AQL 2.5 table for garment inspection

General Inspection Level II, normal inspection, single sampling. Ac / Re: accept the lot with Ac defects or fewer; reject it at Re.

Lot size (pieces)	Code letter	Sample size	AQL 1.5 Ac / Re	AQL 2.5 Ac / Re	AQL 4.0 Ac / Re
2 to 8	A	2	0 / 1 on 8	**0 / 1 on 5**	0 / 1 on 3
9 to 15	B	3	0 / 1 on 8	**0 / 1 on 5**	0 / 1
16 to 25	C	5	0 / 1 on 8	**0 / 1**	0 / 1 on 3
26 to 50	D	8	0 / 1	**0 / 1 on 5**	1 / 2 on 13
51 to 90	E	13	0 / 1 on 8	**1 / 2 on 20**	1 / 2
91 to 150	F	20	1 / 2 on 32	**1 / 2**	2 / 3
151 to 280	G	32	1 / 2	**2 / 3**	3 / 4
281 to 500	H	50	2 / 3	**3 / 4**	5 / 6
501 to 1,200	J	80	3 / 4	**5 / 6**	7 / 8
1,201 to 3,200	K	125	5 / 6	**7 / 8**	10 / 11
3,201 to 10,000	L	200	7 / 8	**10 / 11**	14 / 15
10,001 to 35,000	M	315	10 / 11	**14 / 15**	21 / 22
35,001 to 150,000	N	500	14 / 15	**21 / 22**	21 / 22 on 315
150,001 to 500,000	P	800	21 / 22	**21 / 22 on 500**	21 / 22 on 315
500,001 and over	Q	1,250	21 / 22 on 800	**21 / 22 on 500**	21 / 22 on 315

Common garment practice: 0 critical defects accepted, AQL 2.5 for major defects, AQL 4.0 for minor defects. Agree the levels and the defect list in writing before production.

“on N”: an arrow in the standard moves that plan to another sample size; inspect N pieces instead. If N is more than the lot, inspect every piece.

AQL 2.5 is not a 2.5% defect allowance. It is the worst average defect rate the plan is designed to tolerate over a series of lots, not a limit for one lot.

Values: ISO 2859-1 Tables 1 and 2-A, the same as MIL-STD-105E. Free to print and share.
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