

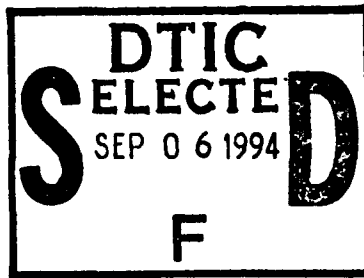
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MILITARY STANDARD

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES



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SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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FOREWORD

This publication provides sampling procedures and reference tables for use in planning and conducting inspection by attributes. The sampling concept is based on the probabilistic recurrence of events when a series of lots or batches are produced in a stable environment.

This publication should be used to guide the user in the development of an inspection strategy that provides a cost effective approach to attaining confidence in product compliance with contractual technical requirements. The user is warned of the assumed risks relative to the chosen sample size and AQL.

Military specifications should not contain requirements for use of specific sampling plans, nor should they provide AQL's or LTPD's as a requirement.

Sampling plans for continuous, rather than lot inspection, are contained in MIL-STD-1235, "Single and Multi-Level Continuous Sampling Procedures and Tables for Inspection by Attributes".

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SAMPLING PROCEDURES AND TABLES
FOR INSPECTION BY ATTRIBUTES

1. SCOPE

1.1 Purpose. This publication establishes lot or batch sampling plans and procedures for inspection by attributes. This publication shall not be interpreted to supercede or conflict with any contractual requirements. The words "accept", "acceptance", "acceptable", etc, refer only to the contractor's use of the sampling plans contained in this standard and do not imply an agreement by the Government to accept any product. Determination of acceptability by the Government shall be as described in contractual documents. The sampling plans described in this standard are applicable to AQL's of .01 percent or higher and are therefore not suitable for applications where quality levels in the defective parts per million range can be realized.

1.2 Application. Sampling plans designated in this publication are applicable, but not limited, to inspection of the following:

- a. End items.
- b. Components and raw materials.
- c. Operations or services.
- d. Materials in process.
- e. Supplies in storage.
- f. Maintenance operations.
- g. Data or records.
- h. Administrative procedures.

These plans are intended primarily to be used for a continuing series of lots or batches. The plans may also be used for the inspection of isolated lots or batches, but, in this latter case, the user is cautioned to consult the operating characteristic curves to find a plan which will yield the desired protection (See 4.11).

2. REFERENCED DOCUMENTS

2.1 Not applicable.

3. DEFINITIONS

3.1 Acceptable Quality Level (AQL). When a continuous series of lots is considered, the AQL is the quality level which, for the purposes of sampling inspection, is the limit of a satisfactory process average (See 3.19).

NOTE: A sampling plan and an AQL are chosen in accordance with the risk assumed. Use of a value of AQL for a certain defect or group of defects indicates that the sampling plan will accept the great majority of the lots or batches provided the process average level of percent defective (or defects per hundred units) in these lots or batches be no greater than the designated value of AQL. Thus, the AQL is a designated value of percent defective (or defects per hundred units) for which lots will be accepted most of the time by the sampling procedure being used. The sampling plans provided herein are so arranged that the probability of acceptance at the designated AQL value depends upon the sample size, being generally higher for large samples than for small ones, for a given AQL. The AQL alone does not identify the chances of accepting or rejecting individual lots or batches but more directly relates to what might be expected from a series of lots or batches, provided the steps indicated in this publication are taken. It is necessary to refer to the operating characteristic curve of the plan to determine the relative risks.

3.2 Average Outgoing Quality (AOQ). For a particular process average, the AOQ is the average quality of outgoing product including all accepted lots or batches, plus all rejected lots or batches after the rejected lots or batches have been effectively 100 percent inspected and all defectives replaced by non-defectives.

3.3 Average Outgoing Quality Limit (AOQL). The AOQL is the maximum AOQ for a given acceptance sampling plan. Factors for computing 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.

3.4 Classification of Defects. A classification of defects is the enumeration of possible defects of the unit of product classified according to their seriousness.

3.5 Critical Defect. A critical defect is a defect that judgement and experience indicate would result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product, or a defect that judgement and experience indicate is likely to prevent performance of the tactical function of a major end item such as a ship, aircraft, tank, missile, or space vehicle.

3.6 Critical Defective. A critical defective is a unit of product which contains one or more critical defects and may also contain major and/or minor defects.

3.7 Defect. A defect is any nonconformance of the unit of product with specified requirements.

3.8 Defective. A defective is a unit of product which contains one or more defects.

3.9 Defects per Hundred Units. The number of defects per hundred units of any given quantity of units of product is one hundred times the number of defects contained therein (one or more defects being possible in any unit of product) divided by the total number of units of product, i.e.:

$$\text{Defects per hundred units} = \frac{\text{Number of defects} \times 100}{\text{Number of units inspected}}$$

3.10 Inspection. Inspection is the process of measuring, examining, testing, or otherwise comparing the unit of product with the requirements.

3.11 Inspection by Attributes. Inspection by attributes is inspection whereby either the unit of product is classified simply as defective or non-defective, or the number of defects in the unit of product is counted, with respect to a given requirement or set of requirements.

3.12 Lot or Batch. The term lot or batch shall mean "inspection lot" or "inspection batch", i.e., a collection of units of product from which a sample is to be drawn and inspected and may differ from a collection of units designated as a lot or batch for other purposes (e.g., production, shipment, etc.).

3.13 Lot or Batch Size. The lot or batch size is the number of units of product in a lot or batch.

3.14 Major Defect. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

3.15 Major Defective. A major defective is a unit of product which contains one or more major defects, and may also contain minor defects but contains no critical defect.

3.16 Minor Defect. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.

3.17 Minor Defective. A minor defective is a unit of product which contains one or more minor defects but contains no critical or major defect.

3.18 Percent Defective. The percent defective of any given quantity of units of product is one hundred times the number of defective units of product contained therein divided by the total number of units of product, i.e.:

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

3.19 Process Average. The process average is the average percent defective or average number of defects per hundred units (whichever is applicable) of product submitted by the supplier for original inspection. Original inspection is the first inspection of a particular quantity of product as distinguished from the inspection of product which has been resubmitted after prior rejection.

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

3.21 Sample Size Code Letter. The sample size code letter is a device used along with the AQL for locating a sampling plan on a table of sampling plans.

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

3.23 Unit of Product. The unit of product is the thing inspected in order to determine its classification as defective or non-defective or to count the number of defects. It may be a single article, a pair, a set, a length, an area, an operation, a volume, a component of an end product, or the end product itself. The unit of product may or may not be the same as the unit of purchase, supply, production, or shipment.

4. GENERAL REQUIREMENTS

4.1 Written Procedures. Written procedures are ordinarily developed and made available for the Government representative's review, upon request. When the written procedures indicate use of this standard, they shall comply with the requirements of this standard and reference appropriate parts as necessary.

4.2 Nonconformance. The extent of nonconformance of product shall be expressed either in terms of percent defective or in terms of defects per hundred units.

4.3 Formation and Identification of Lots or Batches. The product shall be assembled into identifiable lots, sublots, batches, or in such other manner as may be prescribed. Each lot or batch 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. The lots or batches shall be identified by the contractor and shall be kept intact in adequate and suitable storage space.

4.4 AQL.

4.4.1 AQL Use. The AQL, together with the Sample Size Code Letter, is used for indexing the sampling plans provided herein.

4.4.2 Limitation. The selection or use of an AQL shall not imply that the contractor has the right to supply any defective unit of product.

4.4.3 Choosing AQLs. Different AQLs may be chosen for groups of defects considered collectively, or for individual defects. An AQL for a group of defects may be chosen in addition to AQLs for individual defects, or subgroups, within that group. AQL values of 10.0 or less may be expressed either in percent defective or in defects per hundred units; those over 10.0 shall be expressed in defects per hundred units only.

4.5 Sampling.

4.5.1 Representative (Stratified) Sampling. When appropriate, the number of units in the sample shall be selected in proportion to the size of sublots or sub-batches, or parts of the lot or batch, identified by some rational criterion. When representative sampling is used, the units from each subplot, sub-batch or part of the lot or batch shall be selected at random.

4.5.2 Time of Sampling. A sample may be drawn after all the units comprising the lot or batch have been assembled, or sample units may be drawn during assembly of the lot or batch, in which case the size of the lot or batch will be determined before any sample units are drawn. If the sample units are drawn during assembly of the lot or batch, and if the rejection number is reached before the lot is completed, that portion of the lot already completed shall be rejected. The cause of the defective product shall be determined and corrective action taken, after which a new lot or batch shall be begun.

4.5.3 Double or Multiple Sampling. When double or multiple sampling is to be used, each sample shall be selected over the entire lot or batch.

4.6 Inspection Procedures. Normal inspection will be used at the start of inspection. Normal, tightened or reduced inspection shall continue unchanged for each class of defects or defectives on successive lots or batches except where the switching procedures given below require change. The switching procedures shall be applied to each class of defects or defectives independently.

4.7 Switching Procedures.

4.7.1 Normal to Tightened. When normal inspection is in effect, tightened inspection shall be instituted when 2 out of 2, 3, 4, or 5 consecutive lots or batches have been rejected on original inspection (i.e., ignoring resubmitted lots or batches for this procedure).

4.7.2 Tightened to Normal. When tightened inspection is in effect, normal inspection shall be instituted when 5 consecutive lots or batches have been considered acceptable on original inspection.

4.7.3 Normal to Reduced. When normal inspection is in effect, reduced inspection shall be instituted provided that all of the following conditions are satisfied:

a. The preceding 10 lots or batches (or more, as indicated by the note to Table VIII) have been on normal inspection and all have been accepted on original inspection; and

b. The total number of defectives (or defects) in the samples from the preceding 10 lots or batches (or such other number as was used for condition "a" above) is equal to or less than the applicable number given in Table VIII. If double or multiple sampling is in use, all samples inspected should be included, not "first" samples only; and

c. Production is at a steady rate; and

d. Reduced inspection is considered desirable.

4.7.4 Reduced to Normal. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:

a. A lot or batch is rejected; or

b. A lot or batch is considered acceptable under the procedures of 4.10.1.4, or

c. Production becomes irregular or delayed; or

d. Other conditions warrant that normal inspection shall be instituted.

4.8 Discontinuation of Inspection. If the cumulative number of lots not accepted in a sequence of consecutive lots on original tightened inspection reaches five, the acceptance procedures of this standard shall be discontinued. Inspection under the provisions of this standard shall not be resumed until corrective action has been taken. Tightened inspection shall then be used as if 4.7.1 had been invoked.

4.9 Sampling Plans.

4.9.1 Inspection Level. The inspection level determines the relationship between the lot or batch size and the sample size. The inspection level to be used for any particular requirement will be as prescribed by the contractor's written procedures. Three inspection levels: I, II, and III, are given in Table I for general use (see 4.1). Normally, Inspection Level II is used. However, Inspection Level I may be used when less discrimination is needed, or Level III may be used for greater discrimination. Four additional special levels: S-1, S-2, S-3, and S-4, are given in the same table and may be used where relatively small sample sizes are necessary and large sampling risks can or must be tolerated.

NOTE: In the selection of inspection levels S-1 to S-4, care must 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 when 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 choose S-1 if the AQL is 0.10 percent for which the minimum sample is 125.

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

4.9.3 Obtaining Sampling Plan. The AQL and the 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 code letter, the tables direct the user to a different letter. The sample size to be used is given by the new code letter, not by the original letter. If this procedure leads to different sample sizes for different classes of defects, the code letter corresponding to the largest sample size derived may be used for all classes of defects. 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.

4.9.4 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 code letter, any one may be used. A decision as to type of plan, either single, double, or multiple, when available for a given AQL and code letter, will usually be based upon the comparison between the administrative difficulty and the average sample sizes of the available plans. The average sample size of multiple plans is less than for double (except in the case corresponding to single acceptance number 1) and both of these are always less than a single sample size (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.

4.10 Determination of Acceptability.

4.10.1 Percent Defective Inspection. To determine acceptability of a lot or batch under percent defective inspection, the applicable sampling plan shall be used in accordance with 4.10.1.1, 4.10.1.2, 4.10.1.3, and 4.10.1.4.

4.10.1.1 Single Sampling Plan. The number of sample units inspected shall be equal to the sample size given by the plan. If the number of defectives found in the sample is equal to or less than the acceptance number, the lot or batch shall be considered acceptable. If the number of defectives is equal to or greater than the rejection number, the lot or batch shall be rejected.

4.10.1.2 Double Sampling Plan. A number of sample units equal to the first sample size given by the plan shall be inspected. If the number of defectives found in the first sample is equal to or less than the first acceptance number, the lot or batch shall be considered acceptable. If the number of defectives found in the first sample is equal to or greater than the first rejection number, the lot or batch shall be rejected. If the number of defectives found in the first sample is between the first acceptance and rejection numbers, a second sample of the same size shall be inspected. The number of defectives found in the first and second samples shall be accumulated. If the cumulative number of defectives is equal to or less than the second acceptance number, the lot or batch shall be considered acceptable. If the cumulative number of defectives is equal to or greater than the second rejection number, the lot or batch shall be rejected.

4.10.1.3 Multiple Sample Plan. Under multiple sampling, the procedure shall be similar to that specified in 4.10.1.2, except that the number of successive samples required to reach a decision may be as many as seven.

4.10.1.4 Special Procedure for Reduced Inspection. Under reduced inspection, the sampling procedure may terminate without either acceptance or rejection criteria having been met. In these circumstances, the lot or batch will be considered acceptable, but normal inspection will be reinstated starting with the next lot or batch (see 4.7.4.b).

4.10.2 Defects per Hundred Units Inspection. To determine the acceptability of a lot or batch under defects per hundred units inspection, the procedure specified for percent defective inspection above shall be used, except that the word "defects" shall be substituted for "defectives".

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

4.12 Curves.

4.12.1 Operating Characteristic Curves. The operating characteristic curves for normal 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 curves shown are for single sampling; curves for double and multiple sampling are matched as closely as practicable. The O.C. curves shown for AQLs greater than 10.0 are based on the Poisson distribution and are applicable for defects per hundred units inspection; those for AQLs of 10.0 or less and sample sizes of 80 or less are based on the binomial distribution and are applicable for percent defective inspection; those for AQLs of 10.0 or less and sample sizes larger than 80 are based the Poisson distribution and are applicable either for defects per hundred units inspection, or for percent defective inspection (the Poisson distribution being an adequate approximation to the binomial distribution under these conditions). Tabulated values, corresponding to selected values or probabilities of acceptance (P_a , in percent) are given for each of the curves shown, and, in addition, for tightened inspection, and for defects per hundred units for AQLs of 10.0 or less and sample sizes of 80 or less.

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

SECTION 5
TABLES AND CURVES

TABLE I—Sample size code letters

(see 4.9.1 and 4.9.2)

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
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 1200	C	C	E	F	G	J	K
1201 to 3200	C	D	E	G	H	K	L
3201 to 10000	C	D	F	G	J	L	M
10001 to 35000	C	D	F	H	K	M	N
35001 to 150000	D	E	G	J	L	N	P
150001 to 500000	D	E	G	J	M	P	Q
500001 and over	D	E	H	K	N	Q	R

CODE LETTERS

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

(see 4.9.3 and 4.9.4)

Sample size code letter	Sample size	Acceptable Quality Levels (normal inspections)																					
		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	1000	
A	2	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
B	3	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
C	5	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
D	8	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
E	13	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
F	20	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
G	32	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
H	50	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
J	80	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
K	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
L	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
N	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
P	800	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
Q	1250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
R	2000	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→

Use first sampling plan below arrow. If sample size equals, or exceeds, lot or batch size, do 100 percent 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 4.9.3 and 4.9.4)

Sample size code letter	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
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	1250	→																			
R	2000	→																			
S	3150	→																			

Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 Use first sampling plan above arrow.
 Ac Acceptance number.
 Re Rejection number.

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

(see 4.9.3 and 4.9.4)

Sample size code letter	Sample size	Acceptable Quality Levels (reduced 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	1000	
A	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
B	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
C	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
D	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
E	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
F	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
G	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
H	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
J	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
K	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
L	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
M	125	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	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	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
P	315	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
Q	500	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re
R	800	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	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.
 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 reinspect normal inspection (see 4.9.1.2).

SINGLE
REDUCED

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

(see 4.9.3 and 4.9.4)

Sample size code letter	Sample size	Sample size	Acceptable Quality Levels (normal inspection)																						
			0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250
A			↑																						
B	2	2	↑																						
B	2	4	↑																						
C	3	3	↑																						
C	3	6	↑																						
D	5	5	↑																						
D	5	10	↑																						
E	8	8	↑																						
E	8	16	↑																						
F	13	13	↑																						
F	13	26	↑																						
G	20	20	↑																						
G	20	40	↑																						
H	32	32	↑																						
H	32	64	↑																						
I	50	50	↑																						
I	50	100	↑																						
J	80	80	↑																						
J	80	160	↑																						
K	125	125	↑																						
K	125	250	↑																						
L	200	200	↑																						
L	200	400	↑																						
M	315	315	↑																						
M	315	630	↑																						
N	500	500	↑																						
N	500	1000	↑																						
O	800	800	↑																						
O	800	1600	↑																						
P	1250	1250	↑																						
P	1250	2500	↑																						

■ Use first sampling plan below arrow.
 □ Use first sampling plan above arrow.
 Ac Acceptance number
 Re Rejection number
 . Use corresponding single sampling plan for alternativity, use double sampling plan below, where available.

TABLE IV-A—Multiple sampling plans for normal inspection (Master table)
(see 4.9.3 and 4.9.4)

(Continued)

Sample size	Acceptable Quality Level (normal inspection)	Acceptable Quality Levels (normal inspection)																
		0.100	0.075	0.050	0.040	0.030	0.025	0.020	0.015	0.010	0.005	0.0025	0.0015	0.0010	0.0005	0.00025	0.00015	0.00010
A	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
B	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
C	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
D	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
E	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
F	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
G	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
H	First	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Second	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Third	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fourth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Fifth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Sixth	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1

Use first sampling plan below unless...
 Use first sampling plan above unless...
 Acceptance number
 Rejection number
 Use corresponding single sampling plan (see alternative); use multiple plan below where available
 Acceptance and rejection numbers are given in this sample size

MULTIPLE NORMAL

TABLE IV-B—Multiple sampling plans for tightened inspection (Master table)
(see 4.9.3 and 4.9.4)

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	1000
A	First	32	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	44	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	56	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	68	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	80	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	92	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	104	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
L	First	50	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	60	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	70	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	80	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	90	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	100	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	110	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
M	First	80	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	100	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	120	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	140	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	160	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	180	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
N	First	125	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	150	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	175	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	225	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	275	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
P	First	200	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	250	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	300	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	350	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	400	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	450	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
Q	First	315	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	375	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	435	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	495	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	555	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	615	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	675	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
R	First	500	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	600	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	700	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	800	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	900	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	1000	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	1100	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
S	First	800	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Second	960	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Third	1120	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fourth	1280	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Fifth	1440	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Sixth	1600	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→
	Seventh	1760	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→	→

* Use first sampling plan in first arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 * Use first sampling plan in second arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 * Use second sampling plan in third arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 * Use third sampling plan in fourth arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 * Use corresponding single sampling plan (or alternative); see multiple sampling plan tables, where available.
 * Acceptance not permitted at this sample size.

MULTIPLE
TIGHTENED

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

(see 3.3)

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	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
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	1250																										
R	2000																										

• Notes For the exact AOQL, the above values must be multiplied by $(1 - \frac{\text{Sample size}}{\text{Lot or Batch size}})$

AOQL
NORMAL

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

(see 3.3)

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	600	1000	
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	1200																						
R	2000																						
S	3150																						

* Note: For the exact AOQL, the above values must be multiplied by $(1 - \frac{\text{Sample size}}{\text{Lot or Batch size}})$ (see 11.4)

AOQL
TIGHTENED

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

(see 4.11)

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	2.5	4.0	6.5	10	
A	2																	
B	3																	
C	5																	
D	8																	
E	13																	
F	20																	
G	32																	
H	50																	
J	80																	
K	125																	
L	200																	
V	315																	
N	500																	
P	800																	
Q	1250																	
H	2000																	

LQ (DEFECTIVES)
 10.0%

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

(see 4.11)

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	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000		
A	2																		200	270	330	460	590	770	1000	1400	1900		
B	3													46	77			130	180	220	310	390	510	670	940	1300	1800		
C	5																78	110	130	190	240	310	400	560	770	1100			
D	8																49	67	84	120	150	190	250	350	480	670			
E	13																18	29	41	51	71	91	120	160	220	300	410		
F	20																12	20	27	33	46	59	77	100	140				
G	32																	7.2	12	17	21	29	37	48	63	88			
H	50																	4.6	7.8	11	13	19	24	31	40	56			
J	80																		2.9	4.9	6.7	8.4	12	15	19	25	35		
K	125																		1.8	3.1	4.3	5.4	7.4	9.4	12	16	23		
L	200																			1.2	2.0	2.7	3.3	4.6	5.9	7.7	10	14	
M	315																			0.73	1.2	1.7	2.1	2.9	3.7	4.9	6.4	9.0	
N	500																				0.46	0.78	1.1	1.3	1.9	2.4	3.1	4.0	5.6
P	800																				0.29	0.49	0.67	0.84	1.2	1.5	1.9	2.5	3.5
U	1250																				0.18	0.31	0.43	0.53	0.74	0.94	1.2	1.6	2.1
II	2000																				0.20	0.27	0.33	0.46	0.59	0.77	1.0	1.4	

LQ (DEFECTS)
10%

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

(see 4.11)

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	2.5	4.0	6.5	10
A	2																
B	3																
C	5													45	63	78	66
D	8																60
E	13																50
F	20																46
G	32																37
H	50																32
J	80																26
K	125																24
L	200																24
M	315																24
N	500																24
P	800																24
Q	1250																24
R	2000																24

LQ (DEFECTIVES)
5.0%

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

(see 4.11)

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	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
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	1250																										
R	2000																										

LQ (DEFECTS)
5%

TABLE VIII — Limit Numbers for Reduced Inspection

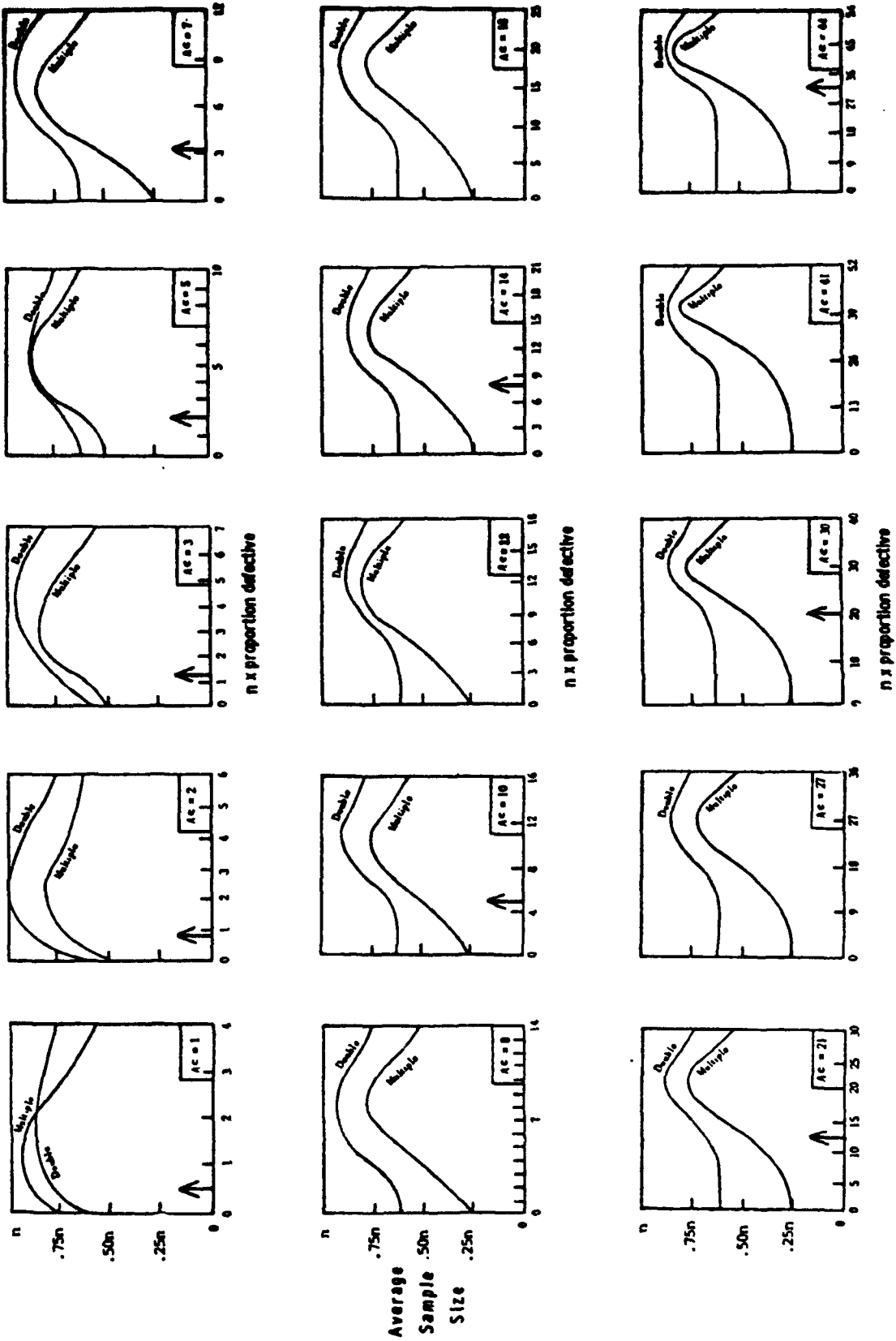
(see 4.7.3)

Number of sample units from lot or batches	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	1000	
20 - 29	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
30 - 49	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
50 - 79	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
80 - 129	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
130 - 199	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
200 - 319	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
320 - 499	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
500 - 799	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
800 - 1249	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
1250 - 1999	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
2000 - 3199	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
3150 - 19999	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
5000 - 7999	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
8000 - 12499	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
12500 - 19999	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
20000 - 31499	0	0	2	4	8	14	22	40	68	115	181																
31500 & Over	0	1	4	8	16	24	38	67	111	186																	

• Provides that the number of sample units from the first ten lots or batches is not sufficient for reduced inspection for this AQL. In this instance more than ten 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 on normal inspection, and that none has been rejected while on original inspection.

TABLE IX — Average sample size curves for double and multiple sampling
(normal and tightened inspection)

(see 4.12.2)

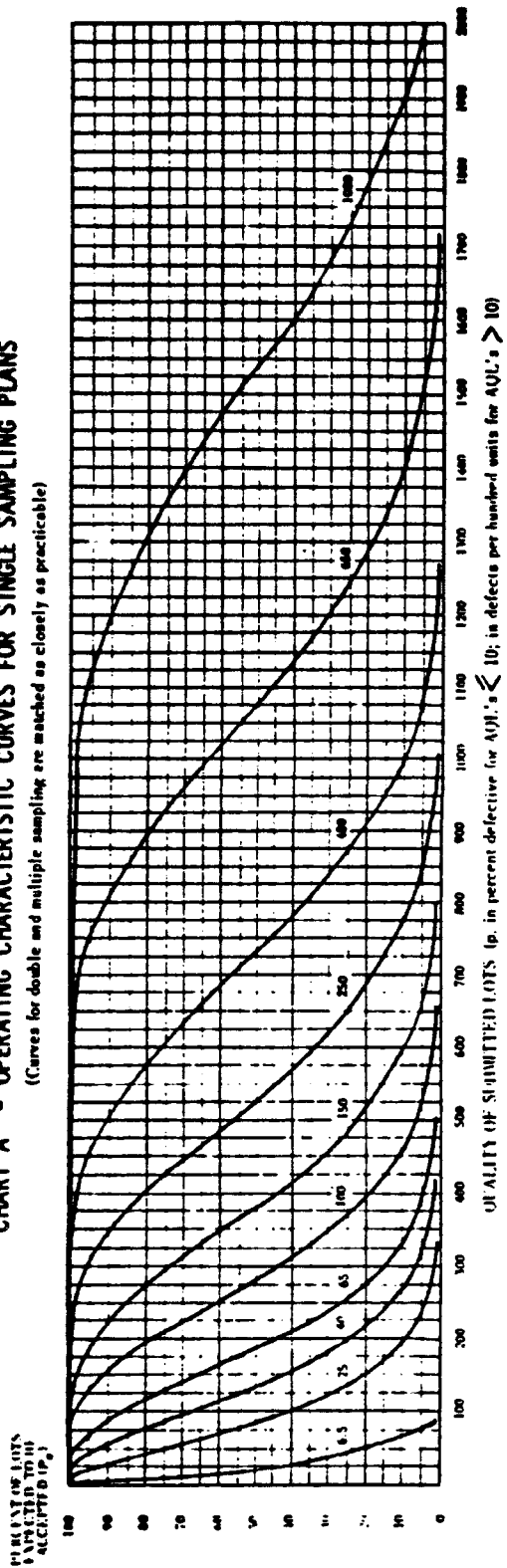


• = Equivalent single sample size
Ac = Single sample acceptance number
↑ = AQL for normal inspection

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

CHART A - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



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

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

P _o	Acceptable Quality Levels (normal inspection)													
	6.5	10	15	20	25	40	65	100	150	250	400	650	1000	
	p (in percent defective)													
99.0	0.503	7.41	21.8	41.2	89.1	145	175	239	305	374	517	629	859	977
95.0	2.56	17.8	40.9	68.3	131	199	235	308	381	462	622	745	995	1122
90.0	5.27	26.6	55.1	87.2	158	233	272	351	432	515	684	812	1073	1206
75.0	11.4	48.1	86.4	127	211	298	342	431	521	612	795	934	1214	1354
50.0	29.3	81.9	134	184	284	383	433	533	633	733	933	1083	1383	1533
25.0	69.3	135	196	255	371	484	540	651	761	870	1087	1248	1548	1728
10.0	115	194	266	334	444	589	650	770	889	1006	1238	1409	1748	1916
5.0	150	237	315	388	526	657	722	848	972	1094	1335	1512	1862	2035
1.0	230	332	420	502	655	800	870	1007	1141	1272	1529	1718	2089	2270
	X	40	65	100	150	X	250	X	400	X	650	X	1000	X
	Acceptable Quality Levels (tightened inspection)													

Note: Binomial distribution used for percent defective computations. Percentages for defects per hundred 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													
		Acceptable Quality Levels (tightened inspection)																																
		Less than 6.5	6.5	10	15	25	40	65	100	150	250	400	650	1000	1000	1000	1000	1000	1000	1000														
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	4	5	5	6	7	8	9	10	10	11	12	13	14	15	16	18	19	21	22	27	28	30	31	2
Double		▽	•		Use code Letter	Use code Letter	Use code Letter	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)		
Multiple		▽	•		Use code Letter	Use code Letter	Use code Letter	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)	(*)		
		Less than 10	10	15	25	40	65	100	150	250	400	650	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000	1000		

▽ = 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

CHART B - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

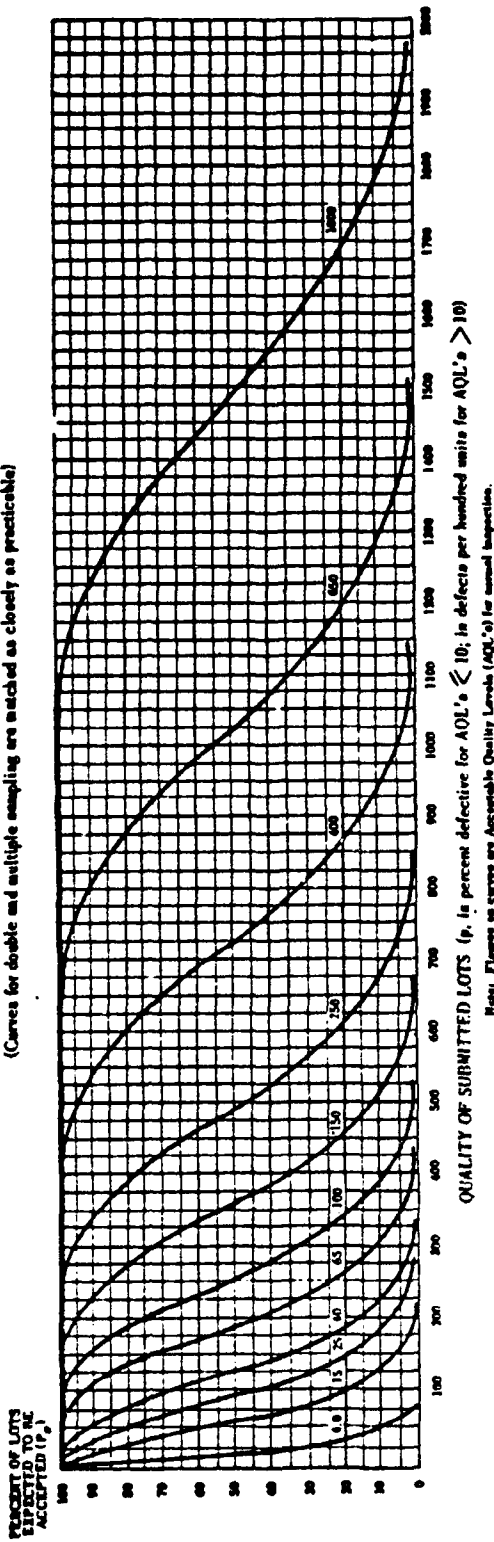


TABLE X-B-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)															
	4.0	15	25	40	65	100	150	200	250	300	400	500	650	1000		
p (in percent defective)	0.334	4.97	14.5	27.4	59.5	96.9	117	159	203	249	345	419	572	651	947	1029
99.0	1.71	11.6	27.3	45.5	87.1	133	157	206	256	308	415	496	663	748	1065	1152
95.0	3.45	17.7	36.7	58.2	105	155	181	234	286	343	456	541	716	804	1131	1222
90.0	9.14	32.0	57.6	84.5	141	199	228	287	347	408	530	623	809	903	1249	1344
75.0	20.6	55.9	89.1	122	189	256	289	356	422	489	622	722	922	1022	1389	1489
50.0	37.0	89.8	131	170	247	323	360	434	507	580	724	832	1045	1152	1539	1644
25.0	53.6	130	177	223	309	392	433	514	593	671	825	939	1165	1271	1683	1793
10.0	61.2	158	210	258	350	438	481	565	648	730	890	1008	1241	1356	1773	1886
5.0	78.5	221	280	335	437	533	580	671	761	848	1019	1145	1392	1513	1951	2069
1.0	6.5	25	40	65	100	150	200	250	300	400	500	650	800	1000	1000	1000

Acceptable Quality Levels (tightened insp.: 100)

Note: Binomial distribution used for percent defective comparisons; Poisson for defects per hundred 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	6.5	10	15	25	40	65	100	150	250	400	650	1000																					
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re																				
Single	3	0	1			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	18	19	21	22	27	28	30	31	41	42	44	45	3		
			Use																																
Double	2	•				0	2	3	4	5	6	7	8	9	10	11	12	13	14	16	17	18	20	21	22	23	29	25	31	2					
	4		Use			1	2	3	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	4
Multiple			Use	A	D	C																													
			Use				10	15	25	40	65	100	150	250	400	650	1000	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
		Less than 4.0																																	
		Less than 6.5																																	

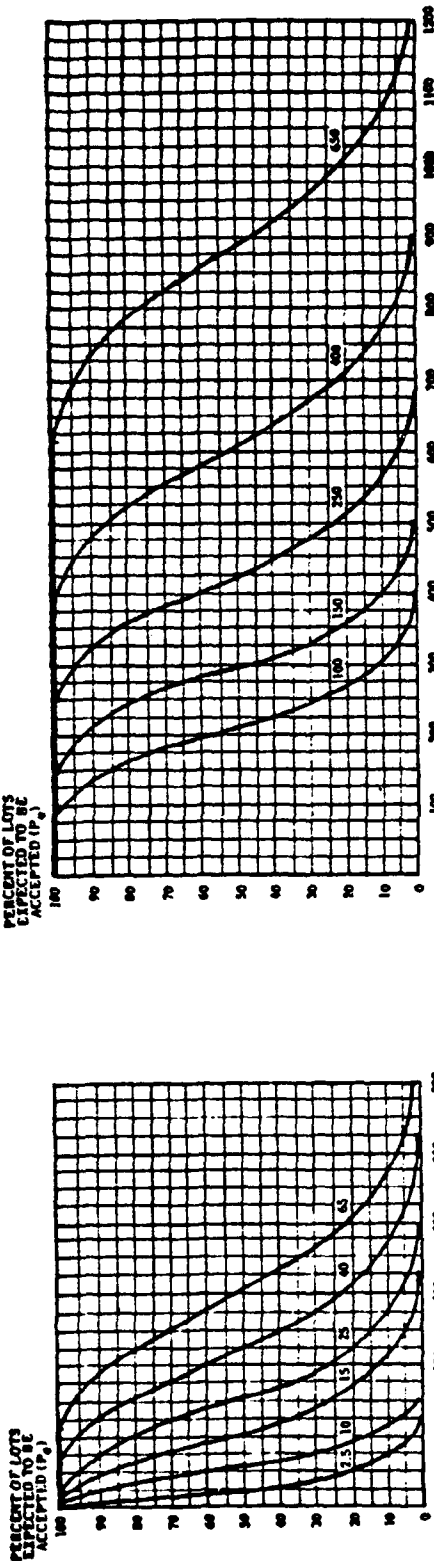
Acceptable Quality Levels (tightened inspection)

- ▽ = 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 alone (or alternatively use code letter E)
- ++ = Use double sampling plan alone (or alternatively use code letter D)

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

CHART C - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



QUALITY OF SUBMITTED LOTS (p_1 in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)
 Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

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

r_c	Acceptable Quality Levels (normal inspection)																
	p (in defects per hundred units)																
	2.5	10	2.5	10	15	25	40	65	100	150	250	400	650				
99.0	0.201	3.27	0.201	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	1.01	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	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	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	893
25.0	24.2	45.4	27.7	53.9	78.4	102	148	194	216	260	304	348	435	499	627	691	986
10.0	36.9	58.4	46.1	77.8	106	134	185	235	260	308	356	403	495	564	699	766	1076
5.0	45.1	65.7	59.9	94.9	126	155	210	263	289	339	389	438	534	605	745	814	1131
1.0	60.2	77.8	92.1	131	168	201	262	320	348	403	456	509	612	687	835	908	1241
4.0	X	X	4.0	15	25	40	65	X	100	X	150	X	250	X	400	X	650

Note: Binomial distribution used for percent defective computations. Patterns for defects per hundred units.

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

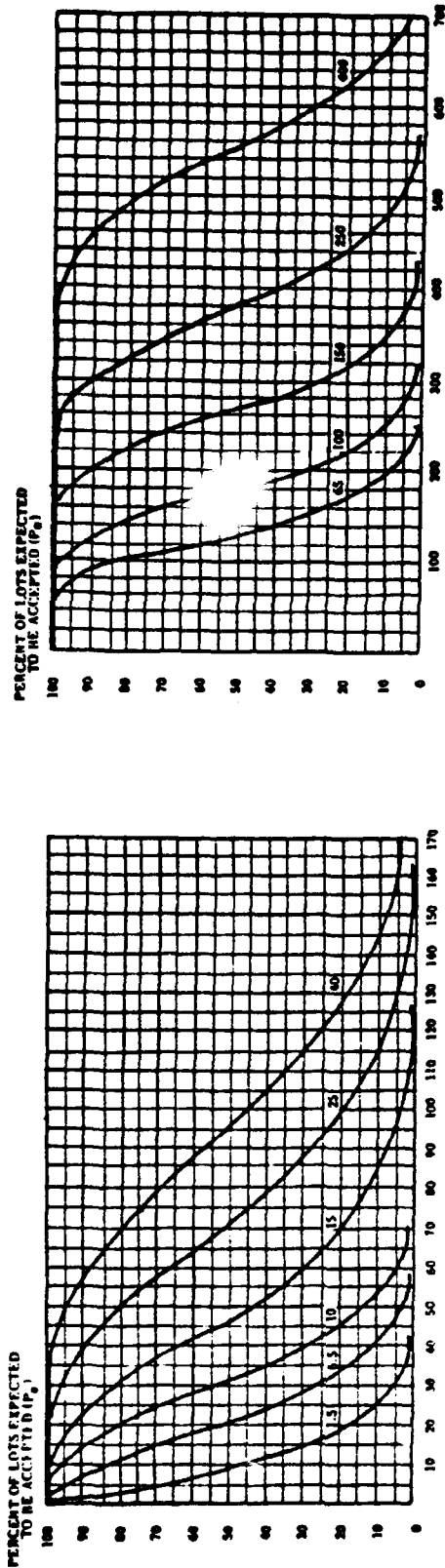
Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (tightened inspection)															Cumulative sample size							
		Less than 2.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000								
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
Single	5	▽	0	1																				
Double	3	▽	•																					
	6																							
Multiple																								
	Less than 4.0																							

▽ = 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

CHART D - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



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

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

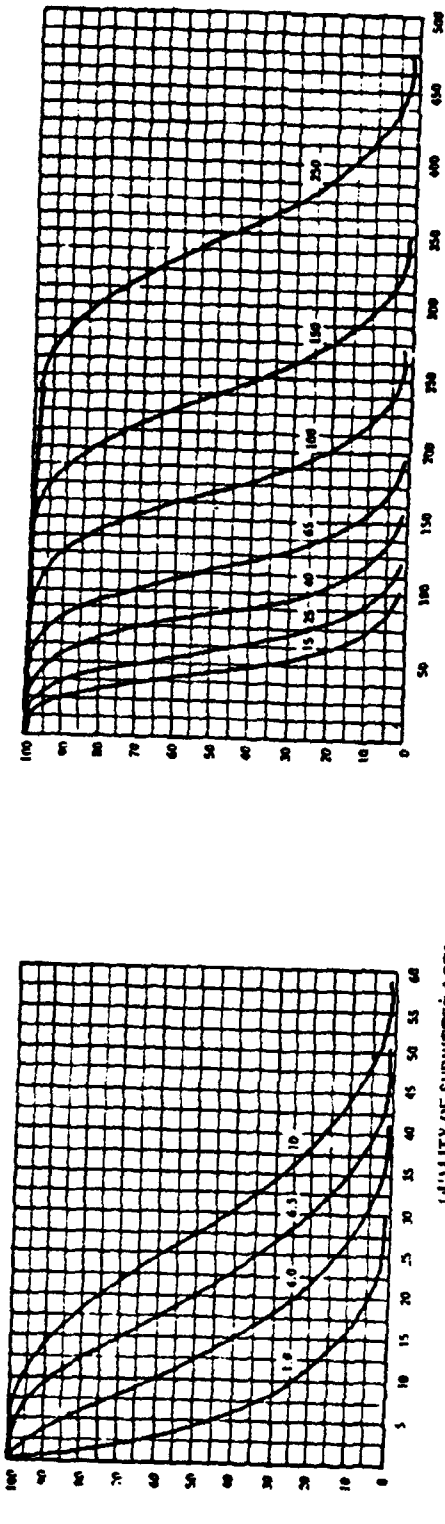
P _a	Acceptable Quality Levels (normal inspection)															
	1.5	6.5	10	15	25	40	65	100	150	215	250	400	400			
	p (in percent defective)															
99.0	0.126	1.97	6.08	10.3	22.3	36.3	43.8	59.6	76.2	93.5	129	157	215	244	355	386
95.0	0.639	4.64	11.1	17.1	32.7	49.8	58.7	77.1	96.1	116	156	186	249	281	399	432
90.0	1.31	6.88	14.7	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	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	45.9	70.9	95.9	108	133	158	183	233	271	346	383	521	558
25.0	15.9	30.3	43.3	63.9	92.8	121	135	163	190	217	272	312	392	432	577	617
10.0	25.0	40.6	53.8	83.5	116	147	162	193	222	252	309	352	437	479	631	672
5.0	31.2	47.1	60.0	96.9	131	164	180	212	243	274	334	378	465	509	665	707
1.0	41.8	59.0	70.7	126	164	200	218	252	285	318	382	429	522	568	732	776
	2.5	10	10	25	40	65	100	150	215	250	400	400	400	400	400	400
	Acceptable Quality Levels (lightened inspection)															

Notes: Binomial distribution used for percent defective computations; Poisson for defects per hundred units.

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

CHART E - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)
 Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

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

P _o	Acceptable Quality Levels (normal inspection)																			
	p (in defects per hundred units)																			
	1.0	4.0	6.5	10	1.0	4.0	6.5	10	15	25	40	65	100	150	250					
99.0	0.077	1.18	3.58	6.75	0.0773	1.15	3.35	6.33	13.7	22.4	27.0	36.7	46.9	57.5	79.6	96.7	132	150	219	238
95.0	0.394	2.81	6.60	11.3	0.395	2.73	6.29	10.5	20.1	30.6	36.1	47.5	59.2	71.1	95.7	115	153	173	246	266
90.0	0.807	4.17	8.80	14.2	0.810	4.09	8.48	13.4	24.2	35.8	41.8	54.0	66.5	79.2	105	125	165	185	261	282
75.0	2.19	7.41	13.4	19.9	2.21	7.39	13.3	19.5	32.5	45.8	52.6	66.3	80.2	94.1	122	144	187	208	288	310
50.0	5.19	12.6	20.0	27.5	5.33	12.9	20.6	28.2	43.6	59.0	66.7	82.1	97.4	113	144	167	213	236	321	344
25.0	10.1	19.4	28.0	36.1	10.7	20.7	30.2	39.3	57.3	74.5	83.1	100	117	134	167	192	241	266	355	379
10.0	16.2	26.8	36.0	44.4	17.7	29.9	40.9	51.4	71.3	90.5	100	119	137	155	190	217	269	295	390	414
5.0	20.6	31.6	41.0	49.5	23.0	36.5	48.4	59.6	80.9	101	111	130	150	168	205	233	286	313	409	435
1.0	29.8	41.3	50.6	58.8	35.4	51.1	64.7	77.3	101	123	134	155	176	196	235	264	321	349	450	477
1.5	6.5	10	10	X	1.5	6.5	10	15	25	X	40	X	65	X	100	X	150	X	250	X

Note: Binomial distribution used for percent defective comparisons. (Please use for defects per hundred 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)																Higher than 250							
		Less than 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	
Single	13	△	0	1																					
		Use	Use	Use																					
Double	8	▽	.																						
	16																								
Multiple	3	▽	.																						
	6																								
	9																								
	12																								
	15																								
	18																								
	21																								
		Less than 1.5	1.5																						
			Use	Use	Use																				

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.

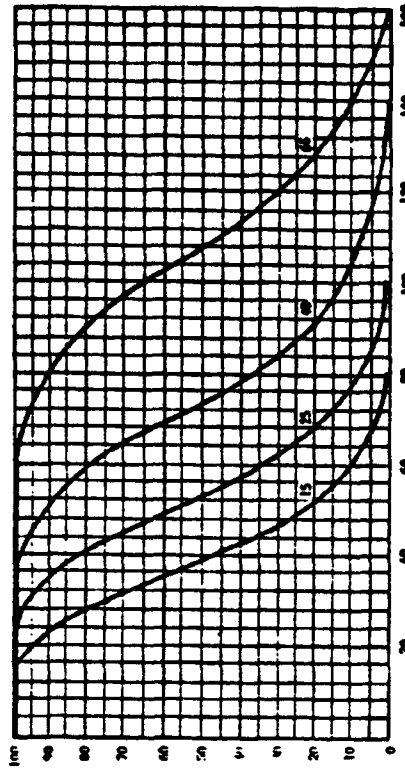
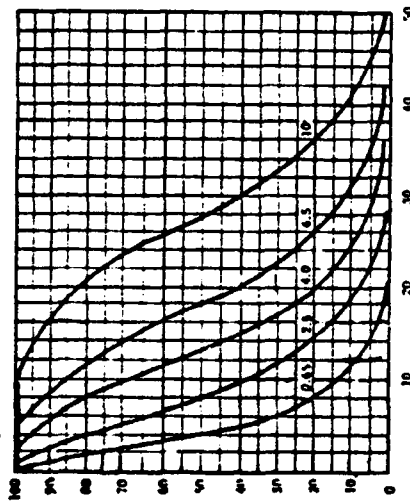
E

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

CHART F - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

PERCENT OF LOTS
EXPECTED TO BE
ACCEPTED (P_a)



QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)
Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

MIL-STD-105E

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

p (in defects per hundred units)	Acceptable Quality Levels (normal inspection)							
	6.5	10	15	25	40	65		
4.12	8.93	14.5	17.5	23.9	30.5	37.4	51.7	62.9
6.83	13.1	19.9	23.5	30.8	38.4	46.2	62.2	74.5
8.72	15.8	23.3	27.2	35.1	43.2	51.5	68.4	81.2
12.7	21.1	29.8	34.2	43.1	52.1	61.2	79.5	93.4
18.4	28.4	38.3	43.3	53.3	63.3	73.3	93.3	108
25.5	37.1	48.4	54.8	65.1	76.1	87.0	109	125
33.4	46.4	58.9	65.0	77.0	88.9	101	124	141
38.8	52.6	65.7	72.2	84.8	97.2	109	133	151
50.2	65.5	80.0	87.0	101	114	127	153	172
10	15	25	40	65	100	150	200	250

r Levels (lighter inspection)

defective components) Problems for defects per hundred units.

Acceptable Quality Levels (normal inspection)

P _a	p (in percent defective)									
	0.65	2.5	4.0	6.5	10	15	25	40	65	100
99.0	0.0502	0.759	2.27	4.36	9.75	0.0503	0.749	2.27	4.36	9.75
95.0	0.256	1.81	4.22	7.14	14.0	0.256	1.70	4.22	7.14	14.0
90.0	0.525	2.69	5.64	9.03	16.6	0.527	2.66	5.64	9.03	16.6
75.0	1.43	4.81	8.70	12.8	21.6	1.44	4.81	8.70	12.8	21.6
50.0	3.41	6.25	13.1	18.1	27.9	3.47	6.39	13.1	18.1	27.9
25.0	6.70	12.9	18.7	24.2	34.8	6.93	13.5	18.7	24.2	34.8
10.0	10.9	18.1	24.5	30.4	41.5	11.5	19.4	24.5	30.4	41.5
5.0	13.9	21.6	28.3	34.4	45.6	15.0	23.7	28.3	34.4	45.6
1.0	20.6	28.9	35.8	42.1	53.2	23.0	33.2	35.8	42.1	53.2
1.0	1.0	4.0	6.5	10	15	25	40	65	100	150

Acceptable

Note: Shaded distribution used for p_a

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Higher than 6.5									
		Less than 0.65	0.65	1.0		1.5	2.5		4.0		6.5		10		15		25		40		65										
				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	9	10	11	12	13	14	15	18	19	21	22	∆	20	
	13	∇	.		Use code Letter			0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	16	11	16	∆	13
Double	26				Use code Letter			1	2	3	4	5	6	7	8	9	11	12	12	13	15	16	18	19	21	26	26	27		26	
	5	∇	.		E			2	2	2	2	3	4	4	4	4	4	4	4	5	6	6	7	7	7	7	7	7	7		5
Multiple	10				H			2	2	2	2	3	4	4	4	4	4	4	4	5	6	6	7	7	7	7	7	7	7		10
	15				G			2	2	3	3	4	5	6	6	7	8	8	9	9	10	10	11	11	11	11	11	11	11		15
	20				F			2	3	4	4	5	6	7	7	8	9	10	10	11	12	13	13	14	14	15	16	16	19	25	20
	25				D			3	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	17	18	19	20	22	25	29	25
	30				C			3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	20	21	23	27	29	31	33	30
	35				B			3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	20	21	22	25	32	33	37	35
		Less than 1.0	1.0		1.5	2.5	4.0	6.5	10	15		25	40	65		15		25	40	65		40	65		65					Higher than 6.5	

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) where appropriate. Acceptance not permitted at this sample size.



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

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

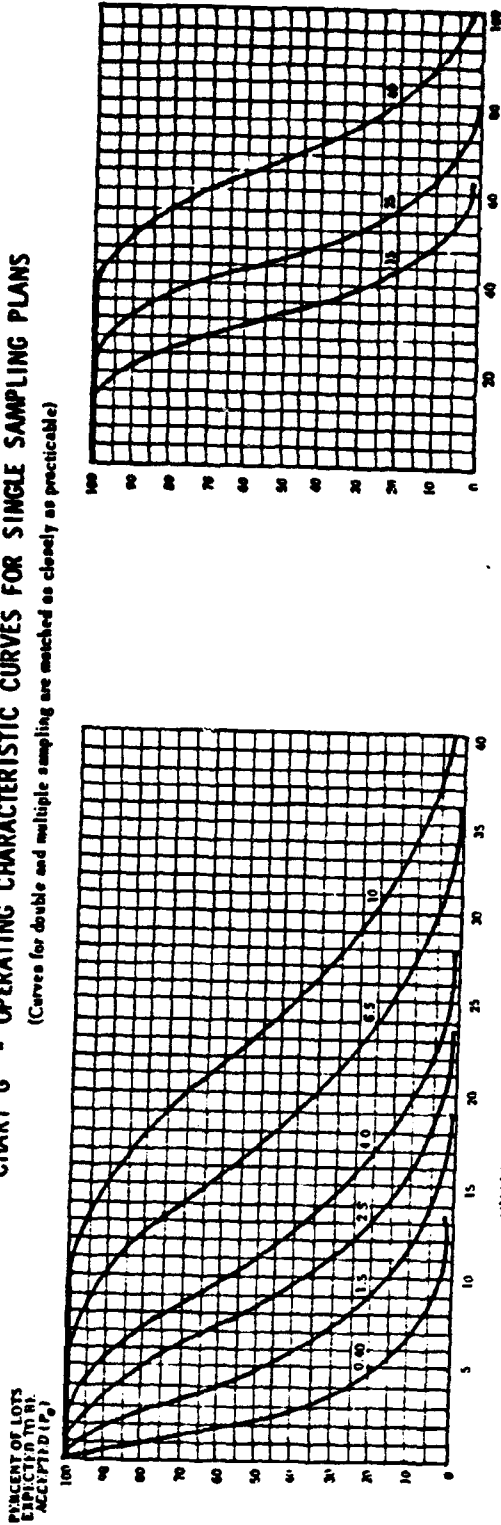


TABLE X-G-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _a	Acceptable Quality Levels (normal inspection)																	
	p (in percent defective)					p (in defects per hundred units)												
	0.40	1.5	2.5	4.0	6.5	10	0.40	1.5	2.5	4.0	6.5	10	15	25	40			
99.0	0.0314	0.471	1.40	2.67	5.88	9.79	0.0314	0.464	1.36	2.57	5.58	9.08	11.0	14.9	19.1	23.4	32.3	39.3
95.0	0.160	1.12	2.60	4.38	8.50	13.1	0.160	1.11	2.58	4.27	8.17	12.4	14.7	19.3	24.0	28.9	38.9	46.5
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	32.2	42.7	50.8
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	38.2	49.7	58.4
50.0	2.14	5.19	8.27	11.4	17.5	23.7	2.17	5.24	8.36	11.5	17.7	24.0	27.1	33.3	39.6	45.8	58.3	67.7
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	54.4	67.9	78.0
10.0	6.94	11.6	15.8	19.7	27.1	34.1	7.20	12.2	16.6	20.9	29.0	36.8	40.6	48.1	55.6	62.9	77.4	88.1
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	68.4	83.4	94.5
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	79.5	95.6	107
0.65	2.5	4.0	6.5	10	10	10	0.65	2.5	4.0	6.5	10	10	15	25	40	40	40	40

Note: Binomial distribution used for percent defective computations; Poisson for defects per hundred units.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)															Cumulative sample size												
		Less than 0.40		0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	Higher than 40														
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac		Re											
Single	32	▽	0	1																△									
Double	20	▽			Use code Letter																△								
Multiple	8	▽			Use code Letter																△								
	16																												
	24																												
	32																												
	40																												
	48																												
56																													
		▽	0.65																				Higher than 40						
															Acceptable Quality Levels (tightened inspection)														
		Less than 0.65																					Higher than 40						

△ = 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

CHART H - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

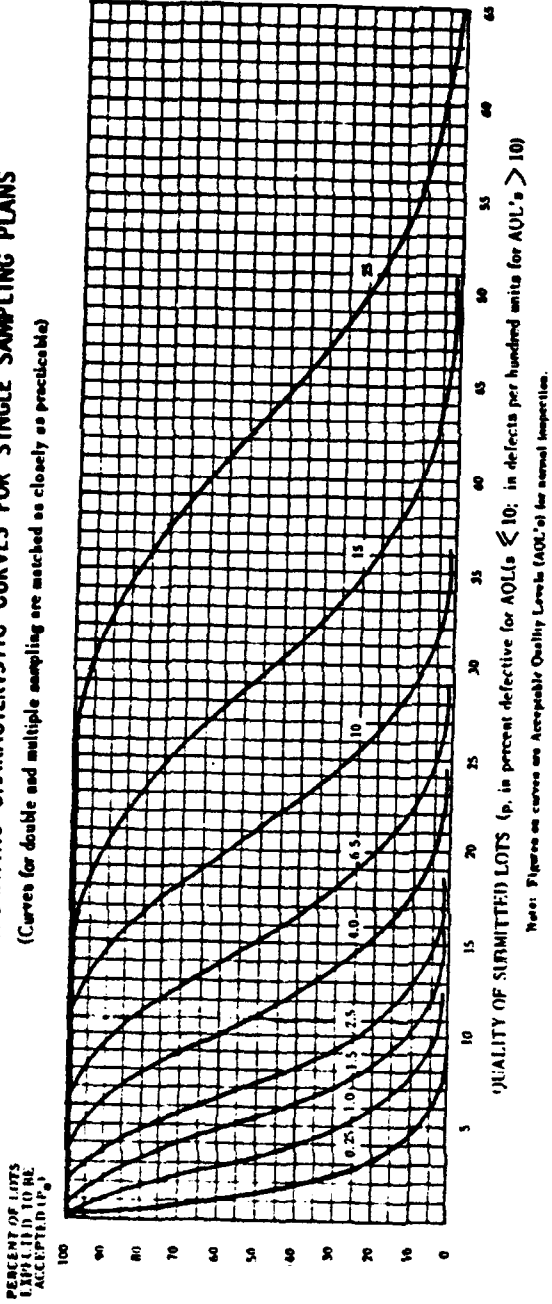


TABLE X-H-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P _h	Acceptable Quality Levels (normal inspection)										Acceptable Quality Levels (tightened inspection)																														
	0.25	1.0	1.5	2.5	4.0	6.5	10	15	25	40	50	65	100	150	200	250	300	350	400	500	600	700	800	900	1000																
99.0	0.0201	0.300	0.486	1.68	3.69	6.07	7.36	10.1	0.0201	0.297	0.872	1.65	3.57	5.81	7.01	9.54	12.2	15.0	20.7	25.1	0.0201	0.300	0.486	1.68	3.69	6.07	7.36	10.1	0.0201	0.297	0.872	1.65	3.57	5.81	7.01	9.54	12.2	15.0	20.7	25.1	
95.0	0.103	0.715	1.66	2.78	5.36	8.22	9.72	12.9	0.103	0.711	1.64	2.73	5.23	7.96	9.39	12.3	15.4	18.5	24.9	29.8	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	
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	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	
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	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	
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	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	
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	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	
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	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	
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	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	
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	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	
0.40	1.5	2.5	4.0	6.5	10	15	18	22	0.40	1.5	2.5	4.0	6.5	10	15	20	25	30	35	40	0.40	1.5	2.5	4.0	6.5	10	15	18	22	0.40	1.5	2.5	4.0	6.5	10	15	20	25	30	35	40

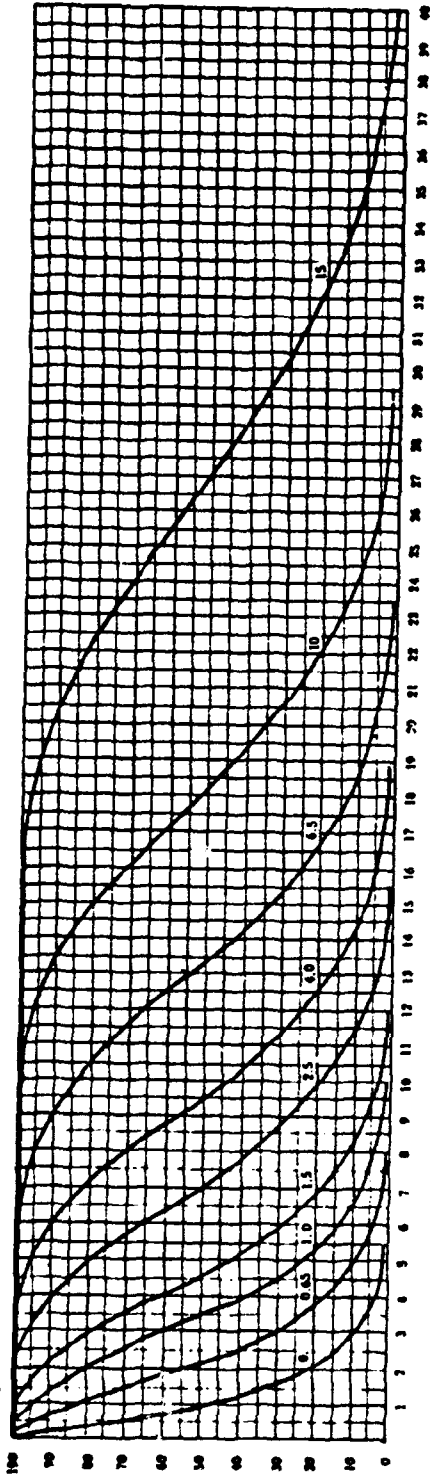
Note: Binomial distribution used for percent defective comparisons; Poisson for defects per hundred units.

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

CHART J - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are attached as *cl. dr.* as practicable)

PERCENT OF LOTS
SUBMITTED TO THE
INSPECTOR TO BE
ACCEPTED (P_a)



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

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

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

P _a	Acceptable Quality Levels (normal inspection)																					
	p (in defects per hundred units)																					
	0.15	0.65	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	35	40	45							
99.0	0.0126	0.187	0.550	1.04	2.28	3.73	4.51	6.17	7.86	9.76	0.0126	0.186	0.545	1.03	2.23	3.63	4.38	5.96	7.62	9.35	12.9	15.7
95.0	0.0641	0.446	1.03	1.73	3.32	5.07	6.00	7.93	9.89	11.9	0.0641	0.444	1.02	1.71	3.27	4.98	5.87	7.71	9.61	11.6	15.6	18.6
90.0	0.132	0.667	1.39	2.20	3.99	5.91	6.90	8.95	11.0	13.2	0.132	0.665	1.38	2.18	3.94	5.82	6.79	8.78	10.8	12.9	17.1	20.3
75.0	0.359	1.201	2.16	3.18	5.30	7.50	8.61	10.9	13.2	15.5	0.360	1.20	2.16	3.17	5.27	7.45	8.55	10.8	13.0	15.3	19.9	23.4
50.0	0.863	2.09	3.33	4.57	7.06	9.55	10.8	13.3	15.8	18.3	0.866	2.10	3.34	4.59	7.09	9.59	10.8	13.3	15.8	18.3	23.3	27.1
25.0	1.72	3.33	4.84	6.30	9.14	11.9	13.3	16.0	18.6	21.3	1.73	3.37	4.90	6.39	9.28	12.1	13.5	16.3	19.0	21.7	27.2	31.2
10.0	2.84	4.78	6.52	8.16	11.3	14.3	15.7	18.6	21.4	24.2	2.88	4.86	6.65	8.35	11.6	14.7	16.2	19.3	22.2	25.2	30.9	35.2
5	3.68	5.79	7.66	9.41	12.7	15.8	17.3	20.3	23.2	26.0	3.74	5.93	7.87	9.69	13.1	16.4	18.0	21.2	24.3	27.4	33.4	37.8
1.0	5.59	8.01	10.1	12.0	15.6	18.9	20.5	23.6	26.6	29.5	5.76	8.30	10.5	12.6	16.4	20.0	21.8	25.2	28.5	31.8	38.2	42.9
0.25	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	0.25	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	35

Acceptable Quality Levels (tightened inspection)

Note: Binomial distribution used for percent defective comparisons; Poisson for defects per hundred 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)																		Higher than 15
		Less than 0.15	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	35	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		
Single	80	▽	0 1																△	
	50	▽	•																△	
Double	100																			
	50																			
Multiple	20	▽	•																△	
	40																			
	60																			
	80																			
	100																			
	120																			
	140																			
	Less than 0.25	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	35	40	45	50	Higher than 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

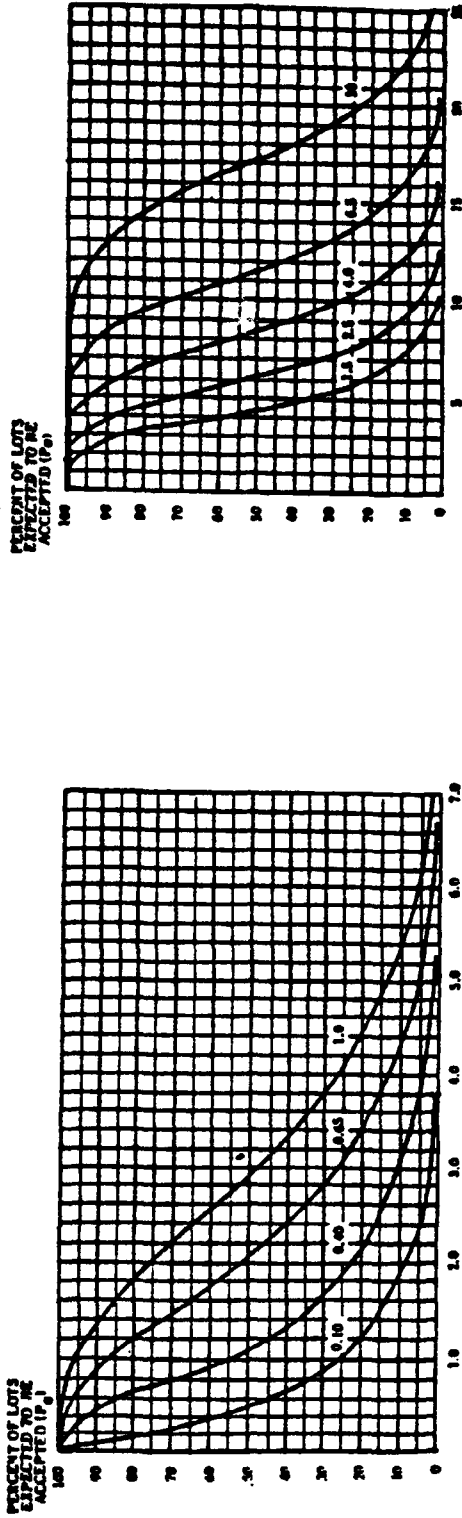
• Use single sampling plan above (or alternatively use code letter M)

• Acceptance not permitted at this sample size.

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

CHART K - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



QUALITY OF SHIPPED LOTS (p, in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)

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

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

P _o	Acceptable Quality Levels (normal inspection)											
	0.10	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10			
	p (in percent defective or defects per hundred units)											
99.0	0.00004	0.119	0.349	0.659	1.43	2.32	2.81	3.82	4.88	5.98	8.28	10.1
95.0	0.0410	0.284	0.654	1.09	2.09	3.16	3.76	4.94	6.15	7.40	9.95	11.9
90.0	0.0843	0.425	0.882	1.40	2.52	3.72	4.35	5.62	6.92	8.24	10.9	13.0
75.0	0.230	0.769	1.302	2.03	3.38	4.76	5.47	6.90	8.34	9.79	12.7	14.9
50.0	0.555	1.34	2.14	2.94	4.54	6.14	6.94	8.53	10.1	11.7	14.9	17.3
25.0	1.11	2.15	3.14	4.09	5.94	7.75	8.64	10.4	12.2	13.9	17.4	20.0
10.0	1.84	3.11	4.26	5.34	7.42	9.42	10.4	12.3	14.2	16.1	19.8	22.5
5.0	2.40	3.80	5.04	6.20	8.41	10.5	11.5	13.6	15.6	17.5	21.4	24.2
1.0	3.68	5.31	6.72	8.04	10.5	12.8	13.3	16.1	18.3	20.4	24.5	27.5
	0.15	0.65	1.0	1.5	2.5	4.0	6.5	10	15	20.4	24.5	27.5
	Acceptable Quality Levels (tightened inspection)											

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																			Higher than 10												
		Less than 0.10		0.10		0.15		0.25		0.40		0.65		1.0		1.5		2.5		4.0		6.5		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							
Single	125	▽	0	1						1	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	16	19	21	22	△		
	80	▽	•						Use code Letter	0	2	0	3	1	4	2	5	3	7	3	7	5	6	10	7	11	9	14	11	16	△		
	160								Use code Letter	1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	26	27			
Multiple	32	▽	•						Use code Letter	•	2	•	2	•	3	•	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	△	
	64								Use code Letter	•	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14		
	96								Use code Letter	•	0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19	
	128								Use code Letter	•	0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25	
	160								Use code Letter	•	1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	29		
	192								Use code Letter	•	1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33	
224								Use code Letter	•	2	3	4	5	6	7	9	10	13	14	14	15	16	19	21	22	25	26	32	33	37	38		
		Less than 0.15	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	1000	1500	2500	4000	6500	10000	15000	25000	40000	Higher than 10		

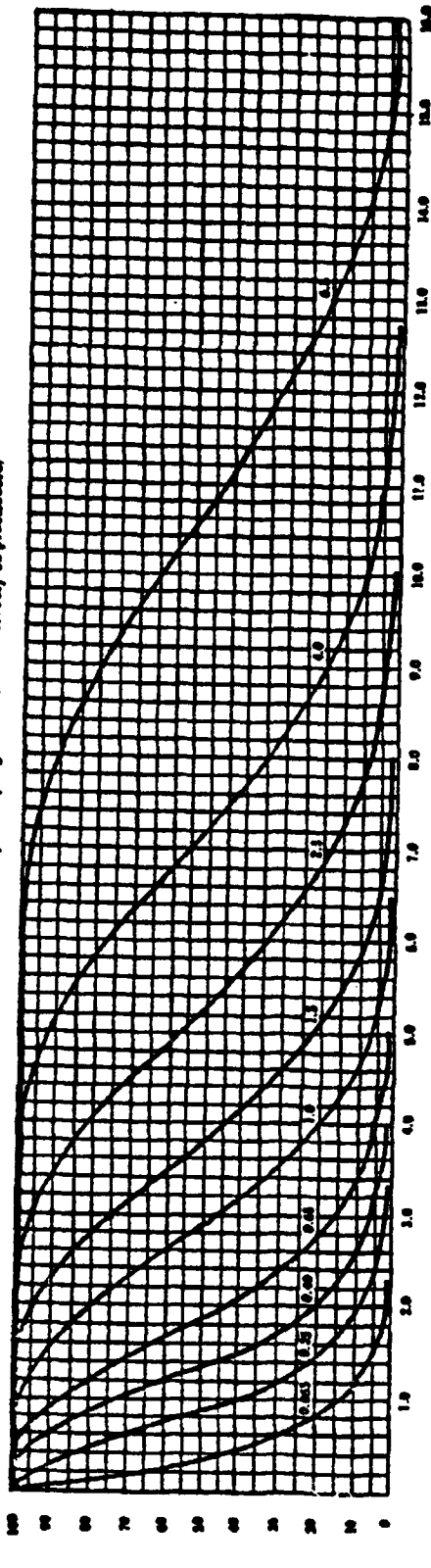
Acceptable Quality Levels (tightened inspection)

- △ 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 #)
- Acceptance not permitted at this sample size.

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

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)
 Note: Figures on curves are Acceptable Quality Levels (AQL's) 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	10.0	15.0	
	p (in percent defective or defects per hundred units)											
99.0	0.00503	0.075	0.218	0.412	0.693	1.05	1.75	2.39	3.05	3.76	5.17	6.29
95.0	0.0256	0.178	0.409	0.683	1.31	1.99	2.35	3.08	3.84	4.62	6.22	7.45
90.0	0.0527	0.266	0.551	0.872	1.58	2.33	2.72	3.51	4.32	5.15	6.94	8.32
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	3.84	4.33	5.33	6.33	7.33	9.33	10.9
25.0	0.693	1.35	1.96	2.55	3.71	4.83	5.40	6.51	7.61	8.78	10.9	12.5
10.0	1.15	1.94	2.66	3.34	4.64	5.89	6.90	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	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0	15.0	25.0	40.0
	Acceptable Quality Levels (tightened inspection)											

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																		Higher than 6.5										
		Less than 0.065		0.065		0.10		0.15		0.25		0.40		0.65		1.0		1.5			2.5		4.0		6.5					
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re				
Single	200	▽		1						1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	18	19	21	22	△	
									Use																					
Double	125	▽		•						0	2	3	4	5	6	7	8	9	11	12	13	15	16	18	19	23	24	26	27	△
	250								Use																					
Multiple	50	▽		•						•	2	•	2	•	3	•	4	•	4	•	4	•	6	•	6	•	7	•	9	△
	100									•	2	•	3	•	5	•	6	•	7	•	8	•	9	•	10	•	12	•	16	
	150									0	2	•	3	•	6	•	8	•	9	•	10	•	12	•	13	•	17	•	19	
	200									0	3	•	4	•	7	•	10	•	13	•	16	•	20	•	22	•	25	•	29	
	250									1	3	•	4	•	8	•	11	•	15	•	19	•	24	•	28	•	33	•	37	
	300									1	3	•	4	•	7	•	10	•	14	•	18	•	23	•	27	•	31	•	35	
	350									2	3	•	4	•	6	•	9	•	13	•	17	•	22	•	26	•	32	•	36	
		Less than 0.10								0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5												Higher than 6.5

Acceptable Quality Levels (tightened inspection)

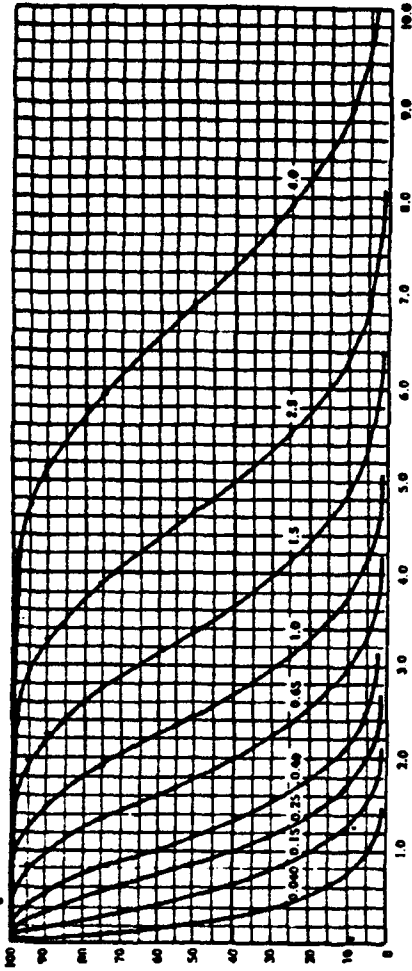
- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection number
- = Use single sampling plan above (or alternatively use code letter P)
- = Acceptance not permitted at this sample size.

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

CHART M - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (Pa)



QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤ 10 ; in defects per hundred units for AQL's > 10)
 Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

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

P _e	Acceptable Quality Levels (normal inspection)											
	0.040	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	10.0	10.0	
p (in percent defective or in defects per hundred units)	0.02719	0.0472	0.134	0.261	0.567	0.923	1.11	1.51	1.94	2.37	3.26	3.99
99.0	0.0163	0.113	0.260	0.434	0.830	1.26	1.49	1.96	2.44	2.94	3.95	4.73
95.0	0.0335	0.169	0.350	0.534	1.00	1.48	1.72	2.23	2.74	3.27	4.34	5.16
90.0	0.0913	0.305	0.548	0.805	1.34	1.89	2.17	2.74	3.31	3.89	5.05	5.93
85.0	0.220	0.533	0.849	1.17	1.80	2.43	2.75	3.39	4.02	4.66	5.93	6.88
80.0	0.440	0.855	1.24	1.62	2.36	3.07	3.43	4.13	4.80	5.52	6.90	7.92
75.0	0.731	1.23	1.69	2.12	2.94	3.74	4.13	4.89	5.64	6.39	7.86	8.95
70.0	0.951	1.51	2.00	2.46	3.34	4.17	4.56	5.38	6.17	6.95	8.47	9.60
65.0	1.46	2.11	2.67	3.19	4.16	5.08	5.52	6.40	7.24	8.08	9.71	10.9
60.0	0.065	0.25	0.40	0.65	1.0	1.5	1.5	2.5	4.0	4.0	4.0	X
Acceptable Quality Levels (tightened inspection)												

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial

M

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

Type of sampling plan	Cumu- lative sample size	Acceptable Quality Levels (normal inspection)														Higher than 4.0			
		Less than 0.040	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	Higher than 4.0					
		Ac He	Re Ac	Re Ac	Re Ac	Re Ac	Re Ac	Re Ac	Re Ac	Re Ac	Re Ac	Re Ac	Re Ac		Re Ac		Re Ac		
Single	315	▽	0 1															△	
	200 400	▽	.															△	
Multiple	80	▽	.															△	
	160																		
	240																		
	320																		
	400																		
	480																		
	560																		
		Less than 0.065	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	Higher than 4.0						
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.
 He = Rejection number.
 • = Use single sampling plan above (or alternatively use code letter Q)
 P = Acceptance not permitted at this sample size.

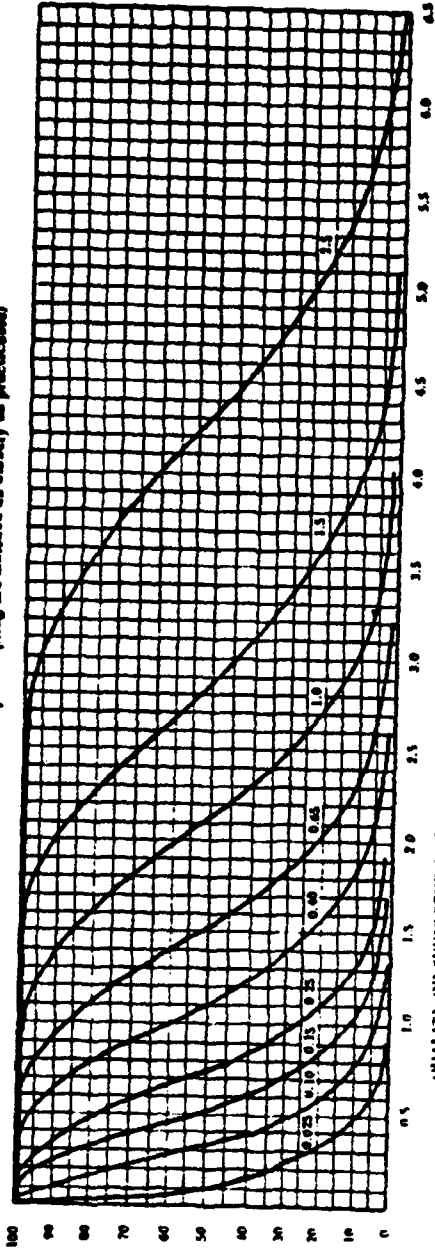


TABLE X-N - Tables for sample size code letter: N

CHART N - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P_a)



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

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

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

P _o	Acceptable Quality Levels (normal inspection)											
	0.025	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	3.5		
	p (in percent defective or in defects per hundred units)											
99.0	0.00201	0.00997	0.0072	0.165	0.357	0.581	0.701	0.954	1.22	1.50	2.07	2.51
95.0	0.0103	0.711	0.164	0.273	0.523	0.796	0.939	1.23	1.54	1.85	2.49	2.90
90.0	0.0211	0.106	0.220	0.349	0.630	0.931	1.09	1.40	1.73	2.06	2.73	3.25
75.0	0.0575	0.192	0.345	0.507	0.844	1.19	1.37	1.72	2.08	2.45	3.16	3.76
50.0	0.139	0.336	0.535	0.734	1.13	1.53	1.73	2.13	2.53	2.93	3.73	4.33
25.0	0.277	0.539	0.784	1.02	1.48	1.94	2.16	2.60	3.04	3.48	4.35	4.99
10.0	0.461	0.778	1.06	1.34	1.85	2.35	2.60	3.08	3.56	4.03	4.95	5.64
5.0	0.599	0.949	1.26	1.55	2.10	2.63	2.89	3.39	3.89	4.38	5.34	6.05
1.0	0.921	1.33	1.68	2.01	2.62	3.20	3.48	4.03	4.56	5.09	6.12	6.87
0.040	0.15	0.25	0.40	0.65	1.0	1.5	2.0	2.5	3.0	3.5	4.0	4.5
	Acceptable Quality Levels (tightened inspection)											

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial

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

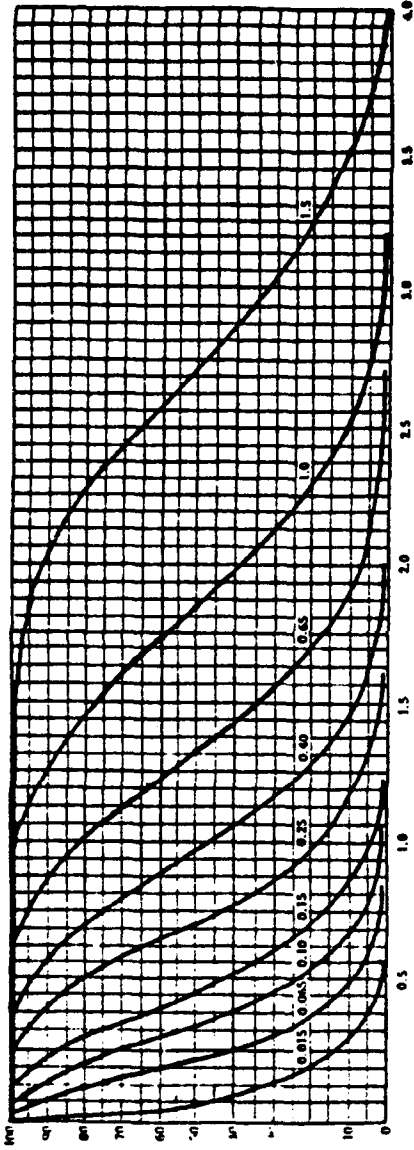
Type of sampling plan	Con- lative sample size	Acceptable Quality Levels (normal inspection)																					Higher than 2.5			
		Less than 0.025		0.025		0.040		0.065		0.10		0.15		0.25		0.40		0.65		1.0		1.5		2.5		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac		Re	Ac	Re
Single	500	▽	0	1	1	2	3	3	4	5	6	7	8	9	10	11	12	13	14	15	18	19	21	22	△	
Double	315	▽			0	2	3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△
Multiple	630	▽			1	2	3	4	5	6	7	8	9	11	12	13	15	16	18	19	23	24	26	27	△	
Multiple	125	▽			2	3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△	
Multiple	250	▽			2	3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△	
Multiple	375	▽			2	3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△	
Multiple	500	▽			3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△		
Multiple	625	▽			1	3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△	
Multiple	750	▽			1	3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△	
Multiple	875	▽			2	3	4	5	6	7	8	9	10	11	12	13	15	16	18	19	23	24	26	27	△	
	Less than 0.040	△	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	5	10	20	35	50	80	125	200	315	500	750	1125	Higher than 2.5	

△ = 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 R)
p = Acceptance not permitted at this sample size.

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

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

PERCENT OF LOTS
EXPECTED TO BE
ACCEPTED (P_a)



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

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

P _a	Acceptable Quality Levels (normal inspection)										
	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5
	p (in percent defective or defects per hundred units)										
99.0	0.00126	0.0186	0.0545	0.103	0.223	0.363	0.538	0.762	0.935	1.29	1.57
95.0	0.00641	0.0444	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.56	1.86
90.0	0.0132	0.0665	0.138	0.218	0.394	0.582	0.679	0.878	1.08	1.71	2.03
75.0	0.0340	0.120	0.216	0.317	0.527	0.745	0.855	1.08	1.30	1.99	2.34
50.0	0.0866	0.210	0.334	0.459	0.709	0.959	1.08	1.33	1.58	2.33	2.71
25.0	0.173	0.337	0.490	0.639	0.928	1.21	1.35	1.63	1.90	2.72	3.12
10.0	0.288	0.486	0.665	0.835	1.16	1.47	1.62	1.93	2.22	3.09	3.52
5.0	0.374	0.593	0.787	0.969	1.31	1.64	1.80	2.12	2.43	3.34	3.78
1.0	0.576	0.830	1.05	1.26	1.64	2.00	2.18	2.52	2.85	3.82	4.29
0.05	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10
	Acceptable Quality Levels (tightened inspection)										

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																	Higher than 1.5							
		0.010		0.015		0.025		0.040		0.065		0.10		0.15		0.25		0.40		0.65		1.0		1.5		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac		Re	Ac	Re	Ac	Re	Ac	Re
Single	800	∇		0	1																				△	
	500	∇																								△
Double	1000																									
	200	∇		*																						△
Multiple	400																									
	600																									
	800																									
	1000																									
	1200																									
	1400																									
		Less than 0.025																								
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.

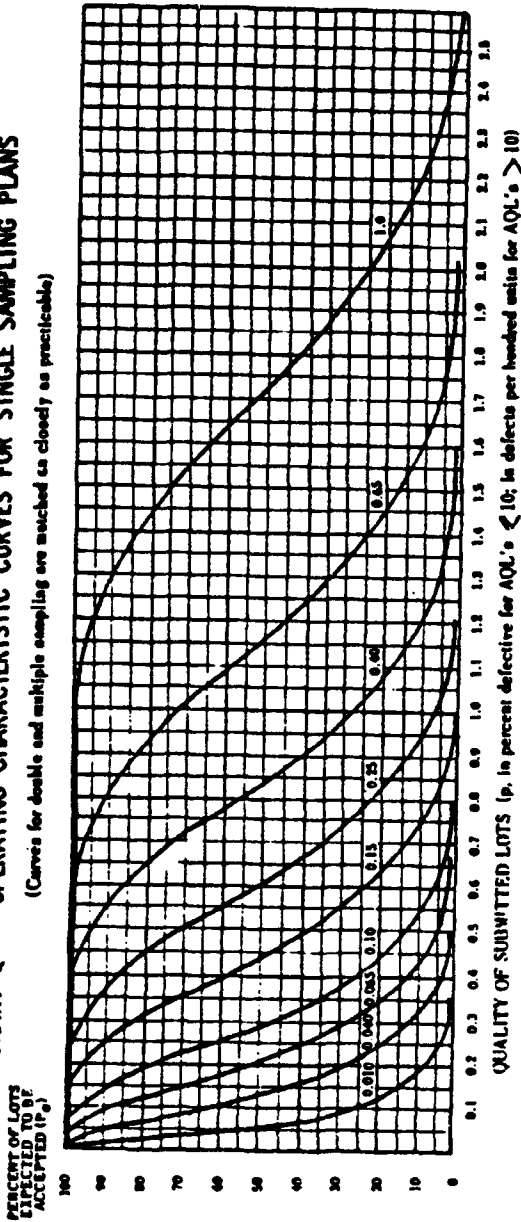
∅ = Acceptance not permitted at this sample size.

P

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

CHART Q - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



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

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

P _a	Acceptable Quality Levels (normal inspection)											
	0.010	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.0	1.0	
	p (in percent defective or defects per hundred units)											
99.0	0.000804	0.0119	0.0340	0.0658	0.143	0.232	0.281	0.382	0.488	0.598	0.828	1.01
95.0	0.00410	0.0284	0.0654	0.109	0.209	0.318	0.376	0.494	0.615	0.740	0.995	1.19
90.0	0.00843	0.0425	0.0882	0.140	0.252	0.372	0.435	0.562	0.692	0.824	1.09	1.39
75.0	0.0230	0.0769	0.138	0.203	0.308	0.476	0.547	0.690	0.834	0.979	1.27	1.49
50.0	0.0555	0.134	0.214	0.294	0.454	0.614	0.694	0.853	1.01	1.17	1.49	1.73
25.0	0.111	0.215	0.314	0.409	0.594	0.775	0.864	1.04	1.22	1.39	1.74	2.00
10.0	0.184	0.311	0.426	0.534	0.742	0.942	1.04	1.23	1.42	1.61	1.98	2.25
5.0	0.240	0.380	0.504	0.620	0.841	1.05	1.15	1.36	1.56	1.75	2.14	2.42
1.0	0.348	0.531	0.672	0.804	1.05	1.28	1.39	1.61	1.83	2.04	2.45	2.75
0.015	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.65	2.65	4.5	7.5	12.5
	Acceptable Quality Levels (tightened inspection)											
	0.010	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.0	1.0	1.0

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial

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

Type of sampling plan	Commi- native sample size	Acceptable Quality Levels (normal inspection)														Higher than 1.0									
		0.010		0.015		0.025		0.040		0.065		0.10		0.15			0.25		0.40		0.65		1.0		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	
Single	1250	X																X		X		X			
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
Double	800 1600																							Δ	
		Use	Letter	•	Letter	Use	code Letter	Use	code Letter	Use	code Letter	Use	code Letter	Use	code Letter	Use	code Letter	Use	code Letter	Use	code Letter	Use	code Letter	Use	code Letter
Multiple	315																							Δ	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
	630																								
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
	945																								
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
1260																									
	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
1575																									
	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
1890																									
	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
2205																									
	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
		X		X		X		X		X		X		X		X		X		X		X		X	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re

Acceptable Quality Levels (lightened inspection)

- Δ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection number
- = Use single sampling plan above.
- = Acceptance not permitted at this sample size.



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

CHART R - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

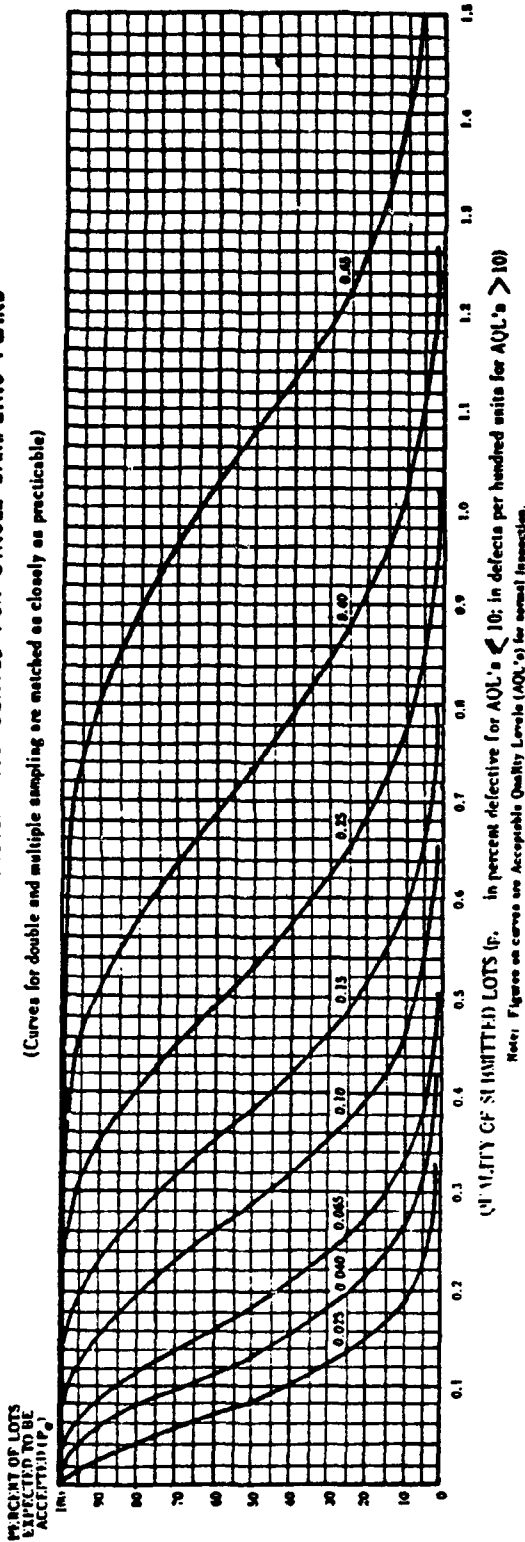


TABLE X-R-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P ₀	Acceptable Quality Levels (normal inspection)									
	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	0.65	0.65
	P (in percent defective or defects per hundred units)									
99.0	0.00743	0.0218	0.0412	0.0892	0.145	0.239	0.305	0.374	0.517	0.629
95.0	0.0178	0.0409	0.0683	0.131	0.199	0.309	0.394	0.462	0.622	0.745
90.0	0.0266	0.0551	0.0872	0.158	0.233	0.351	0.432	0.515	0.684	0.812
75.0	0.0481	0.0864	0.127	0.211	0.298	0.431	0.521	0.612	0.795	0.934
50.0	0.0839	0.134	0.181	0.284	0.383	0.533	0.633	0.733	0.933	1.08
25.0	0.135	0.196	0.255	0.371	0.484	0.651	0.761	0.870	1.09	1.25
10.0	0.194	0.266	0.334	0.464	0.589	0.770	0.889	1.01	1.24	1.41
5.0	0.237	0.315	0.388	0.526	0.657	0.849	0.972	1.09	1.33	1.51
1.0	0.332	0.420	0.502	0.655	0.800	1.02	1.14	1.27	1.53	1.72
0.040	0.065	0.10	0.15	0.25	0.40	0.65	0.65	0.65	0.65	0.65
	Acceptable Quality Levels (lightened inspection)									

Note: All values given in above table based on Poisson distribution as an approximation to the Binomial.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																		Higher than 0.65			
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65				
	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			
Single	0	1																					
	2000	0 1																					△
Double	1250	•																					△
	2500	•																					△
Multiple	500																						△
	1000																						△
	1500																						△
	2000																						△
	2500																						△
	3000																						△
	3500																						△
	0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65	0.65	Higher than 0.65
Acceptable Quality Levels (lightened inspection)																							

△ Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 Ac Acceptance number.
 Re Rejection number.
 • Use single sampling plan above.
 • Acceptance not permitted at this sample size.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Level (normal inspection)	
		Ac	Re
Single	3150	1	2
	2000	0	2
Double	4000	1	2
	800	0	2
Multiple	1600	0	2
	2400	0	2
	3200	0	3
	4000	1	3
	4800	3	3
	5600	3	3
		0.025	
		Acceptable Quality Level (tightened inspection)	

Ac = Acceptance number
 Re = Rejection number
 # = Acceptance not permitted at this sample size.

6. NOTES

6.1 Intended Use. Sampling procedures and tables for inspection by attributes are intended to be used in the acquisition of Defense material.

6.2 Subject Term (Key Word) Listing.

Acceptable Quality Level (AQL)

Average Outgoing Quality (AOQ)

Defect

Defective

Lot or Batch

Process Average

Sample

Sampling Plan

Unit of Product

6.3 Changes from Previous Issue. Vertical lines or asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

MIL-STD-105E

CONCLUDING MATERIAL

Custodians:

Army - AR
Navy - OS
Air Force - 23

Preparing Activity:

Army - AR

Review Activities:

Army - MI, EA, TE, AV, ER
Navy - AS, EC, MC, OM, SA,
SH, TD, YD
DLA - ES, GS, SS
OSD - IP, SO

(Project QCIC-0085)

User Activities:

Army - ME
DLA - ES, SS

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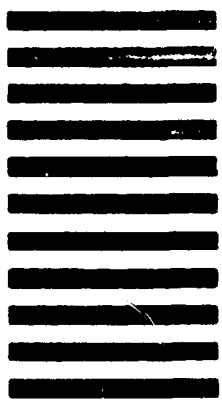
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3a. NAME OF SUBMITTING ORGANIZATION		4. TYPE OF ORGANIZATION (Mark one)	
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