


 <small>A JOULON COMPANY</small>	Submitted by ENGINEERING					SARA/DOC/0042			
	Title: Sampling Plan					Page 01 of 01			
Release Date	22-Sep-20		Responsibility			Quality			
Revision no.	1								
Signature			Created by		Released By.		Approved By.		
									
Departments			Jaypal Singh (Asst. MR)		Sanjeev Kumar (Quality Manager/ MR)		Arun Semwal (Engineering Head)		

Sr No.	As per Table 1 of ISO 2859-1		As per Table 2-A of ISO 2859	Acceptance Quality Limit AQL , in percent of non conforming items and non conformities per 100items (Normal inspection)					
	LOT SIZE	Sample Code	SAMPLE Size	1.5		2.5		4	
				Ac	Re	Ac	Re	Ac	Re
1	2 TO 8	A	2	0	1	0	1	0	1
2	9 TO 15	B	3	0	1	0	1	0	1
3	16 TO 25	C	5	0	1	0	1	0	1
4	26 TO 50	D	8	0	1	0	1	1	2
5	51 TO 90	E	13	0	1	1	2	1	2
6	91 TO 150	F	20	1	2	1	2	2	3
7	151 TO 280	G	32	1	2	2	3	3	4
8	281 TO 500	H	50	2	3	3	4	5	6
9	501 TO 1200	J	80	3	4	5	6	7	8
10	1201 TO 3200	K	125	5	6	7	8	10	11
11	3201 TO 10 000	L	200	7	8	10	11	14	15
12	10 001 TO 35 000	M	315	10	11	14	15	21	22
13	35 001 TO 150 000	N	500	14	15	21	22	21	22
14	150 001 TO 500 000	P	800	21	22	21	22	21	22
15	500 001 and over	Q	1250	21	22	21	22	21	22

Description	Quantity to Check	Allowed Quantity of Defectives
LPT Threads Gauging Inspection – Hammer Union	100%	0
All Threads Gauging Inspection – Flanges	100%	0
Hardness of flanges	100%	0
All Machining items Visual Inspection	100%	0

Note :

Ac – Acceptance number is number of non conformity , to accept the lot with less or equal to said number of non conformity item(s).

Re – Rejection number is number of non conformity, to reject the lot with more or equal to said number of non conformity item(s).

Instructions :

- Follow Level-II,1.5AQL for Dimensional Inspection.
- Follow Level II , 2.5AQL for 'O' rings & 1.5AQL for other seals dimensional inspection.
- Follow Level-II,4 AQL for Hardness Inspection.
- Follow the Instruction for all products unless otherwise specified by the customer for particular products.
- In case If lot size is bigger than lot size mentioned in above table please communicate with Quality Head.