DIN ISO 3951-1:2024-08 (E)

Sampling procedures for inspection by variables - Part 1: Specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection for a single quality characteristic and a single AQL (ISO 3951-1:2022)

Contents

Page

National foreword ... **4**

National Annex NA (informative) **Bibliography** ... **5**

Foreword ... **6**

Introduction ... **7**

1 Scope ... **9**

2 Normative references ... **9**

3 Terms and definitions ... **10**

4 Symbols ... **14**

5 Choice of a sampling plan ... **15**
5.1 Choice between variables and attributes ... 15
5.2 General ... 16
5.3 Choice between the *s*-method and σ-method ... 16
5.4 Choice of inspection level and AQL ... 17

6 Standard procedures for the *s*-method ... **18**
6.1 General ... 18
6.2 Single specification limits ... 18
6.3 Double specification limits ... 19

7 Standard procedures for the σ-method ... **19**
7.1 General ... 19
7.2 Single specification limits ... 19
7.3 Double specification limits ... 20

8 The *p-method** ... **20**

9 Switching between inspection severities ... **21**
9.1 Rules for switching between inspection severities ... 22
9.2 Records for switching between inspection severities ... 23

10 Relation to ISO 2859-1 ... **23**
10.1 Similarities ... 23
10.2 Differences ... 24

11 Allowing for measurement uncertainty ... **25**

12 Normality, data transformations and outliers ... **25**
12.1 Normality ... 25
12.2 Data transformations ... 25
12.3 Outliers ... 26

13 Monitoring and recording of inspection results ... **26**
13.1 Monitoring of inspection results ... 26
13.2 Process capability and performance assessment ... 26
13.3 Monitoring of process parameters ... 26

14 Tables ... **27**
14.1 Form *k* for single sampling plans: *s*-method ... 27
14.2 Form *k* for single sampling plans: σ-method ... 33

14.3 Form p^* single sampling plans 39
14.4 Values of f_σ for maximum process standard deviation (MPSD) 45
14.5 Supplementary acceptance constants for qualifying towards reduced inspection 45

15 Examples 46
15.1 General 46
15.2 Examples for the *s*-method 46
15.3 Examples for the σ-method 53
15.4 Examples for the p^*-method 57

Annex A (informative) **Procedures for obtaining *s* and σ 60**

Annex B (informative) **Accommodating measurement variability 63**

Annex C (informative) **Sampling strategies 68**

Annex D (informative) **Operating characteristics for the σ–method 70**

Annex E (informative) **Operating characteristic for the *s*-method – tabulated values for single sampling plans, normal inspection 71**

Annex F (informative) **Consumer's risk qualities 80**

Annex G (informative) **Producer's risks 87**

Annex H (informative) **Construction of acceptance diagrams for double specification limits 95**

Annex I (informative) **Use of the underlying software 106**

Bibliography 111