

		Submitted by	ENGINEERING		SARA/DOC/0042
		Title:	Sampling Plan		
Release Date	17-Apr-10	Responsibility		Quality	Page 01 of 01
Revision no.	0				
Signature		Created by		Released By.	Approved By.
Departments		Arun Semwal (Engineering)		J. M. Singh (Quality Manager)	K. K. Dhiman (Engineering Manager)

SAMPLING PLAN - in line with ISO 2859 - 1, Level -II, 4 Acceptance quality level

Batch size	Quantity to Check	Allowed Quantity of Defectives
2 to 8	2	0
9 to 15	2	0
16 to 25	3	0
26 to 50	5	0
51 to 100	5	0
101 to 150	8	0
151 to 300	13	1
301 to 500	13	2
501 to 1000	20	3
1001 to 3000	32	3
3001 to 10000	32	3

LPT threads –hammer unions	100%	0
LPT / EUE threads – Flanges	100%	0
Hardness of flanges	100%	0

Machining items (Visual)

Gaskets, Unions, Flanges, swivel joints	100%	0
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