BRITISH STANDARD

Sampling procedures for inspection by variables –

Part 2: General guide to single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection of independent quality characteristics

ICS 03.120.30



NO COPYING WITHOUT BSI PERMISSION EXCEPT AS PERMITTED BY COPYRIGHT LAW

Publishing and copyright information

The BSI copyright notice displayed in this document indicates when the document was last issued.

© BSI 2007

ISBN 978 $0\;580\;50164\;7$

The following BSI references relate to the work on this standard: Committee reference SS/5 Draft for comment 05/30134582

Text affected

Publication history

First published as BS 6002, May 1979 First published as BS 6002-1, November 1993 First published as BS 6002-2, February 2007

Amendments issued since publication

Amd. no. Date

Contents

Foreword vIntroduction 1

- 1 Scope 5
- **2** Normative references *6*
- **3** Terms and definitions *7*
- 4 Symbols 10
- **5** Acceptance quality limit (AQL) 12
- 6 Switching rules for normal, tightened and reduced inspection 13
- 7 Relationship to BS 6001-1 and BS 6002-1 14
- 8 Consumer protection 16
- 9 Planning 17
- **10** Choice between variables and attributes *18*
- **11** Choice between the "s" and " σ " methods 19
- 12 Choice of inspection level and AQL 19
- **13** Choice of sampling scheme 19
- **14** Preliminary operations *21*
- **15** Standard univariate "s" method procedures *21*
- **16** Standard multivariate "s" method procedures for independent quality characteristics *30*
- **17** Standard univariate " σ " method procedures 33
- **18** Standard multivariate " σ " method procedures for independent quality characteristics 37
- **19** Standard multivariate combined "s" and " σ " method procedures for independent quality characteristics 39
- **20** Procedure during continuing inspection 40
- **21** Normality and outliers *41*
- **22** Records 41
- **23** Operation of switching rules 42
- **24** Discontinuation and resumption of inspection 43
- **25** Switching between the "s" and " σ " methods 43

Annexes

Annex A (normative) Table for determining the sample size code letter 44

Annex B (normative) Form k "s" method single sampling plans 45 Annex C (normative) Form k " σ " method single sampling plans 48 Annex D (normative) Form p^* "s" method single sampling plans 51

Annex E (normative) Form p^* " σ " method single sampling plans 54 Annex F (normative) Values of f_s for maximum sample standard deviation (MSSD) 57

Annex G (normative) Values of f_{σ} for maximum process standard deviation (MPSD) 60

Annex H (normative) Estimating the process fraction nonconforming for sample size 3: "s" method 63

Annex I (normative) Values of c_u for upper control limit on the sample standard deviation 66