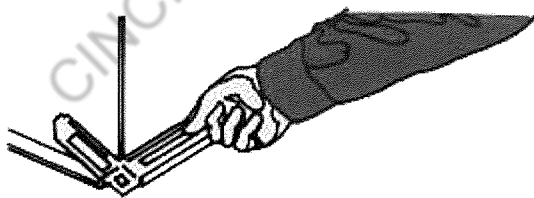
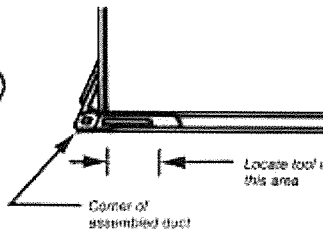
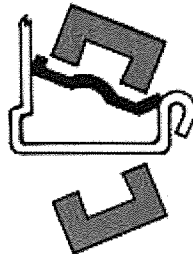


**Typical installation of T.D.C. corners with the Iowa Precision Shop Tool**



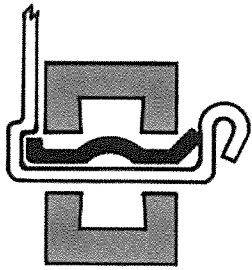
**1.**  
 Place a corner into T.D.C. flanges after duct is knocked together and partially squared.



**2.**  
 Place tool over corner and flange, one jaw on the corner and one on the T.D.C. Jaws of the tool should be centered on the corner.

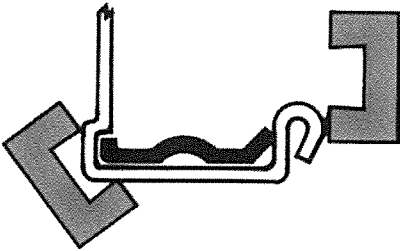
# IPI T.D.C. Shop Tool

3.



Squeeze tool handles together until the corner snaps into the groove on the back side of the T.D.C. flange.

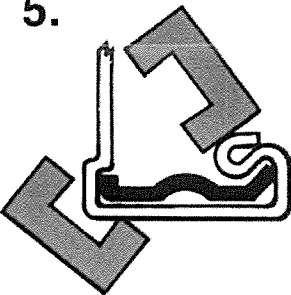
4.



Open jaws halfway, roll tool towards inside of the duct to hook jaw on inside of the groove. Opposite jaw's back leg should line up with the hem on the outside of the T.D.C. flange.

*Note: Keep tool close to the corner of the duct for ease of bending over the hem side. This is necessary on 18 gauge.*

5.

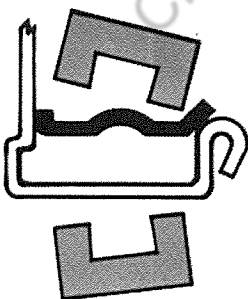


Squeeze tool handle to bend hem over in order to hold corner in place.

6.

Open jaws and remove tool. Check to see that the inside of the corner is to the outside of the corner brake of the duct. This insures that the second corner will line up with T.D.C. flange.

7.

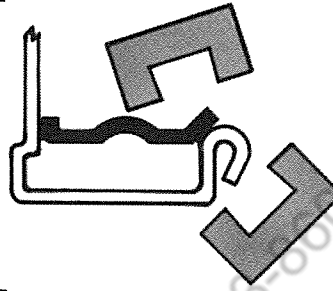


Repeat the process in step 2. The corner is in a different position than when the first side was installed, but it will work the same way. Repeat steps 3, 4, and 5.

## Damaged flanges or heavy gauge (18 and 20 gauge)

Also use this procedure on light metal duct. It is easier and faster.

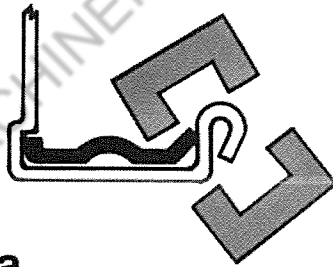
8.



With the front teeth (legs), grab the corner near the hem lip on the angle edge and the other jaw will line up on the T.D.C. flange near the end.

9.

Squeeze tool handles and at the same time pull tool to the outside of the duct. You will hear the corner snap into place.



*Note: When the corner is in place, squeeze the angle side again to set it down as far as possible. This procedure makes it easier to fold the hem over.*

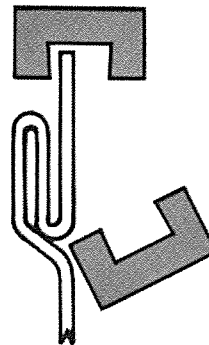
9a.

Repeat steps 4 and 5. Both sides of the corner have been installed.

## Repairing damaged T.D.C. flanges

1. Hold the damaged flange as though you were going to put in a corner.
2. Squeeze handles together.
3. Twist from side to side. The flange will open.
4. Install new corner.

## Opening Pittsburghs



1.

Put the inside of the top jaw on the inside of the Pittsburgh flap. Put the bottom jaw on the outside of the Pittsburgh flap past the groove formed on the flap.

2.

Pull until the Pittsburgh is open wide enough to put the male side in.

