INSPECTION REQUIREMENTS
SEQUENCE SWITCHES
"A"- AND "B"-TYPES
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS

TABLE 815-019-186, Issue 3-D

Lot Range (See Note 1)		A	B		C		D		E		F		G		H	
Lot Size (Number of Sequence Switches in Inspection Lot)		1 200	201 500		501 850		851 1250		1251 1750		1751 2250		2251 3000		3001 4000	
Sample Size (Sequence Switches) (See Note 2)		All	160		180		230		280		360		400		460	
Inspection Item (For requirements refer to Bell System Practices, Section 030-801-701 and Sections on Numbering and Lettering.)	Basis		Allowable Defect Numbers and Spottiness Numbers													
			SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN	SN	AN
1. Lettering and Numbering	Switch	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
2. Drive Pull (Slip)	"	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
3. Operation of A Cam Roller	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
4. End Play of Cam Shaft	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
5. Gap Between Driving and Driven Discs	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
6. Gap Between Driving Disc and Pole Piece	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
7. Gap Between Driven Disc and Sequence Switch Frame	"	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
8. Vertical Location of Driving Disc with Respect to Driven Disc	"	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
9. "A" Cam Roller Pressure	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
10. A Spring Clearance (or B Spring Clearance - 20 Position Switches without "A" Cams)	"	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
11. Special Spring Adjustment	"	-	2	1	1	1	1	2	1	2	1	4	1	4	1	5
12. Pointer Adjustment	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
13. Condition of Spider Springs	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
14. Clearance Between Mounting Screws and Right Hand End of Slots in Sequence Switch Frame	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
15. Parallelism of Contact Portion of Contact Spring with Face of Cam (Non-Split Contact Spring on A Cam Only) See Note 3	"	-	2	2	2	2	1	4	1	5	1	6	1	7	1	9
16. Cleaning	"		All switches of sample shall be clean													
17. Lubrication: A Cam Roller and Sequence Switch Bearings	"		All Samples: the lubrication shall meet the intent of the requirement.													
18. Contact Spring Pressure (a) Spring Pressure	Cam	-	2	2	2	2	1	3	1	4	1	6	1	7	1	9
19. (c) Equalization of Pressure (Split Springs)	"	-	7	19	5	21	3	28	3	34	3	45	3	50	3	58
20. Clearance Between Adjacent Contact Springs and Between the Springs and Framework	"	-	2	2	2	2	1	3	1	4	1	6	1	7	1	9
21. Clearance Between Inner Surface of Contact Springs and Metal Parts of Cams	"	-	2	2	2	2	1	3	1	4	1	6	1	7	1	9
22. Vertical Location of Contact Springs	"	-	4	4	3	5	2	7	2	9	2	12	2	14	2	17

AN = Allowable Number of defects in sample.

SN = Spottiness Number (applying to subsamples on selector frame equipment only).
Note: The portion of the sample selected from one side of a frame constitutes a subsample.

Note 1: For lot sizes in lot range A, involving more than 480 cams, for items 18 to 22 inclusive, inspect a sample consisting of the contact springs associated with 480 cams and use the allowable defect numbers of lot range B. In so far as possible an equal number of cams shall be selected from each sequence switch of the lot and the distribution requirements for the remaining lot ranges shall be followed.

Note 2: For items 18 to 22 inclusive in so far as the requirements apply, inspect the contact springs associated with three non-adjacent cams and the A cam, on each sequence switch selected for the sample. The distribution of the particular cams selected for determining the sample of contact springs for lot ranges B to H inclusive shall be varied from switch to switch.

Note 3: Where 20 position switches with non-split contact springs are included in the lot, the sample for this item shall be increased to include the springs on three additional non-adjacent cams on each of such switches in the sample. All defects observed on these springs for this item shall be charged to the sample.

For detailed explanation and use of Table refer to BSP Section AA668.002.

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