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## SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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**MIL-STD-105E**

DEPARTMENT OF DEFENSE

Washington, DC 20301

SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES

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MIL-STD-105E

## FOREWORD

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

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

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

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

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SAMPLING PROCEDURES AND TABLES
FOR INSPECTION BY ATTRIBUTES

1. SCOPE

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

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

a. End items.

b. Components and raw materials.

c. Operations or services.

d. Materials in process.

e. Supplies in storage.

f. Maintenance operations.

g. Data or records.

h. Administrative procedures.

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

2. REFERENCED DOCUMENTS

2.1 Not applicable.

3. DEFINITIONS

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

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

4. GENERAL REQUIREMENTS

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

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

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

4.4 AQL.

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

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

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

4.5 Sampling.

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

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

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

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

4.7 Switching Procedures.

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

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

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

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

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

c. Production is at a steady rate; and

d. Reduced inspection is considered desirable.

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

a. A lot or batch is rejected; or

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

c. Production becomes irregular or delayed; or

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

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

4.9 Sampling Plans.

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

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

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

4.9.3 Obtaining Sample Plan. The AQL and the code letter shall be used to obtain the sampling plan from Tables II, III, or IV. When no sampling plan is available for a given combination of AQL and code letter, the tables direct the user to a different letter. The sample size to be used is given by the new code letter, not by the original letter. If this procedure leads to different sample sizes for different classes of defects, the code letter corresponding to the largest sample size derived may be used for all classes of defects. As an alternative to a single sampling plan with an acceptance number of 9, the plan with an acceptance number of 1, with its correspondingly larger sample size for a designated AQL (where available), may be used.

4.9.4 Types of Sampling Plans. Three types of sampling plans: Single, Double, and Multiple, are given in Tables II, III, and IV, respectively. When several types of plans are available for a given AQL and code letter, any one may be used. A decision as to type of plan, either single, double, or multiple, when available for a given AQL and code letter, will usually be based upon the comparison between the administrative difficulty and the average sample sizes of the available plans. The average sample size of multip0le plans is less than for double (except in the case corresponding to a single acceptance number 1) and both of these are always less than a single sample size (see Table IX). Usually the administrative difficulty for single sampling and the cost per unit of the sample are less than for double or multiple.

4.10 Determination of Acceptability

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

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

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

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

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

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

4.11 Limiting Quality Protection. The sample 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 risks 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 off lots or batches, thus fixing minimum sample size where there is some reason for avoiding (with more than a given consumer's risk) more than a limiting proportion of defectives (or defects) in any single lot or batch.

4.12 Curves

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

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

TABLE I – **Sample Size code letters**

(See 4.9.1 and 4.9.2)

| Lot or batch size | | | Special inspection levels | | | | **General inspection levels** | | |
|---|---|---|---|---|---|---|---|---|---|
| | | | S-1 | S-2 | S-3 | S-4 | I | II | III |
| 2 | To | 8 | A | A | A | A | A | A | B |
| 9 | To | 15 | A | A | A | A | A | B | C |
| 16 | To | 25 | A | A | B | B | B | C | D |
| 26 | To | 50 | A | B | B | C | C | D | E |
| 51 | To | 90 | B | B | C | D | D | F | G |
| 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 | H |
| 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 |
| 500000 | And | Over | D | E | H | K | N | Q | R |

**CODE LETTERS**

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

See 4.9.3. and 4.9.4)

| Sample size Code Letters | Sample size | Acceptable Quality Levels (Normal Inspection) | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 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 | 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 65 |
| C | 5 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↑ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | 30 31 | 44 65 | ↑ |
| D | 8 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | 30 31 | 44 65 | ↑ | ↑ |
| E | 13 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↑ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | 30 31 | 44 65 | ↑ | ↑ | ↑ |
| F | 20 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↑ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| G | 32 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| H | 50 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| J | 80 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| K | 125 | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| L | 200 | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| M | 315 | ↓ | ↓ | ↓ | 0 1 | ↑ | ↑ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| N | 500 | ↓ | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| P | 800 | ↓ | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| Q | 1250 | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| R | 2000 | ↑ | ↑ | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |

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

**SINGLE NORMAL**

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

(See 4.9.3. and 4.9.4)

| Sample size Code Letters | Sample size | Acceptable Quality Levels (Normal Inspection) | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 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 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 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 | 27 28 | 41 42 | ↑ | ↑ |
| E | 13 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↓ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 8 9 | 12 13 | 18 19 | 27 28 | 41 42 | ↑ | ↑ | ↑ |
| 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 | ↓ | ↓ | ↓ | 0 1 | ↓ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 8 9 | 12 13 | 18 19 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| P | 800 | ↓ | ↓ | 0 1 | ↓ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 8 9 | 12 13 | 18 19 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| Q | 1250 | ↓ | 0 1 | ↓ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 8 9 | 12 13 | 18 19 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| R | 2000 | 0 1 | ↑ | ↓ | 1 2 | 2 3 | 3 4 | 5 6 | 8 9 | 12 13 | 18 19 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| S | 3150 | | | 1 2 | | | | | | | | | | | | | | | | | | | | | | | |

| | | |
|---|---|---|
| | = | Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspections |
| ⇑ | = | 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)

See 4.9.3. and 4.9.4)

| Sample size Code Letters | Sample size | Acceptable Quality Levels (Reduced Inspection)† | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re |
| 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 | ↑ | ↓ | 0 2 | 1 3 | 2 4 | 3 5 | 5 6 | 7 8 | 10 11 | 14 15 | 21 22 | 30 31 |
| C | 2 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 1 | ↑ | ↓ | 0 2 | 1 3 | 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 1 | ↑ | ↓ | 0 2 | 1 3 | 1 4 | 2 5 | 3 6 | 5 8 | 7 10 | 10 13 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| R | 800 | ↑ | ↑ | 0 2 | 1 3 | 1 4 | 2 5 | 3 6 | 5 8 | 7 10 | 10 13 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |

| | | |
|---|---|---|
| | = | Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspections |
| ⇑ | = | 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) |
| † | = | 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 (see4.10.1.4) |

**SINGLE**
**REDUCED**

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

See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | Acceptable Quality Levels (Normal Inspection)† | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 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 | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| B | First<br>Second | 2<br>2 | 2<br>4 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | 17 22<br>37 38 | 25 31<br>56 57 |
| C | First<br>Second | 3<br>3 | 3<br>6 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↑<br>↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | 17 22<br>37 38 | 25 31<br>56 57 | ↑ |
| D | First<br>Second | 5<br>5 | 5<br>10 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↑<br>↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | 17 22<br>37 38 | 25 31<br>56 57 | ↑ | ↑ |
| E | First<br>Second | 8<br>8 | 8<br>16 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↑<br>↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | 17 22<br>37 38 | 25 31<br>56 57 | ↑ | ↑ | ↑ |
| F | First<br>Second | 13<br>13 | 13<br>26 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↑<br>↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| G | First<br>Second | 20<br>20 | 20<br>40 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| H | First<br>Second | 32<br>32 | 32<br>64 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| J | First<br>Second | 50<br>50 | 50<br>100 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↑<br>↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| K | First<br>Second | 80<br>80 | 80<br>160 | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| L | First<br>Second | 125<br>125 | 125<br>250 | ↓ | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| M | First<br>Second | 200<br>200 | 200<br>400 | ↓ | ↓ | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| N | First<br>Second | 315<br>315 | 315<br>630 | ↓ | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| P | First<br>Second | 500<br>500 | 500<br>1000 | ↓ | ● | ↑<br>↓ | ↓ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| Q | First<br>Second | 800<br>800 | 800<br>1600 | ● | ↑ | ↑<br>↓ | ↑<br>↓ | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| R | First<br>Second | 1250<br>1250 | 1250<br>2500 | ↑ | ↑ | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 5 9<br>12 13 | 7 11<br>18 19 | 11 16<br>26 27 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |

| | | |
|---|---|---|
| | = | Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspections |
| ⇑ | = | 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**

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

See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | 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 | 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 | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● |
| B | First | 2 | 2 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | 15 20 | 23 29 |
| | Second | 2 | 4 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | 31 33 | 34 35 |
| C | First | 3 | 3 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | 15 20 | 23 29 | ↑ |
| | Second | 3 | 6 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | 31 33 | 34 35 | ↑ |
| D | First | 5 | 5 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | 15 20 | 23 29 | ↑ | ↑ |
| | Second | 5 | 10 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | 31 33 | 34 35 | ↑ | ↑ |
| E | First | 8 | 8 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | 15 20 | 23 29 | ↑ | ↑ | ↑ |
| | Second | 8 | 16 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | 31 33 | 34 35 | ↑ | ↑ | ↑ |
| F | First | 13 | 13 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 13 | 26 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 4 5 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| G | First | 20 | 20 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 20 | 40 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| H | First | 32 | 32 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 32 | 64 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| J | First | 50 | 50 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 50 | 100 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| K | First | 80 | 80 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 80 | 160 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| L | First | 125 | 125 | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 125 | 250 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| M | First | 200 | 200 | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 200 | 400 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| N | First | 315 | 315 | ↓ | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 315 | 630 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| P | First | 500 | 500 | ↓ | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 500 | 1000 | ↓ | ↓ | ↓ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| Q | First | 800 | 800 | ↓ | ● | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 800 | 1600 | ↓ | ↑ | ↓ | ↓ | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| R | First | 1250 | 1250 | ● | ↑ | ↓ | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 6 10 | 9 14 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 1250 | 2500 | | | | 1 2 | 3 4 | 4 5 | 6 7 | 11 12 | 15 16 | 23 24 | | | | | | | | | | | | | | | | |
| S | First | 2000 | 2000 | | | 0 2 | | | | | | | | | | | | | | | | | | | | | | | |
| | Second | 2000 | 4000 | | | 1 2 | | | | | | | | | | | | | | | | | | | | | | | |

| | | |
|---|---|---|
| ↓ | = | Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspections |
| ⇑ | = | 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 TIGHTENED**

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

See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | Acceptable Quality Levels (Reduced Inspection)† | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| | | | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re |
| A | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| B | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| C | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ↑ |
| D | First<br>Second | 2<br>2 | 2<br>4 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | 7 12<br>18 22 | 11 17<br>26 30 | ↑ | ↑ |
| E | First<br>Second | 3<br>3 | 3<br>6 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | 7 12<br>18 22 | 11 17<br>26 30 | ↑ | ↑ | ↑ |
| F | First<br>Second | 5<br>5 | 5<br>10 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| G | First<br>Second | 8<br>8 | 8<br>16 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| H | First<br>Second | 13<br>13 | 13<br>26 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| J | First<br>Second | 20<br>20 | 20<br>40 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| K | First<br>Second | 32<br>32 | 32<br>64 | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| L | First<br>Second | 50<br>50 | 50<br>100 | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| M | First<br>Second | 80<br>80 | 80<br>160 | ↓ | ↓ | ↓ | ● | ↑ | ↓ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| N | First<br>Second | 125<br>125 | 125<br>250 | ↓ | ↓ | ● | ↑ | ↑ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| P | First<br>Second | 200<br>200 | 200<br>400 | ↓ | ● | ↑ | ↑ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| Q | First<br>Second | 315<br>315 | 315<br>630 | ● | ↑ | ↑ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| R | First<br>Second | 500<br>500 | 500<br>1000 | ↑ | ↑ | 0 2<br>0 2 | 0 3<br>0 4 | 0 4<br>1 5 | 0 4<br>3 6 | 1 5<br>4 7 | 2 7<br>6 9 | 3 8<br>8 12 | 5 10<br>12 16 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |

| | | |
|---|---|---|
| | = | Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspections |
| ⇑ | = | 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) |
| † | = | 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 (see4.10.1.4) |

**DOUBLE REDUCED**

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

See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | Acceptable Quality Levels (Normal Inspection)† | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 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 | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| B | | | | | | | | | | | | | | | | | ● | ◆ | | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ |
| C | | | | | | | | | | | | | | | | ● | ↑ | ↓ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ↑ |
| D | First | 2 | 2 | | | | | | | | | | | | ● | | | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 2 9 | 4 12 | 6 16 | | | |
| | Second | 2 | 4 | | | | | | | | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | 11 19 | 17 27 | | | |
| | Third | 2 | 6 | | | | | | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | 19 27 | 29 39 | | | |
| | Fourth | 2 | 8 | | | | | | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | 27 34 | 40 49 | | | |
| | Fifth | 2 | 10 | | | | | | | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | 36 40 | 53 58 | | | |
| | Sixth | 2 | 12 | | | | | | | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | 45 47 | 65 68 | | | |
| | Seventh | 2 | 14 | | | | | | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | 53 54 | 77 78 | | | |
| E | First | 3 | 3 | | | | | | | | | | | ● | | | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 2 9 | 4 12 | 6 16 | | | | |
| | Second | 3 | 6 | | | | | | | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | 11 19 | 17 27 | | | | |
| | Third | 3 | 9 | | | | | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | 19 27 | 29 39 | | | | |
| | Fourth | 3 | 12 | | | | | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | 27 34 | 40 49 | | | | |
| | Fifth | 3 | 15 | | | | | | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | 36 40 | 53 58 | | | | |
| | Sixth | 3 | 18 | | | | | | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | 45 47 | 65 68 | | | | |
| | Seventh | 3 | 21 | | | | | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | 53 54 | 77 78 | | | | |
| F | First | 5 | 5 | | | | | | | | | | ● | | | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 2 9 | | | | | | | |
| | Second | 5 | 10 | | | | | | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | |
| | Third | 5 | 15 | | | | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | |
| | Fourth | 5 | 20 | | | | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | |
| | Fifth | 5 | 25 | | | | | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | |
| | Sixth | 5 | 30 | | | | | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | |
| | Seventh | 5 | 35 | | | | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | |
| G | First | 8 | 8 | | | | | | | | | ● | | | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 2 9 | | | | | | | | |
| | Second | 8 | 16 | | | | | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | |
| | Third | 8 | 24 | | | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | |
| | Fourth | 8 | 32 | | | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | |
| | Fifth | 8 | 40 | | | | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | |
| | Sixth | 8 | 48 | | | | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | |
| | Seventh | 8 | 56 | | | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | |
| H | First | 13 | 13 | | | | | | | | ● | | | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 2 9 | | | | | | | | | |
| | Second | 13 | 26 | | | | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | |
| | Third | 13 | 39 | | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | |
| | Fourth | 13 | 52 | | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | |
| | Fifth | 13 | 65 | | | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | |
| | Sixth | 13 | 78 | | | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | |
| | Seventh | 13 | 91 | | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | |
| J | First | 20 | 20 | | | | | | | ● | | | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 2 9 | | | | | | | | | | |
| | Second | 20 | 40 | | | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | |
| | Third | 20 | 60 | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | |
| | Fourth | 20 | 80 | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | | |
| | Fifth | 20 | 100 | | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | | |
| | Sixth | 20 | 120 | | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | |
| | Seventh | 20 | 140 | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | |

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

⇑ = 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)

‡ = Use corresponding double sampling plan (or alternatively, use double sampling plan below, where available)

∞ = Acceptance not permitted at this sample size.

**MULTIPLE NORMAL**

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

See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | Acceptable Quality Levels (Normal Inspection)† | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 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 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 0 2 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| B | | | | | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | |
| C | | | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | |
| | | | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | | |
| | | | | | | | | | | | | 1 3 | 2 5 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | | |
| | | | | | | | | | | | | 1 3 | 3 6 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | |
| | | | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | |
| D | First | 2 | 2 | | | | | ● | ↑ | ↓ | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 0 2 | | | | | | | | | | | |
| | Second | 2 | 4 | | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | | |
| | Third | 2 | 6 | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | | |
| | Fourth | 2 | 8 | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | | | |
| | Fifth | 2 | 10 | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | | | |
| | Sixth | 2 | 12 | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | | |
| | Seventh | 2 | 14 | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | | |
| E | First | 3 | 3 | | | | ● | ↑ | ↓ | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 0 2 | ↑ | | | | | | | | | | | |
| | Second | 3 | 6 | | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | | | |
| | Third | 3 | 9 | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | | | |
| | Fourth | 3 | 12 | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | | | | |
| | Fifth | 3 | 15 | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | | | | |
| | Sixth | 3 | 18 | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | | | |
| | Seventh | 3 | 21 | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | | | |
| F | First | 5 | 5 | | | ● | ↑ | ↓ | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 0 2 | ↑ | | | | | | | | | | | | |
| | Second | 5 | 10 | | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | | | | |
| | Third | 5 | 15 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | | | | |
| | Fourth | 5 | 20 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | | | | | |
| | Fifth | 5 | 25 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | | | | | |
| | Sixth | 5 | 30 | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | | | | |
| | Seventh | 5 | 35 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | | | | |
| G | First | 8 | 8 | | ● | ↑ | ↓ | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 0 2 | ↑ | | | | | | | | | | | | | |
| | Second | 8 | 16 | | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | | | | | |
| | Third | 8 | 24 | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | | | | | |
| | Fourth | 8 | 32 | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | | | | | | |
| | Fifth | 8 | 40 | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | | | | | | |
| | Sixth | 8 | 48 | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | | | | | |
| | Seventh | 8 | 56 | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | | | | | |
| H | First | 13 | 13 | ● | ↑ | ↓ | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 0 2 | ↑ | | | | | | | | | | | | | | |
| | Second | 13 | 26 | | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | | | | | | |
| | Third | 13 | 39 | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | | | | | | |
| | Fourth | 13 | 52 | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 12 17 | 19 25 | | | | | | | | | | | | | | | |
| | Fifth | 13 | 65 | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 17 20 | 25 29 | | | | | | | | | | | | | | | |
| | Sixth | 13 | 78 | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | | | | | | |
| | Seventh | 13 | 91 | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | | | | | | |
| J | First | 20 | 20 | ↑ | ↑ | ∞ 2 | ∞ 2 | ∞ 3 | ∞ 4 | 0 4 | 0 5 | 1 7 | 0 2 | ↑ | | | | | | | | | | | | | | | |
| | Second | 20 | 40 | | | ∞ 2 | 0 3 | 0 3 | 1 5 | 1 6 | 3 8 | 4 10 | 7 14 | | | | | | | | | | | | | | | | |
| | Third | 20 | 60 | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 6 10 | 8 13 | 13 19 | | | | | | | | | | | | | | | | |
| | Fourth | 20 | 80 | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 8 13 | 11 15 | 19 25 | | | | | | | | | | | | | | | | |
| | Fifth | 20 | 100 | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 11 15 | 14 17 | 25 29 | | | | | | | | | | | | | | | | |
| | Sixth | 20 | 120 | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 14 17 | 21 23 | 31 33 | | | | | | | | | | | | | | | | |
| | Seventh | 20 | 140 | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 18 19 | 25 26 | 37 38 | | | | | | | | | | | | | | | | |

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

⇑ = 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)

∞ = Acceptance not permitted at this sample size.

**MULTIPLE NORMAL**

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

See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | 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 | 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 | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● |
| B | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ |
| C | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ↑ |
| D | First | 2 | 2 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | 3 10 | 6 15 | ↑ | ↑ |
| | Second | 2 | 4 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | 10 17 | 16 25 | ↑ | ↑ |
| | Third | 2 | 6 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | 17 24 | 26 36 | ↑ | ↑ |
| | Fourth | 2 | 8 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | 24 31 | 37 46 | ↑ | ↑ |
| | Fifth | 2 | 10 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | 32 37 | 49 55 | ↑ | ↑ |
| | Sixth | 2 | 12 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | 40 43 | 61 64 | ↑ | ↑ |
| | Seventh | 2 | 14 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 22 22 | 32 33 | 48 49 | 72 73 | ↑ | ↑ |
| E | First | 3 | 3 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | 3 10 | 6 15 | ↑ | ↑ | ↑ |
| | Second | 3 | 6 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | 10 17 | 16 25 | ↑ | ↑ | ↑ |
| | Third | 3 | 9 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | 17 24 | 26 36 | ↑ | ↑ | ↑ |
| | Fourth | 3 | 12 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | 24 31 | 37 46 | ↑ | ↑ | ↑ |
| | Fifth | 3 | 15 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | 32 37 | 49 55 | ↑ | ↑ | ↑ |
| | Sixth | 3 | 18 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | 40 43 | 61 64 | ↑ | ↑ | ↑ |
| | Seventh | 3 | 21 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 22 22 | 32 33 | 48 49 | 72 73 | ↑ | ↑ | ↑ |
| F | First | 5 | 5 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 5 | 10 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 5 | 15 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 5 | 20 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 5 | 25 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 5 | 30 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 5 | 35 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 22 22 | 32 33 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| G | First | 8 | 8 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 8 | 16 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 8 | 24 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 8 | 32 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 8 | 40 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 8 | 48 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 8 | 56 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 22 22 | 32 33 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| H | First | 13 | 13 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 13 | 26 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 13 | 39 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 13 | 52 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 13 | 65 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 13 | 78 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 13 | 91 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 22 22 | 32 33 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| J | First | 20 | 20 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 20 | 40 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 20 | 60 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 20 | 80 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 20 | 100 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 20 | 120 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 20 | 140 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 22 22 | 32 33 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |

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

⇑ = 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)

‡ = Use corresponding double sampling plan (or alternatively, use double sampling plan below, where available)

# = Acceptance not permitted at this sample size.

**MULTIPLE TIGHTENED**

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

See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | 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 | 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 |
| K | First | 32 | 32 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 32 | 64 | | | | | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | | | | | | | | | | |
| | Third | 32 | 96 | | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | | | | | | | | | | |
| | Fourth | 32 | 128 | | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | | | | | | | | | | |
| | Fifth | 32 | 160 | | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | | | | | | | | | | |
| | Sixth | 32 | 192 | | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | | | | | | | | | | |
| | Seventh | 32 | 224 | | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 21 22 | 32 33 | | | | | | | | | | |
| L | First | 50 | 50 | | | | | | ● | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | | | | | | | | | | |
| | Second | 50 | 100 | | | | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | | | | | | | | | | | |
| | Third | 50 | 150 | | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | | | | | | | | | | | |
| | Fourth | 50 | 200 | | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | | | | | | | | | | | |
| | Fifth | 50 | 250 | | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | | | | | | | | | | | |
| | Sixth | 50 | 300 | | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | | | | | | | | | | | |
| | Seventh | 50 | 350 | | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 21 22 | 32 33 | | | | | | | | | | | |
| M | First | 80 | 80 | | | | | ● | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | | | | | | | | | | | |
| | Second | 80 | 160 | | | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | | | | | | | | | | | | |
| | Third | 80 | 240 | | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | | | | | | | | | | | | |
| | Fourth | 80 | 320 | | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | | | | | | | | | | | | |
| | Fifth | 80 | 400 | | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | | | | | | | | | | | | |
| | Sixth | 80 | 480 | | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | | | | | | | | | | | | |
| | Seventh | 80 | 560 | | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 21 22 | 32 33 | | | | | | | | | | | | |
| N | First | 125 | 125 | | | | ● | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | | | | | | | | | | | | |
| | Second | 125 | 250 | | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | | | | | | | | | | | | | |
| | Third | 125 | 375 | | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | | | | | | | | | | | | | |
| | Fourth | 125 | 500 | | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | | | | | | | | | | | | | |
| | Fifth | 125 | 625 | | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | | | | | | | | | | | | | |
| | Sixth | 125 | 750 | | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | | | | | | | | | | | | | |
| | Seventh | 125 | 875 | | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 21 22 | 32 33 | | | | | | | | | | | | | |
| P | First | 200 | 200 | | | ● | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | | | | | | | | | | | | | | |
| | Second | 200 | 400 | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | ↑ | | | | | | | | | | | | | |
| | Third | 200 | 600 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | | | | | | | | | | | | | | |
| | Fourth | 200 | 800 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | | | | | | | | | | | | | | |
| | Fifth | 200 | 1000 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | | | | | | | | | | | | | | |
| | Sixth | 200 | 1200 | | ↓ | | | | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | | | | | | | | | | | | | | |
| | Seventh | 200 | 1400 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 21 22 | 32 33 | | | | | | | | | | | | | | |
| Q | First | 315 | 315 | | ● | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | | | | | | | | | | | | | | | |
| | Second | 315 | 630 | | | | | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | | | | | | | | | | | | | | | |
| | Third | 315 | 945 | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | ↑ | | | | | | | | | | | | | | |
| | Fourth | 315 | 1260 | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | | | | | | | | | | | | | | | |
| | Fifth | 315 | 1575 | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | | | | | | | | | | | | | | | |
| | Sixth | 315 | 1890 | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 12 14 | 18 20 | 27 29 | | | | | | | | | | | | | | | |
| | Seventh | 315 | 2205 | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 14 15 | 21 22 | 32 33 | | | | | | | | | | | | | | | |
| R | First | 500 | 500 | ● | ↑ | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 6 | 1 8 | ↑ | | | | | | | | | | | | | | | |
| | Second | 500 | 1000 | | | | # 2 | 0 3 | 0 3 | 1 5 | 2 7 | 3 9 | 6 12 | | | | | | | | | | | | | | | | |
| | Third | 500 | 1500 | | | | 0 2 | 0 3 | 1 4 | 2 6 | 4 9 | 7 12 | 11 17 | | | | | | | | | | | | | | | | |
| | Fourth | 500 | 2000 | | | | 0 3 | 1 4 | 2 5 | 3 7 | 6 11 | 10 15 | 16 22 | | | | | | | | | | | | | | | | |
| | Fifth | 500 | 2500 | | | | 1 3 | 2 4 | 3 6 | 5 8 | 9 12 | 14 17 | 22 25 | | | | | | | | | | | | | | | | |
| | Sixth | 500 | 3000 | | | | 1 3 | 3 5 | 4 6 | 7 9 | 12 | 18 20 | 27 29 | | | | | | | | | | | | | | | | |
| | Seventh | 500 | 3500 | | | | 2 3 | 4 5 | 6 7 | 9 10 | 14 | 21 22 | 32 33 | | | | | | | | | | | | | | | | |
| | | | | | | | | | | | 15 | | | | | | | | | | | | | | | | | | |
| S | First | 800 | 800 | | | # 2 | | | | | | | | | | | | | | | | | | | | | | | |
| | Second | 800 | 1600 | | | # 2 | | | | | | | | | | | | | | | | | | | | | | | |
| | Third | 800 | 2400 | | | 0 2 | | | | | | | | | | | | | | | | | | | | | | | |
| | Fourth | 800 | 3200 | | | 0 3 | | | | | | | | | | | | | | | | | | | | | | | |
| | Fifth | 800 | 4000 | | | 1 3 | | | | | | | | | | | | | | | | | | | | | | | |
| | Sixth | 800 | 4800 | | | 1 3 | | | | | | | | | | | | | | | | | | | | | | | |
| | Seventh | 800 | 5600 | | | 2 3 | | | | | | | | | | | | | | | | | | | | | | | |

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

⇑ = 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)

\# Acceptance not permitted at this sample size.

**MULTIPLE TIGHTENED**

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

See 4.9.3. and 4.9.4)

| Sample Code Letter | Sample | Sample Size | Cumulative sample size | Acceptable Quality Levels (reduced inspection) † | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| | | | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re |
| A | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| B | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| C | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| D | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | ↓ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| E | | | | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↑ | ↓ | ↓ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ‡ | ↑ | ↑ |
| F | First | 2 | 2 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↓ | ↓ | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | 0 6 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 2 | 4 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 3 9 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 2 | 6 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 2 | 8 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 8 15 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 2 | 10 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 2 | 12 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 14 20 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 2 | 14 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 11 | 13 17 | 18 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| G | First | 3 | 3 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | 0 6 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 3 | 6 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 3 9 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 3 | 9 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 3 | 12 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 8 15 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 3 | 15 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 3 | 18 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 14 20 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 3 | 21 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 11 | 13 17 | 18 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| H | First | 5 | 5 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | # 2 | # 2 | # 3 | # 2 | # 4 | # 4 | 0 5 | 0 6 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 5 | 10 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | # 2 | # 3 | # 3 | # 2 | 0 5 | 1 6 | 1 7 | 3 9 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 5 | 15 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 2 | 0 3 | 0 4 | 0 2 | 1 6 | 2 8 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 5 | 20 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 0 5 | 0 3 | 2 7 | 3 10 | 5 12 | 8 15 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 5 | 25 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 1 6 | 1 3 | 3 8 | 5 11 | 7 13 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 5 | 30 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 1 5 | 1 6 | 1 3 | 4 9 | 7 12 | 10 15 | 14 20 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 5 | 35 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 1 3 | 1 5 | 2 7 | 2 3 | 6 10 | 9 11 | 13 17 | 18 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| J | First | 8 | 8 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | # 2 | # 2 | # 3 | # 2 | # 4 | # 4 | 0 5 | 0 6 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 8 | 16 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | # 2 | # 3 | # 3 | # 2 | 0 5 | 1 6 | 1 7 | 3 9 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 8 | 24 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 2 | 0 3 | 0 4 | 0 2 | 1 6 | 2 8 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 8 | 32 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 0 5 | 0 3 | 2 7 | 3 10 | 5 12 | 8 15 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 8 | 40 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 1 6 | 1 3 | 3 8 | 5 11 | 7 13 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 8 | 48 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 1 5 | 1 6 | 1 3 | 4 9 | 7 12 | 10 15 | 14 20 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 8 | 56 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 1 3 | 1 5 | 2 7 | 2 3 | 6 10 | 9 11 | 13 17 | 18 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| K | First | 13 | 13 | ↓ | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | # 2 | # 2 | # 3 | # 2 | # 4 | # 4 | 0 5 | 0 6 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 13 | 26 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | # 2 | # 3 | # 3 | # 2 | 0 5 | 1 6 | 1 7 | 3 9 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Third | 13 | 39 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 2 | 0 3 | 0 4 | 0 2 | 1 6 | 2 8 | 3 9 | 6 12 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fourth | 13 | 52 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 0 5 | 0 3 | 2 7 | 3 10 | 5 12 | 8 15 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Fifth | 13 | 65 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 0 4 | 1 6 | 1 3 | 3 8 | 5 11 | 7 13 | 11 17 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Sixth | 13 | 78 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 0 3 | 1 5 | 1 6 | 1 3 | 4 9 | 7 12 | 10 15 | 14 20 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Seventh | 13 | 91 | ↓ | ↓ | ↓ | ↓ | ↓ | ↓ | ↑ | ↓ | 1 3 | 1 5 | 2 7 | 2 3 | 6 10 | 9 11 | 13 17 | 18 22 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |

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

⇑ = 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)

‡ = Use corresponding double sampling plan (or alternatively, use double 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 4.10.1.4)

**MULTIPLE TIGHTENED**

**TABLE IV-C** – Multiple sampling plans for reduced inspection (Master table)
(Continued)
See 4.9.3. and 4.9.4)

| Sample Size Code Letter | Sample | Sample Size | Cumulative sample size | Acceptable Quality Levels (reduced inspection) † | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| | | | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re |
| L | First | 20 | 20 | ↓ | ↓ | ↓ | ↓ | ● | ↑ | ↓ | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | 0 6 | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ | ↑ |
| | Second | 20 | 40 | | | | | | | | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 3 9 | | | | | | | | | | | |
| | Third | 20 | 60 | | | | | | | | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 6 12 | | | | | | | | | | | |
| | Fourth | 20 | 80 | | | | | | | | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 8 15 | | | | | | | | | | | |
| | Fifth | 20 | 100 | | | | | | | | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 11 17 | | | | | | | | | | | |
| | Sixth | 20 | 120 | | | | | | | | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 14 20 | | | | | | | | | | | |
| | Seventh | 20 | 140 | | | | | | | | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 14 | 13 17 | 18 22 | | | | | | | | | | | |
| M | First | 32 | 32 | | | | ● | | | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | # 4 | ↑ | | | | | | | | | | | |
| | Second | 32 | 64 | | | | | ↑ | | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 1 6 | | | | | | | | | | | | |
| | Third | 32 | 96 | | | | | | | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 2 8 | | | | | | | | | | | | |
| | Fourth | 32 | 128 | | | | | | | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 3 10 | | | | | | | | | | | | |
| | Fifth | 32 | 160 | | | | | | | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 5 11 | | | | | | | | | | | | |
| | Sixth | 32 | 192 | | | | | | | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 7 12 | | | | | | | | | | | | |
| | Seventh | 32 | 224 | | | | | | | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 14 | 13 17 | 9 11 | | | | | | | | | | | | |
| N | First | 50 | 50 | | | ● | ↑ | | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | # 4 | ↑ | | | | | | | | | | | | |
| | Second | 50 | 100 | | | | | | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 1 6 | | | | | | | | | | | | | |
| | Third | 50 | 150 | | | | | | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 2 8 | | | | | | | | | | | | | |
| | Fourth | 50 | 200 | | | | | | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 3 10 | | | | | | | | | | | | | |
| | Fifth | 50 | 250 | | | | | | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 5 11 | | | | | | | | | | | | | |
| | Sixth | 50 | 300 | | | | | | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 7 12 | | | | | | | | | | | | | |
| | Seventh | 50 | 350 | | | | | | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 14 | 13 17 | 9 11 | | | | | | | | | | | | | |
| P | First | 80 | 80 | | ● | ↑ | ↓ | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | # 4 | ↑ | | | | | | | | | | | | | |
| | Second | 80 | 160 | | | | | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 1 6 | | | | | | | | | | | | | | |
| | Third | 80 | 240 | | | | | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 2 8 | | | | | | | | | | | | | | |
| | Fourth | 80 | 320 | | | | | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 3 10 | | | | | | | | | | | | | | |
| | Fifth | 80 | 400 | | | | | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 5 11 | | | | | | | | | | | | | | |
| | Sixth | 80 | 480 | | | | | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 7 12 | | | | | | | | | | | | | | |
| | Seventh | 80 | 560 | | | | | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 14 | 13 17 | 9 11 | | | | | | | | | | | | | | |
| Q | First | 125 | 125 | ● | ↑ | ↓ | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | # 4 | ↑ | | | | | | | | | | | | | | |
| | Second | 125 | 250 | | | | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 1 6 | | | | | | | | | | | | | | | |
| | Third | 125 | 375 | | | | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 2 8 | | | | | | | | | | | | | | | |
| | Fourth | 125 | 500 | | | | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 3 10 | | | | | | | | | | | | | | | |
| | Fifth | 125 | 625 | | | | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 5 11 | | | | | | | | | | | | | | | |
| | Sixth | 125 | 750 | | | | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 7 12 | | | | | | | | | | | | | | | |
| | Seventh | 125 | 875 | | | | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 14 | 13 17 | 9 11 | | | | | | | | | | | | | | | |
| R | First | 200 | 200 | ↑ | | # 2 | # 2 | # 3 | # 3 | # 4 | # 4 | 0 5 | # 4 | ↑ | | | | | | | | | | | | | | | |
| | Second | 200 | 400 | | | # 2 | # 3 | # 3 | 0 4 | 0 5 | 1 6 | 1 7 | 1 6 | | | | | | | | | | | | | | | | |
| | Third | 200 | 600 | | | 0 2 | 0 3 | 0 4 | 0 5 | 1 6 | 2 8 | 3 9 | 2 8 | | | | | | | | | | | | | | | | |
| | Fourth | 200 | 800 | | | 0 3 | 0 4 | 0 5 | 1 6 | 2 7 | 3 10 | 5 12 | 3 10 | | | | | | | | | | | | | | | | |
| | Fifth | 200 | 1000 | | | 0 3 | 0 4 | 1 6 | 2 7 | 3 8 | 5 11 | 7 13 | 5 11 | | | | | | | | | | | | | | | | |
| | Sixth | 200 | 1200 | | | 0 3 | 1 5 | 1 6 | 3 7 | 4 9 | 7 12 | 10 15 | 7 12 | | | | | | | | | | | | | | | | |
| | Seventh | 200 | 1400 | | | 1 3 | 1 5 | 2 7 | 4 8 | 6 10 | 9 14 | 13 17 | 9 11 | | | | | | | | | | | | | | | | |

↓ = Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspections
⇑ = 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)
# = 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 4.10.1.4)

**MULTIPLE TIGHTENED**

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

(See 3.3)

| Code Letter | Sample Size | Acceptable Quality Level | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | 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 | | | | | | | | | | | | | | | | 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 | | | 4.2 | 6.9 | 9.7 | 16 | 22 | 33 | 47 | 73 | | | | | | |
| G | 32 | | | | | | | | | 1.2 | | | 2.6 | 4.3 | 6.1 | 9.9 | 14 | 21 | 29 | 46 | | | | | | | |
| H | 50 | | | | | | | | 0.74 | | | 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 $\left(1 = \frac{\text{Sample size}}{\text{Lot or Batch size}}\right)$

**AOQL NORMAL**

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

(See 3.3)

| Code Letter | Sample Size | Acceptable Quality Level | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 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 | | | | | | | | | | | | | | | | | | | 42 | 69 | 97 | 160 | 260 | 400 | 620 | 970 |
| B | 3 | | | | | | | | | | | | | | | 12 | | | 28 | 46 | 65 | 110 | 170 | 270 | 410 | 650 | 1100 |
| C | 5 | | | | | | | | | | | | | | 7.4 | | | 17 | 27 | 39 | 63 | 100 | 160 | 250 | 390 | 610 | |
| D | 8 | | | | | | | | | | | | | 4.6 | | | 11 | 17 | 24 | 40 | 64 | 99 | 160 | 240 | 380 | | |
| E | 13 | | | | | | | | | | | | 2.8 | | | 6.5 | 11 | 15 | 24 | 40 | 61 | 95 | 150 | 240 | | | |
| F | 20 | | | | | | | | | | | 1.8 | | | 4.2 | 6.9 | 9.7 | 16 | 36 | 40 | 62 | | | | | | |
| G | 32 | | | | | | | | | | 1.2 | | | 2.6 | 4.3 | 6.1 | 9.9 | 16 | 25 | 30 | | | | | | | |
| H | 50 | | | | | | | | | 0.74 | | | 1.7 | 2.7 | 3.9 | 6.3 | 10 | 16 | 25 | | | | | | | | |
| J | 80 | | | | | | | | 0.46 | | | 1.1 | 1.7 | 2.4 | 4.0 | 6.4 | 9.9 | 16 | | | | | | | | | |
| K | 125 | | | | | | | 0.29 | | | 0.67 | 1.1 | 1.6 | 2.5 | 4.1 | 6.4 | 9.9 | | | | | | | | | | |
| L | 200 | | | | | | 0.18 | | | 0.42 | 0.69 | 0.97 | 1.6 | 2.6 | 4.0 | 6.2 | | | | | | | | | | | |
| M | 315 | | | | | 0.12 | | | 0.27 | 0.44 | 0.62 | 1.0 | 1.6 | 2.5 | 3.9 | | | | | | | | | | | | |
| N | 500 | | | | 0.074 | | | 0.17 | 0.27 | 0.39 | 0.63 | 1.0 | 1.6 | 2.5 | | | | | | | | | | | | | |
| P | 800 | | | 0.046 | | | 0.11 | 0.17 | 0.24 | 0.40 | 0.64 | 0.99 | 1.6 | | | | | | | | | | | | | | |
| Q | 1250 | | 0.029 | | | 0.067 | 0.11 | 0.16 | 0.25 | 0.41 | 0.64 | 0.99 | | | | | | | | | | | | | | | |
| R | 2000 | 0.018 | | | 0.042 | 0.069 | 0.097 | 0.16 | 0.26 | 0.40 | 0.62 | | | | | | | | | | | | | | | | |
| S | 3150 | | | 0.027 | | | | | | | | | | | | | | | | | | | | | | | |

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

**AOQL TIGHTENED**

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

(See 3.3)

| Code Letter | Sample Size | Acceptable Quality Level | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 |
| | | Ac Re | Ac Re | Ac Re | Ac Re | 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 | | | | | | | | | | | | | | | 68 | |
| B | 3 | | | | | | | | | | | | | | 54 | | |
| C | 5 | | | | | | | | | | | | | 37 | | | 58 |
| D | 8 | | | | | | | | | | | | 25 | | | 41 | 54 |
| E | 13 | | | | | | | | | | | 16 | | | 27 | 36 | 44 |
| F | 20 | | | | | | | | | | 11 | | | 18 | 25 | 30 | 42 |
| G | 32 | | | | | | | | | 6.9 | | | 12 | 16 | 20 | 27 | 34 |
| H | 50 | | | | | | | | 4.5 | | | 7.6 | 10 | 13 | 18 | 22 | 29 |
| J | 80 | | | | | | | 2.8 | | | 4.8 | 6.5 | 8.2 | 11 | 14 | 19 | 24 |
| 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 | | | | | | |

**LQ (DEFECTIVES)**
**10.0%**

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

(See 4.1)

| 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 |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | 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 | | | | | | | | | | | | | | | | | | | 42 | 69 | 97 | 160 | 260 | 400 | 620 | 970 |
| B | 3 | | | | | | | | | | | | | | | 12 | | | 28 | 46 | 65 | 110 | 170 | 270 | 410 | 650 | 1100 |
| C | 5 | | | | | | | | | | | | | | 7.4 | | | 17 | 27 | 39 | 63 | 100 | 160 | 250 | 390 | 610 | |
| D | 8 | | | | | | | | | | | | | 4.6 | | | 11 | 17 | 24 | 40 | 64 | 99 | 160 | 240 | 380 | | |
| E | 13 | | | | | | | | | | | | 2.8 | | | 6.5 | 11 | 15 | 24 | 40 | 61 | 95 | 150 | 240 | | | |
| F | 20 | | | | | | | | | | | 1.8 | | | 4.2 | 6.9 | 9.7 | 16 | 36 | 40 | 62 | | | | | | |
| G | 32 | | | | | | | | | | 1.2 | | | 2.6 | 4.3 | 6.1 | 9.9 | 16 | 25 | 30 | | | | | | | |
| H | 50 | | | | | | | | | 0.74 | | | 1.7 | 2.7 | 3.9 | 6.3 | 10 | 16 | 25 | | | | | | | | |
| J | 80 | | | | | | | | 0.46 | | | 1.1 | 1.7 | 2.4 | 4.0 | 6.4 | 9.9 | 16 | | | | | | | | | |
| K | 125 | | | | | | | 0.29 | | | 0.67 | 1.1 | 1.6 | 2.5 | 4.1 | 6.4 | 9.9 | | | | | | | | | | |
| L | 200 | | | | | | 0.18 | | | 0.42 | 0.69 | 0.97 | 1.6 | 2.6 | 4.0 | 6.2 | | | | | | | | | | | |
| M | 315 | | | | | 0.12 | | | 0.27 | 0.44 | 0.62 | 1.0 | 1.6 | 2.5 | 3.9 | | | | | | | | | | | | |
| N | 500 | | | | 0.074 | | | 0.17 | 0.27 | 0.39 | 0.63 | 1.0 | 1.6 | 2.5 | | | | | | | | | | | | | |
| P | 800 | | | 0.046 | | | 0.11 | 0.17 | 0.24 | 0.40 | 0.64 | 0.99 | 1.6 | | | | | | | | | | | | | | |
| Q | 1250 | | 0.029 | | | 0.067 | 0.11 | 0.16 | 0.25 | 0.41 | 0.64 | 0.99 | | | | | | | | | | | | | | | |
| R | 2000 | 0.018 | | | 0.042 | 0.069 | 0.097 | 0.16 | 0.26 | 0.40 | 0.62 | | | | | | | | | | | | | | | | |
| S | 3150 | | | 0.027 | | | | | | | | | | | | | | | | | | | | | | | |

**LQ (DEFECTS)**
**10%**

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

(See 4.11)

| 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 |
| | | Ac Re | Ac Re | Ac Re | Ac Re | 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 | | | | | | | | | | | | | | | 78 | |
| B | 3 | | | | | | | | | | | | | | 63 | | |
| C | 5 | | | | | | | | | | | | | 45 | | | 66 |
| D | 8 | | | | | | | | | | | | 31 | | | 47 | 60 |
| E | 13 | | | | | | | | | | | 21 | | | 32 | 41 | 50 |
| F | 20 | | | | | | | | | | 14 | | | 22 | 28 | 34 | 46 |
| G | 32 | | | | | | | | | 8.9 | | | 14 | 18 | 23 | 30 | 37 |
| H | 50 | | | | | | | | 5.8 | | | 9.1 | 12 | 15 | 20 | 25 | 32 |
| J | 80 | | | | | | | 3.7 | | | 5.8 | 7.7 | 9.4 | 13 | 16 | 20 | 26 |
| K | 125 | | | | | | 2.4 | | | 3.8 | 5.0 | 6.2 | 8.4 | 11 | 14 | 18 | 24 |
| L | 200 | | | | | 1.5 | | | 2.4 | 3.2 | 3.9 | 5.3 | 6.6 | 8.5 | 11 | 15 | |
| M | 315 | | | | 0.95 | | | 1.5 | 2.0 | 2.5 | 3.3 | 4.2 | 5.4 | 7.0 | 9.6 | | |
| N | 500 | | | 0.60 | | | 0.95 | 1.3 | 1.6 | 2.1 | 2.6 | 3.4 | 4.4 | 6.1 | | | |
| P | 800 | | 0.38 | | | 0.59 | 0.79 | 0.97 | 1.3 | 1.6 | 2.1 | 2.7 | 3.8 | | | | |
| Q | 1250 | 0.24 | | | 0.38 | 0.50 | 0.62 | 0.84 | 1.1 | 1.4 | 1.8 | 2.4 | | | | | |
| R | 2000 | | | 0.24 | 0.32 | 0.39 | 0.53 | 0.66 | 0.85 | 1.1 | 1.5 | | | | | | |

**LQ (DEFECTIVES)**
**5.0%**

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

(See 4.11)

| Code Letter | Sample Size | Acceptable Quality Level | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | 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 | | | | | | | | | | | | | | | 150 | | | 240 | 320 | 390 | 530 | 660 | 850 | 1100 | 1500 | 2000 |
| B | 3 | | | | | | | | | | | | | | 100 | | | 160 | 210 | 260 | 350 | 440 | 570 | 730 | 1000 | 1400 | 1900 |
| C | 5 | | | | | | | | | | | | | 60 | | | 95 | 130 | 160 | 210 | 260 | 340 | 440 | 610 | 810 | 1100 | |
| D | 8 | | | | | | | | | | | | 38 | | | 59 | 79 | 97 | 130 | 160 | 210 | 270 | 380 | 510 | 710 | | |
| E | 13 | | | | | | | | | | | 23 | | | 37 | 48 | 60 | 81 | 100 | 130 | 170 | 230 | 310 | 440 | | | |
| F | 20 | | | | | | | | | | 15 | | | 24 | 32 | 39 | 53 | 66 | 85 | 110 | 150 | | | | | | |
| G | 32 | | | | | | | | | 9.4 | | | 15 | 20 | 24 | 33 | 41 | 53 | 68 | 95 | | | | | | | |
| H | 50 | | | | | | | | 6.0 | | | 9.5 | 13 | 16 | 21 | 26 | 34 | 44 | 61 | | | | | | | | |
| J | 80 | | | | | | | 3.8 | | | 5.9 | 7.9 | 9.7 | 13 | 16 | 21 | 27 | 38 | | | | | | | | | |
| K | 125 | | | | | | 2.4 | | | 3.8 | 5.0 | 6.2 | 8.4 | 11 | 14 | 18 | 24 | | | | | | | | | | |
| L | 200 | | | | | 1.5 | | | 2.4 | 3.2 | 3.9 | 5.3 | 6.6 | 8.5 | 11 | 15 | | | | | | | | | | | |
| M | 315 | | | | 0.95 | | | 1.5 | 2.0 | 2.5 | 3.3 | 4.2 | 5.4 | 7.0 | 9.6 | | | | | | | | | | | | |
| N | 500 | | | 0.60 | | | 0.95 | 1.3 | 1.6 | 2.1 | 2.6 | 3.4 | 4.4 | 6.1 | | | | | | | | | | | | | |
| P | 800 | | 0.38 | | | 0.59 | 0.79 | 0.97 | 1.3 | 1.6 | 2.1 | 2.7 | 3.8 | | | | | | | | | | | | | | |
| Q | 1250 | 0.24 | | | 0.38 | 0.50 | 0.62 | 0.84 | 1.1 | 1.4 | 1.8 | 2.4 | | | | | | | | | | | | | | | |
| R | 2000 | | | 0.24 | 0.32 | 0.39 | 0.53 | 0.66 | 0.85 | 1.1 | 1.5 | | | | | | | | | | | | | | | | |

**LQ (DEFECTS)**
**5%**

**TABLE VIII** – Limit Numbers for Reduced Inspection

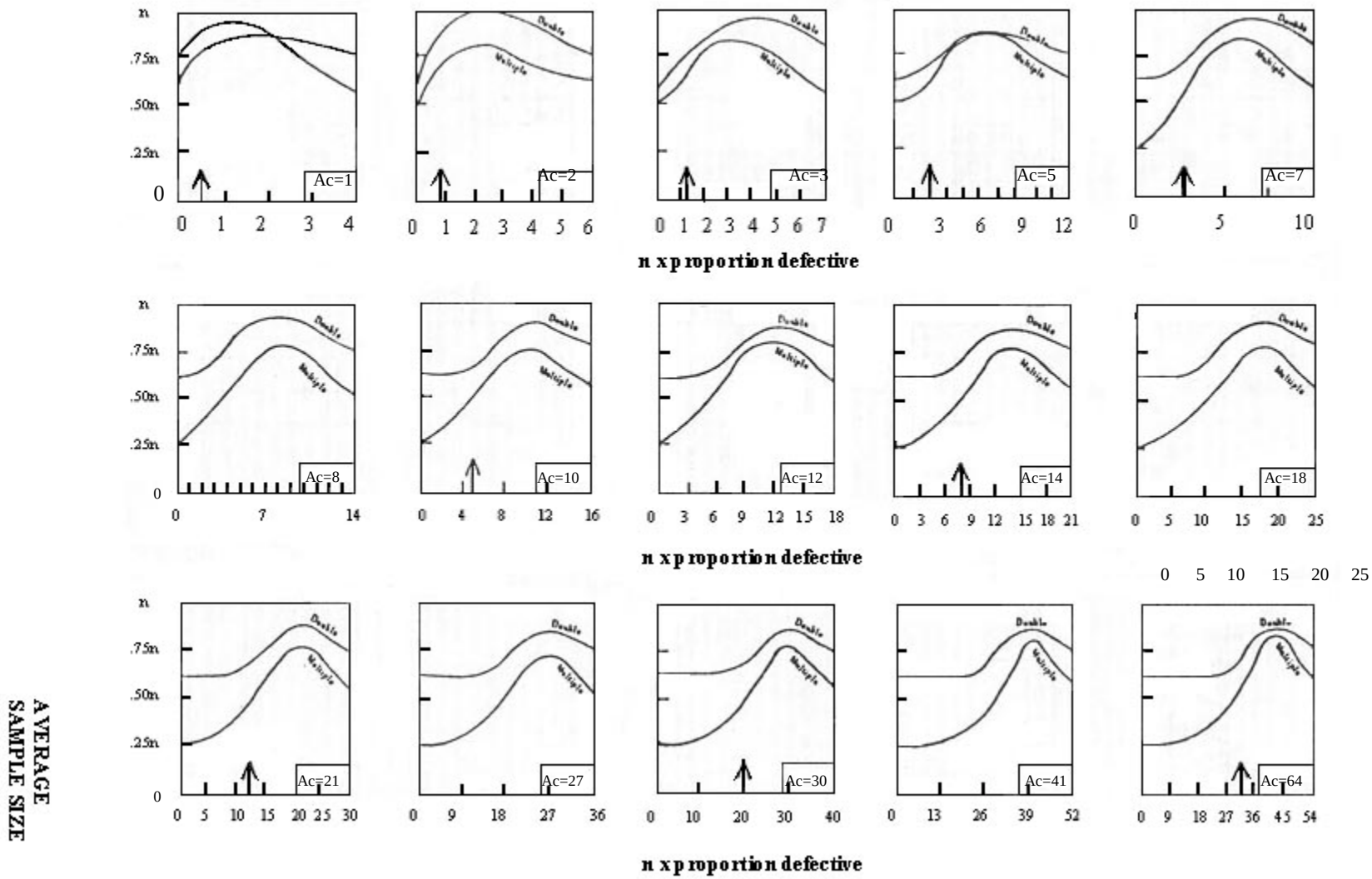
(See 4.7.3)

| Number of sample units from last 10 lots or batches | Acceptable Quality Level | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.010 | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re |
| 20 - 29 | * | * | * | * | * | * | * | * | * | * | * | | * | * | * | 0 | 0 | 2 | 4 | 8 | 14 | 22 | 40 | 68 | 115 | 181 |
| 30 - 49 | * | * | * | * | * | * | * | * | * | * | * | | * | * | 0 | 0 | 1 | 3 | 7 | 13 | 22 | 36 | 63 | 105 | 178 | 277 |
| 50 - 79 | * | * | * | * | * | * | * | * | * | * | * | | * | 0 | 0 | 2 | 3 | 7 | 14 | 25 | 40 | 63 | 110 | 181 | 301 | |
| 80 - 129 | * | * | * | * | * | * | * | * | * | * | * | | 0 | 0 | 2 | 4 | 7 | 14 | 24 | 42 | 68 | 105 | 181 | 297 | | |
| 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 | 189 | | | | | | |
| 500 - 799 | * | * | * | * | * | * | * | * | 0 | 0 | 2 | 3 | 7 | 14 | 25 | 40 | 63 | 110 | 181 | | | | | | | |
| 800 - 1249 | * | * | * | * | * | * | * | 0 | 0 | 2 | 4 | 7 | 14 | 24 | 42 | 68 | 105 | 181 | | | | | | | | |
| 1250 - 1999 | * | * | * | * | * | * | 0 | 0 | 2 | 4 | 7 | 13 | 24 | 40 | 69 | 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 | | | | | | | | | | | | | | | |
| 3150 & Over | 0 | 1 | 4 | 8 | 14 | 24 | 38 | 67 | 111 | 186 | | | | | | | | | | | | | | | | |

* Denotes that the number of sample units from the last ten lots or batches is not sufficient for reduced inspection for this AQL. In this instance, more than ten lots or batches may be used for the calculation, provided that the lots or batches used are the most recent ones in sequence, that they have all been on normal inspection, and that none has been rejected while on original inspection.

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

(see 4.12.2)

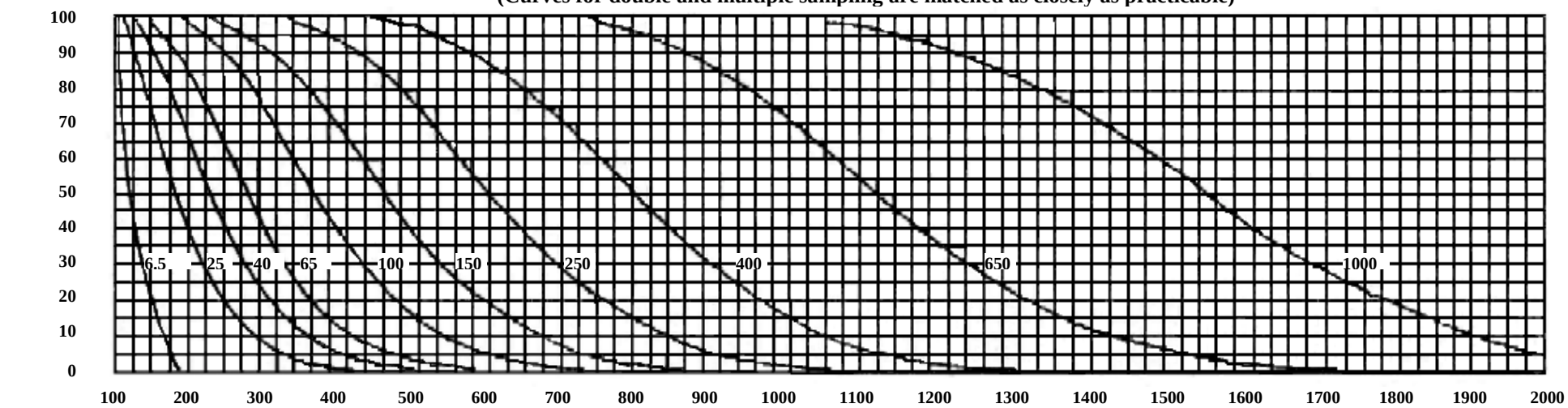



Ac = Single sample acceptance number
= AQL for normal inspection

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

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

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




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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 6.5 | 6.5 | 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 | 0.501 | 0.503 | 7.48 | 21.8 | 41.2 | 89.3 | 145 | 175 | 239 | 305 | 374 | 517 | 629 | 859 | 977 |
| 95.0 | 2.53 | 2.56 | 17.8 | 40.9 | 68.3 | 131 | 199 | 235 | 308 | 381 | 462 | 622 | 745 | 995 | 1122 |
| 90.0 | 5.13 | 5.27 | 26.6 | 55.1 | 87.2 | 158 | 233 | 272 | 351 | 432 | 515 | 684 | 812 | 1073 | 1206 |
| 75.0 | 13.4 | 14.4 | 48.1 | 86.4 | 127 | 211 | 298 | 342 | 431 | 521 | 612 | 795 | 934 | 1214 | 1354 |
| 50.0 | 29.3 | 34.7 | 83.9 | 134 | 184 | 284 | 383 | 433 | 533 | 633 | 733 | 933 | 1083 | 1383 | 1533 |
| 25.0 | 50.0 | 69.3 | 135 | 196 | 255 | 371 | 484 | 540 | 651 | 761 | 870 | 1087 | 1248 | 1568 | 1728 |
| 10.0 | 68.4 | 115 | 194 | 266 | 334 | 464 | 589 | 650 | 770 | 889 | 1006 | 1238 | 1409 | 1748 | 1916 |
| 5.0 | 77.6 | 150 | 237 | 315 | 388 | 526 | 657 | 722 | 848 | 972 | 1094 | 1335 | 1512 | 1862 | 2035 |
| 1.0 | 90.0 | 230 | 332 | 420 | 502 | 655 | 800 | 870 | 1007 | 1141 | 1272 | 1529 | 1718 | 2088 | 2270 |
| A | X | X | 40 | 65 | 100 | 150 | X | 250 | X | 400 | X | 650 | X | 1000 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | |

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

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

| Type of sampling plan | Cumu-lative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | | Cumu-lative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Less than 6.5 | 6.5 | ╳ | 10 | 15 | 25 | 40 | 65 | 100 | 150 | ╳ | 250 | ╳ | 400 | ╳ | 650 | ╳ | 1000 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 2 | ∇ | 0 1 | Use Code Letter D | Use Code Letter C | Use Code Letter B | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | 27 28 | 30 31 | 2 |
| Double | | ∇ | • | | | | (•) | (•) | (•) | (•) | (•) | (•) | (•) | (•) | (•) | (•) | (•) | (•) | (•) | |
| Multiple | | ∇ | • | | | | • | • | • | • | • | • | • | • | • | • | • | • | • | |
| | | Less than 10 | ╳ | 10 | 15 | 25 | 40 | 65 | 100 | 150 | ╳ | 250 | ╳ | 400 | ╳ | 650 | ╳ | 1000 | ╳ | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | | |

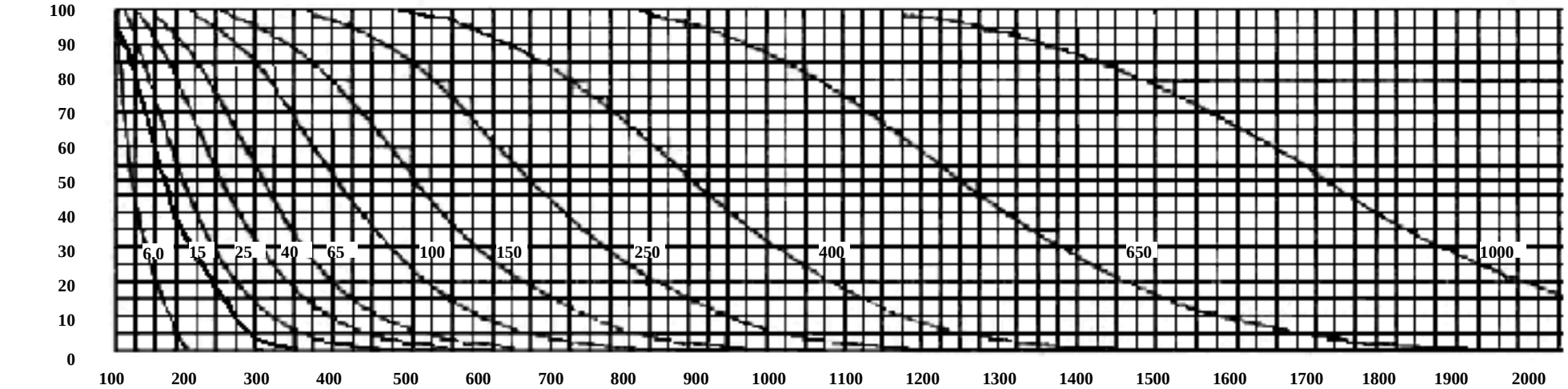
∇ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac = Acceptance number
Re = Rejection number
• = Use single sampling plan above (or alternatively use code letter D)
(•) = Use single sampling (for alternatively use code Letter D)

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)**




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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 4.0 | 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 | 0.334 | 0.335 | 4.97 | 14.5 | 27.4 | 59.5 | 96.9 | 117 | 159 | 203 | 249 | 345 | 419 | 572 | 651 | 947 | 1029 |
| 95.0 | 1.70 | 1.71 | 11.8 | 27.3 | 45.5 | 87.1 | 133 | 157 | 206 | 256 | 308 | 415 | 496 | 663 | 748 | 1065 | 1152 |
| 90.0 | 3.45 | 3.51 | 17.7 | 36.7 | 58.2 | 105 | 155 | 181 | 234 | 288 | 343 | 456 | 541 | 716 | 804 | 1131 | 1222 |
| 75.0 | 9.14 | 9.59 | 32.0 | 57.6 | 84.5 | 141 | 199 | 228 | 287 | 347 | 408 | 530 | 623 | 809 | 903 | 1249 | 1344 |
| 50.0 | 20.6 | 23.1 | 55.9 | 89.1 | 122 | 189 | 256 | 289 | 356 | 422 | 489 | 622 | 722 | 922 | 1022 | 1389 | 1489 |
| 25.0 | 37.0 | 46.2 | 89.8 | 131 | 170 | 247 | 323 | 360 | 434 | 507 | 580 | 724 | 832 | 1045 | 1152 | 1539 | 1644 |
| 10.0 | 53.6 | 76.8 | 130 | 177 | 223 | 309 | 392 | 433 | 514 | 593 | 671 | 825 | 939 | 1165 | 1277 | 1683 | 1793 |
| 5.0 | 63.2 | 99.9 | 158 | 210 | 258 | 350 | 438 | 481 | 565 | 648 | 730 | 890 | 1008 | 1241 | 1356 | 1773 | 1886 |
| 1.0 | 78.5 | 154 | 221 | 280 | 335 | 437 | 533 | 580 | 671 | 761 | 848 | 1019 | 1145 | 1392 | 1513 | 1951 | 2069 |
| B | 6.5 | 6.5 | 25 | 40 | 65 | 100 | X | 150 | X | 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-B-2 - SAMPLING PLANS FOR SAMPLE SIZE CODE LETTER: B

| Type of sampling plan | Cumu-lative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | | | | Cumu-lative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Less than 4.0 | 4.0 | 6.5 | ↓ | 10 | 15 | 25 | 40 | 65 | 100 | ↓ | 150 | ↓ | 250 | ↓ | 400 | ↓ | 650 | ↓ | 1000 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 3 | ∇ | 0 1 | Use Code Letter A | Use Code Letter D | Use Code Letter C | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | 27 28 | 30 31 | 41 42 | 44 45 | 3 |
| Double | 2<br>4 | ∇ | • | | | | 0 2<br>1 2 | 0 3<br>3 4 | 1 4<br>4 5 | 2 5<br>6 7 | 3 7<br>8 9 | 3 7<br>11 12 | 5 9<br>12 13 | 6 10<br>15 16 | 7 11<br>18 19 | 9 14<br>23 24 | 11 16<br>26 27 | 15 20<br>34 35 | 17 22<br>37 38 | 23 29<br>52 53 | 25 31<br>56 57 | 2<br>4 |
| Multiple | | ∇ | • | | | | | | | | | | | | | | | | | | | |
| | | Less than 6.5 | 6.5 | ↓ | 10 | 15 | 25 | 40 | 65 | 100 | ↓ | 150 | ↓ | 250 | ↓ | 400 | ↓ | 650 | ↓ | 1000 | ↓ | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | | | | |

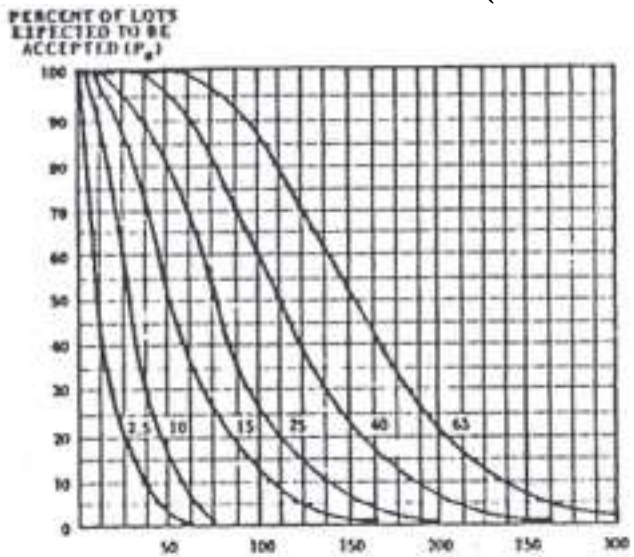
∇ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac = Acceptance number
Re = Rejection number
• = Use single sampling plan above (or alternatively use code letter D)
= Use single sampling (for alternatively use code Letter D)

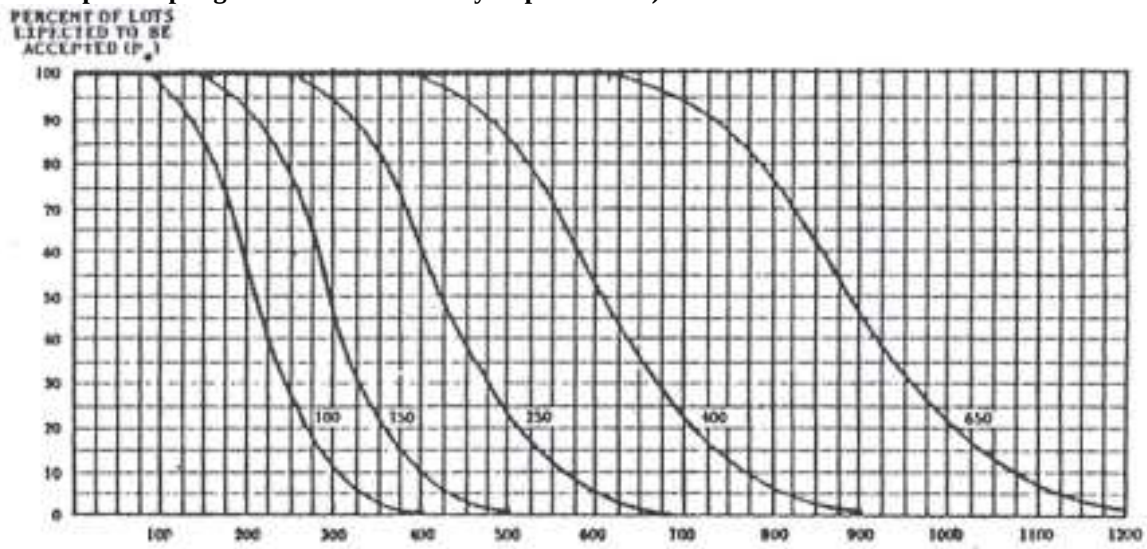
B

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

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

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




**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

| **P.** | **Acceptable Quality Levels (normal inspection)** | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 2.5 | 10 | 2.5 | 10 | 15 | 25 | 40 | 65 | X | 100 | X | 150 | X | 250 | X | 400 | X | 650 |
| | p(in percent defective) | | p(in defects per hundred units) | | | | | | | | | | | | | | | |
| 99.0 | 0.201 | 3.27 | 0.201 | 2.97 | 8.72 | 16.5 | 37.5 | 58.1 | 70.1 | 95.4 | 122 | 150 | 207 | 251 | 343 | 391 | 568 | 618 |
| 95.0 | 1.02 | 7.64 | 1.03 | 7.11 | 16.4 | 27.3 | 52.3 | 79.6 | 93.9 | 123 | 154 | 185 | 249 | 298 | 398 | 449 | 639 | 691 |
| 90.0 | 2.09 | 11.2 | 2.11 | 10.6 | 22.0 | 34.9 | 63.0 | 93.1 | 109 | 140 | 173 | 206 | 273 | 325 | 429 | 482 | 679 | 733 |
| 75.0 | 5.59 | 19.4 | 5.75 | 19.2 | 34.5 | 50.7 | 84.4 | 119 | 137 | 172 | 208 | 245 | 318 | 374 | 485 | 542 | 749 | 806 |
| 50.0 | 12.9 | 31.4 | 13.9 | 33.6 | 53.5 | 73.4 | 113 | 153 | 173 | 213 | 253 | 293 | 373 | 433 | 553 | 613 | 833 | 893 |
| 25.0 | 24.2 | 45.4 | 27.7 | 53.9 | 78.4 | 102 | 148 | 194 | 216 | 260 | 304 | 348 | 435 | 499 | 627 | 691 | 923 | 986 |
| 10.0 | 36.9 | 58.4 | 46.1 | 77.8 | 106 | 134 | 185 | 235 | 260 | 304 | 356 | 403 | 495 | 564 | 699 | 766 | 1010 | 1076 |
| 5.0 | 45.1 | 65.7 | 59.9 | 94.9 | 126 | 155 | 210 | 263 | 289 | 339 | 389 | 438 | 534 | 605 | 745 | 814 | 1064 | 1131 |
| 1.0 | 60.2 | 77.8 | 92.1 | 133 | 168 | 201 | 262 | 320 | 348 | 403 | 456 | 509 | 612 | 687 | 835 | 908 | 1171 | 1241 |
| | 4.0 | X | 4.0 | 15 | 25 | 40 | 65 | X | 100 | X | 150 | X | 250 | X | 400 | X | 650 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | |

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

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

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

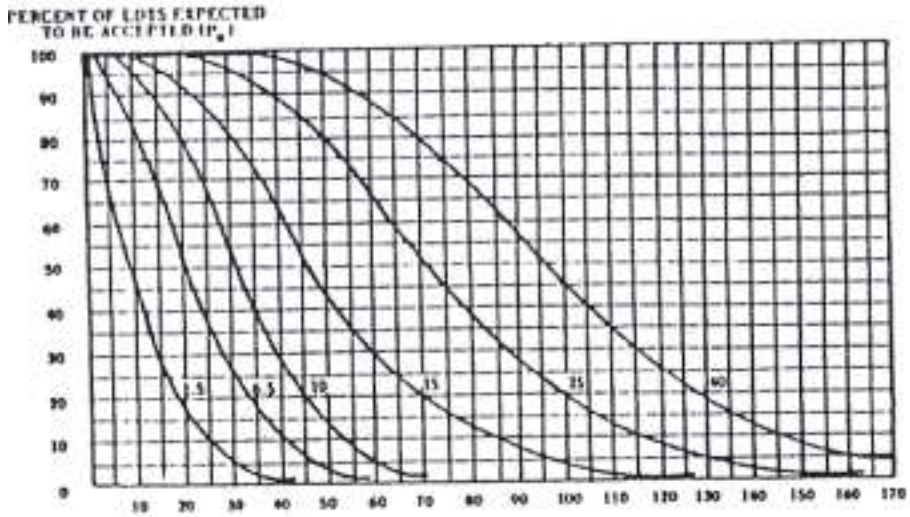
• = Use single sampling plan above (or alternatively use code letter D)

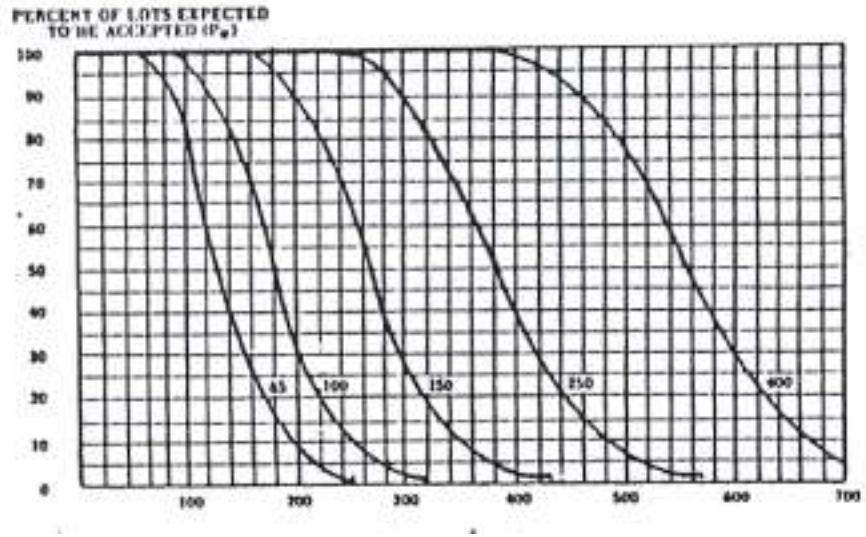
= Use single sampling (for alternatively use code Letter D)

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

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

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




**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

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

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

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

| Type of sampling plan | Cumulative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | | | | Cumulative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Less than 1.5 | 1.5 | 2.5 | X | 4.0 | 6.5 | 10 | 15 | 25 | 40 | X | 65 | X | 100 | X | 150 | X | 250 | X | 400 | Higher than 400 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 5 | ∇ | 0 1 | Use Code Letter C | Use Code Letter F | Use Code Letter E | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | 27 28 | 30 31 | 41 42 | 44 45 | Δ | 8 |
| Double | **5** | ∇ | • | | | | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 3 7 | 5 9 | 6 10 | 7 11 | 9 14 | 11 16 | 15 20 | 17 22 | 23 29 | 25 31 | Δ | 5 |
| | **10** | | | | | | 1 2 | 3 4 | 4 5 | 6 7 | 8 9 | 11 12 | 12 13 | 15 16 | 18 19 | 23 24 | 26 27 | 34 35 | 37 38 | 52 53 | 56 57 | | 10 |
| Multiple | 2 | ∇ | • | | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 4 | 0 5 | 0 6 | 1 7 | 1 8 | 2 9 | 3 10 | 4 12 | 6 15 | 6 16 | Δ | 2 |
| | 4 | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 1 6 | 2 7 | 3 8 | 3 9 | 4 10 | 6 12 | 7 14 | 10 17 | 11 19 | 16 25 | 17 27 | | 4 |
| | 6 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 4 9 | 6 10 | 7 12 | 8 13 | 11 17 | 13 19 | 17 24 | 19 27 | 26 36 | 29 39 | | 6 |
| | 8 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 6 11 | 8 13 | 10 15 | 12 17 | 16 22 | 19 25 | 24 31 | 27 34 | 37 46 | 40 49 | | 8 |
| | 10 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 9 12 | 11 15 | 14 17 | 17 20 | 22 25 | 25 29 | 32 37 | 36 40 | 49 55 | 53 58 | | 10 |
| | 12 | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 12 14 | 14 17 | 18 20 | 21 23 | 27 29 | 31 33 | 40 43 | 45 47 | 61 64 | 65 68 | | 12 |
| | 14 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 14 15 | 18 19 | 21 22 | 25 26 | 32 33 | 37 38 | 48 49 | 53 54 | 72 73 | 77 78 | | 14 |
| | | Less than 2.5 | 2.5 | X | 4.0 | 6.5 | 10 | 15 | 25 | 40 | X | 65 | X | 100 | X | 150 | X | 250 | X | 400 | X | Higher than 400 | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | | | | | |

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

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

Ac = Acceptance number

Re = Rejection number

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

= Use single sampling (for alternatively use code Letter D)

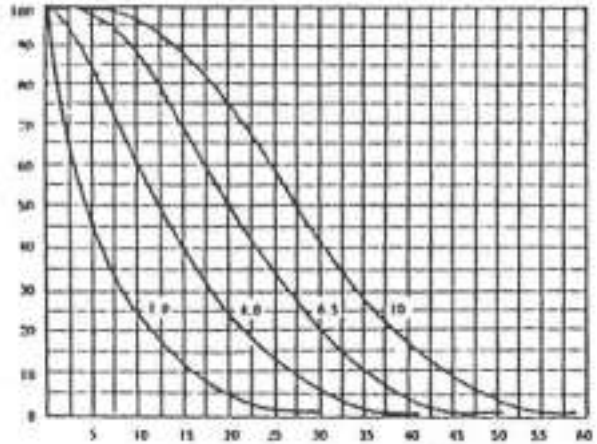
D

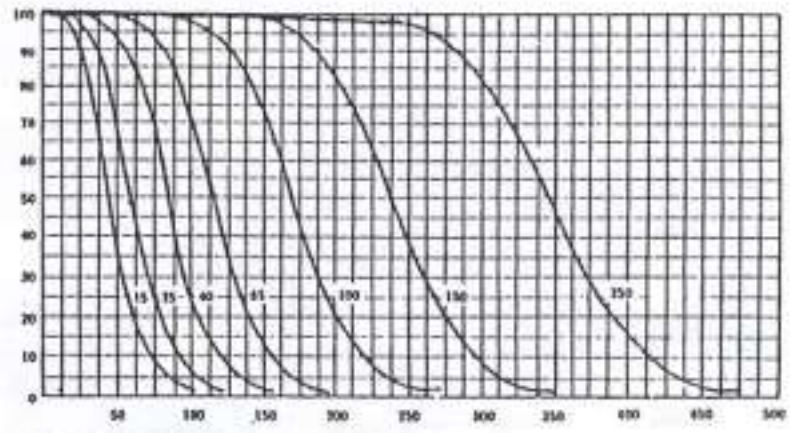
## TABLE X-E - Tables for sample size code letter: E

**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.)





**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

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

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

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

| Type of sampling plan | Cumulative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | | | | Cumulative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Less than 1.0 | 1.0 | 1.5 | X | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | X | 40 | X | 65 | X | 100 | X | 150 | X | 250 | Higher than 250 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 13 | ∇ | 0 1 | | | | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | 27 28 | 30 31 | 41 42 | 44 45 | Δ | 13 |
| Double | **8** | ∇ | • | | | | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 3 7 | 5 9 | 6 10 | 7 11 | 9 14 | 11 16 | 15 20 | 17 22 | 23 29 | 25 31 | Δ | 8 |
| | **16** | | | Use Code Letter D | Use Code Letter G | Use Code Letter F | 1 2 | 3 4 | 4 5 | 6 7 | 8 9 | 11 12 | 12 13 | 15 16 | 18 19 | 23 24 | 26 27 | 34 35 | 37 38 | 52 53 | 56 57 | | 16 |
| Multiple | 3 | ∇ | • | | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 4 | 0 5 | 0 6 | 1 7 | 1 8 | 2 9 | 3 10 | 4 12 | 6 15 | 6 16 | Δ | 3 |
| | 6 | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 1 6 | 2 7 | 3 8 | 3 9 | 4 10 | 6 12 | 7 14 | 10 17 | 11 19 | 16 25 | 17 27 | | 6 |
| | 9 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 4 9 | 6 10 | 7 12 | 8 13 | 11 17 | 13 19 | 17 24 | 19 27 | 26 36 | 29 39 | | 9 |
| | 12 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 6 11 | 8 13 | 10 15 | 12 17 | 16 22 | 19 25 | 24 31 | 27 34 | 37 46 | 40 49 | | 12 |
| | 15 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 9 12 | 11 15 | 14 17 | 17 20 | 22 25 | 25 29 | 32 37 | 36 40 | 49 55 | 53 58 | | 15 |
| | 18 | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 12 14 | 14 17 | 18 20 | 21 23 | 27 29 | 31 33 | 40 43 | 45 47 | 61 64 | 65 68 | | 18 |
| | 21 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 14 15 | 18 19 | 21 22 | 25 26 | 32 33 | 37 38 | 48 49 | 53 54 | 72 73 | 77 78 | | 21 |
| | | Less than 1.5 | 1.5 | X | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | X | 40 | X | 65 | X | 100 | X | 150 | X | 250 | X | Higher than 250 | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | | | | | |

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

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

Ac = Acceptance number

Re = Rejection number

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

= Use single sampling (for alternatively use code Letter D)

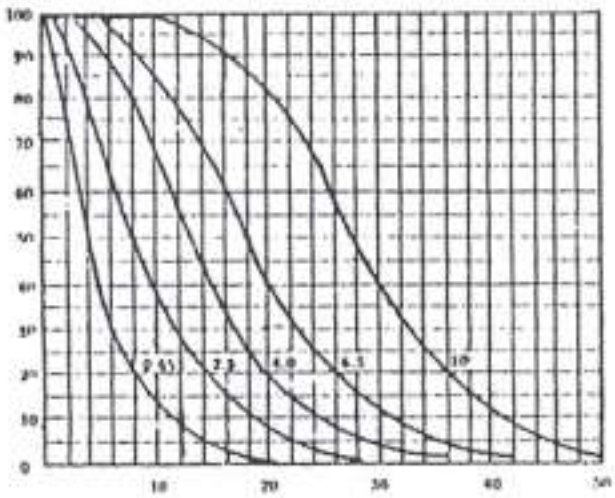
E

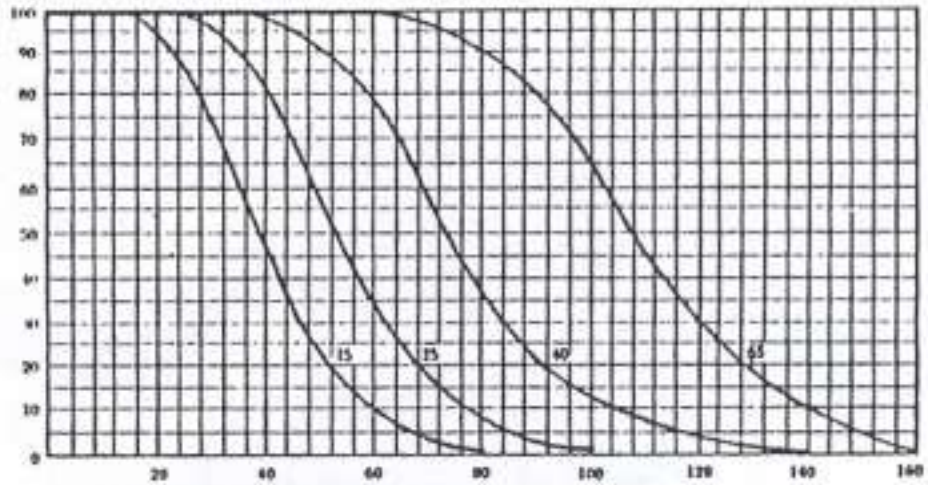
## TABLE X-F - Tables for sample size code letter: F

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

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

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)





**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.65 | 2.5 | 4.0 | 6.5 | 10 | 0.65 | 2.5 | 4.0 | 6.5 | 10 | 15 | X | 25 | X | 40 | X | 65 |
| | p(in percent defective) | | | | | p(in defects per hundred units) | | | | | | | | | | | |
| 99.0 | 0.0502 | 0.759 | 2.27 | 4.36 | 9.75 | 0.0503 | 0.743 | 2.18 | 4.12 | 8.93 | 14.5 | 17.5 | 23.9 | 30.5 | 37.4 | 51.7 | 62.9 |
| 95.0 | 0.256 | 1.81 | 4.22 | 7.14 | 14.0 | 0.256 | 1.78 | 4.09 | 6.83 | 13.1 | 19.9 | 23.5 | 30.8 | 38.4 | 46.2 | 62.2 | 74.5 |
| 90.0 | 0.525 | 2.69 | 5.64 | 9.03 | 16.6 | 0.527 | 2.66 | 5.51 | 8.72 | 15.8 | 23.3 | 27.2 | 35.1 | 43.2 | 51.5 | 68.4 | 81.2 |
| 75.0 | 1.43 | 4.81 | 8.70 | 12.8 | 21.6 | 1.44 | 4.81 | 8.64 | 12.7 | 21.1 | 29.8 | 34.2 | 43.1 | 52.1 | 61.2 | 79.5 | 93.4 |
| 50.0 | 3.41 | 8.25 | 13.1 | 18.1 | 27.9 | 3.47 | 8.39 | 13.4 | 18.4 | 28.4 | 38.3 | 43.3 | 53.3 | 63.3 | 73.3 | 93.3 | 108 |
| 25.0 | 6.70 | 12.9 | 18.7 | 24.2 | 34.8 | 6.93 | 13.5 | 19.6 | 25.5 | 37.1 | 48.4 | 54.0 | 65.1 | 76.1 | 87.0 | 109 | 125 |
| 10.0 | 10.9 | 18.1 | 24.5 | 30.4 | 41.5 | 11.5 | 19.4 | 26.6 | 33.4 | 46.4 | 58.9 | 65.0 | 77.0 | 88.9 | 101 | 124 | 141 |
| 5.0 | 13.9 | 21.6 | 28.3 | 34.4 | 45.6 | 15.0 | 23.7 | 31.5 | 38.8 | 52.6 | 65.7 | 72.2 | 84.8 | 97.2 | 109 | 133 | 151 |
| 1.0 | 20.6 | 28.9 | 35.8 | 42.1 | 53.2 | 23.0 | 33.2 | 42.0 | 50.2 | 65.5 | 80.0 | 87.0 | 101 | 114 | 127 | 153 | 172 |
| | 1.0 | 4.0 | 6.5 | 10 | X | 1.0 | 4.0 | 6.5 | 10 | 15 | X | 25 | X | 40 | X | 65 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | |

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

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

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

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

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

Ac = Acceptance number

Re = Rejection number

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

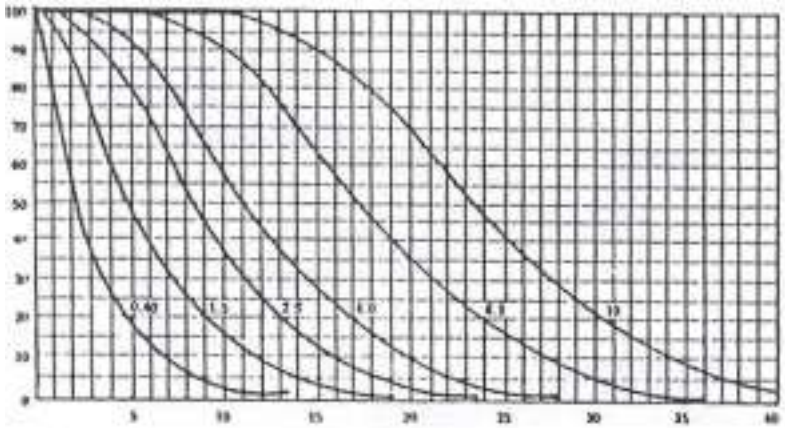
= Use single sampling (for alternatively use code Letter D)

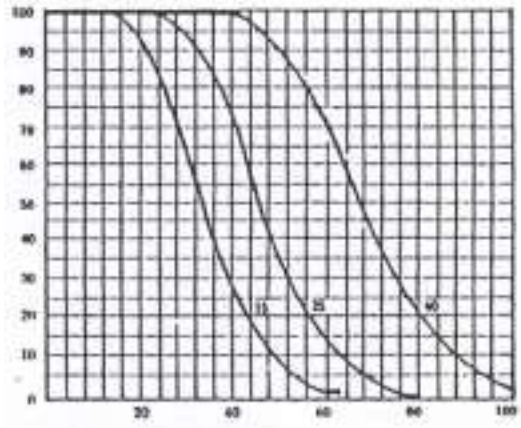
## TABLE X-G - Tables for sample size code letter: G

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)

**CHART G - 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)**

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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.40 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 0.40 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | X | 15 | X | 25 | X | 40 |
| | p(in percent defective) | | | | | | p(in defects per hundred units) | | | | | | | | | | | |
| 99.0 | 0.0314 | 0.471 | 1.40 | 2.67 | 5.88 | 9.73 | 0.0314 | 0.464 | 1.36 | 2.57 | 5.58 | 9.08 | 11.0 | 14.9 | 19.1 | 23.4 | 32.3 | 39.3 |
| 95.0 | 0.160 | 1.12 | 2.60 | 4.38 | 8.50 | 13.1 | 0.160 | 1.11 | 2.56 | 4.27 | 8.17 | 12.4 | 14.7 | 19.3 | 24.0 | 28.9 | 38.9 | 46.5 |
| 90.0 | 0.329 | 1.67 | 3.49 | 5.56 | 10.2 | 15.1 | 0.329 | 1.66 | 3.44 | 5.45 | 9.85 | 14.6 | 17.0 | 21.9 | 27.0 | 32.2 | 42.7 | 50.8 |
| 75.0 | 0.895 | 3.01 | 5.42 | 7.98 | 13.4 | 19.0 | 0.899 | 3.00 | 5.40 | 7.92 | 13.2 | 18.6 | 21.4 | 26.9 | 32.6 | 38.2 | 49.7 | 58.4 |
| 50.0 | 2.14 | 5.19 | 8.27 | 11.4 | 17.5 | 23.7 | 2.17 | 5.24 | 8.36 | 11.5 | 17.7 | 24.0 | 27.1 | 33.3 | 39.6 | 45.8 | 58.3 | 67.7 |
| 25.0 | 4.24 | 8.19 | 11.9 | 15.4 | 22.3 | 29.0 | 4.33 | 8.41 | 12.3 | 16.0 | 23.2 | 30.3 | 33.8 | 40.7 | 47.6 | 54.4 | 67.9 | 78.0 |
| 10.0 | 6.91 | 11.6 | 15.8 | 19.7 | 27.1 | 34.1 | 7.20 | 12.2 | 16.6 | 20.9 | 29.0 | 36.8 | 40.6 | 48.1 | 55.6 | 62.9 | 77.4 | 88.1 |
| 5.0 | 8.94 | 14.0 | 18.4 | 22.5 | 30.1 | 37.2 | 9.36 | 14.8 | 19.7 | 24.2 | 32.9 | 41.1 | 45.1 | 53.0 | 60.8 | 68.4 | 83.4 | 94.5 |
| 1.0 | 13.4 | 19.0 | 23.8 | 28.1 | 36.0 | 43.2 | 14.4 | 20.7 | 26.3 | 31.4 | 41.0 | 50.0 | 54.4 | 63.0 | 71.3 | 79.5 | 95.6 | 107 |
| G | 0.65 | 2.5 | 4.0 | 6.5 | 10 | X | 0.65 | 2.5 | 4.0 | 6.5 | 10 | X | 15 | X | 25 | X | 40 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | |

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

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

| Type of sampling plan | Cumu-lative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | Cumu-lative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Less than 0.40 | 0.40 | 0.65 | ╳ | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | ╳ | 15 | ╳ | 25 | ╳ | 40 | Higher than 40 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 32 | ∇ | 0 1 | Use Code Letter F | Use Code Letter J | Use Code Letter H | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | Δ | 32 |
| Double | 20 | ∇ | • | | | | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 3 7 | 5 9 | 6 10 | 7 11 | 9 14 | 11 16 | Δ | 20 |
| | 40 | | | | | | 1 2 | 3 4 | 4 5 | 6 7 | 8 9 | 11 12 | 12 13 | 15 16 | 18 19 | 23 24 | 26 27 | | 40 |
| Multiple | 8 | ∇ | • | | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 4 | 0 5 | 0 6 | 1 7 | 1 8 | 2 9 | Δ | 8 |
| | 16 | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 1 6 | 2 7 | 3 8 | 3 9 | 4 10 | 6 12 | 7 14 | | 16 |
| | 24 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 4 9 | 6 10 | 7 12 | 8 13 | 11 17 | 13 19 | | 24 |
| | 32 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 6 11 | 8 13 | 10 15 | 12 17 | 16 22 | 19 25 | | 32 |
| | 40 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 9 12 | 11 15 | 14 17 | 17 20 | 22 25 | 25 29 | | 40 |
| | 48 | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 12 14 | 14 17 | 18 20 | 21 23 | 27 29 | 31 33 | | 48 |
| | 56 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 14 15 | 18 19 | 21 22 | 25 26 | 32 33 | 37 38 | | 56 |
| | | Less than 0.65 | 0.65 | ╳ | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | ╳ | 15 | ╳ | 25 | ╳ | 40 | ╳ | Higher than 65 | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | |

∇ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Δ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac = Acceptance number
Re = Rejection number
• = Use single sampling plan above (or alternatively use code letter D)
= Use single sampling (for alternatively use code Letter D)

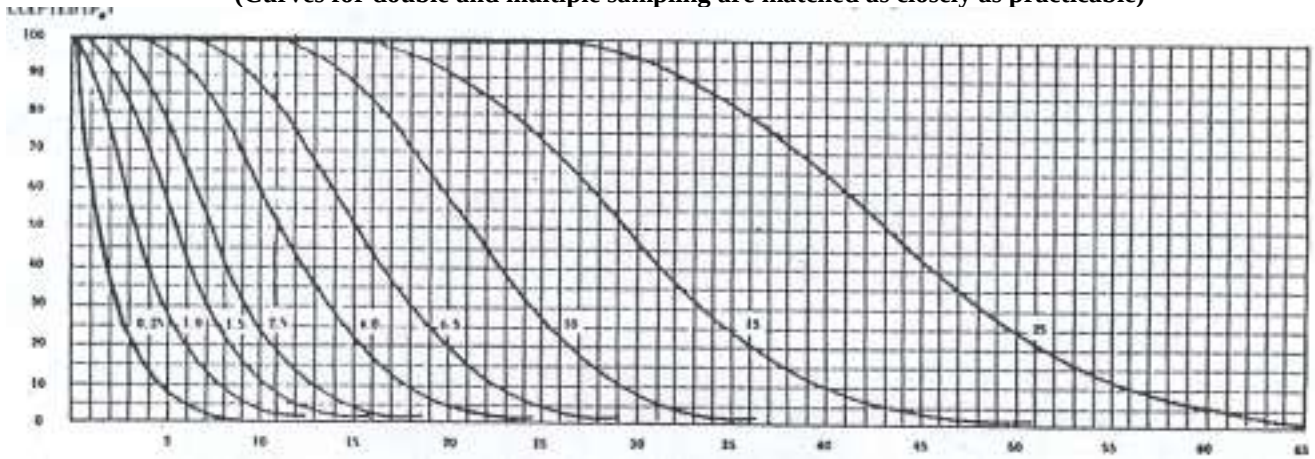
G

# 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.)



**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

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

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

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

| Type of sampling plan | Cumu-lative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | Cumu-lative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Less than 0.25 | 0.25 | 0.40 | X | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | X | 10 | X | 15 | X | 25 | Higher than 25 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 50 | ∇ | 0 1 | Use Code Letter G | Use Code Letter K | Use Code Letter J | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | Δ | 50 |
| Double | 32 | ∇ | • | | | | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 3 7 | 5 9 | 6 10 | 7 11 | 9 14 | 11 16 | Δ | 32 |
| | 64 | | | | | | 1 2 | 3 4 | 4 5 | 6 7 | 8 9 | 11 12 | 12 13 | 15 16 | 18 19 | 23 24 | 26 27 | | 64 |
| Multiple | 13 | ∇ | • | | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 4 | 0 5 | 0 6 | 1 7 | 1 8 | 2 9 | Δ | 13 |
| | 26 | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 1 6 | 2 7 | 3 8 | 3 9 | 4 10 | 6 12 | 7 14 | | 26 |
| | 39 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 4 9 | 6 10 | 7 12 | 8 13 | 11 17 | 13 19 | | 39 |
| | 52 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 6 11 | 8 13 | 10 15 | 12 17 | 16 22 | 19 25 | | 52 |
| | 65 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 9 12 | 11 15 | 14 17 | 17 20 | 22 25 | 25 29 | | 65 |
| | 78 | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 12 14 | 14 17 | 18 20 | 21 23 | 27 29 | 31 33 | | 78 |
| | 91 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 14 15 | 18 19 | 21 22 | 25 26 | 32 33 | 37 38 | | 91 |
| | | Less than 0.40 | 0.40 | X | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | X | 10 | X | 15 | X | 25 | X | Higher than 25 | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | |

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

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

Ac = Acceptance number

Re = Rejection number

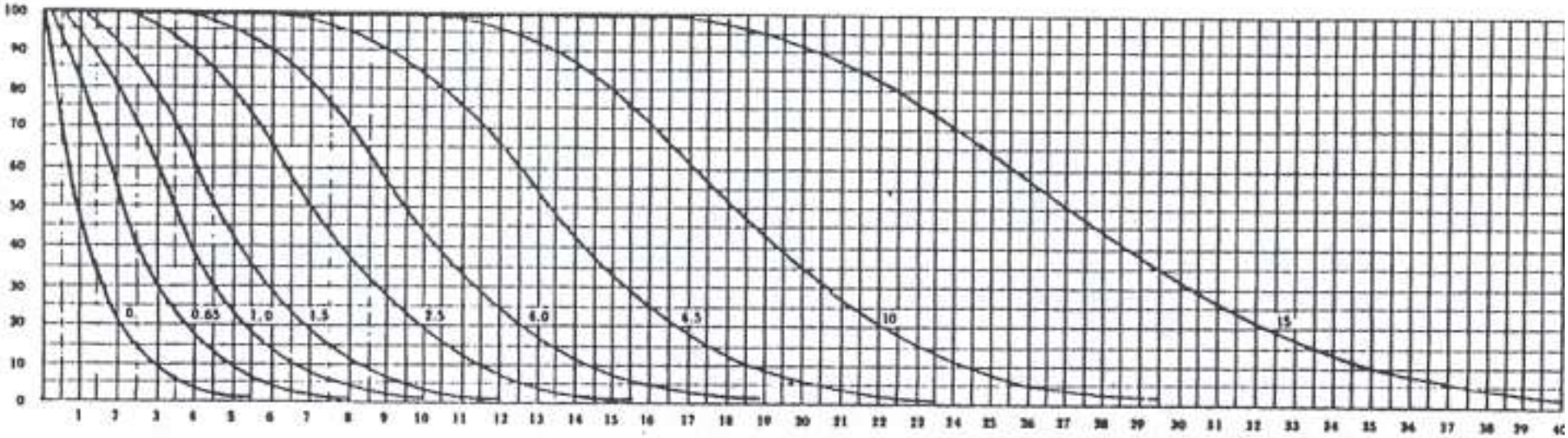
• = Use single sampling plan above (or alternatively use code letter D)

= Use single sampling (for alternatively use code Letter D)

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

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

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




**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.15 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | X | 6.5 | X | 10 | 0.15 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | X | 6.5 | X | 10 | X | 15 |
| | p(in percent defective) | | | | | | | | | | p(in defects per hundred units) | | | | | | | | | | | |
| 99.0 | 0.0126 | 0.187 | 0.550 | 1.04 | 2.28 | 3.73 | 4.51 | 6.17 | 7.88 | 9.76 | 0.0126 | 0.186 | 0.545 | 1.03 | 2.23 | 3.63 | 4.38 | 5.96 | 7.62 | 9.35 | 12.9 | 15.7 |
| 95.0 | 0.0641 | 0.446 | 1.03 | 1.73 | 3.32 | 5.07 | 6.00 | 7.93 | 9.89 | 11.9 | 0.0641 | 0.444 | 1.02 | 1.71 | 3.27 | 4.98 | 5.87 | 7.71 | 9.61 | 11.6 | 15.6 | 18.6 |
| 90.0 | 0.132 | 0.667 | 1.39 | 2.20 | 3.99 | 5.91 | 6.90 | 8.95 | 11.0 | 13.2 | 0.132 | 0.665 | 1.38 | 2.18 | 3.94 | 5.82 | 6.79 | 8.78 | 10.8 | 12.9 | 17.1 | 20.3 |
| 75.0 | 0.359 | 1.201 | 2.16 | 3.18 | 5.30 | 7.50 | 8.61 | 10.9 | 13.2 | 15.5 | 0.360 | 1.20 | 2.16 | 3.17 | 5.27 | 7.45 | 8.55 | 10.8 | 13.0 | 15.3 | 19.9 | 23.4 |
| 50.0 | 0.863 | 2.09 | 3.33 | 4.57 | 7.06 | 9.55 | 10.8 | 13.3 | 15.8 | 18.3 | 0.866 | 2.10 | 3.34 | 4.59 | 7.09 | 9.59 | 10.8 | 13.3 | 15.8 | 18.3 | 23.3 | 27.1 |
| 25.0 | 1.72 | 3.33 | 4.84 | 6.30 | 9.14 | 11.9 | 13.3 | 16.0 | 18.6 | 21.3 | 1.73 | 3.37 | 4.90 | 6.39 | 9.28 | 12.1 | 13.5 | 16.3 | 19.0 | 21.7 | 27.2 | 31.2 |
| 10.0 | 2.84 | 4.78 | 6.52 | 8.16 | 11.3 | 14.3 | 15.7 | 18.6 | 21.4 | 24.2 | 2.88 | 4.86 | 6.65 | 8.35 | 11.6 | 14.7 | 16.2 | 19.3 | 22.2 | 25.2 | 30.9 | 35.2 |
| 5.0 | 3.68 | 5.79 | 7.66 | 9.41 | 12.7 | 15.8 | 17.3 | 20.3 | 23.2 | 26.0 | 3.74 | 5.93 | 7.87 | 9.69 | 13.1 | 16.4 | 18.0 | 21.2 | 24.3 | 27.4 | 33.4 | 37.8 |
| 1.0 | 5.59 | 8.01 | 10.1 | 12.0 | 15.6 | 18.9 | 20.5 | 23.6 | 26.6 | 29.5 | 5.76 | 8.30 | 10.5 | 12.6 | 16.4 | 20.0 | 21.8 | 25.2 | 28.5 | 31.8 | 38.2 | 42.9 |
| | 0.25 | 1.0 | 1.5 | 2.5 | 4.0 | X | 6.5 | X | 10 | X | 0.25 | 1.0 | 1.5 | 2.5 | 4.0 | X | 6.5 | X | 10 | X | 15 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | | | | | |

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

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

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

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

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

Ac = Acceptance number

Re = Rejection number

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

= Use single sampling (for alternatively use code Letter D)

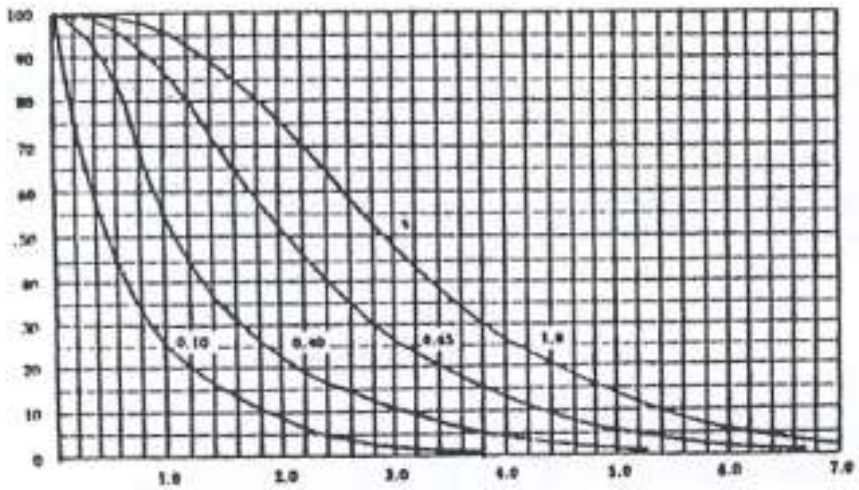
J

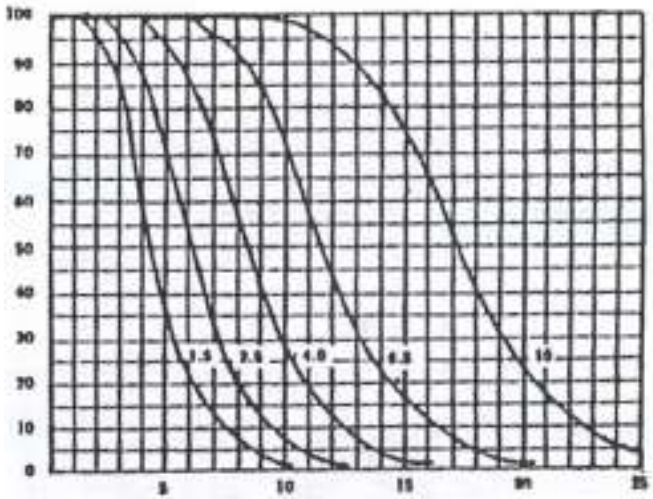
## TABLE X-K - Tables for sample size code letter: K

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

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

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)





**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

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

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

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

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

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

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

Ac = Acceptance number

Re = Rejection number

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

= Use single sampling (for alternatively use code Letter D)

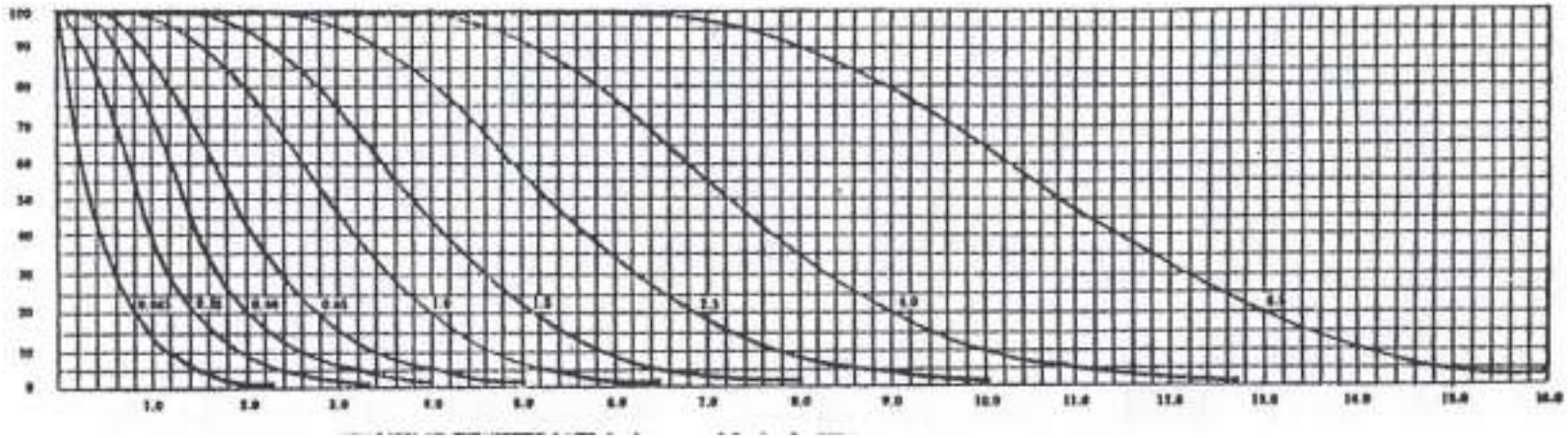
K

## 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)**

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)



**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.065 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | X | 2.5 | X | 4.0 | X | 6.5 |
| | p(in percent defective or in defects per hundred units) | | | | | | | | | | | |
| 99.0 | 0.00503 | 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 | 3.08 | 3.84 | 4.62 | 6.22 | 7.45 |
| 90.0 | 0.0527 | 0.266 | 0.551 | 0.872 | 1.58 | 2.33 | 2.72 | 3.51 | 4.32 | 5.15 | 6.84 | 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 | 2.55 | 3.71 | 4.83 | 5.40 | 6.51 | 7.61 | 8.70 | 10.9 | 12.5 |
| 10.0 | 1.15 | 1.94 | 2.66 | 3.34 | 4.64 | 5.89 | 6.50 | 7.70 | 8.89 | 10.1 | 12.4 | 14.1 |
| 5.0 | 1.50 | 2.37 | 3.15 | 3.88 | 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 |
| L | 0.10 | 0.40 | 0.65 | 1.0 | 1.5 | X | 2.5 | X | 4.0 | X | 6.5 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | |

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

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

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

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

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

Ac = Acceptance number

Re = Rejection number

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

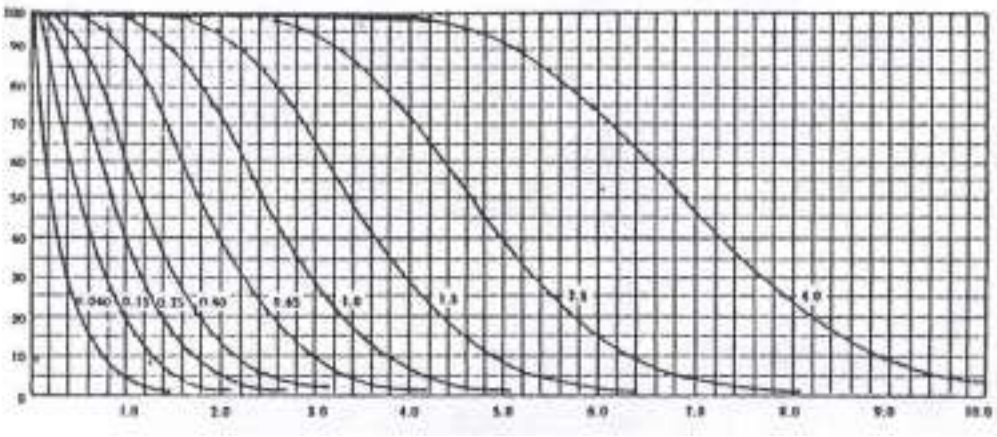
= Use single sampling (for alternatively use code Letter D)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)

## 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)**



**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.040 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | X | 1.5 | X | 2.5 | X | 4.0 |
| | p(in percent defective or in defects per hundred units) | | | | | | | | | | | |
| 99.0 | 0.00319 | 0.0472 | 0.138 | 0.261 | 0.567 | 0.923 | 1.11 | 1.51 | 1.94 | 2.37 | 3.28 | 3.99 |
| 95.0 | 0.0163 | 0.113 | 0.260 | 0.434 | 0.830 | 1.26 | 1.49 | 1.96 | 2.44 | 2.94 | 3.95 | 4.73 |
| 90.0 | 0.0335 | 0.169 | 0.350 | 0.534 | 1.00 | 1.48 | 1.72 | 2.23 | 2.74 | 3.27 | 4.34 | 5.16 |
| 75.0 | 0.0913 | 0.305 | 0.548 | 0.805 | 1.34 | .189 | 2.17 | 2.74 | 3.31 | 3.89 | 5.05 | 5.93 |
| 50.0 | 0.220 | 0.533 | 0.849 | 1.17 | 1.80 | 2.43 | 2.75 | 3.39 | 4.02 | 4.66 | 5.93 | 6.88 |
| 25.0 | 0.440 | 0.855 | 1.24 | 1.62 | 2.36 | 3.07 | 3.43 | 4.13 | 4.83 | 5.52 | 6.90 | 7.92 |
| 10.0 | 0.731 | 1.23 | 1.69 | 2.12 | 2.94 | 3.74 | 4.13 | 4.89 | 5.64 | 6.39 | 7.86 | 8.95 |
| 5.0 | 0.951 | 1.51 | 2.00 | 2.46 | 3.34 | 4.17 | 4.58 | 5.38 | 6.17 | 6.95 | 8.47 | 9.60 |
| 1.0 | 1.46 | 2.11 | 2.67 | 3.19 | 4.16 | 5.08 | 5.52 | 6.40 | 7.24 | 8.08 | 9.71 | 10.9 |
| M | 0.065 | 0.25 | 0.40 | 0.65 | 1.0 | X | 1.5 | X | 2.5 | X | 4.0 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | |

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

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

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

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

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

Ac = Acceptance number

Re = Rejection number

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

= Use single sampling (for alternatively use code Letter D)

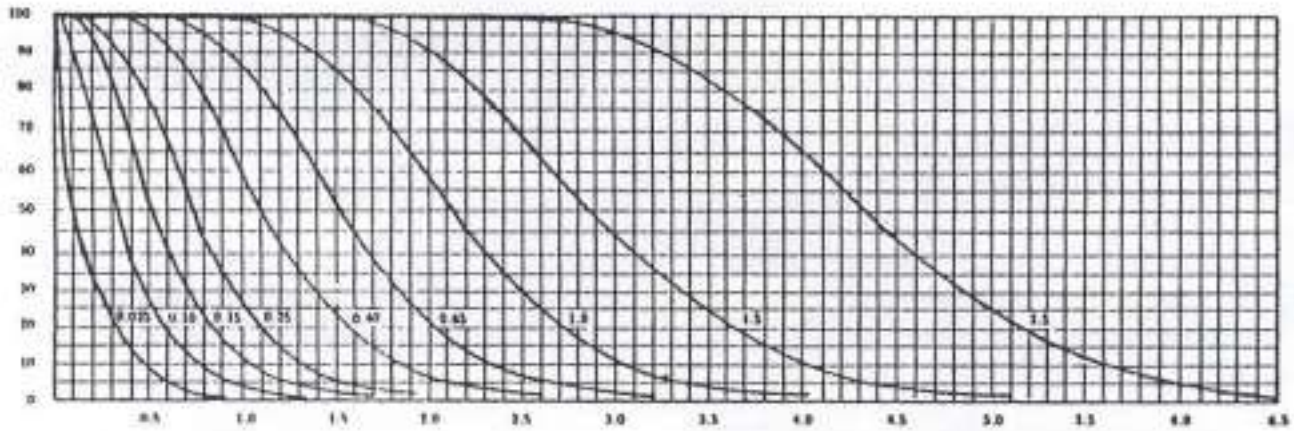
M

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)

## 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)**

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

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

| P. | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 0.025 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | X | 1.0 | X | 1.5 | X | 2.5 |
| | p(in percent defective or in defects per hundred units) | | | | | | | | | | | |
| 99.0 | 0.00201 | 0.0297 | 0.0872 | 0.165 | 0.357 | 0.581 | 0.701 | 0.954 | 1.22 | 1.50 | 2.07 | 2.51 |
| 95.0 | 0.0103 | 0.711 | 0.164 | 0.273 | 0.523 | 0.796 | 0.939 | 1.23 | 1.54 | 1.85 | 2.49 | 2.98 |
| 90.0 | 0.0211 | 0.106 | 0.220 | 0.349 | 0.630 | 0.931 | 1.09 | 1.40 | 1.73 | 2.06 | 2.73 | 3.25 |
| 75.0 | 0.0575 | 0.192 | 0.345 | 0.507 | 0.844 | 1.19 | 1.37 | 1.72 | 2.08 | 2.45 | 3.18 | 3.74 |
| 50.0 | 0.139 | 0.336 | 0.535 | 0.734 | 1.13 | 1.53 | 1.73 | 2.13 | 2.53 | 2.93 | 3.73 | 4.33 |
| 25.0 | 0.277 | 0.539 | 0.784 | 1.02 | 1.48 | 1.94 | 2.16 | 2.60 | 3.04 | 3.48 | 4.35 | 4.99 |
| 10.0 | 0.461 | 0.778 | 1.06 | 1.34 | 1.85 | 2.35 | 2.60 | 3.08 | 3.56 | 4.03 | 4.95 | 5.64 |
| 5.0 | 0.599 | 0.949 | 1.26 | 1.55 | 2.10 | 2.63 | 2.89 | 3.39 | 3.89 | 4.38 | 5.34 | 6.05 |
| 1.0 | 0.921 | 1.33 | 1.68 | 2.01 | 2.62 | 3.20 | 3.48 | 4.03 | 4.56 | 5.09 | 6.12 | 6.87 |
| N | 0.040 | 0.15 | 0.25 | 0.40 | 0.65 | X | 1.0 | X | 1.5 | X | 2.5 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | |

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

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

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

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

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

Ac = Acceptance number

Re = Rejection number

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

= Use single sampling (for alternatively use code Letter D)

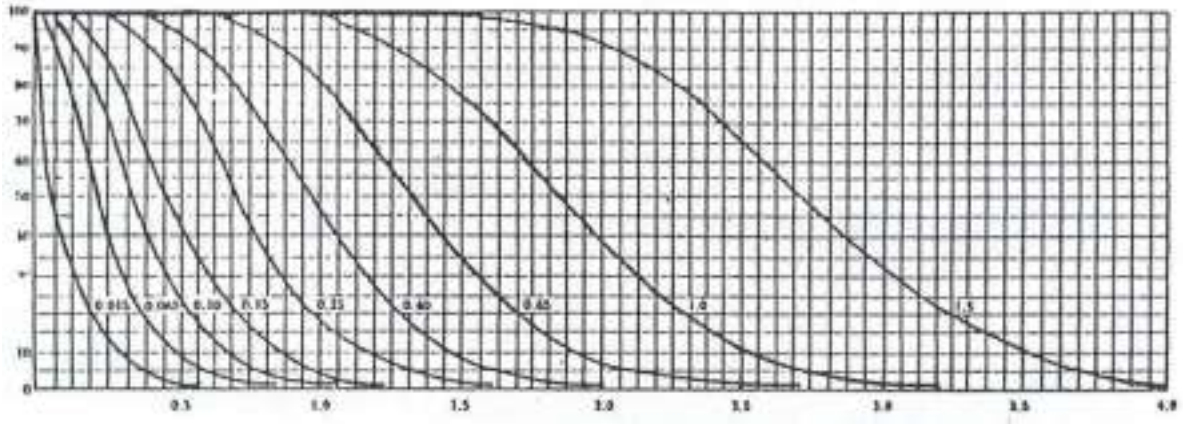
N

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)

## 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)**

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

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

| P. | 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 |
| | p(in percent defective or in defects per hundred units) | | | | | | | | | | | |
| 99.0 | 0.00126 | 0.0186 | 0.0545 | 0.103 | 0.223 | 0.363 | 0.438 | 0.596 | 0.762 | 0.935 | 1.29 | 1.57 |
| 95.0 | 0.00641 | 0.0444 | 0.102 | 0.171 | 0.327 | 0.498 | 0.587 | 0.771 | 0.961 | 1.16 | 1.56 | 1.86 |
| 90.0 | 0.0132 | 0.0665 | 0.138 | 0.218 | 0.394 | 0.582 | 0.679 | 0.878 | 1.08 | 1.29 | 1.71 | 2.03 |
| 75.0 | 0.0360 | 0.120 | 0.216 | 0.317 | 0.527 | 0.745 | 0.855 | 1.08 | 1.30 | 1.53 | 1.99 | 2.34 |
| 50.0 | 0.0866 | 0.210 | 0.334 | 0.459 | 0.709 | 0.959 | 1.08 | 1.33 | 1.58 | 1.83 | 2.33 | 2.71 |
| 25.0 | 0.173 | 0.337 | 0.490 | 0.639 | 0.928 | 1.21 | 1.35 | 1.63 | 1.90 | 2.17 | 2.72 | 3.12 |
| 10.0 | 0.208 | 0.486 | 0.665 | 0.835 | 1.16 | 1.47 | 1.62 | 1.93 | 2.22 | 2.52 | 3.09 | 3.52 |
| 5.0 | 0.374 | 0.593 | 0.787 | 0.969 | 1.31 | 1.64 | 1.80 | 2.12 | 2.43 | 2.74 | 3.34 | 3.78 |
| 1.0 | 0.576 | 0.830 | 1.05 | 1.26 | 1.64 | 2.00 | 2.18 | 2.52 | 2.85 | 3.18 | 3.82 | 4.29 |
| P | 0.025 | 0.10 | 0.15 | 0.25 | 0.40 | X | 0.65 | X | 1.0 | X | 1.5 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | |

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

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

| Type of sampling plan | Cumulative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | Cumulative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 0.010 | 0.015 | 0.025 | X | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | X | 0.65 | X | 1.0 | X | 1.5 | Higher than 1.5 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 800 | ∇ | 0 1 | Use Code Letter N | Use Code Letter R | Use Code Letter Q | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | Δ | 800 |
| Double | 500 | ∇ | • | | | | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 3 7 | 5 9 | 6 10 | 7 11 | 9 14 | 11 16 | Δ | 500 |
| | 1000 | | | | | | 1 2 | 3 4 | 4 5 | 6 7 | 8 9 | 11 12 | 12 13 | 15 16 | 18 19 | 23 24 | 26 27 | | 1000 |
| Multiple | 200 | ∇ | • | | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 4 | 0 5 | 0 6 | 1 7 | 1 8 | 2 9 | Δ | 200 |
| | 400 | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 1 6 | 2 7 | 3 8 | 3 9 | 4 10 | 6 12 | 7 14 | | 400 |
| | 600 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 4 9 | 6 10 | 7 12 | 8 13 | 11 17 | 13 19 | | 600 |
| | 800 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 6 11 | 8 13 | 10 15 | 12 17 | 16 22 | 19 25 | | 800 |
| | 1000 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 9 12 | 11 15 | 14 17 | 17 20 | 22 25 | 25 29 | | 1000 |
| | 1200 | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 12 14 | 14 17 | 18 20 | 21 23 | 27 29 | 31 33 | | 1200 |
| | 1400 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 14 15 | 18 19 | 21 22 | 25 26 | 32 33 | 37 38 | | 1400 |
| | | Less than 0.025 | 0.025 | X | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | X | 0.65 | X | 1.0 | X | 1.5 | X | Higher than 1.5 | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | |

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

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

Ac = Acceptance number

Re = Rejection number

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

= Use single sampling (for alternatively use code Letter D)

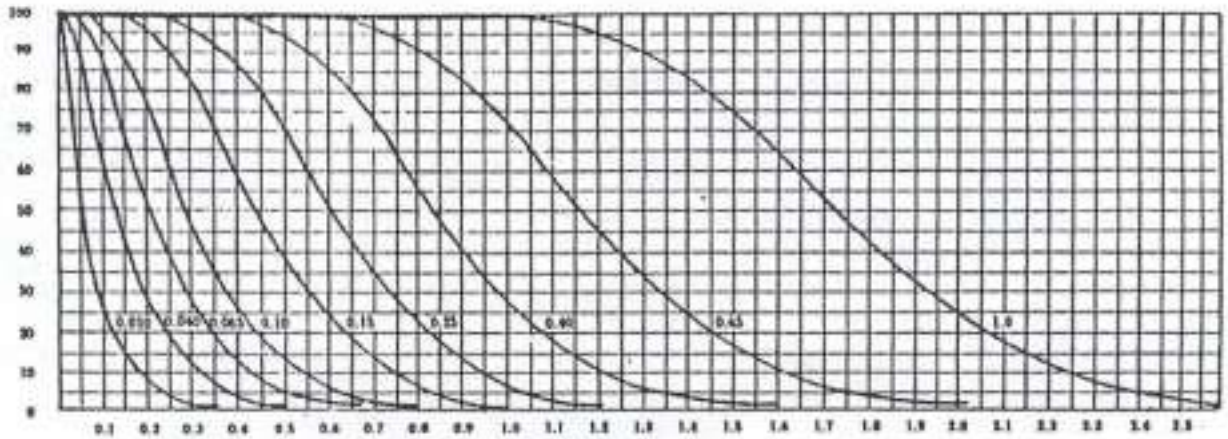
P

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (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)**



**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

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

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

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

| Type of sampling plan | Cumulative sample size | Acceptable Quality Levels (normal inspection) | | | | | | | | | | | | | | | | | Cumulative sample size |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | ╳ | 0.010 | 0.015 | ╳ | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | ╳ | 0.40 | ╳ | 0.65 | ╳ | 1.0 | Higher than 1.0 | |
| | | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | Ac Re | |
| Single | 1250 | ∇ | 0 1 | Use Code Letter P | Use Code Letter S | Use Code Letter R | 1 2 | 2 3 | 3 4 | 5 6 | 7 8 | 8 9 | 10 11 | 12 13 | 14 15 | 18 19 | 21 22 | Δ | 1250 |
| Double | 800 | ∇ | • | | | | 0 2 | 0 3 | 1 4 | 2 5 | 3 7 | 3 7 | 5 9 | 6 10 | 7 11 | 9 14 | 11 16 | Δ | 800 |
| | 1600 | | | | | | 1 2 | 3 4 | 4 5 | 6 7 | 8 9 | 11 12 | 12 13 | 15 16 | 18 19 | 23 24 | 26 27 | | 1600 |
| Multiple | 315 | ∇ | • | | | | # 2 | # 2 | # 3 | # 4 | 0 4 | 0 4 | 0 5 | 0 6 | 1 7 | 1 8 | 2 9 | Δ | 315 |
| | 630 | | | | | | # 2 | 0 3 | 0 3 | 1 5 | 1 6 | 2 7 | 3 8 | 3 9 | 4 10 | 6 12 | 7 14 | | 630 |
| | 945 | | | | | | 0 2 | 0 3 | 1 4 | 2 6 | 3 8 | 4 9 | 6 10 | 7 12 | 8 13 | 11 17 | 13 19 | | 945 |
| | 1260 | | | | | | 0 3 | 1 4 | 2 5 | 3 7 | 5 10 | 6 11 | 8 13 | 10 15 | 12 17 | 16 22 | 19 25 | | 1260 |
| | 1575 | | | | | | 1 3 | 2 4 | 3 6 | 5 8 | 7 11 | 9 12 | 11 15 | 14 17 | 17 20 | 22 25 | 25 29 | | 1575 |
| | 1890 | | | | | | 1 3 | 3 5 | 4 6 | 7 9 | 10 12 | 12 14 | 14 17 | 18 20 | 21 23 | 27 29 | 31 33 | | 1890 |
| | 2205 | | | | | | 2 3 | 4 5 | 6 7 | 9 10 | 13 14 | 14 15 | 18 19 | 21 22 | 25 26 | 32 33 | 37 38 | | 2205 |
| | | 0.010 | 0.015 | ╳ | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | ╳ | 0.40 | ╳ | 0.65 | ╳ | 1.0 | ╳ | Higher than 1.0 | |
| | | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | | | | | | | | |

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

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

Ac = Acceptance number

Re = Rejection number

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

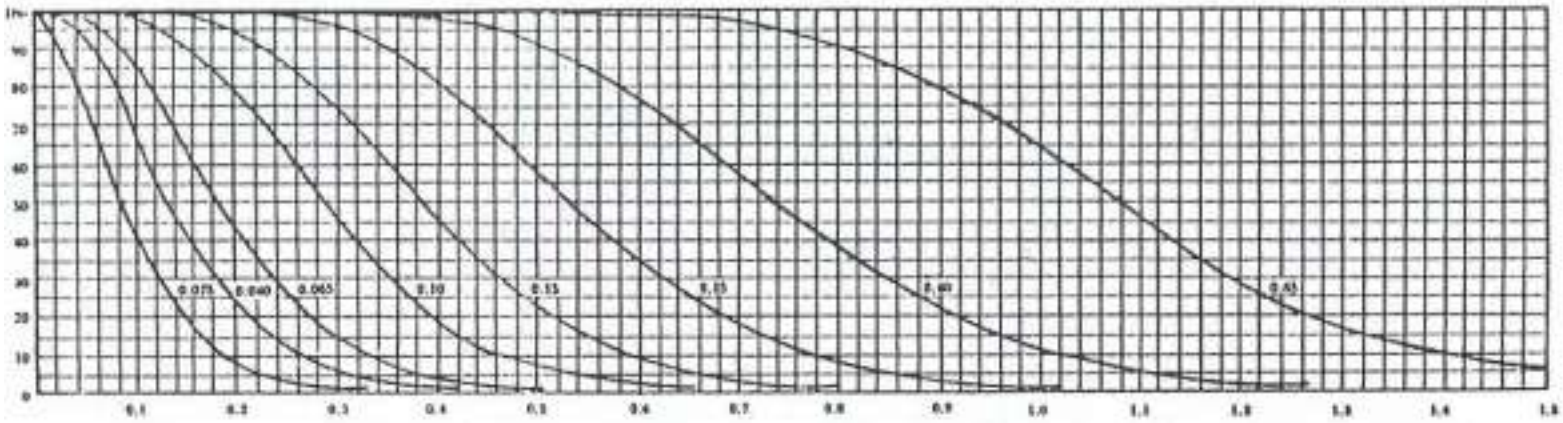
= Use single sampling (for alternatively use code Letter D)

PERCENT OF LOTS EXPECTED TO BE ACCEPTED (P.)

## 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)**



**Quality of Submitted Lots( p. in percent defective for AQL's ≤ 10: in defects per hundred units for AQL's > 10)**

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

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

| P. | 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 in defects per hundred units) | | | | | | | | | | |
| 99.0 | 0.00743 | 0.0218 | 0.0412 | 0.0892 | 0.145 | 0.175 | 0.239 | 0.305 | 0.374 | 0.517 | 0.629 |
| 95.0 | 0.0178 | 0.0409 | 0.0683 | 0.131 | 0.199 | 0.235 | 0.309 | 0.384 | 0.462 | 0.622 | 0.745 |
| 90.0 | 0.0266 | 0.0551 | 0.0872 | 0.158 | 0.233 | 0.272 | 0.351 | 0.432 | 0.515 | 0.684 | 0.812 |
| 75.0 | 0.0481 | 0.0864 | 0.127 | 0.211 | 0.298 | 0.342 | 0.431 | 0.521 | 0.612 | 0.795 | 0.934 |
| 50.0 | 0.0839 | 0.134 | 0.181 | 0.284 | 0.383 | 0.433 | 0.533 | 0.633 | 0.733 | 0.933 | 1.08 |
| 25.0 | 0.135 | 0.196 | 0.255 | 0.371 | 0.484 | 0.540 | 0.651 | 0.761 | 0.870 | 1.09 | 1.25 |
| 10.0 | 0.194 | 0.266 | 0.334 | 0.464 | 0.589 | 0.650 | 0.770 | 0.889 | 1.01 | 1.24 | 1.41 |
| 5.0 | 0.237 | 0.315 | 0.388 | 0.526 | 0.657 | 0.722 | 0.848 | 0.972 | 1.09 | 1.33 | 1.51 |
| 1.0 | 0.332 | 0.420 | 0.502 | 0.655 | 0.800 | 0.870 | 1.02 | 1.14 | 1.27 | 1.53 | 1.72 |
| R | 0.040 | 0.065 | 0.10 | 0.15 | X | 0.25 | X | 0.40 | X | 0.65 | X |
| | Acceptable Quality Levels (tightened inspection) | | | | | | | | | | |

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

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

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

**R**

∇ = Use next subsequent sample size code letter for which acceptance and rejection numbers are available.
Ac = Acceptance number
Re = Rejection number
• = Use single sampling plan above (or alternatively use code letter D)
= Use single sampling (for alternatively use code Letter D)

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

| Type of sampling plan | Cumu-lative sample size | Acceptable Quality Levels (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 Levels (tightened inspection) | |

S

Ac = Acceptance number
Re = Rejection number
# = Use single sampling (for alternatively use code Letter D)

MIL-STD-105E

6. NOTES

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

6.2. Subject Term (Key Word) Listing.

Acceptable Quality Level (AQL)

Average Outgoing Quality (AOQ)

Defect

Defective

Lot or Batch

Process Average

Sample

Sampling Plan

Unit of Product

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

MIL-STD-105E

CONCLUDING MATERIAL

Custodians:
Army - AR
Navy - OS
Air Force - 23

Preparing Activity
Army - AR

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

(Project QCIC-0085)

User Activities:
Army - ME
DLA - ES, SS

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

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**5. PROBLEM AREAS**

a. Paragraph Number and Wording:

b. Recommended Wording:

c. Reason/Rationale for Recommendation:

**6. REMARKS**

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