

# Lohdk; Z xqkoRrk Lrj ¼DI S Vsy DokYKfV yoy)

lks jkt sk Hhk



Tkc Hkh ifj/kku fu; kZ bUMLVh ¼vişy ,DI iks½ ea xqkoRrk dh ckr vkrh gS rks vDI j , s D; w , y- "kCn dk bLrky gkrk gA bUMLVh es l Hkh ykx bl "kCn dks Lora : lk l s bLrky djrs gS ; g l kpdj dh mlga , s D; w , y- dk vFKZ vPNs l sirk gA yfdu tc dN o'kkz igys , d vefjdu vişy bEi kZj use l s ; g fuonu fd ; k fd eam l ds Hkkjr ea fLFkr l kfi k vKQI ea , s D; w , y- vl y es D ; k gS , d i Hkkoh : lk l s ml s ds s bLrky dj ds ckjes tkudkj nWrks ml ds i hNs D ; k rdZ Fkk\ ep s vgl kl gvk fd l gh ek ; uks ea , s D ; w , y- dh l e > vişy bUMLVh ea dke dj jgs cgr l s , DI D ; qVol -ea ugh gA D ; kfd fu ; kZ m | kx ea ifj/kku f"ki eV l ~ ds fu . kZ ¼acceptance / Lohdk; Z k½ , s D ; w , y- ij vk/kfjr l Eifyak lyku ij gkrsgA bl fy ; s ; g egROI wkZ gSfd bl bUMLVh l s t m l Hkh ykx ka ea de l s de , s D ; w , y- D ; k gS dk cfi d ¼eny½ vkbZM ; k gsk vk" ; d gA bl ys [k ea ge , s D ; w , y- ds QUMkeV Vy dUl s V ¼eksyd /kk½ , s D ; w , y dk l kr , d vKxukbZt s ku dksfd l idkj fu/kfjr , s D ; w , y- rd igppuk gS ds ckjes ea tkudkj i kl dj xA ge l c dks irk gSfd fufj {k . k , d , s k Vny gSft l ds } kjk ge vkadyu djrs gA fd nh xbz ejp s m kbZt + fu/kfjr funz kka ; k vko" ; drk vka ds vuq lk gS ; k ughA ; | fi fufj {k . k dk Qh vko" ; d gS , d gea m Rikn dh vko" ; d vuq irk ds ckjes ea vPNk vankt k nrk gS yfdu ; g l Hko ugh gSfd nh xbz f"ki eV ; k YkKW ds gj , d i hl ¼ Hkh ; fuVI ½ dk fufj {k . k gks ik ; A ; g e [ ; r % fuEu dkj . kka dh otg l s gS %

- ; g dkQh egxk gA
- 100% fufj {k . k vko" ; d : lk l s d Hkh & d Hkh gh 100% l gh , d Hkj d an gkrk gA
- ; g vl Hko , d pkguh ; ugha gS D ; kfd bl ea vFR ; f/kd gS m fyak gkrh gSft l dh otg l s eky ¼xV l ½ dk u ; ki u [kks tkrk gA

; g tkua ds ckn fd 100% fujh {k . k djuk cgr vPNh ckr ugha gS rks i z' u ; g gSfd vxj 100% ugh rks fdruk fujh {k . k djA gekjs i kl nks fodYi gA & igyk fodYi ge ; g fu . kZ dj ya fd YkKW ds Lohdk ; Z fu . kZ rd igppus ds fy ; sykW ds fuf"pr vuq kr (lk i kj "ku) dk fufj {k . k fd ; k tk ; sk , oanw jk fodYi ; g gSfd ge fn ; s x ; s , s D ; w , y- ij , DI S VBI l Eifyak ifdz k dk bLrky dja , d Lohdk ; Z fu . kZ ¼DI S VBI fMfl tu½ yA l kgyk fodYi euekuk ¼kjfcVj½ gS , d bl dk dksZ oSkfud vk/kkj ¼ kbZUVfOd cfi l ½ ugh gS tks ges crk l dsfd bl rduhd ij fuHkj fd ; k tk l drk gS ; k ughA D ; kfd , DI S VBI fMfl tu egROI wkZ O ; ol kf ; d ¼def" kZ y½ fu . kZ gkrsgS ; g vko" ; d gSfd bu fu . kZ ka ij igppus ds fy ; s gekjs i kl fo"ol uh ; , d oSkfud ifdz k gks gea irk gsk pfg ; sfd bl rjg ds fu . kZ ka ea cgr fjLd ¼t k [ke½ gSA , DI S VBI l Eifyak , d oSkfud rduhd gS , d bl dk bLrky djrs gq s gea xyr fu . kZ ysa dh l EHKkouk Hkh jgrh gA

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, s D; w , y- D; k gS\

tS sinhi oh- egrk crkrs gS p, a D; w , y- xyr ihl ka dk og l cl s T; knk ifr"kr gS ftl s l Sifyak fufj{k.k ea ikd d , ojt ¼ fdz k dk vkS r½ ds fy; s l Urkktud ekuk tk l drk gS l k/kkj.k Hkk'kk ea tc ck; j , d l Sifyak lyku ds fy; s , s D; w , y- fu/kkZjr djrk gS rks bl l s ck; j dk rRik; Z gkrk gS fd tc rd f"kiebVI ea xyr xkjebVI - dk ifr"kr fn; s x; s , s D; w , y- l s de gksck] T; knkrj f"kiebVI - ¼ ykW½ Lohdkj (vDI S V) fd; s tk; xA ikd d , ojt dk eryc gS fd fufj{k.k ds fy; s fn; s x; s ykW ds xyr ihl ka dk vkS ru ifr"kr ¼ j l s Vst fMOQSDVo¼A ekuy] vl y ea xkjebVI - ds xyr ihl ka dk ifr"kr Ng ¼ ½ ykW l - ea de" k% 2-3] 2-7] 2-4] 2-6] 2-8 , Oka 2-2 gS rks ikd d , ojt s 2-5% fMOQSDVo gks tk, xkA vijy QDVhl es ikd d , ojt rd igpus dk rjhdk bl vkfVdy ea vkxs fn; k x; k gA

**, D; w , y- dk l f{kr bfrgkl , o , ÐI S VBI l Sifyak**  
, ÐI S VBI l Sifyak] LVSVI fVdy DokfYkV dUVky ¼ kf[; dh; xqkoRrk fu; æ.k½ dk e[; Hkkx gS ftl s MKVI-t , o jkSex us ykdfiz rk inku dh , o bl s igyh ckj ; w, l - fefyVh ea nW js fo"o ; o ds nkSku cyV l - ds ifj{k.k ¼ V½V½ ea bLreky fd; k x; kA vxj l kjh cyV l - dks igys gh V½V dj fy; k tkrk rks f"ki djus ds fy; s , d Hkh cyV l u cprhA vxj nW js gkFk ij fd l h dks Hkh V½V ugh fd; k x; k tkrk rkS ; o fks- ea "kk; n cyV l - dke u djrh ftl dh otg l sfouk"kd kjh ifj.kke gks l drs FkA  
, ÐI S VBI l Sifyak lyku , ÐI S Vey , o vu, ÐI S Vey ¼ Lohdk; Z , o vLohdk; ½ ykW l - es vLrj djus ea enn xkj gA ; gkW ij cS l d /kkj.kk ; g gS fd vxj , d l Sifyak dks ykW l s fcuk l kps & l e> s fudkyk tk, s rks ; g l Sifyak ykW dk xqkoRrk Lrj irk pyskA iWkZ fufj{k.k , o dkbZ fufj{k.k u djus dh chp , ÐI S VBI l Sifyak , d chp dk jkLrk gSA  
vefjdu fefyVh ds foLrr dk; Z ds vk/kkj ij nW js fo"o ; o ds nkSku , o ; o l s igyS ; w , l - xojuebV us 1963 ea l Sifyak ifdz k , o MTL-STD-105D uke dk fufj{k.k Vey fudkykA bl s 1989 es MIL-STD-105E ds : lk ea l a kks/kr ¼ ekSMQkbZ@ l qkjk x; k½ fd; k x; k] , o Qojh 1995 ea bl s **ANSI/ASQC.Z 1.4** uke fn; k x; kA l kjs 0; kgokgfj d mnas ; ka ¼ SDVdy ij l ½ ds fy; s **MIL-STD-105D** , o **ANSI/ASQCZ 1.4** yxHkx , d tS s gA ifj/kku m | kx ea , ÐI S VBI l Sifyak fufj{k.k ds fy; s t; knkrj ck; j l - blgh ea l s fd l h LVBMZ ds Vey dks ns[krs ¼ j Qj½ gA gkykfd ifj/kku m | kx fufj{k.k ds fy; s l keku; fufj{k.k Lrj dk bLreky djrs gA bu fufj{k.k LVBMZ - dks mRi kn d ds fi Nys in"ku ds vuq kj de , o T; knk ¼ M; q M-, o VkbZ/uM½ fd; k tk l drk gA

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, ÐLki Vsy DokfyfV Ykoy dk Vsy Acceptable Quality Level Table

Lot Or Batch Size	Sample Size code Letter	Sample Size	Acceptable Quality Level					
			2.5		4.0		6.5	
			Ac	Re	Ac	Re	Ac	Re
2 to 8	A	2	0	1	0	1	0	1
9 to 15	B	3	0	1	0	1	0	1
16 to 25	C	5	0	1	0	1	0	1
26 to 50	D	8	0	1	1	2	1	2
51 to 90	E	13	1	2	1	2	2	3
91 to 150	F	20	1	2	2	3	3	4
151 to 280	G	32	2	3	3	4	5	6
281 to 500	H	50	3	4	5	6	7	8
501 to 1200	J	80	5	6	7	8	10	11
1201 to 3200	K	125	7	8	10	11	14	15
3201 to 10000	L	200	10	11	14	15	21	22
10001 to 35000	M	315	14	15	21	22	21	22

From ANSI/ASQC Z 1.4 the sampling procedure and tables for inspection by attributes.

## , ÐI S VSI I Sifyx lyku ds sdle djrk gS\

lkfj/kku m | ks ea fu.kz yus ds fy; se q; r% fl xy I Sifyx lyku dk bLreky gkrk gA ; | fi dN ck; jI ~Mcy I Sifyx lyku dk Hkh bLreky djrs gS fl xy lyku ea, a D; w, y- Vsy ds vk/kkj ij vki , d s gh] nh xbZ I q; k ds vuq kj YkkW I s xkjeVSI ~mBkrs gA I Sifyx lyku gea ; g Hkh crkrk gS fd fdrus xyr ihl I ~I Si y lyku ds vlrjxr% Lohdk; Z gkx A vxj xyr ihl ka dh I q; k Lohdk; Z xyr ihl ks dh I q; k I s de gkxh rks ykW Lohdkj fd; k tk; sk vxj xyr ihl ka dh I q; k Lohdk; Z xyr ihl ks dh I q; k I s T; knk gkxh rks ykW fjt DV gk tk; sk A vki ; g cksy s fd , ÐI S VSI I Sifyx I kbZUVfQd gS I gh ek; use arks bl ds ifj.kke 100% fo"ol uh; gkuk pfg; A vyx "kOnka eS bl ds }kjk Lohdk; Z I q; k I s de xyr ihl ks okys ykW geSkk Lohdkj fd; s tkus pfg; A , Ð Lohdk; Z I q; k I s vrfjDr xyr ihl ka okys ykW geSkk fjt DV fd; s tkua pfg; A ij ; g I Hko ugh gS D; kfd , ÐI S VSI dk fu.kz doy ykW I s fudkys , d FkkM/s I s I Siky ij fd; k tkrk gS ft; dh otg I s xyr fu.kz dh I Hkkouk ¼ jLd ½ jgrh gA , s D; w, y ij vk/kkfjr , ÐI S VSI fu.kz I s fuEu nks lkZkj ds fLd tM/s gS &

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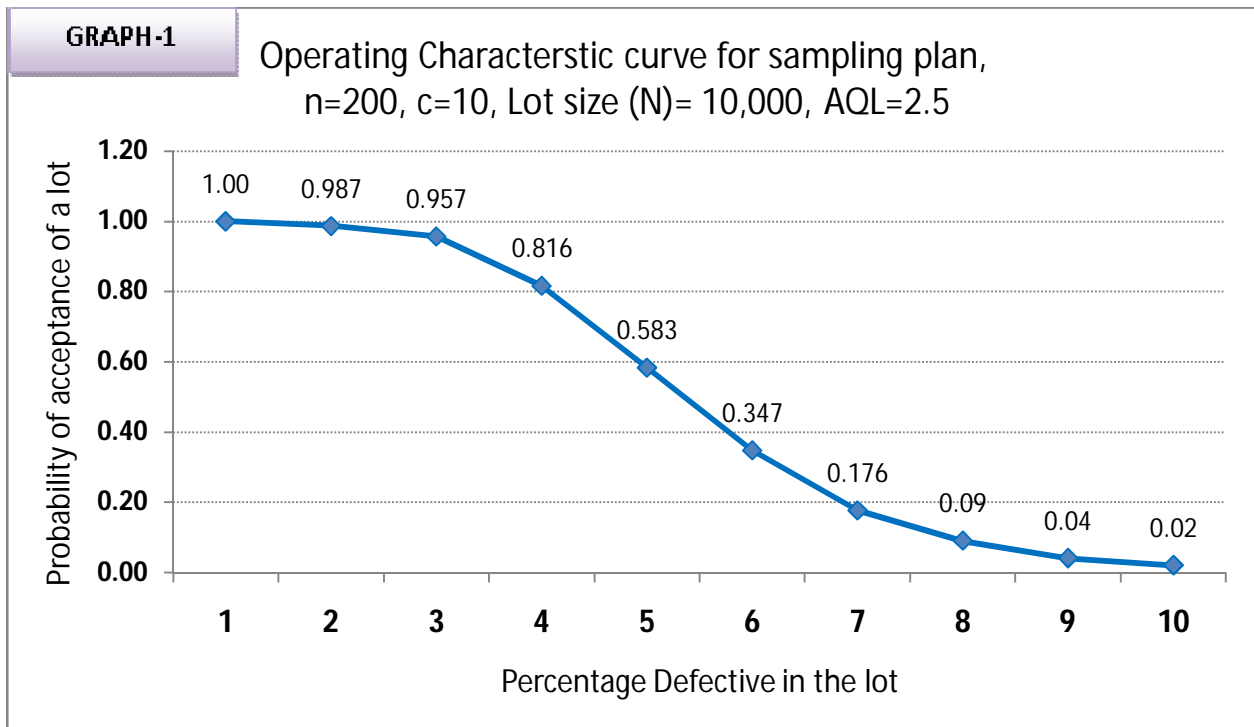
## 1- Cukusokysdk ¼ ÐI; q j ½ fjLd &

, d vPNk ykW fj tDV gkus dh voLFkk ¼ pKUL ½ ; kuh , d , d k ykW ftI ea Lohdk; ZI ; k dscjkj ; k ml l s de xyr ihl l -gka A

## 2- xkgd ¼ dLvej ½ dk fjLd &

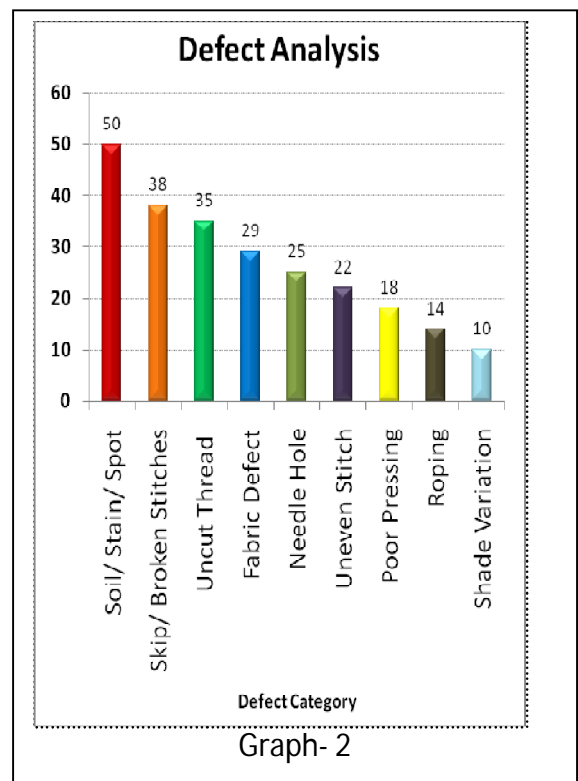
, d [kjk ykW dks Lohdkj djus dh voLFkk ¼ pKUL ½ ftI ea fMO\$DVo ihl l -dk T; knkrj Hkkx xkgd cgr de ifr"kr l e; [kjhuk pkgxkA bl s ykW Vkwj d ijl \$V fMO\$DVo ¼ LTPD ½ dgk tkrk gS ; k bl s fj tDVx DokfYkfV yoy ¼ RQL ½ }kjk Hkh n"kkz k tk l drk gA

ge vkwj \$Vx d \$ dVj fLVd doz (vks l h or O.C.) }kjk l e> l drsgfd vxj l \$iy lyku ds vk/kkj ij gg a fu.kz xyr gka Rkks dLvej ¼ xkgd ½ , d i kM; q j l -¼ mRi kn d ½ ds l keus fdl rjg ds fjLd vk l drsgA l \$iy lyku dk vks l h- doz vyx&vyx 'xyr ihl ka ds Lrj' ij ykW ds , ÐI \$ V\$ l , d fj tD"ku dh l EHkkouk crkrk gA xtQ 1& l \$iky lyku] n=200 , d ykW Lkkt] C=10, , d 10,000 ihl l -ds ykW l kbzt dk 2.5 AQL ij vks l h- doz fn[kk jgk gA xtQ 1 ij Y&, \$DI l ykW ds , ÐI \$V gkus dh l EHkkouk crkrh gS tcf d X & , \$DI l xyr ihl ks dk ifr"kr crkrh gA t\$ k fd n[kk tk l drk gS ftu ykW l -ea 2-5% rd xyr ejp\$Mkkt gkrh gS mudh 95% l EHkkouk , ÐI \$V ¼ Lohdr ½ gkus dh gkrh gS , Oka 5% l EHkkouk fj tDV gkus dh ¼ kM; q j fjLd ½ A i < us okys ; g tku dj pdr gkus fd ftu ykW l -ea 5% xyr ihl l -gks gS ¼ kuh AQL l s nksxuk ½ muds Hkh Lohdkj gkus dh l EHkkouk 100 ea l s 58-3 ckj gA bl l \$iy lyku l s dLvej dk fjLd yxHkx 10% gA ftI ykW ea 8% xyr ihl gka ml ds , ÐI \$V gkus dh Hkh l EHkkouk gA ftI lokbUV ij dLvej ugh pkgxk dh bl ds vks l \$iyak fufj{k.k }kjk ykW l , ÐI \$V gka ml s ykW Vkwj d ijl \$V fMO\$DVo ¼ LTPD ½ dgk tkrk gA l Hkh l \$iy lyku dk vks l h- doz cukus dh vkl ku ifdz k l \$ ge l e> l drsgfd og lyku fdl rjg l s , d vPNs , d cjs ykW ea QdZ fn[kk, skA tks yks bl fo'k; dh vks xgjkbz ea tkuk pkgsg og , - D; w , y- , d , y- Vh- ih- Mh- fn[kk dj , d mi ; q r l \$iy lyku viuh t: jr vuq kj tku l drsgA



**, - D; w , y- ij vKkjr fufj{k.k dS s l fuf"pr dja\**

bl i'z'u dk mRrj dkQh vkl ku gS yfdu i kuk cgr ef"dy gA l fuf"pr djafd vki dk vKs ru xyr ihl ka dk i fr"kr ck; j }kjk fn; sx; s , - D; w , y- l s de gA bl dk D; k Ekryc gS\ bl dk Ekryc gSfd l gh es , - D; w , y ds vk/kkj ij fufj{k.k ds fy; sfn; sx; sykW ea xyr ihl ka dk i fr"kr , - D; w , y- l s de gkuk pkfg; A bl ds fy; s vkWxukbzt'sku dk sekstmk vKs ru 'xyr ihl ka dk i fr"kr' eki uk gkxk ¼ i kS d , o jst ¼A dLvej ds fufj{k.k l s igy} ; g YkkW ds l si fyax fufj{k.k }kjk fd; k tk l drk gA bl rjg dsekeyka ea ykW ds l Hkh ihl l ~dk fufj{k.k fd; k tkrk gS , o ykW l -ea xyr ihl ka dk Lrj tkuk tkrk gA vxj vkWxukbzt'sku , d kj yxrkj 300 ykW l -dsfy; s djrh gS , o bu ykW l -dk vKs ru xyr ihl ka dk i fr"kr i rk djrh gS rks i kS d , o jst dk vPNk



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vnttk gks tk; skA eku fyft; sfd ikl st+, ojist ,s D; w , y- Lrj l sde gSrkscgr gh de vol j gks ¼ k/kkj.kr; k 5% l s 10% ½ ftuea f"ki eV fj tDV gkschA vxj ikl d , ojist ,s D; w , y- Lrj l s T; knk gksck rks vki dks bl ds Åij vks dk; Z djuk gksck] vxj l Ekkir djus ij ugh rks tM+l s xFyr; kllgVkus dh vks] rkdh ikl d , ojist ,s D; w , y- Lrj l sde gks tk; A vxj ikl d , ojist ,s D; w , y- yoy l s T; knk gks rks ,s D; w , y- }kjk fufj{k.k ea ikl d , ojist ij vk/kkfjr f"ki eV l -Qsy gks ds vol j T; knk gksck ikl d , ojist dks de djus dk l cl svPNk rjhd] ikbz tkus okyh fofHku idkj dh xFyr; ka dh Rkknkn dk eW; kaud djuk gA xtQ &2 eafn[kk; k x; k gsf d i j s/ks pkVZ }kjk eW; ka du cgr Qk; nœn gks l drk gA , d ckj tc vki dks irk py tk; sk fd l cl s T; knk vkus okyh xFyr; kll dks l h gA rks vki bu xFyr; ka ds l kr@tM+rd vkl kuh l sigp l drs gA , d bu xFyr; ka dks pdkne , .M bQDV , sukfyfl l p ¼ dkj .k , d i Hkko eW; ka du ½ }kjk [kRe dj l drs gA , d mul s fuokj .k i kus ds mik; ykxq dj l drs gA

## ,s D; w , y- D; k ugh gS\

,s D; w , y- D; k gS\ ; s d s dke djrk gS\ ,s D; w , y- ij vk/kkfjr fufj{k.k ea d s dke; kch i k, a\ tkus ds ckn ; g Hkh egROI w kZ gsf d ; g tkusfd ,s D; w , y- D; k ugh gSA ,s D; w , y- fuEuk ugh gS&

1- fu/kkfjr ,s D; w , y- Lrj ij xyr i hl ka dks f"ki djus dk ij feV %&

,s D; w , y- 4-00 dk ; g eryc fcYdy ugh gsf d l lyk; j ds ikl ; g gd gsf d og 4 i fr"kr xyr ejp s Mk bzt+dLvej@ck; j dks f"ki djA

2- xkj h fd ,s D; w , y- fufj{k.k ea i kl l Hkh f"ki eV l -fn; s x; s ,s D; w , y- l s ges'kk de gkch&

, d h dkbz xkjUVh ugh gsf d , d sy kVI -ftuea xyr i hl ka dk i fr"kr T; knk gksck og ,s D; w , y- fufj{k.k ea i kl ugh gkckA

3- mRiknd }kjk i kl xqkoRrk ds Lrj dk l pd&

, d k eku yrs gsf d mRiknd dh f"ki eV ea 6% xyr i hl ks dk vks r g s yfdu ck; j

}kjk QkbZuy fufj{k.k] 2-5 ,s D; w , y- ij gvk gA ; g l Hko gsf d mRiknd 100% fufj{k.k

dj dj xyr i hl ka dks fudkys rkdh f"ki eV ck; j ds fn; s x; s 2-5 ,s D; w , y- ij

QkbZuy bul i d"ku ea i kl gks i k; A