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SAMPLING PROCEDURES AND TABLES
FOR INSPECTION BY ATTRIBUTES

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DEPARTMENT OF DEFENSE
Washington 25, D. C.

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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1. This standard has been approved by the Department of Defense and is
mandatory for use by the Departments of the Army, the Navy, the Air Force
and the Defense Supply Agency. This revision supersedes MIL-STD-105C,
dated 18 July 1961.

2. This publication provides sampling procedures and reference tables
for use in planning and conducting inspection by attributes. This
publication was developed by a working group representing the military
services of Canada, the United Kingdom and the United States of America
with the assistance and cooperation of American and European organizations
for quality control. The international designation of this document is
ABC-STD-105. When revision or cancellation of this standard is proposed,
the departmental custodians will inform their respective Departmental
Standardization Office so that appropriate action may be taken respecting
the international agreement concerned.

3. The U.S. Army Munitions Command is designated as preparing activity for
this standard. Recommended corrections, additions, or deletions should be
addressed to the Commanding Officer, U. S. Army CBR Engineering Office,
Attn: SMUCE-ED-S, Army Chemical Center, Maryland.

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SAMPLING PROCEDURES AND TABLES

FOR INSPECTION BY ATTRIBUTES

1. SCOPE

1.1 PURPOSE. This publication establishes sampling plans and procedures for inspection by attributes. When specified by the responsible authority, this publication shall be referenced in the specification, contract, inspection instructions, or other documents and the provisions set forth herein shall govern. The "responsible authority" shall be designated in one of the above documents.

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

a. End items.

b. Components and raw materials.

c. Operations.

d. Materials in process.

e. Supplies in storage.

f. Maintenance operations.

g. Data or records.

h. Administrative procedures.

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

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

1.3 INSPECTION. Inspection is the process of measuring, examining, testing, or otherwise comparing the unit of product (see 1.5) with the requirements.

1.4 INSPECTION BY ATTRIBUTES. Inspection by attributes is inspection whereby either the unit of product is classified simply as defective or nondefective, or the number of defects in the unit of product is counted, with respect to a given requirement or set of requirements.

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

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2. CLASSIFICATION OF DEFECTS AND DEFECTIVES

2.1 METHOD OF CLASSIFYING DEFECTS.

A classification of defects is the enumeration of possible defects of the unit of product classified according to their seriousness. A defect is any nonconformance of the unit of product with specified requirements. Defects will normally be grouped into one or more of the following classes; however, defects may be grouped into other classes, or into subclasses within these classes.

2.1.1 CRITICAL DEFECT.

A critical defect is a defect that judgment and experience indicate is likely to result in hazardous or unsafe conditions f o r individuals using, maintaining, or depending upon the product; or a defect that judgment and experience indicate is likely to prevent performance of the tactical function of a major end item such as a ship, aircraft, tank, missile or space vehicle. NOTE: For a special provision relating to critical defects, see 6.3.

2.1.2 MAJOR DEFECT.

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

2.1.3 MINOR DEFECT.

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

2.2 METHOD OF CLASSIFYING DEFECTIVES.

A defective is a unit of product which contains one or more defects. Defectives will usually be classified as follows:

2.2.1 CRITICAL DEFECTIVE.

A critical defective contains one or more critical defects and may also contain major and or minor defects. NOTE: For a special provision relating to critical defectives, see 6.3.

2.2.2 MAJOR DEFECTIVE.

A major defective contains one or more major defects, and may also contain minor defects but contains no critical defect.

2.2.3 MINOR DEFECTIVE.

A minor defective contains one or more minor defects but contains no critical or major defect.

3. PERCENT DEFECTIVE AND DEFECTS PER HUNDRED UNITS

3.1 EXPRESSION OF NONCONFORMANCE.

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

3.2 PERCENT DEFECTIVE.

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

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

3.3 DEFECTS PER HUNDRED UNITS.

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

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

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4. ACCEPTABLE QUALITY LEVEL (AQL)

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

4.2 DEFINITION. The AQL is the maximum percent defective (or the maximum number of defects per hundred units) that, for purposes of sampling inspection, can be considered satisfactory as a process average (see 11.2).

4.3 NOTE ON THE MEANING OF AQL. When a consumer designates some specific value of AQL for a certain defect or group of defects, he indicates to the supplier that his (the consumer's) acceptance sampling plan will accept the great majority of the lots or batches that the supplier submits, provided the process average level of percent defective (or defects per hundred units) in these lots or batches be no greater than the designated value of AQL. Thus, the AQL is a designated value of percent defective (or defects per hundred units) that the consumer indicates will be accepted most of the time by the acceptance sampling procedure to be used. The sampling plans provided herein are so arranged that the probability of acceptance at the designated AQL value depends upon the sample size, being generally higher for large samples than for small ones, for a given AQL. The AQL alone does not describe the protection to the consumer for individual lots or batches but more directly relates to what might be expected from a series of lots or batches, provided the steps indicated in this publication are taken. It is necessary to refer to the operating characteristic curve of the plan, to determine what protection the consumer will have.

4.4 LIMITATION. The designation of an AQL shall not imply that the supplier has the right to supply knowingly any defective unit of product.

4.5 SPECIFYING AQLs. The AQL to be used will be designated in the contract or by the responsible authority. Different AQLs may be designated for groups of defects considered collectively, or for individual defects. An AQL for a group of defects may be designated in addition to AQLs for individual defects, or subgroups, within that group. AQL values of 10.0 or less may be expressed either in percent defective or in defects per hundred units; those over 10.0 shall be expressed in defects per hundred units only.

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

5. SUBMISSION OF PRODUCT

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

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

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5. SUBMISSION OF PRODUCT (Continued)

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

5.3 LOT OR BATCH SIZE. The lot or batch size is the number of units of product in a lot or batch.

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

6. ACCEPTANCE AND REJECTION

6.1 ACCEPTABILITY OF LOTS OR BATCHES. Acceptability of a lot or batch will be determined by the use of a sampling plan or plans associated with the designated AQL or AQLs.

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

6.3 SPECIAL RESERVATION FOR CRITICAL DEFECTS. The supplier may be required at the discretion of the responsible authority to inspect every unit of the lot or batch for critical defects. The right is reserved to inspect every unit submitted by the supplier for critical defects, and to reject the lot or batch immediately, when a critical defect is found. The right is reserved also to sample, for critical defects, every lot or batch submitted by the supplier and to reject any lot or batch if a sample drawn therefrom is found to contain one or more critical defects.

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

7. DRAWING OF SAMPLES

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

7.2 REPRESENTATIVE SAMPLING. When appropriate, the number of units in the sample shall be selected in proportion to the size of sublots or subbatches, or parts of the lot or batch, identified by some rational criterion.

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7. DRAWING OF SAMPLES (Continued)

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

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

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

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

8. NORMAL, TIGHTENED AND REDUCED INSPECTION

8.1 INITIATION OF INSPECTION. Normal inspection will be used at the start of inspection unless otherwise directed by the responsible authority.

8.2 CONTINUATION OF INSPECTION. Normal, tightened or reduced inspection shall continue unchanged for each class of defects or defectives on successive lots or batchs except where the switching procedures given below require change. The switching procedures given below require a change. The switching procedures shall be applied to each class of defects or defectives independently.

8.3 SWITCHING PROCEDURES.

8.3.1 NORMAL TO TIGHTENED. When normal inspection is in effect, tightened inspection shall be instituted when 2 out of 5 consecutive lots or batches have been rejected on original inspection (i.e., ignoring resubmitted lots or batches for this procedure).

8.3.2 TIGHTENED TO NORMAL. When tightened inspection is in effect, normal inspection shall be instituted when 5 consecutive lots or batches have been considered acceptable on original inspection.

8.3.3 NORMAL TO REDUCED. When normal inspection is in effect, reduced inspection shall be instituted providing that all of the following conditions are satisfied:

a. The preceding 10 lots or batches (or more, as indicated by the note to Table VIII) have been on normal inspection and none has been rejected on original inspection; and

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

c. Production is at a steady rate; and

d. Reduced inspection is considered desirable by the responsible authority.

8.3.4 REDUCED TO NORMAL. When reduced inspection is in effect, normal inspection shall be instituted if any of the following occur on original inspection:

a. A lot or batch is rejected; or

b. A lot or batch is considered acceptable under the procedures of 10.1.4; or

c. Production becomes irregular or delayed; or

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

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

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9. SAMPLING PLANS

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

9.2 INSPECTION LEVEL. The inspection level determines the relationship between the lot or batch size and the sample size. The inspection level to be used for any particular requirement will be prescribed by the responsible authority. Three inspection levels: I, II, and III, are given in Table I for general use. Unless otherwise specified. Inspection Level II will be used. However, Inspection Level I may be specified when less discrimination is needed, or Level III may be specified for greater discrimination. Four additional special levels: S-1, S-2, S-3 and S-4, are given in the same table and may be used where relatively small sample sizes are necessary and large sampling risks can or must be tolerated.

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

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

9.4 OBTAINING SAMPLING PLAN. The AQL and the code letter shall be used to 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 when designated or approved by the responsible authority. As an alternative to a single sampling plan with an acceptance number of 0, the plan with an acceptance number of 1 with its correspondingly larger sample size for a designated AQL (where available), may be used when designated or approved by the responsible authority.

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

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10. DETERMINATION OF ACCEPTABILITY

10.1 PERCENT DEFECTIVE INSPECTION.
To determine acceptability of a lot or batch under percent defective inspection, the applicable sampling plan shall be used in accordance with 10.1.1, 10.1.2, 10.1.3, 10.1.4, and 10.1.5.

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

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

10.1.3 MULTIPLE SAMPLE PLAN. Under multiple sampling, the procedure shall be similar to that specified in 10.1.2, except that the number of successive samples required to reach a decision may be more than two.

10.1.4 SPECIAL PROCEDURE FOR REDUCED INSPECTION. Under reduced inspection, the sampling procedure may terminate without either acceptance or rejection criteria having been met. In these circumstances, the lot or batch will be considered acceptable, but normal inspection will be reinstated starting with the next lot or batch (see 8.3.4 (b)).

10.2 DEFECTS PER HUNDRED UNITS 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."

11. SUPPLEMENTARY INFORMATION

11.1 OPERATING CHARACTERISTIC CURVES. The operating characteristic curves for normal inspection, shown in Table X (pages 30–62), indicate the percentage of lots or batches which may be expected to be accepted under the various sampling plans for a given process quality. The curves shown are for single sampling; curves for double and multiple sampling are matched as closely as practicable. The O. C. curves shown for AQLs greater than 10.0 are based on the Poisson distribution and are applicable for defects per hundred units inspection; those for AQLs of 10.0 or less and sample sizes of 80 or less are based on the binomial distribution and are applicable for percent defec-

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11. SUPPLEMENTARY INFORMATION (Continued)

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

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

11.3 AVERAGE OUTGOING QUALITY (AOQ). The AOQ is the average quality of outgoing product including all accepted lots or batches, plus all rejected lots or batches after the rejected lots or batches have been effectively 100 percent inspected and all defectives replaced by nondefectives.

11.4 AVERAGE OUTGOING QUALITY LIMIT (AOQL). The AOQL is the maximum of the AOQs for all possible incoming qualities for a given acceptance sampling plan. AOQL values are given in Table V-A for each of the single sampling plans for normal inspection and in Table V-B for each of the single sampling plans for tightened inspection.

11.5 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 a given process quality. The curves assume no curtailment of inspection and are approximate to the extent that they are based upon the Poisson distribution, and that the sample sizes for double and multiple sampling are assumed to be 0.631n and 0.25n respectively, where n is the equivalent single sample size.

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

TABLE 1 — *Sample size code letters*

(See 9.2 and 9.3)

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

CODE LETTERS

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

(See 9.4 and 9.5.)

Acceptable Quality Levels (normal inspection). Each cell shows "Ac Re" (Acceptance number / Rejection number). ↓ = use first sampling plan below arrow; ↑ = use first sampling plan above arrow.

Code	Sample size	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	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31
B	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45
C	5	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑
D	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑
E	13	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑
F	20	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑
G	32	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑
H	50	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑
J	80	↓	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑
K	125	↓	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑	↑
L	200	↓	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑	↑	↑
M	315	↓	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
N	500	↓	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
P	800	↓	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
Q	1250	↓	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
R	2000	↓	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑

⇩ = Use first sampling plan below arrow. If sample size equals, or exceeds, lot or batch size, do 100 percent inspection.

⇧ = Use first sampling plan above arrow.

Ac = Acceptance number.

Re = Rejection number.

SINGLE NORMAL

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

(See 9.4 and 9.5)

Acceptable Quality Levels (tightened inspection)

Sample size code letter	Sample size	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
A	2																																	0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19	27	28
B	3																											0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19	27	28	41	42
C	5																			0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19	27	28	41	42								
D	8																	0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19														
E	13															0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																
F	20													0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																		
G	32											0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																				
H	50									0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																						
J	80							0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																								
K	125					0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																										
L	200			0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																												
M	315	0	1	⇧		1	2	2	3	3	4	5	6	8	9	12	13	18	19																														
N	500	⇩		1	2	2	3	3	4	5	6	8	9	12	13	18	19																																
P	800	1	2	2	3	3	4	5	6	8	9	12	13	18	19																																		
Q	1250	2	3	3	4	5	6	8	9	12	13	18	19																																				
R	2000	3	4	5	6	8	9	12	13	18	19	⇧																																				
S	3150	5	6	8	9	12	13	18	19																																								

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

SINGLE TIGHTENED

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

Acceptable Quality Levels (reduced inspection)†

(See 9.4 and 9.5)

Sample size code letter	Sample size	0.010 Ac	Re	0.015 Ac	Re	0.025 Ac	Re	0.040 Ac	Re	0.065 Ac	Re	0.10 Ac	Re	0.15 Ac	Re	0.25 Ac	Re	0.40 Ac	Re	0.65 Ac	Re	1.0 Ac	Re	1.5 Ac	Re	2.5 Ac	Re	4.0 Ac	Re	6.5 Ac	Re	10 Ac	Re	15 Ac	Re	25 Ac	Re	40 Ac	Re	65 Ac	Re	100 Ac	Re	150 Ac	Re	250 Ac	Re	400 Ac	Re	650 Ac	Re	1000 Ac	Re
A	2																											0	1	⇩⇧		↓		1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22	30	31
B	2																									0	1	⇩⇧		↓		1	3	2	4	3	5	5	6	7	8	10	11	14	15	21	22	30	31
C	2																							0	1	⇩⇧		↓		1	4	2	5	3	6	5	8	7	10	10	13	14	17	21	24	↑		
D	3																					0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	14	17	21	24	↑			
E	5																			0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	14	17	21	24	↑					
F	8																	0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑									
G	13															0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑											
H	20													0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑												
J	32											0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑													
K	50									0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑														
L	80							0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑															
M	125					0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑																	
N	200			0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑																			
P	315	0	1	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑																					
Q	500	⇩⇧		↓		0	2	1	3	1	4	2	5	3	6	5	8	7	10	10	13	↑																							
R	800	↓		0	1	↑																																							

⟨⟩ = 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.
† = If the acceptance number has been exceeded, but the rejection number has not been reached, accept the lot, but reinstate normal inspection (see 10.1.4).

SINGLE
REDUCED

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

(See 9.4 and 9.5)

Acceptable Quality Levels (normal inspection)

Sample size code letter	Sample	Sample size	Cumulative sample size
A			
B	First / Second	2 / 2	2 / 4
C	First / Second	3 / 3	3 / 6
D	First / Second	5 / 5	5 / 10
E	First / Second	8 / 8	8 / 16
F	First / Second	13 / 13	13 / 26
G	First / Second	20 / 20	20 / 40
H	First / Second	32 / 32	32 / 64
J	First / Second	50 / 50	50 / 100
K	First / Second	80 / 80	80 / 160
L	First / Second	125 / 125	125 / 250
M	First / Second	200 / 200	200 / 400
N	First / Second	315 / 315	315 / 630
P	First / Second	500 / 500	500 / 1000
Q	First / Second	800 / 800	800 / 1600
R	First / Second	1250 / 1250	1250 / 2500

Legend:
⇩ ⇧ = 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 (or alternatively, use double sampling plan below, where available).

DOUBLE
NORMAL

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

(See 9.4 and 9.5)

**DOUBLE
TIGHTENED**

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

(See 9.4 and 9.5)

Acceptable Quality Levels (reduced inspection)†

= 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 (or 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 reinstate normal inspection (see 10.1.4).

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**DOUBLE
REDUCED**

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

(See 9.4 and 9.5)

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

(See 9.4 and 9.5)

= 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 (or alternatively, use multiple plan below, where available).
. = Acceptance not permitted at this sample size.

MULTIPLE NORMAL

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

(See 9.4 and 9.5)

Acceptable Quality Levels (tightened inspection)

■ Use first sampling plan below arrow (refer to continuation of table on following page, where necessary). 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 (or alternatively, use multiple sampling plan below, where available)
■ Use corresponding double sampling plan (or alternatively, use multiple sampling plan below, where available)
↓ Acceptance not permitted at this sample size

MULTIPLE TIGHTENED

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

(See 9.4 and 9.5)

Acceptable Quality Levels (tightened inspection)

Sample size code letter	Sample	Cumulative sample size
A	First, Second, Third, Fourth, Fifth, Sixth, Seventh	32, 64, 96, 128, 160, 192, 224
L	First, Second, Third, Fourth, Fifth, Sixth, Seventh	50, 100, 150, 200, 250, 300, 350
M	First, Second, Third, Fourth, Fifth, Sixth, Seventh	80, 160, 240, 320, 400, 480, 560
N	First, Second, Third, Fourth, Fifth, Sixth, Seventh	125, 250, 375, 500, 625, 750, 875
P	First, Second, Third, Fourth, Fifth, Sixth, Seventh	200, 400, 600, 800, 1000, 1200, 1400
Q	First, Second, Third, Fourth, Fifth, Sixth, Seventh	315, 630, 945, 1260, 1575, 1890, 2205
R	First, Second, Third, Fourth, Fifth, Sixth, Seventh	500, 1000, 1500, 2000, 2500, 3000, 3500
S	First, Second, Third, Fourth, Fifth, Sixth, Seventh	800, 1600, 2400, 3200, 4000, 4800, 5600

Sample size (each row): A = 32; L = 50; M = 80; N = 125; P = 200; Q = 315; R = 500; S = 800

↓ = 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 (or alternatively, use multiple sampling plan below, where available).
∗∗ = Acceptance not permitted at this sample size.

MULTIPLE TIGHTENED

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

(See 9.4 and 9.5)

Acceptable Quality Levels (reduced inspection) †

Ac = Acceptance number
Re = Rejection number

⇨ = Use first sampling plan below arrow (refer to continuation of table on following page, when necessary). 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 (or alternatively, use multiple sampling plan below, where available)
‡ = Use corresponding double sampling plan (or alternatively, use multiple sampling plan below, where available)
• = Acceptance not permitted 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 reinstate normal inspection (see 10.1.4)

MULTIPLE
REDUCED

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

(See 9.4 and 9.5)

Acceptable Quality Levels (reduced inspection) †

= = 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

* = 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 reinstate normal inspection (see 10.1.4).

MULTIPLE REDUCED

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

(See 11.4)

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														12			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											2.8			6.5	11	15	24	34	50	72	110	170	250			
F	20										1.8		2.6	4.2	6.9	9.7	16	22	33	47	73						
G	32									1.2		1.7	2.6	4.3	6.1	9.9	14	21	29	46							
H	50								0.74		1.7	1.7	2.7	3.9	6.3	9.0	13	19	29								
J	80							0.46			1.1	1.7	2.4	4.0	5.6	8.2	12	18									
K	125						0.29			0.67	1.1	1.6	2.5	3.6	5.2	7.5	12										
L	200					0.18			0.42	0.69	0.97	1.6	2.2	3.3	4.7	7.3											
M	315				0.12			0.27	0.44	0.62	1.00	1.4	2.1	3.0	4.7												
N	500			0.074			0.17	0.27	0.39	0.63	0.90	1.3	1.9	2.9													
P	800		0.046			0.11	0.17	0.24	0.40	0.56	0.82	1.2	1.8														
Q	1250	0.029			0.067	0.11	0.16	0.25	0.36	0.52	0.75	1.2															
R	2000			0.042	0.069	0.097	0.16	0.22	0.33	0.47	0.73																

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

AOQL
NORMAL

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

(See 11.4)

Acceptable Quality Level

Code letter	Sample size	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																				69	97	160	260	400	620	970
B	3																			42	65	110	170	270	410	650	1100
C	5																		28	46	63	100	160	250	390	610	
D	8																	17	27	39	64	99	160	240	380		
E	13																11	17	24	40	61	95	150	240			
F	20															12	11	15	24	40	62						
G	32														7.4	6.5	9.7	16	26	40							
H	50													4.6	4.2	6.9	9.9	16	25	39							
J	80												2.8	2.6	4.3	6.1	10	16	25								
K	125										1.2	1.8	1.7	2.7	3.9	6.3	9.9	16									
L	200									0.74	0.67	1.1	1.7	2.4	4.0	6.4	9.9										
M	315								0.46	0.42	0.69	1.1	1.6	2.5	4.1	6.4											
N	500							0.29	0.27	0.44	0.62	0.97	1.6	2.6	4.0	6.2											
P	800						0.18	0.17	0.27	0.39	0.63	1.0	1.6	2.5	3.9												
Q	1250					0.12	0.11	0.17	0.24	0.40	0.64	0.99	1.6	2.5													
R	2000			0.046	0.074	0.067	0.11	0.16	0.25	0.41	0.64	0.99	1.6														
S	3150	0.018	0.029	0.027	0.042	0.069	0.097	0.16	0.26	0.40	0.62	0.99															

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)

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AOQL
TIGHTENED

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

(See 11.6)

Code letter	Sample size	\(\;\)	\(\;\)	\(\;\)	\(\;\)	\(\;\)	\(\;\)	\(\;\)	\(\;\)	Acceptable Quality Level						
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10
A	2															68	
B	3														54	41	58
C	5													37	27	36	54
D	8												25	18	25	30	44
E	13											16	12	16	20	27	42
F	20										11	7.6	10	13	18	22	34
G	32									6.9	4.8	6.5	8.2	11	14	19	29
H	50								4.5	3.1	4.3	5.4	7.4	9.4	12	16	24
J	80							2.8	2.0	2.7	3.3	4.6	5.9	7.7	10	14	23
K	125						1.8	1.2	1.7	2.1	2.9	3.7	4.9	6.4	9.0		
L	200					1.2	0.78	1.1	1.3	1.9	2.4	3.1	4.0	5.6			
M	315				0.73	0.49	0.67	0.84	1.2	1.5	1.9	2.5	3.5				
N	500			0.46	0.31	0.43	0.53	0.74	0.94	1.2	1.6	2.3					
P	800		0.29														
Q	1250	0.18															
R	2000			0.20	0.27	0.33	0.46	0.59	0.77	1.0	1.4						

LQ (DEFECTIVES)
10.0%

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

(See 11.6)

Acceptable Quality Level

Code letter	Sample size	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			7.8	11	13	19	24	31	40	56								
J	80							2.9			4.9	6.7	8.4	12	15	19	25	35									
K	125						1.8			3.1	4.3	5.4	7.4	9.4	12	16	23										
L	200					1.2			2.0	2.7	3.3	4.6	5.9	7.7	10	14											
M	315				0.73			1.2	1.7	2.1	2.9	3.7	4.9	6.4	9.0												
N	500			0.46			0.78	1.1	1.3	1.9	2.4	3.1	4.0	5.6													
P	800		0.29			0.49	0.67	0.84	1.2	1.5	1.9	2.5	3.5														
Q	1250	0.18			0.31	0.43	0.53	0.74	0.94	1.2	1.6	2.3															
R	2000			0.20	0.27	0.33	0.46	0.59	0.77	1.0	1.4																

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LQ (DEFECTS)
10%

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

(See 11.6)

Code letter	Sample size	__	__	__	__	__	__	__	Acceptable Quality Level __	__	__	__	__	__	__	__
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10
A	2																
B	3															78	
C	5														63		66
D	8													45		47	60
E	13												31		32	41	50
F	20											21		22	28	34	46
G	32										14		14	18	23	30	37
H	50									8.9		9.1	12	15	20	25	32
J	80								5.8		5.8	7.7	9.4	13	16	20	26
K	125							3.7		3.8	5.0	6.2	8.4	11	14	18	24
L	200						2.4		2.4	3.2	3.9	5.3	6.6	8.5	11	15	
M	315					1.5		1.5	2.0	2.5	3.3	4.2	5.4	7.0	9.6		
N	500				0.95		0.95	1.3	1.6	2.1	2.6	3.4	4.4	6.1			
P	800			0.60		0.59	0.79	0.97	1.3	1.6	2.1	2.7	3.8				
Q	1250	0.24	0.38		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						

LQ (DEFECTIVES)
5.0%

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

(See 11.6)

Acceptable Quality Level

Code letter	Sample size	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		9.5	13	20	24	33	41	53	68	95							
H	50								6.0		5.9	7.9	9.7	16	21	26	34	44	61								
J	80							3.8		3.8	5.0	6.2	8.4	13	16	21	27	38									
K	125						2.4		2.4	3.2	3.9	5.3	6.6	11	14	18	24										
L	200					1.5		1.5	2.0	2.5	3.3	4.2	5.4	8.5	11	15											
M	315				0.95		0.95	1.3	1.6	2.1	2.6	3.4	4.4	7.0	9.6												
N	500			0.60		0.59	0.79	0.97	1.3	1.6	2.1	2.7	3.8	6.1													
P	800		0.38		0.38	0.50	0.62	0.84	1.1	1.4	1.8	2.4															
Q	1250	0.24		0.24	0.32	0.39	0.53	0.66	0.85	1.1	1.5																
R	2000																										

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LQ (DEFECTS) 5%

TABLE VIII — Limit Numbers for Reduced Inspection

(See 8.3.3)

Acceptable Quality Level

Number of sample units from last 10 lots or batches	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	397		
130 - 199	•	•	•	•	•	•	•	•	•	•	•	0	0	2	4	7	13	25	42	72	115	177	301	490		
200 - 319	•	•	•	•	•	•	•	•	•	•	0	0	2	4	8	14	22	40	68	115	181	277	471			
320 - 499	•	•	•	•	•	•	•	•	•	0	0	1	4	8	14	24	39	68	113	169						
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	7	13	24	40	68	110	169									
2000 - 3149	•	•	•	•	•	0	0	2	4	8	14	22	40	68	115	181										
3150 - 4999	•	•	•	•	0	0	1	4	8	14	24	38	67	111	186											
5000 - 7999	•	•	•	0	0	2	3	7	14	25	40	63	110	181												
8000 - 12499	•	•	0	0	2	4	7	14	24	42	68	105	181													
12500 - 19999	•	0	0	2	4	7	13	24	40	69	110	169														
20000 - 31499	0	0	2	4	8	14	22	40	68	115	181															
31500 - 49999	0	1	4	8	14	24	38	67	111	186																
50000 & Over	2	3	7	14	25	40	63	110	181	301																

• 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.

LIMIT
NUMBERS

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

(See 11.5)

n x proportion defective

n x proportion defective

n x proportion defective

Average
Sample
Size
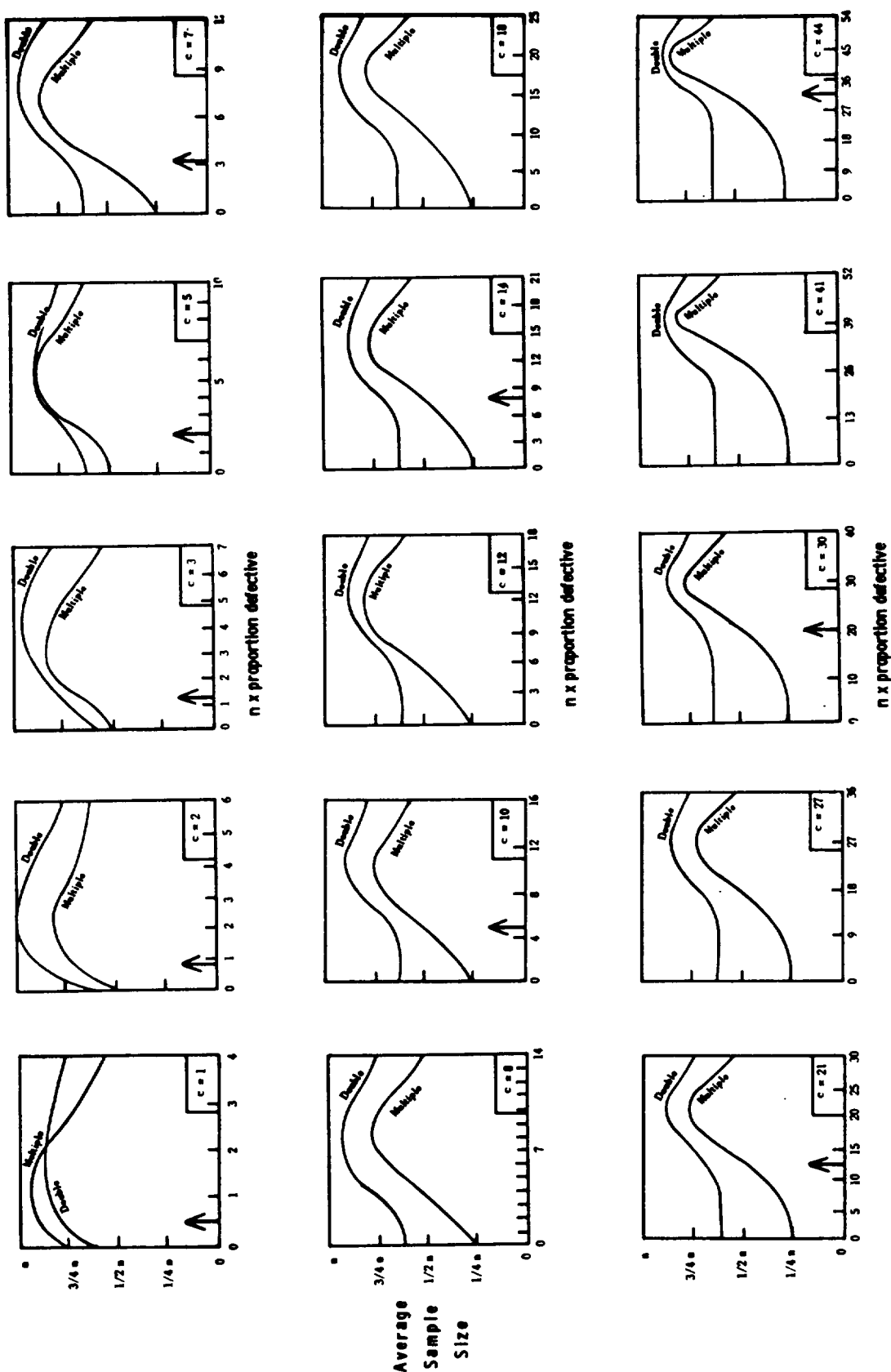
n = Equivalent single sample size
c = Single sample acceptance number
↑ = AQL for normal inspection

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AVERAGE
SAMPLE SIZE

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)

[Chart A: Operating characteristic curves. Vertical axis: PERCENT OF LOTS EXPECTED TO BE ACCEPTED (Pa), scaled 100, 90, 80, 70, 60, 50, 40, 30, 20, 10, 0. Horizontal axis: 100 to 2000. Curves labelled 6.5, 25, 40, 65, 150, 250, 400, 650, 1000.]

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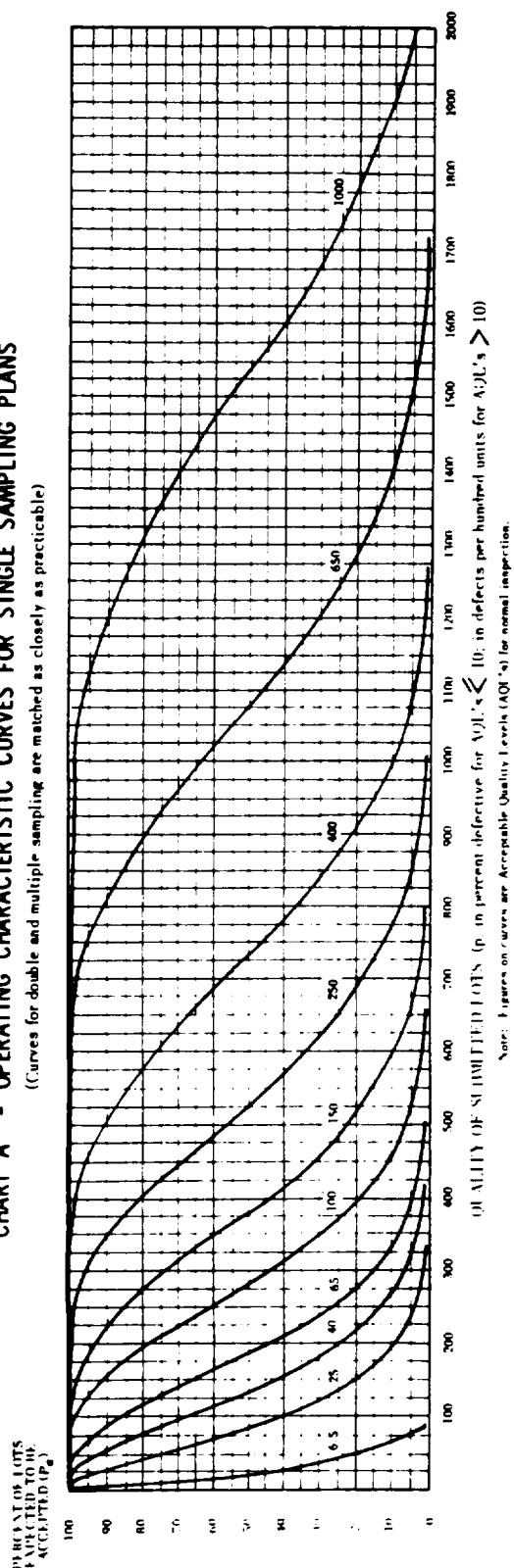
Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

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

Acceptable Quality Levels (normal inspection)

P_a	6.5	X	25	40	65	100	150	X	250	X	400	X	650	X	1000
	p (in percent defective)	p (in defects per hundred units)													
99.0	0.301	0.51	7.45	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	385	462	622	745	995	1122
90.0	5.13	5.25	26.6	55.1	87.3	158	233	272	351	432	515	684	812	1073	1206
75.0	13.4	14.4	48.1	86.8	127	211	298	342	431	521	612	795	934	1314	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	256	371	484	540	651	761	870	1087	1248	1568	1728
10.0	68.4	115	195	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	1334	1512	1862	2035
1.0	90.0	230	332	420	502	655	800	870	1007	1141	1272	1529	1718	2088	2270
	X	6.5	25	40	65	100	150	250	X	400	X	650	X	1000	X

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)												
		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
Single	2	▽	0 1	X	Use Letter D	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31
Double		▽	•	Use Letter D	Use Letter C	(•)	(•)	(•)	(•)	(•)	(•)	(•)	(•)	(•)
Multiple		▽	•		Use Letter B	•	•	•	•	•	•	•	•	•

Cumulative sample size													
Less than 10	X	10	15	25	40	65	100	150	250	400	650	1000	X

Acceptable Quality Levels (tightened inspection)

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

Ac = Acceptance number

Re = Rejection number

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

(•) = Use single sampling plan (or alternatively use letter B).

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A

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

CHART B - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P_a): 100, 90, 80, 70, 60, 50, 40, 30, 20, 10, 0

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

Curves labeled: 1000, 650, 400, 250, 150, 100, 65, 40, 25, 15, 10, 6.5, 4.0
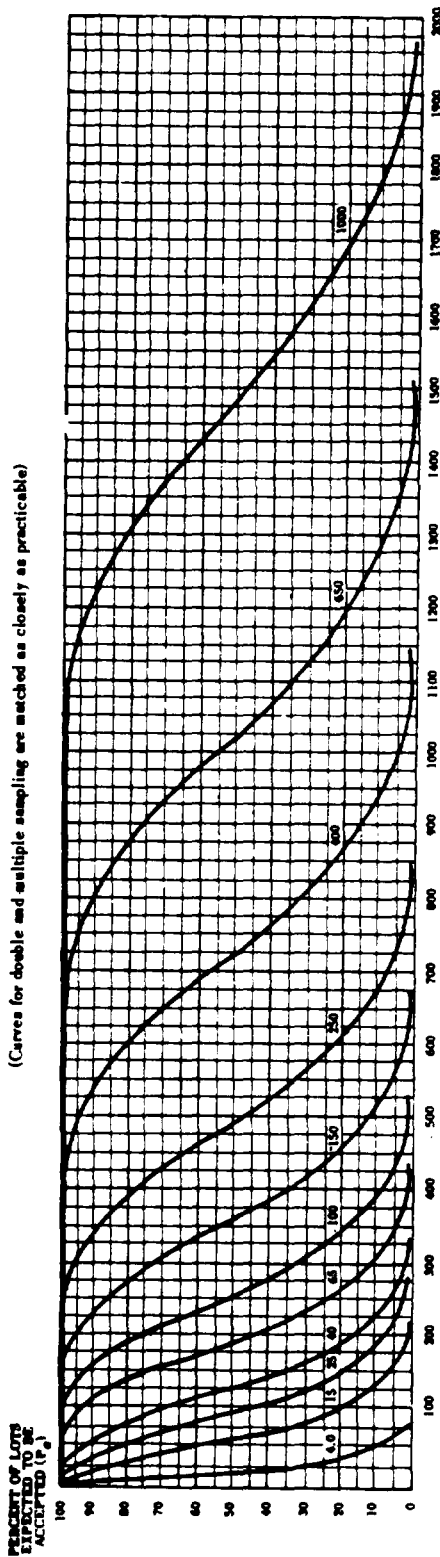
Note: Figures on curves are Acceptable Quality Levels (AQL's) for normal inspection.

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

P_a	4.0	15	25	40	65	100	X	150.	X	250	X	400	X	650	X	1000
	p (in percent defective)						p (in defects per hundred units)									
99.0	0.34	4.97	14.5	27.4	59.5	96.9	117	159	203	249	345	419	573	651	947	1029
95.0	1.71	11.8	27.3	45.5	87.1	133	157	206	256	308	415	496	663	748	1065	1152
90.0	3.50	17.7	36.7	58.2	105	155	181	234	288	343	456	541	716	804	1131	1222
75.0	9.60	32.0	57.6	84.5	141	199	228	287	347	408	530	623	809	903	1249	1344
50.0	23.1	55.9	89.1	122	189	256	289	356	422	489	622	722	922	1022	1389	1489
25.0	46.2	89.8	131	170	247	323	360	434	507	580	724	832	1046	1152	1539	1644
10.0	76.8	130	177	223	309	392	433	514	593	671	825	939	1165	1277	1683	1793
5.0	99.9	158	210	258	350	438	481	565	648	730	890	1008	1241	1356	1773	1886
1.0	154	221	280	335	437	533	580	672	761	848	1019	1145	1392	1513	1951	2069
	6.5	25	40	65	100	150		250		400		650		1000		X

Acceptable Quality Levels (normal inspection) — top AQL row.

Acceptable Quality Levels (tightened inspection) — bottom AQL row.

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

B

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

Acceptable Quality Levels (normal inspection)

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

Acceptable Quality Levels (tightened inspection)

	Less than 6.5	6.5	10	15	25	40	65	100	150	250	400	650	1000

Legend:

▽ = 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 letter E).

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

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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)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P_a)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P_a)

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

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

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

Acceptable Quality Levels (normal inspection)

P_a	p (in percent defective)		p (in defects per hundred units)															
	2.5	10	2.5	10	15	25	40	65	✕	100	✕	150	✕	250	✕	400	✕	650
99.0	0.20	3.28	0.20	2.89	8.72	16.5	35.7	58.1	70.1	95.4	122	150	207	251	344	391	568	618
95.0	1.02	7.63	1.03	7.10	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	2.10	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	5.76	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	211	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	987
10.0	36.9	58.4	46.1	77.8	106	134	186	235	260	308	356	403	495	564	699	766	1010	1076
5.0	45.1	65.8	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	133	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	✕

Acceptable Quality Levels (tightened inspection)

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

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

Acceptable Quality Levels (tightened inspection)

Type of sampling plan	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	Ac Re	Ac Re	Ac Re
Single	5	▽	0 1	Use Letter B		1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	Use Letter B
Double	3	▽	●	Use Letter E	Use Letter D	0 2	0 3	1 4	2 5	3 7	5 9	7 11	11 16	17 22	25 31	Use Letter B
	6					1 2	3 4	4 5	6 7	8 9	12 13	18 19	26 27	37 38	56 57	
Multiple		▽	●	Use Letter D		‡	‡	‡	‡	‡	‡	‡	‡	‡	‡	‡

(A lower AQL scale is also shown: Less than 4.0, 4.0, 6.5, 10, 15, 25, 40, 65, 100, 150, 250, 400, 650, 1000. Columns marked ✕ indicate cells for which the plan is not applicable.)

Legend:

▽ = 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 letter F).
‡ = Use double sampling plan above (or alternatively use letter D).

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

CHART D - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

QUALITY OF SUBMITTED LOTS (p. in percent defective for AOL's ≤ 10; in defects per hundred units for AOL'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_a	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	0.13	2.00	6.00	0.13	1.86	5.45	10.3	22.3	36.3	43.8	59.6	76.2	93.5	129	157	215	244	355	386
95.0	0.64	2.64	11.1	0.64	4.44	10.2	17.1	32.7	49.8	58.7	77.1	96.1	116	156	186	249	281	399	432
90.0	1.31	6.88	14.7	1.31	6.65	13.8	21.8	39.4	58.2	67.9	87.8	108	129	171	203	268	301	424	458
75.0	3.53	12.1	22.1	3.60	12.0	21.6	31.7	52.7	74.5	85.5	108	130	153	199	234	303	339	468	504
50.0	8.30	20.1	32.1	8.66	21.0	33.4	45.9	70.9	95.9	108	133	158	183	233	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	218	272	312	392	432	577	617
10.0	25.0	40.6	53.9	28.8	48.6	66.5	83.5	116	147	162	193	222	252	309	352	437	478	631	672
5.0	31.2	47.1	59.9	37.5	59.3	78.7	96.9	131	164	180	212	243	274	334	378	465	509	665	707
1.0	43.8	58.8	70.7	57.6	83.0	105	126	164	200	218	252	285	318	382	429	522	568	732	776
	2.5	10		2.5	10	15	25	40	65		100	150	250	400
				Acceptable Quality Levels (tightened inspection)										

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

Acceptable Quality Levels (normal inspection)

Type of sampling plan	Cumulative sample size	Less than 1.5 (Ac Re)	1.5 (Ac Re)	2.5 (Ac Re)	4.0 (Ac Re)	6.5 (Ac Re)	10 (Ac Re)	15 (Ac Re)	25 (Ac Re)	40 (Ac Re)	65 (Ac Re)	100 (Ac Re)	150 (Ac Re)	250 (Ac Re)	400 (Ac Re)	Higher than 400 (Ac Re)
Single	8	▽	0 1	Use ltr C	Use ltr C	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	30 31	44 45	△
Double	5	▽	•	Use ltr F	Use ltr F	0 2	0 3	1 4	2 5	3 7	5 9	6 10	9 14	17 22	25 31	△
Double	10					1 2	3 4	4 5	6 7	8 9	12 13	16 18	23 24	37 38	56 57	
Multiple	2	▽	•	Use ltr E	Use ltr E	▪ 2	▪ 2	▪ 3	▪ 4	0 4	0 5	0 6	1 7	3 10	6 16	△
Multiple	4					▪ 2	0 3	0 3	1 5	1 6	3 8	3 9	6 12	10 17	17 27	
Multiple	6					0 2	0 3	1 4	2 6	3 8	6 10	7 12	11 17	17 24	29 39	
Multiple	8					0 3	1 4	2 5	3 7	5 10	8 13	10 15	16 22	24 31	40 49	
Multiple	10					1 3	2 4	3 6	5 8	7 11	11 15	14 17	22 25	32 37	53 58	
Multiple	12					1 3	3 5	4 6	7 9	10 12	14 17	18 20	27 29	40 43	65 68	
Multiple	14					2 3	4 5	6 7	9 10	13 14	18 19	21 22	32 33	48 49	77 78	

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	Higher than 400

△ = 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 letter G).

▪ = Acceptance not permitted at this sample size.

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D

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

CHART E - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

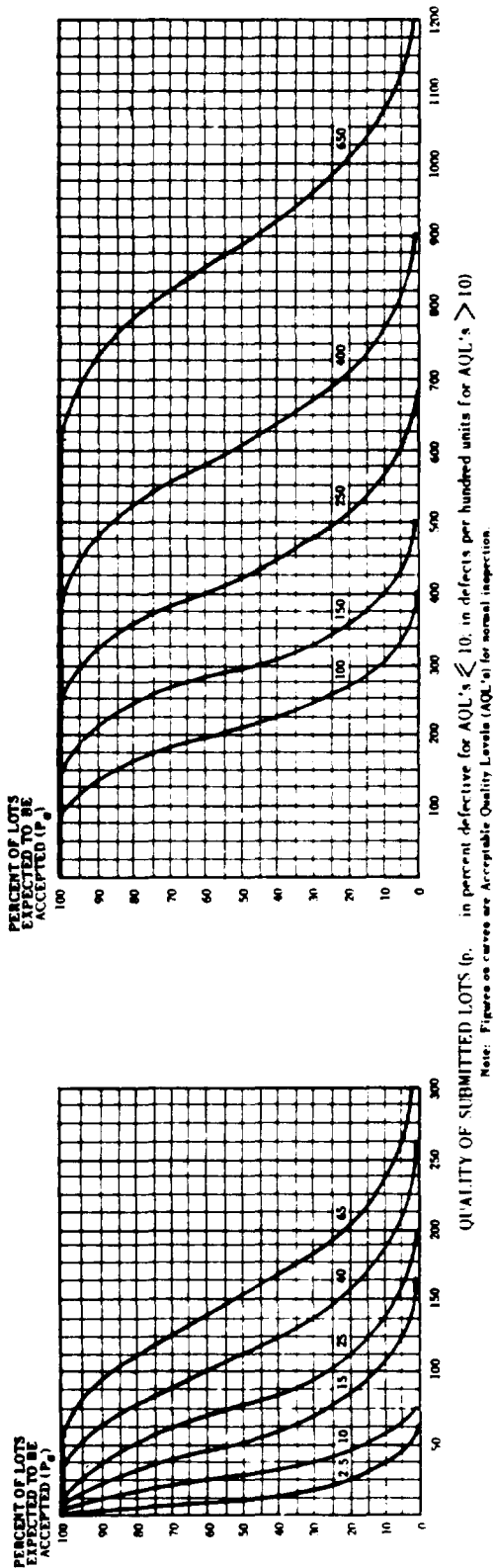(Curves for double and multiple sampling are matched as closely as practicable)

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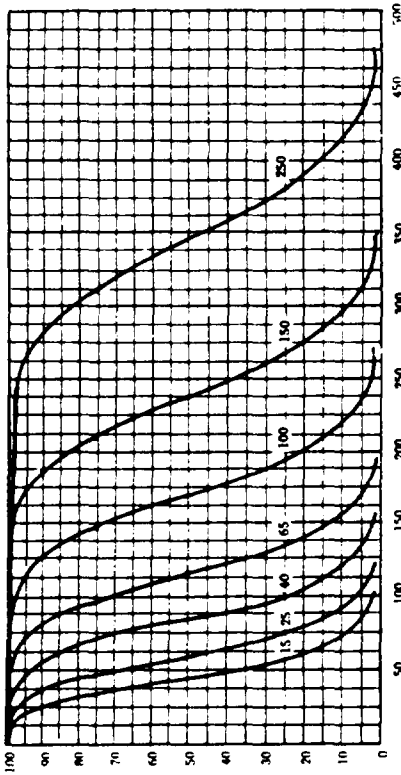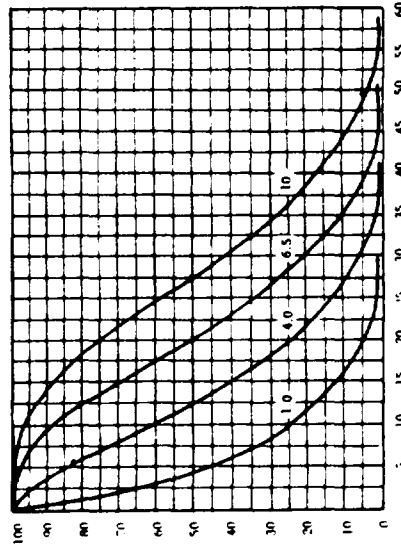
QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's $\leq$ 10; in defects per hundred units for AQL's $>$ 10)

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

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

Acceptable Quality Levels (normal inspection)

P_a	1.0	4.0	6.5	10	15	25	X	40	X	65	X	100	X	150	X	250
	p (in defects per hundred units)															
99.0	0.078	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	0.395	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	0.808	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	2.22	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	5.33	12.9	20.6	28.2	43.6	59.0	66.7	82.1	97.5	113	144	168	213	236	321	344
25.0	10.7	20.7	30.2	39.3	57.1	74.5	83.1	100	117	134	167	190	241	266	355	379
10.0	17.7	29.9	40.9	51.4	71.3	90.5	100	119	137	155	190	217	269	295	388	414
5.0	23.0	36.5	48.4	59.6	80.9	101	111	130	150	168	205	233	286	313	409	435
1.0	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	15	25	40	X	65	X	100	X	150	X	250	X	X

Acceptable Quality Levels (tightened inspection)

Acceptable Quality Levels (tightened inspection)

P_a	1.0	4.0	6.5	10
	p (in percent defective)			
99.0	0.077	1.19	3.63	7.00
95.0	0.394	2.81	6.63	11.3
90.0	0.807	4.16	8.80	14.2
75.0	2.19	7.41	13.4	19.9
50.0	5.19	12.6	20.0	27.5
25.0	10.1	19.4	28.0	36.2
10.0	16.2	26.8	36.0	44.4
5.0	20.6	31.6	41.0	49.5
1.0	29.8	41.5	50.6	58.7
	1.5	6.5	10	X

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

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

Acceptable Quality Levels (normal inspection)

Type of sampling plan	Cumulative sample size	Less than 1.0 (Ac)	1.0 (Ac Re)	1.5	2.5	4.0 (Ac Re)	6.5 (Ac Re)	10 (Ac Re)	15 (Ac Re)	25 (Ac Re)	40 (Ac Re)	65 (Ac Re)	100 (Ac Re)	150 (Ac Re)	250 (Ac Re)	Higher than 250 (Re)
Single	13	▽	0 / 1			1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22	30 / 31	44 / 45	△
Double	8	▽	Use Letter D	Use Letter	Use Letter F	0 / 2	0 / 3	1 / 4	2 / 5	3 / 7	5 / 9	7 / 11	11 / 16	17 / 22	25 / 31	△
	16					1 / 2	3 / 4	4 / 5	6 / 7	8 / 9	12 / 13	18 / 19	26 / 27	37 / 38	52 / 53	56 / 57
Multiple	3	▽	Use Letter D	Use Letter G		* / 2	* / 2	* / 3	* / 4	0 / 4	0 / 5	1 / 6	2 / 8	4 / 12	6 / 16	△
	6					0 / 2	0 / 3	0 / 3	1 / 5	1 / 6	3 / 8	4 / 10	7 / 12	11 / 19	17 / 27	
	9					0 / 2	1 / 3	1 / 4	2 / 6	3 / 8	6 / 10	8 / 13	13 / 17	19 / 27	29 / 39	
	12					0 / 3	1 / 4	2 / 5	3 / 7	5 / 10	8 / 13	12 / 15	19 / 25	27 / 34	40 / 49	
	15					1 / 3	2 / 4	3 / 6	5 / 8	7 / 11	11 / 15	16 / 17	24 / 25	36 / 40	53 / 58	
	18					1 / 3	3 / 5	4 / 6	7 / 9	9 / 12	14 / 17	20 / 21	29 / 31	45 / 47	65 / 68	
	21					2 / 3	4 / 5	6 / 7	9 / 10	13 / 14	18 / 19	22 / 25	32 / 33	53 / 54	77 / 78	

Acceptable Quality Levels (tightened inspection)

	Less than 1.5	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	Higher than 250

Legend:

- △ = 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 letter H).
- * = Acceptance not permitted at this sample size.

E

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

CHART F - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

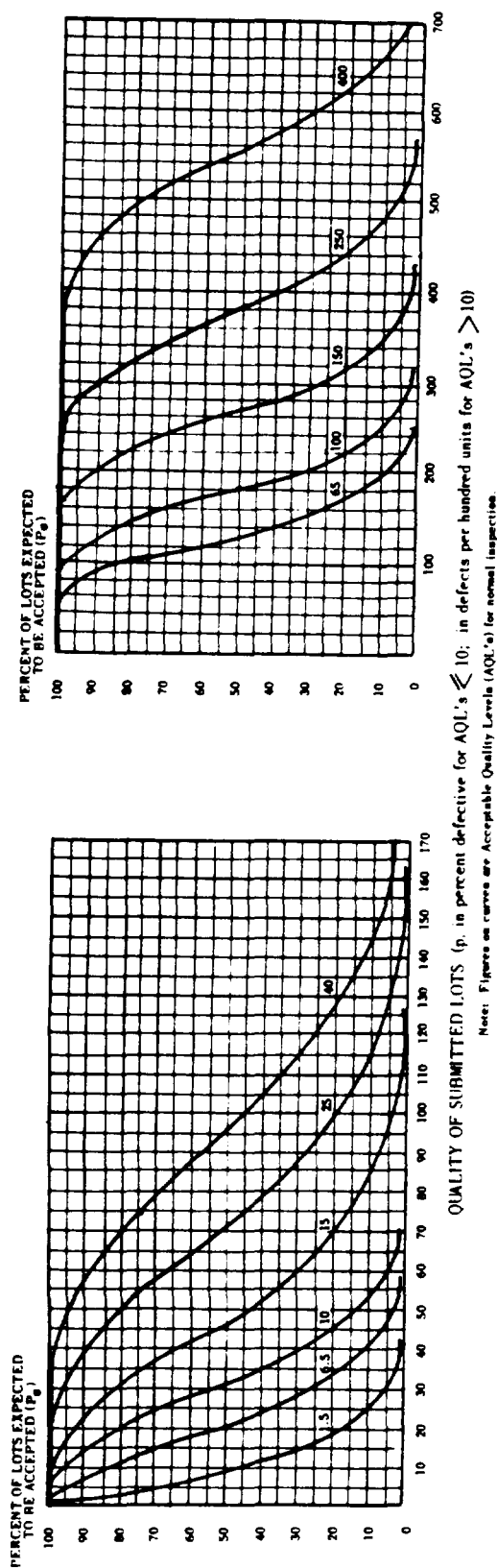(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS
EXPECTED TO BE
ACCEPTED (P_a)

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

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

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	15	25	40	65
	p (in percent defective)						p (in defects per hundred units)			
99.0	0.050		0.75	2.25	4.31	9.75				
95.0	0.256		1.80	4.22	7.13	14.0				
90.0	0.525		2.69	5.64	9.03	16.6				
75.0	1.43		4.81	8.70	12.8	21.6				
50.0	3.41		8.25	13.1	18.1	27.9				
25.0	6.70		12.9	18.7	24.2	34.8				
10.0	10.9		18.1	24.5	30.4	41.5				
5.0	13.9		21.6	28.3	34.4	45.6				
1.0	20.6		28.9	35.6	42.0	53.4				
	1.0		4.0	6.5	10					

P_a	Acceptable Quality Levels (normal inspection)												
	0.65	2.5	4.0	6.5	10	15	25	40	65
	0.051	0.75	2.18	4.12	8.92	14.5	23.9	37.4	62.9
	0.257	1.78	4.09	6.83	13.1	19.9	30.8	46.2	74.5
	0.527	2.66	5.51	8.73	15.8	23.3	35.1	51.5	81.2
	1.44	4.81	8.68	12.7	21.1	29.8	43.1	61.2	93.4
	3.47	8.39	13.4	18.4	28.4	38.3	53.3	73.3	108
	6.93	13.5	19.6	25.5	37.1	48.4	65.1	87.0	125
	11.5	19.5	26.6	33.4	46.4	58.9	77.0	101	141
	15.0	23.7	31.5	38.8	52.6	65.7	84.8	109	151
	23.0	33.2	42.0	50.2	65.5	80.0	101	127	172
	1.0	4.0	6.5	10	15	25	40	65

Acceptable Quality Levels (tightened inspection)

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

F

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

Acceptable Quality Levels (normal inspection)

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

(Middle note columns 1.0/1.5 read: "Use Letter E", "Use Letter H", "Use Letter G", "F")

Acceptable Quality Levels (tightened inspection) — AQL header: Less than 1.0 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | Higher than 65

Legend:

△ = 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 letter J).

* = Acceptance not permitted at this sample size.

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F

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 (Pa)

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

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

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

Acceptable Quality Levels (normal inspection) — p (in defects per hundred units)

Pa	0.40	1.5	2.5	4.0	6.5	10	15	25	40
99.0	0.012	0.466	1.16	2.57	5.57	9.08	14.9	23.4	39.3
95.0	0.160	1.10	2.55	4.26	8.16	12.4	19.3	28.9	46.5
90.0	0.328	1.66	3.44	5.45	9.85	14.6	21.9	32.2	50.8
75.0	0.900	3.00	5.39	7.92	13.2	18.6	26.9	38.2	58.4
50.0	2.16	5.24	8.35	11.5	17.7	24.0	33.3	45.8	67.7
25.0	4.33	8.41	12.3	16.0	23.2	30.3	40.7	54.4	78.0
10.0	7.19	12.2	16.6	20.9	29.0	36.8	48.1	62.9	88.1
5.0	9.36	14.8	19.7	24.2	32.9	41.1	53.0	68.4	94.5
1.0	14.4	20.7	26.3	31.4	41.0	50.0	63.0	79.5	107
	0.65	2.5	4.0	6.5	10	15	25	✕	40

Acceptable Quality Levels (tightened inspection)

p (in percent defective)

Pa	0.40	1.5	2.5	4.0	6.5	10
99.0	0.032	0.475	1.38	2.63	5.94	9.75
95.0	0.161	1.13	2.59	4.39	8.50	13.1
90.0	0.329	1.67	3.50	5.56	10.2	15.1
75.0	0.895	3.01	5.42	7.98	13.4	19.0
50.0	2.14	5.19	8.27	11.4	17.5	23.7
25.0	4.23	8.19	11.9	15.4	22.3	29.0
10.0	6.94	11.6	15.8	19.7	27.1	34.1
5.0	8.94	14.0	18.4	22.5	30.1	37.2
1.0	13.5	19.0	23.7	28.0	35.9	43.3
	0.65	2.5	4.0	6.5	10	✕

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

G

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

Acceptable Quality Levels (normal inspection)

Type of sampling plan	Cumulative sample size	Less than 0.40 Ac / Re	0.40 Ac / Re	0.65 Ac / Re	1.0 Ac / Re	1.5 Ac / Re	2.5 Ac / Re	4.0 Ac / Re	6.5 Ac / Re	10 Ac / Re	15 Ac / Re	25 Ac / Re	40 Ac / Re	Higher than 40 Ac / Re
Single	32	▽	0 / 1	Use Letter	Use Letter	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22	△
Double	20	▽	•	Use Letter F	Use Letter	0 / 2	0 / 3	1 / 4	2 / 5	3 / 7	5 / 9	7 / 11	11 / 16	△
	40		•			1 / 2	3 / 4	4 / 5	6 / 7	8 / 9	12 / 13	18 / 19	26 / 27	
Multiple	8	▽		Use Letter	Use Letter H	▴ / 2	▴ / 2	▴ / 3	▴ / 4	0 / 4	0 / 5	1 / 7	2 / 9	△
	16					▴ / 2	0 / 3	0 / 3	1 / 5	1 / 6	3 / 8	6 / 10	7 / 14	
	24					0 / 2	0 / 3	1 / 4	2 / 6	3 / 8	6 / 10	11 / 13	13 / 19	
	32					0 / 3	1 / 4	2 / 5	3 / 7	5 / 10	8 / 13	16 / 17	19 / 25	
	40					1 / 3	2 / 4	3 / 6	5 / 8	7 / 11	11 / 15	22 / 20	25 / 29	
	48					1 / 3	3 / 5	4 / 6	7 / 9	10 / 12	14 / 17	27 / 23	31 / 33	
	56					2 / 3	4 / 5	6 / 7	9 / 10	13 / 14	18 / 19	25 / 26	37 / 38	

Acceptable Quality Levels (tightened inspection)

Less than 0.65	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	Higher than 40
	0.65	1.0	1.5	2.5	4.0	6.5	10	X	X	40	

Legend:

△ = 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 letter K).
▴ = Acceptance not permitted at this sample size.

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G

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

CHART H - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

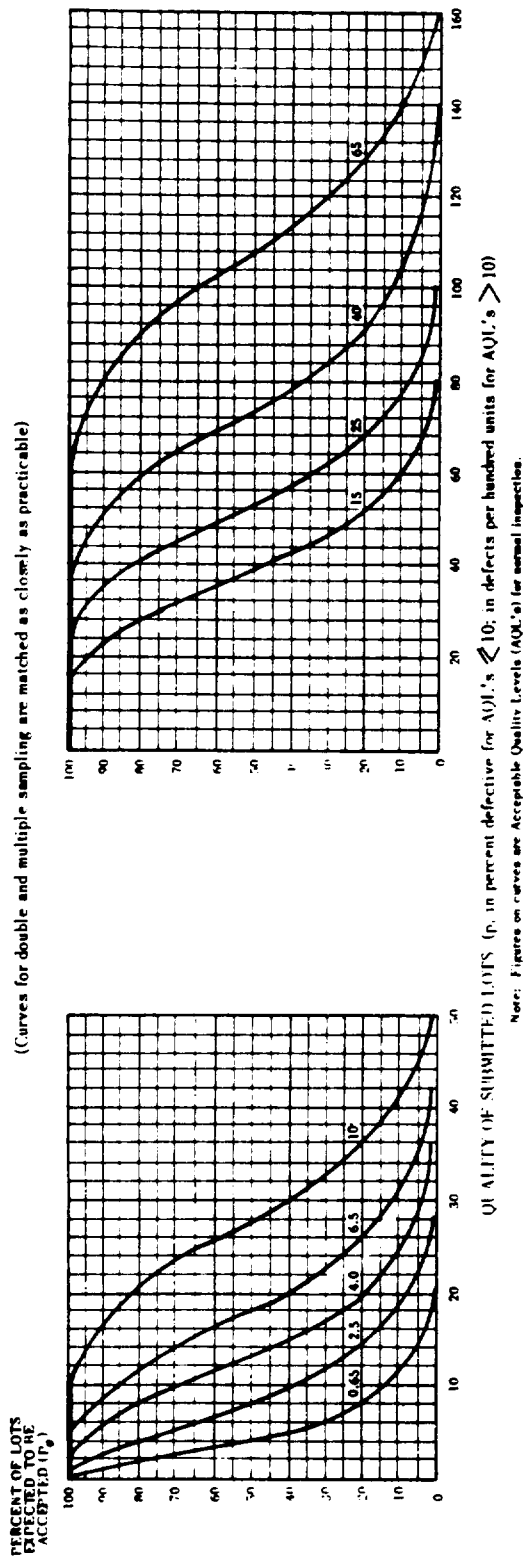(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P_a)

QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's $\leqslant$ 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-H-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

Acceptable Quality Levels (normal inspection) — p (in percent defective)

P_a	0.25	1.0	1.5	2.5	4.0	6.5		10
99.0	0.020	0.306	0.888	1.69	3.66	6.06	7.41	11.1
95.0	0.103	0.712	1.66	2.77	5.34	8.20	9.74	12.9
90.0	0.210	1.07	2.23	3.54	6.42	9.53	11.2	14.5
75.0	0.574	1.92	3.46	5.09	8.51	12.0	13.8	17.5
50.0	1.38	3.33	5.31	7.30	11.3	15.2	17.2	21.2
25.0	2.74	5.30	7.70	10.0	14.5	18.8	21.0	25.2
10.0	4.50	7.56	10.3	12.9	17.8	22.4	24.7	29.1
5.0	5.82	9.13	12.1	14.8	19.9	24.7	27.0	31.6
1.0	8.80	12.5	15.9	18.8	24.3	29.2	31.7	36.3
Acceptable Quality Levels (tightened inspection)	0.40	1.5	2.5	4.0	6.5	10	X	X

Acceptable Quality Levels (normal inspection) — p (in defects per hundred units)

P_a	0.25	1.0	1.5	2.5	4.0	6.5		10		15		25
99.0	0.020	0.298	0.872	1.65	3.57	5.81	7.01	9.54	12.2	15.0	20.7	25.1
95.0	0.103	0.710	1.64	2.73	5.23	7.96	9.39	12.3	15.4	18.5	24.9	29.8
90.0	0.210	1.06	2.20	3.49	6.30	9.31	10.9	14.0	17.3	20.6	27.3	32.5
75.0	0.576	1.92	3.45	5.07	8.44	11.9	13.7	17.2	20.8	24.5	31.8	37.4
50.0	1.39	3.36	5.35	7.34	11.3	15.3	17.3	21.6	25.3	29.3	37.3	43.3
25.0	2.77	5.39	7.84	10.2	14.8	19.4	21.6	26.0	30.4	34.8	43.5	49.9
10.0	4.61	7.78	10.6	13.4	18.6	23.5	26.0	30.8	35.6	40.3	49.5	56.4
5.0	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	9.21	13.3	16.8	20.1	26.2	32.0	34.8	40.3	45.6	50.9	61.1	68.7
Acceptable Quality Levels (tightened inspection)	0.40	1.5	2.5	4.0	6.5	10	X	15	X	25	X	X

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

H

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

Acceptable Quality Levels (normal inspection)

Type of sampling plan	Cumulative sample size	Less than 0.25	0.25 Ac Re	0.40	0.65	1.0 Ac Re	1.5 Ac Re	2.5 Ac Re	4.0 Ac Re	6.5 Ac Re	10 Ac Re	(X) Ac Re	15 Ac Re	(X) Ac Re	25 Ac Re	Higher than 25
Single	50	▽	0 1			1 2	2 3	3 4	5 6	7 8	10 11	12 13	14 15	18 19	21 22	△
Double	32	▽	•			0 2	0 3	1 4	2 5	3 7	5 9	6 10	7 11	9 14	11 16	△
	64					1 2	3 4	4 5	6 7	8 9	12 13	15 16	18 19	23 24	26 27	
Multiple	13	▽	•			* 2	* 2	* 3	* 4	0 4	0 5	0 6	1 7	1 8	2 9	△
	26					* 2	0 3	0 3	1 5	1 6	3 8	3 9	4 10	6 12	7 14	
	39					0 2	0 3	1 4	2 6	3 8	6 10	7 12	8 13	11 17	13 19	
	52					0 3	1 4	2 5	3 7	5 10	8 13	10 15	12 17	16 22	19 25	
	65					1 3	2 4	3 6	5 8	7 11	11 15	14 17	17 20	22 25	25 29	
	78					1 3	3 5	4 6	7 9	10 12	14 17	18 20	21 23	27 29	31 33	
	91					2 3	4 5	6 7	9 10	13 14	18 19	21 22	25 26	32 33	37 38	

Notes in Double/Multiple columns: "Use Letter G" (0.40), "Use Letter K" (0.65), "Use Letter J" (1.0).

Acceptable Quality Levels (tightened inspection): 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.

△ = 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.
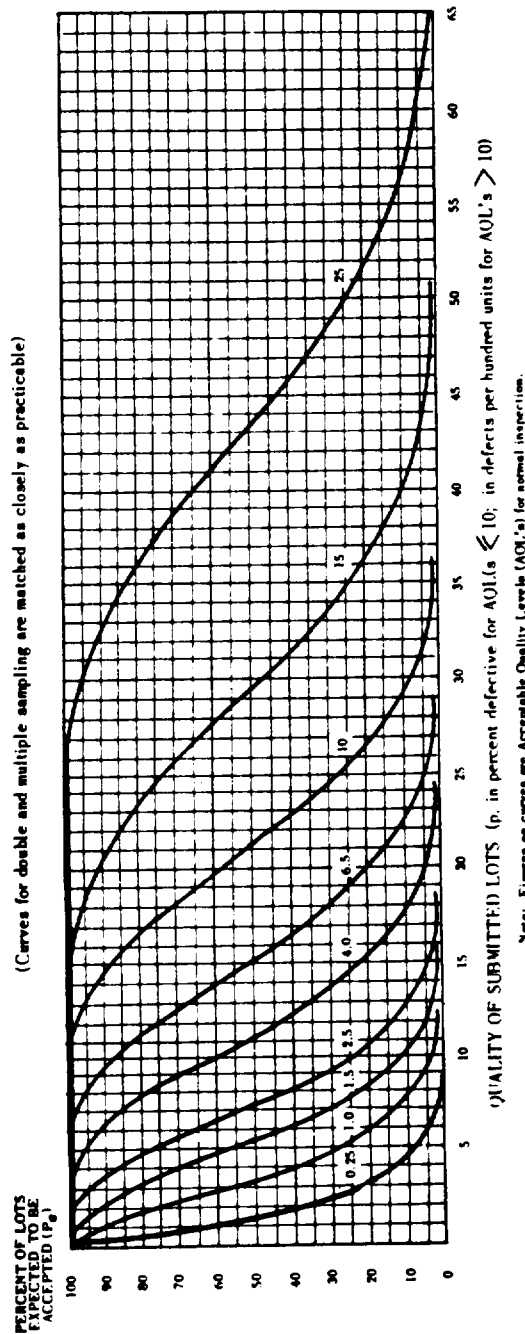
Ac = Acceptance number

Re = Rejection number

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

* = Acceptance not permitted at this sample size.

45

H

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)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (Pa)
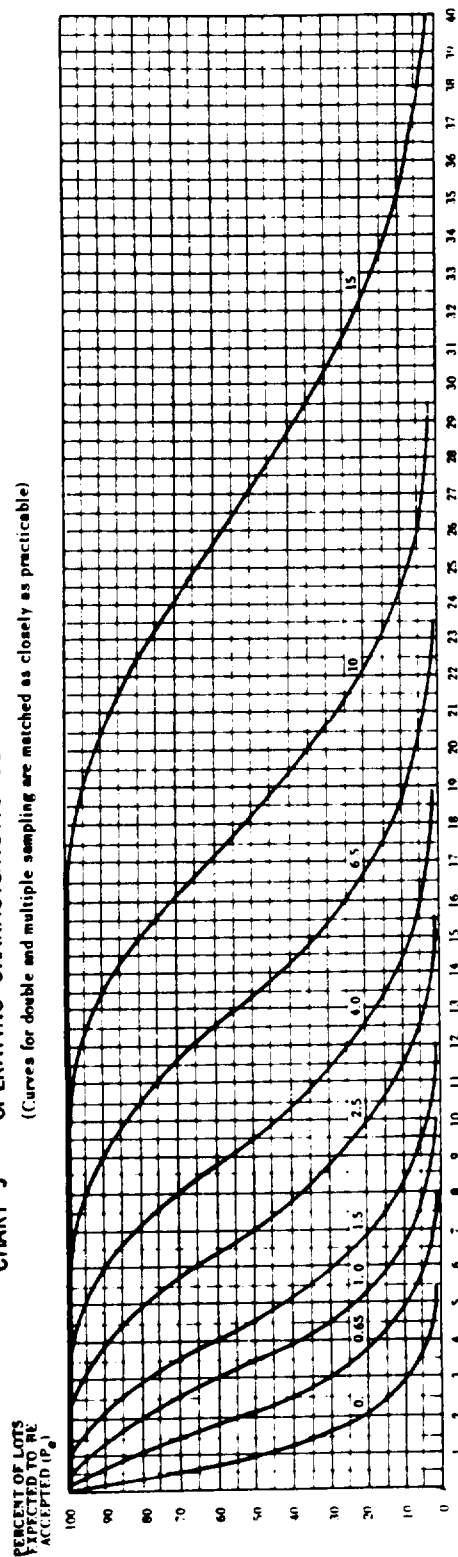
QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤10; in defects per hundred units for AQL's >10)

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

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

(percent defective)

Pa	0.15	0.65	1.0	1.5	2.5	4 0	[X]	6.5	[X]	10
					p (in percent defective)					
99 0	0.013	0.188	0.550	1.05	2.30	3.72	4.50	6.13	7.88	9.75
95.0	0.064	0.444	1.03	1.73	3.32	5.06	5.98	7.91	9.89	11.9
90.0	0.132	0.666	1.38	2.20	3.98	5.91	6.91	8.95	11.0	13.2
75 0	0.359	1.202	2.16	3.18	5.30	7.50	8.62	10.9	13.2	15.5
50.0	0.863	2.09	3.33	4.57	7.06	9.55	10.8	13.3	15.8	18.3
25.0	1.72	3.33	4.84	6.31	9.14	11.9	13.3	16.0	18.6	21.3
10.0	2.84	4.78	6.52	8.16	11.3	14.2	15.7	18.6	21.4	24.2
5.0	3.68	5.80	7.66	9.39	12.7	15.8	17.3	20.3	23.2	26.0
1 0	5.59	8.00	10.1	12.0	15.6	18.9	20.5	23.6	26.5	29.5
	0.25	1 0	1.5	2.5	4 0	6.5	[X]	10	[X]	6.5

Acceptable Quality Levels (defects per hundred units)

Pa	0.15	0.65	1.0	1.5	2.5	4.0	[X]	6.5	[X]	10	[X]	15
				Acceptable Quality Levels (normal inspection)								
						p (in defects per hundred units)							
99 0	0.013	0.186	0.545	1.03	2.23	3.63	4.38	5.96	7.62	9.35	12.9	15.7
95.0	0.064	0.444	1.02	1.71	3.27	4.98	5.87	7.71	9.61	11.6	15.6	18.6
90.0	0.131	0.665	1.38	2.18	3.94	5.82	6.79	8.78	10.8	12.9	17.1	20.3
75 0	0.360	1.20	2.16	3.17	5.27	7.45	8.55	10.8	13.0	15.3	19.9	23.4
50.0	0.866	2.10	3.34	4.59	7.09	9.59	10.8	13.3	15.8	18.3	23.3	27.1
25.0	1.73	3.37	4.90	6.39	9.28	12.1	13.5	16.3	19.0	21.8	27.2	31.2
10.0	2.88	4.86	6.65	8.35	11.6	14.7	16.2	19.3	22.2	25.2	30.9	35.2
5.0	3.75	5.93	7.87	9.69	13.1	16.4	18.0	21.2	24.3	27.4	33.4	37.8
1 0	5.76	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	[X]	10	[X]	15		

Acceptable Quality Levels (tightened inspection)

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

J

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

Acceptable Quality Levels (normal inspection) — values given as **Ac Re**

Type of sampling plan	Cumulative sample size	<0.15	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	Higher than 15
Single	80	▽	0 1	Use Letter H	Use Letter L	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	▲
Double	50	▽	•	Use Letter	Use Letter	0 2	0 3	1 4	2 5	3 7	5 9	7 11	11 16	▲
	100					1 2	3 4	4 5	6 7	8 9	12 13	18 19	26 27	
Multiple	20	▽	•	Use Letter	Use Letter	✱ 2	✱ 2	✱ 3	✱ 4	0 4	0 5	1 7	2 9	▲
	40					✱ 2	0 3	0 3	1 5	1 6	3 8	4 10	7 14	
	60					0 2	0 3	1 4	2 6	3 8	6 10	8 13	13 19	
	80					0 3	1 4	2 5	3 7	5 10	8 13	12 17	19 25	
	100					1 3	2 4	3 6	5 8	7 11	11 15	17 20	25 29	
	120					1 3	3 5	4 6	7 9	10 12	14 17	21 23	31 33	
	140					2 3	4 5	6 7	9 10	13 14	18 19	25 26	37 38	

Acceptable Quality Levels (tightened inspection) — tightened AQL for each column, reading left-to-right beneath the data columns:

<0.15 col	0.15 col	0.25 col	0.40 col	0.65 col	1.0 col	1.5 col	2.5 col	4.0 col	6.5 col	10 col	15 col
Less than 0.25	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	Higher than 15

Legend

- ▲ = 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 letter M)
- ✱ = Acceptance not permitted at this sample size.

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

CHART K - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are matched 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-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	0.0081	0.119	0.349	0.658	1.43	2.33	2.81	3.82	4.88	5.98	8.28	10.1
95.0	0.0410	0.284	0.654	1.09	2.09	3.19	3.76	4.94	6.15	7.40	9.95	11.9
90.0	0.0840	0.426	0.882	1.40	2.52	3.73	4.35	5.62	6.92	8.24	10.9	13.0
75.0	0.230	0.769	0.382	2.03	3.38	4.77	5.47	6.90	8.34	9.79	12.7	14.9
50.0	0.554	1.34	2.14	2.94	4.54	6.14	6.94	8.53	10.1	11.7	14.9	17.3
25.0	1.11	2.15	3.14	4.09	5.94	7.75	8.64	10.4	12.2	13.9	17.4	20.0
10.0	1.84	3.11	4.26	5.35	7.42	9.42	10.4	12.3	14.2	16.1	19.8	22.5
5.0	2.40	3.80	5.04	6.20	8.41	10.5	11.5	13.6	15.6	17.5	21.4	24.2
1.0	3.68	5.31	6.73	8.04	10.5	12.8	18.3	16.1	18.3	20.4	24.5	27.5
	0.15	0.65	1.0	1.5	2.5	4.0	✕	✕	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.

K

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

Acceptable Quality Levels (normal inspection) — values shown as Ac Re

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

Acceptable Quality Levels (tightened inspection): Less than 0.15 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | Higher than 10

△ = 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 letter N).
* = Acceptance not permitted at this sample size.

K

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

CHART L - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

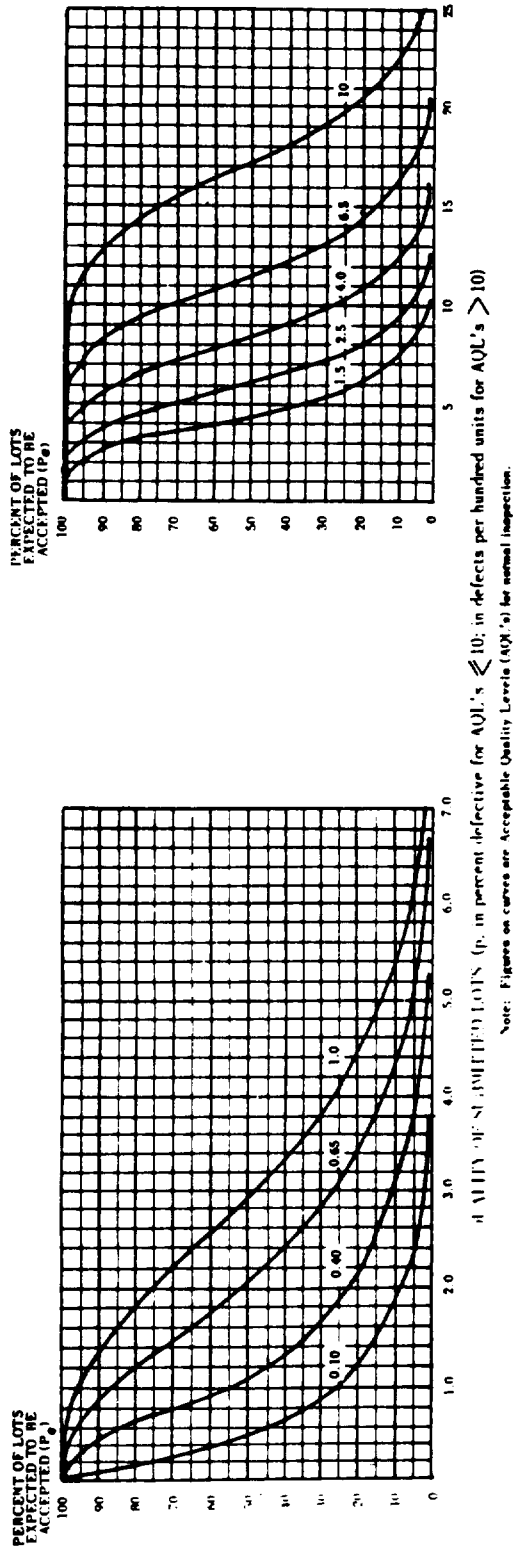(Curves for double and multiple sampling are matched as closely as practicable)

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

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

PERCENT OF LOTS
EXPECTED TO BE
ACCEPTED (Pₐ)

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

Pₐ	Acceptable Quality Levels (normal inspection)												
	0.065	0.25	0.40	0.65	1.0	1.5	$\times$	2.5	$\times$	4.0	$\times$	6.5
	p (in percent defective or defects per hundred units)											
99.0	0.0051	0.075	0.218	0.412	0.893	1.45	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	3.09	3.85	4.62	6.22	7.45
90.0	0.0525	0.266	0.551	0.873	1.58	2.33	2.72	3.51	4.32	5.15	6.84	8.12
75.0	0.144	0.481	0.864	1.27	2.11	2.98	3.42	4.31	5.21	6.12	7.95	9.34
50.0	0.347	0.839	1.34	1.84	2.84	3.84	4.33	5.33	6.33	7.33	9.33	10.8
25.0	0.693	1.35	1.96	2.56	3.71	4.84	5.40	6.51	7.61	8.70	10.9	12.5
10.0	1.15	1.95	2.66	3.34	4.64	5.89	6.50	7.70	8.89	10.1	12.4	14.1
5.0	1.50	2.37	3.15	3.88	5.26	6.57	7.22	8.48	9.72	10.9	13.3	15.1
1.0	2.30	3.32	4.20	5.02	6.55	8.00	8.70	10.1	11.4	12.7	15.3	17.2
	0.10	0.40	0.65	1.0	1.5	$\times$	2.5	$\times$	4.0	$\times$	6.5	$\times$
	Acceptable Quality Levels (tightened inspection)											

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

L

50

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

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

Acceptable Quality Levels (normal inspection)

Acceptable Quality Levels (tightened inspection), corresponding columns:

Less than 0.10	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	Higher than 6.5
X	X	X	X	X	X	X	X	X	X	X	

Legend

△ = 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 letter P).

= Acceptance not permitted at this sample size.

L

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

CHART M - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

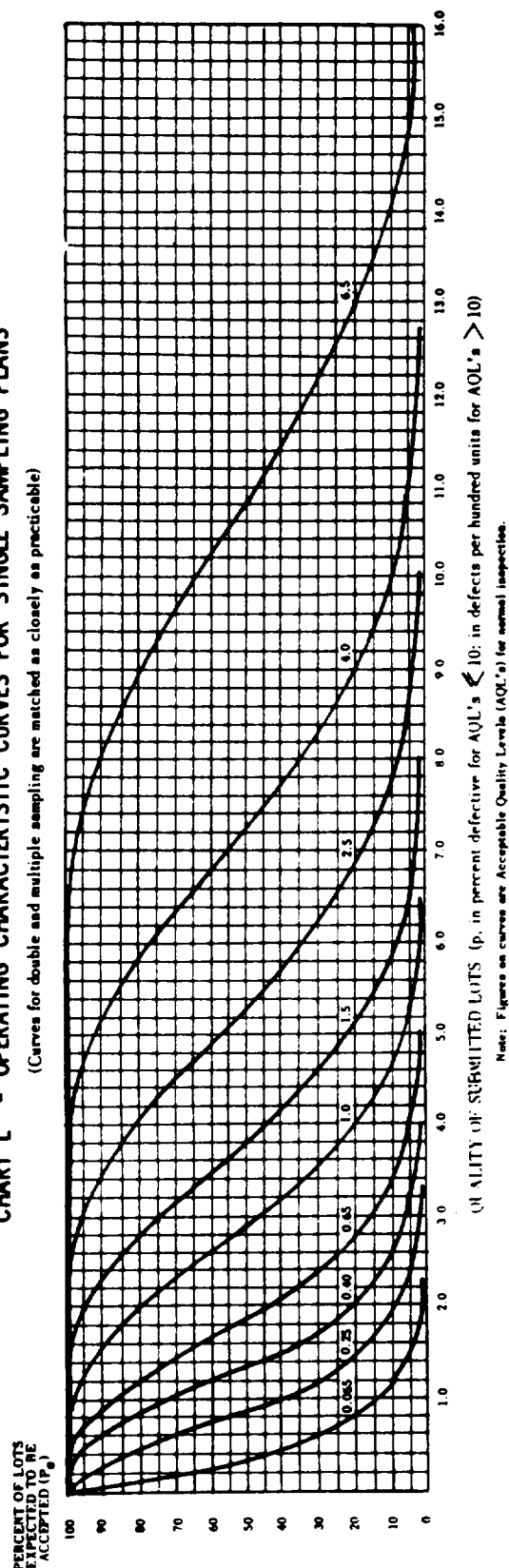(Curves for double and multiple sampling are matched as closely as practicable)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (Pa)
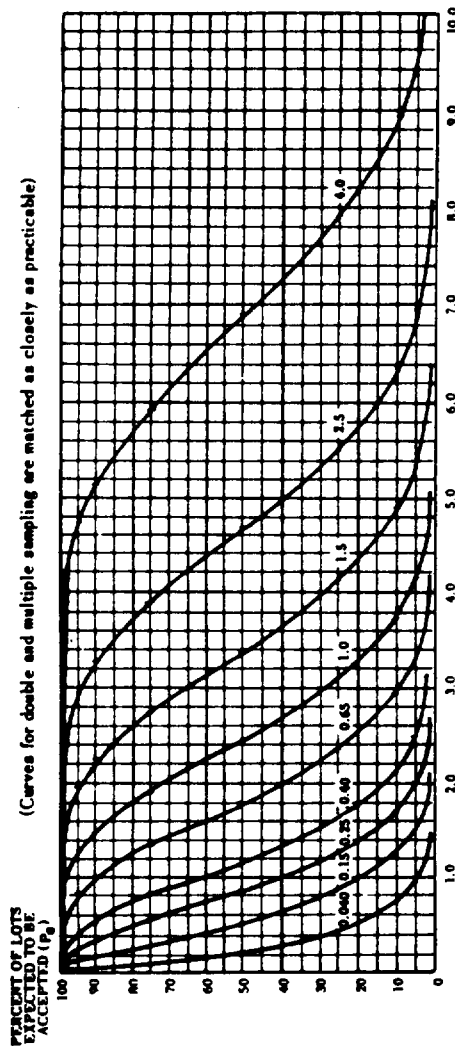
QUALITY OF SUBMITTED LOTS (p, in percent defective for AQL's ≤10; in defects per hundred units for AQL's >10)

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

TABLE X-M-1 - TABULATED VALUES FOR OPERATING CHARACTERSTIC 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	X	2.5	X	4.0
	p (in percent defective or in defects per hundred units)										
99.0	0.0032	0.047	0.138	0.261	0.566	0.922	1.51	1.94	2.38	3.28	3.99
95.0	0.0163	0.112	0.259	0.433	0.829	1.26	1.96	2.44	2.94	3.95	4.73
90.0	0.0333	0.168	0.349	0.533	1.00	1.48	2.23	2.75	3.27	4.34	5.16
75.0	0.0914	0.305	0.590	0.804	1.34	1.89	2.74	3.31	3.89	5.05	5.93
50.0	0.220	0.532	0.848	1.17	1.80	2.43	3.39	4.02	4.66	5.93	6.88
25.0	0.440	0.854	1.24	1.62	2.36	3.07	4.13	4.83	5.52	6.90	7.92
10.0	0.731	1.23	1.69	2.12	2.94	3.74	4.89	5.65	6.39	7.86	8.95
5.0	0.951	1.51	2.00	2.46	3.34	4.17	5.38	6.17	6.95	8.47	9.60
1.0	1.46	2.11	2.67	3.19	4.16	5.08	6.40	7.25	8.08	9.71	10.9
	0.065	0.25	0.40	0.65	1.0	1.5	X	2.5	X	4.0	
	Acceptable Quality Levels (tightened inspection)										

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

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

Each cell shows **Ac Re** (Acceptance number / Rejection number) under the Acceptable Quality Levels (normal inspection).

Type of sampling plan	Cumulative sample size	Less than 0.040	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	Higher than 4.0
Single	315	▽	0 1	▽ Use letter L	▽ Use letter N	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22	△
Double	200	▽	•	▽ Use letter L	▽ Use letter P	0 2	0 3	1 4	2 5	3 7	5 9	7 11	11 16	△
Double	400					1 2	3 4	4 5	6 7	8 9	12 13	18 19	26 27	
Multiple	80	▽	•	▽ Use letter L	▽ Use letter N	* 2	* 2	* 3	* 4	0 4	0 5	1 7	2 9	△
Multiple	160					* 2	* 3	0 3	1 5	1 6	3 8	4 10	7 14	
Multiple	240					0 2	0 3	1 4	2 6	3 8	6 10	8 13	13 19	
Multiple	320					0 3	1 4	2 5	3 7	5 10	8 13	12 17	19 25	
Multiple	400					1 3	2 4	3 6	5 8	7 11	11 15	17 20	25 29	
Multiple	480					1 3	3 5	4 6	7 9	10 12	14 17	21 23	31 33	
Multiple	560					2 3	4 5	6 7	9 10	13 14	18 19	25 26	37 38	

Acceptable Quality Levels (tightened inspection) — column scale: Less than 0.065 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | Higher than 4.0

Legend

- △ = 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 letter Q).
- * = Acceptance not permitted at this sample size.

M

N

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

CHART N - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

(Curves for double and multiple sampling are 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-N-1 - TABULATED VALUES FOR OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

P_a	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	0.0020	0.030	0.087	0.165	0.357	0.581	0.701	0.954	1.22	1.50	2.07	2.51
95.0	0.0103	0.071	0.164	0.273	0.523	0.796	0.939	1.23	1.54	1.85	2.49	2.98
90.0	0.0210	0.106	0.220	0.349	0.630	0.931	1.09	1.40	1.73	2.06	2.73	3.25
75.0	0.0576	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	1.86	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	1.328	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

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

Acceptable Quality Levels (normal inspection)

Legend: ▽ = Less than 0.025 → use next preceding sample size code letter (for all plan types). △ = Higher than 2.5 → use next subsequent sample size code letter (for all plan types).

Single sampling plan

Cumulative sample size	0.065 (Ac Re)	0.10 (Ac Re)	0.15 (Ac Re)	0.25 (Ac Re)	0.40 (Ac Re)	0.65 (Ac Re)	1.0 (Ac Re)	1.5 (Ac Re)	2.5 (Ac Re)
500	0 1	1 2	2 3	3 4	5 6	7 8	10 11	14 15	21 22

(At AQL 0.025 and 0.040: ▽ use next preceding code letter.)

Double sampling plan

Cumulative sample size	0.040	0.065	0.10 (Ac Re)	0.15 (Ac Re)	0.25 (Ac Re)	0.40 (Ac Re)	0.65 (Ac Re)	1.0 (Ac Re)	1.5 (Ac Re)	2.5 (Ac Re)
315	Use Letter M	Use Letter Q	0 2	0 3	1 3	2 5	3 7	5 9	7 11	11 16
630			1 2	3 4	4 5	6 7	8 9	12 13	18 19	26 27

(At AQL 0.025: ● use single sampling plan above, or alternatively use letter R.)

Multiple sampling plan

Cumulative sample size	0.10 (Ac Re)	0.15 (Ac Re)	0.25 (Ac Re)	0.40 (Ac Re)	0.65 (Ac Re)	1.0 (Ac Re)	1.5 (Ac Re)	2.5 (Ac Re)
125	* 2	* 2	* 3	* 4	0 4	0 5	1 7	2 9
250	* 2	0 3	0 3	1 5	1 6	3 8	4 10	7 14
375	0 2	0 3	1 4	2 6	3 8	6 10	8 13	13 19
500	0 3	1 4	2 5	3 7	5 10	8 13	12 17	19 25
625	1 3	2 4	3 6	5 8	7 11	11 15	17 20	25 29
750	1 3	3 5	4 6	7 9	10 12	14 17	21 23	31 33
875	2 3	4 5	6 7	9 10	13 14	18 19	25 26	37 38

(* = acceptance not permitted at this sample size. For lower AQLs: Use Letter P.)

Acceptable Quality Levels (tightened inspection) — column headers shifted by one: Less than 0.040, 0.040, 0.065, 0.10, 0.15, 0.25, 0.40, 0.65, 1.0, 1.5, 2.5, Higher than 2.5.

Legend:

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

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

Ac = Acceptance number

Re = Rejection number

● = Use single sampling plan above (or alternatively use letter R).

* = Acceptance not permitted at this sample size.

N

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

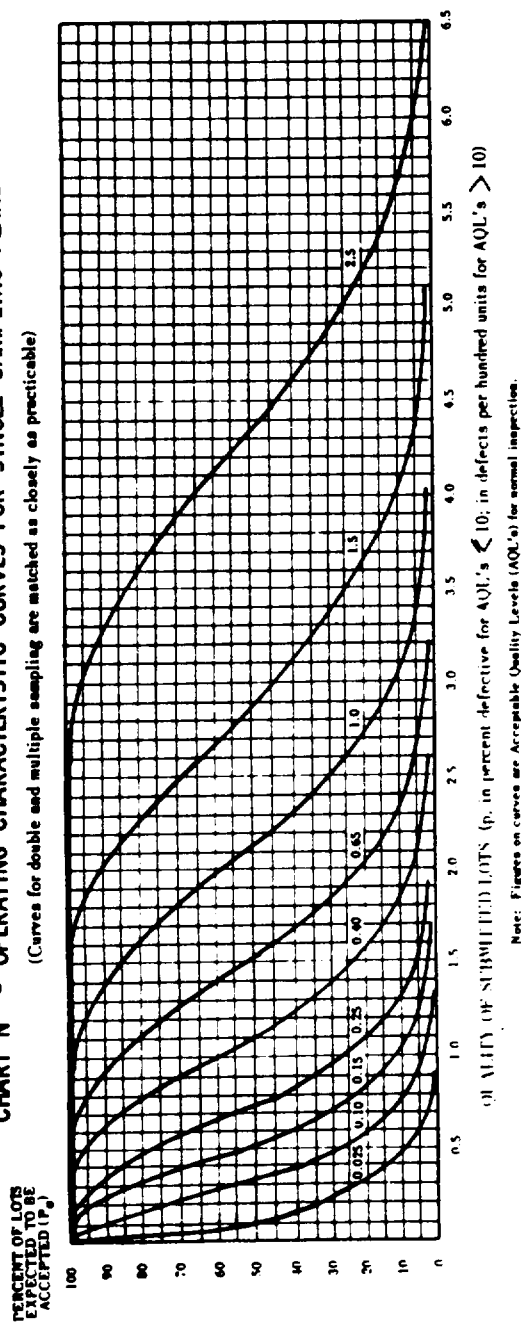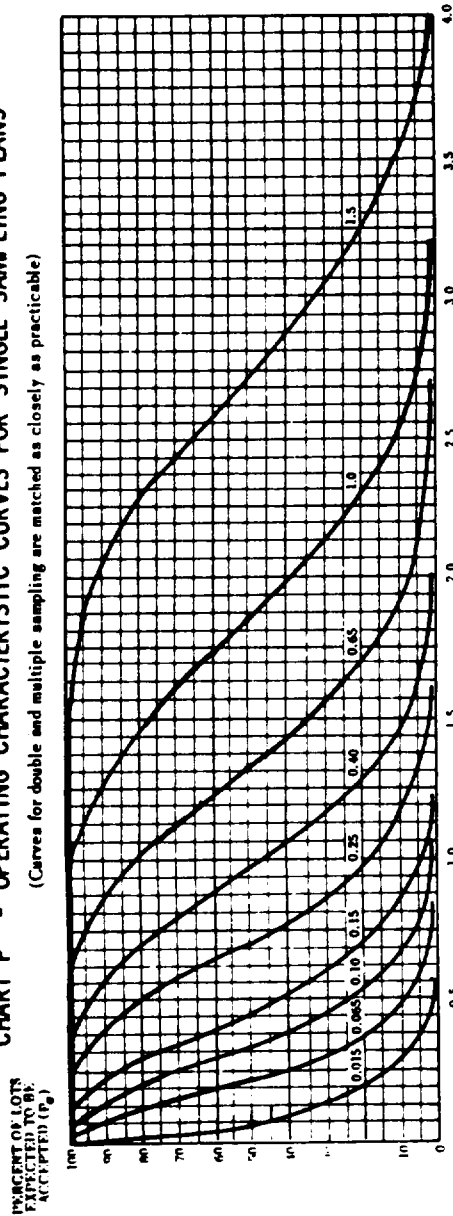## CHART P - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

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-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	X	0.65	X	1.0	X	1.5
	Min percent defective or defects per hundred units)											
99.0	0.0013	0.0186	0.055	0.103	0.223	0.363	0.438	0.596	0.762	0.935	1.29	1.57
95.0	0.0064	0.0444	0.102	0.171	0.327	0.498	0.587	0.771	0.961	1.16	1.56	1.86
90.0	0.0131	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	2.18	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	0.375	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	X	1.0	X	1.5	X	X
	Acceptable Quality Levels (tightened inspection)											

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

P

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

Acceptable Quality Levels (normal inspection) — top header row
Acceptable Quality Levels (tightened inspection) — bottom header row (offset by one column)

Values are given as Ac/Re (Acceptance number / Rejection number). "X" = crossed column (tightened‑only). ▽ and △ are arrows (see legend).

Single

Cumulative sample size	0.015	0.025	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	Higher than 1.5
800	0/1	(Use Letter)	1/2	2/3	3/4	5/6	7/8	10/11	14/15	21/22	△

(normal inspection: tightened‑only columns carry 8/9, 12/13, 18/19; ▽ at AQL 0.010)

Double

Cumulative sample size	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	Higher than 1.5
500	Use Letter N	Use Letter R	0/2	0/3	1/4	2/5	3/7	5/9	7/11	9/14	11/16	△
1000			1/2	3/4	4/5	6/7	8/9	11/12	15/16	23/24	26/27

(▽ at AQL 0.010; • at AQL 0.015 = Use single sampling plan above)

Multiple

Cumulative sample size	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5
200	*/2	*/2	*/3	*/4	0/4	0/5	1/7	2/9
400	*/2	0/3	0/3	1/5	1/6	3/8	4/10	7/14
600	0/2	0/3	1/4	2/6	3/8	6/10	8/13	13/19
800	0/3	1/4	2/5	3/7	5/10	8/13	12/17	19/25
1000	1/3	2/4	3/6	5/8	7/11	11/15	17/20	25/29
1200	1/3	3/5	4/6	7/9	10/12	14/17	21/23	31/33
1400	2/3	4/5	6/7	9/10	13/14	18/19	25/26	37/38

Tightened‑only (X) columns, Ac/Re by stage (200,400,600,800,1000,1200,1400):
- 0/4, 2/7, 4/9, 6/11, 9/12, 12/14, 14/15
- 0/6, 3/9, 7/12, 10/15, 14/17, 18/20, 21/22
- 1/8, 6/12, 11/17, 16/22, 22/25, 27/29, 32/33

(▽ at AQL 0.010)

Acceptable Quality Levels (tightened inspection) header (offset): Less than 0.025 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | Higher than 1.5

Legend:

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

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

Ac = Acceptance number.
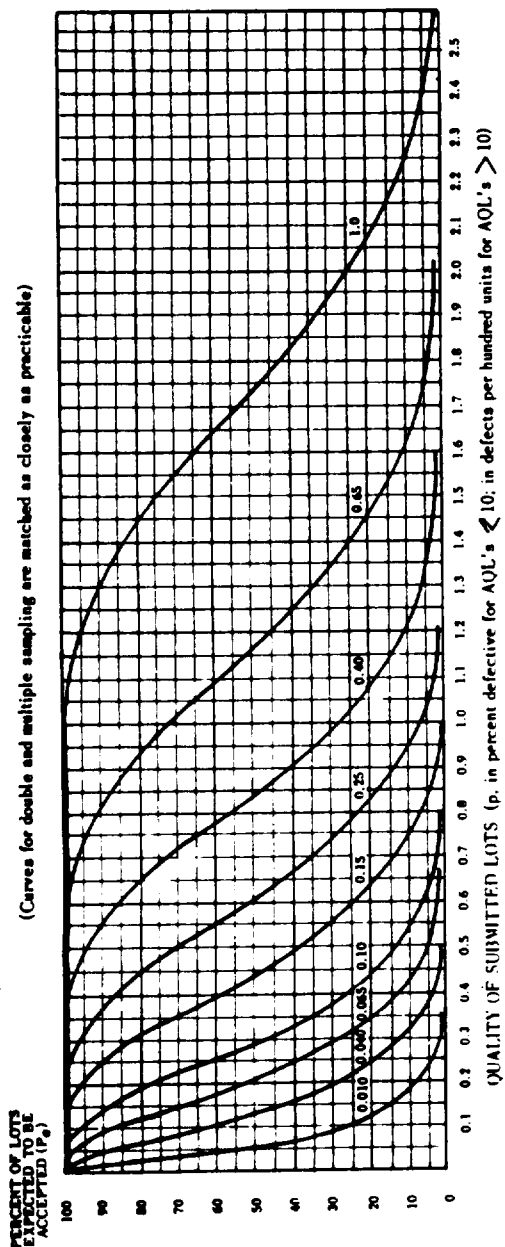
Re = Rejection number.

• = Use single sampling plan above.

* = Acceptance not permitted at this sample size.

P

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

CHART Q - OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

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

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (Pa)

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

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

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

P_a	Acceptable Quality Levels (normal inspection)											
	0.010	0.040	0.065	0.10	0.15	0.25	X	0.40	X	0.65	X	1.0
	p (in percent defective or defects per hundred units)											
99.0	0.00081	0.0119	0.0349	0.0656	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	0.00840	0.0426	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	0.0554	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	0.310	0.426	0.534	0.742	0.942	1.04	1.23	1.42	1.56	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	1.83	1.61	1.83	2.04	2.45	2.75
	0.015	0.065	0.10	0.15	0.25	0.40	X	0.65	X	1.0	X	
	Acceptable Quality Levels (tightened inspection)											

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

Q

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

Acceptable Quality Levels (normal inspection)

Type of sampling plan	Cumulative sample size	0.010 Ac	Re	0.040 Ac	Re	0.065 Ac	Re	0.10 Ac	Re	0.15 Ac	Re	0.25 Ac	Re	0.40 Ac	Re	0.65 Ac	Re	X Ac	Re	1.0 Ac	Re	Higher than 1.0
Single	1250	0	1	1	2	2	3	3	4	5	6	7	8	10	11	14	15	18	19	21	22	△
Double	800			0	2	0	3	1	4	2	5	3	7	5	9	7	11	9	14	11	16	△
Double	1600			1	2	3	4	4	5	6	7	8	9	12	13	18	19	23	24	26	27	
Multiple	315			*	2	*	2	*	3	*	4	0	4	0	5	0	6	1	7	2	9	△
Multiple	630			*	2	0	3	0	3	1	5	1	6	3	8	3	9	6	10	7	14	
Multiple	945			0	2	0	3	1	4	2	6	3	8	6	10	7	12	11	13	13	19	
Multiple	1260			0	3	1	4	2	5	3	7	5	10	8	13	10	15	16	17	19	25	
Multiple	1575			1	3	2	4	3	6	5	8	7	11	11	15	14	17	22	25	25	29	
Multiple	1890			1	3	3	5	4	6	7	9	10	12	14	17	18	20	27	29	31	33	
Multiple	2205			2	3	4	5	6	7	9	10	13	14	18	19	21	22	32	33	37	38	

(Blank cells for Single/Double at AQL 0.010–0.025: "Use next preceding sample size code Letter P, R, S" as indicated by the Use Letter / P / R / S notations.)

Acceptable Quality Levels (tightened inspection):
0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0

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

Ac = Acceptance number

Re = Rejection number

• = Use single sampling plan above.

• = Use single sampling plan.

* = Acceptance not permitted at this sample size.

Q

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

CHART R – OPERATING CHARACTERISTIC CURVES FOR SINGLE SAMPLING PLANS

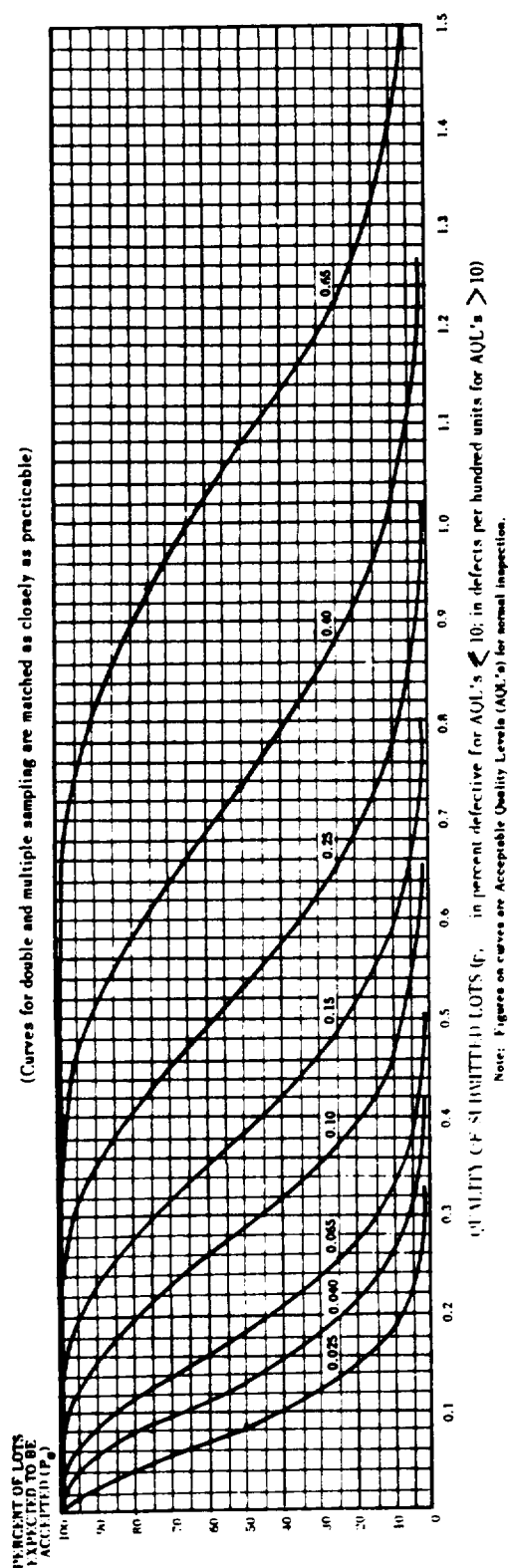(Curves for double and multiple sampling are matched as closely as practicable)

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

P_a	Acceptable Quality Levels (normal inspection)										
	0.025	0.040	0.065	0.10	0.15	X	0.25	X	0.40	X	0.65
	p (in percent defective or defects per hundred units)										
99.0	0.0074	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	0.385	0.462	0.622	0.745
90.0	0.0266	0.0551	0.0873	0.158	0.233	0.272	0.351	0.432	0.515	0.684	0.812
75.0	0.0481	0.0868	0.127	0.211	0.298	0.342	0.431	0.521	0.612	0.795	0.934
50.0	0.0839	0.134	0.184	0.284	0.384	0.433	0.533	0.633	0.733	0.933	1.08
25.0	0.135	0.196	0.256	0.371	0.484	0.540	0.651	0.761	0.870	1.09	1.25
10.0	0.195	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	0.25	0.40	0.40	0.65	0.65	X
	Acceptable Quality Levels (tightened inspection)										

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

R

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

Acceptable Quality Levels (normal inspection) — values given as Ac / Re

Type of sampling plan	Cumulative sample size	0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	Higher than 0.65
Single	2000	0/1	↑	1/2	2/3	3/4	5/6	7/8	10/11	14/15	21/22	▽
Double (1st)	1250	Use Letter Q	Use Letter P	0/2	0/3	1/4	2/5	3/7	5/9	7/11	11/16	▽
Double (2nd)	2500			1/2	3/4	4/5	6/7	8/9	12/13	18/19	26/27	
Multiple	500			#/2	#/2	#/3	#/4	#/4	0/5	1/7	2/9	▽
Multiple	1000			#/2	0/3	0/3	0/5	0/6	3/8	6/10	7/14	
Multiple	1500			0/2	0/3	1/4	1/6	1/8	6/10	11/13	13/19	
Multiple	2000			0/3	1/4	2/5	2/7	3/10	8/13	16/17	19/25	
Multiple	2500			1/3	2/4	3/6	3/8	5/11	11/15	22/20	25/29	
Multiple	3000			1/3	3/5	4/6	4/9	7/12	14/17	27/23	31/33	
Multiple	3500			2/3	4/5	6/7	6/10	10/14	18/19	32/26	37/38	

Acceptable Quality Levels (tightened inspection) — AQL scale shifts one column:
0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | Higher than 0.65

Tightened single (n = 2000): 0/1 · ↑ · 1/2 · 2/3 · 3/4 · 5/6 · 8/9 · 12/13 · 18/19 · ▽

Legend:

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

Ac = Acceptance number.

Re = Rejection number.

• = Use single sampling plan above.

■ = Acceptance not permitted at this sample size.

R

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

Type of sampling plan	Cumulative sample size	Acceptable Quality Level (normal inspection) ✕	
		Ac	**Re**
Single	3150	1	2
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.

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Index of terms with special meanings

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