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MILITARY STANDARD

SAMPLING PROCEDURES AND TABLES  
FOR INSPECTION BY ATTRIBUTES

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MIL-STD-105E

DEPARTMENT OF DEFENSE  
Washington, DC 20301

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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FOREWORD

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

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

Military specifications should not contain requirements for use of specific sampling plans, nor should they provide AQL's or LTPD's as a requirement. Sampling plans for continuous, rather than lot inspection, are contained in MIL-STD-1235, "Single and Multi-Level Continuous Sampling Procedures and Tables for Inspection by Attributes".

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SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

1. SCOPE

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

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

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

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

2. DOCUMENTS

2.1 Not applicable.

3. DEFINITIONS



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

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

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

3.3 Average Outgoing Quality Limit (AOQL). The AOQL is the maximum AOQ for a given acceptance sampling plan. Factors for computing AOQL values are given in Table V-A for each of the single sampling plans for normal inspection and in Table V-B for each of the single sampling plans for tightened inspection.

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

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

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

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

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

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

$$\begin{array}{rcl} \text{Defects per} & = & \frac{\text{Number of defects} \times 100}{\text{Number of units inspected}} \\ \text{hundred units} & & \end{array}$$

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

#### 4. GENERAL REQUIREMENTS

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

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

4.3 Formation and Identification of Lots or Batches. The product shall be assembled into identifiable lots, sublots, batches, or in such other manner as may be prescribed. Each lot or batch shall, as far as is practicable, consist of units of product of a single type, grade, class, size, and composition, manufactured under essentially the same conditions, and at essentially the same time. The lots or batches shall be identified by the contractor and shall be kept intact in adequate and suitable storage space.

#### 4.4 AQL.

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

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

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

#### 4.5 Sampling.

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

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

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

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

4.7 Switching Procedures.

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

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

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

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

b. The total number of defectives (or defects) in the samples from the 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, "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 4.101.4, or

c. Production becomes irregular or delayed; or

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

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

#### 4.9 Sampling Plans.

4.9.1 Inspection Level. The inspection level determines the relationship bet 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 risk can or must be tolerated.

NOTE: In the selection of inspection levels S-1 to S-4, care must be exercised to avoid AQLs inconsistent with these inspection levels. In other words, the purpose of the special inspection levels is to keep samples small when necessary. For instance, the code letters under S-1 go no further than D, equivalent to a single sample of size 8, but it is of no use to choose S-1 if the AQL is 0.10 percent for which the minimum sample is 125.

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

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

4.9.4 Types of Sampling Plans. Three types of sampling plans: Single, Double, 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 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 administrative difficulty and the average sample sizes of the available plans. 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 double or multiple.

#### 4.10 Determination of Acceptability.

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

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

4.10.1.2 Double Sampling Plan. A number of sample units equal to the first ample size given by the plan shall be inspected. If the number of defectives in the first sample is equal to or less than the first acceptance number, 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, 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 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 1 be considered acceptable. If the cumulative number of defectives is equal to or greater than the second rejection number, the lot or batch shall be rejected.

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

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

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

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

#### 4.12 Curves.

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

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



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SECTION 5  
TABLES AND CURVES

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TABLE I—Sample size code letters

(see 4.9.1 and 4.9.2)

Lot or batch size			Special inspection levels				General inspection levels		
			S-1	S-2	S-3	S-4	I	II	III
2	to	8	A	A	A	A	A	A	B
9	to	15	A	A	A	A	A	B	C
16	to	25	A	A	B	B	B	C	D
26	to	50	A	B	B	C	C	D	E
51	to	90	B	B	C	C	C	E	F
91	to	150	B	B	C	D	D	F	G
151	to	280	B	C	D	E	E	G	H
281	to	500	B	C	D	E	F	H	J
501	to	1200	C	C	E	F	G	J	K
1201	to	3200	C	D	E	G	H	K	L
3201	to	10000	C	D	F	G	J	L	M
10001	to	35000	C	D	F	H	K	M	N
35001	to	150000	D	E	G	J	L	N	P
150001	to	500000	D	E	G	J	M	P	Q
500001	and	over	D	E	H	K	N	Q	R

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CODE  
LETTERS













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

(see 4.9.3 and 4.9.4)

Sample size code letter	Sample size	Cumulative sample size	Acceptable Quality Levels (reduced inspection)†																															
			0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000						
			Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re			
A			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓				
B			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
C			↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
U	First Second	2 2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
F	First Second	3 3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
F	First Second	3 6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
F	First Second	5 5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
F	First Second	5 10	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
C	First Second	8 8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
C	First Second	8 16	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
H	First Second	13 13	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
H	First Second	13 26	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
J	First Second	20 20	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
J	First Second	20 40	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
K	First Second	32 32	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
K	First Second	32 64	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
L	First Second	50 50	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
L	First Second	50 100	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
M	First Second	80 80	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
M	First Second	80 160	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
N	First Second	125 125	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
N	First Second	125 250	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
P	First Second	200 200	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
P	First Second	200 400	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
U	First Second	315 315	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
U	First Second	315 630	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
R	First Second	500 500	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			
R	First Second	500 1000	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓			

- ⊗ Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.
- ↑ Use first sampling plan above arrow.
- Ac Acceptance number.
- Re Rejection number.
- \* Use corresponding single sampling plan for alternatively, use double sampling plan below, when available.)
- † If, after the second sample, the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but retestate normal inspection (see 4.10.1.4)

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**DOUBLE  
REDUCED**

MULTIPLE NORMAL

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

(see 4.9.3 and 4.9.4)

Sample size code letter	Sample size	Continuous sample size	Variable Quality Levels (Normal Inspection)																											
			0.010		0.015		0.025		0.040		0.063		0.100		0.150		0.250		0.400		0.630		1.000		1.500		2.500		4.000	
			Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
A																														
B																														
C																														
H	First	2	2																											
	Second	2	1																											
	Third	2	6																											
	Fourth	2	8																											
	Fifth	2	10																											
	Sixth	2	12																											
I	First	3	3																											
	Second	3	6																											
	Third	3	9																											
	Fourth	3	12																											
	Fifth	3	15																											
	Sixth	3	18																											
J	First	4	4																											
	Second	4	6																											
	Third	4	9																											
	Fourth	4	12																											
	Fifth	4	15																											
	Sixth	4	18																											

The first sampling plan below arrow refers to continuation of table on following page, when necessary. If sample size equals or exceeds lot or batch size, do 100 percent inspection.  
 The first sampling plan above arrow.  
 Ac = Acceptance number  
 Re = Rejection number  
 \* = The corresponding single sampling plan for alternatively, use multiple sampling plan below, when available.  
 Use corresponding double sampling plan for alternatively, use multiple sampling plan below, when available.  
 \* = Acceptance not permitted at this sample size

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

(see 4.9.3 and 4.9.4)

Sample size code letter	Sample size	Lot or batch size	Acceptable Quality Levels (normal inspection)																														
			0.100	0.115	0.125	0.140	0.150	0.165	0.180	0.200	0.225	0.250	0.280	0.315	0.350	0.400	0.450	0.500	0.550	0.600	0.650	0.700	0.800	0.900	1.000	1.100	1.250	1.400	1.600	1.800	2.000		
			Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac
K	First	32	12																														
	Second	32	64																														
	Third	32	96																														
	Fourth	32	128																														
	Fifth	32	160																														
	Sixth	32	192																														
Seventh	32	224																															
L	First	50	50																														
	Second	50	100																														
	Third	50	150																														
	Fourth	50	200																														
	Fifth	50	250																														
	Sixth	50	300																														
Seventh	50	350																															
M	First	80	80																														
	Second	80	160																														
	Third	80	240																														
	Fourth	80	320																														
	Fifth	80	400																														
	Sixth	80	480																														
Seventh	80	560																															
N	First	125	125																														
	Second	125	250																														
	Third	125	375																														
	Fourth	125	500																														
	Fifth	125	625																														
	Sixth	125	750																														
Seventh	125	875																															
P	First	200	200																														
	Second	200	400																														
	Third	200	600																														
	Fourth	200	800																														
	Fifth	200	1000																														
	Sixth	200	1200																														
Seventh	200	1400																															
Q	First	315	315																														
	Second	315	630																														
	Third	315	945																														
	Fourth	315	1260																														
	Fifth	315	1575																														
	Sixth	315	1890																														
Seventh	315	2205																															
R	First	500	500																														
	Second	500	1000																														
	Third	500	1500																														
	Fourth	500	2000																														
	Fifth	500	2500																														
	Sixth	500	3000																														
Seventh	500	3500																															

= Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.  
 = Use first sampling plan above arrow (refer to preceding page, when necessary).  
 Ac = Acceptance number.  
 Re = Rejection number.  
 \* = Use corresponding single sampling plan for alternatively, use multiple plan below, where available!  
 a = Acceptance not permitted at this sample size.

MULTIPLE  
NORMAL

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

(see 4.9.3 and 4.9.4)

Sample size code letter	Sample size	Normal finite sample size	Acceptable Quality Levels (tightened inspection)																																																	
			0.010		0.015		0.025		0.040		0.065		1.0		1.5		2.5		4.0		6.5		10		15		25		40		65		100		150		250		400		650		1000									
			Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re								
A	First	32	32																																																	
	Second	32	64																																																	
	Third	32	96																																																	
	Fourth	32	128																																																	
	Fifth	32	160																																																	
	Sixth	32	192																																																	
	Seventh	32	224																																																	

MULTIPLE  
TIGHTENED

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- Use first sampling plan below when sample size equals or exceeds lot or batch size, or 100 percent inspection.
- Use first sampling plan above when (refer to preceding page, when necessary).
- Ac Acceptance number.
- Re Rejection number.
- Use corresponding single sampling plan (or alternatively, use multiple sampling plan below, where available).
- Acceptance not permitted at this sample size.



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

(see 4.9.3 and 4.9.4)

Table with columns for Sample size, Sample, Cumulative sample size, and Acceptable Quality Levels (reduced inspection) for various percentages from 0.010 to 1000. The table contains numerical data and arrows indicating sampling plans.

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MULTIPLE  
REDUCED

- ↑ Use first sampling plan below arrow. If sample size equals, or exceeds, lot or batch size, do 100 percent inspection.
⇓ Use first sampling plan above arrow (refer in preceding page when necessary).
Ac = Acceptance number
Re = Rejection number
\* = Acceptance not permitted at this sample size
† = If, after the final sample, the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but substitute normal inspection (see 4.10.1.4)

AOQL  
NORMAL

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

(see 3.3)

Code Letter	Sample Size	Acceptable Quality Level																																	
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000								
A	2																				18				42	69	97	160	220	330	470	730	1100		
B	3																									28	46	65	110	150	220	310	490	720	1100
C	5															7.4									17	27	39	63	90	130	190	290	430	660	
D	8													4.6								11			17	24	40	56	82	120	180	270	410		
E	13																								15	24	34	50	72	110	170	250			
F	20															1.8									16	22	33	47	73						
G	32																																		
H	50																																		
J	80																																		
K	125																																		
L	200																																		
M	315																																		
N	500																																		
P	800																																		
Q	1250																																		
R	2000																																		

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

Inspection.]

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

(see 3.3)

Code letter	Sample size	Acceptable Quality Level																										
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000	
A	2																											
B	3														7.4	12				17	28	44	65	110	170	270	410	620
C	5																			27	39	63	100	160	250	390	610	
D	8																											
E	13											1.0	2.0	4.6		6.5	11			17	26	40	64	99	150	240	380	
F	20														4.2	6.9	9.7			16	26	40	61	95	150	240	380	
G	32																											
H	50																											
J	80								0.46	0.74	1.2																	
K	125																											
L	200																											
M	315				0.12	0.18	0.29																					
N	500																											
P	800			0.046	0.074	0.11	0.17	0.27	0.39	0.63	1.0	1.6	2.5															
Q	1250		0.029			0.067	0.11	0.16	0.25	0.41	0.64	0.99																
R	2000	0.018																										
S	3150			0.027	0.042	0.069	0.097	0.16	0.26	0.40	0.62																	

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

AOQL  
TIGHTENED

Inspection.]

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

(see 4.11)

LQ (DEFECTIVES)  
10.0%

Code letter	Sample size	Acceptable Quality Level															
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10
A	2	0.18	0.29	0.46	0.73	1.2	1.8	2.8	4.5	6.9	11	16	25	37	54	68	80
B	3																
C	5																
D	8																
E	13																
F	20																
G	32																
H	50																
J	80																
K	125																
L	200																
M	315																
N	500																
P	800																
Q	1250																
R	2000																

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

(see 4.11)

Code letter	Sample size	Acceptable Quality Level																									
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
A	2															120			200	270	330	460	590	770	1000	1400	1900
B	3														77			130	180	220	310	390	510	670	940	1300	1800
C	5												46			78	110	130	190	240	310	400	560	770	1100		
D	8											29			49	67	84	120	150	190	250	350	480	670			
E	13										18			30	41	51	71	91	120	160	220	300	410				
F	20									12			20	27	33	46	59	77	100	140							
G	32									7.2			12	17	21	29	37	48	63	88							
H	50							4.6				7.0	11	13	19	24	31	40	56								
J	80						2.9					4.9	6.7	8.4	12	15	19	25	35								
K	125						1.8					3.1	4.3	5.4	7.4	9.4	12	16	23								
L	200				1.2							2.0	2.7	3.3	4.6	5.9	7.7	10	14								
M	315			0.73								1.2	1.7	2.1	2.9	3.7	4.9	6.4	9.0								
N	500			0.46			0.78					1.1	1.3	1.9	2.4	3.1	4.0	5.6									
P	800		0.29			0.49	0.67	0.84				1.2	1.5	1.9	2.5	3.5											
Q	1250	0.18			0.31	0.43	0.53	0.74	0.94			1.2	1.6	2.3													
It	2000			0.20	0.27	0.33	0.46	0.59	0.77	1.0	1.4																

10%  
LQ (DEFECTS)

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

(see 4.11)

5.0%  
LQ (DEFECTIVES)

Code letter	Sample size	Acceptable Quality Level																
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	
A	2															78		
B	3														63			
C	5												45				66	
D	8													31		47	60	
E	13											21			32	41	50	
F	20									14			22	28	34	46		
G	32										8.9			14	18	23	30	37
H	50									5.8		9.1	12	15	20	25	32	
J	80							3.7			5.8	7.7	9.4	13	16	20	26	
K	125						2.4				3.8	6.2	8.4	11	14	18	24	
L	200					1.5				2.4	3.2	5.3	6.6	8.5	11	15		
M	315				0.95					2.0	2.5	4.2	5.4	7.0	9.6			
N	500			0.60			0.95			1.3	1.6	2.1	2.6	3.4	4.4	6.1		
P	800		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							

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

(see 4.11)

Code letter	Sample size	Acceptable Quality Level																									
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
A	2														150				240	320	390	530	660	850	1100	1500	2000
B	3													100				160	210	260	350	440	570	730	1000	1400	1900
C	5												60			95	130	160	210	260	340	440	610	810	1100		
D	8											38			59	79	97	130	160	210	270	380	510	710			
E	13										23			37	48	60	81	100	130	170	230	310	440				
F	20									15			24	32	39	53	66	85	110	150							
G	32								9.4			15	20	24	33	41	53	68	95								
H	50							6.0			9.5	13	16	21	26	34	44	61									
J	80						3.8			5.9	7.9	9.7	13	16	21	27	38										
K	125					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												
M	315			0.95			1.5	2.0	2.5	3.3	4.2	5.4	7.0	9.6													
N	500			0.60		0.95	1.3	1.6	2.1	2.6	3.4	4.4	6.1														
P	800		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																

5% LQ (DEFECTS)

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TABLE VIII—Limit Numbers for Reduced Inspection

(see 4.7.3)

LIMIT  
NUMBERS

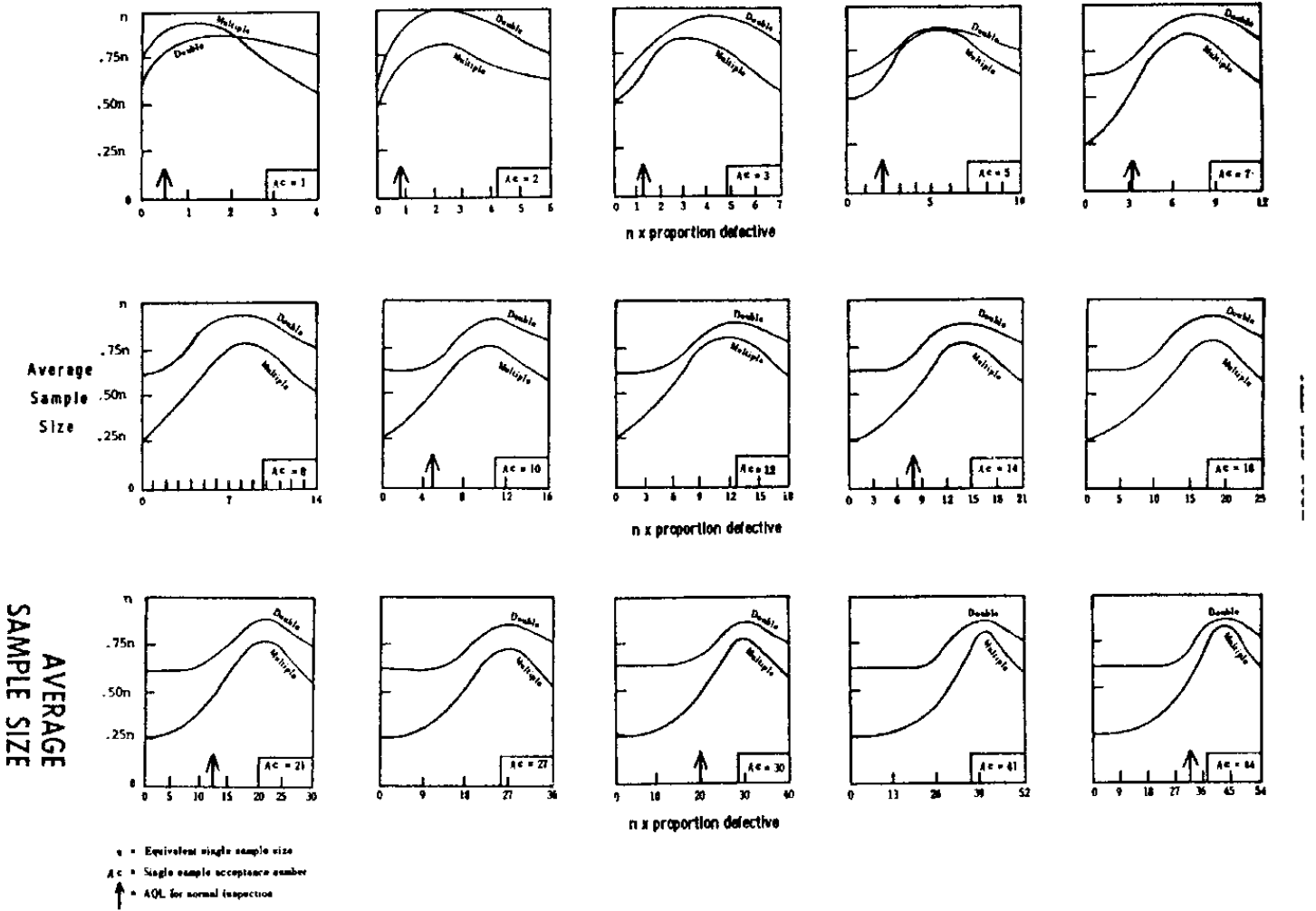
Number of sample units from least 10 lots or batches	Acceptable Quality Level																									
	0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000
20 - 29	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	0	0	2	4	8	14	22	40	68	115	181
30 - 49	*	*	*	*	*	*	*	*	*	*	*	*	*	*	0	0	1	3	7	13	22	36	63	105	178	277
50 - 79	*	*	*	*	*	*	*	*	*	*	*	*	*	0	0	2	3	7	14	25	40	63	110	181	301	
80 - 129	*	*	*	*	*	*	*	*	*	*	*	*	0	0	2	4	7	14	24	42	68	105	181	297	490	
130 - 199	*	*	*	*	*	*	*	*	*	*	*	0	0	2	4	7	13	25	42	72	115	177	301			
200 - 319	*	*	*	*	*	*	*	*	*	*	0	0	2	4	8	14	22	40	68	115	181	277	471			
320 - 499	*	*	*	*	*	*	*	*	*	0	0	1	4	8	14	24	39	68	113	189						
500 - 799	*	*	*	*	*	*	*	*	0	0	2	3	7	14	25	40	63	110	181							
800 - 1249	*	*	*	*	*	*	*	0	0	2	4	7	14	24	42	68	105	181								
1250 - 1999	*	*	*	*	*	0	0	2	4	8	14	24	40	68	110	181	169									
2000 - 3149	*	*	*	*	0	0	2	4	8	14	22	38	67	111	186											
3150 - 4999	*	*	*	0	0	2	4	8	14	24	40	69	110	181												
5000 - 7999	*	*	0	0	2	4	7	13	24	40	69	110	181													
8000 - 12499	*	0	0	2	4	7	13	24	40	69	110	181														
12500 - 19999	*	0	0	2	4	7	13	24	40	69	110	181														
20000 - 31499	0	0	2	4	8	14	22	40	68	115	181															
31500 & Over	0	1	4	8	14	24	38	67	111	186																

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\* 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 more than ten lots or batches may be used for the calculation, provided that the lots or batches used are the most recent ones in sequence, that they have all been on normal inspection, and that none has been rejected while on original inspection.

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

(see 4.12.2)



Sampling.]

A

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

CHART A - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

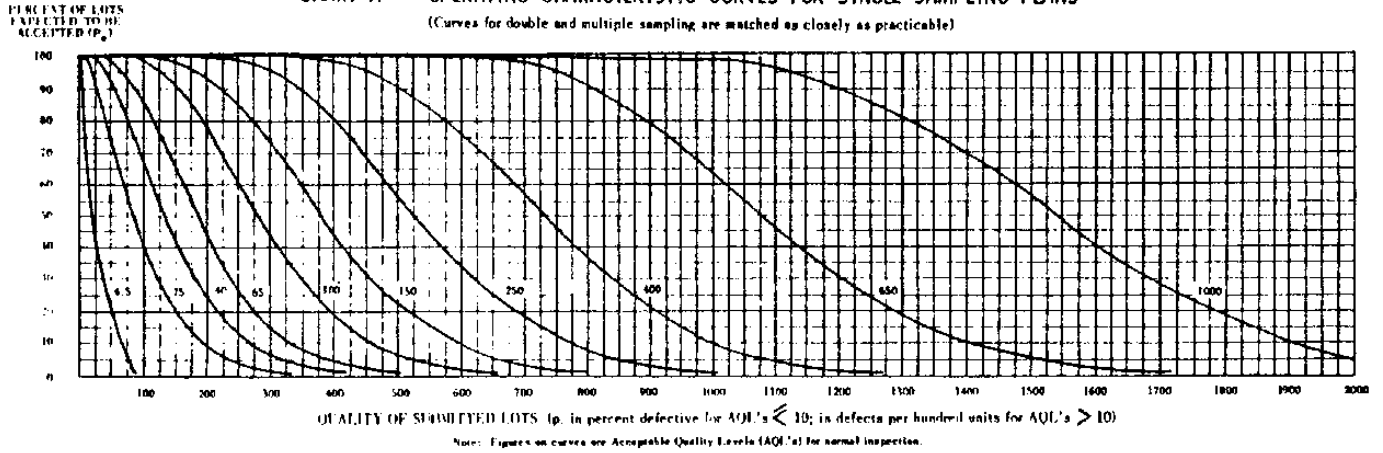


TABLE X-A-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)														
	6.5	6.5	25	40	65	100	150	×	250	×	400	×	650	×	1000
	p (in percent defective)							p (in defects per hundred units)							
99.0	0.501	0.503	7.43	21.8	41.2	89.2	145	175	239	305	374	517	629	859	977
95.0	2.53	2.56	17.8	40.9	68.3	131	199	235	308	381	462	622	745	995	1122
90.0	5.13	5.27	26.6	55.1	87.2	158	233	272	351	432	515	684	812	1073	1206
75.0	13.4	14.4	48.1	86.4	127	211	298	342	431	521	612	795	934	1214	1354
50.0	29.3	34.7	83.9	134	184	284	383	433	533	633	733	933	1083	1383	1533
25.0	50.0	69.3	135	196	255	371	484	540	651	761	870	1087	1248	1568	1728
10.0	68.4	115	194	266	334	464	589	650	770	889	1006	1238	1409	1748	1916
5.0	77.6	150	237	315	388	526	657	722	848	972	1094	1335	1512	1862	2035
1.0	90.0	230	332	420	502	655	800	870	1007	1141	1272	1529	1718	2088	2270
	×	×	40	65	100	150	×	250	×	400	×	650	×	1000	×
	Acceptable Quality Levels (tightened inspection)														

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



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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																								Cumulative sample size										
		Less than 6.5		6.5		10		15		25		40		65		100		150		250		400		650			1000									
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re						
Single	2	▽	0	1																									2							
Double		▽	*		Use code Letter D	Use code Letter C	Use code Letter B																													
Multiple		▽	*																																	
		Less than 10	×		10	15	25	40	65	100	150	×	250	×	400	×	650	×	1000	×																
Acceptable Quality Levels (tightened inspection)																																				

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- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection number
- \* = Use single sampling plan above for alternatively use code letter D).
- (\*) = Use single sampling for alternatively use code letter B).

A

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

B

CHART B - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

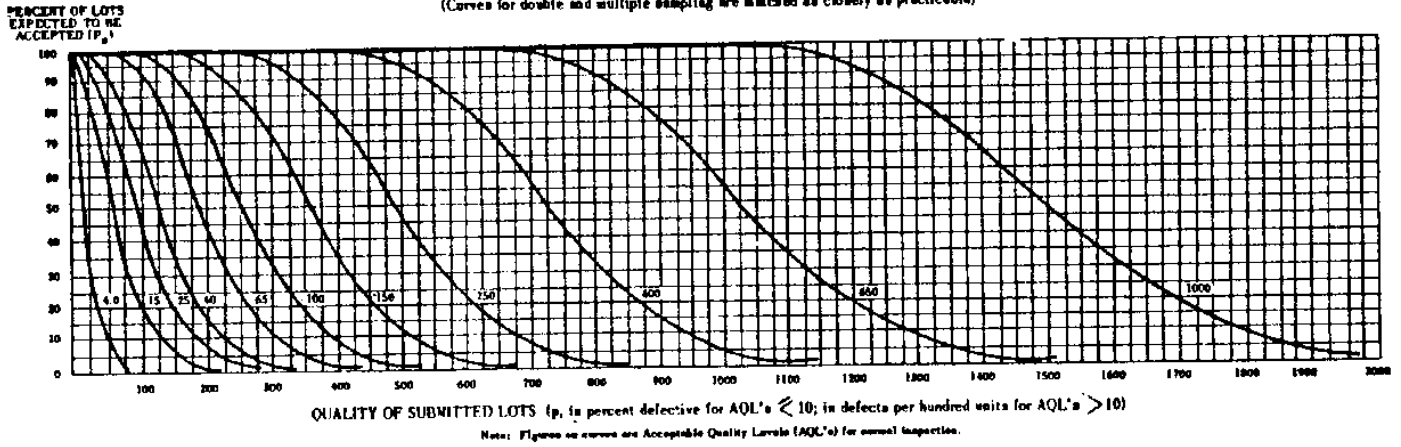


TABLE X-B-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)																
	4.0	4.0	15	25	40	65	100	×	150	×	250	×	400	×	650	×	1000
	p (in percent defective)	p (in defects per hundred units)															
99.0	0.334	0.335	4.97	14.5	27.4	59.5	96.9	117	159	203	249	345	419	577	651	947	1029
95.0	1.70	1.71	11.8	27.3	45.5	87.1	133	157	206	256	308	415	496	663	748	1065	1152
90.0	3.45	3.51	17.7	36.7	58.2	105	155	181	234	288	343	456	541	716	804	1131	1222
75.0	9.14	9.59	32.0	57.6	84.5	141	199	228	287	347	408	530	623	809	903	1249	1344
50.0	20.6	23.1	55.9	89.1	122	189	256	289	356	422	489	622	722	922	1022	1389	1489
25.0	37.0	46.2	89.8	131	170	247	323	360	434	507	580	724	832	1045	1152	1539	1644
10.0	53.6	76.8	130	177	223	309	392	433	514	593	671	825	939	1165	1277	1683	1793
5.0	63.2	99.9	158	210	258	350	438	481	565	648	730	890	1008	1241	1356	1773	1886
1.0	78.5	154	221	280	335	437	533	580	671	761	848	1019	1145	1392	1513	1951	2069
	6.5	6.5	25	40	65	100	×	150	×	250	×	400	×	650	×	1000	×
	Acceptable Quality Levels (tightened inspection)																

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

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Cumulative sample size		
		Less than 4.0	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000									
		Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re									
Single	3	▽	0 1																					3
Double	2	▽	*																					2
	4			A	D	C																		4
Multiple		▽	*																					
		Less than 6.5	6.5	10	15	25	40	65	100	150	250	400	650	1000										
Acceptable Quality Levels (tightened inspection)																								

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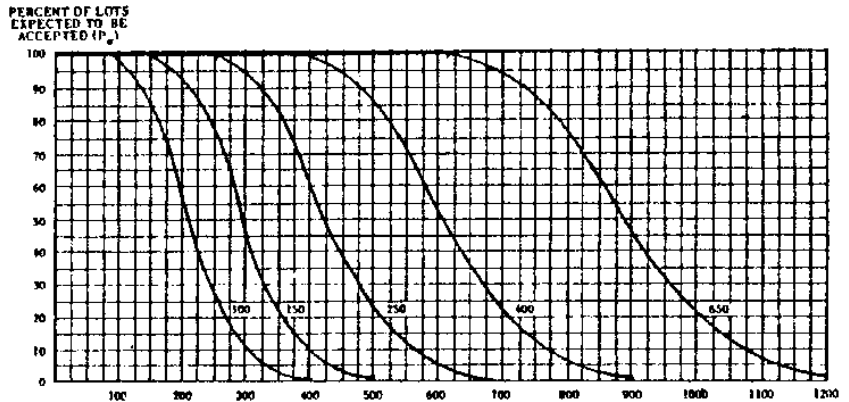
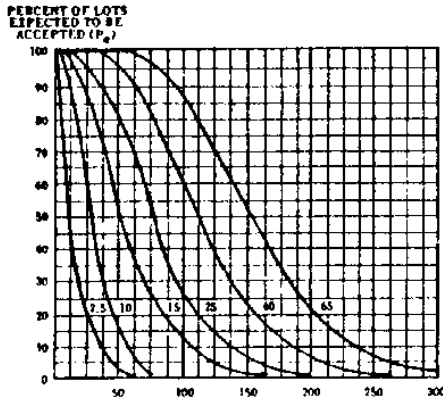
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection number
- \* = Use single sampling plan above (or alternatively use code letter E)
- ++ = Use double sampling plan above (or alternatively use code letter D)

**B**

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

CHART C - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



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

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

$P_a$	Acceptable Quality Levels (normal inspection)																	
	2.5	10	2.5	10	15	25	40	65	×	100	×	150	×	250	×	400	×	650
	p (in percent defective)			p (in defects per hundred units)														
99.0	0.201	3.27	0.201	2.97	8.72	16.5	37.5	58.1	70.1	95.4	122	150	207	251	343	391	568	618
95.0	1.02	7.64	1.03	7.11	16.4	27.3	52.3	79.6	93.9	123	154	185	249	298	398	449	639	691
90.0	2.09	11.2	2.11	10.6	22.0	34.9	63.0	93.1	109	140	173	206	273	325	429	482	679	733
75.0	5.59	19.4	5.75	19.2	34.5	50.7	84.4	119	137	172	208	245	318	374	485	542	749	806
50.0	12.9	31.4	13.9	33.6	53.5	73.4	113	153	173	213	253	293	373	433	553	613	833	893
25.0	24.2	45.4	27.7	53.9	78.4	102	148	194	216	260	304	348	435	499	627	691	923	986
10.0	36.9	58.4	46.1	77.8	106	134	185	235	260	308	356	403	495	564	699	766	1010	1076
5.0	45.1	65.7	59.9	94.9	126	155	210	263	289	339	389	438	534	605	745	814	1064	1131
1.0	60.2	77.8	92.1	131	168	201	262	320	348	403	456	509	612	687	835	908	1171	1241
	4.0	×	4.0	15	25	40	65	×	100	×	150	×	250	×	400	×	650	×

Note: Binomial distribution used for percent defective computations;  $P_a$  values for defects per hundred units.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (tightened inspection)																				Cumulative sample size																	
		Less than 2.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000																							
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re														
Single	5	▽	0	1				1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	27	28	30	31	41	42	44	45		5
Double	3	▽	*		Use code Letter B	Use code Letter E	Use code Letter D	0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	15	20	17	22	23	29	25	31	Use code Letter B	3
	6							1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27	34	35	37	38	52	53	56	57	6	
Multiple		▽	*					++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++	++			
		Less than 4.0	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000																								

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- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number.
- Re = Rejection number.
- \* = Use single sampling plan above (or alternatively use code letter F)
- ++ = Use double sampling plan above (or alternatively use code letter D)

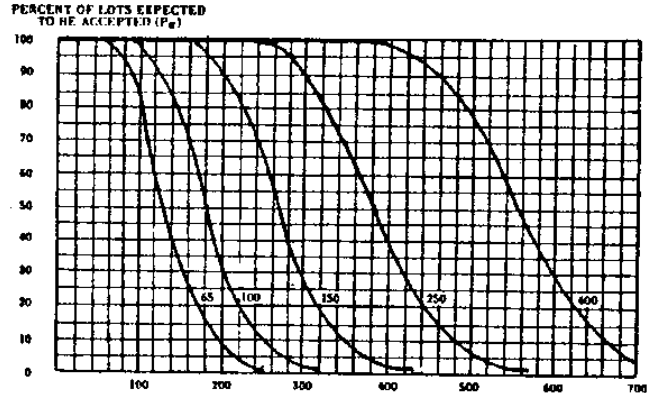
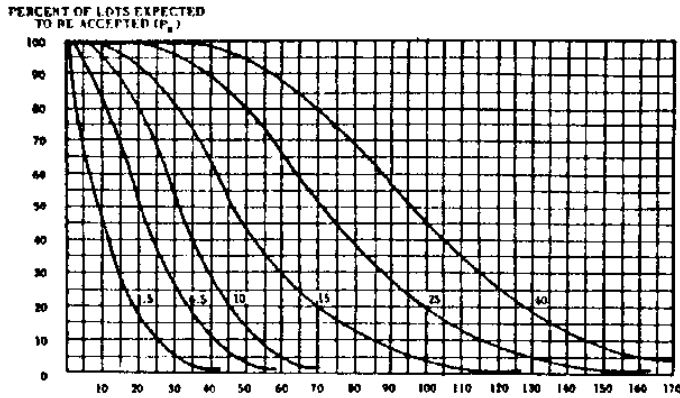
C

**D**

**TABLE X-D—Tables for sample size code letter: D**

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

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



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

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

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

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)																		
	1.5	6.5	10	1.5	6.5	10	15	25	40	×	65	×	100	×	150	×	250	×	400
	p (in percent defective)			p (in defects per hundred units)															
99.0	0.126	1.97	6.08	0.126	1.86	5.45	10.3	22.3	36.3	43.8	59.6	76.2	93.5	129	157	215	244	355	386
95.0	0.639	4.64	11.1	0.641	4.44	10.2	17.1	32.7	49.8	58.7	77.1	96.1	116	156	186	249	281	399	432
90.0	1.31	6.88	14.7	1.32	6.65	13.8	21.8	39.4	58.2	67.9	87.8	108	129	171	203	268	301	424	458
75.0	3.53	12.1	22.1	3.60	12.0	21.6	31.7	52.7	74.5	85.5	108	130	153	199	234	303	339	468	504
50.0	8.30	20.1	32.1	8.66	21.0	33.4	45.9	70.9	95.9	108	133	158	183	233	271	346	383	521	558
25.0	15.9	30.3	43.3	17.3	33.7	49.0	63.9	92.8	121	135	163	190	217	272	312	392	432	577	617
10.0	25.0	40.6	53.8	28.8	48.6	66.5	83.5	116	147	162	193	222	252	309	352	437	479	631	672
5.0	31.2	47.1	60.0	37.4	59.3	78.7	96.9	131	164	180	212	243	274	334	378	465	509	665	707
1.0	43.8	59.0	70.7	57.6	83.0	105	126	164	200	218	252	285	318	382	429	522	568	732	776
	2.5	10	×	2.5	10	15	25	40	×	65	×	100	×	150	×	250	×	400	×

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

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																												Cumulative sample size							
		Less than 1.5		1.5		2.5		4.0		6.5		10		15		25		40		65		100		150		250		400			Higher than 400						
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re					
Single	8	▽	0	1																											△	8					
Double	5	▽	*		Use code Letter	Use code Letter	Use code Letter																								△	5					
	10				C	F	E																								△	10					
Multiple	2	▽	*																												△	2					
	4																															△	4				
	6																																△	6			
	8																																△	8			
	10																																△	10			
	12																																	△	12		
14																																	△	14			
		Less than 2.5	2.5	×	4.0	6.5	10	15	25	40	×	65	×	100	×	150	×	250	×	400	×	Higher than 400															
Acceptable Quality Levels (tightened inspection)																																					

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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.
- Ac = Acceptance number
- Re = Rejection number
- \* = Use single sampling plan above (or alternatively use code letter G)
- # = Acceptance not permitted at this sample size.

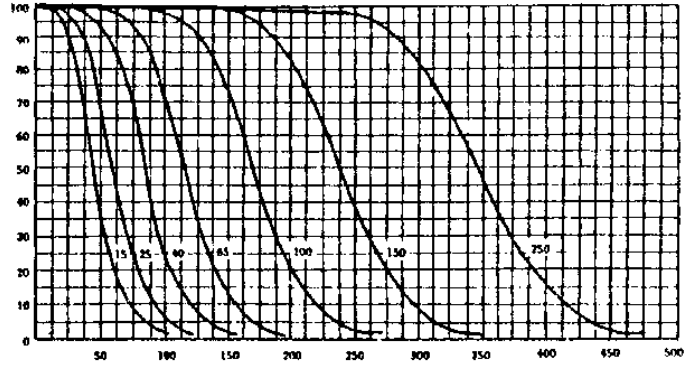
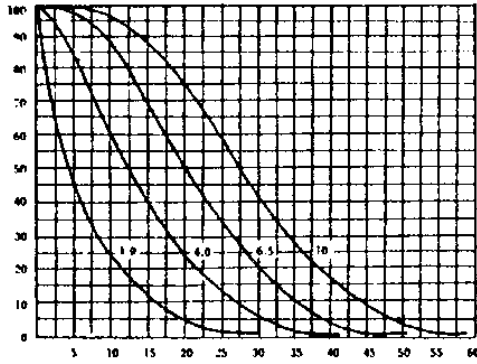
D

**E**

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

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

PERCENT OF LOTS  
EXPECTED TO BE  
ACCEPTED (P<sub>a</sub>)



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

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

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)																			
	1.0	4.0	6.5	10	1.0	4.0	6.5	10	15	25	×	40	×	65	×	100	×	150	×	250
	p (in percent defective)				p (in defects per hundred units)															
99.0	0.077	1.18	3.58	6.75	0.0773	1.15	3.35	6.33	13.7	22.4	27.0	36.7	46.9	57.5	79.6	96.7	132	150	219	238
95.0	0.394	2.81	6.60	11.3	0.395	2.73	6.29	10.5	20.1	30.6	36.1	47.5	59.2	71.1	95.7	115	153	173	246	266
90.0	0.807	4.17	8.80	14.2	0.810	4.09	8.48	13.4	24.2	35.8	41.8	54.0	66.5	79.2	105	125	165	185	261	282
75.0	2.19	7.41	13.4	19.9	2.21	7.39	13.3	19.5	32.5	45.8	52.6	66.3	80.2	94.1	122	144	187	208	288	310
50.0	5.19	12.6	20.0	27.5	5.33	12.9	20.6	28.2	43.6	59.0	66.7	82.1	97.4	113	144	167	213	236	321	344
25.0	10.1	19.4	28.0	36.1	10.7	20.7	30.2	39.3	57.1	74.5	83.1	100	117	134	167	192	241	266	355	379
10.0	16.2	26.8	36.0	44.4	17.7	29.9	40.9	51.4	71.3	90.5	100	119	137	155	190	217	269	295	388	414
5.0	20.6	31.6	41.0	49.5	23.0	36.5	48.4	59.6	80.9	101	111	130	150	168	205	233	286	313	409	435
1.0	29.8	41.3	50.6	58.8	35.4	51.1	64.7	77.3	101	123	134	155	176	196	235	264	321	349	450	477
	1.5	6.5	10	×	1.5	6.5	10	15	25	×	40	×	65	×	100	×	150	×	250	×

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

Sampling Plans.]



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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																								Cumulative sample size		
		Less than 1.0	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	Higher than 250												
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re							
Single	13	▽	0	1																						△	13	
	8	▽	*		Use code Letter D	Use code Letter G	Use code Letter F																				△	8
Multiple	16																										16	
	3	▽	*																								△	3
	6																										6	
	9																										9	
	12																											12
	15																											15
18																											18	
21																											21	
		Less than 1.5	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	Higher than 250	Acceptable Quality Levels (tightened inspection)												

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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.
- Ac = Acceptance number.
- Re = Rejection number.
- \* = Use single sampling plan above (or alternatively use code letter H)
- # = Acceptance not permitted at this sample size.

**E**

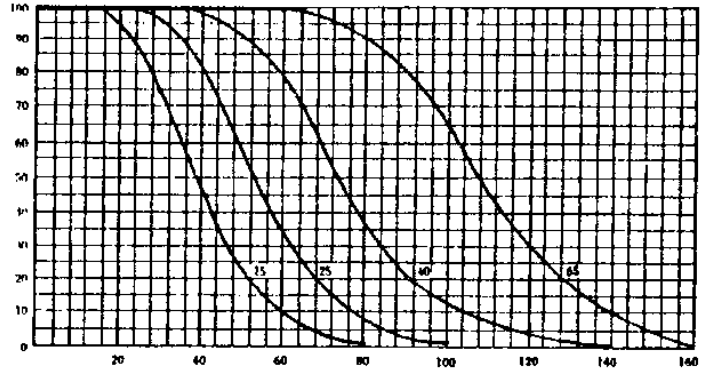
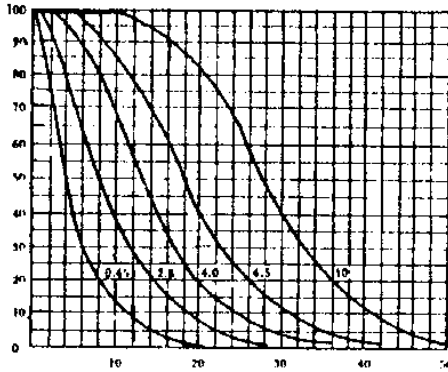
**F**

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

**CHART F - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS**

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

PERCENT OF LOTS  
EXPECTED TO BE  
ACCEPTED ( $P_a$ )



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

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

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

$P_a$	Acceptable Quality Levels (normal inspection)																
	0.65	2.5	4.0	6.5	10	0.65	2.5	4.0	6.5	10	15	<del>X</del>	25	<del>X</del>	40	<del>X</del>	65
	$p$ (in percent defective)					$p$ (in defects per hundred units)											
99.0	0.0502	0.759	2.27	4.36	9.75	0.0503	0.743	2.18	4.12	8.93	14.5	17.5	23.9	30.5	37.4	51.7	62.9
95.0	0.256	1.81	4.22	7.14	14.0	0.256	1.78	4.09	6.83	13.1	19.9	23.5	30.8	38.4	46.2	62.2	74.5
90.0	0.525	2.69	5.64	9.03	16.6	0.527	2.66	5.51	8.72	15.8	23.3	27.2	35.1	43.2	51.5	68.4	81.2
75.0	1.43	4.81	8.70	12.8	21.6	1.44	4.81	8.64	12.7	21.1	29.8	34.2	43.1	52.1	61.2	79.5	93.4
50.0	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	108
25.0	6.70	12.9	18.7	24.2	34.8	6.93	13.5	19.6	25.5	37.1	48.4	54.0	65.1	76.1	87.0	109	125
10.0	10.9	18.1	24.5	30.4	41.5	11.5	19.4	26.6	33.4	46.4	58.9	65.0	77.0	88.9	101	124	141
5.0	13.9	21.6	28.3	34.4	45.6	15.0	23.7	31.5	38.8	52.6	65.7	72.2	84.8	97.2	109	133	151
1.0	20.6	28.9	35.8	42.1	53.2	23.0	33.2	42.0	50.2	65.5	80.0	87.0	101	114	127	153	172
	1.0	4.0	6.5	10	<del>X</del>	1.0	4.0	6.5	10	15	<del>X</del>	25	<del>X</del>	40	<del>X</del>	65	<del>X</del>
	Acceptable Quality Levels (tightened inspection)																

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

Sampling Plans.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																												Cumulative sample size																							
		Less than 0.65		0.65		1.0		X		1.5		2.5		4.0		6.5		10		15		X		25		X		40			X		65		Higher than 65																		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re																	
Single	20	▽	0	1																													△	20																			
Double	13	▽	*		Use code Letter E	Use code Letter H	Use code Letter G	0		2		0		3		1		4		2		5		3		7		3		7		5		9		6		10		7		11		9		14		11		16		△	13
	26							1		2		3		4		4		5		6		7		8		9		11		12		12		13		15		16		18		19		23		24		26		27			26
Multiple	5	▽	*					*	2	*	2	*	3	*	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9														△	5									
	10							*	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14																		10						
	15							0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19																			15					
	20							0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25																				20				
	25							1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29																				25				
	30							1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33																					30			
35							2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38																					35				
		Less than 1.0	1.0	X	1.5	2.5	4.0	6.5	10	15	X	25	X	40	X	65	X	Higher than 65	Acceptable Quality Levels (tightened inspection)																																		

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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.
- Ac = Acceptance number
- Re = Rejection number
- \* = Use single sampling plan above (or alternatively use code letter J)
- = Acceptance not permitted at this sample size.

**F**

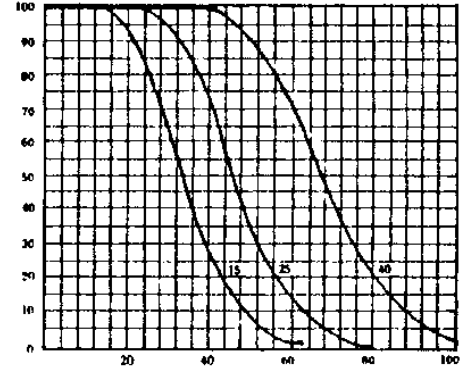
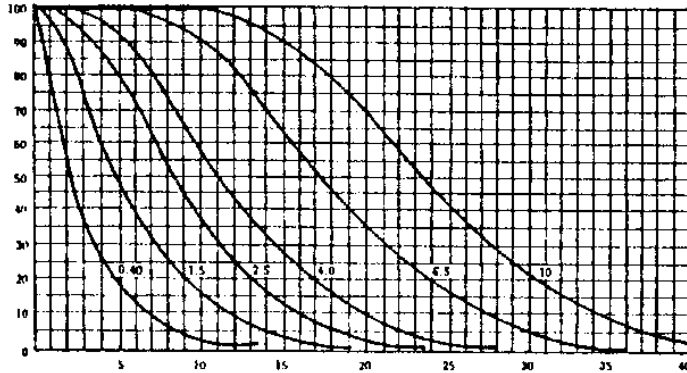
**G**

**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)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED ( $P_a$ )



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

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

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

$P_a$	Acceptable Quality Levels (normal inspection)																	
	0.40	1.5	2.5	4.0	6.5	10	0.40	1.5	2.5	4.0	6.5	10	×	15	×	25	×	40
	p (in percent defective)						p (in defects per hundred units)											
99.0	0.0314	0.471	1.40	2.67	5.88	9.73	0.0314	0.464	1.36	2.57	5.58	9.08	11.0	14.9	19.1	23.4	32.3	39.3
95.0	0.160	1.12	2.60	4.38	8.50	13.1	0.160	1.11	2.56	4.27	8.17	12.4	14.7	19.3	24.0	28.9	38.9	46.5
90.0	0.329	1.67	3.49	5.56	10.2	15.1	0.329	1.66	3.44	5.45	9.85	14.6	17.0	21.9	27.0	32.2	42.7	50.8
75.0	0.895	3.01	5.42	7.98	13.4	19.0	0.899	3.00	5.40	7.92	13.2	18.6	21.4	26.9	32.6	38.2	49.7	58.4
50.0	2.14	5.19	8.27	11.4	17.5	23.7	2.17	5.24	8.36	11.5	17.7	24.0	27.1	33.3	39.6	45.8	58.3	67.7
25.0	4.24	8.19	11.9	15.4	22.3	29.0	4.33	8.41	12.3	16.0	23.2	30.3	33.8	40.7	47.6	54.4	67.9	78.0
10.0	6.94	11.6	15.8	19.7	27.1	34.1	7.20	12.2	16.6	20.9	29.0	36.8	40.6	48.1	55.6	62.9	77.4	88.1
5.0	8.94	14.0	18.4	22.5	30.1	37.2	9.36	14.8	19.7	24.2	32.9	41.1	45.1	53.0	60.8	68.4	83.4	94.5
1.0	13.4	19.0	23.8	28.1	36.0	43.2	14.4	20.7	26.3	31.4	41.0	50.0	54.4	63.0	71.3	79.5	95.6	107
	0.65	2.5	4.0	6.5	10	×	0.65	2.5	4.0	6.5	10	×	15	×	25	×	40	×

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

Sampling Plans.

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

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

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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.
- Ac = Acceptance number.
- Re = Rejection number.
- \* = Use single sampling plan above (or alternatively use code letter K)
- # = Acceptance not permitted at this sample size.

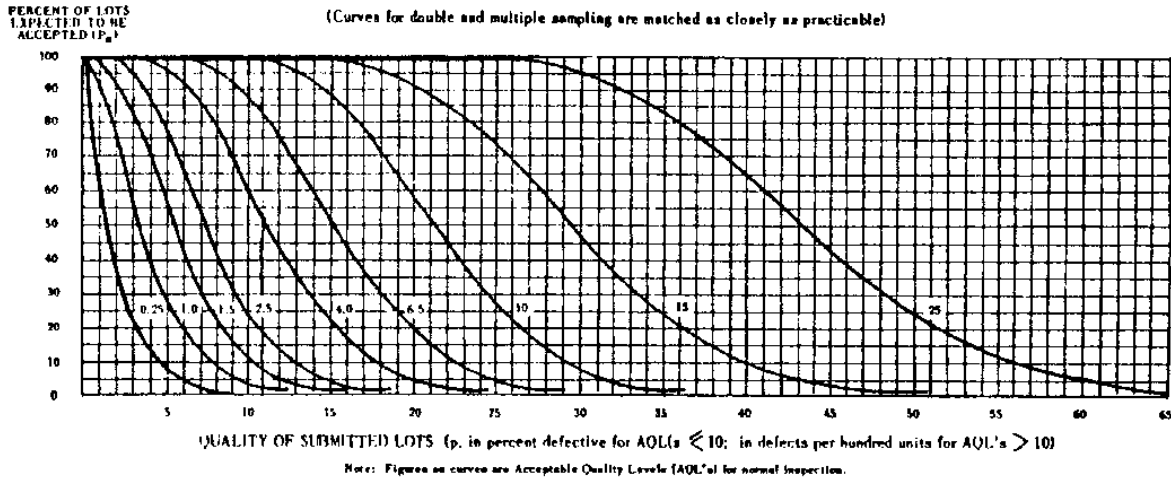
G

# H

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

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

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



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

P <sub>0</sub>	Acceptable Quality Levels (normal inspection)																			
	0.25	1.0	1.5	2.5	4.0	6.5	×	10	0.25	1.0	1.5	2.5	4.0	6.5	×	10	×	15	×	25
	p (in percent defective)								p (in defects per hundred units)											
99.0	0.0201	0.300	0.886	1.68	3.69	6.07	7.36	10.1	0.0201	0.297	0.872	1.65	3.57	5.81	7.01	9.54	12.2	15.0	20.7	25.1
95.0	0.103	0.715	1.66	2.78	5.36	8.22	9.72	12.9	0.103	0.711	1.64	2.73	5.23	7.96	9.39	12.3	15.4	18.5	24.9	29.8
90.0	0.210	1.07	2.22	3.53	6.43	9.54	11.2	14.5	0.211	1.06	2.20	3.49	6.30	9.31	10.9	14.0	17.3	20.6	27.3	32.5
75.0	0.574	1.92	3.46	5.10	8.51	12.0	13.8	17.5	0.575	1.92	3.45	5.07	8.44	11.9	13.7	17.2	20.8	24.5	31.8	37.4
50.0	1.38	3.33	5.31	7.29	11.3	15.2	17.2	21.2	1.39	3.36	5.35	7.34	11.3	15.3	17.3	21.3	25.3	29.3	37.3	43.3
25.0	2.73	5.29	7.69	10.0	14.5	18.8	21.0	25.2	2.77	5.39	7.84	10.2	14.8	19.4	21.6	26.0	30.4	34.8	43.5	49.9
10.0	4.50	7.56	10.3	12.9	17.8	22.4	24.7	29.1	4.61	7.78	10.6	13.4	18.5	23.5	26.0	30.8	35.6	40.3	49.5	56.4
5.0	5.82	9.14	12.1	14.8	19.9	24.7	27.0	31.6	5.99	9.49	12.6	15.5	21.0	26.3	28.9	33.9	38.9	43.8	53.4	60.5
1.0	8.00	12.6	15.8	18.7	24.2	29.2	31.7	36.3	9.21	13.3	16.8	20.1	26.2	32.0	34.8	40.3	45.6	50.9	61.2	68.7
0.40	1.5	2.5	4.0	6.5	×	10	×	×	0.40	1.5	2.5	4.0	6.5	×	10	×	15	×	25	×

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

Sampling Plans.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Cumulative sample size														
		Less than 0.25		0.25		0.40		X		0.65		1.0		1.5		2.5		4.0		6.5			X		10		X		15		X		25		Higher than 25	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	50	▽	0	1																													△	50		
Double	32	▽	*																														△	32		
	64				G	K	J																										△	64		
Multiple	13	▽	*																														△	13		
	26																																	△	26	
	39																																		△	39
	52																																		△	52
	65																																		△	65
	78																																		△	78
	91																																		△	91
		Less than 0.40	0.40	X	0.65	1.0	1.5	2.5	4.0	6.5	X	10	X	15	X	25	X	Higher than 25																		
Acceptable Quality Levels (tightened inspection)																																				

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H

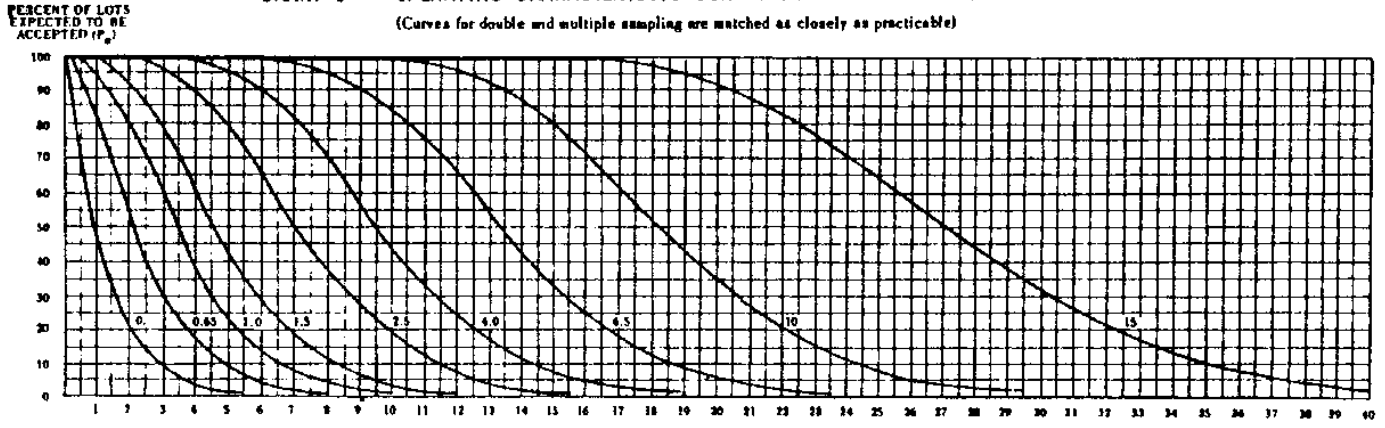
- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection number
- \* = Use single sampling plan above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

J

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

CHART J - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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



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

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

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

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)																					
	0.15	0.65	1.0	1.5	2.5	4.0	6.5	10	0.15	0.65	1.0	1.5	2.5	4.0	6.5	10	15					
	p (in percent defective)										p (in defects per hundred units)											
99.0	0.0126	0.187	0.550	1.04	2.28	3.73	4.51	6.17	7.88	9.76	0.0126	0.186	0.545	1.03	2.23	3.63	4.38	5.96	7.62	9.35	12.9	15.7
95.0	0.0641	0.446	1.03	1.73	3.32	5.07	6.00	7.93	9.89	11.9	0.0641	0.444	1.02	1.71	3.27	4.98	5.87	7.71	9.61	11.6	15.6	18.6
90.0	0.132	0.667	1.39	2.20	3.99	5.91	6.90	8.95	11.0	13.2	0.132	0.665	1.38	2.18	3.94	5.82	6.79	8.78	10.8	12.9	17.1	20.3
75.0	0.359	1.201	2.16	3.18	5.30	7.50	8.61	10.9	13.2	15.5	0.360	1.20	2.16	3.17	5.27	7.45	8.55	10.8	13.0	15.3	19.9	23.4
50.0	0.863	2.09	3.33	4.57	7.06	9.55	10.8	13.3	15.8	18.3	0.866	2.10	3.34	4.59	7.09	9.59	10.8	13.3	15.8	18.3	23.3	27.1
25.0	1.72	3.33	4.84	6.30	9.14	11.9	13.3	16.0	18.6	21.3	1.73	3.37	4.90	6.39	9.28	12.1	13.5	16.3	19.0	21.7	27.2	31.2
10.0	2.84	4.78	6.52	8.16	11.3	14.3	15.7	18.6	21.4	24.2	2.88	4.86	6.65	8.35	11.6	14.7	16.2	19.3	22.2	25.2	30.9	35.7
5.0	3.68	5.79	7.66	9.41	12.7	15.8	17.3	20.3	23.2	26.0	3.74	5.93	7.87	9.69	13.1	16.4	18.0	21.2	24.3	27.4	33.4	37.8
1.0	5.59	8.01	10.1	12.0	15.6	18.9	20.5	23.6	26.6	29.5	5.76	8.30	10.5	12.6	16.4	20.0	21.8	25.2	28.5	31.8	38.2	42.9
	0.25	1.0	1.5	2.5	4.0	6.5	10	15	20	25	0.25	1.0	1.5	2.5	4.0	6.5	10	15	20	25	30	35
	Acceptable Quality Levels (tightened inspection)																					

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

Sampling Plans.



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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Cumulative sample size														
		Less than 0.15		0.15		0.25		X		0.40		0.65		1.0		1.5		2.5		4.0			X		6.5		X		10		X		15		Higher than 15	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	80	▽	0	1	Use code Letter H	Use code Letter L	Use code Letter K	1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	△	80					
Double	50	▽	•	0				2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	△	50						
	100			1				2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27		100						
Multiple	20	▽	•	•	2	•	2	•	3	•	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	△	20									
	40			•	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14		40									
	60				0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	1	13	11	17	13	19		60								
	80				0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25		80								
	100				1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29		100								
	120				1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33		120								
140				2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38		140									
		Less than 0.25	0.25	X	0.40	0.65	1.0	1.5	2.5	4.0	X	6.5	X	10	X	15	X	Higher than 15	Acceptable Quality Levels (tightened inspection)																	

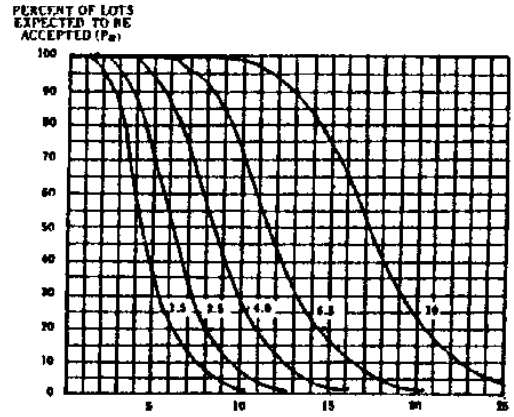
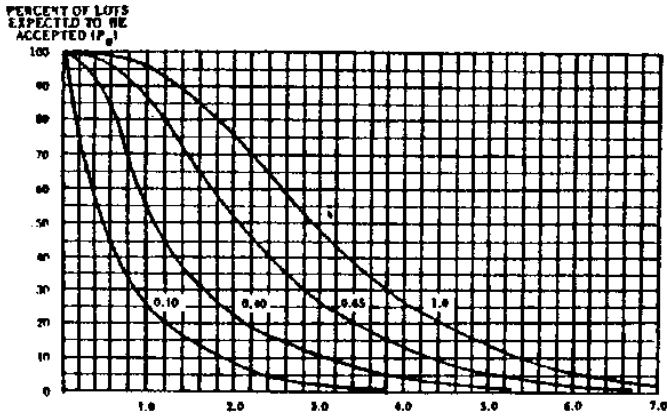
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- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection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

**K**

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

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



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

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

$P_a$	Acceptable Quality Levels (normal inspection)											
	0.10	0.40	0.65	1.0	1.5	2.5	×	4.0	×	6.5	×	10
p (in percent defective or defects per hundred units)												
99.0	0.00804	0.119	0.349	0.659	1.43	2.32	2.81	3.82	4.88	5.98	8.28	10.1
95.0	0.0410	0.284	0.654	1.09	2.09	3.18	3.76	4.94	6.15	7.40	9.95	11.9
90.0	0.0843	0.425	0.882	1.40	2.52	3.72	4.35	5.62	6.92	8.24	10.9	13.0
75.0	0.230	0.769	1.382	2.03	3.38	4.76	5.47	6.90	8.34	9.79	12.7	14.9
50.0	0.555	1.34	2.14	2.94	4.54	6.14	6.94	8.53	10.1	11.7	14.9	17.3
25.0	1.11	2.15	3.14	4.09	5.94	7.75	8.64	10.4	12.2	13.9	17.4	20.0
10.0	1.84	3.11	4.26	5.34	7.42	9.42	10.4	12.3	14.2	16.1	19.8	22.5
5.0	2.40	3.80	5.04	6.20	8.41	10.5	11.5	13.6	15.6	17.5	21.4	24.2
1.0	3.68	5.31	6.72	8.04	10.5	12.8	13.3	16.1	18.3	20.4	24.5	27.5
	0.15	0.65	1.0	1.5	2.5	×	4.0	×	6.5	×	10	×
Acceptable Quality Levels (tightened inspection)												

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

Sampling Plans.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																								Cumulative sample size										
		Less than 0.10		0.10		0.15		X		0.25		0.40		0.65		1.0		1.5		2.5		X		4.0			X		6.5		X		10		Higher than 10	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	125	▽	0	1							1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	△	125		
Double	80	▽	*		Use code Letter	Use code Letter	Use code Letter				0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	△	80		
	160				J	M	L				1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27		160		
Multiple	32	▽	*								#	2	#	2	#	3	#	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	△	32		
	64										#	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14		64		
	96										0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19		96		
	128										0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25		128		
	160										1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29		160		
	192										1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33		192		
224										2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38		224			
		Less than 0.15	0.15	X	0.25	0.40	0.65	1.0	1.5	2.5	X	4.0	X	6.5	X	10	X	Higher than 10	Acceptable Quality Levels (tightened inspection)																	

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

K

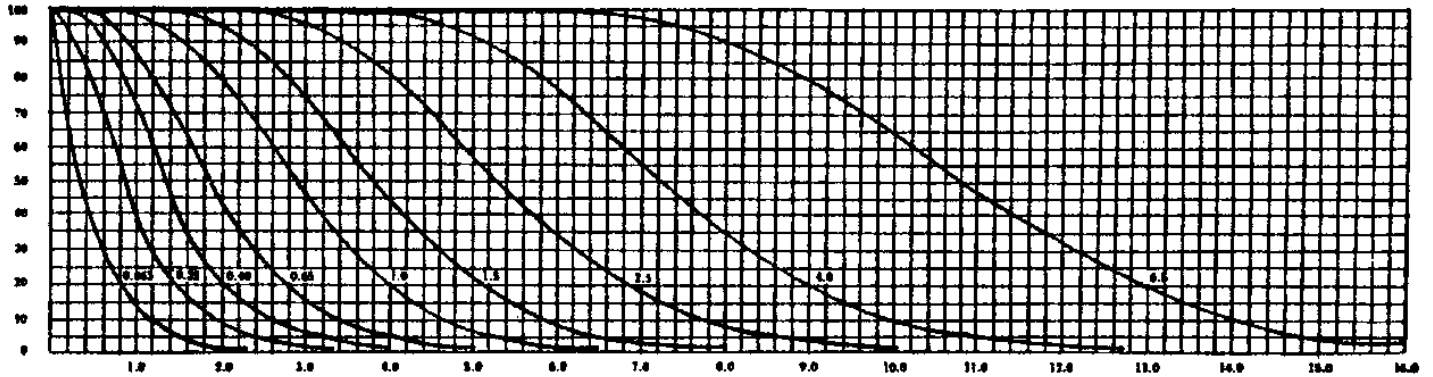
L

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

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

PERCENT OF LOTS EXPECTED TO BE ACCEPTED ( $P_a$ )



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

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

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

$P_a$	Acceptable Quality Levels (normal inspection)											
	0.065	0.25	0.40	0.65	1.0	1.5	×	2.5	×	4.0	×	6.5
$p$ (in percent defective or defects per hundred units)												
99.0	0.00903	0.075	0.218	0.412	0.893	1.65	1.75	2.39	3.05	3.74	5.17	6.29
95.0	0.0256	0.178	0.409	0.683	1.31	1.99	2.35	3.08	3.84	4.62	6.22	7.45
90.0	0.0527	0.266	0.551	0.872	1.50	2.33	2.72	3.51	4.32	5.15	6.84	8.12
75.0	0.144	0.481	0.864	1.27	2.11	2.90	3.42	4.31	5.21	6.12	7.95	9.34
50.0	0.347	0.839	1.34	1.84	2.84	3.84	4.33	5.33	6.33	7.33	9.33	10.8
25.0	0.693	1.35	1.96	2.55	3.71	4.83	5.40	6.51	7.61	8.70	10.9	12.5
10.0	1.15	1.94	2.66	3.34	4.64	5.89	6.50	7.70	8.89	10.1	12.4	14.1
5.0	1.50	2.37	3.15	3.80	5.25	6.57	7.22	8.48	9.72	10.9	13.3	15.1
1.0	2.30	3.32	4.20	5.02	6.55	8.00	8.70	10.1	11.4	12.7	15.3	17.2
	0.10	0.40	0.65	1.0	1.5	×	2.5	×	4.0	×	6.5	×
Acceptable Quality Levels (tightened inspection)												

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

Sampling Plans.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Cumulative sample size														
		Less than 0.065		0.065		0.10		X		0.15		0.25		0.40		0.65		1.0		1.5			X		2.5		X		4.0		X		6.5		Higher than 6.5	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	200	▽	0	1							1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	△	200		
	125	▽	*	Use code Letter K	Use code Letter N	Use code Letter M	0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	△	125	250					
250	1						2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27									
Multiple	50	▽	*	K	N	M	#	2	#	2	#	3	#	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	△	50						
	100						#	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14			100					
	150						0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19				150				
	200						0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25					200			
	250						1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29						250		
	300						1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33							300	
350	2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38	350													
		Less than 0.10	0.10	X	0.15	0.25	0.40	0.65	1.0	1.5	X	2.5	X	4.0	X	6.5	X	Higher than 6.5																		
Acceptable Quality Levels (tightened inspection)																																				

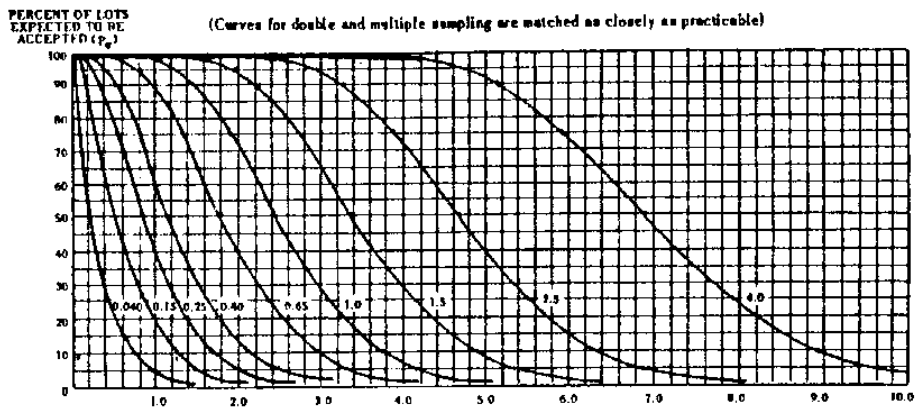
- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
- ▽ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
- Ac = Acceptance number
- Re = Rejection number
- \* = Use single sampling plan above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

L

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

M

CHART M - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS



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

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

$P_a$	Acceptable Quality Levels (normal inspection)											
	0.040	0.15	0.25	0.40	0.65	1.0	×	1.5	×	2.5	×	4.0
p (in percent defective or in defects per hundred units)												
99.0	0.00319	0.0472	0.138	0.261	0.567	0.923	1.11	1.51	1.94	2.37	3.28	3.99
95.0	0.0163	0.113	0.260	0.434	0.830	1.26	1.49	1.96	2.44	2.94	3.95	4.73
90.0	0.0335	0.169	0.350	0.534	1.00	1.48	1.72	2.23	2.74	3.27	4.34	5.16
75.0	0.0913	0.305	0.548	0.805	1.34	1.89	2.17	2.74	3.31	3.89	5.05	5.93
50.0	0.220	0.533	0.849	1.17	1.80	2.43	2.75	3.39	4.02	4.66	5.93	6.88
25.0	0.440	0.855	1.24	1.62	2.36	3.07	3.43	4.13	4.83	5.52	6.90	7.92
10.0	0.731	1.23	1.69	2.12	2.94	3.74	4.13	4.89	5.64	6.39	7.86	8.95
5.0	0.951	1.51	2.00	2.46	3.34	4.17	4.58	5.38	6.17	6.95	8.47	9.60
1.0	1.46	2.11	2.67	3.19	4.16	5.08	5.52	6.40	7.24	8.08	9.71	10.9
	0.065	0.25	0.40	0.65	1.0	×	1.5	×	2.5	×	4.0	×

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

Sampling Plans.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Cumulative sample size														
		Less than 0.010		0.040		0.065		X		0.10		0.15		0.25		0.40		0.65		1.0			X		1.5		X		2.5		X		4.0		Higher than 4.0	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	315	▽	0	1							1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	△	315		
Double	200	▽	*		Use code Letter L	Use code Letter P	Use code Letter N	0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16			△	200			
	400							1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27					△	400	
Multiple	80	▽	*					#	2	#	2	#	3	#	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9			△	80			
	160							#	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14				△	160		
	240							0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19				△	240		
	320							0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25				△	320		
	400							1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29				△	400		
	480							1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33				△	480		
	560							2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38				△	560		
		Less than 0.065	0.065	X	0.10	0.15	0.25	0.40	0.65	1.0	X	1.5	X	2.5	X	4.0	X	Higher than 4.0	Acceptable Quality Levels (tightened inspection)																	

M

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

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

N

CHART N - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

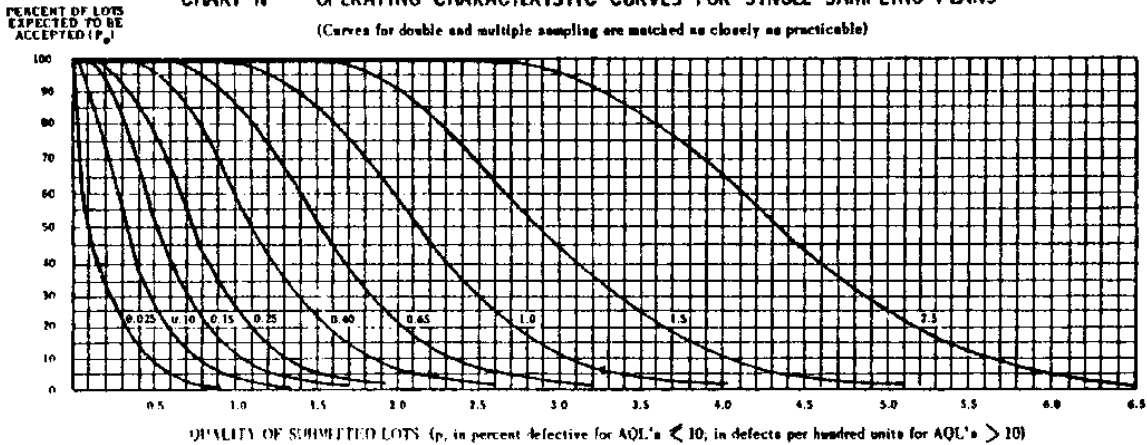


TABLE X-N-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)											
	0.025	0.10	0.15	0.25	0.40	0.65	×	1.0	×	1.5	×	2.5
p (in percent defective or in defects per hundred units)												
99.0	0.00201	0.0297	0.0872	0.165	0.357	0.581	0.701	0.954	1.22	1.50	2.07	2.51
95.0	0.0103	0.111	0.164	0.273	0.523	0.796	0.939	1.23	1.54	1.85	2.49	2.98
90.0	0.0211	0.106	0.220	0.349	0.630	0.931	1.09	1.40	1.73	2.06	2.73	3.25
75.0	0.0575	0.192	0.345	0.507	0.844	1.19	1.37	1.72	2.08	2.45	3.18	3.74
50.0	0.139	0.336	0.535	0.734	1.13	1.53	1.73	2.13	2.53	2.93	3.73	4.33
25.0	0.277	0.539	0.784	1.02	1.48	1.94	2.16	2.60	3.04	3.48	4.35	4.99
10.0	0.461	0.778	1.06	1.34	1.85	2.35	2.60	3.08	3.56	4.03	4.95	5.64
5.0	0.599	0.949	1.26	1.55	2.10	2.63	2.89	3.39	3.89	4.38	5.34	6.05
1.0	0.921	1.33	1.68	2.01	2.62	3.20	3.48	4.03	4.56	5.09	6.12	6.87
	0.040	0.15	0.25	0.40	0.65	×	1.0	×	1.5	×	2.5	×
Acceptable Quality Levels (tightened inspection)												

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

Sampling Plans.



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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																								Cumulative sample size																
		Less than 0.025		0.025		0.040		X		0.065		0.10		0.15		0.25		0.40		0.65		X		1.0			X		1.5		X		2.5		Higher than 2.5							
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re								
Single	500	▽	0	1							1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	18	19	21	22	△	500								
Double	315	▽	•	N	Q	P	Use code Letter		Use code Letter		Use code Letter		0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	△	315						
	630						1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27												630		
Multiple	125	▽	•	N	Q	P	Use code Letter		Use code Letter		Use code Letter		#	2	#	2	#	3	#	4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	△	125						
	250						#	2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14											250			
	375						0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19												375		
	500						0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25													500	
	625						1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29														625
	750						1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33														750
875	2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38														875						
	Less than 0.040		0.040		X		0.065		0.10		0.15		0.25		0.40		0.65		X		1.0		X		1.5		X		2.5		X		Higher than 2.5									
Acceptable Quality Levels (tightened inspection)																																										

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

N

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

P

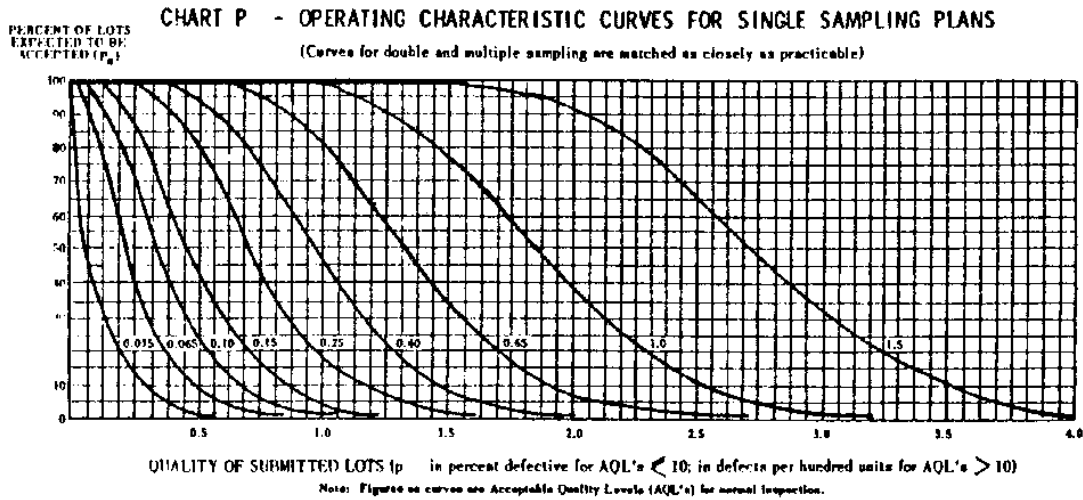


TABLE X-P-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

$P_a$	Acceptable Quality Levels (normal inspection)											
	0.015	0.065	0.10	0.15	0.25	0.40	×	0.65	×	1.0	×	1.5
$p$ (in percent defective or defects per hundred units)												
99.0	0.00126	0.0186	0.0545	0.103	0.223	0.363	0.438	0.596	0.762	0.935	1.29	1.57
95.0	0.00641	0.0444	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.16	1.56	1.86
90.0	0.0132	0.0665	0.138	0.218	0.394	0.582	0.679	0.878	1.08	1.29	1.71	2.03
75.0	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	1.08	1.33	1.58	1.83	2.33	2.71
25.0	0.173	0.337	0.490	0.639	0.928	1.21	1.35	1.63	1.90	2.17	2.72	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	0.374	0.593	0.787	0.969	1.31	1.64	1.80	2.12	2.43	2.74	3.34	3.78
1.0	0.576	0.830	1.05	1.26	1.64	2.00	2.18	2.52	2.85	3.18	3.82	4.29
	0.025	0.10	0.15	0.25	0.40	×	0.65	×	1.0	×	1.5	×
Acceptable Quality Levels (tightened inspection)												

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

Sampling Plans.

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

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

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

**P**

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

Q

CHART Q - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

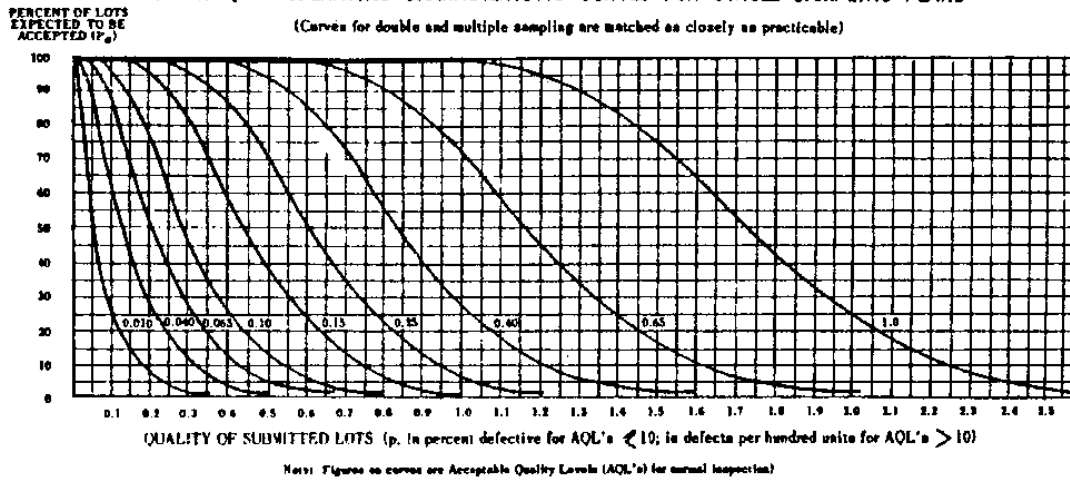


TABLE X-Q-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)											
	0.010	0.040	0.065	0.10	0.15	0.25	×	0.40	×	0.65	×	1.0
p (in percent defective or defects per hundred units)												
99.0	0.000804	0.0119	0.0349	0.0659	0.143	0.232	0.281	0.382	0.488	0.598	0.828	1.01
95.0	0.00410	0.0284	0.0654	0.109	0.209	0.318	0.376	0.494	0.615	0.740	0.995	1.19
90.0	0.00843	0.0425	0.0882	0.140	0.252	0.372	0.435	0.562	0.692	0.824	1.09	1.30
75.0	0.0230	0.0769	0.138	0.203	0.338	0.476	0.547	0.690	0.834	0.979	1.27	1.49
50.0	0.0555	0.134	0.214	0.294	0.454	0.614	0.694	0.853	1.01	1.17	1.49	1.73
25.0	0.111	0.215	0.314	0.409	0.594	0.775	0.864	1.04	1.22	1.39	1.74	2.00
10.0	0.184	0.311	0.426	0.534	0.742	0.942	1.04	1.23	1.42	1.61	1.98	2.25
5.0	0.240	0.380	0.504	0.620	0.841	1.05	1.15	1.36	1.56	1.75	2.14	2.42
1.0	0.368	0.531	0.672	0.804	1.05	1.28	1.39	1.61	1.83	2.04	2.45	2.75
	0.015	0.065	0.10	0.15	0.25	×	0.40	×	0.65	×	1.0	×
Acceptable Quality Levels (tightened inspection)												

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

Sampling Plans.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																				Cumulative sample size														
		X		0.010		0.015		X		0.025		0.040		0.065		0.10		0.15		0.25			X		0.40		X		0.65		X		1.0		Higher than 1.0	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		
Single	1250			0	1																													△	1250	
Double	800				*																													△	800	
	1600																																			1600
Multiple	315				*																													△	315	
	630																																			630
	945																																			945
	1260																																			1260
	1575																																			1575
	1890																																			1890
	2205																																			2205
				0.010	0.015	X		0.025	0.040	0.065	0.10	0.15	0.25	X		0.40	X	0.65	X	1.0	X													Higher than 1.0		
Acceptable Quality Levels (tightened inspection)																																				

MIL-STD-105E

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

R

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

CHART R - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

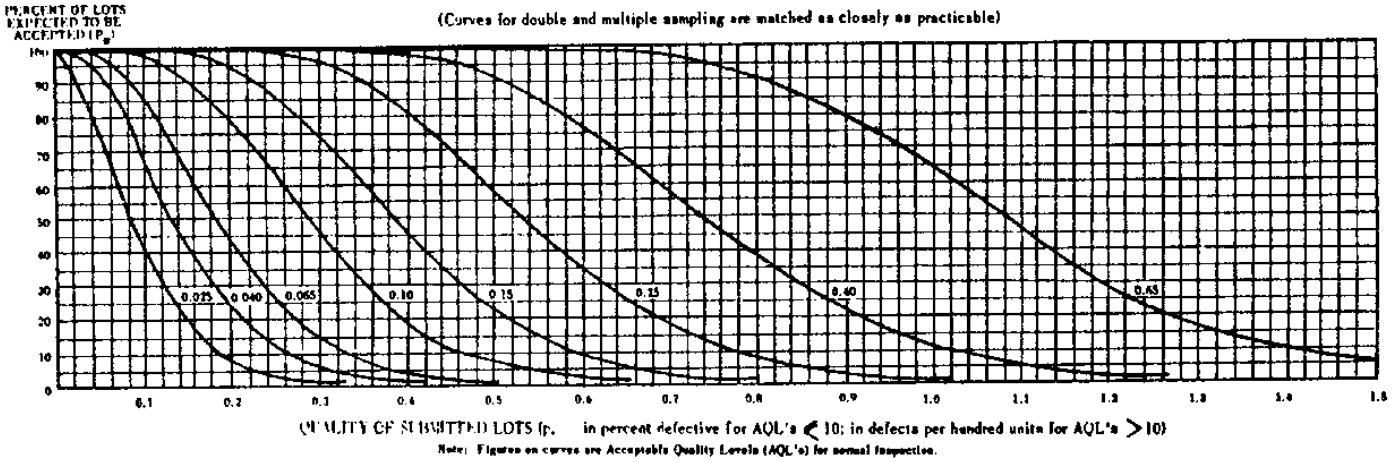


TABLE X-R-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P <sub>a</sub>	Acceptable Quality Levels (normal inspection)										
	0.025	0.040	0.065	0.10	0.15	×	0.25	×	0.40	×	0.65
p (in percent defective or defects per hundred units)											
99.0	0.00743	0.0218	0.0412	0.0892	0.145	0.175	0.239	0.305	0.374	0.517	0.629
95.0	0.0178	0.0409	0.0683	0.131	0.199	0.235	0.309	0.384	0.462	0.622	0.745
90.0	0.0266	0.0551	0.0872	0.158	0.233	0.272	0.351	0.432	0.515	0.684	0.812
75.0	0.0481	0.0864	0.127	0.211	0.298	0.342	0.431	0.521	0.612	0.795	0.934
50.0	0.0839	0.134	0.181	0.284	0.383	0.433	0.533	0.633	0.733	0.933	1.08
25.0	0.135	0.196	0.255	0.371	0.484	0.540	0.651	0.761	0.870	1.09	1.25
10.0	0.194	0.266	0.334	0.464	0.589	0.650	0.770	0.889	1.01	1.24	1.41
5.0	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	1.72
	0.040	0.065	0.10	0.15	×	0.25	×	0.40	×	0.65	×
Acceptable Quality Levels (tightened inspection)											

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

Sampling Plans.

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Levels (normal inspection)																												Cumulative sample size				
		X		0.010		0.015		X		0.025		0.040		0.065		0.10		0.15		X		0.25		X		0.40		X			0.65		Higher than 0.65	
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re		Ac	Re	Ac	Re
Single	2000	0	1	Use code Letter		Use code Letter		Use code Letter		1	2	2	3	3	4	5	6	7	8	8	9	10	11	12	13	14	15	16	19	21	22	△	2000	
Double	1250	•	Use code Letter		Use code Letter		Use code Letter		0	2	0	3	1	4	2	5	3	7	3	7	5	9	6	10	7	11	9	14	11	16	△	1250		
	2500		Q	P	S	1	2	3	4	4	5	6	7	8	9	11	12	12	13	15	16	18	19	23	24	26	27	△	2500					
Multiple	500	•	Use code Letter		Use code Letter		Use code Letter		* 2	* 2	* 3	* 4	0	4	0	4	0	5	0	6	1	7	1	8	2	9	△	500						
	1000		* 2	0	3	0	3	1	5	1	6	2	7	3	8	3	9	4	10	6	12	7	14	△	1000									
	1500		0	2	0	3	1	4	2	6	3	8	4	9	6	10	7	12	8	13	11	17	13	19	△	1500								
	2000		0	3	1	4	2	5	3	7	5	10	6	11	8	13	10	15	12	17	16	22	19	25	△	2000								
	2500		1	3	2	4	3	6	5	8	7	11	9	12	11	15	14	17	17	20	22	25	25	29	△	2500								
	3000		1	3	3	5	4	6	7	9	10	12	12	14	14	17	18	20	21	23	27	29	31	33	△	3000								
3500	2	3	4	5	6	7	9	10	13	14	14	15	18	19	21	22	25	26	32	33	37	38	△	3500										
		0.010	0.015	X		0.025	0.040	0.065	0.10	0.15	X		0.25	X		0.40	X		0.65	X		Higher than 0.65												
Acceptable Quality Levels (tightened inspection)																																		

- △ = Use next preceding sample size code letter for which acceptance and rejection numbers are available.
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- \* = Use single sampling plan above.
- # = Acceptance not permitted at this sample size.

R

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

S

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

Ac = Acceptance number

Re = Rejection number

# = Acceptance not permitted at this sample size.





6. NOTES

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

6.2 Subject Term (Key Word) Listing.

Acceptable Quality Level (AQL)

Average Outgoing Quality (AOQ)

Defect

Defective

Lot or Batch

Process Average

Sample

Sampling Plan

Unit of Product

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

CONCLUDING MATERIAL

Custodians:

Army - AR  
Navy - OS  
Air Force - 23

Preparing Activity:

Army - AR

Review Activities:

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

(Project QCIC-0085)

User Activities:

Army - ME  
DLA - ES, SS