INSPECTION REQUIREMENTS
ELEVATOR APPARATUS
SELECTORS
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS

TABLE 815-019-181, Issue 2-D

Lot Range		A	B		C		D		E		F		G		H	
Lot Size (Number of Elevators in Lot)		1 200	201 500		501 850		851 1250		1251 1750		1751 2250		2251 3000		3001 4000	
Sample Size (Elevators) (See Note 1)		All	160		180		230		280		360		400		460	
Inspection Item (For Requirements refer to Bell System Practices Sections 026-125-704 and 026-125-706)	Basis		Allowable Defect Numbers and Spottiness Numbers													
			SN	AN	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	1	5
2. Rack Tongue Position (b) Position	"	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
3. Rack Coupling Pin Engagement	"	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
4. Clearance Between Rotating Lever and Top Clutch Locating Plate	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
5. Clearance Between Trip Armature Extension and Adjacent Multiple Brush	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
6. Stop Collars Loose (w)	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
7. Location of Down Stop Collar with Respect to Bearings	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
8. Down Stop Collar and Multiple Brush Frame Clearance	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
9. Clearance Between Each Multiple Brush Frame and Cross Member	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
10. "Y" Commutator Brush Spring Clearance	" "	-	1	0	1	0	1	0	1	0	1	1	1	1	1	2
11. Trip Rod Stop Collar Loose (w)	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
12. Clearance Between Trip Rod Stop Collar and Bottom of Bearing Plate	" "	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
13. Bent Multiple Bank Terminals (See Note 1) (w)	Terminal	-	9	40	6	45	5	59	5	73	5	94	5	102	5	123
14. Brush Rod Bearing Loose (w)	Bearing	-	4	13	3	13	3	17	3	21	3	29	3	32	3	37
15. Brush Rod Bearing Gap	"	-	6	19	4	21	4	27	3	34	3	45	3	50	3	59
16. Freedom of Movement of Brush Rod	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
17. Multiple Brush Securely Mounted and Assembled (w)	Brush	-	3	5	2	5	2	7	2	9	2	13	2	14	2	17
18. Clearance Between Multiple Brush Frame and Bank Terminals	"	-	2	2	1	2	1	3	1	4	1	5	1	6	1	7
19. Horizontal Centering of Multiple Brushes	"	-	4	12	3	13	3	17	3	21	3	29	3	32	3	37
20. Tip and Ring Spring Clearance	"	-	3	5	2	5	2	7	2	9	2	13	2	14	2	17
21. Brush Intrusion	"	-	4	12	3	13	3	17	3	21	3	29	3	32	3	37
22. Brush Stud Gap	"	-	3	5	2	5	2	7	2	9	2	13	2	14	2	17
23. Parallelism of Contacting Surface of Tip, Ring and Sleeve Brush Springs	"	-	6	19	4	21	4	27	3	34	3	45	3	50	3	59
24. Brush Spring Tension	"	-	6	19	4	21	4	27	3	34	3	45	3	50	3	59
25. Tip and Ring Spring Location	"	-	3	5	2	5	2	7	2	9	2	13	2	14	2	17
26. Sleeve Spring Location (Bridging or Non-Bridging)	"	-	3	5	2	5	2	7	2	9	2	13	2	14	2	17
27. Location of No. 8A Indicator on Final Frames	-		Inspect All Indicators in Group													
28. Clearance Between Brush Rod Up Stop Collar and Bottom of Bearing Plate	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
29. 1 Type Guide Loose (w)	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
30. 1 Type Guide Location	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
31. Clearance Between End of Trip Finger and Sleeve Springs	Finger	-	4	12	3	13	3	17	3	21	3	29	3	32	3	37
32. Point of Contact Between Trip Armature Extension and Rotating Lever	Brush Rod	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
33. Vertical Location of Trip Armature Extension with Respect to Rotating Lever	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5

TABLE 815-019-181, Issue 2-D (Continued)

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Sample Size (Elevators) (See Note 1)		All	160		180		230		280		360		400		460	
Inspection Item (For Requirements refer to Bell System Practices Sections 026-125-704 and 026-125-706)	Basis		Allowable Defect Numbers and Spottiness Numbers													
			SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN
34. Parallelism of Contact Between Trip Armature Extension and Rotating Lever	Brush Rod	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
35. Location of Sharp Edge of Trip Armature Extension	" "	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
36. Freedom of Movement of Trip Rod	" "	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
37. Vertical Clearance Between Bottom of Horizontal Flange of Trip Finger and Trip Lever	Finger	-	4	12	3	13	3	17	3	21	3	29	3	32	3	39
38. Horizontal Clearance Between Trip Finger and Trip Lever	"	-	4	12	3	13	3	17	3	21	3	29	3	32	3	37
39. Trip Finger Return to Normal	"	-	6	19	4	21	4	27	3	34	3	45	3	50	3	59
40. Clearance Between Trip Armature Extension and Rack	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
41. Smooth Brush Travel	Brush	-	3	5	2	5	2	7	2	9	2	13	2	14	2	17
42. Multiple Brush Reset	"	-	2	2	1	2	1	3	1	4	1	5	1	6	1	7
43. Pawl Clearance	Rack	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
44. Pawl Engagement	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
45. Lubrication	-		All Samples: The Lubrication shall meet the Intent of the Requirement													

AN = Allowable Number of Defects in sample.

SN = Spottiness Number (applying to sub-samples). Note: The portion of the sample selected from one side of a frame constitutes a sub-sample.

Note 1: The sample shall include all multiple brushes, trip rods, etc. associated with the elevators selected. The vertical rows of multiple bank terminals opposite the multiple brushes so selected shall also be included in the sample.

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

For detailed explanation and use of table refer to Bell System Practices Section 815-018-180.

Bell Telephone Laboratories, Inc.