



SAMPLING PLAN FOR INWARD, INPROCESS AND FINAL INSPECTION

IS2500 PART - I FOR VISUAL INSPECTION

Lot Size	Sample Qty
8 TO 15	2
16 TO 25	3
26 TO 90	5
91 TO 150	8
151 TO 280	13
281 TO 500	20
501 TO 1200	32
1201 TO 3200	50
3201 TO 10000	80
10001 TO 35000	125
35001 TO 150000	200
150001 TO 500000	315
500001 TO 10000000000	500

* ACCEPTANCE CRITERIA FOR VISUAL AND ATTRIBUTE INSPECTION IS ZERO (0) DEFECT PLAN.

IS 2500 PART - II FOR DIMENSIONAL INSPECTION

Lot Size	Sample Qty
8 TO 500	3
501 TO 1000	4
1001 TO 3000	5
3001 TO 10000	7
10001 TO 10000000000	10

Sampling Plan for Raw Material

Lot Size	Sample Qty
Less than 1000 Kg	25 Kg
1000 Kg to 5000 Kg	75 Kg
5000 Kg to 15000 Kg	125 Kg
15000 Kg to 25000 Kg	200 Kg
More Than 25000 Kg	275 Kg

Note : As per sampling plan, if single component / raw material lot found defective -

- 1) Lot decision is rejected,
- 2) Accepted under Deviation
- 3) Segregation
- 4) Rework & reinspection.

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