ISO 3951-2:2013-09 (E)

Sampling procedures for inspection by variables - Part 2: General specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection of independent quality characteristics

Contents

Page

Foreword vi

Introduction viii

1 Scope 1

2 Normative references 2

3 Terms and definitions 2

4 Symbols 6
4.1 Univariate symbols 6
4.2 Multivariate symbols 8

5 Acceptance quality limit (AQL) 8
5.1 Concept 8
5.2 Use 8
5.3 Specifying AQLs 8
5.4 Preferred AQLs 9
5.5 Caution 9
5.6 Limitation 9

6 Switching rules for normal, tightened, and reduced inspection 9

7.1 Relation to ISO 2859-1 10
7.1.1 Similarities to ISO 2859-1 10
7.1.2 Differences from ISO 2859-1 10

8 Consumer protection 12
8.1 Use of individual plans 12
8.2 Consumer's risk quality (CRQ) tables 12
8.3 Producer's risk tables 12
8.4 Operating characteristic (OC) curves 12

9 Accommodating measurement variability 12

10 Planning 13

11 Choice between variables and attributes 13

12 Choice between the s-method and -method 14

13 Choice of inspection level and AQL 14

14 Choice of sampling scheme 14
14.1 Standard plans 14
14.2 Special plans 15

15 Preliminary operations 15

16 Standard procedures for the univariate s-method 16
16.1 Obtaining a plan, sampling, and preliminary calculations 16
16.2 Form k acceptability criterion for the s-method 16
16.3 Form p* acceptability criterion for the s-method 18
16.3.1 Introduction 18
16.3.2 Combined control for the s-method 18
16.3.3 Separate control for the s-method 24
16.3.4 Complex control for the s-method 24

17 Standard multivariate s-method procedures for independent quality characteristics 24
17.1 General methodology 24
17.2 Example 25

18 Standard univariate -method procedures 27
18.1 Obtaining a plan, sampling, and preliminary calculations 27
18.2 Acceptability criterion for a single specification limit or for double specification limits with separate control 27
18.3 Acceptability criterion for double specification limits with combined or complex control . 28

19 Standard multivariate -method procedures for independent quality characteristics 30
19.1 General methodology 30
19.2 Example 31

20 Standard multivariate combined s-method and -method procedures for independent quality characteristics 32
20.1 General methodology 32
20.2 Example 33

21 Procedure during continuing inspection 35

22 Normality and outliers 35
22.1 Normality 35
22.2 Outliers 35

23 Records 35
23.1 Control charts 35
23.2 Lots that are not accepted 35

24 Operation of switching rules 36

25 Discontinuation and resumption of inspection 36

26 Switching between the s-method and -method 37
26.1 Estimating the process standard deviation 37
26.2 State of statistical control 37
26.3 Switching from the s-method to the -method 37
26.4 Switching from the -method to the s-method 37

Annex A (normative) Table for determining the sample size code letter 38

Annex B (normative) Form k single sampling plans: s-method 39

Annex C (normative) Form k single sampling plans: -method 42

Annex D (normative) Form p* single sampling plans: s-method 45

Annex E (normative) Form p* single sampling plans: -method 48

Annex F (normative) Values of fs for maximum sample standard deviation (MSSD) 51

Annex G (normative) Values of f for maximum process standard deviation (MPSD) 54

Annex H (normative) Estimating the process fraction nonconforming for sample size 3: s-method ..57

Annex I (normative) Values of cU for upper control limit on the sample standard deviation 60

Annex J (normative) Supplementary acceptability constants for qualifying towards reduced inspection 61

Annex K (normative) Procedures for obtaining s and 62

Annex L (normative) Estimating the process fraction nonconforming 64

Annex M (informative) Consumer's risk qualities 70

Annex N (informative) Producer's risks 74

Annex O (informative) Operating characteristics for the -method 78

Annex P (informative) Accommodating measurement variability 79

Bibliography 85