

**INSPECTION REQUIREMENTS
RELAYS
229-, 230-, AND 232-TYPES
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS**

TABLE 815-020-180, Issue 1-D

Lot Range (See Note 1)		A	B	C	D	E	F
Lot Size (Number of Relays in Lot)(See Note 2)		1	181	501	851	1251	1751
Sample Size (Relays)(See Note 3)		160	500	850	1250	1750	2250
		All	180	180	230	280	360
Inspection Item (For requirements refer to Bell System Practices Section 040-241-701 and Section AA613.006)	Basis	Allowable Defect Numbers					
		AN	AN	AN	AN	AN	
1. Lettering and Numbering (On Individual Cover and on Front of Relay)	Relay	-	2	2	4	5	6
2. Relay Mounting	"	-	2	2	4	5	6
3. Armature Movement	"	-	2	2	4	5	6
4. Armature Travel	"	-	1	1	2	2	4
5. Tightness of Lock Nut	"	-	1	1	2	2	4
6. Tightness of Back Stop Bar Clamping Screws	"	-	1	1	2	2	4
7. Draw Bar Locating Spring Tension	"	-	1	1	2	2	4
8. Armature Spring Tension: Combined Tension	"	-	1	1	2	2	4
9. Electrical Requirements	"	-	1	1	2	2	4
10. Tightness of Assembly	Spring Assembly	-	5	6	9	11	15
11. Contact and Spring Alignment	"	-	2	2	3	4	6
12. Spring Tang Position	"	-	5	6	9	11	15
13. Contact Separation	"	-	2	2	3	4	6
14. Armature Spring Tension: Each Armature Spring	"	-	5	6	9	11	15
15. Front Contact Spring Tension	"	-	5	6	9	11	15
16. Back Contact Spring Tension	"	-	5	6	9	11	15
17. Straightness of Spring	"	-	5	6	9	11	15
18. Separation between Springs	"	-	2	2	3	4	6
19. Covers - Fit, Finish, Damage (w)	Cover	-	See Note 4				

AN = Allowable Number of Defects in Sample

Note 1: In Lot Range A when the number of spring assemblies in a lot exceeds the number specified for the sample in Lot Range B, the provisions of Lot Range B may be used for the inspection items involved.

Note 2: Each unit of the double-unit type relays, the 230 and 232 types, shall be treated as a single relay. If possible only one unit from each double-unit relay shall be included in the sample.

Note 3: In Lot Ranges B to F, inclusive, only three spring assemblies from each relay of the sample and those covers removed for the relay inspection shall be

included in the inspection for the items involved. A spring assembly consists of those springs associated with a single mounting bracket.

Note 4: The Allowable Defect Number for item 19 shall be 3.0 per cent of the covers inspected.

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

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

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