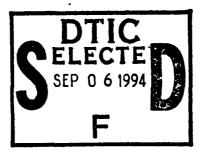
AD-A284 013



NOT MEASUREMENT SENSITIVE

MIL-STD-105E 10 MAY 1989

SUPERSEDING MIL-STD-105D 29 APRIL 1963



MILITARY STANDARD

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES



94-28736

DTIC QUALITY INSPECTED 1

AMSC N/A

94 9 02

060

AREA QCIC

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

DEPARTMENT OF DEFENSE Washington, DC 20301

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

- 1. This military standard is approved for use by all Departments and Agencies of the Department of Defense.
- 2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to:

Commander
U.S. Army Armament Research, Development and Engineering Center
ATTN: SMCAR-BAC-S/Bldg. 6
Picatinny Arsenal, NJ 07806-5000

by using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or letter.

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".

Acce	sior. For	
DTIC Unan	CRA&I V TAB nounced ication	
By Distrit	oution!	
1	Wallabelity cortes	-
Dist	Avas 101700 Semolal	
A-1		

CONTENTS

Db			Page
Paragraph	1.	SCOPE	1
	1.1	Purpose	1
	1.2	Application	1
	2.	REFERENCED DOCUMENTS	1
	2.1	Not applicable	1
	3.	DEFINITIONS	1
	3.1	Acceptable Quality Level (AQL)	2
	3.2	Average Outgoing Quality (AC^\)	2
	3.3	Average Outgoing Quality 1 (*OQL)	2
	3.4	Classification of Defects.	2
	3.5		2
		Critical Defect	2
	3.6	Critical Defective	2
	3.7	Defect	2
	3.8	Defective	3
	3.9	Defects Per Hundred Units	3
	3.10	Inspection	3
	3.11	Inspection by Attributes	3
	3.12	Lot or Batch	3
	3.13	Lot or Batch Size	2222223333333333
	3.14	Major Defect	3
	3.15	Major Defective	3
	3.16		
		Minor Defect	2
	3.17	Minor Defective	3
	3.18	Percent Defective	4
	3.19	Process Average	4
	3.20	Sample	4
	3.21	Sample Size Code Letter	4
	3.22	Sampling Plan	4
	3.23	Unit of Product	4
	4.	GENERAL REQUIREMENTS	4
	4.1	Written Procedures	4
	4.2	Nonconformance	4
	4.3	Formation and Identification of Lots or Batches	
	4.4	AOL	5 5 5
	4.4.1		5
		AQL Use	5
	4.4.2	Limitation	5
	4.4.3	Choosing AQLs	5

CONTENTS - Continued.

			rage
Paragraph		Compline	5
	4.5	Sampling	55556666667
	4.5.1	Representative Sampling	5
	4.5.2	Time of Sampling	5
	4.5.3	Double or Multiple Sampling	2
	4.6	Inspection Procedures	6
	4.7	Switching Procedures	6
	4.7.1	Normal to Tightened	6
	4.7.2	Tightened to Normal	6
	4.7.3	Normal to Reduced	6
	4.7.4	Reduced to Normal	6
	4.8	Discontinuation of Inspection	
	4.9	Sampling Plans	7
	4.9.1	Inspection Level	7
	4.9.2	Code Letters	7
	4.9.3	Obtaining Sampling Plan	7
	4.9.4	Types of Sampling Plans	8
	4.10	Determination of Acceptability	8
	4.10.1	Percent Defective Inspection	8
	4.10.1.1	Single Sampling Plan	8
	4.10.1.2	Double Sampling Plan	8
	4.10.1.3	Multiple Sampling Plan	8
	4.10.1.4	Special Procedure for Reduced Inspection	8
	4.10.2	Defects Per Hundred Units Inspection	9
	4.11	Limiting Quality Protection	88888999
	4.12	Curves	9
	4.12.1	Operating Characteristic Curves	9
	4.12.2	Average Sample Size Curves	9
	5. TAE	SLES	11
	J. IAC	ILECO	**
Table	_		
	I.	Sample Size Code Letters	13
	II-A.	Single Sampling Plans for Normal	
		Inspection (Master table)	14
	II-B.	Single Sampling Plans for Tightened	
		Inspection (Master table)	15
	II-C.	Single Sampling Plans for Reduced	_
		Inspection (Master table)	16
	III-A.	Double Sampling Plans for Normal	
		Inspection (Master table)	17
	III-B.	Double Sampling Plans for Tightened	
		Inspection (Master table)	18
	III-C.	Double Sampling Plans for Reduced	
		Inspection (Master table)	19

CONTENTS - Continued.

mak 1 a			Page
Table	IV-A.	Multiple Compline Plane for Normal	
	TA-W.	Multiple Sampling Plans for Normal Inspection (Master table)	20
	IV-B.	Multiple Sampling Plans for Tightened	20
	1V-D.	Inspection (Master table)	22
	IV-C.	Multiple Sampling Plans for Reduced	24
	14 0.	Inspection (Master table)	24
	V-A.	Average Outgoing Quality Limit Factors for	24
	v n.	Normal Inspection (Single Sampling)	26
	V-B.	Average Outgoing Quality Limit Factors for	20
	· 2.	Tightened Inspection (Single Sampling)	27
	VI-A.	Limiting Quality (in Percent Defective) for	21
	V = 1	which a Pa = 10% (for Normal Inspection,	
		Single Sampling)	28
	VI-B.	Limiting Quality (in Defects per Hundred	20
	· ·	Units) for which the Pa = 10% (for Normal	
		Inspection, Single Sampling)	29
	VII-A.	Limiting Quality (in Percent Defective) for	
		which the Pa = 5% (for Normal Inspection,	
		Single Sampling)	30
	VII-B.	Limiting Quality (in Defects per Hundred	•
		Units) for which the Pa = 5% (for Normal	
		Inspection, Single Sampling)	31
	VIII.	Limit Numbers for Reduced Inspection	32
	IX.	Average Sample Size Curves for Double and	
		Multiple Sampling	33
		ns and Operating Characteristic	
(Data) for:	
	X-A.	Sample Size Code Letter A	34
	X-B.	Sample Size Code Letter B	36
	x-c.	Sample Size Code Letter C	38
	X-D.	Sample Size Code Letter D	40
	X-E.	Sample Size Code Letter E	42
	X-F.	Sample Size Code Letter F	44
	X-G.	Sample Size Code Letter G	46
	х-н.	Sample Size Code Letter H	48
	X-J.	Sample Size Code Letter J	50
	х-к.	Sample Size Code Letter K	52
	X-L.	Sample Size Code Letter L	54
	х-м.	Sample Size Code Letter M	56
	X-N.	Sample Size Code Letter N	58
	X-P.	Sample Size Code Letter P	60
	x-Q.	Sample Size Code Letter Q	62
	X-R.	Sample Size Code Letter R	64

CONTENTS - Continued.

			Page
	x-s.	Sample Size Code Letter S	66
Paragraph			
	6.	NOTES	67
	6.1	Intended Use	67
	6.2	Subject Term (key word) Listing	67
	6.3	Changes from Previous Issue	67
		CONCLUDING MATERIAL	68

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.
 - q. 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).

- REFERENCED DOCUMENTS
- 2.1 Not applicable.
- 3. DEFINITIONS

3.1 <u>Acceptable Quality Level (AQL)</u>. 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 <u>Critical Defective</u>. 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 <u>Defect</u>. A defect is any nonconformance of the unit of product with specified requirements.

- 3.8 <u>Defective</u>. A defective is a unit of product which contains one or more defects.
- 3.9 <u>Defects per Hundred Units</u>. The number of defects per hundred units of any given quantity of units of product is one hundred times the number of defects contained therein (one or more defects being possible in any unit of product) divided by the total number of units of product, i.e.:

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

- 3.10 <u>Inspection</u>. Inspection is the process of measuring, examining, testing, or otherwise comparing the unit of product with the requirements.
- 3.11 <u>Inpection by Attributes</u>. 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 or 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 <u>Major Defect</u>. 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 <u>Major Defective</u>. 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 <u>Minor Defective</u>. A minor defective is a unit of product which contains one or more minor defects but contains no critical or major defect.

3.18 <u>Percent Defective</u>. 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.:

Percent Defective = Number of defectives x 100
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 <u>Sample</u>. 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 <u>Sampling Plan</u>. A sampling plar 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 <u>Written Procedures</u>. 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 <u>Nonconformance</u>. 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 <u>Limitation</u>. 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 <u>Representative (Stratified) Sampling</u>. 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 sublot, sub-batch or part of the lot or batch shall be selected at random.
- 4.5.2 <u>Time of Sampling</u>. 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 <u>Double or Multiple Sampling</u>. When double or multiple sampling is to be used, each sample shall be selected over the entire lot or batch.

4.6 <u>Inspection Procedures</u>. 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 <u>Tightened to Normal</u>. 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 <u>Discontinuation of Inspection</u>. If the cummulative 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 <u>Inspection Level</u>. 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 <u>Code Letters</u>. 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 <u>Single Sampling Plan</u>. 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 <u>Double Sampling Plan.</u> 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 <u>Multiple Sample Plan</u>. 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 <u>Special Procedure for Reduced Inspection</u>. 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 <u>Defects per Hundred Units Inspection</u>. 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 (IQ) and a consumer's risk to be associated with it. Tables VI and VII give values of IQ for the the commonly used consumer's risks of 10 percent and 5 percent respectively. If a different value of consumer's risk is required, the C.C. curves and their tabulated values may be used. The concept of IQ 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 (Pa, 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 0.63ln and 0.25n respectively, where n is the equivalent sample size.

SECTION 5
TABLES AND CURVES

TABLE 1—Sample size code letters

									247	770	2K	-			-	
evels	ш	8	υ	0	L	in.	9	I	~	×	J	=	Z	۵	0	Œ
General inspection levels	=	٧	83	၁	۵	ш	٤.	g	I		¥	۔	×	z	ه.	>
Gener	-	4	<	8	၁	ပ	a	ம	Œ,	G	¥	•	×	د	X	Z
	7,	4	<	80	ပ	ပ	۵	Ŀ	ш	ie.	ပ	9	×	•	••••	¥
ction levels	£	<	<	&	Ø	ပ	ပ	۵	۵	ш	w	le.	Ŀ	g	Ů	=
Special inspection levels	S-2	4	<	<	60	80	æ	ပ	U	ပ	a	a	a	Ľ	ш	u
	S-1	4	<	<	~	6	æ	æ	£	ပ	ပ	υ	ပ	Q	۵	٥
	eize e	ھ	15	ង	8	8	150	580	200	1200	3200	10000	32000	150000	200000	over
	Lot or batch size	9	9	9	9	9	9	9	2	2	9	9	9	3	9	pu
	3	~	6	92	8	: 15	16	151	1	201	1201	3201	10001	35001	120001	200001

CODE LETTERS

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

(see 4.9.3 and 4.9.4)

_									
		8	al ab	# 2 C					
Ì		3	2	2 = 3	1				
İ		3	Re Ac	2 2 2 2 2 2 3 3 3 3 3 3 3 3 3 3 3 3 3 3	7				
		\$	ye H	14 17 21 22 B 3	: (-				
		230	c Re	1 15	# # \-				
	ı	-	34 48	0 10 11 14 35 21	8 3 V				
		3	y v	~ 9 2	28 1				
1		š	Ac Re	\$ 4 7 0	= 2 K				
		3	ž	3 6 5 6	15 12 22 22	<u> </u>			
		_	Re Ac	m = w	2	N /_			
		\$	Re Ac	2 6 3	2 B II	2 1 1			
		ĸ	ye ı	- 2 6	s 7 10 1	= = (
		15	2	□	3 4 5 6 7 8	10 11 14 15 21 22	4		
1	ł	•	Pe Ac	7 ~	n + 0	• = N	B A		
	ĵ.		Re Ac	<u> </u>	2 6 2	8 10 11 14 14 14 14 14 14 14 14 14 14 14 14	2		
	Ĭ.	6.5	¥	[44	- 2 6	v ~ ē	≥ ≈ √		
	Acceptable Quality Levels (normal inspection)	6.0	Ac Re	\$:\$	4	3 6 4 6	16 15 22 22	\	
		2.5	ě	i.	公 公 "	3 6	4 15 4 5 15 4 5 15 15 15 15 15 15 15 15 15 15 15 15 1	<u>ت</u> کــــــــــــــــــــــــــــــــــــ	
			Re Ac		- 	~ ~ ~	• • =	± 2	
	3	1.5	Rr Ac	·/	。 (字)	3 2 3 3	8 + 0	= 2 2 7	4
		°:	γc		<u>→ </u>	5>- ~	W 4 0	2 2 2	
	_	8.0	Ac Re		\Rightarrow $\bar{\cdot}$	⟨⟨⟨⟩	N W N	7 6 10 11 14 15	22
		9.0	Ac Re			。 (\$<)	2 2 3	5 6 7 8 10 11	14 15
	}	\$2.	Ę		<u> </u>	⇒ <u>·</u>	\$ ~ ~ ~	+ · · ·	=
	ł		Re Ac				<u> </u>	E 4.9	9
		0.15	٧٧			/ •	ሊ	2 2 3	
	- [01.0	Ac Re				- (>)	3 4	8
		0.065	Ac Re				\$:\$	₹\}	3 4
	1	90.0	뢒				$\Rightarrow \overline{}$	◊◊ =	
	ł		Re Ac					- 44	2 2
	-	520 0	Re Ac				/	[(>4)	
	- {	0.015	¥¢					⇒ . ⟨=	
		0.010	Ac Re						
	1	<u> </u>		2 6 5	• <u></u> 8	225	200 200 315	05 80 52 05 05 12 05 05 12 05 05 12 05 05 12 05 05 12 05 05 12 05 05 12 05 10 br>10 05 10 05	2000
	1	3 8	ŧ.	∢ 6 0 U	F	U = -	X 7 3	240	æ
: _									

Liber first sampling plan below orrow. If sample size equals, or exceeds, lot or batch also, do 100 percent inspection.

As an Acceptance number.

Re in Rejection number.

- Rejection number.

SINGLE NORMAL

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

4		1	1 30	* * C					_	
o.										
7T		3	Ac Bo	0 R 2					\Rightarrow	
(see 4.9.3 and 4.9.4)	1	8	Ac Be	228	: (=				=	
.9.3		8	-	• 22 5					\equiv	
e 4		8	Re Ac	*•=						
8		8	Po Ac	700	2 2 2 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4					
		3	Ac Re Ac	M - 0		1				
			7	***	,	2 4				
		3	*		2	=				
		8	e Ac	4	~ ~ ~	3 2 ¢			=	
		2	Ac R	□	~ ~ ~	- 2 2	(=		<u> </u>	
		2	Ac R	\Rightarrow	- ~ ~	N = N	: ←		=	
	ec (pe	3	Ac Re Ac Re Ac Re Ac Re	\$.□	⇒∷	n u =	2 2 4		===	
	end in	4.0	Ac Re	î. Î		3 4 5 6	6 9 12 13 16 19	=	\Rightarrow	
	le lüght	2.5			- C	~ ~ ~	s •	: (=	===	
	iy Lore	1.5	<u>ب</u> د		⇒; -	⇒ = =		=	=	
	de Opesi	0:1	, Pe		<u></u> ⇒.	⇒ -	0 m m	8 9 12 13 1	Þ	
	Acceptable Quality Lavels lightened laspaction	97.0	Ac Re Ac Re Ac Re Ac Re Ac Re Ac Re			- ⇒	~ ~ ~	9 9 13		
		0.40	Re Ac				7 2 2	6 4 9	13 16 19	
		0.75	. Re				7 - "	U 4 0	6	
		0.15				<u>→</u>	- ~	5 3 2	•	
		_	Re Ac Re			/	~ - ~	7 2 2	*	
		0.10	Re				5)。	¬\	- n	
		90.0	۷				<u>⇒</u> `.	<u></u>	7 7	
		0.040	Re Ac Re				\Longrightarrow			
		0.025	He Ac R					⇒	\Rightarrow	- 7
		0.015	٧					⇒ .	\Diamond	
		0.010	Ac Re					\Longrightarrow	1 0	
		jı		S W S	- ¤ ≥	228	125 200 315	500 800 1250	2000	3150
	Seast	11		< 20 ∪	O m e	9 X ~	X J X	2 4 0	¥	<u>~</u>

— The first compling plea below arrow. If cample pice equals or exceeds for or batch size, do 100 percent inspection.
 — The first compling plea 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)

Second Control Contr		900	2	= = = = = = = = = = = = = = = = = = =
Court Cour		┝╧┤	- 4	
2 40 0 0015 0005 0000 0005 010 0.15 0.25 0.00 0.66 1.0 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5 25 4.0 6.5 10 1.5		8		888
22 24 25 26 26 27 28 28 29 20 20 20 20 20 20 20 20 20 20 20 20 20		\$	ž V	z z z z ∠ z ← z ← z ← _ z ← _ z ← _ z ← _ z ← _ z ← _ z ← _ z ← _ z ← _ z ← _ z ← z ←
22 24 25 26 26 27 28 28 29 20 20 20 20 20 20 20 20 20 20 20 20 20		ន	<u>و</u> بر	
Seminary Condition Condi		3.		2 = -
Semple Colid C		8	耂	••• \$ 3
Acceptable Quality Level Codered images (cod) 2 2 2 3 4		\vdash	귈	*** * 2 2
Acceptable Quality Level Codered images (cod) 2 2 2 3 4			3 2	/ - • • • • • • • • • • • • • • • • • • •
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2		-	Je Ac	N N N N N N N N N N N N N N N N N N N
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2		82	* *	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2		2	Ac R	\$ ~ · · · · · · · · · · · · · · · · ·
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	_	2	Ac R	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	ection)	\$	Ac Re	· 今 · · · · · · · · · · · · · · · · · ·
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	1 1	4.0	Ac Re	\$-\$-\$
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	3	25	Ac Re	→ - (++)
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	1 2	2.1	<u>ب</u> ر	→ - ()
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	8 4	0.1	c Re	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	Acceptal	99.0	r R	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2			Re	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2		-	Re	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2		_	Re	——————————————————————————————————————
Semiler 0.010 0.015 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.000 0.005 0.00			Re	
See 0.010 0.015 0.025 0.040 0.05 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2		-	Re	
Sending 1		-	٧c	
2 2 2 2 2 2 2 2 3 3 3 3 3 3 3 3 3 3 3 3			٧	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2			¥ 4	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2			Ac R.	
		0.00	Ac Re	
FERSE ABOOM FOR X Y B S C O E		ţ:		20
			r r	480 DMF 0I # X 1 3 Z 7 0 E

Ever first sampling plan below serve.
 Ever first sampling plan shore serve.
 Ever first sampling plan shore serve.
 Acceptance number.
 Hejection number.
 Hejection number.
 Hejection number has been exceeded, but the rejection number has not been reached, accept the lot, but rejuste normal inappretion page 4.10.1.4?

TABLE III-A - Double sampling plans for normal insp.

(see 4.9.3 and 4.9.4)

Master table)

10	
28	
23	
23	
2	
8 2 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	
8 y	
2 4 5 0-00-00-00-00-00-00-00-00-00-00-00-00-0	
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	
1 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	
■ □ □ □ · ← □ · · · · · · · · · · · · · ·	
	
	= % \
	1 1/-
	7 2 2 2 2 2
	S 2
	2 2 3 4 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5
	1 1 1 -
	4 0 0 0 0 0
6 \$ 7 0 - 0 m	
	0 5 - 0 0 0
8 =	~~ ~ ~ ~ ~
	2 0 0 - 0
8 ½ □ → · ←	□
\(\frac{\pi}{2}\) \(\pi	(中日) ::
Si 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	. (=
	
Class of the control	Sco. 1000 1000 1000 1000 1000 1000 1000 100
2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	S S S S S S S
First Second Sec	1
	e > =

DOUBLE NORMAL

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

	1	3		2. =	1														
		+	<u> </u>	5 2	/														
	3	۔ ا		À :=	7, 7	14													
l	-	1	-	= 7	7 12 7 12	2.5													
1	3	3	<u> </u>	- 5	= =	n 22	7												
	5.	3	•	4 7 Z	2 2	1	2 2 2 2	=										<u> </u>	
	5	3		- 3	2 5	= 7.	83	二											
1	<u> </u>	ير	<u>.</u>	2 =	- 3		25	\ <u></u>											
į	Ē	ž	١.	~ •	- =	- 5	- 2	(=										—	
ŀ	3	E			m ~	1 -	= =	38	<u> </u>										
1	 	3	-	===	3 5		~ <u>22</u>	92	= %										
1		4	·			~ •	-=	• =	- 2	(=									
	n	٤	₽	0 -	3 6	- 3	2 2	2 2	6 10 15 16	3 2 2	\forall							U	
	-	1	<u> </u>		~ ~	7 +	- 50	200	- 2	2 2	= 8	1							
		*		<u> </u>		0 -		~•	=	• 2	- 2	4							
]]	2	3			\Rightarrow	0 7	0 7		~ ~	3 7	2 2	2 2	l⟨⊨					—	
	3	<u> </u>	₽	1.		\equiv	77	7-	+ v	~ ~	~ 22	2 2	22	<u></u>					
]	-	1	V	<u> </u>		<u>-γ</u>	<u> </u>	2 2 3		- 3	2=	7 6 12 15	6 2	2 %					
1	<u> </u>	ž		<u> </u>	•		ightharpoons	<u></u>	0 -		~ •	^ =	 ₹	- 2	V				
Acceptable sparies Lowise Highward impressant	5	¥			\Rightarrow		=	\Rightarrow	• -	D T		2 5) 1 11 12	6 10	22 24	\leftarrow			
1	2	à				\Rightarrow			\Rightarrow	~ ~ - c	3 0	* 5	2 5	12	2 2	14	U		
1		<u>-</u>						\vdash	T		-1 8	7 +	2 9	2 -	7 2 12 13	16 33	2 2	1	
1	=	٠.					<u> </u>	<u> </u>		\Rightarrow	<u> </u>	• ~	-•	~ •	~ =	• ⊆	• 2	Û	
	9	<u> </u>						\Rightarrow			\Rightarrow	2 -	0 7		2 .	3 7 11 12	6 10 15 16	9 14	
	3	1											~~			s ~	7	2 2	
	-	<i>3</i> ±								Ŀ			>-	2 ~		9 5	11 1	7 6	
	2	3								\Rightarrow	•		\Rightarrow	o -	0 -	- •	~ •	e =	
	e 15	11									\Rightarrow			\Rightarrow	71 P	3 4	1 4	2 5	
		2				<u>:</u>						<u> </u>				~ ~	7 +	+ 8	
	"	<u>+</u>										<u></u>	•		7	o -	0 0	- •	
	1	: <u>:</u>											\Rightarrow	•		\Rightarrow	0 2 -	9 3	
	en estas	2												<u></u>				2 2	
		<i>2</i>												/	Ľ		/	<u> </u>	2
	: 0 0	3													\Rightarrow	•		\Rightarrow	0 -
	e ets	<u> </u>														=>			
	_	돌														<u> </u>		1	
Ш	9 9	و		_=			,											<u> </u>	
į	įţ	1			7 0	5	• •	28	5 8	2 2	2 8	8 3	≅ 2	2 3	£ 3	3 <u>8</u>	3 3	1250	3000
	₹. •			~ ~	- m	v v		==	22	2 2	23	28	<u> 8</u> δ	8 8	313	3 S	2 8	1250	2000
 				-	7	-	<u>-</u>	-	7	72	7	7	7	-		ļ			
<u> </u>	j			Fired	F. 174	First See	F. Cr.	E S	F. CO.	First	First	First	First	Į .	First	18 0 J	1 3	F. 12.	# F
	1 2	ì	-	=	-	ء	-	4	٠,	=	-	æ		>	,	-		٠	,

The first sampling plas below some. If sample size equals or exceeds by selected size, do 100 percess inspections.
 It first sampling plas above some.
 At == Arrestance number.
 Ite = Hejections number.
 Ite = Hejection number.
 Ite convengentating single sempling plas (as, alternatively see chadde sampling plas below, where available).

DOUBLE TIGHTENED

MIL-67D-105B

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

4		1	Z Z		⟨ =													
4.9		3	2	••	•	(5
and		8	74 74 74		•	ER	1											=
		-	2		-	1 × 22	= 8											
.9.3		250	7 1		•	22	= R	(=1
e 4.		3	¥		•	2 2	~ :	任										
see (see		2	भ अ	,	•	21 e	2 %	一										
		65	Ac Re	• •	•	1 2 6 9		2 2	Û.									\Rightarrow
		3	Ac Pe		•		~ •	- 2	91 21	(=								=
		и	A		•	• •	5 -		3 0	2 2	(_							
		15	2	, 7.	•				~ •	• 2	2 =	<u></u>						ᆿ
			2		•	7 -	4 10		3.		21 21	2 %	<u>/</u> _					=
	+ [**	6.5	#			~ ~		75		% P	r •	12 5	2 2	1				〓
ļ	•	6.0	4	<u></u>	<u>万</u>	~~	00	7 -	• •		4 2		0 12 12	2 2	1			
	Acceptable Omility Lavels treduced inspection)		7 A	14.	<u> </u>	5	00	00	0 -	0 n		C1 40	7 6	8 S	9 2	4		
	d afar	2.5	¥ 4	/	<u>. </u>	₽		00	00	0	9 5	- •	5 2 4	- 6	2 2	\		
	alley L	51	7		<u>√</u>	Ŀ_		4	00		o -	0 .		2 9	1 1	91 71 91 5		
	4	1.0	¥ ¥			ightrightarrow	<u> • </u>	<u>\{\righta} \</u>	4	2 2		9 1	9 €	- 5	6 0	2) e	5 10 12 16	
	Accep	9.6	14 14				\Rightarrow	•	\$	c>	0 0		9 0	3 6	1 5	2 7	J 8	2 2 2
		9.40	£ 2					\Rightarrow	•	4	口	2 0	b 3	2 1	3 6	1 5	2 7 6 9	2 6
		6.25	¥ y		=				\Rightarrow	•	()	仓	6 2	0 4	1 5	9 9	2 4	0 4
Į		0.15	ž							<u> </u>	•	Û,	1	~ ~	~ ~	* S		~ ~
		0.10	3							_ <u></u>		•	(2 0	0 -	9 5	7 0
		0.046	34									7	•	₩	-7	~ ~	~ +	
		0.000	Re											_	7		7 7	
			*										<u> </u>	•	Û	5	••	
		15 \$ 025	te Ac He											= >	Ŀ,	⅌	5	
		0.015	e Ac He												\Rightarrow	Ŀ	E	
		0.00	A F	Ш												\Rightarrow	•	
	į	ij	į			~ 7	m •	~ 2	- 2	= x	83	32	8 8	09 1	ন গ্র	8 8	315	8 8 8
		† :				~ ~		s =		22	2 8	22	88	88	ត ឆ	88	25 E	§ §
		j				1 3	First	1	First Second	1 3	F inst	1 3	First	Fire a	1	Fire	F. 22	T S
	j	11	į	< €	Ü	ء	ta:	•	ن	*	-	# ·	ب ۔	=	2		3	=
ı								L		<u> </u>		لـــــــــــــــــــــــــــــــــــــ					لــــــــــــــــــــــــــــــــــــــ	لـــــا

DOUBLE REDUCED

Der first sampling plus before arrar. If sample size equals or exceeds for an barrh size, do 100 percent impaction.

 Der first sampling plus above arrar.

 No. — Acrepiance member.

 Perceptance member.

 Des corresponding single sampling plus for observatively, was double sampling plus below, whos evoluble.)

 Des corresponding single sampling plus for observatively, was double sampling plus below, whos evoluble.)

 Des corresponding single sampling plus for observatively, was double sampling plus below, whos evoluble.)

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

(see 4.9.3 and 4.9.4)

. 1		Τ.	Т	2 1	<u> </u>													
:		Ī	ł_	[· 1								=						\Rightarrow
		3		4 . 1	\$ 14													$\overline{}$
		1	T	<u>}</u>	1 26	****	2 (<u></u>										\equiv
-		3	1	1.1	1 ==	282	3 3	S R S	331									<u> </u>
-		-	 	3		SEAR		251										<u> </u>
-	;	<u> </u>	!	<u> </u>		2288	1	= 2 :	× 8 :	3 /-								_
ı		Ŀ	 	. :	<u> </u>	2222	9 -	- 2 2 k	2 = :	1								=
-		*		# · 1	#	2022		222		- =	E 4 4 2 5							\overline{a}
		*		. 1	# 13.	-2=3:	: [~	- 2 :	2 = :	- 2	2283	7 - :	2 N S 3					_
-		R		1. 1							222	_			0 2 2 2	1 4		
					+==	****	1:		~ 2:	2	•===	1	-225	0 = :	11==	1/		\equiv
		2			1		· -	- ~ ~	n ~ :		2 = 2 :	2 • -	3555	<u> </u>	ដែកសា មេដល់សា		288. 228:	5 E
		2	ه د		‡			~ - «	* * * *		~ * * * *						== 8	3.6
	Ī	2	1	•	3		7	~~		123	. n			:		_	20 m	: :
	1	;	- 1		7		-	~ ~ ~		225								
	Virgidalie (bolity Lovie (menal lesperting	}	- 3	3.1	1		<u> </u>	• • •		000				• • - ~ -		1	200	2
1	!	2	- +	7	1/-				$\overline{\rightarrow}$		•	• • •					~~~.	
		2	= ₹				16		_		──{)	****	200-	***			
		3	7			==	1.			(=		, E				~ ~		7.5
	•	ÿ	±						<u></u>	<u> </u>	 -	1/					<u> </u>	
	1	3 5	3							<u> </u>		1		1			• •	<u>``</u>
	ŀ	2	1									<u> </u>		1				4
	ŀ	┇	ر غ										/	J		1		긔
1	-	-	- 2												\Longrightarrow	ŀ		╛
	-	1															===	\
	L	1	2 2													_		5
		•	2				=		_									计
	Ī	ğ	<u>}</u>															H
	r	<u> </u>	2 2					_										H
	.	<u> </u>	2 2				_	=										
\vdash			$\overline{}$		T		<u> </u>									=		
L		11:	_		~	-222		- = 4	2 = 2	~ 2 2	ម្តីស្ត	- = :	ក្នុង ន ង	2882	2 R #	R 9 5	8 8 8 8	2
L		1				~~~~	-, -,		•		***	•••		2222	222	9,25	. A 2 R	2
		j			1 3 3		7 3	11:	3	:]]	111	3 2		1311	2 1 1	: 1	is:	1
Γ	1	111	7	< E U			+		- 1	_		2.3°	- 2 2 3 3	= 5 = 2	297	<u> </u>	123	4
					<u> </u>							L						

MULTIPLE NORMAL

(see4.9.3 and 4.9.4) TABLE IV-A—Multiple sampling plans for normal inspection (Master table)
(Continued)

	ş	4 2 3			
	3	de He]
	7.	41 14			j
	3	à	<u> </u>		
	\vdash	¥			
	<u> </u>	*			
İ	3	٧			
	3	41 34			
ì	ŭ	Ar 14		===	
	2	2			
	<u>.</u>	<u>۲</u>			}
		<u>خ</u>	 		1
	[3]	۶. اد			*
1	:	, <u>1</u>		==	
Acceptable Usalny Errols (manal inspection)	2	3	*******	 -	sample star equals or excess hat or hatch star, do 100 percent capacities or preceding page; when necessary) for alternatively, mer mahliple plan helper, where available?
1	 	<u>ځ</u>			
1, 1,	2	2 7			
3	:	2	コーチャキャー チャートロ チャーロコロス ショココポニヤ トココロロビ アニコンカスカー		
44.7	┝─┤	- 3	N - 1 - 4 - 4 - 4 - 4 - 4 - 4 - 4 - 5 4 - 4 - 5 - 5 N - 5 - 7 - 7 - 7 N - 5 - 7 - 7 N - 5 - 7 - 7 N - 5 N - 5 - 7 N - 5	223#	obes necessary) andres necessary) andrese gies helow
ř	3	- 4		2835	
	35	ᆂ	langer with the contract of th	222 222	
	X.	3		25.5	the arror. If sample arr equals arreceds be or been been been arror in the page, when necessary amounting place for algebrasically, we making place he
		2	 	2 2 2 2	
	اقا	*	V	~~ 22	
	9	<u>≐</u> ∵			eplang plas felos acros. Il sos eplang plas above acros felos to estados estados estados estados felos feros estados estados felos feros
	3	÷		A + + -	
1	ائا	۲ <u>.</u>	V		Use first ampling plan for a Use first ampling plan in a Keeper too a market. Keeper too a market. Meeper t
1	3	¥ .		- ~ ~ •	
	500	Ar He			1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
	\$ a	ž	\(\(\(\) \		33 33 4
		¥ ≟	\$		* * * * * * * * * * * * * * * * * * *
	0,140	د			\$\\\\
		ì	日本本東京会社 台西田田田田田 (本本市の日本市 日本市 日本市 日本市 日本市 日本市 日本市 日本市 日本市 日本市	9002 0002 0002	
	} :		리리리리면리리 <mark>결정인정점점 함께를통하는 한</mark> 경환자리는 한경험성성성 근근본등관점 등 등 <mark>경</mark> 영		
	ţ			111	
	}	1	4 2 8 2 2 2		

MULTIPLE NORMAL

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

(see 4.9.3 and 4.9.4)

	1	1	2	;						
			-÷-	 	Ta					
### ### ### ### ### ### ### ### ### ##	}	3	1	1 . 1 1	(-					
## 1 1 1 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2					4	===				
### 1		•	-			28×8×35				
## ## 1		H-	-	' ' '			,			
### 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		2		-	1	1	 			
### ### ### ### ### ### ### ### ### ##					222282		<u></u>			
The state of the		<u> </u>					7			
The state of the		3.	ı			1	1	1 \		
Company Comp				. : :	i	Į.	i		(
Care Care	ĺ	-		A					-228882	14
Company Comp		-		7.1					=====	\ <u> </u>
The state of the s		_ <u>s</u>		□⇒ :	1		1		1	1
Company Comp	1	2			******		mn-n-+-		4=535	*****
Company Comp	1		Ī		1					0 K + 0 2 2 2 2
Company Comp	1	تا		\$ -	→				·	į i
Color Colo	į	3		⇔		─	******	*******		_
Color Colo	1	- <u>-</u> -	_			· · · · · · · · · · · · · · · · · · ·	Λ		L	
Color Colo	17	<u> </u>		7	<u> </u>		/	*****	 	
Color Colo	3	=			\Longrightarrow	•		\Longrightarrow		
Color Colo	1	•	i i							~~~~~
The state of the	٤	\vdash	_			γγ			/	1 · · · · · · · · · · · · · · · · · · ·
		·					\longrightarrow	<u> </u>		\
Company Comp	1			<u> </u>				\Longrightarrow	[•	
The state of the		22	1							
The state of the	1	٦							<u></u>	
Trans. Trans.			*							
Company Comp		•								===⇒
Company Comp		2								
		ŀ°-								γ
										$\Longrightarrow $
Company Comp		8								
		- 1								
		30.0								 >
The state of the s	J				~ • • • <u>• • • • • • • • • • • • • • • •</u>	~ • • ¤ ¤ = ≈	2528282	*******	2842352	8338383
				-			****		232222	RRRRRRR
			\neg		11774	. 1241	112.41	: 175 1	: 1:1:-	: 17 14 2 1
	<u> </u>	<u> </u>	_	~~	1921113	1322233	2322233	£32253	ESELETT	
,,,,	Ì	; [-=-	=	•	•	ن ا	±	-

nature plan (or alternatively, one makinja nampling plan below, where evallable). This of the for alternatively, one malijake nampling plan below, where evallable).

MULTIPLE TIGHTENED

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

4	•	•					MIL	-91 D-105	i B		
4.9.4)											
and											
۳.		1	1	(===							
4.9			3								
		65	*	1							
eee)		\$	W ye	(
		2	Ac Ne	\							
		8.	3								
		_	Ro Ac	<u></u>							
		2	*	<u> </u>							
		3	4	(
		8	#	\							
Ì		A	ş	<u> </u>							
· }		<u></u>	1	<u> </u>					·—-		
ľ	mape CI real	_	2	V ====================================	14						
,		اٿ	¥	######################################	(
	1	3.	Ac He	######################################	-222222 -222222						į
	Acceptable (Juality Levels (tighteard	:	\$	2 2 2 2 2 4 2 4 2 4 2 4 2 4 2 4 2 4 2 4	281554 281554	2222 2222 2322 2322					
	1110	<u> </u>	¥	-N	***===================================	** 525582	-พะแพล				
nea	4	\dashv	*			2 1 1 1 2 1 2 1 2 1 2 1 2 1 2 1 2 1 2 1	====================================	-228882			
in	Pro l	<u>~</u>	¥	**			2452	==####	(
(Continued		2	Ac Se	******	-0-0040 0-0040			au-5422	==RARR	\	
2	Ì	å	ž	~~~~	MAMA400	~~~~~	******	====	**22288		
		-	40			201998	*****	******	4 0 4 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		
l		-	¥		******	*******	************	*****	9 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6		
1		χ.	3			•••				224440	<u> </u>
- 1		2	Ar.	•		\Longrightarrow	*******	*********	*****	1-2W2-0	İ
l		2 0	\$					~~~~	~~~~~	mn-ss-s-	
ł	ŀ	*	He Ac	7		•			MUMMUM	N	
	- }	-	*		/			ν	******	******	·
į		3	a le			\Longrightarrow	•		\Longrightarrow		L
- 1		550	2				\Longrightarrow	•		=== >	
		0 015	ŧ					>			
		9	He							4	
1		•	7						 >	•	
	į	1 1		23 <u>55</u> 22	2525253	8388833	2222325E	200 200 1000 1200 1200 1000	211. 01.0 01.0 01.0 01.0 01.0 01.0 01.0	0051 0007 0052 0051 0051 0061	800 1840 2401 2700 4400 6400 5400
		† :		REREFER	222222	888888	នតននននន	222222	222222	3333333	939 00 00 00 00 00 00 00 00 00 00 00 00 00
		1					Hilli	112121	112121		177
	į	: 1		4	ب	3	>	a	0	Œ	s

MULTIPLE TIGHTENED

₩≥≥..

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

(see 4.9.3 and 4.9.4)

	1	Ŧ	1					
1	<u> • </u>	1						
	\$	2	· · · ←					صحح
1	1	à	1 (
	<u> </u>	77 74		14				
		7	• • • • • •	/				
	2	*		 				
-		*	1 1	<u> </u>				
	<u> </u>	*	<u>`</u>	22588	14			
-	8	77	• • • • •	•===	 			
1		. Pe	11	2555000	284420	(<u></u>		
1		7/11			22.02222	** 22282	1	
	2	¥	,				(
-	_ 2	*	\$ + +	10-NP-9		200000	22 - B !!	—
1	2	2	3.11	M400FF6	*****	*****	~~~ <u>~~~</u>	225 b t t
		2	- V		M-N-N-	*****		22522
Ī	3	¥	• (24) + +		***			
Lectorable Quelity Lavels (reduced lespecies)	:	At 18e	4.44:					
3	2	ě	□ · Þ		~~~			4×4×4×2
1	Н	*		*****	*******	******		200000
1	2	Ac A	$\Rightarrow \cdot \diamond$		••••-			
11	•	ž	₩ ·			*****	******	nn-03
]	-	*	<u> </u>	 			****	~~~~~
	3.	۲	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	<u> </u>	(\\		
	3	Yc Br		\Longrightarrow	• .	—		
1	× ×	ě						
Į	<u>s</u>	*				L		A
1	٥	¥					•	
1	2	Ac Re						•
	3	ž						
	۳	老						
	3	¥						
	ğ	Æ ¥						=== ⇒
1		ž						
		¥ 2						
	≗	ų ų						
	111	1		~ • • • • • • • •		~ 5 2 8 2 3 2	-=====	245825
	1:					****	•••••	222222
	j			[[]]	1]2[1]			[]][[]]
	11	i	< a U, a w		9	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	•	2

It is first somplang plan beine were (refer to continuation of tailde to following page, when necessary). If usuaple size organics, or exceeds his or bands nime, do 180 percent important

- Use corresponding single ampling plas (or absenceively, our multiple comping plas below, where available).
 Her corresponding double complete plas (or absenceively, our multiple comping plas below, where available).
 Acceptance are permitted at this complete size.
 If a fire the final complet, the acceptance number has been exceeded, but the reportion defend complet, the acceptance number has been exceeded, but the reportion of the particles of the firething plan is not released in the first plant of the better than the final complete, the acceptance of the first particles of the

MULTIPLE REDUCED

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

		٠.		•			TO SEE SE	4.00000	4248383	2888000
				•			*****	A	******	8:82
= .		•					182222			
4.9.4)				A				• • • • •		
		1	4					~~~~~	******	700000
and		3	Ac Be	==			=	*****	*******	nn-00-
			, ag y	(_				
4.9.3			2	<u> </u>					******	*******
4		ä	¥	(****
eses (see		3	Ac Re	=			=	V	\	
ا ٿ		8	ž	<u> </u>				<u> </u>	\ <u> </u>	
		_	¥ ¥	<u> </u>				 >	, •	(
		3	لا	<u> </u>			228888	8 2 2 2 2 3 3 3	222222	223288
1		3	Ac Re	=		=			- AMMSES	4 + 2 2 2 2 2
		Ø	ž	(_	222222	2 2 2 2 2 3	2555555	222222
ſ			왕	<u></u>		_	121.1	. 12 5 4 4 5	17844	17505
j		- 13	Ne Ac	· · · · · · · · · · · · · · · · · · ·			11111		111111	
]	+	2	. پد			_	=	۵	6	=
	abecc.	6.5	Ar Te	******	\	_	=	I	<u> </u>	لـــــــل
ļ	Accristable (budity Levels (reduced inspection) 1	••	ž	2 - 4 2 2 2 2	**22288	4	- -			
	- Ja		4	4 0 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	2	3	_			
	lese.	25	٧٧		0-44-52	۰	_	25		
2	Sealet	1.5	ic Ne	-0-26-9		•				
nea	4sble	0.1	r fe	6 0 6 1 6 1 6 3 7	****	•	.			
(Continued)	Arce	\$9.0	Je Ac	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~	N 4 N 9 F F M	F	5			
ou		-	#	256633	******	-	_			
9		0.40	Ac H	**000==	* * • • • • • • • • • • • • • • • • • •	Ŀ	e			
	!	0.25	Ac Ke	*******	******					
'	i	0.15	2	<u></u>	**************************************	~	MIL-SI	D-105E		
			₽ Pr	4	· · · · · · ·	-	;			====
		0.10	¥			Ŀ				
'		\$90.0	Ac Re	•	\	C				
	:	0.040	ž			7				
1			#	γ		_				
		9 005	¥		\rightarrow	Ŀ				
		0.015	F H			=				
		0.010	*			_				
			ž			_				
			=	833888	828252	Я				
		ž s		222222	*****	я				
		Semple	. —.			ļ.,				
		Semple		First Park	First Second Third Fourth Fifth Saith Second	3				
		1 1 1	į	ı						
İ	<u> </u>	x = 8	<u>.</u>	L		L_				
							2000001			
							===			
								. 222584		
						i	- 5 2 5 5 A	F • 2225	******	
						•	MM N -		•	
									·	

MULTIPLE REDUCED

he rejection number has not been reached, occups the lot, but rejection persod inspection (non-4.10.1.4)

n or back size, do 100 percent inapection sy).

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

(see 3.3)

	901	911					
	953	8 8 3		 			
	8	6 8 3	3				
	82	98 98 98 98	2 2				·
	351	2 2 2	8 E				
	190	3 25 55	81 61				
	જ	2 5 8	22 22 22				
	\$	888	%	3			
	Ŋ	3 3 8	3 % %	8 8			
	25	2 2	នន ន	2 6 9			
	2	11	17 15 16	2 2 2	12		
	6.5	=	11 12 12 12 12 12 12 12 12 12 12 12 12 1	9.9	7.5		
3	9.	22	6.5	6.1 6.3 5.6	5.2 4.7 4.7		
Acceptable Quality Level	2.5	7.4	4.2	3.9	3.6 3.3 3.0	2.9	
Xable	1.5		9	2.4	2.5 2.2 2.1	<u> </u>	
Accep	°:		24 88	2.2	3 3 3	1.3	
	0.65			=	1.1 0.97	0.90 0.82 0.75	0.73
	3			1.2	0.67	0.56	0.67
	0.25			0.74	0.42	0.36	0.33
	0.15				0.27	0.24	0.22
	0.10					0.17 0.17 0.16	0.16
	0.040 0.065		 		0.18	0.11	0.042 0.069 0.097
	0.0		,	·	0.12	0.067	0.069
	0.015 0.025					0.074	0.042
						0.045	
	0.00					0.029	
Sample	Size	ผูพ พ	8 13 20	26 23 33	125 200 315	500 800 1250	2000
కే	Letter	∢ છ ∪	9	0 E ¬	* 7 Z	z 4 0	Œ

AOQL NORMAL

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

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

(see 3.3)

	•	8 §					
	8	888		-		——————————————————————————————————————	
	8	858	3			1	
	8	258	22				
	2	355	3 2				
	3	F25	2.8				
	8	\$82	3 2 3				
		228	***	a			
	*	RR	***	**			
	2	£	2 2 X	***			
	2	•	= = 2	2 2 2			
1	59	22	33	333	33		
1	**	72	77	323	333		
Assessed Order Lord	ม		3	222	222	n	
]]	51		3	22	222	22	
	2		2	7	120	255	
	8			3	553	333	27'6
	•			27.	2.2	87 0 87 0 14 0	0.0
	ä		·	3	623	77°0	***
	ň				9	553	9. 18
	.				3	35	140° (
	3				27.	9.467	•••
	3		·			5	9
	ă		 			3	
	ğ					8	
	\$						3
	jı	84 M W	-34	***	N # S	2 2 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3	9517 9037
	31	48 0	a w b	0 = -	R 17 E	240	**

. Notes For the exact AOQL, the above values must be multiplied by (1 - Let or Betch eise

(*** 11.4)

AOQL TIGHTENED

(see 4.11)		10		88	动	\$	#	ಸ	&	*	ឌ							
eee (see		6.5	89		÷	×	8	22	ឌ	16	16	*						
		4.0	J	\$		12	ช	ಜ	18	*	12	2	9.0					
Percent		2.5		37			18	91	13	11	₽'6	7.7	9 .4	5.6				
10		1.5			22			12	10	8.2	7.4	5.9	4.9	4.0	3.5			
Pa =		1.0				91			7.6	6.5	5.4	4.6	3.7	3.1	2.5	2.3		
wbich ng)	e e	0.65					11			4.8	4.3	3.3	2.9	2.4	1.9	1.6	1.4	
for s samplis	Acceptable Quality Level	0.40						6.9			3.1	2.7	2.1	1.9	1.5	1.2	1.0	
ective) ingle	table Qu	0.25				_			4.5			2.0	1.7	1.3	1.2	0.94	72.0	
int de ion, S	Accep	0.15								2.8			1.2	1.1	0.84	0.74	0.59	
perce		0.10						_			1.8			0.78	0.67	0.53	0.46	
lity (in rmal		90.0										1.2			0.49	0.43	0.33	
g Qua		0.040											0.73			0.31	0.27	
imitin ()		0.025												0.46			0.20	
7-V		0.015		<u>-</u>											0.29			
TABLE VI-A—Limiting Quality (in percent defective) for which (for Normal Inspection, Single sampling)		0.010														0.18		
TAB	Sample	U718	2	ი ს	8	13	20	32	20	80	125	200	315	200	800	1250	2000	
	Code		< €	ာ ပ	a	ய	ů.	ຽ	=	-	×	د	7	z	۵	Ġ	=	

LQ (DEFECTIVES)
10.0%

(see 4.11) 'IABLE VI-B—Limiting Quality (in defects per hundred units) for which P_a == 10 Percent (for Normal Inspection, Single sampling)

		_										_					
	9901	9061	3														
	959	0991	905	8	•												
	9	900	3	770	670												
	052	22	29	38	\$	9							-				
	951	280	210	ŝ	200	8											
	851	\$	8	310	କ୍ଷ	ន											
	જી	g	310	240	8	3	\$				•						· · · · · · · · · · · · · · · · · · ·
	\$	210	ន	8	951	82	8	28									
	22	8	8	85	021	5	H	8	8								
	15		130	911	2	=	S	3	\$	×							
	91			28	29	3	\$	37	3	ผ	g						
Level	6.5	8		_	\$	Ŧ	33	62	22	2	9	=					
Acceptable Quality Level	4.0		11			8	27	21	61	55	12	2	9.0				
oble ()	2.5		-	\$			8	17	<u> </u>	12	9.4	7.7	7.9	5.6			
Accept	1.5				&			12	=	*	7.	5.9	4.9	4.0	3.5		
	1.0					18			7.8	6.7	5.4	4.6	3.7	3.1	2.5	2.3	
	0.65						12			6.	4.3	3.3	2.9	2.4	6.1	9.	=
	0.40							7.2			3.1	2.7	2.1	1.9	1.5	1.2	0.1
	0.25			-	_		_		4.6			2.0	1.7	1.3	1.2	26.0	0.77
	0.15									2.9			1.2	1.1	0.84	0.74	0.59
	0.10										1.8			0.78	19.0	0.53	0.46
	9.065											1.2			0 49	0.43	0.33
	0.040 0.065												0.73			0.31	0.27
	20.0													9 :0			0.20
	0.010 0.015 0.025														0.29		
	0.010															91.0	
Semple	size	2	60	5	80	13	20	35	S	28	125	200	315	200	908	1250	2000
9 83	letter	4	33	ပ	۵	er.	ie.	ဗ	I	-	¥	ب	7	7.	ے	>	=

LQ (DEFECTS)
10%

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

(see 4.11)

	10	8	283	2 2 2	ಸ		
	6.5	R	\$ 5 \$	2 12 2	8 1 S1	**************************************	
	4.0	8	R 8	ឧងន	14 11 9.6		
	2.5	\$	ន	18 15 13	11 8.5 7.0	6.1	
	1.5		31	7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7	88	4. E	
	1.0		8	9.1	6.2 5.3	2.4	
	0.65		*	k,	3.9	2.6	1.5
	0.40			6	3.8	2.1	
y Level	0.25			5.8	2.0	1.3	0.65
Acceptable Quality Level	0.15			3.7	1.5	0.97	99.0
cceptab	0.10				7 5	0.38	0.53
	0.065				1.5	0.59	0.39
	0.040				0.95	0.38	0.32
	0.025					09.0	0.24
	0.015			vav		0.38	
	0.010					0.24	
Sample	eize.	81 M W	13 8	32 50	125 200 315	500 800 1250	2000
	etter.	< m U	0 11 1	9 = -	×JZ	z a o	Œ

LQ (DEFECTIVES) 5.0%

(see 4.11) TABLE VII-B—Limiting Quality (in defects per hundred units) for which P_a = 5 Percent (for Normal Inspection, Single sampling)

_		_	-		_			_	_			_	_	_	-		
	1	ä	Ĭ		_												
	959	250	8	90.1								-					
	8	1100	8	93	110							-					
	92	93	2	610	510	3		-	 -								
	150	3	230	3	9	310									-		
	100	83	\$	3	270	82											
	99	88	8	260	210	2	8								•		
	3	320	8	210	8	130	21	88									
	23	240	210	160	061	8	2	3	3			-171,					
	15		3	130	16	5	3	S	\$	8					-		
	10			æ	82	8	ន	=	ಸ	z	×						
i	6.5	150			33	\$	8	ន	×	21	91	15					
	6.0		8			33	32	72	2	16	=	=	9.6				
F ve	2.5			3			ಸ	8	22	13	11	6.5	0.2	1.9			
elity	1.5				켮			51	13	9.7	8.4	6.6	\$. \$.	3	3.6		
9	1.0					ន			9.5	7.9	6.2	5.3	4.2	3.4	2.7	2.4	
Acceptable Quality Level	0.65						25			5.9	5.0	3.9	3.3	2.6	2.1	2:	1.5
	0.40							9.4			3.8	3.2	2.5	2.1	1.6	=	=
	0.25								6.0			2.4	2.0	1.6	1.3	=	8.0
	0.15									3.8			1.5	1.3	0.97	3 .0	0.66
	0.10										2.4			8.0	9.79	0.62	0.53
- [0.065											1.5			0.59	0.50	0.39
	0.040 0.065												0.95			0.38	0.32
	0.025													9.6			0.24
	0.015														0.38		
	0.010															0.24	
Sample		2	m	\$	80	13	8	32	S	8	125	200	315	88	8	1250	2000
3	etter	<	&	ပ	۵	ίω	4	Ü	×	-	×	ب	Z	z	۵	0	æ

LQ (DEFECTS) 5%

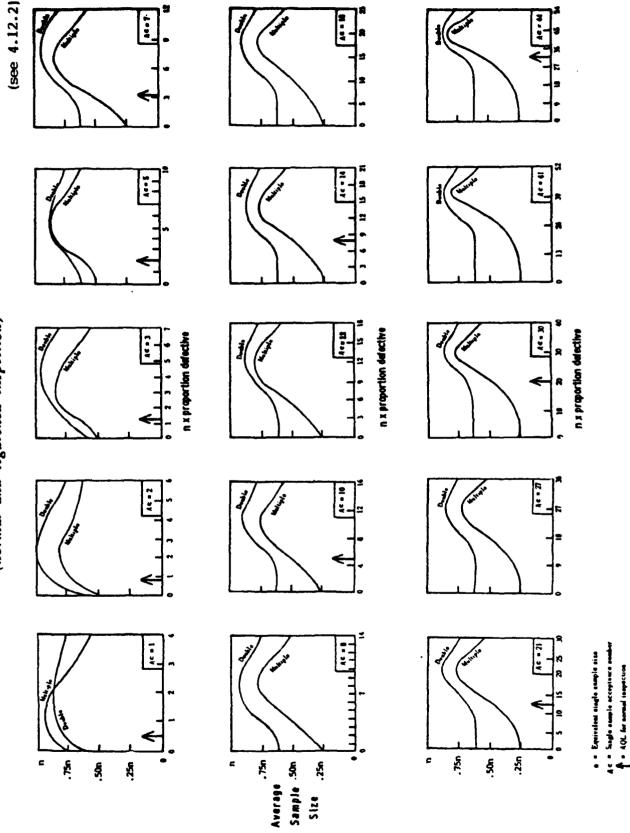
TABLE VIII—Limit Numbers for Reduced Inspection

(see 4.7.3)

Pronces that the number of sample units from the fast on hat he has no furthers is not sufficient for reduced impection for this AUL. In this lastinate more than the fast on the sample on ariginal impection, consider that the fast of the sample of ariginal impection.

LIMIT NUMBERS

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



AVERAGE SAMPLE SIZE

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

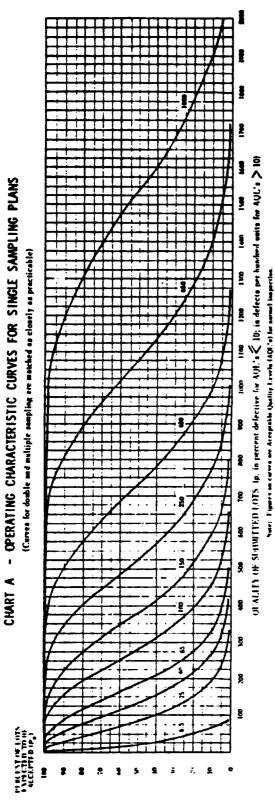


TABLE X-A-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptab	ste Quality	Levels (no	Acceptable Quality Levels (normal inspection)	ion)						
e*	٤ 9	6.8	25	0\$	89	951	8	X	250	X	900	X	959	X	1000
	p (in percent defective)						, j	p (in defects per hundred units)	r hundred w	nits)					
0 66	105 0	0.503	141	218	2 11	- 68 - 88	155	175	239	20 5	374	515	£3	859	11.6
3.0	2 53	2.56	17.8	6 0\$	6.83	131	661	235	306	381	462	23	345	\$66	1122
0 06	\$ 13	5.2.7	26.6	55.1	5 19	158	233	212	381	432	SIS	3	812	£701	120
75.0	13.4	11.4	4.8 1	96 €	121	211	962	342	103	521	612	Æ	934	1214	28
0 05	893	34.7	639	134	184	787	:183	433	533	633	233	8.	1083	1363	1533
25.0	0.0\$	693	135	196	583	37.1	187	35	159	191	67.0	1087	1248	1368	1728
10.0	7 89	115	104	266	334	198	286	059	077	869	905	1238	1409	1748	1916
5.0	77.6	150	237	315	388	92 %	657	222	878	216	200	133;	. 1512	1862	203
0.1	0 06	230	332	420	205	929	800	870	1001	1911	1272	1529	9121	2089	22.70
	X	Χ	40	99	001	0\$1	X	0 5 Z	X	00+	Χ	650	X	0001	Χ
					Acrepte	ble Quality	Lovels (tip	Acceptable Wality Lovels (lightened inspection)	pection						

Becaused distribution upod for passent defective communications; Poisson for defects per hypothed units.

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

j	11:		2				
	_	ž	ñ	€	· .		
	100	٧٧	Я			\triangle	
	χ	2	8	ε	•	900	
	^	Pe Pe	z z				
	93	Yc t		ε	•	X	
	X	Ac Re	61 91	€	•	650	
	909	2	15	ε	•	X	
	,	ReAc	3 14			 	
	X	Ac F	12 13	ε	•	99	
3	250	Re	10 11 12	ε	•	X	(BO
Acceptable (Justity Levels (normal inspection)	X	Ac Re Ac	6	ε	•	250	Acceptable Quality Levels (tightened inspection)
i lamos	150	2	•	ε	•	X	ightened
Levels (8	Re Ac	2 9	£		051	Levels (t
ality	-	Re Ac	\$				otity
ن او	S9	٧c		ε	•.	8	3
Accepte	9	Ac Re	2 3	ε	•	65	Accepta
	X	Ac Re	1 2	٤	, •	3	
	15	Ac Re		Sade Us	æ	x	
	2	ڇ	:	Leigh Us	U	15	
	X	Ac Re Ac		3 3 <u>5</u>	<u>a</u>	9	
	6.5	ž		•	•	X	
		Fe Ac				5	
	Less than 6.5	Ac I	D	>	>	Leas than 10	
3	Partice Partice		2				
	sampling ples		, Si		Keltiple		

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

Acceptance number

Rejection number

Dee single sampling plan above for alternatively use cade letter D).

Use single sampling for alternatively use code letter B). D & & . E

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

CHART B - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

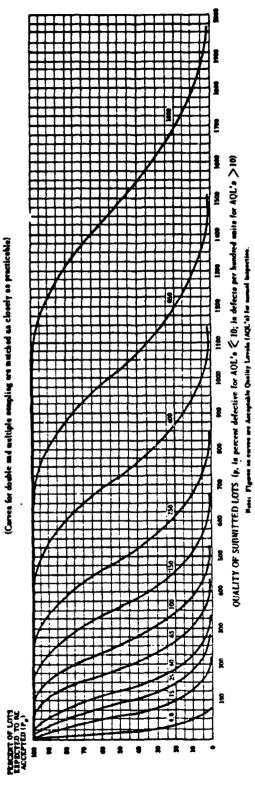


TABLE X-8-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

						Acces	Xable Qual	Acceptable Quality Levels (normal inspection)	(acreal is	apection)							
a *	0.7	9,	13	ß	\$	88	901	Χ	150.	X	0 52	X	907	X	989	X	7000
	p (in percent defective)							p (is	lefects per	p (in defects per hundred units)	nite)						
0.06	0.334	0.335	16.9	14.5	27.4	S 65	8	111	159	203	249	345	419	215	651	247	1029
8.0	1 70	171	11.8	27.3	45.5	87.1	133	157	206	256	306	415	8	663	25	1065	1152
900	345	3.51	17.7	36.7	58.2	202	155	181	234	289	343	456	541	912	3	1611	<u> </u>
75.0	710	9.59	32.0	57.6	2.5	Ξ	8	822	782	347	90+	230	623	609	903	1269	134
8	20.6	23.1	55.9	1.08	122	<u>86</u>	ž	289	356	23	£	229	ZL.	726	1022	1369	-63
280	37.0	193	9 649	181	170	247	323	360	E	205	98	121	832	5101	1152	1539	1644
10.0	53.6	76.8	55	177	23	38	392	83	316	593	11/9	828	939	\$911	1221	1683	1793
8.0	63.2	8	<u>\$</u>	210	ž	25	8	15	\$ 8	3	130	800	1006	1241	9581	1773	9991
0.7	78.5	154	122	280	35	437	83	985 87	671	192	848	1010	1145	1392	1513	1951	2069
	6.5	• 5	x	\$	8	90.	Χ	051	X	220	Χ	009	Χ	959	X	0001	X
						Yec	eptable Or	Acceptable Quality Levels (tightened insp./ 10n)	ls (tighten	ed insper	(40)						

ir Masenial distribution used for procest defective comparationa; Poisson for defects per bundred salts.

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

_	WITH-SID-IODE		, , , , , , , , , , , , , , , , , , , 				
		2 4	6	2	1	į	
X	‡	; 31 ; 57	\$	2	1000		
		8 3 8 3	23	Re Ac Re Ac			
1900	<u></u>	38 52	31 41	٧			
IXI	‡	17 22	31	2	8		
	‡	35 37	<u>8</u>	ReAc	∇		
93		16 15 27 34	22	e Ac	\triangle		
IXI	‡			F H	\$		
\$	‡	14 11 24 26	13 14 15 18 19 21	Ac Re Ac Re Ac	X		
1 7 7 1		19 23	15 18	ع ا		tion)	
X	‡	7	=	٧٥	ર્જી	oade	
65 150 X 250 X	‡			RAAC RE AC RE AC RE AC RE	X	Acceptable Quality Levels (normal inspection)	
	‡	9 6	11 12	2	951]s (no	
+4 :		1 5 12 12	01 6	- V	-	Leve	
82	‡	3 11 1	∞_	Ac F	X	ality	
X	‡	3 7	7 8		901	ele Q	
8 4		2 5	•	He Ac	જ	cepta	
↓	‡	6 9	v.	Re Ac	-	¥ċ	
8	‡	4 6	3		\$	•	
\$	‡	3 4	3	Re Ac Re Ac	22		
+		2 2 3	2 2	~ ~	10		
ន	‡	0 -		ReAc	15		
2	٠	~	=		01		
02		. Cetter		Ac Re Ac	X		
X	<	code code		Re Ac Re Ac	6.5		
6.5	•	•	0	Ac Re /	4.0		
				Fe A	5		
Less than 6.5	>	D	٥	γc	Less than		
		2 +	60		lative sample	ا د	
	4 ultiple	Double	Single	S	Type of		

MIL-SID-105E

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

Acceptance number Ħ

Hejection number 11

Use single sampling plan above (or alternatively use code letter E) Use double sampling plan above (or alternatively use code letter D) 11 11

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

CHART C - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS (Curve for double and multiple compling are matched as closely as practicable)

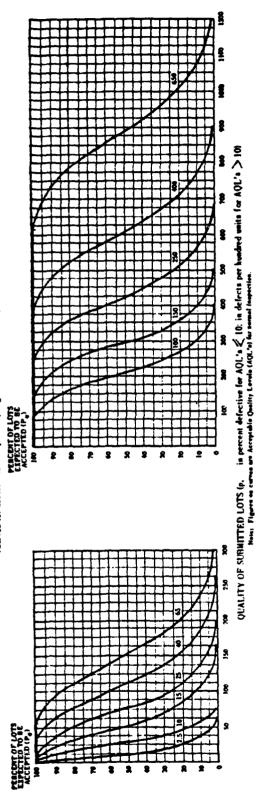


TABLE X-C-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

							Acceptab	le Quality	Acceptable Quality Levels (normal inspection)	rmel inspec	tion)							
د.	2.5	=	2.5	2	15	23	07	Ş	X	100	X	951	X	82	X	900	X	939
	p (in percen	p (in percent defective)							ei) d	defects per	p (in defects per hundred units)	mits)						
8	0.201	3.27	0.2 <u>0</u>	2.97	8.72	16.5	37.5	59.1	70.1	95.4	122	051	202	12	æ	፳	35	618
8.0	1.02	7.68	1.03	7.11	16.4	27.3	52.3	79.6	93.9	123	154	165	249	862	306	649	83	169
90.06	2.09	11.2	2.11	9.01	22.0	34.9	0.63	93.1	109	0+1	173	306	2773	355	43	482	679	133
75.0	5.59	19.4	5.75	19.2	34.5	2.35	54.4	611	137	2/1	208	245	318	374	485	242	749	906
20.0	12.9	31.4	977	33.6	53.5	73.4	EU	153	173	213	233	293	373	an ta	553	613	833	693
25.0	24.2	45.4	7.72	53.9	78.4	102	871	194	216	260	304	348	4.15	663	627	\$	923	986
10.0	36.9	7 :95	1.6	8.77	106	134	591	235	260	906	356	604	495	35	669	992	1010	1076
8.0	1.53	65.7	89.9	8.9	136	15.5	210	263	289	330	389	83	534	909	745	ž	201	1131
0.1	2.09	17.8	92.1	133	168	201	292	320	348	+03	456	85	612	687	803	36	เกก	1241
	ê	X	0.4	15	Ø	40	S9	Χ	100	X	150	X	Šį	X	900	X	059	X
							Accept	able Qualit	Acceptable Quality Levels (tightened inspection)	tightened i	napection)							

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

				7	
1111	\$	m •			
9 2				3000	
83 3		E 52	‡	X	
Y &	2	2 3 2 3	‡	3	
X	31	2223		V	
\$ 9		8	‡	10	
X	27 28	* # \$ \$	<u> </u>	8	
80 A 80 A 80 A 80 A 80 A	Z 12	2 2	‡	X	
X	8 19 21	2 % 11	‡	ង	
85 8	91 51	11	‡	X	
\ \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	13 14	16 18		1.	pection
	11 12	9 6	#	3	ed in
2 130 Y	6 10	5 11	‡	X	tighter
يًّ X	6	3 7	‡	8	evela (
8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8	9 2	3 7	‡	X	olity L
		2 6	‡	18	Acceptable Quality Levela (tightened inspection)
	*	S + 2		\$	ccepts
N N	3	4 3	‡	•	~
15 15 15 15 15 15 15 15 15 15 15 15 15 1		0 m	‡	KI	
" *	-	0 7	‡	53	
		3 5 5		2	
X		2	2	6.5	
Re Ac Re Ac Re Ac		Code Code Code Code	3	X	
2.5 c. Re	0	•	•	9	
Less then 25	D	\triangleright	>	: 40 P	
Cuma- Jacive size	s	m vg			
				-	
Type of sampling plan	S. et al.	Double	Maltiple		

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

Acceptance number.

Rejection number. **▷ ₹ ₹ .** ‡

Use single sampling plan above (or alternatively use code letter f). Use double sampling plan above (or alternatively use code letter 0)

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

CHART D - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS (Curres for double and multiple compling are matched as closely as practicable)

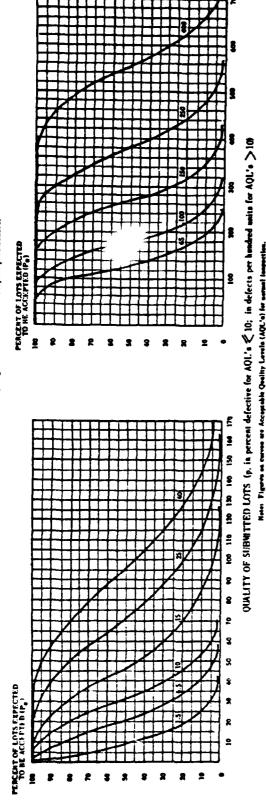


TABLE X-D-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

							¥	ceptable ()	Acceptable Quality Lovels (normal inspection)	s (normal in	spection)								
۵.	1.5	6.5	10	1.5	6.5	10	15	22	Ş	X	8	X	8	X	051	X	82	X	ŝ
	g eis g	p (in percent defective)	ective)							p (in de	fects per	p (in defects per hundred units)	ii.						
0.0%	0.126	1.97	90.9	0.176	1 86	\$ 45	10.3	22.3	36.3	8.53	9.69	76.2	93.5	138	2	215	ž	23.	ğ
95.0	0.639	30.7	11.1	0.641	17.4	10.2	17.1	32.7	8.63	2.82	77.1	28.	ž	156	38	249	Ē	\$	3
8.0	1.31	98 9	14.7	1.32	6.65	13.8	21.8	₽'6£	28.2	67.9	87.8	<u>8</u>	82	12.1	ã	20	ē	3	3
75.0	3.53	121	22.1	3 60	12.0	21.6	31.7	52.7	76.5	85.5	90-	136	3	8	ន	500	â	3	3
20.0	8.30	20.1	32.1	99 69	21.0	33.4	623	70.9	6'56	901	133	5 2	噩	£	Ē	*	Ŕ	125	3
25.0	15.9	30.3	43.3	17.3	33.7	0.64	63.9	8.29	121	35	163	š	â	m	312	365	3	2LL	5
10.0	25.0	9:07	53.8	28.8	9:87	66.5	80.5	911	251	162	193	22	252	8	N	5	478	3	213
8.0	31.2	1.7	0.03	37.4	59.3	78.7	6.96	131	191	<u>8</u>	212	22	27.4	ž	32	253	Ş	88	Ę.
0.	43.8	0.65	7.02	57.6	83.0	501	126	191	200	218	222	28 2	318	382	8	22	33	732	2
	2.5	2	X	2.5	9	15	25	07	X	83	Χ	100	X	150	X	052	X	8	X
						ļ		Acceptabl	Acceptable Quality Levels (tightened inspection	Levels (tig	htened in	spection)							

** Steemist distribution was for several distributions and the several distribution and the several se

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

													•	
	jil	4	•	.n	2	7	•	•	•	2	2	=		
	##\$	Ac Re	۵	۵		٥							F 18	
1'	8	2/2	ন		23	91	ZI.	ዳ	\$	39	3	2	V	İ
	3	٧	3		3	•	=	8	3	3	3	4	\triangle	
ŀ	X	2	27 1)	S	6 15	x	*	\$	58	3	2	ş	1
	1	₹	<u> </u>		38 52	21	91 61	27 28	34 37	\$	47-	2 2	1	ł
l	ង	بد	8	ſ	37	•	=	2	22	*	Ş	8	X	İ
	V	2	8		æ	01	11	25	E	3	3	\$	ន្ត	
1		% 24 24	2		<u> </u>	~	2	2	7	33	\$	3	N N	
	25	2	n	l .	12	•	=	2	X	8	2	8	X	
1	1	¥	19	=	24 28	2	12 7	17 13	<u>=</u>	22	<u> </u>	3		
	IX	Ac Re	2	i	23 2	_	9				23	ze ze	<u>≅</u>	
1	 _		52		19 2	1	2	13	17 16	8	2 2		\	
i e	8	Ac Re	=	:	9	-	7	-	12	= 2	2 2	25 2	X	lion)
Į ž	V	2	13	2 :	16	9	•	2	15	11	20	22	8	<u> </u>
1 3		2	2		115	0	m	~	2	=		2		d is
į	જ	Ac Re	=	•	1 13	5 0	eo eo	6 10	9 13	55	11	20	ΙX	ie ie
٥	1	- 2	=		12 12	-		-	=	12 11	=	15 18	 	(c)
1 4	l X	Ac R		ì	=	0	~	•	9	-	12 1	=	જ	els
j.	 ´ `	2			-	-	•	-	2	=	13	=	17	يَّ
1 3	\$	٧	~		20	0	-	•	5		2	2	X	ality
Acceptable Quality Levels (sormal inspection)	×	æ	9	ł	(*	S	9	~	∞	۰	2	3	Acceptable Quality Levels (tightened inspection)
1 8 9		Re Ac	3		2	3	-	-		-5-		~	 	100
*	15	\ B B			•	•		_	~	6		•	ង	Acc
1		2	т.		•	7	6	6	*	•	S	'n	13	
1	2	٧	~	، د	າ		•	•	_	~	m	•		
1	6.5	<u> </u>	~	64 6	7	~	7	7	m	~	m	m	10	
	 	ReAc					-	-	•			~		
	6.	٧c		Celter Code	<u>.</u>	1							6.5	
	X	Ac Re		Letter 6	ú	-							4.0	
	2.5	Ac Re Ac R		code code	ر	,							X	
	1.5	Ac Re	-	•		•							2.5	
ĺ	-	Re		 									<u> </u>	
	Less than 1.5	Ac R	D	>		\triangleright							Less than 2.5	
	Lative sample	9 ize	•	v g	2	8	•	•	80	2	12	=		
	Type of		Single	Double	,				Wultiple					

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

the next subsequent sample size code letter for which acceptance and rejection numbers are available. 4 4 4

Acceptance number

Rejection number

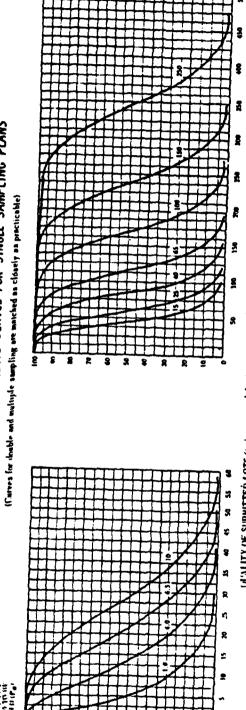
Use single sampling plan above (or alternatively use code letter G)

Acceptance not permitted at this sample aize.

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

E

CHART E - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



(A'ALITY OF SUBNITTED LOTS (p. in percent defective for AQL's \$\infty 10; in defects per hundred units for AQL's \$\infty 10)
Note: Figure on curse one Acceptable Goulity Levels (AJL's) for manual impection.

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

_																				
				}		į		Accepte	ble Quelii	y Levels	Acceptable Quality Levels (normal inspection)	spection)								
• م	0.	Ę.	6.5	2	0.7	4.0	6.5	2	7	*	2	1	2				Į,			
							4		?	3	<u> </u>	3	<u> </u>	8	X	8	X	8	$\overline{\rangle}$	8
	٠	p fin percent defective	i defectiv	÷															1	
1						1					E C	OFFICES P	p in detects per hundred units							
3	0.077	=	35.5	6.75	0.0773	31.15	3.35	6.33	13.7	200	27.0	74.3	9,9	3						
95.0	965.0	2.81	6.60	11.3	200	↓	}					\$	١		3.0	è	132	8	53	27
1						?	0	3	20.1	30.6	- ×	47.5	59.2	7 7	28.7	115	151	יגו	**	75.
2	0.007	4:1	9.80	14.2	0.810	\$	8	7.0	24.9	34.0	1	1		I				:		8
75.0	2.19	19.7	13.4	00		1	Ť.			25.6	9.1	7	ŝ	79.2	<u>8</u>	133		že	28	282
					3	2	13.3	19.5	32.5	45.8	\$2.6	 	80.2	3	Z	3	131	Ž	2	٩
\$0.0	5.19	12.6	20.0	27.5	5.33	12.0	30.6	٤	3	1			I			1			3	ans.
35.0	191		100	T;				,,,	2	39.0	2	2	97.4	=======================================	<u> </u>	16,	213	ž	321	*
			2.83	Ŕ	10.7	20.1	30.2	39.3	57.1	24.5	1 14	٤	:	1	1	1	1		1	1
10.0	16.2	26.8	90	* **	13.3	8	1					3		2	١	25.	741	%	×	ž,
!							200	31.4	71.3	20°S	8	611	232	255	8	213	95	£	5	1
2	53.6	31.6	0.1	19.5	23.0	36.5	48.4	9 05	9	٤	=	1	1	1		1				
1.0	8.62	41.3	905	5	Ž							3	3	8	Ę	270	<u>\$</u>	-	ę	\$\$
	I	T	1		3		Š	77.3	<u>[0</u>	2	ž	S	921	8	Si	792	321	98	3	15
	1.5	6.5	02	X	.55	6.5	01	\$1	×	>	1	1	T;	1>		†	†	+	+	T
													3	<	3	X	8	X	<u></u>	X
								Accep	table Qua	ility Level	Acceptable Ouality Levels (tightened inspection)	d inspect	Ē							Γ
													•							-

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

	11	1	2	•	*	-	•	•	2	2	2	ä]	
۴													2	I
	12		4	٥		4	_						Z IN	
1	82	2	3	31	57	*	22	R	\$	3	3	2	X	
•	*	ReAc	3	N	38	9	=======================================	3	3	3	3	12 12	1~	
	X	Ac F	3 17	22 23	23	51	N			33			ង	
1	 ``	8	- R	R	*	2	<u>\$</u>	22	37	\$	=======================================	<u> </u>	1	
	33	¥د	8	11	37	-	=	2	12	*	3	я	X	
•	V	2	R	R	Ж	2	=	7	E	37	3	\$	8	
]		2	22	10	×	7	2	2	8	Ħ	\$	8	<u> </u>	
1	8	2	N	12	2	6 2	3	2	Ø	8	8	***************************************	IX	
Ì		<u>5</u>	1921	=	8	-	<u> </u>	17	<u> </u>	<u>10</u>	<u> </u>	<u> </u>	 	
]	IX	٧٧	=	•	ន	_	•	=	9	Ħ	72	Ħ	8	
	23	2	23	=	2	~	2	2	11	8	ន	×	V	
Acceptable Quality Levels (secres) laspection)		3	13 14	-	1618		•	•	12	=	2 2 2 2 2 2 2 2 2 2	22	$ \wedge $	Acceptable Quality Levels (tightened Inspection)
}	ΙX	æ		9		•	•	- 13	22	=			3	¥
1	 ^ \	ReAc	21	-	13 15	8	-	- 02	13 10	15	- <u>#</u> -	1 <u>8</u>	1	7
<u> </u>	\$		91	<u>ب</u>			m	9	-			=	ΙX	1
1		ReAc		-	12 12	-	-	•	=	12 11	÷	- 52	 	13)
1 2	LX	Re Ac	-	m	=	0	~	~	•	•	2	±	3	1
1	×	æ	∞	7	•	-	9	•	9	=	2	=	V	ity [
1 2		¥.	7	m	_	•	_		S	^	2	10 13	$ \Delta $	3
7	15	. Re	9	S	-			9	E.S.	s	•		x	eb le
8		- Re - Ac	\$	~	- 5	-		-	<u>~</u>	-	-5	-	-	8
	2			-	•		•	_	~	•	-	•	2	¥
	6.5	Re	6	8	+	~	6	m	*	•	S	Ŋ		
1	9	ReAc	2		e	-	•	9		~		•	으	
	9		2	~	~~	7	~	2	m		m	m	5.5	
		ReAc				-	-	<u> </u>	•		_	~	 	
	2.5	٧											0.4	
	X	Re Ac Ro	1	apos apos	Letter C)							2.5	
	1.5		1	90	Letter	-							X	
	1.0	le ReAc	ι 0		•								5.	
	1129	Ac ReAc	٥	٥		D							3 2 2	
	le in de la company de la comp	eize A	13	•	91	n	•	•	72	15	=	ส		L
_			Sing-le		Doeble				1					

Use sett praceding sample size-code letter for which acceptance and rejection numbers are evailable. **45.**

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

Acceptance number.

Rejection number.

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

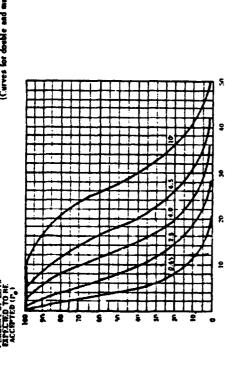
Acceptance not permitted at this sample size.

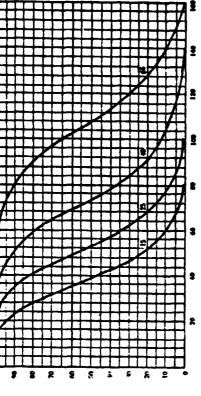
E

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)





QCALITY (IF SIIIVITTEI) LIVIS (p, in percent defective for AQL's < 10, in defects per hundred units for AQL's > 101 Rate: Figures on carrs are Acceptable Shaliny Lawds (AQL's) ha named happenha.

MIL-STD-105E

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

81.2 63 7.5 93.4 8 <u>₹</u>3 2 123 Ξ 62.2 \$ 93.3 51.7 3 Ē 133 53 124 87.0 37.4 51.5 73.3 \$ 61.2 ₫ <u>\$</u> 121 97.2 **8** 30.5 7. £3.2 52.1 **76.** 63.3 ₹ \$ 77.0 3 23.9 8 38.1 £3. **S**3 **3**3 ₫ p (in defects per handred units) 72.2 17.5 23.5 27.2 3 2.0 65.0 0.7 34.2 r Levels (tightened inspection) 14.5 19.9 23.3 65.7 8 83 \$ **8** 2 8 6.93 3. 15.8 Ħ 52.6 21.1 37.1 \$ 65.5 6.83 8.72 4.12 12.7 25.5 33.4 2.2 6.5

iro camputationes Paissens for defects per headerd caffe.

7	•
man income	
ality Levels (a	
ccertable Ou	

4	A							
5	1.0	1.0	X	9	6.5	4.0	0.1	
77	33.2	23.0	53.2	42.1	35.0	28.9	97.02	1.0
K. KE	7.02	15.0	9 50	34.4	28.3	21.6	13.9	5.0
38.	19.4	11.5	5 17	30.4	24.5	1.81	10.9	10.0
19,	13.5	6.93	976	24.2	18.7	12.9	6.70	25.0
13.	6.39	3.47	6'12	1'81	13.1	8.25	3.41	0.08
	18.1	1.44	9112	12.8	02.8	19.5	1.43	75.0
5.8	2.66	125.0	9'91	£0 6	5.64	2.69	0.525	0.06
7	1.78	952'-0	14.0	11.7	21	18.1	0.256	95.0
2.	0.70	0.0503	9.75	95" þ	2.2	654.0	2050'0	0.66
				ctive)	p (in percent defective)	p (in p		
7	2.5	99.0	01	\$:•	01	2.5	9 0	<u>.</u>

Non Phental Ambailm and

44

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

	4	44									_		1	
	11	i	8	2	8	~	2	\$	R	×	8	*		
	Higher then 65	Ac Pe	٥	٥		٥							Higher Shae 65	
1	8	ž	Z	2	21	6	=	2	ĸ	8	33	8	X	
ł		٤	33	=	æ	~	~	2	2	Ŋ	Ħ	33	$ \wedge $	
İ	X	ž	19	=	*	•	12	11	Ħ	X	8	33	65	
•	\triangle	¥	=	•	ส		•	=	2	Ħ	2	22	٠	
1	3	æ	15	=	61	_	2	13	11	R	ผ	*	X	
]		¥	11 61	-	=		<u> </u>	•	-2	=	2	×		ĺ
	X	윤		2	2		•	12	15	17	R	Ø	\$	
	<u> </u>	¥	12	-	<u> </u>	•			2	=	=	-2		
	×	.	=		2	0	_	2	=======================================	15	11	61	X	
	 	¥. ¥	2 6	2	12 12	-		-	<u>-</u>	12 11	=	15	 	-
ig (a)	IX	Ac R			=		~	-	= 9	•	12	=	×	Acceptable Quality Levels (tightened inspection)
1 8	<u> </u>	- Y	••	-	-	-	9	-	2	=		=		
Acceptable Quality Levels (normal inspection)	2	Ac	~	_	-		_	•	2	_	2	13	X	hiese
3	 	2	•	5	~	-	S	•	~	60	•	2	-	3
1 1 2	2	Ac I	S	~	9		_	~		v,	1	•	15	Legel
1		2	-	-	6	-	~	-	20	•	•	~		elity
3	6.5	Ψ¢	æ		•		•		2	~	-	•	9	충
1 2	0,	Æ	3	3	•	2	М		•	~	'n	S	6.5	Cepte
¥	L	¥	2	•	m	•	٥	•	_	~	m	•		٧
	2.5	æ	2	2	7	2	8	2	•	m	m	m	0,	
	<u> </u>	¥	-	-		<u> </u>	•	•	۰		~	~		ĺ
	1.5	Ac Re	:			ی							2.5	
	X	₹ ¥	:	# #			· · · · · · · · · · · · · · · · · · ·						1.5	
	0.1	Ac Re Ac		9 9		w							X	
	9.65	lc Re	- 0			•							0.1	
	1 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	Ac Re Ac	٥	D		D							Less than 1.0	
9	lative semple		8	13	*	s	2	15	8	x	8	æ		<u> </u>
	Type of a series of		Single	:	aj es o()				Valtiple			•		

MIL-STD-105E

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

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

Acceptance number

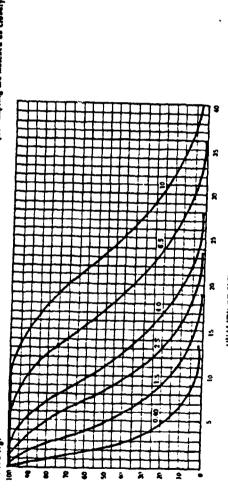
Resection number

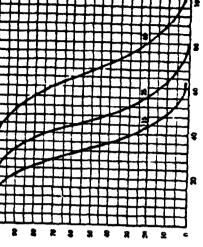
Use single sampling plan above (or alternatively use code letter J)

Acceptance not permitted at this nample 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)





ULALITY OF SUBNITTED LOTS (p. — in procent defective for AUL's \$\left\{10\); in defects per handred units for AOL's > 10\)
Note: Figures as carres and Acceptable (badity Levels (AQL's) for normal impaction.

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

					× [ceptable (Juality Lev	ris (norma	inspection	œ.						
╝	22	9	6.5	٥	0.40	1.5	2.5	4.0	6.5	2	X	22	X	×	X	[
5	Derce	ı defective	(15	de fects pe						
		2.67	5.80	9.73	0.0314	0.464	32	139								
	2.60	20.4	9	:	1		?		R	8	2	=	<u></u>	23.4	32.3	39.3
			95.0		3	=	8	2.0	8.17	12.4	14.7	19.3	24.0	28.9	30.9	5.99
_	2.43	5.56	10.2	15.1	0.329	1.66	3.6	5.65	8	34.6	13.0	91.0	9.5	3	1	
	5.42	7.98	13.4	19.0	0.899	3.00	5.40	7.92	13.2	38.6		2	3) ;	77.5	22.7	3
_	8.27	7 11	17.5	2.7	15	2				20		69.9	32.0	2 2	2.6	\$
1-	6					5	R			24.0	27.1	33.3	39.6	65.8	33	67.7
┿	<u> </u>	2.6	22.3	28.0	4.33	8.41	12.3	16.0	23.2	30.3	33.8	10.7	7 (7	3	3	1
	15.8	19.7	27.1	3.1	7.20	12.2	14.6	9	ę	;			9	*	2	3.0
_	18.4	3,6	۶	;						30.6	40.0	\$	SS 6	62.9	77.4	1.00
†				7:5	2	2	19.7	24.2	32.9	41.1	4 S.1	S. S.	8.09	5	2	8
十	8:5	1.1	8.0	3.2	2.4	20.7	26.3	31.4	0.10	80.0	7.75	0.03	11.3	28.	8	Ē
-1	9	\$3	2	X	39.0	2.5	0.9	6.5	01	X	15	X	м	X	\$	X
- 1	}					Acceptable	Ouality Le	rvels (tigh	rened inspe	rtina)						
	15 0.471 1.12 1.67 3.01 5.19 8.19 11.6 11.6 11.6 12.5		2 2.60 4.30 2 2.60 4.30 2 2.60 4.30 7 3.49 5.50 1 5.42 7.98 9 8.27 11.4 11.9 15.4 15.8 19.7 18.4 22.5 23.8 28.1 4.0 6.5	2 2.6 4.38 2 2.60 4.38 7 3.49 5.56 7 3.49 5.56 11.9 15.4 5 15.8 19.7 5 18.4 22.5 3 23.8 28.1 3	2 2.5 4.0 6.5 10 10 10 10 10 10 10 10 10 10 10 10 10	2 2.5 4.0 6.5 10 0.40 p lin percent defective. 2 2.60 4.38 8.50 13.1 0.166 7 3.49 5.56 10.2 15.1 0.326 8 2.7 11.4 17.5 23.7 2.17 15.8 19.7 27.1 34.1 7.20 18.4 22.5 30.1 37.2 9.36 23.8 28.1 36.0 43.2 14.4 4.0 6.5 10 \$\infty\$	2 25 4.0 6.5 10 0.40 p (in percent defective) 2 2.60 4.38 8.50 13.1 0.100 7 3.49 5.56 10.2 15.1 0.130 7 3.49 5.56 10.2 15.1 0.130 9 8.27 11.4 17.5 23.7 2.17 11.9 15.4 22.3 29.0 4.33 15.8 19.7 27.1 34.1 7.20 18.4 22.5 30.1 37.2 9.36 23.8 28.1 36.0 43.2 14.4	2 25 4.0 6.5 10 0.40 p (in percent defective) 2 2.60 4.38 8.50 13.1 0.100 7 3.49 5.56 10.2 15.1 0.130 7 3.49 5.56 10.2 15.1 0.130 9 8.27 11.4 17.5 23.7 2.17 11.9 15.4 22.3 29.0 4.33 15.8 19.7 27.1 34.1 7.20 18.4 22.5 30.1 37.2 9.36 23.8 28.1 36.0 43.2 14.4	2 25 4.0 6.5 10 0.40 p (in percent defective) 2 2.60 4.38 8.50 13.1 0.100 7 3.49 5.56 10.2 15.1 0.130 7 3.49 5.56 10.2 15.1 0.130 9 8.27 11.4 17.5 23.7 2.17 11.9 15.4 22.3 29.0 4.33 15.8 19.7 27.1 34.1 7.20 18.4 22.5 30.1 37.2 9.36 23.8 28.1 36.0 43.2 14.4	S 2.5 4.0 6.5 10 0.40 1.5 2.5 4.0 6 P (in perrent defective) 21 1.40 2.67 5.88 9.73 0.0314 0.464 1.16 2.57 4.0 6 21 1.40 2.67 5.88 9.73 0.0314 0.464 1.15 2.57 5 2 2.60 4.38 8.50 13.1 0.160 1.11 2.56 4.27 8 3 4.90 5.60 3.60 3.46 5.40 7.92 13 9 8.27 11.4 17.5 23.7 2.17 5.24 8.36 11.5 17.2 11.9 15.4 22.3 29.0 4.33 8.41 12.3 16.0 29.3 11.9 15.4 27.1 34.1 7.20 12.2 13.4 41.5 23.6 23.6 43.2 34.4 20.7 26.3 31.4 41.5	S 2.5 4.0 6.5 10 0.40 1.5 2.5 4.0 6.5 P in percent defective: 12 1.40 2.67 5.88 9.73 0.0314 0.464 1.16 2.57 4.0 6.73 2 2.60 4.38 8.50 13.1 0.160 1.11 2.56 4.27 8 7 3.49 5.56 10.2 15.1 0.379 1.66 3.46 5.45 13 9 8.27 11.4 17.5 23.7 2.17 5.26 8.36 11.5 17 11.9 15.4 22.3 29.0 4.33 8.41 12.3 16.0 29. 11.9 15.4 22.3 29.0 4.38 19.7 24.2 32. 11.9 15.4 22.5 30.1 37.2 9.36 14.8 19.7 24.2 32. 23.6 25. 14.4 20.7 26.3 31.	S 2.5 4.0 6.5 10 0.40 1.5 2.5 4.0 6.5 P in percent defective: 12 1.40 2.67 5.88 9.73 0.0314 0.464 1.16 2.57 4.0 6.73 2 2.60 4.38 8.50 13.1 0.160 1.11 2.56 4.27 8 7 3.49 5.56 10.2 15.1 0.379 1.66 3.46 5.45 13 9 8.27 11.4 17.5 23.7 2.17 5.26 8.36 11.5 17 11.9 15.4 22.3 29.0 4.33 8.41 12.3 16.0 29. 11.9 15.4 22.3 29.0 4.38 19.7 24.2 32. 11.9 15.4 22.5 30.1 37.2 9.36 14.8 19.7 24.2 32. 23.6 25. 14.4 20.7 26.3 31.	2.5 4.0 6.5 10 0.40 1.5 2.5 4.0 6.5 10	5 4.0 6.5 10 0.40 1.5 2.5 4.0 6.5 10 X 15 71 1.40 2.67 5.89 9.73 0.0314 0.464 1.36 2.57 5.89 9.06 11.0 14.9 71 1.40 2.67 5.89 9.73 0.0314 0.464 1.36 2.57 5.89 9.06 11.0 14.9 7 2.60 4.38 8.50 13.1 0.160 1.11 2.56 4.27 8.17 12.4 14.7 19.3 7 3.49 5.56 10.2 15.1 0.160 3.46 5.45 9.65 14.6 11.9 14.9	S 2.5 4.0 6.5 10 0.40 1.5 2.5 4.0 6.5 10	S 2.5 4.0 6.5 10 0.40 1.5 2.5 4.0 6.5 10

Observed Aprelian to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions and the sound to some descriptions are some descriptions a

MIL-910-105E

J	11	**	Ħ	8	8	•	2	×	×	8	3	3		
	11:	Ac Re	٥	٥		۵							2 a 9	
	*	2	**	22	21	•	*	2	Ю	8	Ħ	R	X	
1		V	2 6	=	*			_=_	2	Ŋ	<u> </u>	<u> </u>	^	
1	IX	Ac Re	2		23 24	-	6 12	11 11	2 2	N N	23	a a	8	
	x	#	15	=	2	-	2	=	11	8	ឧ	*	X	
1		Re	13 14	9	= =	9	-	12	15 12	11/11	8	N N	+^-	
	X	Ac F			15.		m	-	2	=			×	
		2	11 112	•	2	~	•	2	==	2	===	19	V	
2	22	Pe Ac	e	'n	22		m	٠	•	=	<u> </u>	2	X	-
1 8	X		•	3 7	1 12	•	2 1	•	=	22	±	1 15	15	pectio
1 3	 	Pe Ac		-	==	-	-	-	<u> </u>	=	12 12	=======================================	1	
1	2	¥	-	-	•	0	-	~	S	~	2	2	X	Į.
1 7	6.5	2	•	8	~	-	· ·	•	~	•	•	2	2	1
1 të	Ľ	ReAc	9	N	۰	•		~	~	מי	~	•		3
Acceptable Quality Levels (sermal impaction)	3		*	_	⋄			~	2.	9	•	1 9	6.5	Acceptable (Justity Levels (tightened inspection)
1 1	22	Re Ac	67	~	•	~	٣	•	-	*	S	S	0,	4
₹		2	~	•	m	•		•		~	<u></u>	*	-	80
	27	Pc Re	1 2	0 2	1. 2	2		0	9		-	2	2.5	`
	2	Re Ac Re Ac		* * * * * * * * * * * * * * * * * * *	3	£							1.5	
	X	Ac Re		* 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5	-	•							1.0	
	0.66	훈		C C C	t.	L							X	
	0,40	Ac Re Ac	0 1			•							39.0	
	Less thas 0.40	Ac Re	۵	٥		٥							Less then 0.65	
į	lative sample	azie	æ	R	\$	60	92	38	32	\$	\$	38		
	Type of Type of		Single	Deble					Maltiple					

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

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

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

Acceptance number.

Rejection number.

Use single sampling plan above (or elternatively use code letter K)

Acceptance not permitted at this sample size.

G

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

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

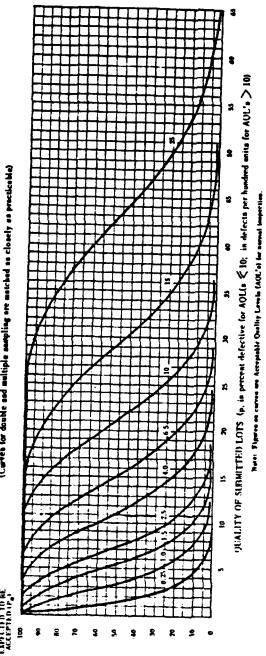


TABLE X-H-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

								Acr	eptable ()	vality Lev	Acreptable Quality Levels (normal inspection)	linspecti	<u>(£</u>		!					
۵	0.25	0	1.5	,	•	3.7		٤				\int								
					- 1			9	0.23	0.7	1.5	2.5	0.4	6.5	X	2	X	15	X	ĸ
			ءَ	p (in perren	defective,	¥			يمدا				٩	(in defect	b (in defects per hunderd unital]_			Ī
0.66	0.0201	OUR U	788 0	3	5	3]:			L										
8	50.0		3 3	80.	60.7	à	8	2.5	0.0201	0.297	0.872	1.65	3.57	5.81	7.01	35.6	12.2	15.0	20.7	2.1
	0 103	0.715	8	2.78	5.36	8 22	3.72	129	0.103	0.711	25.	2.73	5.23	8	200	123	3	1	6 70	1
0.0 0.0	0 210	1 07	2.22	3.53	6.43	2.6	11.2	14.5	0.211	£	2.20	3.6	8		1			c e		
75.0	0.574	1 92	3.46	01.5	8.51	12.0	13.8	13.5	3	5					ž			98	27.3	22.5
8	8	2.2	5					,		7	2	20.0	3	611	13.7	17.2	9 .02	24.5	31.0	37.4
		2	5	δ.,	5.11	15.2	172	21.2	<u>8</u>	3.36	5.35	7.34	11.3	15.3	17.3	21.3	25.3	2	2	:
22.0	2.73	5.29	7.69	10.0	14.5	18.8	21.0	25.2	2.77	5.30	2	100			+				:	3
0 01	4.30	3 .2	103	12.9	17.8	20.0	24.3	1 02	137						+	9	P.	200	6.5	607
S	C 8.3	::]						0.0	e, ',	20	2	18.5	23.5	200	906	25.6	£03	69.5	38
	,,,,	•	-	8	661	24.7	0.12	31.6	8.	67 6	9.21	15.5	21 0	26.3	0 80	9 2	9	1	:	T
- 10	8.00	12.6	15.8	18.7	24.2	20.2	31.7	36.3	200	٤	1 2	١	1		+			3	2	3
	0 40	<u>ر</u>	,	1	[9.6	25.0	20 25	63	959	Š	2.19	3
			3		65	X	91	X	0.00	1.5	2.5	9	9.9	X	01	X	15	X	×	X
								Acc	prable Ou	ality Lev	Acceptable Quality Levels (tighteand inspection)		1						1	
																				_

o: Bhomrel diotribution used for percest deferring commentation. Buttern A. L. .

MIL-SID-105E

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

3	<u> </u>		8	Ħ	3	13	*	8	æ	3	22	5		
	H. S. S. S. S. S. S. S. S. S. S. S. S. S.	Ac Re	٥	٥		۵							Higher shan 25	
	S	ag.	z	2	12	•	=	2	23	8	2	23	V	İ
1	×	۲	12	=	æ	~	~	=	2	x	Ħ	2		İ
		æ	61	=	24	8	12	11	z	Ŋ	83	33	Z	
	X	٧c	2	•	2	-	9	=	Ξ.	22	12	32		
	15	Re	51	=	6	~	91	13	12	8	เร	2		
		¥	±		2		•	•	12	1	31	x	X	
	V	ž	13	2	9	9	•	13	15	~	8	ដ	2	
		٧٥	21	•	5	٥	m	~	2	Ξ	=	2		İ
	2	æ	=	•	2	_ ~	•	2	13	15	13	2		3
		¥	2	8	2	•	m_	٠	6 0	=_	=	2	X	CT.
Î Ş		老	64	-	12	-	-	•	=	12	=	13	2	1
1 5		٧٧	•		=_	°	7	. 🕶	9	•	12	=		٦
=	6.5	Re	•	_	•	•	•	•	2	=	12	=	$ \mathbf{Y} $	i k
Ę		Ac	-			•			N.	~	2	=	$ \triangle $. ≘
Acceptable Quality Levels (normal inspection)	6.0	Ac Re	9 9	2 8				2	3 7	SS SS	~	6	6.5	Acceptable (Juality Levels (tightened inspection)
<u>*</u>	S	Re	•	-	-v	т.	m	•	S	•	•	~		il and
į	2.5	٧c	•	_	-	•	٥	_	2	•	-	•	-	a a
la se	1.5	Re	3	6	-	2	~	٠	-	-	5	S	S	Cept
9		۸c	2	0		•	0	6	_	2	~	•	~	Ac
~	1.0	품	2	2	2	2	2	2	~	е.	~	Ю	1.5	
		γc			_	•	•	•	_	_	_	~		
	0.65	Ac Re	1	8		•							1.0	
	X	Re		900		c			.,				0.65	
	-	٧c												ļ
	9.6	Ac Re	1	8		•							X	
	0.25	Re	-						-				0.40	
ļ		٧٧	0									 	1 1	
	Less than 0.25	Ac Re	٥	>		٥							Less than	
,	lative sample		S	32	3	13	8	86	83	8	82	5	ا د	
	Type of sampling plan		Single	-	aignori				Multiple	,				

 ^{△ ■} Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ▼ △ Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
 Acc → Acceptance number

Re # Rejection number

m Use single sampling plan above (or alternatively use code letter L)

[#] Acceptance not permitted at this sample size

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

CHART J - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

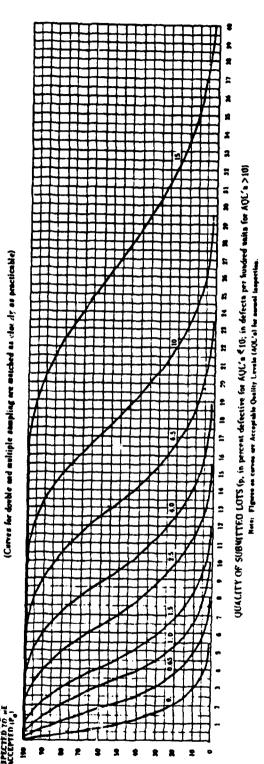


TABLE X-J-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

									V C	reptable	Onabity 1	evels (a	Acceptable Unality Levels (normal inspection)	pection)								
ď	0.15	0.65	10	18	2.5	3	X	5.5	X	2	0 15	9.65	e	2	12	15	>		>	1	$ \rangle$	Ţ
				•	p (in percent defective)	a defect	3													2	{	2
															9 (3 9	p (in defects per hundred units)	headred	mits)				
8	0.0126	0.187	0 550	2.	2.29	3.73	4.51	6.17	1 88	9.76	0.0126	0.186	0.545	8.	22	3.63	82	8	163	ž	2	2
8.0	0.064	0.446	1.03	1.73	3.32	5.07	8.8	7.93	866	6 =	0.0641	0 44	8	12.	3.27	8	287	: 5	3	3	1	
90.0	0.132	0.667	1 39	2 20	3.99	2.9	8.8	8	0 =	13.2	0.132	5999	8	2 18	3	3	2					
75.0	0.359	1.201	2 16	3 18	5.30	25.	9.61	60	13.2	15.5	0.360	8	2.16	3.5	5.27	2 2		9 6		5 5		3 8
\$0.0	0.863	2 09	3.33	4.57	7 08	9.55	20.8	133	15.8	18.3	9980	2.10	334	95.7	8	9	1					i
22.0	1.72	3.33	18.7	6.30	9.16	6 ==	13.3	16.0	18.6	21.3	1.73	3.37	8	8.9	82.0		+	2 5	2 2		3 6	
0.01	2.84	2	6 52	8 16	=	E.5	15.7	981	21.4	24.2	28	¥.	18	-†-	1	+	+	+				7
2.0	38	5.73	7.88	9.4	127	15.8	17.3	28.3	23.2	80	2.	5 93	187	┰		十	十	十	7	70		2.3
1.0	5.59	9.0	100	12.0	15.6	18.9	885	23.6	2 %	8.0	8 %	8	2	十		+	╅	١,				2
	χ.ο	9	=	1	5	$ \rangle$	T	[]								+	+		î l	9 7	Ž,	\$
				:			c	X	2	X	0.20	<u>-</u>	2	2.5	4.0	X	6.5	X	2	X	~	X
					1				Acce	peble Q	vality Le	veta (11,8)	Acceptable Quality Levels (tightened inspection	pection)								Γ
																						_

des Albemial distribution uned for percons defective competations: Polenies for defects are bandud antes

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

1	ij		8	3.	2	8	*	8	8	2	8	2		
	i j22	Ac R	٥	₫		٥							Higher S 2 S 2	
	22	2	z	2	22	•	=	2	Ŋ	R	2	興	Y	
1		¥	12	=	8	2	~	2	2	×	គ	ñ		
1	Y	2	2	=	*	•	21	1	Ħ	Ŋ	83	2	21	
1		2	=	=	2	1 1	9 01	13 11	17 16	R	2	X X		
	2	2	15			-	-	<u>۔</u> س					X	
		ReAc	13 14	2	91	9	÷	=	15 12	11/11	8	N N	 ``	
Į.	IX	Ac B	21		22		•	~	2	=	2	a	2	
1		2	1 11	•	<u> </u>	8	•	2	<u> </u>	15	=	2	∇	
1	6.5	Ac 1	01	·	22	•	•	•	•	=	=	=	X	
l	\vee	2	6	-	22	+	7	•	=	12	=	22	6.5	-
S S	Δ	¥		m	=		8	•	•	۰	27	*	۰	ection
1	4.0	2	€0	-	•	•	•	•	2	=	12	=	X	i
1 7		3	-	60	•	0		9	2		2 6	<u> </u>	1/	Tes ed
3	22	: Re	9	ν.	1		•,						9	(ije)
1		Re	\$	7	2	8		7	5	- 9	-	<u>~</u>		a sele
1	1.5	Ae B	9	_	~		•	~	~	~	-	•	2.5	ity C
ا ق	<u> </u>	윤	m	m	-	2	-	~	•	-	S	80	5	S a
1 7	2	۔ الا	~	0	m		•	٥	-	N	•	•	1.5	ej q
Acceptuble Quality Levels (normal taspection)	8	25	2	~	8	2	7	~	6	•	6	<u>س</u>	0.1	Acceptable Quality Levels (tightened inspection)
	0.68	٧	_			<u> </u>	•	۰	0		_	8		1
	9. 8	Ac Re		* *	<u> </u>	<							0.65	
	X	Rc Ac Re		a a b 03	Letter .			_					3.0	
	8.0			00 code		E							X	
	0.15	Ac Re Ac		•		•							0.25	
	Less then 0.15	Ac Re	D	D		D							Less than	
	lative samplo		8	S	8	8	\$	8	8	8	82	3		
	Cype of a policy of the policy		Stagle		Double				Multiple					

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

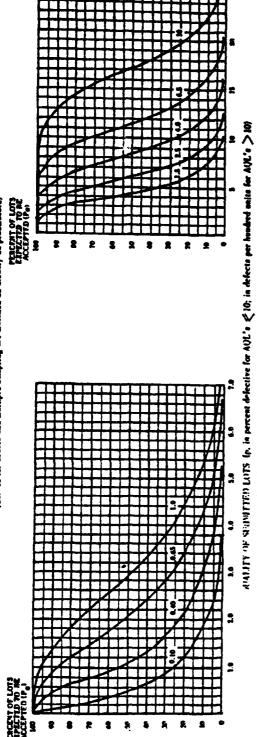
Acceptance number

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 (Cerves for double and aultiple sampling are metched as closely as practicable)



Note: Figures on curves are Acceptable Quality Lavels (AQL's) for series Inspection.

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

					Accepta	ble Quality Lev	Acceptable Quality Levels (normal inspection)	ection)				
a*	0.10	0.40	9.62	1.0	1.5	2.5	X	4.0	X	6.5	X	01
	p (in percen	p (in percent defective ar defe	efects per hundred units)	ed units)								
86.0	0.00604	0.119	0.349	0.659	1.43	2:32	2.81	3.62	87	8.8	8.8	1.01
95.0	0.0410	0.284	0.654	1.09	2.09	3.18	3.76	3.7	6.15	2.8	8.6	11.9
0.08	0.0643	0.425	0.862	1.60	2.52	3.72	4.35	5.62	6.92	6.24	10.9	13.0
15.0	0.230	0.769	1.382	2.03	3.38	4.76	29.62	6.90	16.34	6.79	12.7	14.9
80.0	0.555	1.34	2.14	76'2	15.7	91.9	3 .9	8.53	19.1	11.7	14.9	17.3
25.0	1.11	2.15	3.16	4.09	8.94	1.75	19.0	10.4	12.2	13.9	17.4	80.0
10.0	1.	3.11	4.26	5.34	7.42	27.6	10.4	12.3	14.2	1.91	161	2.5
9.0	2.40	3.80	\$.04	6.20	19'8	10.5	5.11	13.6	18.6	5'41	21.4	24.2
0.1	3.68	5.31	6.72	8.04	8:01	12.8	16.3	16.1	18.3	₹00.4	24.5	27.5
	0.15	9.65	0.1	1.5	2.5	Χ	4.0	X	6.5	Χ	10	Χ
		:			Accept	toble Quality Le	Acceptable Quality Levels (tightened laspection)	in spection)				

Hoter All veduce gives in above table based on Potessa



MIL-910-105E

3	1		ह्य	8	3	я	• \$	*	ន	3	\$	ñ		
	11.00 10.00	Ac Re	٥	٥		٥							10 mg	
	9	£	22	2	2	•	=	-6	X	&	2	8	X	
1		¥c	2	=	*	2	~	2	2	Ŋ	3	×	$ \wedge $	
	X	He.	61	=	۶		12	11	z	X	8	2	2	
1	\triangle	V	2	-	8	-	<u> </u>	=	=	8	2 2	<u>×</u>		
	6.5	c Re	51	1 11	2		92 +	10	2 17			%	X	
	H.	ReAc	13	2	2	-	-	-2-	15 12	17 17	2	22	+	
	X	ا ¥د	12		23		~	-	2	=	=	2	6.5	
		Re	=	•			•	2	=	<u>S</u>	=	2	$\overline{\mathbf{V}}$	
1	4.0	و	2	~	2	•	m	•	•	=	=	=	X	
1	∇	Re Ac	-	~	2	-	-	•	=	12	=	15	0.4	Acceptable Quality Levels (tightened inspection)
ect is	Λ	٩c	•		=	0	84	•	•	•	12	=_	÷	2
Acceptable Quality Levels (normal inspection)	2.5	골	•	1	٥	-	9	₩	9	==	2	7	V	ned i
-	-2	¥	1			•		~	vs .		2	=	X	ighe
=	1.5	2	•	•	7	-	•	•	~	•	•	2	2.5	els (i
1		¥c	\$	~	•	•	_	~	~	v	~			Š
1 1	9	Re	•	-	S		m	•	S	9	•	~	1.5	1
3	<u> </u>	Re Ac	3 3	-	-	-	-		-		\$	- 5		O ag
	9.6	Ac F	7		m		•	•		~	m	•	9	a de
¥ o	_	Re		~	~	8	~	8	т.		<u> </u>	<u> </u>	S	YCC
	0.45		_		-		•	•	•	_	_	~	0.65	
	0.25	Ac Re Ac		e 8	3	<u></u>				-		· 	o. 6	
	X	le Ac Re		9 · 8	E	3							0.25	
	0.15	Re Ac Re		agn of	<u> </u>	-							X	
	0.10	Ac	1 0			•							0.15	
	Cess them 0.10	Ac Re	Δ	٥		٥							Less than 0.15	
į		# 26	ĸ	8	<u>3</u>	æ	3	8	128	991	192	ž		
	Type of		a) Baig		Double				Multiple					

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

Use next preceding sample size code letter for which acceptance and rejection numbers are available. Use next subsequent sample size code letter for which acceptance and rejection numbers are available. **454.**

Acceptance number

Rejection number

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

Acceptance not permitted at this sample size.

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

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

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

QUALITY OF SUBNITIED LUTS (p. in percent defective for AQL's \$10; in defects per handred units for AQL's > 100

Hotol Pigwoo ee serves are Anceptable Dealty Lorsis (AGL's) he cornel kespection

									TONIC W	SWEET SWILLING FLANS		
					Accepted	Acceptable (ballty Lovels (acmai jaspectios)	qeal famon) el	ection)				
<u>.</u>	0.068	0.25	0.40	0.65	0.1	1.5	X	22	X	9	X	59
	p (ia percent	p (in percent defective or defect	efects per headred units)	and madica)								
99.0	0.0000	0.075	0.218	0.412	0.893	1.65	1.75	239	3.65	17.		8
80.0	0.0256	0.178	0.409	0.663	1.31	1.9	2.5	8.2	3.84	797	23	3 2
80	0.0527	0.266	155.0	0.872	1.58	2.33	2.72	3.51	H.	\$1.5	78.9	
5.0	9.14	0.481	199.0	1.7	11.2	2.90	3.6	7	12.5	3	8	:
93	0.347	0.639	1.34	1.04	2.84	3.04	a,	3.0	6.30	27	8.	10.0
28.0	0.693	1.33	1.86	2.55	3.71	4.83	5.40	53	7.61	2	992	
10.0	1.15	1.94	2.66	3.34	193	8.8	8.9	7.78	5	101	13.5	
8.0	1.50	2.37	3.15	3,88	5.2%	6.57	1.22	9.5				
0.1	2.30	3.22	4.20	20.5	6.53	8.	2.5	102		12.7	15.5	13.1
	01.0	0,40	0.65	1.0	1.5	X	2.5	X	9,	X	6.5	X
					Accepta	Acceptable Quality Levels (tightened inspection)	elo (tightened i	nepection)				

II All values gives in above calls based on Paleona Genellacies on as approximation to the Observat.

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

3	111		A	ā	ñ		3.	ğ	2	ä	ñ	8	Ř		
	. S	Ac Re	٥	<)		٥							Higher Season	
	S.	2	z	7	2		•	=	2	ĸ	8	R	8	IV	
	•	3	72	↓ =	8	4	~		2	2	ĸ	_=	7	$1 \sim$	
	X	Ac Re	2	=		- [_	2 12	21	z	XI ~	8	8	3	
		F.	15	+=	2 2	ᅥ		9 02	13	17 16	2 2	22 22	8	1	
	9.	¥e (2	~	=	1		•	-	12	-	2	ĸ	X	
	\vee	2	2	2	91	丁	•	•	2	15	11	R	8	4.0	
	X	3	12		25	\bot	•	6	~	2	=	=	2	•	
	2.5	2	=	•	2	1	40	-	2	=======================================	25	=	2	IX	
		¥ Ve	01	~		4	<u></u>		•		=	=	==	1	- Fo
ğ	IXI	Ac Re		9	12	1	•	~	-	9	9 12	12 14	Z 15	2.5) bec
3		Re	60	 ~		\dashv	-	•	-	9	=		=	1	i i
1	1.5	Ac	~	m	•		•	-	6	S	1	2	=	X	ig the
Acceptable Quality Levels (normal inspection)	1.0	Re	9	*	~	\Box	-	5	•	~	•	•	2	1.5	Acceptable Quality Levels (tightened inspection)
P		٧c	S	<u> ~ ~ </u>	۰	\perp	•		~	е	~	~	٥	<u> </u>	3
e i	0.65	Ac Re	*		S		e.	0	-	2 5	. v o	9	2 9	0.7	
3		Re A	Б	+		ᆉ	~			``	-	<u>,</u>	<u>.</u>	1 5) əğ
1 8	0.40	Ac	2			1	•	•	0	_	8	m	•	99.0	cept
٧	0.25	2	2	~	8		8	8	8	67	ω.	~	т.	0.45	4
1	-	¥c.	-	<u> </u>				•	•				~	 	
1	0.15	Ac Ne		2 2	ا الق	*								0.25	
		Re												55	
		γc		ž (} }	z								0.15	
	0.10	- 2		a i		¥	:							X	
	 	Re Ac		T										+	
	0.065	yc I			•		•							0.10	
	0.06S	괖	٥		D		٥							ess than 0.10	
	es o	٧c												1 0	
Cumb	lative sample size		200	Ř	. X		8	8	<u>8</u>	9 2	220	98	350		
	o di di		Single		Doable					Multiple					

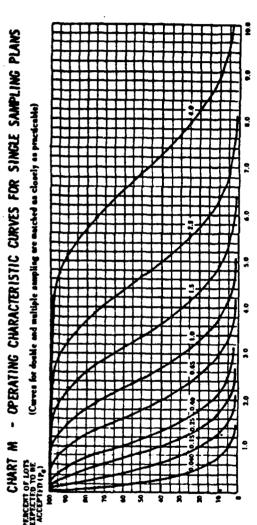
△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ▼ = Use next subaequent sample size code letter for which acceptance and rejection numbers are available.
 Acceptance number

Re = Rejection number

= Use aingle sampling plan above (or elternatively use code letter P)

Acceptance not permitted at this sample size.

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



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

Note: Figure on corner or Acceptable Quality Levals (AQL's) for monal impection.

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

	9		8.5	F .	\$ 1¢	5.93	1	8	¥ 8	5		X	
	L		_				L				60	<u> </u> ^	
	X		3.28	š	7.	\$ 08	88	8	7.86	4.67	11.6	9	
	2.5		2.37	2.8	3.77	3.89	99.1	\$ 5.0	6.79	8,8	8.8	X	
	X		3.1	244	2.74	3.31	4.02	87	3.5	617	7.7	22	
	1.5		1.51	8:	2.23	2.74	3.39	4.13	69.3	5.38	6.40	X	pection)
Acceptable Quality Levels (namal inspection)	X		17.1	1.49	1.72	2.17	2.75	3.63	4.13	4.56	5.52	1.5	Acceptable Quality Levels (tightened inspection)
olity Levels (na	1.0		6.923	1.26	1.48	1.89	2.43	3.07	3.74	4.17	5.06	Χ	le Osobity Level
Acceptable Qu	0.66		195.0	0.830	1.00	1.34	1.80	2.36	2.94	3.34	4.16	1.0	Acceptabl
	0.40	la per hundred units)	0.261	0.434	0.534	0.805	1.17	1.62	2.12	2.46	3.19	0.63	
	0.25	defects per bun	0.138	0.260	0.350	0.548	0.849	1.24	1.69	2 00	2 67	0.40	
	0.15	p (in percent defective or in defect	0.0472	0.113	0.169	0.305	0.533	0.655	1.23	1.51	2.11	0.25	
	0.040	p (in percent	0.00319	0.0163	0.0335	0.0913	0.220	0.440	0.731	0.951	1.46	0.065	
	a*		0.06	25.0	0.00	75.0	90.0	25.0	10.0	5.0	0.7		

Note: All refers give is above table board on Pulsace distributes so as appreciated to the Manusch

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

	į	1		315	82	\$	8	3	3	8 2	9	ş	3		
		11. 15.0 4.0	Ac Re	٥	٥		٥	, -						Higher than 4.0	
		0.4	ž	77	2	2	•	=	≙	ĸ	&	æ	8	\vee	
			٧c	21	=	*	2	~	Ξ.	<u> </u>	ผ	F	33	X	
		X	r Re	61 1	*	8	•	12	11	ដ	K 3	29	32 33	9	
			Re	15 18	=	5	1	-	=	17 16	8	22	-8-		
١		2.5	¥c	*		_ <u>=</u>	_	-	•	2	-	ន	Ю	X	
•		\overline{V}	2	13	2	2	٠	6	12	2	=	8	Ø	2.5	
			٧ç	12	۰	15	•	m	~	2	=	2	7	7	
		1.5	æ	=	•	13	5	•	2	13	22	=	61	X	
	(wa	<u> </u>	Re Ac	01	2 5	12 12	-	7 3	- 6	=	12 11	<u> </u>	15 18		(WO
1	Acceptable Quality Levels (normal inspection)	X			, m			7	•	9	-		=	1.5	Acceptable Quality Levels (tightened inspection)
	. <u>.</u>		ReAc	80	~	- 	•	-	•	=	Ξ	12 12	=		ed in
1	(nor	1.0	γc	1	m	•	•	_	6	S	-	2	13	X	ghen
	evelu	0.65	R	9	S	٦	-	S	•	~	*	٥	0	1.0	is) sla
	lity [L	٧c	S	~	•	•		8	<u> </u>	S	~	•	_	٤
	e Que	0.40	2	•		vo 	m	<u>-</u>	_	2	3	•	6 7	0.65	uality
ĺ	Q a	-	Re Ac	3	3		2		<u>_</u>	-		- v	- <u>s</u>	 	ble ()
	Acce	0.25	Ac R	8		~		0	•	_	. ~	m	•	9.	cepta
		0.15	-E	2	- 2	~	2	~	7	6	6	е.	<u> </u>	χ3	¥c
		6	٠ ٧	-	•	-	•	•	٥	٥	-		8	0.25	
		0.10	Ac Re	-	Code Letter		E					_		0.15	:
		X	Re Ac Re		2 8 2 3 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5		<u>.</u>	_						0.10	
		0.06	Ac Re	=	Code	•	د							X	•
		0.040	Re	0 1	•									0.065	
		then then 0.040	Ac Re Ac	٥	D	-	٥							then 0.065	
	,	lative sample		315	900	\$	8	33	240	320	Q	8	93		
		Type of sempling plan		Single		Double				Multiple					

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

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

Acceptance number.

Hejection number. Use single sampling plan above (or alternatively use code letter Q) **454.**

Acceptance not permitted at this sample size.

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

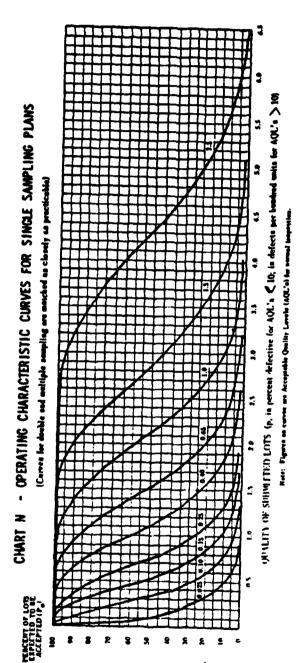


TABLE X-N-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

			T	丁		T	1	_	Γ	٦		Ţ			T	٦	_	Τ	7	-
		2.5			2.51			3.00	1		2		\$	3.5	3	3	6.87	X		
		X			2.07	97.0		2.73	315		3.73		4.0	53	7.	\$.	6.12	2		
		2.5			8	3		2.06	2.65		2.93		8.0	£.83	, F		s. 8	X		
		X			<u> </u>	35		1.73	2.08		253	5	5	3.56	3.69		4.56	\$1		
ection)		<u>.</u>			28.0	1.23	٩		1.72		2.13	2.60		3.08	3.39		4.03	X		inspection)
els (normal insp	1	X			0.70	0.939	8		1.37		1.13	2.16		7.00	2.89		90.7	0.1		Acceptable Usality Levels (tightened inspection)
Acceptable Quality Levels (normal inspection)		0.65		193 6	187.5	0.7%	1200		6	5	3	X	ž	3	2.63	Ę	337	X		
Accepti		0.40		0 187		0.523	0.90		*	٤		3.	=		2.10	2,42		9.65		Accep
		0.0	lects per hundred saits)	0.165		0.273	0.349		0.50	47.0		70.	72		1.55	2 01		0.40		
	21.0			0.0872		0.104	0.220	0.346	0.563	0.535		0 784	8		8	58		6.33		
	9		plin percent defective or in de	0.0297		0.71	901.0	101.0	241.0	0.336		0.539	0.778	0,00	ík s	1.33		25		
	0.025		b (in perce	0.00201	50100		0.0211	0.0576		0 136		117.0	19+0	0 5 0		126.0	900	355		
•	۵			93.0	88		90.0	75.0		20.0	ž	3	0.0	0.5		1.0				.,

All relate gives in above table board on Potents distribution as an exercision to the Birents

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

					_		III.	2440,	-10	5E_		7	
j	111]	8	¥ 8	2	8	R	3	9	æ	E		
	ja:	Ac Be	٥	٥	۵							112	
	22	å	Ħ	2 2	•	=	2	M	R	=	8	Y	
		*	Z	= 8	<u> </u>	~	2	2	×	=	×	X	
	X	2	19	2 2	•	22	=	Ħ	M	R	8	2	
	 ``	Re Ac	11 21	= 2	-		===	17 16	8	E E	***	1	
	2	F F	1	- 9	_	-	-	12		- -	Ŋ	X	
	∇	2	2	2 2	-	•	21	- 22	=	R	N		
	X	3	21	<u>ه</u> د	-	•	~	2	=	=	ន	1.5	
	F.	2	ıı.	• 3	20	•	2	2	15 15	2	2	X	
		2	2	w 2	•		•	•	11 21	=======================================	2	$1 \triangle$	3
3	X	£	•	- 21		-	•	=			22	0.1	Pecti
To the state of th		¥ 24	•	~ . .	1 -	- 7	-	9 9	=	12 12	=	1	ă.
Acceptable Quality Levels (sormal inspection)	9.6		1			_	m	5	7	2	<u> </u>	X	Acceptable Quality Levels (tightened inspection)
-		Re Ac	9	w ~	-	8	9	~	-	=	=		3
7	9.0	Ac	8	~ •		-	84	•	S	-	•	9.65	3
3	0.25	2	•	4 10		•	•	8	9	9	1	0.60	Ality
3	•	¥ .	3		<u> • </u>	۰	-	~	<u></u>	•	•	ļ °	라 *
1	9.15	2	8		7	•	m	•	•	v 5	v	22.0	4
100		ReAc	2 2	N 0	-				~	<u> </u>		-	8
	9.0	¥.	-	• -		_	•	•	_	_	8	0.15	
	92	2			 								
	0.065	٧c			<u> </u>							0.10	
	Y	2		8 3	0							0.065	
		Re Ac											
	9.060	Ac		5 8 5	*							X	
	9.025	c Re	-	•								0.040	
	0.028	: Re Ac	D	D	D			. 				0.040 0.040	
į	19 19 1	¥c.	8	SE 83	12	ន្ត	375	8	£	<u>8</u>	37	3	
	i j		Single	Peter				Maltiple					
									_		-	_	

Use sest preceding sample size code letter for which acceptance and rejection numbers are prailable. 4 P 4 &

Use sett subsequest sample size code letter for which acceptance and rejection nembers are stallable.

Acceptance number

Rejection number

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

Acceptance not permitted at this sample size.

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

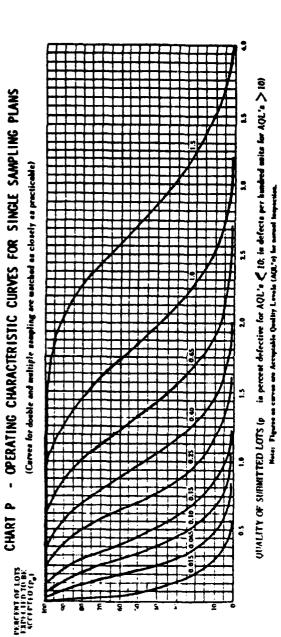


TABLE X-P-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

Acceptable (Juntity Lovels (mormal inspection)	0.15 0.25 0.40 X 0.65 X 1.0 X 1.5	váred umits)	45 0.103 0.223 0.363 0.438 0.596 0.762 0.935 1.29 1.57	2 0.171 0.327 0.498 0.587 0.711 0.961 1.16 1.56 1.06	8 0.218 0.394 0.582 0.679 0.878 1.08 1.29 1.71 2.03	6 0.317 · 0.527 0.745 0.855 1.08 1.30 1.53 1.99 2.34	4 0.459 0.709 0.959 1.06 1.33 1.58 1.63 2.33 2.71	0 0.639 0.928 1.21 1.35 1.63 1.90 7.17 2.72 3.12	0.835 1.16 1.47 1.62 1.93 2.22 2.52 3.09	7 0.969 1.31 1.64 1.80 2.12 2.43 2.74 3.34 3.78	1.26 1.64 2.00 2.18 2.52 2.85 3.18 3.82 4.29	8.5 A 0.1 X 0.6 X 0.0 X	
Acceptable Quality Le			_						ļ	_			
Acc		units)	-			÷				_			
	0.10	fects per hundred units)	0.0545	0.102	0.138	0.216	0.334	0.100	0.665	0.787	1.05	0.15	
	0 065	plin percent defective or defects	0.0186	0 0444	0.0665	0.120	0.210	0.337	0.486	0.593	0.8.0	0.10	
	5100	p(in percent	0.00126	0.00641	0.0132	0.0.40	0.09656	0.173	0.789	0.374	0.576	0.025	
	٤.		0 66	95.0	0 06	75.0	20.0	25.0	10.0	5.0	0.1		

betre All values given in above table based on Potence distribution on an approximation to the Planning

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

	11		8	3.	900	Ř	ş	ş	8	8	8	8		
	then 1.5	ž	٥	٥		٥	<u> </u>						Higher then 1.5	
ł		Re Ac	22	2	z,	•	=	6	M	8	R	R		
	1.5	¥	2	=	×	2	~	13	2	ĸ	#	Ħ	Λ	
	∇	2	2	=	8		12	1	Ħ	1/3	80	a	1.5	
	\triangle	2	2	•	ឧ		•	=	2	য়	-	R		
	1.0	Ac Re	14 15	= -	18 19	1 7	91	13	2 17	8 ~	2	a a	X	
		2	2	2	16 1	9	•	2	12 13	17 17	8	2 2	\vdash	
	X	Ac F	23	•	15		~	-	2	=	=	ដ	9.7	
	9	2	=	•	13	~	•	2	2	2	=	2	V	
	0.65	٧c	2	S	13	•	m	•	•	=	=	2	X	
1	V	5	•	-	12	+	2	6	=	12	=	15	0.65	ection
1 2	\triangle	_ ₹	•	6	11	•		*	•		12	=	L	in
Acceptable Quality Lovels (normal inspection)	3.0	c Re	7	3	8	•	9	60	5 10	7 11	10 12	13 14	X	Acceptable Quality Levels (tightened inspectios)
1 1	-	Re	•	- N	7	-	- S			•	-		+	100
1	6.2	γc	S	7	vo		_	8	m	v	~	_	0.40	Levels
1	53	æ	•	-	\$	6	60	•	S	9	9	~	0.20	dity
ě	9.15	٧c	9	-	•	•	•	_	8	<u>_</u>	•	•	9	ð
1 3	0.10	æ	~	e .	•	7	m	•	•	-	S	40	0.15	4
8		₹	- 2	-	6	-	_			~	<u> </u>	•	-	Acce
	0.065	Ac Pe	1 2	0 2	-	2	- 3	0	9		~	3	0.10	
	0.040	Re		* 85 2 85		 >							0.065	
1	0	Re Ac											+	
	X	Re Ac R		3 83		=							0.040	
	0.025	۸c				z 							X	
	0.015	Ac Re	0 1	•		•					-		0.025	
	0.010	Ac Re	Δ	D		Δ							Less then 0.025	
į	a ig		008	85	000	60 2	\$	\$	8	1000	1200	000		L. <u></u>
			Single	Double					Multiple					

Use nest preceding numple nize cade letter for which accommance and rejection numbers are evailable. **4 5 4 5**

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

Acceptance number.

Rejection number.

Acceptance not permitted at this sample size. Use single sampling plan above.

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

CHART Q - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS (Carrès for double and multiple anapling are matched an cloudy on practicable)

02 0.3 0.4 0.5 0.5 0.7 0.0 0.0 1.0 1.1 1.2 1.4 1.5 1.4 1.7 1.0 1.9 2.0 2.1 2.3 2.5 UMALITY OF SUBNITTED LITTS (p. 10 percent defective for AQL's < 10; in defects per handred units for AQL's > 10)

Rote: Pigeres en curves are Acceptable Quality Lanels (AQL's) for several impaction)

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

					Accepts	ble Quality Lev	Acceptable Quality Levels (normal inspection)	ection)				
۵.	0.010	0.040	0.065	0.10	0.15	0.23	X	0.40	X	990	X	0.1
	teased oil d	p in percent defective or defects	lefects per hundred maits	ed mits								
0.66	0.00004	0.0119	0.0340	0.0659	0.163	0.232	0.781	98. 0	97,6	85.0		
95.0	0.00410	0.0284	0.0654	0.109	0.20	0.318	0.376	100	3170	86.9	0.00	5
0.08	0.0043	0.0425	0.0882	0.140	0.22	0.372	270	3	618.9	200	6.3	<u>a</u> !
75.0	0.0230	0.0769	0.138	0.203	0.338	0.476	73.0	890		898	5.	R.
0.08	0.0555	W1.0	0.214	162.0	23.0	0.614	3 90	9 863	2			6.
25.0	0.111	0.215	0.314	0.409	95.0	0.775	798 0	2	: :			1.73
10.0	0.184	0.311	829	0.534	0.70	3	2				7.1	8.2
5.0	0.240	0.380	35.0	0.630	1	7	5	3 .	2.1	1.0	8-	2.25
0.0	9%	0.531	0.672	708.0	18	87	2	8 1	8	2.3	214	2.0
	0.015	0.065	9.10	0.15	× c	\ \	9 6		2 3	5,	Q Z	23
							3.5	(0.65	X	<u>.</u>	X
					Accept	able Quality Le	Acceptable Quality Levels (tightened inspection)	nspection)				

the All refers gives to show tolk based as Palenas distributes as as assumptions in the Research

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

[]	11		8		1	3		315	3	3	3	1575	£	22		
	112	Ac Ro	٥,		٥			٥							E 0	
	1.0	2	Ħ		2	22 5		•	71 /	2	Ŋ	8	2	8	X	
	 	7	19	╁	=======================================	<u>*</u>	4	<u> </u>	2	17 13	= =	N N	<u> </u>	-R	 	
1	IX	<u>ء</u> ع	2		ř	2 2			9	=	2 2	2	2	3	=	
		2	- S1	+	=	2	7	~	2	-=	=	8	ล	×	∇	
İ	9.6	ş	≈		~	=			•	•	==	=	2	12	X	
1	V	2	13	T	2	2		•	•	2	22	=	8	N	0.65	
}		٤	2111	$oldsymbol{\perp}$	•	2		•	•	~	2	=	=	ន	Ö	
	3	Æ			•	=		•	•	2	2	22	==	2	X	
1		7	*	+	~	77	-	<u>-</u> -	~	_ _		=	==	===	\ <u>\</u>	8
3	IX	Ac Re			3 7	11 12		•	~	-	= 9	9 12	7 21	21 12	0.60) de
}	H-	V eig	•	┿	~	-	\dashv	-	-	•	2	=	=======================================	=		7
1 7	6.0	Ac F	~		~	•	١	•	-	•	~	~	2	13	X	ighte.
Acceptable Quality Levels (sermal lespectes)	0.15	2	•	T	v	~	7	•	S	9	~	•	•	2	6.7X	Acceptable Quality Lavels (tightened inspection)
1 5		Ac	8	\bot	~	۰	_	_	_	8	е.	s	~	•		ا يُّ
	0.10	2	•	1	•	50	Ì	•	m	~	50	•	9	~	0.15	ig ig
1 8	-	, Ac	-	+		-	-		•	~	~	m	-			1 3
1 4	0.065	Ac Ro	m		m	-	1	~	~	m -	-	~	w	5	9 9	
1 3	-	Re.	2	╁			+		- 7	~	<u>m</u>	3	<u> </u>	*	├	۲
1	0.040	Ac F	_		•	_	-		•	0	•	_	_	8	0.068	
	0.025	Ac Re		3	8	Š	Œ								0.040	
	X	Ac Re		*	90	¥ 197	•		-						0.02	
	9.015	Ac Re		3	e poo	S	٩								X	
	0.010	Ac Re	1 0		•	•		•							0.015	
	X	Ac Re		3		Š	æ								0.010	
į	lative eemple	2	120		9	9091		315	93	206	1280	1575	0681	2202		
	įįi		opburg:		:	Openia					Multiple					

The next proceding sample size code letter for which acceptance and rejection numbers are svailable. 4

= Acceptance number

Rejection number

Use single eampling plan above. Acceptance not permitted at this numple size.

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

CHART R - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



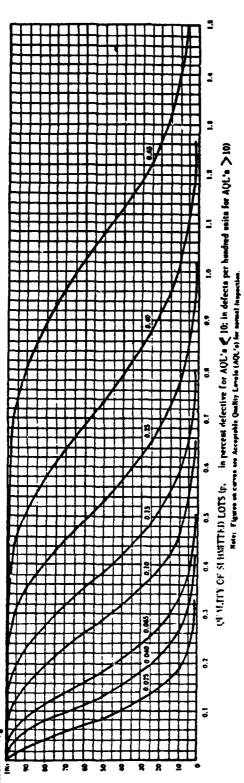


TABLE X-R-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

				week	(aoie Ceality Let	Acceptable (Sellity Levels (norms) inspection)	rction)				
<u>.</u>	0.035	0.040	0.065	0.10	0.15	Χ	0.25	Χ	0+0	Χ	9.66
	p (in percent d	p (in percent defective or defects per hundred units)	la per hundred un	ite)							
0.0%	0.00743	0.0218	0.0412	0.0892	0.145	0.175	6/2/0	0.305	0.374	0.517	6.679
8.0	0.0178	0.0409	0.0683	0.131	0.199	0.235	0.309	0.34	0.462	0.622	9.745
0.06	0.0266	0.0651	0.0872	0.158	0.233	22.0	0.351	0.432	0.515	99.0	0.012
25.0	0.0481	0.0864	0.127	0.211	967.0	0.342	0.431	0.521	0.612	e.75	0.934
20.0	0.0839	0.134	0.181	0.284	0.383	0.433	0.533	0.633	0.73	9.933	8.1
ο. Σ	0.135	0.196	0.255	0.371	787'0	015.0	0.651	0.761	0.870	1.0	1.5
10.0	0.194	0.266	0.334	0.464	0.589	059.0	0.770	0.889	10.1	1.24	÷.
9.0	0.237	0.315	0.388	0.526	0.657	0.722	0.848	0.972	1.09	1.33	1.51
1.0	0.332	0.420	0.502	0.655	0.800	0.870	1.02	1.14	1.27	1.53	1.2
	0.040	0.065	0.10	0.15	Χ	0.25	X	07:0	Χ	0.66	Χ
				•	Acceptable Quality	Acceptable Quality Levels (tightened inspection)	red inspection)				

MIL-SID-105E

	11	3	88	927		8	98	150	8000	8	8	3500		
	Here ibre	Ac Re	۵	٥		4							There iben 0.65	
	0.66	2	Z	2 2		•	=	2	KQ	83	æ	8	X	
1		7€	_ 72	<u> </u>		~	~	2	=	ম	Ē	37	1/	
	X	c Re	61 81	- n		_	6 12	11 17	22 91	Z Z	2 2	e E	99.0	
	\vdash	Re	15	= 2		_	9	===	==	8	<u> </u>	*	1	
	0.60	1	=	- =	l	_	-	-				ĸ	X	
1	V	Re	23	2 %	T	•	•	12	15 12	17 17	8	n	9	
	X	Re Ac	21	5 5		۰	en .	~	2	15 14	17	<u> </u>	0.40	
l	0.25	Æ	=	. 8		2	•	10	22	25	13	2	X	
<u>§</u>	8	٤	2	2 ~		•	•	•	•	=	=	=	1	3
ienpect	X	ReAc	6	7		•	~	•	=	12	=	15	0.25	j
1	 	Re Ac	-	- 6 - 3		-	-7	-	9	=	12 12	=	-	7
3 9	0.15		~	m •			_	m	ر د	7	2	1 1	X	fricks
1 1		Re	9	2 -	十	+	S	•	~	•	-	2	0.15	1
3	0.10	۲	S	~ •	Ī	•	-	7	~	S	~	•	9	4
Acceptable Quality Lavels (acres) inapection)	0.065	c Re	*	* 5			60	*	پ	9	9	1 9	0.10	Accounts Outline Lough (tichtand innerstine)
1 8	 	ReAc	3	m +	-	2	<u> </u>	-	7			<u></u>	-	3
	0.040	Ac F	2	0 10		•	•	•	_	~	en	~	0.065	
	2	₩	~	8 8	\dashv	7	7	7	6	6	6	~	† -	
{	0.025	٧c		0 -	\perp	•		•	•	_	_	~	0.040	
	X	Ac Re	;	code Letter	S								0.025	
İ	5	뢒		• 5									1	
	0.015	¥c	:		<u> </u>								X	
	0.010	Ac Re	 	20 00 PE	0								0.015	
		ž	-										2	
	X	¥							•				0.010	
į	lative suple	3	2000	1250		8	0001	1500	2000	82	3000	3200		
	The state of	Į.	S. S. S. S. S. S. S. S. S. S. S. S. S. S	Double					Multiple					

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

Use sent preceding sample size code letter for which acceptance and rejection aumbers are available.

Acceptance number. 44.

Rejection number.

Use single sompling plan above.

Acceptance not permitted at this sample size.

Acceptance number ~ & ~

Rejection number

Acceptance not permitted at this sample size.

MIL-STD-105E

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 <u>Changes from Previous Issue</u>. 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

User Activities:

Army - ME DLA - ES, SS

(Project QCIC-0085)

INSTRUCTIONS: In a continuing effort to make our standardisation documents better, the DoD provides this form for use in submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide submitting comments and suggestions for improvements. All users of military standardization documents are invited to provide suggestions. This form may be detached, folded along the lines indicated, taped along the loose edge (DO NOT STAPLE), and lied. In block 5, be as specific as possible about particular problem areas such as wording which required interpretation, was too rigid, restrictive, loose, ambiguous, or was incompatible, and give proposed wording changes which would alleviate the problems. Enter in block 6 any remarks not related to a specific paragraph of the document. If block 7 is filled out, an acknowledgement will be mailed to you within 30 days to let you know that your comments were received and are being considered.

NOTE: This form may not be used to request copies of documents, nor to request waivers, deviations, or clarification of specification requirements on current contracts. Comments submitted on this form do not constitute or imply authorization to waive any portion of the referenced document(s) or to amend contractual requirements.

(Pold along this line)

(Fold along this line)

DEPARTMENT OF THE ARMY



OFFICIAL BUSINESS
PENALTY FOR PRIVATE USE \$300

BUSINESS REPLY MAIL

FIRST CLASS PERMIT NO. 12062

WASHINGTON D. C.

POSTAGE WILL BE PAID BY THE DEPARTMENT OF THE ARMY

CO! MANDER

U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER

ATTN: SMCAR-BAC-S

PICATINNY ARSENAL, NJ 07806-5000

NO POSTAGE.
NECESSARY
IF MAILED
IN THE
UNITED STATES

STA	NDARDIZATION DOCUMENT II (See Instructions - Re	
1. DOCUMENT NUMBER MIL-STD-105E	2. DOCUMENT TITLE SAMPLING PROCEDURES AND	TABLES FOR INSPECTION BY ATTRIBUTES
S. NAME OF SUSMITTING ORG	MANIZATION	4. TYPE OF ORGANIZATION (Mark one) VENDOR
•		UREA
a. ADDRESS (Street, City, State, I	ELP Code)	MANUFACTURER
		OTHER (Speel/y):
S. PROBLEM AREAS c. Paragraph Number and World	ng:	
b. Recommended Wording:	· •	
c. Ressen/Retionals for Recom	mendetion:	
6. REMARKS		
·	,	
74. NAME OF SUBMITTER Last	Piret, MI) - Optional	8. WORK TELEPHONE NUMBER (Include Area Code) — Optional
c. MAILING ADDRESS (Street, C	ity, State, ZIP Code) — Optional	8. DATE OF SUBMISSION (YYMMDD)