

INSPECTION REQUIREMENTS
CLUTCHES
REED SPRING TYPE AND ASSOCIATED RACKS
GENERAL EQUIPMENT REQUIREMENTS
PANEL SYSTEMS

TABLE A - CLUTCHES WITH UP DRIVES NOT EQUIPPED WITH RELEASE SPRINGS

Lot Range	A	B	C	D	E	F	G	H	
Lot Size (Number of Clutches) (in Lot - See Note 1)	1 200	201 500	501 850	851 1250	1251 1750	1751 2250	2251 3000	3001 4000	
Sample Size (Clutches)	All	160	180	230	280	360	400	460	
Inspection Item (For requirements refer to Bell System Practices, Section 026-115-703)	Basis For Counting Defects	Allowable Defect Number (See Note 2)							
		AN	AN	AN	AN	AN	AN	AN	AN
1. Foreign Parts in Clutch (w)	Clutch	-	1	1	2	2	4	4	5
2. Adjusting Screws and Nuts Loose (w)	"	-	2	2	4	5	6	7	9
3. Bow of Rack	"	-	1	1	2	2	4	4	5
4. Slipping of Rack	"	-	1	1	2	2	4	4	5
5. Clutch Location a. Clearance	"	-	2	2	4	5	6	7	9
6. b. Position	"	-	2	2	4	5	6	7	9
7. c. Alignment	"	-	1	1	2	2	4	4	5
8. Clutch Retaining Spring Tension	"	-	2	2	4	5	6	7	9
9. Clearance Between Front Stops and Armatures	"	-	2	2	4	5	6	7	9
10. Clearance Between Bent Portion of Trip Armature and Magnet Core	"	-	2	2	4	5	6	7	9
11. Clearance Between Non-Magnetic Disc on Trip Armature and Core Nearer Fulcrum	"	-	2	2	4	5	6	7	9
12. Trip Magnet Electrical Requirement	"	-	1	1	2	2	4	4	5
13. Unoperated Core Gap (Up Drives)	"	-	2	2	4	5	6	7	9
14. Gap Between Reed Spring Adjusting Screw and Roller Arm (Up Drives)	"	-	2	2	4	5	6	7	9
15. Reed Spring Tension (Up Drives)	"	-	2	2	4	5	6	7	9
16. Up Drive Electrical Requirements (Low Speed)	"	-	1	1	2	2	4	4	5
17. Up Drive Electrical Requirements (High Speed)	"	-	1	1	2	2	4	4	5
18. Unoperated Core Gap (Down Drive)	"	-	2	2	4	5	6	7	9
19. Gap Between Reed Spring Adjusting Screw and Roller Arm (Down Drive)	"	-	2	2	4	5	6	7	9
20. Down Drive Electrical Requirements	"	-	1	1	2	2	4	4	5
21. Pawl Clearance (See Note 3)	"	-	1	1	2	2	4	4	5
22. Pawl Engagement (See Note 3)	"	-	2	2	4	5	6	7	9

AN = Allowable Number of defects in sample.

TABLE B - CLUTCHES WITH UP DRIVES EQUIPPED WITH RELEASE SPRINGS

Lot Range	A	B	C	D	E	F	G	H	
Lot Size (Number of Clutches) (in Lot - See Note 1)	1 200	201 500	501 850	851 1250	1251 1750	1751 2250	2251 3000	3001 4000	
Sample Size (Clutches)	All	160	180	230	280	360	400	460	
Inspection Item (For requirements refer to Bell System Practices Section 026-115-704)	Basis For Counting Defects	Allowable Defect Number (See Note 2)							
		AN	AN	AN	AN	AN	AN	AN	AN
1. Foreign Parts in Clutch (w)	Clutch	-	1	1	2	2	4	4	5
2. Adjusting Screws and Nuts Loose (w)	"	-	2	2	4	5	6	7	9
3. Bow of Rack	"	-	1	1	2	2	4	4	5
4. Slipping of Rack	"	-	1	1	2	2	4	4	5
5. Clutch Location a. Clearance	"	-	2	2	4	5	6	7	9

SECTION 815-020-185

TABLE B - CLUTCHES WITH UP DRIVES EQUIPPED WITH RELEASE SPRINGS (Cont'd)

Lot Range		A	B	C	D	E	F	G	H
Lot Size (Number of Clutches in Lot - See Note 1)		1	201	501	851	1251	1751	2251	3001
Sample Size (Clutches)		All	160	180	230	280	360	400	460
Inspection Item	Basis	Allowable Defect Number (See Note 2)							
		AN	AN	AN	AN	AN	AN	AN	AN
6. b. Position	Clutch	-	2	2	4	5	6	7	9
7. c. Alignment	"	-	1	1	2	2	4	4	5
8. Clutch Retaining Spring Tension	"	-	2	2	4	5	6	7	9
9. Clearance Between Front Stops and Armatures	"	-	1	1	2	2	4	4	5
10. Clearance Between Bent Portion of Trip Armature and Magnet Core	"	-	2	2	4	5	6	7	9
11. Clearance Between Non-Magnetic Disc on Trip Armature and Core Nearer Fulcrum	"	-	2	2	4	5	6	7	9
12. Trip Magnet Electrical Requirement	"	-	1	1	2	2	4	4	5
13. Unoperated Core Gap (Up Drives)	"	-	2	2	4	5	6	7	9
14. Gap Between Reed Spring Adjusting Screws and Roller Arm (Up Drives)	"	-	2	2	4	5	6	7	9
15. Reed Spring Tension (Up Drives)	"	-	2	2	4	5	6	7	9
16. Up Drive Electrical Requirements - Release Spring Attached (Low Speed Up Drive)	"	-	1	1	2	2	4	4	5
17. Up Drive Electrical Requirements - Release Spring Attached (High Speed Up Drive)	"	-	1	1	2	2	4	4	5
18. Unoperated Core Gap (Down Drives)	"	-	2	2	4	5	6	7	9
19. Gap Between Reed Spring Adjusting Screw and Roller Arm (Down Drives)	"	-	2	2	4	5	6	7	9
20. Down Drive Electrical Requirements	"	-	1	1	2	2	4	4	5
21. Position of Release Spring	"	-	2	2	4	5	6	7	9
22. Pawl Clearance (See Note 3)	"	-	1	1	2	2	4	4	5
23. Pawl Engagement (See Note 3)	"	-	2	2	4	5	6	7	9

AN = Allowable Number of Defects in sample.

Note 1: Table A provides the inspection information for clutches with up drives not equipped with release springs and Table B for clutches with up drives equipped with release springs.

Note 2: For Lot Ranges B and C a spottiness number, SN, of 2 shall apply to the subsample selected from one side of each frame. For Lot Ranges D to H, inclusive, a corresponding spottiness number of 1 shall apply.

Note 3: The inspection for these items shall be made in connection with the inspection of the associated elevator apparatus. They are shown here for reference only.

(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 AA668.002.