

STEP 1 FIND YOUR SAMPLING SIZE

Look for your lot size and find your letter based on the General Inspection Level (95% use level II). You can also define your Special Inspection Levels (only used for specific checks and testing).

SAMPLING 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 1 200	G	J	K	C	C	E	F
1 201 to 3 200	H	K	L	C	D	E	G
3 201 to 10 000	J	L	M	C	D	F	G
10 001 to 35 000	K	M	N	C	D	F	H
35 001 to 150 000	L	N	P	D	E	G	J
150 001 to 500 000	M	P	Q	D	E	G	J
500 001 and over	N	Q	R	D	E	H	K

STEP 2 DEFINE YOUR ACCEPTABLE QUALITY LIMIT

Identify your sampling size based on the letter from previous chart. Define your acceptable quality limits and find the maximum number of critical, major and minor defects. Generally, the limits used are: critical= 0, major= 2.5, minor= 4.

		ACCEPTABLE QUALITY LIMITS FOR NORMAL INSPECTIONS																						
Sample size code letter	Sample size	0.065		0.1		0.15		0.25		0.4		0.65		1		1.5		2.5		4		6.5		
		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
B	3																						0	1
C	5																						0	1
D	8																						0	1
E	13																						0	1
F	20																						0	1
G	32																						0	1
H	50																						0	1
J	80																						0	1
K	125																						0	1
L	200																						0	1
M	315																						0	1
N	500																						0	1
P	800																						0	1
Q	1250																						0	1
R	2000																						0	1

↓ Use first sampling plan below arrow. If sample size equals, or exceeds lot or batch size, do 100% inspection. ↑ Use first sampling plan above narrow. Ac Acceptance number Re Rejection number