

Table B-4

Standard Deviation Method

Master Table for Reduced 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												
		.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	3													
D	3													
E	3													
F	4													
G	5	↓	↓	0.041	1.34	3.33	5.82	9.80	14.37	20.19	26.55	33.94		
H	7	0.087	0.421	1.06	2.13	3.54	5.34	8.40	12.19	17.34	23.30	30.50		
I	10	0.349	0.714	1.27	2.14	3.27	4.72	7.26	10.53	15.17	20.73	27.65		
J	15	0.491	0.839	1.33	2.09	3.06	4.32	6.55	9.48	13.74	18.97	25.63		
K	20	0.531	0.864	1.33	2.03	2.93	4.10	6.18	8.95	13.01	18.07	24.58		
L	25	0.551	0.874	1.32	2.00	2.86	3.97	5.98	8.65	12.60	17.55	23.97		
M	30	0.567	0.885	1.32	1.98	2.82	3.91	5.87	8.48	12.37	17.25	23.61		
N	50	0.503	0.778	1.16	1.73	2.47	3.44	5.21	7.61	11.23	15.87	21.99		
P	75	0.461	0.711	1.06	1.59	2.27	3.17	4.83	7.10	10.58	15.07	21.05		

All AQL values are in percent nonconforming.

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.