

INSPECTION REQUIREMENTS
RELAYS
280 TYPE
GENERAL EQUIPMENT REQUIREMENTS
COMMON SYSTEMS

TABLE 800-668-186

Lot Range		A	B	C	D	E	F	G	H	I	J	K
Lot Size (number of relays in lot)		1 200	201 300	301 600	601 900	901 1200	1201 1500	1501 2000	2001 3000	3001 5000	5001 7000	7001 10,000
Sample Size (relays)		All	180	260	300	340	370	400	440	400	560	700
Inspection Item (see note 1) (For requirements, refer to Section 040-267-701 and sections of Division 800.)	Basis For Count- ing De- fects	Allowable Defect Numbers										
		AN	AN	AN	AN	AN	AN	AN	AN	AN	AN	AN
1. Functional, Numerical, and Group Designations (on relays and on covers)	Relay	Record all defects found. See note 2.										
2. Relay Mounting	"	0	2	3	3	4	4	4	5	6	7	9
3. Cover Clearance	"	0	2	3	3	4	4	4	5	6	7	9
4. Cover Cap	"	0	3	5	5	6	7	8	9	10	11	15
5. Biasing Spring Position	SI	0	2	3	3	4	4	4	5	6	7	9
6. Armature and Spool Clearance	"	0	2	3	3	4	4	4	5	6	7	9
7. Contact Alignment	"	0	3	5	5	6	7	8	9	10	11	15
8. Contact Travel	"	0	3	5	5	6	7	8	9	10	11	15
9. Contact Make	"	0	2	3	3	4	4	4	5	6	7	9
10. Electrical Requirements	SI	0	3	5	5	6	7	8	9	10	11	15
11. Pulse Repeating Require- ments	"	See note 3.										

AN = Allowable Number of defects in sample.

SPOTTINESS TABLE

Size of Subsample	3	26	71	126	176	201	251	301	351	401	451	501	551	601
	25	70	125	175	200	250	300	350	400	450	500	550	600	650
SN	2	3	4	6	7	8	10	11	12	13	14	16	17	19

SN = Spottiness Number (applying to subsample).

Note 1: Except for relays mounted and wired during installation, inspection for this type of relay is limited to the items designated by SI (Selected Item). Extension of inspection to the remaining items for lots in lot range A shall be made when one or more defects are found for both selected items. Extension of inspection to the remaining items in range B through K shall be made when the AN is exceeded for both selected items.

Note 2: For each type of defect recorded, sufficient additional inspection shall be made to

insure elimination of the irregularity in the equipment involved.

Note 3: Where pulse repeating requirements are specified, a complete check shall be made on all circuits for this requirement 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.

REASON FOR REISSUE

To expand Note 1.