ISO 10725:2000-12 (E)

Acceptance sampling plans and procedures for the inspection of bulk materials

Contents

Page

Foreword vi

Introduction vii

1 Scope 1

2 Normative references 1

3 Terms and definitions 2

4 Symbols and abbreviated terms 3

5 Sampling plans 6
5.1 General 6
5.2 Applicability 6
5.3 Standardized sampling procedures 7
5.4 Standard deviations 8
5.5 Costs 9
5.6 Acceptance quality limit and non-acceptance quality limit 10
5.7 Responsible authority 11

6 Inspection procedures 12
6.1 General 12
6.2 Assessment of the standard deviations 12
6.3 Determination of sample sizes 18
6.4 Selection and preparation of samples 21
6.5 Determination of the acceptance value 30
6.6 Determination of lot acceptability 31

7 Examples 32
7.1 Imprecise standard deviation with one-sided specification limit 32
7.2 Imprecise standard deviation with two-sided specification limits 33
7.3 Optional procedure for known standard deviation with one-sided specification limit 34
7.4 Known standard deviation with one-sided specification limit 35
7.5 Known standard deviations with two-sided specification limits 36
7.6 Revision of discrimination interval 38
7.7 Results from one lot 39
7.8 Results from consecutive lots 40

Annex A (normative) Special procedures for inspecting multiple characteristics of a material 42

Annex B (normative) Acceptance sampling plans and procedures for use where the measurement standard deviation is dominant 47

Annex C (informative) Theoretical background 52

Annex D (informative) Operating characteristic curves 62

Bibliography 72

Figure 1 -- Schematic model of bulk acceptance sampling procedures 8

Figure C.1 -- Relationship between mA, mR and acceptance value (Distribution of .....x ; lower specification limit) 55

Figure C.2 -- Relationship between mA, mR and acceptance value (Distribution of ..... x ; upper specification limit) 57

Figure C.3 -- Relationship between mAs, mRs and acceptance values (Distribution of ..... x ; two-sided specification limits) 57

Figure C.4 -- Relationship between D and D (when D = d ´ D) (Distribution of ..... x ; two-sided specification limits) 57

Figure D.1 -- OC curve for Example 1 65

Figure D.2 -- OC curve for Example 2 66

Figure D.3 -- OC curve for Example 3 68

Figure D.4 -- OC curve for Example 4 71

Table 1 -- Values of d for two-sided specification limits (imprecise standard deviations) 11

Table 2 -- Values of fU for UCL 15

Table 3 -- Sample sizes (a »»»» 5 %, b »»»» 10 %), cost ratio level 1 for RC »»»» 0,10 (0 to 0,17) 22

Table 4 -- Sample sizes (a »»»» 5 %, b »»»» 10 %), cost ratio level 2 for RC »»»» 0,32 (0,18 to 0,56) .. 22

Table 5 -- Sample sizes (a »»»» 5 %, b »»»» 10 %), cost ratio level 3 for RC »»»» 1,0 (0,57 to 1,7) 23

Table 6 -- Sample sizes (a »»»» 5 %, b »»»» 10 %), cost ratio level 4 for RC »»»» 3,2 (1,8 to 5,6) 23

Table 7 -- Sample sizes (a »»»» 5 %, b »»»» 10 %), cost ratio level 5 for RC »»»» 10 (5,7 or over) 24

Table 8 -- Sample sizes (a »»»» 5 %, b »»»» 5 %), cost ratio level 1 for RC »»»» 0,10 (0 to 0,17) 24

Table 9 -- Sample sizes (a »»»» 5 %, b »»»» 5 %), cost ratio level 2 for RC »»»» 0,32 (0,18 to 0,56) 25

Table 10 -- Sample sizes (a »»»» 5 %, b »»»» 5 %), cost ratio level 3 for RC »»»» 1,0 (0,57 to 1,7) 25

Table 11 -- Sample sizes (a »»»» 5 %, b »»»» 5 %), cost ratio level 4 for RC »»»» 3,2 (1,8 to 5,6) 26

Table 12 -- Sample sizes (a »»»» 5 %, b »»»» 5 %), cost ratio level 5 for RC »»»» 10 (5,7 or over) 26

Table 13 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 1, cost ratio level 1 for RC »»»» 0,10 (0 to 0,17) 27

Table 14 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 1, cost ratio level 2 for RC »»»» 0,32 (0,18 to 0,56) 27

Table 15 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 1, cost ratio level 3 for RC »»»» 1,0 (0,57 to 1,7) 28

Table 16 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 1, cost ratio level 4 for RC »»»» 3,2 (1,8 to 5,6) 28

Table 17 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 1, cost ratio level 5 for RC »»»» 10 (5,7 or over) 28

Table 18 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 2, cost ratio level 1 for RC »»»» 0,10 (0 to 0,17) 29

Table 19 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 2, cost ratio level 2 for RC »»»» 0,32 (0,18 to 0,56) 29

Table 20 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 2, cost ratio level 3 for RC »»»» 1,0 (0,57 to 1,7) 29

Table 21 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 2, cost ratio level 4 for RC »»»» 3,2 (1,8 to 5,6) 30

Table 22 -- Sample sizes (a »»»» 5 %, b »»»» 5 %) and degrees of freedom for nM = 2, cost ratio level 5 for RC »»»» 10 (5,7 or over) 30

Table 23 -- Data obtained from one lot 39

Table 24 -- Data of consecutive lots 41

Table A.1 -- Correction factor, fD, for J characteristics for known standard deviations 43

Table A.2 -- Risks at mA (a*) and at mR (b*) (for each of J characteristics, in %) 44

Table A.3 -- Correction factor, fD, for J characteristics for imprecise standard deviations 46

Table B.1 -- Sample sizes for special procedures (known standard deviations; a »»»» 5 %, b »»»» 10 %) 48

Table B.2 -- Sample sizes for special procedures (known standard deviations; a »»»» 5 %, b »»»» 5 %) 49

Table B.3 -- Sample sizes for special procedures (imprecise standard deviations; a »»»» 5 %, b »»»» 5 %) 49

Table D.1 -- OC values for Example 1 65

Table D.2 -- OC values for Example 2 67

Table D.3 -- OC values for Example 3, lower side 68

Table D.4 -- OC values for Example 3, upper side 68

Table D.5 -- OC values for Example 4 70