FNMI APPROVED SAMPLING PLAN
IAW MIL-STD-1916
WITH THE FOLLOWING EXCEPTIONS:

Paragraph 4.3 – MIL-STD-1916; is revised as follows:

Sentence 1 should be replaced with: "Any unit observed to be nonconforming should be properly controlled in such a way as to preclude the unit from being submitted to the Government."

Sentence 3 should be replaced with: "Reworked* material may join in the regular production flow after it has been inspected in accordance with the associated rework inspection procedures. Repaired** material must be screened, unless otherwise authorized, and submitted separately from the regular production flow. If a lot has been withheld from acceptance, then it shall be reworked* or repaired**, screened, and resubmitted to the Government apart from the regular production flow.

> *Rework shall be done to documented procedures that are subject to disapproval by the Quality Assurance Representative (QAR).
> **Repair shall be done according to procedures approved by the Government and accepted on a Waiver/Deviation."

Sampling Plan Tables:

The provisions of MIL-STD-1916 shall remain in effect with the following exceptions:

1. The acceptance plans contained in Tables 1-a and 1-H of the Squeglia document, as modified per the attached tables, are allowed to be used as a substitute for the acceptance tables contained in paragraphs 5.2 through 5.2.2.3.3.1 of MIL-STD-1916. (The attached tables have been modified to provide a cross reference between the Squeglia inspection plans and the associated verification level from MIL-STD-1916).

    a. When Verification Levels per MIL-STD-1916 are specified in the Government Tech Data, the corresponding C=0 inspection plans for those Verification Levels, as specified in the attached Tables, may be utilized (e.g. if the Government tech data requires a verification level III per MIL-STD-1916, the C=0 inspection plans from the column in Table 1-a with sample sizes varying from *(100%) to 143 may be used).

    b. When AQL based inspection plans are specified in the Government Tech Data, the following procedures shall be applied:

        1) For all Major QAP characteristics with the AQL of .65 or greater (that is an AQL with a numerical value equal to ***or*** greater than .65, e.g. 1.0, 1.5, etc.), Verification Level III of Table 1-a or 1-H shall be used.

2) For all Major QAP characteristics with an AQL less than .65 (***that*** is an AQL with a numerical value less than .65, e.g. .40, .25, etc.), if any, the corresponding column for that AQL in Table 1-a or 1-H shall be used.

3) For Major QAP characteristics which specify 100% inspection (if any), 100% inspection will continue to be used.

4) For all ***Minor*** QAP characteristics, Verification Level II of Table 1-a or 1-H shall be used.

2. The switching procedures specified in paragraphs 5.2.1.3 through 5.2.1.4 of MIL-STD-1916, supplemented by the following shall be applied using Tables 1-a or 1-H:

   a. In Tables 1-a and 1-h:
   When a sampling plan with a corresponding Verification Level is used, one Verification Level to the left/right of that Verification Level column is the respective tightened/reduced plan.

   When a sampling plan with a corresponding AQL, but without a Verification Level, is used, the nearest Verification Level to the left/right of the AQL column is the respective tightened/reduced plan.

   Note: MIL-STD-1916 switching rules only allow one level of switching. Sampling cannot go from one reduced level to a further reduced level, or from one tightened level to a further tightened level.

   b. Table 1-a - for Verification Level I, the reduced inspection plan shall be the plan in the column immediately to the right of Verification Level I plan (i.e. the column headed by associated AQL 6.5).

   c. Table 1-H – for Verification Level IV (or 0.25 AQL), the tightened inspection plan shall be 100% inspection of the entire lot.

   d. Table 1-H – there shall be no reduced inspection for Verification Level II when Table 1-H is used.

3. If verification levels or AQLs outside the range of Table 1-H are specified, Table 1-a must be used.

4. The attached matrix summarizes the various procedures presented above.

C=O SAMPLING PLANS

MIL-STD-1916 (Associated Verification Level)	VII		VI			V		IV		III		II	I			
INDEX VALUE (Associated AQL)	.010	.015	.025	.040	.065	.10	.15	.25	.40	.65	1.0	1.5	2.5	4.0	6.5	10.0
LOT SIZE								**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
150,000 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 (100%)**
NOTE: The Acceptance Number in all cases is ZERO.

TABLE NO. 1-a

SMALL LOT SIZE SUPPLEMENT

MIL-STD-1916 (Associated Verification Level)	IV		III		II
INDEX VALUE (Associated AQL)	.25	.4	.65	1.0	1.5
LOT SIZE	SAMPLE SIZE				
5-10	*	*	*	8	5
11-15	*	*	11	8	5
16-20	*	16	12	9	6
21-25	22	17	13	10	6
26-30	25	20	16	11	7
31-35	28	23	18	12	8

* Indicates entire lot must be inspected (100%)
NOTE: The Acceptance Number in all cases is ZERO.

TABLE NO. 1-H

	GOVERNMENT TECH DATA PACKAGE SPECIFIES					
	VLs PER MIL-STD-1916 *	AQLs *				
		MAJOR			MINOR	
		< 0.65		≥ 0.65		
COLUMN TO USE IN TABLE 1-a OR 1-H	CORRESPONDING VL COLUMN OF TABLE 1-a OR 1-H	CORRESPONDING AQL COLUMN OF TABLE 1-a OR 1-H		VL III OF TABLE 1-a OR 1-H	VL II OF TABLE 1-a OR 1-H FOR ALL MINORS	
		TABLE 1-a	TABLE 1-H		TABLE 1-a	TABLE 1-H
SWITCHING RULES	ONE VL TO THE LEFT/RIGHT IS THE RESPECTIVE TIGHTENED/REDUCED PLAN EXCEPT: 1. IN 1-a REDUCED PLAN FOR VL I IS THE COLUMN HEADED BY AQL 6.5. 2. IN 1-H TIGHTENED FOR VL IV IS 100%. 3. IN 1-H NO REDUCED FOR VL II.	NEAREST VL TO THE LEFT/RIGHT OF THE AQL COLUMN IS THE RESPECTIVE TIGHTENED/REDUCED PLAN	FOR 0.4 AQL USE VL IV (.25) FOR TIGHTENED VL III (.65) FOR REDUCED FOR 0.25 AQL USE 100% FOR TIGHTENED VL III (.65) FOR REDUCED	VL IV FOR TIGHTENED VL II FOR REDUCED	VL III FOR TIGHTENED VL I FOR REDUCED	VL III FOR TIGHTENED NO REDUCED ALLOWED

* FOR VLs OR AQLs OUTSIDE THE RANGE OF TABLE 1-H, USE TABLE 1-a.

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via Datafax
March 13, 2001

Department of the Army
U.S. Army Tank-Automotive and Armaments Command
Building 110
Rock Island, IL 61299-7630

ATTENTION: *Ms. Teresa Stottlemyre, AMSTA-LC-CSCA*

SUBJECT: Sample Inspection Plan, MIL-STD-1916, as Modified

REFERENCE: A) FNMI letter dated January 22, 2001
B) TACOM-RI letter dated February 6, 2001

Dear Ms. Stottlemyre:

FN Manufacturing, Inc. has made the corrections, as outlined in the reference B) letter, to the Attachment 1, "Exceptions to MIL-STD-1916", which was provided for review, approval and subsequent incorporation into its current contracts.

With this done, FNMI again requests modification of said contracts, for its conclusion.

Please contact Ms. Beryl Myers, at 803/736-0522, ext. 215 (e-mail berylm@fnfmg.com), should you have any questions.

Sincerely,

Jeff Rankin
Director of Contracts

Cc: Ms. Karen Benner, ACO, DCMA-Atlanta
FNMI-QAR Terry Smith/Robert Taylor/Warren Imhof
TACOM-RI, AMSTA-AR-QAW, Ken Campbell/JoAnn McConville/Jerry Farmer/Dustin Galbraith