

INSPECTION REQUIREMENTS
RELAYS
235 TYPE
GENERAL EQUIPMENT REQUIREMENTS
COMMON SYSTEMS

TABLE 800-668-189

Lot Range		A	B	C	D	E	F	G	H	I	J
Lot Size (total 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
Sample Size (relays)		All	180	260	300	340	370	400	440	500	560
Inspection Item (note 2) (For requirements, refer to Section 040-242-701 and sections of Divisions 800.)	Basis For Counting Defects	Allowable Defect Numbers									
		AN	AN	AN	AN	AN	AN	AN	AN	AN	AN
1. Functional, Numerical, and Group Designations (on covers and on relays)	Relay	Record all defects found. See note 1.									
2. Relay Mounting	"	0	2	3	3	4	4	4	5	6	7
3. Vertical Clearance	"	0	2	3	3	4	4	4	5	6	7
4. Cover Spring and Cover Guide Pressure	"	0	2	3	3	4	4	4	5	6	7
5. Contact Alignment	"	0	2	3	3	4	4	4	5	6	7
6. Contact Separation	"	0	2	3	3	4	4	4	5	6	7
7. Clearance Between Heater Unit Wrapping Wires and Adjacent Spring	"	0	2	3	3	4	4	4	5	6	7
8. Timing Requirements	"	0	3	5	5	6	7	8	9	10	11
9. Relay Insulated From Mounting Plate	"	0	2	3	3	4	4	4	5	6	7
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	651	701	751	801
	25	70	125	175	200	250	300	350	400	450	500	550	600	650	700	750	800	850
SN	2	3	4	6	7	8	10	11	12	13	14	16	17	19	20	22	23	24
SN = Spottiness Number (applying to subsample).																		

Note 1: For each type of defect recorded, sufficient additional inspection shall be made to insure the elimination of the irregularity in the equipment involved.

Note 2: Verification of this type of relay is not required except when test results or other evidence indicates an unsatisfactory condition of adjustment.

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 revise note 2.