

## MIL-STD-1916 SINGLE (NORMAL) SAMPLE VARIABLES INSPECTION TABLES

L III (MAJOR)			
Lot Size	Tightened Sample	Normal Sample	Reduced Sample
2-170	29	18	9
171-288	29	18	9
289-544	29	18	9
545-960	32	20	11
961-1632	37	23	13
1633-3072	41	26	15
3073-	44	29	18

L II (Minor)			
Lot Size	Tightened Sample	Normal Sample	Reduced Sample
2-170	18	9	4
171-288	18	9	4
289-544	20	11	5
545-960	23	13	7
961-1632	26	15	8
1633-	29	18	9

Switching Procedures (Per 5.2.1.3 of MIL-STD-1916):

- 1) **Normal to Tightened** - 2 lots rejected within last 5 or fewer
- 2) **Tightened to Normal** - root cause/corrective action completed plus 5 consecutive lots accepted
- 3) **Normal to Reduced** - 10 consecutive lots accepted while on normal inspection
- 4) **Reduced to Normal**- one lot rejected

Records supporting switching procedures must be retained

**Note: Any lot with any nonconformance found or unmet "k" or "F" criterion, shall be rejected unless appropriately documented and approved by the contracting officer**

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## MIL-STD-1916 SINGLE (NORMAL) SAMPLE ATTRIBUTE INSPECTION TABLES

L III (MAJOR)			
Lot Size	Tightened Sample	Normal Sample	Reduced Sample
2-170	80	32	12
171-288	80	32	12
289-544	80	32	12
545-960	96	40	16
961-1632	128	48	20
1633-3072	160	64	24
3073-	192	80	32

L II (Minor)			
Lot Size	Tightened Sample	Normal Sample	Reduced Sample
2-170	32	12	5
171-288	32	12	5
289-544	40	16	6
545-960	48	20	8
961-1632	64	24	10
1633-	80	32	12

Switching Procedures (Per 5.2.1.3 of MIL-STD-1916):

- 1) **Normal to Tightened** - 2 lots rejected within last 5 or fewer
- 2) **Tightened to Normal** - root cause/corrective action completed plus 5 consecutive lots accepted
- 3) **Normal to Reduced** - 10 consecutive lots accepted while on normal inspection
- 4) **Reduced to Normal**- one lot rejected

Records supporting switching procedures must be retained

**Note: Any lot with any nonconformance found shall be rejected unless appropriately documented and approved by the contracting officer**

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