WAR-110

APPENDIX D

SAMPLING PLAN: (ISO 2859)

Example: for a hypothetical inspection of a production with 4,000 units, the site inspector has selected level II normal inspection and AQL of 2.5.

In Table A below, the intersection of the respective Lot Size and General Inspection Level indicates sample size code letter L. Then, referring to Table B, we locate row L, which indicates the required sample size of 200 units.

To comply with AQL 2.5, no more than 10 units from that sample size can fail inspection. (Table B).

Table A:

SAMPLE SIZE CODE LETTERS

Lot Size	General Inspection Levels			Special Inspection Levels			
	I	II	III	S1	S2	S3	S4
2 to 8	A	A	B	A	A	A	A
9 to 15	A	B	C	A	A	A	A
16 to 25	B	C	D	A	A	B	B
26 to 50	C	D	E	A	B	B	C
51 to 90	C	E	F	B	B	C	C
91 to 150	D	F	G	B	B	C	D
151 to 280	E	G	H	B	C	D	E
281 to 500	F	H	J	B	C	D	E
501 to 1200	G	J	K	C	C	E	F
1201 to 3200	H	K	L	C	D	E	G
3201 to 10000	J	L	M	C	D	F	G
10001 to 35000	K	M	N	C	D	F	H
35001 to 150000	L	N	P	D	E	G	J
150001 to 500000	M	P	Q	D	E	G	J
500001 and over	N	Q	R	D	E	H	K

ANSI/ASQ Standard Z1.4 - 2008

Table B:

SINGLE SAMPLING PLANS FOR NORMAL INSPECTION

Sample Size Code Letter	Sample Size	0.065 Ac	0.065 Re	0.10 Ac	0.10 Re	0.15 Ac	0.15 Re	0.25 Ac	0.25 Re	0.40 Ac	0.40 Re	0.65 Ac	0.65 Re	1.0 Ac	1.0 Re	1.5 Ac	1.5 Re	2.5 Ac	2.5 Re	4.0 Ac	4.0 Re	6.5 Ac	6.5 Re
A	2																					0	1
B	3																			0	1		
C	5																	0	1				
D	8															0	1					1	2
E	13													0	1					1	2	2	3
F	20											0	1					1	2	2	3	3	4
G	32									0	1					1	2	2	3	3	4	5	6
H	50							0	1					1	2	2	3	3	4	5	6	7	8
J	80					0	1					1	2	2	3	3	4	5	6	7	8	10	11
K	125			0	1					1	2	2	3	3	4	5	6	7	8	10	11	14	15
L	200	0	1					1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22
M	315					1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22		
N	500			1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22				
P	800	1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22						
Q	1250	2	3	3	4	5	6	7	8	10	11	14	15	21	22								
R	2000	3	4	5	6	7	8	10	11	14	15	21	22										

Column group header: **Acceptable Quality Levels (Normal Inspection)**

↑ Use first sampling plan above arrow, if sample size equals or exceeds lot or batch size, do 100 percent inspection.

↓ Use first sampling plan below arrow

AC : Acceptance number   **Re** : Rejection number