

INSPECTION REQUIREMENTS

SELECTORS

204 TYPE (MINOR SWITCH)

GENERAL EQUIPMENT REQUIREMENTS

STEP-BY-STEP AND TOLL SYSTEMS

TABLE 800-669-184, Issue 1-D

Lot Range	A	B	C	D	E	F	G	H			
Lot Size (Number of Switches in Lot)	1 100	101 250	251 750	751 1300	1301 1700	1701 2250	2251 2650	2651 3000			
Sample Size	All	75	95	120	175	225	270	305			
Inspection Item (For requirements refer to Bell System Practices Section A468.003 Issue 3-D)	Basis	Spottiness Numbers and Allowable Defect Numbers									
		SN	AN	AN	AN	AN	AN	AN	AN	AN	
1. Loose Assembly of Parts (w)	Switch	2	-	1	1	2	3	5	6	8	
2. Wiper Assembly Play	"	2	-	1	1	2	3	5	6	8	
3. Wiper Tip Separation	"	2	-	1	2	3	5	7	9	10	
4. Wiper Spring Tension	"	2	-	1	2	3	5	7	9	10	
5. Relation of Wiper Tips to Bank and Bank Contacts (a) Center on Visible Length of Bank Contact	"	2	-	1	2	3	5	7	9	10	
6. (b) Centering with Respect to Width of Bank Contact	"	2	-	1	1	2	3	5	6	8	
7. Clearance between Release Ratchet Dog and Ratchet Teeth	"	2	-	1	2	3	5	7	9	10	
8. Normal Finger Position (a) First Step from Normal	"	2	-	1	2	3	5	7	9	10	
9. (b) Normal Position and (c) Clearance	"	2	-	1	1	2	3	5	6	8	
10. Freedom of Movement of Release Armature	"	2	-	1	2	3	5	7	9	10	
11. Wiper Assembly Restoring Spring Tension	"	2	-	1	2	3	5	7	9	10	
12. Rotary Armature Spring Position and Tension (a) Clearance and (c) Tension (When Required)	"	2	-	1	2	3	5	7	9	10	
13. (b) Parallel To Main Surface of Frame	"	2	-	1	2	3	5	7	9	10	
14. Freedom of Movement of Rotary Armature	"	2	-	1	2	3	5	7	9	10	
15. Rotary Magnet Heelpiece Airgap	"	2	-	1	2	3	5	7	9	10	
16. Rotary Armature Travel	"	2	-	1	2	3	5	7	9	10	
17. Pawl Alignment	"	2	-	1	2	3	5	7	9	10	
18. Pawl Spring Tension	"	2	-	1	1	2	3	5	6	8	
19. Pawl Guide Arm Position	"	2	-	1	2	3	5	7	9	10	
20. Wiper Assembly Rotary Play	"	2	-	1	2	3	5	7	9	10	
21. Spring Alignment	"	2	-	1	2	3	5	7	9	10	
22. Stud Alignment	"	2	-	1	2	3	5	7	9	10	
23. Contact Alignment	"	2	-	1	1	2	3	5	6	8	
24. Off-normal Lever Spring and Roller Engagement	"	2	-	1	2	3	5	7	9	10	
25. Off-normal Arm Roller Movement	"	2	-	1	2	3	5	7	9	10	
26. Off-normal Lever Spring Clearance and (When Required) Second Lever Spring Follow	"	2	-	1	2	3	5	7	9	10	
27. Off-normal Lever Spring Tension	"	2	-	1	1	2	3	5	6	8	
28. Contact Separation	"	2	-	1	1	2	3	5	6	8	
29. Contact Pressure	"	2	-	1	2	3	5	7	9	10	
30. Contact Follow	"	2	-	1	1	2	3	5	6	8	
31. Electrical Requirements (See Note 1)	"	2	-	1	1	2	3	5	6	8	
32. Cleaning	-	-	All Switches of the sample shall be clean								
33. Lubrication	-	-	All Samples: The lubrication shall meet the intent of the requirement								

Note 1: In Toll Systems equipment all selectors of the lot shall be inspected for this item when electrical requirements are specified on the Circuit Requirements Table. In Local Systems, for those cases where no electrical requirements are specified on the Circuit Requirements Table, inspection for this item may be omitted where the circuit operation test specified in the Performance Requirements Section is the equivalent of that

specified in part (b) of the Electrical Requirements.

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

For detailed explanation and use of Table refer to Bell System Practices Sections 809-007-180 and 800-668-181 (X-65564-02).

Bell Telephone Laboratories, Inc.