(2) Reject the lot after examining the single sample or first sample of a double sampling plan when any one or more of the following conditions occur:

(i) The number of critical defects equals or exceeds the applicable rejection number (Re) for critical defects, or

(ii) The number of major defects equals or exceeds the applicable rejection number (Re) for major defects, or

(iii) The total number of critical, major, and minor defects equals or exceeds the applicable rejection number (Re) for total defects.

(3) If the lot can neither be accepted nor rejected on the first sample, when a double sampling plan is used, select and examine the prescribed second sample. Accept the lot if the accumulated defects of the first and second sample meet conditions of paragraph (c)(1) of this section, otherwise, reject the lot.

[31 FR 4687, Mar. 19, 1966, as amended at 36 FR 18456, Sept. 15, 1971. Redesignated at 42 FR 32514, June 27, 1977 and 46 FR 63203, Dec. 31, 1981]

§ 42.108 Normal, tightened, or reduced inspection.

(a) *Normal inspection.* Sampling plans for normal inspection are those in Tables I and I–A. These plans shall be used except when the history of inspection permits reduced inspection or requires tightened inspection.

(b) *Tightened inspection.* Sampling plans for tightened inspection are those in Tables II and II–A.

(c) *Reduced inspection.* Sampling plans for reduced inspection are those in Tables III and III–A.

(d) *Switching rules.* The normal inspection procedure shall be followed except when conditions in paragraph (d) (1) or (3) of this section are applicable or unless otherwise specified. Application of the following switching rules will be restricted to the inspection of lots for one applicant at a single location (plant, warehouse, etc.), and will be based upon records of original inspections of lots (excluding resubmitted lots) at that same location.

(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 provided that all of the following conditions are satisfied for each class of defect:

(i) The preceding 10 inspection lots (or more, as indicated by the note to Table III–B) which have been inspected within the preceding 6 months have been on normal inspection and none has been rejected on original inspection; and

(ii) The total number of defects in the samples from the preceding 10 inspection lots (or such other number of lots used for condition in paragraph (d)(1)(i) of this section) is equal to or less than the applicable number given in Table III–B. If a double sampling plan is used, all samples inspected should be included, not ''first'' samples only; and

(2) *Reduced inspection to normal inspection.* When reduced inspection is in effect, normal inspection shall be reinstituted if any of the following occur:

(i) An inspection lot is rejected on original inspection; or

(ii) Production becomes irregular (delayed or accelerated); or

(iii) Other valid conditions warrant that normal inspection shall be reinstituted.

(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.

(4) *Tightened inspection to normal inspection.* When tightened inspection is in effect, normal inspection shall be reinstituted when five consecutive inspection lots have been considered acceptable on original inspection.

(e) When the rules require a switch in the inspection status because of one or more classes of defects, all classes of defects shall be inspected under the new inspection criteria. At the option of the user of the service and when approved by the Administrator, such user may elect to remain on normal inspection when qualified for reduced inspection, or on tightened inspection when qualified for normal inspection.

(f) *Appeal inspection*—(1) *Appeal request.* Any interested party who is not satisfied with the results of a condition

inspection on packaged food containers, as stated on an official certificate, may request an appeal inspection.

(2) *How to file an appeal.* A request for an appeal inspection may be made orally or in writing. If made orally, written confirmation may be required. The applicant shall clearly state the reasons for requesting the appeal service and a description of the product to be appealed.

(3) *When an application for an appeal inspection may be refused.* When it appears that: (i) The reasons given in the request are frivolous or not substantial; or (ii) the condition of the containers has undergone a material change since the original inspection; or (iii) the original lot is no longer intact, the applicant's request for the appeal inspection may be refused. In such case, the applicant shall be promptly notified of the reason(s) for such refusal.

(4) *Who shall perform the appeal.* An appeal inspection shall be performed by a person(s) other than the person who made the inspection being appealed.

(5) *Sampling procedures.* The sampling plan for an appeal inspection shall be the next larger sampling plan from the plan in the table used in the original inspection.

(6) *Appeal certificate.* Immediately after an appeal inspection is completed, an appeal certificate shall be issued to show that the original inspection was sustained or was not sustained. Such certificate shall supersede any previously issued certificate for the inspection involved and shall clearly identify the number and date of the superseded certificate. The issuance of the appeal certificate may be withheld until the previously issued certificate and all copies have been returned when such action is deemed necessary to protect the interest of the Government.

[31 FR 4687, Mar. 19, 1966, as amended at 36 FR 18456, Sept. 15, 1971. Redesignated at 42 FR 32514, June 27, 1977 and 46 FR 63203, Dec. 31, 1981]

§ 42.109 Sampling plans for normal condition of container inspection, Tables I and I–A.

TABLE I—SAMPLING PLANS FOR NORMAL CONDITION OF CONTAINER INSPECTION

Code	Lot size ranges—Number of containers in lot	Type of plan	AQL 0.15						Other acceptable quality levels															
			Sample size		Ac	Re	Sample size		0.25		0.50		1.0		1.5		2.5		4.0		6.5		10.0	
									Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
CA	6,000 or less	Single		126	0	1		84	0	1	1	2	2	3	3	4	4	5	6	7	9	10	13	14
		Double					1st	36	(*)	(*)	0	2	0	3	0	4	0	4	0	5	2	7	3	9
CB	6,001–12,000	Single		264	1	2		168	1	2	2	3	4	5	5	6	7	8	11	12	16	17	23	24
		Double	1st	174	0	3	1st	120	0	2	0	3	2	5	2	6	3	7	6	10	10	14	14	19
			2d	162			2d	60																
			Total	336	1	2	Total	180	1	2	2	3	4	5	5	6	8	9	12	13	17	18	25	26
CC	12,001–36,000	Single		500	2	3		315	2	3	3	4	6	7	8	9	13	14	19	20	28	29	41	42
		Double	1st	252	0	3	1st	168	0	3	0	4	1	5	2	7	5	10	7	13	12	18	19	26
			2d	288			2d	180																
			Total	540	2	3	Total	348	2	3	3	4	7	8	9	10	14	15	21	22	31	32	45	46
CD	Over 36,000	Single		800	3	4		500	3	4	5	6	9	10	12	13	18	19	28	29	42	43	62	63
		Double	1st	456	0	4	1st	228	0	3	0	5	2	7	3	9	5	11	8	17	15	24	23	34
			2d	408			2d	288																
			Total	864	3	4	Total	516	3	4	5	6	9	10	12	13	19	20	29	30	43	44	64	65
CE		Single		1,250	4	5		800	4	5	7	8	13	14	18	19	27	28	42	43	64	65	95	96

Ac=Acceptance number.
Re=Rejection number.
(*)=Reject on one or more defects. These plans are less preferable than those with numbers listed under Ac and Re.

TABLE I–A—SAMPLING PLANS OF SELECTED AQL'S FOR NORMAL CONDITION OF CONTAINER INSPECTION

Code	Lot size ranges—No. of containers in lot	Type of plan	Sample size		Acceptable quality levels					
					0.25		1.5		6.5	
					Ac	Re	Ac	Re	Ac	Re
CA	6,000 or less	Double	1st	36	(*)	(*)	0	4	2	7
			2d	60	.....	.....	.....	.....	.....	.....
			Total	96	(*)	(*)	3	4	10	11
CB	6,001–12,000	Double	1st	120	0	2	2	6	10	14
			2d	60	.....	.....	.....	.....	.....	.....
			Total	180	1	2	5	6	17	18
CC	12,001–36,000	Double	1st	168	0	3	2	7	12	18
			2d	180	.....	.....	.....	.....	.....	.....
			Total	348	2	3	9	10	31	32
CD	Over 36,000	Double	1st	228	0	3	3	9	15	24
			2d	288	.....	.....	.....	.....	.....	.....
			Total	516	3	4	12	13	43	44

(*)=Reject on one or more defects.

[31 FR 4637, Mar. 19, 1966, as amended at 36 FR 18457, Sept. 15, 1971. Redesignated at 42 FR 32514, June 27, 1977 and 46 FR 63203, Dec. 31, 1981]

§ 42.110 Sampling plans for tightened condition of container inspection; Tables II and II–A.

TABLE II—SAMPLING PLANS FOR TIGHTENED CONDITION OF CONTAINER INSPECTION

Code	Lot size ranges—Number of containers in lot	Type of plan	AQL 0.15						Other acceptable quality levels															
			Sample size		Ac	Re	Sample size		0.25		0.50		1.0		1.5		2.5		4.0		6.5		10.0	
									Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
CB	6,000 or less	Single		264	0	1		168	0	1	1	2	2	3	4	5	5	6	7	8	11	12	16	17
		Double	1st	1st				120	(*)	(*)	0	2	0	3	2	5	2	6	3	7	6	10	10	14
			2d				2d	60																
			Total				Total	180	(*)	(*)	1	2	2	3	4	5	5	6	8	9	12	13	17	18
CC	6,001–12,000	Single		500	1	2		315	1	2	2	3	3	4	6	7	8	9	13	14	19	20	28	29
		Double	1st	360	0	2	1st	168	0	2	0	3	0	4	1	5	2	7	5	10	7	13	12	18
			2d	156			2d	180																
			Total	516	1	2	Total	348	1	2	2	3	3	4	7	8	9	10	14	15	21	22	31	32
CD	12,001–36,000	Single		800	2	3		500	2	3	3	4	5	6	9	10	12	13	18	19	28	29	42	43
		Double	1st	456	0	3	1st	228	0	3	0	3	0	5	2	7	3	9	5	11	8	17	15	24
			2d	408			2d	288																
			Total	864	2	3	Total	516	2	3	3	4	5	6	9	10	12	13	19	20	29	30	43	44
CE	Over 36,000	Single		1,250	3	4		800	3	4	4	5	7	8	13	14	18	19	27	28	42	43	64	65
		Double	1st				1st	456	0	4	1	5	2	6	5	10	8	13	12	19	21	28	32	41
			2d			2d	408																	
			Total				Total	864	3	4	4	5	8	9	14	15	19	20	29	30	44	45	69	70
CF		Single		1,250	3	4		1,250	4	5	7	6	10	11	19	20	26	27	41	42	63	64	96	97

(*) Reject on one or more defects.

TABLE II–A—SAMPLING PLANS OF SELECTED AQL'S FOR TIGHTENED CONDITION OF CONTAINER INSPECTION

Code	Lot size ranges—No. of containers in lot	Type of plan	Sample size		Acceptable quality levels					
					0.25		1.5		6.5	
					Ac	Re	Ac	Re	Ac	Re
CB	6,000 or less	Double	1st	120	(*)	(*)	2	5	6	10
			2d	60	.....	.....	.....	.....	.....	.....
			Total	180	(*)	(*)	4	5	12	13
CC	6,001–12,000	Double	1st	168	0	2	1	5	7	13
			2d	180	.....	.....	.....	.....	.....	.....
			Total	348	1	2	7	8	21	22
CD	12,001–36,000	Double	1st	228	0	3	2	7	8	17
			2d	288	.....	.....	.....	.....	.....	.....
			Total	516	2	3	9	10	29	30
CE	Over 36,000	Double	1st	456	0	4	5	10	21	28
			2d	408	.....	.....	.....	.....	.....	.....
			Total	864	3	4	14	15	44	45

(*) Reject on one or more defects.

[31 FR 4687, Mar. 19, 1966, as amended at 36 FR 18457, Sept. 15, 1971. Redesignated at 42 FR 32514, June 27, 1977 and 46 FR 63203, Dec. 31, 1981]

§ 42.111 Sampling plans for reduced condition of container inspection, Tables III and III–A; and limit number for reduced inspection, Table III–B.

TABLE III—SAMPLING PLANS FOR REDUCED CONDITION OF CONTAINER INSPECTION

Code	Lot size ranges—Number of containers in lot	Type of plan	Sample size		Acceptable quality levels																	
					0.15		0.25		0.50		1.0		1.5		2.5		4.0		6.5		10.0	
					Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re	Ac	Re
CAA	6,000 or less	Single		29	1	2	1	2	1	2	1	2	1	2	2	3	3	4	4	5	5	6
		Double	1st	18	0	2	0	2	0	2	0	2	0	2	0	3	1	3	1	4	2	5
			2d	18	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....
			Total	36	1	2	1	2	1	2	1	2	1	2	2	3	4	5	5	6	6	7
CA	6,001–36,000	Single		84	1	2	1	2	1	2	2	3	3	4	4	5	6	7	9	10	13	14
	Double	1st	36	0	2	0	2	0	2	0	3	0	4	0	4	0	5	2	7	3	9	
			2d	60	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....
			Total	96	1	2	1	2	1	2	2	3	3	4	4	5	7	8	10	11	15	16
CB	Over 36,000	Single		168	1	2	1	2	2	3	4	5	5	6	7	8	11	12	16	17	23	24
		Double	1st	120	0	2	0	2	0	3	2	5	2	6	3	7	6	10	10	14	14	19
			2d	60	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....	....
			Total	180	1	2	1	2	2	3	4	5	5	6	8	9	12	13	17	18	25	26
CC		Single		315	1	2	2	3	3	4	6	7	8	9	13	14	19	20	28	29	41	42

TABLE III–A—SAMPLING PLANS FOR REDUCED CONDITION OF CONTAINER INSPECTION

Code	Lot size ranges—No. of containers in lot	Type of plan	Sample size		Acceptable quality levels					
					0.25		1.5		6.5	
					Ac	Re	Ac	Re	Ac	Re
CAA	6,000 or less	Double	1st	18	0	2	0	2	1	4
		2d	18	.....	.....	.....	.....	.....	.....	
			Total	36	1	2	1	2	5	6
CA	6,001–36,000	Double	1st	36	0	2	0	4	2	7
			2d	60	.....	.....	.....	.....	.....	.....
			Total	96	1	2	3	4	10	11
CB	Over 36,000	Double	1st	120	0	2	2	6	10	14
			2d	60	.....	.....	.....	.....	.....	.....
			Total	180	1	2	5	6	17	18

TABLE III–B—LIMIT NUMBERS FOR REDUCED INSPECTION

Number of sample units from last 10 lots inspected within 6 months	Acceptable quality level								
	0.15	0.25	0.5	1.0	1.5	2.5	4.0	6.5	10.0
320–499	(*)	(*)	(*)	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	765
12,500–19,999	13	24	52	110	169	290	471	777	1,207

*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 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.

[31 FR 4687, Mar. 19, 1966, as amended at 36 FR 18457, Sept. 15, 1971; 41 FR 42639, Sept. 28, 1976. Redesignated at 42 FR 32514, June 27, 1977 and 46 FR 63203, Dec. 31, 1981]

§ 42.112 Defects of containers: Tables IV, V, VI, and VII.

TABLE IV—METAL CONTAINERS

Defects	Categories		
	Critical	Major	Minor
Type or size of container or component parts not as specified	(1)	(1)	(1)
Closure incomplete, not located correctly or not sealed, crimped, or fitted properly	.....	101	.....
Dirty, stained or smeared container	.....	.....	201
Key opening metal containers (when required):			
(a) Key missing	.....	102	.....
(b) Key does not fit tab	.....	103	.....
(c) Tab of opening band insufficient to provide accessibility to key	.....	104	.....
(d) Improper scoring (band would not be removed in one continuous strip)	.....	105	.....
Open top with plastic overcap (when required):			
(a) Plastic overcap missing	.....	106	.....
(b) Plastic overcap warped (making opening or reapplication difficult)	.....	107	.....
Outside tinplate or coating (when required):			
(a) Missing or incomplete	.....	.....	202
(b) Blistered, flaked, sagged, or wrinkled	.....	.....	203
(c) Scratched or scored	.....	.....	204
(d) Fine cracks	.....	.....	205
Rust (rust stain confined to the top or bottom double seam or rust that can be removed with a soft cloth is not scored a defect):			
(a) Rust stain (nonmilitary purchases)	.....	.....	206
(b) Rust stain (military purchases)	.....	108	.....
(c) Pitted rust	.....	109	.....
Wet cans (excluding refrigerated containers)	.....	.....	207

TABLE IV—METAL CONTAINERS—Continued

Defects	Categories		
	Critical	Major	Minor
Dent:			
(a) Materially affecting appearance but not usability			208
(b) Materially affecting usability		110	
Buckle:			
(a) Not involving end seam			209
(b) Extending into the end seam		111	
Collapsed container		112	
Paneled side materially affecting appearance but not usability			210
Solder missing when required		113	
Cable cut exposing seam		114	
Improper side seam		115	
Swell, springer, or flipper (not applicable to gas or pressure packed product nor frozen products)	1		
Leaker or blown container	2		
Frozen products only:			
(a) Bulging ends 3/16″ to 1/4″ beyond lip			211
(b) Bulging ends more than 1/4″ beyond lip		116	

[1] None permitted.

TABLE V—GLASS CONTAINERS

Defects	Categories		
	Critical	Major	Minor
Type or size of container or component parts not as specified	(1)	(1)	(1)
Closure not sealed, crimped, or fitted properly		101	
Dirty, stained, or smeared container			201
Chip in glass			202
Stone (unmelted material) in glass			203
Pits in surface of glass			204
Sagging surface			205
Bead (bubble within glass):			
(a) 1/8″ to 1/16″ in diameter			206
(b) Exceeding 1/8″ in diameter		102	
Checked		103	
Thin spot in glass		104	
Blister (structural defect)		105	
Bird swing (glass appendage inside container)	1		
Broken or leaking container	2		
Cap (nonheat processed):			
(a) Cross-threaded			207
(b) Loose but not leaking			208
(c) Pitted rust		106	
Cap (heat processed):			
(a) Cross-threaded or loose	3		
(b) Pitted rust		107	
Sealing tape or cello band (when required):			
(a) Improperly placed			209
(b) Not covering juncture of cap and glass		108	
(c) Ends overlap by less than 1/2″		109	
(d) Loose or deteriorating		110	

[1] None permitted.

TABLE VI—RIGID AND SEMIRIGID CONTAINERS—CORRUGATED OR SOLID FIBERBOARD, CHIPBOARD, WOOD, ETC. (EXCLUDING GLASS AND METAL)

Defects	Categories		
	Critical	Major	Minor
Type or size of container or component parts not as specified	(1)	(1)	(1)
Component part missing		101	
Closure not sealed, crimped, or fitted properly:			
(a) Primary container		102	
(b) Other than primary container			201
Dirty, stained, or smeared container			202
Wet or damp (excluding ice packs):			
(a) Materially affecting appearance but not usability			203

TABLE VI—RIGID AND SEMIRIGID CONTAINERS—CORRUGATED OR SOLID FIBERBOARD, CHIPBOARD, WOOD, ETC. (EXCLUDING GLASS AND METAL)—Continued

Defects	Categories		
	Critical	Major	Minor
(b) Materially affecting usability		103	
Moldy area	1		
Crushed or torn area:			
(a) Materially affecting appearance but not usability			204
(b) Materially affecting usability		104	
Separation of lamination (corrugated fiberboard):			
(a) Materially affecting appearance but not usability			205
(b) Materially affecting usability		105	
Product sifting or leaking		106	
Nails or staples (when required):			
(a) Not as required, insufficient number or improperly positioned			206
(b) Nails or staples protruding		107	
Glue or adhesive (when required); not holding properly not covering area specified, or not covering sufficient area to hold properly:			
(a) Primary container		108	
(b) Other than primary container			207
Flap:			
(a) Projects beyond edge of container more than ¼ inch			208
(b) Does not meet properly, allowing space of more than ¼ inch			209
Sealing tape or strapping (when required):			
(a) Missing		109	
(b) Improperly placed or applied			210

[1] None permitted.

TABLE VII—FLEXIBLE CONTAINERS (PLASTIC, CELLO, PAPER, TEXTILE, ETC.)

Defects	Categories		
	Critical	Major	Minor
Type or size of container or component parts not as specified	([1])	([1])	([1])
Closure not sealed, crimped, stitched, or fitted properly:			
(a) Primary container		101	
(b) Other than primary container			201
Dirty, stained, or smeared container			202
Unmelted gels in plastic			203
Torn container:			
(a) Materially affecting appearance but not usability			204
(b) Materially affecting usability		102	
Product sifting or leaking		103	
Moldy area	1		
Individual packages sticking together or to shipping case (tear when separated)		104	
Not fully covering product		105	
Wet or damp (excluding ice packs):			
(a) Materially affecting appearance but not usability			205
(b) Materially affecting usability		106	
Overwrap (when required):			
(a) Missing		107	
(b) Loose, not sealed or closed			206
(c) Improperly applied			207
Sealing tape, strapping or adhesives (when required):			
(a) Missing		108	
(b) Improperly placed, applied, torn, or wrinkled			208
Tape over bottom and top closures (when required):			
(a) Not covering stitching		109	
(b) Torn (exposing stitching)		110	
(c) Wrinkled (exposing stitching)		111	
(d) Not adhering to bag:			
1. Exposing stitching		112	
2. Not exposing stitching			209
(e) Improper placement			210

[1] None permitted.

[31 FR 4687 Mar. 19, 1966, as amended at 36 FR 18457, Sept. 15, 1971; 41 FR 42639, Sept. 28, 1976. Redesignated at 42 FR 32514, June 27, 1977 and 46 FR 63203, Dec. 31, 1981]