

INTERNATIONAL STANDARD

ISO
8422

First edition
1991-11-15

Sequential sampling plans for inspection by attributes

Plans d'échantillonnage progressifs pour le contrôle par attributs



Reference number
ISO 8422:1991(E)

Contents

	Page
Section 1 General	1
1.1 Scope	1
1.2 Normative references	1
1.3 Definitions and symbols	2
1.4 Principle of a sequential sampling plan by attributes	3
Section 2 Choice of sampling plan	5
2.1 Choice between sequential, single, double and multiple sampling plans	5
2.2 Particular reservations on the inspection of small lots	5
2.3 Selection of a sampling plan	6
2.4 Pre-operation preparations	6
Section 3 Operation of a sequential sampling plan	11
3.1 Specification of the plan	11
3.2 Drawing of the sample	11
3.3 Cumulative count	11
3.4 Determination of acceptability	11
3.5 Operating characteristic curves and average sample size	13
3.6 Validity of approximations	13
Annexes	
A Sequential sampling plans corresponding to ISO 2859-1 sampling plans	18
B Determination of the parameters of a sequential sampling plan	40
C Calculation of the operating characteristic curve and average sample size	41
D Bibliography	45

© ISO 1991

All rights reserved. No part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from the publisher.

International Organization for Standardization
Case Postale 56 • CH-1211 Genève 20 • Switzerland

Printed in Switzerland

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.

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 8422 was prepared by Technical Committee ISO/TC 69, *Applications of statistical methods*, Sub-Committee SC 5, *Acceptance sampling*.

Annexes A, B and C form an integral part of this International Standard. Annex D is for information only.

STANDARDSISO.COM : Click to view the full PDF of ISO 8422:1991

This page intentionally left blank

Sequential sampling plans for inspection by attributes

Section 1: General

1.1 Scope

1.1.1 This International Standard specifies sequential sampling plans and procedures for inspection by attributes of discrete items.

The plans in the main body of the standard are indexed in terms of the producer's risk point and the consumer's risk point.

Annex A specifies sequential sampling plans and procedures indexed in terms of the acceptable quality level (AQL) to supplement the system of sampling plans in ISO 2859-1.

The purpose of this International Standard is to provide procedures for sequential assessment of inspection results that may be used to induce the supplier through the economic and psychological pressure of non-acceptance of lots of inferior quality to supply lots of a quality having a high probability of acceptance. At the same time, the consumer is protected by a prescribed upper limit to the probability of accepting lots of poor quality.

1.1.2 The sampling plans designated in this International Standard are applicable, but not limited, to inspection in different fields, such as

- end items;
- components and raw materials;
- operations;
- materials in process;
- supplies in storage;
- maintenance operations;
- data or records;

- administrative procedures.

It contains sampling plans for inspection by attributes of discrete items. The sampling plans may be used when the extent of nonconformity is expressed either in terms of proportion (or percent) nonconforming items or in terms of nonconformities per item (per 100 items).

The sampling plans are based on the assumption that nonconformities occur randomly and with statistical independence. There may be good reasons to suspect that one nonconformity in an item could be caused by a condition also likely to cause others. If so, it may be better to consider the items just as conforming or not, and ignore multiple nonconformities.

The plans in annex A are primarily intended to be used for inspection of a continuing series of lots from the same production run. The plans in the main body of this International Standard may also be used for inspection of lots in isolation.

1.2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 2859-1:1989, *Sampling procedures for inspection by attributes — Part 1: Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection*.

ISO 3534-1:—¹⁾, *Statistics — Vocabulary and symbols — Part 1: Probability and general statistical terms.*

ISO 3534-2:—¹⁾, *Statistics — Vocabulary and symbols — Part 2: Statistical quality control.*

1.3 Definitions and symbols

1.3.1 Definitions

For the purposes of this International Standard, the definitions given in ISO 3534-1, ISO 3534-2 and ISO 2859-1, together with the following definitions, apply.

1.3.1.1 cumulative count (D): When sampling inspection of items from a lot is performed sequentially, the total number of nonconforming items (nonconformities) found during inspection, counting from the start of inspection up to, and including, the item last inspected.

1.3.1.2 cumulative sample size (n_{cum}): When sampling inspection of items from a lot is performed sequentially, the total of inspected items, counting from the start of the inspection up to, and including, the item last inspected.

1.3.1.3 acceptance value for sequential sampling (A): A value derived from the specified parameters of the sampling plan and the cumulative sample size. Whether the lot may yet be accepted is determined by comparing the cumulative count with the acceptance number.

NOTE 1 In sampling by attributes, acceptance values are integers and are referred to as acceptance numbers. This latter term is used throughout this International Standard.

1.3.1.4 rejection value for sequential sampling (R): A value derived from the specified parameters of the sampling plan and the cumulative sample size. Whether the lot shall yet be considered not acceptable is determined by comparing the cumulative count with the rejection number.

NOTE 2 In sampling by attributes, rejection values are integers and are referred to as rejection numbers. This latter term is used throughout this International Standard.

1.3.2 Symbols

The symbols used in this International Standard are as follows:

A_0 Acceptance number for a corresponding single sampling plan.

A	Acceptance number for sequential sampling.
A_t	Acceptance number corresponding to the curtailed value of the cumulative sample size.
CRQ	Consumer's risk quality level (in percent nonconforming).
D	Cumulative count.
g	Multiplier of the cumulative sample size that is used to determine the acceptance and the rejection numbers (slope of the acceptance and rejection lines).
h_A	Constant that is used to determine the acceptance numbers (intercept of the acceptance line).
h_R	Constant that is used to determine the rejection numbers (intercept of the rejection line).
n_0	Sample size for a corresponding single sampling plan.
n_{av}	Average sample size.
n_{cum}	Cumulative sample size.
n_t	Curtailed value of the cumulative sample size.
p	Lot or process quality level (in proportion nonconforming or nonconformities per item).
p_A	Producer's risk quality level. $P_a = 1 - \alpha$ when $p = p_A$.
p_R	Consumer's risk quality level. $P_a = \beta$ when $p = p_R$.
P_a	The probability of acceptance.
PRQ	Producer's risk quality level (in percent nonconforming).
R	Rejection number for sequential sampling.
R_t	Rejection number corresponding to the curtailed value of the cumulative sample size.

1) To be published.

α	The producer's risk. ²⁾
β	The consumer's risk. ²⁾
λ	Index parameter that is used to determine approximations to the OC curve at general quality levels. (See C.2.2.)

1.4 Principle of a sequential sampling plan by attributes

Under a sequential sampling plan by attributes, items are selected at random and subjected to inspection one by one, and a cumulative count is kept of the number of nonconforming items (or of the number of nonconformities). After the inspection of each item, the cumulative count is used to assess whether there is sufficient information to sentence the lot at that stage of the inspection.

If, at a given stage, the cumulative count is such that the risk of accepting a lot of an unsatisfactory quality level (the consumer's risk) is sufficiently low, the lot is considered acceptable and sampling of that lot is terminated.

If, on the other hand, the cumulative count is such that the risk of non-acceptance for a lot of a satisfactory quality level (the producer's risk) is sufficiently low, the lot shall be considered not acceptable, and sampling of that lot is terminated.

If the cumulative count does not allow either of the above decisions to be taken, then an additional item is inspected. The process is continued until sufficient sample information has been accumulated to warrant a decision that the lot is acceptable or not acceptable.

STANDARDSISO.COM : Click to view the full PDF of ISO 8422:1991

2) α and β may be considered to be the type I and type II risks, respectively, when testing the null hypothesis

$$H_0: p = p_A$$

against the alternative hypothesis

$$H_1: p = p_R$$

STANDARDSISO.COM : Click to view the full PDF of ISO 8422:1991

Section 2: Choice of sampling plan

2.1 Choice between sequential, single, double and multiple sampling plans

2.1.1 Advantages and disadvantages of sequential plans

The *average* sample size is the average of the various sample sizes which may occur under a sampling plan for a given lot or process quality level. Like double and multiple sampling plans, the use of sequential sampling plans leads to a smaller average sample size than single sampling plans having the same operating characteristic. However, the average savings are even greater when using a sequential sampling plan than when a double or multiple sampling plan is used.

For good quality lots, the savings may reach, or even exceed, 50 % compared with a maximum saving of 37 % with double sampling. Annex C gives a method for determining approximate values of the average sample size.

On the other hand, the actual number of items inspected for a particular lot when using a double, multiple or sequential sampling plan may exceed that of the corresponding single sampling plan. For double and multiple sampling plans there is an upper limit to the actual number of items to be inspected.

For sequential sampling plans, there is generally no such limit, and the number of inspected items may considerably exceed the sample size of the corresponding single sampling plan and even exceed the lot size. For the sequential sampling plans in this International Standard, a curtailment rule (see 2.1.3) has been introduced in order to limit the potential number of inspected items.

As the ultimate sample size from a particular lot is not known in advance, the selection of the sample may present organizational difficulties when sequential sampling plans are used. Moreover, the scheduling of inspection operations may present difficulties when using a double, multiple or sequential sampling plan. A further disadvantage is that the execution of a sequential sampling plan is more easily misunderstood by the inspectors than the simpler rules for single sampling.

The balance between the advantages of a smaller average sample size and the organizational disadvantages associated with a fluctuating inspection load results in sequential sampling being suitable only when inspection of individual items is costly in comparison with inspection overheads.

2.1.2 Caution

The choice between single, double, multiple and sequential sampling plans shall be made before the inspection of a lot is started. During the inspection of a lot, it is not permitted to switch from one type of sampling plan to another as the operating characteristic of the plan may be drastically changed if the actual inspection results influence the choice of acceptance criterion.

2.1.3 Curtailment of the sample size

Although a sequential sampling plan is on average much more economical than the equivalent single sampling plan, it may occur, during the inspection of a particular lot, that acceptance or non-acceptance comes at a very late stage because the cumulative count remains between the acceptance number and the rejection number for a long time. With the graphical method this corresponds to the random progress of the step curve remaining in the indecision zone. Such a situation is most likely to occur when the quality level of the lot (in proportion nonconforming or in nonconformities per item) is close to g , where g is the slope of the acceptance and rejection lines.

In order to alleviate this disadvantage, a maximum cumulative sample size n_k is set before sampling begins, and inspection is stopped if the cumulative sample size reaches the curtailment value, n_k , without a decision having been made. The acceptance or non-acceptance of the lot is then determined in accordance with a rule which is also agreed in advance of sampling. The curtailment rules of this International Standard have been determined in such a way that the producer's and consumer's risks are hardly affected by this deviation from the principles underlying the statistical theory of sequential sampling inspection. The curtailment rules to be used are given in 2.4.2.

2.2 Particular reservations on the inspection of small lots

The statistical theory underlying the sequential sampling plans in this International Standard is based on the assumption that the samples taken from the lot are "with replacement", i.e. each sampled item is replaced before the next item in the sample is selected. When, as is usual, sampling is without replacement, the theory remains valid for all practical purposes if the cumulative sample size does not exceed one-tenth of N , where N denotes the lot size; the theory remains approximately valid even for cumulative sample sizes up to one-seventh

of N . Unfortunately, in contrast to the situation for single sampling plans, the actual cumulative sample size that is necessary in a sequential sampling plan will not be known in advance.

In the case of a small lot it is therefore advisable to ensure that the size of the lot is sufficiently large to allow a curtailed sequential sampling plan to operate under sampling without replacement, in accordance with the specified producer's and consumer's risks. For the general sequential sampling plans described in 2.3.2 and 2.4.1, it is therefore recommended that the lot size exceed $7n_k$, where n_k is the curtailment value of the sequential sampling plan.

NOTE 4 If the lot size is not sufficiently large to satisfy the above requirement, both the consumer's and the producer's risks will generally become less than their specified values. If, however, the acceptance number of the corresponding single sampling plan is zero, then the producer's risk may slightly exceed the specified values.

2.3 Selection of a sampling plan

2.3.1 Plans matching those of ISO 2859-1

If it is required to find a sequential sampling plan matching a plan from ISO 2859-1:1989, then annex A may be used. Annex A contains sequential sampling plans indexed by acceptable quality level (AQL) and sample size code letter. The operating characteristic curves of these sequential sampling plans match, as closely as practicable, those of the corresponding plans in ISO 2859-1.

2.3.2 General plans

The general method described in 2.3.2 and in 2.4.1 is used when the requirements of the sequential sampling plan are specified in terms of two points on the operating characteristic curve of the plan. The point corresponding to the higher probability of acceptance shall be designated the *producer's risk point*; the other shall be designated the *consumer's risk point*.

The first step when designing a sequential sampling plan is to choose these two points, if they have not already been dictated by circumstances. For this purpose, a producer's risk of $\alpha = 0,05$ and a consumer's risk of $\beta = 0,10$ are often used. (See figure 1.)

When the desired sequential sampling plan is required to have approximately the same operating characteristic as an existing single, double or multiple sampling plan, the producer's risk point and the consumer's risk point may be read off from a graph or a table of the operating characteristic of that plan. When no such plan exists, the producer's and con-

sumer's risk points have to be determined from direct considerations of the conditions under which the sampling plan will operate.

2.4 Pre-operation preparations

2.4.1 Obtaining the parameters h_A , h_R and g

The criteria for acceptance or non-acceptance of a lot that are invoked at each stage of the inspection are determined from the parameters h_A , h_R and g .

The values of these parameters corresponding to a producer's risk of $\alpha = 0,05$, a consumer's risk of $\beta = 0,10$ and preferred values of the producer's and consumer's risk quality levels are given in tables 1-A and 1-B.

Annex B gives general procedures for determining h_A , h_R and g for any combination of producer's and consumer's risk points.

EXAMPLE

The specification for a type of electrical insulator is given as the nominal withstand value 1000 kV. An inspection agency is using a single sampling plan with sample size 65 and acceptance number 6 for determination of the acceptability of production lots of this insulator type. Since the build-up of the test voltage is consuming in both time and energy, it has been decided that a sequential sampling plan should be used in future to determine the acceptability of production lots of the insulator. The sequential sampling plan is to have an operating characteristic similar to that of the single sampling plan being used.

The single sampling plan has the following properties:

- if 5 % of the insulators from the production fail at the nominal voltage then the probability of accepting a lot is 0,95;
- if 16 % of the insulators from the production fail at the nominal voltage then the probability of accepting the lot is 0,10.

These requirements correspond to fixing

- a) the producer's risk quality (PRQ) at 5 % with 95 % of lots expected to be accepted; i.e. such that the producer's risk is 5 %, or $\alpha = 0,05$.
- b) the consumer's risk quality (CRQ) at 16 % non-conforming with 10 % of lots expected to be accepted; i.e. such that the consumer's risk is 10 %, or $\beta = 0,10$.

The requirements are indicated on the graph of the operating characteristic curve in figure 1.

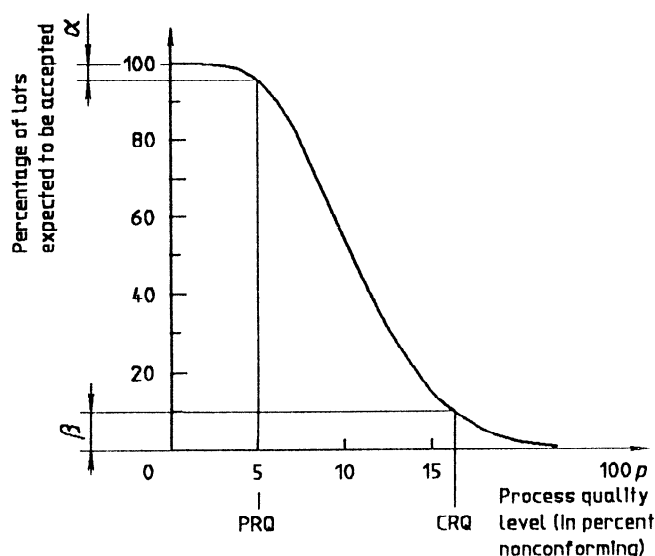


Figure 1 — Operating characteristic curve for a sampling plan with producer's risk $\alpha = 0,05$ and consumer's risk $\beta = 0,10$

From table 1-A it is found that the parameters of the sequential sampling plan that satisfies these requirements are

$$h_A = 1,750$$

$$h_R = 2,247$$

$$g = 0,0957$$

The same values could have been found by calculation using the procedure given in annex B.

2.4.2 Determining the curtailment value of the sample size

2.4.2.1 Standard procedures

- If the sample size n_0 of the single sampling plan that is equivalent to the sequential sampling plan under consideration is known, the curtailment value for the cumulative sample size is determined as $n_t = 1,5n_0$, rounded up to the nearest integer.
- If the sample size of the equivalent single sampling plan is not known, the curtailment value under inspection for percent nonconforming is determined as

$$n_t = \frac{2h_A h_R}{g(1-g)}$$

rounded up to the nearest integer and, in the case of inspection for nonconformities per 100 items, n_t is determined as

$$n_t = \frac{2h_A h_R}{g}$$

rounded up to the nearest integer.

2.4.2.2 Truncation for small lots

If the resulting value of n_t exceeds the lot size, then the sequential sampling plan shall be used with the curtailment value n_t of the sample size equal to the lot size.

2.4.2.3 Example

Consider the sequential sampling plan for inspection for percent nonconforming with parameters $h_A = 1,750$, $h_R = 2,247$ and $g = 0,0957$ that were determined in the example given in 2.4.1. The plan was chosen to match the single sampling plan with $n_0 = 65$ and $A_0 = 6$.

The curtailment value for the cumulative sample size is therefore $n_t = 98$.

Had the corresponding single sampling plan not been known, the curtailment value would have been determined by 2.4.2.1 b). Substituting the values of h_A , h_R and g in the formula in 2.4.2.1 b) leads to the curtailed sample size $n_t = 91$.

2.4.3 Choosing the form of the sampling plan

This International Standard gives two methods of operating a sequential sampling plan: a numerical method and a graphical method.

The numerical method has the advantage of being accurate, thereby avoiding disputes about acceptance or non-acceptance.

The graphical method is well suited to the inspection of series of lots, as the chart needs only to be drawn once, but the method is less accurate due to the inaccuracy inherent in plotting points and in drawing straight lines. On the other hand, the method does have the advantage of displaying the increase in the information on the quality of the lot as additional items are inspected, information being represented by the progress of a broken line within the indecision zone until the line reaches, or crosses, one of the boundaries of that zone.

The numerical method is the standard method, so far as acceptance or non-acceptance of a lot is concerned. See the caution in 3.4.2.

2.4.3.1 Numerical method

For each value, n_{cum} , of the cumulative sample size that is less than the curtailment value of the sample size, the acceptance number A is found by rounding the quantity

$$gn_{\text{cum}} - h_A \quad \dots (2.1)$$

down to the nearest integer. The rejection number R is found by rounding the quantity

$$gn_{\text{cum}} + h_R \quad \dots (2.2)$$

up to the nearest integer.

The acceptance number, A_t , corresponding to the curtailed sample size is determined as

$$A_t = gn_t$$

rounded down to the nearest integer.

The corresponding rejection number is calculated as

$$R_t = A_t + 1$$

Whenever the value of equation (2.1) is negative, the cumulative sample size is too small to allow acceptance of the lot. Conversely, whenever the value of equation (2.2) is larger than the cumulative sample size, the cumulative sample size is too small to permit non-acceptance of the lot under inspection for proportion nonconforming.

The quantities given by equations (2.1) and (2.2) shall be determined to three decimal places before rounding.

The smallest cumulative sample size permitting acceptance of the lot is obtained by rounding h_A/g up to the nearest integer.

The smallest cumulative sample size permitting non-acceptance of the lot under inspection for proportion nonconforming is obtained by rounding $h_R/(1 - g)$ up to the nearest integer.

EXAMPLE

For the sequential sampling plan with parameters $h_A = 1,750$, $h_R = 2,247$ and $g = 0,095\,7$ that were determined in the example given in 2.4.1, the curtailment value of the sample size was determined in the example given in 2.4.2.3 to be $n_t = 98$. The corresponding acceptance number is found by rounding $gn_t = 9,38$ down to the nearest integer, hence the acceptance number A_t is 9 and the rejection number R_t is 10.

The formula for the acceptance number A becomes

$$0,095\,7n_{\text{cum}} - 1,750$$

rounded down to the nearest integer, and the formula for the rejection number R becomes

$$0,095\,7n_{\text{cum}} + 2,247$$

rounded up to the nearest integer.

The acceptance and rejection numbers corresponding to the cumulative sample sizes $n_{\text{cum}} = 1, 2, \dots, 97$ are determined by successively inserting the values of n_{cum} in these formulae and rounding the result as described above. The result is shown in figure 2.

Cumulative sample size n_{cum}	$gn_{\text{cum}} - h_A$ [equation (2.1)]	Acceptance number A	$gn_{\text{cum}} + h_R$ [equation (2.2)]	Rejection number R
1	-1,654	*	2,343	**
2	-1,559	*	2,438	**
3	-1,463	*	2,534	3
4	-1,367	*	2,630	3
5	-1,272	*	2,726	3
6	-1,176	*	2,821	3
7	-1,080	*	2,917	3
8	-0,985	*	3,013	4
9	-0,889	*	3,108	4
10	-0,793	*	3,204	4
11	-0,697	*	3,300	4
12	-0,602	*	3,395	4
13	-0,506	*	3,491	4
14	-0,410	*	3,587	4
15	-0,315	*	3,683	4
16	-0,219	*	3,778	4
17	-0,123	*	3,874	4
18	-0,028	*	3,970	4
19	0,068	0	4,065	5
20	0,164	0	4,161	5
.	.	.	.	.
.	.	.	.	.
97	7,533	7	11,530	12
98	—	9	—	10

* indicates that the cumulative sample size is too small to permit acceptance.
 ** indicates that the cumulative sample size is too small to permit non-acceptance.

Figure 2 — Inspection record sheet for the sequential sampling plan considered in the example given in 2.4.3.1

2.4.3.2 Graphical method

Prepare a graph as shown in figure 3, with the cumulative sample size as the horizontal axis, the cumulative count as the vertical axis, and with the quantities given by equations (2.1) and (2.2) represented by two straight lines with the same slope, g . The lower line, with intercept $-h_A$, is designated the *acceptance line*, and the upper line, with intercept h_R , is designated the *rejection line*.

Add a vertical line, the *curtailment line*, at a cumulative sample size n_i .

The lines define three zones on the chart.

- The *acceptance zone* is the zone below (and including) the acceptance line, together with that part of the curtailment line that is below (and includes) the point $(n_i; A_i)$.
- The *rejection zone* is the zone above (and including) the rejection line together with that part of the curtailment line that is above (and includes) the point $(n_i; R_i)$.
- The *indecision zone* is the strip between the acceptance and rejection lines that is to the left of the curtailment line.

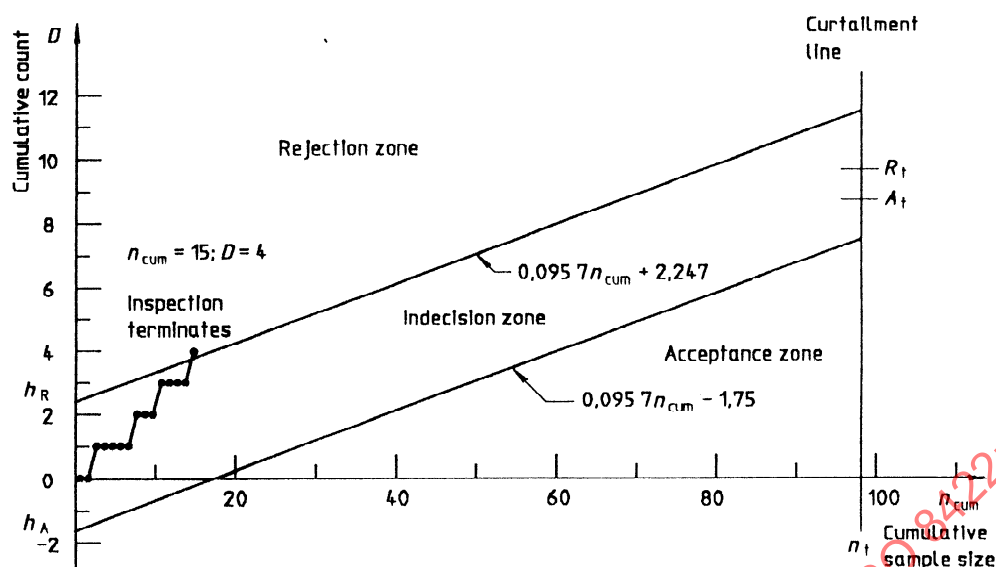


Figure 3 — Acceptance chart for the sequential sampling plan considered in the example given in 2.4.3.2

EXAMPLE

Consider figure 3, which shows an acceptance chart for the sequential sampling plan with the parameters $h_A = 1,750$, $h_R = 2,247$ and $g = 0,095\,7$ that were determined in the example given in 2.4.1. To construct this acceptance chart a sheet of graph paper was prepared with the cumulative sample size n_{cum} on the horizontal axis and the cumulative count D on the vertical axis. The acceptance line is the straight line passing through the point $(0; -h_A)$ and all the points $(n_{cum}; gn_{cum} - h_A)$. Choosing $n_{cum} = 97$ we find $gn_{cum} - h_A = 7,533$. The line was constructed by plotting the points $(0; -1,750)$ and $(97; 7,533)$ on the graph paper and connecting the two points by a straight line. The rejection line was

similarly constructed by connecting the points $(0; 2,247)$ and $(97; 11,530)$, corresponding to $(0; h_R)$ and $(n_{cum}; gn_{cum} + h_R)$ with $n_{cum} = 97$. Finally, the curtailment line was constructed as a vertical line through $n_{cum} = 98$ (see the example given in 2.4.2.3).

The acceptance zone is bordered by the acceptance line and the curtailment line; moreover the part of the curtailment line that is below and includes the point $(98; 9)$ belongs to the acceptance zone. The rejection zone is bordered by the rejection line and the curtailment line; moreover the part of the curtailment line that is above and includes the point $(98; 10)$ belongs to the rejection zone. The indecision zone is bordered by the acceptance line, the rejection line and the curtailment line.

Section 3: Operation of a sequential sampling plan

3.1 Specification of the plan

The choice between single, double, multiple and sequential sampling plans shall be made before the inspection of a lot is started.

Before sequential sampling takes place, the inspector must record on the sampling document the specified values of h_A , h_R , g , n_t and A_t .

3.2 Drawing of the sample

The individual items in the sample shall be drawn at random from the lot and inspected one by one in the order in which they were drawn. If, for convenience, successive samples of several items at a time are drawn, the order in which the items of each sample are inspected shall be independent of their original position in the lot.

3.3 Cumulative count

3.3.1 Inspection for proportion nonconforming

Following the inspection of each item, record the inspection result as a zero for a conforming item and 1 otherwise; then record the cumulative count D as the number of nonconforming items found so far in the sample from the lot.

3.3.2 Inspection for nonconformities per item

Following the inspection of each item, record the inspection result as the number of nonconformities

found for that item; then record the cumulative count D as the number of nonconformities found so far in the sample from the lot.

3.4 Determination of acceptability

3.4.1 Numerical method

- If the cumulative count D is less than or equal to the corresponding acceptance number A_t , the lot shall be considered acceptable.
- If the cumulative count D is greater than or equal to the corresponding rejection number R_t , the lot shall be considered not acceptable.
- If neither a) nor b) is satisfied, another item shall be sampled and inspected.

When the cumulative sample size reaches the curtailment value n_t , the rules in a) and b) apply with the curtailment acceptance number A_t and the curtailment rejection number $R_t = A_t + 1$.

EXAMPLE

For the sequential sampling plan with $h_A = 1,750$, $h_R = 2,247$ and $g = 0,0957$, the acceptance and rejection numbers were determined in the example given in 2.4.3.1. Assume that, of the first 15 insulators sampled from a lot, the 3rd, 8th, 11th and 15th insulators were found not to conform to the specified nominal withstand voltage. These inspection results may be presented in tabular form, as shown in figure 4.

Cumulative sample size n_{cum}	Inspection result for item n_{cum}	Acceptance number A	Cumulative count D	Rejection number R
1	0	*	0	**
2	0	*	0	**
3	1	*	1	3
4	0	*	1	3
5	0	*	1	3
6	0	*	1	3
7	0	*	1	3
8	1	*	2	4
9	0	*	2	4
10	0	*	2	4
11	1	*	3	4
12	0	*	3	4
13	0	*	3	4
14	0	*	3	4
15	1	*	4	4
16		*		4
17		*		4
18		*		4
19		0		5
20		0		5
.		.		.
.		.		.
97		7		12
98		9		10

* indicates that the cumulative sample size is too small to permit acceptance.

** indicates that the cumulative sample size is too small to permit non-acceptance.

Figure 4 — Inspection record sheet for the data of the example given in 3.4.1

As the cumulative count after the inspection of 15 insulators equals the rejection number, the lot is considered not acceptable and inspection is terminated.

On the other hand, if the first 19 insulators in a sample from another lot had all been found to conform to the specification, inspection of that lot would have been terminated after inspection of the 19th insulator and the lot accepted, since the cumulative count (zero) then equals the acceptance number.

If, during inspection of a lot, inspection has not terminated before inspection of the 98th item, inspection shall terminate following inspection of the 98th item. The lot is considered acceptable if, after inspection of the 98th item, the cumulative count is at most 9 items. If the cumulative count is 10 or more, the lot is considered not acceptable.

3.4.2 Graphical method

Plot the point (n_{cum} ; D) on the acceptance chart prepared in accordance with 2.4.3.2.

- a) If the point lies in the acceptance zone, the lot shall be considered acceptable.

- b) If the point lies in the rejection zone, the lot shall be considered not acceptable.

- c) If the point lies in the indecision zone, another item shall be sampled and inspected.

The successive points on the chart may be connected by a step curve to show up any trend in the inspection results.

CAUTION — If the point is close to the acceptance or rejection lines, the numerical method shall be used to make the decision.

EXAMPLE

For the sequential sampling plan for proportion nonconforming with parameters $h_A = 1,750$, $h_R = 2,247$ and $g = 0,095\ 7$, the construction of the acceptance chart has been described in the example given in 2.4.3.2.

Assume as before that inspection of the first 15 insulators sampled from a lot resulted in the 3rd, 8th, 11th and 15th insulators being found not to conform to the specified nominal withstand voltage.

The successive points ($n_{\text{cum}}; D$) are plotted on the chart and connected by a step curve as shown in figure 3. Since the point (15; 4) is clearly in the rejection zone, inspection is terminated after inspection of the 15th item, and the lot considered not acceptable.

3.5 Operating characteristic curves and average sample size

3.5.1 Operating characteristic curves

The operating characteristic curve for a sampling plan shows the fraction of lots that may be expected to be accepted by the sampling plan as a function of the process quality level.

When the method described in 2.3.2 and 2.4.1 has been used to determine the sampling plan, the probability of acceptance P_a will be approximately equal to $1 - \alpha$ when the process quality level is PRQ and approximately equal to the consumer's risk β when the process quality level is CRQ. (For the validity of the approximations see 3.6.)

Annex C provides a method for determining the intermediate points on the OC curve.

3.5.2 Average sample size

The average sample size is the average of the various sample sizes which may occur under a sam-

pling plan for a given level of the process quality. Annex C gives a method for determining approximate values of the average sample size.

3.6 Validity of approximations

The procedure described in annex B was also used to calculate the plans in tables 1-A and 1-B. The procedure has the advantage that it is simple to apply and gives reasonably accurate results.

- a) Although the actual producer's and consumer's risks associated with a plan determined by this procedure may be fairly different from the nominal risks α and β , it can be stated that the sum of the actual risks will not be greater than the sum $\alpha + \beta$ of the nominal risks. This defect is not specific to sequential inspection. In all types of attribute sampling plans specified by the producer's and the consumer's risk points, the discrete nature of items and of the definition of nonconformance imply that only in exceptional cases will the actual risk of the sampling plan coincide with the nominal risk.
- b) The approximation to the average sample size given in annex C tends to underestimate the average sample size of the plan, the discrepancy between the actual average sample size and the calculated approximation being most pronounced for small values of the approximate average sample size. This is true even if the sampling plan has been curtailed.

**Table 1-A — Sequential sampling plans for inspection for percent nonconforming
for producer's risk $\alpha = 0,05$ and consumer's risk $\beta = 0,10$**

PRQ and CRQ levels in percent nonconforming

PRQ	Par- ameters	Consumer's risk quality level CRQ																
		0.80	1.00	1.25	1.60	2.00	2.50	3.15	4.00	5.00	6.30	8.00	10.00	12.50	16.00	20.00	25.00	31.50
0.100	h_A	1.079	0.974	0.887	0.808	0.747	0.694	0.647	0.604	0.568	0.535	0.504	0.478	0.454	0.429	0.408	0.388	0.367
	h_R	1.385	1.250	1.139	1.037	0.959	0.891	0.830	0.775	0.729	0.687	0.647	0.614	0.583	0.551	0.524	0.498	0.472
	g	0.00337	0.00391	0.00456	0.00543	0.00637	0.00750	0.00891	0.0107	0.0127	0.0152	0.0185	0.0222	0.0267	0.0330	0.0402	0.0494	0.0616
0.125	h_A	1.208	1.078	0.973	0.878	0.806	0.746	0.691	0.642	0.602	0.565	0.531	0.502	0.475	0.448	0.425	0.403	0.381
	h_R	1.551	1.384	1.249	1.127	1.035	0.957	0.887	0.825	0.773	0.726	0.682	0.644	0.610	0.575	0.546	0.518	0.489
	g	0.00364	0.00421	0.00490	0.00580	0.00679	0.00797	0.00944	0.0113	0.0134	0.0160	0.0194	0.0232	0.0279	0.0344	0.0419	0.0513	0.0638
0.160	h_A	1.393	1.223	1.089	0.972	0.885	0.812	0.748	0.691	0.645	0.602	0.564	0.531	0.501	0.471	0.446	0.422	0.398
	h_R	1.789	1.570	1.399	1.247	1.136	1.042	0.960	0.887	0.828	0.774	0.724	0.682	0.644	0.605	0.572	0.542	0.511
	g	0.00398	0.00459	0.00531	0.00627	0.00731	0.00855	0.0101	0.0120	0.0142	0.0170	0.0205	0.0245	0.0294	0.0362	0.0439	0.0536	0.0666
0.200	h_A	1.617	1.392	1.221	1.075	0.970	0.883	0.808	0.742	0.689	0.641	0.597	0.561	0.528	0.494	0.466	0.440	0.414
	h_R	2.076	1.787	1.568	1.381	1.245	1.134	1.037	0.952	0.884	0.823	0.767	0.720	0.677	0.635	0.599	0.565	0.532
	g	0.00433	0.00498	0.00574	0.00675	0.00784	0.00915	0.0108	0.0128	0.0151	0.0180	0.0216	0.0257	0.0308	0.0378	0.0458	0.0559	0.0692
0.250	h_A	1.926	1.615	1.390	1.204	1.074	0.968	0.878	0.801	0.739	0.684	0.635	0.594	0.557	0.520	0.489	0.460	0.432
	h_R	2.473	2.074	1.785	1.546	1.378	1.243	1.128	1.028	0.949	0.879	0.815	0.762	0.715	0.667	0.628	0.591	0.555
	g	0.00473	0.00541	0.00622	0.00729	0.00844	0.00981	0.0115	0.0136	0.0160	0.0190	0.0228	0.0271	0.0324	0.0397	0.0479	0.0583	0.0721
0.315	h_A	2.403	1.937	1.622	1.374	1.207	1.075	0.966	0.873	0.800	0.736	0.679	0.632	0.591	0.549	0.515	0.483	0.452
	h_R	3.085	2.487	2.083	1.764	1.549	1.381	1.230	1.121	1.028	0.945	0.872	0.812	0.758	0.705	0.661	0.620	0.580
	g	0.00521	0.00593	0.00679	0.00792	0.00914	0.0106	0.0124	0.0146	0.0171	0.0202	0.0242	0.0287	0.0342	0.0418	0.0503	0.0611	0.0753
0.40	h_A	3.229	2.441	1.961	1.610	1.385	1.214	1.076	0.962	0.875	0.799	0.732	0.678	0.630	0.583	0.545	0.509	0.475
	h_R	4.146	3.134	2.518	2.067	1.778	1.559	1.382	1.236	1.123	1.026	0.940	0.871	0.809	0.749	0.700	0.654	0.610
	g	0.00577	0.00655	0.00747	0.00867	0.00996	0.0115	0.0134	0.0157	0.0184	0.0217	0.0258	0.0305	0.0363	0.0441	0.0530	0.0642	0.0790
0.50	h_A	4.759	3.224	2.437	1.917	1.606	1.381	1.205	1.064	0.958	0.868	0.790	0.727	0.673	0.619	0.576	0.537	0.498
	h_R	6.110	4.140	3.129	2.461	2.062	1.774	1.548	1.366	1.231	1.114	1.014	0.934	0.863	0.795	0.740	0.689	0.640
	g	0.00638	0.00722	0.00819	0.00947	0.0108	0.0125	0.0145	0.0169	0.0197	0.0232	0.0275	0.0324	0.0384	0.0466	0.0558	0.0674	0.0827
0.63	h_A	9.357	4.834	3.256	2.390	1.926	1.611	1.377	1.196	1.064	0.953	0.860	0.786	0.723	0.662	0.613	0.568	0.526
	h_R	12.013	6.206	4.180	3.069	2.472	2.069	1.768	1.535	1.366	1.224	1.104	1.009	0.928	0.849	0.787	0.729	0.675
	g	0.00712	0.00801	0.00905	0.0104	0.0119	0.0136	0.0157	0.0183	0.0212	0.0249	0.0294	0.0346	0.0408	0.0494	0.0590	0.0710	0.0868
0.80	h_A	9.999	4.994	3.210	2.425	1.946	1.614	1.371	1.200	1.062	0.947	0.858	0.783	0.712	0.656	0.605	0.557	0.517
	h_R	12.837	6.411	4.122	3.113	2.499	2.073	1.760	1.541	1.363	1.231	1.125	1.027	0.943	0.862	0.795	0.737	0.687
	g	0.00896	0.01011	0.0115	0.0131	0.0149	0.0172	0.0200	0.0231	0.0269	0.0317	0.0371	0.0437	0.0526	0.0646	0.0791	0.0916	0.1091
1.00	h_A	9.976	4.729	3.201	2.417	1.925	1.589	1.364	1.200	1.062	0.947	0.858	0.783	0.712	0.656	0.605	0.557	0.517
	h_R	12.808	6.071	4.110	3.103	2.472	2.040	1.751	1.525	1.343	1.215	1.104	1.009	0.928	0.849	0.787	0.729	0.675
	g	0.0112	0.0128	0.0144	0.0164	0.0188	0.0217	0.0250	0.0290	0.0341	0.0397	0.0466	0.0559	0.0664	0.0794	0.0965	0.1176	0.1437

Table 1-A — (concluded)

Table 1-A — (concluded)																		
PRQ and CRQ levels in percent nonconforming																		
PRQ	Par- ameters	Consumer's risk quality level CRQ																
		0,80	1,00	1,25	1,60	2,00	2,50	3,15	4,00	5,00	6,30	8,00	10,00	12,50	16,00	20,00	25,00	31,50
1,25	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				8,990 11,543 0,0142	4,713 6,052 0,0160	3,189 4,095 0,0180	2,386 3,063 0,0206	1,890 2,426 0,0237	1,580 2,028 0,0272	1,348 1,731 0,0314	1,168 1,500 0,0367	1,036 1,331 0,0427	0,929 1,193 0,0499	0,830 1,066 0,0597	0,755 0,969 0,0706	0,688 0,884 0,0841	0,627 0,805 0,1018
1,60	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				9,908 12,721 0,0179	4,943 6,346 0,0202	3,247 4,169 0,0229	2,392 3,072 0,0262	1,917 2,461 0,0299	1,586 2,036 0,0345	1,343 1,724 0,0401	1,171 1,504 0,0464	1,036 1,330 0,0540	0,915 1,175 0,0643	0,824 1,058 0,0758	0,745 0,957 0,0899	0,674 0,865 0,1084	
2,00	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				9,863 12,663 0,0224	4,830 6,202 0,0253	3,154 4,049 0,0289	2,376 3,051 0,0328	1,888 2,424 0,0376	1,553 1,994 0,0436	1,329 1,706 0,0503	1,157 1,485 0,0582	1,008 1,294 0,0690	0,899 1,154 0,0810	0,806 1,035 0,0958	0,723 0,928 0,1150		
2,50	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				9,467 12,155 0,0281	4,637 5,953 0,0319	3,131 4,019 0,0361	2,335 2,998 0,0412	1,843 2,367 0,0475	1,535 1,971 0,0546	1,311 1,683 0,0630	1,123 1,441 0,0743	0,989 1,269 0,0869	0,878 1,127 0,1023	0,780 1,001 0,1223			
3,15	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				9,089 11,669 0,0356	4,677 6,005 0,0401	3,100 3,980 0,0455	2,289 2,939 0,0522	1,832 2,353 0,0597	1,521 1,953 0,0686	1,274 1,635 0,0805	1,104 1,417 0,0937	0,967 1,242 0,1099	0,850 1,091 0,1307				
4,00	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				9,637 12,372 0,0448	4,705 6,040 0,0507	3,060 3,929 0,0578	2,295 2,947 0,0658	1,827 2,346 0,0752	1,481 1,902 0,0879	1,256 1,613 0,1018	1,083 1,390 0,1187	0,938 1,204 0,1406					
5,00	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				9,193 11,803 0,0563	4,484 5,757 0,0639	3,013 3,868 0,0724	2,255 2,895 0,0824	1,750 2,247 0,0957	1,445 1,855 0,1103	1,220 1,566 0,1281	1,039 1,333 0,1509						
6,30	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				8,753 11,238 0,0712	4,482 5,754 0,0802	2,987 3,835 0,0908	2,162 2,776 0,1049	1,714 2,201 0,1204	1,406 1,805 0,1390	1,171 1,503 0,1629							
8,0	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				9,184 11,792 0,0897	4,535 5,822 0,1010	2,871 3,686 0,1160	2,132 2,737 0,1323	1,875 2,151 0,1520	1,675 1,935 0,1771								
10,0	$\frac{h_A}{h_R}$ $\frac{h_R}{g}$				8,958 11,501 0,1121	4,177 5,363 0,1280	2,776 3,564 0,1452	2,049 2,631 0,1660	1,585 2,035 0,1922									

Table 1-B — Sequential sampling plans for inspection for nonconformities per 100 items
for producer's risk $\alpha = 0,05$ and consumer's risk $\beta = 0,10$

PRQ and CRQ levels in nonconformities per 100 items

PRQ	Par- ameters	Consumer's risk quality level CRQ																
		0,80	1,00	1,25	1,60	2,00	2,50	3,15	4,00	5,00	6,30	8,00	10,00	12,50	16,00	20,00	25,00	31,50
0,100	h_A	1,083	0,978	0,891	0,812	0,751	0,699	0,653	0,610	0,575	0,543	0,514	0,489	0,466	0,444	0,425	0,408	0,391
	h_R	1,390	1,255	1,144	1,042	0,965	0,898	0,838	0,784	0,739	0,698	0,660	0,628	0,599	0,570	0,546	0,523	0,502
0,125	h_A	0,00337	0,00391	0,00455	0,00541	0,00634	0,00746	0,00884	0,0106	0,0125	0,0150	0,0180	0,0215	0,0257	0,0313	0,0376	0,0451	0,0546
	h_R	1,213	1,083	0,978	0,883	0,812	0,751	0,698	0,650	0,610	0,574	0,541	0,514	0,489	0,464	0,444	0,425	0,407
0,160	h_A	1,557	1,390	1,255	1,134	1,042	0,965	0,896	0,834	0,784	0,737	0,695	0,660	0,628	0,596	0,570	0,546	0,523
	h_R	0,00364	0,00421	0,00489	0,00579	0,00676	0,00793	0,00937	0,0112	0,0132	0,0158	0,0189	0,0225	0,0269	0,0327	0,0392	0,0469	0,0567
0,200	h_A	1,399	1,228	1,095	0,978	0,891	0,819	0,755	0,699	0,654	0,613	0,575	0,544	0,517	0,489	0,466	0,446	0,426
	h_R	1,796	1,577	1,406	1,255	1,144	1,051	0,970	0,898	0,840	0,787	0,739	0,699	0,663	0,628	0,599	0,572	0,547
0,250	h_A	0,00398	0,00458	0,00530	0,00625	0,00729	0,00851	0,0100	0,0119	0,0141	0,0167	0,0200	0,0238	0,0283	0,0344	0,0411	0,0492	0,0593
	h_R	1,624	1,399	1,228	1,083	0,978	0,891	0,817	0,751	0,699	0,653	0,610	0,575	0,544	0,514	0,489	0,466	0,445
0,315	h_A	2,085	1,796	1,577	1,390	1,255	1,144	1,048	0,965	0,898	0,838	0,784	0,739	0,699	0,660	0,628	0,599	0,571
	h_R	0,00433	0,00497	0,00573	0,00673	0,00782	0,00911	0,0107	0,0127	0,0149	0,0177	0,0211	0,0251	0,0297	0,0361	0,0430	0,0514	0,0619
0,40	h_A	1,936	1,624	1,399	1,213	1,083	0,978	0,889	0,812	0,751	0,698	0,650	0,610	0,575	0,541	0,514	0,489	0,466
	h_R	2,485	2,085	1,796	1,557	1,390	1,255	1,141	1,042	0,965	0,896	0,834	0,784	0,739	0,695	0,660	0,628	0,598
0,50	h_A	0,00473	0,00541	0,00621	0,00727	0,00842	0,00977	0,0114	0,0135	0,0159	0,0187	0,0224	0,0264	0,0313	0,0379	0,0451	0,0537	0,0646
	h_R	2,415	1,949	1,633	1,385	1,218	1,087	0,978	0,886	0,814	0,751	0,696	0,651	0,612	0,573	0,542	0,515	0,489
0,63	h_A	3,101	2,502	2,097	1,778	1,564	1,395	1,255	1,137	1,045	0,965	0,894	0,836	0,785	0,736	0,696	0,661	0,628
	h_R	0,00520	0,00593	0,00678	0,00791	0,00912	0,0105	0,0123	0,0145	0,0169	0,0200	0,0238	0,0280	0,0331	0,0399	0,0474	0,0564	0,0677
0,80	h_A	3,248	2,457	1,976	1,624	1,399	1,228	1,091	0,978	0,891	0,817	0,751	0,699	0,654	0,610	0,575	0,544	0,516
	h_R	4,170	3,154	2,537	2,085	1,796	1,577	1,401	1,255	1,144	1,048	0,965	0,898	0,840	0,784	0,739	0,699	0,662
1,00	h_A	0,00577	0,00655	0,00746	0,00866	0,00994	0,0115	0,0133	0,0156	0,0182	0,0214	0,0254	0,0298	0,0352	0,0423	0,0501	0,0595	0,0712
	h_R	4,790	3,248	2,457	1,936	1,624	1,399	1,223	1,083	0,978	0,889	0,812	0,751	0,699	0,650	0,610	0,575	0,543
0,80	h_A	6,150	4,170	3,154	2,485	2,085	1,796	1,570	1,390	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
	h_R	0,00638	0,00721	0,00819	0,00946	0,0108	0,0124	0,0144	0,0168	0,0195	0,0229	0,0271	0,0317	0,0373	0,0447	0,0529	0,0626	0,0748
0,63	h_A	9,424	4,873	3,286	2,415	1,949	1,633	1,399	1,218	1,087	0,978	0,886	0,814	0,754	0,696	0,651	0,612	0,575
	h_R	12,099	8,256	4,218	3,101	2,502	2,097	1,796	1,564	1,395	1,255	1,137	1,045	0,967	0,894	0,836	0,785	0,739
0,40	h_A	0,00712	0,00801	0,00905	0,0104	0,0119	0,0136	0,0157	0,0182	0,0211	0,0246	0,0290	0,0339	0,0397	0,0475	0,0560	0,0662	0,0789
	h_R	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,228	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
0,250	h_A	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
	h_R	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
1,00	h_A	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
	h_R	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
0,080	h_A	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
	h_R	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
0,063	h_A	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
	h_R	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
0,040	h_A	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
	h_R	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
0,0250	h_A	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
	h_R	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
0,0160	h_A	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
	h_R	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
0,0100	h_A	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
	h_R	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
0,0080	h_A	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
	h_R	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
0,0063	h_A	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
	h_R	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
0,0040	h_A	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
	h_R	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
0,00250	h_A	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
	h_R	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399	1,223	1,091	0,978	0,891	0,819	0,751	0,699	0,654	0,613
0,00160	h_A	12,953	6,476	3,154	2,457	2,085	1,796	1,577	1,399	1,255	1,141	1,042	0,965	0,898	0,834	0,784	0,739	0,698
	h_R	0,00896	0,0101	0,0115	0,0131	0,0149	0,0171	0,0199	0,0229	0,0267	0,0313	0,0364	0,0426	0,0507	0,0596	0,0703	0,0836	0,0983
0,00100	h_A	10,089	5,044	3,044	2,457	2,085	1,796	1,577	1,399									

Table 1-B — (concluded)

PRQ	Par- ameters	Consumer's risk quality level CRQ												PRQ and CRQ levels in nonconformities per 100 items				
		0,80	1,00	1,25	1,60	2,00	2,50	3,15	4,00	5,00	6,30	8,00	10,00	12,50	16,00	20,00	25,00	31,50
1,25	h_A h_R g				9,120 11,709 0,014 2	4,790 6,150 0,016 0	3,248 4,170 0,018 0	2,436 3,127 0,020 6	1,936 2,485 0,023 6	1,624 2,085 0,027 1	1,392 1,787 0,031 2	1,213 1,557 0,036 4	1,083 1,390 0,042 1	0,978 1,255 0,048 9	0,883 1,134 0,057 9	0,812 1,042 0,067 6	0,751 0,965 0,079 3	0,698 0,886 0,093 7
1,60	h_A h_R g					10,089 12,953 0,017 9	5,044 6,476 0,020 2	3,323 4,267 0,022 9	2,457 3,154 0,026 2	1,976 2,537 0,029 8	1,643 2,109 0,034 3	1,399 1,796 0,039 8	1,228 1,577 0,045 8	1,095 1,406 0,053 0	0,978 1,255 0,062 5	0,891 1,144 0,072 9	0,819 1,051 0,085 1	0,755 0,970 0,100 3
2,00	h_A h_R g						10,089 12,953 0,022 4	4,956 6,363 0,025 3	3,248 4,170 0,028 9	2,457 3,154 0,032 7	1,962 2,519 0,037 5	1,624 2,085 0,043 3	1,399 1,796 0,049 7	1,228 1,577 0,057 3	1,083 1,390 0,067 3	0,978 1,255 0,078 2	0,891 1,144 0,091 1	0,817 1,048 0,107 0
2,50	h_A h_R g							9,741 12,506 0,028 1	4,790 6,150 0,031 9	3,248 4,170 0,036 1	2,436 3,127 0,041 1	1,936 2,485 0,047 3	1,624 2,085 0,054 1	1,399 1,796 0,062 1	1,213 1,557 0,072 7	1,083 1,390 0,084 2	0,978 1,255 0,097 7	0,889 1,141 0,114 5
3,15	h_A h_R g								9,424 12,099 0,035 6	4,873 6,256 0,040 0	3,248 4,170 0,045 4	2,415 3,101 0,052 0	1,949 2,502 0,059 3	1,633 2,097 0,067 8	1,385 1,778 0,079 1	1,218 1,564 0,091 2	1,087 1,395 0,105 5	0,978 1,255 0,123 1
4,00	h_A h_R g									10,089 12,953 0,044 8	4,956 6,363 0,050 6	3,248 4,170 0,057 7	2,457 3,154 0,065 5	1,976 2,537 0,074 6	1,624 2,085 0,086 6	1,399 1,796 0,099 4	1,228 1,577 0,114 6	1,091 1,401 0,133 3
5,00	h_A h_R g										9,741 12,506 0,056 2	4,790 6,150 0,063 8	3,248 4,170 0,072 1	2,457 3,154 0,081 9	1,936 2,485 0,094 6	1,624 2,085 0,108 2	1,399 1,796 0,124 3	1,223 1,570 0,144 0
6,30	h_A h_R g											9,424 12,099 0,071 2	4,873 6,256 0,080 1	3,286 4,218 0,090 5	2,415 3,101 0,104 1	1,949 2,502 0,118 6	1,633 2,097 0,135 7	1,399 1,796 0,156 6
8,0	h_A h_R g												10,089 12,953 0,089 6	5,044 6,476 0,100 8	3,248 4,170 0,115 4	2,457 3,154 0,131 0	1,976 2,537 0,149 2	1,643 2,109 0,171 5
10,0	h_A h_R g													10,089 12,953 0,112 0	4,790 6,150 0,127 7	3,248 4,170 0,144 3	2,457 3,154 0,163 7	1,962 2,519 0,187 4

Annex A (normative)

Sequential sampling plans corresponding to ISO 2859-1 sampling plans

A.1 Introduction

This annex contains sequential sampling plans that supplement the system of sampling plans given in ISO 2859-1. In ISO 2859-1, three types of sampling plans — single, double and multiple — are given in tables II, III and IV. This annex gives in tables 2-A to 2-D a fourth type of sampling plan, sequential sampling plans, indexed by the same values of AQL and the same sample size code letters as in ISO 2859-1.

A.2 Relation to ISO 2859-1

When the sampling plans in this annex are used to supplement the system of sampling plans in ISO 2859-1, all rules in ISO 2859-1 shall apply, the only exception being that the acceptance criteria in clause 11 of ISO 2859-1:1989 shall be replaced by the acceptance criteria for sequential sampling in A.5 of this International Standard.

A.3 Choice between single, double, multiple and sequential sampling plans

See 2.1.

A.4 Obtaining a sampling plan

The AQL and the sample size code letter shall be used to obtain a plan from tables 2-A to 2-D.

Plans for percent nonconforming inspection are given in table 2-A (normal inspection) and table 2-B (tightened inspection). Plans for nonconformities per 100 items inspection are given in table 2-C (normal inspection) and table 2-D (tightened inspection).

The tables give the parameters h_A , h_R and g of the sequential sampling plan (see 2.4.1). Tables 3-A to 3-D give the curtailment value n_t of the sample size and the corresponding acceptance number A_1 for the sequential sampling plans in this annex.

When no sampling plan is available for a given combination of AQL and sample size code letter, arrows in the table direct the user to a different code letter.

For some combinations of AQL and sample size code letter, the entry in the table is a star (*) indicating that the corresponding single sampling plan

has acceptance number zero for this combination of code letter and AQL. In such a case the sequential sampling plan is identical with the single sampling plan with curtailment, and the user is advised to use the simpler single sampling plan in place of the more complicated sequential plan. Then the curtailment rule for these plans is that inspection shall be terminated and the lot considered not acceptable if, and as soon as, one nonconforming item is found.

A.5 Determination of acceptability

To determine the acceptability of a lot, the applicable sampling plan shall be used in accordance with 3.1, 3.2, 3.3 and 3.4.

A.6 Switching rules

When the sequential sampling plans in this annex are substituted for plans in ISO 2859-1, the switching rules given in clause 9 of ISO 2859-1:1989 shall apply with the only exception that reduced inspection is not possible with the sequential sampling plans given in this annex.

A.7 Supplementary information

A.7.1 Operating characteristic curves

The sampling plans in this annex have been determined such that their operating characteristic (OC) curves match as closely as practicable the OC curves of the corresponding single sampling plans in ISO 2859-1. The curves and tables in table X of ISO 2859-1:1989 may therefore be used to determine the OC curves for the plans in this annex.

A.7.2 Average sample size

Values of the average sample size for the sequential sampling plans are given in tables 4-A to 4-D.

For each sampling plan, table 4 gives the exact value of the average sample size corresponding to four levels of process quality. The four levels of process quality that have been chosen to illustrate the average sample size are

- a) zero, corresponding to perfect production with all items conforming to specifications;

- b) p_A , the process quality level that would lead to 90 % of the lots being accepted by the sampling plan;
- c) p_R , the process quality level that would lead to 10 % of the lots being accepted by the sampling plan; and
- d) g , virtually the worst possible case, corresponding to an average proportion nonconforming (nonconformities per item) in the process which is equal to the parameter g of the sampling plan. (In terms of percent nonconforming or nonconformities per 100 items, the process quality level is $100g$.)

The values of p_A and p_R for the individual sampling plans are given in percent nonconforming or

nonconformities per 100 items in table X of ISO 2859-1:1989.

Under percent nonconforming inspection, the average sample size corresponding to an extreme process quality level with all items nonconforming may be found by rounding $h_R/(1 - g)$ up to the nearest integer.

Under nonconformities per 100 items inspection, the average sample size corresponding to the hypothetical process quality level with infinitely many nonconformities per 100 items is always 1.

Values of the average sample size corresponding to process quality levels that are not tabulated may be found by interpolation between the tabulated values for the sampling plan.

STANDARDSISO.COM : Click to view the full PDF of ISO 8422:1991

Table 2-A — Sequential sampling plans for normal inspection for percent nonconforming (master table)

Code letter	Par- ameters	Acceptable quality level in percent nonconforming (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
D	$\frac{h_A}{h_R}$ $\frac{g}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	*	↑	↑	0,824 0,798 0,202 1	1,000 0,786 0,321 4
E	$\frac{h_A}{h_R}$ $\frac{g}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	*	↑	↑	1,011 0,753 0,126 4	1,205 0,808 0,200 9	1,244 1,173 0,275 7
F	$\frac{h_A}{h_R}$ $\frac{g}{g}$	↑	↑	↑	↑	*	↑	↑	↑	↑	↑	↑	↑	0,998 0,829 0,082 9	1,244 0,946 0,131 8	1,446 1,205 0,180 7	1,651 1,465 0,279 0
G	$\frac{h_A}{h_R}$ $\frac{g}{g}$	↑	↑	↑	↑	↑	↑	↑	*	↑	↑	↑	1,043 0,802 0,052 1	1,258 1,002 0,083 0	1,500 1,227 0,113 6	1,769 1,571 0,175 9	1,917 1,801 0,237 2
H	$\frac{h_A}{h_R}$ $\frac{g}{g}$	↑	↑	↑	↑	↑	↑	*	↑	↑	1,060 0,826 0,033 5	1,335 0,985 0,053 3	1,561 1,268 0,073 2	1,838 1,619 0,112 8	2,114 1,872 0,152 2	2,390 2,195 0,211 9	
J	$\frac{h_A}{h_R}$ $\frac{g}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	1,080 0,824 0,021 0	1,367 1,000 0,033 3	1,570 1,271 0,045 8	1,910 1,650 0,070 6	2,238 1,952 0,095 2	2,531 2,297 0,132 8	2,865 2,683 0,182 7	
K	$\frac{h_A}{h_R}$ $\frac{g}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	1,085 0,824 0,013 6	1,359 0,980 0,021 5	1,575 1,262 0,029 6	1,919 1,631 0,045 6	2,198 1,894 0,061 7	2,514 2,259 0,085 7	2,840 2,585 0,117 9	3,227 3,000 0,174 1
* Use corresponding curtailed single sampling plan in ISO 2859-1 with Ac = 0.																	

Table 2-A (concluded)

Acceptable quality level in percent nonconforming (normal inspection)																	
Code letter	Par- ameters	Acceptable quality level in percent nonconforming (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
L	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
M	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
N	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
P	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
Q	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
R	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑

* Use corresponding curtailed single sampling plan in ISO 2859-1 with Ac = 0.

* Use corresponding curtailed single sampling plan in ISO 2859-1 with Ac = 0.

Table 2-B — Sequential sampling plans for tightened inspection for percent nonconforming (master table)

Code letter	Parameters	Acceptable quality level in percent nonconforming (tightened inspection)										
		0,010	0,015	0,025	0,040	0,065	0,10	0,15	0,25	0,40	0,65	1,0
D	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
E	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
F	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
G	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
H	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
J	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
K	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→
	$\frac{h_A}{h_R} \frac{g}{g}$	→	→	→	→	→	→	→	→	→	→	→

* Use corresponding curtailed single sampling plan in ISO 2859-1 with $A_c = 0$.

Table 2-B (concluded)																	
Code letter	Par- ameters	Acceptable quality level in percent nonconforming (tightened 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
L	$\frac{h_A}{h_R}$ $\frac{h}{g}$	↑	↑	↑	↑	↑	*	↑	↑	↑	1,093 0,822 0,008 48	1,372 0,987 0,013 4	1,600 1,282 0,018 4	1,965 1,661 0,028 5	2,395 2,085 0,043 5	2,815 2,535 0,063 5	3,313 3,031 0,083 7
M	$\frac{h_A}{h_R}$ $\frac{h}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	1,093 0,828 0,005 34	1,377 0,991 0,008 52	1,612 1,289 0,011 7	1,992 1,679 0,018 0	2,425 2,114 0,027 6	2,908 2,602 0,040 3	3,453 3,159 0,050 4
N	$\frac{h_A}{h_R}$ $\frac{h}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	1,390 0,995 0,005 35	1,618 1,297 0,007 37	2,002 1,682 0,011 4	2,477 2,157 0,017 4	2,950 2,639 0,025 4	3,537 3,229 0,037 3	↑
P	$\frac{h_A}{h_R}$ $\frac{h}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	1,628 1,303 0,004 60	2,017 1,695 0,007 10	2,494 2,171 0,010 8	2,993 2,671 0,015 8	3,618 3,298 0,023 3	↑	↑
Q	$\frac{h_A}{h_R}$ $\frac{h}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	2,024 1,700 0,004 54	3,021 2,694 0,010 1	3,621 3,300 0,014 9	↑	↑	↑	↑
R	$\frac{h_A}{h_R}$ $\frac{h}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	2,510 2,182 0,004 34	3,657 3,326 0,009 35	↑	↑	↑	↑	↑
S	$\frac{h_A}{h_R}$ $\frac{h}{g}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	1,103 0,832 0,000 536	↑	↑	↑	↑	↑	↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

↑

* Use corresponding curtailed single sampling plan in ISO 2859-1 with Ac = 0.

Table 2-C — Sequential sampling plans for normal inspection for nonconformities per 100 items (master table)

Table 2-C — Sequential sampling plans for normal inspection for nonconformities per 100 items (master table)																				
Code letter	Par- ameters	Acceptable quality level in nonconformities per 100 items (normal inspection)																		
		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
D	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																			
E	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																			
F	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																			
G	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																			
H	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																			
J	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																			
K	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																			
* Use corresponding curtailed single sampling plan in ISO 2859-1 with Ac = 0.																				

* Use corresponding curtailed single sampling plan in ISO 2859-1 with Ac = 0.

Table 2-C (concluded)

Table 2-C (concluded)																	
Code letter	Par- ameters	Acceptable quality level in nonconformities per 100 items (normal inspection)															
		0,010	0,015	0,025	0,040	0,65	1,0	1,5	2,5	4,0	6,5	10					
L	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																
M	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																
N	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																
P	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																
Q	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																
R	$\frac{h_A}{h_R}$	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
	$\frac{h_R}{g}$																
* Use corresponding curtailed single sample plan in ISO 2859-1 with Ac = 0.																	

* Use corresponding curtailed single sample plan in ISO 2859-1 with Ac = 0.

Table 2-D — Sequential sampling plans for tightened inspection for nonconformities per 100 items (master table)

Table 2-D — Sequential sampling plans for tightened inspection per 100 items (master table)																			
Code letter	Par- ameters	Acceptable quality level in nonconformities per 100 items (tightened inspection)																	
		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
D	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.049	1.167	1.292	1.822	2.203	2.541	3.167	3.591
	0.782											0.833	1.095	1.435	1.791	2.291	2.833	3.227	4.100
E	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.2109	0.3351	0.4594	0.7094	1.082	1.582	2.332	3.456
	0.366											0.566	0.926	1.185	1.577	2.267	3.563	4.500	5.206
F	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.279	1.510	1.885	2.167	2.696	3.239	3.813	4.700
	0.824											0.956	1.297	1.833	2.267	2.891	3.563	4.500	5.206
G	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.2060	0.2827	0.4359	0.6672	0.9754	1.433	2.128	3.203
	1.351											1.561	1.929	2.350	2.763	3.367	4.100	5.206	6.100
H	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.077	1.255	1.643	2.017	2.500	3.100	3.813	4.700
	0.811											0.963	1.255	1.643	2.017	2.500	3.100	3.813	4.700
I	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0845	0.1839	0.2840	0.4339	0.6332	0.9346	1.433	2.128
	1.375											1.596	1.967	2.419	2.803	3.458	4.100	5.206	6.100
J	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.367	1.611	2.036	2.473	2.974	3.563	4.100	5.206
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
K	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0528	0.1149	0.1773	0.2711	0.3959	0.5834	0.9346	1.433
	1.079											1.375	1.596	1.967	2.419	2.803	3.458	4.100	5.206
L	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.084	1.383	1.623	2.036	2.473	2.974	3.563	4.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
M	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0337	0.0534	0.0737	0.1136	0.1737	0.2536	0.3731	0.5834
	1.367											1.611	2.036	2.473	2.974	3.563	4.100	5.206	6.100
N	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.623	1.974	2.473	2.974	3.563	4.100	5.206	6.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
O	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834	0.9346
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
P	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.383	1.623	1.974	2.473	2.974	3.563	4.100	5.206
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
Q	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0335	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
R	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.084	1.383	1.623	2.036	2.473	2.974	3.563	4.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
S	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0534	0.0737	0.1136	0.1737	0.2536	0.3731	0.5834	0.9346
	1.367											1.611	2.036	2.473	2.974	3.563	4.100	5.206	6.100
T	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.623	1.974	2.473	2.974	3.563	4.100	5.206	6.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
U	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834	0.9346
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
V	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.383	1.623	1.974	2.473	2.974	3.563	4.100	5.206
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
W	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0335	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
X	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.084	1.383	1.623	2.036	2.473	2.974	3.563	4.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
Y	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0534	0.0737	0.1136	0.1737	0.2536	0.3731	0.5834	0.9346
	1.367											1.611	2.036	2.473	2.974	3.563	4.100	5.206	6.100
Z	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.623	1.974	2.473	2.974	3.563	4.100	5.206	6.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AA	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834	0.9346
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
AB	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.383	1.623	1.974	2.473	2.974	3.563	4.100	5.206
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AC	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0335	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
AD	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.084	1.383	1.623	2.036	2.473	2.974	3.563	4.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AE	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0534	0.0737	0.1136	0.1737	0.2536	0.3731	0.5834	0.9346
	1.367											1.611	2.036	2.473	2.974	3.563	4.100	5.206	6.100
AF	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.623	1.974	2.473	2.974	3.563	4.100	5.206	6.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AG	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834	0.9346
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
AH	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.383	1.623	1.974	2.473	2.974	3.563	4.100	5.206
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AI	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0335	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
AJ	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.084	1.383	1.623	2.036	2.473	2.974	3.563	4.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AK	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0534	0.0737	0.1136	0.1737	0.2536	0.3731	0.5834	0.9346
	1.367											1.611	2.036	2.473	2.974	3.563	4.100	5.206	6.100
AL	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.623	1.974	2.473	2.974	3.563	4.100	5.206	6.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AM	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834	0.9346
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
AN	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.383	1.623	1.974	2.473	2.974	3.563	4.100	5.206
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AO	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0335	0.0459	0.0709	0.1082	0.1582	0.2332	0.3731	0.5834
	1.623											1.974	2.473	2.974	3.563	4.100	5.206	6.100	7.100
AP	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.084	1.383	1.623	2.036	2.473	2.974	3.563	4.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	4.700
AQ	h_R	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	0.0534	0.0737	0.1136	0.1737	0.2536	0.3731	0.5834	0.9346
	1.367											1.611	2.036	2.473	2.974	3.563	4.100	5.206	6.100
AR	h_A	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑	1.623	1.974	2.473	2.974	3.563	4.100	5.206	6.100
	0.826											0.960	1.278	1.648	2.152	2.625	3.198	3.813	

* Use corresponding curtailed single sample plan in ISO 2859-1 with $A_c = 0$.

Table 2-D (concluded)																	
		Acceptable quality level in nonconformities per 100 items (tightened inspection)															
Code letter	Par- ameters	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
L	$\bar{h}_A$	↑	↑	↑	↑	↑	*	↑	↑	1,097 0,826 0,008 45	1,380 0,993 0,013 4	1,657 1,305 0,018 4	2,071 1,700 0,028 4	2,543 2,196 0,043 4	2,906 2,781 0,063 3	3,703 3,297 0,093 5	↑
	$\bar{h}_R$																
M	$\bar{h}_A$	↑	↑	↑	↑	↑	↑	↑	1,098 0,823 0,005 34	1,377 0,991 0,008 52	1,592 1,259 0,011 5	2,009 1,723 0,018 0	2,569 2,153 0,027 5	2,980 2,740 0,040 3	3,618 3,441 0,059 3	↑	↑
	$\bar{h}_R$																
N	$\bar{h}_A$	↑	↑	↑	↑	↑	↑	↑	1,099 0,833 0,003 37	1,629 1,313 0,007 37	2,017 1,699 0,011 4	2,474 2,233 0,017 4	3,116 2,654 0,025 4	3,611 3,426 0,037 3	↑	↑	↑
	$\bar{h}_R$																
P	$\bar{h}_A$	↑	↑	↑	↑	↑	↑	↑	1,398 0,998 0,003 35	2,032 1,706 0,007 09	2,549 2,179 0,010 8	3,071 2,690 0,015 8	3,686 3,407 0,023 3	↑	↑	↑	↑
	$\bar{h}_R$																
Q	$\bar{h}_A$	↑	↑	↑	↑	↑	↑	↑	2,039 1,702 0,004 54	2,524 2,191 0,006 94	3,035 2,742 0,010 1	3,694 3,336 0,014 9	↑	↑	↑	↑	↑
	$\bar{h}_R$																
R	$\bar{h}_A$	↑	↑	↑	↑	↑	↑	↑	2,533 2,185 0,004 34	3,041 2,718 0,006 33	3,696 3,360 0,009 35	↑	↑	↑	↑	↑	↑
	$\bar{h}_R$																
S	$\bar{h}_A$	↑	↑	↑	↑	↑	↑	↑	1,103 0,832 0,000 536	1,397 0,998 0,001 34	1,637 1,312 0,001 84	2,041 1,712 0,002 84	2,533 2,185 0,004 34	3,041 2,718 0,006 33	3,696 3,360 0,009 35	↑	↑
	$\bar{h}_R$																
* Use corresponding curtailed single sample plan in ISO 2859-1 with Ac = 0.																	

Table 3-A — Curtailment values for sequential sampling plans for normal inspection for percent nonconforming																
Code letter	Single sample size n_0	Curtailed sample size n_t	Acceptance number, A_1													
			Acceptable quality level in percent nonconforming													
			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
D	8	12									*					
E	13	20									*			2	4	5
F	20	30								*			2	3	5	8
G	32	48							*			2	3	5	8	11
H	50	75						*			2	3	5	8	11	15
J	80	120								2	3	5	8	11	15	21
K	125	188							2	4	5	8	11	16	22	32
L	200	300						2	4	5	8	11	16	22	32	
M	315	473		*			2	4	5	8	11	16	22	32		
N	500	750	*			2	4	5	8	11	15	22	32			
P	800	1 200				4	5	8	11	16	22	32				
Q	1 250	1 875		2	4	5	8	11	15	21	32					
R	2 000	3 000	2	4	5	8	11	16	22	32						
* Use corresponding curtailed single sampling plan in ISO 2859-1 with $A_c = 0$.																

Table 3-B — Curtailment values for sequential sampling plans for tightened inspection for percent nonconforming

Code letter	Single sample size n_0	Curtailed sample size n_t	Acceptance number, A_t													
			Acceptable quality level in percent nonconforming													
			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
D	8	12									*				2	
E	13	20												2	4	
F	20	30											2	3	5	
G	32	48							*			2	3	5	8	
H	50	75						*			2	3	5	8	12	
J	80	120								2	3	5	8	12	18	
K	125	188					*			2	4	5	8	13	19	
L	200	300				*			2	4	5	8	13	19	28	
M	315	473			*			2	4	5	8	13	19	28		
N	500	750		*				2	4	5	8	13	19	28		
P	800	1 200	*				2	4	5	8	12	18	27			
Q	1 250	1 875			2	4	5	8	13	18	27					
R	2 000	3 000		2	4	5	8	13	18	28						
S	3 150	4 725	2													
* Use corresponding curtailed single sampling plan in ISO 2859-1 with $A_c = 0$.																

Table 3-C — Curtailment values for sequential sampling plans for normal inspection for nonconformities per 100 items																				
Code letter	Single sample size n_0	Curtailed sample size n_t	Acceptance number, A_t																	
			Acceptable quality level in nonconformities per 100 items																	
			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
D	8	12																		
E	13	20																		
F	20	30																		
G	32	48																		
H	50	75																		
J	80	120																		
K	125	188																		
L	200	300																		
M	315	473																		
N	500	750																		
P	800	1200																		
Q	1250	1875																		
R	2000	3000																		

* Use corresponding curtailed single sampling plan in ISO 2859-1 with $A_c = 0$.

Table 3-D — Curtailment values for sequential sampling plans for tightened inspection for nonconformities per 100 items

Code letter	Single sample size n_0	Curtailed sample size n_t	Acceptance number, A_1																				
			Acceptable quality level in nonconformities per 100 items																				
			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
D	8	12																					
E	13	20																					
F	20	30																					
G	32	48																					
H	50	75																					
J	80	120																					
K	125	188																					
L	200	300																					
M	315	473																					
N	500	750																					
P	800	1200																					
Q	1250	1875																					
R	2000	3000																					
S	3150	4725	2	2	4	5	8	13	18	28													

* Use corresponding curtailed single sampling plan in ISO 2859-1 with Ac = 0.

* Use corresponding curtailed single sampling plan in ISO 2859-1 with $A_c = 0$

Table 4-A — Average sample size for sequential sampling plans for normal inspection for percent nonconforming

Code letter	Quality level, p (proportion nonconforming)	Acceptable quality level in percent nonconforming (normal inspection)													
		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
D	0,00													5	4
	p_A													6,0	5,9
	g													6,5	6,6
	p_R													4,1	4,6
E	0,00												8	6	5
	p_A												9,8	8,6	8,3
	g												10,3	9,4	9,9
	p_R												6,4	6,4	6,7
F	0,00											13	10	8	6
	p_A											15,5	13,8	13,3	12,5
	g											15,6	14,7	15,4	15,4
	p_R											9,2	9,4	10,0	10,6
G	0,00										21	16	14	11	9
	p_A										24,8	22,2	21,5	20,4	19,1
	g										24,7	23,6	24,0	24,2	23,5
	p_R										14,4	14,8	15,3	16,0	16,0
H	0,00									32	26	22	17	14	12
	p_A									37,8	35,6	33,7	31,6	30,8	29,8
	g									37,7	37,2	37,2	37,0	37,2	37,2
	p_R									21,9	22,9	23,0	23,9	24,7	25,4
J	0,00								52	41	35	28	24	20	16
	p_A								61,2	56,4	53,9	51,1	50,0	48,3	46,7
	g								60,7	58,7	59,1	59,1	59,3	59,2	58,9
	p_R								34,8	35,9	36,6	37,8	38,8	39,6	40,2
K	0,00							80	64	54	43	36	30	25	19
	p_A							93,8	87,2	81,8	76,6	73,2	69,8	65,4	60,1
	g							92,7	90,2	89,1	87,8	86,1	84,4	81,0	76,3
	p_R							52,8	54,7	54,6	55,4	55,6	55,5	54,3	52,3

Table 4-A — (concluded)

Code letter	Quality level, p (proportion nonconforming)	Acceptable quality level in percent nonconforming (normal inspection)													
		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
L	0,00						129	103	87	69	59	50	41	33	
	p_A						152	141	133	125	120	116	109	103	
	g						150	145	145	143	141	139	134	130	
	p_R						84,9	87,8	88,1	89,9	90,3	91,1	89,2	88,1	
M	0,00					205	162	138	111	95	80	67	54		
	p_A					241	221	211	200	192	186	179	171		
	g					237	227	229	229	225	224	221	215		
	p_R					135	137	139	143	144	146	146	145		
N	0,00				326	260	220	177	152	128	108	88			
	p_A				383	354	335	317	311	298	289	280			
	g				377	365	363	362	364	358	355	351			
	p_R				213	220	220	226	232	233	235	236			
P	0,00			522	415	354	285	245	206	175	143				
	p_A			613	566	540	513	499	481	470	458				
	g			605	583	586	584	584	577	577	574				
	p_R			342	351	355	365	372	375	380	385				
Q	0,00		820	649	556	446	383	326	276	227					
	p_A		965	886	850	804	779	765	742	728					
	g		952	912	924	916	910	919	909	912					
	p_R		539	549	559	573	580	596	599	611					
R	0,00	1 303	1 040	889	716	615	521	440	363						
	p_A	1 531	1 419	1 357	1 293	1 252	1 221	1 178	1 159						
	g	1 508	1 461	1 473	1 475	1 464	1 465	1 441	1 449						
	p_R	853	879	892	921	932	949	949	970						

NOTES

1 Values of p_A ($p_a = 0,90$) and p_R ($p_a = 0,10$) are shown in table X of ISO 2859-1:1989.

2 Average sample size for $p = 1,0$ (100 % nonconforming) is an integer immediately above $h_R/(1 - g)$

Table 4-B — Average sample size for sequential sampling plans for tightened inspection for percent nonconforming

Code letter	Quality level, p (proportion nonconforming)	Acceptable quality level in percent nonconforming (tightened inspection)													
		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
D	0,00														5
	p_A														6,0
	g														6,5
	p_R														4,1
E	0,00													8	6
	p_A													9,8	8,6
	g													10,3	9,4
	p_R													6,4	6,4
F	0,00												13	10	8
	p_A												15,5	13,8	13,3
	g												15,6	14,7	15,4
	p_R												9,2	9,4	10,0
G	0,00											21	16	14	11
	p_A											24,8	22,2	21,5	20,4
	g											24,7	23,6	24,0	24,2
	p_R											14,4	14,8	15,3	16,0
H	0,00										32	26	22	17	13
	p_A										37,8	35,6	33,7	31,6	30,4
	g										37,7	37,2	37,2	37,0	37,2
	p_R										21,9	22,9	23,0	23,9	24,9
J	0,00									52	41	35	28	22	18
	p_A									61,2	56,4	53,9	51,1	49,3	47,0
	g									60,7	58,7	59,1	59,1	59,6	58,4
	p_R									34,8	35,9	36,6	37,8	39,3	39,4
K	0,00								80	64	54	43	34	27	21
	p_A								93,8	87,2	81,8	76,6	71,8	67,5	61,2
	g								92,7	90,2	89,1	87,8	85,3	82,7	76,8
	p_R								52,8	54,7	54,6	55,4	55,5	55,0	52,3

Table 4-B — (concluded)

Code letter	Quality level, p (proportion nonconforming)	Acceptable quality level in percent nonconforming (tightened inspection)													
		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
L	0,00							129	103	87	69	56	45	36	
	p_A							152	141	133	125	119	112	105	
	g							150	145	145	143	141	137	131	
	p_R							84,9	87,8	88,1	89,9	90,8	90,6	88,5	
M	0,00						205	162	138	111	88	73	59		
	p_A						241	221	211	200	188	182	174		
	g						237	227	229	229	223	222	217		
	p_R						135	137	139	143	144	146	146		
N	0,00					326	260	220	177	143	117	95			
	p_A					383	354	335	317	307	294	283			
	g					377	365	363	362	363	357	352			
	p_R					213	220	220	226	233	234	235			
P	0,00				522	415	354	285	231	190	155				
	p_A				613	566	540	513	496	478	465				
	g				605	583	586	584	586	580	578				
	p_R				342	351	355	365	376	380	386				
Q	0,00			820	649	556	446	361	299	243					
	p_A			965	886	850	804	774	754	723					
	g			952	912	924	916	916	916	897					
	p_R			539	549	559	573	587	600	597					
R	0,00		1 303	1 040	889	716	579	478	392						
	p_A		1 531	1 419	1 357	1 293	1 242	1 203	1 168						
	g		1 508	1 461	1 473	1 475	1 467	1 460	1 449						
	p_R		853	879	892	921	940	954	964						
S	0,00	2 059													
	p_A	2 419													
	g	2 384													
	p_R	1 347													

NOTES

1 Values of p_A ($P_a = 0,90$) and p_R ($P_a = 0,10$) are shown in table X of ISO 2859-1:1989.

2 Average sample size for $p = 1,0$ (100 % nonconforming) is an integer immediately above $h_R/(1 - g)$

Table 4-C — Average sample size for sequential sampling plans for normal inspection for nonconformities per 100 items

Code letter	Quality level, p (nonconformities per item)	Acceptable quality level in nonconformities per 100 items (normal inspection)															
		0,40	0,65	1,0	1,5	2,5	4,0	6,5	10	15	25	40	65	100	150	250	400
D	0,00							5	4	4	3	2	2	2	2	1	1
	p_A							6,0	5,5	6,0	5,3	5,3	5,6	5,6	5,6	5,6	5,8
	g							6,2	5,9	6,5	6,3	6,2	7,0	6,7	6,7	6,6	6,8
	p_R							3,8	3,9	4,2	4,1	4,2	4,5	4,5	4,5	4,5	4,6
E	0,00						9	7	6	5	4	3	3	3	2	2	
	p_A						10,7	9,6	9,1	8,9	8,2	7,8	8,2	8,3	8,1	8,5	
	g						10,8	10,1	10,1	10,4	9,7	9,5	10,0	10,4	10,1	10,4	
	p_R						6,4	6,3	6,5	6,8	6,4	6,4	6,7	7,0	6,9	7,0	
F	0,00					13	11	9	7	6	5	5	4				
	p_A					15,4	14,9	13,6	13,2	13,0	12,5	12,3	12,1				
	g					15,4	15,5	15,1	15,5	15,6	15,5	15,1	15,3				
	p_R					9,0	9,5	9,4	10,0	10,1	10,2	10,1	10,4				
G	0,00				21	17	14	12	10	9	7	6					
	p_A				24,9	23,3	21,8	21,0	20,6	21,8	19,5	19,4					
	g				24,8	24,1	24,2	24,2	24,4	27,3	24,2	24,3					
	p_R				14,3	14,7	14,9	15,3	15,7	17,3	16,1	16,4					
H	0,00			33	26	22	18	16	13	11	9						
	p_A			38,8	35,7	33,9	32,2	32,2	31,0	30,0	29,9						
	g			38,5	37,0	37,2	36,8	37,9	37,4	36,8	37,9						
	p_R			22,0	22,5	22,9	23,3	24,3	24,3	24,5	25,5						
J	0,00		52	42	36	29	25	21	18	15							
	p_A		61,3	57,9	54,5	52,3	51,1	50,1	48,5	47,4							
	g		60,7	60,2	59,4	60,1	59,9	60,5	59,7	59,9							
	p_R		34,7	36,3	36,2	37,7	38,3	39,1	39,5	40,4							
K	0,00	82	65	56	45	39	33	28	24								
	p_A	96,7	88,9	85,9	81,5	79,6	77,8	76,0	75,5								
	g	95,8	91,7	93,6	93,6	93,4	93,6	93,8	95,1								
	p_R	54,5	55,4	56,7	58,7	59,6	60,8	61,8	63,5								

Table 4-C — (concluded)

Code letter	Quality level, p (non conformities per item)	Acceptable quality level in nonconformities per 100 items (normal inspection)												
		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
L	0,00						130	104	90	73	62	54	45	36
	p_A						153	142	137	132	126	124	120	118
	g						151	146	150	151	148	149	148	148
	p_R						85,6	88,4	90,7	94,0	94,5	96,7	97,1	99,1
M	0,00					205	162	139	113	97	81	73	58	
	p_A					241	221	208	206	198	195	189	186	
	g					237	227	225	235	233	235	232	232	
	p_R					135	137	136	147	149	152	153	156	
N	0,00				327	262	222	178	156	131	112	93		
	p_A				385	358	339	320	318	307	300	297		
	g				380	369	369	365	372	368	368	373		
	p_R				215	222	223	229	237	238	242	249		
P	0,00			524	417	357	287	248	209	182	147			
	p_A			616	570	546	518	504	491	484	473			
	g			608	587	593	590	590	590	593	593			
	p_R			344	354	358	368	376	382	390	397			
Q	0,00		806	651	558	449	386	330	281	229				
	p_A		976	890	855	808	786	773	753	743				
	g		958	917	931	921	918	929	924	929				
	p_R		545	551	563	575	584	602	608	622				
R	0,00	1 305	1 043	891	719	617	527	445	370					
	p_A	1 533	1 424	1 361	1 299	1 261	1 230	1 191	1 173					
	g	1 511	1 466	1 478	1 481	1 474	1 475	1 458	1 467					
	p_R	854	881	894	924	937	955	958	981					

NOTES

1 Values of p_A ($P_a = 0,90$) and p_R ($P_a = 0,10$) are shown in table X of ISO 2859-1:1989.

2 Average sample size for $p = \infty$ is always 1.