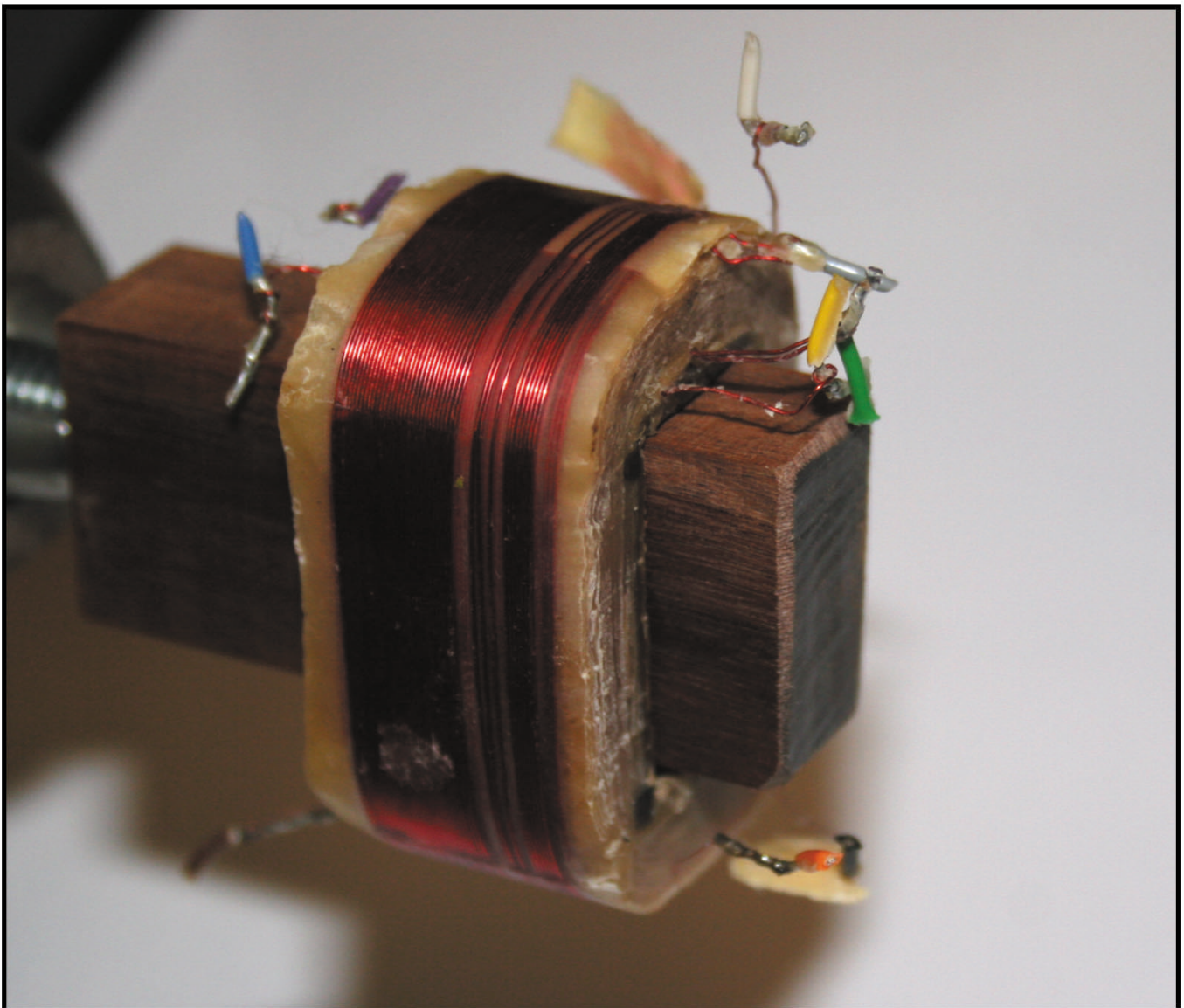


subsequent layers were wound in the same rotation direction. The photo in Fig 25 shows that the last layer that was originally wound had a smaller number of winds. When the number of wraps needed to complete a full wind are short of a complete layer, it is considered proper to spread the last windings out to cover the full width of the coil. That is what Triad did here and that is generally the technique most manufacturers use to deal with short layers.

### *The unwinding begins*

The unwinding begins at the white lead of the secondary. The gauge of the secondary wire is 31 and the winding sheet uses the the suffix SN after the gauge. Winding these layer coils requires a decent winding machine. The spacing between each wrap is critical and it's very important that the wind is even with absolutely no wire crossovers as the wind progresses from one end of the coil to the other. A winding machine with an accurate adjustable traverse is mandatory.



**Fig. 25** A better view of the coil on the unwinder.