

INTERNATIONAL STANDARD

NORME INTERNATIONALE

**Electromechanical elementary relays of assessed quality –
Part 10: Sectional specification – Relays for industrial application**

**Relais électromécaniques élémentaires sous assurance de la qualité –
Partie 10: Spécification intermédiaire – Relais pour applications industrielles**

IEC 61811-10:2002

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IEC Central Office
3, rue de Varembe
CH-1211 Geneva 20
Switzerland

Tel.: +41 22 919 02 11
Fax: +41 22 919 03 00
info@iec.ch
www.iec.ch

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

**ELECTROMECHANICAL ELEMENTARY RELAYS
OF ASSESSED QUALITY –**
**Part 10: Sectional specification –
Relays for industrial application**

FOREWORD

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International Standard IEC 61811-10 has been prepared by IEC technical committee 94: All-or-nothing electrical relays.

This standard cancels and replaces IEC 60255-19 (1983) and constitutes a technical revision.

This bilingual version (2014-01) corresponds to the monolingual English version, published in 2002-11.

The text of this standard is based on the following documents:

FDIS	Report on voting
94/168/FDIS	94/172/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

The French version of this standard has not been voted upon.

The QC number that appears on the front cover of this publication is the specification number in the IEC Quality Assessment System for Electronic Components (IECQ).

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.

The committee has decided that the contents of this publication will remain unchanged until 2006. At this date, the publication will be

- reconfirmed;
- withdrawn;
- replaced by a revised edition, or
- amended.

Withdrawn

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ELECTROMECHANICAL ELEMENTARY RELAYS OF ASSESSED QUALITY –

Part 10: Sectional specification – Relays for industrial application

1 General

1.1 Scope

This part of IEC 61811 is a sectional specification applicable to electromechanical elementary (non-specified time all-or-nothing) relays of assessed quality for industrial application.

NOTE Electromechanical all-or-nothing telecom relays of assessed quality are covered by IEC 61811-50.

It is based on the basic relay standard IEC 61810-1 as well as on the generic specification IEC 61811-1 and selects from IEC 61810-7 the appropriate test and measurement procedures to be used in detail specifications derived from this specification. Moreover it contains a basic test schedule to be used in the preparation of such specifications. Detailed test schedules are given in the blank detail specifications supplementary to this sectional specification.

For the purpose of this standard, only fundamental tests have been compiled. Depending on the field of application, further tests should be selected as appropriate, preferably in accordance with the test and measurement procedures of IEC 61810-7.

1.2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60062:1992, *Marking codes for resistors and capacitors*

IEC 60255-23:1994, *Electrical relays – Part 23: Contact performance*

IEC 60410:1973, *Sampling plans and procedures for inspection by attributes*

IEC 61709:1996, *Electronic components – Reliability – Reference conditions for failure rates and stress models for conversion*

IEC 61810-1:1998, *Electromechanical non-specified time all-or-nothing relays – Part 1: General requirements*

IEC 61810-5:1998, *Electromechanical non-specified time all-or-nothing relays – Part 5: Insulation coordination*

IEC 61810-7:1997, *Electromechanical all-or-nothing relays – Part 7: Test and measurement procedures*

IEC 61811-1:1999, *Electromechanical non-specified time all-or-nothing relays of assessed quality – Part 1: Generic specification*

IEC QC 001002-3, *IEC Quality Assessment System for Electronic Components (IECQ) – Rules of Procedure – Part 3: Approval procedures*

1.3 Marking

Relays and their package supplied in accordance with detail specifications covered by this sectional specification, shall as a minimum be marked as follows:

1.3.1 Relay

- Trade mark or manufacturer's name
- Relay type and variant code
- Date of manufacture, year/week, coded in accordance with IEC 60062
- IECQ mark

Where space permits, a circuit diagram or terminal identification should be given.

1.3.2 Package

- Trade mark or manufacturer's name
- Detail specification reference if not marked on the relay
- Quantity
- Relay type and variant code
- Manufacturer's batch identification code

1.4 Ordering information

The ordering information shall be coded and shall contain the following details:

- IECQ detail specification number
- Coded coil voltage
- Terminal code
- Coded mounting arrangement
- Specials code

2 Quality assessment procedures

2.1 Primary stage of manufacture

The primary stage of manufacture is the first process subsequent to the manufacture of finished parts and subassemblies of the relay.

NOTE 1 A subassembly is understood to mean here the permanent assembly of two or more piece parts.

NOTE 2 Important manufacturing steps are as follows:

- a) fabrication, heat treatment and plating of the component parts of the relay;
- b) coil winding;
- c) assembling of the electrical and electromechanical parts;
- d) adjustment of the relay contacts, if applicable;
- e) high-temperature drying, gas backfilling and sealing of the relay, if applicable;
- f) final measurements and periodic inspection of test groups A to D.

2.2 Structurally similar relays

Relays are considered structurally similar if having no differences in design other than in:

- a) coil wire diameter, number of windings and the coil transient suppression device;
- b) types, numbers and material of contacts;
- c) rated coil and/or contact voltage(s);
- d) mounting and terminal variants within the limits prescribed in the detail specification.

2.3 Subcontracting

Subcontracting the primary stage of manufacture (see 2.1) and/or subsequent stages to an unapproved manufacturer is forbidden. Subcontracting is permitted for any stages preceding the primary stage of manufacture and shall be in accordance with the requirements of (normative) Annex B to Clause 2 of IEC QC 001002-3.

2.4 Qualification approval procedures

The manufacturer shall comply with the general requirements of the basic rules governing qualification approval defined in Clause 3 of IEC QC 001002-3 and the provisions given in 2.2 of IEC 61811-1.

The requirements contained in 4.2 of IEC 61810-1 shall be met.

Qualification approval tests shall include all the tests prescribed in the detail specification, and shall be performed by a schedule specifically prescribed in the detail specification.

Sampling shall be carried out in accordance with the sampling plans and procedures specified in IEC 60410. The number of specimens for each subgroup is specified in the blank detail specification. As a general rule, a minimum of five specimens are required for each group of tests. The qualification tests schedule may specify destructive and cumulative non-destructive tests.

2.5 Quality conformance inspection requirements

2.5.1 General requirements

Quality conformance inspection shall be carried out in accordance with the requirements of Clause 3 of IEC QC 001002-3 and 2.3 of IEC 61811-1.

2.5.2 Formation of inspection lots

Inspection lots to be submitted to group A and B acceptance tests shall be formed in accordance with 3.2.3 and 3.3.1 of IEC QC 001002-3 and with the sampling plans and procedures given in IEC 60410, except where production is too infrequent or too small for sampling plans to apply; in these cases inspection shall be 100 %.

When sampling is carried out in accordance with IEC 60410, the percent defective concept only shall be used. Stratified or representative sampling shall always be used to include all production lines and structurally similar relays in proportion to their respective quantities in the lot. Exceptions from proportionality may become necessary and shall be stated in the detail specification or agreed between the manufacturer and the National Supervising Inspectorate (NSI). Specimens shall be as representative as possible of the production.

2.5.3 Periodic inspection

Fixed samples for group C and D inspection shall be taken from a lot (or lots) which has passed group A and B inspection during, or at the end, of the specified reference period. In both cases the inspection lot (or lots) shall not be less than the average of production lots during the reference period for each group.

2.6 Test schedule

2.6.1 Test sequence

A test sequence shall consist of all tests listed in the (blank) detail specification.

The reference numbers of the tests are those of IEC 61810-7, with the exception of additional test(s) described in the sectional, the blank detail or the detail specification.

2.6.2 Groups A and B

The IL (inspection level) notation applies for all tests in one subgroup. A corresponding range of values for AQL (acceptable quality level) shall be given in the blank detail specification, and the authority preparing detail specifications shall choose the appropriate value which then applies to all tests in one subgroup.

2.6.3 Groups C and D

The blank detail specification shall prescribe for each subgroup:

- a) Periodicity of this subgroup. If the same periodicity is applicable to all subgroups, it shall be given at the beginning of the group test details.
- b) The minimum sample size for each test (or group of tests) performed with the same relays, the number of test specimens and the permitted number of defectives shall be specified.

2.7 Order of tests

Quality conformance inspection is divided into two parts: that carried out lot-by-lot, on which the release of the individual lots is based, and that carried out on a periodic basis which contains the time-consuming and more expensive tests.

Following 2.3 of IEC 61811-1, groups A and B contain lot-by-lot tests, while periodic tests required for the maintenance of qualification approval are contained in groups C and D.

When several tests are subsequently to be carried out on any one specimen or number of specimens, the following order shall apply unless otherwise prescribed in the blank detail specification:

- Screening or sorting tests (if applicable) and subgroup A1 shall always precede any other non-destructive (ND) or destructive (D) tests.
- The remaining tests shall be conducted as given in the blank detail specification. The order of tests within subgroups is mandatory.
- Destructive tests may be preceded by one or more non-destructive or destructive tests, provided that the effects of the preceding tests are not considered liable to invalidate the results of the later tests.

3 Preparation of blank detail and detail specifications

3.1 Contents of blank detail and detail specifications

Blank detail specifications shall conform with the test schedule given in Table 1 of this specification and the related explanations.

Tests marked M are mandatory. If tests are marked R (recommended) they may be included in the blank detail specification; they then become mandatory for the detail specification.

Blank detail specifications shall give the following information or call for inclusion into the detail specification:

- a) Identification of the detail specification.
- b) Identification of the relay and information on its applications. Identification shall be provided by such properties as rated power, dimensions, sealing, whether monostable or bistable, polarised or not, or otherwise required for identification.
- c) Outline drawings of the relay and key dimensions. Variants, such as for terminals, may be given in an annex to the detail specification.

- d) Reference data of the relay. A limited number of values is required on the front page, so as to describe the overall performance of the relay. Full information in conformance with IEC 61810-1 shall be added on one of the subsequent pages. Rated values should preferably be those listed therein. Where tests are referred to rated values, they shall be indicated with each test. Where tests are to be performed at other than rated values, the test values shall be indicated and clearly distinguished from the rated values.
- e) Related documents. Reference shall be made to IEC 61811-1 and this sectional specification. When reference to further documents is necessary, such documents shall be listed with their full title, year of edition and, unless common knowledge, the source from which they can be obtained.
- f) Periodicity of tests.
- g) Formation of inspection lots, if predictable in the sense of 2.5.
- h) Order of the tests.
- i) General test conditions, if deviating from 3.5 of IEC 61810-7.
- j) Qualification approval test schedule.
- k) Quality conformance test schedule.
- l) Specification of IL numbers (groups A and B) and sample sizes (groups C and D).
- m) Specification of AQL numbers (groups A and B) and permitted number of defectives (groups C and D).
- n) Marking of package and/or relays, ordering information beyond that listed in this specification, if necessary.
- o) Coded ordering information.

Additional information such as curves and drawings may be given in an annex of the detail specification.

When preparing blank detail specifications, the following steps are to be taken:

- include in the blank detail specification all the mandatory tests of Table 1, together with those recommended tests considered appropriate for the intended use;
- if necessary, add any other tests required either from or beyond IEC 61810-7.

3.2 Basic test schedule

The basic test schedule is given in Table 1.

3.2.1 Order of tests

The order within subgroups shall be defined in the blank detail specification.

3.2.2 Sampling values

IL and AQL values, sample size and allowed defectives shall be chosen from IEC 60410 and by using Annex A, and shall be stated in the blank detail specification.

3.2.3 Abbreviations

Options:

Tests marked with M are mandatory for inclusion in the (blank) detail specification.

Tests marked with R are recommended for inclusion in the (blank) detail specification.

Types of relays:

- RT 0 Unenclosed relay
- RT I Dust protected relay
- RT II Flux proof relay
- RT III Wash tight relay
- RT IV Sealed relay
- RT V Hermetically sealed relay

The respective definitions are given in 2.2 of IEC 61810-7.

3.3 Test schedule for blank detail specifications

The mandatory and recommended tests for quality conformance inspection to be used for the establishment of a test schedule in a blank detail specification are given in Table 1 below.

Table 1 – Tests for quality conformance inspection

Group A

Conducted on a sampling basis, lot by lot.

Subgroup A1

For all tests in this subgroup

IL: ...

AQL: ...

Test from IEC 61810-7 and respective subclause number	Options and particular requirements	
Visual inspection – relay marking (ND) 3.6.4 items a) and b)	M	
Coil resistance (ND) 3.8.1	M	
Dielectric test (ND) 3.9	M	In accordance with Clauses 3 and 4 of IEC 61810-5
Contact-circuit resistance, static (ND) 3.12	M	Test voltage and current according to CA category/ies specified for the relay
Functional tests (ND) 3.13	M	Operate and release value shall be checked as a minimum. In accordance with 4.1.2 of IEC 61810-1
Timing tests (ND) 3.14.2	R	