

INSPECTION REQUIREMENTS

RELAYS

B AND G TYPE(S)

| Lot Range | | A | B | C | D | E | F | G | H |
|--|----------------------------|---------------------------------------|------------|------------|-------------|--------------|--------------|--------------|----------------|
| Lot Size (total number of relays in lot) | | 1 100 | 101 300 | 301 600 | 601 1000 | 1001 2000 | 2001 3000 | 3001 5000 | 5001 10,000 |
| Sample Size (relays) | | All | 90 | 165 | 245 | 325 | 385 | 455 | 520 |
| Inspection Item (see note 1) (For requirements, refer to Section 040-506-701 and sections of Division 800.) | Basis For Counting Defects | Allowable Defect Numbers | | | | | | | |
| | | AN | AN | AN | AN | AN | AN | AN | AN |
| 1. Functional, Numerical, and Group Designations (on covers and on spoolheads) | Relay | Record all defects found. See note 2. | | | | | | | |
| 2. Relay Mounting | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 3. Cover Clearance | " | 0 | 1 | 2 | 4 | 6 | 7 | 9 | 10 |
| 4. Cover Cap: Fit | " | 0 | 1 | 2 | 4 | 6 | 7 | 9 | 10 |
| 5. Contact Alignment | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 6. Application of Removable Paper Armature Stop or Paper Backstop (see note 3) | " | 0 | 1 | 2 | 4 | 6 | 7 | 9 | 10 |
| 7. Contact Follow: Flexible Spring Position | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 8. Flexible Front Contact Spring Position | " | 0 | 1 | 2 | 4 | 6 | 7 | 9 | 10 |
| 9. Minimum Front Contact Make | SI | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 10. Contact Separation | SI | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 11. Maximum Armature Travel | SI | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 12. Spring Sequence | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 13. Clearance Between Armature and Flexible Contact Spring | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 14. Position of Adjusting Screws | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 15. Electrical Requirements (excluding flashing requirements) (see note 4) | SI | 0 | 1 | 2 | 4 | 6 | 7 | 9 | 10 |
| 16. Armature Tension Spring Position | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |
| 17. Clearance Between Armature and Core Support Bracket | " | 0 | 0 | 1 | 2 | 3 | 4 | 5 | 6 |

AN = Allowable Number of defects in sample.

SPOTTINESS TABLE

| | | | | | | | | | | | | |
|---|---------|----------|-----------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
| Size of Subsample | 3 25 | 26 70 | 71 125 | 126 175 | 176 200 | 201 250 | 251 300 | 301 350 | 351 400 | 401 450 | 451 500 | 501 550 |
| SN | 2 | 3 | 4 | 6 | 7 | 8 | 10 | 11 | 12 | 13 | 14 | 16 |
| SN = Spottiness Number (applying to subsample). | | | | | | | | | | | | |

Note 1: Except for relays mounted and wired during installation, inspection for this type of relay may be 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 in at least two selected items. Extension of inspection to the remaining items in ranges B through H shall be made when the AN is exceeded in at least two 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: All B and G type relays equipped with metal armature stops shall be inspected for "position" of the stop.

Note 4: Inspection for the flashing requirement will be made only when this feature is not checked as a part of the tests specified in the respective Performance Requirements section.

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

REASONS FOR REISSUE

To apply the Selected Item procedure (PEL5193) to these relays and to reduce the sample size requirements based on the process average quality of the manufactured product, and to designate the selected items for installer inspection.