INSPECTION REQUIREMENTS
ELEVATOR APPARATUS
CALL DISTRIBUTING "B" LINK
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS

TABLE 815-019-183 ISSUE 1-D

Lot Range (Number of Sender Selector and Trunk) (Finder Elevators in Equipment Group)			A	B		C		D		E		F		G	
			1	161		501		851		1251		1751		2251	
			160	500		850		1250		1750		2250		3000	
Sample Size* (Elevators)			All	160		180		230		280		360		400	
Inspection Item	Allowable Per Cent Defective For Lot	Basis		Allowable Defect Numbers and Spottiness Numbers											
				SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN
1. Rack Tongue Position	2.0	Rack	-	2	1	1	1	1	2	1	2	1	4	1	4
2. Rack Coupling Pin Engagement	2.0	"	-	2	1	1	1	1	2	1	2	1	4	1	4
3. Stop Collars Loose (Including #1A Guide) (w)	2.0	Collar	-	2	3	2	4	2	5	2	7	2	10	2	11
4. Down Stop Collar Location	2.0	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4
5. Compensator Location	2.0	" "	-	2	1	1	1	1	2	1	2	1	4	1	4
6. Bent Multiple Bank Terminals (w)*	0.02	Terminal	-	4	10	3	12	3	16	3	19	3	26	3	31
7. Bearings Loose (w)	2.0	Bearing	-	3	7	3	8	2	11	2	14	2	19	2	21
8. Brush Rod Bearing Gap	3.0	"	-	4	12	3	14	3	18	3	22	3	30	3	34
9. Freedom of Movement of Brush Rod	2.0	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4
10. Securely Mounted and Assembled (w)	1.0	Brush	-	2	1	1	1	1	2	1	2	1	4	1	4
11. Multiple Brush Intrusion	2.0	"	-	2	3	2	4	2	5	2	7	2	10	2	11
12. Multiple Brush Stud Gap	1.0	"	-	2	1	1	1	1	2	1	2	1	4	1	4
13. Parallelism of Brush Springs	3.0	"	-	3	6	3	7	2	9	2	12	2	16	2	18
14. Multiple Brush Spring Tension	3.0	"	-	3	6	3	7	2	9	2	12	2	16	2	18
15. Vertical Location of Sleeve Springs of Lower Brush and Tip and Ring Springs of Both Brushes (Sender Selectors) and Tip, Ring and Sleeve Spring Location (Trunk Finders)	1.0	"	-	2	1	1	1	1	2	1	2	1	4	1	4
16. Vertical Location of Sleeve Springs of Upper Sender Selector Brushes and Hunt Spring Location (Trunk Finders)	1.0	"	-	1	0	1	0	1	0	1	0	1	1	1	1
17. #1-A Guide Up-Stop Collar Location or Clearance Between Up-Stop Collar and Bottom of Bearing Plate	2.0	Brush Rod	-	2	1	1	1	1	2	1	2	1	4	1	4
18. Smooth Brush Travel	1.0	Brush	-	2	1	1	1	1	2	1	2	1	4	1	4
19. Pawl Engagement	3.0	Rack	-	2	2	2	2	1	4	1	5	1	6	1	7
20. Pawl Clearance (Snagging)	2.0	"	-	2	1	1	1	1	2	1	2	1	4	1	4
21. Lubrication	-	-	All Samples: The lubrication shall meet the intent of the requirement												
22. Clearance Between Multiple Brush Frame and Bank Terminals	0.5	Brush	-	1	0	1	0	1	0	1	0	1	1	1	1
23. Horizontal Centering of Multiple Brushes	2.0	"	-	2	1	1	1	1	2	1	2	1	4	1	4
24. Pressure of Trip Fingers Against Their Back Stops	2.0	"	-	2	1	1	1	1	2	1	2	1	4	1	4
25. Clearance Between Trip Lever and Trip Rod	1.0	"	-	1	0	1	0	1	0	1	0	1	1	1	1
26. Clearance Between Trip Finger and End of Brush Trip Lever	2.0	"	-	2	1	1	1	1	2	1	2	1	4	1	4

TABLE 815-019-183 ISSUE 1-D (Continued)

Lot Range				A	B		C		D		E		F		G	
Lot Size (Number of Sender Selector and Trunk) (Finder Elevators in Equipment Group)				1 160	161 500		501 850		851 1250		1251 1750		1751 2250		2251 3000	
Sample Size* (Elevators)				All	160		180		230		280		360		400	
Inspection Item	Allowable Per Cent Defective For Lot	Basis		Allowable Defect Numbers and Spottiness Numbers												
					SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN
27. Clearance Between Sides of Slots in Trip Finger and Trip Lever	2.0	Brush	-		2	1	1	1	1	2	1	2	1	4	1	4
28. Clearance Between Trip Lever and Trip Finger	2.0	"	-		2	1	1	1	1	2	1	2	1	4	1	4
29. Location of Trip Finger Back Stop with Respect to Trip Lever	3.0	"	-		2	2	2	2	1	4	1	5	1	6	1	7
30. Multiple Brush Tripping Test	1.0	"	-		1	0	1	0	1	0	1	0	1	1	1	1
31. Down Stop Collar Location (Re-setting of Multiple Brush)	2.0	"	-		2	1	1	1	1	2	1	2	1	4	1	4
32. Armature Gap with Trip Magnet Normal																
33. Armature Gap with Trip Magnet Operated Manually																
34. Freedom of Movement of Trip Rod																
35. Trip Rod End Play																
36. Clearance Between Multiple Brush Frame and Trip Rod Bearing																
37. Retractile Spring Tension																
38. Clearance Between Trip Armature Extension and Hub of Rotating Lever																
39. Engagement of Trip Armature Extension with Rotating Lever																
40. Trip Magnet Operate and Release																

THE LOT SHALL BE

INSPECTED COMPLETELY

FOR THESE REQUIREMENTS.

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.

* The sample shall be selected on the basis of elevators as specified and shall include an equal number of Sender Selector and Trunk Finder elevators. All of the stop collars, bearings, multiple brushes with their trip fingers, compensators, etc., associated with each elevator of the sample shall be included. The vertical rows of multiple bank terminals opposite the multiple brushes selected shall also be considered a part of the sample.

(w) Requirements for items marked with a "w" are based on accepted standards of workmanship. For requirements for the remaining items refer to Bell System Practices, Section 026-125-701 and Section 026-125-706.

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

Bell Telephone Laboratories, Inc.