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Sampling procedures for inspection by attributes —

Part 1 :

Sampling plans indexed by acceptable quality level
(AQL) for lot-by-lot inspection

Règles d'échantillonnage pour les contrôles par attributs —

*Partie 1 : Plans d'échantillonnage pour les contrôles lot par lot, indexés d'après le
niveau de qualité acceptable (NQA)*



Reference number
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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 2859-1 was prepared by Technical Committee ISO/TC 69, *Applications of statistical methods*.

This first edition of ISO 2859-1 cancels and replaces ISO 2859 : 1974 of which it constitutes a technical revision.

ISO 2859 will consist of the following parts, under the general title *Sampling procedures for inspection by attributes* :

- *Part 0 : Introduction to the ISO 2859 attribute sampling system*
- *Part 1 : Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection*
- *Part 2 : Sampling plans indexed by limiting quality (LQ) for isolated lot inspection*
- *Part 3 : Skip lot sampling procedures*

Annex A of this part of ISO 2859 is for information only.

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Sampling procedures for inspection by attributes —

Part 1:

Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection

TECHNICAL CORRIGENDUM 1

Règles d'échantillonnage pour les contrôles par attributs —

Partie 1: Plans d'échantillonnage pour les contrôles lot par lot, indexés d'après le niveau de qualité acceptable (NQA)

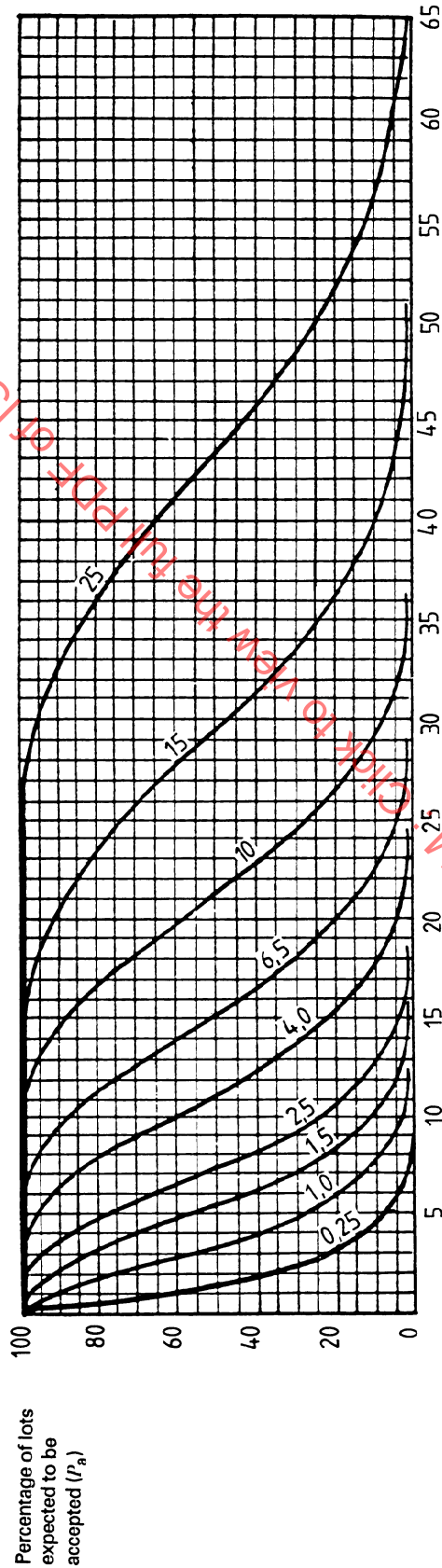
RECTIFICATIF TECHNIQUE 1

Technical corrigendum 1 to International Standard ISO 2859-1:1989 was prepared by Technical Committee ISO/TC 69, *Applications of statistical methods*, Sub-Committee SC 5, *Acceptance sampling*.

Page 48

Chart H should be replaced with the corrected version enclosed. The curve furthest to the left has been renumbered as "0,25". The numbers on the horizontal axis have been moved one place to the right.

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



Sampling procedures for inspection by attributes —

Part 1:

Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection

1 Scope

This part of ISO 2859 specifies sampling plans and procedures for inspection by attributes of discrete items. It is indexed in terms of the Acceptable Quality Level (AQL).

Its purpose is to induce a supplier through the economic and psychological pressure of lot non-acceptance to maintain a process average at least as good as the specified AQL, while at the same time providing an upper limit for the risk to the consumer of accepting the occasional poor lot.

This part of ISO 2859 is not intended as a procedure for estimating lot quality or for segregating lots.

Sampling plans designated in this part of ISO 2859 are applicable, but not limited, to inspection of

- a) end items;
- b) components and raw materials;
- c) operations;
- d) materials in process;
- e) supplies in storage;
- f) maintenance operations;
- g) data or records;
- h) administrative procedures.

These plans are intended primarily to be used for a continuing series of lots sufficient to allow the switching rules to be applied, which provide for

- an automatic protection to the consumer, should a deterioration in quality be detected (by a switch to tightened inspection or discontinuance of inspection);
- an incentive to reduce inspection costs (at the discretion of the responsible authority) should consistently good quality be achieved (by a switch to reduced inspection).

These plans may also be used for the inspection of lots in isolation but, in this case, the user is strongly advised to consult the operating characteristic curves to find a plan which will yield the desired protection (see 12.6). In that case, the user is also referred to the sampling plans indexed by limiting quality (LQ) given in ISO 2859-2.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this part of ISO 2859. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this part of ISO 2859 are encouraged to investigate the possibility of applying the most recent editions of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 3534 : 1977, *Statistics — Vocabulary and symbols*.

3 Terminology and definitions

The terminology and definitions used in this International Standard are in accordance with ISO 3534.

3.1 defect: A departure of a quality characteristic that results in a product, process or service not satisfying its intended normal usage requirements.

3.2 nonconformity: A departure of a quality characteristic that results in a product, process or service not meeting a specified requirement. Nonconformities will generally be classified by their degree of seriousness such as:

Class A — Those nonconformities of a type considered to be of the highest concern for the product or service. In acceptance sampling, such types of nonconformity will be assigned very small AQL values.

Class B — Those nonconformities of a type considered to have the next lower degree of concern. Therefore these can be assigned a larger AQL value than those in class A and smaller than in class C, if a third class exists, etc.

NOTES

- 1 The term defect is reserved for nonconformities that result in a product or service not satisfying its intended usage requirements.
- 2 The user is cautioned that adding characteristics and classes of nonconformities will generally affect the overall probability of acceptance of the product.
- 3 The number of classes, the assignment into a class, and the choice of AQL for each class, should be appropriate to the quality requirements of the specific situation.

3.3 nonconforming unit: A unit of product or service containing at least one nonconformity. Nonconforming units will generally be classified by their degree of seriousness such as :

Class A — A unit which contains one or more nonconformities of class A and may also contain nonconformities of class B and/or class C.

Class B — A unit which contains one or more nonconformities of class B and may also contain nonconformities of class C, but contains no nonconformity of class A.

3.4 percent nonconforming: The percent nonconforming of any given quantity of units of product is 100 times the number of nonconforming units divided by the total number of units of product, i.e.

$$\text{Percent nonconforming} = \frac{\text{Number of nonconforming units}}{\text{Total number of units}} \times 100$$

NOTE — Sampling plans for inspection by attributes are given in terms of the percentage or proportion of units of product in a lot or batch that depart from some requirement, or the number of such departures. Throughout this part of ISO 2859 the terms "percent nonconforming units" (3.4) or "numbers of nonconformities per 100 units" (3.5) are used since these terms are likely to constitute the most widely used criteria for sampling.

3.5 nonconformities per 100 units: The number of nonconformities per 100 units of any given quantity or units of product is 100 times the number of nonconformities contained therein (one or more nonconformities being possible in any unit of product) divided by the total number of units of product, i.e.

$$\text{Nonconformities per 100 units} = \frac{\text{Number of nonconformities}}{\text{Total number of units}} \times 100$$

3.6 acceptable quality level (AQL): When a continuous series of lots is considered, the quality level which for the purposes of sampling inspection is the limit of a satisfactory process average. (See clause 5.)

3.7 sampling plan: A specific plan which indicates the number of units of product from each lot which are to be inspected (sample size or series of sample sizes) and the associated criteria for determining the acceptability of the lot (acceptance and rejection numbers).

NOTE — For the purposes of this part of ISO 2859, a distinction should be made between the terms *sampling plan* (3.7), *sampling scheme* (3.8) and *sampling system* (3.9).

3.8 sampling scheme: A combination of sampling plans with switching procedures (see 9.3).

3.9 sampling system: A collection of sampling plans or schemes. 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.

3.10 responsible authority: A generic term 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.

NOTES

- 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.
- 2 The duties and functions of a responsible authority are outlined in this part of ISO 2859 (see 5.2, 6.2, clause 7, 9.1, 9.3.3, 9.4, 10.1, 10.3).

3.11 inspection: The process of measuring, examining, testing, gauging or otherwise comparing the unit of product (see 3.14) with the applicable requirements.

3.12 original inspection: The first inspection of a particular quality of product as distinguished from the inspection of product which has been resubmitted after prior non-acceptance.

3.13 inspection by attributes: Inspection whereby either the unit of product is classified simply as conforming or nonconforming, or the number of nonconformities in the unit of product is counted, with respect to a given requirement or set of requirements.

3.14 unit of product: The item inspected in order to determine its classification as conforming or nonconforming or to count the number of nonconformities. It may be a single article, a pair, a set, a length, an area, an operation or a volume. It may be a component of an end product or the end product itself. The unit of product may or may not be the same as the unit of purchase, supply, production, or shipment.

3.15 lot: A collection of units of product from which a sample shall be drawn and inspected to determine conformance with the acceptability criteria, and which may differ from a collection of units designated as a lot for other purposes (for example, production, shipment, etc.) (see clause 6).

NOTE — The term "batch" is sometimes used.

3.16 lot size: The number of units of product in a lot.

3.17 sample: A sample consists of one or more units of product drawn from a lot, the units of the sample being selected at random without regard to their quality. The number of units of product in the sample is the sample size.

3.18 limiting quality (LQ): When a lot is considered in isolation, a quality level which, for the purposes of sampling inspection, is limited to a low probability of acceptance.

NOTE — For a particular sampling system (see ISO 2859-2), the probability of acceptance will lie within a defined range.

4 Expression of nonconformity

The extent of nonconformity shall be expressed either in terms of percent nonconforming (see 3.4) or in terms of nonconformities per 100 units (see 3.5). The tables assume that nonconformities occur randomly and with statistical independence. There may be good reasons for suspecting that one nonconformity could be caused by a condition also likely to cause others. If so, it may be better to consider the units just as conforming or not and ignore multiple nonconformities.

5 Acceptable quality level (AQL)

5.1 Use and application

The AQL, together with the sample size code letter (see 10.2), is used for indexing the sampling plans and schemes provided in this part of ISO 2859.

When a specific value of the AQL is designated for a certain nonconformity or group of nonconformities, it indicates that the sampling scheme will accept the great majority of the lots submitted, provided the quality level (percent nonconforming or nonconformities per 100 units) in these lots is no greater than the designated value of AQL. Thus, the AQL is a designated value of percent nonconforming (or nonconformities per 100 units) that will be accepted most of the time by the sampling scheme to be used. The sampling plans provided are so arranged that the probability of acceptance at the designated AQL value depends upon the sample size for a given AQL, being generally higher for large samples than for small ones.

The AQL is a parameter of the sampling scheme and should not be confused with the process average which describes the operating level of the manufacturing process. It is expected that the process average will be less than or equal to the AQL to avoid excessive rejections under this system.

CAUTION — The designation of an AQL shall not imply that the supplier has the right knowingly to supply any nonconforming unit of product.

5.2 Specifying AQLs

The AQL to be used shall be designated in the contract or by, or according to, the responsible authority. Different AQLs may be designated for groups of nonconformities considered collectively or for individual nonconformities as defined in 3.2. The classification into groups should be appropriate to the quality requirements of the specific situation. An AQL for a group of nonconformities may be designated in addition to AQLs for individual nonconformities, or subgroups, within that group.

AQL values of 10 or less may be expressed either in percent nonconforming or in nonconformities per 100 units; those over 10 shall be expressed in nonconformities per 100 units only.

5.3 Preferred AQLs

The values of AQLs given in the tables are known as preferred AQLs. If, for any product, an AQL is designated other than a preferred AQL, these tables are not applicable.

6 Submission of product for sampling

6.1 Formation of lots

The product shall be assembled into identifiable lots, sub-lots, or in such other manner as may be laid down (see 6.2). Each lot shall, as far as is practicable, consist of units of product of a single type, grade, class, size and composition, manufactured under essentially the same conditions and at essentially the same time.

6.2 Presentation of lots

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

7 Acceptance and non-acceptance

7.1 Acceptability of lots

Acceptability of a lot shall be determined by the use of a sampling plan or plans associated with the designated AQL or AQLs.

The term "non-acceptance" is used in this context for "rejection" when it refers to the result of following the procedure. Forms of the term "reject" are retained when they refer to actions the consumer may take, as in "rejection number."

The responsible authority shall decide how lots which are not accepted will be disposed of. Such lots may be scrapped, sorted (with or without nonconforming units being replaced), reworked, re-evaluated against more specific usability criteria, held for additional information, etc.

7.2 Nonconforming units

The right is reserved to reject any unit of product found nonconforming during inspection whether that unit of product forms a part of a sample or not, and even if the lot as a whole is accepted. Rejected units may be repaired or corrected, and resubmitted for inspection with the approval of, and in the manner specified by, the responsible authority.

7.3 Special reservation for designated nonconformities

Since most acceptance sampling involves evaluation of more than one quality characteristic and since these may differ in importance in terms of quality and/or economic effects, it is often desirable to classify the types of nonconformity according to agreed classes as defined in 3.2. Specific assignment of types of nonconformities to each class depends on agreement on specific sampling applications. In general, the function of such classification is to permit the use of a set of sampling plans having a common sample size, but different acceptance numbers, for each class having a different AQL, such as in tables II, III and IV.

At the discretion of the responsible authority, every unit of the lot may be required to be inspected for designated classes of nonconformities. The right is reserved to inspect every unit submitted for designated nonconformities and to reject the lot immediately a nonconformity of this class is found. The right is also reserved to sample, for specified classes of nonconformities, every lot submitted by the supplier and to reject any lot if a sample drawn from it is found to contain one or more of these nonconformities.

7.4 Resubmitted lots

All parties shall be immediately notified if a lot is found unacceptable. Such lots shall not be resubmitted for reinspection until all units are re-examined or retested and the supplier is satisfied that all nonconforming units have been removed or nonconformities corrected. The responsible authority shall determine whether normal or tightened inspection shall be used on reinspection and whether reinspection shall include all types or classes of nonconformities or only the particular types or classes of nonconformities which caused initial rejection.

8 Drawing of samples

8.1 Representative or stratified sampling

When appropriate, the number of units in the sample shall be selected in proportion to the size of sub-lots or strata of the lot, identified by some rational criterion. When stratified sampling is used, the units from each stratum of the lot shall be selected at random.

8.2 Time for drawing the samples

Samples may be drawn after all the units comprising the lot have been assembled, or during production of the lot. In either case, the samples shall be selected at random.

8.3 Double or multiple sampling

When double or multiple sampling is to be used, each sample shall be selected from the entire 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 change. The switching procedures shall be applied to each class of nonconformities or nonconforming units 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 put into operation when two out of five or less 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 reverted to when five consecutive lots have been considered acceptable on original inspection.

9.3.3 Normal to reduced

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

- the preceding 10 lots (or more, as indicated by the note to table VIII) have been submitted to normal inspection and all have been accepted on original inspection; and
- the total number of nonconforming units (or nonconformities) in the samples from the preceding 10 lots [or such other number as was used for condition a) above] is equal to or less than the applicable limit number given in table VIII. If a double or multiple sample is in use, all samples inspected should be included, not "first" samples only; and
- production is at a steady rate; and
- reduced inspection is considered desirable by the responsible authority.

9.3.4 Reduced to normal

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

- a lot is not accepted; or

- b) a lot is considered acceptable under the procedures for reduced inspection given in 11.1.4; or
- c) production becomes irregular or delayed; or
- d) other conditions warrant that normal inspection shall be reverted to.

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 be discontinued. Inspection under the provisions 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. The responsible authority shall agree that this action is likely to be effective. Tightened inspection shall then be used as if 9.3.1 had been invoked.

10 Sampling plans

10.1 Inspection level

The inspection level required for any particular application shall be prescribed 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 forms of inspection. Three inspection levels, I, II, and III, are given in table I 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 I and may be used where relatively small sample sizes are necessary and large sampling risks can or shall be tolerated.

In the designation of inspection levels S-1 to S-4, care shall be exercised to avoid AQLs inconsistent with these inspection levels. In other words, the purpose of the special inspection levels is to keep samples small where necessary. For instance, the code letters under S-1 go no further than D, equivalent to a single sample of size 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 percentage of the lot, provided the lot is large relative to the sample that is examined. In spite of this, there are three reasons for varying the sample size with the lot size:

- a) when there is more at stake, 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 selection is relatively more time consuming if the sample is too small a proportion of the lot.

10.2 Sample size code letters

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

10.3 Obtaining a sampling plan

The AQL and the sample size code letter shall be used to obtain the sampling plan from tables II, III or IV. 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, the sample size code letter corresponding to the largest sample size derived may be used for all classes of nonconformities, 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.

10.4 Types of sampling plans

Three types of sampling plans, — single, double and multiple —, are given in tables II, III and IV, respectively. When several types of plans are available for a given AQL and sample size code letter, any one may be used. A decision as to type of plan, either single, double, or multiple, when available for a given AQL and 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 (except in the case corresponding to single acceptance number 1), and both of these are usually less than the single sample size (see table IX). Usually, the administrative difficulty for single sampling and the cost per unit of the sample are less than for double or multiple.

11 Determination of acceptability

11.1 Percent nonconforming inspection

To determine acceptability of a lot under percent nonconforming inspection, the applicable sampling plan shall be used in accordance with 11.1.1, 11.1.2, 11.1.3 and 11.1.4.

11.1.1 Single sampling plan

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

11.1.2 Double sampling plan

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

11.1.3 Multiple sampling plan

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

11.1.4 Special procedure for reduced inspection

In reduced inspection, the sample may contain a number of nonconforming units or nonconformities per 100 units between the acceptance and rejection numbers. In these circumstances, the lot shall be considered acceptable, but normal inspection shall be reinstated starting with the next lot [see 9.3.4 b)].

11.2 Nonconformities per 100 units inspection

In order to determine the acceptability of a lot in a nonconformities per 100 units inspection, the procedure specified for percent nonconforming inspection (see 11.1) shall be used, except that the term "nonconformities" shall be substituted for "nonconforming units".

12 Further information

12.1 Operating characteristic (OC) curves

The operating characteristic curves for normal and tightened inspection, shown in table X, indicate the percentage of lots or batches which may be expected to be accepted under the various sampling plans for a given process quality. The operating characteristic curve for unqualified acceptance in a reduced inspection (i.e. when the number of nonconforming units is less than or equal to the acceptance number) can be found by using the AQL index of the normal plan with the sample size(s) and acceptance number(s) of the reduced plan. The curves shown are for single sampling; curves for double and multiple sampling are matched as closely as practicable. The OC curves shown for AQLs greater than 10 are based on the Poisson distribution and are applicable for nonconformities

per 100 units inspection; those for AQLs of 10 or less and sample sizes of 80 or less are based on the binomial distribution and are applicable for percent nonconforming inspection; those for AQLs of 10 or less and sample sizes larger than 80 are based on the Poisson distribution and are applicable either for nonconformities per 100 units inspection or for percent nonconforming inspection (the Poisson distribution being an adequate approximation to the binomial distribution under these conditions).

Tabulated values, corresponding to selected values of probabilities of acceptance, P_a , expressed in percentage terms, are given for each of the curves shown, and, in addition, for tightened inspection, and for nonconformities per 100 units for AQLs of 10 or less and sample sizes of 80 or less.

12.2 Process average

The process average can be estimated by the average percent nonconforming or average number of nonconformities per 100 units (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 AOQ is the average quality of outgoing product, including all accepted lots, plus all lots which are not accepted, after such lots have been effectively 100 % inspected and all nonconforming units replaced by conforming units.

12.4 Average outgoing quality limit (AOQL)

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

12.5 Average sample size curves

Average sample size curves for double and multiple sampling, as compared with the single sampling plan for each acceptance number, are given in table IX. 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.

12.6 Limiting quality protection

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 should 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 Limiting quality tables

If the lot or batch is of an isolated nature, it may be desirable to limit the selection of sampling plans to those, associated with a designated AQL value, that provide not less than a specified limiting quality protection. Sampling plans for this purpose can be selected by choosing a limiting quality (LQ) and a

consumer's risk to be associated with it. For a definition of limiting quality, see 3.18.

Tables VI and VII give percent nonconforming levels for which the probabilities of lot acceptance under various sampling plans are 10 % and 5 %, respectively. For individual lots with percents nonconforming or nonconformities per 100 units equal to the specified limiting quality values, the probabilities of lot acceptance are less than 10 % in the case of plans listed in table VI and less than 5 % in the case of plans listed in table VII. Where there is reason for avoiding more than a limiting percentage of nonconforming units (or nonconformities) in a lot, tables VI and VII may be useful for fixing minimum sample sizes to be associated with the AQL and inspection level specified for the inspection of a series of lots. For example, if an LQ of 5 % is desired for individual lots with an associated P_a of 10 % or less, then if an AQL of 1 is designated for inspection of a series of lots, table VI indicates that the minimum sample size shall be given by sample size code letter L. ISO 2859-2 gives further details of the method of sampling for lots in isolation.

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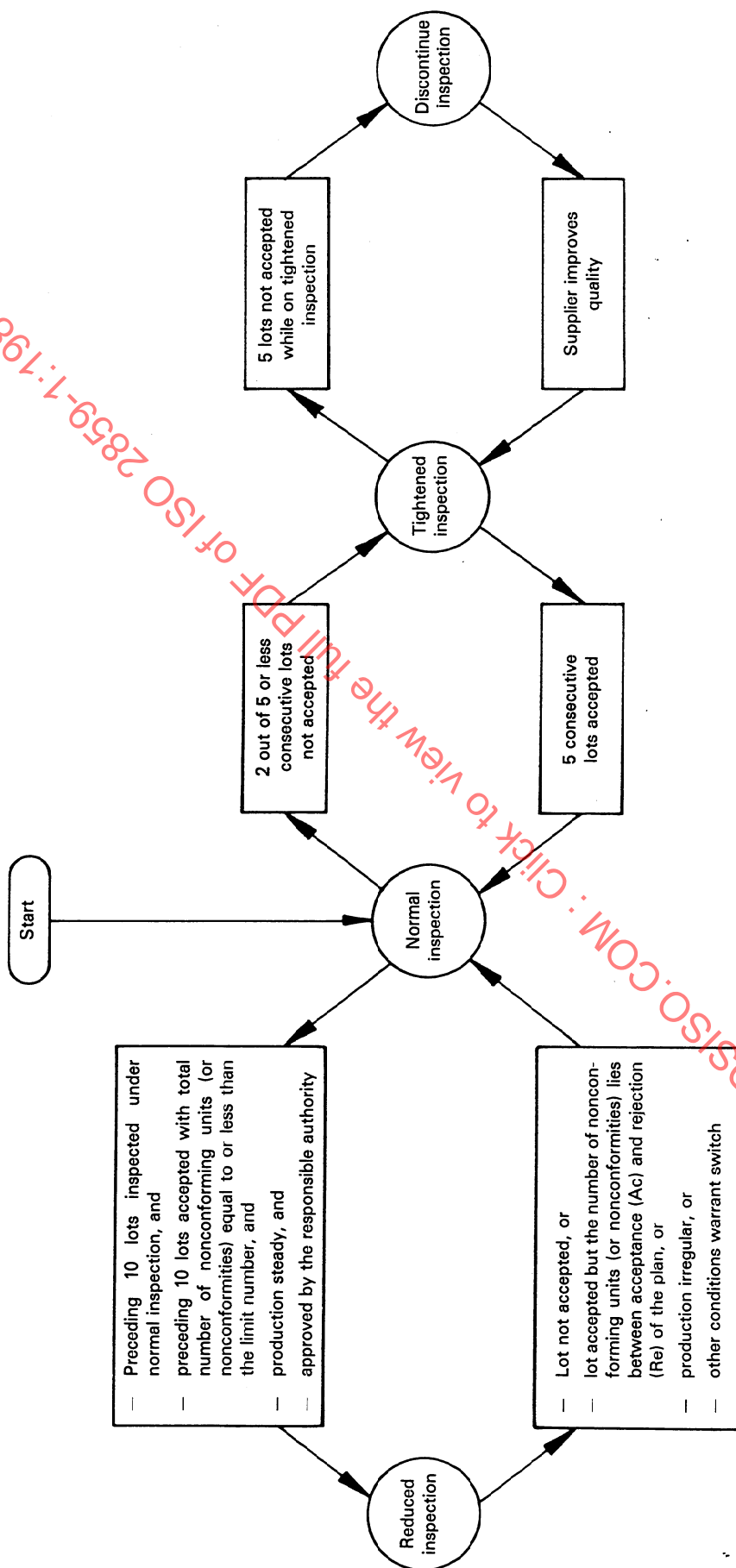


Figure 1 — Outline of the switching rules (see 9.3)

TABLES

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Table I — Sample size code letters (see 10.1 and 10.2)

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

CODE
LETTERS

Table II-A — Single sampling plans for normal inspection (Master table) (see 10.3 and 10.4)

Sample size code letter		Sample size		Acceptable quality levels (normal inspection)																				
				0,010	0,015	0,025	0,040	0,065	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
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	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

**SINGLE
NORMAL**

Table II-B — Single sampling plans for tightened inspection (Master table) (see 10.3 and 10.4)

Sample size code letter		Acceptable quality levels (tightened inspection)																				
		0,010	0,015	0,025	0,040	0,065	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
Sample size	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	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
S	3 150	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

**SINGLE
TIGHTENED**

Table II-C — Single sampling plans for reduced inspection (Master table) (see 10.3 and 10.4)

Sampling size code letter		Sample size	Acceptable quality levels (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		
A	B	C	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
			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
			0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1
D	E	F	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
			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
			0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1
G	H	J	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
			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
			0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1
K	L	M	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
			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
			0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1
N	P	Q	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
			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
			0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1
R		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	
		↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
		0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	0 1	

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

† = If the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but revert to normal inspection (see 11.1.4).

**SINGLE
REDUCED**

Table III-A — Double sampling plans for normal inspection (Master table) (see 10.3 and 10.4)

			Acceptable quality levels (normal inspection)																									
			0,010	0,015	0,025	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					
Sample size code letter	Sample size	Cumulative sample size	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	First	2																										
	Second	2																										
C	First	3																										
	Second	3																										
D	First	5																										
	Second	5																										
E	First	8																										
	Second	8																										
F	First	13																										
	Second	13																										
G	First	20																										
	Second	20																										
H	First	32																										
	Second	32																										
J	First	50																										
	Second	50																										
K	First	80																										
	Second	80																										
L	First	125																										
	Second	125																										
M	First	200																										
	Second	200																										
N	First	315																										
	Second	315																										
P	First	500																										
	Second	500																										
Q	First	800																										
	Second	800																										
R	First	1 250																										
	Second	1 250																										

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

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

Table III-B – Double sampling plans for tightened inspection (Master table) (see 10.3 and 10.4)

Acceptable quality levels (tightened inspection)																											
Sample size code letter	Sample size	Cumulative sample size	0,010	0,015	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		
A			→																								
B	First	2	→																								
	Second	2	→																								
C	First	3	→																								
	Second	3	→																								
D	First	5	→																								
	Second	5	→																								
E	First	8	→																								
	Second	8	→																								
F	First	13	→																								
	Second	13	→																								
G	First	20	→																								
	Second	20	→																								
H	First	32	→																								
	Second	32	→																								
J	First	50	→																								
	Second	50	→																								
K	First	80	→																								
	Second	80	→																								
L	First	125	→																								
	Second	125	→																								
M	First	200	→																								
	Second	200	→																								
N	First	315	→																								
	Second	315	→																								
P	First	500	→																								
	Second	500	→																								
Q	First	800	→																								
	Second	800	→																								
R	First	1 250	→																								
	Second	1 250	→																								
S	First	2 000	→																								
	Second	2 000	→																								

↓ ×

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

= Use first sampling plan above arrow.

Ac = Acceptance number
Re = Rejection number

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

Table III-C — Double sampling plans for reduced inspection (Master table) (see 10.3 and 10.4)

Sample size code letter	Sample size	Cumulative sample size	Acceptable quality levels (reduced inspection) †																						
			0,010	0,015	0,025	0,040	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	
A			↓																						
B			↓																						
C			↓																						
D	First Second	2 2	↓																						
E	First Second	3 3	↓																						
F	First Second	5 5	↓																						
G	First Second	8 8	↓																						
H	First Second	13 13	↓																						
J	First Second	20 20	↓																						
K	First Second	32 32	↓																						
L	First Second	50 50	↓																						
M	First Second	80 80	↓																						
N	First Second	125 125	↓																						
P	First Second	200 200	↓																						
Q	First Second	315 315	↓																						
R	First Second	500 500	↓																						

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

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

† = If, after the second sample, the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but revert to normal inspection (see 11.1.4).

Table IV-A — Multiple sampling plans for normal inspection (Master table) (see 10.3 and 10.4)

Sample size code letter	Sample size	Cumulative sample size	Acceptable quality levels (normal inspection)																65	100	150	250	400	650	1 000			
			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			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
B			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
C			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
D	First	2	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
	Second	2	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
	Third	2	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
	Fourth	2	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
	Fifth	2	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
	Sixth	2	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
	Seventh	2	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
E	First	3	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
	Second	3	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
	Third	3	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
	Fourth	3	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
	Fifth	3	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
	Sixth	3	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
	Seventh	3	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
F	First	5	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
	Second	5	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
	Third	5	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
	Fourth	5	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
	Fifth	5	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
	Sixth	5	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
	Seventh	5	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
G	First	8	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
	Second	8	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
	Third	8	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
	Fourth	8	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
	Fifth	8	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
	Sixth	8	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</							

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

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

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

= Acceptance not permitted for this sample size.

**MULTIPLE
NORMAL**

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↓	=	Use first sampling plan below arrow.
↑	=	Use first sampling plan above arrow.
Ac	=	Acceptance number
Re	=	Rejection number
*	=	Use corresponding single sampling plan (or alternatively use multiple sampling plan below, where available).
#	=	Acceptance not permitted for this sample size.

Table IV-A (concluded)

Sample size letter	Sample size	Cumulative sample size	Acceptable quality levels (normal inspection)																											
			0,010	0,015	0,025	0,040	0,065	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000							
N	First	125	→	→	*	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Second	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Third	375	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fourth	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fifth	625	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Sixth	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Seventh	875	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
P	First	200	→	*	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Second	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Third	600	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fourth	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fifth	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Sixth	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Seventh	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
Q	First	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Second	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Third	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fourth	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fifth	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Sixth	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Seventh	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
R	First	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Second	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Third	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fourth	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Fifth	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Sixth	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		
	Seventh	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→		

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

↑ = Use first sampling plan above arrow (refer to preceding page, where necessary).

Ac = Acceptance number

Re = Rejection number

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

= Acceptance not permitted for this sample size.

20

↓	=	Use first sampling plan below arrow (refer to continuation of the table on the following page, where necessary). If sample size equals, or exceeds, lot or batch size, carry out 100 % inspection.
↑	=	Use first sampling plan above arrow.
Ac	=	Acceptance number
Re	=	Rejection number
*	=	Use corresponding single sampling plan (or alternatively use multiple sampling plan below, where available).
+	=	Use corresponding double sampling plan (or alternatively use multiple sampling plan below, where available).
#	=	Acceptance not permitted for this sample size.

↓ = Use first sampling plan below arrow (refer to continuation of the table on the following page, where necessary). If sample size equals, or exceeds, lot or batch size, carry out 100 % inspection.

= Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

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

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

= Acceptance not permitted for this sample size.

Table IV-B (continued)

Sample size code letter	Sample	Sample size	Cumulative sample size	Acceptable quality levels (tightened inspection)																							
				0,010	0,015	0,025	0,040	0,065	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	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
	Second	13	26	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
	Third	13	39	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
	Fourth	13	52	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
	Fifth	13	65	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
	Sixth	13	78	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
	Seventh	13	91	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
J	First	20	20	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
	Second	20	40	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
	Third	20	60	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
	Fourth	20	80	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
	Fifth	20	100	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
	Sixth	20	120	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
	Seventh	20	140	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
K	First	32	32	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
	Second	32	64	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
	Third	32	96	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
	Fourth	32	128	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
	Fifth	32	160	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
	Sixth	32	192	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
	Seventh	32	224	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
L	First	50	50	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
	Second	50	100	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
	Third	50	150	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
	Fourth	50	200	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
	Fifth	50	250	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
	Sixth	50	300	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
	Seventh	50	350	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
M	First	80	80	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
	Second	80	160	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
	Third	80	240	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
	Fourth	80	320	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
	Fifth	80	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
	Sixth	80	480	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
	Seventh	80	560	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



= Use first sampling plan below arrow (refer to continuation of the table on the following page, where necessary). If sample size equals, or exceeds, lot or batch size, carry out 100 % inspection.

= Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

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

= Acceptance not permitted for this sample size.

**MULTIPLE
TIGHTENED**

Table IV-B (concluded)

Sample size code letter	Sample size	Cumulative sample size	Acceptable quality levels (tightened inspection)																											
			0,010	0,015	0,025	0,040	0,065	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						
N	First	125	↓	↓	↓	*	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Second	125	↓	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Third	125	↓	↓	↓	↓	↓	↓	0 2	0 3	1 4	2 6	4 9	7 12	11 17	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fourth	125	↓	↓	↓	↓	↓	↓	0 3	1 4	2 5	3 7	6 11	10 15	16 22	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fifth	500	↓	↓	↓	↓	↓	↓	1 3	2 4	3 6	5 8	9 12	14 17	22 25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Sixth	125	↓	↓	↓	↓	↓	↓	1 3	3 5	4 6	7 9	12 14	18 20	27 29	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Seventh	125	↓	↓	↓	↓	↓	↓	2 3	4 5	6 7	9 10	14 15	21 22	32 33	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
P	First	200	↓	↓	*	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Second	200	↓	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Third	200	↓	↓	↓	↓	↓	↓	0 2	0 3	1 4	2 6	4 9	7 12	11 17	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fourth	200	↓	↓	↓	↓	↓	↓	0 3	1 4	2 5	3 7	6 11	10 15	16 22	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fifth	200	↓	↓	↓	↓	↓	↓	1 3	2 4	3 6	5 8	9 12	14 17	22 25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Sixth	200	↓	↓	↓	↓	↓	↓	1 3	3 5	4 6	7 9	12 14	18 20	27 29	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Seventh	200	↓	↓	↓	↓	↓	↓	2 3	4 5	6 7	9 10	14 15	21 22	32 33	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
Q	First	315	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Second	315	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Third	315	↓	↓	↓	↓	↓	0 2	0 3	1 4	2 6	4 9	7 12	11 17	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fourth	315	↓	↓	↓	↓	↓	0 3	1 4	2 5	3 7	6 11	10 15	16 22	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fifth	315	↓	↓	↓	↓	↓	1 3	2 4	3 6	5 8	9 12	14 17	22 25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Sixth	315	↓	↓	↓	↓	↓	1 3	3 5	4 6	7 9	12 14	18 20	27 29	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Seventh	315	↓	↓	↓	↓	↓	2 3	4 5	6 7	9 10	14 15	21 22	32 33	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
R	First	500	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Second	500	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Third	500	↓	↓	↓	↓	↓	0 2	0 3	1 4	2 6	4 9	7 12	11 17	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fourth	500	↓	↓	↓	↓	↓	0 3	1 4	2 5	3 7	6 11	10 15	16 22	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fifth	500	↓	↓	↓	↓	↓	1 3	2 4	3 6	5 8	9 12	14 17	22 25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Sixth	500	↓	↓	↓	↓	↓	1 3	3 5	4 6	7 9	12 14	18 20	27 29	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Seventh	500	↓	↓	↓	↓	↓	2 3	4 5	6 7	9 10	14 15	21 22	32 33	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
S	First	800	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Second	800	↓	↓	↓	↓	↓	# 2	# 2	# 3	# 4	0 4	0 6	1 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Third	800	↓	↓	↓	↓	↓	0 2	0 3	1 4	2 6	4 9	7 12	11 17	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fourth	800	↓	↓	↓	↓	↓	0 3	1 4	2 5	3 7	6 11	10 15	16 22	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Fifth	800	↓	↓	↓	↓	↓	1 3	2 4	3 6	5 8	9 12	14 17	22 25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Sixth	800	↓	↓	↓	↓	↓	1 3	3 5	4 6	7 9	12 14	18 20	27 29	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		
	Seventh	800	↓	↓	↓	↓	↓	2 3	4 5	6 7	9 10	14 15	21 22	32 33	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓		

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

↑ = Use first sampling plan above arrow (refer to preceding page, where necessary).

Ac = Acceptance number

Re = Rejection number

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

= Acceptance not permitted for this sample size.

Table IV-C — Multiple sampling plans for reduced inspection (Master table) (see 10.3 and 10.4)

Sample size letter	Sample size	Cumulative sample size	Acceptable quality levels (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	
A			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
B			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
C			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
D			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
E			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
F	First	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Second	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Third	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fourth	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fifth	10	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Sixth	12	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Seventh	14	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
G	First	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Second	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Third	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fourth	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fifth	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Sixth	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Seventh	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
H	First	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Second	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Third	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fourth	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fifth	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Sixth	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Seventh	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
J	First	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Second	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Third	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fourth	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Fifth	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Sixth	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	
	Seventh	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	



↓ = Use first sampling plan below arrow (refer to continuation of the table on the following page, where necessary). If sample size equals, or exceeds, lot or batch size, carry out 100 % inspection.

↑ = Use first sampling plan above arrow.

Ac = Acceptance number

Re = Rejection number

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

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

= Acceptance not permitted for this sample size.

† = If, after the final sample, the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but revert to normal inspection (see 11.1.4).

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== Use first sampling plan above arrow.

Re = Rejection number

* = Use corresponding

= If after the final sample, the acceptance number

Figure 1

Table IV-C (concluded)

Sample size code letter	Sample size	Cumulative sample size	Acceptable quality levels (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
P	First	80	↓	*	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Second	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Third	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Fourth	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Fifth	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Sixth	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Seventh	80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Q	First	125	*	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Second	125	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Third	125	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Fourth	125	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Fifth	125	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Sixth	125	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Seventh	125	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
R	First	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Second	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Third	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Fourth	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Fifth	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Sixth	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
	Seventh	200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓



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

↑ = Use first sampling plan above arrow (refer to preceding page, where necessary).

Ac = Acceptance number

Re = Rejection number

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

= Acceptance not permitted for this sample size.

† = If, after the final sample, the acceptance number has been exceeded, but the rejection number as not been reached, accept the lot, but revert to normal inspection (see 11.1.4).

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Table V-B — Approximate values of average outgoing quality limits for tightened inspection (Single sampling) (see 12.4)

		Acceptable quality level																				
Code letter	Sample size	0,010	0,015	0,025	0,040	0,065	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											
B	3																					
C	5									7,4			17	28	42	69	97	160	260	400	620	970
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																					

Table VI-A — Limiting quality (in percent nonconforming) for which 10 % of lots will be expected to be accepted
(Normal inspection, single sampling) (see 12.6)

Code letter	Sample size	Acceptable quality level											
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5
A	2												1,5
B	3												2,5
C	5												3,7
D	8												5,4
E	13												6,5
F	20												10
G	32												16
H	50												25
J	80												37
K	125												54
L	200												68
M	315												10
N	500												16
P	800												23
Q	1 250												34
R	2 000												42

Table VI-B — Limiting quality (in nonconformities per 100 units) for which 10 % of lots will be expected to be accepted
(Normal inspection, single sampling) (see 12.6)

		Acceptable quality level																										
		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	
Code letter	Sample size	A	2														120			200	270	330	460	590	770	1 000	1 400	1 900
		B	3													77			130	180	220	310	390	510	670	940	1 300	1 800
		C	5									46							78	110	130	190	240	310	400	560	770	1 100
		D	8										29				49	67	84	120	150	190	250	350	480	670		
		E	13										18			30	41	51	71	91	120	160	220	300	410			
		F	20										12			20	27	33	46	59	77	100	140					
		G	32																									
		H	50																									
		J	80																									
		K	125																									
		L	200																									
		M	315																									
		N	500																									
		P	800																									
		Q	1 250																									
R	2 000																											

Table VII-A — Limiting quality (in percent nonconforming) for which 5 % of lots will be expected to be accepted
(Normal inspection, single sampling) (see 12.6)

Code letter	Sample size	Acceptable quality level											
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5
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												

LQ (NONCONFORMING)

5 %

Table VII-B — Limiting quality (in nonconformities per 100 units) for which 5 % of lots will be expected to be accepted
(Normal inspection, single sampling) (see 12.6)

Code letter	Sample size	Acceptable quality level																							
		0,010	0,015	0,025	0,040	0,065	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000			
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																								

LQ (NONCONFORMITIES)

5 %

Table VIII — Limit numbers for reduced inspection (see 9.3.3)

Number of sample units from last 10 lots or batches	Acceptable quality level																				
	0,010	0,015	0,025	0,040	0,065	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	650	1 000
20 — 29	*	*	*	*	*	*	*	*	*	*	0	0	2	4	8	14	22	40	68	115	181
30 — 49	*	*	*	*	*	*	*	*	*	*	0	1	3	7	13	22	36	63	105	177	277
50 — 79	*	*	*	*	*	*	*	*	*	*	0	2	3	7	14	25	40	63	110	181	301
80 — 129	*	*	*	*	*	*	*	*	*	0	4	7	14	24	42	68	105	181	297	490	
130 — 199	*	*	*	*	*	*	*	*	*	0	8	15	25	42	72	115	177	301	490		
200 — 319	*	*	*	*	*	0	0	2	4	8	14	22	40	68	115	181	277	471			
320 — 499	*	*	*	*	0	0	1	4	8	14	24	39	68	113	189						
500 — 799	*	*	*	0	0	2	3	7	14	25	40	63	110	181							
800 — 1 249	*	*	*	0	2	4	7	14	24	42	68	105	181								
1 250 — 1 999	*	*	*	2	4	7	13	24	40	69	110	169									
2 000 — 3 149	*	*	*	4	8	14	22	40	68	115	181										
3 150 — 4 999	*	*	*	8	14	24	38	67	111	186											
5 000 — 7 999	*	*	*	16	25	40	63	110	181												
8 000 — 12 499	*	*	0	2	42	68	105	181													
12 500 — 19 999	*	0	0	4	69	110	169														
20 000 — 31 499	0	0	2	4	115	181															
over 31 449	0	1	4	8	186																

* Denotes that the number of sample units from the last 10 lots or batches is not sufficient for reduced inspection for this AQL. In this instance, more than 10 lots or batches may be used for the calculation, provided that the lots or batches used are the most recent ones in sequence, that they have all been subjected to normal inspection and that none has been rejected during the normal inspection.

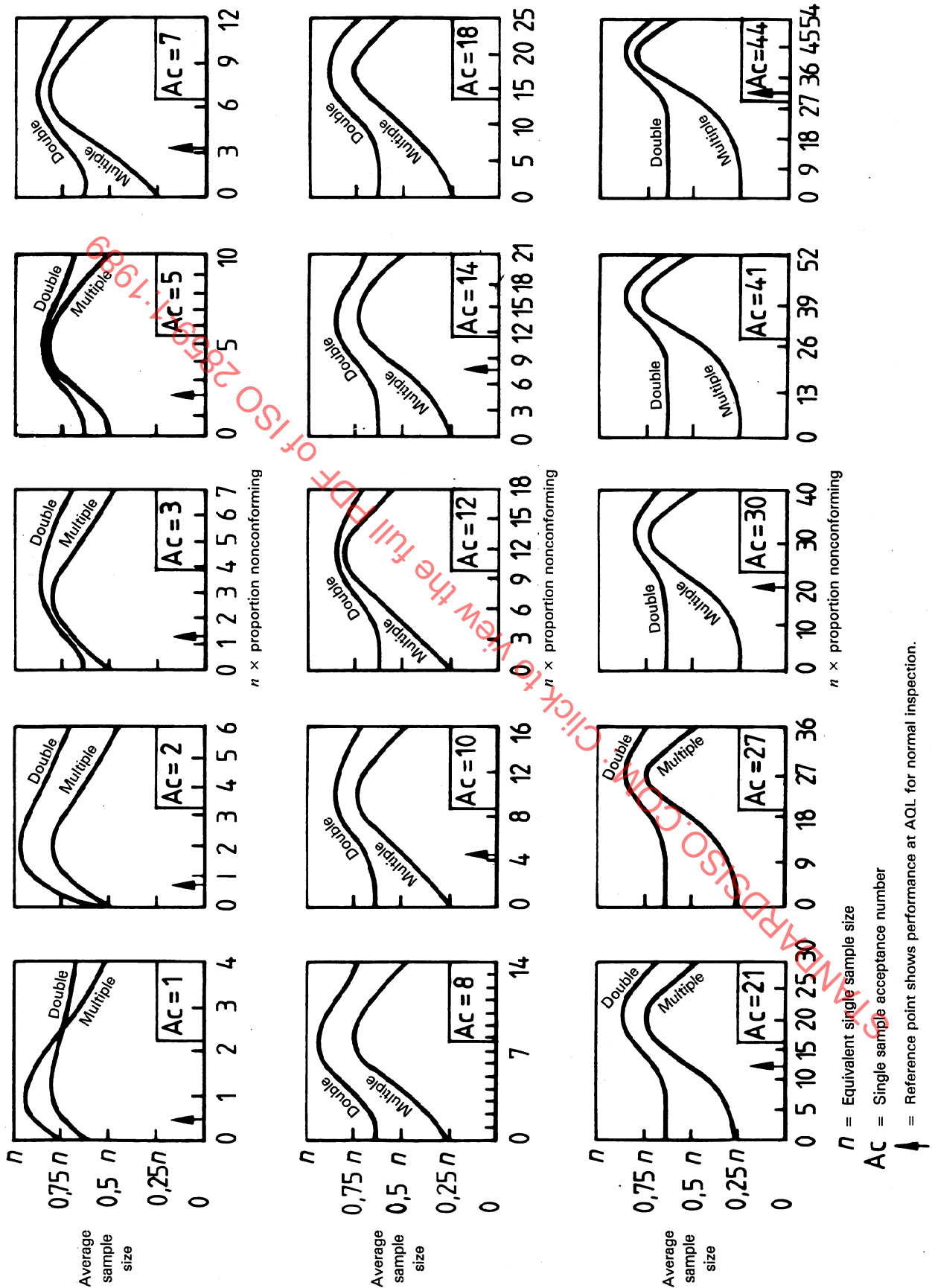
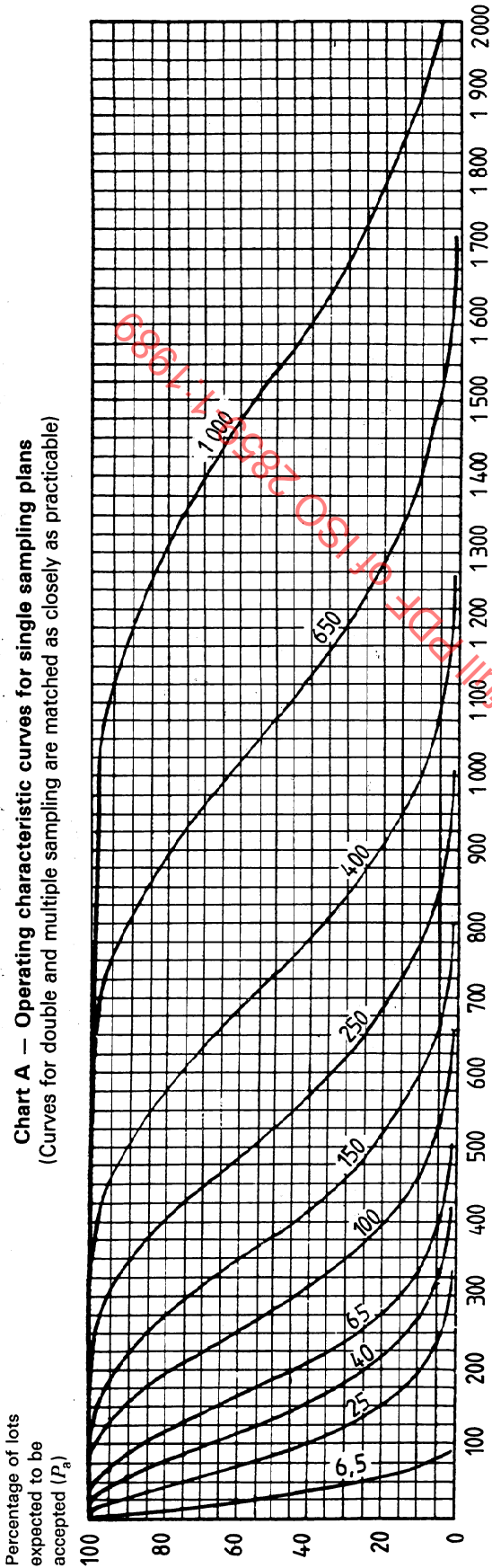


Table X-A — Tables for sample size code letter A (Individual plans)

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



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

NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	p (in percent nonconforming)	Acceptable quality levels (normal inspection)															Acceptable quality levels (tightened inspection)														
		6,5	6,5	25	40	65	100	150	250	400	650	1000	1799	2500	4000	6500	10000	15000	25000	40000	65000	100000									
		p (in nonconformities per 100 units)																													
99,0	0,501	0,503	7,43	21,8	41,2	89,3	145	175	239	305	374	517	629	859	977																
95,0	2,53	2,56	17,8	40,9	68,3	131	199	235	308	384	462	622	745	995	1 122																
90,0	5,13	5,27	26,6	55,1	87,2	158	233	272	351	432	515	684	812	1 073	1 206																
75,0	13,4	14,4	48,1	86,4	127	211	298	342	431	521	612	795	934	1 214	1 354																
50,0	29,3	34,7	83,9	134	184	284	383	433	533	633	733	933	1 083	1 383	1 533																
25,0	50,0	69,3	135	196	255	371	484	540	651	761	870	1 087	1 248	1 568	1 728																
10,0	68,4	115	194	266	334	464	589	650	770	889	1 006	1 238	1 409	1 748	1 916																
5,0	77,6	150	237	315	388	526	657	722	848	972	1 094	1 335	1 512	1 862	2 035																
1,0	90,0	230	332	420	502	655	800	870	1 007	1 141	1 272	1 529	1 718	2 088	2 270																
			40	65	100	150	250	400	650	1 000	1 500	2 500	4 000	6 500	10 000																

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

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

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																			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	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	27 28	30 31	2		
Double		▽	*			(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)			
Multiple		▽	*			*	*	*	*	*	*	*	*	*	*	*	*	*			
		< 10	10	15	25	40	65	100	150	250	400	650	1 000								
Acceptable quality levels (tightened inspection)																					

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

Ac = Acceptance number

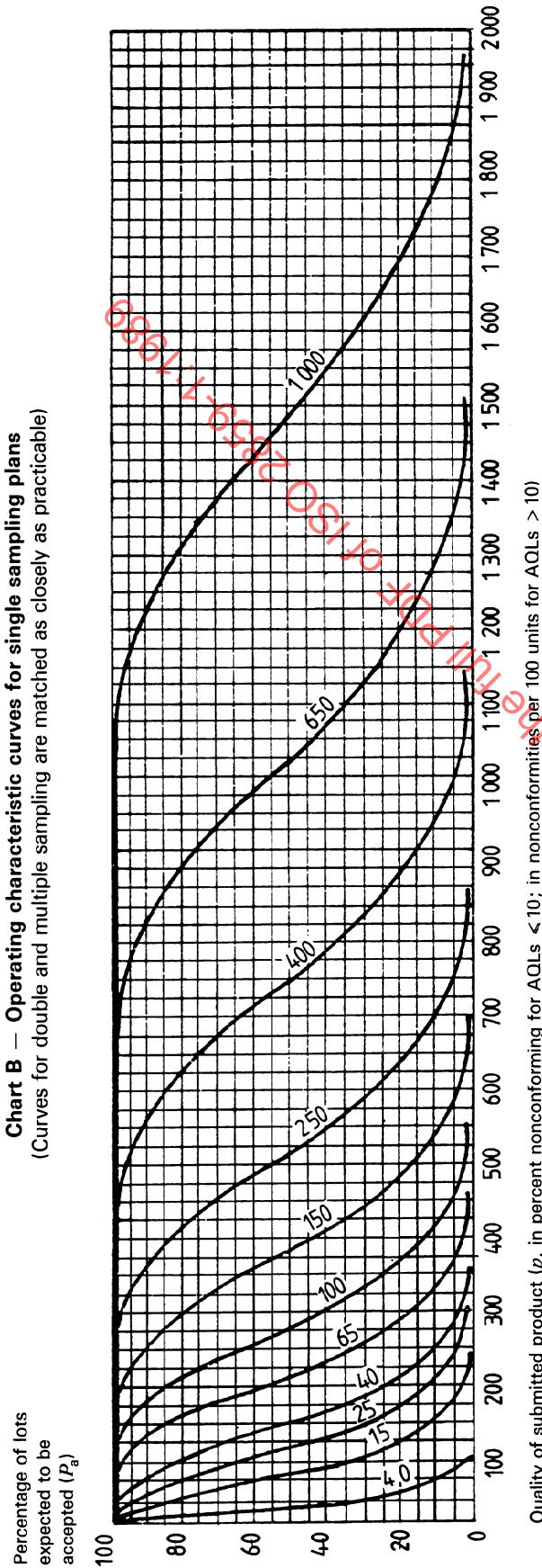
Re = Rejection number

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

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

Table X-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 — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)																		Acceptable quality levels (tightened inspection)																	
	p (in percent nonconforming)																		p (in nonconformities per 100 units)																	
	4,0	0,334	0,335	4,0	15	25	40	65	100	150	203	249	345	419	572	651	947	1 029	4,0	15	25	40	65	100	150	203	249	345	419	572	651	947	1 029			
99,0	0,334																																			
95,0	1,70	1,71	11,8	27,3	45,5	87,1	133	157	206	256	308	415	496	663	748	1 065	1 152																			
90,0	3,45	3,51	17,7	36,7	58,2	105	155	181	234	288	343	456	541	716	804	1 131	1 222																			
75,0	9,14	9,59	32,0	57,6	84,5	141	199	228	287	347	408	530	623	809	903	1 249	1 344																			
50,0	20,6	23,1	55,9	89,1	122	189	256	289	356	422	489	622	722	922	1 022	1 389	1 489																			
25,0	37,0	46,2	89,8	131	170	247	323	360	434	507	580	724	832	1 045	1 152	1 539	1 644																			
10,0	53,6	76,8	130	177	223	309	392	433	514	593	671	825	939	1 165	1 277	1 683	1 793																			
5,0	63,2	99,9	158	210	258	350	438	481	565	648	730	890	1 008	1 241	1 356	1 773	1 886																			
1,0	78,5	154	221	280	335	437	533	580	671	761	848	1 019	1 145	1 392	1 513	1 951	2 069																			
	6,5	6,5	25	40	65	100																														

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

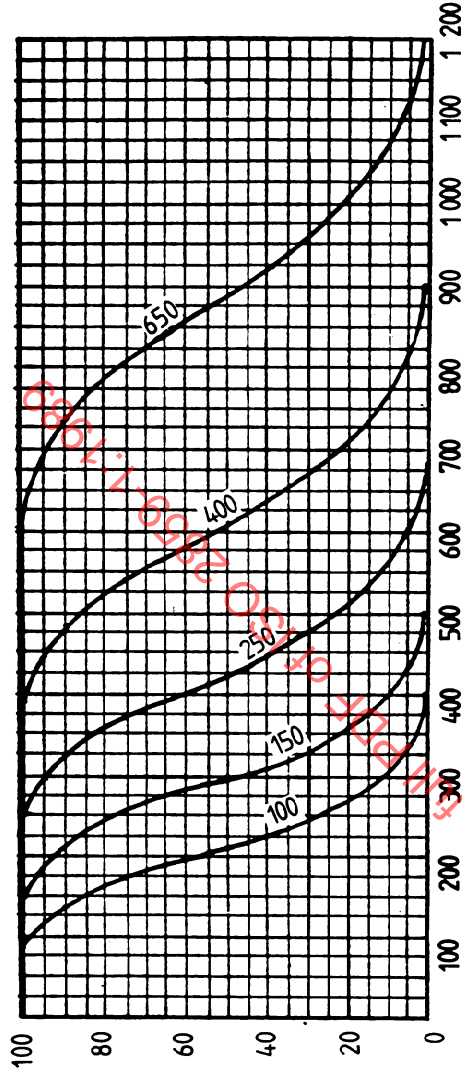
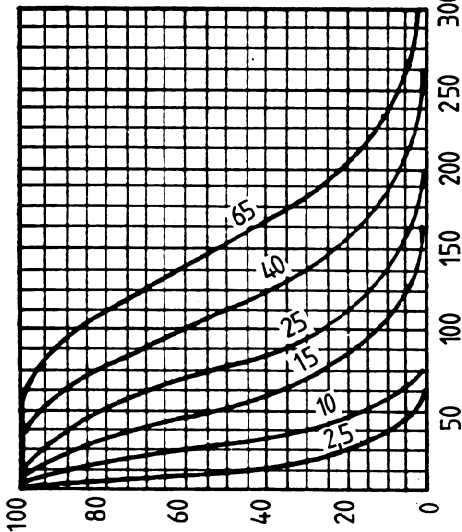
Table X-B-2 — Sampling plans for sample size code letter B

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																Cumulative sample size																		
		< 4,0	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																				
Single	3	▽	0	1		1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	27	28	30	31	41	42	44	45	
Double	2	▽	*			0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	15	20	17	22	23	29	25	31	
	4					1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27	34	35	37	38	52	53	56	57	
Multiple		▽	*																																	
		< 6,5	6,5		10	15	25	40	65	100		150		250		400		650		1 000																
		Acceptable quality levels (tightened inspection)																																		

Table X-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)

Percentage of lots
expected to be
accepted (P_a)



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

NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)																		Acceptable quality levels (tightened inspection)																	
	2,5	10	2,5	10	15	25	40	65	100	150	250	400	650	2,5	10	15	25	40	65	100	150	250	400	650												
	p (in percent nonconforming)												p (in nonconformities per 100 units)																							
99,0	0,201	3,27	0,201	2,97	8,72	16,5	37,5	58,1	70,1	95,4	122	150	207	251	343	391	568	618																		
95,0	1,02	7,64	1,03	7,11	16,4	27,3	52,3	79,6	93,9	123	154	185	249	298	398	449	639	691																		
90,0	2,09	11,2	2,11	10,6	22,0	34,9	63,0	93,1	109	140	173	206	273	325	429	482	679	733																		
75,0	5,59	19,4	5,75	19,2	34,5	50,7	84,4	119	137	172	208	245	318	374	485	542	749	806																		
50,0	12,9	31,4	13,9	33,6	53,5	73,4	113	153	173	213	253	293	373	433	553	613	833	893																		
25,0	24,2	45,4	27,7	53,9	78,4	102	148	194	216	260	304	348	435	499	627	691	923	986																		
10,0	36,9	58,4	46,1	77,8	106	134	185	235	260	308	356	403	495	564	699	766	1 010	1 076																		
5,0	45,1	65,7	59,9	94,9	126	155	210	263	289	339	389	438	534	605	745	814	1 064	1 131																		
1,0	60,2	77,8	92,1	133	168	201	262	320	348	403	456	509	612	687	835	908	1 171	1 241																		
	4,0		4,0	15	25	40	65		100		150		250		400		650																			

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

Table X-C-2 — Sampling plans for sample size code letter C

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																		Cumulative sample size	
		< 2,5	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					
Single	5	▽	0 1			1 2	2 3	3 4	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	27 28	30 31	41 42	44 45	5
Double	3	▽	*			0 2	0 3	1 4	2 5	3 7	3 7	5 9	6 10	7 11	9 14	11 16	15 20	17 22	23 29	25 31	3
	6					1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27	34 35	37 38	52 53	56 57	6
Multiple		▽	*			++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	
		< 4,0	4,0				15	25	40	65	100	150	250	400	650	1 000					
		Acceptable quality levels (tightened inspection)																			

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

Ac = Acceptance number

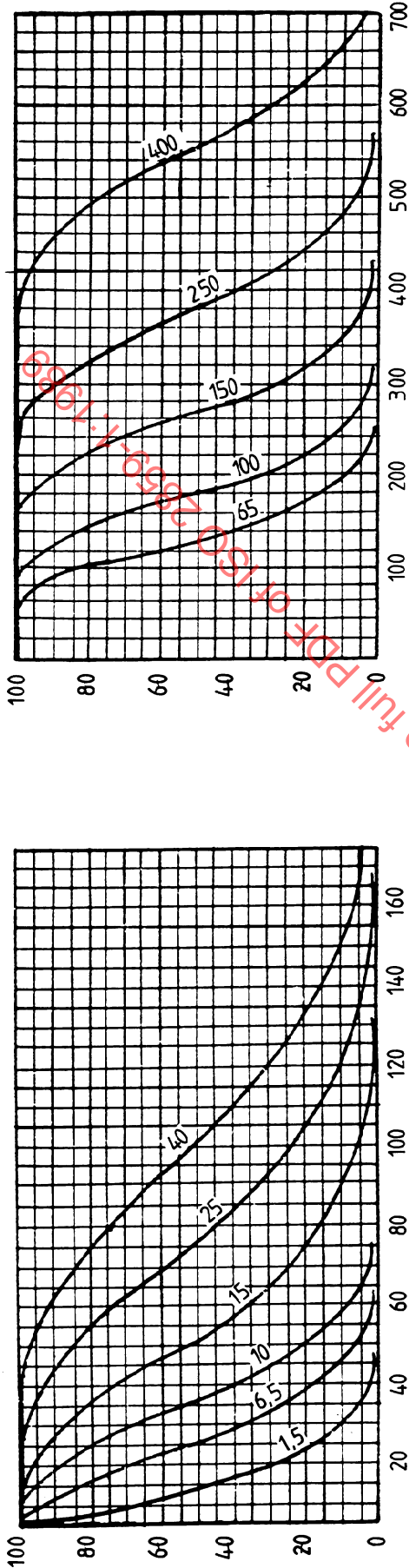
Re = Rejection number

* = Use single sampling plan above (or alternatively use code letter F).

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

Table X-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)



NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)																								Acceptable quality levels (tightened inspection)																							
	p (in percent nonconforming)												p (in nonconformities per 100 units)																																			
	1,5	6,5	10	1,5	6,5	10	15	25	40	65	100	150	250	400	1,5	6,5	10	15	25	40	65	100	150	250	400																							
99,0	0,126	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	215	244	355	386																													
95,0	0,639	4,64	11,1	0,641	4,44	10,2	17,1	32,7	49,8	58,7	77,1	96,1	116	156	186	249	281	399	432																													
90,0	1,31	6,86	14,7	1,32	6,65	13,8	21,8	39,4	58,2	67,9	87,8	108	129	171	203	268	301	424	458																													
75,0	3,53	12,1	22,1	3,60	12,0	21,6	31,7	52,7	74,5	85,5	108	130	153	199	234	303	339	468	504																													
50,0	8,30	20,1	32,1	8,66	21,0	33,4	45,9	70,9	95,9	108	133	158	183	233	271	346	383	521	558																													
25,0	15,9	30,3	43,3	17,3	33,7	49,0	63,9	92,8	121	135	163	190	217	272	312	392	432	577	617																													
10,0	25,0	40,6	53,8	28,8	48,6	66,5	83,5	116	147	162	193	222	252	309	352	437	479	631	672																													
5,0	31,2	47,1	60,0	37,4	59,3	78,7	96,9	131	164	180	212	243	274	334	378	465	509	665	707																													
1,0	43,8	59,0	70,7	57,6	83,0	105	126	164	200	218	252	285	318	382	429	522	568	732	776																													
	2,5	10		2,5	10	15	25	40		65		100		150		250		400																														

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

Table X-D-2 — Sampling plans for sample size code letter D

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																		Cumulative sample size		
		< 1,5	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	> 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						
Single	8	▽	0 1			1 2	2 3	3 4	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	27 28	30 31	41 42	44 45	△	8
Double	5	▽	*			0 2	0 3	1 4	2 5	3 7	3 7	5 9	6 10	7 11	9 14	11 16	15 20	17 22	23 29	25 31	△	5
	10					1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27	34 35	37 38	52 53	56 57		10
Multiple	2	▽	*	Use code letter C	Use code letter F	# 2	# 2	# 3	# 4	0 4	0 4	0 5	0 6	1 7	1 8	2 9	3 10	4 12	6 15	6 16	△	2
	4					# 2	0 3	0 3	1 5	1 6	2 7	3 8	3 9	4 10	6 12	7 14	10 17	11 19	16 25	17 27		4
	6					0 2	0 3	1 4	2 6	3 8	4 9	6 10	7 12	8 13	11 17	13 19	17 24	19 27	26 36	29 39		6
	8					0 3	1 4	2 5	3 7	5 10	6 11	8 13	10 15	12 17	16 22	19 25	24 31	27 34	37 46	40 49		8
	10					1 3	2 4	3 6	5 8	7 11	9 12	11 15	14 17	17 20	22 25	25 29	32 37	36 40	49 55	53 58		10
	12					1 3	3 5	4 6	7 9	10 12	12 14	14 17	18 20	21 23	27 29	31 33	40 43	45 47	61 64	65 68		12
	14					2 3	4 5	6 7	9 10	13 14	14 15	18 19	21 22	25 26	32 33	37 38	48 49	53 54	72 73	77 78		14
	< 2,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	> 400								
Acceptable quality levels (tightened inspection)																						

△ = 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

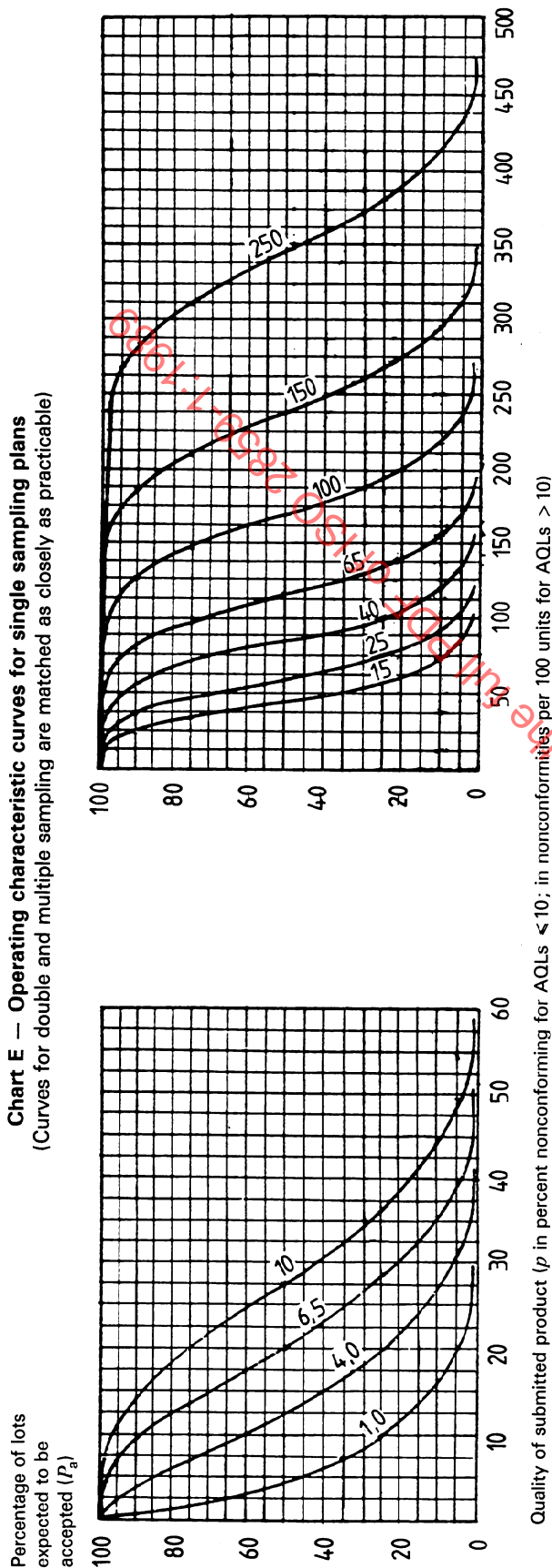
Re = Rejection number

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

= Acceptance not permitted at this sample size.

Table X-E — Tables for sample size code letter E (Individual plans)

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



NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

Table X-E-1 — Tabulated values for operating characteristic curves for single sampling plans

P_a	Acceptable quality levels (normal inspection)																												Acceptable quality levels (tightened inspection)																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													
	p (in percent nonconforming)														p (in nonconformities per 100 units)														p (in percent nonconforming)														p (in nonconformities per 100 units)																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
	1,0	4,0	6,5	10	10	1,0	4,0	6,5	10	15	25	40	65	100	150	250	1,0	4,0	6,5	10	15	25	40	65	100	150	250	1,0	4,0	6,5	10	15	25	40	65	100	150	250																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																				
99,0	0,077	1,18	3,58	6,95	0,077	1,15	3,35	6,33	13,7	22,4	27,0	36,7	46,9	57,5	79,6	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7	96,7

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

Table X-E-2 — Sampling plans for sample size code letter E

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																			Cumulative sample size	
		< 1,0	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	> 250						
		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						
Single	13	▽	0 1		1 2	2 3	3 4	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	27 28	30 31	41 42	44 45	△	13	
Double	8	▽	*		0 2	0 3	1 4	2 5	3 7	3 7	5 9	6 10	7 11	9 14	11 16	15 20	17 22	23 29	25 31	△	8	
	16				1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27	34 35	37 38	52 53	56 57		16	
Multiple	3	▽	*	Use code letter D	Use code letter G	# 2	# 2	# 3	# 4	0 4	0 4	0 5	0 6	1 7	1 8	2 9	3 10	4 12	6 15	6 16	△	3
	6					# 2	0 3	0 3	1 5	1 6	2 7	3 8	3 9	4 10	6 12	7 14	10 17	11 19	16 25	17 27		6
	9					0 2	0 3	1 4	2 6	3 8	4 9	6 10	7 12	8 13	11 17	13 19	17 24	19 27	26 36	29 39		9
	12					0 3	1 4	2 5	3 7	5 10	6 11	8 13	10 15	12 17	16 22	19 25	24 31	27 34	37 46	40 49		12
	15					1 3	2 4	3 6	5 8	7 11	9 12	11 15	14 17	17 20	22 25	25 29	32 37	36 40	49 55	53 58		15
	18					1 3	3 5	4 6	7 9	10 12	12 14	14 17	18 20	21 23	27 29	31 33	40 43	45 47	61 64	65 68		18
	21					2 3	4 5	6 7	9-10	13 14	14 15	18 19	21 22	25 26	32 33	37 38	48 49	53 54	72 73	77 78		21
		< 1,5	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	> 250							
		Acceptable quality levels (tightened inspection)																				

△ = 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.

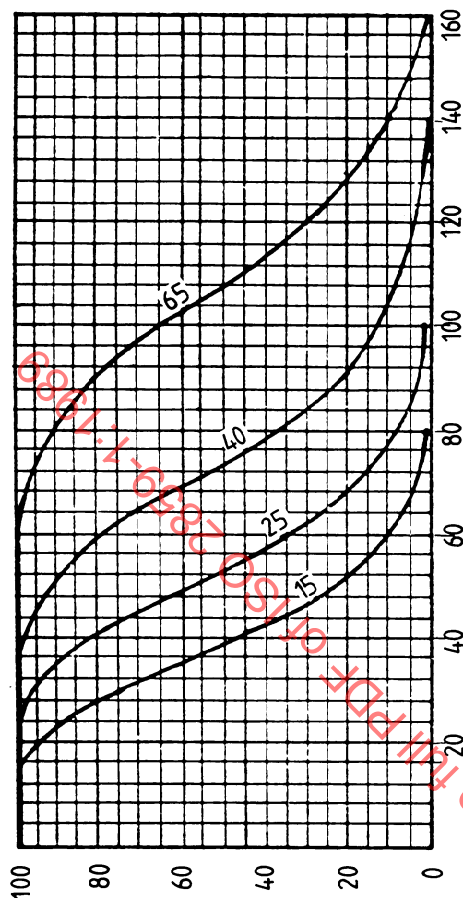
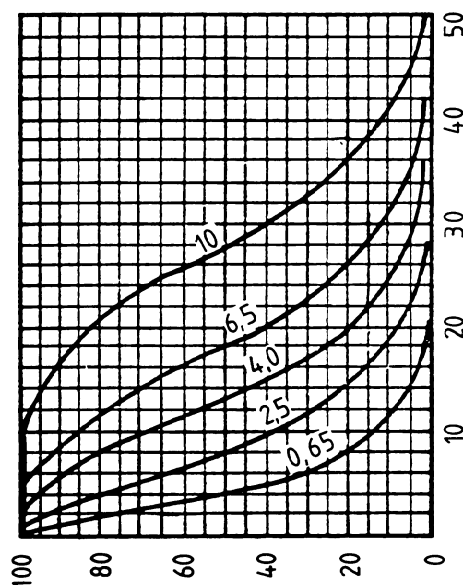
Ac = Acceptance number

Re = Rejection number

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

= Acceptance not permitted at this sample size.

Table X-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)Percentage of lots
expected to be
accepted (P_a)Quality of submitted product (p in percent nonconforming for AQLs < 10 ; in nonconformities per 100 units for AQLs > 10)

NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)																				Acceptable quality levels (tightened inspection)																																																																																																																
	p (in percent nonconforming)										p (in nonconformities per 100 units)										p (in percent nonconforming)										p (in nonconformities per 100 units)																																																																																																						
	0,65	2,5	4,0	6,5	10	0,65	2,5	4,0	6,5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100	105	110	115	120	125	130	135	140	145	150	155	160	165	170	175	180	185	190	195	200																																																																																					
99,0	0,050 2	0,759	2,27	4,36	9,75	0,050 3	0,743	2,18	4,12	8,93	14,5	17,5	23,9	30,5	37,4	44,2	51,7	59,9	68,4	77,5	87,0	97,2	108	119	130	141	152	163	174	185	196	207	218	229	240	251	262	273	284	295	306	317	328	339	350	361	372	383	394	405	416	427	438	449	460	471	482	493	504	515	526	537	548	559	570	581	592	603	614	625	636	647	658	669	680	691	702	713	724	735	746	757	768	779	790	801	812	823	834	845	856	867	878	889	900	911	922	933	944	955	966	977	988	999																													
95,0	0,256	1,81	4,22	7,14	14,0	0,256	1,78	4,09	6,83	13,1	19,9	23,5	30,8	38,4	46,2	55,1	62,2	70,2	78,2	86,2	94,2	102	110	118	126	134	142	150	158	166	174	182	190	198	206	214	222	230	238	246	254	262	270	278	286	294	302	310	318	326	334	342	350	358	366	374	382	390	398	406	414	422	430	438	446	454	462	470	478	486	494	502	510	518	526	534	542	550	558	566	574	582	590	598	606	614	622	630	638	646	654	662	670	678	686	694	702	710	718	726	734	742	750	758	766	774	782	790	798	806	814	822	830	838	846	854	862	870	878	886	894	902	910	918	926	934	942	950	958	966	974	982	990
90,0	0,525	2,69	5,64	9,03	16,6	0,527	2,66	5,51	8,72	15,8	23,3	27,2	35,1	43,2	51,5	60,4	68,4	76,4	84,4	92,4	100	108	116	124	132	140	148	156	164	172	180	188	196	204	212	220	228	236	244	252	260	268	276	284	292	300	308	316	324	332	340	348	356	364	372	380	388	396	404	412	420	428	436	444	452	460	468	476	484	492	500	508	516	524	532	540	548	556	564	572	580	588	596	604	612	620	628	636	644	652	660	668	676	684	692	700	708	716	724	732	740	748	756	764	772	780	788	796	804	812	820	828	836	844	852	860	868	876	884	892	900	908	916	924	932	940	948	956	964	972	980	988	996
75,0	1,43	4,81	8,70	12,8	21,6	1,44	4,81	8,64	12,7	21,1	29,8	34,2	43,1	52,1	61,2	70,2	79,2	88,2	97,2	106	115	124	133	142	151	160	169	178	187	196	205	214	223	232	241	250	259	268	277	286	295	304	313	322	331	340	349	358	367	376	385	394	403	412	421	430	439	448	457	466	475	484	493	502	511	520	529	538	547	556	565	574	583	592	601	610	619	628	637	646	655	664	673	682	691	700	709	718	727	736	745	754	763	772	781	790	799	808	817	826	835	844	853	862	871	880	889	898	907	916	925	934	943	952	961	970	979	988	997														
50,0	3,41	8,25	13,1	18,1	27,9	3,47	8,39	13,4	18,4	28,4	30,3	43,3	53,3	63,3	73,3	83,3	93,3	103	113	123	133	143	153	163	173	183	193	203	213	223	233	243	253	263	273	283	293	303	313	323	333	343	353	363	373	383	393	403	413	423	433	443	453	463	473	483	493	503	513	523	533	543	553	563	573	583	593	603	613	623	633	643	653	663	673	683	693	703	713	723	733	743	753	763	773	783	793	803	813	823	833	843	853	863	873	883	893	903	913	923	933	943	953	963	973	983	993																										
25,0	6,70	12,9	18,7	24,2	34,8	6,93	13,5	19,6	25,5	37,1	48,4	54,0	65,1	76,1	87,0	97,0	107	117	127	137	147	157	167	177	187	197	207	217	227	237	247	257	267	277	287	297	307	317	327	337	347	357	367	377	387	397	407	417	427	437	447	457	467	477	487	497	507	517	527	537	547	557	567	577	587	597	607	617	627	637	647	657	667	677	687	697	707	717	727	737	747	757	767	777	787	797	807	817	827	837	847	857	867	877	887	897	907	917	927	937	947	957	967	977	987	997																											
10,0	10,9	18,1	24,5	30,4	41,5	11,5	19,4	26,6	33,4	46,4	58,9	65,0	77,0	88,9	101	112	124	135	146	157	168	179	190	201	212	223	234	245	256	267	278	289	300	311	322	333	344	355	366	377	388	399	410	421	432	443	454	465	476	487	498	509	520	531	542	553	564	575	586	597	608	619	630	641	652	663	674	685	696	707	718	729	740	751	762	773	784	795	806	817	828	839	850	861	872	883	894	905	916	927	938	949	960	971	982	993																																					
5,0	13,9	21,6	28,3	34,4	45,6	15,0	23,7	31,5	38,8	52,6	65,7	72,2	84,8	97,2	109	120	131	142	153	164	175	186	197	208	219	230	241	252	263	274	285	296	307	318	329	340	351	362	373	384	395	406	417	428	439	450	461	472	483	494	505	516	527	538	549	560	571	582	593	604	615	626	637	648	659	670	681	692	703	714	725	736	747	758	769	780	791	802	813	824	835	846	857	868	879	890	901	912	923	934	945	956	967	978	989	1000																																					
1,0	20,6	28,9	35,8	42,1	53,2	23,0	33,2	42,0	50,2	65,5	80,0	87,0	101	114	127	140	153	166	179	192	205	218	231	244	257	270	283	296	309	322	335	348	361	374	387	400	413	426	439	452	465	478	491	504	517	530	543	556	569	582	595	608	621	634	647	660	673	686	699	712	725	738	751	764	777	790	803	816	829	842	855	868	881	894	907	920	933	946	959	972	985	998																																																			
	1,0	4,0	6,5	10		1,0	4,0	6,5	10	15	25	40	65	100	150	200	250	300	350	400	450	500	550	600	650	700	750	800	850	900	950	1000	1050	1100	1150	1200	1250	1300	1350	1400	1450	1500	1550	1600	1650	1700	1750	1800	1850	1900	1950	2000	2050	2100	2150	2200	2250	2300	2350	2400	2450	2500	2550	2600	2650	2700	2750	2800	2850	2900	2950	3000	3050	3100	3150	3200	3250	3300	3350	3400	3450	3500	3550	3600	3650	3700	3750	3800	3850	3900	3950	4000	4050	4100	4150	4200	4250	4300	4350	4400	4450	4500	4550	4600	4650	4700	4750	4800	4850	4900	4950	5000																					

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

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

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																		Cumulative sample size
		< 0,65	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	> 65						
		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	20	▽	0 1			1 2	2 3	3 4	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	Δ	20		
Double	13	▽	*			0 2	0 3	1 4	2 5	3 7	3 7	5 9	6 10	7 11	9 14	11 16	Δ	13		
	26					1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27		26		
Multiple	5	▽	*			#	2	#	3	#	4	0 4	0 4	0 5	0 6	1 7	2 9	Δ	5	
	10					#	2	0 3	0 3	1 5	1 6	2 7	3 8	3 9	4 10	6 12	7 14	10		
	15					0 2	0 3	1 4	2 6	3 8	4 9	6 10	7 12	8 13	11 17	13 19		15		
	20					0 3	1 4	2 5	3 7	5 10	6 11	8 13	10 15	12 17	16 22	19 25		20		
	25					1 3	2 4	3 6	5 8	7 11	9 12	11 15	14 17	17 20	22 25	25 29		25		
	30					1 3	3 5	4 6	7 9	10 12	12 14	14 17	18 20	21 23	27 29	31 33		30		
	35					2 3	4 5	6 7	9 10	13 14	14 15	18 19	21 22	25 26	32 33	37 38		35		
		< 1,0	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	> 65							
		Acceptable quality levels (tightened inspection)																		

△ = 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

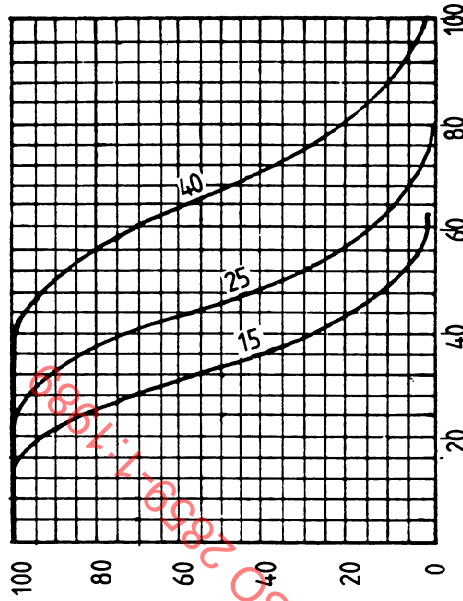
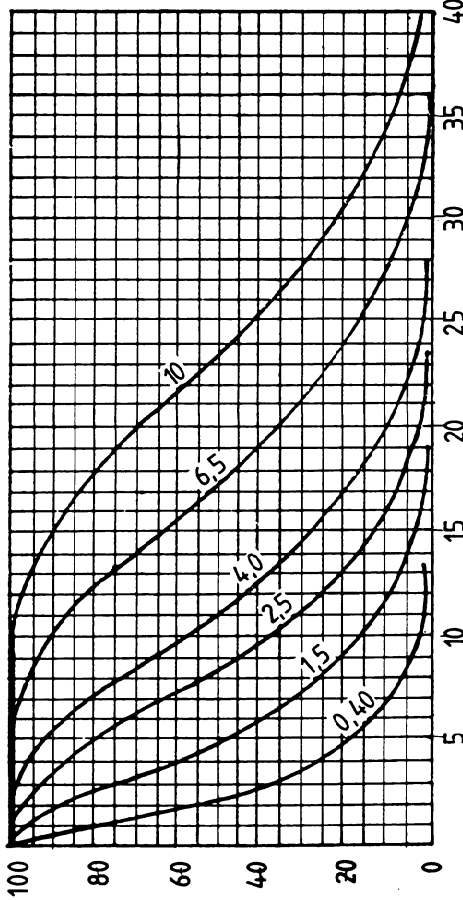
* = Use single sampling plan above (or alternatively use code letter J).

= Acceptance not permitted at this sample size.

Table X-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)

Percentage of lots
expected to be
accepted (P_a)



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

NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)														
	p (in percent nonconforming)														
	0,40	1,5	2,5	4,0	6,5	10	15	20	25	30	35	40	45	50	60
99,0	0,031 4	0,471	1,40	2,67	5,88	9,73	0,031 4	0,464	1,36	2,57	5,58	9,08	11,0	14,9	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	14,7	19,3	24,0
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	21,9	27,0
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	26,9	32,6
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	33,3	39,6
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	40,7	47,6
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	48,1	55,6
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	53,0	60,8
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	63,0	71,3
	0,65	2,5	4,0	6,5	10		0,65	2,5	4,0	6,5	10		15	25	40
Acceptable quality levels (tightened inspection)															
99,0	0,031 4	0,471	1,40	2,67	5,88	9,73	0,031 4	0,464	1,36	2,57	5,58	9,08	11,0	14,9	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	14,7	19,3	24,0
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	21,9	27,0
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	26,9	32,6
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	33,3	39,6
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	40,7	47,6
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	48,1	55,6
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	53,0	60,8
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	63,0	71,3
	0,65	2,5	4,0	6,5	10		0,65	2,5	4,0	6,5	10		15	25	40

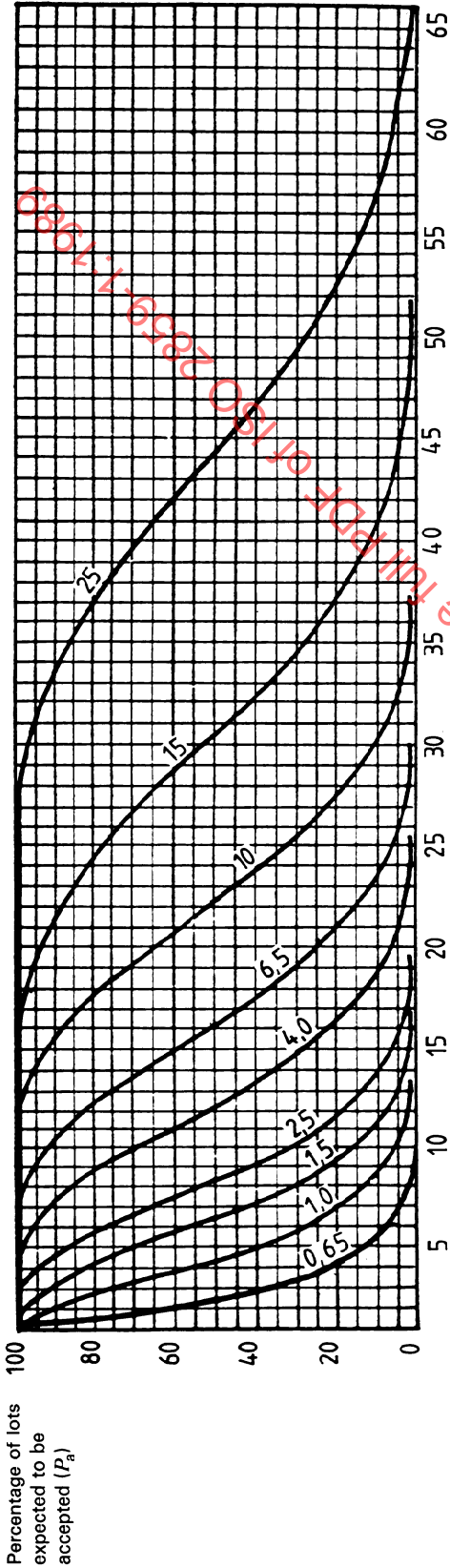
NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																Cumulative sample size
		< 0,40 Ac Re	0,40 Ac Re	0,65 Ac Re	1,0 Ac Re	1,5 Ac Re	2,5 Ac Re	4,0 Ac Re	6,5 Ac Re	10 Ac Re	15 Ac Re	25 Ac Re	40 Ac Re	> 40 Ac Re				
Single	32	▽	0 1														32	
Double	20	▽	*														20	
	40																40	
Multiple	8	▽	*														8	
	16																16	
	24																24	
	32																32	
	40																40	
	48																48	
	56																56	
		< 0,65	0,65		1,0	1,5		4,0	6,5	10		15		25		40	> 40	
		Acceptable quality levels (tightened inspection)																

Δ	=	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 K).
#	=	Acceptance not permitted at this sample size.

Table X-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)



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

NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)															Acceptable quality levels (tightened inspection)														
	p (in percent nonconforming)															p (in nonconformities per 100 units)														
	0,25	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400	0,25	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400
99,0	0,020 1	0,300	0,886	1,68	3,69	6,07	7,36	10,1	0,020 1	0,297	0,872	1,65	3,57	5,81	7,01	9,54	12,2	15,0	20,7	25,1	25,1	25,1	25,1	25,1	25,1	25,1	25,1	25,1	25,1	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	12,3	15,4	18,5	24,9	29,8	29,8	29,8	29,8	29,8	29,8	29,8	29,8	29,8	29,8	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	17,3	20,6	27,3	32,5	32,5	32,5	32,5	32,5	32,5	32,5	32,5	32,5	32,5	32,5
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	24,5	31,8	37,4	37,4	37,4	37,4	37,4	37,4	37,4	37,4	37,4	37,4	37,4
50,0	1,38	3,33	5,31	7,29	11,3	15,2	17,2	21,2	1,39	3,36	5,35	7,34	11,3	15,3	17,3	21,3	25,3	29,3	37,3	43,3	43,3	43,3	43,3	43,3	43,3	43,3	43,3	43,3	43,3	43,3
25,0	2,73	5,29	7,69	10,0	14,5	18,8	21,0	25,2	2,77	5,39	7,84	10,2	14,8	19,4	21,6	26,0	30,4	34,8	43,5	49,9	49,9	49,9	49,9	49,9	49,9	49,9	49,9	49,9	49,9	49,9
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	40,3	49,5	56,4	56,4	56,4	56,4	56,4	56,4	56,4	56,4	56,4	56,4	56,4
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	43,8	53,4	60,5	60,5	60,5	60,5	60,5	60,5	60,5	60,5	60,5	60,5	60,5
1,0	8,00	12,6	15,8	18,7	24,2	29,2	31,7	36,3	9,21	13,3	16,8	20,1	26,2	32,0	34,8	40,3	45,6	50,9	61,2	68,7	68,7	68,7	68,7	68,7	68,7	68,7	68,7	68,7	68,7	68,7
0,40	15,8	24,2	29,2	31,7	36,3	40,3	45,6	50,9	15,8	24,2	29,2	31,7	36,3	40,3	45,6	50,9	61,2	68,7	75,0	80,0	80,0	80,0	80,0	80,0	80,0	80,0	80,0	80,0	80,0	80,0

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

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

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																		Cumulative sample size
		< 0,25	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	> 25						
		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	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	△	50		
Double	32	▽	*			0 2	0 3	1 4	2 5	3 7	3 7	5 9	6 10	7 11	9 14	11 16	△	32		
	64					1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27	64			
Multiple	13	▽	*			# 2	# 2	# 3	# 4	0 4	0 4	0 5	0 6	1 7	1 8	2 9	△	13		
	26					# 2	0 3	0 3	1 5	1 6	2 7	3 8	3 9	4 10	6 12	7 14	26			
	39					0 2	0 3	1 4	2 6	3 8	4 9	6 10	7 12	8 13	11 17	13 19	39			
	52					0 3	1 4	2 5	3 7	5 10	6 11	8 13	10 15	12 17	16 22	19 25	52			
	65					1 3	2 4	3 6	5 8	7 11	9 12	11 15	14 17	17 20	22 25	25 29	65			
	78					1 3	3 5	4 6	7 9	10 12	12 14	14 17	18 20	21 23	27 29	31 33	78			
	91					2 3	4 5	6 7	9 10	13 14	14 15	18 19	21 22	25 26	32 33	37 38	91			
		< 0,40	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	△	> 25						
		Acceptable quality levels (tightened inspection)																		

△ = 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.

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

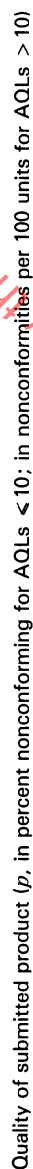


Table X-J-1 – Tabulated values for operating characteristic curves for single sampling plans

NOTE — Binomial distribution used for percent nonconforming computations; Poisson for nonconformities per 100 units.

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

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)															Cumulative sample size	
		< 0,15	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	> 15				
		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	80	▽	0 1			1 2	2 3	3 4	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	Δ	80
Double	50	▽	*			0 2	0 3	1 4	2 5	3 7	3 7	5 9	6 10	7 11	9 14	11 16	Δ	50
	100				Use code letter H	1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27		100
Multiple	20	▽	*		Use code letter L	# 2	# 2	# 3	# 4	0 4	0 4	0 5	0 6	1 7	1 8	2 9	Δ	20
	40					# 2	0 3	0 3	1 5	1 6	2 7	3 8	3 9	4 10	6 12	7 14		40
	60					0 2	0 3	1 4	2 6	3 8	4 9	6 10	7 12	8 13	11 17	13 19		60
	80					0 3	1 4	2 5	3 7	5 10	6 11	8 13	10 15	12 17	16 22	19 25		80
	100					1 3	2 4	3 6	5 8	7 11	9 12	11 15	14 17	17 20	22 25	25 29		100
	120					1 3	3 5	4 6	7 9	10 12	12 14	14 17	18 20	21 23	27 29	31 33		120
	140					2 3	4 5	6 7	9 10	13 14	14 15	18 19	21 22	25 26	32 33	37 38		140
		< 0,25	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	> 15					
Acceptable quality levels (tightened inspection)																		

△ = 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

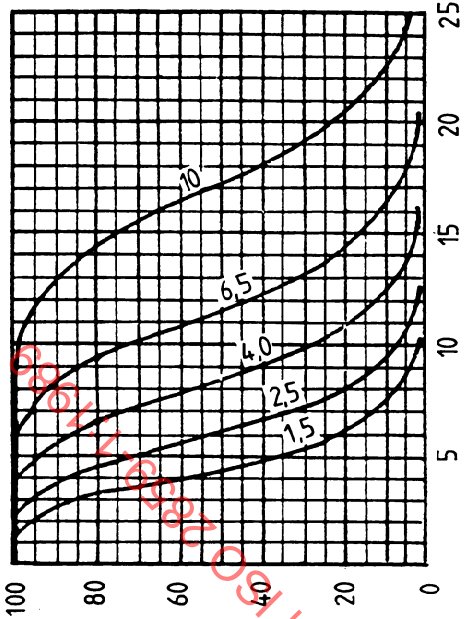
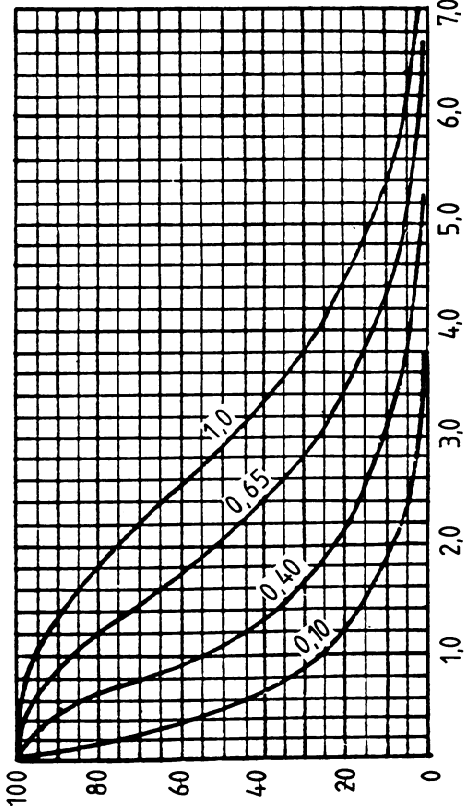
* = Use single sampling plan above (or alternatively use code letter M).

= Acceptance not permitted at this sample size.

Table X-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)

Percentage of lots
expected to be
accepted (P_a)



Quality of submitted product in percent nonconforming or in nonconformities per 100 units

NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)									
	p (in percent nonconforming or nonconformities per 100 units)									
	0,10	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	
99,0	0,008 04	0,119	0,349	0,659	1,43	2,32	2,81	3,82	4,88	5,98
95,0	0,041 0	0,284	0,654	1,09	2,09	3,18	3,76	4,94	6,15	7,40
90,0	0,084 3	0,425	0,882	1,40	2,52	3,72	4,35	5,62	6,92	8,24
75,0	0,230	0,769	1,38	2,03	3,38	4,76	5,47	6,90	8,34	9,79
50,0	0,555	1,34	2,14	2,94	4,54	6,14	6,94	8,53	10,1	11,7
25,0	1,11	2,15	3,14	4,09	5,94	7,75	8,64	10,4	12,2	13,9
10,0	1,84	3,11	4,26	5,34	7,42	9,42	10,4	12,3	14,2	16,1
5,0	2,40	3,80	5,04	6,20	8,41	10,5	11,5	13,6	15,6	17,5
1,0	3,68	5,31	6,72	8,04	10,5	12,8	13,9	16,1	18,3	20,4
0,15		0,65	1,0	1,5	2,5		4,0		6,5	10

NOTE — All the values given in the table above are based on Poisson distribution as an approximation to the binomial distribution.

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

Type of sampling plan	Cumulative sample size	Acceptable quality levels (normal inspection)																Cumulative sample size		
		< 0,10	0,10	0,15		0,25	0,40	0,65	1,0	1,5	2,5			4,0		6,5			10	> 10
		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
Single	125	▽	0 1				1 2	2 3	3 4	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	△	125	
Double	80	▽	*				0 2	0 3	1 4	2 5	3 7	3 7	5 9	6 10	7 11	9 14	11 16	△	80	
	160						1 2	3 4	4 5	6 7	8 9	11 12	12 13	15 16	18 19	23 24	26 27		160	
Multiple	32	▽	*	Use code letter J	Use code letter M	Use code letter L	# 2	# 2	# 3	# 4	0 4	0 4	0 5	0 6	1 7	1 8	2 9	△	32	
	64						# 2	0 3	0 3	1 5	1 6	2 7	3 8	3 9	4 10	6 12	7 14		64	
	96						0 2	0 3	1 4	2 6	3 8	4 9	6 10	7 12	8 13	11 17	13 19		96	
	128						0 3	1 4	2 5	3 7	5 10	6 11	8 13	10 15	12 17	16 22	19 25		128	
	160						1 3	2 4	3 6	5 8	7 11	9 12	11 15	14 17	17 20	22 25	25 29		160	
	192						1 3	3 5	4 6	7 9	10 12	12 14	14 17	18 20	21 23	27 29	31 33		192	
	224						2 3	4 5	6 7	9 10	13 14	14 15	18 19	21 22	25 26	32 33	37 38		224	
		< 0,15	0,15		0,25	0,40	0,65	1,0	1,5	2,5				4,0	6,5			> 10		
		Acceptable quality levels (tightened inspection)																		

△ = 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

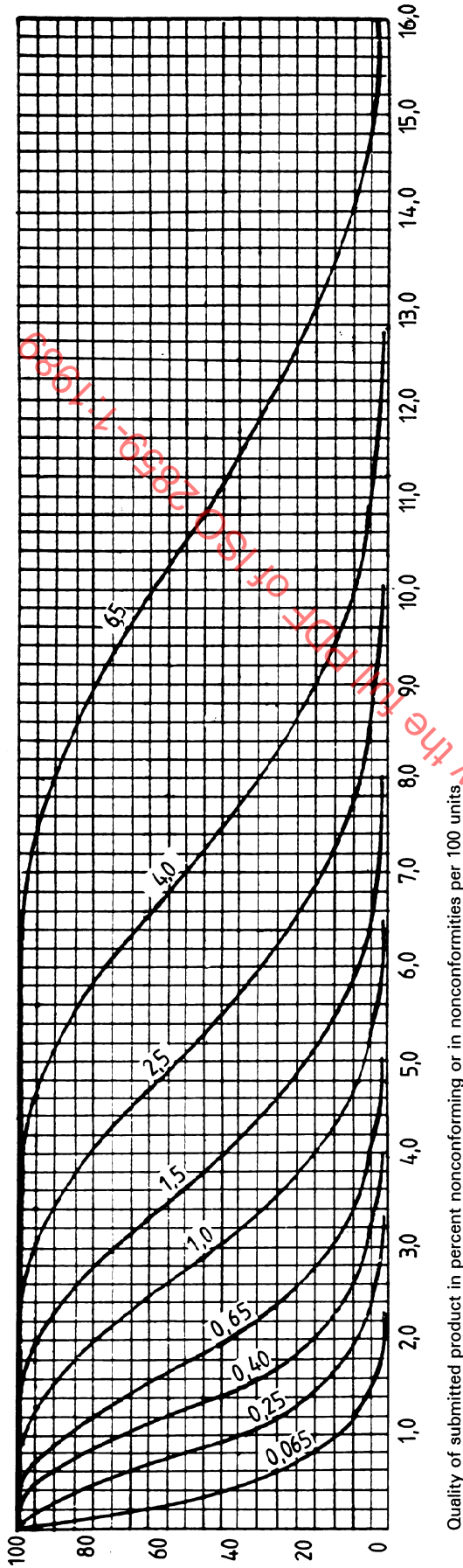
* = Use single sampling plan above (or alternatively use code letter N).

= Acceptance not permitted at this sample size.

Table X-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)

Percentage of lots
expected to be
accepted (P_a)



Quality of submitted product in percent nonconforming or in nonconformities per 100 units

NOTE — Values on curves are Acceptable Quality Levels (AQLs) for normal inspection.

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

P_a	Acceptable quality levels (normal inspection)											
	0,065	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5			
	p (in percent nonconforming or nonconformities per 100 units)											
99,0	0,005 03	0,074 3	0,218	0,412	0,893	1,45	1,75	2,39	3,05	3,74	5,17	6,29
95,0	0,025 6	0,178	0,409	0,683	1,31	1,99	2,35	3,08	3,84	4,62	6,22	7,45
90,0	0,052 7	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	2,98	3,42	4,31	5,21	6,12	7,95	9,34
50,0	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	0,693	1,35	1,96	2,55	3,71	4,84	5,40	6,51	7,61	8,70	10,9	12,5
10,0	1,15	1,94	2,66	3,34	4,64	5,89	6,50	7,70	8,89	10,1	12,4	14,1
5,0	1,50	2,37	3,15	3,88	5,26	6,57	7,22	8,48	9,72	10,9	13,3	15,1
1,0	2,30	3,32	4,20	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	10,0	15,0	20,0	25,0
	Acceptable quality levels (tightened inspection)											

NOTE — All the values given in the table above are based on Poisson distribution as an approximation to the binomial distribution.