

Standard Operating Procedure

Sampling Plan For PDI

Purpose : To define the sampling plan for PDI items to assure quality of dispatch material affecting product and process.

Sampling Plans as per IS : 2500

Sampling Procedure - Variable

S. No.	From	To	T	N	R
1	Upto	100	10	7	5
2	101	150	15	10	7
3	151	300	20	15	10
4	301	500	25	20	15
5	501	1000	30	25	20
6	1001	3000	35	30	25
7	3001	10000	40	35	30
8	10001	and over	50	40	35

Sampling Procedure - Attribute

S. No.	From	To	T	N	R
1	Upto	100	8	5	2
2	101	150	13	8	3
3	151	300	20	13	5
4	301	500	32	20	8
5	501	1000	50	32	13
6	1001	3000	80	50	20
7	3001	10000	125	80	32
8	10001	and over	150	125	50

Legends : T- Tight Inspection (In-case of any customer complaint)
N- Normal Inspection(No PPM before 3 month)
R- Reduce Inspection(No PPM before 6 Month)

