

# **KUMPULAN TABEL MIL-STD-105E**

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<sup>\*)</sup> *Farnum, Nicholas R. 1994. Modern Statistical Quality Control and Improvement. Wadsworth, Inc., California.*

## **Tahapan Implementasi MIL-STD-105E**

1. Tentukan *AQL (Acceptable Quality Level)* berdasarkan perjanjian produsen dan pelanggan.
2. Tetapkan modus dan tingkat inspeksi (jika tidak, gunakan *Normal Inspection, Level II*).
3. Tentukan ukuran lot (*lot size*).
4. Gunakan tabel *Sample Size Code Letters* untuk memilih huruf kode yang sesuai.
5. Tetapkan tipe prosedur pengambilan sampel : *single, double, atau multiple sampling*.
6. Gunakan tabel yang berkaitan dengan prosedur pengambilan sampel terpilih (tahap 5) dan modus/tingkat inspeksi (tahap 2) untuk mendapatkan ukuran sampel dan angka penerimaan (*Ac*) serta angka penolakan (*Re*). Dalam kasus dimana suatu rancangan tidak ada untuk ukuran lot dan *AQL*-nya, hati-hati mengikuti tanda panah dalam tabel ke rancangan terdekat yang ada.
7. Mulailah gunakan rancangan tersebut dan catat penerimaan dan penolakan sehingga switching rule dapat diterapkan. Jika switching dilakukan, tentukan modus dan tingkat dan ulangi tahap 4-6 untuk mendapatkan rancangan pengambilan sampel yang baru.

## **SWITCHING RULE for MIL-STD-105E**



- Dari *Normal* ke *Tightened Inspection* : setelah 2 lot ditolak dari 2, 3, 4, atau 5 lot berurutan
- Dari *Tightened* ke *Normal Inspection* : setelah 5 lot berurutan diterima
- Dari *Normal* ke *Reduced Inspection* : jika (i) 10 lot berurutan diterima, dan (ii) jumlah total *nonconforming items* dalam 10 lot tersebut tidak melebihi batas pada *Table VIII. Limit Numbers for Reduced Inspection.*, dan (iii) produksi stabil/mantap, dan (iv) disetujui oleh otoritas yang bertanggungjawab.
- Dari *Reduced* ke *Normal Inspection* : jika (i) suatu lot tunggal ditolak, atau (ii) suatu lot hanya sebagian dapat diterima (dhi. jumlah *nonconforming items* diantara angka diterima dan ditolak), atau (iii) produksi menjadi tidak stabil, atau (iv) kondisi-kondisi lain yang menjamin bahwa inspeksi Normal dapat dilakukan.

**Table I. Sample-Size Code Letters.**

| Lot or batch size  | Special Inspection Levels |     |     |     | General Inspection Levels |    |     |
|--------------------|---------------------------|-----|-----|-----|---------------------------|----|-----|
|                    | S-1                       | S-2 | S-3 | S-4 | I                         | II | III |
| 2 to 8             | A                         | A   | A   | A   | A                         | A  | B   |
| 9 to 15            | A                         | A   | A   | A   | A                         | B  | C   |
| 16 to 25           | A                         | A   | B   | B   | B                         | C  | D   |
| 26 to 50           | A                         | B   | B   | C   | C                         | D  | E   |
| 51 to 90           | B                         | B   | C   | C   | C                         | E  | F   |
| 91 to 150          | B                         | B   | C   | D   | D                         | F  | G   |
| 151 to 280         | B                         | C   | D   | E   | E                         | G  | H   |
| 281 to 500         | B                         | C   | D   | E   | F                         | H  | J   |
| 501 to 1,200       | C                         | C   | E   | F   | G                         | J  | K   |
| 1,201 to 3,200     | C                         | D   | E   | G   | H                         | K  | L   |
| 3,201 to 10,000    | C                         | D   | F   | G   | J                         | L  | M   |
| 10,001 to 35,000   | C                         | D   | F   | H   | K                         | M  | N   |
| 35,001 to 150,000  | D                         | E   | G   | J   | L                         | N  | P   |
| 150,001 to 500,000 | D                         | E   | G   | J   | M                         | P  | Q   |
| 500,001 and over   | D                         | E   | H   | K   | N                         | Q  | R   |

**Table II - A. Single Sampling Plans for Normal Inspection (Master Table).**

| Sample size code letter | 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 | 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 45 |       |  |
| C                       | 5           | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | 0 1   | ↑     | ↑     | 1 2   | 2 3   | 3 4   | 5 6   | 7 8   | 10 11 | 14 15 | 21 22 | 30 31 | 44 45 | ↑     |  |
| D                       | 8           | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | 0 1   | ↑     | ↑     | ↓     | 1 2   | 2 3   | 3 4   | 5 6   | 7 8   | 10 11 | 14 15 | 21 22 | 30 31 | 44 45 | ↑     | ↑     |       |  |
| E                       | 13          | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | 0 1   | ↑     | ↑     | ↓     | 1 2   | 2 3   | 3 4   | 5 6   | 7 8   | 10 11 | 14 15 | 21 22 | 30 31 | 44 45 | ↑     | ↑     |       |  |
| F                       | 20          | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | 0 1   | ↑     | ↑     | ↓     | 1 2   | 2 3   | 3 4   | 5 6   | 7 8   | 10 11 | 14 15 | 21 22 | ↑     | ↑     | ↑     | ↑     |       |  |
| 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 inspection.  
 = Use first sampling plan above arrow.

Ac = Acceptance number.  
 Re = Rejection number.

**Table II - B. Single Sampling Plans for Tightened Inspection (Master Table).**

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

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number.

Re = Rejection number.

**Table II - C. Single Sampling Plans for Reduced Inspection (Master Table).**

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

↑ = Use first sampling plan above arrow.



† = If the acceptance number has been exceeded, but the rejection number has not been reached; accept the lot, but reinstate normal inspection.

Ac = Acceptance number.

Re = Rejection number.

**Table III - A. Double Sampling Plans for Normal Inspection (Master Table).**

| 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 | Ac Re | Ac Re |
| A                       |                 |              |                        | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| B                       | First<br>Second | 2<br>2       | 2<br>4                 | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| C                       | First<br>Second | 3<br>3       | 3<br>6                 | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| D                       | First<br>Second | 5<br>5       | 5<br>10                | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| E                       | First<br>Second | 8<br>8       | 8<br>16                | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| F                       | First<br>Second | 13<br>13     | 13<br>26               | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| G                       | First<br>Second | 20<br>20     | 20<br>40               | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| H                       | First<br>Second | 32<br>32     | 32<br>64               | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| J                       | First<br>Second | 50<br>50     | 50<br>100              | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| K                       | First<br>Second | 80<br>80     | 80<br>160              | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| L                       | First<br>Second | 125<br>125   | 125<br>250             | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| M                       | First<br>Second | 200<br>200   | 200<br>400             | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| N                       | First<br>Second | 315<br>315   | 315<br>630             | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| P                       | First<br>Second | 500<br>500   | 500<br>1000            | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| Q                       | First<br>Second | 800<br>800   | 800<br>1600            | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| R                       | First<br>Second | 1250<br>1250 | 1250<br>2500           | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |



 = Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.  
 = Use first sampling plan above arrow.  
 • = Use corresponding single sampling plan (or alternatively, use double sampling plan below, where available).

Ac = Acceptance number.  
 Re = Rejection number.



**Table III - B. Double Sampling Plans for Tightened Inspection (Master Table).**

| 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 | Ac Re | Ac Re |
| A                       |                 |              |                        | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| B                       | First<br>Second | 2<br>2       | 2<br>4                 | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| C                       | First<br>Second | 3<br>3       | 3<br>6                 | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| D                       | First<br>Second | 5<br>5       | 5<br>10                | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| E                       | First<br>Second | 8<br>8       | 8<br>16                | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| F                       | First<br>Second | 13<br>13     | 13<br>26               | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| G                       | First<br>Second | 20<br>20     | 20<br>40               | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| H                       | First<br>Second | 32<br>32     | 32<br>64               | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| J                       | First<br>Second | 50<br>50     | 50<br>100              | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| K                       | First<br>Second | 80<br>80     | 80<br>160              | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| L                       | First<br>Second | 125<br>125   | 125<br>250             | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| M                       | First<br>Second | 200<br>200   | 200<br>400             | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| N                       | First<br>Second | 315<br>315   | 315<br>630             | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| P                       | First<br>Second | 500<br>500   | 500<br>1000            | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| Q                       | First<br>Second | 800<br>800   | 800<br>1600            | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| R                       | First<br>Second | 1250<br>1250 | 1250<br>2500           | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| S                       | First<br>Second | 2000<br>2000 | 2000<br>4000           | ↓   | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |

 = Use first sampling plan below arrow. If sample size equals or exceeds lot or batch size, do 100 percent inspection.  
 = Use first sampling plan above arrow.  
 • = Use corresponding single sampling plan (or alternatively, use double sampling plan below, where available).

Ac = Acceptance number.  
 Re = Rejection number.

**Table III - C. Double Sampling Plans for Reduced Inspection (Master Table).**

| 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 | Ac Re | Ac Re |
| A                       |        |             |                        | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| B                       |        |             |                        | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| C                       |        |             |                        | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| D                       | First  | 2           | 2                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 2           | 4                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| E                       | First  | 3           | 3                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 3           | 6                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| F                       | First  | 5           | 5                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 5           | 10                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| G                       | First  | 8           | 8                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 8           | 16                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| H                       | First  | 13          | 13                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 13          | 26                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| J                       | First  | 20          | 20                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 20          | 40                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| K                       | First  | 32          | 32                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 32          | 64                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| L                       | First  | 50          | 50                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 50          | 100                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| M                       | First  | 80          | 80                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 80          | 160                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| N                       | First  | 125         | 125                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 125         | 250                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| P                       | First  | 200         | 200                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 200         | 400                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| Q                       | First  | 315         | 315                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 315         | 630                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| R                       | First  | 500         | 500                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second | 500         | 1000                   | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |

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

↑ = Use first sampling plan above arrow.

Ac = Acceptance number.

Re = Rejection number.

• = Use corresponding single sampling plan (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.

**Table IV - A. Multiple Sampling Plans for Normal Inspection (Master Table).**



| 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 | Ac Re | Ac Re |
| A                       |         |             |                        |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| B                       |         |             |                        |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| C                       |         |             |                        |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| D                       | First   | 2           | 2                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Second  | 2           | 4                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Third   | 2           | 6                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fourth  | 2           | 8                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fifth   | 2           | 10                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Sixth   | 2           | 12                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Seventh | 2           | 14                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| E                       | First   | 3           | 3                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Second  | 3           | 6                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Third   | 3           | 9                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fourth  | 3           | 12                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fifth   | 3           | 15                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Sixth   | 3           | 18                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Seventh | 3           | 21                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| F                       | First   | 5           | 5                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Second  | 5           | 10                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Third   | 5           | 15                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fourth  | 5           | 20                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fifth   | 5           | 25                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Sixth   | 5           | 30                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Seventh | 5           | 35                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| G                       | First   | 8           | 8                      |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Second  | 8           | 16                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Third   | 8           | 24                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fourth  | 8           | 32                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fifth   | 8           | 40                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Sixth   | 8           | 48                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Seventh | 8           | 56                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| H                       | First   | 13          | 13                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Second  | 13          | 26                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Third   | 13          | 39                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fourth  | 13          | 52                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fifth   | 13          | 65                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Sixth   | 13          | 78                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Seventh | 13          | 91                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
| J                       | First   | 20          | 20                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Second  | 20          | 40                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Third   | 20          | 60                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fourth  | 20          | 80                     |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Fifth   | 20          | 100                    |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Sixth   | 20          | 120                    |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |
|                         | Seventh | 20          | 140                    |   |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |       |

= Use first sampling plan below arrow (refer to continuation of table on following page, when necessary). If sample size equals or exceeds lot or batch size, do 100 percent inspection.
 = Use first sampling plan above arrow.
   
 • = Use corresponding single sampling plan (or alternatively, use double sampling plan below, where available). Ac = Acceptance number.
   
 ++ = Use corresponding double sampling plan (or alternatively, use multiple sampling plan below, where available). # = Acceptance not permitted at this sample size. Re = Rejection number.



**Table IV - B. Multiple Sampling Plans for Tightened Inspection (Master Table).**

| 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 | Ac Re | Ac Re |
| A                       |         |             |                        | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| B                       |         |             |                        | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| C                       |         |             |                        | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| D                       | First   | 2           | 2                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second  | 2           | 4                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Third   | 2           | 6                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fourth  | 2           | 8                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fifth   | 2           | 10                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Sixth   | 2           | 12                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Seventh | 2           | 14                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| E                       | First   | 3           | 3                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second  | 3           | 6                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Third   | 3           | 9                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fourth  | 3           | 12                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fifth   | 3           | 15                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Sixth   | 3           | 18                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Seventh | 3           | 21                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| F                       | First   | 5           | 5                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second  | 5           | 10                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Third   | 5           | 15                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fourth  | 5           | 20                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fifth   | 5           | 25                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Sixth   | 5           | 30                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Seventh | 5           | 35                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| G                       | First   | 8           | 8                      | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second  | 8           | 16                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Third   | 8           | 24                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fourth  | 8           | 32                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fifth   | 8           | 40                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Sixth   | 8           | 48                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Seventh | 8           | 56                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| H                       | First   | 13          | 13                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second  | 13          | 26                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Third   | 13          | 39                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fourth  | 13          | 52                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fifth   | 13          | 65                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Sixth   | 13          | 78                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Seventh | 13          | 91                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
| J                       | First   | 20          | 20                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Second  | 20          | 40                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Third   | 20          | 60                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fourth  | 20          | 80                     | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Fifth   | 20          | 100                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Sixth   | 20          | 120                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |
|                         | Seventh | 20          | 140                    | ↓  | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     | ↓     |       |       |       |

 = Use first sampling plan below arrow (refer to continuation of table on following page, when necessary). If sample size equals or exceeds lot or batch size, do 100 percent inspection.
  = Use first sampling plan above arrow.

• = Use corresponding single sampling plan (or alternatively, use double sampling plan below, where available). Ac = Acceptance number. Re = Rejection number.

++ = Use corresponding double sampling plan (or alternatively, use multiple sampling plan below, where available). # = Acceptance not permitted at this sample size.









**Table V-A. Average Outgoing Quality Limit Factors for Normal Inspection (Single Sampling) \***

| Code Letter | Sample size | Acceptable Quality Level |       |       |       |       |      |      |      |      |      |      |      |      |     |     |     |     |     |     |     |     |     |     |     |     |      |
|-------------|-------------|--------------------------|-------|-------|-------|-------|------|------|------|------|------|------|------|------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|------|
|             |             | 0.010                    | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0  | 1.5  | 2.5  | 4.0 | 6.5 | 10  | 15  | 25  | 40  | 65  | 100 | 150 | 250 | 400 | 650 | 1000 |
| A           | 2           |                          |       |       |       |       |      |      |      |      |      |      |      |      |     | 18  |     |     | 42  | 69  | 97  | 160 | 220 | 330 | 470 | 730 | 1100 |
| B           | 3           |                          |       |       |       |       |      |      |      |      |      |      |      |      | 12  |     |     | 28  | 46  | 65  | 110 | 150 | 220 | 310 | 490 | 720 | 1100 |
| C           | 5           |                          |       |       |       |       |      |      |      |      |      |      |      | 7.4  |     |     | 17  | 27  | 39  | 63  | 90  | 130 | 190 | 290 | 430 | 660 |      |
| D           | 8           |                          |       |       |       |       |      |      |      |      |      |      | 4.6  |      |     | 11  | 17  | 24  | 40  | 56  | 82  | 120 | 180 | 270 | 410 |     |      |
| E           | 13          |                          |       |       |       |       |      |      |      |      |      | 2.8  |      |      | 6.5 | 11  | 15  | 24  | 34  | 50  | 72  | 110 | 170 | 250 |     |     |      |
| F           | 20          |                          |       |       |       |       |      |      |      |      | 1.8  |      |      | 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 |      |      | 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 |      |      | 1.1 | 1.6 | 2.5 | 3.6 | 5.2 | 7.5 | 12  |     |     |     |     |     |      |
| L           | 200         |                          |       |       |       | 0.18  |      |      |      |      |      |      |      | 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 |       |       |      |      |      | 0.27 | 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 volume must be multiplied by  $\left(1 - \frac{\text{Sample size}}{\text{Lot or Batch size}}\right)$

**Table V-B. Average Outgoing Quality Limit Factors for Tightened Inspection (Single Sampling) \***

| Code Letter | Sample size | Acceptable Quality Level |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
|-------------|-------------|--------------------------|-------|-------|-------|-------|------|------|------|------|------|-----|-----|-----|-----|-----|----|----|----|----|----|-----|-----|-----|-----|-----|------|
|             |             | 0.010                    | 0.015 | 0.025 | 0.040 | 0.065 | 0.10 | 0.15 | 0.25 | 0.40 | 0.65 | 1.0 | 1.5 | 2.5 | 4.0 | 6.5 | 10 | 15 | 25 | 40 | 65 | 100 | 150 | 250 | 400 | 650 | 1000 |
| A           | 2           |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| B           | 3           |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| C           | 5           |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| D           | 8           |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| E           | 13          |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| F           | 20          |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| G           | 32          |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| H           | 50          |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| J           | 80          |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| K           | 125         |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| L           | 200         |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| M           | 315         |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| N           | 500         |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| P           | 800         |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| Q           | 1250        |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| R           | 2000        |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |
| S           | 3150        |                          |       |       |       |       |      |      |      |      |      |     |     |     |     |     |    |    |    |    |    |     |     |     |     |     |      |

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

**Table VIII. Limit Numbers for Reduced Inspection.**

| 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 |
| 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 |     |     |     |     |     |     |     |     |     |     |     |     |     |     |      |
| 31500 - 49999                                       | 0                        | 1     | 4     | 8     | 14    | 24   | 38   | 67   | 111  | 186  |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |      |
| 50000 & over  | 2                        | 3     | 7     | 14    | 25    | 40   | 63   | 110  | 181  | 301  |     |     |     |     |     |     |     |     |     |     |     |     |     |     |     |      |

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