

8.3 Double or multiple sampling

When double or multiple sampling is to be used, each subsequent sample shall be selected from the remainder of the same lot.

9 Normal, tightened and reduced inspection

9.1 Start of inspection

Normal inspection shall be carried out at the start of inspection, unless otherwise directed by the responsible authority.

9.2 Continuation of inspection

Normal, tightened or reduced inspection shall continue unchanged on successive lots, except where the switching procedures (see 9.3) require the severity of the inspection to be changed. The switching procedures shall be applied to each class of nonconformities or nonconforming items independently.

9.3 Switching rules and procedures (see Figure 1)

9.3.1 Normal to tightened

When normal inspection is being carried out, tightened inspection shall be implemented as soon as two out of five (or fewer than five) consecutive lots have been non-acceptable on original inspection (that is, ignoring resubmitted lots or batches for this procedure).

9.3.2 Tightened to normal

When tightened inspection is being carried out, normal inspection shall be re-instated when five consecutive lots have been considered acceptable on original inspection.

9.3.3 Normal to reduced

9.3.3.1 General

When normal inspection is being carried out, reduced inspection shall be implemented provided that all of the following conditions are satisfied:

- the current value of the switching score (see 9.3.3.2) is at least 30; and
- production is at a steady rate; and
- reduced inspection is considered desirable by the responsible authority.

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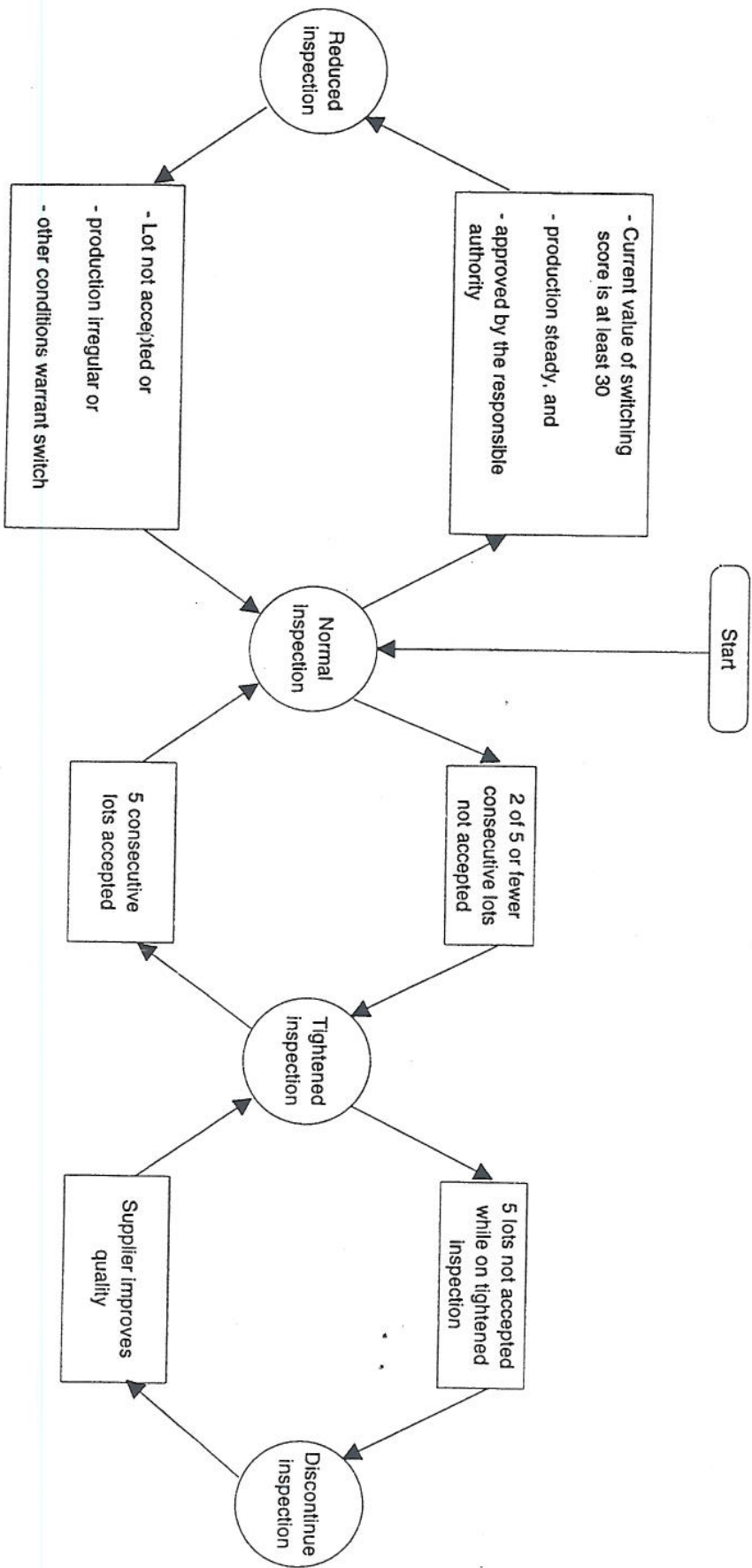


Figure 1 - Outline of the switching rules (see 9.3)

9.3.3.2 Switching score

The calculation of the switching score shall be initiated at the start of normal inspection unless otherwise specified by the responsible authority.

The switching score shall be set at zero at the start and updated following the inspection of each subsequent lot on original normal inspection.

- a) Single sampling plans:
 - 1) when the acceptance number is 2 or more, add 3 to the switching score if the lot would have been accepted if the AQL had been one step tighter; otherwise reset the switching score to zero;
 - 2) when the acceptance number is 0 or 1, add 2 to the switching score if the lot is accepted; otherwise reset the switching score to zero.
- b) Double and multiple sampling plans:
 - 1) when a double sampling plan is used, add 3 to the switching score if the lot is accepted after the first sample; otherwise reset the switching score to zero;
 - 2) when a multiple sampling plan is used, add 3 to the switching score if the lot is accepted by the third sample; otherwise reset the switching score to zero.

NOTE The application of the switching score is illustrated in annex A.

9.3.4 Reduced to normal

When reduced inspection is being carried out, normal inspection shall be re-instated if any of the following occur on original inspection:

- a) a lot is not accepted; or
- b) production becomes irregular or delayed; or
- c) other conditions warrant that normal inspection shall be re-instated.

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9.4 Discontinuation of inspection

If the cumulative number of lots not accepted in a sequence of consecutive lots on original tightened inspection reaches 5, the acceptance procedures of this part of ISO 2859 shall not be resumed until action has been taken by the supplier to improve the quality of the submitted product or service, and the responsible authority has agreed that this action is likely to be effective. Tightened inspection shall then be used as if 9.3.1 had been invoked.

9.5 Skip-lot sampling

The lot-by-lot inspection in this part of ISO 2859 may be replaced by skip-lot sampling when the requirements of ISO 2859-3 are fulfilled.

NOTE There are limitations to the use of the skip-lot procedures of ISO 2859-3 in place of the reduced-inspection procedures of this part of ISO 2859. Some of the AQLs and inspection levels are not applicable.