

INSPECTION REQUIREMENTS
RELAYS
L, N, AND S TYPE(S)
GENERAL EQUIPMENT REQUIREMENTS
COMMON SYSTEMS

TABLE 800-668-196

Lot Range		A	B	C	D	E	F	G	H
Lot Size (number of relays in lot)		1 100	101 300	301 600	601 1000	1001 2000	2001 3000	3001 5000	5001 10000
Sample Size (relays)		ALI	90	165	245	325	385	455	520
Inspection Item (see note 1) (For requirements, refer to Section 040-514-701 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 Designation (on relays and on covers)	Relay	Record all defects found. See note 2.							
2. Relay Mounting	"	0	0	1	2	3	4	5	6
3. Cover and Cap Tightness	"	0	1	2	4	6	7	9	10
4. Cover Guide Position	"	0	1	2	4	6	7	9	10
5. Clearance Between Cover and Contact Bracket Spreader	"	0	0	1	2	3	4	5	6
6. Contact Alignment	"	0	0	1	2	3	4	5	6
7. Clearance Between Contact Spring and Retractable Spring	SI	0	0	1	2	3	4	5	6
8. Tightness of Screws	"	0	0	1	2	3	4	5	6
9. Armature Movement	"	0	0	1	2	3	4	5	6
10. Contact Screw Bracket Position	"	0	1	2	4	6	7	9	10
11. Contact Spring Pressure (see notes 3 and 4)	"	0	1	2	4	6	7	9	10
12. Armature Travel	SI	0	0	1	2	3	4	5	6
13. Contact Separation	SI	0	0	1	2	3	4	5	6
14. Electrical Requirements	SI	0	1	2	4	6	7	9	10

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: Except for relays mounted and wired during installation, inspection for this type of relay may be limited to the items designated 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 for 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 L relays (L24) on decoder sender of panel system shall be inspected for this inspection item.

Note 4: The reverification requirement shall be waived for Inspection Item 12.

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

REASON FOR REISSUE

To apply the Selected Item procedure (PEL5193) to these relays, 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.