



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 1200	C	C	E	F	G	J	K
1201 to 3200	C	D	E	G	H	K	L
3201 to 10000	C	D	F	G	J	L	M
10001 to 35000	C	D	F	H	K	M	N
35001 to 150000	D	E	G	J	L	N	P
150001 to 500000	D	E	G	J	M	P	Q
500001 and Over	D	E	H	K	N	Q	R



TABLE II - A - Single sampling plans for normal inspections (Master Table)

Sample size code letter	Sample size	Acceptance Quality Limits (normal inspection)										
		0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	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	↑	↓	1 2
E	13	↓	↓	↓	↓	↓	↓	↓	0 1	↑	↓	2 3
F	20	↓	↓	↓	↓	↓	↓	↓	0 1	↑	↓	3 4
G	32	↓	↓	↓	↓	↓	↓	↓	1 2	↑	↓	5 6
H	50	↓	↓	↓	↓	↓	↓	↓	1 2	↑	↓	7 8
J	80	↓	↓	0 1	0 1	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	↓	↑	↑	↓	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	↑	↑	↑	↑	↑

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

↑ = Use first sampling plan below arrow.

Ac = Acceptance number

Re = Rejection number



TABLE III - A - Double sampling plans for normal inspections (Master Table)

Code letter	Sample	Sample size	Total Sample size	Acceptance Quality Limits (normal inspection)													
				0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	
				Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	Ac Re	
A											■			●	●	●	
B	First	2	2								■			0 2	0 3	1 4	2 5
	Second	2	4											1 2	3 4	4 5	6 7
C	First	3	3								■			0 2	0 3	1 4	2 5
	Second	3	6											1 2	3 4	4 5	6 7
D	First	5	5											0 2	0 3	1 4	2 5
	Second	5	10											1 2	3 4	4 5	6 7
E	First	8	8											0 2	0 3	1 4	2 5
	Second	8	16											1 2	3 4	4 5	6 7
F	First	13	13											0 2	0 3	1 4	2 5
	Second	13	26											1 2	3 4	4 5	6 7
G	First	20	20											0 2	0 3	1 4	2 5
	Second	20	40											1 2	3 4	4 5	6 7
H	First	32	32											0 2	0 3	1 4	2 5
	Second	32	64											1 2	3 4	4 5	6 7
J	First	50	50											0 2	0 3	1 4	2 5
	Second	50	100											1 2	3 4	4 5	6 7
K	First	80	80											0 2	0 3	1 4	2 5
	Second	80	160											1 2	3 4	4 5	6 7
L	First	125	125											0 2	0 3	1 4	2 5
	Second	125	250											1 2	3 4	4 5	6 7
M	First	200	200											0 2	0 3	1 4	2 5
	Second	200	400											1 2	3 4	4 5	6 7
N	First	315	315											0 2	0 3	1 4	2 5
	Second	315	630											1 2	3 4	4 5	6 7
P	First	500	500											0 2	0 3	1 4	2 5
	Second	500	1000											1 2	3 4	4 5	6 7
Q	First	800	800											0 2	0 3	1 4	2 5
	Second	800	1600											1 2	3 4	4 5	6 7
R	First	1250	1250											0 2	0 3	1 4	2 5
	Second	1250	2500											1 2	3 4	4 5	6 7

- ▼ = Use first sampling plan below arrow
- ▲ = Use first sampling plan above arrow.
- = Use corresponding single sampling plan
- = Use corresponding single sampling plan or double sampling plan below
- Ac = Acceptance number
- Re = Rejection number