

Table B-3

Standard Deviation Method

Master Table for Normal and Tightened Inspection for Plans Based on Variability Unknown
(Double Specification Limit and Form 2—Single Specification Limit)

Sample size code letter	Sample size	Acceptable Quality Levels (normal inspection)												
		T	.10	.15	.25	.40	.65	1.00	1.50	2.50	4.00	6.50	10.00	
B	3	M	M	M	M	M	M	M	M	M	M	M	M	M
C	4													
D	5		↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
E	7	↓	0.005	0.087	0.421	1.05	2.13	3.54	5.34	8.40	12.19	17.34	23.30	
F	10	0.077	0.179	0.349	0.714	1.27	2.14	3.27	4.72	7.26	10.53	15.17	20.73	
G	15	0.186	0.311	0.491	0.839	1.33	2.09	3.06	4.32	6.55	9.48	13.74	18.97	
H	20	0.228	0.356	0.531	0.864	1.33	2.03	2.93	4.10	6.18	8.95	13.01	18.07	
I	25	0.250	0.378	0.551	0.874	1.32	2.00	2.86	3.97	5.98	8.65	12.60	17.55	
J	35	0.253	0.373	0.534	0.833	1.24	1.87	2.66	3.70	5.58	8.11	11.89	16.67	
K	50	0.243	0.355	0.503	0.778	1.16	1.73	2.47	3.44	5.21	7.61	11.23	15.87	
L	75	0.225	0.326	0.461	0.711	1.06	1.59	2.27	3.17	4.83	7.10	10.58	15.07	
M	100	0.218	0.315	0.444	0.684	1.02	1.52	2.18	3.06	4.67	6.88	10.29	14.71	
N	150	0.202	0.292	0.412	0.636	0.946	1.42	2.05	2.88	4.42	6.56	9.86	14.18	
P	200	0.204	0.294	0.414	0.637	0.945	1.42	2.04	2.86	4.39	6.52	9.80	14.11	
		Acceptable Quality Levels (tightened inspection)												
		.10	.15	.25	.40	.65	1.00	1.50	2.50	4.00	6.50	10.00		

All AQL values are in percent nonconforming. T denotes plan used exclusively on tightened inspection and provides symbol for identification of appropriate OC curve.

↓ Use first sampling plan below arrow; that is, both sample size as well as M value. When sample size equals or exceeds lot size, every item in the lot must be inspected.