

Method for coiling wide-striped helical spirals is carried out using a mandrel, a roller, the machine's drive chuck and an axial slot in which the bent end of the strip is secured using a sleeve. A strip is installed in the gap between the left and right oblique bushings on the mandrel. The bent end of the strip is secured, which is inserted into the axial slot machined on the left end surface of the right oblique bushing, and secure the left oblique bushing—with its smaller-diameter side—in the machine's drive chuck. The mandrel on the left side is secured in the pneumatic cylinder so that it can rotate and move axially after the pneumatic cylinder is activated and after the coiling process is complete. When secured in the axial slot, the strip is positioned flush against the rotating sleeve, which is mounted in the machine tool's support; the left oblique sleeve is partially housed within it on the right side, and the right oblique sleeve is fully housed within it; additionally, the strip is placed along the outer end surface in a guide roller, which is positioned to rotate in a circular motion in the lower part of the rotating sleeve and secured in the lathe's support. Next, the machine's drive chuck with the left oblique sleeve is set in rotation. A wide-strip helical spiral is coiled from a strip using a rotating mandrel. During the coiling process, the clamping force and the offset of the left oblique mandrel relative to the stop washer are adjusted and limited by nuts.