INTERNATIONAL STANDARD

ISO 3951-1

Second edition
2013-09-01

Corrected version
2016-12-15

Sampling procedures for inspection by variables —

Part 1: Specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection for a single quality characteristic and a single AQL

Règles d'échantillonnage pour les contrôles par mesures —

Partie 1: Spécification pour les plans d'échantillonnage simples indexés d'après une limite de qualité acceptable (LQA) pour un contrôle lot par lot pour une caractéristique-qualité unique et une LQA unique

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Reference number
ISO 3951-1:2013(E)

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ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 69, *Application of statistical methods,* SC 5, *Acceptance sampling.*

This second edition cancels and replaces the first edition (ISO 3951-1:2006), of which it constitutes a minor revision with the following changes:

— procedures have been introduced to accommodate measurement uncertainty;

— many of the sampling plans have been adjusted to improve the match between their operating characteristic curves and the operating characteristic curves of the corresponding plans for single sampling by attributes in ISO 2859-1.

ISO 3951 consists of the following parts, under the general title *Sampling procedures for inspection by variables*:

— *Part 1: Specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection for a single quality characteristic and a single AQL*

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

— *Part 3: Double sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

— *Part 4: Procedures for assessment of declared quality levels*

— *Part 5: Sequential sampling plans indexed by acceptance quality limit (AQL) for inspection by variables (known standard deviation)*

This corrected version of ISO 3951-1:2013 incorporates the following corrections:

— Clause 4, process mean (6th line): the symbol "m" has been replaced with "μ", and "process mean" has been replaced with "unknown process mean";

— 16.2, before Example 1: "$Q_U \leq k$" and "$Q_L \leq k$" have been replaced with "$Q_U < k$" and "$Q_L < k$";

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— 16.4.2, Formula (4): "$\left[\sqrt{(1-Q\sqrt{3}\ /\ 2)\ /\ 2}\right]$" has been replaced with "$\left[\sqrt{(1-Q\sqrt{3}\ /\ 2)\ /\ 2}\right]$";

— 17.2, Example: "it is seen that for an AQL of 1,0 %" has been replaced with "it is seen that for an AQL of 0,65 %";

— N.2, Formula (N.2): "$\left[(1\ -\ Q\sqrt{3}\ /\ 2)\ 2\right]$" has been replaced with "$\left[(1\ -\ Q\sqrt{3}\ /\ 2)\ /\ 2\right]$";

— O.4, Formula (O.6): in the fourth line, the question mark has been replaced with a "0", thus correcting a typographic error.

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Introduction

This part of ISO 3951 specifies an acceptance sampling system of single sampling plans for inspection by variables. It is indexed in terms of the acceptance quality limit (AQL) and is designed for users who have simple requirements. (A more comprehensive and technical treatment is given in ISO 3951-2.) This part of ISO 3951 is complementary to ISO 2859-1.

The objectives of the methods laid down in this part of ISO 3951 are to ensure that lots of acceptable quality have a high probability of acceptance and that the probability of not accepting inferior lots is as high as practicable. This is achieved by means of the switching rules, which provide the following:

a) an automatic protection to the consumer (by means of a switch to tightened inspection or discontinuation of sampling inspection) should a deterioration in quality be detected;

b) an incentive (at the discretion of the responsible authority) to reduce inspection costs (by means of a switch to a smaller sample size) should consistently good quality be achieved.

In this part of ISO 3951, the acceptability of a lot is implicitly determined from an estimate of the percentage of nonconforming items in the process, based on a random sample of items from the lot.

This part of ISO 3951 is intended for application to a continuing series of lots of discrete products all supplied by one producer using one production process. If there are different producers or production processes, this part of ISO 3951 is applied to each one separately.

This part of ISO 3951 is intended for application to a single quality characteristic that is measurable on a continuous scale. For two or more such quality characteristics, see ISO 3951-2.

It is assumed in the body of this part of ISO 3951 that measurement error is negligible (see ISO 10576-1:2003). For information on allowing for measurement error, see Annex O, which was derived from Reference [20] in the Bibliography.

For double specification limits, this part of ISO 3951 treats combined control. For other types of control, refer to ISO 3951-2.

CAUTION — The procedures in this part of ISO 3951 **are not suitable for application to lots that have been screened for nonconforming items.**

Inspection by variables for percent nonconforming items, as described in this part of ISO 3951, includes several possible modes, the combination of which leads to a presentation that may appear quite complex to the user:

— unknown standard deviation, or originally unknown then estimated with fair precision, or known since the start of inspection;

— a single specification limit, or combined control of double specification limits;

— normal inspection, tightened inspection, or reduced inspection.

Table 1 is intended to facilitate the use this part of ISO 3951 by directing the user to the paragraphs and tables concerning any situation with which he may be confronted. The table only deals with Clauses 15, 16, 20, 21, and 22; in every case, it is necessary, first of all, to have read the other clauses.

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Table 1 — Summary table

Inspection	Single specification limit						Double specification limits with combined control					
	s–method			*σ*–method			*s*–method			*σ*–method		
	Clauses or sub-clauses	Tables/ Annexes	Charts	Clauses or sub-clauses	Tables/ Annexes	Charts	Clauses or sub-clauses	Tables/ Annexes	Charts	Clauses or sub-clauses	Tables/ Annexes	Charts
Normal inspection	16.1, 16.2, 16.3, 21.1	A.1, B.1, B to R	B to R	17.1, 17.2, 21.1	A.1, C.1, B to R[a]	B to R[a]	16.1, 16.4, 21.1	A.1, D.1, E.1 (for n = 3), G.1 (for n = 3 or 4), B to R[a]	*s*-D to *s*-R, B to R[a]	17.1, 17.3 and 21.1	A.1, C.1, E.1, B to R[a]	B to R[a]
Switching between normal and tightened inspection	21.2, 21.3	B.1, B.2	B to R	21.2, 21.3	C.1, C.2	B to R[a]	21.2, 21.3	D.1, D.2	*s*-D to *s*-R, B to R[a]	21.2, 21.3	C.1, C.2, E.1	B to R[a]
Switching between normal and reduced inspection	21.4, 21.5	B.1, B.3	B to R	21.4, 21.5	C.1, C.3, I	B to R[a]	21.4, 21.5	D.1, D.3, G.1 (for n = 3 or 4)	*s*-D to *s*-R, B to R[a]	21.4, 21.5	C.1, C.3, E.1	B to R[a]
Switching between tightened and discontinued inspection	22	B.2	B to R	22	C.2	B to R[a]	22	D.2	*s*-D to *s*-R, B to R[a]	22	E.1	B to R[a]
Switching between the *s*-method and σ-method	23	Annex J		23	Annex J		23	Annex J		23	Annex E, Annex J	

[a] But see 8.4.

Fifteen annexes are provided. Annexes A to I provide the tables needed to support the procedures. Annex J indicates how the sample standard deviation, s, and the presumed known value of the process standard deviation, σ, should be determined. Annex K provides the statistical theory underlying the calculation of the consumer's risk qualities, together with tables showing these quality levels for normal, tightened, and reduced inspection as well as for the s–method and σ–method. Annex L provides similar information for the producer's risks. Annex M gives the general formula for the operating characteristic of the σ–method. Annex N provides the statistical theory underlying the estimation of the process fraction nonconforming under the s–method for sample sizes 3 and 4, which, for technical reasons, are treated differently from the other sample sizes in this part of ISO 3951. Annex O provides procedures for accommodating measurement uncertainty.

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