

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

(See 9.4 and 9.5)

Sample size code letter	Sample size	Acceptance Quality Limits, AQLs, in Percent Nonconforming Items and Nonconformities per 100 Items (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	44 45		
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 the first sampling plan below the arrow. If sample size equals, or exceeds, lot size, carry out 100 percent inspection.

↑ = Use the first sampling plan above the arrow.

Ac = Acceptance number.

Re = Rejection number.

# Tables For Normal Sampling With Unknown

**Jay S. Kim, Ronald J. Dailey**



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