

INSPECTION REQUIREMENTS

RELAYS

E, EA, F, H, R, AND T TYPE(S)

GENERAL EQUIPMENT REQUIREMENTS

COMMON SYSTEMS

TABLE 800-668-194

Lot Range		A	B	C	D	E	F	G	H	I
Lot Size (total number of (see relays in lot) note 6)		1 100	101 300	301 600	601 1000	1001 2000	2001 3000	3001 5000	5001 10,000	10,001 20,000
Sample Size (relays) (see note 1)		All	90	165	245	325	385	455	520	650
Inspection Item (For requirements, refer to Section 040-510-701 and sec- tions of Division 800.)	Basis For Counting Defects	Allowable Defect Numbers								
		AN	AN	AN	AN	AN	AN	AN	AN	AN
1. Contact Alignment	Relay	0	0	1	2	3	4	5	6	8
2. Stud Gap	"	0	0	1	2	3	4	5	6	8
3. Contact Separation	"	0	0	1	2	3	4	5	6	8
4. Contact Follow	"	0	0	1	2	3	4	5	6	8
5. Electrical and Timing Requirements (see note 2)	"	0	1	2	4	6	7	9	10	13
6. Functional, Numerical, and Group Designations (on relays and on covers)	"	Record all defects found. See note 3.								
7. Relay Insulated From Mounting Plate	"	0	0	1	2	3	4	5	6	8
8. Relay Mounting	"	0	0	1	2	3	4	5	6	8
9. Vertical Clearance Between Relays	"	0	0	1	2	3	4	5	6	8
10. Cover Spring and Cover Guide Pressure and Cover Cap Tightness	"	0	1	2	4	6	7	9	10	13
11. Application of KS-7246 Separator and KS-7743 Separator	"	0	0	1	2	3	4	5	6	8
12. Spring Tang Position	"	0	0	1	2	3	4	5	6	8
13. Armature and Spring Stud Clearance	"	0	0	1	2	3	4	5	6	8
14. Adjusting Stud Clearance	"	0	0	1	2	3	4	5	6	8
15. Adjusting Nut Tightness (including adjustable stop pin tightness on F-type relays)	"	0	0	1	2	3	4	5	6	8
16. Adjustable Stop Pin Position	"	0	0	1	2	3	4	5	6	8
17. Armature Travel (see note 4)	"	0	0	1	2	3	4	5	6	8

**TABLE 800-668-194 (Cont)**

Lot Range		A	B	C	D	E	F	G	H	I
Lot Size (total number of (see relays in lot) (see note 6))		1 100	101 300	301 600	601 1000	1001 2000	2001 3000	3001 5000	5001 10,000	10,001 20,000
Sample Size (relays) (see note 1)		All	90	165	245	325	335	455	520	650
Inspection Item (For requirements, refer to Section 040-510-701 and sections of Division 800.)	Basis for Counting Defects	Allowable Defect Numbers								
		AN	AN	AN	AN	AN	AN	AN	AN	AN
18. Straightness of Springs (see note 5)	Relay	0	1	2	4	6	7	9	10	13
19. Separation Between Springs	"	0	0	1	2	3	4	5	6	8
20. Contact Pressure	"	0	0	1	2	3	4	5	6	8
21. Spring Sequence	"	0	0	1	2	3	4	5	6	8

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:** In panel, step-by step, and crossbar systems equipment where the test specified for the line circuit relays in the Performance Requirements section is applied, verification of these relays may be omitted as a part of the inspection procedure.

**Note 2:** When pulse repeating requirements are specified, a complete check shall be made in all cases for these requirements either as a part of the verification or of the testing procedures.

**Note 3:** For each type of defect recorded, sufficient additional inspection shall be made to insure elimination of the irregularity in the equipment involved.

**Note 4:** Where relays with KS-7246 separators are included in the lot, the sample size requirement shall be met for this inspection item in so far as possible by selecting relays without separators. In case the AN number is exceeded in the sample or more than 2.0 per cent of defects is found in the lot where sampling is not involved, the inspection for armature travel shall be extended to all relays in the lot.

**Note 5:** Where the AN number for inspection Item 18 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 6:** Except for relays mounted and wired during installation, inspection for this type of relay is not required except when testing 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 eliminate installer inspection under certain conditions.