

# Package ‘AQLSchemes’

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**Type** Package

**Title** Retrieving Acceptance Sampling Schemes

**Version** 1.7-2

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## **Description**

Functions are included for recalling AQL (Acceptable Quality Level or Acceptance Quality Level) Based single, double, and multiple attribute sampling plans from the Military Standard (MIL-STD-105E) - American National Standards Institute/American Society for Quality (ANSI/ASQ Z1.4) tables and for retrieving variable sampling plans from Military Standard (MIL-STD-414) - American National Standards Institute/American Society for Quality (ANSI/ASQ Z1.9) tables. The sources for these tables are listed in the URL: field. Also included are functions for computing the OC (Operating Characteristic) and ASN (Average Sample Number) coordinates for the attribute plans it recalls, and functions for computing the estimated proportion nonconforming and the maximum allowable proportion nonconforming for variable sampling plans. The MIL-STD AQL Sampling schemes were the most used and copied set of standards in the world. They are intended to be used for sampling a stream of lots, and were used in contract agreements between supplier and customer companies. When the US military dropped support of MIL-STD 105E and 414, The American National Standards Institute (ANSI) and the International Standards Organization (ISO) adopted the standard with few changes or no changes to the central tables. This package is useful because its computer implementation of these tables duplicates that available in other commercial software and subscription online calculators.

**URL** [https://archive.org/details/MIL-STD-105E\\_1](https://archive.org/details/MIL-STD-105E_1)

<https://archive.org/details/MIL-STD-414>

**License** GPL-2

**LazyLoad** yes

**Suggests** R.rsp

**VignetteBuilder** R.rsp

**NeedsCompilation** no

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## R topics documented:

AQLSchemes-package . . . . .	2
AADouble . . . . .	3
AAMultiple . . . . .	4
AASingle . . . . .	5
AAZ14Double . . . . .	5
AAZ14Multiple . . . . .	6
AAZ14Single . . . . .	7
AAZ19 . . . . .	8
EPn . . . . .	8
MPn . . . . .	9
OCASNZ4D . . . . .	10
OCASNZ4M . . . . .	11
OCASNZ4S . . . . .	12
<b>Index</b>	<b>13</b>

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AQLSchemes-package	<i>This package contains functions to recall MIL-STD-105E - ANSI/ASQ Z1.4, and the MIL-STD-414 - ANSI/ASQ Z1.9 Variable Sampling Plans from the Public Domain Published Tables</i>
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## Description

The **AAQLSchemes** package provides a functions to recall MIL-STD-105E - ANSI/ASQ Z1.4 - ISO2859-1 and MIL-STD-414 - ANSI Z1.9 - ISO3951-1 Sampling Plans from Published Tables.

## Details

Package:	AQLSchemes
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#### Index:

AADouble	Calls function AAZ14Double
AAMultiple	Calls function AAZ14Multiple
AASingle	Calls function AAZ14Single
AAZ14Double	Recalls and prints Sampling plans
AAZ14Multiple	Recalls and prints Sampling Plans
AAZ14Single	Recalls and prints Sampling Plans
AAZ19	Recalls and Prints Z19 Sampling Plans
EPn	Calculates the estimated proportion non-conforming
MPn	Calculates the maximum allowable proportion non-conforming
OCASNZ4S	Calculates the OC values for an attribute single sampling plan
OCASNZ4D	Calculates the OC and ASN values for an attribute double sampling plan
OCASNZ4M	Calculates the OC and ASN values for an attribute multiple sampling plan

#### Author(s)

John Lawson <lawson@byu.edu>  
 Maintainer: John Lawson <lawson@byu.edu>

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AADouble	<i>This function recalls MIL-STD-105E - ANSI/ASQ Z1.4 Double Sampling Plans from the published tables.</i>
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#### Description

This function calls the function AAZ14Double function that queries the user for the inspection level, lotsize, and AQL, and then it recalls the appropriate sample sizes, acceptance numbers and rejection numbers and returns a data frame with two rows and three columns.

#### Usage

```
AADouble(type)
```

#### Arguments

type            type is either 'Normal', 'Tightened' or 'Reduced' to specify which type sampling plan is desired.

#### Value

returns a data frame with two rows and three columns

**Note**

This function calls the function AAZ14Double to get the specifications and recall and return the plan in a data frame.

**Author(s)**

John S. Lawson <lawson@byu.edu>

**References**

<[https://archive.org/details/MIL-STD-105E\\_1](https://archive.org/details/MIL-STD-105E_1)>

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AAMultiple

*This function recalls MIL-STD-105E - ANSI/ASQ Z1.4 Multiple Sampling Plans from the published tables.*

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**Description**

This function calls the function AAZ14Multiple function that queries the user for the inspection level, lotsize, and AQL, and then it recalls the appropriate sample sizes, acceptance numbers and rejection numbers and returns a data frame.

**Usage**

```
AAMultiple(type)
```

**Arguments**

type            type is either 'Normal', 'Tightened' or 'Reduced' to specify which type sampling plan is desired.

**Value**

returns a data frame with seven rows and three columns

**Note**

This function calls the function AAZ14Multiple to get the specifications and recall and print the plan.

**Author(s)**

John S. Lawson <lawson@byu.edu>

**References**

<[https://archive.org/details/MIL-STD-105E\\_1](https://archive.org/details/MIL-STD-105E_1)>

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AASingle	<i>This function recalls MIL-STD-105E - ANSI/ASQ Z1.4 Single Sampling Plans from the published tables.</i>
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**Description**

This function calls the function AAZ14Single function that queries the user for the , inspection level, lotsize, and AQL, and then recalls and prints the appropriate sample sizes, acceptance numbers and rejection numbers and returns a data frame.

**Usage**

```
AASingle(type)
```

**Arguments**

type	type is either 'Normal', 'Tightened' or 'Reduced' to specify which type sampling plan is desired.
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**Value**

returns a data frame with one row and three columns

**Note**

This function calls the function AAZ14Single to get the specifications and recall and print the plan.

**Author(s)**

John S. Lawson <lawson@byu.edu>

**References**

<[https://archive.org/details/MIL-STD-105E\\_1](https://archive.org/details/MIL-STD-105E_1)>

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AAZ14Double	<i>This function queries the user for the specs and recalls MIL-STD-105E - ANSI/ASQ Z1.4 Double Sampling Plans from the published tables.</i>
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**Description**

This function is called by the function AADouble function.

**Usage**

```
AAZ14Double(PPLAN, INSL, LOTS, AQL)
```

**Arguments**

PLAN	PLAN is the plan type 1=normal, 2=Tightened, 3=reduced.
INSL	INSL is the inspection level, 1-7.
LOTS	LOTS is the lot size, 1-15.
AQL	AQL is the Acceptance Quality Level, 1-26.

**Value**

returns a data frame with two rows and three columns

**Note**

This function is called by the function AADouble.

**Author(s)**

John S. Lawson <lawson@byu.edu>

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AAZ14Multiple	<i>This function queries the user for the specs and recalls MIL-STD-105E - ANSI/ASQ Z1.4 Multiple Sampling Plans from the published tables.</i>
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**Description**

This function is called by the function AAMultiple function.

**Usage**

```
AAZ14Multiple(PLAN, INSL, LOTS, AQL)
```

**Arguments**

PLAN	PLAN is the plan type 1=normal, 2=Tightened, 3=reduced.
INSL	INSL is the inspection level, 1-7.
LOTS	LOTS is the lot size, 1-15.
AQL	AQL is the Acceptance Quality Level, 1-26.

**Value**

returns a data frame with seven rows and three columns

**Note**

This function is called by the function AAMultiple.

**Author(s)**

John S. Lawson <lawson@byu.edu>

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AAZ14Single

*This function queries the user for the specs and recalls MIL-STD - ANSI/ASQ Z1.4 Double Sampling Plans from the published tables.*

---

**Description**

This function is called by the function AASingle function.

**Usage**

AAZ14Single(PPLAN, INSL, LOTS, AQL)

**Arguments**

PPLAN	PPLAN is the plan type 1=normal, 2=Tightened, 3=reduced.
INSL	INSL is the inspection level, 1-7.
LOTS	LOTS is the lot size, 1-15.
AQL	AQL is the Acceptance Quality Level, 1-26.

**Value**

returns a data frame with one row and three columns

**Note**

This function is called by the function AASingle.

**Author(s)**

John S. Lawson <lawson@byu.edu>

AAZ19

*This function queries the user for the specs and recalls MIL-STD-414 variable sampling plans from the published tables.*

---

### Description

This function recalls Normal, Tightened and Reduced Plans including the sample size n, acceptability constant (k), and the maximum proportion nonconforming allowable M.

### Usage

AAZ19(type, stype, INSL, LOTS, AQL)

### Arguments

type	type is the plan type 'Normal', 'Tightened', or 'Reduced', Normal is Default.
stype	stype is "known" or "unknown", unknown is Default
INSL	INSL is 1-5
LOTS	LOTS is 1-16
AQL	AQL is 1-11

### Value

returns a vector of length 3 containing the sample size (n), acceptability constant (k), and the maximum proportion nonconforming allowable (M).

### Author(s)

John S. Lawson <lawson@byu.edu>

### References

<<https://archive.org/details/MIL-STD-414>>

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 EPn

*This function calculates the estimated proportion non-conforming.*

---

### Description

This function calculates the estimated proportion non-conforming with sigma unknown or known using the standardized distribution.

### Usage

EPn(sample, sided, stype, LSL, USL, sigma, xbar, s, n)



**Arguments**

sample	sample is a numeric vector of sampled values.
sided	sided is 'one' or 'two' depending on whether there is one or two specification limits. The default is 'one'.
stype	stype is 'known' or 'unknown' depending on whether the standard deviation is known. The default is 'unknown'.
LSL	LSL is the lower specification limit, leave it out if there is no lower specification limit.
USL	USL is the upper specification limit, leave it out if there is no upper specification limit.
sigma	sigma is the known standard deviation, leave it out if it is unknown and stype is 'unknown'.
xbar	sample mean. Leave it out if the vector sample is supplied.
s	sample standard deviation. Leave it out if the vector sample is supplied.
n	number of items in the sample. Leave it out if the vector sample is supplied.

**Value**

returns a single number (the estimated proportion nonconforming)

**Author(s)**

John S. Lawson <lawson@byu.edu>

**Examples**

```
EPn(sided="one",stype="known",LSL=100,sigma=8,xbar=110,n=10)
EPn(sided="one",stype="unknown",LSL=225,xbar=255,s=15,n=42)
sample<-c(197,188,184,205,201)
EPn(sample,sided="one",USL=209)
sample<-c(197,188,184,205,201)
EPn(sample,sided="two",LSL=180,USL=209)
EPn(sided="two",stype="known",sigma=2,LSL=90,USL=100,xbar=96.68,n=21)
```

---

MPn

*This function calculates the maximum allowable proportion non-conforming.*

---

**Description**

This function calculates the maximum allowable proportion non-conforming with sigma unknown or known using the standardized distribution.

**Usage**

MPn(k, n, stype)

**Arguments**

k	k is the acceptance constant for the variables sampling plan.
stype	stype is 'known' or 'unknown' depending on whether the standard deviation is known. The default is 'unknown'.
n	n is number of items in the sample required by the variables sampling plan.

**Value**

returns a single number (the maximum allowable proportion nonconforming)

**Author(s)**

John S. Lawson <lawson@byu.edu>

**References**

Lawson, J. "An Introduction to Acceptance Sampling and SPC with R" pp 45=48.

**Examples**

```
MPn(k=1.6094, n=10, stype="known")
MPn(k=1.905285, n=42, stype="unknown")
```

---

OCASNZ4D

*This function creates a data frame containing three columns 1)proportion defective=pd, 2)OC=prob accept, and 3)ASN=average sample no.*

---

**Description**

This function takes the data frame=plan created by the AAZ14Double function and and a vector of proportion defectives=pd. It calculates OC and ASN values and creates a data frame.

**Usage**

```
OCASNZ4D(plan, pd)
```

**Arguments**

plan	plan is a data frame with two rows containing sample no's=n, acceptance no's=c, and rejection no's=r for first and second samples
pd	pd is a vector of values of the poprtion defective to b used in the OC ASN Curves

**Value**

returns a data frame containing three columns 1)proportion defective=pd, 2)OC=prob accept, and 3)ASN=average sample no.

**Note**

This function calls the function AAZ14Double to get the specifications and recall and print the plan.

**Author(s)**

John S. Lawson <lawson@byu.edu>

**Examples**

```
p1and<-data.frame(n=c(125,125),c=c(3,8), r=c(7,9))
Pnc<-seq(0,.08,.005)
OCASND<-OCASNZ4D(p1and,Pnc)
OCASND$OC
OCASND$ASN
```

---

OCASNZ4M

*This function creates a data frame containing three columns 1)proportion defective=pd, 2)OC=prob accept, and 3)ASN=average sample no.*

---

**Description**

This function takes the data frame=plan created by the AAZ14Multiple function and a vector of proportion defectives=pd. It calculates OC and ASN values and creates a data frame.

**Usage**

```
OCASNZ4M(plan,pd)
```

**Arguments**

plan	plan is a data frame with seven rows containing sample no's=n,acceptance no's=c, and rejection no's=r for first through seventh samples
pd	pd is a vector of values of the poprtion defective to b used in the OC ASN Curves

**Value**

returns a data frame containing three columns 1)proportion defective=pd, 2)OC=prob accept, and 3)ASN=average sample no.

**Note**

This function calls the function AAZ14Double to get the specifications and recall and print the plan.

**Author(s)**

John S. Lawson <lawson@byu.edu>

**Examples**

```
planm<-data.frame(n=c(50,50,50,50,50,50,50),c=c(0,1,3,5,7,10,13),r=c(4,6,8,10,11,12,14))
Pnc<-seq(0,.08,.005)
OCASNM<-OCASNZ4M(planm,Pnc)
OCASNM$OC
OCASNM$ASN
```

---

OCASNZ4S

*This function creates a data frame containing three columns 1)proportion defective=pd, 2)OC=prob accept, and 3)ASN=average sample no.*

---

**Description**

This function takes the data frame=plan created by the AAZ14Single function and and a vector of proportion defectives=pd. It calculates OC and ASN values and creates a data frame.

**Usage**

```
OCASNZ4S(plan,pd)
```

**Arguments**

`plan` plan is a data frame with two rows containing sample no's=n,acceptance no's=c, and rejection no's=r for first and second samples

`pd` pd is a vector of values of the poprtion defective to b used in the OC ASN Curves

**Value**

returns a data frame containing three columns 1)proportion defective=pd, 2)OC=prob accept, and 3)ASN=average sample no.

**Note**

This function calls the function AAZ14Double to get the specifications and recall and print the plan.

**Author(s)**

John S. Lawson <lawson@byu.edu>

**Examples**

```
plans<-data.frame(n=c(200),c=c(7),r=c(8))
Pnc<-seq(0,.08,.005)
OCASNS<-OCASNZ4S(plans,Pnc)
OCASNS$OC
OCASNS$ASN
```

# Index

## \* file

- AADouble, [3](#)
- AAMultiple, [4](#)
- AAZ14Double, [5](#)
- AAZ14Multiple, [6](#)
- AAZ14Single, [7](#)
- AAZ19, [8](#)
- EPn, [8](#)
- MPn, [9](#)
- OCASNZ4D, [10](#)
- OCASNZ4M, [11](#)
- OCASNZ4S, [12](#)

## \* package

- AQLSchemes-package, [2](#)

## \* sampscheme

- AASingle, [5](#)

- AADouble, [3](#)
- AAMultiple, [4](#)
- AASingle, [5](#)
- AAZ14Double, [5](#)
- AAZ14Multiple, [6](#)
- AAZ14Single, [7](#)
- AAZ19, [8](#)
- AQLSchemes-package, [2](#)

- EPn, [8](#)

- MPn, [9](#)

- OCASNZ4D, [10](#)
- OCASNZ4M, [11](#)
- OCASNZ4S, [12](#)