

INSPECTION REQUIREMENTS

RELAYS

111 (PART OF 163), 121, 122, 125, 149, 162, 178, AND 179 TYPE(S)

(ROUND TYPE)

GENERAL EQUIPMENT REQUIREMENTS

COMMON SYSTEMS

TABLE 800-668-184

Lot Range		A	B	C	D	E	F	G	H
Lot Size (total number of relays)		1	201	301	601	901	1201	1501	2001
in lot)		200	300	600	900	1200	1500	2000	3000
Sample Size (relays) (see note 1)		All	180	260	300	340	370	400	440
Inspection Item (see note 1) (For requirements, refer to Section 040-219-701 and sections of Division 800.)	Basis for Counting Defects	Allowable Defect Number							
		AN	AN	AN	AN	AN	AN	AN	AN
1. Functional, Numerical, and Group Designations (on cover and on spool head)	Relay	Record all defects found. See note 2.							
2. Relay Mounting	"	0	2	3	3	4	4	4	5
3. Cover Fit and Tightness of Cover Nut	"	0	3	5	5	6	7	8	9
4. Application of Separator per KS-7246	"	0	2	3	3	4	4	4	5
5. Contact Alignment	"	0	2	3	3	4	4	4	5
6. Armature Stud Clearance	"	0	2	3	3	4	4	4	5
7. Traveling Spring Position	"	0	2	3	3	4	4	4	5
8. Stop Spring Position	"	0	2	3	3	4	4	4	5
9. Flexible Front Contact Spring Position	"	0	2	3	3	4	4	4	5
10. Straightness of Springs (see note 3)	"	0	2	3	3	4	4	4	5
11. Separation Between Springs	"	0	2	3	3	4	4	4	5
12. Tightness of Locknut	"	0	2	3	3	4	4	4	5
13. Armature Alignment	"	0	2	3	3	4	4	4	5
14. Armature Travel	"	0	2	3	3	4	4	4	5
15. Contact Pressure	"	0	2	3	3	4	4	4	5
16. Stud Gap	"	0	2	3	3	4	4	4	5
17. Contact Separation	"	0	2	3	3	4	4	4	5
18. Contact Follow	"	0	2	3	3	4	4	4	5
19. Spring Sequence	"	0	2	3	3	4	4	4	5
20. Electrical Requirements	"	0	3	5	5	6	7	8	9
21. Timing Requirements		See note 4.							
22. Relay Insulated From Mounting Plate	"	0	2	3	3	4	4	4	5

AN = Allowable Number of defects in sample

SPOTTINESS TABLE

Size of Subsample	3	26	71	126	176	201	251	301	351
	25	70	125	175	200	250	300	350	400
SN	2	3	4	6	7	8	10	11	12
SN = Spottiness Number (applying to subsamples).									

Note 1: Verification of this type of relay is not required except when test results or other evidence indicates an unsatisfactory condition of adjustment.

Note 2: For each type of defect recorded, sufficient additional inspection shall be made to insure elimination of the irregularity of the equipment involved.

Note 3: Where the AN number of Inspection Item 10 is not exceeded, correction of defects for this item may be omitted. Where the AN number is exceeded, the case shall be reviewed with the operating company people to determine the corrective measure to be taken.

Note 4: Where timing requirements are applied, complete check shall be made in all cases either as a part of the verification or of the testing procedures.

For detailed explanation and use of tables, refer to Section 800-668-180.

REASONS FOR REISSUE

To reduce the sample size requirements based on the process average quality of the manufactured product and to add a new note 1.