### MILITARY STANDARD

## SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

### TO ALL ACTIVITIES:

- 1. The following corrections should be made to MIL-STD-105D:
- (a) Page ii, lines 2, 3, and 4: Change to read "Recommended corrections, additions or deletions should be addressed to Director of Quality Assurance, U.S. Army Edgewood Arsenal, ATTN: SMUEA-QA-E, Edgewood Arsenal, Md., 21010."
  - (b) Page 2, paragraph 3.2, line 3: Change "hunderd" to read "hundred".
  - (c) Page 4, paragraph 6.4, line 9 Change "for" to read "only".
  - (d) Page 5, paragraph 8.2, line 5: Change "batchs" to read "batches".
  - (e) Page 5, paragraph 8.2, line 6: Change "require change" to read "require a change".
- (f) Page 5, paragraph 8.2, lines 6, 7, and 8: Delete the sentence that reads, "The switching procedures given below require a change".
- (g) Page 7, paragraph 10.1, lines 5 and 6: Change "10.1.3, 10.1.4, and 10.1.5" to read "10.1.3 and 10.1.4". Delete reference to 10.1.5.
  - (h) Page 8, paragraph 11.1, line 2: Change "larger then 80" to read "larger than 80".
  - (i) Page 9, table I: Add the following footnote beneath table I:

Note.	BALLINE BALLINE BALLINE	Small sample i	nspection levels of	MIL-STD-106C	Convert to these special inspection levels
		and L-2			
		and L-4			:=
		and L-6 and L-8			S-4

- (j) Page 29, table IX, vertical scale on three charts: Change "¾n, ½n, ½n, ½n" to read ".75n, .50n, .25n".
- (k) Page 36, table X-D-1: Add footnote, "Note: Binomial distribution used for percent defective computations; Poisson for defects per hundred units".
- (l) Page 46, table X-J-1: Change footnote to read, "Note: Binomial distribution used for percent defective computations; Poisson for defects per hundred units".
  - (m) Page 48, table X-K-1: For Pa=75.0 and AQL=0.65, change "0.382" to read "1.382".
- (n) Page 52, table X-M-1: In line below row of AQL values, change "dejects" to read "defects".
  - (o) Page 54, table X-N-1: In the footnote, change "Pisson" to read "Poisson".
  - (p) Page 56, table X-P-1: In the footnote, change "Poission" to read "Poisson".
- (q) Page 63, for the term Reduced inspection: Change paragraph references from "8.2 and 8.3.3" to read "8.2, 8.3.3 and 10.1.4".
- (r) Page 64, mailing address for the U.S. Government Printing Office: Delete reference to zone 25 and, after D.C., add the ZIP code "20402".
- 2. The following is a cumulative list of earlier changes: Notice 1 (Navy) dated 1 November 1963 provided a table of conversion from the small sample inspection levels (L-1, L-2, etc.) of MIL-STD-105C, to the special inspection levels (S-1, etc.) of MIL-STD-105D. The same conversion information is covered by correction 1(i) above to page 9, table I.
  - 3. Retain this notice and insert before the table of contents.
- 4. Holders of MIL-STD-105D will verify that corrections indicated above have been entered and will destroy the previous notice. Activities which stock these notices for issue are warned that each notice, together with its appended revised pages if any, is in effect a separate publication to be retained until the military standard is completely revised or canceled.

MIL-STD-105D NOTICE-1 (NAVY) 1 November 1963

### MILITARY STANDARD

### SAMPLING PROCEDURES AND TABLES

### FOR INSPECTION BY ATTRIBUTES

The designations used for Inspection Levels in MIL-STD-105D differ from those in the previous issue, MIL-STD-105C. This notice is issued as an interim measure to provide conversion information, as follows:

For Speci	ified Small	Use	Special
Semple In	spection	Inspec	tion Level
Level Mli	STD-105C		-STD-105D
\$18 (2.6 F)\$ 6			
L-1	and L-2		S-1
	and L-4		S-2
L5	and L-6		S-3
L-7	and L-8		S-4

Preparing Activity: Navy-Weps SPC 63003

MIL-STD-105D

29 April 1963

SUPERSEDING MIL-STD-105C 18 July 1961

### MILITARY STANDARD

# SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES



### DEPARTMENT OF DEFENSE Washington 25, D. C.

### SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

MIL-STD-105D

29 APRIL 1963

- 1. This standard has been approved by the Department of Defense and is mandatory for use by the Departments of the Army, the Navy, the Air Force and the Defense Supply Agency. This revision supersedes MIL-STD-105C, dated 18 July 1961.
- 2. This publication provides sampling procedures and reference tables for use in planning and conducting inspection by attributes. This publication was developed by a working group representing the military services of Canada, the United Kingdom and the United States of America with the assistance and cooperation of American and European organizations for quality control. The international designation of this document is ABC-STD-105. When revision or cancellation of this standard is proposed, the departmental custodians will inform their respective Departmental Standardization Office so that appropriate action may be taken respecting the international agreement concerned.
- 3. The U.S. Army Munitions Command is designated as preparing activity for this standard. Recommended corrections, additions, or deletions should be addressed to the Commanding Officer, U.S. Army CBR Engineering Office, Attn: SMUCE-ED-S, Army Chemical Center, Maryland.

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## SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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### 1. SCOPE

- 1.1 PURPOSE. This publication establishes sampling plans and procedures for inspection by attributes. When specified by the responsible authority, this publication shall be referenced in the specification, contract, inspection instructions, or other documents and the provisions set forth herein shall govern. The "responsible authority" shall be designated in one of the above documents.
- 1.2 APPLICATION. Sampling plans designated in this publication are applicable, but not limited, to inspection of the following:
  - a. End items.
  - b. Components and raw materials.
  - c. Operations.
  - d. Materials in process.
  - e. Supplies in storage.
  - f. Maintenance operations.
  - g. Data or records.
  - h. Administrative procedures.

These plans are intended primarily to be used for a continuing series of lots or batches.

The plans may also be used for the inspection of isolated lots or batches, but, in this latter case, the user is cautioned to consult the operating characteristic curves to find a plan which will yield the desired protection (see 11.6).

- 1.3 INSPECTION. Inspection is the process of measuring, examining, testing, or otherwise comparing the unit of product (see 1.5) with the requirements.
- 1.4 INSPECTION BY ATTRIBUTES. Inspection by attributes is inspection whereby either the unit of product is classified simply as defective or nondefective, or the number of defects in the unit of product is counted, with respect to a given requirement or set of requirements.
- 1.5 UNIT OF PRODUCT. The unit of product is the thing inspected in order to determine its classification as defective or nondefective or to count the number of defects. It may be a single article, a pair, a set, a length, an area, an operation, a volume, a component of an end product, or the end product itself. The unit of product may or may not be the same as the unit of purchase. supply, production, or shipment.

### 2. CLASSIFICATION OF DEFECTS AND DEFECTIVES

- 2.1 METHOD OF CLASSIFYING DEFECTS. A classification of defects is the enumeration of possible defects of the unit of product classified according to their seriousness. A defect is any nonconformance of the unit of product with specified requirements. Defects will normally be grouped into one or more of the following classes; however, defects may be grouped into other classes, or into subclasses within these classes.
- 2.1.1 CRITICAL DEFECT. A critical defect is a defect that judgment and experience indicate is likely to result in hazardous or unsafe conditions for individuals using, maintaining, or depending upon the product; or a defect that judgment and experience indicate is likely to prevent performance of the tactical function of a major end item such as a ship, aircraft, tank, missile or space vehicle. NOTE: For a special provision relating to critical defects, see 6.3.
- 2.1.2 MAJOR DEFECT. A major defect is a defect, other than critical, that is likely to result in failure, or to reduce materially the usability of the unit of product for its intended purpose.

- 2.1.3 MINOR DEFECT. A minor defect is a defect that is not likely to reduce materially the usability of the unit of product for its intended purpose, or is a departure from established standards having little bearing on the effective use or operation of the unit.
- 2.2 METHOD OF CLASSIFYING DEFECTIVES. A defective is a unit of product which contains one or more defects. Defectives will usually be classified as follows:
- 2.2.1 CRITICAL DEFECTIVE. A critical defective contains one or more critical defects and may also contain major and or minor defects. NOTE: For a special provision relating to critical defectives, see 6.3.
- 2.2.2 MAJOR DEFECTIVE. A major defective contains one or more major defects, and may also contain minor defects but contains no critical defect.
- 2.2.3 MINOR DEFECTIVE. A minor defective contains one or more minor defects but contains no critical or major defect.

### 3. PERCENT DEFECTIVE AND DEFECTS PER HUNDRED UNITS

- 3.1 EXPRESSION OF NONCONFORM-ANCE. The extent of nonconformance of product shall be expressed either in terms of percent defective or in terms of defects per hundred units.
- 3.2 PERCENT DEFECTIVE. The percent defective of any given quantity of units of product is one hunderd times the number of defective units of product contained therein divided by the total number of units of product, i.e.:

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

3.3 DEFECTS PER HUNDRED UNITS. The number of defects per hundred units of any given quantity of units of product is one hundred times the number of defects contained therein (one or more defects being possible in any unit of product) divided by the total number of units of product, i.e.:

Defects per Number of defects × 100 Number of units inspected

### 4. ACCEPTABLE QUALITY LEVEL (AQL)

- 4.1 USE. The AQL, together with the Sample Size Code Letter, is used for indexing the sampling plans provided herein.
- 4.2 **DEFINITION.** The AQL is the maximum percent defective (or the maximum number of defects per hundred units) that, for purposes of sampling inspection, can be considered satisfactory as a process average (see 11.2).
- NOTE ON THE MEANING OF AQL. 4.3 When a consumer designates some specific value of AQL for a certain defect or group of defects, he indicates to the supplier that his (the consumer's) acceptance sampling plan will accept the great majority of the lots or batches that the supplier submits, provided the process average level of percent defective (or defects per hundred units) in these lots or batches be no greater than the designated value of AQL. Thus, the AQL is a designated value of percent defective (or defects per hundred units) that the consumer indicates will be accepted most of the time by the acceptance sampling procedure to be used. The sampling plans provided herein are so arranged that the probability of acceptance at the designated AQL value depends upon the sample size, being generally higher for large samples than for small ones, for a given AQL. The AQL alone does not
- describe the protection to the consumer for individual lots or batches but more directly relates to what might be expected from a series of lots or batches, provided the steps indicated in this publication are taken. It is necessary to refer to the operating characteristic curve of the plan, to determine what protection the consumer will have.
- **4.4** LIMITATION. The designation of an AQL shall not imply that the supplier has the right to supply knowingly any defective unit of product.
- 4.5 SPECIFYING AQIs. The AQL to be used will be designated in the contract or by the responsible authority. Different AQLs may be designated for groups of defects considered collectively, or for individual defects. An AQL for a group of defects may be designated in addition to AQLs for individual defects, or subgroups, within that group. AQL values of 10.0 or less may be expressed either in percent defective or in defects per hundred units; those over 10.0 shall be expressed in defects per hundred units only.
- **4.6** PREFERRED AQLs. The values of AQLs given in these tables are known as preferred AQLs. If, for any product, an AQL be designated other than a preferred AQL, these tables are not applicable.

### 5. SUBMISSION OF PRODUCT

5.1 LOT OR BATCH. The term lot or batch shall mean "inspection lot" or "inspection batch," i.e., a collection of units of product from which a sample is to be drawn and inspected to determine conformance with the acceptability criteria, and may differ from a collection of units designated as a lot or batch

for other purposes (e.g., production, shipment, etc.).

5.2 FORMATION OF LOTS OR BATCHES. The product shall be assembled into identifiable lots, sublots, batches, or in such other manner as may be prescribed (see 5.4). Each

lot or batch shall, as far as is practicable,

### 5. SUBMISSION OF PRODUCT (Continued)

consist of units of product of a single type, grade, class, size, and composition, manufactured under essentially the same conditions, and at essentially the same time.

- 5.3 LOT OR BATCH SIZE. The lot or batch size is the number of units of product in a lot or batch.
- 5.4 PRESENTATION OF LOTS OR BATCHES. The formation of the lots or

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

### 6. ACCEPTANCE AND REJECTION

- 6.1 ACCEPTABILITY OF LOTS OR BATCHES. Acceptability of a lot or batch will be determined by the use of a sampling plan or plans associated with the designated AQL or AQLs.
- 6.2 DEFECTIVE UNITS. The right is reserved to reject any unit of product found defective during inspection whether that unit of product forms part of a sample or not, and whether the lot or batch as a whole is accepted or rejected. Rejected units may be repaired or corrected and resubmitted for inspection with the approval of, and in the manner specified by, the responsible authority.
- 6.3 SPECIAL RESERVATION FOR CRITI-CAL DEFECTS. The supplier may be required at the discretion of the responsible authority to inspect every unit of the lot or batch for

critical defects. The right is reserved to inspect every unit submitted by the supplier for critical defects, and to reject the lot or batch immediately, when a critical defect is found. The right is reserved also to sample, for critical defects, every lot or batch submitted by the supplier and to reject any lot or batch if a sample drawn therefrom is found to contain one or more critical defects.

6.4 RESUBMITTED LOTS OR BATCHES. Lots or batches found unacceptable shall be resubmitted for reinspection only after all units are re-examined or retested and all defective units are removed or defects corrected. The responsible authority shall determine whether normal or tightened inspection shall be used, and whether reinspection shall include all types or classes of defects or for the particular types or classes of defects which caused initial rejection.

### 7. DRAWING OF SAMPLES

- 7.1 SAMPLE. A sample consists of one or more units of product drawn from a lot or batch, the units of the sample being selected at random without regard to their quality. The number of units of product in the sample is the sample size.
- 7.2 REPRESENTATIVE SAMPLING. When appropriate, the number of units in the sample shall be selected in proportion to the size of sublots or subbatches, or parts of the lot or batch, identified by some rational criterion.

### 7. DRAWING OF SAMPLES (Continued)

When representative sampling is used, the units from each part of the lot or batch shall be selected at random.

7.3 TIME OF SAMPLING. Samples may be drawn after all the units comprising the lot or batch have been assembled, or sam-

ples may be drawn during assembly of the lot or batch.

7.4 DOUBLE OR MULTIPLE SAMPLING. When double or multiple sampling is to be used, each sample shall be selected over the entire lot or batch.

### 8. NORMAL TIGHTENED AND REDUCED INSPECTION

- 8.1 INITIATION OF INSPECTION. Normal inspection will be used at the start of inspection unless otherwise directed by the responsible authority.
- 8.2 CONTINUATION OF INSPECTION. Normal, tightened or reduced inspection shall continue unchanged for each class of defects or defectives on successive lots or batchs except where the switching procedures given below require change. The switching procedures given below require a change. The switching procedures shall be applied to each class of defects or defectives, independently.

### 8.3 SWITCHING PROCEDURES.

- **8.3.1 NORMAL TO TIGHTENED.** When normal inspection is in effect, tightened inspection shall be instituted when 2 out of 5 consecutive lots or batches have been rejected on original inspection (i.e., ignoring resubmitted lots or batches for this procedure).
- 8.3.2 TIGHTENED TO NORMAL. When tightened inspection is in effect, normal inspection shall be instituted when 5 consecutive lots or batches have been considered acceptable on original inspection.
- **8.3.3** NORMAL TO REDUCED. When normal inspection is in effect, reduced inspection shall be instituted providing that all of the following conditions are satisfied:

- a. The preceding 10 lots or batches (or more, as indicated by the note to Table VIII) have been on normal inspection and none has been rejected on original inspection; and
- b. The total number of defectives (or defects) in the samples from the preceding 10 lots or batches (or such other number as was used for condition "a" above) is equal to or less than the applicable number given in Table VIII. If double or multiple sampling is in use, all samples inspected should be included, not "first" samples only; and
  - c. Production is at a steady rate; and
- d. Reduced inspection is considered desirable by the responsible authority.
- 8.3.4 REDUCED TO NORMAL. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:
  - a. A lot or batch is rejected; or
- b. A lot or batch is considered acceptable under the procedures of 10.1.4; or
- c. Production becomes irregular or delayed; or
- d. Other conditions warrant that normal inspection shall be instituted.

### 8.4 DISCONTINUATION OF INSPECTION.

In the event that 10 consecutive lots or batches remain on tightened inspection (or such other number as may be designated by the responsible authority), inspection under the provisions of this document should be discontinued pending action to improve the quality of submitted material.

### 9. SAMPLING PLANS

- 9.1 SAMPLING PLAN. A sampling plan indicates the number of units of product from each lot or batch which are to be inspected (sample size or series of sample sizes) and the criteria for determining the acceptability of the lot or batch (acceptance and rejection numbers).
- INSPECTION LEVEL. The inspection level determines the relationship between the lot or batch size and the sample size. The inspection level to be used for any particular requirement will be prescribed by the responsible authority. Three inspection levels: I, II, and III, are given in Table I for general use. Unless otherwise specified, Inspection Level II will be used. However, Inspection Level I may be specified when less discrimination is needed, or Level III may be specified for greater discrimination. Four additional special levels: S-1, S-2, S-3 and S-4, are given in the same table and may be used where relatively small sample sizes are necessary and large sampling risks can or must be tolerated.

NOTE: In the designation of inspection levels S-1 to S-4, care must be exercised to avoid AQLs inconsistent with these inspection levels.

- 9.3 CODE LETTERS. Sample sizes are designated by code letters. Table I shall be used to find the applicable code letter for the particular lot or batch size and the prescribed inspection level.
- 9.4 OBTAINING SAMPLING PLAN. The AQL and the code letter shall be used to ob-

tain the sampling plan from Tables II. III or IV. When no sampling plan is available for a given combination of AQL and code letter. the tables direct the user to a different letter. The sample size to be used is given by the new code letter not by the original letter. If this procedure leads to different sample sizes for different classes of defects, the code letter corresponding to the largest sample size derived may be used for all classes of defects when designated or approved by the responsible authority. As an alternative to a single sampling plan with an acceptance number of 0, the plan with an acceptance number of 1 with its correspondingly larger sample size for a designated AQL (where available), may be used when designated or approved by the responsible authority.

9.5 TYPES OF SAMPLING PLANS. Three types of sampling plans: Single, Double and Multiple, are given in Tables II, III and IV, respectively. When several types of plans are available for a given AQL and code letter, any one may be used. A decision as to type of plan, either single, double, or multiple, when available for a given AQL and code letter, will usually be based upon the comparison between the administrative difficulty and the average sample sizes of the available plans. The average sample size of multiple plans is less than for double (except in the case corresponding to single acceptance number 1) and both of these are always less than a single sample size. Usually the administrative difficulty for single sampling and the cost per unit of the sample are less than for double or multiple.

### 10. DETERMINATION OF ACCEPTABILITY

- 10.1 PERCENT DEFECTIVE INSPECTION. To determine acceptability of a lot or batch under percent defective inspection, the applicable sampling plan shall be used in accordance with 10.1.1, 10.1:2, 10.1.3, 10.1.4, and 10.1.5.
- 10.1.1 SINGLE SAMPLING PLAN. The number of sample units inspected shall be equal to the sample size given by the plan. If the number of defectives found in the sample is equal to or less than the acceptance number, the lot or batch shall be considered acceptable. If the number of defectives is equal to or greater than the rejection number, the lot or batch shall be rejected.
- 10.1.2 DOUBLE SAMPLING PLAN. The number of sample units inspected shall be equal to the first sample size given by the plan. If the number of defectives found in the first sample is equal to or less than the first acceptance number, the lot or batch shall be considered acceptable. If the number of defectives found in the first sample is equal to or greater than the first rejection number, the lot or batch shall be rejected. If the number of defectives found in the first sample is between the first acceptance and rejection numbers, a second sample of the size given by the plan shall be inspected. The

- number of defectives found in the first and second samples shall be accumulated. If the cumulative number of defectives is equal to or less than the second acceptance number, the lot or batch shall be considered acceptable. If the cumulative number of defectives is equal to or greater than the second rejection number, the lot or batch shall be rejected.
- 10.1.3 MULTIPLE SAMPLE PLAN. Under multiple sampling, the procedure shall be similar to that specified in 10.1.2, except that the number of successive samples required to reach a decision may be more than two.
- 10.1.4 SPECIAL PROCEDURE FOR REDUCED INSPECTION. Under reduced inspection, the sampling procedure may terminate without either acceptance or rejection criteria having been met. In these circumstances, the lot or batch will be considered acceptable, but normal inspection will be reinstated starting with the next lot or batch (see 8.3.4 (b)).
- 10.2 DEFECTS PER HUNDRED UNITS IN-SPECTION. To determine the acceptability of a lot or batch under Defects per Hundred Units inspection, the procedure specified for Percent Defective inspection above shall be used, except that the word "defects" shall be substituted for "defectives."

### 11. SUPPLEMENTARY INFORMATION

11.1 OPERATING CHARACTERISTIC CURVES. The operating characteristic curves for normal inspection, shown in Table X (pages 30-62), indicate the percentage of lots or batches which may be expected to be accepted under the various sampling plans for a given process quality. The curves shown are for single sampling; curves for double

and multiple sampling are matched as closely as practicable. The O. C. curves shown for AQLs greater than 10.0 are based on the Poisson distribution and are applicable for defects per hundred units inspection; those for AQLs of 10.0 or less and sample sizes of 80 or less are based on the binomial distribution and are applicable for percent defec-

### 11. SUPPLEMENTARY INFORMATION (Continued)

tive inspection; those for AQLs of 10.0 or less and sample sizes larger then 80 are based on the Poisson distribution and are applicable either for defects per hundred units inspection, or for percent defective inspection (the Poisson distribution being an adequate approximation to the binomial distribution under these conditions). Tabulated values, corresponding to selected values of probabilities of acceptance (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.

- 11.2 PROCESS AVERAGE. The process average is the average percent defective or average number of defects per hundred units (whichever is applicable) of product submitted by the supplier for original inspection. Original inspection is the first inspection of a particular quantity of product as distinguished from the inspection of product which has been resubmitted after prior rejection.
- 11.3 AVERAGE OUTGOING QUALITY (AOQ). The AOQ is the average quality of outgoing product including all accepted lots or batches, plus all rejected lots or batches after the rejected lots or batches have been effectively 100 percent inspected and all defectives replaced by nondefectives.
- 11.4 AVERAGE OUTGOING QUALITY LIMIT (AOQL). The AOQL is the maximum of the AOQs for all possible incoming qualities for a given acceptance sampling plan. AOQL values are given in Table V-A for each of the single sampling plans for normal inspection and in Table V-B for each of the single sampling plans for tightened inspection.

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

### 11.6 LIMITING QUALITY PROTECTION.

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

TABLE 1—Sample size code letters

								2	(See 9.2 and 9.3)
				Special insp	Special inspection levels		Gene	General inspection levels	
ភ្ម	Lot or batch size	size						La Barrella A. C.	2000
			S-1	S-2	S-3	S-4	_	=	Ħ
2	ţ	æ	V	٧	٧	¥	A	A	В
٥	2	15	4	4	∢	A	4	ω	U
16	2	25	∢	∢	æ	മ	80	U	۵
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At the Acceptance number.

Re # Rejection number.

SINGLE NORMAL

TABLE II-5 --- Single sampling plans for tightened inspection (Master table)

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 Me The Resistance number.
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Re m. Rejection number.

The m. If the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but ministers normal inspection (see 10.1.4).

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

(See 9.4 and 9.5)

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DOUBLE NORMAL

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

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Lise first sampling plan above arrow.

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Re ass Rejection number

as Use corresponding single sampling plan

Use corresponding single sampling plan (or, alternatively, use woode sampling plan telow, where available).

(See 9.4 and 9.5)

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

(See 9.4 and 9.5)

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

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MULTIPLE NORMAL

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

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

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(See 9.4 and 9.5)

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

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

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

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

(See 11.4)

3	Sample										¥	ccepta	Acceptable Quality Level	ality L	evel												
Letter		0.010	0.015	0.015 0.025 0.040 0.	0.040	88	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	0.4	6.5	10	15	83	3	65	138	150 2	250 40	8	650	9001
*	2										<del>                                     </del>	<u> </u>		<b> </b>	-	99		<del>                                     </del>	23	8	1 1 1	160	220	330 47	470 7	8	8
60	m					~									12			83	\$	1 9	110	- <del></del>	220 3	310 45	- 26	82	100
ပ	ī.V													4.5			-	27	e e	83	8	130	86	¥ 82	630	98	
٥		<del></del>				•							<u>+</u>			<u>-</u>	12	72	9	8	8	88	180 2	270 4	614	1	
ᇤ	13											99			9		15	24	34	8		110 1	170 2	250	—		
Œ	ន										89			4.2	6.9	. 6 7.	76	23	8	<u> </u>	73		- <del></del>	·			
o	32	T								- 2			 	£	1.9	6,	=	12	├-	3	Ī						
I	ጽ								0.74			2.1	2.7	3.9	6.3	9.0	13	61	8)	<u></u>							
_	8							0.46			1.1	1.7	2.4	4.0	5.6	8.2	12	18	<del></del>			·					
×	125	·				•	67.0		·	19.0	1.1	1.6	2.5	3.6	5.2	7.5	12		·····								
د	800					0.18			0.42	69'0	0.97	9.	2.2	3.3	4.7	<del>د</del> .											
X	315				0.12	···		0.27	0.44	0.62	1.00	1.4	2.1	3.0	4.7										· · · -		
z	8,	·		0.074			0.17	0.27	0.39	0.63	8.0	1.3	1.9	2.9								······					
۵	<b>8</b>		0.046			0.11	0.17	0.24	0.40	9.56	0.82	5.	1.8														
0	1250	0.029			0.067	0.11	0.16	0.25	98.0	0.52	0.75	1.2															
	0000		·	0.042	0 042 0 059 0	780	0.16	0.22	0.33	7.9	0.73												~ <b>~</b> ~~~				
<u>-</u>			-2																								

AOQL NORMAL Notes For the exact AOQL, the above values must be multiplied by ( 1 - Sample aire )

( 840 11.4 )

22

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

(See 11.4)

8 8 900 8333 3 **3** ÷ 8 8 景 262 3 3 Ŋ 3 3 353 3 8 X 2 3 8 ള 2 2 3 3 3 3 2 K **3 2** 3 3 8 K K KI KN **3 R** X 2 2 2 = = 3 3 23 5 6 **9**, 11 11 9.7 9 6.3 6.4 3 2 6.9 4.6 Acceptable Quality Level **7** 4 6 6 6 6 1 0 6 1 0 6 \*. 0 9. 2.4 2 2 2 2 2.5 2.5 55 1.6 1.6 9:1 2.8 ? o \$ \$ 1.60 2 9 Ι. 0.65 0.67 0.69 0.62 5 3 3 5 0 5 0 0.62 :: K 9 1 3. 2 3.0 3.0 X3 0.77 1 % N 0.15 0.17 0.13 82 0.097 0.10 9.E 0.18 0.067 590.0 0.065 920.0 960 0.042 0.025 Z0 0 8 0.015 60.0 0.030 0.038 Sample sixa 04 FM VI • 28 **388** 3 8 S 8 8 8 8 2002 jegie, **∢ n** ∪ G 43 LL z 4 0

Note: For the exact AOQL, the above values must be juidplied by ( 1 - Sample size )

AOQL TIGHTENED

TABLE VI-A—Limiting Quality (in percent defective) for which P<sub>a</sub> = 10 Percent (for Normal Inspection, Single sampling)

	_			6		
L o		N 4 4	****	~		
6.5	8	<b>4 % %</b>	2 2 2	92 73		
4.0	x	2 4	20 81 81	12 10 9.0		
2.5	37	81	16 13 11	9.4 7.7 6.4	e n	
1.5		ស	12 10 8.2	5.9	5. <b>1</b>	
1.0		91	7.6	5.4 4.6 7.9	2.5	
0.65		=	4.8	3.3	1.9	*
64.0		<u></u>	6.9	2.7	1.5	1.0
0.25			5.4	2.0	27 28.0	0.77
0.15			2.8	1.2	0.74 0.74	<b>\$</b>
0.10				& <b>%</b> ~	0.67	0.46
0.065				7.7	0.40	0.33
0.040				0.73	0.31	0.27
0.025				4	<u> </u>	0.20
0.015					62.0	
					9.18	
	ими	* C &	2	21 8 21 8 21 8	£ & £	2000
	<b>∢ B</b> ∪	оыь	O # -	× 7 × 5	c a 2	α
	0.040 0.065 0.10 0.15 0.25 0.40 0.65 1.0 1.5 2.5 4.0	2 0.010 0.015 0.025 0.040 0.065 0.10 0.15 0.25 0.40 0.665 1.0 1.5 2.5 4.0 6.5 3	2 0.010 0.015 0.025 0.040 0.085 0.10 0.15 0.25 0.40 0.65 1.0 1.5 2.5 4.0 6.5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5	2 0.010 0.015 0.025 0.040 0.065 0.10 0.15 0.25 0.40 0.65 1.0 1.5 2.5 4.0 6.5 3 1	2 0.010 0.015 0.025 0.040 0.065 0.10 0.15 0.25 0.40 0.65 1.0 1.5 2.5 4.0 6.5 1.0 1.5 2.5 4.0 6.5 1.0 1.5 2.5 4.0 6.5 1.0 1.5 2.5 4.0 6.5 1.0 1.5 2.5 4.0 6.5 1.0 1.5 2.5 4.0 6.5 1.0 1.5 2.5 4.0 6.5 1.0 1.5 2.5 2.5 4.0 6.5 1.0 1.5 2.5 2.5 2.5 2.5 2.5 2.5 2.5 2.5 2.5 2	2

LQ (DEFECTIVES) 10.0%

TABLE VI-B—Limiting Quality (in defects per hundred units) for which P<sub>a</sub> = 10 Porcons (for Normal Inspection, Single sampling)

(966 11.0)	8	0 <u>0</u> 61	1800		-	*******	**************************************	Consuma e e e	· ·	- Se ser page.	· · · · · · · · · · · · · · · · · · ·	and the same of th	Maria Chianger		-	ange <del>raa <u>a</u></del>	
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	3	23	220	8	8	8	8	28									
	x	82	180	8	120	8	2	3	38								<u>-</u>
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	01			78	<b>%</b>	S	8	85	ਲ	ĸ	-	3			<u>_</u>		
3	6.5	83			6\$	4	ಜ	8	র	10	1	2 :	-t		<del></del> -	~	**************************************
Acceptable Quality Lavel	0.4		4			98	23	21	61	15	1:	: 5	9.0	T		Meradadada sasang	
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	0.40						<del> </del>	7.2			~	2.7	7	0		1.2	9 9
	0.25			-v					4.5			2.0	1.7	<u></u>	- 2	3.0	0.77
	0.15									5.9			ç,	T =	25	0.74	0.59
	0.10										œ.			0.79			38
	0.065									e en un		2.7	-		64.0		0.33
	0.040		<u></u>		**************************************		****	THE REAL PROPERTY.	TO THE STATE OF TH	<u></u>	***************************************		0.73	T		<u>6.3</u>	0.27
	0.025				Evian, my car.		·	V	**************************************		************			9,0			8.
	0.015													<del>, ,</del>	8.		0
	0.010 0.015 0.025 0.040 0.065 0.10			·						-			~ TEX E		ø	0.18	
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LQ (DEFECTS)
10%

(See 11.6)

							<del></del>	<del></del>					·	<del></del>				1
ECT	Code	Sample						Acceptal	ole Quali	ty Level	ļ							
DEFECTIVES)	letter	șize	0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10
	A	2															78	
	В	3														63		
	С	5							i		· 				45			66
	D	8												31			47	60
	E	13											21			32	41	50
	F	20										14			22	28	34	46
26	G	32									8.9			14	18	23	30	37
	Н	50	}							5.8			9.1	12	15	2C	25	32
	J	80							3.7		ļ	5.8	7.7	9.4	13	16	20	26
	К	125	1					2.4			3.8	5.0	6.2	8.4	11	14	18	24
	L	200					1.5			2.4	3.2	3.9	5.3	6.6	8.5	11	15	
	М	315			<u> </u>	0.95			1.5	2.0	2.5	3.3	4.2	5.4	7.0	9.6		
	N	500		1	0.60			0.95	1.3	1.6	2.1	2.6	3.4	4.4	6.1			
	P	800	ĺ	0.38			0.59	0.79	0.97	1.3	1.6	2.1	2.7	3.8				
	Q	1250	0.24			0.38	0.50	0.62	0.84	1.1	1.4	1.8	2.4					
	R	2000			0.24	0.32	0.39	0.53	0.66	0.85	1.1	1.5						

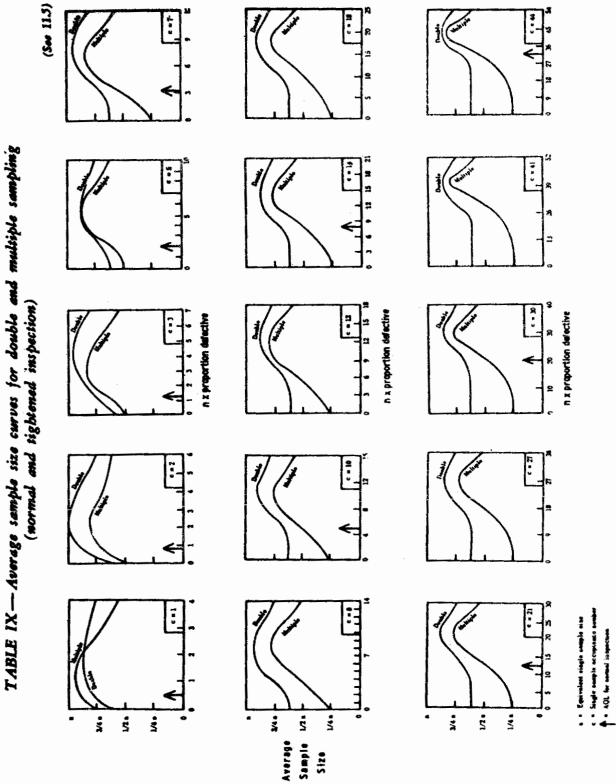
TABLE VII-B—Limiting Quality (in defects per hundred units) for which  $P_a = 5$  Percent (for Normal Inspection, Single sampling)

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(See 11.6)		650 10	1500	1400 1900	1100	<u> </u>	*****					~ <u>-</u>							
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		100	530 6	5	340	270 3	230 3												,
		65 1	380	350 4	260 3	210 2	170 2	35.	]	, <del></del>		·			<del></del>				<del></del>
1		0\$	320	260 3	210 2	160	138	110 11	95	۰	<del></del>					·			
			240 3	210 2	160	8	82	85	38		· ·			·	·-··				
		5 25	22	180	130 16	97	83 10	-8	53 6	<b>44</b>	 88	I -							
		10 15	-						ļ	<b>,</b>		-				· <u>-</u>			
			150		ол ———	59 79		53	3 41	26 34	1 27	18 24						· · · · · · ·	
-		0 6.5	=					33	8		23			9.6				·	
	-i	5.0		-E		F	E.	32	24	23	97	*	=======================================		-				
Table Street	Acceptable Quality Level	5 2.5			3		·	*	8	16	7 13	7	8.5	7.0	6.1	മാ			
	Queli	5:			<del></del>	89			13	13	7.6	8.4	3 6.6	2 5.4	3		·•	<del>, -</del> -	
-	pteble	5 1.0					23		T	5.6	5.7	6.2	5.3	<b>→</b>	5	2.7	2.4		
, Total	Acce	0 0.65	<b>-</b>			**********		n.	<u> </u>		rz.	5.0	3.9	3.3	2.8	2.1			<u> </u>
		0.40					·	~	4.6			3.8	3.2	2.5	2.1	1.6	<del></del>		,,,,
		0.25								0.0		<sub>g</sub>	2.4	2.0	1.6				0.85
		0.15						er sesse .	The Estate Science		3,8	l i			<u> </u>	0.97	<b>ॐ</b> ं		.0. 28.
		0.10				··	· • • • • • • • • • • • • • • • • • • •				<b></b>	2.4			0.95	0.79	0.62		0.53
and the second of the second		0.065									Je.,		1/3			0.59	35.0		6.3
The Constitution of Street, St		0.040												0.95			88		0.32
A		0.025													S6 5				0.24
		0.010 0.015 0.025 0.040 0.065														0.38			
and a second		0.010												.,			0.24		
Policy (Company)	Sample	3776	63	~	S	œ	13	8	32	B	88	135	200	315	500	800	35		2000
	Code	Parks a	*	ac	U	۵	LLi	ia.	<u>ت</u>	æ	Ţ	i.e	نبر	×	z	a,	¢		ï

LQ (DEFECTS) 5%

Number of												Ao	c <del>optable</del> 1	Quality	Level											
acupte units from last 10 lots or betches	0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	i.S	2.5	4.0	6.5	10	15	25	40	45	100	150	250	400	650	1000
20 - 29 30 - 49 50 - 79	:	:	:	:	:	:	:	•	A CANADA	•	•	:	:	:	٠	0 0 2	0 1 3	2 3 7	4 7 14	13 25	14 22 40	22 36 43	40 63 110	48 185 181	115 178 301	181 277
80 - 129 130 - 199 200 - 319	:				:	:		:		:			0 0 2	0 2 4	4	4 7 14	7 13 22	14 25 40	24 42 68	42 72 115	115 181	105 177 277	181 301 471	297 490		
320 - 499 500 - 799 800 - 1249	1:	:	:							0 2	0 2	3 7	4 7 14	8 14 24	14 25 42	24 40 48	39 63 105	60 110 101	113 181	189						
1250 - 1999 2000 - 3149 3150 - 1999	:	:	:	:		. 0	0	0 2 4	2 4 8	4 8 14	7 14 24	13 22 30	24 40 67	40 44 111	69 115 186	101	169									
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20000 - 31499 31500 - 49999 50000 & Over	000	0 1 3	2 4 7	4 8 14	14 25	14 24 40	22 38 63	40 67 110	46 111 181	115 186 301	161															

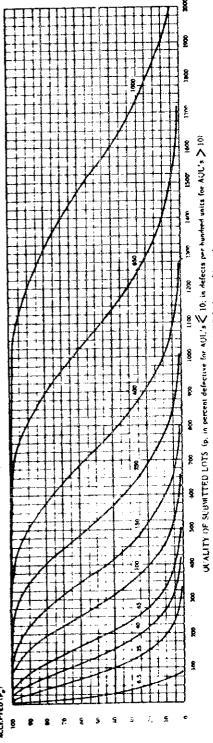
Denotes that the number of sample units from the last ten lots or batches is not sufficient for reduced inspection for this AQL. In this instance once then ten lots or batches may be used for the colorisation, provided that the lots or batches under or the most recent each is sequence, that they have all been us normal inspection, and that some has been rejected while on original inspection.



AVERAGE SAMPLE SIZE

CHART A - OPERATING CHARACTERISTIC CURVES FOR SANGLE SAMPLING PLANS

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



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

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

			And the Control of th	THE PARTY AND PERSONS ASSESSED.		A									-
					Acceptab	le Ocality	Levels (nor	Acceptable ()eality Levels (normal inspection)	(non)		A PROPERTY OF THE PERSON OF TH	And any Company of the Control of th	Character Control of C		
۵.	6.5	6.5	X	ş	\$9	8	85	Χ	250	Χ	ŝ	X	<b>3</b> 8	X	000
· 	n (in normal defective)		A THE PROPERTY OF THE PERSON	ALTERNATION OF THE PARTY OF THE	A CONTRACTOR OF THE PROPERTY.	Approximately and the second of the second o	) a	p (in defects per hundred units)	r hundred w	nits)	!   				
٤	0.50	150	7.45	21.8	41.2	89.2	145	175	239	305	374	517	629	929	716
	na de la companya del companya de la companya del companya de la c	2.56	B. 1.1	609	£8.3	131	199	252	\$	3	£62	622	345	\$66	1122
2 2	- Service	76.3	*	1.87	57.3	8	273	272	351	25	\$15	A COLUMNIA CONTRACTOR	812	1973	333
2 4	en elektrische der der der der der der der der der de	16.4	3	<b>38</b>	127	211	88.2	342	183	521	612	795	934	1314	1354
Š	error of the state	medanasara remajir empahr	83.9	134	184	284	383	433	533	633	23.	933	1083	1383	1533
200	( 155	60.3	135	8	355	37.1	*8*	95	159	192	870	1087	1248	1568	1728
	T BY		35	388	338	*5*	289	959	770	&8 8	1006	1238	(40)	174R	1916
5 6	97.7	81	787	315	3895	526	657	727	98	272	1001	1334	1512	1862	3038
0	0.06	230	332	629	205	\$\$9	900	870	1007	1141	1272	1529	1718	2088	2270
	X	X	07	65	100	SS.	X	250	X	400	Χ	089	Χ	1000	Χ
			, martin	A	Acceptu	able Quality	y Levels (ti	Acceptable Quality Levels (tightened inspection)	spection)						

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

is a	Commo-			and a respective state.			ļ	Accepts	ible Qual	Acceptable Quality Levels (soresal inspection)	s (sorms)	ibspecti	Î		ATTACON TO THE LANGEST			#		Č
payling sales	sample size	Lass them 6.5	6.5	X	2	53	Ŋ	3	3	86:	83	X	82	X	8	X	(339	X	.000	lative seeple
	, , , , , , , , , , , , , , , , , , ,	Ac Re	Ac Re	Ne Ac Ne	Re Ac Ne	AC Re	3	β. 34. 34.	Ac Re	ည့	Re Ac Re	Re Ac Re Ac	4	Ac Re	Ac Re	Ac Ne Ac	*	2	\$. 3. 3.	
Siego.	ez.	Þ		***	p.		64 .~	es	w.	<b>40</b> 1/2	en t	6	10 11	12 13	\$2		8	8 5	33	7
Domble		Þ	•	į į			•	( • )	· ·	( <b>( )</b>	<b>E</b>	£	ε	<b>(</b> )	ε	•	e e	3	€	Here were the second
<b>S</b> ettiple		٥		3	,	9	•		•	•	•	•	•	•	•	•	. •	•	•	Ann Canada and Canada
	3	Leas than	X	01	55	×	3	3		S <sub>2</sub>	X	S	Χ	- / \ 8	X	SS	X	1,000	TX	Carrier (Constitution)
	لـــــ				- Constitution Pro-		Y	cceptable	Ouglity	Acceptable Quality Levels (tightened inapection)	Eightenad	inapectio	A)		CONTRACTOR					

Use next subsequent sample size code letter for which acceptince and rejection numbers are available.
Acceptance number
Nepection number
Use single sampling plan above for alternatively use letter D).
Lise suggle sampling for alternatively use letter B).

3.140

CHART B - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

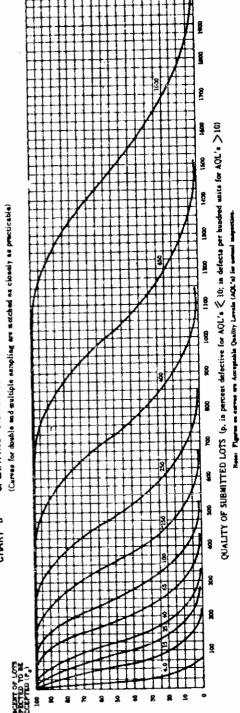


TABLE X-B-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					-												
						Acce	Acceptable Quality Levels (normal inspection)	lity Levels	i (normal is	spection)							
Ď.	0.4	0.4	2	X	\$	a	100	X	150.	Χ	952	Χ	9	X	ş	X	8
•	(in passent defective)				-			ai) d	defects per	p (in defects per hundred units)	oits)						
				1	2	505	8	117	159	283	546	ž	419	573	153	136	1029
0.66	0.33	3.0	Š			3		:	2	ž	a.	415	Ş	583	248	1065	2311
8	1.20	7	8:1	23.33	\$5.5	87.1	3	15/	88	83		2					200
	3 46	5	17.7	188	88	18	155	181	234	288	2	35	3	316	Š	E	
3	3,			1	1	5	8	378	287	347	90\$	SS	23	\$	8	1249	7
75.0	9.14	8	32.0	0.70	ŝ	2					T		1	5	.00	1300	7.80
٤	4 %	73.1	55.9	<b>8</b> 2	122	189	ğ	88	28	8	8	3	77.	2	701	â	
3	2.03				4	,	202	ş	Ş	295	38	*2.	832	30,66	1152		<u>\$</u>
22.0	37.0	58.2	86	3	2		Call.	3				,50	0.00	371		1,683	703
0 01	53.6	76.8	38	T.I	ដ	8	392	3	514	<u> </u>	671	g	ŝ	3			
		8	2	210	82	355	83		38	<b>3</b>	8	86	800	1241	33	1773	8
2	65.4		3			1	:	8	22.9	192	3	1019	1165	1392	1513	1981	2069
0.7	78.4	7	នី	36	csc	ž	3						]		)		
	6.5	6.5	ห	ş	ક	100	Χ	351	X	9 <u>2</u>	X	600	X	8	X	3	$\langle$
		**				1	centable 0	selity Lev	ela (tighter	Acceptable Osality Levels (tightened inspection)	(soe)						
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and the state of the second defective communications; Poinness for defects per hundred with

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

	Cumu-									Acce	ptable Q	uality L	evels (i	oomal i	**pecțio	e)						Cara
Type of sampling plan	lative sample	Less than 4.0	4.0	6.5	$\times$	10	15	25	40	65	100	$\times$	150	$\times$	250	$\times$	400	$\times$	650	$\times$	1000	letiv
<b>,</b>	size	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac P	e Ac F	e Ac R	e Ac F	eAc Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	size
Single	3	▽	0 1	Use	Use	Use	1 2	2 :	3 3	5 6	7 8	8 9	10 11	12 13	14 15	18 19	21 22	27 28	30 31	41 42	44 45	3
Double	2	▽	•		Letter		0 2		7		3 7	l	5 9 12 13		i	l	İ	1		23 29 52 53	1	1
				A	D	С																
fultiple		▽	•					++	++	++	**	**	**	**	**	**	++	++	**	++	++-	
	· <u> </u>	Less than	6.5	×	10	15	25	40	65	100	×	150	×	250	<b>&gt;</b> <	400	×	650	×	1000	×	
		<u> </u>			·			-						d inspec			<u> </u>		<b></b>	·		

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

Ac = Acceptance number

le = Rejection number

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

**33** 

💝 - 😑 Use double sampling plan above (or alternatively use letter D).

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

CHART C - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS (Curres for double and multiple sampling are matched as clobely as practicable)

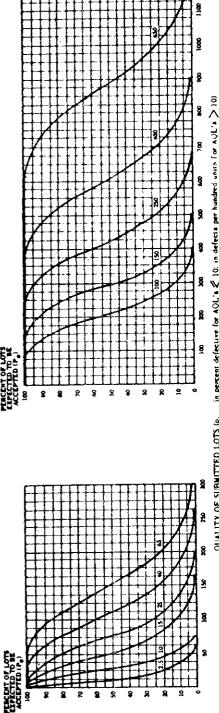


TABLE X-C-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

							Acceptabl	e Quality 1	Acceptable Quality Levels (normal inspection)	mai inspec	tion)							
۲.	2.5	10	2.5	10	15	Ŋ	0#	\$3	X	8	X	જ	X	0\$2	X	00\$	X	953
	p (in percen	p (in percent defective)							p (in 6	lefects per	p (in defects per hundred units)	lits)				4		
8.	0.20	3.28	6.20	2.89	8.72	16.5	35.7	38	70.1	\$¢	122	051	8	Ñ	ž	391	33	618
95.0	1.02	7.63	1.03	7.10	16.4	27.3	52.3	79.6	93.9	123	154	58	249	ž.	398	\$	3	169
8	2.09	11.2	2.10	10.6	22.0	34.9	63.0	93.1	660	140	173	336	273	325	83,	482	679	733
75.0	5.59	19.4	5.76	19.2	35.5	5.3	94.4	119	13.7	172	308	245	318	374	<b>3</b>	25.2	692	908
80.0	12.9	31.4	13.9	33.6	s S	73.4	113	153	173	21.3	253	83	373	£3	553	613		993
Š	28.2	3.53	27.7	53.9	3.0	102	831	<b>≯</b> 61	216	260	304	346	435	85	627	68	923	238
10.0	88.9	\$.B2		77.8	8	\$1.1	186	235	260	308	æ	£03	495	<b>*</b>	669	\$8	1010	9201
5.0	\$5.1	8.29	59.9	3	128	155	210	263	286	336	389	85	534	\$08	245	814	307	1131
1.0	60.2	77.8	92.1	133	98 88		262	330	87.	\$03	3	85	612	38	835	3	12.1	1241
	0.4	X	6.4	15	×	0#	\$9	Χ	82	Χ	55	X	220	X	007	X	33	X
			A:				Accept	able Quatin	Acceptable Quality Levels (tightened inspection)	ightened ii	hspection)							
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TABLE X-C-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: C

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-	X			ត ខ	<b>‡</b>	3	
	8		9		<b>†</b>	X	
	X			8 8 8 7 17		8	
	Ñ	4	12 22	2 5	<b>‡</b>	X	
	X	9 4 6	61 81	2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	<b>†</b>	8	
	8			11 61	‡	X	ê
	Χ	4		10 7	<b>‡</b>	OSI	Acceptable Quality Levels (tightened inspection)
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Type of	Sound in grant		3	į	a di la		

Use sest subsequent sample size code letter for which acceptance and rejection sembers are available.

Acceptance number.

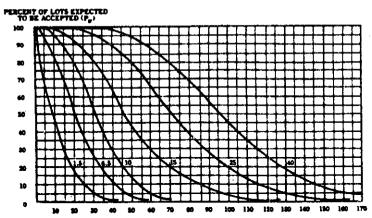
Rejection number. 

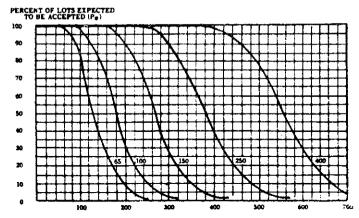
Use single sampling plan above (or shamatively use letter F), Use double sampling plan above (or alternatively ass letter D),

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

### CHART D - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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





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

Hotel: Figure on ourses are Acceptable Quality Levels (AQL's) for normal impaction.

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

							Ac	ceptable ()	unlity Love	is (normal is	epection)								
P.	1.5	6.5	10	1.5	6.5	10	15	25	40	×	65	$\times$	100	X	150	X	250	$\times$	400
•	p (in p	ercent def	ective)		\	,-				p (in de	elects per	hundred u	nits)						
99.0	0.13	2.00	6.00	0.13	1.86	5.45	10.3	22.3	36.3	43.8	59.6	76.2	93.5	129	157	215	244	355	386
95.0	0.64	2.64	11.1	0.64	4.44	10.2	17.1	32.7	49.8	58.7	77.1	96.1	116	156	186	249	281	399	432
90.0	1.31	6.88	14.7	1.31	6.65	13.8	21.8	39.4	58.2	67.9	87.8	108	129	171	203	268	301	424	458
75.0	3.53	12.1	22.1	3.60	12.0	21.6	31.7	52.7	74.5	85.5	108	130	153	199	234	303	339	468	504
50.0	8.30	20.1	32.1	8.66	21.0	33.4	45.9	70.9	95.9	108	133	158	183	233	<b>271</b>	346	383	521	558
25.0	15.9	30.3	43.3	17.3	33.7	49.0	53.9	92.8	121	135	163	190	216	272	312	392	432	577	617
10.0	25.0	40.6	\$3.9	28.8	48.6	66.5	83.5	116	147	162	193	222	252	309	352	437	478	631	672
\$:0	31.2	47.1	59.9	37.5	59.3	78.7	96.9	131	164	180	212	243	274	334	378	465	509	665	707
1.0	43.8	58.8	70.7	57.6	83.0	105	126	164	200	218	252	285	318	382	429	522	568	732	776
	2.5	10	X	2.5	10	15	25	40	X	65	X	100	X	150	$\times$	250	$\times$	400	$\sim$
	<b> </b>	<u> </u>	- `		A	<u> </u>	<u> </u>	Accepted	de Quality	Levels (ti	cheesed is	spection i	<del> </del>					•	<del></del>

x

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

	1									Acce	appraph	Acceptable Quality Levels (novnat inspection)	<u>ځ</u>	alar 1)	30mm	ged 1	ection	•											
Type of Land	Lective Lemple	Leve these	1.5	2.5	X	\$	0 6.5	<del> </del>	2	2	KI	\$	$\vdash$	Y	8		1	8	IX	3	14	X	ង			8	138		-
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	<b>&amp;</b>	>	0	-			Tank	2 2	M	3	2 6	~	60 60	•	11 01	12	13 14	22	18 19	-2	g g	8	1	=	2	2 3	◁	80	ı
Dertie	\$ 01	D	•		tool	2 2	C -	N N	2 3	·* vs	2 5	rs 60	7 3	- 21	5 9	۶ × ۲۵	16 18	== 81	2 2 11	= 8	8 F	8 %	17 22 37 38	<u> </u>	8 · 3	% % % Ø	٥	v g	E .
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	10					·		3	♣ ***	<b>v</b> 0	SC SC	<u>~</u>		- 12	11 15	ž	17 71	8	22 23	ĸ	8	25	×	<u>\$</u>	8	33 38		2	
	12					<del></del>		<u></u>	×	•	7	2	12 112	Ξ	14 17	82	<u> </u>	ន	8	품	- <del>8</del>	3	8 2	<del>- 2</del>	3	88		12	
	*				····		~	<b>→</b>		P	6 10	2	*	- 52	18 19	2	22	*	22	3	<b>9</b> 8	\$	3	7	E	72		<b>*</b>	
		Z 5	2.5	X	0,	6.5	2	<u> </u>	53	ĸ	9	X	1	8	X	901		X	<u>95</u>	$\Lambda$	V	22	X	*	8	IX	1 8 1 8		
										To so	S) alga	Acceptable Quality Lavels (tightened inspection)	3	1	# Fe Be	d in d	ket io	ê										<del></del> -	
	•		Total September 1			distance of the last			Section 1	STATE OF STREET	ACAD STATES		1					ŀ			I							7	

Use ment preceding sample size code letter for which acceptance and rejection numbers are available. . . & & < C

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

Acceptance number

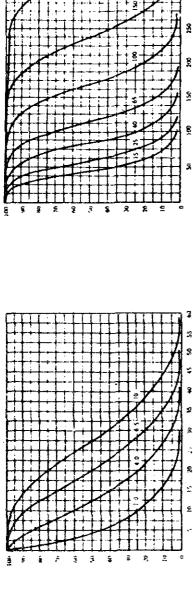
Rejection number

Use single sampling plan above for alternatively use letter GJ. Acceptance not permitted at this sample size.

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

# CHART E . OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Furvex for doubly and multiply sampling are matched as closely as practicable)



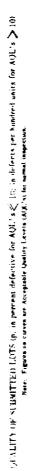


TABLE X-E-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

		**************************************						Acreptabl	* Quality	Levels (n	Acceptable Quality Levels (normal inspection)	section)								
a. <b>"</b>	9.1	17-1	11.5	2	B.1	07	6.5	91	SI	×J	X	94	X	જ	Χ	(6) !	Χ	33	X	25ú
	]	y tin parties defectives	e defective	-		de commence de la com		-			) ti	lefects pe	y (in defects per hundred units)	units)						
0.64)	120.0	57.	1.5.	(%)	0.078	- 15	3.35	6.13	13.3	83.5	27.0	76.7	6.64	57.5	19.0	7.96	132	8	219	2.45
5.0	£	18.7	1.6.5	~	24.15	27.5	67.0	10.5	1.0%	30.6	-1 93	47.5	54.2	7.1.	5	115	153	173	74€	ga <sub>2</sub> -
12,1%	13,847	4.18	×	19.4	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	40.8	N. 8.8	\$.5.	14.2	35.8	×:	0.12	\$. 5.5	79.2	105	ž.	<u>;3</u>	<b>38</b>	197	282
25.0	516	1.1	1.1.4	3.3.	77.7	\$5.7	13.5	19.5	32.5	45.8	52.6	£6.3	36.2	3	122	144	187	308	266	017
743.03	61.5	977	38.0	27.5	5.33	671	3.0.5	3.83	13.6	30.0	\$	1.23	97.5	<u>=</u>	इ	891	213	236	ाटा	33.6
25.4	3.1	1%.4	₹.	S. 48	10.7	202	30.2	39.3	57.1	74.5	. Q	8	137	4.1	152	761	24.1	565	355	379
10.0	15.3	3.6.8	9.6.0	\$.0.6	17.7	が大	6.04	51.4	21.3	38.	3	611	137	\$3	3	23.7	588	35	388	414
5.0	9.8	31.6	9.16	5.64	23.0	36.5	7.0	59.0	80.9	101	111	130	353	20	302	233	38	313	*O*	435
=:	20 8.	5.14	50.0	2.3	£.7.	2.12	7. \$	77.3	101	121	*	155	9,1	951	336	264	321	349	550	477
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TABLE X-E-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER; E

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own and stated	3.3	*	Þ	Þ									323	
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s se next preceding temple sine code letter for which incompliance and rejection numbers are available. Use next sebonguest sample sine code letter for which acceptance and rejection numbers are available.

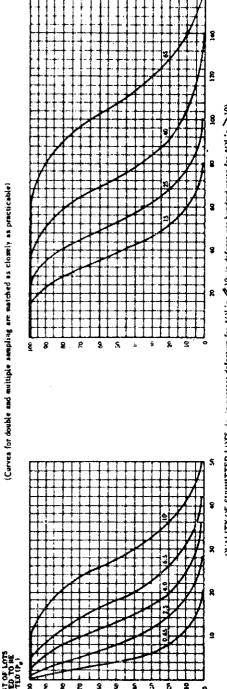
Acceptance number. ODEE,.

Rejection sumber.

Use single associang plan above (or alternatively too letter M).

Acceptance not permitted at this sumple size.

CHART F - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



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

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

							Accep	table Qualit	Acceptable Quality Levels (normal taspection)	ornal inspe	ction)				,		
ď	0.65	2.5	6.9	6.5	10	0.65	2.5	6.0	6.5	91	15	X	8	X	Ş	Χ	92
		a (ia	p (in percent defect	ctive)						p (is	defects pe	p (in defects per hundred units)	mits)				
8.0	0.050	0.7S	2.2	4.31	9.75	0.051	0.75	2.18	4.12	8.92	14.5	17.5	23.9	30.5	37.4 .	51.7	62.9
95.0	0.256	1.80	4.22	7.13	14.0	0.257	1.78	4.09	6.83	13.1	19.9	23.5	30.8	38.5	46.2	62.2	74.5
0.08	0.525	2.69	5.64	9.03	16.6	0.527	2.66	5.51	8.73	15.8	23.3	27.2	35.1	43.2	51.5	<b>3</b> 8	81.2
25.0	1.43	18.4	8.70	12.8	21.6	1.44	4.81	8.68	12.7	21.1	29.8	34.2	43.1	52.1	61.2	20.5	93.4
20.0	3.41	8.25	13.1	18.1	27.9	3.47	8.39	13.4	18.4	28.4	38.3	43.3	53.3	63.3	73.3	93.3	85
22.0	6.70	12.9	18.7	24.2	8.3	6.93	13.5	19.6	25.5	37.1	4.8.4	0.75	65.1	76.1	87.0	109	123
10.0	10.9	18.1	24.5	30.4	41.5	11.5	19.5	26.6	33.4	4.6.4	58.9	65.0	77.0	6.38	101	124	141
5.0	13.9	21.6	28.3	4.8	45.6	15.0	7.82	31.5	38.8	52.6	65.7	72.2	84.8	97.2	109	133	151
1.0	30.6	88.9	32.6	42.0	53.4	23.0	33.2	42.0	50.2	66.5	90.0	67.0	101	114	12.	153	172
	1.0	4.0	6.5	01	X	3.0	4.0	6.5	01	15	Χ	ช	Χ	\$	Χ	38	Χ
							Aco	sptable Ose	Acceptable Quality Levels (tightened inspection)	(Tightened)	inspection)						

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

Type of	Cumit							*	ccepts	ole Q	ality L	evels (	Acceptable Quality Levels (normal inspection)	iospeci	(wo										
sempling plea	sample	0.65 8.65	0.65	1.0	X	1.5	2.5	-	0.	9	, s	2	53		X	X		$ \rangle$	=	-			-		Come
	1	¥c	Re Ac Re	Re Ac Re	Ac Be	¥ .	٤		1			1		+					_	+		\$	_		semple
			•					2		١	¥ V	<u>د</u>	¥	<b>8</b> <b>≻</b>	2	¥	Re A	Ac Re	٧c	Re	Ac Re	¥c	R	يغ	325
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	:			3	<b>3</b>	- C		+			+						+			+					
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	S	D	•					*	7	-	<del>*</del> ۳	•	•	•	•	0	~ ~	•	-		œ	~		<	
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	x						~	3	•	m	9	80	7	-	2	=======================================					3 K		7 8		8
	R						3	~	S		- 9	•	97	12 12	=	<u>.</u>	17 18	8							g .
	×						6 6	*	v		- 6	0.	<u>د</u>	=======================================		81	19 21						3 %		8 x
		1 4 0 1 0	9_	X	2.1	2.5	ç	L.	S.	01	ļ_	2	X	a	+	X		3	X	1°	a s	X	Higher	   <u> </u> <u> </u> <u> </u> <u> </u>	7
								Acc	eptapl	8	i, 1,	1 1	Acceptable Quality Levels (tightened inspection)	in pe	1,00		-			-			9		
	]									į					,									_	

Use nest proceding sample size code letter for which acceptance an . rejection numbers are available. Use nest subsequent sample size code letter for which acceptance and rejection numbers are available. # # # # # # # # A D & # . .

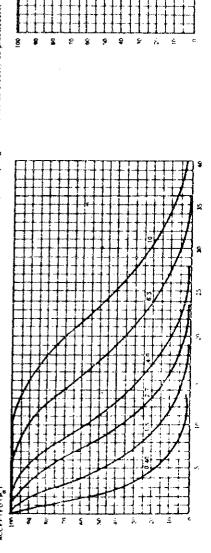
Acceptance aumber

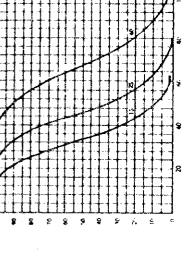
Rejection number

L.ne single sampling plan above (or alternatively use letter J). Acceptance not permitted at this sample size.

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

CHART 6 - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS
(Curve for Southe and multiple ampling are matched as closely as practicable)





CITALETA QF SI RHIFFEN LOFS (p. — in percent defective for ISL'S < 10; in defects per hundred units for AQL'S > 10).
Note: Figures on curves are Acceptable Challet Lavels (AQL'S) for normal inspection.

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

							Ace	Ceptable ()	uality Lev	Acceptable Quality Levels (normal inspection)	inspection	·						
г. <b>,</b>	ert u	- 15	5.5	4.0	6.5	10	0.40	1.5	2.5	4.0	6.5	02	X	15	X	Ŋ	X	Q.
		٥	p (in percent de	defective)							pi) d	defects per	p (in defects per hundred units)	nis)				
67 <b>9</b> 6	₹£0'0	0.475	1.19	2.63	5.94	9.75	250.0	0.466	1,36	2.57	5.57	90.6	11.9	14.9	161	<b>†</b> C	32.3	39.3
03.0	0.161	1.13	2.30	62.4	9.50	13.1	0.160	1.10	2.55	4.26	8.16	12.4	14.7	19.3	0.34.0	6.82	38.9	46.5
וו טענ	0.329	1.67	3.50	3.56	10.2	18.1	0.328	1.66	3.44	5.45	9.85	14.6	17.0	6,12	0.75	2.38	42.7	50.8
0.57	56K 1	1.03	2.4.2	96'2	13.4	19.0	0.900	3.00	6£.5	767	13.2	18.6	21.4	26.9	32.6	38.5	1'07	\$B.4
50.0	2.13	5.19	8.27	11.4	17.5	23.7	2.16	5.24	8.35	11.5	17.7	24.0	27.3	33.3	39.6	8.5.8	58.3	67.7
25.0	133	01.g	11.9	15.4	22.3	0.62	4.33	8.41	12.3	16.0	23.7	30.3	33.8	40.7	9'27	. 7.35	b'#\$	78.0
10.0	₹.04	911.	15.8	19.7	27.1	34.1	7.19	23	16.6	5.62 1.02	0.02	36.8	40.6	48.1	55.6	90.9	77.4	88.3
8.0	ν v	14.0	18.4	22.5	30.1	37.2	9.36	14.8	19.7	24.2	32.9	41.1	45.1	53.0	8.09	58.4	83.4	94.5
1.9	14.5	19.0	23.7	28.0	35.9	43.3	14.4	20.7	26.3	33.4	61.0	50.0	54.4	63.0	11.3	79.5	9:56	107
	9970	2.5	۴.0	6.5	10	Χ	0.65	2.5	4.0	6.5	10	Χ	15	X	22	X	0.9	X
								Anceptable	. Ounlity L	Acceptable Outlity Levels (tightened inspection)	itened insp	ection						

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

Simple   Fig.   Comparing   Line   Least task   Comparing   Least task   Comparing   Compari	Type of	Current							Accept	Acceptable Quality Levels (normal inspection)	lity Level	l» (nom	al insy	ection)				!				
32	sempling plea	lative sample	Less than 0.40		0.65	X	0.7	1.5	2.5	0.4	5.5	2	+	Y	2	$ \rangle$	H.	<del> </del>			Higher	Cume
32         ∇         0         1         2         2         3         4         5         6         7         8         9         10         11         13         14         15         13         14         15         13         14         15         13         14         15         16         16         17         13         14         15         13         14         15         15         15         15         15         15         15         16         17         13         14         15         15         15         15         16         17         11         16         17         11         16         17         11         16         17         15		<u>:</u>								1		_	+	#		1	+	+	1	3	r da	semble
20 ∇ 0 1  20 ∇ 0 1  30 ∇ 0 1  30 ∇ 0 1  30 ∇ 0 1  30 ∇ 0 1 1 1 2 13 14 15 18 19 12 12 2			í			Ac Re	æ	ı	٧	¥	υŽ	إد		2	- 1	٩c					<b>¥</b>	
20         ∇         Lenner         Lenner         Celler         1         2         6         3         7         3         7         3         7         3         7         3         7         3         7         3         4         1         1         2         3         7         3         7         3         9         10         7         11         16         ∆           20         3         4         5         6         7         3         9         11         15         13         14         16         2         7         14         2         5         7         3         9         11         16         2         7         14         2         6         7         9         11         15         15         16         2         7         14         15         1         6         17         16         2         7         14         16         15         15         15         16         2         7         14         15         16         2         7         14         16         16         16         17         16         17         16         17         16	Single	32	٥						۲۷	m	v					12			í	i	△	<u> </u>
40  • F J H 1 2 3 4 4 5 6 7 8 9 11 12 12 13 15 16 18 19 23 24 26 27  • F J H 2 3 4 4 5 6 7 8 9 11 12 12 13 15 16 18 19 23 24 26 27  16  24  25  • O 2 O 3 I 4 2 5 3 7 3 7 3 9 8 10 12 12 13 15 16 18 19 23 24 26 27  26  27  • O 2 O 3 I 4 2 5 3 7 5 10 6 II 8 13 II 7 13 19  40  40  • O 2 O 3 I 4 2 5 3 7 5 10 6 II 8 13 II 7 13 19  40  40  40  40  40  40  40  40  40  4		1				2	C						$\dashv$	+			-	$\dashv$				;
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16   16   17   18   18   19   19   19   19   19   19		\$			(a	_	=					<b>6</b>				15						99
16  26  27  28  39  30  31  40  40  40  40  40  40  40  40  40  4			Þ	•	<u> </u>	•	τ,		İ	1	1		<del>-</del>		İ					- }		
26 32 40 40 40 40 40 40 40 40 40 40 40 40 40		\$				*****						, 					<del>-</del>				٥	eco
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54  40  46  46  46  46  46  46  47  48  48  48  48  48  48  48  48  48	K																000					34
Less than 0.665       3       6       5       8       7       11       9       12       11       15       14       17       17       20       22       25       29         Less than 0.665       3       6       7       9       10       12       12       14       17       18       19       21       22       25       29       31       33         Dodg       3       6       7       9       10       13       14       15       18       19       21       22       26       32       33       37       39         Purplex       0       6.5       10       5       10       5       10       5       25       25       26       32       33       37       39         Purplex       14       15       16       15       16       15       15       25       25       26       32       33       37       39         10       15       25       25       26       32       33       37       40       20       40		χ.	-		<del></del>				<del>-</del>						~		12					55
Learthan       0.65       1.0       1.5       2.5       4.0       6.5       10       12       12       14       17       18       20       12       22       23       27       29       31       33         0.65       3.0       3.5       4.0       6.5       10       13       14       15       18       19       21       22       25       26       32       33       37       39		3													15		1					
Lear, Mann 0.665       3.06       1.0       1.5       2.3       4.5       6.7       9.10       13.14       14.15       18.19       21.22       25.25       26.32       33.37       39.         0.665       3.06		\$													17							. 9
0.66 X 1.0 1.5 2.5 4.0 6.5 10 X 15 X 25 X 40 X 01 X 02 X 02 X 02 X 02 X 040 X		ж		7-7-14											6.1		ห					g y
// * / / : / /			Leas than 0.65	0.68	X	9	1.5	2.5	0.4	6.5	01	TX	15	1	X	1 1	$\perp_{X}$	+	<u>                                     </u>	$\lambda$	Higher	
		·					1						1		7			+			0.0	

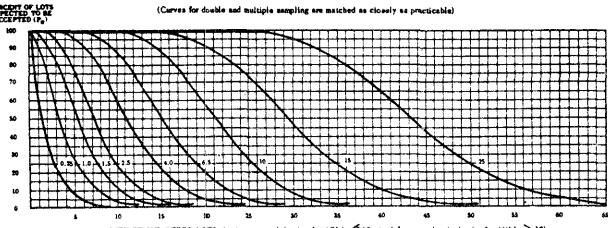
w Use ment preceding numbers are code letter for which acceptance and rejection numbers are available.
w Use next subsequent numbers are code letter for which acceptance and rejection numbers are available. 

Acceptance number,

Rejection number, Use single nampling plan above (or alternatively use letter K). Acceptance not permitted at this nample size,

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

### CHART H - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



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

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

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

	<u> </u>							Acce	ptuble Qu	atity Levi	els (sorma	i inspecti	on)							
P <sub>e</sub>	0.25	1.0	1.5	2.5	4.0	6.5	$\times$	10	0.25	1.0	1.5	2.5	4.0	6.5	$\times$	10	$\times$	15	$\times$	25
•			p (	in percen	t defective	e)	ادبس بيروا						ρ	(is defec	ta per hua	dred unite	.)			
99.0	0.020	0.306	0.868	1.69	3.66	6.06	7.41	11.1	0.020	0.298	0.872	1.65	3.57	5.81	7.01	9.54	12.2	15.0	26.7	25.1
95.0	0.103	0.712	1.66	2.77	5.34	8.20	9.74	12.9	0.103	0.710	1.64	2.73	5.23	7.96	9.39	12.3	15.4	18.5	24.9	29.8
90.0	0.210	1.07	2.23	3.54	6.42	9.53	11:2	14.5	0.210	1.06	2.20	3.49	6.30	9,31	10.9	14.0	17.3	20.6	27.3	32.5
75.0	0.574	1.92	3.46	5.09	8.51	12.0	13.8	17.5	0.576	1.92	3.45	\$.07	8 44	11.9	13.7	17.2	20.8	24.5	31.8	37.4
50.0	1.38	3.33	5.31	7.30	11.3	15.2	17.2	21.2	1.39	3.36	5.35	7.34	11.3	15.3	17.3	21.6	25.3	29.3	37.3	43.3
25.0	2.74	5.30	7.70	10.0	14.5	18.8	21.0	25.2	2.77	5.39	7.84	10.2	14.8	19.4	21.6	26.0	30.4	34.8	43.5	49.9
10.0	4.50	7.56	10.3	12.9	17.8	22.4	24.7	29.1	4.61	7.78	10.6	13.4	18.6	23.5	25.0	30.8	35.6	40.3	49.5	56.4
5.0	5.82	9.13	12.1	14.8	19.9	24.7	27.0	31.6	5.99	9.49	12.6	15.5	21.0	26.3	28.9	33.9	38.9	43.8	53.4	60.5
1.0	8.80	12.5	15.9	18.8	24.3	29.2	31.7	36.3	9.21	13.3	16.8	20.1	26.2	32.0	34.8	46.3	45.6	50.9	61.1	68.7
	0.40	1.5	2.5	4.0	6.5	×	10	×	0.40	1.5	2.5	6.0	6.5	$\times$	10	×	15	X	25	$\overline{}$

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Type of sampling plan Single  Single	Cumuries sample size 20 20 20 13	\$ 0 0 D	then 0.25 15 0 1	Ac Be Case G	X Gitter Use	Us:	1 0 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		3 Ac 2 2 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4	S	1	8 Re Ac \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		10 10 11 10 11 12 13	7 % % % % % % % % % % % % % % % % % % %	15 AC 15	2 S S S S S S S S S S S S S S S S S S S	24 19 19 Ac Ac Ac Ac Ac Ac Ac Ac Ac Ac Ac Ac Ac	27 28 R. 27 29 28 29 29 29 29 29 29 29 29 29 29 29 29 29	Higher 155 A	Cumu. lative sample size 56
Multiple	26 33 52 52 65 78						* * 0 0 2	* 0 0 - 0 6 4	2 + m 2 - 1 0 *	* - 0 % % ~ 0	6 5 1 1 0 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	6 2 6 2 8 8 8 8 9 9 9 9 9 9 9 9 9 9 9 9 9 9 9	4 0 7 3 3 6 6 6 6 11 11 11 11 11 11 11 11 11 11 1	13 13 19 19 19 19 19 19 19 19 19 19 19 19 19	0 6 6 10 10 15 12 12 12 12 12 12 12 12 12 12 12 12 12	1 7 10 8 13 12 17 20 17 20 21 23 25 26	6 6 11 11 16 22 22 27 32	8 2 12 2 19 2 25 25 25 25 33 37	\$ 3 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8		13 26 55 52 18
	<del></del>	Less than 0.40	9.0	X	0.65	1.0	1.5	2.5	0,	6.5	X	2	X		7.7	X	\$3	X	Higher than		
	J							2	acceptable Quality Levels (tightened inspection)	lity Leve	is (tight	rned ins	Pection								

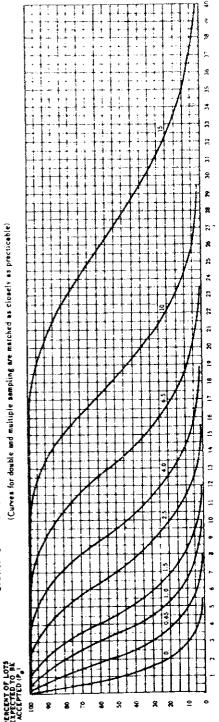
△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ▼ = Acceptance number
 Re = Rejection number

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

= Acceptence not permitted at this sample size.

### TABLE X.] — Tables for sample size code letter: ]

CHART J - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



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

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

181	+	1-1-
_	9.14 11.3 12.7 15.6 4.0	\$ 8 0

Mores. All values gives to shove tokke become or Prizones therefore to se senggeneralmentes to the Measurist.

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TABLE X-1-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: J

Less thm         0.15         0.25         X         0.40         0.0           Ac         Re         Ac         Re         Ac         Re         Ac         Re         Ac         Ac           Φ         0         1         0         1         3 <td< th=""><th>Type of</th><th>Cumu-</th><th></th><th></th><th>į</th><th></th><th></th><th>¥</th><th>ceptable</th><th>, Quelity</th><th>Acceptable Quality Levels (normal inspection)</th><th>normel in</th><th>18 Pection</th><th></th><th></th><th></th><th></th><th></th><th></th><th></th><th>-</th><th></th></td<>	Type of	Cumu-			į			¥	ceptable	, Quelity	Acceptable Quality Levels (normal inspection)	normel in	18 Pection								-	
100   100	sampling plan	sample	Less tha		-	$\vdash$	0.00	3,0		Į:	F	-			ŀ		Ì				<u>ت</u>	É
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Use sest preceding sample size code letter for which acceptance and rejection numbers are available. Use sest subsequent sample size code letter for which acceptance and rejection numbers are available. **ddaa.** .

Acceptance number

Rejection number

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

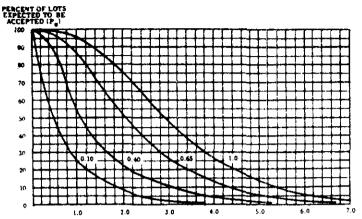
Acceptance not permitted at this sample size.

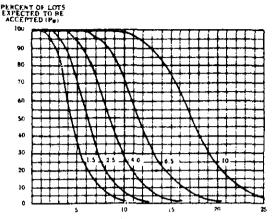
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### TABLE X-K-Tables for sample size code letter: K

### CHART K - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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





APALITY OF SUBMITTED LOTS (p. in percent defective for AQL's €10; in defects per hundred units for AQL's ≥10)

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

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

					Acceptal	ble Quality Lev	els (normal insp	ection)				
P.	0.10	0.40	0.65	10	1.5	2.5	$\times$	4.0	$\times$	6.5	$\times$	10
	p (in percen	t defective or de	efects per hundr	ed unite)								
99.0	0.0081	0.119	0.349	0.658	1.43	2.33	2 81	3.82	4.88	5.98	8.28	10 1
95.0	0.0410	0.284	0.654	1.09	2.09	3.19	3.76	4.94	6.15	7.40	9.95	11 9
90.0	0.0840	0.426	0.882	1 40	2.52	3.73	4.35	5.62	6.92	8.24	10.9	13.0
75.0	0.230	0.769	0.382	2.03	3,38	4.77	5.47	6.90	8.34	9.79	12.7	14.9
50.0	0.554	1.34	2.14	2.94	4.54	6.14	6.94	8.53	10.1	11.7	14.9	17.3
25.0	1.11	2.15	3.14	4.09	5.94	7.75	8.64	10.4	12.2	13.9	17 4	20.0
10.0	1.84	3.11	4.26	5.35	7.42	9.42	10.4	12.3	14.2	16.1	19.8	22 5
5.0	2.40	3.80	5.04	6.20	8.41	10.5	11.5	13 6	15.6	17.5	21.4	24 2
1.0	3.68	5.31	6.73	8.04	10.5	12.8	18.3	16.1	18.3	20.4	24 5	27.5
	0.15	0.65	1.0	1.5	2.5	×	4.0	X	6.5	$\times$	10	$\sim$

Note: All values given is show table haned as Polance distribution as an approximation to the Binemial.

#

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

Re Ac Re 0.10
0 V 0 ·
Cumulative Less than sample 0.10 at zero 125 Ac Re 125 Ac Re 1260 Ac 128

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.

F Acceptance number

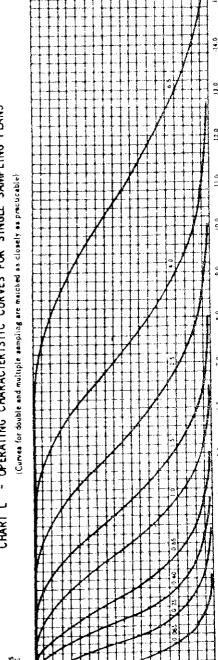
a Rejection number **ddam.**.

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

Acceptance not permitted at this sample size.

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

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



(ALALITY OF SUBMITTED LINTS (p. in percent defective for AQL'S \$ 10; in defects per hundred units for AQL's > 10) hote; Figures on curves are Acceptable Chaliny Levets (AQL's) for sormel raspartion

TARBLATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptabl	Acceptable Quality Levels (normal inappection)	Moment lamper	stron)			TO SERVICE STATE OF THE SERVICE STATE STATE OF THE	(Anapalogical) (Significants)
<b>.</b>	0 (465	0.25	0.40	0.65	0.1	1.5	X	2.5	Χ	6 ()	X	6.5
•	ii tin percent	gi (in percent defective or defects per hundred univa)	fects per hundre	d unita)				A THE STATE OF THE			AND COMPANY OF PARTY AND PARTY.	AND THE PROPERTY OF THE PERSON OF THE PERSON
11.50	U.0051	0.075	0.218	0.412	0.893	1.45	2.	2 39	3.05	3.74	5.13	629
0.50	9.0256	0.178	0.409	0.683	1.31	8.1	2.35	8.	3.85	4.62	23	7 45
ac o	0.0525	0.3%	0.55	0.873	98.	2.33	2.72	3.51	4.32	5.15	6.84	8 12
2 2	0 144	O ARI	0.854	1.27	10.0	2.98	3.42	4.33	5.21	612	7.95	9.34
2 3		0.830	P2 !	1.86	2.84	3.84	4.33	5.33	6.33	7.33	9.33	308
20.00	0.69%	1.35	1 96	2.56	3.71	4.84	5.40	6.51	191	8.70	10.9	22.5
2 5	200.0	. 6	2.66	3.34	\$ -	5.89	8.8	7.70	8.69	101	12.4	161
200	5	2.4.6	3.15	3.86	5.28	6.57	EC.#	88.8	9.72	10.9	13.3	15.1
0.0	2 30	3.32	4.20	\$.02	5.55	3 00	8.70	10.1	11.4	12.7	15.3	17.2
	0.10	0 + 0	0.65	1.0	5.5	X	2.5	Χ	0.4	Χ	6.5	X
				A THE REST OF THE PARTY OF THE	Accep	Acceptable Quality Levels (tightened inspection)	evels (tightened	inspection)				

hein : All values gives in absort tablo bessed on Polosma distribution on on suppre

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

Type of	C.							Acceptab	ie Quelin	Acceptable Quality Levels (norms) inspection	(ama)	To be property in the	The North See	A THE PERSON OF	The second secon	The state of the state of		A CANADA CONTRACTOR CO		
sampling plan	PICE S	Less then 0.065	90.0	6.10	X	0.15	0.25	0.40	0 0 0 65	0	and distribution of the last o		5				Name (Name )	-	17.11	Cumu.
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	Ē					Use	The second secon			+	-		-	+	-	1	11.6	1	1	3
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				×	Z	¥	7 1	-	<b>4</b>	وو	gs)	=======================================	12 12	13	16 18	5	23 24	26 27	<del>- 4-20</del>	250
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	3 5						*	0	0			77	<b>~1</b>	<u>ب</u>		0	_	_	1	3 5
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Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 W = Acceptance number
 Re = Acceptance number
 Re = Rejection number

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

 Mcceptance not permitted at this semple size.

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

CHART M - OPERATING CHARACTER ISTIC CURVES FOR SINGLE SAMPLING PLANS

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QUALITY OF SUBMITTED LOTS (p. - in percent defective for AQL's < 10; in defects per hundred units for AQL's > 10)
Note: Figure as surves are Acceptable Quality Loveis (AQL's) for normal tespecies.

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

					Acceptable Que	Acceptable Quality Levels (normal inspection)	mal inspection)					
å	0.040	0.15	0,25	0.60	0.65	1.0	X	1.5	Χ	2.5	Χ	4.0
	p (in parcent	p (in percent defective or in d	dejects per hundred units)	dred units)								
8.0	0.0032		0.138	0.261	0.566	0.922	1.11	1.51	1.94	2.38	3.28	3.99
8	0.0163	0.112	0.259	0.433	0.829	1.26	1.49	1.96	2.46	2.94	3.95	4.73
8	0.0333	0.166	0.349	0.533	1.00	1.48	1.72	2.23	2.75	3.27	4.3	5.16
3.0	0.0914	0.305	0.580	0.804	1.34	1.89	2.17	2.74	3.31	3.89	5.05	5.93
5	0.220	0.532	0.848	1.17	1.80	2.43	2.75	3.39	4.02	4.66	5.93	6.88
25.0	9,460	9.854	1.24	1.62	2.36	3.07	3.43	4.13	4.83	5:52	96.90	7.92
9	0.731	1.83	1 69	2.12	2.94	3.74	4.13	€.89	5.65	6:36	7.86	8.8
S	0.95	1.51	2.00	2.46	3.34	4.17	4.58	5.38	6.17	96.95	8.47	9.60
0.1	1.46	2.11	267	3.19	4.16	5.08	5.53	6.40	7.25	80'8	9.71	10.9
	0.065	0.25	0,40	0.65	1.0	Χ	1.5	Χ	2.5	X	0.4	X
					Acceptab	Acceptable Quality Levels (tightened inspection)	a (tightened ins	pection)				
					The state of the s							

Notes. All volume given in above table based on Pottama discribation as an approximation to the Misserial

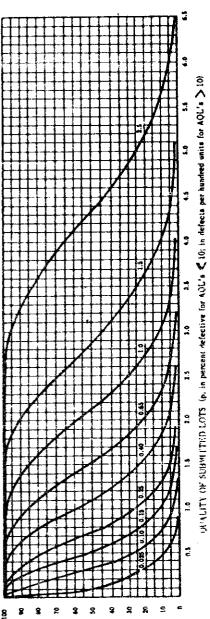
TABLE X-M-2 . SAMPLING PL., S FOR SAMPLE SIZE CODE LETTER: M

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	2.5	1	2	15		77	0		~	2	13	17 16	<u>8</u>		<u>ম</u>	श्च	+	+
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Use next preceding sample size code letter for which acceptance and rejection numbers are available. Use next subsequent sample size code letter for which acceptance and rejection numbers are available.

Acceptance number.





Neto! Figures et carres are Acceptable Quality Levals (AQL's) for some! inspection.

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

					Acceptab	Acceptable Quality Levels (normal inspection)	la (normal inspe	ction)	-			
¢.	0.025	0.10	0.15	0.25	0,40	970	Χ	1.0	Χ	1.5	Χ	2.5
	nacree ui) e	p (in parcent defective or in	osessassassassassassassassassassassassass	tadrad units)	A NATIONAL PROPERTY OF THE PRO							
0.68	0.0020	0.030	0.087	C. 185	D. 35?	0.581	0.701	0.95	1.22	8:	2.07	2.51
0.50	0.0103	0.071	D. 166	0.273	0.523	0.796	0.939	1.23	1.54	1.85	2.69	2.38
0.06	0.0210	0.105	0.23	0.359	0.830	0.931	1.09	0.1	1.73	2.0%	2.73	3.23
75.0	0.0576	0.192	0.345	C. S. 7	9.846	S 1	1.37	1.72	2.08	2.45	3.18	3.74
50.0	0.139	0.336	0.535	0.734	1.83	2.5	1.73	2.13	2.53	2.93	3.73	4.33
3.0	0.277	66.80	0.764	1.02	1.48	1.94	2.36	2.69	3,0%	3,48	4.35	\$ 3
10.0	0.461	0.776	1.06	100 mm	9.1	X 4	2.60	<b>%</b> 1.5	3.56	<b>6.03</b>	\$ 3	25.52
5.0	0.593	0.949	S. S.	Control of the contro	2, 10	7.5	2,39	3.39	3.89	*	5.34	5.85
( )	0.921	1.28	1.50	2.61	29.5	8	3,48	4.03	95.7	5.03	6.12	&.37
SASTERIA CONTRACTOR CONTRACTOR	0,040	0.15	0.25	0.60	0,65	X	1.0	Χ	3.5	Χ	2.5	Χ
	Annual Contract Annual Contract of Contrac		Democratical company of the company	stantante description de la company de la co	mangementarentering Access	Acceptable (Reilly Lavels (tighteded inspection)	veia (tightope)	inapection)			:	

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

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	ន			***************************************	<u></u>	-		gi 6.4	m -	•	0	0	-	S	0	, 9	~	90	eq	4	125	
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	3							e br sore	Sality S	ecceptable (hality Levels (tightened inspection)	ightened	raspeci	tion)							!		

77. Use next preceding sample size code letter for which acceptance and rejection/humbers are available. △ □ Use next preceding us

✓ □ Use next subsequents

Ac □ Acceptance number

Re □ Rejection number

□ □ Use single sampling of

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

# Use single sampling plan sbove (or alternatively use letter R) # Acceptance not permitted at this sample size.

# TABLE X.P — Tables for sample size code letter: P

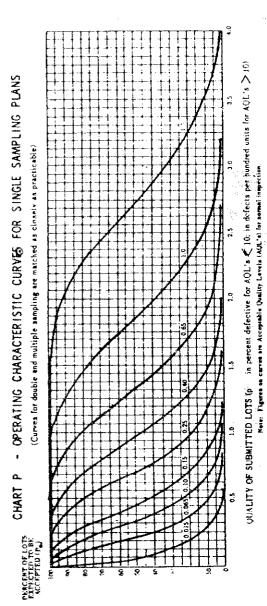


TABLE X-P-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

					Acceptable	Acceptable (Juality Levels (normal inspection)	(normal inspect	ion)				
ď	0.015	0.065	0.10	0.15	0.25	0.40	X	0.65	Χ	1.0	X	1.5
	p(in percent d	efective or defer	p(in percent defective or defects per hundred units)	ınit#)								
0.88	0.0013	0.0186	0.055	0.103	0.23	0.363	0.438	0.596	0.762	0.935	1.29	1.57
85.0	0.0064	0.044	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.16	1.56	1.86
8	0.0131	0.0665	9.138	0.218	0.394	0.582	629.0	0.878	1.08	1.29	17.1	2.03
35.0	0.0360	0.120	0.216	0.317	0.527	0.745	0.855	1.08	1.30	1.53	1.99	2.34
50.0	0.0866	0.210	0.334	0.459	0.709	0.959	1.06	1.33	1.58	1.83	2.33	2.71
82	0.173	0.337	0.490	0.639	0.928	1.21	1.35	1.63	1.90	2.18	2::2	3.12
10.0	0.288	0.486	0.665	0.835	1.16	1.47	1 62	1.93	2.22	2.52	3.09	3.52
5.0	0.375	0.593	0.787	0.959	1.31	35.1	1.80	2.12	2.43	2.74	3 5	3.78
1.0	0.576	0.830	50.1	1.26	2	2:00	2.18	2.52	2.85	3.18	3.82	ξ <del>, 4</del>
	0.025	0.10	0.15	0.25	0,40	Χ	0.65	Χ	1.0	Χ	1.5	Χ
					Acces	Acceptable Quality Levels (rightened inspection)	evels (tightened	inspection)				

Notes All values gives in the ve table based on Pelmine distribution on an appreciateless to the Biscomial

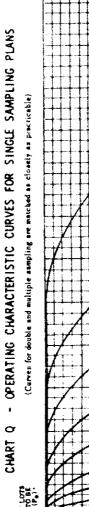
TABLE X-P-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER; P

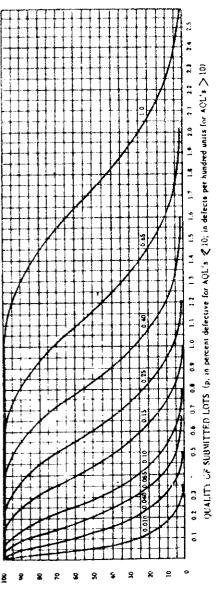
Haire   Cold	Twee of	Cume						7	4cceptab)	Acceptable Quality Levels (nomas inspection)	y Levels	(norms	inapeci	tion)		 							
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0.025 X 0.040 0.065 0.10 0.15 0.25 0.40 X 0.65 X 1.0 X 1.5 X Acceptable Quality Levels (inchitened inspection)												:	4		5					رب ب	<b>%</b>	-	1400
		·			X		0.065	0.10	0.15	0.25	0.40	X	9.5	<del> </del>	X	0.1	$  \triangle $	\ \ V	1.5	IX	x = 3	Kher En	
								, V	eptable	Overlity	evels (r)	Shiened		1			-	-				υ	

△ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
 ∇ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
 Acceptance number.
 Bejection number.
 ■ Use single sampling plan above.
 ■ Acceptance not permitted at this sample size.

Rejection number. Use single nampling plan above. Acceptance not permitted at this nample nize.

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





Nees: Figuria on curvas are Acceptable Quality Levels (AQL's) for samest inequestions

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

					Acceptat	sie Quality Leve	Acceptable (Muslity Levels (norms) inspections	ection)		***************************************		
ъ	0 000	0.040	390.0	0.10	0.15	0.25	Χ	0.40	Χ	9.65	X	0.1
	p (in percen	p (in percent defective or de	efects per hundred units	ed units								
0 %	0.00081	6110.0	0.0349	0.0656	0.143	0.232	0.281	0.382	0.486	0.598	0.828	10 1
3.0	0.00410	0.0284	0.0654	0.109	0.208	0.318	0.376	0.494	0.615	0.740	966.0	1.19
8	0.00840	0.0426	0.0882	0.140	0.252	0.372	0.435	0.562	269.0	0.824	1.09	8
75.0	0.0230	0.0765	6.13	0 203	0.338	0.476	0.547	0.690	0.834	0.979	1.27	1.49
5	2000	0.134	0.214	0 294	454.0	919.0	0.694	0.853	1.01	1.17	1.49	1.73
2,50	0.311	0.215	0.314	604.0	0.594	0.775	0.864	3	1.22	1.39	1.74	2:00
0 01	0.184	0.310	0.426	0.534	0.742	0.942	20.1	1.23	1.42	1.61	98: T	2.25
, C	0.240	0.380	0.504	0.620	0.841	1.05	1.15	1.36	38.	1.75	2.14	2.42
3	398	0.531	0.672	0.804	1.05	1.28	1.83	1.61	1.83	2.04	2.45	2.75
	0.015	0.065	0.10	0.15	0.25	Χ	0,40	Χ	9:02	Χ	1.0	Χ
					Accep	table Ouelity Le	Acceptable Outlity Levels (tightened inspection)	inspection)				

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

Type of	3						•	Acceptab	de Quali	Acceptable Quality Levels (normal inspection)	a (norme)	inspect	iou)								
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	ä	1		Į.				+	4		0.15	8	χ	0.40	X	88.	<u> </u>	$\overline{\chi}$	1.0	e e	sample
	$\prod$	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	٧	Re Ac	Re Ac	Re Ac	Re Ac	P.	Ac Re	٧	Re Ac	ReAc	2	4	3	size
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		0.000	0.015	X	0.025	0.040	0.065	0.10	0.15	6 83	$\downarrow X$	0.0	X	$T_V$	0.65	TX	1.	<del> </del>	TX	Nigher	
							*	cceptabl	Qualit	Acceptable Quality Levels (tightened inspection)	(tighten	ed in be	it of the last	1				-	,	0	

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

Ac = Acceptance number

Re = Rejection number

? = Use single sampling plan above.

F = Acceptance not permitted at this sample size.

# TABLE W-R - Tables for sample size code letter: R

CHART R - OPERATING CHARACTERISTIC CURRY FOR SINGLE SAMPLING PLANS

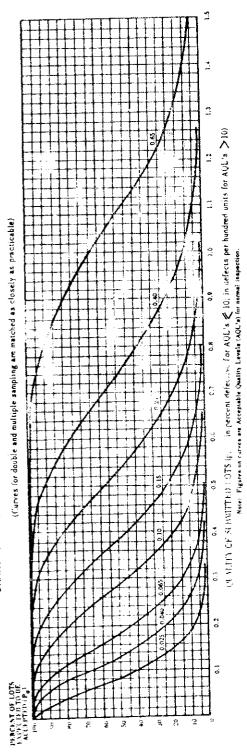


TABLE X-R-1 - TABULATED VALUES FOR OFEREITING CHARACTERIETIC CURVES FOR SINGLE SAMPLING PLANS

				Accept	able Quanty Leve	Acceptable Quanty Levels (normal inspection)	ction)				
			9000	0.10	51.0	Х	0.25	X	0.40	Χ	39'0
o. <b>"</b>	0.0.3	040.0	0.00	01.0							
	n (in percent defective or	efective or defect	defects per hundred units)	{51							
5	*****	81000	0.0412	C 0800	0.145	0.175	0.239	0.30\$	0.374	0.517	0.629
0.4%	0.007	25700		0.121	8.0	0.235	0 309	0.385	0.462	0.622	0.745
0.38	0.0178	0.0409	0.0003	151.0	0.177			0.430	0.515	0.684	0.812
8	0.0266	0.0531	0.0873	0.158	0.233	0.272	0.351	45.454			
	1870 0	0.0868	0.127	0.211	0.298	5.85	0.433	0.521	0.612	0.795	0.934
0.6)	10000		481.0	100.0	.00.0	0.433	0.533	0,633	0.733	0.933	1.08
20.0	0.0839	0.134	67.0	\$07.0	0.304	2000			0.00		7
25.0	0.135	0.196	0.256	0.371	0.484	0.540	0.651	0.761	0.870	1.69	Ġ
9	801.0	370 0	10.34	0.464	0.589	0.650	0.770	0.889	1.01	1.24	1.41
10.0	50.00	0.350	887 13	905.0	0.467	0.793	0.840	0.972	1.09	1.33	1.51
5.0	0.00	0.313		2000	130.0	17.5				1.63	\$ F
1.0	0.332	0.420	0.502	0.655	0.800	0.870	1.02	1.34	1.27	1.33	7).1
	0:040	0.065	0.10	0.15	Χ	0.25	Χ	0.40	Χ	0.65	X
					Acceptable Oual	Acceptable Ovality Levels (tightened inspection)	ined inspection)				
	_							Contract of the Contract of th			

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

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Acceptable Quality Levels (normal inspection)	0.15	Ac Re	Ì		۲.	6		4	•	00	0.	Ξ	12 1		*		X	Acceptable Quality Levels (tightened inspection)
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ble Qua	<b>}</b>	Re Ac	\$	-	<del></del>	•		<b>A</b>	ω, 	2	5 3		-1		٥.	$\perp$	0.15	elity L
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Type of	sempling plan		Single	······································	Double		<u>-</u> -				Multiple			<b></b>	_			

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

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

Q < ž . .

R

Type of	Cumu-	Acceptable Quality Level (normal inspection)	الععوا
sampling	lative sample	X	
	size	Ac	g.
Single	3150		2
	2000	0	2
Double	000	1	2
	800	**	2
	1600	*	73
	2400	0	2
Multiple	3200	0	m
	4000		es
	4800	-	ო
	2600	21	m
		0.025	
		Acceptable Quality Level (tightened inspection)	ty Level tion)

Ac = Acceptance number

Re = Rejection number

\* = Acceptance not permit

Rejection number Acceptance not permitted at this sample size.

### Index of terms with special meanings

Term	Paragraph
Acceptable Quality Level (AQL)	4.2 and 11.1
Acceptance number	9.4 and 10.1.1
Attributes	1.4
Average Outgoing Quality (AOQ)	11.3
Average Outgoing Quality Limit (AOQL)	11.0
Average sample size	11.5
Batch	5.1
Classification of defects	2.1
Code letters	9.3
Critical defect	211
Critical defective	2.1.1
Defect	2.1
Defective unit	99
Defects per hundred units	. 2,2 2,2
Double sampling plan	10.1.2
Inspection	1 2
Inspection by attributes	1.4
Inspection level	9.2
Inspection lot or inspection batch	. J.A 5.1
Isolated lot	11 @
Limiting Quality (LQ)	11.0
Lot	5.J
Lot or batch size	5.3
Major defect	ე.ე ექე
Major defective	2.1.4
Minor defect	0.1.2
Minor defective	4.1.0 5 9 9
Multiple sampling plan	4.4.3
Normal inspection	10.1.0
Operating characteristic curve	o.Land 8.2
Original inspection	11.0
Percent defective	2.2
Preferred AQLs	3.Z A.C
Process average	4.0 11.0
Reduced inspection	29 1000
Rejection number	0.2 and 8.3.3
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Resubmitted lots or batches	
Sample	6.4
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Tightened inspection	8.3
Unit of product	8.2 and 8.3.1 1.5
p	U. 1

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U.S. Naval Supply Depot
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