

Australian Standard™

**Sampling procedures for inspection by  
attributes**

**Part 3: Skip-lot sampling procedures**

This Australian Standard was prepared by Committee QR-008, Quality Systems. It was approved on behalf of the Council of Standards Australia on 28 May 2003 and published on 28 July 2003.

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**Part 3: Skip-lot sampling procedures**

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## PREFACE

This Standard was prepared by the Standards Australia Committee QR-008, Quality Systems.

This Standard is identical with, and has been reproduced from ISO 2859-3:1991, *Sampling procedures for inspection by attributes, Part 3: Skip-lot sampling procedures*.

The objective of this Standard is to specify general attribute skip-lot sampling procedures for reducing the inspection effort on products submitted by those suppliers who have demonstrated their ability to control, in an effective manner, all facets of quality and who consistently produce lots which meet requirements.

As this Standard is reproduced from an international Standard, the following applies:

- (a) Its number appears on the cover and title page while the international Standard number appears only on the cover.
- (b) A full point substitutes for a comma when referring to a decimal marker.

References to International Standards should be replaced by references to Australian or Australian/New Zealand Standards, as follows:

<i>Reference to International Standard</i>		<i>Australian Standard</i>	
ISO		AS	
2859	Sampling procedures for inspection by attributes	1199	Sampling procedures for inspection by attributes
2859-1	Part 1: Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection	1199.1	Part 1: Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection

Only International Standard referenced documents identical to Australian Standards have been listed.

The terms 'normative' and 'informative' are used to define the application of the annex to which they apply. A normative annex is an integral part of a standard, whereas an informative annex is only for information and guidance.

The International Organization for Standardization's Committee TC 69 is currently in the process of updating the ISO 2859 series to bring the older documents into line with Parts 1 and 4. Where any inconsistency arises between the sections of this series of Standards, the more recently published document will apply.

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NOTES

## AUSTRALIAN STANDARD

**Sampling procedures for inspection by attributes —****Part 3:**  
**Skip-lot sampling procedures****1 Scope**

**1.1** This part of ISO 2859 specifies generic attribute skip-lot sampling procedures for reducing the inspection effort on products submitted by those suppliers who have demonstrated their ability to control, in an effective manner, all facets of quality and who consistently produce lots which meet requirements. The reduction in inspection effort is achieved by selecting at random, with a specified probability, whether a lot presented for inspection will be passed without inspection. This procedure extends to the inspection of lots the principle of random selection already applied within ISO 2859-1 to the individuals comprising a lot.

Inspection may take place at the supplier's or purchaser's locations or at an interface between operations of a production process. The skip-lot procedures are designed to be used with the attribute lot-by-lot plans described in ISO 2859-1.

**NOTE 1** The skip-lot procedures specified in this part of ISO 2859 should be distinguished from Dodge's skip-lot plans. See [4], [5] and [6] in annex D.

**1.2** Since every product has its own environment and characteristics, options are provided in recognition of the fact that the supplier and responsible authority select the appropriate options to meet the specific needs of the product and its environment. All choices as a result of this tailoring should be specified in a written document (see annex A).

The procedures specified are applicable to, but not limited to, the inspection of

- a) end items, such as complete units or sub-assemblies;
- b) components and raw materials;

- c) services;
- d) materials in process;
- e) supplies in storage;
- f) data or records;
- g) administrative procedures.

These procedures are intended only for a continuing series of lots or batches and are not to be used for isolated lots. All lots in the series are expected to be of a similar quality and there should be reason to believe that the lots not inspected are of the same quality as the ones inspected.

This part of ISO 2859 is to be used only for characteristics inspected by attributes as designated in ISO 2859-1. Its application differs from that of reduced inspection in ISO 2859-1. With respect to the inspection of multiple characteristics, the skip-lot procedures will follow the same principles used in the associated ISO 2859-1 procedures.

The skip-lot procedures in this part of ISO 2859 can only be implemented if the ISO 2859-1 procedures are in use, on normal or reduced inspection, or a combination of normal and reduced inspection, at general inspection levels I, II or III.

Multiple sampling plans may only be used during the qualification phase associated with normal inspection. It is strongly recommended that single sampling plans with an acceptance number of zero are not used in this part of ISO 2859 (see 8.1 and clause C.4).

**NOTES**

2 Reduced inspection is a feature of ISO 2859-1 permitting smaller sample sizes than used in normal inspection.