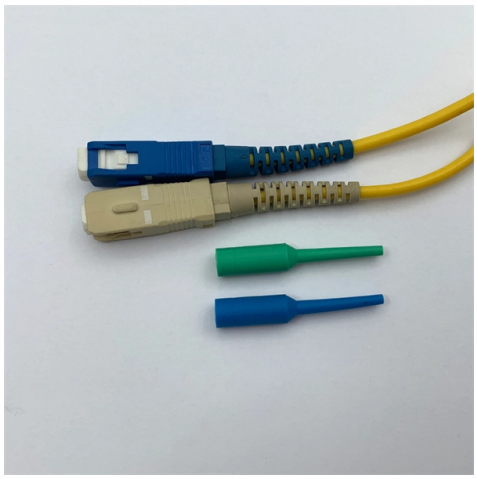
# Method for winding pigtail tubes



## Overview

Compared with the prior art, the present invention facilitates the orderly arrangement of the pigtails, and avoids the different sizes of the rings formed by free winding, which cause the wires...

## Key Takeaways

A pigtail tube can be formed by carefully winding the tube around a mandrel or jig, using controlled rotation and axial guidance to achieve a smooth, uniform coil without kinks.

### Tools and Setup

Winding Jig or Mandrel: Select a jig with a diameter slightly larger than the tube's outer diameter to prevent deformation. For copper capillary tubes, specialized winding machines can automate rotation and tension control. Rotary Spindle: Provides controlled rotation of the tube around the jig, allowing precise shaping of the pigtail.

Tube Support: Ensure the tube is supported along its length to avoid bending or kinking during winding.

### Winding Procedure

Secure the Tube: Insert one end of the tube onto the mandrel or jig. Apply Gentle Tension: Maintain slight tension to keep the tube in contact with the jig while preventing stretching. Rotate the Tube: Use a rotary spindle or manual rotation to wind the tube around the jig in a smooth, continuous motion.

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Axial Adjustment: Move the tube axially along the jig if forming a tapered or barrel-shaped pigtail, ensuring uniform spacing between coils. Check for Kinks: Inspect the tube during winding; any sharp bends can compromise flow or structural integrity. Release and Inspect: Once the desired number of turns is achieved, carefully remove the tube from the jig and verify the coil shape.

### Tips for Success

Lubrication: For metal tubes, a light lubricant can reduce friction and prevent scratching. Temperature Considerations: Some metals, like copper, are easier to bend when slightly warmed. Consistent Speed: Maintain a steady rotation speed to ensure uniform coil diameter.

Practice on Scrap Tubing: Before working on the final piece, practice winding to perfect technique. By following these steps, a smooth, functional pigtail coil can be produced for applications in refrigeration, HVAC, or laboratory setups, ensuring proper flow and mechanical stability.

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