

INSPECTION REQUIREMENTS
RELAYS-UB TYPE
GENERAL EQUIPMENT REQUIREMENTS
COMMON SYSTEMS

TABLE 800-668-199

Lot Range		A	B	C	D	E	F	G	H	I	J	K
Lot Size (total number of re-lays in lot) (see note 1)		1 100	101 300	301 600	601 1000	1001 2000	2001 3000	3001 5000	5001 10000	10001 20000	20001 50000	50001 100000
Sample Size (relays)		All	90	165	245	325	385	455	520	650	710	770
(For requirements, refer to Section 040-520-701 and sections of Division 800.)	Basis For Counting Defects	Allowable Defect Numbers										
		AN	AN	AN	AN	AN	AN	AN	AN	AN	AN	AN
1. Functional, Numerical, and Group Designations (on covers and on relays)	Relay	Record all defects found. See note 2.										
2. Relay Mounting	"	0	0	1	2	3	4	5	6	8	9	10
3. Vertical Clearance	"	0	0	1	2	3	4	5	6	8	9	10
4. Cover Spring and Cover Guide Pressure and Cover Cap Tightness	"	0	1	2	4	6	7	9	10	13	15	17
5. Spring Tang Position and Card Clearance	"	0	0	1	2	3	4	5	6	8	9	10
6. Adjusting Stud Clearance	"	0	0	1	2	3	4	5	6	8	9	10
7. Adjusting Nut Tightness or Adjusting Nut Locknut Tightness	"	0	0	1	2	3	4	5	6	8	9	10
8. Armature Position	"	0	0	1	2	3	4	5	6	8	9	10
9. Armature Travel and Application of Attachable Separators (b and c)	"	0	0	1	2	3	4	5	6	8	9	10
10. Spring Tension - Spoolhead Springs	"	0	0	1	2	3	4	5	6	8	9	10
11. Spring Tension - Balancing Springs	"	0	0	1	2	3	4	5	6	8	9	10
12. Spring Tension - Moving Springs	"	0	0	1	2	3	4	5	6	8	9	10
13. Armature Back Tension	"	0	0	1	2	3	4	5	6	8	9	10
14. Separation Between Springs	"	0	0	1	2	3	4	5	6	8	9	10
15. Contact Make Normal and Operated Position	"	0	0	1	2	3	4	5	6	8	9	10
16. Contact Gauging	"	0	2	4	6	8	10	13	15	19	21	23
17. Electrical Requirements	"	0	1	2	4	6	7	9	10	13	15	17
18. Relay Insulated from Mounting Plate	"	0	0	1	2	3	4	5	6	8	9	10

AN = Allowable Number of defects in sample.

SPOTTINESS TABLE

Size of	3	26	71	126	176	201	251	301	351	401	451	501	551	601	651	701	751	801	851	901	951
Subsample	25	70	125	175	200	250	300	350	400	450	500	550	600	650	700	750	800	850	900	950	1000
SN	2	3	4	6	7	8	10	11	12	13	14	16	17	19	20	22	23	24	25	26	28
SN = Spottiness Number (applying to subsample).																					

Note 1: Except for relays mounted and wired during installation, inspection for this type of relay is not required except where 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.

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.