

**INSPECTION REQUIREMENTS
SWITCHES
211- AND 212-TYPES
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS**

TABLE 815-019-185 Issue 1

Lot Range			A*	B	C	D	E	F
**Lot Size (Number of Switches)			1	161	501	851	1251	1751
(in Equipment Group)			160	500	850	1250	1750	2250
**Sample Size (Switches)			All	160	180	230	280	360
Inspection Item	Allowable Per Cent Defective For Lot	Basis	Allowable Defect Numbers					
			AN	AN	AN	AN	AN	
1. Lettering and Numbering on Switch	3.0	Switch	-	2	2	4	5	6
2. Tightness of Screws and Nuts	2.0	"	-	1	1	2	2	4
3. Shaft and Roller Movement	3.0	"	-	2	2	4	5	6
4. Draw Bar Locating Spring Tension	3.0	"	-	2	2	4	5	6
Sample Size: Inspect 3 Spring Assemblies on each Switch selected for the Sample**								
5. Contact Alignment	1.0	Spring Assembly	-	2	2	3	4	6
6. Spring Tang Position	2.0	"	-	5	6	9	11	15
7. Tang Clearance	2.0	"	-	5	6	9	11	15
8. Straightness of Springs	2.0	"	-	5	6	9	11	15
9. Contact Separation	1.0	"	-	2	2	3	4	6
10. Contact Spring Clearance	1.0	"	-	2	2	3	4	6
11. Tang Pressure	2.0	"	-	5	6	9	11	15
12. Contact Sequence	1.0	"	-	2	2	3	4	6
Sample Size: Inspect all Covers removed for Switch Sample								
13. Cover Fit (Include Finish & Damage w)	5.0	Cover	-	3% of Covers Inspected				

w For requirements for the Inspection Items refer to Bell System Practice Section 030-711-701 and to X-65088 and X-65092.

* For Lot Sizes in lot range "A" involving more than 40 relays, for items 5 to 12 inclusive inspect 480 spring Assemblies and use the Allowable Defect Numbers of lot range "B".

**A "Spring Assembly" consists of those springs associated with a single mounting bracket.

AN = Allowable Number of defects in sample.

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

APPROVED:

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