

INSPECTION SERVICES

SAMPLE SIZE AND ACCEPTANCE QUALITY LIMIT (AQL)



Total Quality. Assured.

Edition 2018-9-28

Table I-Sample size code letters

Obtain you sample size code by referencing your lot or batch size in accordance with ANSI/ASQ Z1.4; BS 6001 / ISO 2859; DIN 40080; NF X 06-022; GB/T 2828.1.

Lot or Batch Size	Special Inspection Levels				General Inspection Levels		
	S-1	S-2	S-3	S-4	I	II	III
2~8	A	A	A	A	A	A	B
9~15	A	A	A	A	A	B	C
16~25	A	A	B	B	B	C	D
26~50	A	B	B	C	C	D	E
51~90	B	B	C	C	C	E	F
91~150	B	B	C	D	D	F	G
151~280	B	C	D	E	E	G	H
281~500	B	C	D	E	F	H	J

Lot or Batch Size	Special Inspection Levels				General Inspection Levels		
	S-1	S-2	S-3	S-4	I	II	III
501~1200	C	C	E	F	G	J	K
1201~3200	C	D	E	G	H	K	L
3201~10000	C	D	F	G	J	L	M
10001~35000	C	D	F	H	K	M	N
35001~150000	D	E	G	J	L	N	P
150001-500000	D	E	G	J	M	P	Q
500001 and over	D	E	H	K	N	Q	R

Table II-A-Single sampling plans for normal inspection

Confirm your sample size by sample size code and select suitable AQL in accordance with ANSI/ASQ Z1.4; BS 6001 / ISO 2859; DIN 40080; NF X 06-022; GB/T 2828.1.

Sample size code	Sample size	Acceptance Quality Limit																											
		0.010	0.015	0.025	0.040	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5	10	15	25	40	65	100	150	250	400	650	1000		
A	2																												
B	3																												
C	5																												
D	8																												
E	13																												
F	20																												
G	32																												
H	50																												
J	80																												
K	125																												
L	200																												
M	315																												
N	500																												
P	800																												
Q	1250																												
R	2000																												

↓ = Use the first sampling plan below the arrow. If sample size equals, or exceeds lot or batch size, carry out 100 percent inspection.

↑ = Use the first sampling plan above the arrow.

Ac=Acceptance number.

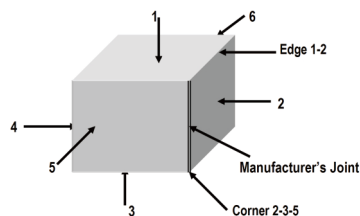
Re=Rejection number.



ON-SITE CARTON DROP TEST

Drop or impact the packaged product using below sequence with reference from the International Safe Transit Association Resource Book (2014).

Sequence #	Orientation	Specific face, edge or corner
1	Corner	most fragile face-3 corner, if not known, test 2-3-5
2	Edge	shortest edge radiating from the corner tested
3	Edge	next longest edge radiating from the corner tested
4	Edge	longest edge radiating from the corner tested
5	Face	one of the smallest faces
6	Face	opposite small face
7	Face	one of the medium faces
8	Face	opposite medium face
9	Face	one of the largest faces
10	Face	opposite large face



Packaged-Product Weight				Drop Height	
Equal to or greater than		But Less than		Free Fall	
lb	kg	lb	kg	in.	mm
0	0	21	10	30	760
21	10	41	19	24	610
41	19	61	28	18	460
61	28	100	45	12	310
100	45	150	68	8	200

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