

AQL table (ISO 2859-1): sample size and accept / reject numbers

Single sampling plans, normal inspection. Print it and keep it next to your purchase orders.

How to read the table

1. **Find the code letter** in table 1, from the lot size and the inspection level (level II unless agreed otherwise).
2. **Read the sample size** for this letter in table 2.
3. **Read Ac / Re** in the column of each AQL: if the number of defects found is $\leq$ Ac the lot is accepted, if it is $\geq$ Re the lot is rejected. Critical, major and minor defects are counted separately.

Table 1: code letter by lot size

Lot size	Level I	Level II	Level III
2 – 8	A	A	B
9 – 15	A	B	C
16 – 25	B	C	D
26 – 50	C	D	E
51 – 90	C	E	F
91 – 150	D	F	G
151 – 280	E	G	H
281 – 500	F	H	J
501 – 1,200	G	J	K
1,201 – 3,200	H	K	L
3,201 – 10,000	J	L	M
10,001 – 35,000	K	M	N
35,001 – 150,000	L	N	P
150,001 – 500,000	M	P	Q
500,001 – ...	N	Q	R

Table 2: sample size and Ac / Re by AQL (normal inspection)

Code letter	Sample size	0.065	0.10	0.15	0.25	0.40	0.65	1.0	1.5	2.5	4.0	6.5
A	2	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 / 1
B	3	↓	↓	↓	↓	↓	↓	↓	↓	↓	0 / 1	0 / 1
C	5	↓	↓	↓	↓	↓	↓	↓	↓	0 / 1	0 / 1	1 / 2
D	8	↓	↓	↓	↓	↓	↓	↓	0 / 1	0 / 1	1 / 2	1 / 2
E	13	↓	↓	↓	↓	↓	↓	0 / 1	0 / 1	1 / 2	1 / 2	2 / 3
F	20	↓	↓	↓	↓	↓	0 / 1	0 / 1	1 / 2	1 / 2	2 / 3	3 / 4
G	32	↓	↓	↓	↓	0 / 1	0 / 1	1 / 2	1 / 2	2 / 3	3 / 4	5 / 6
H	50	↓	↓	↓	0 / 1	0 / 1	1 / 2	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8
J	80	↓	↓	0 / 1	0 / 1	1 / 2	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11
K	125	↓	0 / 1	0 / 1	1 / 2	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15
L	200	0 / 1	0 / 1	1 / 2	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22
M	315	0 / 1	1 / 2	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22	↑
N	500	1 / 2	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22	↑	↑
P	800	1 / 2	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22	↑	↑	↑
Q	1,250	2 / 3	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22	↑	↑	↑	↑
R	2,000	3 / 4	5 / 6	7 / 8	10 / 11	14 / 15	21 / 22	↑	↑	↑	↑	↑

↓ use the first plan below the arrow, ↑ the first plan above, with that plan's sample size. If the sample size is equal to or larger than the lot, inspect 100 %.

Example

Lot of 5,000 units, level II → letter **L**, sample of **200** units. Usual levels for consumer goods: critical 0 (no defect tolerated), major 2.5 → accept up to **10**, reject from **11**; minor 4.0 → accept up to **14**, reject from **15**.

Simplified reproduction of ISO 2859-1 tables I and II-A (equivalent to MIL-STD-105E / ANSI Z1.4) for AQL 0.065 to 6.5. For contractual use, refer to the standard.

Try the AQL simulator

Enter your lot size and AQL levels, get the sample size and limits instantly: lpi-quality.com/faq/quality-assurance-guide · inquiries@lpi-quality.com