



Tessa Precision Products  
850 Callendar Blvd  
Painesville, Oh 44077

# QUALITY SYSTEM PROCEDURE

Title  
STATISTICAL TECHNIQUES

Number  
FORM 1028

Rev.  
A

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## C=0 SAMPLING PLANS INDEX VALUES (ASSOCIATED AQLS)

Lot Size	AQL PERCENTILE LEVEL																			
	CLASS																			
					A				C				D/B		C		A		B	
	.010	.015	.025	.040	.065	.10	.15	.25	.40	.65	1.0	1.5	2.5	4.0	6.5	10.0				
	Sample Size																			
2 to 8	*	*	*	*	*	*	*	*	*	*	*	*	5	3	2	2				
9 to 15	*	*	*	*	*	*	*	*	*	*	13	8	5	3	2	2				
16 to 25	*	*	*	*	*	*	*	*	*	20	13	8	5	3	3	2				
26 TO 50	*	*	*	*	*	*	*	*	32	20	13	8	5	5	5	3				
51 TO 90	*	*	*	*	*	*	80	50	32	20	13	8	7	6	5	4				
91 TO 150	*	*	*	*	*	125	80	50	32	20	13	12	11	7	6	5				
151 TO 280	*	*	*	*	200	125	80	50	32	20	20	19	13	10	7	6				
281 TO 500	*	*	*	315	200	125	80	50	48	47	29	21	16	11	9	7				
501 TO 1200	*	800	500	315	200	125	80	75	73	47	34	27	19	15	11	8				
1201 TO 3200	1250	800	500	315	200	125	120	116	73	53	42	35	23	18	13	9				
3201 TO 10,000	1250	800	500	315	200	192	189	116	86	68	50	38	29	22	15	9				
10,001 TO 35,000	1250	800	500	315	300	294	189	135	108	77	60	46	35	29	15	9				
35,001 TO 150,000	1250	800	500	490	476	294	218	170	123	96	74	56	40	29	15	9				
150,001 TO 500,000	1250	800	750	715	476	345	270	200	156	119	90	64	40	29	15	9				
500,001 and over	1250	1200	1112	715	556	435	303	244	189	143	102	64	40	29	15	9				

\*Indicates entire lot must be inspected

NOTE: The Acceptance Number in all cases is ZERO.



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	(CLASS A) AQL		(CLASS B) AQL		(CLASS C) AQL		(CLASS D) AQL	
	Index Value	Percentile Level	Index Value	Percentile Level	Index Value	Percentile Level	Index Value	Percentile Level
<b>DIMENSIONAL REQUIREMENTS</b>								
Identified Critical & Major Characteristics		100%		100%		100%		100%
Diameter Total Tolerance .001 or less		100%	1.0		0.15		1.0	
Total tolerance > .001 up to .004	0.65		1.0		0.15		1.0	
Total tolerance greater than .004	2.5		4.0		1.5		1.0	
Angular Tolerance 0° 30' or less		100%	1.0		0.15		1.0	
Angular tolerance greater than 0° 30'	0.65		4.0		1.5		1.0	
Surface Finish of 31 micro or finer	0.65		1.0		0.15		1.0	
Surface finish greater than 31 micro	2.5		4.0		1.5		4.0	
Dimensions with min. or max. requirements	2.5		4.0		1.5		4.0	
Linear, true positions and geometric form 0.001 or less		100%	1.0		0.15		1.0	
Fit, form or function checked with acceptance gage		100%		100%		100%		100%
Dimensions where a cast (mold & comparator check) is necessary	2.5		4.0		1.5		1.0	
Threads (Plugs, Rings and Variable Gages)	0.65		1.0		0.15		1.0	
Marking and Acceptance Symbols		100%		100%		100%		100%
Spring Load Test	2.5		1.0		1.5		4.0	

**When CLASS E is called out 100% inspection is required. A cpk study of 1.33 or better can be submitted for reduced sampling plans to use CLASS A**

<b>History of Rev Changes</b>		
<b>REV</b>	<b>Changes Made</b>	<b>DATE</b>
A	Added new Logo and Class E requirements	6/11/2020