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SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES



DEPARTMENT OF DEFENSE Washington 25, D. C.

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

MIL-STD-1050

29 APRIL 1963

- 1. This standard has been approved by the Department of Defense and is mandatory for use by the Departments of the Army, the Navy, the Air Force and the Defense Supply Agency. This revision supersedes MIL-STD-105C, dated 18 July 1961.
- 2. This publication provides sampling procedures and reference tables for use in planning and conducting inspection by attributes. This publication was developed by a working group representing the military services of Canada, the United Kingdom and the United States of America with the assistance and cooperation of American and European organizations for quality control. The international designation of this document is ABC-STD-105. When revision or cancellation of this standard is proposed, the departmental custodians will inform their respective Departmental Standardization Office so that appropriate action may be taken respecting the international agreement concerned.
- 3. The U.S. Army Munitions Command is designated as preparing activity for this standard. Recommended corrections, additions, or deletions should be addressed to the Commanding Officer, U.S. Army CRR Engineering Office, Attn: SMUCE-ED-S, Army Chemical Center, Maryland.

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SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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1. SCOPE

- 1.1 PURPOSE. This publication establishes sampling plans and procedures for inspection by attributes. When specified by the responsible authority, this publication shall be referenced in the specification, contract, inspection instructions, or other documents and the provisions set forth herein shall govern. The "responsible authority" shall be designated in one of the above documents.
- 1.2 APPLICATION. Sampling plans designated in this publication are applicable, but not limited, to inspection of the following:
 - a. End items.
 - b. Components and raw materials.
 - c. Operations.
 - d. Materials in process.
 - e. Supplies in storage.
 - f. Maintenance operations.
 - g. Data or records.
 - h. Administrative procedures.

These plans are intended primarily to be used for a continuing series of lots or batches.

The plans may also be used for the inspection of isolated lots or batches, but, in this latter case, the user is cautioned to consult the operating characteristic curves to find a plan which will yield the desired protection (see 11.6).

- 1.3 INSPECTION. Inspection is the process of measuring, examining, testing, or otherwise comparing the unit of product (see 1.5) with the requirements.
- 1.4 INSPECTION BY ATTRIBUTES. Inspection by attributes is inspection whereby either the unit of product is classified simply as defective or nondefective, or the number of defects in the unit of product is counted, with respect to a given requirement or set of requirements.
- 1.5 UNIT OF PRODUCT. The unit of product is the thing inspected in order to determine its classification as defective or nondefective or to count the number of defects. It may be a single article, a pair, a set, a length, an area, an operation, a volume, a component of an end product, or the end product itself. The unit of product may or may not be the same as the unit of purchase, supply, production, or shipment.

2. CLASSIFICATION OF DEFECTS AND DEFECTIVES

- 2.1 METHOD OF CLASSIFYING DEFECTS. A classification of defects is the enumeration of possible defects of the unit of product classified according to their seriousness. A defect is any nonconformance of the unit of product with specified requirements. Defects will normally be grouped into one or more of the following classes; however, defects may be grouped into other classes, or into subclasses within these classes.
- 2.1.1 CRITICAL DEFECT. A critical defect is a defect that judgment and experience indicate is likely to result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product; or a defect that judgment and experience indicate is likely to prevent performance of the tactical function of a major end item such as a ship, aircraft, tank, missile or space vehicle. NOTE: For a special provision relating to critical defects, see 6.3.
- 2.1.2 MAJOR DEFECT. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

- 2.1.3 MINOR DEFECT. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.
- 2.2 METHOD OF CLASSIFYING DEFECTIVES. A defective is a unit of product which contains one or more defects. Defectives will usually be classified as follows:
- 2.2.1 CRITICAL DEFECTIVE. A critical defective contains one or more critical defects and may also contain major and or minor defects. NOTE: For a special provision relating to critical defectives, see 6.3.
- 2.2.2 MAJOR DEFECTIVE. A major defective contains one or more major defects, and may also contain minor defects but contains no critical defect.
- 2.2.3 MINOR DEFECTIVE. A minor defective contains one or more minor defects but contains no critical or major defect.

3. PERCENT DEFECTIVE AND DEFECTS PER HUNDRED UNITS

- 3.1 EXPRESSION OF NONCONFORM-ANCE. The extent of nonconformance of product shall be expressed either in terms of percent defective or in terms of defects per hundred units.
- 3.2 PERCENT DEFECTIVE. The percent defective of any given quantity of units of product is one hunderd times the number of defective units of product contained therein divided by the total number of units of product, i.e.:

Percent defective =
$$\frac{\text{Number of defectives}}{\text{Number of units inspected}} \times 100$$

3.3 DEFECTS PER HUNDRED UNITS. The number of defects per hundred units of any given quantity of units of product is one hundred times the number of defects contained therein (one or more defects being possible in any unit of product) divided by the total number of units of product, i.e.:

Defects per hundred units = Number of defects × 100

4. ACCEPTABLE QUALITY LEVEL (AQL)

- 4.1 USE. The AQL, together with the Sample Size Code Letter, is used for indexing the sampling plans provided herein.
- 4.2 **DEFINITION.** The AQL is the maximum percent defective (or the maximum number of defects per hundred units) that, for purposes of sampling inspection, can be considered satisfactory as a process average (see 11.2).
- NOTE ON THE MEANING OF AQL. When a consumer designates some specific value of AQL for a certain defect or group of defects, he indicates to the supplier that his (the consumer's) acceptance sampling plan will accept the great majority of the lots or batches that the supplier submits, provided the process average level of percent defective (or defects per hundred units) in these lots or batches be no greater than the designated value of AQL. Thus, the AQL is a designated value of percent defective (or defects per hundred units) that the consumer indicates will be accepted most of the time by the acceptance sampling procedure to be used. The sampling plans provided herein are so arranged that the probability of acceptance at the designated AQL value depends upon the sample size, being generally higher for large samples than for small ones,
- describe the protection to the consumer for individual lots or batches but more directly relates to what might be expected from a series of lots or batches, provided the steps indicated in this publication are taken. It is necessary to refer to the operating characteristic curve of the plan, to determine what protection the consumer will have.
- 4.4 LIMITATION. The designation of an AQL shall not imply that the supplier has the right to supply knowingly any defective unit of product.
- 4.5 SPECIFYING AQLs. The AQL to be used will be designated in the contract or by the responsible authority. Different AQLs may be designated for groups of defects considered collectively, or for individual defects. An AQL for a group of defects may be designated in addition to AQLs for individual defects, or subgroups, within that group. AQL values of 10.0 or less may be expressed either in percent defective or in defects per hundred units; those over 10.0 shall be expressed in defects per hundred units only.
- 4.6 PREFERRED AQLs. The values of AQLs given in these tables are known as preferred AQLs. If, for any product, an AQL be designated other than a preferred AQL, these tables are not applicable.

5. SUBMISSION OF PRODUCT

5.1 LOT OR BATCH. The term lot or batch shall mean "inspection lot" or "inspection batch," i.e., a collection of units of product from which a sample is to be drawn and inspected to determine conformance with the acceptability criteria, and may differ from a collection of units designated as a lot or batch

for a given AQL. The AQL alone does not

for other purposes (e.g., production, shipment, etc.).

5.2 FORMATION OF LOTS OR BATCHES.

The product shall be assembled into identifiable lots, sublots, batches, or in such other manner as may be prescribed (see 5.4). Each lot or batch shall, as far as is practicable,

5. SUBMISSION OF PRODUCT (Continued)

consist of units of product of a single type, grade, class, size, and composition, manufactured under essentially the same conditions, and at essentially the same time.

- 5.3 LOT OR BATCH SIZE. The lot or batch size is the number of units of product in a lot or batch.
- 5.4 PRESENTATION OF LOTS OR BATCHES. The formation of the lots or

batches, lot or batch size, and the manner in which each lot or batch is to be presented and identified by the supplier shall be designated or approved by the responsible authority. As necessary, the supplier shall provide adequate and suitable storage space for each lot or batch, equipment needed for proper identification and presentation, and personnel for all handling of product required for drawing of samples.

6. ACCEPTANCE AND REJECTION

- 6.1 ACCEPTABILITY OF LOTS OR BATCHES. Acceptability of a lot or batch will be determined by the use of a sampling plan or plans associated with the designated AQL or AQLs.
- 6.2 DEFECTIVE UNITS. The right is reserved to reject any unit of product found defective during inspection whether that unit of product forms part of a sample or not, and whether the lot or batch as a whole is accepted or rejected. Rejected units may be repaired or corrected and resubmitted for inspection with the approval of, and in the manner specified by, the responsible authority.
- 6.3 SPECIAL RESERVATION FOR CRITI-CAL DEFECTS. The supplier may be required at the discretion of the responsible authority to inspect every unit of the lot or batch for

critical defects. The right is reserved to inspect every unit submitted by the supplier for critical defects, and to reject the lot or batch immediately, when a critical defect is found. The right is reserved also to sample, for critical defects, every lot or batch submitted by the supplier and to reject any lot or batch if a sample drawn therefrom is found to contain one or more critical defects.

6.4 RESUBMITTED LOTS OR BATCHES. Lots or batches found unacceptable shall be resubmitted for reinspection only after all units are re-examined or retested and all defective units are removed or defects corrected. The responsible authority shall determine whether normal or tightened inspection shall be used, and whether reinspection shall include all types or classes of defects or for the particular types or classes of defects which caused initial rejection.

7. DRAWING OF SAMPLES

- 7.1 SAMPLE. A sample consists of one or more units of product drawn from a lot or batch, the units of the sample being selected at random without regard to their quality. The number of units of product in the sample is the sample size.
- 7.2 REPRESENTATIVE SAMPLING. When appropriate, the number of units in the sample shall be selected in proportion to the size of sublots or subbatches, or parts of the lot or batch, identified by some rational criterion.

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7. DRAWING OF SAMPLES (Continued)

When representative sampling is used, the units from each part of the lot or batch shall be selected at random.

7.3 TIME OF SAMPLING. Samples may be drawn after all the units comprising the lot or batch have been assembled, or sam-

ples may be drawn during assembly of the lot or batch.

7.4 DOUBLE OR MULTIPLE SAMPLING. When double or multiple sampling is to be used, each sample shall be selected over the entire lot or batch.

8. NORMAL, TIGHTENED AND REDUCED INSPECTION

- **8.1 INITIATION OF INSPECTION.** Normal inspection will be used at the start of inspection unless otherwise directed by the responsible authority.
- 8.2 CONTINUATION OF INSPECTION. Normal, tightened or reduced inspection shall continue unchanged for each class of defects or defectives on successive lots or batchs except where the switching procedures given below require change. The switching procedures given below require a change. The switching procedures shall be applied to each class of defects or defectives independently.

8.3 SWITCHING PROCEDURES.

- 8.3.1 NORMAL TO TIGHTENED. When normal inspection is in effect, tightened inspection shall be instituted when 2 out of 5 consecutive lots or batches have been rejected on original inspection (i.e., ignoring resubmitted lots or batches for this procedure).
- 8.3.2 TIGHTENED TO NORMAL. When tightened inspection is in effect, normal inspection shall be instituted when 5 consecutive lots or batches have been considered acceptable on original inspection.
- 8.3.3 NORMAL TO REDUCED. When normal inspection is in effect, reduced inspection shall be instituted providing that all of the following conditions are satisfied:

- a. The preceding 10 lots or batches (or more, as indicated by the note to Table VIII) have been on normal inspection and none has been rejected on original inspection; and
- b. The total number of defectives (or defects) in the samples from the preceding 10 lots or batches (or such other number as was used for condition "a" above) is equal to or less than the applicable number given in Table VIII. If double or multiple sampling is in use, all samples inspected should be included, not "first" samples only; and
 - c. Production is at a steady rate; and
- d. Reduced inspection is considered desirable by the responsible authority.
- **8.3.4 REDUCED TO NORMAL.** When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:
 - a. A lot or batch is rejected; or
- b. A lot or batch is considered acceptable under the procedures of 10.1.4; or
- c. Production becomes irregular or delayed; or
- d. Other conditions warrant that normal inspection shall be instituted.
- 8.4 DISCONTINUATION OF INSPECTION.

In the event that 10 consecutive lots or batches remain on tightened inspection (or such other number as may be designated by the responsible authority), inspection under the provisions of this document should be discontinued pending action to improve the quality of submitted material.

9. SAMPLING PLANS

- 9.1 SAMPLING PLAN. A sampling plan indicates the number of units of product from each lot or batch which are to be inspected (sample size or series of sample sizes) and the criteria for determining the acceptability of the lot or batch (acceptance and rejection numbers).
- 9.2 INSPECTION LEVEL. The inspection level determines the relationship between the lot or batch size and the sample size. The inspection level to be used for any particular requirement will be prescribed by the responsible authority. Three inspection levels: I, II, and III, are given in Table I for general use. Unless otherwise specified. Inspection Level II will be used. However, Inspection Level I may be specified when less discrimination is needed, or Level III may be specified for greater discrimination. Four additional special levels: S-1, S-2, S-3 and S-4, are given in the same table and may be used where relatively small sample sizes are necessary and large sampling risks can or must be tolerated.

NOTE: In the designation of inspection levels S-1 to S-4, care must be exercised to avoid AQLs inconsistent with these inspection levels.

- 9.3 CODE LETTERS. Sample sizes are designated by code letters. Table I shall be used to find the applicable code letter for the particular lot or batch size and the prescribed inspection level.
- 9.4 OBTAINING SAMPLING PLAN. The AQL and the code letter shall be used to ob-

tain the sampling plan from Tables II. III or IV. When no sampling plan is available for a given combination of AQL and code letter. the tables direct the user to a different letter. The sample size to be used is given by the new code letter not by the original letter. If this procedure leads to different sample sizes for different classes of defects, the code letter corresponding to the largest sample size derived may be used for all classes of defects when designated or approved by the responsible authority. As an alternative to a single sampling plan with an acceptance number of 0, the plan with an acceptance number of 1 with its correspondingly larger sample size for a designated AQL (where available), may be used when designated or approved by the responsible authority.

TYPES OF SAMPLING PLANS. Three types of sampling plans: Single, Double and Multiple, are given in Tables II, III and IV, respectively. When several types of plans are available for a given AQL and code letter, any one may be used. A decision as to type of plan, either single, double, or multiple, when available for a given AQL and code letter, will usually be based upon the comparison between the administrative difficulty and the average sample sizes of the available plans. The average sample size of multiple plans is less than for double (except in the case corresponding to single acceptance number 1) and both of these are always less than a single sample size. Usually the administrative difficulty for single sampling and the cost per unit of the sample are less than for double or multiple.

10. DETERMINATION OF ACCEPTABILITY

- 10.1 PERCENT DEFECTIVE INSPECTION. To determine acceptability of a lot or batch under percent defective inspection, the applicable sampling plan shall be used in accordance with 10.1.1, 10.1.2, 10.1.3, 10.1.4, and 10.1.5.
- 10.1.1 SINGLE SAMPLING PLAN. The number of sample units inspected shall be equal to the sample size given by the plan. If the number of defectives found in the sample is equal to or less than the acceptance number, the lot or batch shall be considered acceptable. If the number of defectives is equal to or greater than the rejection number, the lot or batch shall be rejected.
- 10.1.2 DOUBLE SAMPLING PLAN. The number of sample units inspected shall be equal to the first sample size given by the plan. If the number of defectives found in the first sample is equal to or less than the first acceptance number, the lot or batch shall be considered acceptable. If the number of defectives found in the first sample is equal to or greater than the first rejection number, the lot or batch shall be rejected. If the number of defectives found in the first sample is between the first acceptance and rejection numbers, a second sample of the size given by the plan shall be inspected. The

- number of defectives found in the first and second samples shall be accumulated. If the cumulative number of defectives is equal to or less than the second acceptance number, the lot or batch shall be considered acceptable. If the cumulative number of defectives is equal to or greater than the second rejection number, the lot or batch shall be rejected.
- 10.1.3 MULTIPLE SAMPLE PLAN. Under multiple sampling, the procedure shall be similar to that specified in 10.1.2, except that the number of successive samples required to reach a decision may be more than two.
- 10.1.4 SPECIAL PROCEDURE FOR REDUCED INSPECTION. Under reduced inspection, the sampling procedure may terminate without either acceptance or rejection criteria having been met. In these circumstances, the lot or batch will be considered acceptable, but normal inspection will be reinstated starting with the next lot or batch (see 8.3.4 (b)).
- 10.2 DEFECTS PER HUNDRED UNITS IN-SPECTION. To determine the acceptability of a lot or batch under Defects per Hundred Units inspection, the procedure specified for Percent Defective inspection above shall be used, except that the word "defects" shall be substituted for "defectives."

11. SUPPLEMENTARY INFORMATION

11.1 OPERATING CHARACTERISTIC CURVES. The operating characteristic curves for normal inspection, shown in Table X (pages 30-62), indicate the percentage of lots or batches which may be expected to be accepted under the various sampling plans for a given process quality. The curves shown are for single sampling; curves for double

and multiple sampling are matched as closely as practicable. The O. C. curves shown for AQLs greater than 10.0 are based on the Poisson distribution and are applicable for defects per hundred units inspection; those for AQLs of 10.0 or less and sample sizes of 80 or less are based on the binomial distribution and are applicable for percent defec-

11. SUPPLEMENTARY INFORMATION (Continued)

tive inspection; those for AQLs of 10.0 or less and sample sizes larger then 80 are based on the Poisson distribution and are applicable either for defects per hundred units inspection, or for percent defective inspection (the Poisson distribution being an adequate approximation to the binomial distribution under these conditions). Tabulated values, corresponding to selected values of probabilities of acceptance (P_a , in percent) are given for each of the curves shown, and, in addition, for tightened inspection, and for defects per hundred units for AQLs of 10.0 or less and sample sizes of 80 or less.

- 11.2 PROCESS AVERAGE. The process average is the average percent defective or average number of defects per hundred units (whichever is applicable) of product submitted by the supplier for original inspection. Original inspection is the first inspection of a particular quantity of product as distinguished from the inspection of product which has been resubmitted after prior rejection.
- 11.3 AVERAGE OUTGOING QUALITY (AOQ). The AOQ is the average quality of outgoing product including all accepted lots or batches, plus all rejected lots or batches after the rejected lots or batches have been effectively 100 percent inspected and all defectives replaced by nondefectives.
- 11.4 AVERAGE OUTGOING QUALITY LIMIT (AOQL). The AOQL is the maximum of the AOQs for all possible incoming qualities for a given acceptance sampling plan. AOQL values are given in Table V-A for each of the single sampling plans for normal inspection and in Table V-B for each of the single sampling plans for tightened inspection.

11.5 AVERAGE SAMPLE SIZE CURVES. Average sample size curves for double and multiple sampling are in Table IX. These show the average sample sizes which may be expected to occur under the various sampling plans for a given process quality. The curves assume no curtailment of inspection and are approximate to the extent that they are based upon the Poisson distribution, and that the sample sizes for double and multiple sampling are assumed to be 0.631n and 0.25n respectively, where n is the equivalent single sample size.

11.6 LIMITING QUALITY PROTECTION.

The sampling plans and associated procedures given in this publication were designed for use where the units of product are produced in a continuing series of lots or batches over a period of time. However, if the lot or batch is of an isolated nature, it is desirable to limit the selection of sampling plans to those, associated with a designated AQL value, that provide not less than a specified limiting quality protection. Sampling plans for this purpose can be selected by choosing a Limiting Quality (LQ) and a consumer's risk to be associated with it. Tables VI and VII give values of LQ for the commonly used consumer's risks of 10 percent and 5 percent respectively. If a different value of consumer's risk is required, the O.C. curves and their tabulated values may be used. The concept of LQ may also be useful in specifying the AQL and Inspection Levels for a series of lots or batches, thus fixing minimum sample size where there is some reason for avoiding (with more than a given consumer's risk) more than a limiting proportion of defectives (or defects) in any single lot or batch.

TABLE 1—Sample size code letters

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<u>.</u>	Lot or batch size	,		Special insp	Special inspection levels		Gener	General inspection levels	levels
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92	2	8	<	æ	80	U	U	Q	<u> </u>
51	2	8	æ	æ	υ	U	υ	ы	(<u>t.</u>
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CODE LETTERS

TABLE II.A — Single sampling plans for normal inspection (Master table)

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	Sample		2 3 3 50 8 8 90 80 80 80 80 80 80 80 80 80 80 80 80 80	
	Sample	i i	KEU OMF GIJ XJA KTC E	

m Use first sampling plan below errors. If sample size equals, or exceeds, lot or batch size, do 100 percent inspection.
 m Use first sampling plan above errors.
 m Acceptance number.

m Rejection number.

SINGLE NORMAL

TABLE II-B -- Single sampling plans for tightened inspection (Master table)

Acceptable Quality Lavel (Lightened inspection) Ac. B. Acceptable Quality Lavel (Lightened inspection) Acceptable Acceptable Quality (Lightened inspection) Acceptable Acceptable Quality (Lightened inspection) Acceptable Acceptab
Acceptable Quality Levels (lightened inspection) Acceptable Quality Levels (lightened inspectio
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SINGLE TIGHTENED

TABLE II-C -- Single sampling plans for reduced inspection (Master table)

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TABLE III-A—Double sampling plans for normal inspection (Master table)

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DOUBLE NORMAL

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TABLE III-B — Double sampling plans for tightened inspection (Master table)

(See 9.4 and 9.5)

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DOUBLE TIGHTENED

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TABLE III-C -- Double sampling plans for reduced inspection (Master table)

(See 9.4 and 9.5)

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TABLE IV-A -- Multiple sampling plans for normal inspection (Master table)

									
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MULTIPLE NORMAL

(See 9.4 and 9.5)

TABLE IV-A—Multiple sampling plans for normal inspection (Master table)
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MULTIPLE NORMAL (See 9.4 and 9.5)

TABLE IV-B - Multiple sampling plans for tightened inspection (Master table)

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TABLE IV-B—Multiple sampling plans for tightened inspection (Master table)
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(See 9.4 and 9.5)

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TABLE IV-C -- Multiple sampling plans for reduced inspection (Master table)

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TABLE IV-C - Multiple sampling plans for reduced inspection (Master table)

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TABLE V.A.—Average Outgoing Quality Limit Factors for Normal Inspection (Single sampling)

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	0.65		1.8	=	1.1 0.97 1.00	0.90	0.73
	0.40	l l		1.2	0.67 0.69 0.62	0.63	0.47
	0.25			0.74	0.42	0.39	0.33
	0.15			0.46	0.27	0.24	0.22
	0.10				0.29	0.17	7 0.16
	0.065				0.18	0.11	0.042 0.069 0.097
	0.040		<u></u>		0.12	0.067	0.0%
	0.010 0.015 0.025 0.040 0.065					6 0.074	0.04
	0.015					0.046	
	0.010				·	0.029	
	Size	3 8 2		32 50	125 200 315	500 800 1250	2000
	Letter	< 80 ∪	Спг	5 = -	* 7 *	z a ɔ	E

(*** 11.4)

Notes For the exact AOQL, the above values must be multiplied by (1 - Lot or Batch size

AOQL NORMAL

22

TABLE V-B—Average Outgoing Quality Limit Factors for Tightened Inspection (Single sampling)

				-			
	1000	970 1100					
	959	620 650 610					
	900	400	8				
	220	35 52 35 36	240				
	150	95 25 35	160 150				
	81	110	8 R				
	3	233	3 5 5 6 5 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6				
	8	3 3 %	383	6 £			
	ю	8 %	2 2 8	ĸĸ			
	51	11	71 21 81	36 36 16			
	2		11 11 9.7	9.9 10 9.9	6.6		
Ŧ	6.5	12	6.9	6.1 6.3 6.4	6.4		
ality Le	0.4	72	4.2	4.3 3.9 4.0	4.1 4.0 3.9		
Acceptable Quality Level	2.5		9	2.6 2.7 2.4	2.5 2.6 2.5	2.5	
Acce	5.1		2.8	1.7	1.6 1.6 1.6	1.6 1.6	
	0.7		1.0	1.1	1.1 0.97 1.0	65 CO 65 CO	
	0.65			1.2	0.67 0.69 0.62	19 70 19 70 £90	0.62
	3			0.74	0.42	0.39 0.40 0.41	3
	χ _ζ			3	0.27	0.27	8.
	0.15				0.8	0.07	9.0
	0.10				9.18	0.11	0.097
	0.065				0.12	0.067	698.0
	0000					9.074	0.042
	0.025					9.046	0.027
	0.015					0.029	
	0.010						0.018
	Sample	288	∞ ≘ 8	8 83	25 88 SE	908 908 1250	2000 3150
	Code	≺ 80 ∪	C 71 F	רבט	ネッコ	260	¥ /

Notes For the exact AOQL, the above values must be multiplied by (1 - Sample eire)

AOQL TIGHTENED

TABLE VI-A—Limiting Quality (in percent defective) for which $P_a = 10$ Percent (for Normal Inspection, Single sampling)

_																	
11.6)		10		28	54	44	42	34	83	24	23						
(See 11.6)		6.5	89		41	36	30	27	22	16	16	14					
		4.0		3		27	23	20	18	14	12	10	9.0				
		2.5		37			18	16	13	=	9.4	7.7	6.4	9.6			
		1.5			22	·		12	20	8.2	7.4	5.9	4.9	4.0	3.5		
		1.0				16			9.2	6.5	5.4	4.6	3.7	3.1	2.5	2.3	
	-	0.65					11			4.8	4.3	3.3	2.9	2.4	1.9	1.6	1.4
	ity Leve	0.40					-	6.9	-	<u></u> , -	3.1	2.7	2.1	1.9	1.5	1.2	1.0
	Acceptable Quality Level	0.25							4.5			2.0	1.7	1.3	1.2	0.94	0.77
	Accepta	0.15								2.8			1.2	1.1	0.84	0.74	0.59
		0.10									8.			0.78	0.67	0.53	0.46
		0.065										1.2	<u> </u>		0.49	0.43	0.33
		0.040											0.73			0.31	0.27
		0.025											<u> </u>	0.46			0.20
		0.015													0.29		
		0.010														0.18	
	Sample	size	2	e 10	a	0 2	20 2	S.		8 8	125	200	315	200	008	1250	2000
	Code		<	E U	1	ء د د	<u>ਦ</u>	0		 : ¬	×	 :	=	7		. 0	~

LQ (DEFECTIVES)
10.0% so

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TABLE VI-B—Limiting Quality (in defects per hundred units) for which $P_a = 10$ Percent (for Normal Inspection, Single sampling)

(See 11.6)

						_											
	1000	<u>86</u>	1800														
	650	1400	1300	1100													
	007	000	040	770	029												
	250	022	029	260	689	410											
	150	<u>8</u> 6	210	400	350	9	·										
	001	Ş	330	310	250	220	_										
	99	330	310	240	190	99	\$										
	0\$	270	22	190	150	138	8	88									
	\$2	200	180	130	120	91	11	83	፠								
	15		130	110	84	11	83	æ	\$	83							
	10			78	29	21	\$	37	31	ĸ	23						
Level	6.5	120			\$	7	33	83	77	16	91	71					
Acceptable Quality Level	4.0		11			8	12	21	61	15	12	10	9.0				
able ()	2.5			\$			ଛ	17	13	12	16	7.7	9 .4	5.6			
Accept	1.5				83			12	Ξ	8 . 4	1.4	5.9	4.9	4.0	3.5		
	1.0					18			7.8	6.7	5.4	4.6	3.7	3.1	2.5	2.3	
	9.65						12			4.9	4.3	3.3	2.9	2.4	1.9	1.6	1.4
	0.40							7.2			3.1	2.7	2.1	1.9	1.5	1.2	1.0
	0.25								4.6			2.0	1.7	1.3	1.2	96.0	0.77
	0.15									2.9			1.2	1:1	0.84	0.74	0.59
	0.10										1.8			0.78	0.67	0.53	0.46
	0.065											1.2			0.49	0.43	0.33
	0.040												0.73			0.31	0.27
	0.025									-				9.6			0.20
	0.010 0.015 0.025 0.040 0.065			_											0.29		
	0.010				,-		.,									0.18	
Sample	size	2	m	2	8	13	20	32	S	68	125	200	315	200	800	1250	2000
စို ပိ	letter	4	æ	Ü	a	E	íz.	9	Ŧ	-	×	-	7	×	٦	o .	=

LQ (DEFECTS)
10%

TABLE VII.A—Limiting Quality (in percent defective) for which Pa =

		_			1												
(See 11.6)		10		98	09	50	37	32	92	24							_
(Sec		9.5	82		47	4 8	30	श्च	20	18	15						
		4.0	8	}		32	ន	8:	16	14	11	9.6					
		2.5		45		22	18	15	13	11	8.5	2.0	6.1				
		1.5			31		14	12	9.4	8.4	9.9	5.4	4.4	3.8			
		1.0	_			21		9.1	7.7	6.2	5.3	4.2	3.4	2.7	2.4		
ling)		0.65				14			5.8	5.0	3.9	3.3	2.6	2.1	1.8	1.5	
samp	_	0.40					8.9			3.8	3.2	2.5	2.1	1.6	1.4	1.1	
Single	Acceptable Quality Level	0.25						5.8			2.4	2.0	1.6	1.3	1.1	0.85	
ctson,	ble Qual	0.15						·	3.7			1.5	1.3	0.97	0.84	99.0	
Inspe	Accepta	0.10								2.4			0.95	0.79	0.62	0.53	
(for Normal Inspection, Single sampling)		0.065									1.5			0.59	0.50	0.39	
Jor N		0.040										0.95			0.38	0.32	
		0.025											09.0			0.24	
		0.015												0.38			
		0.010													0.24		
	Sample	size	2	ı v	8	13	32	20	80	125	200	315	005	800	1250	2000	
		letter	V 8	υ O	D	121 (£.	ی	I	J	К	٦	æ	z	۵	Ò	R	
/DE	EECTI	VEC)															

LQ (DEFECTIVES) 5.0%

= 5 Percent TABLE VII-B—Limiting Quality (in defects per hundred units) for which Pa (for Normal Inspection, Single sampling)

Code letter

=

= =

(See 11.6)

0061 <u>8</u> 2000 650 1500 904 901 000 8 810 710 8 230 910 510 8 Š 310 23 3 8 8 8 270 23 3 5 8 210 83 8 55 051 260 જ 210 9 9 9 8 110 200 ጽ 32 Ş 240 210 85 S 3 **38** 28 ĸ 130 R 2 8 97 81 æ 3 15 2 8 283 2 2 2 2 7 6.5 55 3 48 % 2 28 33 18 9.6 6.0 8 **±** = 32 22 21 16 8.5 7.0 6.1 Acceptable Quality Level 8 7 8 2 2 = 13 9.9 4.4 3.8 8.4 1.5 25 9.5 7.9 6.2 5.3 4.2 3.4 2.7 0: ន 0.65 3.9 2.6 æ: 1.5 5.0 3.3 7.7 15 0.40 4.0 = 3.8 3.2 9.1 2.1 7. 0.25 0.85 85 6.0 2.4 1.6 1.3 Ξ 0.15 0.97 9.0 9.0 1.3 ς. 0.79 0.95 0.62 0.10 0.53 2.4 0.065 8,0 0.59 33. 1.5 0.32 0.38 0.040 0.95 0.24 0.010 0.015 0.025 0.60 8 0.24 Sample size 90 S 3000 \simeq हा है B B B

LQ (DEFECTS) 5%

4 - 2

2 2 2

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TABLE VIII - Limit Numbers for Reduced Inspection

(See 8.3.3)

							
	0001	181	_,				
	059	115 871 301					
	00+	88 105 181	£ 8				
	220	40 63 210	181 301				
	951	282	201 171 172				
	001	72 28	88 115 181		· .		
	59	8 23 25	2 2 SI	<u>\$</u>			· .
	9	9 1	2 2 3	≘ ≦			
	ĸ	3 2 4	∓ 10 3	2 5 5	-		
	Şı	0	- 13	* 2	<u>\$6</u>		
	01	0	4 1 4	2 8 8	91 E		
] [2]	5'9	•	~ - =	₹ 85	æ ≅ ≅		
Quality	4:0	0	0 % 4	* ± %	98 =	<u>.</u>	
Acceptable Quality Level	2.5		2 0 0	* ~ 2	2 9 5	011 181	
Y C	1.5	• • •		3 7	22 22	63 105 169	
	01	• • •		0 7 *	r = 8	8 2 C	=
	99:0	• • •	• • •	7 0 0		\$2 £2	30.00
	0+0		• • •		2 - 6	14 24 40	3 = 5
	Z.0	• • •	• • •		0 7	7 14 24	3 7 5
	0.15				00-	3 7 13	ឧភឧ
	0.10			• • •		2 4 7	= 2 3
	590'0	• •	• • •	• • •		0 2 4	- × 12
	0.040					0 2	71 0
	\$20.0		• • •	• • •	• • •		4+
	0.010 0.015	• • •		• • •			0
	0.010	• • •		• • •	• • •		000
Number of	sample units from last 10 lots or batches	23 - 23 30 - 43 30 - 43 30 - 43	80 - 129 130 - 199 200 - 319	320 - 499 500 - 799 800 - 1249	1250 - 1999 2000 - 3149 3150 - 1999	3000 - 7009 8000 - 12199 12500 - 19999	20000 - 31499 31500 - 49999 30000 & 0ver

Practes that the number of nample units from the last ten lots or batches is not sufficient for reduced inspection for this AUL. Is this instance more than ten lots or batches may be used for the calculation, provided that the lots or batches used are the most recest oces in preparate, that they have all bers on normal inspection, and that most have rejected while on original inspection.

LIMIT NUMBERS

(See 11.5) TABLE IX — Average sample size curves for double and multiple sampling (normal and tightened inspection) OC = 3 n x proportion defective n x proportion defective n x proportion defective c = Single numple occupience number a : Equivalent single sample nine * AQL for somed laspection . ! 3/4• 72 3/4• 1/2 7 Sample Average Size AVERAGE SAMPLE SIZE

29

TABLE X-A—Tables for sample size code letter: A

CHART A - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

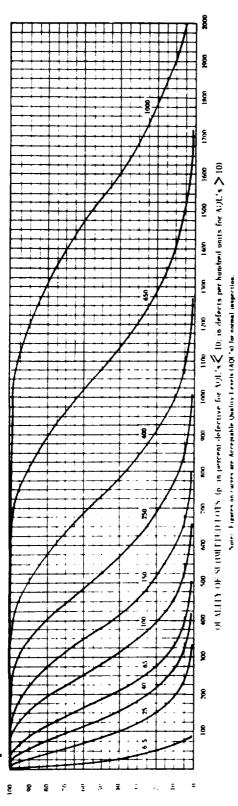


TABLE X-A-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

		:			Acceptab	Acceptable (Juality Levels (normal inspection)	Levels (no	mel inspec	ion)						
<u>-•</u>	6.5	6.5	25	40	65	100	051	X	250	X	007	X	959	X	1000
	p (in percent defective)						i) q	n defects pe	p (in defects per hundred units)	nits)					
0.66	0.501	0.51	7.45	21.8	41.2	89.2	145	175	239	302	374	512	629	829	776
0.56	2 53	2.56	17.8	6.04	6.83	131	661	235	308	382	462	622	745	\$66	1122
0.00	5.13	5.25	26.6	1.88	87.3	158	233	272	351	432	515	789	812	1073	1206
75.0	13.4	14.4	1 84	8.98	127	211	962	342	183	521	612	795	934	1314	1354
20.0	29.3	34.7	83.9	134	184	284	£8£	EEF	533	633	733	933	1083	1383	1533
25.0	30.0	69 3	135	961	256	371	181	01/5	159	192	870	1087	1248	1568	1728
10 0	68.4	115	195	266	334	464	685	059	770	688	1006	1238	1409	1748	9161
5.0	77.6	150	237	315	348	526	657	727	848	972	1094	1334	1512	1862	2035
1.0	0.09	230	332	420	502	655	900	870	2001	1141	1272	1529	8121	2088	2270
	Χ	X	Q‡	65	100	150	X	250	Χ	007	Χ	650	X	0001	Χ
					Accepta	Acceptable Quality Levels (tightened inspection)	Levels (ti	Threned inst	yection)						

issentel distribution used for purcount defective computations; Poisson for defects per hundred units.

A

TABLE X-A-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: A

						7	
Cuma-	sample size		2				
	1000	Ac Re	30 31	ε	•	X	
	Χ	Ac Re	83	€	•	1000	-
	, 059	Re	1 22 27	£	•	X	
	X	Ac Re Ac	8 19 21	€	•	929	
	400	S.	1 15 18	£	•	X	ļ
	X	c Re Ac	2 13 14	€	•	400	
	250	: Re Ac	11 12	. €	•	X	Ē
Acceptable (Quality Levels (normal inspection)	X	: Re Ac	9 10	€	•	250	Acceptable Quality Levels (tightened inspection)
normel in	150	: Re Ac	8	ĵ.	•	Χ	iightened
Levels (100	: Re Ac	6 7	€	•	150	Levels (
- Quality	65	: Re Ac	4 8	€	•	001	Quality
cceptable	\$: Re Ac	3 3	€	•	જ	cceptable
	×S	: Re Ac	2 2	€	•	\$	~
	15	. Re Ac		ـــــــــــــــــــــــــــــــــــــ	<u>l</u>	×	
	2	ReAc		<u> </u>	U	SI SI	
	X	. Re Ac	ļ		a	2	
	6.5	: Re Ac	_		•	X	
	Less then 6.5	Re Ac	> >	>	Þ	Less than	
1	lative nample rize	_	8			12	L
-							
	Type of sampling	•	Single	Double	# ultiple		
				•		-	

Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number

Rejection number

D & & . 0

Use single sampling plan above (or alternatively use letter D). Use single sampling (or alternatively use letter B).

TABLE X-B-Tables for sample size code letter: B

CHART B - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

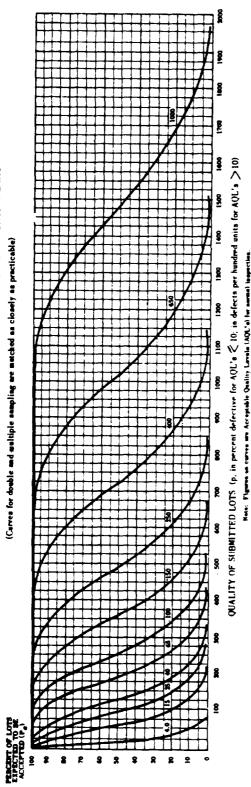


TABLE X-B-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					,	Acce	Acceptable Quality Levels (normal inspection)	lity Level	a (aormal i	nspection)							
a •	0.4	0.4	12	23	6 0	65	100	X	-08	X	220	X	ĝ	X	059	X	90
	p (in percent defective)							e (i	defects pe	p (in defects per hundred units)	mits)						
9.66	0.33	96.0	16.9	14.5	27.4	59.5	6.8	117	129	£	249	35	419	573	123	746	1029
98.0	1.70	17.1	11.8	27.3	45.5	1.78	133	157	8	3 2	306	415	%	38	74.6	1065	1152
0.06	3.45	3.50	17.7	36.7	58.2	105	15.5	181	234	286	343	\$3	35	716	ğ	1131	223
75.0	9.14	9.60	32.0	57.6	84.5	141	8	228	782	347	\$	230	623	8	8	1249	1344
20.0	20.6	23.1	\$5.9	89.1	122	691	952	586	356	422	8	622	727	226	1022	1386	283
25.0	37.0	46.2	9.66 86	131	170	247	323	360	53	205	085	724	832	346	1152	1539	3
10.0	53.6	8.92	230	171	223	309	392	433	514	593	179	825	626	1165	1277	1683	1793
5.0	63.2	6 86	156	210	228	350	438	<u>æ</u>	S%S	3	730	068	9001	1241	1356	1773	989
1.0	78.4	3 51	231	280	335	437	533	8 8	672	192	3	1019	1145	1392	1513	<u>₹</u>	5069
	6.5	6.5	ĸ	9	99	100	X	- PS-	X	250	X	007	Χ	S5	X	1000	X
						V CC	Acceptable Quality Levels (tightened inspection)	ality Leve	ls (tighten	ed inspect	ion)						
				1	;		:										

ete: Bisenial distribution under for normal defective communicaes. Painess (or defects are backed anti-

- SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: B TABLE X-B-2

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-	· }		<u> </u>	31 41	22 23 38 52		V	
١		8		30 3		‡	X	
	ł	7/	ReAc	- 8	20 17 35 37	1	٦	ł
	- 1	ΧI		23		‡	920	
ı			Re Ac	22	16 15 27 34	‡	V	
- 1		\$		21	11 28	+		
1		∇	Ac Re Ac	19	24 14	‡	§	
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- [8	2	۷۷	13 14	7	7	$\downarrow \land \downarrow$	cti
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	E	\triangle	Ac	11 12	6 15		1	3
- 1	Acceptable Quality Levels (normal inspection)	150	S.		9	‡	IX	Acceptable (Juality Levels (tightened inspection)
- 1	- ve	11	۸c	2	2 2		 / 	Ę
-	خ آ	V	Re	6	7 12	‡	051	<u> </u>
	i	\triangle	٧c	8	3	•	+	<u> </u>
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		52	2	2	2 2	‡	22] [
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			2	_			6.5	
		0.7	Ac Re Ac Re Ac	٥	•			
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		5 4 E 0				\triangleright	6.5	1 1
		Less than	٧٧				<u>ٿ</u>	
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		Cumu- lative	size	m	~ ~			
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		. tc]		43		
		Type of sampling	ne lq	Single	Double	Multiple		
		Type of sampling	ē	j.	<u>آ</u>	3		
	1			I	i .	1	1	

I'se next subsequent sample size ande letter for which acceptance and rejection numbers are available. H D ¥

Acceptance number

Rejection number

Use single sampling plan above (or alternatively use letter E). H H H

Lse double sampling plan above (or alternatively use letter D).

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TABLE X-C—Tables for sample size code letter: C

CHART C - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

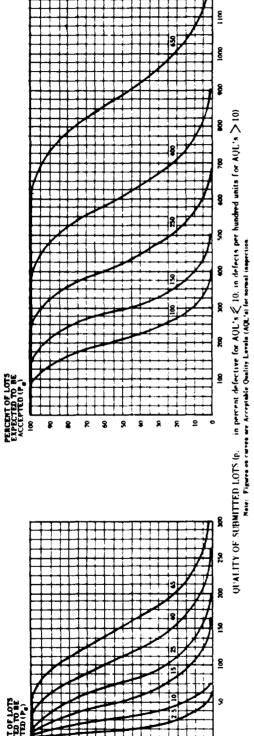


TABLE X-C-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

							Acceptabl	le Quality	Acceptable (Juality Levels (normal inspection)	rmal inspec	tion)							
ځ.	2.5	01	2.5	01	15	23	40	85	X	100	X	051	X	OSZ	X	007	X	939
	p (in percer	p (in percent defective)							p (in	defects per	p (in defects per hundred units)	nits)						
0.6%	0.20	3.28	0.20	2.89	8.72	16.5	35.7	1.85	70.1	95.4	122	150	202	231	344	168	8995	618
95.0	1.02	7.63	1.03	7.10	16.4	27.3	52.3	9.62	93.9	123	154	185	249	298	398	699	639	169
0.0	2.09	11.2	2.10	10.6	22.0	34.9	63.0	93.1	109	140	173	206	273	325	429	28 †	629	733
75.0	5.59	19.4	5.76	19.2	34.5	5.0.7	84.4	611	137	172	802	542	318	374	485	245	749	996
20.0	12.9	31.4	13.9	33.6	53.5	73.4	113	153	173	213	25.3	293	373	£33	553	613	833	893
23.0	24.2	45.4	27.7	53.9	78.4	102	97	194	216	260	304	348	4.35	667	627	1669	923	286
10.0	36.9	58.4	46.1	77.8	901	134	98. 188	235	260	308	356	403	495	385	669	992	1010	1076
5.0	45.1	65.8	59.9	6.8	128	155	210	263	289	539	386	438	534	909	745	814	1064	1131
1.0	2.09	77.8	92.1	133	168	201	292	320	348	403	456	504	612	687	835	806	1111	1241
	4.0	X	4.0	15	83	0.	85	X	6	Χ	130	X	250	X	400	X	059	Χ
-							Accepts	ble Ouslin	Acceptable Quality Levels (tightened inspection)	ightened in	spection)							

Binomial distribution used for percent defective commelstrans. Possess for defects ner bundend units

TABLE X-C-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: C

Cume	lative sample size		S	e 3			
	0001	e Re	8	Letter	a	0001	
	93	c Re Ac	\$	25 31	‡	X	ŗ
	\forall	Re Ac	2	23	‡	059	
	\$ \$		31 41	2223	‡	X	
	X	ReAc	83	35 37	‡	00	
	<u>γ</u>		z z	16 15	‡	X	
	X	Re Ac Re Ac Re Ac	19 21	14 11 24 26	‡	9%	
	051		15 18	11 9	‡	X	(wo
	X	Re	13 14	10 7	‡	051	inspecti
	/\ 02	ReAc	11 12	9 6	‡	X	thtened
	- V	Re Ac	9 10	7 5	‡	8	vels (tip
	88	ReAc	€	7 3	‡	X	Acceptable Quality Levels (tightened inspection)
	03	Re Ac	- 6	2 2	‡	8	P G
		Re Ac	- 5	5 6 2	‡	\$	Accept
	15 23	Re	<u>е</u>	m +	‡	ĸ	
	01	% 8 ₹	2	2 0	‡	52	1
	6.5	¥ ¥		Letter 0		9	
	V	Re Ac		Use Use Use	w	6.5	
	^	Re Ac ReAc			m	X	1
	2.5	R A		- 3	•	9	1
	than	Re Ac	•	D	D	than	
-	ــــــــــــــــــــــــــــــــــــــ					-	1
	Cume- lative	32,56	v	e 3		-	
	Type of	5 ā.	Single	Double	Multiple		

Use next subsequent sample size code letter for which acceptance and rejection numbers are available. 11

Acceptance number.

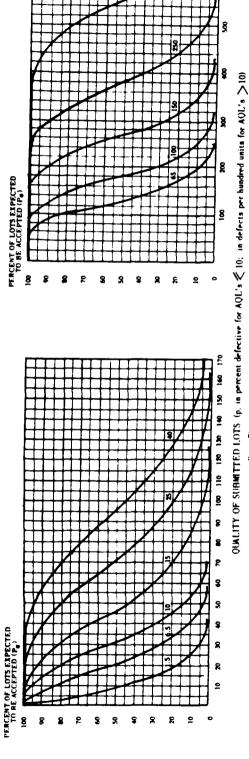
Rejection number.

Use single sampling plan above (or alternatively use letter F). Use double sampling plan above (or alternatively use letter D). 11 11 11 ▷ ₹ ₽ .

TABLE X-D—Tables for sample size code letter: D

OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS CHART D

(Curres for double and multiple sampling are matched as closely as practicable)



Note: Figures on rurven are Acceptable (Vality Levels (AQL's) for normal imagnection

- TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS TABLE X-D-1

		T	\top	Т	. T.	T	T		Τ	\top		T	$\overline{\mathbf{L}}$	<i></i>
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		X		355	ş	S	3	Ē	3 6	5 5	3 3	3 8	ĝ	
2		\$2		787	ž	S.	330	ğ	3 8	2 2	\$ 8	38	X	
JAINE LING FORMS		X		215	249	3	303	35	6	4.37	3	225	92	
		8		157	38	203	38	16	32	3	378	83	X	
1		X		82	156	17.1	8	233	222	8	334	382	150	
		80.	is)	93.5	116	82	IS.	183	218	252	27.4	318	X	
		X	p (in defects per hundred units)	76.2	8	88	061	55	8	222	263	285	8	pection)
	nspection)	\$	fects per	9.69	17.1	87.8	<u>8</u>	133	163	193	212	252	X	threaed in
	i lamon) e	X	p (in d	43.8	5.82	67.9	85.5	8	135	162	86	218	65	evels (tig
	Acceptable Quality Levels (normal inspection)	\$		36.3	8.63	58.2	74.5	98.9	121	167	3	98	X	Acceptable Quality Levels (tightened inspection
	ceptable ()	22		22.3	32.7	39.4	52.7	6.07	9.2.8	9=	131	2	3	Acceptabl
	V ,	51		10.3	17.1	21.8	31.7	45.9	63.9	83.5	6.96	128	ĸ	
		01		5.65	10.2	13.8	21.6	33.4	49.0	5.99	78.7	201	15	
		9.5		88.1	17.44	6.65	12.0	21.0 /	33.7	9.83	59.3	83.0	10	
		1.5		0.13	19:0	1.31	3.60	99'8	17.3	8.82	37.5	97.5	2.5	
		01	ective)	00:9	1'11	2.51	22.1	32.1	43.3	53.9	89.9	70.7	X	
		6.5	p (in percent defective)	2.00	2.64	98.9	12.1	20.1	30.3	9.04	47.1	58.8	10	
		1.5	d ui) d	0.13	0.64	1.31	3.53	9.30	15.9	25.0	31.2	43.8	2.5	
		P.		0.66	95.0	90.0	75.0	0.08	25.0	10.0	5.0	1.0		
L.				لــــا						-	_			

TABLE X-D-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: D

	Cume- lative sample	si ze	€	s	01	2	•	•	•	01	12	±		
	Higher than 400	Ac Re	٥	٥		٥		•					Higher than 400	
	007	Ac Re/	44 45	23 31	55 57	6 16	17 27	SS 33	\$ 9	83 88	65 68	87 77	X	,
ŀ	V	Re	42	क्ष	ß	13	អ	8	\$	SS	3	23	9	
		ReAc	31 41	22	38 22	12 6	19 16	27/26	34 37	\$	47 61	24 42	1	
	250	۷د	8	-1	33	•	=	<u>6</u>	23	%	\$	S	X	
	X	Ac Re	27 28	15 20	æ ₹	3 10	10 17	17 24	24 31	32 37	3	48 49	220	
	051	Ac Re/	8	91	22	2 9	7 14	2	ĸ	83	æ	8	X	
<u> </u>		Re	19 21	=	8	60	12	17 13	22 19	X3	<u>16</u>	33 37	051	
		٧c	82	٥	ន	-	•	=	9	ឧ	72	32	52	
(8	901	Ac Re	14 15	7 11	18 19	1 7	Q 10	8 13	12 17	17 20	21 23	22 28	IX	ion)
Acceptable Quality Levels (normal inspection)	X	٠	13	01 9	91	9	3 9	7 12	15	11	8	22	8	Acceptable Quality Levels (tightened inspection)
<u>.</u>	//	Re Ac I	11		13 15	8	60		13 10	15 14	17 18	19 21	V	ned in
E E	65	۸c	2	S	2	•	m	9	œ	=	=	£	Λ	ighte
evels	X	Ac Re	6	3 7	11 12	•	2 7	•	6 11	9 12		14 15	જ્ઞ	rels (
lity [()	Re	80	2	6	-	•	60	2	=	12 12	=		, Le
8	\$	e Ac	2 9	5 3	- 8	0		9	2	- 8	02	=======================================	$ \Delta $	Qualit
l de pt	23	Ac Re	2 (2	9		-	7	m	S	~	02 6	\$	table
V cce	15	c Re	4	+	'n	3	m	~	ın	9	9	~	x	Accep
		Re Ac	3 3	3	-	2 *	3	-	+	₹	\$	s 8	5	
	10	ReAc	2 2	2 0	2	2	2	2 0		3 2	6	7		:
	6.5	Ac R	1 2	0	1		•	•	0			2	01	
	4.0	Ic Re				<u>ن</u>							6.5	
,	X	Ac Re A	<u>.</u>			-							0.4	
	2.5	Re			,		-						Y	
		Re Ac Re	1		\$					-			<u></u>	
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	Less then 1.5	Ac Re	Δ	٥		٥		40.					Less than 2.5	
	lative	nize	86	\$	10	2	*	•	6	2	12	=		
	Type of sampling plan		Single	Pauble					Multiple					

Use next preceding sample size code letter for which acceptance and rejection numbers are available.

the next subsequent sample size code letter for which acceptance and rejection numbers are available. II

Acceptance number 11

II

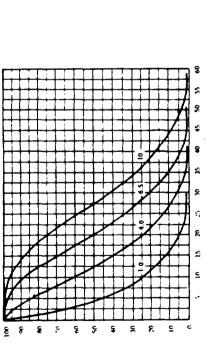
Use single sampling plan above (or alternatively use letter G). Rejection number

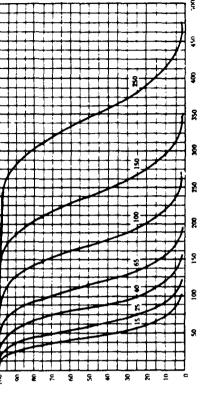
Acceptance not permitted at this sample size.

TABLE X-E-Tables for sample size code letter: E

CHART E - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)





(ATALITY OF SUBMITTED LOTS (p. in percent defective for AQL's \$\infty\$ 10; in defects per hundred units for AQL's \$\infty\$ 10). Note: Figure on curve are Acceptable (Mally Levels (AQL's) for normal impection.

TABLE X-E-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

	1								_		, ,	7	
	250		238	366	282	910	344	6/8	414	435	177	X	
	X		219	246	261	288	321	355	388	400	450	250	
	150		951	173	186	208	236	266	%	313	349	Χ	
	X		132	153	991	187	213	241	569	286	321	150	
	100		7.96	115	125	144	891	192	217	233	264	X	
	Χ		79.6	5.7	105	122	\$	167	061	502	235	100	
	6.5	units)	57.5	11.11	79.2	1.36	113	134	155	99	<u>8</u>	X	
	X	r hundred	6'94	59.2	66.5	80.2	97.5	117	137	120	176	85	tion)
pection)	0*	p (in defects per hundred units)	36.7	47.5	54.0	96.3	82.1	<u>8</u>	611	130	155	X	Acceptable Quality Lovels (tightened inspection)
ormal ins	X	p (in c	27.0	36.1	41.8	52.6	68.7	63.1	90	Ξ	<u> </u>	40	ls (tighten
Acceptable (Juality Levels (normal inspection)	183		22.4	30.6	35.8	45.8	59.0	74.5	90.5	101	123	X	lity Love
le Quality	15		13.7	20.1	24.2	32.5	43.6	57.1	71.3	6.08	101	25	otable Our
Acceptabl	10		6.33	10.5	13.4	19.5	28.2	39.3	51.4	59.6	77.3	15	Accel
	6.5		3.35	62.9	8.48	13.3	20.6	30.2	40.9	48.4	5.4	01	
	4.0		1.15	2.73	4.09	7.39	12.9	20.7	5.83	36.5	51.1	6.5	
	0.1		0.078	0.395	0.808	2.22	5.33	10.7	17.7	23.0	35.4	1.5	
	01	٠	7.00	11.3	14.2	19.9	27.5	36.2	4.4	49.5	58.7	X	
	6.5	p (in percent defective)	3.63	6.63	8.80	13.4	20.0	28.0	36.0	0.14	9.05	0.	
	4.0	(in percent	1.19	2.81	4.16	7.41	12.6	19.4	8.92	31.6	41.5	6.5	
	0.1	ءَ	0.077	0.394	0.807	2.19	5.19	101	16.2	9.02	8.6%	1.5	
	۵.		0.69	95.0	90.0	75.0	50.0	25.0	0.01	5.0	<u> </u>		

TABLE X-E-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: E

إ	letive semple	ai s	13	•	92	ъ	9	6	2	15	<u> </u>	72]	
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	N	2 €	3	5 31	5 57	9 16	72	8	\$	88	5 8	8	ĺΧ	
ļ	1	₽ V	2	83	83	15	25 17	<u>%</u>	- 3	- SS - SS	- 22 - 28	73 77	 	┨
ł	IX	٧	=	R	22	6	16 2	8		\$	19	72 7	ង្គ	
		2	E	ន	8	2	-61	72	34 37	\$	<u>+</u>	3	\forall	1
	<u> </u>	۲	8	12	37	-	=	61	12	8	z,	ន		
	X	2	83	ล	æ	2	17	24	31	37	3	\$	150	
		<u>₹</u>	23	<u>5</u>	27 34	m	2	1	2		\$	\$	<u> </u>	
	8	I		1	Z	6	7 14	3 19	8	83	<u>π</u>	7 38	IX	
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-	श्च	22	15	=	19	7	91	13	11	8	ន	×	X	۔ ا
Z Š	-	- Ro	13 14	- <u>0</u>	16 18		*	- <u>5</u>	15 12	71 71	3 2	22	1/	Ction
Acceptable (majity Levels (sormal inapoction)	ΙX	¥ .	12	9	15 1		en	7					ន	Acceptable Quality Levels (tightened inspection)
Ē	 ``	₩ *	=	6	<u>=</u>	2	•	<u> </u>	13 10	15	17 18	19	17	<u> </u>
<u>8</u>	3	٧	<u> </u>	S	12		6	•	•	=	±	•	X	1
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	K	æ	6 0	1	6	-	•	6 0	9	==	12	=	X	lity
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	10	ReAc	6	_	•		0	_	8	~	•	•	13	<
	6.5	æ	က	9	•	2	6	6	•	•	S	v,	91	
	•	ReAc	2 2	2 0	3	2	2	2	3	3	<u>m</u>	•		
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	2.5	ReAc		5	<u> </u>	<u>. </u>							0.4	
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		ReAc	•		<u> </u>							-		
	343	۸c	D	D		D							Less 1.5	
į	lative sample	9218	13	60	91	3	•	6	12	53	88	ผ		
	Pilote of a self		Single		Double				Multiple		-			

Use next preceding sample size code letter for which acceptance and rejection aumbers are available. **4546**

Use next ambecquent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number.

Rejection number.

Use single sampling plan above (or alternatively use letter H).

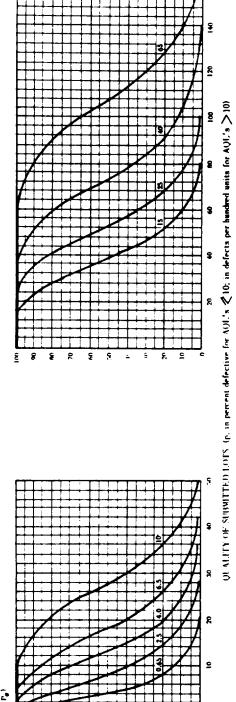
Acceptance not permitted at this sample size.

TABLE X.F.—Tables for sample size code letter: F

F

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS CHART F

(Curves for double and multiple sampling are matched as closely as practicable)



Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection

- TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS TABLE X-F-1

							Accept	Acceptable (Justity Levels (normal inspection)	y Levels (n	ormal inspe	ction)						
ď	0.65	2.5	0.4	6.5	10	99.0	2.5	0.4	6.5	01	15	Χ	22	Χ	40	X	65
		p (in p	p (in percent defective)	ctive)						p (in	p (in defects per hundred units)	r hundred u	nits)				
8	0.050	0.75	2.25	431	9.75	150.0	0.75	2.18	4.12	8.92	14.5	17.5	6.62	30.5	37.4	51.7	62.9
95.0	0.256	1.80	4.22	7.13	14.0	152.0	1.78	60⁺♦	6.83	13.1	6.61	23.5	30.8	38.5	46.2	62.2	74.5
0.06	0.525	2.69	5.64	9.03	9:91	225.0	3.66	15.8	8.73	15.8	23.3	27.2	35.1	43.2	51.5	99	81.2
75.0	1.43	4.81	8.70	12.8	21.6	174	18∵≯	89'8	12.7	1.12	8.62	34.2	43.1	52.1	61.2	79.5	93.4
S S	3.41	8.25	13.1	181	6:12	3.47	8.39	13.4	18.4	78.4	38.3	43.3	53.3	63.3	73.3	93.3	108
23.0	6.70	12.9	18.7	24.2	34.8	6.93	13.5	9:61	5:52	37.1	1.81	54.0	65.1	76.1	0.78	601	125
10.0	10.9	18.1	24.5	30.4	41.5	11.5	5'61	9.92	33.4	46.4	58.9	65.0	0.77	88.9	101	124	141
5.0	13.9	21.6	28.3	34.4	45.6	15.0	182	31.5	38.8	52.6	2:59	72.2	84.8	97.2	109	133	151
0.1	20.6	28.9	35.6	42.0	53.4	23.0	33.2	42.0	50.2	65.5	0.08	87.0	101	114	121	153	172
	1.0	4.0	6.5	10	X	0.1	€.0	6.5	01	15	Χ	S2	Χ	0\$	Χ	99	X
							Acce	Acceptable Quality Levels (tightened inspection)	lity Levels	(tightened i	nspection)						

TABLE X-F-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: F

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	Cume	lative sample	3	8	13	%	ĸ	9	15	8	ĸ	8	35		
		Higher than 65	Ac Re	۵	۵		۷							Higher than 65	
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l		8	۷۷	21	=	8	2	7	2	2	क्ष	ε	37	X	
١		\vee	ž	19	14	72	8	12	17	Z	ß	8	33	65	
		\triangle	٧٠	18	6	ន	-	9	Ξ	9	8	2	33	ڀًا	
		Q	2	15	=	19	-	9	13	17	8	ន	%	X	
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	Acceptable Quality Levels (normal inspection)	N.	ž	+	-	S	3	3	•	2	9	9	7		Acceptable Quality Levels (tightened inspection)
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		0.1	Ac Re		<u>:</u>	Letter	E.							X	
		1,5	2	_											1
		0.65	ł	٥	•		•							2	
		25.55 5.65 5.65 5.65	Ac Re Ac	D	D		D	•						Less	
	(Cumu- letive sample		8	13	92	S	2	15	8	ĸ	æ	æ		
		Type of sampling		Single		Double				Multiple					

lise next subsequent sample size code letter for which acceptance and rejection numbers are available. Use next preceding sample size code letter for which acceptance and rejection numbers are available. H **△ ▷ ₹ ±**

Acceptance number n

H

Rejection number ţ;

Use single sampling plan above (or alternatively use letter J).

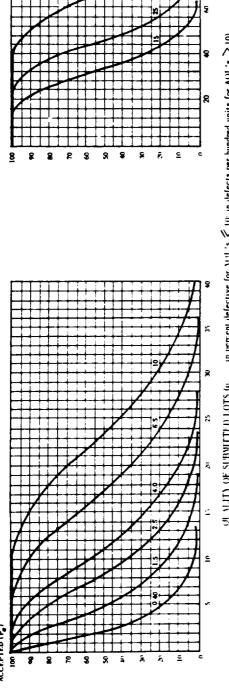
Acceptance not permitted at this sample size.

TABLE X-G-Tables for sample size code letter: G

G

CHART G - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)



UNITY OF SUBMITTED LOTS (p. — in percent defective for VLL's < 10; in defects per hundred units for AQL's > 10).
Note: Figure on curves are Acceptable Quality Levels (AQL's) for normal impection.

OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS - TABULATED VALUES FOR TABLE X-G-1

							ين ب	ceptable U	nality Love	Acceptable Quality Levels (normal inspection)	inspection	2						
م'	0.40	1.5	2.5	4.0	6.5	01	0.40	1.5	2.5	4.0	6.5	01	X	15	X	\$2	X	40
•]	p (in percent defectiv	t defective)	_						uj) d	p (in defects per hundred units)	hundred ur	nits)				
0.89	0.032	0.475	1.38	2.63	5.94	9.75	0.032	0.466	1.36	2.57	5.57	90.6	11.0	14.9	19.1	23.4	32.3	39.3
95.0	0.161	1.13	2.59	4.39	8.50	13.1	0.160	1.10	2.55	4.26	8.16	12.4	14.7	19.3	24.0	28.9	38.9	46.5
9	0.329	1.67	3.50	5.56	10.2	15.1	0.328	1.66	3.44	5.45	9.85	14.6	17.0	21.9	27.0	32.2	42.7	50.8
75.0	0.895	3.01	5.42	2.98	13.4	19.0	0.900	3.00	5.39	26.7	13.2	9.81	21.4	26.9	32.6	38.2	49.7	58.4
20.0	2.14	5.19	8.27	11.4	17.5	23.7	2.16	5.24	8.35	11.5	17.7	24.0	27.1	33.3	39.6	45.8	58.3	67.7
3.0	4.2	8.19	11.9	15.4	22.3	29.0	4.33	8.41	12.3	16.0	23.2	30.3	33.8	40.7	47.6	54.4	67.9	78.0
10.0	6.94	11.6	15.8	19.7	27.1	1.45	7.19	12.2	16.6	20.9	29.0	36.8	9.04	1.81	55.6	62.9	77.4	1.88
0.5	8.0	0.4	18.4	22.5	30.1	37.2	9.36	14.8	19.7	24.2	32.9	1.14	45.1	53.0	8.09	₹8.4	83.4	94.5
0 -	13.5	19.0	23.7	0.82	35.9	43.3	14.4	20.7	26.3	31.4	0.14	0.08	54.4	63.0	71.3	79.5	92.6	107
	0.65	2.5	4.0	6.5	0.	X	99.0	2.5	4.0	6.5	01	X	SI	X	ĸ	X	9	X
								Acceptabl	e Quality 1	Acceptable (Juality Levels (tightened inspection)	htened ins	pection)						
	_																	

TABLE X-G-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: G

, , , , , , , , , , , , , , , , , , ,	C.							¥	- epteb	0 o	Acceptable Quality Levels (normal inspection)	se	NOTH A	l insp	ectio	2									C.
sampling plan	lative sample	Less than 0.40	0,40	0.65	X	1.0	1.5	7	2.5	0.4	89	,	2		$ \chi $	15		X		ĸ	X	$ \cdot $	\$	Higher than	lative sample
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac R	Re Ac	Re	Ac Re	e Vc	~	Ac R	ReAc	ž	٧	8	Ac Re	٧	E.	Ac F	Re Ac	æ	Ac Re	3218
Single	32	D	0				-	2 2		3 4	5	9	1 2	8	6	9	=	12 13	*	15	-	19 21	22	٥	32
	8	٥		Use	3 6	Use		0 5	6	_	2	v	9	3	-	ı,	•	2	<u>~</u>	=	~	= =	18	٥	8
argnor	3		•	اروا ا	Letter -		1 2	2 3	7	→	•	~	c c	=	12	12	13	15 16	- 18	6	23 2	24 28	27		\$
	6 0	Þ	•	-	•	•	*	2 *	2	m =	*	•		0	7	٥	2		- 5	~	_	8	•	٥	66
	16						•	0	ю	0		2	-	- 5	7	٣.	60	3 9	•	2	9	12 7	=		16
	*						0	2	Б	-	2	•	3	~	6	9	-0	7 12	80	13	11	17 13	19		74
Multiple	32						0	3 1	•	2 5	<u>س</u>	~	5 10	9	=	•		10 15	12	12	16 2	22	Ю		32
	\$						_	3 2	•	3 6	<u>د</u>	6 0	7 11	<u> </u>	12	=	15.	14 17	-1	8	22	<u>8</u>	8		9
	æ						_	3	S	9	- 2	6	10 12	2 12	=	±	13	18 20	-21	ន	27 2	33	33		\$
	3 %						8	₩	· S	2 9	•	<u>-</u>	13 14	=	15	82	19 21	1 23	ผ	8	32 3	33 37	8		8
		Less than 0.65	0.65	X	1.0	1.5	2.5		0,	6.5	01		X		15	X		22	$ \Delta $	\vee	\$		X	Higher than 40	
	_							Accepi	teble (Quality	Acceptable (Juality Levels (tightened inspection)	s (tigl	htener	l insp	ection	ء									

Use next preceding sample size code letter for which acceptance and rejection numbers are available.

Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number.

Rejection number.

Use single sampling plan above (or alternatively use letter K). **△▷፥≗..**

TABLE X-H-Tables for sample size code letter: H

CHART H - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

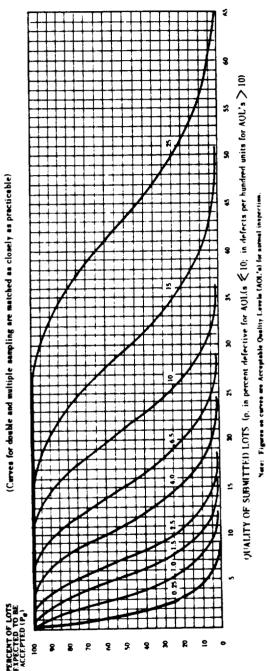


TABLE X-H-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

								V	ship ()	olity Leve	Accessable (basity Levels (normal inspection)	inspection) F							
															ļ,		\ /			
4	0.25	1.0	1.5	2.5	€.0	6.5	Χ	2	0.23	0.1	1.5	2.5	0.	6.5	X	9	X	15	\vec{X}	ß
			ءٌ [p (in percent def	defective] .							à	p (in defects per handred units)	per hand	md units)	_			
										1	01.0	1 37 .	253		2 2	3	12.9	15.0	7.0%	25.1
8.0	0.020	0.306	0.888	9 9:1	3.66	90.9	7.41	1:1	0.020	0.298	0.872	8	2.5	10.0	2	5		3		
80	0.103	0.712	- 8	2.77	5.34	8.20	97.6	12.9	0.103	0.710	3.	2.73	5.23	8.	9.39	12.3	15.4	18.5	24.9	80 K
ŝ	0 210	1.07	2.23	3.54	6.42	9.53	11.2	14.5	0.210	1.06	2.20	3.49	6.30	9.31	6.01	14.0	17.3	9.02	27.3	32.5
2 2	250	1 65	3.66	808	8.51	12.0	13.8	17.5	0.576	1.92	3.45	5.07	2.0	11.9	13.7	17.2	8.02	24.5	31.8	37.4
S	5	333	5.31	7.30	11.3	15.2	17.2	21.2	1.39	3.36	5.38	7.38	11.3	15.3	17.3	9:12	25.3	29.3	37.3	43.3
ž ž	7.6	8	7 70	0 02	14.5	18.6	21.0	25.2	2.77	5.39	7.84	10.2	8.4	19.4	21.6	0.92	30.4	34.8	43.5	6.64
3 5	5	5	10 3	12.0		2.4	24.7	29.1	19.4	7.78	9.01	13.4	18.6	23.5	26.0	30.8	35.6	40.3	49.5	3 8.
2 5	3 2	6 13	12.1	8		24.7	27.0	31.6	5.99	6 6	12.6	15.5	21.0	26.3	28.9	33.9	38.9	43.8	53.4	60.5
2 -	8	12.5	15.9	18.8	24.3	29.2	31.7	36.3	9.21	13.3	16.8	20.1	26.2	32.0	34.8	40.3	45.6	50.9	1 19	7.89
	9	1.5	2.5	0.		X	2	X	0 0	1.5	2.5	0.4	9:9	X	01	X	15	X	ß	X
								Vcc	o elder	ushity Le	Acceptable Quality Levels (tightened inspection)	rned insp	ction)							

Bissuis) distribution mand for servent defective computations. Poisson for defects per bondred within

H

TABLE X-H-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: H

í	Cusme								Acci	eptab	e Qu	ality 1	Acceptable Quality Levels (normal inspection)	1 (BOF	net i	spect	(uoi				Ì					! !	Cumu
sempling plan	lative sample size	Less than 0.25	0.25		0+0	Χ	0.65	1.0		2.1	2.	5	0.4		6.5	\triangle		2	\vdash	IX	ļ	15	X	$\overline{\ }$	ß	Higher than 25	size
		Ac Re	۸c	Re Ac	Re Ac	c Re	Ac Re	٧c	Re Ac	-	¥c	æ	٧c	R	Ac Re	٧c	æ	Ac F	Re Ac	د چ	¥c	Re	٧c	2	Ac R	Re Ac R	<u>~</u>
Single	20	Δ	0	1			<u>!</u>		2 2	en	ю	•	sc.	•	8 ~	•	٥	2	11 12	2 13	=	15	se .	2	2	۵ 2	ક
Druble	32	Þ	•	<u>ة</u> -		Letter	Letter	0 -	2 2 3	m 4	4	→ ∨	2 40	2 5	3 7	3	7 21	5 12	9 6	6 10 5 16	~ 89	11 81	6 82	2 %	3 = 2	7 P2	8 3
	13	٥	•	- T -	<u> </u>	×	-		2	2	•	3		-	•	0	-	0	8	9 0	-	2		-	2	٥	13
	8							*	-0	m	•	6	_	~	1 6	7	~	m	80	9	*	2	9	12	7 1		%
	ድ									m		+	2			•	•	9			60	13	=_	21	13 1	-61	33
¥ultiple	8 %							o -	3 3	+ +	о ₆	S 9	ლ ა	~ 60	5 10 7 11	9 6	12	~ <u>~</u>	13 10	51 0	1 12	2 2	2 2	8 8	2 2	% % 	25 55
	78				_			_	3	'n	-	•	~	-	10 12	12	=	<u> </u>	17 18	8	2	ន	22				282
	16							8	÷	2	9	~	۰	9	13 14	<u>±</u>	15	<u>e</u>	19	23	ี่ช	8	32	8	37 3	8	6
		Less than 0.40	0.40	X	\vdash	0.65	1.0	1.5	 	2.5	-	0	6.5	S	X		e	X		55	X	V	22	١,	X	Higher SS and SS	
					ļ				•	Accep	table	Quality (Acceptable (Juality Levels (tightened inspection)	vels (tighte	ed ir) appec	lion)									

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ▼ ■ Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
 Ac = Acceptance number

Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

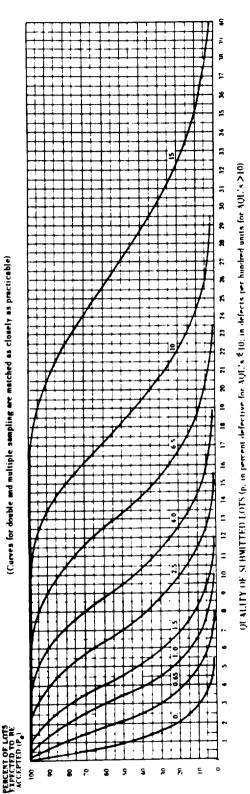
* Rejection number ž

= Use single sampling plan above (or alternatively use letter L).

* Acceptance not permitted at this sample size.

TABLE X-J-Tables for sample size code letter: J

CHART J - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



- TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS TABLE X-J-1

Note: Figures on curves are Acceptable (Justity Levels (A(M.'4) for normal mapretion

									Acre	ptable (Acceptable Quality Levels (normal inspection)	rvels (no	rmal insp	ection)								
2	0.15	0.65	1.0	1.5	2.5	0.4	X	6.5	X	10	0.15	0.65	0.1	1.5	2.5	0.4	X	6.5	X	01	X	15
				٥	p (in percent	t defective)	é								p (in def	ects per	p (in defects per hundred units)	inits)				
8	0.013	0.188	0.550	1.05	2.30	3.72	95. 4	6.13	7.88	9.75	0.013	0.186	0.545	1.03	2.23	3.63	4.38	8.8	7.62	9.35	12.9	15.7
95.0	198.0	0.444	1.03	1.73	3.32	5.08	8.3	7.91	86.0	11.9	90.0	0.444	1.02	1.71	3.27	4 .98	5.87	17.7	19.6	9.11	15.6	18.6
8	0.132	999 0	85.	2.20	3.98	5.91	16.9	8.95	0.11	13.2	0.131	999.0	88.	2.18	3.94	5.82	6.79	8.78	10.8	12.9	17.1	20.3
75.0	0.359	- 38	2.16	3.18	5.30	2.56	8.62	6.01	13.2	15.5	0.360	8	2.16	3.17	5.27	7.45	8 55	10.8	13.0	15.3	6.61	23.4
0.08	0.86.5	2.09	3.33	1.57	2.08	9.55	10.8	13.3	15.8	18.3	998.0	2.10	3.34	€:39	2.09	9.59	10.8	13.3	15.8	18.3	23.3	27.1
28.0	1.72	3.33	\$	6.31	9.16	11.9	13.3	0.91	9.81	21.3	1.73	3.37	06.4	6.39	9.28	12.1	13.5	16.3	0 61	21.8	27.2	31.2
10 01	2.84	87.4	6.52	8.16	113	14.2	15.7	18.6	21.4	24.2	2.88	28	9 9	8.35	9.11	14.7	16.2	19.3	27.7	25.2	30.9	35.2
5.0	9 8	5.80	7.68	85.0	12.7	15.8	17.3	20.3	23.2	26.0	3.75	5.93	787	69 6	13.1	16.4	18.0	21.2	24.3	₹7.4	33.4	37.8
e -	5.59	8.8	101	12.0	15.6	6 81	20.5	23.6	28.5	29.5	5.76	8	10.5	12.6	16.4	20.0	21.8	25.2	28.5	31.8	38.2	42.9
	0.25	0 1	1.5	2.5	0.4	X	6.5	X	01	X	0.25	0.1	1.5	2.5	0.4	X	6.5	X	2	X	21	X
									Acce	pasble ()	Acceptable (Juality Levels (tightened inspection)	vels (tig	htened in	spection	_							

es. All rejean given in above table based on Polenne Catribution on an approximation to the Uterabid.

TABLE X-J-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: J

							Yes	eptabl		E Z	1 1 1	Norms	Acceptable Quality Levels (normal inspection)	xction.											Ç
Type of	Come- lative sample	Less then 0.15	0.15	0.25	X	0.40	0.65	1.0	-	1.5	2	2.5	2	\triangle	\vee	6.5		X	01		X	1	15	Higher then 15	lative semple
	3	Ac Re	Ac Re	Re Ac Rc	Ac Re	Ac Re	Ac Re	¥	- 2	Ac Re	¥	Re	Ac Re	٧c	- <u>P</u>	Ac B	Re Ac	2	۸c	- <u>S</u>	Ac B	Re Ac	Re	Ac Re	
Single	8	٥	0				1 2	- 5	m	т Т	٠,	•	8 2	•	6	10 1	11 12	13	11	15	18 1	19 21	8	٥	8
	S	Þ	•	e c	Use		0 2		6	-	7	N.	3 7	m	~	<u>م</u>	6	92	~	=	6	11 11	91	۵	ક્ક
Double	8			Letter:		<u> </u>	1 2	е .	₹	\$	9 .	7	6	=	12	12 1	13 15	16	=	2	ន	% %	72		001
	8	D	•	=		4	* 2	•	2	*	3	•	† 0	0	4	•	- 0	•	-	~		2	•	٥	8
	\$						2	•	т.	0	3 1	Ŋ	-	9	1	6	- 60		•	2	9	12 7	*1		\$
						· -	0	•	m	_	- 7	9	ص ص		•	•	10 /	12	<u>ب</u>	13	13 11	17 13	19		8
Multiple	8						0		•	~	3	7	5 10	9	=	60	13 10		15 12	11	17 16	22	83		8
	8						1 3	-7	-	т т	- S	6 0	7 11	6	12	11	15 14		71 71	8	ន	N N	83		8
	22						1 3	<u>س</u>	S	•	- 9	6	20 02	12 12	=	*	17 18	8	0 21	ន	Z	<u>8</u>	8		120
	9						2	<u> </u>	S	· •	6	9	13 1	=	15	92	19 21		z z	8	8	33	88		\$
		Less than 0.25	27.0	X	0.40	0.65	<u> </u>	 _	1.5	2.5	}	4.0	X	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	6.5	X	 	2	\square	$ \chi $	15		$ \chi $	Higher than 15	
							ا ا	ept eb.	į	lity 7	yels (tighte	Acceptable Quality Levela (tightened inspection)	pecti	(B)							•			
										ĺ							ĺ				Į				•

Use sext preceding sample size code letter for which acceptance and rejection numbers are available.

Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number **42.**

Rejection number

Use single sampling plan above (or alternatively use letter M) Acceptance not permitted at this sample size.

TABLE X-K-Tables for sample size code letter: K

CHART K - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched as closely as practicable)

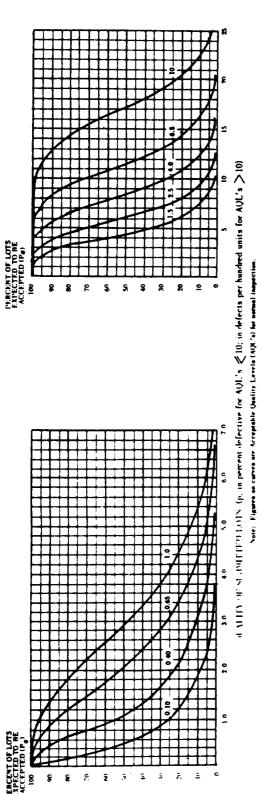


TABLE X-K-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

	,				Accepted	Acceptable Quality Levels (normal inspection)	els (normal inspe	ction)				
٠	0.10	0.40	0.65	1.0	1.5	2.5	X	4.0	Χ	6.5	Χ	10
	p (in percent	t defective or d	p (in percent defective or defects per hundred units)	ed units)								
0.86	1800:0	6110	0.349	959 0	1.43	2.33	2.81	3.82	98'1	5.98	8.28	10.1
95.0	0.0410	0.284	0.654	1.09	2.09	3.19	3.76	161	\$1.9	7.40	9.95	11.9
0.06	0.0840	0.426	0.882	1.40	2.52	3.73	4.35	5.62	6.92	8.24	10.9	13.0
75.0	0.230	0.769	0.382	2.03	3.38	11.4	29.5	06:9	8.34	9.79	12.7	14.9
80.0	0.554	1.34	2.14	2.94	15.1	91.9	76'9	8.53	10.1	11.7	14.9	17.3
25.0	111	2.15	3.14	4.09	96'5	7.75	8.64	10.4	12.2	13.9	17.4	20.0
0.01	1.84	3.11	4.26	5.35	7.42	27:6	10.4	12.3	14.2	1.91	19.8	22.5
5.0	2.40	3.80	5.04	6.20	8.41	10.5	11.5	13.6	15.6	17.5	21.4	24.2
1.0	3.68	5.31	6.73	8.04	10.5	12.8	18.3	1.91	18.3	\$0.4	24.5	27.5
	0.15	0.65	1.0	1.5	2.5	X	4:0	Χ	6.5	Χ	10	Χ
					Accept	Acceptable (Juality Levels (tightened inspection)	evels (tightened	inspection)				

Notes All values given in above table based on Poisson distribution as an approximation to the Binesalel.

K

TABLE X-K-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: K

<u> </u>	e = .	,				1]	
1	lative semple	•	83	&	3 5	33	35	*	128	991	192	72		
	Higher then 10	Ac Re	٥	٥		٥							Higher than 10	
	01	Re	22	92	22	6	14	19	83	23	33	89	X	
		٧c	23	=	8	7	~	13	2	ĸ	31	37		•
	$ \chi $	Re	19	=	*	• • • • • • • • • • • • • • • • • • •	12	17	23	83	8	83	2	
	\square	٧c	82	•	ន		•	=	91_	8	3	26 32		
	6.5	. Re	15	-	19		2	8 13	2 17	202	1 23		X	
		Re Ac	13 14	9	16 18	-	-	-2-	15 12	71 21	20 21	22	 	
	X	Ac F	12 1	_ 	15		6	~	2	±	8 2	12	6.5	
	<u> </u>	Re	1111	0	13	 "	60	2	2	-51		2	1/	
	0.4	Ac	01	رم در	12		~	•	∞	=	=	18	X	
ا ۽ ا	\ <u>/</u>	Re	6	-	121	-	-	0	=	12	=	53		tion)
L ioi	X	Αc	e c	6	=	•	2	•	•	•	21	=	4.0	ushed
<u> </u>	S	Re	80	~	6	-	•	œ	9	=	13	±	V	ned i
Ē	2.5	Ac	4	m	∞	0	-	က	S	7	2	2	X	ighte
Acceptable (Juality Levels (aormal inspection)	S	Re	9	5	~	7	3	9	~	60	•	01	2.5	Acceptable (Juality Levels (tightened inspection)
	-	۸c	S	2	٠			2	6	S	~	۰		1
lity	1.0	Re	•	-	S.	۳	60	•	2	•	•	7	1.5	ality
		Ac			•	<u> </u>	0	_	~	m	•	v	ļ	
ge	0.65	Re	æ	3	→	2	د		4	-	3	υn —	1.0	Q V
Acce		Re Ac	2 2	2 0	2	2	2 0	2 0		3 -		*	-	Acc
	0.45				_			0		_		8	0.65	
		Re Ac		J		1							 	
	0.25	Ac	:		<u> </u>	<u> </u>							9	:
	X	Ac Re	:	.		7							82.0	
	0.15	Ic Re	:	*	Letter	-							X	
	0.10	. Re Ac	-		· · · · · · · · · · · · · · · · · · ·							-	0.15	
		Re Ac	•	-		┼							-	ł
	Less than 0.10	Ac F	D	D		D							Less then 0.15	
	lative		125	8	<u>3</u>	æ	3	8	128	991	192	ž		
,	Type of sampling plan		Single		Double				Vultiple					

Use next preceding sample size code letter for which acceptance and rejection numbers are available.

Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number

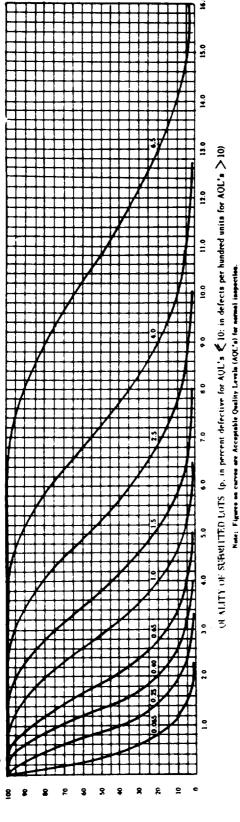
Rejection number

Use single sampling plan above (or alternatively use letter N).

TABLE X-L-Tables for sample size code letter: L

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple nampling are matched an clonely an practicable)



- TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptabl	e Ouality Level	Acceptable (Juality Levels (normal inspection)	ction)				
~	0.065	82.0	0 0	\$9:0	1.0	1.5	X	2.5	Χ	4.0	X	6.5
	p (in percent	p (in percent defective or defects	fects per hundred units)	od units)								
0.86	0.0051	0.075	0.218	0.412	6.893	1.65	1.75	2.39	3.05	3.74	5.17	6.29
8.0	0.0256	0.178	604.0	0.683	1.31	1.99	2.35	3.09	3.85	4.62	6.22	7.45
0.06	0.0525	0.266	0.551	0.873	1.56	2.33	2.72	3.51	æ:•	5.15	6.84	8.12
75.0	91.0	0.481	0.864	1.77	2.11	2.98	3.42	4.31	5.21	6.12	7.95	₩ 6
20.0	0.347	0.639	1.34	1.64	2.84	3.84	£.33	5.33	6.33	7.33	9.33	10.8
83.0	0.693	1.35	8:	2.56	3.71	28.7	O) 'S	6.51	1972	8.70	10.9	12.5
10.0	1.15	8.1	2.66	3.34	197	5.89	05'9	7.70	68.8	10.1	12.4	14.1
9.0	1.50	2.37	3.15	3.88	8.26	6.57	7.22	8.48	22.6	6'01	13.3	1.51
1.0	2.30	3.32	4.20	20.5	9:35	8.00	02.8	10.1	11.4	12.7	15.3	17.2
	01.0	07:0	\$9:0	1.0	5.1	X	2.5	Χ	€.0	Χ	6.5	Χ
					Accept	able Quality Le	Acceptable Quality Levels (tightened inspection)	inspection)				

Totac. All rathers gives to above table based on Polessa distribution so as approximation to the Discussed

TABLE X-L-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: L

	Cumu.						*	Acceptable (Juality Levels (normal inspection)	0 e	lity L	evels (norme	inspec	tion)											Cumu.
l ype ol sampling plan	lative sample	Less than 0.065	0.065	0.10	X	0.15	0.25	0.40		9.65	1.0		ν,	X		2.5	[X]		4.0	$ \!\!\!\!/\!\!\!\!\!/ $	$ \chi $	9	5:	Higher than 6.5	sample size
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	٧c	Re Ac	Re	Ac R	Re Ac	Re	Ac Re	Ac	Re	٧c	Re	Ac Re	Ac.	Re	۸c	Re	Ac Re	!
Single	200	Δ	1 0				1 2	2	3 3	+	S	2 9	60	6 0	6	=	12	13 1	14 15	- 19	61	21	22	٥	500
Double	125	D		Use	Use	Use	0 2 1 2	0 %	e +	→ ∨	6 2	7 8	~ 6	3 7	2 12	9	6 13	01 91	7 11 81	11 9 19 23	77	= %	16	۵	125
	ક	٥	፟.	¥	Z	y	. 2	•	2	m	•	0	-	0	0	5	0	9	_	-	60	8	•	٥	જ
	100						0 2	0 0	3 0	m +	- 61	5 6 5	∞ ∞	2 4	9 6	8 01	6 -	6 2	→ ∞	13 11	12	7 21	± £		90 95
Wultiple	82 S2						0 3	7 2	3 6	us vo	ر د ع	7 5	2 =	6 11 9	11 8	13	2 ±	15 1	12 12	17 16 20 22	8 8	5 %	8 8		230 200
	350						1 3	ო →	s s	9 1-	7 6	9 01 01 13	12	12 14	14 14 15 18	17	118	8 8	2 2 2	23 27 26 32	& B	37	E 8		350
		Less than 0.10	0.10	X	0.15	0.25	0.40	Š	SS S	0.1	1.5	14		2.5	+^-	$ \chi $	0.7	+	X	+	6.5	14	V	Higher than 6.5	
								Accept	ble (bality	Level.	Acceptable Quality Levels (tightened inspection)	اقو	nspeci	(uoi)			1							

= Use next preceding sample size code letter for which acceptance and rejection numbers are available. **4 4**

Use next subsequent sample size code letter for which acceptance and rejection numbers are available. 11

Acceptance number Ħ

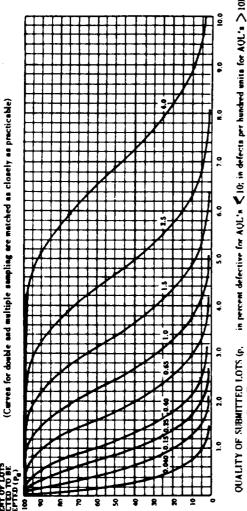
= Rejection number ÷

Use single sampling plan above (or alternatively use letter P).

Acceptance not permitted at this sample size.

TABLE X-M-Tables for sample size code letter: M

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS Œ CHART



in percent defective for AQL's < 10; in defects per hundred units for AQL's > 10)

- TABULATED VALUES FOR OPERATING CHARACTERSTIC CURVES FOR SINGLE SAMPLING PLANS TABLE X-M-1

					Acceptable Que	Acceptable Quality Levels (normal inspection)	mal inspection)					
a •	0.040	0.15	0.25	0,40	0.65	1.0	Χ	1.5	Χ	2.5	X	6.0
	p (in percent	p (in percent defective or in dejecta	dejects per hus	per hundred unita)								
0.66	0.0032	0.047	0.138	0.261	995.0	0.922	1.11	1.51	8 :1	2.38	3.28	3.99
98.0	0.0163	0.112	0.259	0.433	0.829	1.26	1.49	1.96	2.44	2.2	3.95	4.73
0.06	0.0333	0.166	0.349	0.533	1.00	1.48	1.72	2.23	2.75	3.27	¥.3	5.16
75.0	0.0914	0.305	0.580	0.804	1.34	1.89	2.17	2.74	3.31	3.89	5.05	5.93
90.0	0.220	0.532	0.848	1.17	1.80	2.43	2.75	3.39	4.02	99.7	5.93	6.88
25.0	0.440	0.854	1.24	1.62	2.36	3.07	3.43	4.13	183	5.52	6.90	7.92
10.0	0.731	1.23	99.1	2.12	2.94	3.74	4.13	4.89	5.65	6.39	7.86	8.95
5.0	0.951	1.51	2.00	2.46	3.34	4.17	85. 4	5.38	6.17	6.95	8.47	9.60
1.0	1.46	2.11	2 67	3.19	4.16	80.5	5.53	0+9	7.25	8.08	12.6	10.9
	0.065	0.25	0,40	0.65	1.0	Χ	1.5	Χ	2.5	Χ	4.0	X
					Acceptab	Acceptable Quality Levels (tightened inspection)	s (tightened ins	pection)				

Notes: All values gives in above table based on Pole

TABLE X-M-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: M

																							-
•	į							Accep	Acceptable Quality Levels (normal inspection)	vality	Level	Eou e	el inep	ection	F								
lype of sampling plan	lative sample	Less then 0.040	0.040	0.045	X	0.10	0.15	0.23	0.40		0.65	1.0	\vdash	Y	1.5		Y	2.5	<u>^</u>	X	4.0	Higher than 4.0	T
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	٧c	Re Ac	Re	Ac R	F	2	Ac B	ReAc	22	٧	ReAc	2	٧٧	Re Ac	22
Single	315	D	6		·		1 2	2 3	е -	\$	9	~	6 0	6	01	11 12	13	=	15 18	61	21	□ □ □	315
1	982	D	•	letter C			0 2	0		2	'n	3	3	~	, v	9	2	1 -	9 11	=	=	19 29 39 39 39 39 39 39 39 3	82
	400				c	7	1 2	⊕	-	5	~	60	- 11	12	12 13	3 15	2		19	র	28	72	\$
	08	٥	•		.	E	• 2	. 2	•	e e	-		0	-		0 8	9	_	1 1	•	~	4	8
	<u>8</u>							0	.0	3	v	-	7	~	د	<u>د</u>	•	-	9 9	12	7	*	99
	540						0	0 3		4	9	m	₹	•	9	-	12		13 11	17	13	161	240
Multiple	330						0	-	7	3	7	2	9 01	=	8 13	2 10	15	12 1	17 16	8	61	Ж	320
	ş						1 3	7	6	- 2	60	7		121	11 15	<u> </u>	17	17 2	8	Ю	Ю		8
	9						1		•	- 9	•	21 01	12 12	=======================================	17	7 28	8	2 2	2	53	E	33	\$
	98						2 3	→	٠	<u>~</u>	2	13 1/	2	-51	18 19		ង	ĸ	<u> </u>	æ	37		3 8
		Less than 0.065	0.065	X	0.10	0.15	0.25	0.40	0.65		91	X	-	1.5	X	1	2.5	X		9,	X	The the	<u> </u>
							₹	Acceptable Quality Levels (tightened inspection)	e Quali	ų Į	els (ti _t	ghened	d inspe	ction)	_						[·		<u> </u>

Use next preceding sample size code letter for which acceptance and rejection numbers are available.

Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number.

Rejection number.

Use single sampling plan above (or alternatively use letter ()).

Acceptance not permitted at this sample size. **45.45**

TABLE X-N—Tables for sample size code letter: N

OF NATES OF STRAILFIED LOTS (p. in percent defective for AQU's < 10; in defects per hundred units for AQU's > 10) - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS (Curves for double and multiple sampling are matched as closely as practicable) Note: Figures on curves are Acceptable (baslity Levels (AQL's) for normal inspection CHART N ۶ \$ ۶

TABLE X-N-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Accepted	Acceptable (Juality Levels (normal inspection)	s (normal inspe	ction)				
<u>.</u>	0.025	010	0.15	0.25	0+0	9 0	X	1.0	Χ	1.5	Χ	2.5
	p (in percen	p (in percent defective or in defects per hundred units)	n defects per hu	indred units)								
8	0.0020	0.030	0 087	0.165	0 357	0.581	0 201	₩\$6:0	1.22	1.50	2.07	2.51
95.0	0.0103	120.0	0.164	0.273	0.523	0.7%	0 939	1.23	15.1	1 85	2.49	2.98
0 06	0.0210	901.0	0.220	0.349	0.630	0.931	8-	1.40	1.73	2.06	2.73	3.25
75.0	0.0576	0.192	0 345	0.507	0 844	1.19	1.37	1.72	2.08	2.45	3.18	3.74
0.08	0.139	0.336	0.535	0.734	1.13	1.53	1.73	2.13	2.53	2.93	3.73	4.33
23.0	0.277	0.539	0 784	1.02	1.48	\$.	2.16	2.60	3.04	3.48	4.35	66.7
10.0	0.461	0.778	90:1	1.34	1.86	2.35	2.60	3.08	3.56	4.03	4.95	5.64
5.0	0.599	0.949	1.26	1.55	2.10	2.63	2.89	3.39	3.89	8E' ≯	5.34	6.05
	0.921	1.328	1.68	2.01	2.62	3.20	3.48	€0.4	4.56	8.09	6 12	6.87
	0.040	0.15	0.25	0 0	990	Χ	1.0	Χ	1.5	Χ	2.5	X
					Accepi	Acceptable (Juality Levels (tightened inspection)	vels (tightened	inspection)				
					4 - 14-2	6		signature of any series	le i mai			

TABLE X-N-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: N

ļ							Acı	eptabl	8	- j	Acceptable Quality Levels (somal inspection)			<u>ş</u>	}		l	ŀ		ļ	ŀ				
	lative sample	Less than 0.025	0.025	0.040	X	0.065	0.10	0.15		0.25	0.40	0.65	8	ΧI	$\frac{1}{2}$	1.0	<u> </u>	egraphi	1.5	싀	abla I	2.5	2.5 2.5		٠ ۽ ،
	R E	Ac Re Ac	ر چ	Ac Re Ac	æ	Ac Re	Ac Re	Αc	Re Ac	Re	Ac Re	¥c.	Re	Ac R	Re Ac	2	٧	<u>*</u>	Ac Re	¥	2	٧	Re Ac	2	
Single	905	٥	0 1				1 2	7	3	-	9 5	~	60	•	016	=	12	13 14	15	<u>s</u>	£	72	۵ 2	<u> </u>	
	315	ı		8	2 5	8	0 2		3	•	2 5	<u>m</u>	~	е.	2	•	۰	2	7 11	٥	=	=	Q 91	315	, <u>s</u>
Doeble	93	>	•	F .	F	e de	1 2	m	-	v	9	•	- -	1 11	12 12	13	12	91	18 19	ន	2	8	22	93	-
	ΣI	٥	•	x	>	2.	2		2			0	-	.	•	50	٥	•		-	60	7	٥	χī	S
	Ø						2	•	3	m	1 5	-	9	7	7	€0	6	٥	9	9	12	-	<u> </u>	ଯ	_
	375						0	•	3	•	2	<u>8</u>	•	-	6	2	~	12	22 60	13 11	12	13	-61	375	· S
Multiple	8						0		. 4	S	<u>د</u>	2	2	9		13	2	15.	12 17	7 16	ន	61	ĸ	S	_
	Ŕ						1 3	~	*	•	S	-	Ξ	•	12	15	=	13	17 28	8	ĸ	ĸ	&	 83	5
	<u>\$</u>						1 3	м	2	•	6 2	2 6	12	12 1	=======================================	11	2	8	21 23	3 27	&	31	æ	720	•
	E						2 3	•	2	~	9	10	2	±	15	61	2	ន	и И	% %	8	E	R		1 0
		Less than 0.040	0.040	X	0.065	0.10	0.15	0.25		0.40	0.65	X	∇	1.0		X	1.5	2	X		2.5	X	Higher than 2.5	. 1	
								Accept	eble (a lity	Acceptable Quality Levels (tightened inspection)	(tighte	rned i	Sepec	tion)										

Use next preceding sample size code letter for which acceptance and rejection numbers are available. Ħ **△▷੫²..**

Use sext subsequest sample size code letter for which acceptance and rejection numbers are available. Ħ

Acceptance number H

Rejection number

Use single sampling plan above (or alternatively use letter R).

Acceptance not permitted at this sample size.

TABLE X-P — Tables for sample size code letter: P

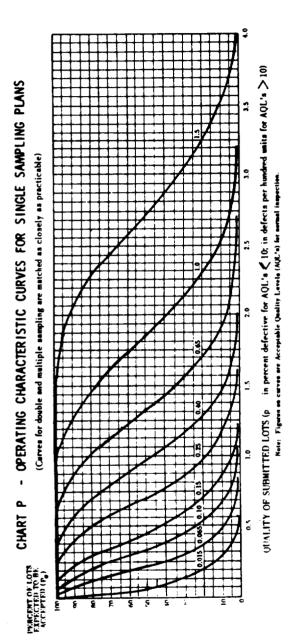


TABLE X-P-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptable	· Ounlity Levels	Acceptable (Junlity Levels (normal inspection)	ion)				
	0.015	90.0	01.0	0.15	0.25	0.40	X	0.65	X	1.0	X	1.5
	plin percent de	plin percent defective or defects per	ts per hundred units)	units)								
0.8	0.0013	0.0186	0.055	0.103	0.23	0.363	0.438	0.596	0.762	0.935	1.29	1.57
80	9000	0.0444	0.102	0.171	0.327	0.498	785.0	0.771	0.961	1.16	1.56	1.86
800	0.0131	0.0666	0.138	0.218	0.394	0.582	0.679	0.878	1.08	1.29	1.71	2.03
3.0	0.0360	0.120	0.216	0.317	0.527	0.745	0.855	1.08	1.30	1.53	1.99	2.34
20.0	0.0866	0.210	0.334	0.459	0.709	0.959	1.08	1.33	1.58	1.83	2.33	2.71
χ	0.173	0.337	0.490	0.639	0.928	1.21	1.35	1.63	1.90	2.18	2.72	3.12
10.0	0.288	0.486	0.665	0.835	1.16	1.47	1.62	1.93	2.22	2.52	3.09	3.52
5.0	0.375	0.593	0.787	0.969	1.31	1.64	1.80	2.12	2.43	2.74	3.34	3.78
1.0	0.576	0.830	1.05	1.26	1.64	2.00	2.18	2.52	2.65	3.18	3.82	4.29
	0.025	0.10	0.15	0.25	0,40	Χ	9.0	Χ	1.0	Χ	1.5	X
					Acre	Nable Quality L	Acceptable Quality Levels (tightened inspection)	inspection)				

All values gives in above table beard on Polasias distribution on an approximation to the Placesic

P

56

TABLE X-P-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: P

	ا							VOE	- Age		diry L	Acceptable Quality Levels (normal inspection)	(nor		, ig	8											,
lype of sampling plan	lative	0.010	0.015	0.025	X	0.040	0.065		0.10	9	0.15	0.25		0.40		\vee	0.65		$ \chi $		1.0	X		1.5		Higher then 1.5	lative sample
	92 is	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac R	Re Ac	<u> </u>	٧c	Ŗ	Ac F	Re Ac	: Re	٧c	Re	Ac B	Re Ac	æ	٧د	쮼	Ac	8	٩c	R A	Ac Re	
Single	8	٥	0 1					2 2	m	т	4	vo	9	60	80	6	10 1	11 12	13	*	15	92	<u>6</u>	12	ន	٥	008
2	95 S	D		2	3	3	•	0 7	6	ļ <u>-</u>	-	2	5 3	1 7	3	~	s	9	2	^	=	6	=	=	99	٥	995
e iongo	1000		•	,		7	-	2 3	•	•	S	9	7 8	6 8	11	12	12 1	13 15	16	8	19	ឌ	75	56	12		1000
	200	Δ	•	E	E	>		2 *	, 2	•	3	•	+	7 0	0	+	0	2 0	9		2	1	60	7	•	٥	200
	ĝ						٠	-	e .	•	ю	-	<u>~</u>	9	8	7	٣	<u>~</u>	•	*	2	٠	12	~	*		6
	99						•	~	0	_	•	6	•	ص ص	•	•	9	10 7	12	•	13	=	12	13	61		8
Multiple	8						•		-	7	Ŋ	m	~	5 10		=		13 10	15	13	17	91	ន	61	ĸ		8
	1000								2	m	•	S	80	7 11	_	12	=	15 14	11	2	8	ដ	Ю	ĸ	8		90
	1200			<u> </u>				س	3	•	٠	~	2 6	0 12	22	=	7	17 18	8	ឌ	ង	8	8	3	æ		1200
	1400				_		8	<u> </u>	S	•	~	•	10 13	3 7	=	15		19	ដ	ĸ	8	×	æ	37	8		1400
		Less than 0.025	0.025	X	0.040	0.065	0.10	+	0.15	°	83	0.40	-	$ \chi $	L	0.65	X	+,,	1.0	$\downarrow \Delta$	V		1.5	$ \Lambda $	\forall	Higher than 1.5	
								Yec	ept ep	♂	elity	Acceptable Quality Levels (tightened inspection)	(tigh	tened	ii.	ection	_								•		
										1					Ì							١	I	I			_

Use next preceding sample size code letter for which acceptance and rejection numbers are available.

Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number.

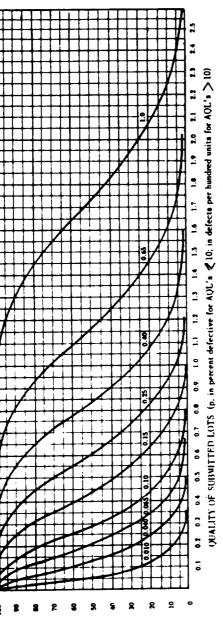
Rejection number.

^{4048.}

Use single sampling plan above.

TABLE X-Q — Tables for sample size code letter: Q

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS (Gurves for double and multiple sampling are matched as closely as practicable) CHART Q



Note: Figures on curves are Acceptable Quality Lavela (AQL's) for sormal imagaction)

OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

- TABULATED VALUES FOR

TABLE X-Q-1

2.42 2.75 1.30 1.73 2.00 2.22 1.19 \$ 1.0 0 0.828 0.995 1.49 1.7 2.14 2.45 8 1.27 8 0 0.598 0.746 0.824 0.979 8 1.39 7.7 3 1.17 1.61 0.615 0.488 0.692 0.834 0.65 1.0 122 1.42 8 1.83 0.690 Acceptable Quality Levels (tightened inspection) **3**50 0.853 0.382 0.562 3 1.23 1.36 \$ 191 Acceptable Quality Levels (normal inspection) 0.435 0.547 969.0 98.0 0.376 0 0.281 1.15 1.83 3 0.318 0.372 0.476 0.775 0.942 0.232 0.614 0.25 1 28 8 0.338 0.742 0.454 0.594 0.143 0.20 0.252 0.841 0 15 1.05 0.25 0 0656 0 620 0.140 0.203 0.294 0.409 0.534 \$ 08 0 0.109 0.10 0 15 defective or defects per hundred units 0.0349 0.0654 0.0682 0.214 0.426 90.00 0.672 0.065 0.138 0.314 0 10 0.0769 0.0119 0.0284 0.0426 0.310 0.040 0.134 0.215 0.380 0.065 0.531 p (in percent 0.00410 0.00840 0.010 0.00081 0.0230 0.0554 0.240 0.368 0.015 0.184 0.111 80 0 8 75.0 8 28.0 10.0 2.0 50.0 •

All values given in above table based on Poisson distribution Z Š

TABLE X-Q-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: Q

Cumu-	lative sample	š	1250	98	0091	315	989	945	1260	1575	0681	5022		
ರ		#	<u>-</u>	ļ							_		_	
	Higher 1.0	Ac I	4	٥		٥							Higher than 1.0	
	1.0	Re	ដ	1	5 27	6 2	7 14	3 19	ĸ	8	8	88	Χ	
		Re Ac	19 21		2	80		17 13	22 19	<u> </u>	33	33 37	\vdash	
	X	Ac R	99	Į	ឌ	_	9	11 1	16 2	ង	27 23	32 3	1.0	
		2	15.		\$	~	2	13	12	8	ន	*	\overline{V}	
	0.65	γc	* 1	٠	82	-	•	∞	13	12	71	ĸ	Χ	
	∇	Re	13	2	91	•	•	12	15	17	8	ผ	0.65	
	\triangle	٧c	12	9	55	•	6	~	2	=	2	2	°	l
	Q .	. Re	=		13	S	60	2	13	15	11	61	X	
		Re Ac	01		12 12	0		6	= 8	12 11	7	15 18	\vdash	tion)
ction)	X	Ac R	6 0	f	=	•	7	•	9	6	12 1	- -	0.40	usbec
d	x	Re	60		-	-	9	6 0		=	12	<u>±</u>		<u> </u>
i lem	0.2	٧c	4	e .	∞	0	-	ю	'n	~	2	EI	X	tighte
ls (no	0.15	Re	9	S	7	7	S	9	2	60	6	01	0.25	Acceptable Quality Levels (tightened inspection)
Leve		٧c	2	~	•	•	_	8	е.	s	_	•		2
elity	0.10	.	•		S.	8	m	•	S	•	•	7	0.15	ii e
Acceptable Quality Levels (normal inspection)		Re Ac	3	3	•	2 **	3	3		*	*	· s		ble
ebteb	0.065	Ac F	2	ŀ	e e			.,	_	7	ю 6		0.10	ccept
V CC	9	<u>.</u>	2	 	7	2	7	8	6	6	٣	6	55	1
	0.040	٧c	ı		-		•	0	0	_	-	8	0.065	
	023	: Re		Use Letter	α	:							0.040	
	0	¥.												
	X	Ac Re	:	Letter Use	v	•							0.025	
	115	æ		y <u>į</u>									\overline{V}	
	0.015	٧		Left of		· 							X	
	0.010	c Re	1	.		•							0.015	
	1	Re Ac	0	<u> </u>									-	
	X	٧c	:	Leffer C	2	:						!	0.010	
Cume	lative Ple		1250	8	1600	315	83	S£	1260	1575	1890	2205		
e e	sampling plan		Single	Double					Wultiple					

Use next preceding sample size code letter for which acceptance and rejection numbers are available. H 4

Rejection number

Acceptance number

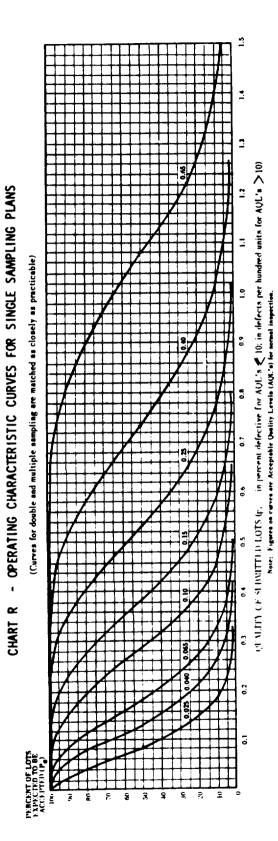
¥c

11 11 11

Use single sampling plan above.

Acceptance not permitted at this sample size.

TOPPE WILL THOUS 101 SHIPE OF THE TOPPE



- TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS TABLE X-R-1

				Accept	Acceptable Quality Levels (normal inspection)	els (normal inspe	ction)				
ď	0.035	0.040	590:0	01:0	0.15	X	0.25	Χ	0.40	Χ	0.66
	p (in percent o	p (in percent defective or defects	ts per hundred units)	its)							
0.66	0.0074	0.0218	0.0412	0.0892	0.145	0.175	0.239	0.305	0.374	0.517	0.629
95.0	0.0178	0.0409	0.0683	0.131	0.199	0.235	0.309	0.365	0.462	0.622	0.745
0.06	0.0266	0.0551	0.0873	0.158	0.233	0.272	0.351	0.432	0.515	0.684	0.812
75.0	0.0481	0.0868	0.127	0.211	0.298	0.342	0.431	0.521	0.612	0.795	0.934
50.0	0.0839	0.134	0.184	0.284	0.384	0.433	0.533	0.633	0.733	0.933	1.08
0.23	0.135	0.196	0.256	0.371	0.484	0.540	199'0	192'0	0.870	1.09	1.23
10.0	0.195	0.266	0.334	0.464	0.589	0.650	0.770	0.889	10.1	1.24	1.41
5.0	0.237	0.315	0.388	0.526	0.657	0.722	0.848	0.972	1.09	1.33	1.51
0.1	0.332	0.420	0.502	0.655	0.800	0.870	1.02	1.14	1.27	1.53	1.72
	0.040	0.065	0.10	0.15	Χ	0.25	X	0+0	Χ	99:0	Χ
					Acceptable Quali	Acceptable Quality Levels (tightened inspection)	ned inspection)				

te: All values gives in above table based on Palanon distribution on an approximation to the Disease

R

TABLE X-R-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: R

	Canal lative	ai ze	2000	1	8 8	8	8,	100	1500	2000	2200	3000	3500		
	Higher than	T <u>e</u>	0	+	1		4		·-·-		 -			Higher than 0.66	
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	L	¥ إ		:	= <u>x</u>	8	~	-	13	19	X	31	37	Λ	
	X	2	l	ĺ			-	6 12	17	2	83	&	8	0.65	
	-	<u>۷</u>	15 18	-	3 2	~	-		13 11	17 16	<u>8</u>	<u> </u>	- 32	 -	
	9	1		;			_	-	•	12 I	17 28	2 2	KI KI	X	
Ì	V	2	=	2			۰	•	12	15		R	8	<u> </u>	1
	X	٧		•	, <u>,</u>	}	0	٣	7	2	=	s	21	0.40	
	0.23	2	=	٩	, =	3	S	•	9	13	15	13	61		
ig.	9	لا	_ ≘		, 5	:	。	~	9	•	=	=	=	X	<u> </u>
Acceptable Quality Levels (sormal inapection)	X	2		,	. 12		•	7	0	Ξ	12	7	15	0.23	Acceptable Quality Levels (tightened inspection)
ě		٧	80	7			0	- 5	- 60	•		2	=	<u> </u>	3
els (mo	0.15	Ac Re	l	-			•	_	3	5 10	7 11	10 12	13 14	X	(tighte
* 1	0.10	22	٠	7	~		•	S	•	7	•	6	2 2	0.15	Levels
8	0	٧	ν	^			*	-	2	6	S	~	•	Ö	lity
ptable	0.065	E.	ľ	7	S		.e.	ю	•	S	. •	•	7	0.10	ble Qua
V V	<u> </u>	¥c		↓	_	_	8	٥		7	<u> </u>	_	9		ejda:
	0.040	Ac Re	2 3				•	0	0	-	2	ю 82	A N	0.065	¥
	\ <u>s</u>	He /	- 2	7			7	8	7	т	6	6	m		_
	0.025	۸c	~	٥			•	•	0	0	_	_	8	0.040	
	X	Re		a. C	Letter	v.	ı							0.025	
	\vdash	Re												-	
	0.015	٧c		Use	Lette	_	•							X	
	0.010	æ		* -	Letter	•	,							0.015	
	Ö	٧c		<u>-</u>		- 1									
	X	Ac Re	•		•					•				0.010	
3	lative		2000	1250	2500		8	1000	1500	2000	2200	3000	3200	} --	
	sampling plan		Single		Double		_			Multiple					

Use next preceding sample size code letter for which acceptance and rejection numbers are available.

	(Acceptable Quality Level (normal inspection)	Level
Type of sampling	Cumu- lative	X	
	size	Ac	Re
Single	3150	1	2
2	2000	0	2
Double	4000	1	2
	900	*	2
	1600	*	2
	2400	0	7
Multiple	3200	0	ю
	000†		က
	0087	-	е
	2600	2	က
		0.025	
	_	Acceptable Quality Level (tightened inspection)	y Level ion)

Acceptance number 11

Ac Re

)

Rejection number Acceptance not permitted at this sample size. N 11

Index of terms with special meanings

Term	Paragraph
Acceptable Quality Level (AQL) Acceptance number Attributes	9.4 and 10.1.1 1.4
Average Outgoing Quality (AOQ)	11.3 11.4
Batch	5.1 2.1
Code letters	9.3
Critical defect	2.1.1 2.2.1
Defect	2.1 2.2
Defects per hundred units	3.3
Double sampling plan	1.3
Inspection by attributes	
Inspection lot or inspection batch	5.1 11.6
Limiting Quality (LQ)	11.6
Lot or batch size Major defect	5.3
Major defective	2.2.2
Minor defect Minor defective	2.2.3
Multiple sampling plan	8.1 and 8.2
Operating characteristic curve	11.1
Percent defective Preferred AQLs	3.2
Process average	11.2
Reduced inspection	10.1.1
Responsible authority Resubmitted lots or batches	6.4
Sample	7.1
Sample size code letter	4.1 and 9.3
Sampling plan	10.1.1
Small-sample inspection Switching procedures	8.3
Tightened inspection	8.2 and 8.3.1

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