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RECEIVING, IN-PROCESS AND FINAL INSPECTION SAMPLING PLAN

Origination Date: XXXX

Document Identifier:	Name, Number, Unique ID
Date:	Latest Revision Date
Project:	Customer, Unique ID, Part Number
Document Status:	Draft, Redline, Released, Obsolete
Document Link:	Location on Server (if used)

Abstract:
This document describes the C=0 sampling plan.

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DOCUMENT CHANGE RECORD

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1.0 Scope

The Zero Acceptance Number plan developed by Nicholas L. Squeglia, available at ASQ.org; ISBN 0-87389-305-0, was originally designed and used to provide equal or greater Consumer protection with less inspection than the corresponding MIL-STD-105 sampling plan. In addition to the economic advantages, the plan is simple to use and administer. As a result of these advantages the plan has found its place in many commercial industries where emphasis is being placed on zero defects. There is no specific sampling plan or procedure that can be considered best suited for all applications. It is impractical to cite all the applications where this C=0 plan can be used. Some applications are for [redacted] Wherever lot-by-lot sampling exists, regardless of the nature of the product, this C=0 plan may be applicable.

2.0 Theory

The basic objective of sampling is often overlooked. Why sample? Sampling is employed to [redacted] It is impractical (in most cases) to perform 100% inspection; therefore, a sampling plan that economically provides a reasonable amount of protection is desirable to assure 100% quality. This C=0 plan provides [redacted]

3.0 Alternate Sampling Plans

Continuous Sampling

This plan is used when units of products are submitted for inspection one at a time. If a frequency check discovers a nonconformance then 100% inspection is applied until [redacted] Multi-Level and Single-Level Continuous Sampling Plans are defined by [redacted]

Lot-by-Lot Attribute Inspection

This plan is used when units of product are submitted for inspection in a group, batch or lot instead of one at a time. The characteristics evaluated either conform or do not conform to

acceptance criteria. Go-No/Go type gauges are prevalent in attribute plans – measurement of characteristics is not required. MIL-STD-105 defines [redacted] ANSI Z 1.4 has replaced MIL-STD-105.

Lot-by-Lot Variables Inspection
This plan is used when units of product are submitted for inspection in a group, batch or lot instead of one at a time. The characteristics evaluated are measured and a smaller sample size is used to obtain the same protection provided by an attribute inspection plan. MIL-STD-414 defines [redacted] ANSI Z 1.9 has replaced MIL-STD-414.

4.0 Relationship of C=0 to MIL-STD-105

The MIL-STD-105 sampling plan is based upon the A.Q.L. concept (Acceptance Quality Level), which provides a Producer Risk lot acceptance probability of 90% to 98%, a Consumer Risk lot rejection probability of 2% to 10% and acceptance of a lot based upon a percent defective that is established for major and/or minor characteristics. The C=0 plan is associated with the A.Q.L.'s of MIL-STD-105 as well as the L.T.P.D (Lot Tolerance Percent Defective) and A.O.Q.L. (Average Outgoing Quality Level). The plan provides equal or greater Consumer Risk protection at the 10% level and requires less inspection; however, [redacted]

The C=0 plan is used when:

[redacted]

5.0 C=0 Sampling Plan

Use MIL-STD-105/ANSI Z 1.4 to establish an A.Q.L., which is normally 1.0 for critical characteristics and 4.0 for minor characteristics. Using Table I, find a lot size in the left-hand column and read across the columns to the appropriate A.Q.L. then read down the column to find the sample size. For instance, [redacted]

A random selection of samples is necessary to assure reliable results.

Table I

C=0 Sampling Plan - Associated A.Q.L.'s

Lot Size	0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10.0
	Sample Size															
[redacted]																

Acceptance number is zero (0) in all cases.