

**INSPECTION REQUIREMENTS**  
**RELAYS**  
**J TYPE**  
**GENERAL EQUIPMENT REQUIREMENTS**  
**COMMON SYSTEMS**

TABLE 800-668-195

Lot Range		A	B	C	D	E	F	G
Lot Size (number of relays in lot) (see note 1)		1 100	101 300	301 600	601 1000	1001 2000	2001 3000	3001 5000
Sample Size (relays)		All	90	165	245	325	385	455
Inspection Item (For requirements, refer to Section 040-512-701 and sections of Division 800.)	Basis For Counting Defects	Allowable Defect Numbers						
		AN	AN	AN	AN	AN	AN	AN
1. Functional, Numerical, and Group Designations (on relays and covers)	Relay	Record all defects found. See note 2.						
2. Relay Mounting	"	0	0	1	2	3	4	5
3. Cover Clearance	"	0	1	2	4	6	7	9
4. Cover and Cover Cap Tightness	"	0	1	2	4	6	7	9
5. Application of Removable Paper Backstops	"	0	0	1	2	3	4	5
6. Contact Alignment	"	0	0	1	2	3	4	5
7. Position of Adjusting Screws	"	0	1	2	4	6	7	9
8. Armature Travel	"	0	0	1	2	3	4	5
9. Contact Follow	"	0	0	1	2	3	4	5
10. Contact Separation	"	0	0	1	2	3	4	5
11. Armature Tension (including contact spring tension when specified)	"	0	0	1	2	3	4	5
12. Electrical Requirements	"	0	1	2	4	6	7	9
13. Armature Tension Spring Position (see note 3)	"	0	0	1	2	3	4	5
AN = Allowable Number of defects in sample.								

## SPOTTINESS TABLE

Size of Subsample	3 25	26 70	71 125	126 175	176 200	201 250	251 300	301 350	351 400
SN	2	3	4	6	7	8	10	11	12

SN = Spottiness Number (applying to subsamples).

*Note 1:* Except for relays mounted and wired during installation, inspection for this type of relay is not required except when testing results or other evidence indicates an unsatisfactory condition of adjustment.

*Note 2:* For each type of defect recorded, sufficient additional inspection shall be made to insure elimination of the irregularity in the equipment involved.

*Note 3:* All J53-type relays shall be inspected for "position of spring attached to armature."

For detailed explanation and use of tables, refer to Section 800-668-180.

## REASONS FOR REISSUE

To reduce the sample size requirements based on the process average quality of the manufactured products and to eliminate installer inspection under certain conditions.