

# Tablas Normas ISO 3951, partes 1 y 2

Table A.1 — Sample-size code letters and inspection levels

Lot or batch size	Special inspection levels				General inspection levels		
	S-1	S-2	S-3	S-4	I	II	III
2 to 8	B	B	B	B	B	B	B
9 to 15	B	B	B	B	B	B	C
16 to 25	B	B	B	B	B	C	D
26 to 50	B	B	B	C	C	D	E
51 to 90	B	B	C	C	C	E	F
91 to 150	B	B	C	D	D	F	G
151 to 280	B	C	D	E	F	G	H
281 to 500	B	C	D	E	F	H	J
501 to 1 200	C	C	E	F	G	J	K
1 201 to 3 200	C	D	E	G	H	K	L
3 201 to 10 000	C	D	F	G	J	L	M
10 001 to 35 000	C	D	F	H	K	M	N
35 001 to 150 000	D	E	G	J	L	N	P
150 001 to 500 000	D	E	G	J	M	P	Q
500 000 and over	D	E	H	K	N	Q	R

NOTE The sample-size code letters and inspection levels in this part of ISO 3951 correspond to those given in ISO 2859-1.

Table A.2 — Sample sizes for sample-size code letters and inspection method

Sample-size code letter	"s" method		"σ" method		Equivalent attributes sample size in ISO 2859-1	
	Normal and tightened inspection	Reduced inspection	Normal and tightened inspection	Reduced inspection	Normal and tightened inspection	Reduced inspection
B	3	3	2	2	3	2
C	4	3	3	2	5	2
D	6	3	4	2	8	3
E	9	4	6	3	13	5
F	13	6	8	4	20	8
G	18	9	10	6	32	13
H	25	13	12	8	50	20
J	35	18	15	10	80	32
K	50	25	18	12	125	50
L	70	35	21	15	200	80
M	95	50	25	18	315	125
N	125	70	32	21	500	200
P	160	95	40	25	800	315
Q	200	125	50	32	1250	500
R	250	160	65	40	2000	800

NOTE The sample-size code letters and inspection levels in this part of ISO 3951 correspond to those given in ISO 2859-1.

## Tablas B

**Table B.1 — Single sampling plans for normal inspection (master table): "s" method**

Code letter	Sample size	Acceptance quality limit % nonconforming															
		0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
		k	k	k	k	k	k	k	k	k	k	k	k	k	k	k	k
B	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,954	0,818	0,526
C	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,163	1,046	0,853	0,580
D	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,395	1,275	1,108	0,902	0,587
E	9	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,615	1,494	1,338	1,159	0,907	0,597
F	13	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,830	1,712	1,565	1,405	1,189	0,938	0,614
G	18	↓	↓	↓	↓	↓	↓	↓	↓	2,025	1,910	1,770	1,622	1,429	1,212	0,944	0,718
H	25	↓	↓	↓	↓	↓	↓	↓	2,215	2,102	1,969	1,829	1,652	1,457	1,225	1,035	0,809
J	35	↓	↓	↓	↓	↓	↓	2,399	2,289	2,160	2,028	1,862	1,684	1,476	1,311	1,118	0,912
K	50	↓	↓	↓	↓	↓	2,569	2,461	2,336	2,209	2,052	1,885	1,693	1,543	1,372	1,193	0,947
L	70	↓	↓	↓	↓	2,736	2,631	2,510	2,389	2,239	2,082	1,904	1,766	1,611	1,451	1,238	↑
M	95	↓	↓	↓	2,889	2,787	2,670	2,553	2,410	2,261	2,093	1,965	1,822	1,676	1,484	↑	↑
N	125	↓	↓	3,037	2,937	2,824	2,711	2,574	2,432	2,274	2,154	2,021	1,886	1,710	↑	↑	↑
P	160	↓	3,179	3,082	2,973	2,865	2,733	2,597	2,447	2,334	2,209	2,083	1,921	↑	↑	↑	↑
Q	200	3,310	3,215	3,109	3,004	2,877	2,747	2,603	2,495	2,377	2,258	2,106	↑	↑	↑	↑	↑
R	250	3,350	3,247	3,146	3,023	2,898	2,760	2,657	2,545	2,432	2,289	↑	↑	↑	↑	↑	↑

NOTE 1 The sample-size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100 % inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

**Table B.2 — Single sampling plans for tightened inspection (master table): "s" method**

Code letter	Sample size	Acceptance quality limit % nonconforming															
		0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
		k	k	k	k	k	k	k	k	k	k	k	k	k	k	k	k
B	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,954	0,818	0,526
C	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,163	1,046	0,853	0,580
D	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,395	1,275	1,108	0,902	0,587
E	9	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,615	1,494	1,338	1,159	0,907	0,597
F	13	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,830	1,712	1,565	1,405	1,189	0,938	0,614
G	18	↓	↓	↓	↓	↓	↓	↓	↓	2,025	1,910	1,770	1,622	1,429	1,212	0,944	0,718
H	25	↓	↓	↓	↓	↓	↓	↓	2,215	2,102	1,969	1,829	1,652	1,457	1,225	1,035	0,809
J	35	↓	↓	↓	↓	↓	↓	2,399	2,289	2,160	2,028	1,862	1,684	1,476	1,311	1,118	0,912
K	50	↓	↓	↓	↓	↓	2,569	2,461	2,336	2,209	2,052	1,885	1,693	1,543	1,372	1,193	0,947
L	70	↓	↓	↓	↓	2,736	2,631	2,510	2,389	2,239	2,082	1,904	1,710	1,526	1,322	↑	↑
M	95	↓	↓	↓	2,889	2,787	2,670	2,553	2,410	2,261	2,093	1,913	1,745	1,559	↑	↑	↑
N	125	↓	↓	3,037	2,937	2,824	2,711	2,574	2,432	2,274	2,105	1,949	1,779	↑	↑	↑	↑
P	160	↓	3,179	3,082	2,973	2,865	2,733	2,597	2,447	2,288	2,141	1,984	↑	↑	↑	↑	↑
Q	200	3,310	3,215	3,109	3,004	2,877	2,747	2,603	2,452	2,313	2,165	↑	↑	↑	↑	↑	↑
R	250	3,442	3,350	3,247	3,146	3,023	2,898	2,760	2,616	2,485	2,345	↑	↑	↑	↑	↑	↑

NOTE 1 The sample-size code letters in this International Standard correspond to those given in ISO 2859-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100 % inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

Table B.3 — Single sampling plans for reduced inspection (master table): "s" method

Code letter	Sample size	Acceptance quality limit % nonconforming															
		0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
		k	k	k	k	k	k	k	k	k	k	k	k	k	k	k	k
B - D	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,954	0,907	0,818	0,526	0,023
E	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,163	1,119	1,046	0,853	0,580	0,099
F	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,395	1,348	1,275	1,108	0,902	0,587	0,161
G	9	↓	↓	↓	↓	↓	↓	↓	↓	1,615	1,566	1,494	1,338	1,159	0,907	0,597	0,368
H	13	↓	↓	↓	↓	↓	↓	↓	1,830	1,782	1,712	1,565	1,405	1,189	0,938	0,763	0,461
J	18	↓	↓	↓	↓	↓	↓	2,025	1,978	1,910	1,770	1,622	1,429	1,212	1,065	0,823	0,619
K	25	↓	↓	↓	↓	↓	2,215	2,168	2,102	1,969	1,829	1,652	1,457	1,329	1,123	0,955	0,809
L	35	↓	↓	↓	↓	2,399	2,353	2,289	2,160	2,028	1,862	1,684	1,569	1,387	1,242	1,118	↑
M	50	↓	↓	↓	2,569	2,524	2,461	2,336	2,209	2,052	1,885	1,778	1,612	1,481	1,372	↑	↑
N	70	↓	↓	2,736	2,692	2,631	2,510	2,389	2,239	2,082	1,982	1,829	1,710	1,611	↑	↑	↑
P	95	↓	2,889	2,846	2,787	2,670	2,553	2,410	2,261	2,167	2,023	1,913	1,822	↑	↑	↑	↑
Q	125	3,037	2,995	2,937	2,824	2,711	2,574	2,432	2,344	2,208	2,105	2,021	↑	↑	↑	↑	↑
R	160	3,139	3,082	2,973	2,865	2,733	2,597	2,513	2,385	2,288	2,209	↑	↑	↑	↑	↑	↑

NOTE 1 The sample-size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100 % inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

Tablas C

Table C.1 — Single sampling plans for normal inspection (master table): "σ" method

Code letter	Sample size	Acceptance quality limit % nonconforming															
		0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
		k	k	k	k	k	k	k	k	k	k	k	k	k	k	k	k
B	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,620	0,478	0,273
C	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,991	0,841	0,643	0,412
D	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,296	1,148	0,964	0,760	0,478	
E	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	1,578	1,432	1,256	1,068	0,818	0,528	
F	8	↓	↓	↓	↓	↓	↓	↓	↓	1,821	1,682	1,517	1,344	1,121	0,872	0,564	
G	10	↓	↓	↓	↓	↓	↓	↓	2,030	1,897	1,742	1,581	1,378	1,157	0,893	0,675	
H	12	↓	↓	↓	↓	↓	↓	↓	2,223	2,096	1,949	1,800	1,613	1,412	1,179	0,991	0,771
J	15	↓	↓	↓	↓	↓	2,410	2,289	2,150	2,009	1,835	1,650	1,439	1,273	1,082	0,879	
K	18	↓	↓	↓	↓	2,576	2,459	2,327	2,193	2,029	1,857	1,662	1,511	1,340	1,162	0,919	
L	21	↓	↓	↓	2,738	2,627	2,500	2,374	2,218	2,057	1,876	1,737	1,582	1,422	1,210	↑	
M	25	↓	↓	↓	2,890	2,783	2,661	2,540	2,393	2,240	2,070	1,941	1,797	1,650	1,459	↑	↑
N	32	↓	↓	3,041	2,937	2,820	2,704	2,563	2,419	2,258	2,136	2,001	1,866	1,690	↑	↑	↑
P	40	↓	3,186	3,086	2,974	2,862	2,727	2,589	2,436	2,321	2,194	2,068	1,905	↑	↑	↑	↑
Q	50	3,319	3,222	3,113	3,005	2,875	2,742	2,596	2,487	2,367	2,247	2,094	↑	↑	↑	↑	↑
R	65	3,359	3,254	3,150	3,025	2,897	2,758	2,653	2,539	2,426	2,281	↑	↑	↑	↑	↑	↑

NOTE 1 The sample-size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100 % inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

Table C.2 — Single sampling plans for tightened inspection (master table): "σ" method

Code letter	Sample size	Acceptance quality limit % nonconforming															
		0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
		k	k	k	k	k	k	k	k	k	k	k	k	k	k	k	k
B	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
C	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
D	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
E	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
F	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
G	10	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
H	12	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
J	15	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
K	18	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
L	21	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
M	25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
N	32	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
P	40	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Q	50	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
R	65	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓

NOTE 1 The sample-size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100 % inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

Table C.3 — Single sampling plans for reduced inspection (master table): "σ" method

Code letter	Sample size	Acceptance quality limit % nonconforming															
		0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
		k	k	k	k	k	k	k	k	k	k	k	k	k	k	k	k
B - D	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
E	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
F	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
G	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
H	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
J	10	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
K	12	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
L	15	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
M	18	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
N	21	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
P	25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Q	32	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
R	40	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓

NOTE 1 The sample-size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100 % inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

## Tablas D

**Table D.1 — Values of  $f_s$  for maximum sample standard deviation for combined control of double specification limits: normal inspection, "s" method**

Code letter	Acceptance quality limit % nonconforming															
	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
	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$
B	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,474	0,507	0,595
C	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,376	0,393	0,481
D	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,314	0,331	0,357	0,396
E	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,274	0,289	0,310	0,338	0,386	0,464
F	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,245	0,257	0,274	0,295	0,328	0,375	0,457
G	↓	↓	↓	↓	↓	↓	↓	↓	0,224	0,234	0,248	0,264	0,289	0,321	0,372	0,426
H	↓	↓	↓	↓	↓	↓	↓	0,206	0,215	0,227	0,240	0,259	0,283	0,317	0,351	0,401
J	↓	↓	↓	↓	↓	↓	0,192	0,200	0,209	0,220	0,235	0,254	0,279	0,302	0,335	0,376
K	↓	↓	↓	↓	↓	0,180	0,187	0,195	0,205	0,217	0,232	0,252	0,269	0,292	0,320	0,368
L	↓	↓	↓	↓	0,170	0,176	0,183	0,191	0,202	0,214	0,230	0,243	0,261	0,281	0,312	↑
M	↓	↓	↓	0,162	0,167	0,174	0,180	0,189	0,200	0,213	0,224	0,237	0,253	0,276	↑	↑
N	↓	↓	0,155	0,160	0,165	0,171	0,179	0,188	0,199	0,208	0,219	0,231	0,249	↑	↑	↑
P	↓	0,149	0,153	0,158	0,163	0,170	0,177	0,187	0,194	0,203	0,213	0,227	↑	↑	↑	↑
Q	0,143	0,147	0,152	0,156	0,162	0,169	0,177	0,183	0,191	0,199	0,211	↑	↑	↑	↑	↑
R	0,142	0,146	0,150	0,155	0,161	0,168	0,174	0,180	0,187	0,197	↑	↑	↑	↑	↑	↑

NOTE The MSSD is obtained by multiplying the standardized MSSD  $f_s$  by the difference between the upper specification limit  $U$  and the lower specification limit  $L$ , i.e.  $MSSD = (U - L)f_s$ .

The above MSSDs indicate the greatest allowable magnitudes of the sample standard deviation under normal inspection when using plans for combined control of double specification when the process variability is unknown. If the sample standard deviation is less than the MSSD then there is a possibility, but not a certainty, that the lot will be accepted.

**Table D.2 — Values of  $f_s$  for maximum sample standard deviation for combined control of double specification limits: tightened inspection, "s" method**

Code letter	Acceptance quality limit % nonconforming															
	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
	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$
B	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,474	0,507
C	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,376	0,393	0,425
D	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,314	0,331	0,357	0,396
E	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,274	0,289	0,310	0,338	0,386	0,464
F	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,245	0,257	0,274	0,295	0,328	0,375	0,457
G	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,224	0,234	0,248	0,264	0,289	0,321	0,372
H	↓	↓	↓	↓	↓	↓	↓	↓	0,206	0,215	0,227	0,240	0,259	0,283	0,317	0,368
J	↓	↓	↓	↓	↓	↓	↓	0,192	0,200	0,209	0,220	0,235	0,254	0,279	0,313	0,355
K	↓	↓	↓	↓	↓	↓	0,180	0,187	0,195	0,205	0,217	0,232	0,252	0,277	0,307	0,348
L	↓	↓	↓	↓	↓	0,170	0,176	0,183	0,191	0,202	0,214	0,230	0,249	0,271	0,299	↑
M	↓	↓	↓	↓	0,162	0,167	0,174	0,180	0,189	0,200	0,213	0,228	0,245	0,266	↑	↑
N	↓	↓	↓	0,155	0,160	0,165	0,171	0,179	0,188	0,199	0,212	0,225	0,241	↑	↑	↑
P	↓	↓	0,149	0,153	0,158	0,163	0,170	0,177	0,187	0,197	0,208	0,222	↑	↑	↑	↑
Q	↓	0,143	0,147	0,152	0,156	0,162	0,169	0,177	0,186	0,196	0,206	↑	↑	↑	↑	↑
R	0,138	0,142	0,146	0,150	0,155	0,161	0,168	0,176	0,184	0,193	↑	↑	↑	↑	↑	↑

NOTE The MSSD is obtained by multiplying the standardized MSSD  $f_s$  by the difference between the upper specification limit  $U$  and the lower specification limit  $L$ , i.e.  $MSSD = (U - L)f_s$ .

The above MSSDs indicate the greatest allowable magnitudes of the sample standard deviation under tightened inspection when using plans for combined control of double specification when the process variability is unknown. If the sample standard deviation is less than the MSSD then there is a possibility, but not a certainty, that the lot will be accepted.

**Table D.3 — Values of  $f_s$  for maximum sample standard deviation for combined control of double specification limits: reduced inspection, "s" method**

Code letter	Acceptance quality limit % nonconforming															
	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
	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$	$f_s$
B-D	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,474	0,485	0,507	0,595	0,849
E	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,376	0,382	0,393	0,425	0,481	0,625
F	↓	↓	↓	↓	↓	↓	↓	↓	↓	0,314	0,320	0,331	0,357	0,396	0,471	0,623
G	↓	↓	↓	↓	↓	↓	↓	↓	0,274	0,280	0,289	0,310	0,338	0,386	0,464	0,542
H	↓	↓	↓	↓	↓	↓	↓	0,245	0,250	0,257	0,274	0,295	0,328	0,375	0,416	0,507
J	↓	↓	↓	↓	↓	↓	0,224	0,228	0,234	0,248	0,264	0,289	0,321	0,347	0,399	0,455
K	↓	↓	↓	↓	↓	0,206	0,210	0,215	0,227	0,240	0,259	0,283	0,301	0,335	0,368	0,401
L	↓	↓	↓	↓	0,192	0,195	0,200	0,209	0,220	0,235	0,254	0,267	0,291	0,313	0,335	↑
M	↓	↓	↓	0,180	0,183	0,187	0,195	0,205	0,217	0,232	0,243	0,261	0,277	0,292	↑	↑
N	↓	↓	0,170	0,173	0,176	0,183	0,191	0,202	0,214	0,223	0,237	0,249	0,261	↑	↑	↑
P	↓	0,162	0,164	0,167	0,174	0,180	0,189	0,200	0,207	0,219	0,228	0,237	↑	↑	↑	↑
Q	0,155	0,157	0,160	0,165	0,171	0,179	0,188	0,194	0,203	0,212	0,219	↑	↑	↑	↑	↑
R	0,150	0,153	0,158	0,163	0,170	0,177	0,183	0,191	0,197	0,203	↑	↑	↑	↑	↑	↑

NOTE The MSSD is obtained by multiplying the standardized MSSD  $f_s$  by the difference between the upper specification limit  $U$  and the lower specification limit  $L$ , i.e.  $MSSD = (U - L)f_s$ .

The above MSSDs indicate the greatest allowable magnitudes of the sample standard deviation under reduced inspection when using plans for combined control of double specification when the process variability is unknown. If the sample standard deviation is less than the MSSD then there is a possibility, but not a certainty, that the lot will be accepted.

**Tabla E**

**Table E.1 — Values of  $f_\sigma$  for maximum process standard deviation for combined control of double specification limits: "σ" method**

Acceptance quality limit % nonconforming	$f_\sigma$
0,010	0,125
0,015	0,129
0,025	0,132
0,040	0,137
0,065	0,141
0,10	0,147
0,15	0,152
0,25	0,157
0,40	0,165
0,65	0,174
1,0	0,184
1,5	0,194
2,5	0,206
4,0	0,223
6,5	0,243
10,0	0,271

Tablas G

Table G.1 — Form p\* single sampling plans for normal inspection (master table): "s" and "c" methods

Code letter	Sample size		Acceptance quality limit (in percent nonconforming)															
	n <sub>s</sub>	n <sub>c</sub>	0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
			100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*
B	3	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
C	4	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
D	6	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
E	9	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
F	13	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
G	18	10	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
H	25	12	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
J	35	15	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
K	50	18	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
L	70	21	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
M	95	25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
N	125	32	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
P	160	40	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Q	200	50	0,03998	0,05689	0,08333	0,1202	0,1842	0,2801	0,4366	0,6007	0,8397	1,161	1,720	2,498	3,698	5,879	9,249	14,82
R	250	65	0,03553	0,05209	0,07495	0,1151	0,1750	0,2729	0,3753	0,5245	0,7258	1,076	1,612	2,685	4,301	6,827	10,74	17,20

NOTE 1 The sample size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1 and ISO 3951-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100% inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

Table G.2 — Form p\* single sampling plans for tightened inspection (master table): "s" and "c" methods

Code letter	Sample size		Acceptance quality limit (in percent nonconforming)															
	n <sub>s</sub>	n <sub>c</sub>	0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
			100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*	100 p*
B	3	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
C	4	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
D	6	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
E	9	6	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
F	13	8	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
G	18	10	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
H	25	12	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
J	35	15	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
K	50	18	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
L	70	21	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
M	95	25	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
N	125	32	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
P	160	40	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Q	200	50	0,03998	0,05689	0,08333	0,1202	0,1842	0,2801	0,4366	0,6798	1,001	1,481	2,311	3,698	5,879	9,249	14,82	22,87
R	250	65	0,02501	0,03553	0,05209	0,07495	0,1151	0,1750	0,2729	0,4249	0,6242	0,9242	1,404	2,149	3,356	5,154	7,754	11,81

NOTE 1 The sample size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1 and ISO 3951-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100% inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

Table G.3 — Form  $p^*$  single sampling plans for reduced inspection (master table): “s” and “σ” methods

Code letter	Sample size $n_s$ $n_r$		Acceptance quality limit (in percent nonconforming)															
			0,01	0,015	0,025	0,04	0,065	0,10	0,15	0,25	0,40	0,65	1,0	1,5	2,5	4,0	6,5	10,0
			$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$	$100 p^*$
B - D	3	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	19,05	21,24	24,94	34,95	49,37
E	4	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	11,23	12,70	15,13	21,57	30,67	46,70
F	6	4	↓	↓	↓	↓	↓	↓	↓	↓	↓	6,724	7,671	9,246	13,29	19,02	29,03	44,10
G	9	6	↓	↓	↓	↓	↓	↓	↓	↓	4,196	4,819	5,833	8,437	12,12	18,52	28,13	36,16
H	13	8	↓	↓	↓	↓	↓	↓	↓	2,578	2,967	3,605	5,245	7,537	11,54	17,54	22,56	32,59
J	18	10	↓	↓	↓	↓	↓	↓	1,620	1,867	2,275	3,323	4,782	7,315	11,12	14,32	20,68	27,03
K	25	12	↓	↓	↓	↓	↓	1,012	1,171	1,428	2,084	3,010	4,603	7,010	9,014	13,02	17,02	21,03
L	35	15	↓	↓	↓	↓	0,6299	0,7296	0,8900	1,304	1,880	2,880	4,379	5,628	8,125	10,62	13,14	↑
M	50	18	↓	↓	↓	0,4021	0,4656	0,5690	0,8335	1,203	1,840	2,800	3,604	5,201	6,808	8,406	↑	↑
N	70	21	↓	↓	0,2511	0,2909	0,3553	0,5209	0,7500	1,160	1,756	2,254	3,251	4,251	5,255	↑	↑	↑
P	95	25	↓	0,1593	0,1847	0,2254	0,3304	0,4765	0,7298	1,110	1,829	2,066	2,699	3,336	↑	↑	↑	↑
Q	125	32	0,1001	0,1161	0,1421	0,2081	0,3005	0,4602	0,7006	0,8992	1,301	1,709	2,098	↑	↑	↑	↑	↑
R	160	40	0,07248	0,08893	0,1302	0,1874	0,2875	0,4381	0,5628	0,8129	1,062	1,311	↑	↑	↑	↑	↑	↑

NOTE 1 The sample size code letters in this part of ISO 3951 correspond to those given in ISO 2859-1 and ISO 3951-1.

NOTE 2 Symbols: ↓ There is no suitable plan in this area; use the first sampling plan below the arrow. If the sample size equals or exceeds the lot size, carry out 100 % inspection.  
 ↑ There is no suitable plan in this area; use the first sampling plan above the arrow.

Tabla H

Table H.1 — Values of  $c_u$  for upper control limit on the sample standard deviation

Sample size $n$	Factor $c_u$	Sample size $n$	Factor $c_u$	Sample size $n$	Factor $c_u$	Sample size $n$	Factor $c_u$
2	2,800	10	1,617	25	1,377	70	1,221
3	2,297	12	1,558	32	1,331	95	1,189
4	2,065	13	1,534	35	1,316	125	1,165
6	1,827	15	1,494	40	1,295	160	1,145
8	1,700	18	1,448	50	1,263	200	1,130
9	1,654	21	1,413	65	1,230	250	1,116



**Tabla I**

**Table I.1 — Supplementary acceptability constants for qualifying towards reduced inspection**

Sample size code letter	AQL %	Acceptability constant for AQL that is one step tighter	
		"s" method	" $\sigma^p$ " method
		<i>k</i>	<i>k</i>
B	4,0	1,118	0,829
C	2,5	1,325	1,201
D	1,5	1,516	1,452
E	1,0	1,740	1,735
F	0,65	1,967	1,989
G	0,40	2,153	2,185
H	0,25	2,350	2,384
J	0,15	2,503	2,532
K	0,10	2,678	2,702
L	0,065	2,856	2,875
M	0,040	3,002	3,018
N	0,025	3,157	3,176
P	0,015	3,272	3,290
Q	0,01	3,407	3,426
R	0,01	3,448	3,466