

DATE 7/18/57
SH. 1 OF _____
COMPILED BY
O.I.P.

TMC SPECIFICATION NO. S-337

TITLE: WINDING AND TAPPING OF TOROIDAL INDUCTORS

JOB

APPROVED

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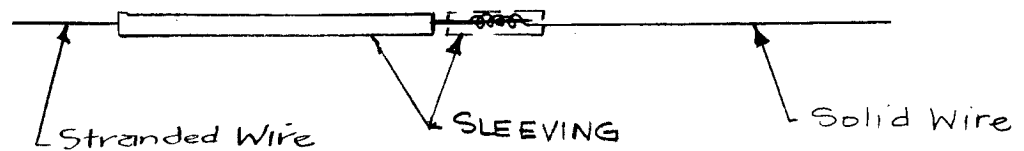
REFERENCE: All toroidal inductors not containing a terminal strip mounted directly on the coil.

OBJECT: To avoid breakage of leads and taps by shock, vibration and mishandling. Stranded wire leads must be used on all such toroids.

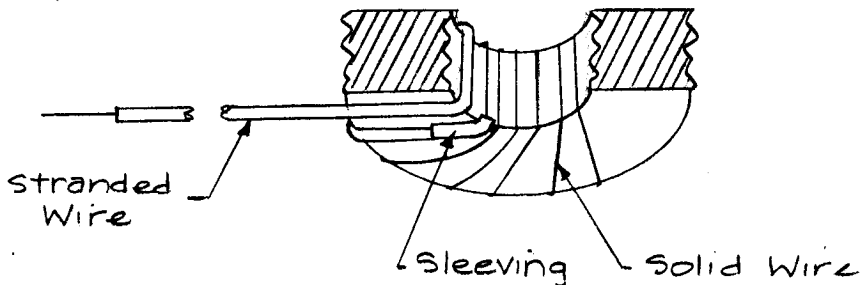
WINDING PROCEDURE:

A. START

1. Slip a short piece of tubing over the solid magnet wire.
2. Join the solid wire with the stranded wire, solder and push the tubing over the joint as shown.

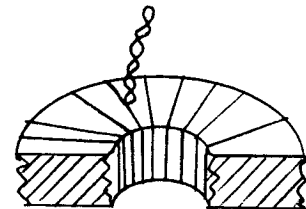


3. The stranded wire must make one full turn around the core as shown.



B. TAP

1. Leave a loop, about 2", of solid wire at the point where tap must be inserted as shown.



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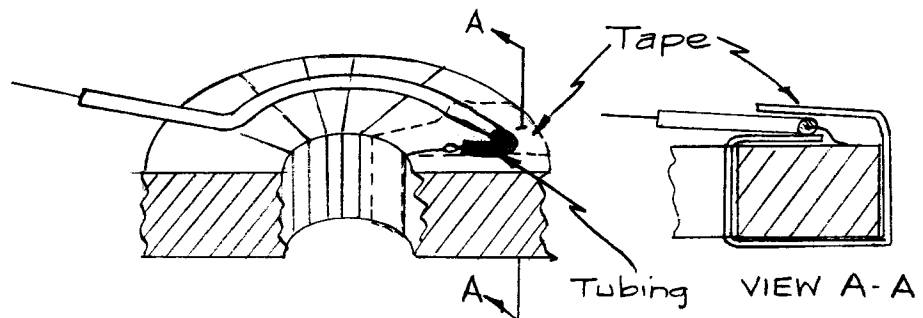
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2. Splice, solder and pull the tubing over the splice as shown in A - 2.
3. Tape the splice with a single layer to the core. Be sure that there is no tension exerted on the solid wire.
4. Place the stranded tap half way around the toroid as shown.
Note: Do not loop the stranded wire around the core.



C. FINISH

1. After the toroid has been wound and cut to the specific value, (or resonated) remove one turn of solid wire and splice it with the stranded wire as described in "A". The joint must not be farther than $\frac{1}{4}$ " away from the coil.
2. Allow the stranded wire to make one full turn around the coil as shown and tape the finish lead with a single layer of tape to the core.

