
**Postopki vzorčenja za kontrolo po številskih spremenljivkah – 1. del:
Specifikacija enojnih vzorčnih načrtov, razvrščenih po prevzemni meji
kakovosti (AQL), za kontrolo zaporednih partij za posamezno karakteristiko
kakovosti in posamezni AQL**

(istoveten ISO 3951-1:2005)

Sampling procedures for inspection by variables - Part 1: Specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection for a single quality characteristic and a single AQL

**Sampling procedures for inspection by
variables —**

Part 1:

**Specification for single sampling plans
indexed by acceptance quality limit (AQL)
for lot-by-lot inspection for a single
quality characteristic and a single AQL**

Règles d'échantillonnage pour les contrôles par mesures —

*Partie 1: Spécifications pour les plans d'échantillonnage simples
indexés d'après le niveau de qualité acceptable (NQA) pour le contrôle
lot par lot pour une caractéristique de qualité unique et un NQA unique*



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ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 3951-1 was prepared by Technical Committee ISO/TC 69, *Applications of statistical methods*, Subcommittee SC 5, *Acceptance sampling*.

This first edition of ISO 3951-1 cancels and replaces ISO 3951:1989, of which it constitutes a technical revision. The most significant differences between ISO 3951-1:2003 and ISO 3951:1989 are as follows.

- The acronym AQL now stands for Acceptance Quality Limit rather than Acceptable Quality Level, in order to reflect more accurately its function.
- The coverage of this part of ISO 3951 is constrained to a single, normally distributed variable with a single class of nonconformity. This part of ISO 3951 includes the case of combined control of double specification limits, but procedures for separate or complex control of double specification limits are deferred to ISO 3951-2. More general procedures that can be used for multiple characteristics and/or multiple AQLs are also given in ISO 3951-2.
- The plans have been modified so that their operating characteristic curves more closely match those of the plans in ISO 2859-1. The sample sizes for both the “*s*” method and the “ σ ” method are constant along rows of the master tables.
- All acceptability constants (see Annexes B, C, G and I) have been revised and tabulated to three decimal places for an extended range of AQLs corresponding to ISO 2859-1:1999.
- All tabulated values of operating characteristics have been recalculated and related directly to reduced inspection as well as to normal and tightened inspection.
- The annex containing the general statistical theory has been removed. It is planned ultimately to reintroduce this within a guidance document to sampling procedures for inspection by variables.
- Tables that are required for implementing the procedures have been relocated into annexes.
- The annex dealing with the “*R*” method has been eliminated, now that the availability of calculators with a standard deviation function key is so widespread. Data for acceptance sampling by variables is often substantially more expensive to acquire than data for sampling by attributes, and the “*s*” method makes more efficient use of this data.

ISO 3951-1:2005(E)

ISO 3951 currently consists of the following parts, under the general title *Sampling procedures for inspection by variables*:

- *Part 1: Specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection for a single quality characteristic and a single AQL*
- *Part 2: General specification for single sampling plans indexed by acceptance quality limit (AQL) for lot-by-lot inspection of independent quality characteristics*

The following parts are under preparation:

- *Part 3: Double sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*
- *Part 5: Sequential sampling plans indexed by acceptance quality limit (AQL) for inspection by variables*