

BASIC KNOWLEDGE

IMPROVEMENT CASE

TROUBLE CASE

PREPARED BY:  
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APPROVED BY:  
Mr. Bharat D

BEFORE

Accrete, E-31 Sampling Plan Rev-01 Date: 04-06-2024

AS PER IS STANDARD - IS 9001:2015

Sr. No.	LOT SIZE	SAMPLING SIZE	
		LEVEL-S4	LEVEL-II
01	02 TO 08	02	02
02	09 TO 15	02	02
03	16 TO 25	03	03
04	26 TO 50	05	08
05	51 TO 90	05	13
06	91 TO 150	08	20
07	151 TO 250	13	32
08	251 TO 500	13	50
09	501 TO 1200	20	80
10	1201 TO 3200	32	125
11	3201 TO 10000	32	200
12	10001 TO 35000	50	315

1) For visual inspection select the samples from LEVEL-II.  
2) For dimensional inspection select the samples from LEVEL-S4.  
3) If the nos of accepted samples are equal to the sample size lot shall be accepted.  
4) If the nos of accepted samples are less than the sample size lot shall be rejected.  
A 100% inspection to be carried out for those rejected lots.

*ack*  
04/06/24

AFTER

Accrete, E-31 Sampling Plan Rev-01 Date: 10-06-2024

AS PER IS STANDARD - IS 9001:2015

Sr. No.	LOT SIZE	SAMPLING SIZE	
		LEVEL-S4	LEVEL-II
01	02 TO 08	04	02
02	09 TO 15	04	02
03	16 TO 25	06	05
04	26 TO 50	10	08
05	51 TO 90	10	13
06	91 TO 150	16	20
07	151 TO 250	26	32
08	251 TO 500	26	50
09	501 TO 1200	40	80
10	1201 TO 3200	64	125
11	3201 TO 10000		200
12	10001 TO 35000		315

1) For visual inspection select the samples from LEVEL-II.  
2) For dimensional inspection select the samples from LEVEL-S4.  
3) If the nos of accepted samples are equal to the sample size lot shall be accepted.  
4) If the nos of accepted samples are less than the sample size lot shall be rejected.  
A 100% inspection to be carried out for those rejected lots.

*ack*  
10/06/24

07	151 TO 250	26	32
08	251 TO 500	26	50
09	501 TO 1200	40	80
10	1201 TO 3200	64	125

Before: final inspection Run out Parameter Inspection frequency set As Sampling Plan 13/500 Nos. is not adhequte to detect

After: final inspection Run out Parameter Inspection frequency set As Sampling Plan 26/500 Nos.