

**INSPECTION REQUIREMENTS
RELAYS—Y TYPE
GENERAL EQUIPMENT REQUIREMENTS
COMMON SYSTEMS**

TABLE 800-668-198

Lot Range		A	B	C	D	E	F	G	H	I	J	K
Lot Size (total number of relays in lot)		1 100	101 300	301 600	601 1000	1001 2000	2001 3000	3001 5000	5001 10000	10001 20000	20001 50000	50001 100000
Sample Size (relays)		All	90	165	245	325	385	455	520	650	710	770
Inspection Item (see note 1) (For requirements, refer to Section 040-522-701 and sections of Division 800.)	Basis For Counting Defects	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	0	1	2	3	4	5	6	8	9	10
3. Vertical Clearance	"	0	0	1	2	3	4	5	6	8	9	10
4. Cover Spring and Cover Guide Pressure and Cover Cap Tightness	"	0	1	2	4	6	7	9	10	13	15	17
5. Contact Alignment	"	0	0	1	2	3	4	5	6	8	9	10
6. Spring Tang Position	"	0	0	1	2	3	4	5	6	8	9	10
7. Adjusting Stud Clearance	"	0	0	1	2	3	4	5	6	8	9	10
8. Adjusting Nut Tightness	"	0	0	1	2	3	4	5	6	8	9	10
9. Armature Position	"	0	0	1	2	3	4	5	6	8	9	10
10. Armature Travel	SI	0	0	1	2	3	4	5	6	8	9	10
11. Spring Tension: (a, b, c, d) Individual Springs	"	0	0	1	2	3	4	5	6	8	9	10
12. Buffer Spring Tension	"	0	0	1	2	3	4	5	6	8	9	10
13. Armature Back Tension	"	0	0	1	2	3	4	5	6	8	9	10
14. Spring Stud Clearance	"	0	0	1	2	3	4	5	6	8	9	10
15. Separation Between Springs	"	0	0	1	2	3	4	5	6	8	9	10
16. Stud Gap	"	0	0	1	2	3	4	5	6	8	9	10
17. Contact Make: Normal and Operated Position	"	0	0	1	2	3	4	5	6	8	9	10
18. Gauging Requirements	"	0	2	4	6	8	10	13	15	19	21	23
19. Contact Separation	"	0	0	1	2	3	4	5	6	8	9	10
20. Contact Sequence	"	0	0	1	2	3	4	5	6	8	9	10
21. Electrical Requirements	"	0	1	2	4	6	7	9	10	12	14	17
22. Relays Insulated From Mounting Plate	"	0	0	1	2	3	4	5	6	8	9	10

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	851	901	951
	25	70	125	175	200	250	300	350	400	450	500	550	600	650	700	750	800	850	900	950	1000
SN	2	3	4	6	7	8	10	11	12	13	14	16	17	19	20	22	23	24	25	26	20
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 item 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 the Selected Item. Extension of inspection to the remaining items in ranges B through K shall be made when the AN is exceeded for the Selected Item.

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

insure elimination of the irregularity in the equipment involved.

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 reduce the number of selected items requiring installer inspection.