

DATE 4/10/58

SH. 1 OF 8

COMPILED BY
Richard Corn

TMC SPECIFICATION NO. S-365

TITLE: SAMPLING PROCEDURES FOR THE INSPECTION OF

JOB

APPROVED

INCOMING MATERIAL

1. The inspection of incoming material at THE TECHNICAL MATERIEL CORPORATION is based on accepted systems of statistical quality control. Tables of sampling procedure indicating the sampling basis used, will be provided, for the inspection of incoming materials. The application of the sampling procedures used will in no way remove any of the vendors responsibility for supplying all parts in accordance with the applicable drawings and specifications. The purpose of this sampling procedure is to provide a convenient and quick system for determining overall quality of a particular lot or shipment with reasonable surety and without 100% inspection.

2. Each table provided covers a different percentage acceptable quality level, and the sampling necessary to obtain reasonable assurance of the maintenance of this quality level.

. The appearance of the "AQL" acceptable quality level percentage on the face of a part drawing or purchase order indicates the particular sampling procedure which will be used for the inspection of incoming parts.

3. Where sample failures from incoming material shipments in excess of the failures permitted by the applicable AQL table are encountered the following shall apply.

A - The complete lot or shipment may be returned to the vendor at the vendors expense, for retest or other disposition at the vendors option. No rejected material is to be returned to THE TECHNICAL MATERIEL CORPORATION without being accompanied with satisfactory written evidence of rework and/or retest as required.

B - The lot or shipment may be retained by THE TECHNICAL MATERIEL CORPORATION and subjected to 100% inspection and/or rework at the vendors expense in order to obtain parts for the maintenance of production - where this option is elected THE TECHNICAL MATERIEL CORPORATION will supply the vendor before 100% test is started a cost estimate on the expense of 100% inspection and/or rework of the material and obtain the vendors prior approval and acceptance of charges for the application of service.

C - Any units from any lot or shipment found defective either on the basis of 100% inspection or sampling may be returned at the vendors expense for credit or replacement.

4. The reference used for the sampling tables will be MIL-STD-105B.

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TMC SPECIFICATION NO. S-365

TITLE: MULTIPLE SAMPLING PLAN

JOB

APPROVED

AQL .10%

Ref: MIL-STD-105B TABLE IV-C

SAMPLE NUMBER	1		2		3		4		5		6		7		8	
	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R
110-1300	110	0 1														
1301-3200	150	0 1														
3201-22,000	75	* 2	150	* 2	225	0 2	300	0 3	375	1 4	450	2 4	525	3 4		
22,001-110,000	100	* 2	200	0 3	300	0 3	400	1 3	500	1 4	600	1 4	700	2 4	800	3 4
110,001-500,000	150	* 2	300	0 3	450	0 4	600	1 4	750	2 5	900	3 5	1050	4 6	1200	5 6
500,000 and over	300	* 3	600	0 4	900	1 5	1200	3 6	1500	5 7	1800	6 8	2100	8 10	2400	9 10

- * - Do Not Accept Lot, Take Next Larger Sample.
- TS - Total Sample Taken.
- A - At This Number of Defectives or Below - Accept the Lot.
- R - At This Number of Defectives or Above - Reject the Lot.
- # - If the Number of Defectives Falls Between A & R, Continue Sampling.
- # - For Detailed Plans for Larger Lots Refer to MIL-STD-105B TABLE IV-C.

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TMC SPECIFICATION NO. S-365

TITLE: MULTIPLE SAMPLING PLAN

JOB

APPROVED

Ref: MIL-STD-105B TABLE IV-C

AQL .40%

SAMPLE NUMBER	1		2		3		4		5		6		7		8	
	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R
50-500	50	0 1														
501-1300	30	* 2	60	0 2	90	0 2	120	0 2	150	1 3	180	1 3	210	2 3		
1301-3200	40	* 2	80	0 3	120	1 3	160	3 5	200	3 5	240	3 5	280	4 5		
3201-8000	50	* 2	100	0 4	150	2 4	200	2 5	250	3 6	300	4 7	350	5 7	400	6 7
8001-22,000	75	* 3	150	1 4	225	1 5	300	2 6	375	3 6	450	5 8	525	7 8		
22001-110,000	100	# 3	200	1 5	300	1 6	400	3 7	500	4 8	600	5 9	700	7 10	800	9 10

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- # - For Detailed Plans for Larger Lots Refer to MIL-STD-105B TABLE IV-C.

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TMC SPECIFICATION NO. S-365

TITLE: MULTIPLE SAMPLING PLAN

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AQL .65%

Ref: MIL-STD-105B TABLE IV-C

SAMPLE NUMBER	1		2		3		4		5		6		7		8	
	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R
25-300	25	0 1														
301-800	20	* 2	40	* 2	60	0 2	80	1 3	100	1 3	120	1 3	140	2 3		
801-1300	30	* 2	60	0 2	90	1 3	120	2 4	150	3 5	180	3 5	210	4 5		
1301-3200	40	* 3	80	0 3	120	1 4	160	3 5	200	4 6	240	6 8	280	8 9		
3201-8000	50	* 3	100	0 4	150	1 4	200	3 6	250	4 7	300	5 8	350	6 8	400	7 8
3001-22M	75	* 4	150	1 5	225	3 5	300	4 7	375	5 8	450	7 9	525	9 10		
22M and over #	100	* 4	200	1 5	300	3 7	400	5 9	500	7 11	600	9 12	700	11 13	800	12 13

- * - Do Not Accept Lot, Take Next Larger Sample.
- TS - Total Sample Taken.
- A - At This Number of Defectives or Below - Accept the Lot.
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- # - If the Number of Defectives Falls Between A & R, Continue Sampling.
- For Detailed Plans for Larger Lots Refer to MIL-STD-105 B TABLE IV-C

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TMC SPECIFICATION NO. S-365

TITLE: MULTIPLE SAMPLING PLAN

JOB

APPROVED

AQL 1%

Ref: MIL-STD-105B TABLE IV-C

SAMPLE NUMBER	1		2		3		4		5		6		7		8	
	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R
15-180	15	0 1														
181-500	14	* 2	28	0 2	42	0 2	56	0 2	70	1 3	84	1 3	98	2 3		
501-800	20	* 2	40	0 3	60	1 3	80	2 4	100	2 4	120	2 4	140	3 4		
801-1300	30	* 3	60	0 3	90	1 4	120	2 6	150	3 6	180	5 7	210	6 7		
1301-3200	40	* 3	80	1 4	120	2 4	160	4 6	200	5 7	240	6 8	280	8 9		
3201-8000	50	* 3	100	1 4	150	2 6	200	3 7	250	4 8	300	5 9	350	7 10	400	9 10
8001-22M	75	0 4	150	2 5	225	3 7	300	5 9	375	7 10	450	9 11	525	10 11		
22001-over	100	0 5	200	2 7	300	5 9	400	7 11	500	10 14	600	12 16	700	15 18	800	18 19

- * - Do Not Accept Lot, Take Next Larger Sample.
- TS - Total Sample Take.
- A - At This Number of Defectives or Below - Accept the Lot.
- R - At This Number of Defectives or Above - Reject the Lot.
- # - If the Number of Defectives Falls Between A & R, Continue Sampling.
- For Detailed Plans for Larger Lots Refer to MIL-STD-105B TABLE IV-C.

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 Richard Corn

TMC SPECIFICATION NO. S-365

TITLE: MULTIPLE SAMPLING PLAN

JOB

APPROVED

AQL 2.5%

Ref: MIL-STD-105B TABLE IV-C

SAMPLE NUMBER	1		2		3		4		5		6		7		8	
	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R
7-65	7	0 1														
66-180	7	* 1	14	* 2	21	0 2	28	1 3	35	2 4	42	3 4				
181-300	10	* 2	20	0 3	30	1 3	40	1 4	50	2 4	60	2 4	70	4 5		
301-500	14	* 2	28	0 3	42	1 4	56	3 5	70	3 5	84	3 5	98	4 5		
501-800	20	* 3	40	1 4	60	2 5	80	3 6	100	5 7	120	6 8	140	7 8		
801-1300	30	0 4	60	2 5	90	3 8	120	4 9	150	6 10	180	8 12	210	11 12		
1301-3200	40	0 4	80	2 7	120	5 9	160	7 11	200	9 13	240	11 15	280	15 16		
3201-8000	50	0 5	100	3 8	150	5 11	200	8 13	250	10 15	300	13 18	350	15 20	400	19 20
8001-22M	75	1 7	150	4 10	225	8 14	300	12 18	275	15 21	450	18 25	525	24 25		
22001-over #	100	1 8	200	5 13	300	10 18	400	14 22	500	18 26	600	23 31	700	27 35	800	34 35

- * - Do Not Accept Lot, Take Next Larger Sample.
- TS - Total Sample Taken.
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- # - If the Number of Defectives Falls Between A & R, Continue Sampling.
- # - For Detailed Plans for Larger Lots Refer to MIL-STD-105B TABLE IV-C.

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TMC SPECIFICATION NO. S-365

TITLE: MULTIPLE SAMPLING PLAN

JOB

APPROVED

AQL 4.0%

Ref: MIL-STD-105B TABLE IV-C

SAMPLE NUMBER	1		2		3		4		5		6		7		8	
	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R
5-40	5	0 1														
41-110	5	* 2	10	0 2	15	0 3	20	1 3	25	2 3						
111-180	7	* 2	14	0 3	21	1 3	28	2 4	35	3 5	42	4 5				
181-300	10	* 3	20	0 3	30	1 4	40	2 6	50	3 7	60	4 7	70	6 7		
301-500	14	* 3	28	1 4	42	2 4	56	3 6	70	4 6	84	5 7	98	6 7		
501-800	20	0 4	40	1 5	60	3 6	80	5 8	100	8 10	120	9 11	140	10 11		
801-1300	30	0 4	60	3 7	90	5 9	120	7 11	150	9 13	180	12 15	210	14 15		
1301-3200	40	1 6	80	4 8	120	7 11	160	10 14	200	13 17	240	16 21	280	20 21		
3201-8000	50	2 7	100	4 11	150	8 15	200	12 19	250	16 22	300	21 26	300	25 29	400	28 29
8001-22M	75	2 9	150	7 13	225	13 18	300	18 23	375	23 27	450	28 32	525	34 35		
22001-over #	100	3 11	200	9 17	300	16 23	400	24 29	500	30 35	600	37 42	700	43 47	800	46 47

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TS - Total Sample Taken.

A - At This Number of Defectives or Below - Accept the Lot.

R. - At This Number of Defectives or Above - Reject the Lot.

- If the Number of Defectives Falls Between A & R, Continue Sampling.

- For Detailed Plans for Larger Lots Refer to MIL-STD-105B TABLE IV-C.

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TMC SPECIFICATION NO. S-365

TITLE: MULTIPLE SAMPLING PLAN

JOB

APPROVED

AQL 6.5%

Ref: MIL-STD-105B TABLE IV-C

SAMPLE NUMBER	1		2		3		4		5		6		7		8	
	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R	TS	A R
5-25	5	0 1														
26-65	4	* 2	8	0 2	12	1 3	16	1 3	20	3 4						
66-110	5	* 2	10	1 3	15	1 4	20	1 4	25	3 4						
111-180	7	* 2	14	1 3	21	2 4	28	3 5	35	4 6	42	5 6				
181-300	10	0 4	20	1 5	30	3 7	40	4 8	50	5 9	60	7 10	70	10 11		
301-500	14	0 4	28	2 5	42	4 8	56	5 9	70	7 10	84	10 12	98	11 12		
501-800	20	1 5	40	3 7	60	5 10	80	7 12	100	9 12	120	12 16	140	16 17		
801-1300	30	1 6	60	5 9	90	8 13	120	11 16	150	13 19	180	16 22	210	21 22		
1301-3200	40	2 8	80	6 12	120	11 16	160	16 21	200	22 26	240	28 31	280	30 31		
3200-8000	50	3 10	100	8 15	150	13 19	200	18 24	250	23 30	300	28 35	350	33 40	400	40 41
8001-22M #	75	4 13	150	11 21	225	19 29	300	27 37	375	35 45	450	43 45	525	55 56		

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