

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		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 10000	L	200	7	8	10	11	14	15
12	10 001 TO 35000	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 :

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