

UNITED STATES DEPARTMENT OF AGRICULTURE
Agricultural Marketing Service
Fruit and Vegetable Division
Processed Products Branch

A-488
December 1993

SUBJECT: Time Sampling and Segregation Procedures for Canned Green and Wax Beans - In Plant

TO: All Inspectors

FILE UNDER: United States Standards for Grades of Canned Green and Wax Beans

PURPOSE AND SCOPE

To inform all in-plant inspectors about the procedures to follow when using time sampling provisions to grade canned green and wax beans under individual attributes. The following are in-plant time sampling and segregation procedures for grading canned green and wax beans under individual attributes.

AUTHORIZATION TO USE TIME SAMPLING

The Officer-in-Charge or area supervisor shall determine whether a plant can qualify to use the time sampling procedures outlined below. This determination shall be based on a review of the plant's quality control records and the ability of the plant to pack product consistently within a desired quality level. The supervisor shall not authorize time sampling for a plant which historically produces product which is determined to have erratic quality levels during a production period.

SOURCE OF SAMPLES

All sample units must be officially drawn from "finished product." Finished product means product that has been processed, cooled, and taken from the container(s) to be graded. Line checks shall not be used in lieu of finished product.

TIME SAMPLING RATES PER INSPECTION PERIOD

Sample units are to be selected on a random time basis averaging within the parameters outlined below so that each sample unit has an equal chance of being selected.

The sampling rate for each product graded is to be **predetermined**, based on knowledge of **previous** production volume for the product per basic inspection period and the **on-line** sampling plans in the "Regulations."

Sampling rates and frequencies for canned green and wax beans are based on the following table:

Predetermined Production Rate	Sampling Frequency	Deviants Allowed
Low Volume (3)	For can sizes #3 cylinder and larger: 400 units per 60 min. (per 90 min., optional)	0
	For smaller than #3 cylinder: 100 units per 60 min. (per 90 min., optional)	
Medium Volume (6 or 13)	For can sizes #3 cylinder and larger: 400 units per 45 min.	0
	For smaller than #3 cylinder: 100 units per 45 min.	
High Volume (21 or more)	For can sizes #3 cylinder and larger: 400 units per 30 min. (per 15 min., optional)	0
	For smaller than #3 cylinder: 100 units per 30 min. (per 15 min., optional)	

MINIMUM SAMPLE SIZE TO CERTIFY A PORTION OF PRODUCTION

For specified defects, 600 units of product **from three (3) sample units** is the minimum sample size under time sampling. For grading small portions of production or small containers, inspectors may need to draw a few extra containers to assure that 600 units are available.

PROCEDURES FOR GRADING MIXED QUALITY WITHIN THE PRODUCTION PERIOD

As provided for lot inspection under individual attributes, there is a similar provision to address pockets of low quality within a production period under time sampling. If during the production period, a sample unit(s) is encountered for one or more specified defects that falls **more than one grade below the indicated grade** for the production period, **certify the production period to the lowest grade**. For the next period of production, the inspector **must** use the lot inspection rate in the Regulations. After grading one production period at the lot inspection rate and finding no pockets of low quality, the inspector may again use time sampling procedures and make note of each occurrence in the Daily Inspection Report under "Remarks".

SEGREGATION PROCEDURES

If at any time during production, a portion of production falls into **the next lower grade**, the entire production fails at that point unless the offending portion can be segregated by codes. Plant management has two options--one, to request segregation of the offending portion or two, to continue production without segregation anticipating better quality product will offset the offending portion. If plant management requests that a portion of failing production be segregated, all defects found that are associated with the failing portion shall be excluded from the tally of the remaining portion. The failing portion may be re-inspected as a new lot only under appeal inspection or after the product has been reworked in an effort to eliminate or reduce the defects from the failing portion.

OTHER REQUIREMENTS

The following are separate but equally important requirements that must be followed when using time sampling for canned green and wax beans:

Inspectors cannot switch back and forth between on-line single sampling rates and time sampling **unless it is due to mixed quality sample units within a production period**.

The inspector must indicate that "time sampling" is being used on each tally sheet.

Attached are the acceptance numbers for three (3) to 38 sample units of cut green and wax beans using the 400 and 100 Plans.


James R. Rodeheaver
Branch Chief

Distribution:A
Agriculture:Washington

**Grade A
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
3 to 38 Sample Units (400 count each)**

UNITS OF PROD	EVM	STEMS	MAJ BLEMS	TOTAL BLEMS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	.4	1.5	.65	1.5	2.5	6.5	1.0	1.0	.04	4.0	8.5	1.0	.4
1200	8	25	12	25	39	92	18	18	1	59	118	18	8
1600	10	32	16	32	50	121	22	22	2	77	155	22	10
2000	12	39	19	39	61	149	27	27	2	95	191	27	12
2400	15	46	22	46	73	176	32	32	2	112	227	32	15
2800	17	52	25	52	84	204	37	37	3	129	263	37	17
3200	18	59	28	59	95	232	41	41	3	146	299	41	18
3600	20	66	31	66	105	259	46	46	3	164	335	46	20
4000	22	73	34	73	116	286	50	50	4	181	371	50	22
4400	24	79	37	79	127	314	55	55	4	198	406	55	24
4800	26	86	40	86	138	341	59	59	4	215	441	59	26
5200	28	92	43	92	149	368	64	64	4	232	476	64	28
5600	30	99	46	99	159	396	68	68	5	248	512	68	30
6000	32	105	49	105	170	423	73	73	5	265	547	73	32
6400	34	112	52	112	181	450	77	77	5	282	583	77	34
6800	36	118	55	118	191	477	81	81	5	299	618	81	36
7200	38	125	58	125	202	504	86	86	6	316	653	86	38
7600	39	131	61	131	212	531	90	90	6	332	688	90	39
8000	41	138	64	138	223	558	95	95	6	350	723	95	41
8400	43	144	67	144	234	585	99	99	6	366	758	99	43
8800	45	151	69	151	244	612	103	103	6	383	793	103	45
9200	47	157	72	157	255	638	108	108	7	399	828	108	47
9600	48	164	75	164	265	665	112	112	7	416	863	112	48
10000	50	170	78	170	276	692	116	116	7	433	898	116	50
10400	52	176	81	176	286	719	121	121	7	450	933	121	52

Grade A - Continued
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
3 to 38 Sample Units (400 count each)

UNITS OF PROD	EVM	STEMS	MAJ BLEMS	TOTAL BLEMS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	.4	1.5	.65	1.5	2.5	6.5	1.0	1.0	.04	4.0	8.5	1.0	.4
10800	54	183	84	183	297	746	125	125	8	466	968	125	54
11200	56	189	87	189	307	772	129	129	8	483	1003	129	56
11600	57	195	89	195	318	799	134	134	8	499	1037	134	57
12000	59	202	92	202	329	826	138	138	8	516	1073	138	59
12400	61	208	95	208	339	853	142	142	8	533	1107	142	61
12800	63	215	98	215	350	880	146	146	9	549	1142	146	63
13200	65	221	101	221	360	906	151	151	9	566	1177	151	65
13600	66	227	104	227	371	933	155	155	9	583	1212	155	66
14000	68	234	106	234	381	960	159	159	9	599	1247	159	68
14400	70	240	109	240	391	986	164	164	10	616	1282	164	70
14800	72	246	112	246	401	1013	168	168	10	632	1316	168	72
15200	73	253	115	253	412	1040	172	172	10	649	1351	172	73

**Grade B
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
3 to 38 Sample Units (400 count each)**

UNITS OF PROD	EVM	STEMS	MAJ BLEMES	TOTAL BLEMES	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	.65	2.5	1.5	2.5	4.0	10.0	2.5	2.5	.65	8.5	N/A	8.5	1.0
1200	12	39	25	39	59	138	39	39	12	118	N/A	118	18
1600	16	50	32	50	77	181	50	50	16	155	N/A	155	22
2000	19	61	39	61	95	223	61	61	19	191	N/A	191	27
2400	22	73	46	73	112	265	73	73	22	227	N/A	227	32
2800	25	84	52	84	129	307	84	84	25	263	N/A	263	37
3200	28	95	59	95	146	350	95	95	28	299	N/A	299	41
3600	31	105	66	105	164	391	105	105	31	335	N/A	335	46
4000	34	116	73	116	181	433	116	116	34	371	N/A	371	50
4400	37	127	79	127	198	475	127	127	37	406	N/A	406	55
4800	40	138	86	138	215	516	138	138	40	441	N/A	441	59
5200	43	149	92	149	232	557	149	149	43	476	N/A	476	64
5600	46	159	99	159	248	599	159	159	46	512	N/A	512	68
6000	49	170	105	170	265	641	170	170	49	547	N/A	547	73
6400	52	181	112	181	282	682	181	181	52	583	N/A	583	77
6800	55	191	118	191	299	723	191	191	55	618	N/A	618	81
7200	58	202	125	202	316	764	202	202	58	653	N/A	653	86
7600	61	212	131	212	332	805	212	212	61	688	N/A	688	90
8000	64	223	138	223	350	847	223	223	64	723	N/A	723	95
8400	67	234	144	234	366	887	234	234	67	758	N/A	758	99
8800	69	244	151	244	383	929	244	244	69	793	N/A	793	103
9200	72	255	157	255	399	970	255	255	72	828	N/A	828	108
9600	75	265	164	265	416	1011	265	265	75	863	N/A	863	112
10000	78	276	170	276	433	1052	276	276	78	898	N/A	898	116

Grade B - Continued
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
3 to 38 Sample Units (400 count each)

U N I T S O F P R O D	E V M	S T E M S	M A J B L E M S	T O T A L B L E M S	M E C H D A M A G E	S H O R T P I E C E S	T O U G H S T R I N G S	E D I B L E F I B E R	I N E D I B L E F I B E R	C O L O R D E F E C T I V E S	"B" C H A R A C T E R	"C" C H A R A C T E R	"SStd" C H A R A C T E R
(AQL)	.65	2.5	1.5	2.5	4.0	10.0	2.5	2.5	.65	8.5	N/A	8.5	1.0
10400	81	286	176	286	450	1093	286	286	81	933	N/A	933	121
10800	84	297	183	297	466	1134	297	297	84	968	N/A	968	125
11200	87	307	189	307	483	1175	307	307	87	1003	N/A	1003	129
11600	89	318	195	318	499	1216	318	318	89	1037	N/A	1037	134
12000	92	329	202	329	516	1257	329	329	92	1073	N/A	1073	138
12400	95	339	208	339	533	1298	339	339	95	1107	N/A	1107	142
12800	98	350	215	350	549	1339	350	350	98	1142	N/A	1142	146
13200	101	360	221	360	566	1380	360	360	101	1177	N/A	1177	151
13600	104	371	227	371	583	1421	371	371	104	1212	N/A	1212	155
14000	106	381	234	381	599	1462	381	381	106	1247	N/A	1247	159
14400	109	391	240	391	616	1502	391	391	109	1282	N/A	1282	164
14800	112	401	246	401	632	1543	401	401	112	1316	N/A	1316	168
15200	115	412	253	412	649	1584	412	412	115	1351	N/A	1351	172

**Grade C
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
3 to 38 Sample Units (400 count each)**

UNITS OF PROD	EVM	STEMS	MAJ BLEMMS	TOTAL BLEMMS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	1.5	4.0	2.5	6.5	8.5	15.0	6.5	6.5	2.5	15.0	N/A	N/A	8.5
1200	25	59	39	92	118	200	92	92	39	200	N/A	N/A	118
1600	32	77	50	121	155	263	121	121	50	263	N/A	N/A	155
2000	39	95	61	149	191	326	149	149	61	326	N/A	N/A	191
2400	46	112	73	176	227	388	176	176	73	388	N/A	N/A	227
2800	52	129	84	204	263	451	204	204	84	451	N/A	N/A	263
3200	59	146	95	232	299	513	232	232	95	513	N/A	N/A	299
3600	66	164	105	259	335	575	259	259	105	575	N/A	N/A	335
4000	73	181	116	286	371	637	286	286	116	637	N/A	N/A	371
4400	79	198	127	314	406	699	314	314	127	699	N/A	N/A	406
4800	86	215	138	341	441	761	341	341	138	761	N/A	N/A	441
5200	92	232	149	368	476	822	368	368	149	822	N/A	N/A	476
5600	99	248	159	396	512	884	396	396	159	884	N/A	N/A	512
6000	105	265	170	423	547	946	423	423	170	946	N/A	N/A	547
6400	112	282	181	450	583	1007	450	450	181	1007	N/A	N/A	583
6800	118	299	191	477	618	1068	477	477	191	1068	N/A	N/A	618
7200	125	316	202	504	653	1130	504	504	202	1130	N/A	N/A	653
7600	131	332	212	531	688	1191	531	531	212	1191	N/A	N/A	688
8000	138	350	223	558	723	1253	558	558	223	1253	N/A	N/A	723
8400	144	366	234	584	758	1314	584	584	234	1314	N/A	N/A	758
8800	151	383	244	612	793	1375	612	612	244	1375	N/A	N/A	793
9200	157	399	255	638	828	1436	638	638	255	1436	N/A	N/A	828
9600	164	416	265	665	863	1497	665	665	265	1497	N/A	N/A	863
10000	170	433	276	692	898	1559	692	692	276	1559	N/A	N/A	898

Grade C - Continued
Acceptance Numbers Table For
Cut Style Canned Green and Canned Wax Beans
3 to 38 Sample Units (400 count each)

UNITS OF PROD	EVM	STEMS	MAJ BLEM S	TOTAL BLEM S	M ECH D A M A G E	S H O R T P I E C E S	T O U G H S T R I N G S	E D I B L E F I B E R	I N E D I B L E F I B E R	C O L O R D E F E C T I V E S	"B" C H A R A C T E R	"C" C H A R A C T E R	"SStd" C H A R A C T E R
(AQL)	1.5	4.0	2.5	6.5	8.5	15.0	6.5	6.5	2.5	15.0	N/A	N/A	8.5
10400	176	450	286	719	933	1620	719	719	286	1620	N/A	N/A	933
10800	183	466	297	746	968	1681	746	746	297	1681	N/A	N/A	968
11200	189	483	307	772	1003	1742	772	772	307	1742	N/A	N/A	1003
11600	195	499	318	799	1037	1803	799	799	318	1803	N/A	N/A	1037
12000	202	516	329	826	1073	1864	826	826	329	1864	N/A	N/A	1073
12400	208	533	339	853	1107	1925	853	853	339	1925	N/A	N/A	1107
12800	215	549	350	880	1142	1986	880	880	350	1986	N/A	N/A	1142
13200	221	566	360	906	1177	2047	906	906	360	2047	N/A	N/A	1177
13600	227	583	371	933	1212	2108	933	933	371	2108	N/A	N/A	1212
14000	234	599	381	960	1247	2169	960	960	381	2169	N/A	N/A	1247
14400	240	616	391	986	1282	2230	986	986	391	2230	N/A	N/A	1282
14800	246	632	401	1013	1316	2291	1013	1013	401	2291	N/A	N/A	1316
15200	253	649	412	1040	1351	2352	1040	1040	412	2352	N/A	N/A	1351

Grade A
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
1 to 38 Sample Units (100 count each)

UNITS OF PROD	EVM	STEMS	MAJ BLENDS	TOTAL BLENDS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	.4	1.5	.65	1.5	2.5	6.5	1.0	1.0	.04	4.0	8.5	1.0	.4
100	1	3	2	3	5	11	2	2	0	7	13	2	1
200	2	6	3	6	8	19	4	4	0	12	24	4	2
300	3	8	4	8	12	27	6	6	0	18	34	6	3
400	4	10	5	10	15	34	7	7	0	22	44	7	4
500	4	12	6	12	18	42	8	8	1	27	53	8	4
600	5	14	7	14	21	49	10	10	.1	32	63	10	5
700	5	16	8	16	24	56	11	11	1	37	72	11	5
800	6	18	9	18	27	64	12	12	1	41	81	12	6
900	7	19	10	19	30	71	14	14	1	46	91	14	7
1000	7	21	11	21	33	78	15	15	1	50	100	15	7
1100	8	23	11	23	36	85	16	16	1	55	109	16	8
1200	8	25	12	25	39	92	18	18	1	59	118	18	8
1300	9	27	13	27	42	99	19	19	2	64	128	19	9
1400	9	28	14	28	45	106	20	20	2	68	137	20	9
1500	10	30	15	30	47	114	21	21	2	73	146	21	10
1600	10	32	16	32	50	121	22	22	2	77	155	22	10
1700	11	34	16	34	53	128	24	24	2	81	164	24	11
1800	11	35	17	35	56	135	25	25	2	86	173	25	11
1900	12	37	18	37	59	142	26	26	2	90	182	26	12
2000	12	39	19	39	61	149	27	27	2	95	191	27	12

Grade A - Continued
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
1 to 38 Sample Units (100 count each)

UNITS OF PROD	EVM	STEMS	MAJ BLENDS	TOTAL BLENDS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	.4	1.5	.65	1.5	2.5	6.5	1.0	1.0	.04	4.0	8.5	1.0	.4
2100	13	41	20	41	64	156	28	28	2	99	200	28	13
2200	13	42	20	42	67	162	30	30	2	103	209	30	13
2300	14	44	21	44	70	169	31	31	2	108	218	31	14
2400	15	46	22	46	73	176	32	32	2	112	227	32	15
2500	15	47	23	47	75	183	33	33	2	116	236	33	15
2600	16	49	23	49	78	190	34	34	3	121	245	34	16
2700	16	51	24	51	81	197	35	35	3	125	254	35	16
2800	17	52	25	52	84	204	37	37	3	129	263	37	17
2900	17	54	26	54	86	211	38	38	3	134	272	38	17
3000	18	56	27	56	89	218	39	39	3	138	281	39	18
3100	18	58	27	58	92	225	40	40	3	142	290	40	18
3200	18	59	28	59	95	232	41	41	3	146	299	41	18
3300	19	61	29	61	97	238	42	42	3	151	308	42	19
3400	19	63	30	63	100	245	44	44	3	155	317	44	19
3500	20	64	30	64	103	252	45	45	3	159	326	45	20
3600	20	66	31	66	105	259	46	46	3	164	335	46	20
3700	21	68	32	68	108	266	47	47	3	168	343	47	21
3800	21	69	33	69	111	273	48	48	3	172	352	48	21

**Grade B
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
1 to 38 Sample Units (100 count each)**

UNITS OF PROD	EVM	STEMS	MAJ BLENDS	TOTAL BLENDS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	.65	2.5	1.5	2.5	4.0	10.0	2.5	2.5	.65	8.5	N/A	8.5	1.0
100	2	5	3	5	7	15	5	5	2	13	N/A	13	2
200	3	8	6	8	12	27	8	8	3	24	N/A	24	4
300	4	12	8	12	18	39	12	12	4	34	N/A	34	6
400	5	15	10	15	22	50	15	15	5	44	N/A	44	7
500	6	18	12	18	27	61	18	18	6	53	N/A	53	8
600	7	21	14	21	32	73	21	21	7	63	N/A	63	10
700	8	24	16	24	37	84	24	24	8	72	N/A	72	11
800	9	27	18	27	41	95	27	27	9	81	N/A	81	12
900	10	30	19	30	46	105	30	30	10	91	N/A	91	14
1000	11	33	21	33	50	116	33	33	11	100	N/A	100	15
1100	11	36	23	36	55	127	36	36	11	109	N/A	109	16
1200	12	39	25	39	59	138	39	39	12	118	N/A	118	18
1300	13	42	27	42	64	149	42	42	13	128	N/A	128	19
1400	14	45	28	45	68	159	45	45	14	137	N/A	137	20
1500	15	47	30	47	73	170	47	47	15	146	N/A	146	21
1600	16	50	32	50	77	181	50	50	16	155	N/A	155	22
1700	16	53	34	53	81	191	53	53	16	164	N/A	164	24
1800	17	56	35	56	86	202	56	56	17	173	N/A	173	25
1900	18	59	37	59	90	212	59	59	18	182	N/A	182	26

Grade B - Continued
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
1 to 38 Sample Units (100 count each)

UNITS OF PROD	EVM	STEMS	MAJ BLEMES	TOTAL BLEMES	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	.65	2.5	1.5	2.5	4.0	10.0	2.5	2.5	.65	8.5	N/A	8.5	1.0
2000	19	61	39	61	95	223	61	61	19	191	N/A	191	27
2100	20	64	41	64	99	234	64	64	20	200	N/A	200	28
2200	20	67	42	67	103	244	67	67	20	209	N/A	209	30
2300	21	70	44	70	108	255	70	70	21	218	N/A	218	31
2400	22	73	46	73	112	265	73	73	22	227	N/A	227	32
2500	23	75	47	75	116	276	75	75	23	236	N/A	236	33
2600	23	78	49	78	121	286	78	78	23	245	N/A	245	34
2700	24	81	51	81	125	297	81	81	24	254	N/A	254	35
2800	25	84	52	84	129	307	84	84	25	263	N/A	263	37
2900	26	86	54	86	134	318	86	86	26	272	N/A	272	38
3000	27	89	56	89	138	329	89	89	27	281	N/A	281	39
3100	27	92	58	92	142	339	92	92	27	290	N/A	290	40
3200	28	95	59	95	146	350	95	95	28	299	N/A	299	41
3300	29	97	61	97	151	360	97	97	29	308	N/A	308	42
3400	30	100	63	100	155	371	100	100	30	317	N/A	317	44
3500	30	103	64	103	159	381	103	103	30	326	N/A	326	45
3600	31	105	66	105	164	391	105	105	31	335	N/A	335	46
3700	32	108	68	108	168	401	108	108	32	343	N/A	343	47
3800	33	111	69	111	172	412	111	111	33	352	N/A	352	48

Grade C
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
1 to 38 Sample Units (100 count each)

UNITS OF PROD	EVM	STEMS	MAJ BLENDS	TOTAL BLENDS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	1.5	4.0	2.5	6.5	8.5	15.0	6.5	6.5	2.5	15.0	N/A	N/A	8.5
100	3	7	5	11	13	21	11	11	5	21	N/A	N/A	13
200	6	12	8	19	24	38	19	19	8	38	N/A	N/A	24
300	8	18	12	27	34	55	27	27	12	55	N/A	N/A	34
400	10	22	15	34	44	71	34	34	15	71	N/A	N/A	44
500	12	27	18	42	53	88	42	42	18	88	N/A	N/A	53
600	14	32	21	49	63	104	49	49	21	104	N/A	N/A	63
700	16	37	24	56	72	120	56	56	24	120	N/A	N/A	72
800	18	41	27	64	81	136	64	64	27	136	N/A	N/A	81
900	19	46	30	71	91	152	71	71	30	152	N/A	N/A	91
1000	21	50	33	78	100	168	78	78	33	168	N/A	N/A	100
1100	23	55	36	85	109	184	85	85	36	184	N/A	N/A	109
1200	25	59	39	92	118	200	92	92	39	200	N/A	N/A	118
1300	27	64	42	99	128	216	99	99	42	216	N/A	N/A	128
1400	28	68	45	106	137	232	106	106	45	232	N/A	N/A	137
1500	30	73	47	114	146	247	114	114	47	247	N/A	N/A	146
1600	32	77	50	121	155	263	121	121	50	263	N/A	N/A	155
1700	34	81	53	128	164	279	128	128	53	279	N/A	N/A	164
1800	35	86	56	135	173	295	135	135	56	295	N/A	N/A	173
1900	37	90	59	142	182	310	142	142	59	310	N/A	N/A	182

Grade C - Continued
Acceptance Numbers Table for
Cut Style Canned Green and Canned Wax Beans
1 to 38 Sample Units (100 count each)

UNITS OF PROD	EVM	STEMS	MAJ BLENDS	TOTAL BLENDS	MECH DAMAGE	SHORT PIECES	TOUGH STRINGS	EDIBLE FIBER	INEDIBLE FIBER	COLOR DEFECTIVES	"B" CHARACTER	"C" CHARACTER	"SStd" CHARACTER
(AQL)	1.5	4.0	2.5	6.5	8.5	15.0	6.5	6.5	2.5	15.0	N/A	N/A	8.5
2000	39	95	61	149	191	326	149	149	61	326	N/A	N/A	191
2100	41	99	64	156	200	342	156	156	64	342	N/A	N/A	200
2200	42	103	67	162	209	357	162	162	67	357	N/A	N/A	209
2300	44	108	70	169	218	373	169	169	70	373	N/A	N/A	218
2400	46	112	73	176	227	388	176	176	73	388	N/A	N/A	227
2500	47	116	75	183	236	404	183	183	75	404	N/A	N/A	236
2600	49	121	78	190	245	420	190	190	78	420	N/A	N/A	245
2700	51	125	81	197	254	435	197	197	81	435	N/A	N/A	254
2800	52	129	84	204	263	451	204	204	84	451	N/A	N/A	263
2900	54	134	86	211	272	466	211	211	86	466	N/A	N/A	272
3000	56	138	89	218	281	482	218	218	89	482	N/A	N/A	281
3100	58	142	92	225	290	498	225	225	92	498	N/A	N/A	290
3200	59	146	95	232	299	513	232	232	95	513	N/A	N/A	299
3300	61	151	97	238	308	529	238	238	97	529	N/A	N/A	308
3400	63	155	100	245	317	544	245	245	100	544	N/A	N/A	317
3500	64	159	103	252	326	560	252	252	103	560	N/A	N/A	326
3600	66	164	105	259	335	575	259	259	105	575	N/A	N/A	335
3700	68	168	108	266	343	591	266	266	108	591	N/A	N/A	343
3800	69	172	111	273	352	606	273	273	111	606	N/A	N/A	352