

**INSPECTION REQUIREMENTS
SELECTOR COMMUTATORS
AND COMMUTATOR BRUSHES
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS**

TABLE 815-019-184 Issue 2-D

Lot Range		A	B	C	D	E	F	G	H								
Lot Size (Commutators)		1 200	201 500	501 850	851 1250	1251 1750	1751 2250	2251 3000	3001 4000								
Sample Size (Commutators)		All	160	180	230	280	360	400	460								
Inspection Item (For requirements refer to Bell System Practices Section 026-120-701)	Basis	Allowable Defect Numbers and Spottiness Numbers															
		SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN		
1. Brush Loosely Mounted (w) (See Note 1)	Brush	2	1	1	1	1	2	1	2	1	4	1	4	1	5		
2. Commutator Mounting	Commutator	2	2	2	2	1	4	1	5	1	6	1	7	1	9		
3. Horizontal Position of Springs	Spring	6	20	4	22	4	29	4	37	4	47	3	55	3	62		
4. Angle of Contact	"	7	31	5	32	5	47	5	57	5	75	4	85	4	98		
5. Contact Pressure: Weak	"	6	20	4	22	4	29	4	37	4	47	3	55	3	62		
6. Contact Pressure: Excessive	"	7	31	5	32	5	47	5	57	5	75	4	85	4	98		
7. Vertical Position of Springs- Left Side of Commutator	"	4	12	3	13	3	17	3	21	3	29	3	32	3	37		
8. Vertical Position of Springs- Right Side of Commutator	"	3	6	3	7	2	9	2	12	2	16	2	18	2	21		

AN = Allowable Number of defects in sample

SN = Spottiness Number (See Note 2)

Note 1: Brushes and Brush Springs associated with the commutators of the sample comprise the sample for Brushes and Brush Springs.

selected from one side of a frame constitutes the sub-sample.

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

Note 2: Spottiness Numbers apply only to sub-samples. The portion of the sample

For detailed explanation and use of Table refer to Bell System Practices Section AA668.002.

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