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PR0302
Procédure d'échantillonnage
Sampling procedure

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Revisions

Date	Rev	Modification	Modified by:	Approved by:
2010-09-29	00	Initial release	-	-
2017-09-01	01	Add template of procedure Revised the level reference	L.P.M	D.C
2017-11-23	02	Add new template and new logo of CVT corp	R.T	R.T B.P

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The sampling procedure which based on the standard MIL-STD-105E establishes a sampling plan with tables of reference, to be used in the planning and conducting of inspections area listed below:

Department:

Receiving inspection

Purchased parts

Raw Material

In-Process inspection

Primary parts

Minor sub-assemblies

Acceptance Level:

The acceptance quality level used is **1.0**.

The single sampling plan is used with normal inspection.

If the size of the sample is equal to or exceeds the size of the lot or batch, do a 100% sampling.

AC: Accept lot if parts found defective in sample size are equal to or less than the number indicated.

RE: Reject lot if parts found defective in sample size are equal to or more than the number indicated.

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How to use tables :

Samples are drawn from a lot or batch, and selected at random without regard to their quality; in such a manner to represent the entire production of the lot or batch.

- Determine the lot or batch size from the material. The size shall be the total amount presented.
- With the inspection level determined below, select the appropriate code letter.
- With the code letter, select the sample size.
- With the instructions at the bottom of the table, proceed with the inspection in such a manner so as to either accept or reject the lot or batch.

The usual procedures will follow the acceptance or rejection of the lot or batch.

Lot or batch size	Inspection Level				Sample code letter	Size of Sample	1.0	
	S3	1	2	3			AC	RE
2 to 8	A	A	A	100%	A	2	0	1
9 to 15	A	A	B		B	3	0	1
16 to 25	B	B	C		C	5	0	1
26 to 50	B	C	D	100%	D	8	0	1
51 to 90	C	C	E		E	13	0	1
91 to 150	C	D	F		F	20	0	1
151 to 280	D	E	G	100%	G	32	1	2
281 to 500	D	F	H	or	H	50	1	2
501 to 1 200	E	G	J	SPC	J	80	2	3
1 201 to 3 200	E	H	K	SPC	K	125	3	4
3 201 to 10 000	F	J	L		L	200	5	6
10 001 to 35 000	F	K	M		M	315	7	8
35 001 and more	G	N	Q	SPC	N	500	10	11
					P	800	14	15
					Q	1 250	21	22
					R	2 000	21	22

Level S3

All others

Level 1:

Key characteristic 1

Level 2:

Key characteristic 2

Level 3:

100% or SPC

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