

This Australian Standard was prepared by Committee QR-008, Quality Systems. It was approved on behalf of the Council of Standards Australia on 26 May 2003 and published on 28 July 2003.

The following are represented on Committee QR-008:

Australian Chamber of Commerce and Industry
Australian Industry Group
Australian Information Industry Association
Australian Institute of Petroleum
Australian Organisation for Quality
Bureau of Steel Manufacturers of Australia
Certification Bodies (Australia)
Commonwealth Department of Transport and Regional Services
Department of Agriculture, Fisheries and Forestry (Commonwealth)
Department of Defence (Australia)
Department of Industry Science and Resources (Commonwealth)
Federal Chamber of Automotive Industries
Institute of Materials Engineering Australasia
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PREFACE

This Standard was prepared by the Standards Australia Committee QR-008, Quality Systems.

This Standard is identical with, and has been reproduced from ISO 2859-1:1999, *Sampling procedures for inspection by attributes*, Part 1: *Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*.

The objective of this Standard is to specify an acceptance sampling system for inspection by attributes. It is indexed in terms of the acceptance quality limit (AQL).

As this Standard is reproduced from an international Standard, the following applies:

- (a) Its number appears on the cover and title page while the international Standard number appears only on the cover.
- (b) A full point substitutes for a comma when referring to a decimal marker.
- (c) In the column “Sample size” corresponding to the row for sample size code letter H, replace the value ‘50’ with the value ‘20’.

NOTE: This correction is identical with Technical Corrigendum 1 (2001) to ISO 2859-1:1999

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2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 2859. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 2859 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 2859-3:1991, *Sampling procedures for inspection by attributes — Part 3: Skip-lot sampling procedures*.

ISO 3534-1:1993, *Statistics — Vocabulary and symbols — Part 1: Probability and general statistical terms*.

ISO 3534-2:1993, *Statistics — Vocabulary and symbols — Part 2: Statistical quality control*.

3 Terms, definitions and symbols

3.1 Terms and definitions

For the purposes of this part of ISO 2859, the terms and definitions given in ISO 3534-1 and ISO 3534-2 and the following apply.

NOTE For ease of reference, the definitions of some of these terms are quoted from ISO 3534-1 and ISO 3534-2, while others are redefined or newly defined.

3.1.1

inspection

activity such as measuring, examining, testing or gauging one or more characteristics of a product or service, and comparing the results with specified requirements in order to establish whether conformity is achieved for each characteristic

3.1.2

original inspection

first inspection of a lot according to the provisions of this part of ISO 2859

NOTE This is to be distinguished from the inspection of a lot which has been resubmitted after previous non-acceptance.

3.1.3

inspection by attributes

inspection whereby either the item is classified simply as conforming or nonconforming with respect to a specified requirement or set of specified requirements, or the number of nonconformities in the item is counted

NOTE Inspection by attributes includes inspection for conformity of items as well as inspection for number of nonconformities per hundred items.

3.1.4

item

that which can be individually described and considered

EXAMPLES

- a physical item;
- a defined quantity of material;
- a service, an activity or a process;
- an organization or a person; or
- some combination thereof.

3.1.5 nonconformity

non-fulfilment of a specified requirement

NOTE 1 In some situations specified requirements coincide with customer usage requirements (see **defect**, 3.1.6). In other situations they may not coincide, being either more or less stringent, or the exact relationship between the two is not fully known or understood.

NOTE 2 Nonconformity will generally be classified according to its degree of seriousness such as:

Class A: those nonconformities of a type considered to be of the highest concern; in acceptance sampling such types of nonconformities will be assigned a very small acceptance quality limit value;

Class B: those nonconformities of a type considered to have the next lower degree of concern; therefore, these can be assigned a larger acceptance quality limit value than those in class A and smaller than in class C, if a third class exists, etc.

NOTE 3 Adding characteristics and classes of nonconformities will generally affect the overall probability of acceptance of the product.

NOTE 4 The number of classes, the assignment into a class, and the choice of acceptance quality limit for each class, should be appropriate to the quality requirements of the specific situation.

3.1.6 defect

non-fulfilment of an intended usage requirement

NOTE 1 The term "defect" is appropriate for use when a quality characteristic of a product or service is evaluated in terms of usage (as contrasted to conformance to specifications).

NOTE 2 Since the term "defect" now has definite meaning within the law, it should not be used as a general term.

3.1.7

nonconforming item

item with one or more nonconformities

NOTE Nonconforming items will generally be classified by their degree of seriousness such as:

Class A: an item which contains one or more nonconformities of class A and may also contain nonconformities of class B and/or class C, etc.;

Class B: an item which contains one or more nonconformities of class B and may also contain nonconformities of class C, etc. but contains no nonconformity of class A.

3.1.8

percent nonconforming

(in a sample) one hundred times the number of nonconforming items in the sample divided by the sample size, viz:

$$\frac{d}{n} \times 100$$

where

d is the number of nonconforming items in the sample;

n is the sample size

3.1.9

percent nonconforming

(in a population or lot) one hundred times the number of nonconforming items in the population or lot divided by the population or lot size, viz:

$$100p = 100 \frac{D}{N}$$

where

- p is the proportion of nonconforming items;
- D is the number of nonconforming items in the population or lot;
- N is the population or lot size

NOTE 1 In this part of ISO 2859 the terms **percent nonconforming** (3.1.8 and 3.1.9) or **nonconformities per 100 items** (3.1.10 and 3.1.11) are mainly used in place of the theoretical terms "proportion of nonconforming items" and "nonconformities per item" because the former terms are the most widely used.

NOTE 2 This definition differs from that found in ISO 3534-2.

3.1.10 **nonconformities per 100 items**

\langle in a sample \rangle one hundred times the number of nonconformities in the sample divided by the sample size, viz:

$$100 \frac{d}{n}$$

where

- d is the number of nonconformities in the sample;
- n is the sample size

3.1.11 **nonconformities per 100 items**

\langle in a population or lot \rangle one hundred times the number of nonconformities in the population or lot divided by the population or lot size, viz:

$$100p = 100 \frac{D}{N}$$

where

- p is the number of nonconformities per item;
- D is the number of nonconformities in the population or lot;
- N is the population or lot size

NOTE An item may contain one or more nonconformities.

3.1.12 **responsible authority**

concept used to maintain the neutrality of this part of ISO 2859 (primarily for specification purposes), irrespective of whether it is being invoked or applied by the first, second or third party

NOTE 1 The responsible authority may be:

- a) the quality department within a supplier's organization (first party);
- b) the purchaser or procurement organization (second party);
- c) an independent verification or certification authority (third party);

- d) any of a), b) or c), differing according to function (see Note 2) as described in a written agreement between two of the parties, for example a document between supplier and purchaser.

NOTE 2 The duties and functions of a responsible authority are outlined in this part of ISO 2859 (see 5.2, 6.2, 7.2, 7.3, 7.5, 7.6, 9.1, 9.3.3, 9.4, 10.1, 10.3, 13.1).

3.1.13

lot

definite amount of some product, material or service, collected together

NOTE An inspection lot may consist of several batches or parts of batches.

3.1.14

lot size

number of items in a lot

3.1.15

sample

set of one or more items taken from a lot and intended to provide information on the lot

3.1.16

sample size

number of items in the sample

3.1.17

sampling plan

combination of sample size(s) to be used and associated lot acceptability criteria

NOTE 1 A single sampling plan is a combination of sample size and acceptance and rejection numbers. A double sampling plan is a combination of two sample sizes and acceptance and rejection numbers for the first sample and for the combined sample.

NOTE 2 A sampling plan does not contain the rules on how to draw the sample.

NOTE 3 For the purposes of this part of ISO 2859, a distinction should be made between the terms **sampling plan** (3.1.17), **sampling scheme** (3.1.18) and **sampling system** (3.1.19).

3.1.18

sampling scheme

combination of sampling plans with rules for changing from one plan to another

NOTE See 9.3.

3.1.19

sampling system

collection of sampling plans, or of sampling schemes, each with its own rules for changing plans, together with sampling procedures including criteria by which appropriate plans or schemes may be chosen

NOTE This part of ISO 2859 is a sampling system indexed by lot-size ranges, inspection levels and AQLs. A sampling system for LQ plans is given in ISO 2859-2.

3.1.20

normal inspection

use of a **sampling plan** (3.1.17) with an acceptance criterion that has been devised to secure the producer a high probability of acceptance when the **process average** (3.1.25) of the lot is better than the **acceptance quality limit** (3.1.26)

NOTE Normal inspection is used when there is no reason to suspect that the **process average** (3.1.25) differs from an acceptable level.

3.1.21**tightened inspection**

use of a **sampling plan** (3.1.17) with an acceptance criterion that is tighter than that for the corresponding plan for **normal inspection** (3.1.20)

NOTE Tightened inspection is invoked when the inspection results of a predetermined number of consecutive lots indicate that the **process average** (3.1.25) might be poorer than the **AQL** (3.1.26).

3.1.22**reduced inspection**

use of a **sampling plan** (3.1.17) with a **sample size** (3.1.16) that is smaller than that for the corresponding plan for **normal inspection** (3.1.20) and with an acceptance criterion that is comparable to that for the corresponding plan for normal inspection

NOTE 1 The discriminatory ability under reduced inspection is less than under normal inspection.

NOTE 2 Reduced inspection may be invoked when the inspection results of a predetermined number of consecutive lots indicate that the **process average** (3.1.25) is better than the **AQL** (3.1.26).

3.1.23**switching score**

indicator that is used under normal inspection to determine whether the current inspection results are sufficient to allow for a switch to reduced inspection

NOTE See 9.3.3.

3.1.24**acceptance score**

indicator that is used for fractional acceptance number plans to determine lot acceptability

NOTE See 13.2.1.2.

3.1.25**process average**

process level averaged over a defined time period or quantity of production

[ISO 3534-2:1993, 3.1.2]

NOTE In this part of ISO 2859 the process average is the quality level (percent nonconforming or number of nonconformities per hundred items) during a period when the process is in a state of statistical control.

3.1.26**acceptance quality limit****AQL**

quality level that is the worst tolerable process average when a continuing series of lots is submitted for acceptance sampling

NOTE 1 This concept only applies when a sampling scheme with rules for switching and for discontinuation, such as in ISO 2859-1 or ISO 3951, is used.

NOTE 2 Although individual lots with quality as bad as the acceptance quality limit may be accepted with fairly high probability, the designation of an acceptance quality limit does not suggest that this is a desirable quality level. Sampling schemes found in International Standards such as this part of ISO 2859, with their rules for switching and for discontinuation of sampling inspection, are designed to encourage suppliers to have process averages consistently better than the AQL. Otherwise, there is a high risk that the inspection severity will be switched to tightened inspection under which the criteria for lot acceptance become more demanding. Once on tightened inspection, unless action is taken to improve the process, it is very likely that the rule requiring discontinuation of sampling inspection pending such improvement will be invoked.

3.1.27**consumer's risk quality****CRQ**

lot or process quality level that in the sampling plan corresponds to a specified consumer's risk

**3.1.21
tightened inspection**

use of a **sampling plan** (3.1.17) with an acceptance criterion that is tighter than that for the corresponding plan for **normal inspection** (3.1.20)

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NOTE See 13.2.1.2.

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process level averaged over a defined time period or quantity of production

[ISO 3534-2:1993, 3.1.2]

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**3.1.24
acceptance score**

indicator that is used for fractional acceptance number plans to determine lot acceptability

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process average**

process level averaged over a defined time period or quantity of production

[ISO 3534-2:1993, 3.1.2]

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**3.1.26
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**3.1.27
consumer's risk quality**

CRQ

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CRQ

lot or process quality level that in the sampling plan corresponds to a specified consumer's risk

8.3 Double or multiple sampling

When double or multiple sampling is to be used, each subsequent sample shall be selected from the remainder of the same lot.

9 Normal, tightened and reduced inspection

9.1 Start of inspection

Normal inspection shall be carried out at the start of inspection, unless otherwise directed by the responsible authority.

9.2 Continuation of inspection

Normal, tightened or reduced inspection shall continue unchanged on successive lots, except where the switching procedures (see 9.3) require the severity of the inspection to be changed. The switching procedures shall be applied to each class of nonconformities or nonconforming items independently.

9.3 Switching rules and procedures (see Figure 1)

9.3.1 Normal to tightened

When normal inspection is being carried out, tightened inspection shall be implemented as soon as two out of five (or fewer than five) consecutive lots have been non-acceptable on original inspection (that is, ignoring resubmitted lots or batches for this procedure).

9.3.2 Tightened to normal

When tightened inspection is being carried out, normal inspection shall be re-instated when five consecutive lots have been considered acceptable on original inspection.

9.3.3 Normal to reduced

9.3.3.1 General

When normal inspection is being carried out, reduced inspection shall be implemented provided that all of the following conditions are satisfied:

- a) the current value of the switching score (see 9.3.3.2) is at least 30; and
- b) production is at a steady rate; and
- c) reduced inspection is considered desirable by the responsible authority.

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When double or multiple sampling is to be used, each subsequent sample shall be selected from the remainder of the same lot.

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- a) the current value of the switching score (see 9.3.3.2) is at least 30; and
- b) production is at a steady rate; and
- c) reduced inspection is considered desirable by the responsible authority.

9.3.3.2 Switching score

The calculation of the switching score shall be initiated at the start of normal inspection unless otherwise specified by the responsible authority.

The switching score shall be set at zero at the start and updated following the inspection of each subsequent lot on original normal inspection.

a) Single sampling plans:

- 1) when the acceptance number is 2 or more, add 3 to the switching score if the lot would have been accepted if the AQL had been one step tighter; otherwise reset the switching score to zero;
- 2) when the acceptance number is 0 or 1, add 2 to the switching score if the lot is accepted; otherwise reset the switching score to zero.

b) Double and multiple sampling plans:

- 1) when a double sampling plan is used, add 3 to the switching score if the lot is accepted after the first sample; otherwise reset the switching score to zero;
- 2) when a multiple sampling plan is used, add 3 to the switching score if the lot is accepted by the third sample; otherwise reset the switching score to zero.

NOTE The application of the switching score is illustrated in annex A.

9.3.4 Reduced to normal

When reduced inspection is being carried out, normal inspection shall be re-instated if any of the following occur on original inspection:

- a) a lot is not accepted; or
- b) production becomes irregular or delayed; or
- c) other conditions warrant that normal inspection shall be re-instated.

9.4 Discontinuation of inspection

If the cumulative number of lots not accepted in a sequence of consecutive lots on original tightened inspection reaches 5, the acceptance procedures of this part of ISO 2859 shall not be resumed until action has been taken by the supplier to improve the quality of the submitted product or service, and the responsible authority has agreed that this action is likely to be effective. Tightened inspection shall then be used as if 9.3.1 had been invoked.

9.5 Skip-lot sampling

The lot-by-lot inspection in this part of ISO 2859 may be replaced by skip-lot sampling when the requirements of ISO 2859-3 are fulfilled.

NOTE There are limitations to the use of the skip-lot procedures of ISO 2859-3 in place of the reduced-inspection procedures of this part of ISO 2859. Some of the AQLs and inspection levels are not applicable.

10 Sampling plans

10.1 Inspection level

The inspection level designates the relative amount of inspection. Three inspection levels, I, II and III, are given in Table 1 for general use. Unless otherwise specified, level II shall be used. Level I may be used when less discrimination is needed or level III when greater discrimination is required. Four additional special levels, S-1, S-2, S-3 and S-4 are also given in Table 1 and may be used where relatively small sample sizes are necessary and larger sampling risks can be tolerated.

The inspection level required for any particular application shall be specified by the responsible authority. This allows the authority to require greater discrimination for some purposes and less for others.

At each inspection level, the switching rules shall operate to require normal, tightened and reduced inspection, as specified in clause 9. The choice of inspection level is quite separate from these three severities of inspection. Thus, the inspection level that has been specified shall be kept unchanged when switching between normal, tightened and reduced inspection.

In the designation of inspection levels S-1 to S-4, care shall be exercised to avoid AQLs inconsistent with these inspection levels. For instance, the code letters under S-1 go no further than D, equivalent to a single sample size of 8, but it is of no use to specify S-1 if the AQL is 0,1 %, for which the minimum sample size is 125.

The amount of information about the quality of a lot gained from examining samples drawn from the lot depends upon the absolute size of the samples, **not** upon the relative size of the sample to the lot size, provided the sample is small relative to the lot that is examined. In spite of this, there are three reasons for varying the sample size with the lot size:

- a) when the loss due to a wrong decision is high, it is more important to make the correct decision;
- b) with a large lot, a sample size can be afforded that would be uneconomic for a small lot;
- c) truly random sampling is relatively more difficult if the sample is too small a proportion of the lot.

10.2 Sample size code letters

Sample sizes are designated by sample size code letters. Table 1 shall be used to find the applicable code letter for the particular lot size and the prescribed inspection level.

NOTE For economy of space in the tables or to avoid unnecessary repetition in the text, the abbreviated term "code letter" is sometimes used.

10.3 Obtaining a sampling plan

The AQL and the sample size code letter shall be used to obtain the sampling plan from Tables 2, 3, 4 or 11. For a specified AQL and a given lot size, the same combination of AQL and sample size code letter shall be used to obtain the sampling plan from the table for normal, tightened and reduced inspection.

When no sampling plan is available for a given combination of AQL and sample size code letter, the tables direct the user to a different letter. The sample size to be used is given by the new sample size code letter, not by the original letter. If this procedure leads to different sample sizes for different classes of nonconformities or nonconforming items, the sample size code letter corresponding to the largest sample size derived may be used for all classes of nonconformities or nonconforming items, 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. As another alternative, the optional fractional acceptance number plans described in clause 13 may be used when approved by the responsible authority.

10.4 Types of sampling plans

Three types of sampling plans, single, double and multiple, are given in Tables 2, 3 and 4, respectively. When several types of plans are available for a given AQL and sample size code letter, any one may be used. A decision as to the type of plan, either single, double or multiple, when available for a given AQL and sample size code letter, shall usually be based upon the comparison between the administrative difficulty and the average sample sizes of the available plans. For the sampling plans given in this part of ISO 2859, the average sample size of multiple plans is less than for double, and both of these are less than the single sample size (see Table 9). Usually, the administrative difficulty for single sampling and the cost per item in the sample are less than for double or multiple sampling.

11 Determination of acceptability

11.1 Inspection for nonconforming items

To determine acceptability of a lot under percent nonconforming inspection, the applicable sampling plan shall be used in accordance with 11.1.1 to 11.1.3.

11.1.1 Single sampling plans (integer acceptance number)

The number of sample items inspected shall be equal to the sample size given by the plan. If the number of nonconforming items found in the sample is equal to or less than the acceptance number, the lot shall be considered acceptable. If the number of nonconforming items is equal to or greater than the rejection number, the lot shall be considered not acceptable.

11.1.2 Double sampling plans

The number of sample items first inspected shall be equal to the first sample size given by the plan. If the number of nonconforming items found in the first sample is equal to or less than the first acceptance number, the lot shall be considered acceptable. If the number of nonconforming items found in the first sample is equal to or greater than the first rejection number, the lot shall be considered not acceptable.

If the number of nonconforming items 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 nonconforming items found in the first and second samples shall be accumulated. If the cumulative number of nonconforming items is equal to or less than the second acceptance number, the lot shall be considered acceptable. If the cumulative number of nonconforming items is equal to or greater than the second rejection number, the lot shall be considered not acceptable.

11.1.3 Multiple sampling plans

In multiple sampling, the procedure shall be similar to that specified in 11.1.2. In this part of ISO 2859, there are five stages so that a decision will be reached by the fifth stage at the latest.

11.2 Inspection for nonconformities

In order to determine the acceptability of a lot in a nonconformities per hundred items inspection, the procedure specified for nonconforming inspection (see 11.1) shall be used, except that the term "nonconformities" shall be substituted for "nonconforming items".

12 Further information

12.1 Operating characteristic (OC) curves

The operating characteristic curves for normal and tightened inspection, shown in Table 10, indicate the percentage of lots which may be expected to be accepted under the various sampling plans for a given process quality. The curves shown are for single sampling, integer acceptance number plans; curves for double and multiple sampling are matched as closely as practicable. The OC curves shown for AQLs greater than 10 are applicable for inspection for number of

nonconformities; those for AQLs of 10 or less are applicable for inspection for nonconforming items. For AQLs of 10 or less these OC curves are also applicable to inspection for number of nonconformities.

For each of the curves shown, values of the quality of submitted product corresponding to selected values of probabilities of acceptance are shown in tabular form. In addition, values corresponding to tightened inspection, and values corresponding to sampling for number of nonconformities for AQLs of 10 or fewer nonconformities per 100 items are also given.

Normalized scheme OC curves found in Table 12 indicate the long-range percentage of lots of various qualities that will be accepted, taking into account the switching rules but disregarding the effect of the rule for discontinuation of inspection (9.4). The abscissa is the ratio of the process quality to the AQL. Each curve represents an acceptance number for normal inspection.

12.2 Process average

The process average can be estimated by the average percent nonconforming or average number of nonconformities per 100 items (whichever is applicable) found in the samples of product submitted by the supplier for original inspection, provided that inspection was not curtailed. When double or multiple sampling is used, only first sample results shall be included in the process average estimation.

12.3 Average outgoing quality (AOQ)

The average outgoing quality is the long-term average quality of outgoing product for a given value of incoming product quality, including all accepted lots, plus all lots which are not accepted, after such lots have been effectively 100 % inspected and all nonconforming items replaced by conforming items.

12.4 Average outgoing quality limit (AOQL)

The AOQL is the maximum of the average outgoing qualities for all possible qualities submitted for a given acceptance sampling plan. Approximate AOQL values are given in Table 8-A for each of the single sampling plans for normal inspection and in Table 8-B for each of the single sampling plans for tightened inspection.

12.5 Average sample size curves

Average sample size curves for double and multiple sampling, as compared with the corresponding single sampling plan for each acceptance number, are given in Table 9. These curves show the average sample sizes which may be expected to occur under the various sampling plans for given levels of process quality. The curves assume that the inspection is not curtailed (see ISO 3534-2:1993, 2.5.7).

12.6 Consumer's and producer's risks

12.6.1 Use of individual plans

This part of ISO 2859 is intended to be used as a system employing tightened, normal and reduced inspection on a successive series of lots to achieve consumer protection while assuring the producer that acceptance will occur most of the time if quality is better than the AQL.

Occasionally, specific individual plans are selected from this part of ISO 2859 and used without the switching rules. For example, a purchaser may be using the plans for verification purposes only. This is not the intended application of the system given in this part of ISO 2859 and its use in this way shall not be referred to as "inspection in compliance with ISO 2859-1". When used in this way, this part of ISO 2859 simply represents a repository for a collection of individual plans indexed by AQL. The operating characteristic curves and other measures of a plan so chosen shall be assessed individually for a plan from the tables provided.

12.6.2 Consumer's risk quality tables

If the series of lots is not long enough to allow the switching rules to be applied, it may be desirable to limit the selection of sampling plans to those, associated with a designated AQL value, that give consumer's risk quality not more than a specified limiting quality protection. Sampling plans for this purpose can be selected by choosing a consumer's risk quality (CRQ) and a consumer's risk (probability of lot acceptance) to be associated with it.

Tables 6 and 7 give values of consumer's risk quality (CRQ) for a consumer's risk of 10 %. Table 6 applies when inspecting for nonconforming items and Table 7 applies when inspecting for number of nonconformities. For individual lots with quality levels less than or equal to the tabulated values of consumer's risk qualities, the probabilities of lot acceptance are equal to or less than 10 %. When there is reason for protecting against a specified limiting quality in a lot, Tables 6 and 7 may be useful for fixing minimum sample sizes to be associated with the AQL and inspection level specified for inspection of the series of lots. ISO 2859-2 gives details of the procedure for selecting sampling plans for lots in isolation.

EXAMPLE Assume a consumer's risk quality of 5 % nonconforming items with an associated probability of acceptance of 10 % or less is desired for individual lots. If an AQL of 1 % nonconforming items is designated for inspection of the series of lots, Table 6-A indicates that the minimum sample size shall be given by sample size code letter L.

12.6.3 Producer's risk tables

Tables 5-A, 5-B and 5-C give the probability of rejection for lots of AQL quality on normal, tightened and reduced inspections, respectively. This probability is denoted as producer's risk in 2.6.7 of ISO 3534-2:1993.

13 Fractional acceptance number plans for single sampling (optional)

13.1 Application of fractional acceptance number plans

This subclause specifies optional procedures for fractional acceptance number sampling plans. The optional procedures may be used with the approval of the responsible authority. Unless otherwise specified, standard procedures shown above shall be followed.

Fractional acceptance number plans are found in Tables 11-A, 11-B and 11-C. For normal and tightened inspection, the fractions 1/3 and 1/2 are found in place of the two entries with arrows in Table 2-A and 2-B between the plans for acceptance number 0 and acceptance number 1. For reduced inspection, the fractions 1/5, 1/3 and 1/2 are found in place of the three entries with arrows in Table 2-C between the plans for acceptance number 0 and acceptance number 1.

The use of fractional acceptance number plans does not require a change in sample size code letters, with the corresponding change in sample size, when the combination of sample size code letter and AQL results in a plan between the 0 and 1 acceptance number as described in 10.3.

13.2 Acceptability determination

13.2.1 Inspection for nonconforming items

13.2.1.1 Constant sampling plans

When the fractional acceptance number sampling plans remain constant for all lots, the following rules apply.

- When there is no nonconforming item in the sample the lot shall be considered acceptable.
- When there are two or more nonconforming items in the sample, the lot shall be considered not acceptable.
- When there is only one nonconforming item in the sample from the current lot, the lot shall be considered acceptable only if no nonconforming items have been found in the samples from a sufficient number of immediately preceding lots.

For an acceptance number of 1/2 one such lot is required. For an acceptance number of 1/3 two such lots are required. For an acceptance number of 1/5 four such lots are required. Otherwise the current lot shall be considered not acceptable. If the first lot inspected has one nonconforming item, that lot is not accepted.

13.2.1.2 Non-constant sampling plans

When the sampling plan does not remain constant for each successive lot, because of varying lot sizes and/or switching, use an acceptance score that is calculated and used as follows.

- a) Reset the acceptance score to zero at the start of any phase of normal, tightened or reduced inspection.
- b) If the sampling plan obtained indicates an acceptance number 0, the acceptance score shall be kept unchanged.
If the given acceptance number is 1/5, add 2 to the acceptance score.
If the given acceptance number is 1/3, add 3 to the acceptance score.
If the given acceptance number is 1/2, add 5 to the acceptance score.
If the given acceptance number is 1 or more, add 7 to the acceptance score.
- c) When, for fractional acceptance number plans, the updated acceptance score prior to inspection is 8 or less, the lot can be considered acceptable only if there are no nonconforming items in the sample. When, for fractional acceptance number plans, the updated acceptance score prior to inspection is 9 or more, the lot can be considered acceptable only if there is at most one nonconforming item in the sample. When the acceptance number is an integer, use this acceptance number to determine acceptability (in accordance with 11.1.1 or 11.2).
d) If one or more nonconforming items are found in the sample, reset the acceptance score to 0 (i.e. after making a decision regarding the acceptability of the lot).

The acceptance score shall be updated (added to) after obtaining the sampling plan but before deciding on the acceptability of the lot. The acceptance score shall be reset after the acceptability decision is made. In contrast, the switching score (see 9.3.3.2) shall be added to or reset after deciding on acceptability of the lot.

NOTE When an acceptance score is used for the case of constant sampling plans, the results are the same as 13.2.1.1.

13.2.2 Inspection for number of nonconformities

In order to determine the acceptability of a lot when inspecting for number of nonconformities, the procedures specified for inspection for nonconforming items (see 13.2.1) shall be used, except that the term "nonconformities" shall be substituted for "nonconforming items".

13.3 Switching rules

13.3.1 Normal to tightened and tightened to normal

These rules are the same as indicated in 9.3.1 and 9.3.2, respectively.

13.3.2 Normal to reduced

The rule for updating the switching score (9.3.3.2) under single sampling when using a fractional acceptance number is as follows.

- a) When the given acceptance number is 1/3 or 1/2, add 2 to the switching score if the lot is accepted; otherwise reset the switching score to zero.
- b) When the acceptance number is zero, add 2 to the switching score if no nonconforming items are found in the sample; otherwise reset the switching score to zero.

13.3.3 Reduced to normal inspection and discontinuation of inspection

The rules are the same as indicated in 9.3.4 and 9.4, respectively.

NOTE Fractional acceptance number sampling plans are not applicable under the ISO 2859-3 skip-lot sampling system.

13.4 Non-constant sampling plan

An example given in annex A illustrates the application of this acceptance sampling system using the optional fractional acceptance number plans with variable lot size.

It is assumed throughout this example that a series of lots are submitted for inspection for nonconforming items, and that it has been agreed to use an AQL of 1 % nonconforming items with general inspection level II. The results for the first 25 lots are given in annex A.

Table 1 - Sample size code letters (see 10.1 and 10.2)

Lot size	Special inspection levels				General inspection levels																		
	S-1	S-2	S-3	S-4	I	II	III	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R
2 to 8	A	A	A	A	A	A	A	B	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R
9 to 15	A	A	A	A	A	A	A	B	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R
16 to 25	A	A	A	A	B	B	B	C	C	C	D	E	F	G	H	J	K	L	M	N	P	Q	R
26 to 50	A	B	B	B	C	C	C	D	D	E	F	G	H	J	K	L	M	N	P	Q	Q	R	R
51 to 90	B	B	B	B	C	C	C	D	D	E	F	G	H	J	K	L	M	N	P	Q	Q	R	R
91 to 150	B	B	B	B	C	C	C	D	D	E	F	G	H	J	K	L	M	N	P	Q	Q	R	R
151 to 280	B	C	C	C	D	D	D	E	E	F	G	H	J	K	L	M	N	P	Q	Q	R	R	R
281 to 500	B	C	C	C	D	D	D	E	E	F	G	H	J	K	L	M	N	P	Q	Q	R	R	R
501 to 1 200	C	C	C	C	D	D	D	E	E	F	G	H	J	K	L	M	N	P	Q	Q	R	R	R
1 201 to 3 200	C	D	D	D	F	F	F	G	G	H	J	K	L	M	N	P	Q	Q	R	R	R	R	R
3 201 to 10 000	C	D	D	D	E	E	E	G	G	H	J	J	K	L	M	N	P	Q	Q	R	R	R	R
10 001 to 35 000	C	D	D	D	F	F	F	G	G	H	J	J	K	L	M	N	P	Q	Q	R	R	R	R
35 001 to 150 000	D	D	D	D	E	E	E	G	G	H	J	J	K	L	M	N	P	Q	Q	R	R	R	R
150 001 to 500 000	D	E	E	E	F	F	F	G	G	H	J	J	K	L	M	N	P	Q	Q	R	R	R	R
500 001 and over	D	E	E	E	F	F	F	G	G	H	J	J	K	L	M	N	P	Q	Q	R	R	R	R

Table 2-A — Single sampling plans for normal inspection (Master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
A	2																											
B	3																											
C	5																											
D	8																											
E	13																											
F	20																											
G	32																											
H	50																											
J	80																											
K	125																											
L	200																											
M	315																											
N	500																											
P	800																											
Q	1 250	0	1																									
R	2 000																											

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.
 ↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

Table 2-A — Single sampling plans for normal inspection (Master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
A	2																											
B	3																											
C	5																											
D	8																											
E	13																											
F	20																											
G	32																											
H	50																											
J	80																											
K	125																											
L	200																											
M	315																											
N	500																											
P	800																											
Q	1 250	0	1																									
R	2 000																											

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.
 ↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

Table 2-C — Single sampling plans for reduced inspection (Master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
A	2																											
B	2																											
C	2																											
D	3																											
E	5																											
F	8																											
G	13																											
H	20																											
J	32																											
K	50																											
L	80																											
M	125																											
N	200																											
P	315																											
Q	500	0	1																									
R	800	0	1																									

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.
 ↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number
 Re = Rejection number

Table 3-A — Double sampling plans for normal inspection (Master table)

Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)											
Sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
0	0	0	0	0	0	0	0	0	0	0	0
1	*	*	*	*	*	*	*	*	*	*	*
2	*	*	*	*	*	*	*	*	*	*	*
3	*	*	*	*	*	*	*	*	*	*	*
4	*	*	*	*	*	*	*	*	*	*	*
5	*	*	*	*	*	*	*	*	*	*	*
6	*	*	*	*	*	*	*	*	*	*	*
7	*	*	*	*	*	*	*	*	*	*	*
8	*	*	*	*	*	*	*	*	*	*	*
9	*	*	*	*	*	*	*	*	*	*	*
10	*	*	*	*	*	*	*	*	*	*	*
11	*	*	*	*	*	*	*	*	*	*	*
12	*	*	*	*	*	*	*	*	*	*	*
13	*	*	*	*	*	*	*	*	*	*	*
14	*	*	*	*	*	*	*	*	*	*	*
15	*	*	*	*	*	*	*	*	*	*	*
16	*	*	*	*	*	*	*	*	*	*	*
17	*	*	*	*	*	*	*	*	*	*	*
18	*	*	*	*	*	*	*	*	*	*	*
19	*	*	*	*	*	*	*	*	*	*	*
20	*	*	*	*	*	*	*	*	*	*	*
21	*	*	*	*	*	*	*	*	*	*	*
22	*	*	*	*	*	*	*	*	*	*	*
23	*	*	*	*	*	*	*	*	*	*	*
24	*	*	*	*	*	*	*	*	*	*	*
25	*	*	*	*	*	*	*	*	*	*	*
26	*	*	*	*	*	*	*	*	*	*	*
27	*	*	*	*	*	*	*	*	*	*	*
28	*	*	*	*	*	*	*	*	*	*	*
29	*	*	*	*	*	*	*	*	*	*	*
30	*	*	*	*	*	*	*	*	*	*	*
31	*	*	*	*	*	*	*	*	*	*	*
32	*	*	*	*	*	*	*	*	*	*	*
33	*	*	*	*	*	*	*	*	*	*	*
34	*	*	*	*	*	*	*	*	*	*	*
35	*	*	*	*	*	*	*	*	*	*	*
36	*	*	*	*	*	*	*	*	*	*	*
37	*	*	*	*	*	*	*	*	*	*	*
38	*	*	*	*	*	*	*	*	*	*	*
39	*	*	*	*	*	*	*	*	*	*	*
40	*	*	*	*	*	*	*	*	*	*	*
41	*	*	*	*	*	*	*	*	*	*	*
42	*	*	*	*	*	*	*	*	*	*	*
43	*	*	*	*	*	*	*	*	*	*	*
44	*	*	*	*	*	*	*	*	*	*	*
45	*	*	*	*	*	*	*	*	*	*	*
46	*	*	*	*	*	*	*	*	*	*	*
47	*	*	*	*	*	*	*	*	*	*	*
48	*	*	*	*	*	*	*	*	*	*	*
49	*	*	*	*	*	*	*	*	*	*	*
50	*	*	*	*	*	*	*	*	*	*	*
51	*	*	*	*	*	*	*	*	*	*	*
52	*	*	*	*	*	*	*	*	*	*	*
53	*	*	*	*	*	*	*	*	*	*	*
54	*	*	*	*	*	*	*	*	*	*	*
55	*	*	*	*	*	*	*	*	*	*	*
56	*	*	*	*	*	*	*	*	*	*	*
57	*	*	*	*	*	*	*	*	*	*	*
58	*	*	*	*	*	*	*	*	*	*	*
59	*	*	*	*	*	*	*	*	*	*	*
60	*	*	*	*	*	*	*	*	*	*	*
61	*	*	*	*	*	*	*	*	*	*	*
62	*	*	*	*	*	*	*	*	*	*	*
63	*	*	*	*	*	*	*	*	*	*	*
64	*	*	*	*	*	*	*	*	*	*	*
65	*	*	*	*	*	*	*	*	*	*	*
66	*	*	*	*	*	*	*	*	*	*	*
67	*	*	*	*	*	*	*	*	*	*	*
68	*	*	*	*	*	*	*	*	*	*	*
69	*	*	*	*	*	*	*	*	*	*	*
70	*	*	*	*	*	*	*	*	*	*	*
71	*	*	*	*	*	*	*	*	*	*	*
72	*	*	*	*	*	*	*	*	*	*	*
73	*	*	*	*	*	*	*	*	*	*	*
74	*	*	*	*	*	*	*	*	*	*	*
75	*	*	*	*	*	*	*	*	*	*	*
76	*	*	*	*	*	*	*	*	*	*	*
77	*	*	*	*	*	*	*	*	*	*	*
78	*	*	*	*	*	*	*	*	*	*	*
79	*	*	*	*	*	*	*	*	*	*	*
80	*	*	*	*	*	*	*	*	*	*	*
81	*	*	*	*	*	*	*	*	*	*	*
82	*	*	*	*	*	*	*	*	*	*	*
83	*	*	*	*	*	*	*	*	*	*	*
84	*	*	*	*	*	*	*	*	*	*	*
85	*	*	*	*	*	*	*	*	*	*	*
86	*	*	*	*	*	*	*	*	*	*	*
87	*	*	*	*	*	*	*	*	*	*	*
88	*	*	*	*	*	*	*	*	*	*	*
89	*	*	*	*	*	*	*	*	*	*	*
90	*	*	*	*	*	*	*	*	*	*	*
91	*	*	*	*	*	*	*	*	*	*	*
92	*	*	*	*	*	*	*	*	*	*	*
93	*	*	*	*	*	*	*	*	*	*	*
94	*	*	*	*	*	*	*	*	*	*	*
95	*	*	*	*	*	*	*	*	*	*	*
96	*	*	*	*	*	*	*	*	*	*	*
97	*	*	*	*	*	*	*	*	*	*	*
98	*	*	*	*	*	*	*	*	*	*	*
99	*	*	*	*	*	*	*	*	*	*	*
100	*	*	*	*	*	*	*	*	*	*	*

ing plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

ing plan above the arrow.

er

Table 3-A — Double sampling plans for normal inspection (Master table)

Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)											
Sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
0	0	0	0	0	0	0	0	0	0	0	0
1	*	*	*	*	*	*	*	*	*	*	*
2	*	*	*	*	*	*	*	*	*	*	*
3	*	*	*	*	*	*	*	*	*	*	*
4	*	*	*	*	*	*	*	*	*	*	*
5	*	*	*	*	*	*	*	*	*	*	*
6	*	*	*	*	*	*	*	*	*	*	*
7	*	*	*	*	*	*	*	*	*	*	*
8	*	*	*	*	*	*	*	*	*	*	*
9	*	*	*	*	*	*	*	*	*	*	*
10	*	*	*	*	*	*	*	*	*	*	*
11	*	*	*	*	*	*	*	*	*	*	*
12	*	*	*	*	*	*	*	*	*	*	*
13	*	*	*	*	*	*	*	*	*	*	*
14	*	*	*	*	*	*	*	*	*	*	*
15	*	*	*	*	*	*	*	*	*	*	*
16	*	*	*	*	*	*	*	*	*	*	*
17	*	*	*	*	*	*	*	*	*	*	*
18	*	*	*	*	*	*	*	*	*	*	*
19	*	*	*	*	*	*	*	*	*	*	*
20	*	*	*	*	*	*	*	*	*	*	*
21	*	*	*	*	*	*	*	*	*	*	*
22	*	*	*	*	*	*	*	*	*	*	*
23	*	*	*	*	*	*	*	*	*	*	*
24	*	*	*	*	*	*	*	*	*	*	*
25	*	*	*	*	*	*	*	*	*	*	*
26	*	*	*	*	*	*	*	*	*	*	*
27	*	*	*	*	*	*	*	*	*	*	*
28	*	*	*	*	*	*	*	*	*	*	*
29	*	*	*	*	*	*	*	*	*	*	*
30	*	*	*	*	*	*	*	*	*	*	*
31	*	*	*	*	*	*	*	*	*	*	*
32	*	*	*	*	*	*	*	*	*	*	*
33	*	*	*	*	*	*	*	*	*	*	*
34	*	*	*	*	*	*	*	*	*	*	*
35	*	*	*	*	*	*	*	*	*	*	*
36	*	*	*	*	*	*	*	*	*	*	*
37	*	*	*	*	*	*	*	*	*	*	*
38	*	*	*	*	*	*	*	*	*	*	*
39	*	*	*	*	*	*	*	*	*	*	*
40	*	*	*	*	*	*	*	*	*	*	*
41	*	*	*	*	*	*	*	*	*	*	*
42	*	*	*	*	*	*	*	*	*	*	*
43	*	*	*	*	*	*	*	*	*	*	*
44	*	*	*	*	*	*	*	*	*	*	*
45	*	*	*	*	*	*	*	*	*	*	*
46	*	*	*	*	*	*	*	*	*	*	*
47	*	*	*	*	*	*	*	*	*	*	*
48	*	*	*	*	*	*	*	*	*	*	*
49	*	*	*	*	*	*	*	*	*	*	*
50	*	*	*	*	*	*	*	*	*	*	*
51	*	*	*	*	*	*	*	*	*	*	*
52	*	*	*	*	*	*	*	*	*	*	*
53	*	*	*	*	*	*	*	*	*	*	*
54	*	*	*	*	*	*	*	*	*	*	*
55	*	*	*	*	*	*	*	*	*	*	*
56	*	*	*	*	*	*	*	*	*	*	*
57	*	*	*	*	*	*	*	*	*	*	*
58	*	*	*	*	*	*	*	*	*	*	*
59	*	*	*	*	*	*	*	*	*	*	*
60	*	*	*	*	*	*	*	*	*	*	*
61	*	*	*	*	*	*	*	*	*	*	*
62	*	*	*	*	*	*	*	*	*	*	*
63	*	*	*	*	*	*	*	*	*	*	*
64	*	*	*	*	*	*	*	*	*	*	*
65	*	*	*	*	*	*	*	*	*	*	*
66	*	*	*	*	*	*	*	*	*	*	*
67	*	*	*	*	*	*	*	*	*	*	*
68	*	*	*	*	*	*	*	*	*	*	*
69	*	*	*	*	*	*	*	*	*	*	*
70	*	*	*	*	*	*	*	*	*	*	*
71	*	*	*	*	*	*	*	*	*	*	*
72	*	*	*	*	*	*	*	*	*	*	*
73	*	*	*	*	*	*	*	*	*	*	*
74	*	*	*	*	*	*	*	*	*	*	*
75	*	*	*	*	*	*	*	*	*	*	*
76	*	*	*	*	*	*	*	*	*	*	*
77	*	*	*	*	*	*	*	*	*	*	*
78	*	*	*	*	*	*	*	*	*	*	*
79	*	*	*	*	*	*	*	*	*	*	*
80	*	*	*	*	*	*	*	*	*	*	*
81	*	*	*	*	*	*	*	*	*	*	*
82	*	*	*	*	*	*	*	*	*	*	*
83	*	*	*	*	*	*	*	*	*	*	*
84	*	*	*	*	*	*	*	*	*	*	*
85	*	*	*	*	*	*	*	*	*	*	*
86	*	*	*	*	*	*	*	*	*	*	*
87	*	*	*	*	*	*	*	*	*	*	*
88	*	*	*	*	*	*	*	*	*	*	*
89	*	*	*	*	*	*	*	*	*	*	*
90	*	*	*	*	*	*	*	*	*	*	*
91	*	*	*	*	*	*	*	*	*	*	*
92	*	*	*	*	*	*	*	*	*	*	*
93	*	*	*	*	*	*	*	*	*	*	*
94	*	*	*	*	*	*	*	*	*	*	*
95	*	*	*	*	*	*	*	*	*	*	*
96	*	*	*	*	*	*	*	*	*	*	*
97	*	*	*	*	*	*	*	*	*	*	*
98	*	*	*	*	*	*	*	*	*	*	*
99	*	*	*	*	*	*	*	*	*	*	*
100	*	*	*	*	*	*	*	*	*	*	*

ing plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

ing plan above the arrow.

er

Table 3-A — Double sampling plans for normal inspection (Master table)

Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)											
Sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
0	0	0	0	0	0	0	0	0	0	0	0
1	*	*	*	*	*	*	*	*	*	*	*
2	*	*	*	*	*	*	*	*	*	*	*
3	*	*	*	*	*	*	*	*	*	*	*
4	*	*	*	*	*	*	*	*	*	*	*
5	*	*	*	*	*	*	*	*	*	*	*
6	*	*	*	*	*	*	*	*	*	*	*
7	*	*	*	*	*	*	*	*	*	*	*
8	*	*	*	*	*	*	*	*	*	*	*
9	*	*	*	*	*	*	*	*	*	*	*
10	*	*	*	*	*	*	*	*	*	*	*
11	*	*	*	*	*	*	*	*	*	*	*
12	*	*	*	*	*	*	*	*	*	*	*
13	*	*	*	*	*	*	*	*	*	*	*
14	*	*	*	*	*	*	*	*	*	*	*
15	*	*	*	*	*	*	*	*	*	*	*
16	*	*	*	*	*	*	*	*	*	*	*
17	*	*	*	*	*	*	*	*	*	*	*
18	*	*	*	*	*	*	*	*	*	*	*
19	*	*	*	*	*	*	*	*	*	*	*
20	*	*	*	*	*	*	*	*	*	*	*
21	*	*	*	*	*	*	*	*	*	*	*
22	*	*	*	*	*	*	*	*	*	*	*
23	*	*	*	*	*	*	*	*	*	*	*
24	*	*	*	*	*	*	*	*	*	*	*
25	*	*	*	*	*	*	*	*	*	*	*
26	*	*	*	*	*	*	*	*	*	*	*
27	*	*	*	*	*	*	*	*	*	*	*
28	*	*	*	*	*	*	*	*	*	*	*
29	*	*	*	*	*	*	*	*	*	*	*
30	*	*	*	*	*	*	*	*	*	*	*
31	*	*	*	*	*	*	*	*	*	*	*
32	*	*	*	*	*	*	*	*	*	*	*
33	*	*	*	*	*	*	*	*	*	*	*
34	*	*	*	*	*	*	*	*	*	*	*
35	*	*	*	*	*	*	*	*	*	*	*
36	*	*	*	*	*	*	*	*	*	*	*
37	*	*	*	*	*	*	*	*	*	*	*
38	*	*	*	*	*	*	*	*	*	*	*
39	*	*	*	*	*	*	*	*	*	*	*
40	*	*	*	*	*	*	*	*	*	*	*
41	*	*	*	*	*	*	*	*	*	*	*
42	*	*	*	*	*	*	*	*	*	*	*
43	*	*	*	*	*	*	*	*	*	*	*
44	*	*	*	*	*	*	*	*	*	*	*
45	*	*	*	*	*	*	*	*	*	*	*
46	*	*	*	*	*	*	*	*	*	*	*
47	*	*	*	*	*	*	*	*	*	*	*
48	*	*	*	*	*	*	*	*	*	*	*
49	*	*	*	*	*	*	*	*	*	*	*
50	*	*	*	*	*	*	*	*	*	*	*
51	*	*	*	*	*	*	*	*	*	*	*
52	*	*	*	*	*	*	*	*	*	*	*
53	*	*	*	*	*	*	*	*	*	*	*
54	*	*	*	*	*	*	*	*	*	*	*
55	*	*	*	*	*	*	*	*	*	*	*
56	*	*	*	*	*	*	*	*	*	*	*
57	*	*	*	*	*	*	*	*	*	*	*
58	*	*	*	*	*	*	*	*	*	*	*
59	*	*	*	*	*	*	*	*	*	*	*
60	*	*	*	*	*	*	*	*	*	*	*
61	*	*	*	*	*	*	*	*	*	*	*
62	*	*	*	*	*	*	*	*	*	*	*
63	*	*	*	*	*	*	*	*	*	*	*
64	*	*	*	*	*	*	*	*	*	*	*
65	*	*	*	*	*	*	*	*	*	*	*
66	*	*	*	*	*	*	*	*	*	*	*
67	*	*	*	*	*	*	*	*	*	*	*
68	*	*	*	*	*	*	*	*	*	*	*
69	*	*	*	*	*	*	*	*	*	*	*
70	*	*	*	*	*	*	*	*	*	*	*
71	*	*	*	*	*	*	*	*	*	*	*
72	*	*	*	*	*	*	*	*	*	*	*
73	*	*	*	*	*	*	*	*	*	*	*
74	*	*	*	*	*	*	*	*	*	*	*
75	*	*	*	*	*	*	*	*	*	*	*
76	*	*	*	*	*	*	*	*	*	*	*
77	*	*	*	*	*	*	*	*	*	*	*
78	*	*	*	*	*	*	*	*	*	*	*
79	*	*	*	*	*	*	*	*	*	*	*
80	*	*	*	*	*	*	*	*	*	*	*
81	*	*	*	*	*	*	*	*	*	*	*
82	*	*	*	*	*	*	*	*	*	*	*
83	*	*	*	*	*	*	*	*	*	*	*
84	*	*	*	*	*	*	*	*	*	*	*
85	*	*	*	*	*	*	*	*	*	*	*
86	*	*	*	*	*	*	*	*	*	*	*
87	*	*	*	*	*	*	*	*	*	*	*
88	*	*	*	*	*	*	*	*	*	*	*
89	*	*	*	*	*	*	*	*	*	*	*
90	*	*	*	*	*	*	*	*	*	*	*
91	*	*	*	*	*	*	*	*	*	*	*
92	*	*	*	*	*	*	*	*	*	*	*
93	*	*	*	*	*	*	*	*	*	*	*
94	*	*	*	*	*	*	*	*	*	*	*
95	*	*	*	*	*	*	*	*	*	*	*
96	*	*	*	*	*	*	*	*	*	*	*
97	*	*	*	*	*	*	*	*	*	*	*
98	*	*	*	*	*	*	*	*	*	*	*
99	*	*	*	*	*	*	*	*	*	*	*
100	*	*	*	*	*	*	*	*	*	*	*

ing plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

ing plan above the arrow.

er

Table 4-A — Multiple sampling plans for normal inspection (Master table)

Sample size code letter	Sample size	Cumulative sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																										
			0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re		
A																													
B																													
C																													
D	First	2	2																										
	Second	2	4																										
	Third	2	6																										
	Fourth	2	8																										
	Fifth	2	10																										
E	First	3	3																										
	Second	3	6																										
	Third	3	9																										
	Fourth	3	12																										
	Fifth	3	15																										
F	First	5	5																										
	Second	5	10																										
	Third	5	15																										
	Fourth	5	20																										
	Fifth	5	25																										
G	First	8	8																										
	Second	8	16																										
	Third	8	24																										
	Fourth	8	32																										
	Fifth	8	40																										

▽ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

▽ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-A — Multiple sampling plans for normal inspection (Master table) (continued)

Sample size code letter	Sample size	Cumulative sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																									
			0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
H	First	13	13	26	39	52	65																					
	Second	13	26	39	52	65																						
	Third	13	39																									
	Fourth	13	52																									
	Fifth	13	65																									
J	First	20	20																									
	Second	20	40																									
	Third	20	60																									
	Fourth	20	80																									
	Fifth	20	100																									
K	First	32	32																									
	Second	32	64																									
	Third	32	96																									
	Fourth	32	128																									
	Fifth	32	160																									
L	First	50	50																									
	Second	50	100																									
	Third	50	150																									
	Fourth	50	200																									
	Fifth	50	250																									
M	First	80	80																									
	Second	80	160																									
	Third	80	240																									
	Fourth	80	320																									
	Fifth	80	400																									

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-A — Multiple sampling plans for normal inspection (Master table) (concluded)

			Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																									
Sample size code letter	Sample size	Cumulative sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
			Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
N	First	125	125					# 2	# 2	# 3	# 4	0	4	0	5	1	7	2	9									
	Second	250						0	2	0	3	0	3	1	5	1	6	3	8	4	10	7	14					
	Third	375		*				0	2	0	3	1	4	2	6	3	8	6	10	8	13	13	19					
	Fourth	500						0	2	1	3	2	5	4	7	5	9	9	12	12	17	20	25					
	Fifth	625						1	2	3	4	4	5	6	7	9	10	12	13	18	19	26	27					
P	First	200	200					# 2	# 2	# 3	# 4	0	4	0	5	1	7	2	9									
	Second	400						0	2	0	3	0	3	1	5	1	6	3	8	4	10	7	14					
	Third	600		*				0	2	0	3	1	4	2	6	3	8	6	10	8	13	13	19					
	Fourth	800						0	2	1	3	2	5	4	7	5	9	9	12	12	17	20	25					
	Fifth	1 000						1	2	3	4	4	5	6	7	9	10	12	13	18	19	26	27					
Q	First	315	315					# 2	# 2	# 3	# 4	0	4	0	5	1	7	2	9									
	Second	630						0	2	0	3	0	3	1	5	1	6	3	8	4	10	7	14					
	Third	945		*				0	2	0	3	1	4	2	6	3	8	6	10	8	13	13	19					
	Fourth	1 260						0	2	1	3	2	5	4	7	5	9	9	12	12	17	20	25					
	Fifth	1 575						1	2	3	4	4	5	6	7	9	10	12	13	18	19	26	27					
R	First	500	500					# 2	# 2	# 3	# 4	0	4	0	5	1	7	2	9									
	Second	1 000						0	2	0	3	0	3	1	5	1	6	3	8	4	10	7	14					
	Third	1 500						0	2	0	3	1	4	2	6	3	8	6	10	8	13	13	19					
	Fourth	2 000						0	2	1	3	2	5	4	7	5	9	9	12	12	17	20	25					
	Fifth	2 500						1	2	3	4	4	5	6	7	9	10	12	13	18	19	26	27					

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).
++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-B — Multiple sampling plans for tightened inspection (Master table)

Sample size code letter	Sample size	Cumulative sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																								
			0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A																											
B																											
C																											
D	First	2	2																								
	Second	2	4																								
D	Third	2	6																								
	Fourth	2	8																								
D	Fifth	2	10																								
E	First	3	3																								
	Second	3	6																								
E	Third	3	9																								
	Fourth	3	12																								
E	Fifth	3	15																								
F	First	5	5																								
	Second	5	10																								
F	Third	5	15																								
	Fourth	5	20																								
F	Fifth	5	25																								
G	First	8	8																								
	Second	8	16																								
G	Third	8	24																								
	Fourth	8	32																								
G	Fifth	8	40																								

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-B — Multiple sampling plans for tightened inspection (Master table) (continued)

Sample size code letter	Sample size	Cumulative sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																														
			0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000					
H	First	13	13	Ac Re	# 2	# 2	# 3	# 4	0	4	0	6	1	8	↑	↑	↑																
	Second	13	26	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	1	5	2	7	3	9	6	12	↑	↑	↑				
	Third	13	39	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	1	4	2	6	4	9	7	12	11	17	↑	↑	↑		
	Fourth	13	52	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	1	3	2	5	4	7	6	11	15	16	22	↑	↑	↑			
	Fifth	13	65	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1 2	3	4	4	5	6	7	10	11	15	16	23	24	↑	↑	↑		
J	First	20	20	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0	4	0	6	1	8	↑	↑	↑	↑	↑	↑		
	Second	20	40	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	0	3	1	5	2	7	3	9	6	12	↑	↑	↑	↑	↑
	Third	20	60	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	1	4	2	6	4	9	7	12	11	17	↑	↑	↑	↑	↑
	Fourth	20	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	1	3	2	5	4	7	6	11	15	16	22	↑	↑	↑	↑	↑	
	Fifth	20	100	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1 2	3	4	4	5	6	7	10	11	15	16	23	24	↑	↑	↑	↑	↑
K	First	32	32	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0	4	0	6	1	8	↑	↑	↑	↑	↑	↑		
	Second	32	64	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	0	3	1	5	2	7	3	9	6	12	↑	↑	↑	↑	↑
	Third	32	96	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	1	4	2	6	4	9	7	12	11	17	↑	↑	↑	↑	↑
	Fourth	32	128	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	1	3	2	5	4	7	6	11	15	16	22	↑	↑	↑	↑	↑	
	Fifth	32	160	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1 2	3	4	4	5	6	7	10	11	15	16	23	24	↑	↑	↑	↑	↑
L	First	50	50	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0	4	0	6	1	8	↑	↑	↑	↑	↑	↑		
	Second	50	100	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	0	3	1	5	2	7	3	9	6	12	↑	↑	↑	↑	↑
	Third	50	150	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	1	4	2	6	4	9	7	12	11	17	↑	↑	↑	↑	↑
	Fourth	50	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	1	3	2	5	4	7	6	11	15	16	22	↑	↑	↑	↑	↑	
	Fifth	50	250	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1 2	3	4	4	5	6	7	10	11	15	16	23	24	↑	↑	↑	↑	↑
M	First	80	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0	4	0	6	1	8	↑	↑	↑	↑	↑	↑		
	Second	80	160	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	0	3	1	5	2	7	3	9	6	12	↑	↑	↑	↑	↑
	Third	80	240	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	0	3	1	4	2	6	4	9	7	12	11	17	↑	↑	↑	↑	↑
	Fourth	80	320	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 2	1	3	2	5	4	7	6	11	15	16	22	↑	↑	↑	↑	↑	
	Fifth	80	400	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1 2	3	4	4	5	6	7	10	11	15	16	23	24	↑	↑	↑	↑	↑

▽ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-B — Multiple sampling plans for tightened inspection (Master table) (continued)

		Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																												
Sample size code letter	Sample size	Cumulative sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000		
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re		
H	First	13	13	26													# 2	# 2	# 3	# 4	0 4	0 6	1 8							
	Second	13	39														0 2	0 3	0 3	1 5	2 7	3 9	6 12							
	Third	13	52														0 2	0 3	1 4	2 6	4 9	7 12	11 17							
	Fourth	13	65														0 2	1 3	2 5	4 7	6 11	11 15	16 22							
	Fifth	13															1 2	3 4	4 5	6 7	10 11	15 16	23 24							
J	First	20	20														# 2	# 2	# 3	# 4	0 4	0 6	1 8							
	Second	20	40														0 2	0 3	0 3	1 5	2 7	3 9	6 12							
	Third	20	60														0 2	0 3	1 4	2 6	4 9	7 12	11 17							
	Fourth	20	80														0 2	1 3	2 5	4 7	6 11	11 15	16 22							
	Fifth	20	100														1 2	3 4	4 5	6 7	10 11	15 16	23 24							
K	First	32	32														# 2	# 2	# 3	# 4	0 4	0 6	1 8							
	Second	32	64														0 2	0 3	0 3	1 5	2 7	3 9	6 12							
	Third	32	96														0 2	0 3	1 4	2 6	4 9	7 12	11 17							
	Fourth	32	128														0 2	1 3	2 5	4 7	6 11	11 15	16 22							
	Fifth	32	160														1 2	3 4	4 5	6 7	10 11	15 16	23 24							
L	First	50	50														# 2	# 2	# 3	# 4	0 4	0 6	1 8							
	Second	50	100														0 2	0 3	0 3	1 5	2 7	3 9	6 12							
	Third	50	150														0 2	0 3	1 4	2 6	4 9	7 12	11 17							
	Fourth	50	200														0 2	1 3	2 5	4 7	6 11	11 15	16 22							
	Fifth	50	250														1 2	3 4	4 5	6 7	10 11	15 16	23 24							
M	First	80	80														# 2	# 2	# 3	# 4	0 4	0 6	1 8							
	Second	80	160														0 2	0 3	0 3	1 5	2 7	3 9	6 12							
	Third	80	240														0 2	0 3	1 4	2 6	4 9	7 12	11 17							
	Fourth	80	320														0 2	1 3	2 5	4 7	6 11	11 15	16 22							
	Fifth	80	400														1 2	3 4	4 5	6 7	10 11	15 16	23 24							

▽ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-C — Multiple sampling plans for reduced inspection (Master table)

Sample size code letter	Sample size	Cumulative sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																							
			0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A																										
B																										
C																										
D																										
E																										
F	First	2	2																							
	Second	2	4																							
F	Third	2	6																							
	Fourth	2	8																							
F	Fifth	2	10																							
G	First	3	3																							
	Second	3	6																							
G	Third	3	9																							
	Fourth	3	12																							
G	Fifth	3	15																							
H	First	5	5																							
	Second	5	10																							
H	Third	5	15																							
	Fourth	5	20																							
H	Fifth	5	25																							

▽ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

△ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-C — Multiple sampling plans for reduced inspection (Master table)

Sample size code letter	Sample size	Cumulative sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																							
			0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A																										
B																										
C																										
D																										
E																										
F	First	2	2																							
	Second	2	4																							
F	Third	2	6																							
	Fourth	2	8																							
F	Fifth	2	10																							
G	First	3	3																							
	Second	3	6																							
G	Third	3	9																							
	Fourth	3	12																							
G	Fifth	3	15																							
H	First	5	5																							
	Second	5	10																							
H	Third	5	15																							
	Fourth	5	20																							
H	Fifth	5	25																							

▽ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

△ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 4-C — Multiple sampling plans for reduced inspection (Master table)

Sample size code letter	Sample size	Cumulative sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																							
			0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A																										
B																										
C																										
D																										
E																										
F	First	2	2																							
	Second	2	4																							
F	Third	2	6																							
	Fourth	2	8																							
F	Fifth	2	10																							
G	First	3	3																							
	Second	3	6																							
G	Third	3	9																							
	Fourth	3	12																							
G	Fifth	3	15																							
H	First	5	5																							
	Second	5	10																							
H	Third	5	15																							
	Fourth	5	20																							
H	Fifth	5	25																							

▽ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

△ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

* = Use the corresponding single sampling plan (or alternatively use the double sampling plan below, where available).

++ = Use the corresponding double sampling plan (or alternatively use the multiple sampling plan below, where available).

= Acceptance is not permitted for this sample size.

Table 5-A — Producer's risk for normal inspection

(in percent of lots not accepted for single sampling plans)

		Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																											
Sample size	Sample code letter	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000		
A	2															12,2 12,6	7,15* 7,19*	9,45*	9,02	4,74	4,31	1,66	1,19	1,37	1,73	1,41	1,35		
B	3															11,3 11,5	6,85* 6,87*	9,45* 9,39*	7,54	4,05	3,38	1,48	1,19	0,667	1,03	0,607	0,979	0,627	
C	5															11,8 11,9	7,15* 7,17*	10,8* 10,8*	9,02	4,05	3,83	1,66	1,83	1,37	1,03	0,940	1,35	2,17	
D	8															11,3 11,4	7,15* 7,16*	10,5* 10,5*	9,63 9,10	4,74 3,81	3,38	1,66	1,68	1,77	1,73	0,607	1,35	1,73	
E	13															12,2 12,2	6,85* 6,86*	10,8* 10,8*	9,63 9,32	5,41 4,80	4,31 3,42	1,48	1,83	1,77	2,62	1,41	0,979	2,17	
F	20															12,2 12,2	7,15* 7,16*	9,45* 9,45*	9,02	4,74 4,39	4,31 3,74	1,66	1,19	1,37	1,73	1,41			
G	32															12,0 12,0	7,63* 7,64*	10,5* 10,5*	8,42 8,30	4,74 4,52	4,11 3,77	1,96	1,68	1,04	1,73	1,20			
H	50															11,8 11,8	7,15* 7,15*	10,8* 10,8*	8,94	9,02	3,83	1,66	1,83	1,37	1,73	1,41			
J	80															11,3 11,3	7,15* 7,15*	10,5* 10,5*	9,63 9,58	4,74 4,66	3,38 3,26	1,66	1,68	1,77	1,73	1,23	0,607		
K	125															11,8 11,8	6,41* 6,41*	10,1* 10,1*	9,02 8,99	4,92 4,87	3,83 3,74	1,25	1,48	1,37	1,95	0,940	0,626		
L	200															12,2 12,2	7,15* 7,15*	9,45* 9,45*	9,02 9,00	4,74 4,71	4,31 4,25	1,66 1,60	1,19 1,13	1,37 1,26	1,73 1,52	1,41 1,33	0,935	1,03	0,940
M	315															11,8 11,8	7,15* 7,15*	10,8* 10,8*	8,19	4,54	3,89	1,83	1,55	0,936	1,52	1,02			
N	500															11,8 11,8	6,41* 6,41*	10,1* 10,1*	9,01	4,04	3,81	1,63	1,79	1,32	0,971	0,857			
P	800															11,3 11,3	7,15* 7,15*	10,5* 10,5*	9,63 9,63	4,74 4,73	3,38 3,37	1,66 1,64	1,68 1,74	1,77 1,74	1,73 1,68	0,607 0,570			
Q	1 250	11,8	6,41*	10,1*	9,02	4,92	3,83	1,66	1,83	1,37	1,95	0,940																	
R	2 000	7,15*	9,45*	9,02	4,74	4,31	1,66	1,19	1,37	1,73	1,41	1,71	1,38																

NOTES

1 The producer's risk is the probability of nonacceptance for lots of AQL quality.

2 Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.
Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-A).

Table 5-B — Producer's risk for tightened inspection

(in percent of lots not accepted for single sampling plans)

		Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																											
Sample size code letter	Sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000		
A	2																18,1 19,0	13,7 14,2*	21,0*	19,1	14,3	8,39	6,81	6,38	6,98	5,25			
B	3																17,7 18,3	13,7* 14,2*	17,9*	17,3	12,1	13,4	8,39	4,03	4,27	3,74	4,09	2,21	
C	5																18,1 18,5	15,5* 15,9*	21,0* 21,6*	17,3	13,2	14,3	11,1	6,81	4,27	5,19	5,25	6,16	
D	8																18,1 18,3	15,1* 15,3*	22,2* 22,6*	19,1 18,7	12,1	14,3	10,5	8,19	6,38	3,74	5,25	5,12	
E	13																17,7 17,8	15,5* 15,6*	22,2* 22,4*	20,7	14,3	13,4	11,1	8,19	8,79	6,98	4,09	6,16	
F	20																18,1 18,2	13,7* 13,8*	21,0* 21,1*	19,1 19,0	14,3 13,7	14,3 13,3	8,39	6,81	6,38	6,98			
G	32																18,8 18,8	15,1* 15,2*	19,7* 19,8*	19,1 19,0	13,8 13,5	15,8 15,2	10,5 9,44	5,58	6,38	6,22			
H	50																18,1 18,2	15,5* 15,5*	21,0* 21,0*	17,3	13,2 12,9	14,3 13,9	11,1 10,4	6,81					
J	80																18,1 18,1	15,1* 15,2*	22,2* 22,2*	19,1 19,1	12,1 11,9	14,3 14,1	10,5 10,1	8,19	6,38	3,74			
K	125																17,1 17,1	14,6* 14,6*	21,0* 21,0*	19,6 19,5	13,2 13,1	12,1 12,0	9,70 9,44	6,81 6,41	7,00 6,34	5,19 4,28			
L	200																18,1 18,1	13,7* 13,7*	21,0* 21,0*	19,1 19,1	14,3 14,2	14,3 14,2	8,39 8,24	6,81 6,56	6,38 6,56	6,98 5,99	6,32		
M	315																18,5 18,5	14,8* 14,8*	19,3* 19,3*	18,7 18,7	13,4 13,3	15,2 15,1	9,98 9,88	5,16 5,03	5,80 5,56	5,52 5,15			
N	500																18,1 18,1	15,5* 15,5*	21,0* 22,2*	17,3 19,1	13,2 12,0	14,3 14,3	11,1 10,5	6,81 8,13	4,27 6,28	5,19 3,63			
P	800																18,1 18,1	15,1* 15,1*	22,2* 22,2*	19,1 19,1	12,1 12,0	14,3 14,3	10,5 10,5	6,81 8,13	6,19 6,28	3,74 3,63			
Q	1 250																17,1 17,1	14,6* 14,6*	21,0* 21,0*	19,6 19,6	13,2 13,1	12,1 12,1	9,70 9,68	6,81 6,77	7,00 6,94	5,19 5,10			
R	2 000	18,1	13,7*	21,0*	19,1	14,3	14,3	8,39	6,81	6,38	6,98						18,7 18,1	18,7 13,7*	21,0*	19,1	14,3	8,38	6,78	6,34	6,92				
S	3 150																												

NOTES

1 The producer's risk is the probability of nonacceptance for lots of AQL quality.

2 Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.
Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-B).

Table 5-C — Producer's risk for reduced inspection

(in percent of lots not accepted for single sampling plans)

		Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																										
Sample size code letter	Sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
A	2															12,2	7,15*	9,45*	9,02	4,74	4,31	1,66	1,19	1,37	1,73	1,41	1,35	
B	2															12,6	7,19*											
C	2															7,69	5,40*	7,15*	9,45*	9,02	4,74	4,31	1,66	1,19	1,37	1,73	1,41	1,35
D	3															4,88	2,33*	3,39*	4,72*	3,69	1,44	0,908	1,07	0,453	0,380	1,37	1,73	1,41
E	5															4,40	2,07*	2,94*	4,51*	3,69	1,09	0,729	0,775	0,396	0,38	0,667	1,03	0,607
F	8															4,88	2,07*	3,16*	4,72*	4,27	1,44	0,729	0,912	0,453	0,629	1,37	1,03	0,940
G	13															4,90	2,06*	3,12*	4,61*	3,70	0,856							
H	20															5,07	2,33*	2,94*	4,72*	4,15	1,59	0,908						
J	32															5,08	2,32*	2,91*	4,65*	3,81	1,20	0,502	0,775	0,453	0,571	1,77		
K	50															5,07	2,56*	3,39*	4,51*	4,27	1,59	1,09	1,07					
L	80															4,88	2,33*	3,39*	4,72*	3,69	1,44	0,908	1,07	0,453				
M	125															4,69	2,33*	3,30*	5,06*	4,15	1,29	0,908	1,00	0,558	0,571	1,04		
N	200															4,88	2,07*	3,16*	4,72*	4,27	1,44	0,729	0,912	0,453	0,629	1,37		
P	315															5,07	2,33*	2,94*	4,72*	4,15	1,59	0,908	0,775	0,453	0,571	1,77		
Q	500	4,88	2,07*	3,16*	4,72*	4,27	1,44	0,729	0,912	0,453	0,629	1,37																
R	800	2,33*	2,94*	4,72*	4,15	1,59	0,908	0,775	0,453	0,571	1,77																	

NOTES

1 The producer's risk is the probability of nonacceptance for lots of AQL quality.

2 Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.
Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-C).

Table 5-C — Producer's risk for reduced inspection

(in percent of lots not accepted for single sampling plans)

		Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																										
Sample size code letter	Sample size	0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
A	2															12,2	7,15*	9,45*	9,02	4,74	4,31	1,66	1,19	1,37	1,73	1,41	1,35	
B	2															12,6	7,19*											
C	2															7,69	5,40*	7,15*	9,45*	9,02	4,74	4,31	1,66	1,19	1,37	1,73	1,41	1,35
D	3															4,88	2,33*	3,39*	4,72*	3,69	1,44	0,908	1,07	0,453	0,380	1,37	1,73	1,41
E	5															4,40	2,07*	2,94*	4,51*	3,69	1,09	0,729	0,775	0,396	0,38	0,667	1,03	0,607
F	8															4,88	2,07*	3,16*	4,72*	4,27	1,44	0,729	0,912	0,453	0,629	1,37	1,03	0,940
G	13															4,90	2,06*	3,12*	4,61*	3,70	0,856							
H	20															5,07	2,33*	2,94*	4,72*	4,15	1,59	0,908						
J	32															5,08	2,32*	2,91*	4,65*	3,81	1,20	0,502	0,775	0,453	0,571	1,77		
K	50															5,07	2,56*	3,39*	4,51*	4,27	1,59	1,09	1,07					
L	80															4,88	2,33*	3,39*	4,72*	3,69	1,44	0,908	1,07	0,453				
M	125															4,69	2,33*	3,30*	5,06*	4,15	1,29	0,908	1,00	0,558	0,571	1,04		
N	200															4,88	2,07*	3,16*	4,72*	4,27	1,44	0,729	0,912	0,453	0,629	1,37		
P	315															5,07	2,33*	2,94*	4,72*	4,15	1,59	0,908	0,775	0,453	0,571	1,77		
Q	500	4,88	2,07*	3,16*	4,72*	4,27	1,44	0,729	0,912	0,453	0,629	1,37																
R	800	2,33*	2,94*	4,72*	4,15	1,59	0,908	0,775	0,453	0,571	1,77																	

NOTES

1 The producer's risk is the probability of nonacceptance for lots of AQL quality.

2 Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.
Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-C).

Table 6-B — Consumer's risk quality for tightened inspection
 (in percent nonconforming for single sampling plans, for inspection for percent nonconforming)

Sample size code letter	Sample size	Acceptance quality limit, AQL, percent nonconforming items															
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10
A	2																
B	3																
C	5																
D	8																
E	13																
F	20																
G	32																
H	50																
J	80																
K	125																
L	200																
M	315																
N	500																
P	800																
Q	1 250																
R	2 000																
S	3 150																

NOTES

1 At the consumer's risk quality, 10% of lots will be expected to be accepted.

2 All the values are based on the binomial distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-B).

Table 6-C — Consumer's risk quality for reduced inspection

(in percent nonconforming for single sampling plans, for inspection for percent nonconforming)

Sample size code letter	Sample size	Acceptance quality limit, AQL, percent nonconforming items															
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10
A	2															68,4	69,0*
B	2															68,4*	69,0*
C	2															68,4	69,0*
D	3															68,4	69,0*
E	5															68,4	75,3
F	8															68,4	65,5
G	13															68,4	52,3
H	20															68,4	46,7
J	32															68,4	37,4
K	50															68,4	29,1
L	80															68,4	24,7
M	125															68,4	24,7
N	200															68,4	24,7
P	315															68,4	24,7
Q	500															68,4	24,7
R	800															68,4	24,7

NOTES

1 At the consumer's risk quality, 10% of lots will be expected to be accepted.

2 All the values are based on the binomial distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-C).

Table 6-C — Consumer's risk quality for reduced inspection

(in percent nonconforming for single sampling plans, for inspection for percent nonconforming)

Sample size code letter	Sample size	Acceptance quality limit, AQL, percent nonconforming items															
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10
A	2															68,4	69,0*
B	2															68,4*	69,0*
C	2															68,4	69,0*
D	3															68,4	69,0*
E	5															68,4	75,3
F	8															68,4	65,5
G	13															68,4	52,3
H	20															68,4	46,7
J	32															68,4	37,4
K	50															68,4	29,1
L	80															68,4	24,7
M	125															68,4	24,7
N	200															68,4	24,7
P	315															68,4	24,7
Q	500															68,4	24,7
R	800															68,4	24,7

NOTES

1 At the consumer's risk quality, 10% of lots will be expected to be accepted.

2 All the values are based on the binomial distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-C).

Table 7-B — Consumer's risk quality for tightened inspection

(in nonconformities per 100 items for single sampling plans, for inspection for nonconformities per 100 items)

Sample size code letter	Sample size	Acceptance quality limit, AQL, nonconformities per 100 items																									
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
A	2																115	116*	125*	194	266	334	464	650	889	1 238	1 748
B	3															76,8	77,5*	83,0*	130	177	223	309	433	593	825	1 165	1 683
C	5															46,1	46,5*	49,8*	77,8	106	134	185	260	356	495	699	1 010
D	8															28,8	29,1*	31,1*	48,6	66,5	83,5	116	162	222	309	437	631
E	13															17,7	17,9*	19,2*	29,9	40,9	51,4	71,3	100	137	190	269	388
F	20															11,5	11,6*	12,5*	19,4	26,6	33,4	46,4	65,0	88,9	124		
G	32															7,20	7,26*	7,78*	12,2	16,6	20,9	29,0	40,6	55,6	77,4		
H	50															4,61	4,65*	4,98*	7,78	10,6	13,4	18,5	26,0	35,6	49,5		
J	80															2,88	2,91*	3,11*	4,86	6,65	8,35	11,6	16,2	22,2	30,9		
K	125															1,84	1,86*	1,99*	3,11	4,26	5,34	7,42	10,4	14,2	19,8		
L	200															1,15	1,16*	1,25*	1,94	2,66	3,34	4,64	6,50	8,89	12,4		
M	315															0,731	0,738*	0,791*	1,23	1,69	2,12	2,94	4,13	5,64	7,86		
N	500															0,461	0,465*	0,498*	0,778	1,06	1,34	1,85	2,60	3,56	4,95		
P	800															0,288	0,291*	0,311*	0,486	0,665	0,835	1,16	1,62	2,22	3,09		
Q	1 250															0,184	0,186*	0,199*	0,311	0,426	0,534	0,742	1,04	1,42	1,98		
R	2 000															0,115	0,116*	0,125*	0,194	0,266	0,334	0,464	0,650	0,889	1,24		
S	3 150															0,123											

NOTES

- 1 At the consumer's risk quality, 10% of lots will be expected to be accepted.
- 2 All the values are based on the Poisson distribution.
- 3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-B).

Table 7-C — Consumer's risk quality for reduced inspection
 (in nonconformities per 100 items for single sampling plans, for inspection for nonconformities per 100 items)

Sample size code letter	Sample size	Acceptance quality limit, AQL, nonconformities per 100 items																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
A	2															115	116*	125*	194*	266	334	464	589	770	1 006	1 409	1 916	
B	2															115	115*	116*	125*	194	266	334	464	589	770	1 006	1 409	1 916
C	2															115	115*	116*	125*	194	266	334	400	527	650	770	1 006	1 409
D	3															76,8	76,8*	77,5*	83,0*	130	177	223	266	351	433	514	671	939
E	5															46,1	46,1*	46,5*	49,8*	77,8	106	134	160	211	260	308	403	564
F	8															28,8	28,8*	29,1*	31,1*	48,6	66,5	83,5	99,9	132	162	193		
G	13															17,7	17,7*	17,9*	19,2*	29,9	40,9	51,4	61,5	81,0	100	119		
H	20															11,5	11,5*	11,6*	12,5*	19,4	26,6	33,4	40,0	52,7	65,0	77,0		
J	32															7,20	7,20*	7,26*	7,78*	12,2	16,6	20,9	25,0	32,9	40,6	48,1		
K	50															4,61	4,61*	4,65*	4,98*	7,78	10,6	13,4	16,0	21,1	26,0	30,8		
L	80															2,88	2,88*	2,91*	3,11*	4,86	6,65	8,35	9,99	13,2	16,2	19,3		
M	125															1,84	1,84*	1,86*	1,99*	3,11	4,26	5,34	6,39	8,43	10,4	12,3		
N	200															1,15	1,15*	1,16*	1,25*	1,94	2,66	3,34	4,00	5,27	6,50	7,70		
P	315															0,731	0,731*	0,738*	0,791*	1,23	1,69	2,12	2,54	3,34	4,13	4,89		
Q	500															0,461	0,461*	0,465*	0,498*	0,778	1,06	1,34	1,60	2,11	2,60	3,08		
R	800															0,288*	0,291*	0,311*	0,486	0,665	0,835	0,999	1,32	1,62	1,93			

NOTES

1 At the consumer's risk quality, 10% of lots will be expected to be accepted.

2 All the values are based on the Poisson distribution.

3 Superscript * denotes that the value is for the optional fractional acceptance number sampling plan (see Table 11-C).

Table 8-A — Average outgoing quality limits for normal inspection (Single sampling plans)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																											
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000		
A	2															18,4					42,0	68,6	97,1	158	224	326	470	733	1 085
B	3															14,8													
C	5															12,3													
D	8															10,5													
E	13															10,0													
F	20															7,36													
G	32															6,70													
H	50															4,60													
J	80															4,33													
K	125															2,83													
L	200															2,73													
M	315															1,84													
N	500															1,79													
P	800															1,15													
Q	1 250															1,13													
R	2 000															0,184													
																0,183													

NOTE

Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.

Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

Table 8-B — Average outgoing quality limits for tightened inspection (Single sampling plans)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
A	2															18,4 14,8				42,0	68,6	97,1	158	257	397	619	966	
B	3															12,3 10,5				28,0	45,7	64,7	106	172	265	412	644	1 020
C	5															7,36 6,70				16,8	27,4	38,8	63,4	103	159	247	387	612
D	8															4,60 4,33				10,5 10,1	17,1	24,3	39,6	64,3	99,3	155	242	382
E	13															2,83 2,73				6,46 6,32	10,5	14,9	24,4	39,6	61,1	95,2	149	235
F	20															1,84 1,79				4,20 4,14	6,86	9,71	15,8	25,7	39,7	61,9		
G	32															1,15 1,13				2,62 2,60	4,28	6,07	9,90	16,1	24,8	38,7		
H	50															0,736 0,728				1,68 1,67	2,74	3,88	6,34	10,3	15,9	24,7		
J	80															0,460 0,457				1,05 1,05	1,71	2,43	3,96	6,43	9,93	15,5		
K	125															0,294 0,293				1,10 0,670	1,55	2,53	4,12	6,36	9,90	10,1		
L	200															0,184 0,183				0,420 0,419	0,686 0,685	0,971 0,971	1,58 1,59	2,57 2,58	3,97 4,00	6,19 6,25		
M	315															0,117 0,117				0,267 0,266	0,435 0,435	0,617 0,617	1,01 1,01	1,63 2,52	2,53 3,93	3,95		
N	500															0,0736 0,0735				0,168 0,168	0,274 0,274	0,388 0,388	0,634 0,634	1,03 1,03	1,59 1,59	2,47 2,48		
P	800															0,0460 0,0460				0,105 0,105	0,171 0,171	0,243 0,243	0,396 0,396	0,643 0,644	0,993 0,995	1,55 1,55		
Q	1 250															0,0294 0,0294				0,0672 0,0672	0,110 0,110	0,155 0,155	0,253 0,254	0,412 0,412	0,636 0,636	0,990 0,991		
R	2 000															0,0184 0,0184				0,0420 0,0420	0,0686 0,0686	0,0971 0,0971	0,158 0,158	0,257 0,257	0,397 0,398	0,619 0,619		
S	3 150															0,0267 0,0267												

NOTE

Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.

Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

Table 8-B — Average outgoing quality limits for tightened inspection (Single sampling plans)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																											
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000		
A	2															18,4 14,8				42,0	68,6	97,1	158	257	397	619	966		
B	3															12,3 10,5				28,0	45,7	64,7	106	172	265	412	644	1 020	
C	5															7,36 6,70				16,8	27,4	38,8	63,4	103	159	247	387	612	
D	8															4,60 4,33				10,5 10,1	17,1	24,3	39,6	64,3	99,3	155	242	382	
E	13															2,83 2,73				6,46 6,32	10,5	14,9	24,4	39,6	61,1	95,2	149	235	
F	20															1,84 1,79				4,20 4,14	6,86	9,71	15,8	25,7	39,7	61,9			
G	32															1,15 1,13				2,62 2,60	4,28	6,07	9,90	16,1	24,8	38,7			
H	50															0,736 0,728				1,68 1,67	2,74	3,88	6,34	10,3	15,9	24,7			
J	80															0,460 0,457				1,05 1,05	1,71	2,43	3,96	6,43	9,93	15,5			
K	125															0,294 0,293				1,10 0,670	1,55	2,53	4,12	6,36	9,90				
L	200															0,184 0,183				0,420 0,419	0,686 0,685	0,971 0,971	1,58 1,59	2,57 2,58	3,97 4,00	6,19 6,25			
M	315															0,117 0,117				0,267 0,266	0,435 0,435	0,617 0,617	1,01 1,01	1,63 1,64	2,52 2,53	3,93 3,95			
N	500															0,0736 0,0735				0,168 0,168	0,274 0,274	0,388 0,388	0,634 0,634	1,03 1,03	1,59 1,59	2,47 2,48			
P	800															0,0460 0,0460				0,105 0,105	0,171 0,171	0,243 0,243	0,396 0,396	0,643 0,644	0,993 0,995	1,55 1,55			
Q	1 250															0,0294 0,0294				0,0672 0,0672	0,110 0,110	0,155 0,155	0,253 0,254	0,412 0,412	0,636 0,636	0,990 0,991			
R	2 000															0,0184 0,0184				0,0420 0,0420	0,0686 0,0686	0,0971 0,0971	0,158 0,158	0,257 0,257	0,397 0,398	0,619 0,619			
S	3 150															0,0267 0,0267													

NOTE

Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.

Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

Table 8-B — Average outgoing quality limits for tightened inspection (Single sampling plans)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
A	2															18,4 14,8				42,0	68,6	97,1	158	257	397	619	966	
B	3															12,3 10,5				28,0	45,7	64,7	106	172	265	412	644	1 020
C	5															7,36 6,70				16,8	27,4	38,8	63,4	103	159	247	387	612
D	8															4,60 4,33				10,5 10,1	17,1	24,3	39,6	64,3	99,3	155	242	382
E	13															2,83 2,73				6,46 6,32	10,5	14,9	24,4	39,6	61,1	95,2	149	235
F	20															1,84 1,79				4,20 4,14	6,86	9,71	15,8	25,7	39,7	61,9		
G	32															1,15 1,13				2,62 2,60	4,28	6,07	9,90	16,1	24,8	38,7		
H	50															0,736 0,728				1,68 1,67	2,74	3,88	6,34	10,3	15,9	24,7		
J	80															0,460 0,457				1,05 1,05	1,71	2,43	3,96	6,43	9,93	15,5		
K	125															0,294 0,293				0,672 0,670	1,10	1,55	2,53	4,12	6,36	9,90		
L	200															0,184 0,183				0,420 0,419	0,686 0,685	0,971 0,971	1,58 1,59	2,57 2,58	3,97 4,00	6,19 6,25		
M	315															0,117 0,117				0,267 0,266	0,435 0,435	0,617 0,617	1,01 1,01	1,63 1,64	2,52 2,53	3,93 3,95		
N	500															0,0736 0,0735				0,168 0,168	0,274 0,274	0,388 0,388	0,634 0,634	1,03 1,03	1,59 1,59	2,47 2,48		
P	800															0,0460 0,0460				0,105 0,105	0,171 0,171	0,243 0,243	0,396 0,396	0,643 0,644	0,993 0,995	1,55 1,55		
Q	1 250															0,0294 0,0294				0,0672 0,0672	0,110 0,110	0,155 0,155	0,253 0,254	0,412 0,412	0,636 0,636	0,990 0,991		
R	2 000															0,0184 0,0184				0,0420 0,0420	0,0686 0,0686	0,0971 0,0971	0,158 0,158	0,257 0,257	0,397 0,398	0,619 0,619		
S	3 150															0,0267 0,0267												

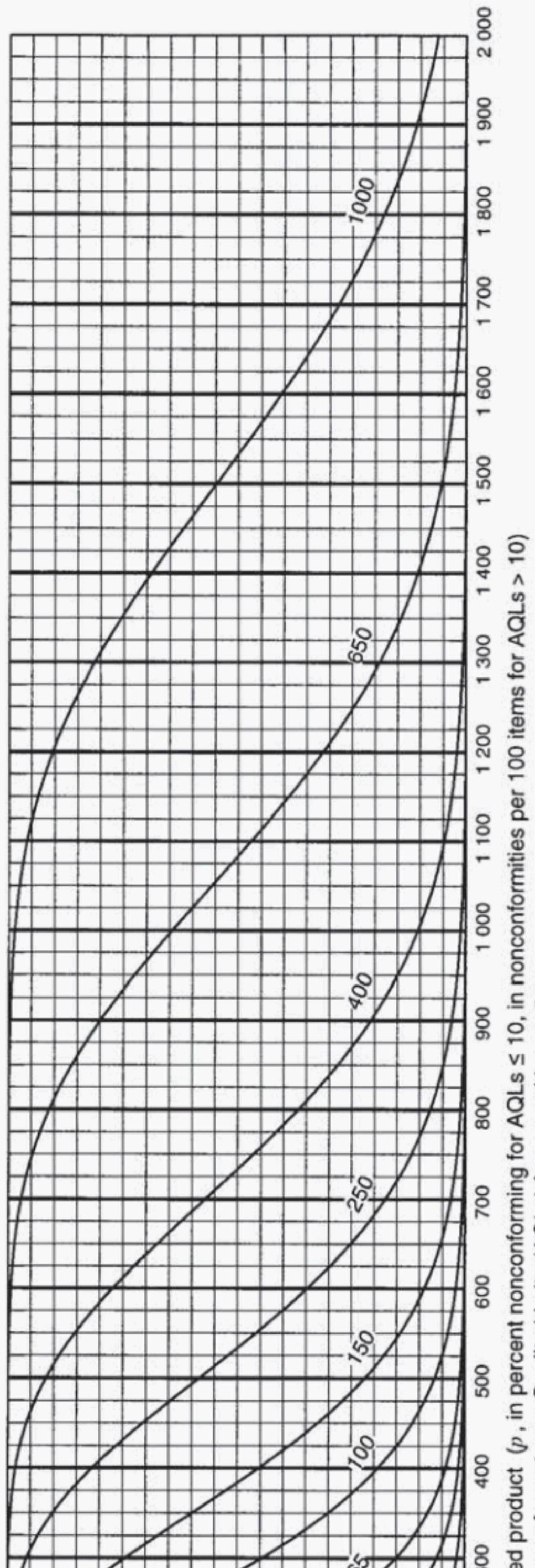
NOTE

Upper entries are for inspection for nonconformities per 100 items and are based on the Poisson distribution.

Lower entries are for inspection for percent nonconforming and are based on the binomial distribution.

Table 10-A — Tables for sample size code letter A (Individual plans)

Chart A Operating characteristic curves for single sampling plans
(Curves for double and multiple sampling are matched as closely as practicable)



Product p , in percent nonconforming for $AQLs \leq 10$, in nonconformities per 100 items for $AQLs > 10$
are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-A-1 — Tabulated values for operating characteristic curves for single sampling plans

t (g)	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)						
	6,5	25	40	65	100	150	250
0,503	7,43	21,8	41,2	89,3	145	175	239
2,56	17,8	40,9	68,3	131	199	235	308
5,27	26,6	55,1	87,2	158	233	272	351
14,4	48,1	86,4	127	211	298	342	431
34,7	83,9	134	184	284	383	433	533
69,3	135	196	255	371	484	540	651
115	194	266	334	464	589	650	770
150	237	315	388	526	657	722	848
230	332	420	502	655	800	870	1 007
	40	65	100	150	250	400	650
							1 000

p (in nonconformities per 100 items)

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

on used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-A-2—Sampling plans for sample size code letter A

		Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												
Type of sampling plan	Cumulative sample size	< 6,5	6,5	10	15	25	40	65	100	150	250	400	650	1 000
	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
Single	2	↓	0	1					1	2	2	3	3	4
Double					use	use	use	use						
		*	*		code	code	code	code	(*)	(*)	(*)	(*)	(*)	(*)
					letter	letter	letter	letter						
					D	C	B							
Multiple									*	*	*	*	*	*
< 10														
		10	15	25	40	65	100	150	250	400	650	1 000		

↓ = use next subsequent sample size code letter for which acceptance and rejection numbers are available

Ac = Acceptance number

Re = Rejection number

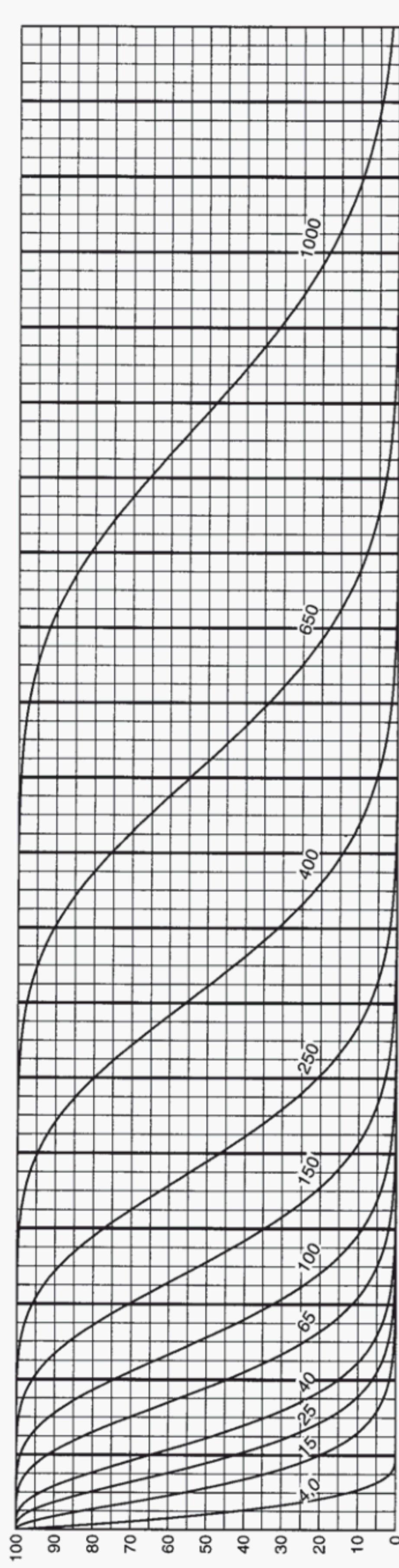
* = use single sampling plan above (or alternatively use code letter D)

(*) = use single sampling (or alternatively use code letter B)

A

B**Table 10-B — Tables for sample size code letter B (Individual plans)**

Chart B Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Quality of submitted product (p , in percent nonconforming for AQLs ≤ 10 , in nonconformities per 100 items for AQLs > 10)
 Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

50

Table 10-B-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a p (in percent nonconforming)	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)											
	4,0	4,0	15	25	40	65	100	150	250	400	650	1 000
99,0	0,334	0,335	4,95	14,5	27,4	59,5	96,9	117	159	203	249	345
95,0	1,70	1,71	11,8	27,3	45,5	87,1	133	157	206	256	308	415
90,0	3,45	3,51	17,7	36,7	58,2	105	144	181	234	288	343	456
75,0	9,14	9,59	32,0	57,6	84,5	141	199	228	287	347	408	530
50,0	20,6	23,1	55,9	89,1	122	189	256	289	356	422	489	623
25,0	37,0	46,2	89,8	131	170	247	323	360	434	507	580	724
10,0	53,6	76,8	130	177	223	309	392	433	514	593	671	825
5,0	63,2	99,9	158	210	258	350	438	481	565	648	730	890
1,0	78,5	154	221	280	335	437	533	580	671	761	848	1 019
	6,5	6,5	25	40	65	100	150	250	400	650	1 000	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-B-2—Sampling plans for sample size code letter B

↓ = use next subsequent sample size code letter for which acceptance and rejection numbers are available

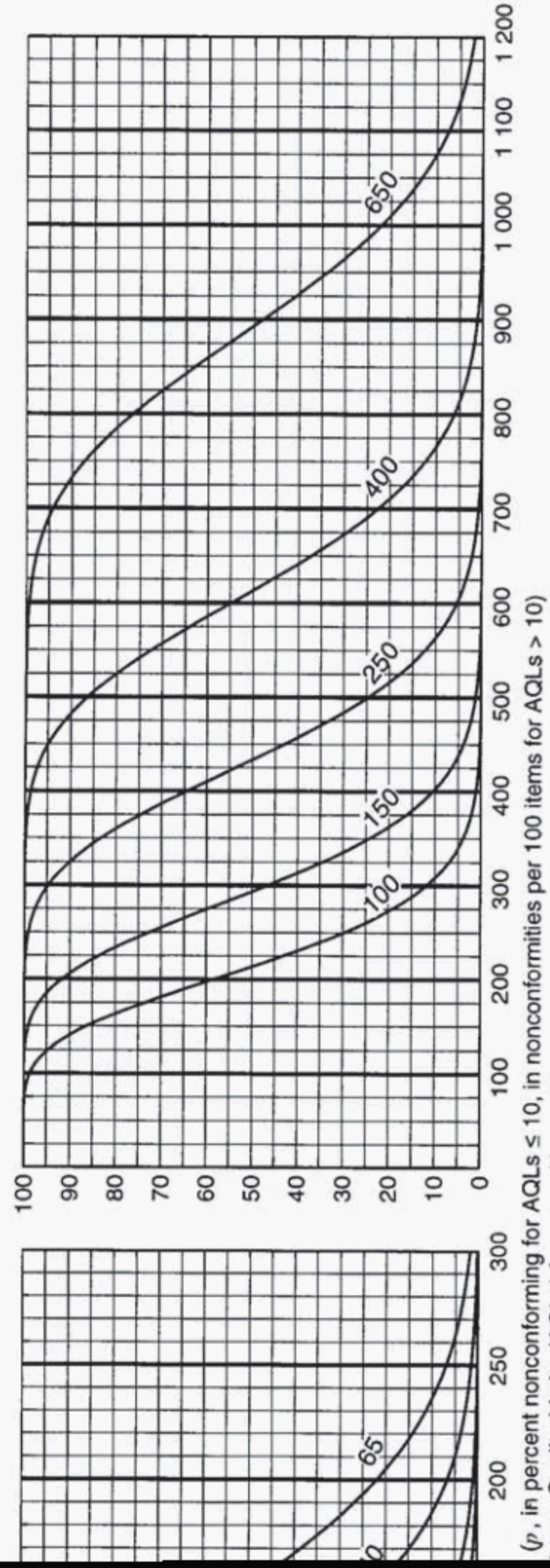
Ac = Acceptance number

Re = Rejection number

* = use single sampling plan above (or alternatively use code letter E)

++ = use double sampling plan above (or alternatively use code letter D)

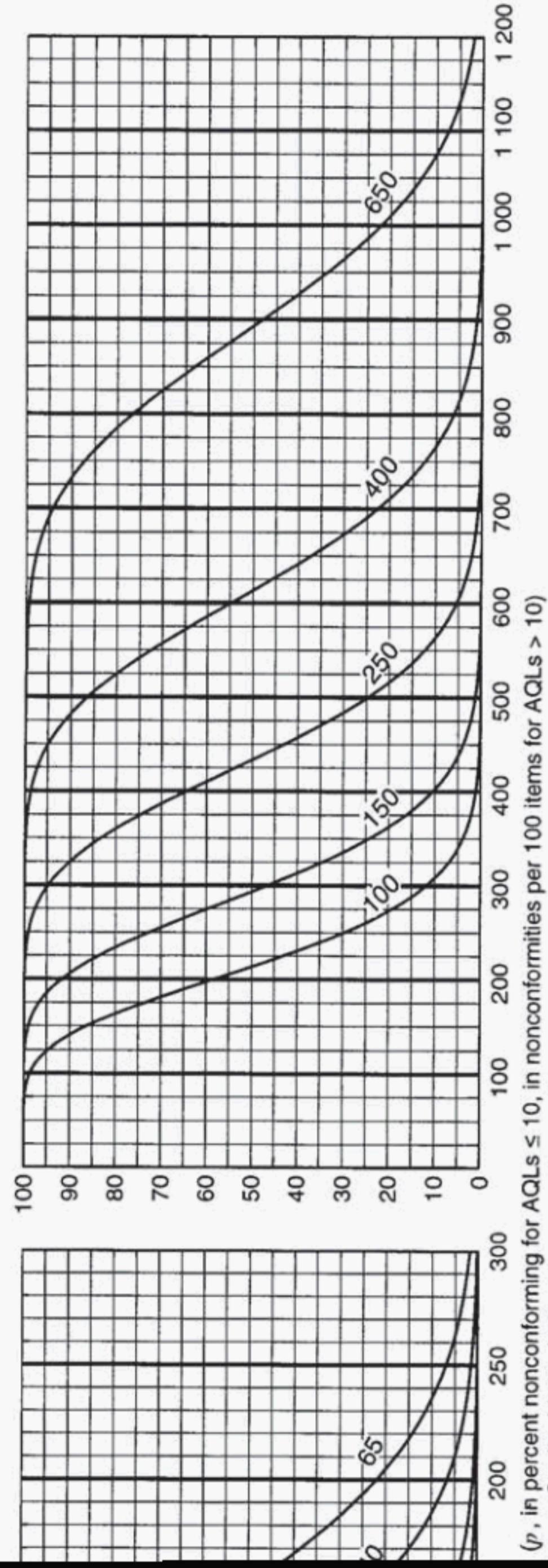
B

Table 10-C — Tables for sample size code letter C (Individual plans)**Chart C Operating characteristic curves for single sampling plans**
(Curves for double and multiple sampling are matched as closely as practicable)**10-C-1 — Tabulated values for operating characteristic curves for single sampling plans**

Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)									
p (in nonconformities per 100 items)									
10	15	25	40	65	100	150	250	400	650
2,97	8,72	16,5	35,7	58,1	70,1	95,4	122	150	207
7,11	16,4	27,3	52,3	79,6	93,9	123	154	185	249
10,6	22,0	34,9	63,0	93,1	109	140	173	206	273
19,2	34,5	50,7	84,4	119	137	172	208	245	318
33,6	53,5	73,4	113	153	173	213	253	293	373
53,9	78,4	102	148	194	216	260	304	348	435
77,8	106	134	185	235	260	308	356	403	495
94,9	126	155	210	263	289	339	389	438	534
133	168	201	262	320	348	403	456	509	612
15	25	40	65	100	150	250	400	650	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-C — Tables for sample size code letter C (Individual plans)**Chart C Operating characteristic curves for single sampling plans**
(Curves for double and multiple sampling are matched as closely as practicable)

(p , in percent nonconforming for $AQLs \leq 10$, in nonconformities per 100 items for $AQLs > 10$)
Acceptance Quality Limits (AQLs) for normal inspection.

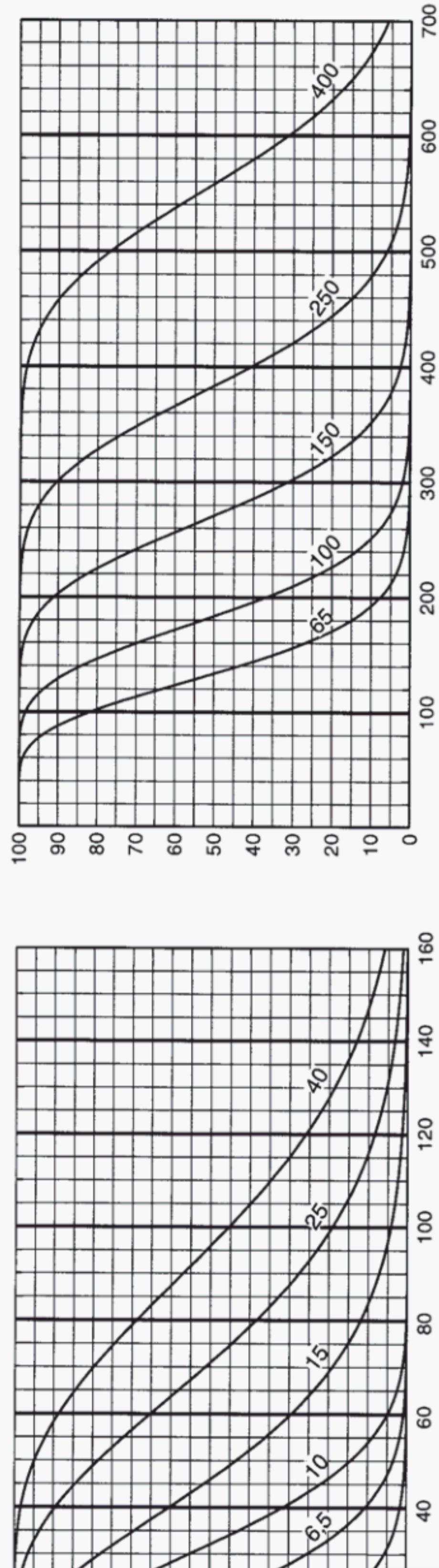
10-C-1 — Tabulated values for operating characteristic curves for single sampling plans

Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)									
p (in nonconformities per 100 items)									
10	15	25	40	65	100	150	250	400	650
2,97	8,72	16,5	35,7	58,1	70,1	95,4	122	150	207
7,11	16,4	27,3	52,3	79,6	93,9	123	154	185	249
10,6	22,0	34,9	63,0	93,1	109	140	173	206	273
19,2	34,5	50,7	84,4	119	137	172	208	245	318
33,6	53,5	73,4	113	153	173	213	253	293	373
53,9	78,4	102	148	194	216	260	304	348	435
77,8	106	134	185	235	260	308	356	403	495
94,9	126	155	210	263	289	339	389	438	534
133	168	201	262	320	348	403	456	509	612
15	25	40	65	100	150	250	400	650	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)
entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-D — Tables for sample size code letter D (Individual plans)

Chart D Operating characteristic curves for single sampling plans
(Curves for double and multiple sampling are matched as closely as practicable)



Probability of submitted product (p , in percent nonconforming for AQLs ≤ 10 , in nonconformities per 100 items for AQLs > 10)
on curves are Acceptance Quality Limits (AQLs) for normal inspection.

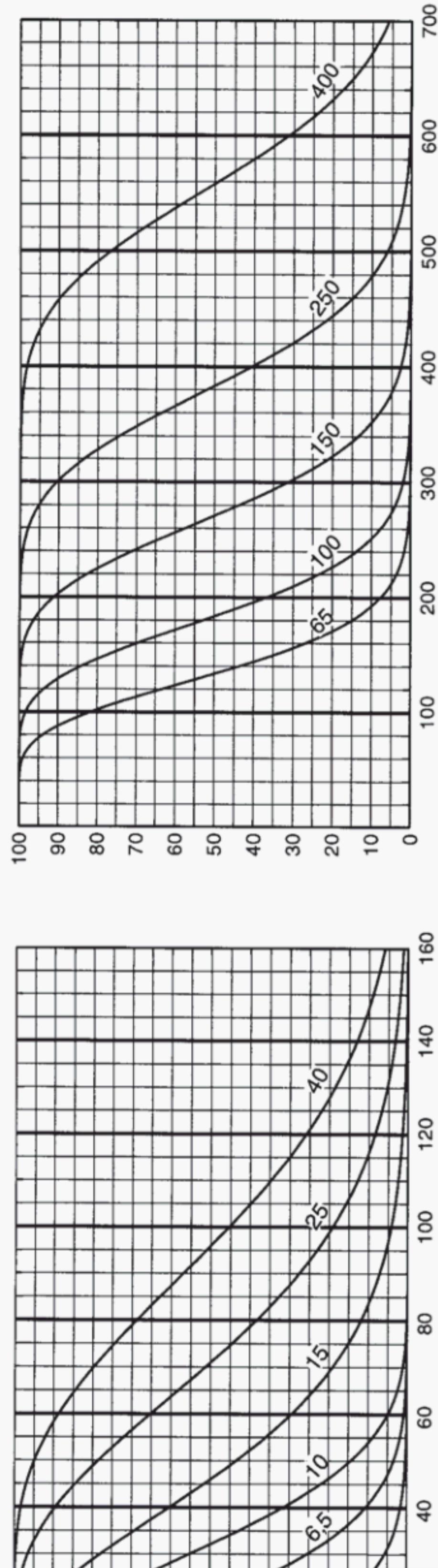
Table 10-D-1 — Tabulated values for operating characteristic curves for single sampling plans

Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)	p (in nonconformities per 100 items)													
	6,5	10	1,5	6,5	10	15	25	40	65	100	150	250	355	400
Percent nonconforming														
6	1,97	6,08	0,126	1,86	5,45	10,3	22,3	36,3	43,8	59,6	76,2	93,5	129	157
9	4,64	11,1	0,641	4,44	10,2	17,1	32,7	49,8	58,7	77,1	96,1	116	156	249
12	6,86	14,7	1,32	6,65	13,8	21,8	39,4	58,2	67,9	87,8	108	129	171	203
20	12,1	22,1	3,60	12,0	21,6	31,7	52,7	74,5	85,5	108	130	153	199	234
30	20,1	32,1	8,66	21,0	33,4	45,9	70,9	95,9	108	133	158	183	233	271
40	30,3	43,3	17,3	33,7	49,0	63,9	92,8	121	135	163	190	217	272	312
47	40,6	53,8	28,8	48,6	66,5	83,5	116	147	162	193	222	252	309	352
59	47,1	60,0	37,4	59,3	78,7	96,9	131	164	180	212	243	274	334	378
59,0	57,6	70,7	83,0	105	126	164	200	218	252	285	318	382	429	522
10	10	2,5	10	15	25	40	65	100	150	250	400	568	732	776

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)
and distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-D — Tables for sample size code letter D (Individual plans)

Chart D Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



Probability of submitted product (p , in percent nonconforming for AQLs ≤ 10 , in nonconformities per 100 items for AQLs > 10)
 on curves are Acceptance Quality Limits (AQLs) for normal inspection.

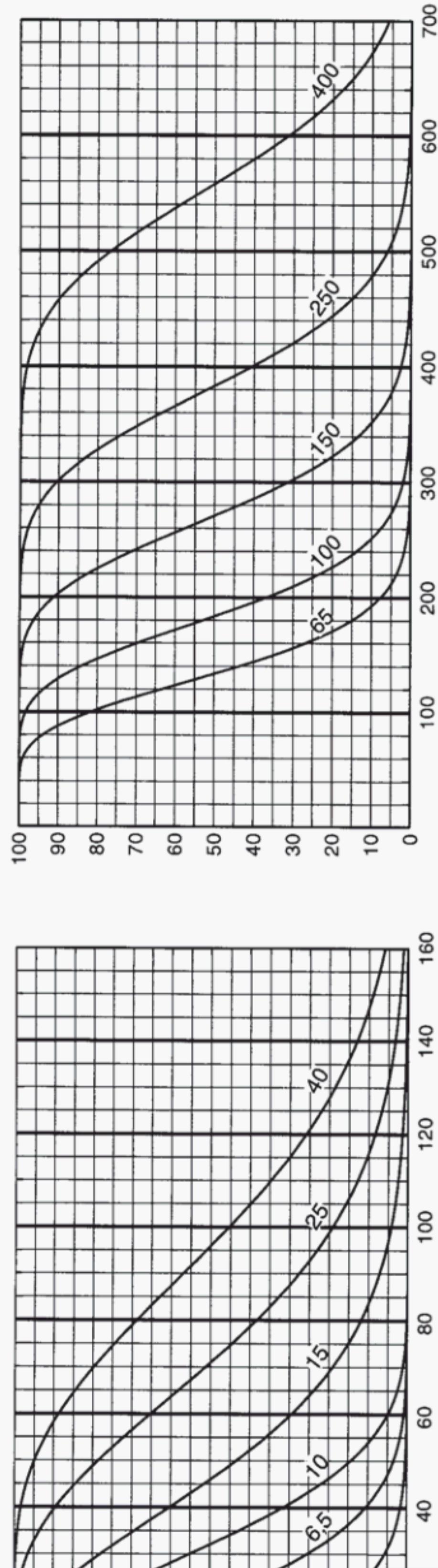
Table 10-D-1 — Tabulated values for operating characteristic curves for single sampling plans

Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)	p (in nonconformities per 100 items)												
	6,5	10	1,5	6,5	10	15	25	40	65	100	150	250	400
Percent nonconforming													
6	1,97	6,08	0,126	1,86	5,45	10,3	22,3	36,3	43,8	59,6	76,2	93,5	129
9	4,64	11,1	0,641	4,44	10,2	17,1	32,7	49,8	58,7	77,1	96,1	116	156
12	6,86	14,7	1,32	6,65	13,8	21,8	39,4	58,2	67,9	87,8	108	129	171
20	12,1	22,1	3,60	12,0	21,6	31,7	52,7	74,5	85,5	108	130	153	199
30	20,1	32,1	8,66	21,0	33,4	45,9	70,9	95,9	108	133	158	183	233
40	30,3	43,3	17,3	33,7	49,0	63,9	92,8	121	135	163	190	217	272
47	40,6	53,8	28,8	48,6	66,5	83,5	116	147	162	193	222	252	309
59	47,1	60,0	37,4	59,3	78,7	96,9	131	164	180	212	243	274	334
59,0	59,0	70,7	57,6	83,0	105	126	164	200	218	252	285	318	382
10	10	2,5	2,5	10	15	25	40	65	100	150	250	400	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)
 (Poisson for inspection for number of nonconformities)

Table 10-D — Tables for sample size code letter D (Individual plans)

Chart D Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



Probability of submitted product (p , in percent nonconforming for AQLs ≤ 10 , in nonconformities per 100 items for AQLs > 10)
 on curves are Acceptance Quality Limits (AQLs) for normal inspection.

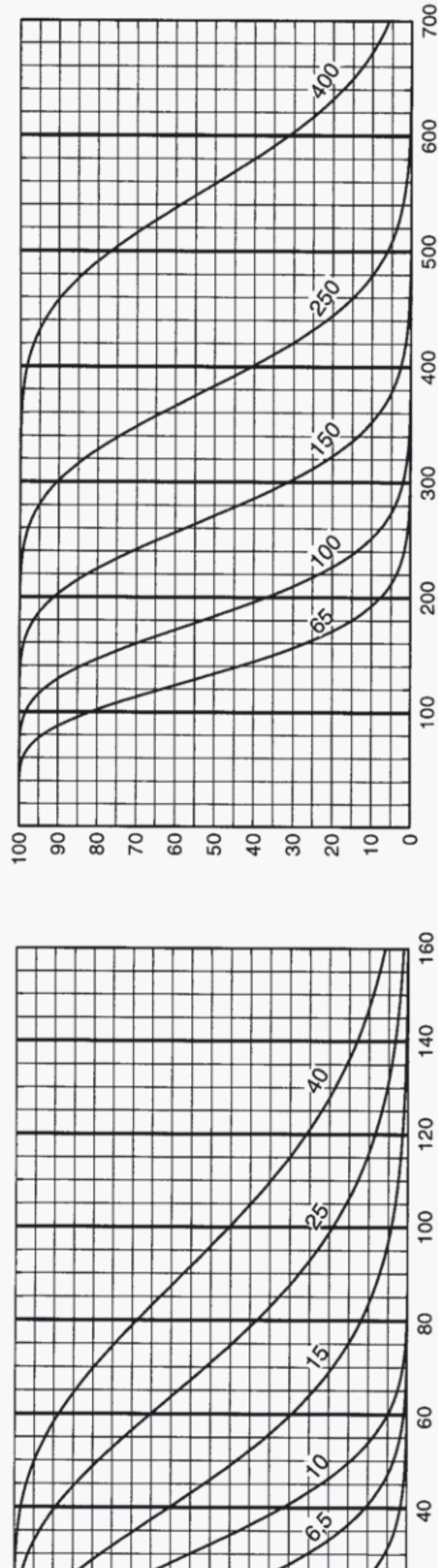
Table 10-D-1 — Tabulated values for operating characteristic curves for single sampling plans

Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)	p (in nonconformities per 100 items)												
	6,5	10	1,5	6,5	10	15	25	40	65	100	150	250	400
Percent nonconforming													
6	1,97	6,08	0,126	1,86	5,45	10,3	22,3	36,3	43,8	59,6	76,2	93,5	129
9	4,64	11,1	0,641	4,44	10,2	17,1	32,7	49,8	58,7	77,1	96,1	116	156
12	6,86	14,7	1,32	6,65	13,8	21,8	39,4	58,2	67,9	87,8	108	129	171
20	12,1	22,1	3,60	12,0	21,6	31,7	52,7	74,5	85,5	108	130	153	199
30	20,1	32,1	8,66	21,0	33,4	45,9	70,9	95,9	108	133	158	183	233
40	30,3	43,3	17,3	33,7	49,0	63,9	92,8	121	135	163	190	217	272
47	40,6	53,8	28,8	48,6	66,5	83,5	116	147	162	193	222	252	309
59	47,1	60,0	37,4	59,3	78,7	96,9	131	164	180	212	243	274	334
59,0	59,0	70,7	57,6	83,0	105	126	164	200	218	252	285	318	382
10	10	2,5	2,5	10	15	25	40	65	100	150	250	400	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)
 (Poisson for inspection for number of nonconformities)

Table 10-D — Tables for sample size code letter D (Individual plans)

Chart D Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



Probability of submitted product (p , in percent nonconforming for AQLs ≤ 10 , in nonconformities per 100 items for AQLs > 10)
 on curves are Acceptance Quality Limits (AQLs) for normal inspection.

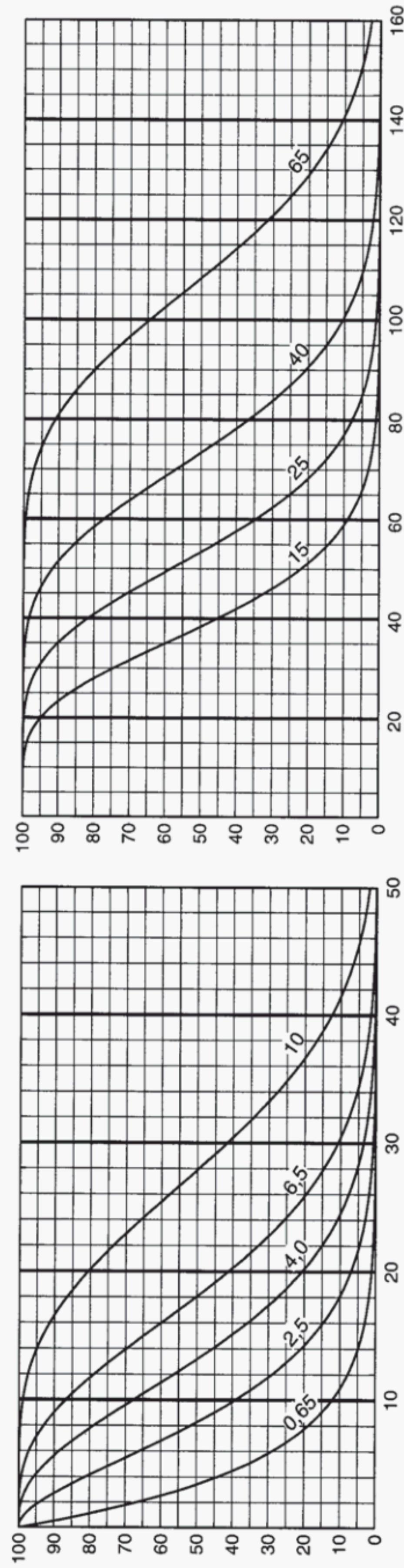
Table 10-D-1 — Tabulated values for operating characteristic curves for single sampling plans

Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)	p (in nonconformities per 100 items)												
	6,5	10	1,5	6,5	10	15	25	40	65	100	150	250	400
Percent nonconforming													
6	1,97	6,08	0,126	1,86	5,45	10,3	22,3	36,3	43,8	59,6	76,2	93,5	129
9	4,64	11,1	0,641	4,44	10,2	17,1	32,7	49,8	58,7	77,1	96,1	116	156
12	6,86	14,7	1,32	6,65	13,8	21,8	39,4	58,2	67,9	87,8	108	129	171
20	12,1	22,1	3,60	12,0	21,6	31,7	52,7	74,5	85,5	108	130	153	199
30	20,1	32,1	8,66	21,0	33,4	45,9	70,9	95,9	108	133	158	183	233
40	30,3	43,3	17,3	33,7	49,0	63,9	92,8	121	135	163	190	217	272
40,6	40,6	53,8	28,8	48,6	66,5	83,5	116	147	162	193	222	252	309
47,1	47,1	60,0	37,4	59,3	78,7	96,9	131	164	180	212	243	274	334
59,0	59,0	70,7	57,6	83,0	105	126	164	200	218	252	285	318	382
10	10		2,5	10	15	25	40	65	100	150	250	400	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)
 (Poisson for inspection for number of nonconformities)

**Table 10-F — Tables for sample size code letter F (Individual plans)****Chart F 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
accepted (P_a)



NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Quality of submitted product (p , in percent nonconforming for AQLs ≤ 10 , in nonconformities per 100 items for AQLs > 10)

Table 10-F-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)											
	0,65	2,5	4,0	6,5	10	0,65	2,5	4,0	6,5	10	15	\diagup
	p (in percent nonconforming)											
99,0	0,0502	0,759	2,27	4,36	9,75	0,0503	0,743	2,18	4,12	8,93	14,5	\diagup
95,0	0,256	1,81	4,22	7,14	14,0	0,256	1,78	4,09	6,83	13,1	19,9	\diagup
90,0	0,525	2,69	5,64	9,02	16,6	0,527	2,66	5,51	8,72	15,8	23,3	\diagup
75,0	1,43	4,81	8,70	12,8	21,6	1,44	4,81	8,64	12,7	21,1	29,8	\diagup
50,0	3,41	8,25	13,1	18,1	27,9	3,47	8,39	13,4	18,4	28,4	38,3	\diagup
25,0	6,70	12,9	18,7	24,2	34,8	6,93	13,5	19,6	25,5	37,1	48,4	\diagup
10,0	10,9	18,1	24,5	30,4	41,5	11,5	19,4	26,6	33,4	46,4	58,9	\diagup
5,0	13,9	21,6	28,3	34,4	45,6	15,0	23,7	31,5	38,8	52,6	65,7	\diagup
1,0	20,6	28,9	35,8	42,1	53,2	23,0	33,2	42,0	50,2	65,5	80,0	\diagup
	1,0	4,0	6,5	10	\diagup	1,0	4,0	6,5	10	15	\diagup	\diagup
												65

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-F-2—Sampling plans for sample size code letter F

↑ = 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

A_C = Acceptance number

Re = Rejection number

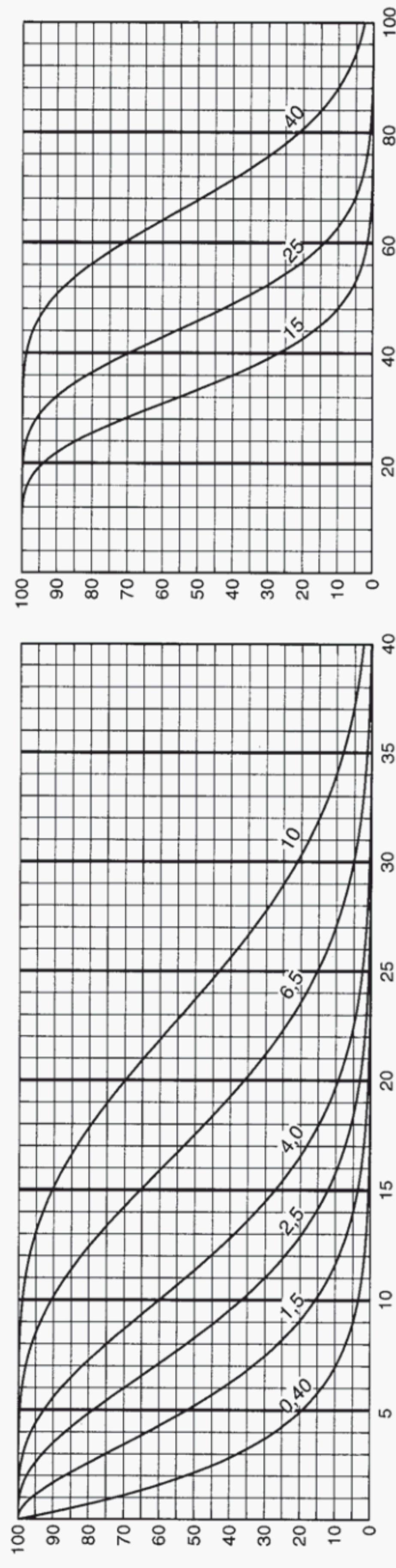
- * = use single sampling plan above (or alternatively use code letter J)

= acceptance Not permitted at this sample size

G

Table 10-G — Tables for sample size code letter G (Individual plans)

Chart G Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Quality of submitted product (p , in percent nonconforming for $AQLs \leq 10$, in nonconformities per 100 items for $AQLs > 10$)

NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-G-1 Tabulated values for operating characteristic curves for single sampling plans

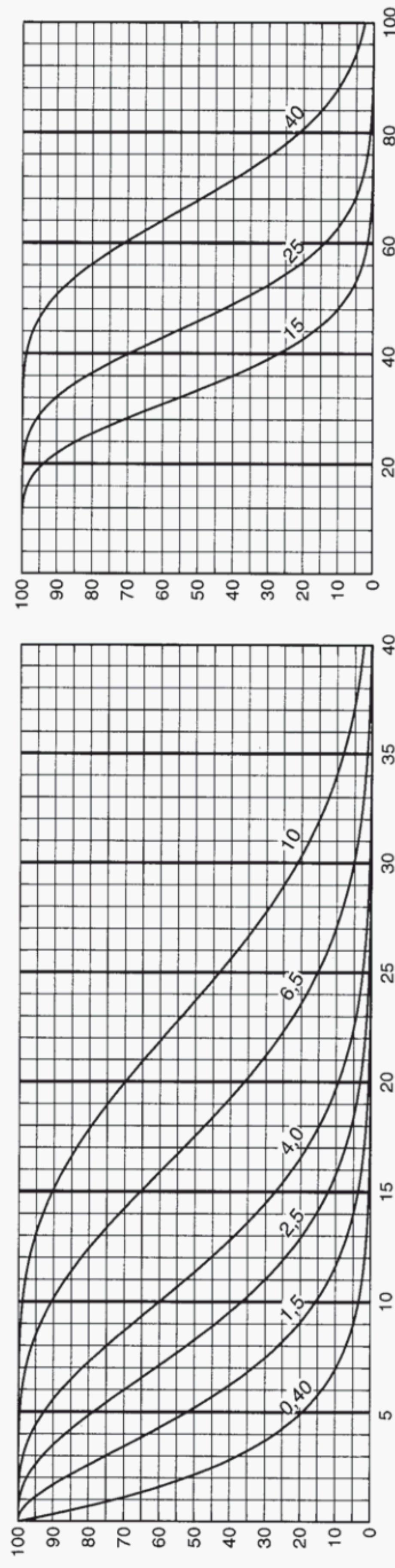
P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												p (in nonconformities per 100 items)
	0,40	1,5	2,5	4,0	6,5	10	0,40	1,5	2,5	4,0	6,5	10	
99,0	0,0314	0,471	1,40	2,67	5,88	9,73	0,0314	0,464	1,36	2,57	5,58	9,08	19,1
95,0	0,160	1,12	2,60	4,38	8,50	13,1	0,160	1,11	2,56	4,27	8,17	12,4	19,3
90,0	0,329	1,67	3,49	5,56	10,2	15,1	0,329	1,66	3,44	5,45	9,85	14,6	17,0
75,0	0,895	3,01	5,42	7,98	13,4	19,0	0,899	3,00	5,40	7,92	13,2	18,6	21,4
50,0	2,14	5,19	8,27	11,4	17,5	23,7	2,17	5,24	8,36	11,5	17,7	24,0	27,1
25,0	4,24	8,19	11,9	15,4	22,3	29,0	4,33	8,41	12,3	16,0	23,2	30,3	33,8
10,0	6,94	11,6	15,8	19,7	27,1	34,0	7,20	12,2	16,6	20,9	29,0	36,8	40,6
5,0	8,94	14,0	18,4	22,5	30,1	37,2	9,36	14,8	19,7	24,2	32,9	41,1	45,1
1,0	13,4	19,0	23,8	28,1	36,0	43,2	14,4	20,7	26,3	31,4	41,0	50,0	54,4
	0,65	2,5	4,0	6,5	10		0,65	2,5	4,0	6,5	10		

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items. Poisson for inspection for number of nonconformities.

G

Table 10-G — Tables for sample size code letter G (Individual plans)

Chart G Operating characteristic curves for single sampling plans
(Curves for double and multiple sampling are matched as closely as practicable)



NOTE Quality of submitted product (p , in percent nonconforming for $AQLs \leq 10$, in nonconformities per 100 items for $AQLs > 10$)

NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-G-1 Tabulated values for operating characteristic curves for single sampling plans

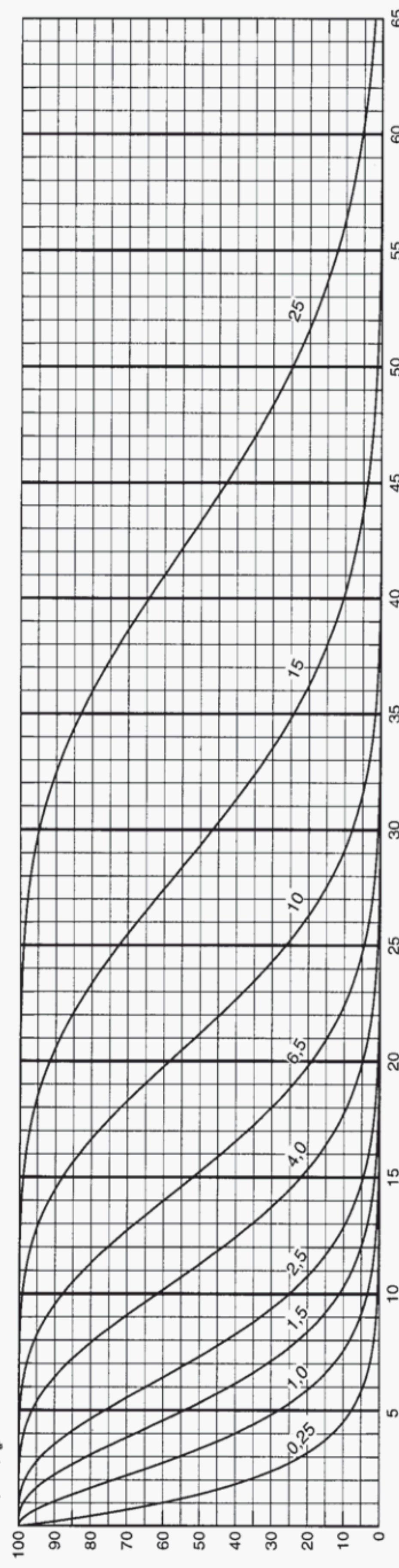
P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												p (in nonconformities per 100 items)
	0,40	1,5	2,5	4,0	6,5	10	0,40	1,5	2,5	4,0	6,5	10	
99,0	0,0314	0,471	1,40	2,67	5,88	9,73	0,0314	0,464	1,36	2,57	5,58	9,08	19,1
95,0	0,160	1,12	2,60	4,38	8,50	13,1	0,160	1,11	2,56	4,27	8,17	12,4	19,3
90,0	0,329	1,67	3,49	5,56	10,2	15,1	0,329	1,66	3,44	5,45	9,85	14,6	17,0
75,0	0,895	3,01	5,42	7,98	13,4	19,0	0,899	3,00	5,40	7,92	13,2	18,6	21,4
50,0	2,14	5,19	8,27	11,4	17,5	23,7	2,17	5,24	8,36	11,5	17,7	24,0	27,1
25,0	4,24	8,19	11,9	15,4	22,3	29,0	4,33	8,41	12,3	16,0	23,2	30,3	33,8
10,0	6,94	11,6	15,8	19,7	27,1	34,0	7,20	12,2	16,6	20,9	29,0	36,8	40,6
5,0	8,94	14,0	18,4	22,5	30,1	37,2	9,36	14,8	19,7	24,2	32,9	41,1	45,1
1,0	13,4	19,0	23,8	28,1	36,0	43,2	14,4	20,7	26,3	31,4	41,0	50,0	54,4
	0,65	2,5	4,0	6,5	10		0,65	2,5	4,0	6,5	10		

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items. Poisson for inspection for number of nonconformities.

H

Table 10-H — Tables for sample size code letter H (Individual plans)

Chart H Operating characteristic curves for single sampling plans
(Curves for double and multiple sampling are matched as closely as practicable)



NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.
Quality of submitted product (p , in percent nonconforming for AQLs ≤ 10 , in nonconformities per 100 items for AQLs > 10)

62

Table 10-H-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)										p (in percent nonconforming)						
	0,25	1,0	1,5	2,5	4,0	6,5	10	0,25	1,0	1,5	2,5	4,0	6,5	10	15	25	
	p (in percent nonconforming)										p (in nonconformities per 100 items)						
99,0	0,0201	0,300	0,886	1,68	3,69	6,07	7,36	10,1	0,0201	0,297	0,872	1,65	3,57	5,81	9,54	20,7	25,1
95,0	0,103	0,715	1,66	2,78	5,36	8,22	9,72	12,9	0,103	0,711	1,64	2,73	5,23	7,96	9,39	24,9	29,8
90,0	0,210	1,07	2,22	3,53	6,43	9,54	11,2	14,5	0,211	1,06	2,20	3,49	6,30	9,31	10,9	14,0	27,3
75,0	0,574	1,92	3,46	5,10	8,51	12,0	13,8	17,5	0,575	1,92	3,45	5,07	8,44	11,9	13,7	17,2	20,8
50,0	1,38	3,33	5,31	7,29	10,0	14,5	15,2	17,2	21,0	1,39	3,36	5,35	7,34	11,3	15,3	21,3	25,3
25,0	2,73	5,29	7,69	10,3	12,9	17,8	22,4	24,7	29,1	2,77	5,39	7,84	10,2	14,8	19,4	21,6	26,0
10,0	4,50	7,56	10,3	12,9	17,8	22,4	24,7	29,1	4,61	7,78	10,6	13,4	18,5	23,5	26,0	30,8	35,6
5,0	5,82	9,14	12,1	14,8	19,9	24,7	27,0	31,6	5,99	9,49	12,6	15,5	21,0	26,3	28,9	33,9	38,9
1,0	8,80	12,6	15,8	18,7	24,2	29,2	31,6	36,3	9,21	13,3	16,8	20,1	26,2	32,0	34,8	40,3	50,9
	0,40	1,5	2,5	4,0	6,5	10	15	20	0,40	1,5	2,5	4,0	6,5	10	15	25	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

NOTE Binomial distribution used for entries corresponding to inspection for number of nonconformities.
Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-H-2 — Sampling plans for sample size code letter H

Type of sampling plan	Cumulative sample size	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)																												
		< 0,25	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	> 25																
Single	50	↓	0	1			1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	↑	
Double	32	↓	*	use	use	0	2	0	3	1	3	2	5	3	6	4	7	5	9	6	10	7	11	9	14	11	16	↑		
	64			code letter	code letter	1	2	3	4	4	5	6	7	9	10	10	11	12	13	15	16	18	19	23	24	26	27			
Multiple	13	↓	*	G	K	J	#	2	#	3	#	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	↑			
	26						0	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14		
	39						0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19		
	52						0	2	1	3	2	5	4	7	5	9	6	11	9	12	11	15	12	17	16	22	20	25		
	65						1	2	3	4	4	5	6	7	9	10	10	11	12	13	15	16	18	19	23	24	26	27		
				< 0,40	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	10	15	25	40	65	10	15	25	40	65	10	15	25	> 25

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

↑ = 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

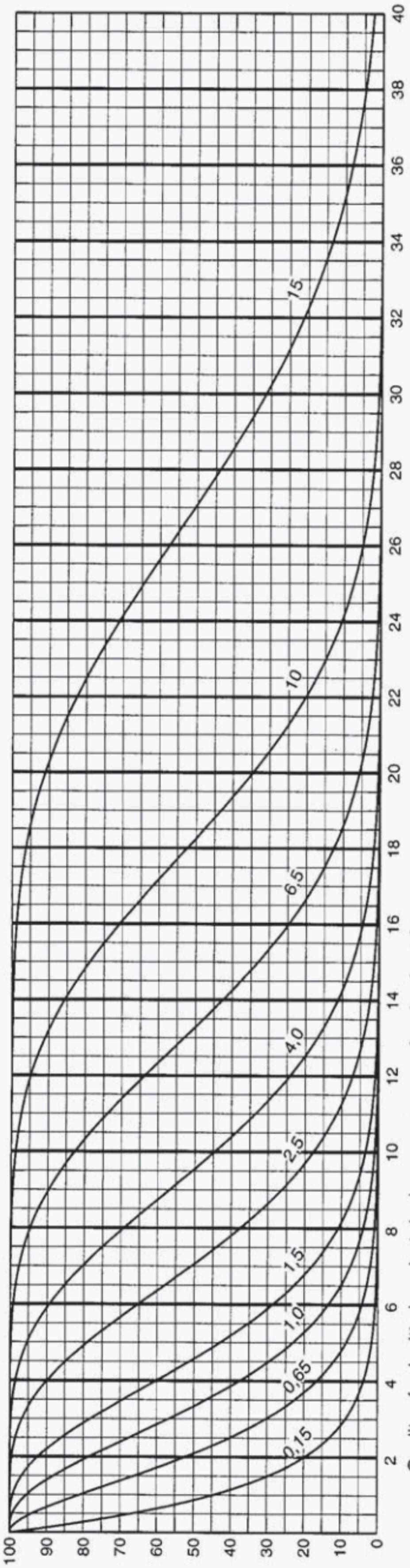
Ac = Acceptance number
 Re = Rejection number

* = use single sampling plan above (or alternatively use code letter L)
 # = acceptance not permitted at this sample size



**Table 10-J — Tables for sample size code letter J (Individual plans)**

Chart J Operating characteristic curves for single sampling plans
(Curves for double and multiple sampling are matched as closely as practicable)

**Table 10-J-1 — Tabulated values for operating characteristic curves for single sampling plans**

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												p (in nonconformities per 100 items)									
	0,15	0,65	1,0	1,5	2,5	4,0	6,5	10	10	1,0	1,5	2,5	4,0	6,5	10	10	1,5					
99,0	0,0126	0,187	0,550	1,04	2,28	3,73	4,51	6,17	7,93	9,76	0,0126	0,186	0,545	1,03	2,23	3,63	4,38	5,96	7,62	9,35	12,9	15,7
95,0	0,0641	0,446	1,03	1,73	3,32	5,07	6,00	7,91	9,89	11,9	0,0641	0,444	1,02	1,71	3,27	4,98	5,87	7,71	9,61	11,6	15,6	18,6
90,0	0,132	0,667	1,39	2,20	3,99	5,91	6,90	8,95	11,0	13,2	0,132	0,665	1,38	2,18	3,94	5,82	6,79	8,78	10,8	12,9	17,1	20,3
75,0	0,359	1,20	2,16	3,18	5,30	7,50	8,61	10,9	13,2	15,5	0,360	1,20	2,16	3,17	5,27	7,45	8,55	10,8	13,0	15,3	19,9	23,4
50,0	0,863	2,09	3,33	4,57	7,06	9,55	10,8	13,3	15,8	18,3	0,866	2,10	3,34	4,59	7,09	9,59	10,8	13,3	15,8	18,3	23,3	27,1
25,0	1,72	3,33	4,84	6,30	9,14	11,9	13,3	16,0	18,6	21,3	1,73	3,37	4,90	6,39	9,28	12,1	13,5	16,3	19,0	21,7	27,2	31,2
10,0	2,84	4,78	6,52	8,16	11,3	14,3	15,7	18,6	21,4	24,2	2,88	4,86	6,65	8,35	11,6	14,7	16,2	19,3	22,2	25,2	30,9	35,2
5,0	3,68	5,79	7,66	9,41	12,7	15,8	17,3	20,3	23,2	26,0	3,74	5,93	7,87	9,69	13,1	16,4	18,0	21,2	24,3	27,4	33,4	37,8
1,0	5,59	8,01	10,1	12,0	15,6	18,9	20,5	23,6	26,6	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	1,0	1,5	2,5	4,0	6,5	10	10	1,0	1,5	2,5	0,25	1,0	1,5	2,5	4,0	6,5	10	10	1,5	15	15	

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-J-2—Sampling plans for sample size code letter J

↑ = 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

A_C = Acceptance number

Re = Rejection number

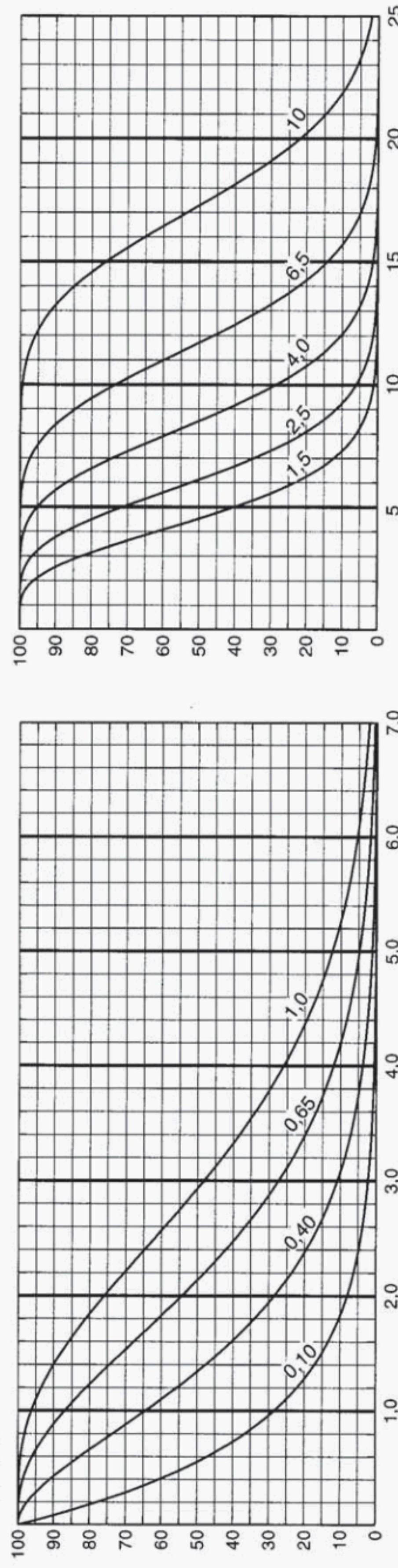
- * = use single sampling plan above (or alternatively use code letter M)

= acceptance not permitted at this sample size



Table 10-K — Tables for sample size code letter K (Individual plans)

Chart K Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-K-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)										p (in nonconformities per 100 items)														
	0,10	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	10,4	12,2	15,1	17,3	21,9	21,9	23,3	26,0	26,0	2,32	2,81	4,88	5,98	8,28	10,1	
99,0	0,00804	0,119	0,351	0,664	1,45	2,36	2,86	3,90	5,00	6,15	8,55	10,4	0,00804	0,119	0,349	0,659	1,43	2,32	2,81	4,88	5,98	8,28	10,1		
95,0	0,0410	0,285	0,657	1,10	2,11	3,22	3,81	5,01	6,26	7,54	10,2	12,2	0,0410	0,284	0,654	1,09	2,09	3,18	3,76	4,94	6,15	7,40	9,95	11,9	
90,0	0,0843	0,426	0,885	1,40	2,54	3,76	4,39	5,69	7,01	8,37	11,1	13,3	0,0843	0,425	0,882	1,40	2,52	3,72	4,35	5,62	6,92	8,24	10,9	13,0	
75,0	0,230	0,769	1,38	2,03	3,39	4,79	5,50	6,94	8,39	9,86	12,8	15,1	0,230	0,769	1,38	2,03	3,38	4,76	5,47	6,90	8,34	9,79	12,7	14,9	
50,0	0,553	1,34	2,13	2,93	4,52	6,12	6,92	8,51	10,1	11,7	14,9	17,3	0,555	1,34	2,14	2,94	4,54	6,14	6,94	8,53	10,1	11,7	14,9	17,3	20,0
25,0	1,10	2,14	3,11	4,05	5,88	7,66	8,54	10,3	12,0	13,7	17,1	19,6	1,11	2,15	3,14	4,09	5,94	7,75	8,64	10,4	12,2	13,9	17,4	20,0	
10,0	1,83	3,08	4,20	5,27	7,29	9,24	10,2	12,1	13,9	15,7	19,3	21,9	1,84	3,11	4,26	5,34	7,42	9,42	10,4	12,3	14,2	16,1	19,8	22,5	
5,0	2,37	3,74	4,95	6,09	8,23	10,3	11,3	13,2	15,1	17,0	20,6	23,3	2,40	3,80	5,04	6,20	8,41	10,5	11,5	13,6	15,6	17,5	21,4	24,2	
1,0	3,62	5,19	6,55	7,81	10,2	12,3	13,4	15,5	17,5	19,4	23,2	26,0	3,68	5,31	6,72	8,04	10,5	12,8	13,9	16,1	18,3	20,4	24,5	27,5	
	0,15	0,65	1,0	1,5	2,5	4,0	6,5	10	15	0,65	1,0	1,5	2,5	4,0	6,5	10	15	2,5	4,0	6,5	10	15	20		

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-K-2—Sampling plans for sample size code letter K

↑ = 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

A_C = Acceptance number

Re = Rejection number

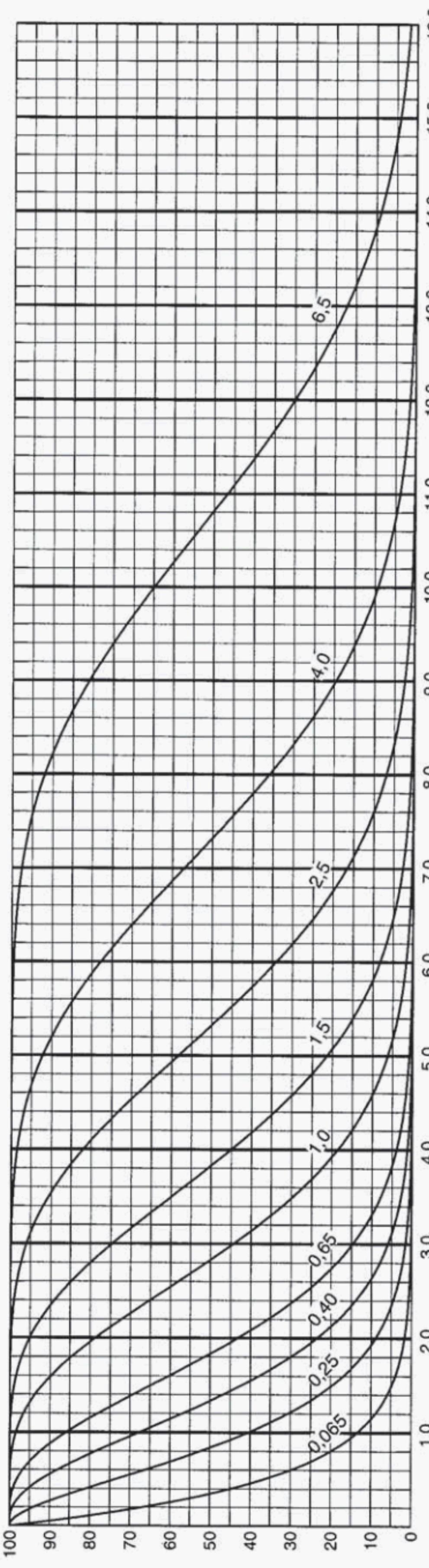
- * = use single sampling plan above (or alternatively use code letter N)

= acceptance not permitted at this sample size



Table 10-L — Tables for sample size code letter L (Individual plans)

Chart L Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

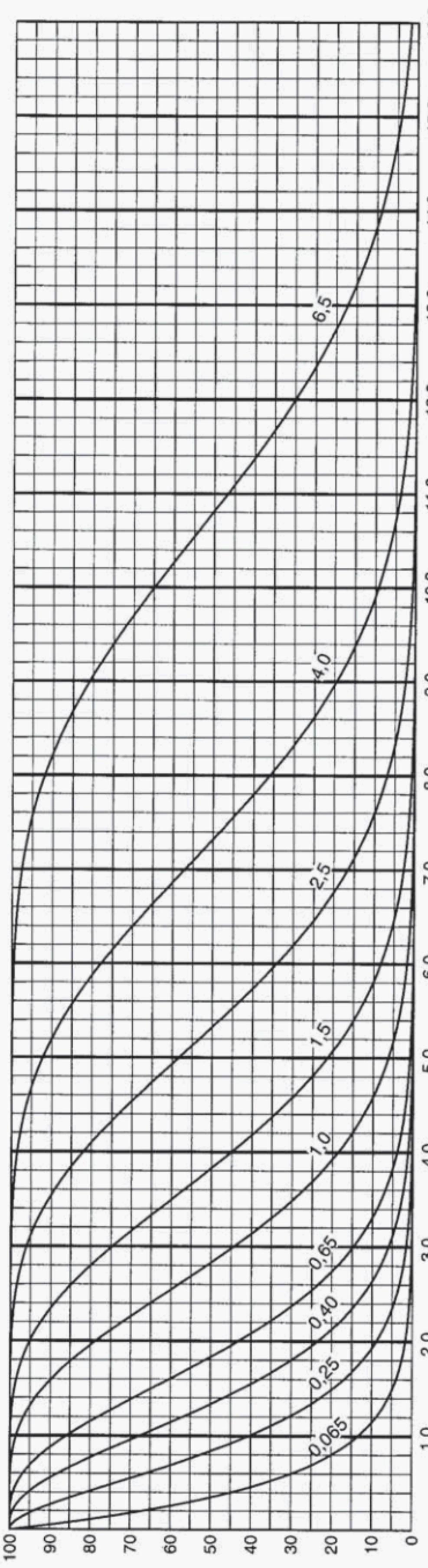
Table 10-L-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)														p (in percent nonconforming)									
	0,065	0,25	0,40	0,65	1,0	1,5	2,0	2,5	4,0	6,5	0,065	0,25	0,40	0,65	1,0	1,5	2,0	2,5	4,0	6,5				
Acceptance Quality Limit, normal inspection (in percent nonconforming)															p (in nonconformities per 100 items)									
99,0	0,00503	0,074	0,219	0,414	0,900	1,47	1,77	2,42	3,10	3,80	5,28	6,43	0,00503	0,074	0,218	0,412	0,893	1,45	1,75	2,39	3,05	3,74	5,17	6,29
95,0	0,0256	0,178	0,410	0,686	1,31	2,01	2,37	3,11	3,89	4,68	6,31	7,57	0,0256	0,178	0,409	0,683	1,31	1,99	2,35	3,08	3,84	4,62	6,22	7,45
90,0	0,0527	0,266	0,552	0,875	1,58	2,34	2,73	3,54	4,36	5,20	6,91	8,22	0,0527	0,266	0,551	0,872	1,58	2,33	2,72	3,51	4,32	5,15	6,84	8,12
75,0	0,144	0,481	0,864	1,27	2,11	2,99	3,43	4,33	5,23	6,15	8,00	9,40	0,144	0,481	0,864	1,27	2,11	2,98	3,42	4,31	5,21	6,12	7,95	9,34
50,0	0,346	0,838	1,33	1,83	2,83	3,83	4,33	5,33	6,32	7,32	9,32	10,8	0,347	0,839	1,34	1,84	2,84	3,83	4,33	5,33	6,33	7,33	9,33	10,8
25,0	0,691	1,34	1,95	2,54	3,69	4,81	5,36	6,46	7,55	8,63	10,8	12,4	0,693	1,35	1,96	2,55	3,71	4,84	5,40	6,51	7,61	8,70	10,9	12,5
10,0	1,14	1,93	2,64	3,31	4,59	5,82	6,42	7,60	8,76	9,91	12,2	13,8	1,15	1,94	2,66	3,34	4,64	5,89	6,50	7,70	8,89	10,1	12,4	14,1
5,0	1,49	2,35	3,11	3,83	5,18	6,47	7,10	8,33	9,54	10,7	13,1	14,8	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	2,28	3,27	4,14	4,93	6,42	7,82	8,50	9,82	11,1	12,4	14,8	16,6	2,30	3,32	4,20	5,02	6,55	8,00	8,70	10,1	11,4	12,7	15,3	17,2
	0,10	0,40	0,65	1,0	1,5	2,5	4,0	6,5	0,10	0,40	0,65	1,0	1,5	2,5	4,0	6,5	0,10	0,40	0,65	1,0	1,5	2,5	4,0	6,5

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-L — Tables for sample size code letter L (Individual plans)

Chart L Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

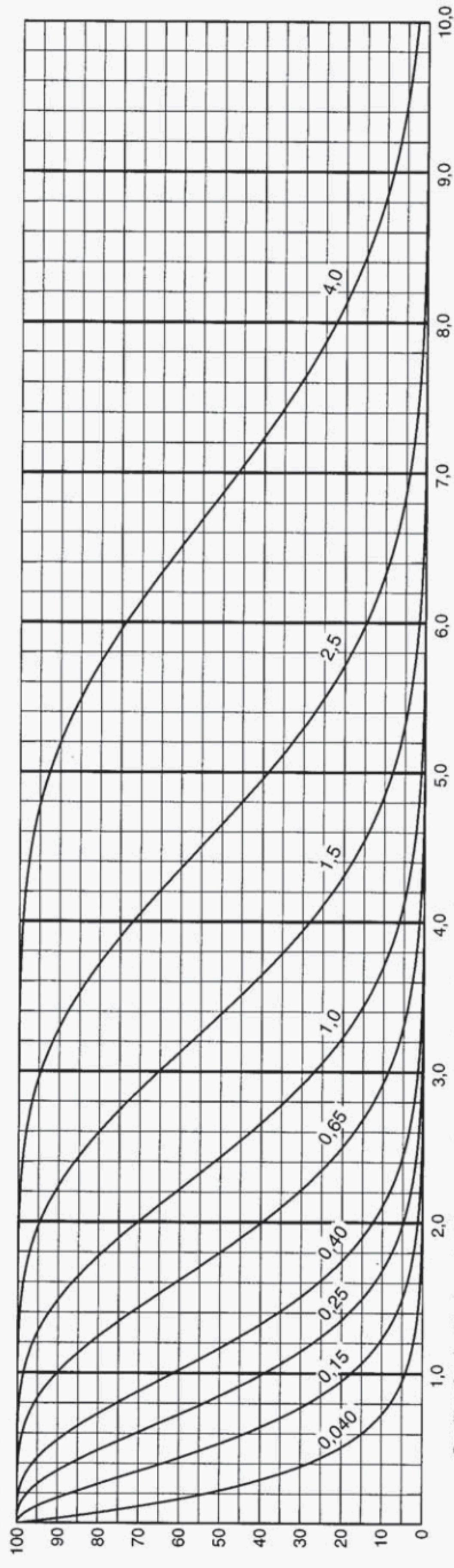
Table 10-L-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												
	0,065	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0	12,0	14,0	16,0
p (in percent nonconforming)													
99,0	0,00503	0,074	0,219	0,414	0,900	1,47	1,77	2,42	3,10	3,80	5,28	6,43	0,00503
95,0	0,0256	0,178	0,410	0,686	1,31	2,01	2,37	3,11	3,89	4,68	6,31	7,57	0,0256
90,0	0,0527	0,266	0,552	0,875	1,58	2,34	2,73	3,54	4,36	5,20	6,91	8,22	0,0527
75,0	0,144	0,481	0,864	1,27	2,11	2,99	3,43	4,33	5,23	6,15	8,00	9,40	0,144
50,0	0,346	0,838	1,33	1,83	2,83	3,83	4,33	5,33	6,32	7,32	9,32	10,8	0,347
25,0	0,691	1,34	1,95	2,54	3,69	4,81	5,36	6,46	7,55	8,63	10,8	12,4	0,693
10,0	1,14	1,93	2,64	3,31	4,59	5,82	6,42	7,60	8,76	9,91	12,2	13,8	1,15
5,0	1,49	2,35	3,11	3,83	5,18	6,47	7,10	8,33	9,54	10,7	13,1	14,8	1,50
1,0	2,28	3,27	4,14	4,93	6,42	7,82	8,50	9,82	11,1	12,4	14,8	16,6	2,30
	0,10	0,40	0,65	1,0	1,5	2,5	4,0	6,5	0,10	0,40	0,65	1,0	2,5

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

M**Table 10-M — Tables for sample size code letter M (Individual plans)**

Chart M Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Quality of submitted product in percent nonconforming or in nonconformities per 100 items
 Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

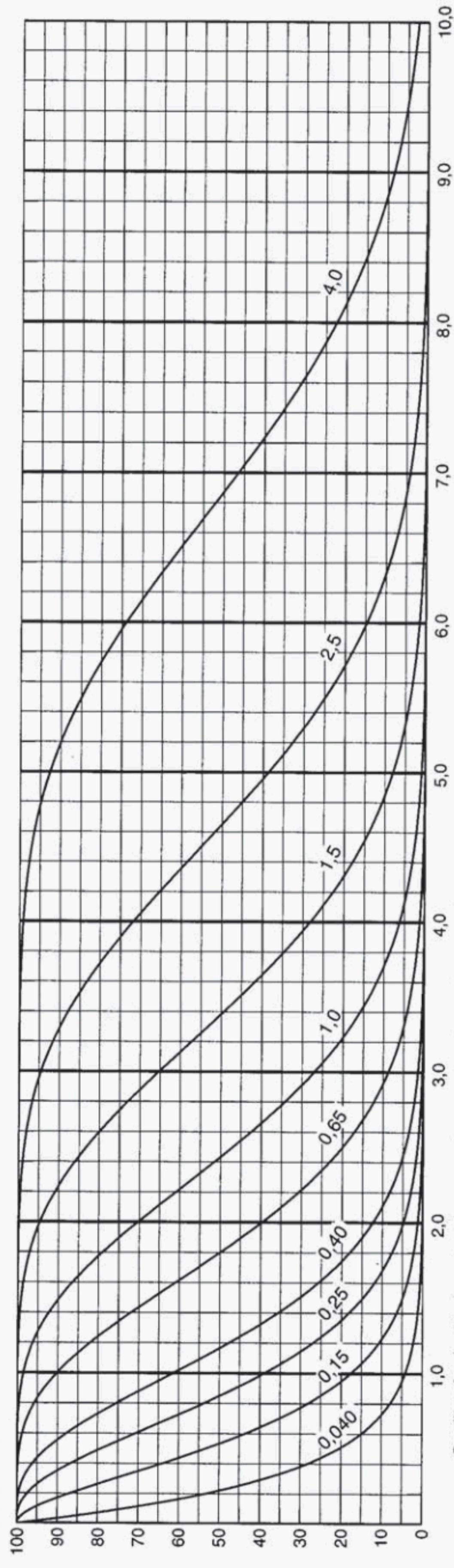
Table 10-M-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												p (in percent nonconforming)											
	0,040	0,15	0,25	0,40	0,65	1,0	1,5	2,0	2,5	4,0	0,040	0,15	0,25	0,40	0,65	1,0	1,5	2,0	2,5	4,0				
p (in percent nonconforming)													p (in nonconformities per 100 items)											
99,0	0,00319	0,047	0,139	0,262	0,570	0,929	1,12	1,53	1,95	2,40	3,33	4,05	0,00319	0,047	0,138	0,261	0,567	0,923	1,11	1,51	1,94	2,37	3,28	3,99
95,0	0,0163	0,113	0,260	0,435	0,833	1,27	1,50	1,97	2,46	2,96	3,99	4,78	0,0163	0,113	0,260	0,434	0,830	1,26	1,49	1,96	2,44	2,94	3,95	4,73
90,0	0,0334	0,169	0,350	0,555	1,00	1,48	1,73	2,24	2,76	3,29	4,37	5,20	0,0334	0,169	0,350	0,554	1,00	1,48	1,72	2,23	2,74	3,27	4,34	5,16
75,0	0,0913	0,305	0,549	0,805	1,34	1,89	2,17	2,74	3,32	3,90	5,07	5,95	0,0913	0,305	0,548	0,805	1,34	1,89	2,17	2,74	3,31	3,89	5,05	5,93
50,0	0,220	0,532	0,848	1,16	1,80	2,43	2,75	3,38	4,02	4,65	5,92	6,87	0,220	0,533	0,849	1,17	1,80	2,43	2,75	3,39	4,02	4,66	5,93	6,88
25,0	0,439	0,853	1,24	1,62	2,35	3,06	3,41	4,11	4,81	5,49	6,86	7,87	0,440	0,855	1,24	1,62	2,36	3,07	3,43	4,13	4,83	5,52	6,90	7,92
10,0	0,728	1,23	1,68	2,11	2,92	3,71	4,09	4,85	5,59	6,33	7,77	8,84	0,731	1,23	1,69	2,12	2,94	3,74	4,13	4,89	5,64	6,39	7,86	8,95
5,0	0,947	1,50	1,99	2,44	3,31	4,13	4,54	5,33	6,10	6,86	8,36	9,46	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	1,45	2,09	2,64	3,15	4,11	5,01	5,44	6,29	7,12	7,93	9,51	10,7	1,46	2,11	2,67	3,19	4,16	5,08	5,52	6,40	7,24	8,08	9,71	10,9
	0,065	0,25	0,40	0,65	1,0	1,5	2,5	4,0	4,0	4,0	4,0	4,0	0,065	0,25	0,40	0,65	1,0	1,5	2,5	4,0	4,0	4,0	4,0	

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.
 Acceptor Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

M**Table 10-M — Tables for sample size code letter M (Individual plans)**

Chart M Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Quality of submitted product in percent nonconforming or in nonconformities per 100 items
 Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

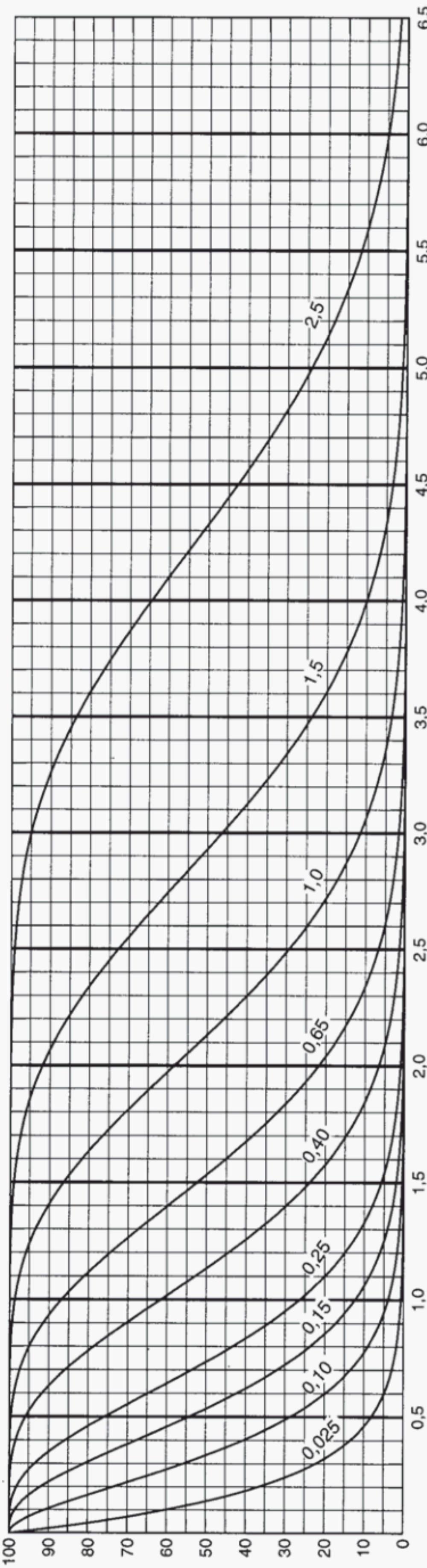
Table 10-M-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)											
	p (in nonconformities per 100 items)											
p (in percent nonconforming)												
	0,040	0,15	0,25	0,40	0,65	1,0	1,5	2,0	2,5	4,0	0,040	0,15
99,0	0,00319	0,047	0,139	0,262	0,570	0,929	1,12	1,53	1,95	2,40	3,33	4,05
95,0	0,0163	0,113	0,260	0,435	0,833	1,27	1,50	1,97	2,46	2,96	3,99	4,78
90,0	0,0334	0,169	0,350	0,555	1,00	1,48	1,73	2,24	2,76	3,29	4,37	5,20
75,0	0,0913	0,305	0,549	0,805	1,34	1,89	2,17	2,74	3,32	3,90	5,07	5,95
50,0	0,220	0,532	0,848	1,16	1,80	2,43	2,75	3,38	4,02	4,65	5,92	6,87
25,0	0,439	0,853	1,24	1,62	2,35	3,06	3,41	4,11	4,81	5,49	6,86	7,87
10,0	0,728	1,23	1,68	2,11	2,92	3,71	4,09	4,85	5,59	6,33	7,77	8,84
5,0	0,947	1,50	1,99	2,44	3,31	4,13	4,54	5,33	6,10	6,86	8,36	9,46
1,0	1,45	2,09	2,64	3,15	4,11	5,01	5,44	6,29	7,12	7,93	9,51	10,7
	0,065	0,25	0,40	0,65	1,0	1,5	2,5	4,0	4,0	0,065	0,25	0,40

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

N**Table 10-N — Tables for sample size code letter N (Individual plans)**

Chart N Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-N-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)										p (in nonconformities per 100 items)
	0,025	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	
99,0	0,00201	0,03	0,087	0,165	0,358	0,584	0,705	0,959	1,23	1,51	2,09
95,0	0,0103	0,071	0,164	0,274	0,524	0,799	0,942	1,24	1,54	1,86	2,50
90,0	0,0211	0,106	0,221	0,349	0,632	0,933	1,09	1,41	1,74	2,07	2,75
75,0	0,0575	0,192	0,346	0,507	0,845	1,19	1,37	1,73	2,09	2,45	3,19
50,0	0,139	0,335	0,534	0,734	1,13	1,53	1,73	2,13	2,53	3,73	4,33
25,0	0,277	0,538	0,783	1,02	1,48	1,93	2,15	2,60	3,03	3,47	4,33
10,0	0,459	0,776	1,06	1,33	1,85	2,34	2,59	3,06	3,54	4,00	4,92
5,0	0,597	0,945	1,25	1,54	2,09	2,61	2,87	3,37	3,86	4,34	5,29
1,0	0,917	1,32	1,67	1,99	2,60	3,17	3,45	3,99	4,51	5,03	6,78
	0,040	0,15	0,25	0,40	0,65	1,0	1,5	2,5	3,48	4,03	5,09

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

NOTE Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

Table 10-N-2—Sampling plans for sample size code letter N

↑ = use next preceding sample size code letter for which acceptance and rejection numbers are available

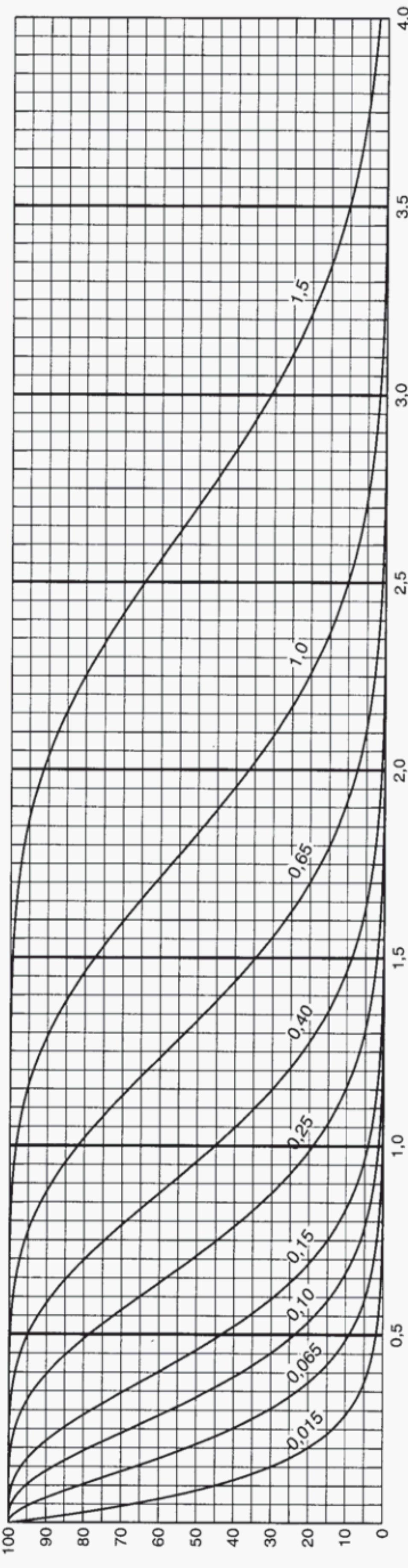
= use next subsequent sample size code letter for which acceptance and rejection numbers are available

A_{C} = Acceptance number

Re = Rejection number

- * = use single sampling plan above (or alternatively use code letter R)

= acceptance not permitted at this sample size

PPercent of lots
expected to be
accepted (P_a)**Table 10-P — Tables for sample size code letter P (Individual plans)****Chart P Operating characteristic curves for single sampling plans**
(Curves for double and multiple sampling are matched as closely as practicable)

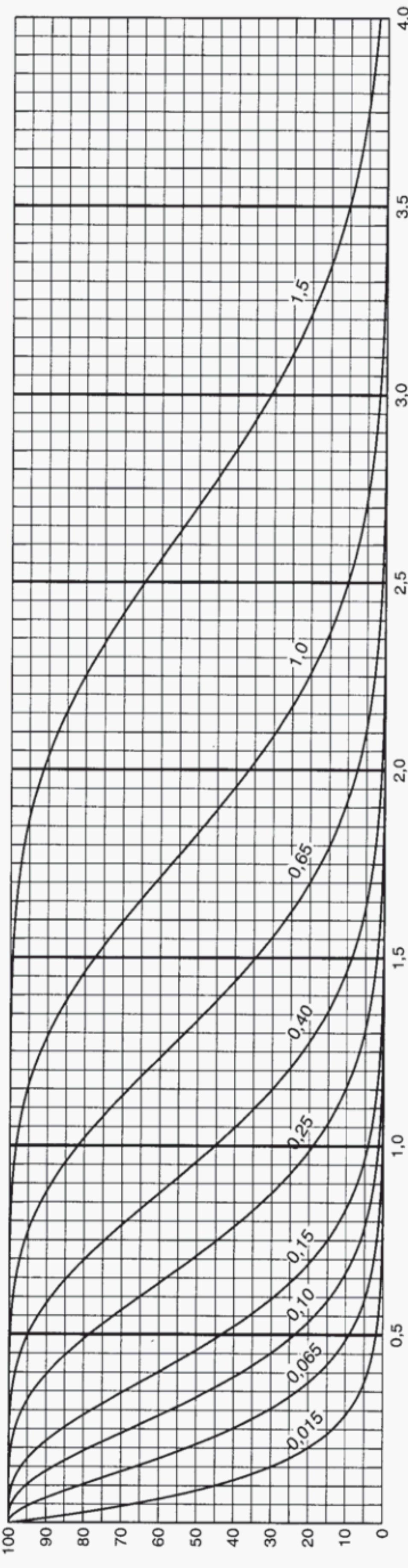
NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-P-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												p (in nonconformities per 100 items)
	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,0	3,0	4,0	
99,0	0,00126	0,0186	0,0546	0,103	0,224	0,364	0,440	0,598	0,765	0,938	1,30	1,58	0,00126
95,0	0,00641	0,0444	0,102	0,171	0,327	0,499	0,588	0,773	0,964	1,16	1,56	1,87	0,00641
90,0	0,0132	0,0665	0,138	0,218	0,394	0,583	0,680	0,879	1,08	1,29	1,71	2,04	0,0132
75,0	0,0360	0,120	0,216	0,317	0,528	0,745	0,855	1,08	1,30	1,53	1,99	2,34	0,0360
50,0	0,0866	0,210	0,334	0,459	0,708	0,958	1,08	1,33	1,58	1,83	2,33	2,71	0,0866
25,0	0,173	0,336	0,489	0,638	0,926	1,21	1,35	1,62	1,90	2,17	2,71	3,11	0,173
10,0	0,287	0,485	0,664	0,833	1,16	1,47	1,62	1,92	2,21	2,51	3,08	3,51	0,288
5,0	0,374	0,592	0,785	0,966	1,31	1,64	1,80	2,11	2,42	2,72	3,32	3,76	0,374
1,0	0,574	0,827	1,05	1,25	1,63	1,99	2,16	2,50	2,83	3,16	3,79	4,26	0,576
	0,025	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,0	2,5	3,0	3,5	0,025

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

PPercent of lots
expected to be
accepted (P_a)**Table 10-P — Tables for sample size code letter P (Individual plans)****Chart P Operating characteristic curves for single sampling plans**
(Curves for double and multiple sampling are matched as closely as practicable)

NOTE Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.

Table 10-P-1 — Tabulated values for operating characteristic curves for single sampling plans

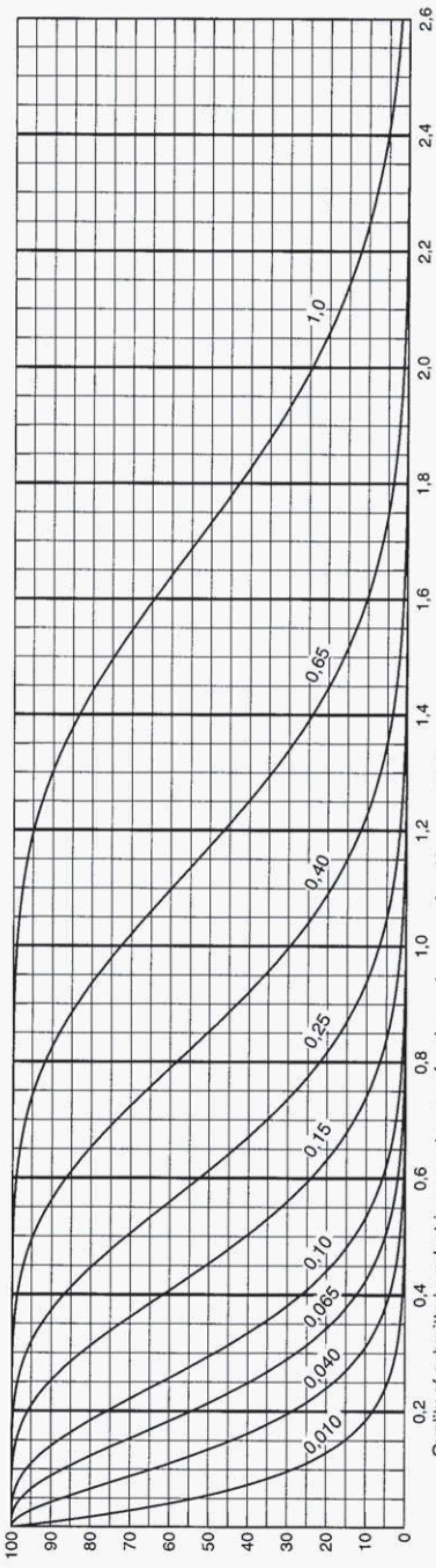
P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)												p (in nonconformities per 100 items)
	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,0	3,0	4,0	
99,0	0,00126	0,0186	0,0546	0,103	0,224	0,364	0,440	0,598	0,765	0,938	1,30	1,58	0,00126
95,0	0,00641	0,0444	0,102	0,171	0,327	0,499	0,588	0,773	0,964	1,16	1,56	1,87	0,00641
90,0	0,0132	0,0665	0,138	0,218	0,394	0,583	0,680	0,879	1,08	1,29	1,71	2,04	0,0132
75,0	0,0360	0,120	0,216	0,317	0,528	0,745	0,855	1,08	1,30	1,53	1,99	2,34	0,0360
50,0	0,0866	0,210	0,334	0,459	0,708	0,958	1,08	1,33	1,58	1,83	2,33	2,71	0,0866
25,0	0,173	0,336	0,489	0,638	0,926	1,21	1,35	1,62	1,90	2,17	2,71	3,11	0,173
10,0	0,287	0,485	0,664	0,833	1,16	1,47	1,62	1,92	2,21	2,51	3,08	3,51	0,288
5,0	0,374	0,592	0,785	0,966	1,31	1,64	1,80	2,11	2,42	2,72	3,32	3,76	0,374
1,0	0,574	0,827	1,05	1,25	1,63	1,99	2,16	2,50	2,83	3,16	3,79	4,26	0,576
	0,025	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,0	2,5	3,0	3,5	0,025

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Acceptance Quality Limit, tightened inspection (in percent nonconforming and nonconformities per 100 items)

Q**Table 10-Q — Tables for sample size code letter Q (Individual plans)**

Chart Q Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE

Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.
 Quality of submitted product in percent nonconforming or in nonconformities per 100 items.

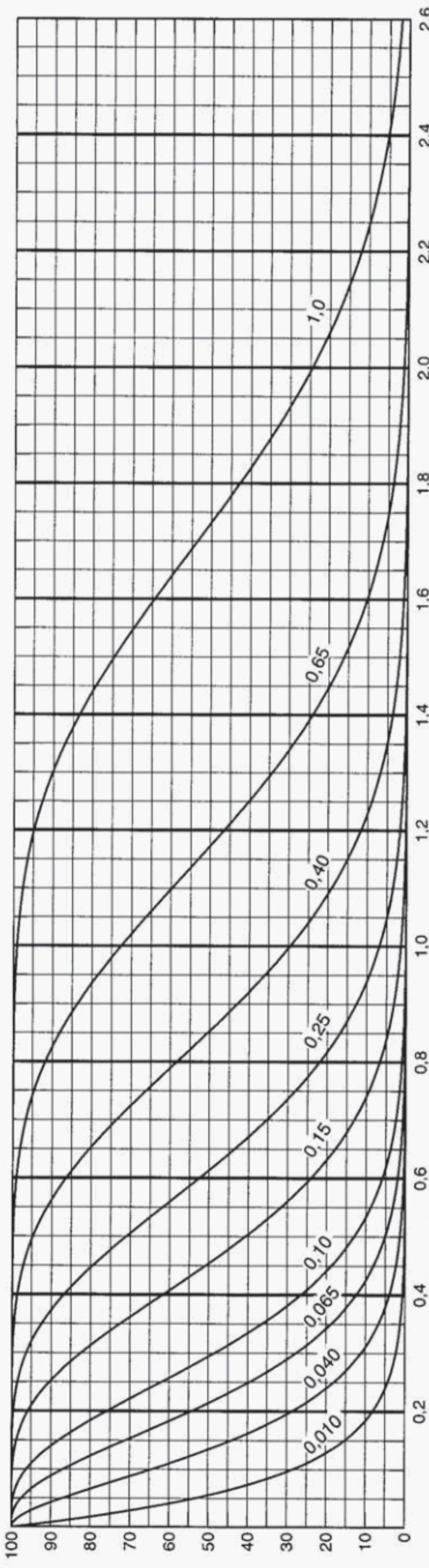
Table 10-Q-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)										p (in nonconformities per 100 items)													
	0,010	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,010		0,040	0,065	0,10	0,15	0,25	0,40	0,65						
99,0	0,0008	0,0119	0,0349	0,0659	0,143	0,233	0,281	0,383	0,489	0,600	0,830	1,01	0,0008	0,0119	0,0349	0,0659	0,143	0,281	0,488	0,598	0,828	1,01		
95,0	0,0041	0,0284	0,0654	0,109	0,209	0,319	0,376	0,494	0,616	0,741	0,998	1,19	0,00410	0,0284	0,0654	0,109	0,209	0,318	0,376	0,494	0,615	0,740	0,995	1,19
90,0	0,00843	0,0426	0,0882	0,140	0,252	0,373	0,435	0,562	0,693	0,825	1,10	1,30	0,00843	0,0425	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	0,477	0,547	0,690	0,834	0,980	1,27	1,50	0,0230	0,0769	0,138	0,203	0,338	0,476	0,547	0,690	0,834	0,979	1,27	1,49
50,0	0,0554	0,134	0,214	0,294	0,453	0,613	0,693	0,853	1,01	1,17	1,49	1,73	0,0555	0,134	0,214	0,294	0,454	0,614	0,694	0,853	1,01	1,17	1,49	1,73
25,0	0,111	0,215	0,313	0,408	0,593	0,774	0,863	1,04	1,22	1,39	1,74	1,99	0,111	0,215	0,314	0,409	0,594	0,775	0,864	1,04	1,22	1,39	1,74	2,00
10,0	0,184	0,311	0,425	0,534	0,741	0,940	1,04	1,23	1,42	1,61	1,98	2,25	0,184	0,311	0,426	0,534	0,742	0,942	1,04	1,23	1,42	1,61	1,98	2,25
5,0	0,239	0,379	0,503	0,619	0,839	1,05	1,15	1,35	1,55	1,75	2,13	2,41	0,240	0,380	0,504	0,620	0,841	1,05	1,15	1,36	1,56	1,75	2,14	2,42
1,0	0,368	0,530	0,671	0,801	1,05	1,28	1,39	1,61	1,82	2,03	2,43	2,73	0,368	0,531	0,672	0,804	1,05	1,28	1,39	1,61	1,83	2,04	2,45	2,75
	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,015	0,065	0,10	0,15	0,25	0,40	0,65	

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Q**Table 10-Q — Tables for sample size code letter Q (Individual plans)**

Chart Q Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE

Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.
 Quality of submitted product in percent nonconforming or in nonconformities per 100 items.

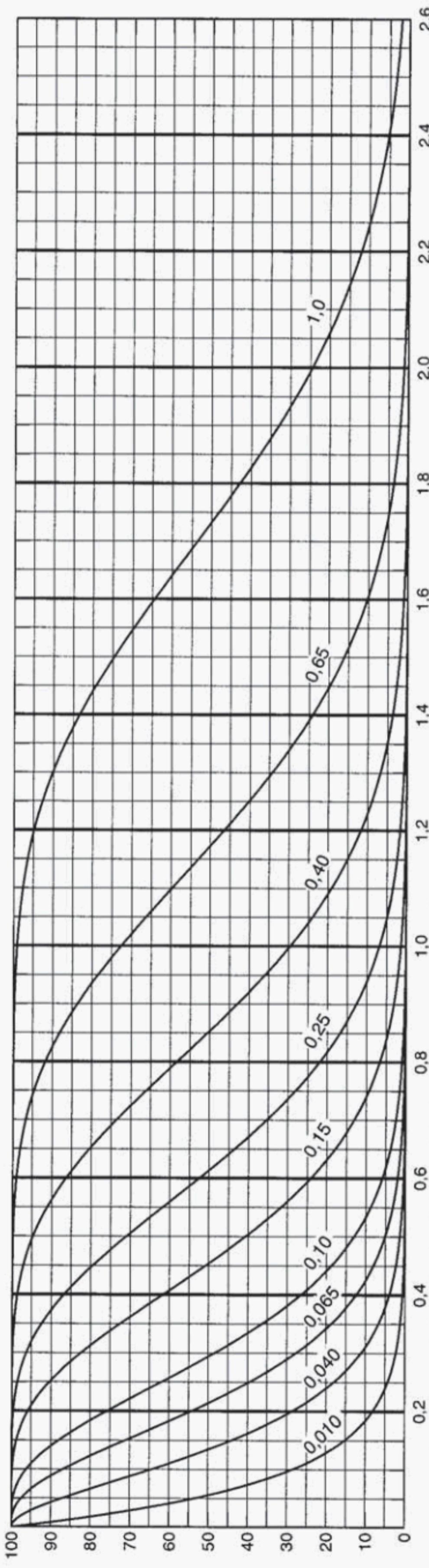
Table 10-Q-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)										p (in nonconformities per 100 items)													
	0,010	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,010		0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0					
99,0	0,0008	0,0119	0,0349	0,0659	0,143	0,233	0,281	0,383	0,489	0,600	0,830	1,01	0,0008	0,0119	0,0349	0,0659	0,143	0,232	0,281	0,488	0,598	0,828	1,01	
95,0	0,0041	0,0284	0,0654	0,109	0,209	0,319	0,376	0,494	0,616	0,741	0,998	1,19	0,00410	0,0284	0,0654	0,109	0,209	0,318	0,376	0,494	0,615	0,740	0,995	1,19
90,0	0,00843	0,0426	0,0882	0,140	0,252	0,373	0,435	0,562	0,693	0,825	1,10	1,30	0,00843	0,0425	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	0,477	0,547	0,690	0,834	0,980	1,27	1,50	0,0230	0,0769	0,138	0,203	0,338	0,476	0,547	0,690	0,834	0,979	1,27	1,49
50,0	0,0554	0,134	0,214	0,294	0,453	0,613	0,693	0,853	1,01	1,17	1,49	1,73	0,0555	0,134	0,214	0,294	0,454	0,614	0,694	0,853	1,01	1,17	1,49	1,73
25,0	0,111	0,215	0,313	0,408	0,593	0,774	0,863	1,04	1,22	1,39	1,74	1,99	0,111	0,215	0,314	0,409	0,594	0,775	0,864	1,04	1,22	1,39	1,74	2,00
10,0	0,184	0,311	0,425	0,534	0,741	0,940	1,04	1,23	1,42	1,61	1,98	2,25	0,184	0,311	0,426	0,534	0,742	0,942	1,04	1,23	1,42	1,61	1,98	2,25
5,0	0,239	0,379	0,503	0,619	0,839	1,05	1,15	1,35	1,55	1,75	2,13	2,41	0,240	0,380	0,504	0,620	0,841	1,05	1,15	1,36	1,56	1,75	2,14	2,42
1,0	0,368	0,530	0,671	0,801	1,05	1,28	1,39	1,61	1,82	2,03	2,43	2,73	0,368	0,531	0,672	0,804	1,05	1,28	1,39	1,61	1,83	2,04	2,45	2,75
	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,015	0,065	0,10	0,15	0,25	0,40	0,65	

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Q**Table 10-Q — Tables for sample size code letter Q (Individual plans)**

Chart Q Operating characteristic curves for single sampling plans
 (Curves for double and multiple sampling are matched as closely as practicable)



NOTE

Values on curves are Acceptance Quality Limits (AQLs) for normal inspection.
 Quality of submitted product in percent nonconforming or in nonconformities per 100 items.

Table 10-Q-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptance Quality Limit, normal inspection (in percent nonconforming and nonconformities per 100 items)										p (in nonconformities per 100 items)													
	0,010	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,010		0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0					
99,0	0,0008	0,0119	0,0349	0,0659	0,143	0,233	0,281	0,383	0,489	0,600	0,830	1,01	0,0008	0,0119	0,0349	0,0659	0,143	0,232	0,281	0,488	0,598	0,828	1,01	
95,0	0,0041	0,0284	0,0654	0,109	0,209	0,319	0,376	0,494	0,616	0,741	0,998	1,19	0,00410	0,0284	0,0654	0,109	0,209	0,318	0,376	0,494	0,615	0,740	0,995	1,19
90,0	0,00843	0,0426	0,0882	0,140	0,252	0,373	0,435	0,562	0,693	0,825	1,10	1,30	0,00843	0,0425	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	0,477	0,547	0,690	0,834	0,980	1,27	1,50	0,0230	0,0769	0,138	0,203	0,338	0,476	0,547	0,690	0,834	0,979	1,27	1,49
50,0	0,0554	0,134	0,214	0,294	0,453	0,613	0,693	0,853	1,01	1,17	1,49	1,73	0,0555	0,134	0,214	0,294	0,454	0,614	0,694	0,853	1,01	1,17	1,49	1,73
25,0	0,111	0,215	0,313	0,408	0,593	0,774	0,863	1,04	1,22	1,39	1,74	1,99	0,111	0,215	0,314	0,409	0,594	0,775	0,864	1,04	1,22	1,39	1,74	2,00
10,0	0,184	0,311	0,425	0,534	0,741	0,940	1,04	1,23	1,42	1,61	1,98	2,25	0,184	0,311	0,426	0,534	0,742	0,942	1,04	1,23	1,42	1,61	1,98	2,25
5,0	0,239	0,379	0,503	0,619	0,839	1,05	1,15	1,35	1,55	1,75	2,13	2,41	0,240	0,380	0,504	0,620	0,841	1,05	1,15	1,36	1,56	1,75	2,14	2,42
1,0	0,368	0,530	0,671	0,801	1,05	1,28	1,39	1,61	1,82	2,03	2,43	2,73	0,368	0,531	0,672	0,804	1,05	1,28	1,39	1,61	1,83	2,04	2,45	2,75
	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,015	0,065	0,10	0,15	0,25	0,40	0,65	1,0	0,015	0,065	0,10	0,15	0,25	0,40	0,65	

NOTE Binomial distribution used for entries corresponding to inspection for nonconforming items, Poisson for inspection for number of nonconformities.

Table 10-R-2—Sampling plans for sample size code letter R

↑ = use next preceding sample size code letter for which acceptance and rejection numbers are available

Ac = Acceptance number

$\text{Re} = \frac{\rho U L}{\mu}$

- # = acceptance not permitted at this sample size
- = use single sampling plan above



Table 10-R-2—Sampling plans for sample size code letter R

↑ = use next preceding sample size code letter for which acceptance and rejection numbers are available

A_C = Acceptance number

Re = Rejection number

- # = acceptance not permitted at this sample size
- = use single sampling plan above

Table 11-A — Single sampling plans for normal inspection (Auxiliary master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (normal inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
A	2																											
B	3																											
C	5																											
D	8																											
E	13																											
F	20																											
G	32																											
H	50																											
J	80																											
K	125																											
L	200																											
M	315																											
N	500																											
P	800																											
Q	1 250	0	1	1/3	1/2	1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22							
R	2 000	1/3	1/2	1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22									

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

Table 11-B — Single sampling plans for tightened inspection (Auxiliary master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (tightened inspection)																								
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
A	2																									
B	3																									
C	5																									
D	8																									
E	13																									
F	20																									
G	32																									
H	50																									
J	80																									
K	125																									
L	200																									
M	315																									
N	500																									
P	800																									
Q	1 250																									
R	2 000	0	1	1/3	1/2	1	2	2	3	3	4	5	6	8	9	12	13	18	19	21	22	23	24	25	26	27

▼ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

▲ = Use the first sampling plan above the arrow.

Ac = Acceptance number

Re = Rejection number

Table 11-C — Single sampling plans for reduced inspection (Auxiliary master table)

Sample size code letter	Sample size	Acceptance quality limit, AQL, in percent nonconforming items and nonconformities per 100 items (reduced inspection)																										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000	
Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
A	2																											
B	2																											
C	2																											
D	3																											
E	5																											
F	8																											
G	13																											
H	50																											
J	32																											
K	50																											
L	80																											
M	125																											
N	200																											
P	315																											
Q	500	0	1	1/5	1/3	1/2	1	2	2	3	3	4	4	5	6	7	8	9	10	11								
R	800	1/5	1/3	1/2	1	2	2	3	3	4	4	5	6	7	8	9	10	11										

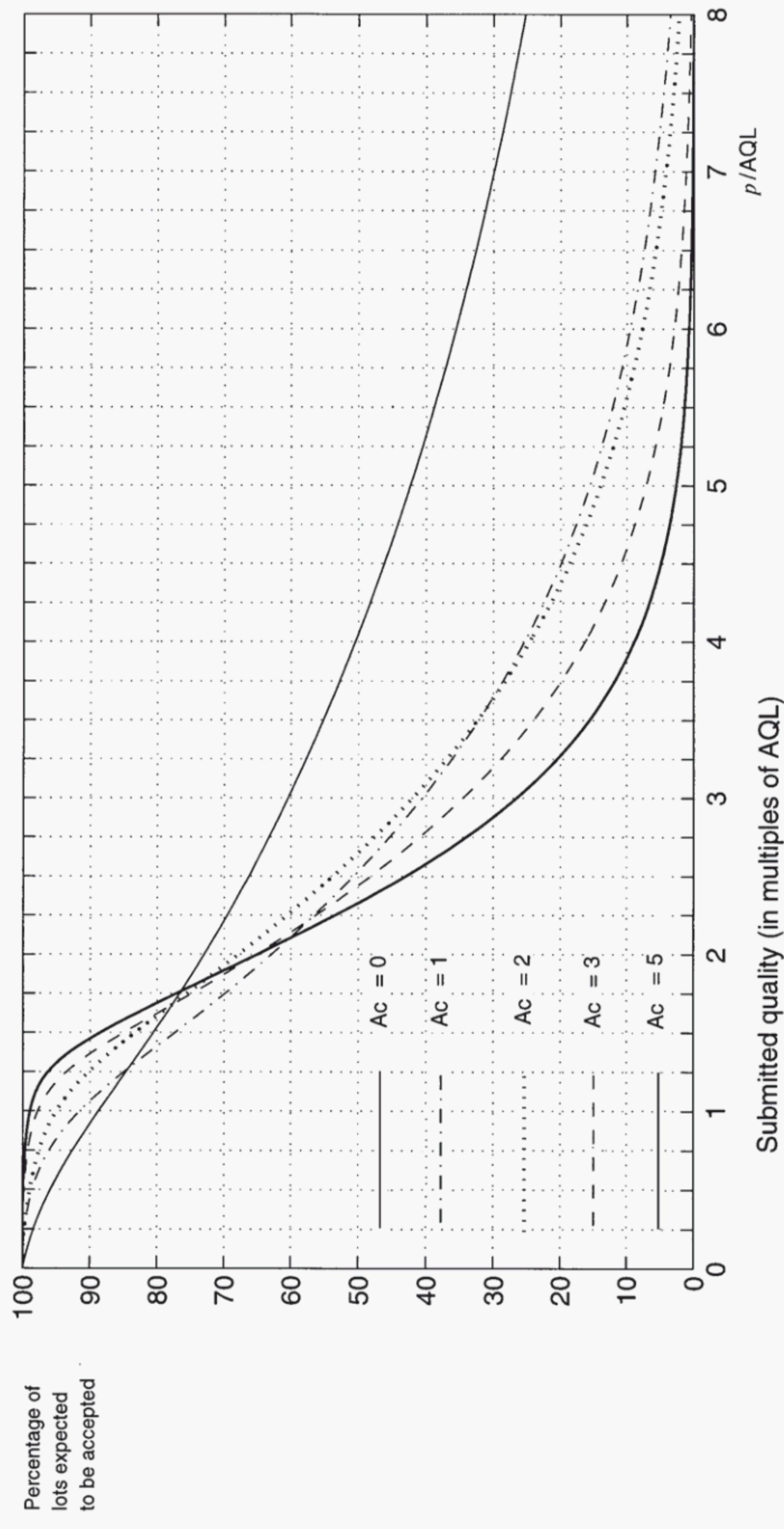
↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 % inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number

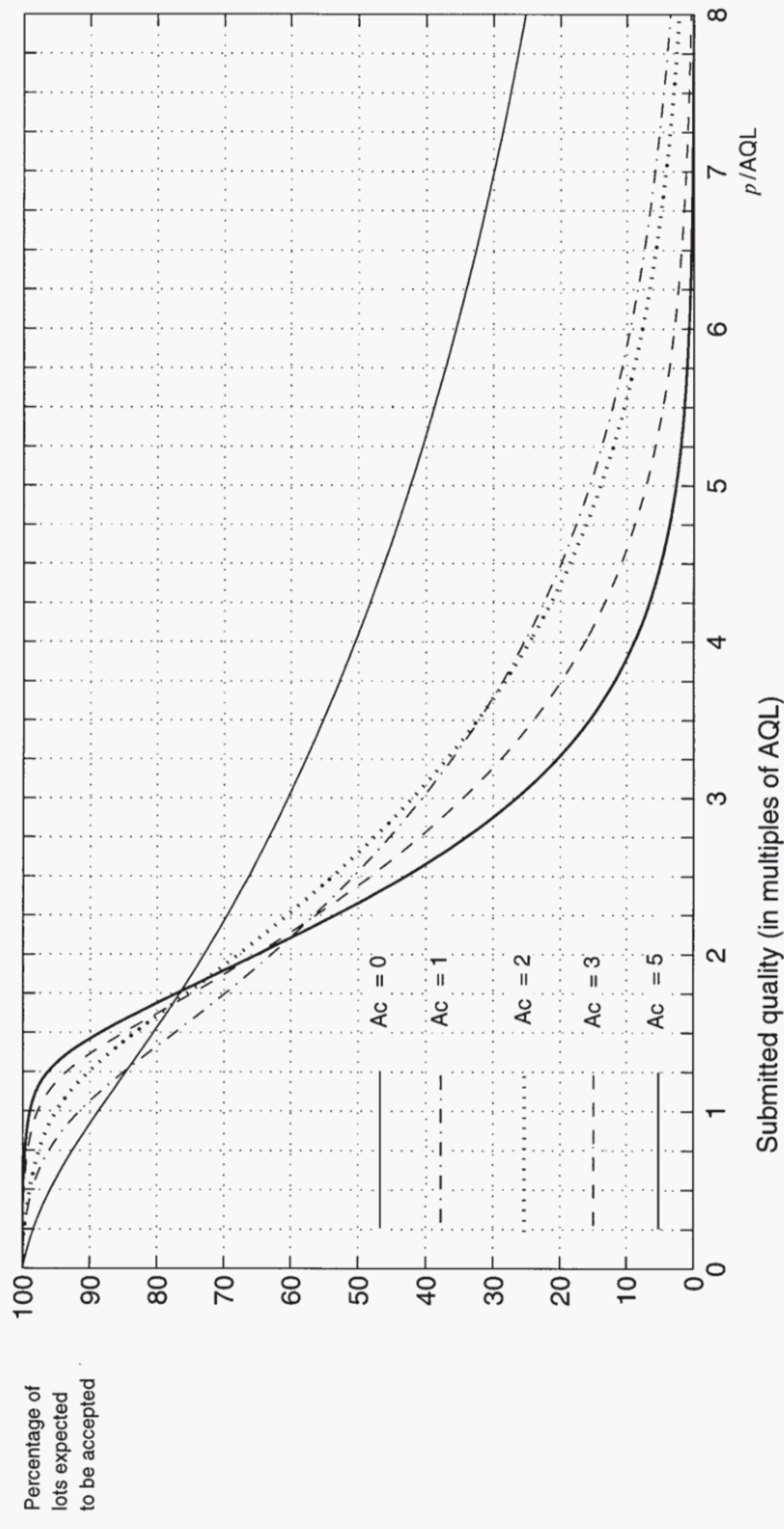
Re = Rejection number

Table 12 — Scheme OC curves (Normalized)



NOTE Ac at each curve denotes the acceptance number for normal inspection.

Table 12 — Scheme OC curves (Normalized)



NOTE Ac at each curve denotes the acceptance number for normal inspection.

Annex A (informative)

Example for non-constant sampling plan

Lot number	Lot size N	Sample size code letter	Sample size n	Given Ac	Acceptance score (before inspection)	Applicable Ac	Nonconforming items d	Acceptability	Acceptance score (after inspection)	Switching score	Future action
1	180	G	32	1/2	5	0	0	A	5	2	Continue normal
2	200	G	32	1/2	10	1	1	A	0	4	Continue normal
3	250	G	32	1/2	5	0	1	R	0	0	Continue normal
4	450	H	50	1	7	1	1	A	0	2	Continue normal
5	300	H	50	1	7	1	1	A	0	4	Continue normal
6	80	E	13	0	0	0	1	R	0	0	Switch to tightened
7	800	J	80	1	7	1	1	A	0	—	Continue tightened
8	300	H	50	1/2	5	0	0	A	5	—	Continue tightened
9	100	F	20	0	5	0	0	A	5	—	Continue tightened
10	600	J	80	1	12	1	0	A	12	—	Continue tightened
11	200	G	32	1/3	15	1	1	A	0*	—	Restore normal
12	250	G	32	1/2	5	0	0	A	5	2	Continue normal
13	600	J	80	2	12	2	1	A	0	5	Continue normal
14	80	E	13	0	0	0	0	A	0	7	Continue normal
15	200	G	32	1/2	5	0	0	A	5	9	Continue normal
16	500	H	50	1	12	1	0	A	12	11	Continue normal
17	100	F	20	1/3	15	1	0	A	15	13	Continue normal
18	120	F	20	1/3	18	1	0	A	18	15	Continue normal
19	85	E	13	0	18	0	0	A	18	17	Continue normal
20	300	H	50	1	25	1	1	A	0	19	Continue normal
21	500	H	50	1	7	1	0	A	7	21	Continue normal
22	700	J	80	2	14	2	1	A	0	24	Continue normal
23	600	J	80	2	7	2	0	A	7	27	Continue normal
24	550	J	80	2	14	2	0	A	0*	30	Switch to reduced
25	400	H	20	1/2	5	0	0	A	5	—	Continue reduced

NOTES: A = acceptable R = not acceptable

* denotes the acceptance score after switching

Bibliography

- [1] ISO 2859-0:1995, *Sampling procedures for inspection by attributes — Part 0: Introduction to the ISO 2859 attribute sampling system.*
- [2] ISO 2859-2:1985, *Sampling procedures for inspection by attributes — Part 2: Sampling plans indexed by limiting quality (LQ) for isolated lot inspection.*
- [3] ISO 3951, *Sampling procedures and charts for inspection by variables for percent nonconforming.*
- [4] ISO 8402, *Quality management and quality assurance — Vocabulary.*

NOTES

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