

ISO 39511:2018 (E)

Sequential sampling plans for inspection by variables for percent nonconforming (known standard deviation)

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Symbols
5	Principles of sequential sampling plans for inspection by variables
6	Selection of a sampling plan
6.1	Producer's risk point and consumer's risk point
6.2	Preferred values of QPR and QCR
6.3	Pre-operation preparations
6.3.1	Obtaining the parameters h_A , h_R and g
6.3.2	Obtaining the curtailment values
7	Operation of a sequential sampling plan
7.1	Specification of the plan
7.2	Drawing a sample item
7.3	Leeway and cumulative leeway
7.4	Choice between numerical and graphical methods
7.5	Numerical method for a single specification limit
7.5.1	Acceptance and rejection values
7.5.2	Determination of acceptability
7.6	Graphical method for a single specification limit
7.6.1	Acceptance chart
7.6.2	Determination of acceptability
7.7	Numerical method for combined control of double specification limits
7.7.1	Maximum values of process standard deviation
7.7.2	Acceptance and rejection values
7.7.3	Determination of acceptability
7.8	Graphical method for combined control of double specification limits
7.8.1	Acceptance chart
7.8.2	Determination of acceptability
7.9	Numerical method for separate control of double specification limits
7.9.1	Maximum values of process standard deviation
7.9.2	Acceptance and rejection values
7.9.3	Determination of acceptability
7.9.3.1	General
7.9.3.2	Determination of acceptability for the upper specification limit
7.9.3.3	Determination of acceptability for the lower specification limit
7.10	Graphical method for separate control of double specification limits
7.10.1	Acceptance chart
7.10.2	Determination of acceptability
7.10.2.1	General
7.10.2.2	Determination of acceptability for the upper specification limit
7.10.2.3	Determination of acceptability for the lower specification limit

8 **Examples**

- 8.1 **Example 1**
- 8.2 **Example 2**
- 8.3 **Example 3**

9 **Tables**

Annex A **(informative) Additional information**

- A.1 **Producer's risk at QPR and consumer's risk at QCR**
- A.2 **Average sample size at QPR and QCR**

Page count: 35