Sampling procedures for inspection by attributes —

Part 1:
Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

Règles d'échantillonnage pour les contrôles par attributs —
Partie 1: Procédures d'échantillonnage pour les contrôles lot par lot, indexés d'après le niveau de qualité acceptable (NQA)
Contents

1 Scope ........................................................................................................................................................................... 1
2 Normative references ................................................................................................................................................... 2
3 Terms, definitions and symbols .................................................................................................................................. 2
4 Expression of nonconformity ......................................................................................................................................... 7
5 Acceptance quality limit (AQL) ................................................................................................................................... 8
6 Submission of product for sampling ............................................................................................................................. 8
7 Acceptance and non-acceptance ................................................................................................................................ 9
8 Drawing of samples ...................................................................................................................................................... 9
9 Normal, tightened and reduced inspection ................................................................................................................. 10
10 Sampling plans .......................................................................................................................................................... 13
11 Determination of acceptability ................................................................................................................................ 14
12 Further information ................................................................................................................................................... 14
13 Fractional acceptance number plans for single sampling (optional) ......................................................................... 16

Tables

1 Sample size code letters ................................................................................................................................................. 19
2-A Single sampling plans for normal inspection (Master table) .................................................................................... 20
2-B Single sampling plans for tightened inspection (Master table) ............................................................................... 21
2-C Single sampling plans for reduced inspection (Master table) ..................................................................................... 22
3-A Double sampling plans for normal inspection (Master table) .................................................................................... 23
3-B Double sampling plans for tightened inspection (Master table) .............................................................................. 24
3-C Double sampling plans for reduced inspection (Master table) .................................................................................. 25
4-A Multiple sampling plans for normal inspection (Master table) ................................................................................. 26
4-B Multiple sampling plans for tightened inspection (Master table) ............................................................................. 29

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Printed in Switzerland
11-A Single sampling plans for normal inspection (Auxiliary master table) ............................................................... 81
11-B Single sampling plans for tightened inspection (Auxiliary master table) ............................................................ 82
11-C Single sampling plans for reduced inspection (Auxiliary master table) ............................................................. 83
12 Scheme OC curves (Normalized) ......................................................................................................................................... 84

Annex A (informative) Example for non-constant sampling plan ..................................................................................... 85

Bibliography ...................................................................................................................................................................... 87
Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 2859-1 was prepared by Technical Committee ISO/TC 69, Applications of statistical methods, Subcommittee SC 5, Acceptance sampling.

This second edition of ISO 2859-1 cancels and replaces the first edition (ISO 2859-1:1989) of which it constitutes a technical revision.

Significant changes in this edition include:

- a new procedure for switching from normal to reduced inspection;
- a reference to skip-lot sampling as an alternative to reduced inspection;
- the term "limiting quality" has been changed to "consumer's risk quality" in the heading of Tables 6-A, 6-B, 6-C, 7-A, 7-B and 7-C;
- a new table has been added giving producer's risk as the probability of rejection of lots with percent nonconforming equal to the AQL;
- optional fractional acceptance number plans have been added; the purpose of these plans is to provide a consistent progression from the plans for acceptance number zero to the acceptance number 1 plans. The fractional acceptance number plans are found in Tables 11-A, 11-B and 11-C, where they take the place of the arrows in the corresponding positions in tables 2-A, 2-B and 2-C;
- reduced plans have been changed to eliminate the gap between the acceptance and rejection numbers;
- some changes have been made to the double sampling plans to provide a smaller average sample size;
- multiple sampling plans have been changed to five stages rather than seven. The change has not increased the average sample size. Some of the new plans have a smaller average sample size than their counterparts in the previous edition;
- scheme operating characteristic curves have been added as Table 12.

ISO 2859 consists of the following parts, under the general title Sampling procedures for inspection by attributes:

- Part 0: Introduction to the ISO 2859 attribute sampling system
- Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection
- Part 2: Sampling plans indexed by limiting quality (LQ) for isolated lot inspection
— Part 3: Skip-lot sampling procedures

It is highly recommended that this part of ISO 2859 be used together with ISO 2859-0, which contains illustrative examples.

Annex A of this part of ISO 2859 is for information only.
1 Scope

1.1 This part of ISO 2859 specifies an acceptance sampling system for inspection by attributes. It is indexed in terms of the acceptance quality limit (AQL).

Its purpose is to induce a supplier through the economic and psychological pressure of lot non-acceptance to maintain a process average at least as good as the specified acceptance quality limit, while at the same time providing an upper limit for the risk to the consumer of accepting the occasional poor lot.

Sampling schemes designated in this part of ISO 2859 are applicable, but not limited, to inspection of

- end items,
- components and raw materials,
- operations,
- materials in process,
- supplies in storage,
- maintenance operations,
- data or records, and
- administrative procedures.

1.2 These schemes are intended primarily to be used for a continuing series of lots, that is, a series long enough to allow the switching rules (9.3) to be applied. These rules provide:

a) a protection to the consumer (by means of a switch to tightened inspection or discontinuation of sampling inspection) should a deterioration in quality be detected;

b) an incentive (at the discretion of the responsible authority) to reduce inspection costs (by means of a switch to reduced inspection) should consistently good quality be achieved.

Sampling plans in this part of ISO 2859 may also be used for the inspection of lots in isolation but, in this case the user is strongly advised to consult the operating characteristic curves to find a plan that will yield the desired protection (see 12.6). In that case, the user is also referred to the sampling plans indexed by limiting quality (LQ) given in ISO 2859-2.