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SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES





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DEPARTMENT OF DEFENSE Washington 25, D. C.

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

MIL-STD-1050

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- 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:
 - 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.



CLASSIFICATION OF DEFECTS AND DEFECTIVES 2.

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

METHOD OF CLASSIFYING 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.
- CRITICAL DEFECT. A critical de-2.1.1 fect 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 DEFEC-TIVES. 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.

PERCENT DEFECTIVE AND DEFECTS PER HUNDRED UNITS

- EXPRESSION OF NONCONFORM-3.1 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 =
$$\frac{\text{Number of defectives}}{\text{Number of units inspected}} \times 100$$

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.:

Number of defects Defects per × 100 hundred units = Number of units inspected



ACCEPTABLE QUALITY LEVEL (AQL)

- The AQL, together with the USE. Sample Size Code Letter, is used for indexing the sampling plans provided herein.
- **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).
- When a consumer designates some specific

NOTE ON THE MEANING OF AQL.

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, for a given AQL. The AQL alone does not 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.
- 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.

SUBMISSION OF PRODUCT 5.

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 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.

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TABLE 1—Sample size code letters

								S)	(See 9.2 and 9.3)
-	erie dated so so.			Special insp	Special inspection levels		Gener	General inspection levels	levels
			S-1	S-2	S-3	S-4	-	Ш	Ш
2	2	æ	٧	V	V	٧	٧	٧	B
6	2	15	∢	V	∢	∢	∢	æ	ບ
16	2	X	⋖	<	6 0	В	B	ပ	a
92	2	8	«	æ	80	υ	υ	Q	ŧъ
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TABLE II-A—Single sampling plans for normal inspection (Master table)

(See 9.4 and 9.5)

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	93	Ac Re A	8 = \$ 1	
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		Re Ac	= 5 g = 5 V	
	0X2	¥	2 2 2 8 3 7	
	95	Ac Re	2 2 3 8 2 2 2 2	_
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	0.010	¥	\(\)\(\)	\Box
	Sample		2 3 3 5 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8	<u> </u>
	Sample	<u> </u>	< E C C B F C E - X - 3 X C C	:

— Use first sampling plan before arrow. If sample size equals, or exceeds, lot or batch size, do 100 percent inspection.

— Use first sampling plan above arrow.

As an Acceptance number.

Re — Rejection number.

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

(See 9.4 and 9.5)

	1000	Ac Re	2 T						
	S 3	Ac Re	18 19 27 28 41 42	=					
	8	A. P.	2 2 8	‡ (=					
	×	<u>ح</u> 2	8 9 12 13 18 19 2	8 3 V					
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(tighter	2.5	Ac Re Ac			2 6 4	9 6 17	° (
y Levels	1.5	2	<u> </u>		- 7 r - 3 r - 5 r	6 8 9 12 9 12 B	= V		
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SINGLE TIGHTENED

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

(See 9.4 and 9.5)

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SINGLE REDUCED

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

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Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
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DOUBLE NORMAL

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

(See 9.4 and 9.5)

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DOUBLE TIGHTENED

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

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DOUBLE REDUCED

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

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MULTIPLE NORMAL

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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MULTIPLE TIGHTENED

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

(See 9.4 and 9.5)

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MULTIPLE TIGHTENED

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

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MULTIPLE REDUCED

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

(See 9.4 and 9.5)

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MULTIPLE REDUCED

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

(See 11.4)

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Level	€.0	12	6.5	6.1 6.3 5.6	5.2 4.7 4.7		
Acceptable Quality Level	2.5	7.4	4.2	4.3 3.9 4.0	3.6 3.3 3.0	2.9	
table (1.5		9:	2.6 2.7 2.4	2.5 2.2 2.1	1.8	
Accep	1.0		2.8	1.7	1.6	1.3	
	0.65		1.8	=	1.1 0.97 1.00	0.90	0.73
	0.40			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	0.16
	0.010 0.015 0.025 0.040 0.065 0.10				0.18	0.11	0.042 0.069 0.097
	0.040				0.12	0.067	0.06
	0.025					0.074	0.042
	0.015					0.046	T
	0.010					6.029	
Sample		2 6 3	13	32 50 80	125 200 315	500 800 1250	2000
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(*** 11.4)

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

AOQL NORMAL

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

(See 11.4)

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7	6.5	12	6.9	13 5	6.4		
ality Le	4.0	7.4	4.2	£ 2 3	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	
Accep	1.5		2.8	1.7	1.6 1.6 1.6	16	
	1.0		9:	1.1	1.1 0.97 1.0	0.1 8.8 9.9	
	0.65			1.2	0.67 0.69 0.62	0 63 0.64 0.64	0.62
	07.0			97.0	0.42	0.39	9
	82.0			9.0	0.27	0.27 0.24 0.25	9.28
	0.15				6.73	0.17 0.17 0.16	9.16
	0.10				0.18	6 .11 0.11	0.097
	0.065				0.12	0.067	698.0
	040.0					97.0	0.042
	20.0		·			970.0	0.027
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	0.010						0.018
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Notes For the exact AOQL, the above values must be multiplied by (1 - Sample size)

(*** 11.4)

AOQL TIGHTENED

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

(See 11.6)

x 8 x 88 44 42 23 24 10 8 8 22 19 91 14 6.5 89 9.0 4.0 54 12 10 18 27 25 25 14 2 7.7 2.5 18 91 13 Ξ 37 4.0 3.5 5.9 4.9 8.2 1.5 12 10 25 3.7 2.5 6.5 4.6 5.4 1.0 તં 16 2.4 1.4 3.3 0.65 1 Acceptable Quality Level 1.0 6.9 2.7 1.5 1.2 0.40 3.1 2.1 . 0.77 0.94 1.2 0.25 2.0 4.5 1.7 0.59 0.84 0.74 1.1 0.15 1.2 2.8 0.67 0.46 0.78 0.53 0.10 1.8 0.33 0.490.43 0.065 1.2 0.27 0.73 0.31 0.040 0.20 0.46 0.025 0.290.015 0.18 0.010 Sample size 2000 800 1250 200 200 S & 125 13 20 Code letter **=** _ \sim = G ¥ **e** の ひ - 교 표

LQ (DEFECTIVES) 10.0%

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

(See 11.6)

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	59	330	310	240	190	991	140											-
	\$	270	82	190	150	130	100	88									·-	
	23	92 200	180	130	120	6	77	63	፠									
	15		130	110	26	11	29	48	\$	33								
	10			78	29	51	46	37	31	ĸ	23							
Level	6.5	120			6\$	7	33	82	77	61	91	*						
Acceptable Quality Level	4.0		"			8	22	21	61	15	12	91	0.6					
ble Q	2.5			2		-	20	17	13	12	7.6	7.7	7 :9	5.6				
Accept	1.5				83			12	=	8 .4	7.4	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	6.1	1.5	1.2	1.0	
	0.25								4.6			2.0	1.7	1.3	1.2	0.94	72.0	:
	0.15									2.9			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			0.49	0.43	0.33	
	0.040				_								0.73			0.31	0.27	
	0.025									481				0.46			0.20	
	0.010 0.015 0.025 0.040 0.065							. <u> </u>							0.29			
	0.010															0.18		-
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LQ (DEFECTS)
10%

TABLE VII-A—Limiting Quality (in percent defective) for which $P_a = 5$ Percent (for Normal Inspection, Single sampling)

(See 11.6) 20 8 46 37 32 26 20 24 6.5 28 18 15 8 8 8 * 41 9.6 4.0 **ස** ද Ξ \mathfrak{S} 32 14 88 16 8.5 7.0 6.1 2.5 45 18 15 13 Ξ 22 9.9 4.4 3.8 8.4 5.4 9.4 1.5 31 14 12 5.3 1.0 9.1 7.7 6.2 4.2 2.7 21 3.9 5.6 1.5 5.8 5.0 1.8 3.3 2.1 0.65 14 0.40 8.9 3.8 3.2 2.5 1.6 1.4 2.1 1:1 Acceptable Quality Level 0.25 0.85 5.8 2.4 2.0 1.3 1:1 0.15 99.0 0.97 0.84 3.7 1.3 1.5 0.10 0.95 0.79 0.62 0.53 2.4 0.065 0.39 0.59 0.50 1.5 0.040 0.32 0.38 0.95 0.025 9.0 0.24 0.015 0.38 0.010 0.24 Sample S 200 315 800 1250 3 13 32 50 80 125 200 2000 20 size Code letter _ Œ za 0 Œ G A B ပ Ľ ĹŁ, I ¥

LQ (DEFECTIVES) 5.0%

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

(See 11.6)

4.0 6.5 10 15 25 40 65 100 150 250 400 650 100 150 260 1000 150 250 1000 150 250 1000 1500 250 1000 10	
6.5 10 15 25 40 65 100 150 250 400 150 160 210 320 390 530 660 850 1100 59 130 160 210 260 340 440 610 810 39 73 130 160 210 260 340 440 610 810 39 53 66 85 110 150 270 380 510 710 20 34 44 61 5 68 95 7 7 7 7 7 7 7 7 100 100 110 150 150 110 440 110	
6.5 10 15 24 66 190 150 250 150 160 210 260 390 530 660 850 59 73 160 210 260 340 440 610 59 73 160 210 260 340 440 610 39 53 66 85 110 150 270 380 510 20 34 44 61 5 68 95 7 7 80 110 150 140 140 140 140 140 150	
150	
6.5 10 15 25 40 65 100 150 160 240 320 390 530 540 59 130 160 210 260 340 440	
6.5 10 15 25 40 65 150 160 210 260 390 59 79 170 160 210 260 39 79 170 160 210 260 39 79 170 160 210 260 39 53 66 85 110 150 21 27 38 44 61 150 18 24 61 85 110 150 15 27 38 95 85 110 150 18 24 61 85 110 150 150 150 150	
6.5 10 15 25 40 150 240 320 89 130 160 210 89 60 81 100 130 39 53 66 85 110 21 27 38 18 24 61	
6.5 10 15 25 4 150 240 3 48 60 81 100 1 26 34 44 61 21 27 38 68 1 18 24 61	
6.5 10 15 150 95 130 39 53 66 21 27 38 18 24 44 15 27 38	
6.5 10 1 6.5 10 1 6.5 10 1 6.5 10 1 7.0 95	
6.5 150 150 15 15 15 15 15 15 15 15 15 15 15 15 15	
0. 8 2 4 0 4 0 6	
2.5 24 24 66 16 11 11 11 11 11 11 11 11 11 11 11	
38 38 13 9.7 9.7 4.4 4.4 4.4 3.8 3.8	
23 23 4.2 5.3 3.4 2.7	2.4
Acceptable Quality Level 0.65 1.0 1.5 2.5 15 23 86 85 5.9 7.9 9.7 13 5.0 6.2 8.4 11 3.9 5.3 6.6 8.5 3.3 4.2 5.4 7.0 2.6 3.4 4.4 6.1 2.1 2.7 3.8	1.8
9.4 9.4 3.8 3.2 2.5 2.5 1.6	1.1
6.0 6.0 2.2 4 2.0 1.6 1.6 1.3	0.85
3.8 3.8 1.3 1.3 1.3 1.3 1.3 1.3 1.3 1.3 1.3 1.3	0.66
0.10 2.4 0.95 0.79	0.62
1.5	0.50
0.040	0.38
09.0	0.24
0.38	
0.010 0.015 0.025 0.040 0.065 0.010 0.065 0.040 0.065 0	0.24
Sample 33 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3	2000
600 c 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	2000

LQ (DEFECTS) 5%

TABLE VIII - Limit Numbers for Reduced Inspection

(See 8.3.3)

	0001	191			 .		
						-	
]]	059	115 178 100					
	400	88 105 181	262	· · · · · · · · · · · · · · · · · · ·		·	
	220	0 1 63	301				
	150	22 % 23	201 771 772				
	100	22 24	88 III		· ·		·
	\$9	8 13	42 72 115	<u>\$</u>			·
	9	* ~ *!	75 75 75 75 75 75 75 75 75 75 75 75 75 7	E 5	•		
	ĸ	3 7	∓ 13 3	3 2 3	-		
	Sı	0	7 13 22	& 2.8i	<u>\$</u>		
	01	0 0 0	* ^ 2	2 8 2	92 16		
1884	6.5	. • •	2 + 8	∓ 10 €	\$ 21 \$		
Juality 1	4.0	0	0 7 +	* = %	\$ \$ I	191	
Acceptable Quality Level	2.5		7 0 0	*~ =	22 92 53	181	
Acc	1.5			3	228	63 105	
	0.1			0 77	7 14 24	3.2 5	=
	0.65	• • •		007		8 2 8	115
	0.40				2 + 6	14 24	3 = <u>5</u>
	0.25				0 2	7 14 24	8 % 011
	0.15				00-	3 7 U	ឧឝឧ
	0.10					2 4 7	₹ \$ \$
	0.065			• • •		0 2	- ≥ ⋈
	0.040		• • •		• • •	2 0 0	4 8 2
	0.025				• • •		7 + 1-
				• • •			3
	0.010	• • •	• • •		• • •	• • •	7 0 0
Number of	sample units from last 10 lots or batches	20 · 29 30 · 49 50 · 79	80 - 129 130 - 199 200 - 319	320 - 499 50C - 799 800 - 1249	1250 - 1999 2000 - 3149 3150 - 1999	3000 - 7999 8000 - 12199 12500 - 19999	20000 - 31499 31500 - 49999 3000 & Over

Denotes that the number of number of number less 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 over in sequence, that they have all been on normal inspection, and that mone has been rejected while on original inspection.

LIMIT NUMBERS

28

(See 11.5) TABLE IX — Average sample size curves for double and multiple sampling C = 41 (normal and tightened inspection) Q: 1 n x proportion defective n x proportion defective n x proportion defective c = Single sample acceptance number n a Equivalent single numple nine * AQL for somel laspection 1/4.0 3/4• 12 3/4• Sample 1/2. 2 Average Size

AVERAGE SAMPLE SIZE

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)

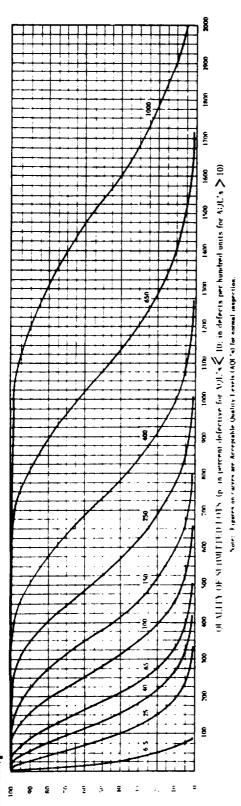


TABLE X-A-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptab	ole ()uality	Levels (no	Acceptable (Juality Levels (normal inspection)	ion)						
ē.	, 5.A	6.5	25	019	65	100	150	X	250	X	007	Χ	959	Χ	1000
	p (in percent defective)						i) d	p (in defects per hundred units)	r hundred u	nits)					
0 66	0.501	0.51	7.45	21.8	41.2	2.68	145	175	539	302	374	215	629	829	726
95.0	2 53	2.56	17.8	6.04	6.83	181	199	235	90£	385	462	729	745	\$66	1122
0.06	5.13	5.25	26.6	1.88	87.3	951	233	272	150	432	515	189	812	1073	1206
75.0	13.4	14.4	48 1	8.98	127	311	298	342	183	521	612	562	934	1314	1354
20.0	29.3	34.7	83.9	1 /E1	184	784	383	£13	533	633	733	633	1083	1383	1533
25.0	30 0	69 3	135	961	256	371	181	045	159	192	870	1087	1248	1568	1728
10 0	68.4	115	195	266	334	464	589	059	770	889	1006	1238	1409	1748	9161
5.0	77.6	150	237	315	348	526	657	722	848	972	1094	> EE1	1512	1862	2035
1.0	0.09	230	332	420	502	655	800	870	2001	1141	1272	1529	8121	2088	2270
	X	X	\$	65	100	150	Χ	250	X	004	X	650	X	0001	X
					Accepta	ble Quality	Levels (ti	Acceptable Quality Levels (tightened inspection)	pection)						

Biocestal distribution used for percent defective computations; Paisman for defects per hundred units.



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

$\overline{}$					T The state of the	1	
Cuma	sample size		2				
	1000	Ac Re	30 31	Đ	•	X	
	X	Ac Re	27 28	€	•	1000	
	059	Re	22	€	•	X	
	X	Ac Re Ac	18 19 21	£	•	929	
	400	Ac Re A	15	£	•	X	
	X	Re	2 13 14	£	•	400	
	250	: Re Ac	11 12	. 0	•	X	(F.
Acceptable (Juality Levels (normal inspection)	X	: Re Ac	9 10	•	•	250	Acceptable Quality Levels (tightened inspection)
ormel in	051	Re Ac	8	•	•	X	ightened
Levels (r	901	. Re Ac	6 7	•	•	150	Levels (t
Quality	88	Re Ac	\$	£	•	001	Quality
ceptable	\$	Re Ac	3	€	•	8	ceptable
¥	ĸ	Re Ac	2 2	€		\$	¥
	15	Re Ac	-	Letter Case	<u> </u>	ß	
	-	Re Ac				57	
	2	Re Ac		<u> </u>	.		
	X	Re Ac	:	Lette Co	1	2	
	6.5	٧	0	•	•	X	
!	Less than 6.5	Ac Re	Þ	>	>	Less than 10	
C	sample aire	_	2				
	Type of sampling		Single	Double	Multiple		
						_	

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 D). Use single sampling (or alternatively use letter B). D & & . E

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

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS (Curves for double and austiple sampling are matched as closely as practicable) CHART B

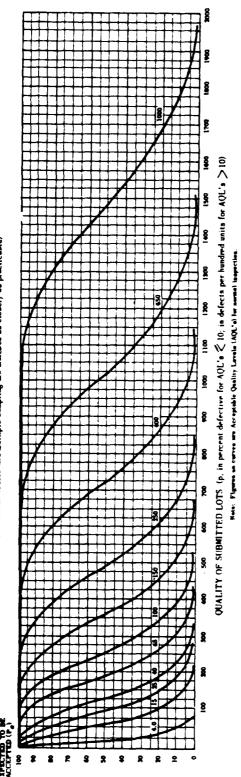


TABLE X-B-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

Pa 40 40 15 25 40 65 100							Acce	ptable Oua	Acceptable Quality Levels (normal inspection)	(Bormal i	nspection)							
p (in percent defective) p (in defects per hundred units) 0.34 4.97 14.5 27.4 59.5 96.9 117 159 239 249 345 419 1.70 1.71 11.8 27.3 45.5 87.1 133 157 206 256 308 415 496 541 496 541 496 541 466 541 466 541 466 320 256 329 320 422 469 228 228 228 228 228 422 469 422 469 623 623 422 469 462 862 278 286 289 336 422 469 623 623 722 722 722 722 722 722 722 722 722 723 723 360 434 507 590 724 723 724 724 724 724 724 724 724 724 <td< th=""><th>۵.</th><th>4.0</th><th>4.0</th><th>15</th><th>82</th><th>3</th><th>9</th><th>8</th><th>X</th><th>150.</th><th>X</th><th>952</th><th>X</th><th>93</th><th>X</th><th>050</th><th>X</th><th><u>8</u></th></td<>	۵.	4.0	4.0	15	82	3	9	8	X	150.	X	952	X	93	X	050	X	<u>8</u>
0.33 0.34 4.97 14.5 27.4 59.5 96.9 117 159 203 249 345 419 1.70 1.71 11.8 27.3 45.5 87.1 133 157 226 256 306 415 496 3.45 3.50 17.7 36.7 58.2 105 155 181 234 288 343 456 541 20.6 22.1 55.9 89.1 122 189 256 229 356 422 499 622 722 33.6 6.2 89.8 131 170 247 323 360 434 593 671 825 939 1 6.3 2 99.9 159 210 258 350 438 681 561 865 1008 1145 1 6.3 2 6.5 25 40 65 100 281 159 233 580 672 761 863 1019 1145 1 Accorpable Quality Levels (19thered inspection)		p (in percent defective)							ان ا	defects pe	r hundred .	mits)						
1.70 1.71 11.8 27.3 45.5 87.1 133 157 206 256 300 415 496 541 845 141 141 141 141 141 141 141 141 141 1	0	0.33	0.34	4.97	14.5	27.4	5.65	8.9	111	159	æ	249	35	614	ST3	153	7\$6	620
3.45 3.50 17.7 36.7 58.2 105 155 181 234 288 343 456 541 20.6 20.0 32.0 57.6 64.5 141 199 228 287 347 408 530 623 37.0 46.2 89.8 131 170 247 323 360 434 507 590 774 832 1 53.6 53.0 130 177 223 399 392 433 514 593 671 825 939 1 63.2 99.9 158 210 258 330 438 461 565 648 730 860 1008 1 65.5 65. 25 40 65 100	80	1.70	1.71	11.8	27.3	45.5	87.1	133	157	206	3 2	8	415	84	38	248	1065	1152
9.14 9.60 32.0 57.6 84.5 141 199 228 287 347 408 530 623 722 37.0 37.0 46.2 89.1 122 189 256 289 356 422 499 622 722 37.0 33.0 13.0 177 223 309 392 433 514 593 671 825 999 1 156 210 258 350 438 431 554 593 671 825 999 1 145 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	0.0	3.45	3.50	17.7	36.7	58.2	105	15.5	19	72	288	343	33	3	716	5	1131	1227
20.6 23.1 55.9 89.1 122 189 256 289 356 422 489 622 722 37.0 46.2 89.8 131 170 247 323 360 434 507 580 724 632 53.6 76.8 130 177 223 309 392 433 514 593 671 825 939 1 63.2 99.9 159 170 258 350 438 481 565 648 730 890 1008 1 78.4 154 221 280 335 431 533 580 672 761 849 1145 1 6.5 25 40 65 100 35 150 350 350 350 350 360 860 1145 1 400 37	5.0	9.14	09.6	32.0	97.6	84.5	141	199	228	287	347	\$	530	623	8	8	1249	35
37.0 46.2 89.8 131 170 247 323 360 434 507 560 774 632 1 1 63.2 1	0.0	20.6	23.1	88.9	89.1	122	<u>&</u>	8	882	356	ä	\$	622	22	226	1022	1386	-148
\$3.6 76.8 130 177 223 309 392 4.33 514 593 671 825 939 19 63.2 99.9 158 210 258 350 438 481 565 648 730 890 1008 1145 6.5 22 280 335 437 533 580 672 761 848 1145 1145 6.5 25 40 65 100 X 150 X 250 X 400 X Acceptable Quality Levels (tightened inspection)	5.0	37.0	46.2	8.68	131	170	247	323	98	25	255	95	22	832	1046	1152	1539	3
63.2 99.9 159 210 258 350 438 461 565 648 730 890 1008 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	0.0	53.6	8.92	130	171	23	88	392	433	514	293	129	825	626	1165	1277	1683	1793
784 154 221 280 335 437 533 580 672 761 848 1019 1145 1145 6.5 25 40 65 100 X 150 X 250 X 400 X Acceptable Quality Levels (1ightened inspection)	20	63.2	6:86	951	210	258	350	438	£	88	3	730	0680	1008	1241	1356	173	989
6.5 25 40 65 100 X 150 X 250 X 400 X Acceptable Quality Levels (11ghtened inspection)	9	78.4	351	ផ្ល	280	335	437	533	85	672	192	25	1019	1165	1392	1513	155	5069
Acceptable (bushisy Levels (tightened inspection)		6.5	6.5	ĸ	9	99	100	X	25	X	82	X	007	X	8	X	980	X
	_				I	 	γcc	eptable Qu	ality Level	ls (tighten	ed inspect	ion)						

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

)	
Сити-	lative sample	378	m	8	•			
	90	å	\$	5 31	5 57	‡	X	
	$\frac{1}{\sqrt{1}}$	Re Ac Re Ac	42 44	83	S3 S6	‡	1000	
	4	<u>۷</u>	31 41	22 23	38 22		Ÿ	
	જુ	Re Ac	30	20 17	37	<u></u>		
	XI	ا يو	27 28	15 20	34 35	‡	929	
	8	Re Ac	z	16 15	27	‡	X	
		Ac Re Ac	19 21	9 14 11	24 26	‡	6	İ
ion)	\triangle		15 18	11 6	19 23		1	
spect	250	Ac R	±	~	∞ ∤	‡	X	ction
mal in	X	ر چ	12 13	9 10	15 16	‡	230	l insp
Acceptable Quality Levels (normal inspection)	051	Re Ac Re Ac Re Ac Re	=	6	13	‡	X	Acceptable (Juality Levels (tightened inspection)
Leve	<u> </u>	- Vc	01 6	7 5	12 12		<u> </u>	ls (tig
ality	X	Re Ac	60	က	=	‡	150	Level
8	901		7 8	3 7	8 9	‡	X	ality
Ceptal	65	ReAc	•	2	7	‡	8	S
~	-	ReAc	ıs.	2	2		┼	cepts
	\$	Re Ac F			4	‡	85	¥
	25	Ac Re	2 3	0 3	ъ 4	‡	\$	
	15	F.	2	2	2	‡	25	
		ReAc	-	0		<u>'</u>	 	
	2	Αc	=		Lette	υ ————————————————————————————————————	15	
	X	Ic Re	<u> </u>	1	Cetter	e	2	
	6.5	. Re Ac		e e e e e e e e e e e e e e e e e e e	Letter Letter Letter	<	X	
		Re Ac		i		_	1/	
	\$	¥		•		•	6.5	
	Less than	Ac Re	Þ	٥	>	D	Less than 6.5	
	Cumu- lative	size	m	,	ı 			
	Type of	ue la	Single		Double	≺ ultiple		

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

Acceptance number

Rejection number ▷ ፟ ፟ .

H H H

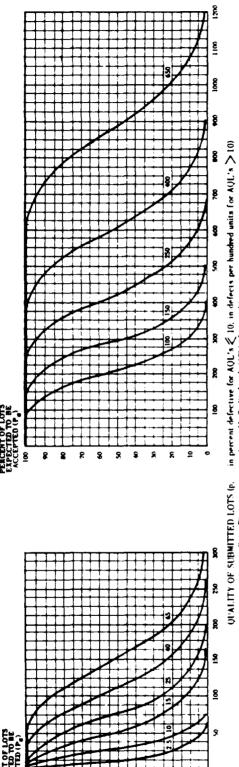
Use double sampling plan above (or alternatively use letter D). I se single sampling plan above (or alternatively use letter E).

B

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

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS CHART C

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



MITTED LOTS (p. — in percent defective for AQL's \leqslant 10, in defects per hundred units for AQL's > 10). Note: Figures on curve are Acceptable Quality Lavels (AQL's lor normal inspection.

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

							Acceptabl	e Quality !	Acceptable (Juality Levels (normal inspection)	rmal inspec	tion)							
ځ.	2.5	10	2.5	01	15	23	40	65	Χ	100	X	150	X	250	X	400	X	959
	p (in percen	p (in percent defective)							p (in	p (in defects per hundred units)	hundred u	ınits)	!					
0.66	0.20	3.28	0.20	2.89	8.72	16.5	35.7	 	1.07	95.4	122	150	202	152	344	391	895	819
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
0.09	2.09	11.2	2.10	10.6	22.0	34.9	63.0	93.1	109	140	173	306	273	325	62)	Z 8†	629	733
75.0	5.59	19.4	5.76	19.2	34.5	50.7	84.4	611	137	172	802	245	318	374	28	245	749	8
50.0	12.9	31.4	13.9	33.6	53.5	73.4	113	153	173	513	25.3	263	373	£\$	553	613	833	893
25.0	24.2	45.4	77.72	53.9	78.4	102	14.8	194	216	260	304	348	435	661	627	1659	923	286
10.0	36.9	58.4	46.1	77.8	901	134	98 186	235	260	308	356	403	495	264	669	992	1010	1076
5.0	45.1	6.5.8	59.9	8.9	126	155	210	263	280	539	386	864	534	909	745	814	1064	1131
1.0	60.2	77.8	92.1	133	991	201	292	320	34.8	403	456	504	612	68 7	835	806	1711	1241
	4.0	X	4.0	15	23	0\$	\$9	X	100	Χ	150	X	250	X	400	Χ	059	X
			ı		!		Accepta	ble Quality	Acceptable Quality Levels (tightened inspection)	lightened ii	repection)							
_																		



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

Cume	sample size		2	e 9			
	0001	Re	a C	Letter		0001	
-	83	G Re	4 45	25 31 56 57	‡	X	
	X	C Re Ac	11 42	& B	‡	95	
	§	C Re Ac	30 31 41	17 2223	‡	X	
	X	G ReiAc	28 28	15 20 17 34 35 37	‡	900	
	ρχ X	Re Ac Re Ac	21 22	2 12	‡	X	
	X	Ac Re	18 19	* 8	‡	220	
	23	Ac Re	25	16 18 19 23	‡	X	ction)
	X	Ac Re Ac	12 13 14	6 10	‡	150	Acceptable Quality Levels (tightened inspection)
	8	Ac Re Ac	9 10 11 12	5 9	‡	X	tightene
	X	Ic Re	6	3 7	‡	8	Levels (
	જ	Re Ac Re Ac	7 88	3 7 8 9	‡	X	Quality
	\$		5 6	2 5	‡	ક્ર	ptable
	ĸ	Ac Re Ac	3 4	1 4	‡	\$	V V V
	15	Ac Re Ac	2 3	3 4	‡	83	
	10	Re Ac Re Ac	1 2	0 2 1 2	‡	15	
	6.5	Re Ac Re		Letter		2	
	X	Ac Re		Use Use Use Letter Letter	ı	6.5	
	4.0	Re Ac Re Ac ReAc			•	X	
	2.5	Ac Re	0 1	•	•	9	
	Less then	Ac Be		D	D	then	
	Jative sample	size	S	9			
	Type of	<u>.</u>	Single	Double	Multiple		

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

Acceptance number.

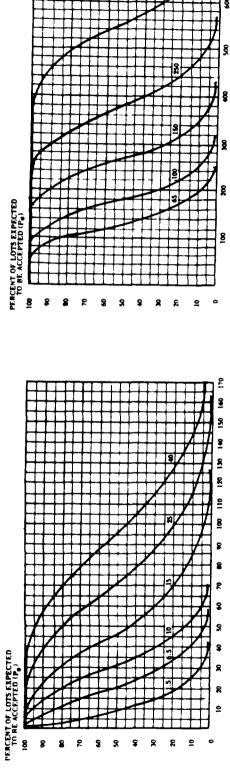
Rejection number.

Use double sampling plan above (or alternatively use letter D). Use single sampling plan above (or alternatively use letter F). 11 11 11 ▷ ≒ ₺ •

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

CHART D - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



QUALITY OF SUBMITTED LOTS (p. in percent defective for AQL's < 10; in defects per hundred units for AQL's >10)
Note: Figures as curves as Acceptable Quality Levals (AQL's) for normal inspection.

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

													- 4				3		
							*	ceptable ()	wality Love	Acceptable Quality Levels (normal inspection)	nspection)								
ď	1.5	6.5	2 │	1.5	6.5	0	15	23	\$	X	9	X	100	X	35	X	SZ	X	ĝ
	p (in p	p (in percent defective)	ective)							p (in de	fects per	p (in defects per hundred units)	ejis)						
0.66	0.13	2.00	00:9	0.13	1.86	5.45	10.3	22.3	36.3	43.8	9.69	76.2	93.5	129	157	215	×	35	ğ
95.0	99.0	2.64	1711	19:0	77.7	10.2	17.1	32.7	8 64	58.7	77.1	-8	911	351	38	249	188	8	3
0.06	1.31	98.9	14.7	1.31	6.65	13.8	21.8	39.4	S8.2	67.9	87.8	98	123	171	203	25	Ē	123	5
75.0	3.53	12.1	22.1	3.60	12.0	21.6	31.7	52.7	74.5	85.5	<u>8</u>	130	153	8:	25	303	33	\$	\$
20.0	9.30	20.1	32.1	8.66	21.0 /	33.4	45.9	6.07	6.59	8	133	55	183	233	123	346	88	165	5
25.0	15.9	30.3	43.3	17.3	33.7	0.64	63.9	92.8	121	135	163	8	218	272	312	392	3	165	3 3
10.0	25.0	9.04	53.9	28.8	9.84	\$ 5	83.5	911	147	162	193	222	252	3%	352	137	47A	5	3
8.0	31.2	47.1	59.9	37.5	59.3	7.87	6.96	131	<u>इ</u>	86	212	243	274	334	378	3	S	3 3	70,
1.0	43.8	8.95	70.7	9'25	83.0	105	128	35	200	218	252	285	318	382	623	225	38	732	776
	2.5	01	X	2.5	10	15	ಜ	0\$	X	65	X	90	X	85	X	052	X	9	X
								Acceptabl	e Quality 1	Acceptable Quality Levels (tightened inspection	htened ins	pection)							



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

	Cume. lative		∞	v	10	2	•	•	∞	01	12	=		_
	Higher than 400	ReAc Re	◁	◁		٥							Higher than 400	
	Ş	Ac Re	2	23 31	56 57	6 16	17 27	82	40 49	53 58	65 68	87 77	X	
	X	Ac Re	41 42	23 23	sz s3	6 15	6 25	26 36	37 46	\$	75	72 73	90	
	8	Ac Re	31	8	88	4 12	1 19 16	23	Ħ	\$	47	7	X	
	V	*	% %	20 17	35	2	17 11	24	31 27	37 36	. C. C. C. C. C. C. C. C. C. C. C. C. C.	₩	052	
		Re Ac	z z	16 15	<u>*</u>	9	2 2	19 17	22	32	3	8 8	7	
	32	¥	21	= =	8	8	~	13	6	ĸ	<u> </u>	33	X	
	X	Ac Re	18 19	6	23 24	6 0	6 12	11 17	16 22	22 25	27 29	32 33	150	
٦	8	Ac Re	15	7 11	61	1 7	01 •	8 13	17	8	23	25 26	X	(uc
Acceptable Quality Levels (normal inspection)	V	2	13 14	2	16 18	•	•	12	15 12	17 17	20 21	22	001	Acceptable Quality Levels (tightened inspection)
l in		ReAc	11	9	13 15	s 0	8	10 7	13 10	15 14	17 18	19 21	-	ned in
uou) s	\$8	¥	01 6	5	2 12	0	7	9	60	=	=	e	Λ	tighte
l'ewel	X	Ac Re	6	e .	11 12	0	2	•	9	9 12	12 14	14 15	જ	vels (
ality .	\$,	Re	8 2	3 7	8 9	† 0	9 1	80	5 10	7 11	10 12	13 14	X	نځ
Pe Q	22	Re Ac	9	v.	7	-	v	•	~	60	6	21 02	\$	e Que
ccepts		ReAc	5	2	2 6	3	3	7	5	9	- 9	6 2		eptabl
*	15	۸c	en en		•	*	•		8	m	-	9	22	¥cc
	10	Ac Re	2 3	3	3 4	# 2	0	0	-	2	3	\$	15	
	6.5	Ac Re	2	2	2	2	7	7	6	6	6	3	10	
	4.0	æ			ا د	_ _	•	•	<u>-</u> -	<u></u> -	- -	2	6.5	
	V	Ac Re Ac	 			•				 ·			4.0	
	2.5	Re Ac			3		-						Y	
		Re Ac Re	-		<u>s</u>								^	
	1.5	٧c	0	•		•							2.5	
	Less than 1.5	Ac Re	٥	Þ		٥							Less than 2.5	
	Cumu- lative sample	size	8	\$	01	2	•	9	œ	92	12	14		
	Type of sampling plan		Single	Deskla					Multiple					

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. II

Acceptance number 11

Rejection number II

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

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

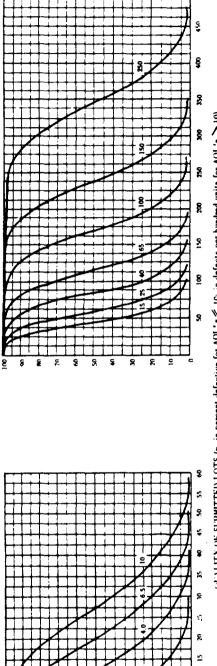
CHART E - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

PERCENT OF LOTS EXPECTED TO BE KCOLFIED (P.

E

۶ ۶



(ATALITY OF SUBMITTED LOTS (p. in percent defective for AQL's 🗧 16; in defects per hindred units for AQL's 🔰 10). Note: Figures on curves are Acceptable (ballity Levels (AQL's) for normal impection.

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

								Acceptabl	e Quality	Acceptable (Juality Levels (normal inspection)	ormal insp	section)								
a.	0.1	4.0	6.5	01	1.0	6.0	6.5	01	15	ß	X	04	X	99	X	100	X	150	X	250
	ءَ	in percen	p (in percent defective)	-							þ (in d	efects pe	p (in defects per hundred units)	units)						
0.60	0.077	1.19	3.63	7.00	820.0	1.15	3.35	6.33	13.7	₹7.72	27.0	36.7	6.94	57.5	79.6	2.96	132	951	219	238
8.0	0.394	2.81	6.63	11.3	0.395	2.73	6.29	10.5	20.1	30.6	36.1	47.5	59.2	1.1	5.7	115	153	173	246	266
90.0	0.807	4.16	8.80	14.2	0.808	4.09	8.48	13.4	24.2	35.8	41.8	54.0	66.5	79.2	105	125	166	18 2	261	282
75.0	2.19	7.41	13.4	19.9	2.22	7.39	13.3	19.5	32.5	45.8	52.6	66.3	80.2	1. 2	122	144	187	208	288	310
50.0	5.19	12.6	20.0	27.5	5.33	12.9	20.6	28.2	43.6	59.0	7.99	82.1	97.5	113	\$1	991	213	236	321	344
25.0	10.1	19.4	28.0	36.2	10.7	20.7	30.2	39.3	57.1	74.5	1.59	901	111	34	191	192	241	266	355	379
10.01	16.2	8.92	36.0	4.4	17.7	6.62	40.9	51.4	71.3	30.5	001	611	137	155	061	217	- 269	562	388	414
5.0	20.6	31.6	41.0	49.5	23.0	36.5	48.4	9.65	6.08	101	Ξ	130	051	98	292	233	286	313	409	435
e. –	30.8	41.5	9.08	58.7	35.4	51.1	5.43	77.3	101	123	134	551	921	8	235	264	321	349	420	477
	1.5	6.5	10	Χ	1.5	6.5	01	15	25	X	40	X	65	X	100	X	150	X	250	X
							i.	Acces	stable Qua	Acceptable Quality Levels (tightened inspection)	ls (tighten	ed inspec	tion)							

Note: Bloomial discribation sand for percent defective compatational Poisson for defects per builded units

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

	3									_	leas)	흏	8	<u> </u>	e ve	e)		1 1	Acceptable (nality Levels (sornal inspection)	_						İ	1	l				
t ilgan	lative	įįs	1.0	1.5	X	2.5	4.0	6.5	2	91	15		ĸ	$\vdash \stackrel{\wedge}{\rightarrow}$	X	3	 _ `	I X	18	<u></u>	X	S .	٠	X	 	ଝୁ		∇	Ñ	E SX	, 	. 4
		Ac Re	ReAc Re	ReAc Re	Re Ac Re	Re Ac Re	ReAc R	ReAc	ReAc	E	٧c	He A	ĺ	ReAc	ž	٧	- 8 ×	i i	<u>₹</u>	2	Ac B	ReAc	2	٧	<u>₹</u>	2	٧	ReAc	5 F	l ĕ	22	
Single	13	٥	1 0		-	<u>.</u>		2 2	3	•	8	•	~	&	•	01	=	12 11	13 14	15 1	8	19 21	ន	27 2	유 য়	31	7	3	2 3	٥	13	1
	60	٥			5	<u>.</u>		0	3	-	7	S	m	7 3	7	ဟ	-	9	2 0	=	9	= 31	2	y ₂	2 8	B	ន	8	23 31	△	•	7
Double	91		•	Letter	Letter Letter Letter	ء الله		2 3	-	S	٠	~	ت د	=	12	12	13 15		16.18	19		28	2	ಸ ಸ	35 37	8	22	- S	56 57		92	
	60	٥	•))	•	•	2	2	3	•	•	•	•	•	0	S.		- 9	-	_	2	•	3 1	9	12	v	15	91 9	٥	F	T
	9						•	2 0	9	3	_	S	_	- 5	7	6	•	ω	*	9	9	12 7	=	10	17 11	19	9	25 17	7 27		•	
	٥						0	2 0	3	•	7	•	<u>س</u>	-	•	•	9	7 13	*	13 11		17 13	6	17 2	24 19	12	×	<u>8</u>	8		•	
Multiple	12						•	3 1	+	2	6	~	2 10	9	=	•	13 10	0 15	2	17 16		<u>\$</u>	ĸ	24 31	-22	ਲ	37	*	\$		12	
	15							3	⊕	•	S	•	7 11		12	=	15 14		17 17	22		8	8	32	37	\$	\$	-8	S2 S8		15	-
	81							e e	<u>s</u>	9	2	6		12 12	=	=	17 18	8	፳	23 27		33	R	\$	<u>ड</u> इ	47	19	- 22 - 28	58		8	
	2						~	₩	S .	2	۰	2 2	13 14	=	15	•	19 21	1 22	ĸ	33		33	8	\$	\$	透	72	73 77	7 78		7	
		Less then 1.5	1.5	X	2.5	0.4	6.5	ļ ^s		15	ĸ	+	X		3	X		8			8			150	_	X	ង្គ	1	lΧ	Higher SS 0		٦ .
										You	q q	<u>ී</u>	Acceptable Quality Levels (tightened inspection)	٤	=	ighte	<u>ā</u>	od a	ction)												· · · · ·	

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

^{7 =} Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Ac * Acceptance number.

le = Rejection number.

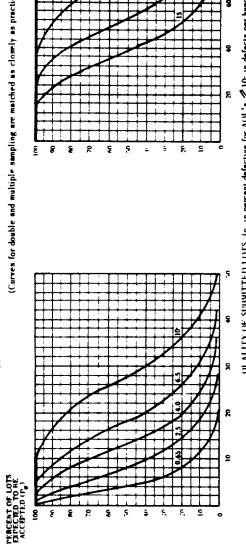
⁼ Use single sampling plan above (or alternatively use letter H).

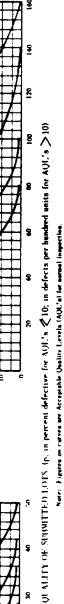
TABLE X-F-Tables for sample size code letter: F

F

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS CHART F

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





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

	. 65		62.9	74.5	81.2	93.4	108	123	₹		151	151
	X		51.7	62.2	99	2.67	93.3	109	124		133	133
	\$		37.4	46.2	51.5	61.2	73.3	87.0	101		601	
	X		30.5	38.5	43.2	52.1	63.3	76.1	6.88		97.2	
	23	d units)	23.9	30.8	35.1	43.1	53.3	65.1	77.0		8.48	- -
	X	p (in defects per hundred units)	17.5	23.5	27.2	34.2	43.3	54.0	65.0		72.2	+
spection)	15	o (in defects	14.5	19.9	23.3	29.8	38.3	48.4	58.9		65.7	
a (normal in	9	2	8.92	13.1	15.8	21.1	28.4	37.1	1.94		22.6	_
Acceptable (Juality Levels (normal inspection)	6.5		4.12	6.83	1 8.73	8 12.7	18.4	25.5	33.4		38.8	-
v() aldendas	\$		5 2.18	8 4.09	6 5.51	1 8.68	9 13.4	19.6	9.92	_	31.5	+-
٧c	2.5		51 0.75	57 1.78	27 2.66	18.4	8.39	3 13.5	19.5	_	73	-
	0.65		5 0.051	0.257	0.527	7	3.47	6.93	11.5	15.0	_	+-
	2		9.75	3 14.0	9.91 8	21.6	27.9	34.8	41.5	45.6	_	+
	6.5	efective)	5 431	2 7.13	6 9.03	0 12.8	181	24.2	30.4	34.4	_	+
	0.4	p (in percent defective)	2.25	4.22	2.64	1 8.70	13.1	18.7	24.5	28.3	_	-
	2.5	j) d	0.75	1.80	5 2.69	4.81	8.25	12.9	18.1	21.6	-	88.9
	0.65		0.050	0.256	0.525	1.43	3.41	6.70	10.9	13.9	-	╅
	ď		8	98.0	0.06	75.0	<u>8</u>	23.0	10.0	2.0		2



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

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	Cume.	lative sample		23	13	%	5	10	15	8	ĸ	8	32		
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			ž	z	92	27	6	=	6	23	&	33	8	V	
l		65	٧٧	21	=	%	~	-	13	61	क्ष	ε	37	X	
١		\vee	ž	19	14	*	80	12	11	22	83	8	33	88	
1		Χ	٧	18	6	ន	_	•	Ξ	91	8	2	8		
		Ç	2	15	=	61	-	9	13	11	8	ន	8	X	
ŀ			٧	<u> </u>	~	<u>e</u>		_	ac	2		12	23		
١		$ \chi $	2	13	2	91	~	6	12	15	11	8	22	\$	
l		\triangle	٧	12	۰	15	0	3	~	2	=	<u>=</u>	-2		
١		23	2	=	6	13	2	6 0	10	13	15	17	10	X	
			۷۷	2	\sqrt{s}	12	-	m	۰	60	Ξ	=			2
١	ē		Re	•	-	12	-	~	•	=	12		15	8	ection
١	ectio	\triangle	٧c	50	т	=_	0			•	_	12	=	ļ	insp
١	insp	22	æ	∞	1	•	•	•	e 0	2	=	12	=	ΙXΙ	Person
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١	e) si	9	æ	9		7	-	• •	•	7	•	•	91	15	vels
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l	Acceptable Quality Levels (normal inspection)	N,	포	+	-	S	~		•	Ŋ	9	9	7		Acceptable Quality Levels (tightened inspection)
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	Acc	4	۷۲	2	0	<u> </u>	•	0	0		7	<u></u>	*	ļ	*
		25	2	64	2	2	^ ا	. 2	2	3	33	•	9	0,	
		2	٧c		0		<u> </u>		۰	•	_	_	8		
		1.5	Ac Re		<u> </u>	l'etter	G							2.5	
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		Less	Re	D	D		t	>						ibess on o	
			1≤				+		. —————					+	1
	,	letive sample	size	8	13	- 5		^ <u> </u>		8	· ×	<u> </u>		-	
		Type of sampling	Ĺ	Single		Double				Weltiple	•				

Use 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. **4**

Acceptance number li

Rejection number ŧi ÷

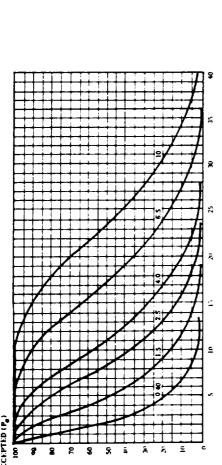
Use single sampling plan above (or alternatively use letter J).

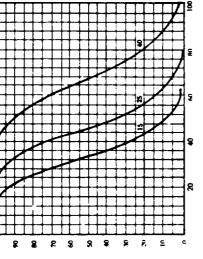
TABLE X-G-Tables for sample size code letter: G

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 VUL's \$\int defects per hundred units for AQL's > 10) Note: Figures on curves are Acceptable Quality Levels (AQL's) for nomal inspection.

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

							٧c	Acceptable Quality Levels (normal inspection)	uality Love	ens (normal	inspection	ē						
۵	0,40	1.5	2.5	0.4	6.5	01	0.40	1.5	2.5	4.0	6.5	01	X	15	X	\$3	X	0.7
)] °	p (in percent defective	defective	_						p Lin	p (in defects per hundred units)	hundred ut	hits)				
0.66	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
0.06	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	80.8
75.0	0.895	3.01	5.42	7.98	13.4	19.0	006:0	3.00	5.39	26.7	13.2	9.81	21.4	26.9	32.6	38.2	49.7	58.4
50.0	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
25.0	4.23	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	S 4.4	67.9	78.0
10.0	6.94	11.6	15.8	19.7	27.1	35.1	7.19	12.2	16.6	6'02	0'67	36.8	9.04	1.8	55.6	67.9	77.4	1.88
5.0	8.2	0.41	18.4	22.5	30.1	37.2	9:36	14.8	19.7	24.2	32.9	41.1	45.1	53.0	8.09	₹8.4	83.4	94.5
-	13.5	19.0	23.7	28.0	35.9	43.3	14.4	20.7	26.3	31.4	41.0	20.0	54.4	63.0	71.3	79.5	9.56	107
	0.65	2.5	0,	6.5	2	Χ	0.65	2.5	6.0	6.5	10	X	15	X	ß	X	9	X
								Acceptable	e Quality I	Acceptable Quality Levels (tightened inspection)	htened ins	pection)						-

and the second second to second to be second to be second to second the second to second to be second and



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

								¥ĕ	- de de	- O	Acceptable Quality Levels (normal inspection)	se	norma	l insp	ectio	2									
Type of	Cumu- lative	Less than						L				 		·	\	- 1	F		F			ŀ		Higher	Cumu- lative
plan	sample size	0.40	9.0	0.65	X	0.1	1.5	2	2.5	9	5.	_	2	<u>'\ </u>	χl	22		XI		г	X	,	\$	then 60	sample
		Ac Re	Ac Re	Re Ac Re	Ac Re	Ac Re	Ac Re	٧	윤	Ac Re	¥	- 2	Ac R	Re	æ	٧	- E	Ac B	Re Ac	ž	٧c	Re	Re	Ac Re	
Single	32	D	0 1					2	е .	→ €	رى -	•	-		•	9	=	12 11	13 14	15	81	19 21	22	٥	32
	8	D		Üse	Ose Ose	Use	0	0 0		_	8	S	9	7	-	2	•	-	7 01	=	5	= =	16	٥	8
Double	40		•	Letter	Letter	Letter	1 2	m		.v.	•	~	ac	=	12	12	13	15 10	91 91	61	23	- 2	Z		\$
	80	٥	٠	L	-	-	2	•	2	m	•	-		0	-	0	<u>~</u>		- 9	-	_	8 2	6	۵	80
	91						* 2	0	ю	0 3		2	•	- 5	7	က	∞	ب	*	2	6 1	12 7	±		16
	*						0 2	0	6	-	2	•	3 8	*	•	•	10	7 12	- 2	13	11 1	17 13	19		25
Multiple	32						0		*	2 5	٣	~	5 10	9	Ξ	∞	13	10	15 12	17	16 2	22	ХЗ		32
	\$						1 3	2	•	3 6	v,	6 0	7 11	<u> </u>	12	=	15	±	71 71	8	22 2	13	83		9
	3						1 3	<u> </u>	S	•	~	-	10 12	2 12	7	±	17_	18	20 21	ន	21 2	31	33		\$
	%						2	-	v	2 9	•		13 14	=	15	8	19	21 22	<u>8</u>	8	32 3	33 37	8		Ж
		Less than 0.65	0.65	X	1.0	1.5	2.5		0.4	6.5	01		X		15	Λ	\ <u></u>	25	^	Y	\$		X	Higher than 40	
							,	Accept	able (Quality	Acceptable (Juality Levels (tightened inspection)	s (tigh	htenes	l insp	ection	٠									

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

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

Acceptance number.

Hejection 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

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

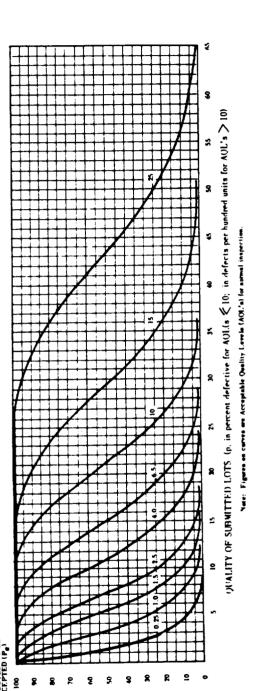


TABLE X-H-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

												1 2 2 2	1							
								Vice	Maple (A	Acceptable (Jamily Levels (normal inspection)	S (nowme	naber:							5	
۵.	0.25	1.0	5.1	2.5	0.4	6.5	X	2	0.23	0.1	1.5	2.5	0,	6.5	X	2	X	2	X	ĸ
•			ءَ [in percen	p (in percent defective)] -							ď	p (in defects per hundred units)	s per hand	med units)			i	
8	Ę	Š	0 888	3	3.68	88	14.7	E	0.020	0.298	0.872	1.65	3.57	5.81	7.01	3 5.6	12.2	15.0	20.7	23.1
2 8	0.020	2,5	3	271	2	8.28	9.76	12.9	0.103	0.710	18	2.73	5.23	8	9.39	12.3	15.4	18.5	24.9	8.62
2 8		5	, ,	2		9.53	11.2	14.5	0.210	8	2.20	3.49	6.30	9.31	6.01	14.0	17.3	9.02	27.3	32.5
Z Z	0.574	8	3.65	80%		12.0	13.8	17.5	0.576	1.82	3.45	5.07	2.2	911	13.7	17.2	20.8	24.5	31.8	37.4
5	5 5	2	5.31	96.		15.2	17.2	21.2	1.39	3.36	5.35	7.34	11.3	15.3	17.3	917	25.3	29.3	37.3	43.3
ž	2 2	S	7 70	9	14.5	18.8	21.0	25.2	2.77	5.39	7.84	10.2	14.8	19.4	21.6	28.0	30.4	34.8	43.5	6.64
0.00	5	3	10 3	2		24	24.7	29.1	19.4	7.78	9.01	13.4	18.6	23.5	26.0	30.8	35.6	40.3	5.64	3 8.4
2 5	2	6 13	27	=	661	24.7	27.0	31.6	8.8	6 46	12.6	15.5	21.0	26.3	28.9	33.9	38.9	43.8	53.4	60.5
3	8	12.5	15.9	88	24.3	29.2	31.7	36.3	9.21	133	16.8	20.1	26.2	32.0	34.8	40.3	45.6	6:05	1 19	68.7
	9	1.5	2.5	3		X	2	X	0 0	1.5	2.5	0.4	9:9	X	01	X	15	X	ß	X
								¥ V	opteble C	Acceptable Quality Levels (tightened inspection)	rels (tight	ened insp	ection)							

Binners of Alexandra and the serves defective competitions. Polesco for defects per booked with.

H



TABLE X-14-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: H

	Came-	lative sample size		S	8	3	E .	8	8	52	65	82			
	తే	<u> </u>	.	35		•		8	ň	· vi	•	2	6		
		Higher than 25	Ac Re	٥	4	1	۵							Higher than 25	
		23	æ	ឌ	29	12	6	=	61	ĸ	8	æ	88	V	١.
			٧٠	2] =	28	~	~	13	6	ĸ	31	34	Λ	
		\vee	æ	2	=	77	80	12	11	22	83	8	E	25	
		\triangle	٧	<u> </u>	•	ឌ	_	9	=	9	ដ	12	32	2	
		15	2	55	=	61	~	2	13	17	8	ន	×	\vee	
Ì		ļ	٧c	=		8_		*	•	12	12	2	ม	Χ	
		X	윤	13	2	16	•	•	12	15	11	8	Ø	15	
			٧c	12	•	15	-	m	~	2	=	22	21		
		2	2	=	•	13	S	•	2	13	15	11	19	X	<u>.</u>
	_	<u> </u>	Ac.	9	8	- 12	•	<u>س</u>	9	*	=	=	92	\square	Acceptable (Juality Levels (tightened inspection)
	tion)	X	.		,	12	1	7		=	12	=	15	2	10.0
	<u>a</u>	<u> </u>	Re Ac	6 0	3	_=	•	9	*	9 01		- 12			1
	. <u>:</u>	6.5		~	9	60		_	e E	2	11 2	10 12	13 14	XI	ight
	Acceptable Quality Levels (normal inspection)		Re Ac	9	N.	~	-	٠,	•	~	60	-	9	\longrightarrow	.
	ve ls	0.4			ļ	_							i	6.5	٤
	<u>.</u>		Re Ac	5	7	- 2	ه		-	5	9	- 9	6 2		• lity
	i e	2.5	Ac R						-					0,	♂
ļ	şe C	$\vdash \vdash \vdash$	Re	3		~	2	3	<u>-</u>	-			2 6		pt sp
	ebte	2	Ac I	5 ;	٥	· m				_	7	د	ű.	2.5	Acce
	¥	\vdash	Re	7	2	7	7	~	~	е.	<u></u>	<u></u>	3		
١		9	Ac	_		_			0	0	-	_	2	2.5	
		0.65	Ac Re		•	Letter	•							0.1	
		X	Ac Re	:	•	Letter	:							0.65	
		0+0	Ac Re		• •	Letter	,					•		X	
		82.0	Ac Re	- 0			•							0.40	
		Lesa than 0.25	Ac Re	D	D		٥			-				Less than 0.40	
	, i			S	32	3	13	*	ጽ	23	જ	82	16	<u>- 1</u>	
		Type of sempling plan		Single		Double				Multiple		•			

△ = 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

Re * Rejection number

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

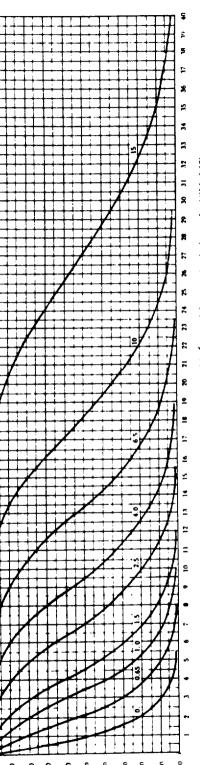
^{*} Acceptance not permitted at this sample size.

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

CHART J - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

8



QUALITY OF SUBMITTED LOTS (p. in percent defective for AQU'S \$10; in defects per hundred units for AQU'S >10). Note: Figures on curves are Acceptable Quality Levels (AQU's) for normal maperiols.

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

							ļ		Ver	-ptable (bushity Lo	evels (no	Acceptable (Juality Levels (normal inspection)	retion)								
ځ.	0.15	0.65	1.0	1.5	2.5	0.4	X	6.5	X	10	0.15	0.65	1.0	1.5	2.5	4.0	X	6.5	X	10	X	15
				٦	p (in percent de	t defective)	<u>6</u>								p (in defe	ets 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	2.88	9.75	0.013	0.186	0.545	1.03	2.23	3.63	4.38	5.96	7.62	9.35	12.9	15.7
95.0	780.0	0.444	1.03	1.73	3.32	5.06	8.3	1672	686	11.9	0.064	0.444	1.02	17.1	3.27	9 6.3	5.87	1.71	19.6	9.11	15.6	18.6
0.06	0.132	999 0	1.38	2.20	3.98	16.3	16.9	8.95	11.0	13.2	0.131	0.665	1.38	2.18	3.94	5.82	6.79	8.78	10.8	12.9	=	20.3
75.0	0.354	1 302	2.16	3.18	5.30	7.50	8.62	6:01	13.2	15.5	0.360	1 20	2.16	3.17	5.27	7.45	8.55	10.8	13.0	15.3	6 61	23.4
30.0	0.863	2.09	3.33	1.57	2.08	9.55	10.8	13.3	15.8	18.3	998.0	2.10	3.34	4.59	60.7	9.59	10.8	13.3	15.8	18.3	23.3	27.1
0.83	1.7	3.33	20.0	6.31	9.16	11.9	13.3	16.0	18.6	21.3	1.73	3.37	8	6.39	9.28	12.1	13.5	16.3	0.61	21.8	27.2	31.2
10.0	2.84	4.78	6.52	8.16	11.3	14.2	15.7	18.6	21.4	24.2	2.88	88	6 65	8.35	9:11	14.7	16.2	19.3	22.2	25.2	30.9	35.2
5.0	58	5.80	7.66	65.6	12.7	15.8	17.3	20.3	23.2	26.0	3.75	5.93	7.87	69 6	13.1	16.4	18.0	21.2	24.3	27.4	33.4	37.8
=	5.59	8.00	10.1	12.0	15.6	6 81	20.5	23.6	26.5	29.5	5.76	8 30	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	SI	X
									Acce	ptable ()	uality Le	vels (tig	Acceptable (Juality Levels (tightened inspection)	spection)							,	

. All values gives in short table based on Polanes distribution to in aggressization to the Utbestid.

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

							Vcc	eptable		غ ا	Acceptable Quality Levels (normal inspection)	i lear	specti	8											3
Type of	Canara- lative sample	Less than	0.15	0.25	X	0.40	0.65	2	-	1.5	2.5	\$		IX	9	Si	X	 	2	igtriangle	V	15		Higher than 15	lative
1	ais	Ac Re Ac	S.	Ac Rc	Ac Re	Ac Re	Ac Re	¥	Re Ac	2	Ac Re	٧	- V	Ac Re	¥	å	Ac f	Re Ac	: Re	Ac.	Re	Vc ⊓	ReAc	æ	2216
Single	8	D	1 0				1 2	7	3	•	8	<u></u>	60	6	2	11	12	13 14	15	188	19	21	22	4	&
	ક	Þ	•	e C	e n	nge C	0		3	-	2 5	8	7	3	2	•	٠	92	7 11	6	=	n	91	٥	S
Double	8			Letter	Leiter .	<u> </u>	1 2	е .	*	S	. 9	8 2	6	11 12	2 12	13	15	16 18	1	19	75	8	72		90
	8	D	•	=	د.	4	- 3	•	2	3	•	0	*	0	•	S	0	9		-	•	8	•	4	æ
	\$						2	•	3	<u>س</u>		2	•			•	60	•	-	9 01	12	7	=		\$
	8					· -	0	•	3	.	~	9	€	•	- 6	10	~	12	ب -	13 111	17	13	61		8
Multiple	8						0		-	80	e	- 2	2	11 9			13 10	12	12 1	17 16	ដ	61	क्ष		26
	81						1	2	*	•	s		=	6	12 11	15	=	17 1	17 2	8	ĸ	ĸ	8		100
	821						1 3	m	<u>~</u>	9	-	9 10	12 1	12 1	=======================================	17	8	8	21 2	22	8	31	8		120
	9						2 3	•	- <u>s</u>	6 7	٥	10 13	=	- <u>-</u>	15 18	61	12	8	ĸ	88	æ	37	88		140
		Less then 0.25	0.23	X	0.	0.65	<u> </u>	ļ <u>-</u>	ı,	2.5	4.0		Y	6.5		$ \chi $	og .		١X١	, ,	15			Higher them 15	
							VSV	pteble		<u>ت</u> او	Acceptable Quality Levela (tightened inspection)	htened	inspe	ction)											

Use 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.

Acceptance number Rejection number

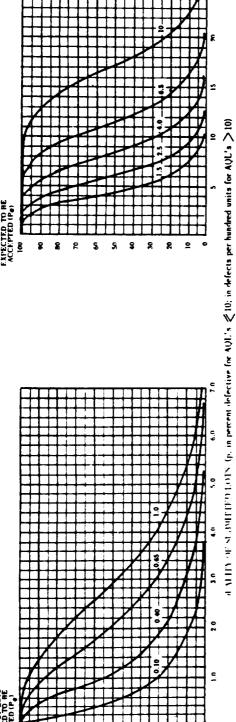
^{4048.}

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

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS CHART K

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



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Æ ç ź ŝ Note: Figures on curves are Acceptable Quality Levels (AQM,'s) for normal inspection.

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

	,				Acceptal	Acceptable Quality Levels (normal inspection)	els (normal inspi	ection)				
ď	01.0	0,40	0.65	1.0	1.5	2.5	Χ	4.0	Χ	6.5	Χ	10
	p (in percen	p (in percent defective or defects per	efects per hundn	hundred units)								
0.86	1900:0	611.0	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	8.7	9.15	7.40	9.95	11.9
0.06	0.0840	0.426	0.882	1.40	2.52	3.73	4.35	5.62	26.9	8.24	10.9	13.0
75.0	0.230	0.769	0.382	2.03	3.38	11.4	5.47	06:9	8.34	9.79	12.7	14.9
80.0	0.554	8.1	2.14	76.7	15'1	9 119	36 .9	8.53	10.1	11.7	6.41	17.3
25.0		2.15	3.14	4.09	96'5	7.75	8.64	10.4	12.2	13.9	7 721	20.0
10.0	1.84	3.11	4.26	5.35	7.42	27.6	10.4	12.3	14.2	1.91	8'61	22.5
8.0	2.40	3.80	5.04	6.20	17:8	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	20.4	24.5	27.5
	0.15	0.65	1.0	1.5	2.5	X	4.0	Χ	6.5	Χ	10	Χ
					Accep	Acceptable (Vaality Levels (tightened inspection)	vela (tightened	inspection)				
								1				

Notes All values given in above table beard on Polanes



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

														1	
	Š.	lative semple		83	86	991	33	3	*	128	99	192	22		
		Higher than 10	Ac Re	٥	٥		۵							Higher than 10	
Ì			æ	22	2	23	6	=	19	ĸ	8	33	8	X	
		2	٧c	21	11	8	8	~	13	2	X	31	37	\triangle	٠.
		V	Re	19	14	24	•	12	13	Z	83	8	83	9	
		\triangle	٧c	81	•	ន		•	=	9	8	2	32		
		6.5	: Re	15	=	61	,	2	8 13	2 17	22	1 23	28	ΙXΙ	
		ļ.,	Re Ac	13 14	2 01	16 18	9	-	-2 -	15 12	71 21	20 21	22	 	
		IX		12 1		15 1			7	9	_ _	18	; ;	6.5	
		۲÷	Re Ac	1111	•	13_1	S	60	9	13	-51		<u>~</u>	1	
		9	Ac 1	10	S	12			•	60	Ξ	±	18	X	
	-		Re	- 6	~	12 1	-	-	•	=	12	=	-51		tion)
	ction	X	Ac 1	•	3	Ξ		2	-	•	۰	2	±	4.0) s pec
	nepe		Re /	80	~	6	-	9	œ	2	=	12	±	V	i.
	THE E	2.5	٧c	2	₆	∞	-	-	٣	S	7	2	13	X	ghter
	Acceptable (Juality Levels (normal inspection)	2	Re	9	25	! ~	-	2	•	~	œ	٥	9	2.5	Acceptable Quality Levels (tightened inspection)
	Fe e	1.5	٧c	S	2	9	•		2	က	S	~	•	7	Lex .
	lity 1	1.0	Re	+	-	2	3	€	*	S	•	•	7	1.5	.lity
	3		۸c	3		_	•	0	_	2	m	-	9		3
	deb	0.65	Re	3		*	2	6	6	•	•	S	'n	9	Pa sp
	I ccel		Ac.	2	0	<u>m</u>	2		2 0	-	3_	3	€	ļ	Acc
		9	Re	2	2	7		2						0.65	
		<u> </u>	Re Ac		<u> </u>		•	_		-			- 5		
		0.23	Ac	:	5.	. tet	د.							9	:
		X	Ac Re	:	*	를 :	*							82.0	
		0.15	Ac Re	:	• •	reffer	-							X	
		0.10	Ac Re A	1 0		· · · · · ·	•							0.15	
		Less than	Re	٥	D		D	-						Less than 0.15	
			Ψc		-										
	Į	lative semple	9 i ze	125	8	<u>8</u>	æ	3		138	91	192	Ř		
		Type of sempling plen		Single		Double				Multiple					

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). Acceptance not permitted at this sample size.

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

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

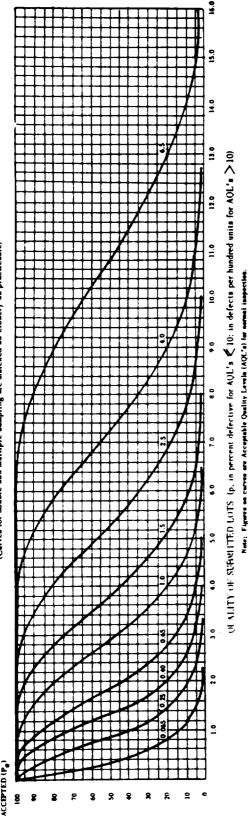


TABLE X-L-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptabl	Acceptable Quality Levels (normal inspection)	s (normal inspe-	ction)				
₫.	0.065	0.25	0,40	99.0	1.0	5'1	Χ	2.5	Χ	4.0	X	6.5
	p (in percent	p (in percent defective or defects per hundred units)	fects per hundri	ed units)								
0.66	0.0051	0.075	0.218	0.412	0.893	1.45	1.75	2.39	3.05	3.74	5.17	6.29
8.0	0.0256	0.178	60+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	155.0	0.873	1.58	2.33	2.72	3.51	4.32	5.15	6.84	8.12
75.0	\$1.0	0.481	0.864	1.27	2.11	2.98	3.42	4.31	5.21	6.12	7.95	9.34
80.0	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	18.1	O) 'S	6.51	1972	8.70	10.9	12.5
10.0	1.15	8.1	2.66	3.34	1971	5.89	05'9	7.70	69.8	10.1	12.4	14.1
8.0	1.50	2.37	3.15	3.88	5.26	6.57	7.22	8.48	9.72	10.9	13.3	15.1
1:0	2.30	3.32	4.20	20:5	6.55	8.00	02.8	10.1	11.4	12.7	15.3	17.2
	01.0	0,40	9.65	1.0	1.5	X	2.5	Χ	4.0	Χ	6.5	Χ
					Accept	Acceptable Quality Levels (tightened inspection)	vels (tightened	inspection)				

Note: All values gives in above table based on Polessa distribution as an approximation to the Biomaid.

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

, o	Cumu.							ccept	able (wality	Fe	s (non	Acceptable Quality Levels (normal inspection)	pection											Cumu.
sampling plan	sample size	Less than 0.065	90.0	0.10	X	0.15	0.25		0.40	0.65		1.0	1.5	\triangle	$\overline{\vee}$	2.5	/\	X	4.0	<u> </u>	$ \chi $	9	S	Higher than 6.5	sample size
		Ac Re	Ac Re	Ac Re	e Ac Re	Ac Re	۷c	Re Ac	Re	Ac Re	¥ Vc	F.	Ac Re	V V	-R	Ac Re	,	F	Ac F	Re Ac	بي م	۸c	æ	Ac Re	
Single	200	٥	0			· ·		2 2	3	3 4	<u>د</u>	9	8 2	66	6	11 01	1 12	13	1 11	15 18	61 8	21	22	٥	200
	125			es C	ž Ž	n n		2 0	6	_	8	2	3 7	9	~	\ v	9	2	~	=	41 6	<u> </u> =	91	△	125
Double	520	D	•	Letter	<u>ڈ</u>	<u> ځ</u>		2	-	.	9	7	6 60	=	13	12 13	3 15	16	81	19 23	3 2	*	27		250
	S	٥	•	×	Z	.		2	7	3	•	+	•	0	-		2 0	9		-	8 1	2	•	۵	જ
	<u>8</u>							2 0	ю	0 3		2	- 6	2	~	3	- 3	•	•	2	6 12	~	=		8
	130						0	2 0	6	-	C1	-9	3	₹	•	9	10 7	12	∞	13 11	1 17	2	ŝ		051
Multiple	200				····		•		+	2 5	<u>س</u>	~	2 10	9	=	∞	13 10	15	12	17 16	22	<u>\$</u>	23		200
	X						_	3	•	3	2	80	7 11	-	12	=	¥ 12	17	11	20 25	23	ध	8,		230
	300						_	3	Ŋ	9		6	10 12	2 12	=	1 ±	17 18	8	21	23 27	82 ~	31	33		900
	320						8	÷	S	2 9	6	01	13 14	<u> </u>	15	82	19 21	23	ĸ	32	2 33	37	8		350
		Less than 0.10	01.0	X	0.15	0.25	0,40		0.65	1.0	-	1.5	X	2.	5	X		4.0	X	\ <u></u>	6.5	$ \wedge $	X	Higher than 6.5	
								Acce	ptable	· Quali	ty Le	vels (ti	Acceptable Quality Levels (tightened inspection)	d insp	ection										

 $\Delta=0$ se next preceding sample size code letter for which acceptance and rejection numbers are available. $\nabla=0$ se next subsequent sample size code letter for which acceptance and rejection numbers are available. At $=\Delta$ ceptance number Use next preceding sample size code letter for which acceptance and rejection numbers are available.

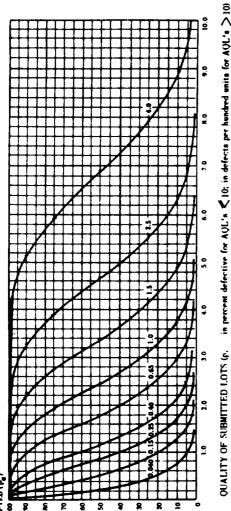
Re = Rejection number

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

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

- OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS CHART M

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



QUALITY OF SUBMITTED LOTS (p. — in percent defective for AQL's < 10; in defects per hundred units for AQL's > 10)

Note: Figure on curse are Acceptable (badity Levels (AQL's) for named impaction.

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

					Acceptable Qu	Acceptable Quality Levels (normal inspection)	mal inspection)					
å	0.040	0.15	0.25	0,40	0.65	1.0	Χ	1.5	X	2.5	X	4.0
	p (in percent	p (in percent defective or in dejects per hundred units)	dejects per hus	dred units)								
0.06	0.0032	0.047	0.138	0.261	995'0	0.922	11.1	1:51	₩1	2.38	3.28	3.99
95.0	0.0163	0.112	0.259	0.433	0.829	1.26	67.1	1.96	2.44	2.2	3.95	4.73
0.06	0.033	0.168	0.349	0.533	1.00	1.48	1.72	2.23	2.75	3.27	£.4	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
\$0.0	0.220	0.532	0.848	1.17	1.80	2.43	2.75	3.39	4.02	99.7	5.93	88.9
25.0	0.440	0.654	1.24	1.62	2.36	3.07	3.43	4.13	4.83	5.52	6.90	7.92
10.0	0.731	1.23	99.	2.12	2.94	3.74	4.13	68.7	5.65	6.39	7.86	8.95
5.0	0.951	1.51	2.00	2.46	3.34	4.17	4.58	5.38	6.17	6.95	8.47	9.60
1.0	1.46	2.11	2 67	3.19	4.16	5.08	5.53	01-9	7.25	8.08	12.6	10.9
	0.065	0.25	0,40	9.0	1.0	Χ	1.5	Χ	2.5	Χ	4.0	X
					Acceptab	Acceptable Quality Levels (tightened inspection)	s (tightened ins	pection)	:			

Note: All raines gives in above table based on Polesses



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

Less 0.040 0.065 X 0.040 0.065 X 0.040 0.065 X 0.040 0.065 X 0.10 0.065 X 0.065 X 0.065 X 0.065 X 0.065 X 0.065 X
0000 0.0065 0.000 0.0065 0.000 0.0065 0.000 0.0065 0.0000 0.0065 0.0000 0.0065 0.00000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.0000 0.000
0.00

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 ()). **45.45**

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

CHART N - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(3) ALLEY OF STEAMERED LOTS (p. in percent defective for AQL's \$10; in defects per hundred units for AQL's > 10) (Curves for double and multiple sampling are matched as closely as practicable) Note: Figures on curves are Acceptable (basity Levels (AQL's) for normal inspection. 8 ۶ 8 ٥

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

					Accepteb	Acceptable (Juality Levels (normal inspection)	s (normal insper	tion)				
۵	0.025	0.10	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)	defects per hu	ndred units)								
0.86	0.0020	0.030	0 087	0.165	0.357	0.581	0.701	₩\$6.0	1.22	1.50	2.07	2.51
95.0	0.0103	120.0	0 164	0.273	0.523	962.0	66 0	1.23	1.54	1.85	2.49	2.98
0 06	0.0210	0.106	0.220	0.349	0.630	0.931	1 09	04.1	1.73	2.06	2.73	3.25
75.0	92900	0.192	0 345	0.507	0.844	1.19	1.37	1.72	2.08	2.45	3.18	3.74
80.0	0.139	0.336	0.535	0.734	1.13	1.53	1.73	2.13	2.53	2.93	3.73	4.33
25.0	0.277	0.539	0 784	1 02	1.48	3 .1	2.16	2.60	3.04	3.48	4.35	6.3
10.0	194-0	0.778	90.1	1.34	1.86	2.35	2.60	3 OB	3.56	4.03	4.95	\$9.5
5.0	0.599	676 0	1.26	1.55	2.10	2.63	2.89	3.39	3.89	4.38	5.34	6.05
0-	0.921	1.328	1.68	2.01	2.62	3.20	3.48	4.03	4.56	5.09	6 12	6.87
	0.040	0.15	0.25	0 40	99.0	Χ	0.1	Χ	1.5	X	2.5	X
					Accep	Acceptable (Juality Levels (tightened inspection)	vels (tightened	inspection)				

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

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		2	19	14	77	80	12	17	ដ	ĸ	8	æ	2.5	
		٧c	5 2	٥	ន	_	9	Ξ	91	ដ	2	R		
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	X		13										1.5	
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		Re A	9 10	-	- 12	-	7	•	=	12	*	12	<u> </u>	ig Sign
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Acceptable Quality Levels (sormal inspection)	9	Re	8	~	•	-	۰	80	2	Ξ	12	=	∇	Acceptable Quality Levels (tightened inspection)
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	0.065	۷۷	:		<u> </u>	<u> </u>							0.10	
	X	Ac Re	:	.		>							0.065	
	0.040	Ac Re Ac	:	8	r r	X							X	
	0.028	2	0 1		•								0.040	
	0.025	Ac Re Ac	Þ	ı	>	D							Less than 0.040	
•	a di		8 8	315	8 3	ន	92	33	8	និ	₹	E		-
	Type of		Single		Doeble				Multiple					

Use next preceding sample size code letter for which acceptance and rejection numbers are available. Ħ **4 5 4 5**

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

Acceptance number H

Rejection number

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

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

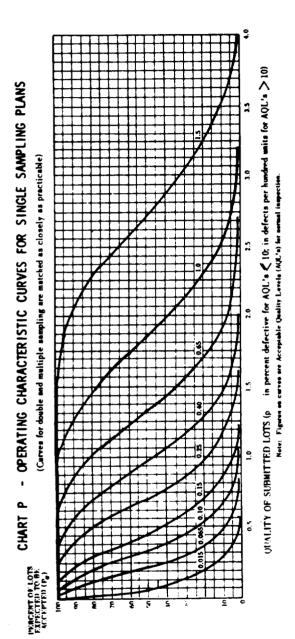


TABLE X-P-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptable	Acceptable (Junlity Levels (normal inspection)	(normal inspect	tion)				
چي	0.015	0.065	01.0	0.15	0.25	0,40	X	0.65	Χ	1.0	Χ	1.5
	plin percent d	plin percent defective or defects per	cts per hundred units)	units)								
8.0	0.0013	0.0186	0.055	0.103	0.23	0.363	0.438	965'0	0.762	0.935	1.29	1.57
8.0	0.0064	0.0444	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.16	1.56	1.98
0.06	0.0131	0.0666	0.138	0.218	0.394	0.582	0.679	9.878	1.08	1.29	1.71	2.03
75.0	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	6.173	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	9870	0.665	0.835	1.16	1.47	1.62	1.93	2.22	2.52	3.09	3.52
9.0	0.375	0.593	0.787	0.969	1:31	1.64	1.80	2.12	2.43	2.74	3.34	3.78
0.1	0.576	0.830	1.05	1.26	1.64	2.00	2.18	2:22	2.65	3.18	3.62	4.29
	0.025	0.10	0.15	0.25	0,40	Χ	99'0	Χ	1.0	Χ	1.5	X
					Acre	Acceptable Quality Levels (tightened inspection)	evels (tightened	inspection)	•			

Name: All values gives in above table based on Poinsies distribution on an expendiantion to the Diseased

P

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

	į							Acce	ide X	8	lity L	evels	E OE	Acceptable Quality Levels (normal inspection)	Pecti	Ê											C
Type of sampling ples	lative	0.010	0.015	0.025	X	0.040	0.065		0.10	e	0.15	0.23		0.40			0.65	$\vdash \hookrightarrow$	$ \chi $		1.0		abla	1.5		Higher then 1.5	lative
	92 is	Ac Re	Re Ac Re	Ac Re	Ac Re	Ac Re	Ac R	Re Ac	윤	۷۷	Re	Ac F	Re Ac	c Re	٧c	Re	Ac B	Re Ac	æ	۷	Re	٧c	8	Ac	Re	Ac Re	
Single	008	٥	0 1				1 2	2 2	•	8	•	v	9	7 88	•	6	10 1	11 12	13	*1	15	18	6	12	ន	۵	008
2	800	D		a n	3	<u>*</u>		0 7	6		-	2	8	3 7	9	~	S	9	92	-	11	•	=	=	99	٥	905
onon	1990		•		i i		-	2 3	•	-	S	9	7	8 9	11	12	12 1	13 15	91	2	19	ន	24	36	z		1000
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	Ş						•	- 0	m	0	m	-	ν.	1 6	8	~	က	- 80	•	*	10	•	12	-	=		8
	8							-0	m	_	*	8	•	د د	•	•	9	10 7	12	60	13	=	12	13	13		8
Multiple	8								•	8	Ŋ	۳	~	5 10	•	=	6	13 10	15	12	17	92	ន	2	ĸ		8
	1000						3	3	•	ю	٠	5 0	80	7 11		12	=	15 14	11	12	8	ដ	Ю	ĸ	8		98
	1200						-	3	'n	•	٠	~	-	10 12	12	=	7	17 18	8	<u> </u>	ន	2	क्ष	3	æ		1200
	9						8	<u>.</u>	vs 	•	-	•		13 14	=	15	18 1	19	ដ	Ŋ	8	×	æ	37	8		1400
		Less than 0.025	0.025	X	0.040	0.065	0.10	+	0.15	L	0.25	0.40	+	$ \chi $	°	0.65	X	+	0.1	$\downarrow \triangle \downarrow$	$ \chi $		1.5		\forall	Higher than 1.5	
								Acc	- Part	8	ality		(tigh	Acceptable Quality Levels (tightened inspection)	i	ction									•		
																						١	١	١			_

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.

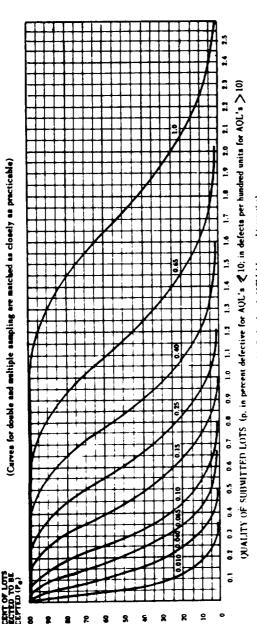
Rejection number.

4042.

Use single sampling plan above.

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

CHART Q - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



Note: Figures on curves are Acceptable Quality Lavels (AQL's) for sormal inapaction)

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

					Acceptab	Acceptable Quality Levels (normal inspection)	els (normal inspi	ection)				
<u>.</u>	0.010	0 0 0	990.0	01.0	0 15	0.25	X	0.40	Χ	99.0	Χ	1:0
	p (in percent	n (in percent defective or defects per hundred units	fects per hundr	ed units								
9 66	0.00081	6110.0	0.0349	9590 0	0.143	0.232	0.281	0.382	0.488	0.598	0.828	10.1
65.0	0.00410	0.0284	0.0654	601.0	0.209	0.318	0.376	0.494	0.615	0.740	0.995	1.19
3	0.00840	0.0426	0.0882	0.140	0.252	0.372	0.435	0.562	0.692	0.824	1.09	1.30
75.0	0.0230	0.0769	0.138	0.203	0.338	925 0	0.547	0.690	0.834	0.979	1.27	1.49
98	0.0534	0.134	0.214	0.294	0.454	0.614	769.0	0.853	10.1	. 1.17	1.49	1.73
25.0	0.111	0.215	0.314	0.409	0.594	0.775	0.864	1 .8	1.22	1.39	1.74	2:00
0.01	98.0	0.310	923.0	0.534	0.742	0 942	1.04	1.23	1.42	19:1	1.98	2.25
0.0	0.240	0.380	0.504	0 620	0.841	1.05	1.15	1.36	1.56	1.75	2.14	2.42
9 -	0.368	0.531	0.672	0.804	1.05	1 28	1.83	19:1	1.83	2.04	2.45	2.75
	0 015	0.065	010	0.15	0.25	Χ	0.40	Χ	0.65	X	1.0	Χ
					Accept	Acceptable Quality Levels (tightened inspection)	evels (tightened	inspection)				

Nees: All values given in above table based on Poloson distribation so an apprezimation to the Binomist



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

	Cuma-				ı		*	ceptsb	Š	lity L	Acceptable Quality Levels (normal inspection)	iamoi.	4	ction)										Cumu-
sampling plan	lative sample	X	0.010	0.015	X	0.025	0.040	0.065		0.10	0.15	0	22	X	6	3	X	\	0.65	\vdash	Y	10	Eben 1.0	lative sample
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	٧٥	Re Ac	S.	Ac Re	e Ac	Re	Ac R	Re Ac	Re	Ac I	Re Ac	c Re	• Vc	Re	Ac F	Re Ac Re	3126
Single	128		0				1 2	8	3	4	<u>s</u>	- 9	•	o c	01 6	11	12	13 14	\$1 1	92	19	z 12	۵, ۵	1250
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	83						* 2	0	3 0	m	-	2	9		۳	80	6	•	01	9	12	7 1	<u> </u>	920
	*				•		0 2	•	3	•	8	9	®	•	9	9	~	12	8 13	=	17	13 1	61	945
Wultiple	1380						0 3		7	S	<u>е</u>	2	01	9	= B	13	91	15 12	2 17	91	22	19 2	×	1260
	1575						1 3	7	₩ ₩	9	<u>د</u>	- 4	=	6	12 11	15	±	71 71	28	8	ĸ	23	8	1575
	98						1 3	e	* *	9	٠	2 6	12	12 1	71	11	≘	<u>2</u>	1 23	3 27	8	31 3		1890
	2205						2 3	*	2 6	7	9 10	0 13	2	14 1:	15 18	61	21	2 2	28	5 32	33	37 3	8	2205
		0.010	0.015	X	0.025	0.040	0.065	0.10		0.15	0.23	X	\Box	0.40	\square	X	0.65		X		1.0	X	Higher than	
								Accept	able (Zelity	Acceptable Quality Levels (tightened inspection)	(tight	ened i	nspec	tion)									· -

Use next preceding sample size code letter for which acceptance and rejection numbers are available. 11 < 4 € .

Acceptance number Rejection number 11 11 11

Use single sampling plan above.

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

CHART R - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

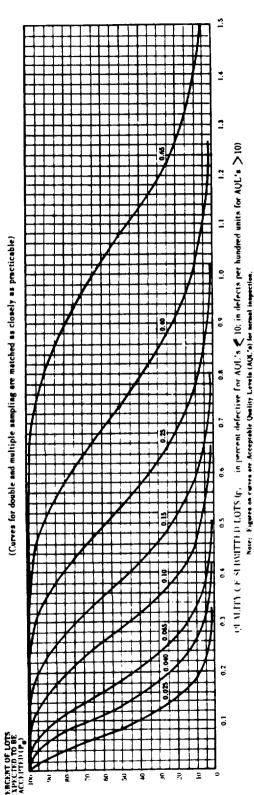


TABLE X-R-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

				Accept	Acceptable Quality Levels (normal inspection)	els (normal inspe	ction)				
ď	0.035	0.040	0.065	01.0	0.15	X	0.25	Χ	0.40	Χ	0.65
	p (in percent d	p (in percent defective or defects pr	s per hundred units)	(8)							
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	9980.0	0.127	0.211	0.298	0.342	0.431	0.521	0.612	0.795	0.934
20.0	0.0839	0.134	0.184	0.284	0.384	0.433	0.533	0.633	0.733	0.933	1.08
22.0	0.135	0.196	0.256	0.371	0.484	075'0	199'0	192'0	0.870	1.09	1.25
10.0	91.0	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	990:0	0.10	0.15	Χ	22.0	X	0+0	Χ	99:0	Χ
					Acceptable Quality Levels (tightened inspection)	ty Levels (tighte	ned inspection)				

res. All values gives in above table based on Palaesa Metibation on an approximation to the Meantal.



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

			a is	2000	1250	2500	905	1000	1500	2000	2500	3000	3500		
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	.E	$ \wedge $	¥	∞	9	=	0	8	•	•	•	21	=	0.25	d in
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	12	Ö	۷ ا	~	<u>س</u>	ac	•	-	3	S	~	2	13	X	• (ti
	Acceptable Quality Levels (normal inspection)	0.10	2		S	~	•	2	9	7	•	•	91	0.15	Acceptable Quality Levels (tightened inspection)
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	eptebl	0.065	2	1	-	S		æ	•	S	, •	•	7	0.10	S a
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	İ	0.040	Re		l "	•	7	е	m	•	•	vo.	N)	0.065	Yec
		0.025 0	٧	2 2	7	2 3	2	- 0	2	3	3	<u></u>	*		
			Ac Re	_		-			6	0	_	_	~	0.040	
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		X	۸c		.	- Jetter	n							0.025	
		0.015	Ac Re		Use	ء الله	<u> </u>							X	
		0.010	Ac Re		2 .	<u>ا</u>	>							0.015	
		X	Ac Re	0 1		•				•				0.010	
	3	lative	size	2000	12%	2500	995	990	1500	2000	2200	3000	3200		
	1	sampling plan	•	Single	:	Double				Multiple					

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

Acceptance number.

Q < 2 .

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

		Acceptable Quality Level (normal inspection)	low
Type of sampling	Cumu- lative sample	X	
	size	Ac F	Re
Single	3150	1	2
17-6	2000	0 2	
Pondie	4000	1	2
	008	*	2
	1600	•	2
	2400	0	7
Multiple	3200	0	
	000+		ب
•	0087		8
	2600	8	3
		0.025	
	_	Acceptable Quality Level (tightened inspection)	vel

Acceptance number 11 Ac Re

)

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



Index of terms with special meanings

Term	Paragraph
Acceptable Quality Level (AQL)	4.2 and 11.1
Acceptance number	9.4 and 10.1.1
Attributes	1.4
Average Outgoing Quality (AOQ)	11.3
Average Outgoing Quality Limit (AOQL)	11.4
Average sample size	11.5
Batch	5.1
Classification of defects	2.1
Code letters	9.3
Critical defect	2.1.1
Critical defective	2.2.1
Defect	2.1
Defective unit	2.2
Defects per hundred units	3.3
Double sampling plan	10.1.2
Inspection	1.3
Inspection by attributes	1.4
Inspection level	9.2
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Isolated lot	11.6
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Lot	5.1
Lot or batch size	5.3
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Minor defect	2.1.3
Minor defective	2.2.3
Multiple sampling plan	01 3 0 2
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Operating characteristic curve	11.1 11.9
Original inspection Percent defective	2 2
Percent delective	3.2 4.6
Preferred AQLs	11 2
Process average	82 and 833
Reduced inspection	10.1.1
Responsible authority	
Resubmitted lots or batches	
Sample	
Sample size	
Sample size code letter	
Sampling plan	
Single sampling plan	
Small-sample inspection	0.0
Switching procedures	
Tightened inspection	
This of product	1.5



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