

INSPECTION REQUIREMENTS
ELEVATOR APPARATUS
LINE AND TRUNK FINDERS
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS

TABLE 815-019-180 Issue 2-D

Lot Range	A	B	C	D	E	F	G							
Lot Size (Number of Elevators in Lot)	1	161	501	851	1251	1751	2251							
Sample Size (Elevators) (See Note 1)	160	500	850	1250	1750	2250	3000							
	All	160	180	230	230	360	400							
Inspection Item (For requirements refer to Bell System Practices Sections 026-125-703 and 026-125-706)	Basis	Allowable Defect Numbers and Spottiness Numbers												
		SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	
1. Rack Tongue Position (a) Tension	Rack	-	2	1	1	1	1	2	1	2	1	4	1	4
2. Rack Tongue Position (b) Position	"	-	2	1	1	1	1	2	1	2	1	4	1	4
3. Rack Coupling Pin Engagement	"	-	2	1	1	1	1	2	1	2	1	4	1	4
4. Stop Collars Loose (w)	Collar	-	2	3	2	4	2	5	2	7	2	10	2	11
5. Bent Multiple Bank Terminals (See Note 1) (w)	Terminal	-	6	20	4	22	4	29	3	37	3	49	3	54
6. Bearings Loose (w)	Bearing	-	4	12	3	13	3	17	3	21	3	29	3	32
7. Brush Rod Bearing Gap	"	-	6	19	4	21	4	27	3	34	3	45	3	50
8. Freedom of Movement of Brush Rod	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4
9. Multiple Brush: Securely Mounted and Assembled (w)	Brush	-	3	4	2	5	2	7	2	9	2	12	2	14
10. Clearance Between Multiple Brush Frame and Bank Terminals	"	-	2	2	1	2	1	3	1	4	1	5	1	6
11. Horizontal Centering of Multiple Brushes	"	-	4	12	3	13	3	17	3	21	3	29	3	32
12. Brush Intrusion	"	-	4	12	3	13	3	17	3	21	3	29	3	32
13. Brush Stud Gap	"	-	3	4	2	5	2	7	2	9	2	12	2	14
14. Parallelism of Multiple Brush Springs	"	-	6	19	4	21	4	27	3	34	3	44	3	50
15. Multiple Brush Spring Tension	"	-	6	19	4	21	4	27	3	34	3	44	3	50
16. Tip and Ring Spring Clearance	"	-	3	4	2	5	2	7	2	9	2	12	2	14
17. Tip, Ring, and Sleeve Spring Location	"	-	3	4	2	5	2	7	2	9	2	12	2	14
18. Hunt Spring Location	"	-	3	4	2	5	2	7	2	9	2	12	2	14
19. Clearance Between Up Stop Collar and Bottom of Bearing Plate	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4
20. Loose Parts: Trip Magnet Assembly and Mounting (w)	Trip Rod	-	2	1	1	1	1	2	1	2	1	4	1	4
21. Armature Gap with Trip Magnet Normal	" "	-	2	2	2	2	1	4	1	5	1	6	1	7
22. Armature Gap with Trip Magnet Operated Manually	" "	-	2	2	2	2	1	4	1	5	1	6	1	7
23. Trip Rod Bearing Loose (w)	" "	-	2	1	1	1	1	2	1	2	1	4	1	4
24. Freedom of Movement of Trip Rod	" "	-	2	1	1	1	1	2	1	2	1	4	1	4
25. Trip Rod End Play	" "	-	2	2	2	2	1	4	1	5	1	6	1	7
26. Retractable Spring Tension	" "	-	2	1	1	1	1	2	1	2	1	4	1	4
27. Clearance Between Trip Armature Extension and Hub of Rotating Lever	" "	-	2	1	1	1	1	2	1	2	1	4	1	4
28. Engagement of Trip Armature Extension by Rotating Lever	" "	-	2	1	1	1	1	2	1	2	1	4	1	4
29. Trip Magnet Operate and Release	" "	-	2	2	2	2	1	4	1	5	1	6	1	7
30. Clearance Between Multiple Brush Frame and Trip Rod Bearings	" "	-	2	1	1	1	1	2	1	2	1	4	1	4
31. Pressure of Trip Fingers Against Their Back Stops	Brush	-	4	12	3	13	3	17	3	21	3	29	3	32
32. Clearance Between Trip Lever and Trip Rod	"	-	3	4	2	5	2	7	2	9	2	12	2	14
33. Clearance Between Trip Finger and End of Trip Lever	"	-	4	12	3	13	3	17	3	21	3	29	3	32
34. Clearance Between Trip Lever and Sides of Slots in Trip Finger	"	-	4	12	3	13	3	17	3	21	3	29	3	32
35. Clearance Between Trip Lever and Trip Finger	"	-	4	12	3	13	3	17	3	21	3	29	3	32
36. Location of Trip Finger Back Stop with Respect to Trip Lever	"	-	6	19	4	21	4	27	3	34	3	44	3	50
37. Multiple Brush Tripping Test	"	-	3	4	2	5	2	7	2	9	2	12	2	14
38. Down Stop Collar Location (a) Position	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4
39. Down Stop Collar Location (b) Resetting of Brushes	" "	-	2	2	1	2	1	3	1	4	1	5	1	6
40. Smooth Brush Travel	" "	-	3	4	2	5	2	7	2	9	2	12	2	14
41. Pawl Engagement	Rack	-	2	2	2	2	1	4	1	5	1	6	1	7
42. Pawl Clearance (Snagging)	"	-	2	1	1	1	1	2	1	2	1	4	1	4
43. Lubrication	-	The lubrication shall meet the intent of the requirement												

AN - Allowable Number of defects in sample.

SN - Spottiness Number (applying to sub-samples). A sub-sample consists of the portion of the sample selected from one side of a frame.

SECTION 815-019-180

Note 1: The sample for Lot Ranges B to G, inclusive, shall be selected on the basis of elevators as specified and shall include the following apparatus forming a part of or associated with them:

- stop collars - all on the sample elevators
- bearings - five from each sample elevator
- brushes - five from each sample elevator
- trip fingers - all associated with the brushes selected

- terminals - the vertical rows opposite the brushes selected
- trip rods - all in the lot but not more than the number of elevators in the sample.

(w) Requirements for items marked with a "w" are based on accepted standards of workmanship.

For detailed explanation and use of tables refer to Section 815-018-180.

Bell Telephone Laboratories, Inc.