

How to find sampling size ?

STEP 1

Find total lot size on first chart, and move over to appropriate General Inspection Level (95% use Level II) to find your letter. Special Inspection Levels are only used for special checks or testing.

Sampling Size Code Letters							
Lot size	General inspection levels			Special Inspection levels			
	I	II	III	S1	S2	S3	S4
2 to 8	A	A	B	A	A	A	A
9 to 15	A	B	C	A	A	A	A
16 to 25	B	C	D	A	A	B	B
26 to 50	C	D	E	A	B	B	C
51 to 90	C	E	F	B	B	C	C
91 to 150	D	F	G	B	B	C	D
151 to 280	E	G	H	B	C	D	E
281 to 500	F	H	J	B	C	D	E
501 to 1 200	G	J	K	C	C	E	F
1 201 to 3 200	H	K	L	C	D	E	G
3 201 to 10 000	J	L	M	C	D	F	G
10 001 to 35 000	K	M	N	C	D	F	H
35 001 to 150 000	L	N	P	D	E	G	J
150 001 to 500 000	M	P	Q	D	E	G	J
500 001 and over	N	Q	R	D	E	H	K

STEP 2

Check 2nd chart for corresponding sampling size. For the Standard 0 (critical) /2.5 (major) /4 (minor) allowance of defects, you can see how many are allowable and what # will fail.

Single Sampling plans for Normal Inspection																								
Sample size code letter	Sample size	Acceptable Quality Limits for normal inspections																						
		0.065		0.1		0.15		0.25		0.4		0.65		1		1.5		2.5		4		6.5		
		Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	
A	2																					0	1	
B	3																			0	1			
C	5																	0	1					
D	8															0	1					1	2	
E	13												0	1							1	2	2	3
F	20										0	1						1	2	2	3	3	4	
G	32							0	1							1	2	2	3	3	4	5	6	
H	50						0	1						1	2	2	3	3	4	5	6	7	8	
J	80					0	1						1	2	2	3	3	4	5	6	7	8	10	11
K	125			0	1					1	2	2	3	3	4	5	6	7	8	10	11	14	15	
L	200	0	1					1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22	
M	315					1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22			
N	500			1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22					
P	800	1	2	2	3	3	4	5	6	7	8	10	11	14	15	21	22							
Q	1250	2	3	3	4	5	6	7	8	10	11	14	15	21	22									
R	2000	3	4	5	6	7	8	10	11	14	15	21	22											

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

Ac Acceptance number

Re Rejection number

↑ Use first sampling plan above narrow.