



BEFORE

AFTER

Accrete, E-31		Sampling Plan		Rev-00 Date-04-08-2022
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	05	
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.
 & 100% inspection to be carried out for these rejected lots.

act
04/08/22

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.
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act
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 Threading Parameter Inspection frequency set
As Sampling Plan 13/500 Nos. is not adhequite to detect

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