

ISO 2859-1:2026-01 (E)

Sampling procedures for inspection by attributes - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

Contents		Page
Foreword		vi
Introduction		vii
1	Scope	1
1.1	Continuous inspection	1
1.2	Skip-lot inspection	2
2	Normative references	2
3	Terms, definitions and symbols	2
3.1	Terms and definitions	2
3.2	Symbols and abbreviations	10
4	Expression of nonconformity	11
4.1	General	11
4.2	Classification of nonconformities	11
5	Acceptance quality limit (AQL)	11
5.1	Use and application	11
5.2	Specifying AQLs	11
5.3	Preferred AQLs	12
6	Submission of product for sampling	12
6.1	Formation of lots	12
6.2	Presentation of lots	12
7	Acceptance and non-acceptance	12
7.1	Acceptability of lots	12
7.2	Disposition of non-acceptable lots	12
7.3	Nonconforming items	12
7.4	Classes of nonconformities or nonconforming items	12
7.5	Special reservation for critical classes of nonconformities	13
7.6	Resubmitted lots	13
8	Drawing of samples	13
8.1	Sample selection	13
8.1.1	General	13
8.1.2	Skip-lot	13
8.2	When to draw the samples	13
8.3	Double or multiple sampling	14
9	Normal, tightened, reduced and skip-lot sampling inspection	14
9.1	Start of inspection	14
9.2	Continuation of inspection	14
9.3	Switching rules and procedures	14
9.3.1	Normal to tightened	14
9.3.2	Tightened to normal	14
9.3.3	Normal to reduced	14
9.3.4	Reduced to normal	16
9.3.5	Skip-lot to normal	16

9.3.6	Reduced to skip-lot	16
9.4	Discontinuation of inspection	16
9.5	Skip-lot sampling inspection	16
9.5.1	General requirements	16
9.5.2	Producer and product qualification	17
9.5.3	Qualification and disqualification	18
9.5.4	Responsibilities on producer qualification	19
10	Sampling plans	19
10.1	Inspection level	19
10.2	Sample size code letters	20
10.3	Obtaining a sampling plan	20
10.4	Types of sampling plans	21
11	Determination of acceptability	21
11.1	Inspection for nonconforming items	21
11.2	Single sampling plans (integer acceptance number)	21
11.3	Double sampling plans	21
11.4	Multiple sampling plans	21
11.5	Inspection for nonconformities	22
12	Further information	22
12.1	Operating characteristic (OC) curves	22
12.2	Process average	22
12.3	Average outgoing quality (AOQ)	22
12.4	Average outgoing quality limit (AOQL)	22
12.5	Average sample size curves	22
12.6	Consumer's and producer's risks	23
12.6.1	Use of individual plans	23
12.6.2	Consumer's risk quality (CRQ) tables	23
12.6.3	Producer's risk (PR) tables	23
13	Fractional acceptance number plans for single sampling (optional)	23
13.1	Application of fractional acceptance number plans	23
13.2	Acceptability determination	24
13.2.1	Inspection for nonconforming items	24
13.2.2	Inspection for number of nonconformities	25
13.3	Switching rules	25
13.3.1	Normal to tightened and tightened to normal	25
13.3.2	Normal to reduced	25
13.3.3	Reduced to normal inspection and discontinuation of inspection	25
13.3.4	Non-constant sampling plan	25
14	Inspection Errors	26
15	Sample size code letters	26
16	Tables of single sampling plans	27
17	Tables of double sampling plans	30
18	Tables of multiple sampling plans	33
19	Tables of producer's risk (PR)	42
20	Tables of consumer risk quality (CRQ)	45
21	Tables of average outgoing quality limits (AOQL)	48
22	Average sample size comparisons by acceptance number	50

23	Tables of single sampling fractional acceptance number plans	52
24	Normalized scheme operating characteristic curves	55
	Annex A (informative) Example for non-constant sampling plan	57
	Annex B (informative) Sampling strategies	58
	Annex C (normative) Procedures for random selection at the skip-lot sampling inspection frequency	60
	Annex D (informative) Skip-lot sampling inspection	61
	Annex E (informative) The construction of operating characteristic (OC) and average sample number (ASN) curves	66
	Annex F (informative) The Construction of Sampling Plans	77
	Bibliography	81