

CONDITIONS FOR SWITCHING TO AND FROM NORMAL INSPECTION

(From “Standards for Condition of Food Containers,” 7 CFR 42.108)

1. Normal Inspection to Reduced Inspection. When normal inspection is in effect, reduced inspection shall be instituted providing that reduced inspection is considered desirable by the Administrator and further providing that all of the following conditions are satisfied for each class of defects:
 - (a) The preceding 10 inspection lots (or more, as indicated by the note to table below) which have been inspected within the preceding 6 months have been on normal inspection and none has been rejected on original inspection (excluding resubmitted lots); and
 - (b) The total number of defects in the samples from the preceding 10 inspection lots (or such other number of lots indicated above) is equal to or less than the applicable number given in table below. Before switching to reduced inspection, all classes of defects must meet the rules for switching.

TABLE III-B –LIMIT NUMBERS FOR REDUCED INSPECTION

Number of sample units from last 10 consecutive lots inspected within 6 months	Acceptable quantity level								
	0.15	0.25	0.5	1.0	1.5	2.5	4.0	6.5	10.0
320-499.....	(*)	(8)	(*)	0	1	4	8	14	24
500-799.....	(*)	(*)	0	2	3	7	14	25	40
800-1,249.....	(*)	0	1	4	7	14	24	42	68
1,250-1,999.....	0	0	3	7	13	24	40	69	110
2,000-3,149.....	0	2	6	14	22	40	68	115	181
3,150-4,999.....	1	4	10	24	38	67	111	186	293
5,000-7,999.....	3	7	18	40	63	110	181	302	472
8,000-12,499.....	7	14	31	68	105	181	297	491	675
12,500-19,999.....	13	24	52	110	169	290	471	777	1207

*Denotes that the number of sample units from the last 10 inspection lots is not sufficient for reduced inspection for this AQL. In this instance more than 10 inspection lots may be used for the calculations if; the inspection lots used are for the most recent ones in sequence within the last 6 months, they have all been on normal inspection, and none has been rejected on original inspection.

2. Reduced Inspection to Normal Inspection.
 - (a) An inspection lot is rejected on original inspection; or
 - (b) Production becomes irregular (delayed or accelerated); or
 - (c) Other valid conditions warrant that normal inspection shall be reinstated.
3. Normal Inspection to Tightened Inspection. When normal inspection is in effect, tightened inspection shall be instituted when 2 out of 5 consecutive inspection lots have been rejected on original inspection. When the rules require a switch to tightened inspection on one or more classes or defects all classes shall be on tightened inspection.
4. Tightened Inspection to Normal inspection. When tightened inspection is in effect, normal inspection shall be reinstated when 5 consecutive inspection lots have been considered acceptable on original inspection. Before switching to normal inspection all classes of defects must meet the rules of switching.