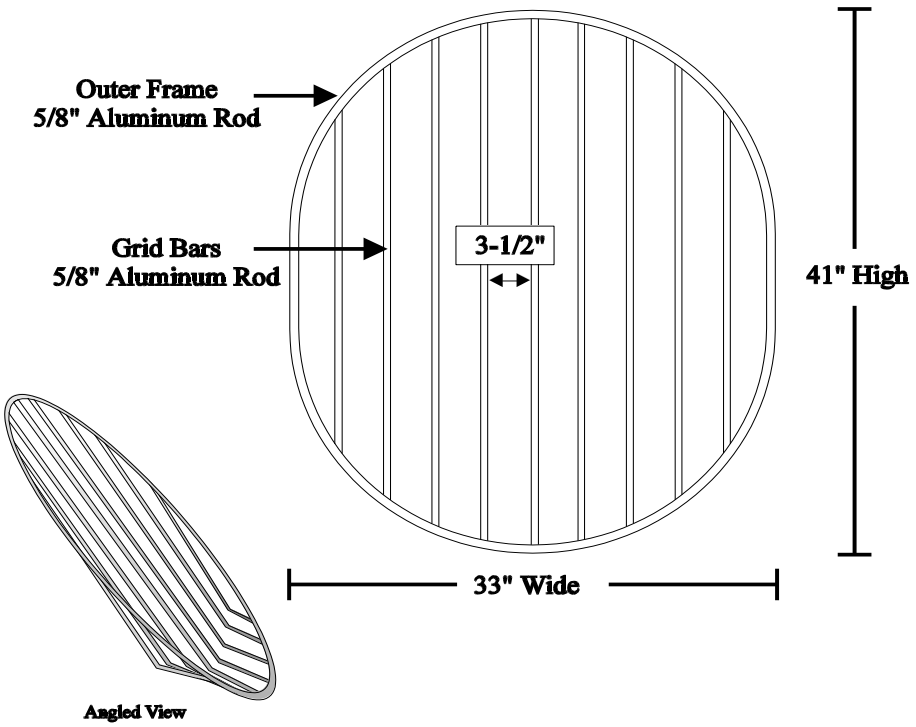
National Marine Fisheries Service
TED Technology Transfer Program
P.O. Drawer 1207
Pascagoula, MS 39568-1207

TED CONSTRUCTION AND INSTALLATION

"BENT ROD TED (mid-size)"

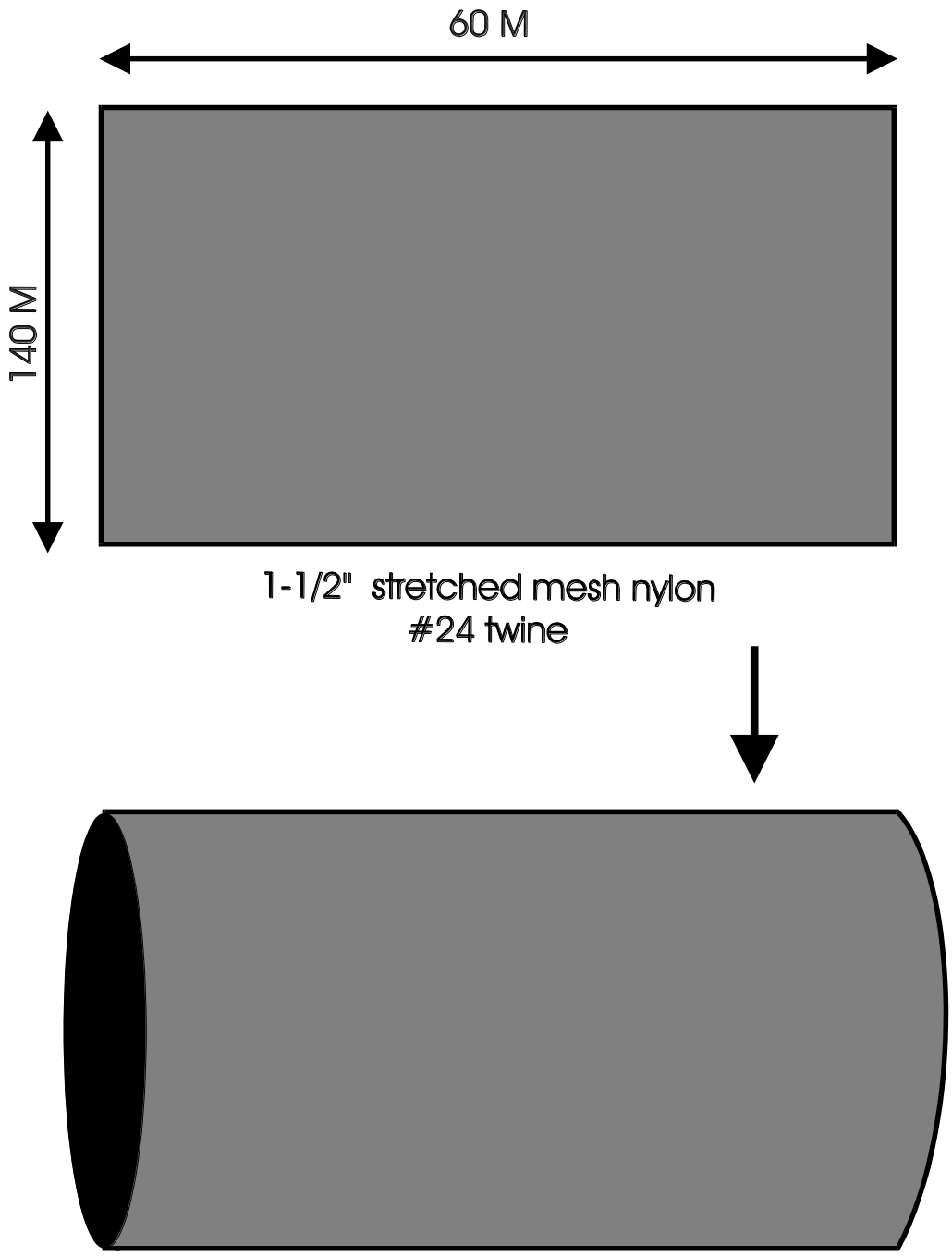
1. Construction of the Frame

A single oval frame is constructed measuring 41 inches high by 33 inches wide. The outer ring of the frame is constructed of 5/8 inch solid aluminum rod. The vertical grid bars are constructed of 5/8 inch solid aluminum rod welded to the inside of the frame 3-1/2 inches apart (4-3/16 inch centers). Each vertical grid bar has a 45 degree bend just above the bottom of the TED frame to help keep the device free of debris.



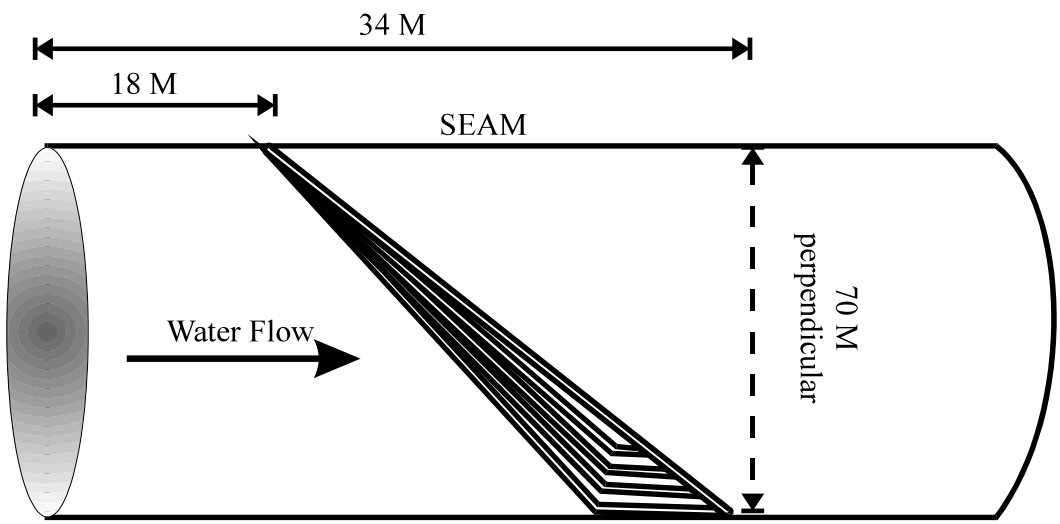
2. Construction of the TED extension

The TED extension is constructed from a single piece of 1-1/2 inch stretched mesh nylon webbing, #24 twine, which is 60 meshes by 140 meshes. Construct a cylinder from the piece by sewing the 60 mesh sides together.



3. Obtaining the correct grid angle

Slide the 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. Position the stretched extension so 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, count 34 meshes along the seam from the leading edge of the extension. From this point count 70 meshes perpendicular from the seam to arrive at the bottom center attachment point. Attach the TED frame to the extension at this point. Once the bottom of the TED frame has been attached to the extension, the sides of the device are then sewn evenly from the top attachment point to the bottom corners of the TED frame. The grid angle should be 50-55° from horizontal.

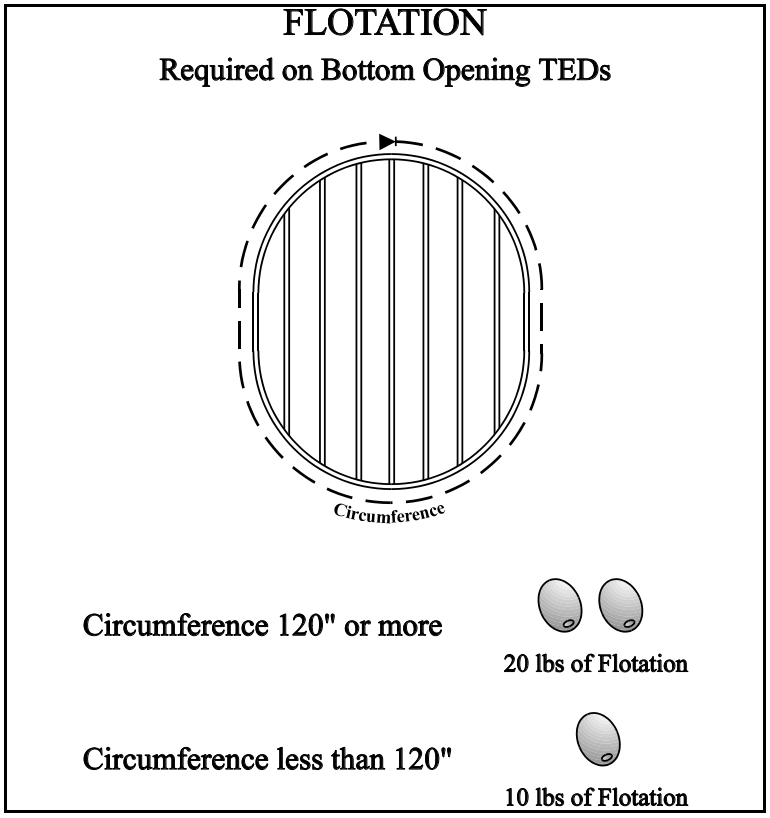


4. **Cutting the exit hole** (see **Escape Openings**)

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.