

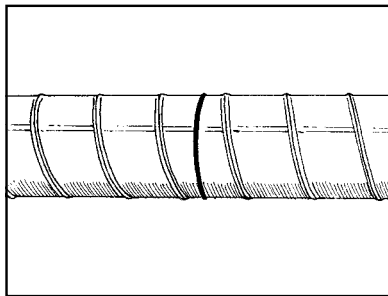


Materials and equipment

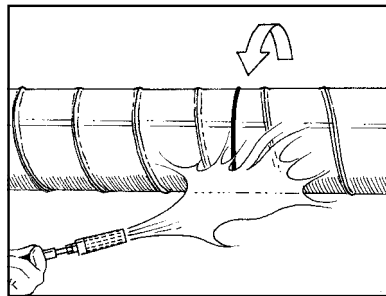
1. Raychem TWDB (supplied with high temperature closure tape)
2. Raychem torch (or equivalent)
3. Propane gas tank, regulator and hose
4. Gloves

Recommended TWDB tape widths

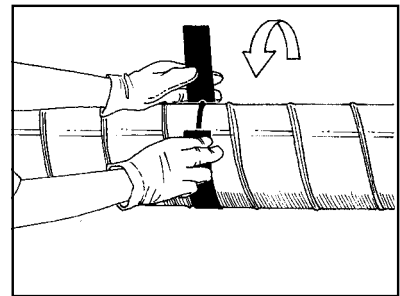
- | | |
|------------------------|-----------|
| Duct to Fitting to 24" | -2" width |
| Duct to Fitting > 24" | -3" width |
| Duct to Duct ≥ 12" | -2" width |
| Duct to Duct 14-48" | -3" width |
| Duct to Duct > 48" | -4" width |



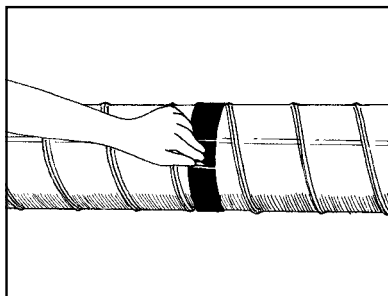
Join duct sections using internal couplers or crimped end male/female type connection. Apply sheet metal screws. 2 screws 180° apart are usually sufficient.



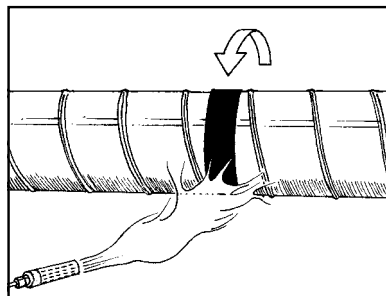
Wipe joint area to remove foreign materials. Preheat joint to remove moisture and burn off surface oil that may be present.



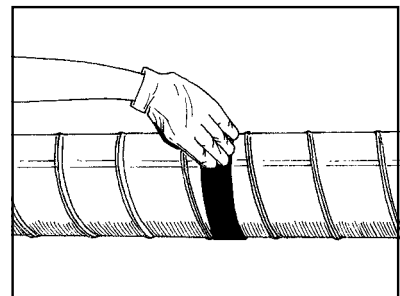
Cut TWDB to appropriate length. See sizing chart on reverse side. Center TWDB and wrap around duct joint.



Using the Tyco Adhesives supplied high temperature tape, secure the loose TWDB end by taping in place.



Using a standard propane torch, heat TWDB on all sides until it has shrunk uniformly and adhesive is showing at each end.



Smooth down the overlap area with gloved hand to ensure proper contact to duct. Note: See reverse side for rectangular and flat oval duct.

TWDB*

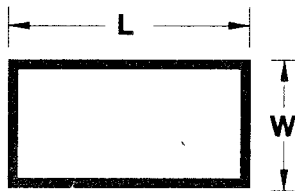
TWDB sizing chart

Round duct

* Cut length includes a 2 inch overlap required to insure proper sealing.

Duct size	TWDB cut length*	Duct size	TWDB cut length
2"	9"	30"	97"
3"	12"	32"	103"
4"	15"	34"	109"
5"	18"	36"	115"
6"	21"	38"	122"
7"	24"	40"	128"
8"	28"	42"	134"
9"	31"	44"	141"
10"	34"	46"	147"
11"	37"	48"	153"
12"	40"	50"	160"
14"	46"	52"	166"
16"	53"	54"	173"
18"	59"		
20"	65"		
22"	72"		
24"	78"		
26"	84"		
28"	90"		

Rectangular duct

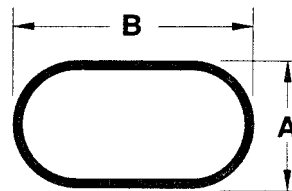


TWDB may be used to seal rectangular ducting. The proper length to cut is shown below.

Length of TWDB
 $= 2 + \text{Perimeter}$
 $= 2 + 2(L+W)$
 Dimensions in inches.

Note:
 Be sure to measure outer dimensions as size on print often refers to internal dimensions.

Flat oval duct



TWDB may be used to seal flat oval ducting. The proper length to cut is shown below.

Length of TWDB
 $= 2 + \text{Circumference}$
 $= 2 + 2.2\sqrt{A^2 + B^2}$
 Dimensions in inches.

Note:
 Be sure to measure outer dimensions as size on print often refers to internal dimensions.

Rectangular size	Length of TWDB (inches)
6 x 4	22
6 x 6	26
8 x 4	26
8 x 6	30
8 x 8	34
10 x 4	30
10 x 6	34
10 x 8	38
10 x 10	42
12 x 4	34
12 x 6	38
12 x 8	42
12 x 10	46
16 x 8	50
16 x 12	58
16 x 16	66
20 x 8	58
20 x 12	66
20 x 16	74
20 x 20	82

Flat oval	Length of TWDB (inches)
3 x 8	21
3 x 9	23
3 x 11	28
3 x 12	30
3 x 14	34
3 x 15	36
4 x 7	20
4 x 9	24
4 x 10	26
4 x 12	31
4 x 13	33
4 x 15	37
6 x 8	25
6 x 9	26
6 x 11	30
6 x 12	32
6 x 14	36
8 x 10	31
8 x 11	33
8 x 13	36
10 x 12	37

Note:

Install TWDB on rectangular and flat oval duct following the procedures for round duct with the following additional step: Immediately after shrinking is complete, press down the still hot TWDB with roller or gloved hand on flat sections.