



HERCULUX Chengdu HercuLux Photoelectric
恒坤光电 Technology Co.,Ltd
Product Approval

Approval number :

Customer :

PN	Code	Product
HK-55@24-15-D9-20-1g-1	1. 01. 71024	HK-55@24-15° Lens
HK-55@24-24-D9-20-1g-1	1. 01. 71045. 21	HK-55@24-24° Lens
HK-55@24-36-D9-20-1g-1	1. 01. 71046. 11	HK-55@24-36° Lens
HK-55@24-60-D9-20-1g-1	1. 01. 91785. 01	HK-55@24-60° Lens

Manufacturer : Chengdu HercuLux Photoelectric Technology Co.,Ltd



Supplier confirmation				Client confirmation			
Proposed		DATE		Qualified ☐		DATE	
Project manager		DATE		Unqualified ☐			
Audit		DATE		Audit		DATE	
Approved		DATE		Approved		DATE	
Stamp		DATE		Stamp		DATE	

(Confirmation of acceptance by both parties must be signed and sealed)

Factory: Chengdu Shuangliu District, Iot industrial park 2 road HercuLux Photoelectric Park

Phone : 028-85887727 (801) 028-85887990 (801)

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Sales Dept: Shenzhen Nanshan District Nanshan Cloud Valley Innovation Industrial Park Comprehensive Service Building,

TEL: 0755-2937 1541

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*Approval In duplicate , for both supplier and customer.



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Product Approval

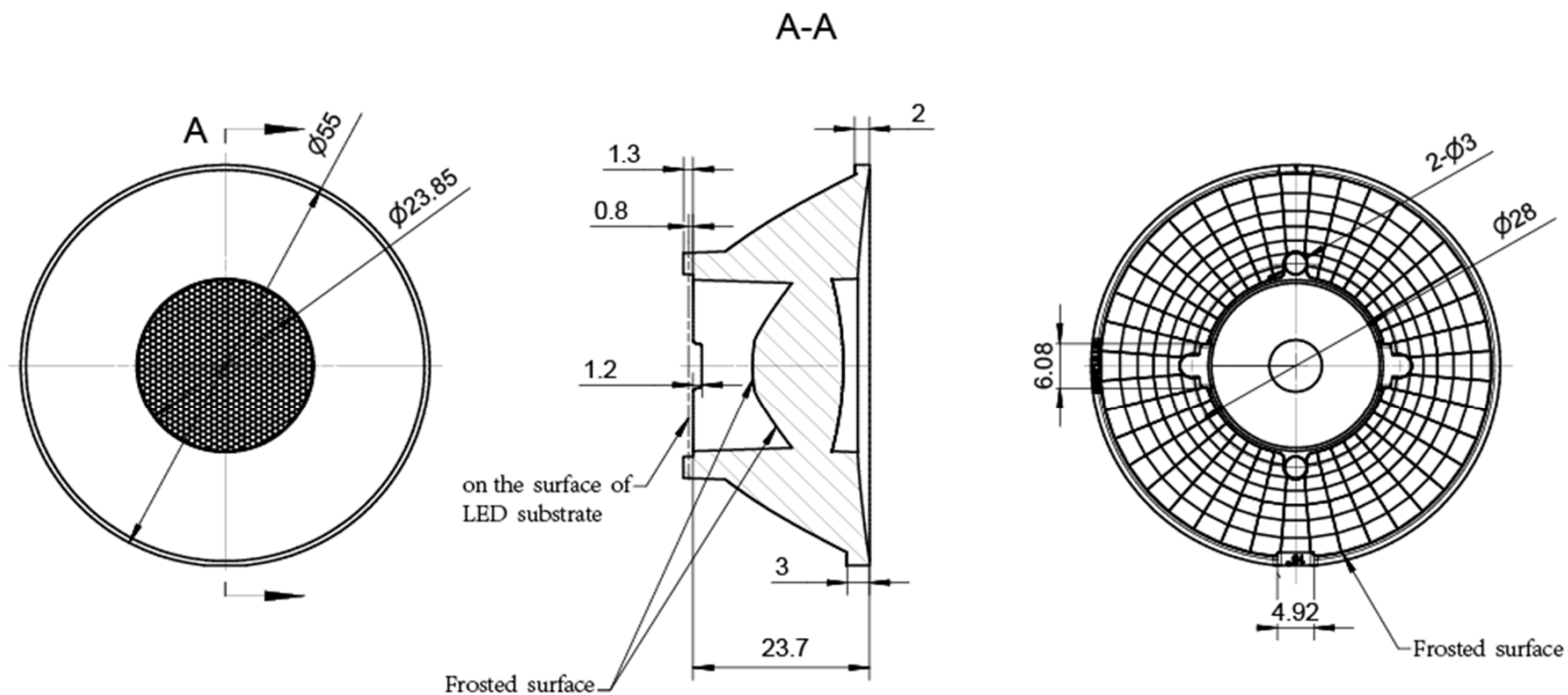
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Date updated: 2020/12/5

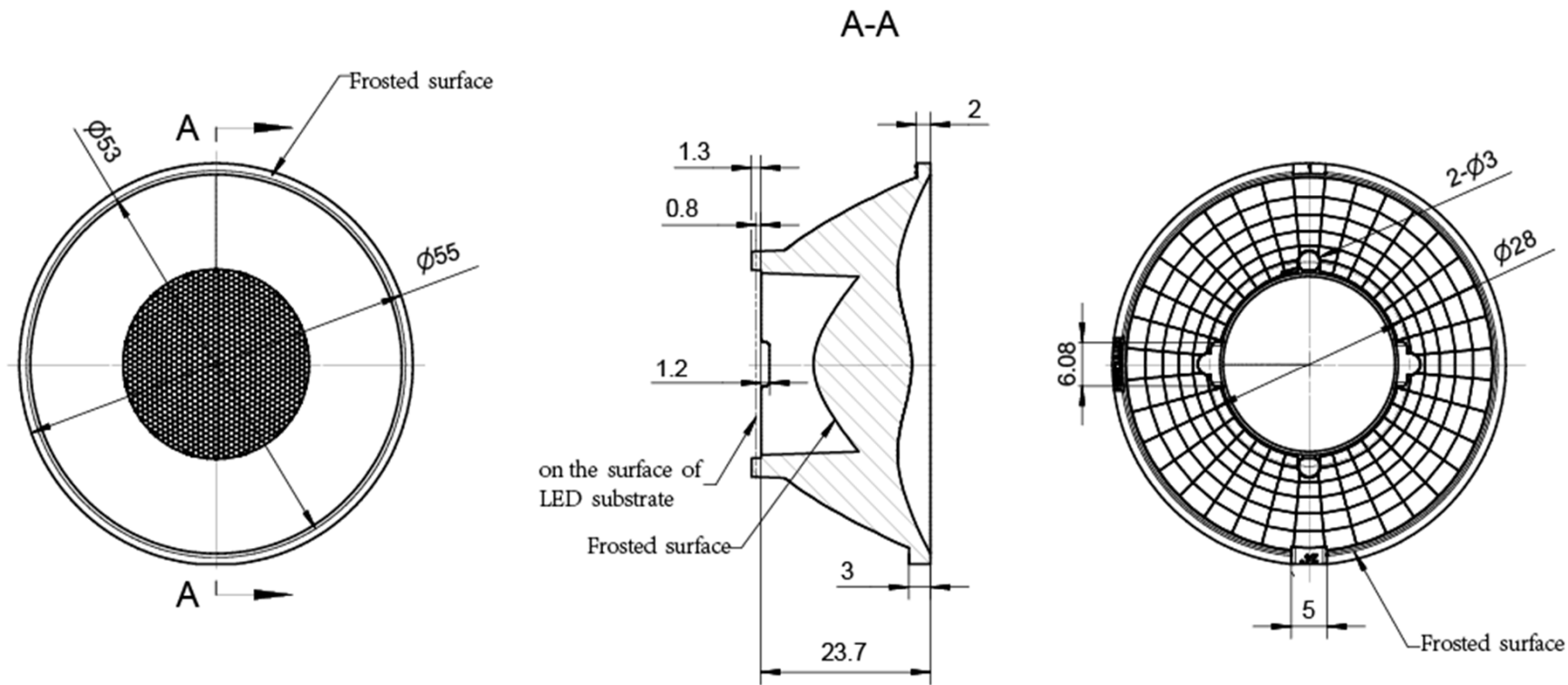
Product Picture:		
PN:	HK-55@24-15-D9-20-1g-1	
Size(L*W*H/Φ*H):	Φ:55mm; H:23.7mm	
1.07.81418_HK-166@03-0223-S	PMMA-8N	
Effiency:	\	
Temperature(Topr):	-40°C to +90°C	
FWHM:	15°/24°/36°/60°	
Matched LES:	D9	

**Technical remark:**

1. The 3D map is not indicated for rounded corners and draft angle.
2. The dimensional tolerances are not specified according to GB/T 14486 2008 MT5.
3. The surface has no flash, shrinkage, bubbles and other defects.

Optical design			HK-55@24-15°Lens		HK-55@24-15-D9-20-1g-1		
Structure design					1.01.71024		
Review					Number of drawing	qty	weight
Validation			Material:	PMMA-8N	CDHK		

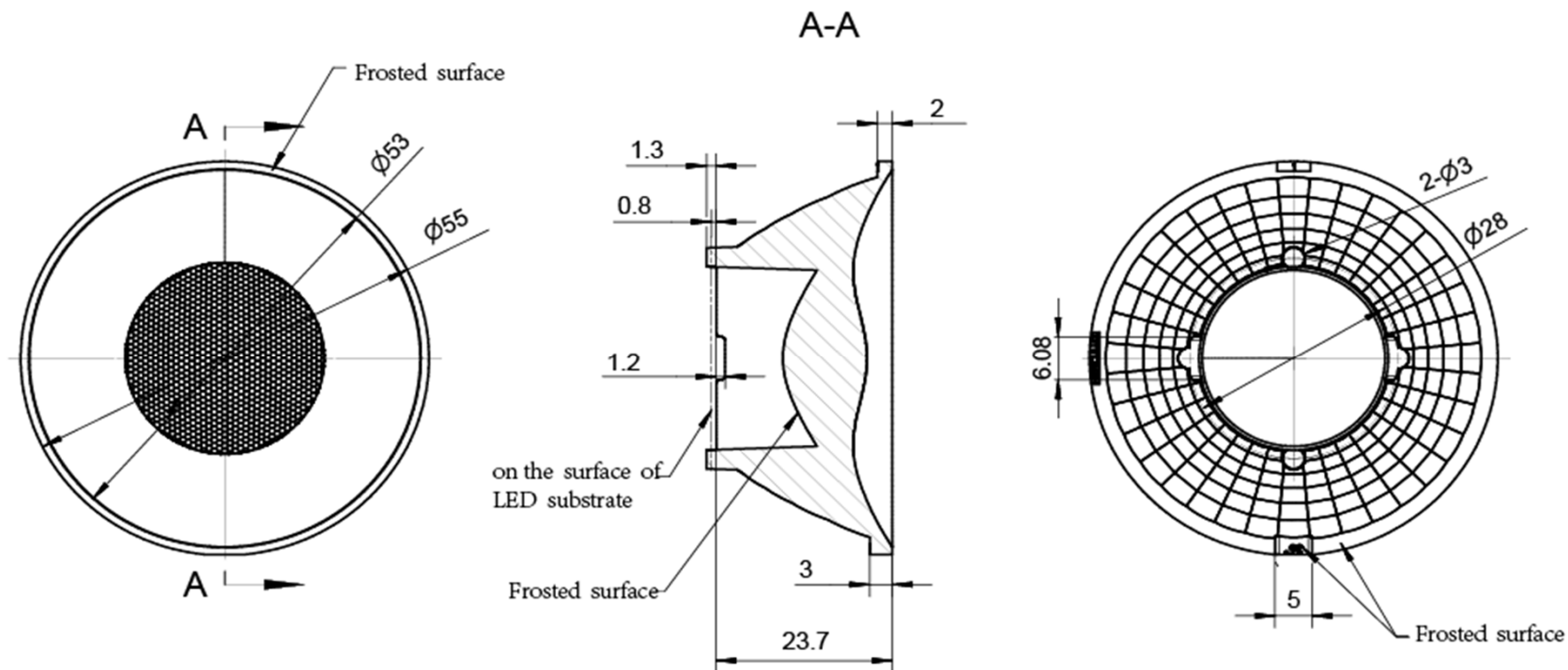
MT5 Tolerance table (mm)	Basic size	<3	3~10	24~65	65~140	140~250	250~450	>450		
	olerance value	±0.1	±0.15	±0.35	±0.50	±0.80	±1.2	±2.0		



Technical remark:
1. The 3D map is not indicated for rounded corners and draft angle.
2. The dimensional tolerances are not specified according to GB/T 14486 2008 MT5.
3. The surface has no flash, shrinkage, bubbles and other defects.

Optical design			HK-55@24-24°Lens		HK-55@24-24-D9-20-1g-1		
Structure design					1.01.71045.21		
Review					Number of drawing	qty	weight
Validation			Material:	PMMA-8N	CDHK		

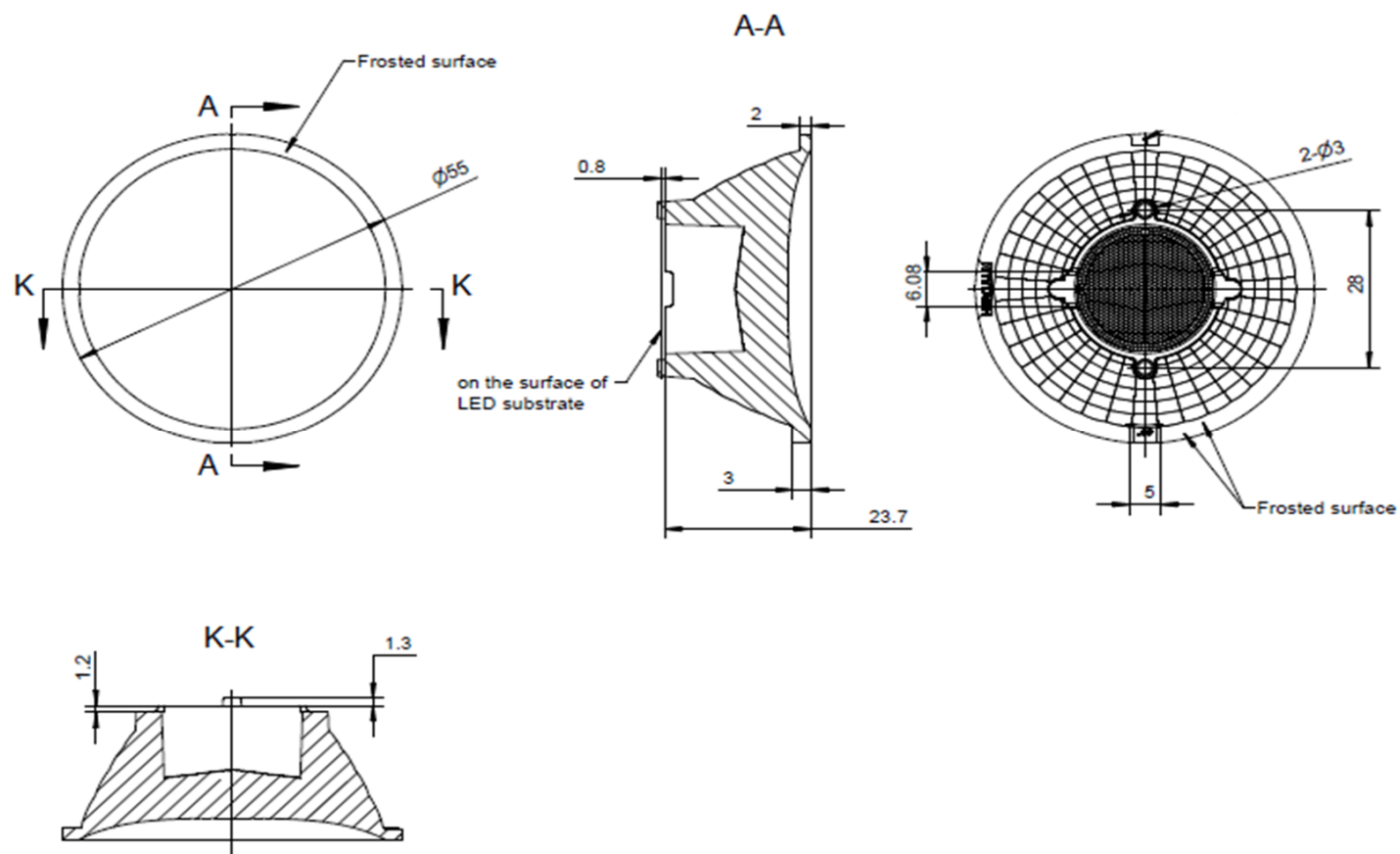
MT5 Tolerance table (mm)	Basic size	<3	3~10	24~65	65~140	140~250	250~450	>450		
	olerance value	±0.1	±0.15	±0.35	±0.50	±0.80	±1.2	±2.0		

**Technical remark:**

1. The 3D map is not indicated for rounded corners and draft angle.
2. The dimensional tolerances are not specified according to GB/T 14486 2008 MT5.
3. The surface has no flash, shrinkage, bubbles and other defects.

Optical design			HK-55@24-36°Lens		HK-55@24-36-D9-20-1g-1		
Structure design					1.01.71046.11		
Review					Number of drawing	qty	weight
Validation			Material:	PMMA-8N	CDHK		

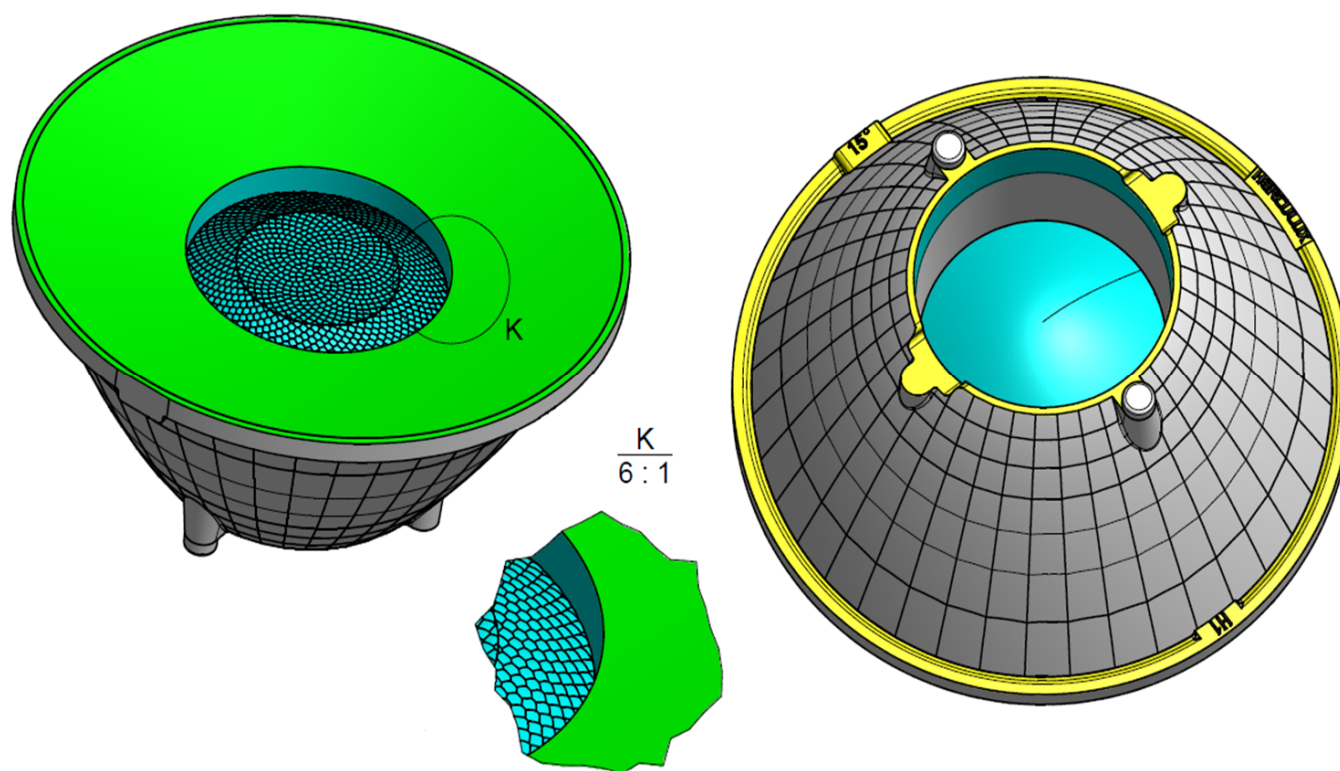
MT5 Tolerance table (mm)	Basic size	<3	3~10	24~65	65~140	140~250	250~450	>450		
	olerance value	±0.1	±0.15	±0.35	±0.50	±0.80	±1.2	±2.0		

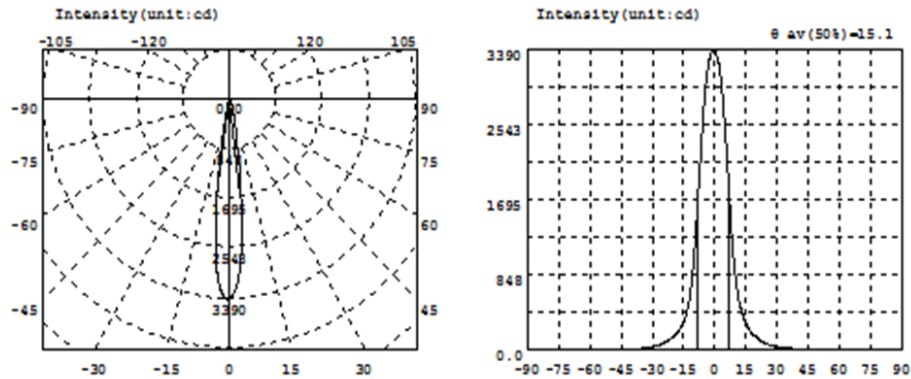
**Technical remark:**

1. The 3D map is not indicated for rounded corners and draft angle.
2. The dimensional tolerances are not specified according to GB/T 14486 2008 MT5.
3. The surface has no flash, shrinkage, bubbles and other defects.

Optical design			HK-55@24-60°Lens		HK-55@24-60-D9-20-1g-1		
Structure design						1.01.91785.01	
Review					Number of drawing	qty	weight
Validation			Material:	PMMA-8N	CDHK		

MT5 Tolerance table (mm)	Basic size	<3	3~10	24~65	65~140	140~250	250~450	>450		
	olerance value	±0.1	±0.15	±0.35	±0.50	±0.80	±1.2	±2.0		





Intensity data: (deg , cd) C0-180

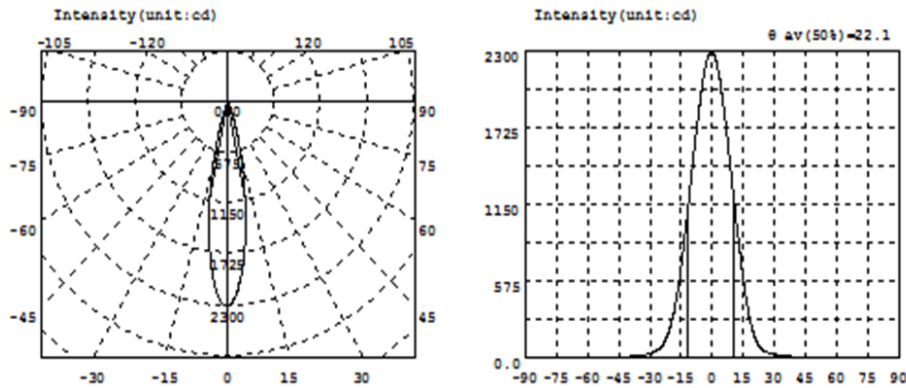
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	1.581	-58.5	5.375	-27.0	58.67	4.5	2634	36.0	22.35	67.5	4.357
-88.5	1.627	-57.0	5.596	-25.5	72.75	6.0	2104	37.5	17.43	69.0	4.117
-87.0	1.661	-55.5	6.023	-24.0	90.39	7.5	1512	39.0	14.28	70.5	3.942
-85.5	1.740	-54.0	6.621	-22.5	111.3	9.0	1035	40.5	12.66	72.0	3.734
-84.0	1.797	-52.5	7.168	-21.0	135.1	10.5	712.2	42.0	11.48	73.5	3.478
-82.5	1.853	-51.0	7.571	-19.5	165.0	12.0	512.6	43.5	10.53	75.0	3.201
-81.0	1.990	-49.5	7.990	-18.0	201.4	13.5	387.7	45.0	9.732	76.5	2.884
-79.5	2.112	-48.0	8.523	-16.5	252.1	15.0	293.1	46.5	9.065	78.0	2.605
-78.0	2.288	-46.5	9.169	-15.0	322.7	16.5	234.5	48.0	8.507	79.5	2.318
-76.5	2.584	-45.0	9.955	-13.5	429.2	18.0	190.2	49.5	8.074	81.0	2.056
-75.0	2.885	-43.5	10.66	-12.0	609.5	19.5	155.7	51.0	7.669	82.5	1.914
-73.5	3.138	-42.0	11.45	-10.5	919.0	21.0	128.7	52.5	7.124	84.0	1.867
-72.0	3.431	-40.5	12.65	-9.0	1368	22.5	104.9	54.0	6.530	85.5	1.810
-70.5	3.669	-39.0	14.20	-7.5	1935	24.0	84.58	55.5	6.002	87.0	1.688
-69.0	3.930	-37.5	16.25	-6.0	2492	25.5	68.12	57.0	5.777	88.5	1.609
-67.5	4.178	-36.0	18.84	-4.5	2950	27.0	55.15	58.5	5.587	90.0	1.507
-66.0	4.403	-34.5	22.22	-3.0	3226	28.5	45.33	60.0	5.400		
-64.5	4.607	-33.0	26.41	-1.5	3363	30.0	38.02	61.5	5.213		
-63.0	4.809	-31.5	31.78	0.0	3372	31.5	32.60	63.0	5.052		
-61.5	4.993	-30.0	38.65	1.5	3253	33.0	28.43	64.5	4.862		
-60.0	5.194	-28.5	47.52	3.0	3025	34.5	25.20	66.0	4.609		

Electricity Parameter:

Current I: 0.1000A Power: 3.299W
Voltage V: 33.00V PF: 1.000

Optical Parameter (Distance=2.410m):

Equivalent Luminous flux: $\Phi_{\text{eff}} = 361.1\text{lm}$ Efficiency: $\text{Eff} = 109.46\text{lm/W}$
Diffuse angle: @ (25%): 20.4deg @ (50%): 15.1deg @ (75%): 10.5deg @ (50%): 15.1deg
Diffuse angle: @ (25%): 20.6deg @ (50%): 15.1deg @ (75%): 10.6deg @ (50%): 15.1deg
Imax=3384cd (C=0.0deg, G=-0.5deg) C0-180Plane Imax= 3384cd (G=-0.5deg)
C0-180Plane IO= 3372cd



Intensity data: (deg , cd) C0-180

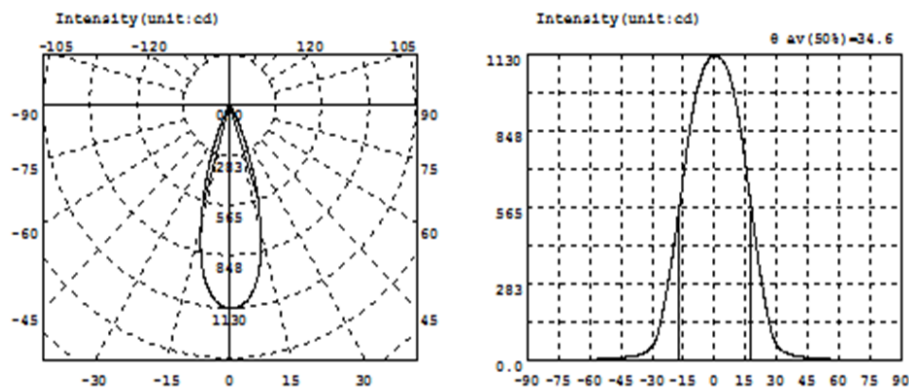
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.9172	-58.5	6.035	-27.0	55.32	4.5	1985	36.0	16.84	67.5	4.276
-88.5	1.032	-57.0	6.214	-25.5	72.60	6.0	1805	37.5	14.88	69.0	3.956
-87.0	1.173	-55.5	6.410	-24.0	99.31	7.5	1602	39.0	13.38	70.5	3.637
-85.5	1.364	-54.0	6.657	-22.5	140.4	9.0	1390	40.5	12.06	72.0	0.5771
-84.0	1.607	-52.5	6.958	-21.0	198.5	10.5	1172	42.0	10.99	73.5	2.988
-82.5	1.862	-51.0	7.382	-19.5	277.3	12.0	961.0	43.5	10.09	75.0	2.713
-81.0	2.119	-49.5	7.857	-18.0	384.7	13.5	758.5	45.0	9.377	76.5	2.443
-79.5	2.372	-48.0	8.402	-16.5	522.9	15.0	576.9	46.5	8.701	78.0	2.177
-78.0	2.628	-46.5	9.056	-15.0	692.0	16.5	421.8	48.0	8.122	79.5	1.909
-76.5	2.861	-45.0	9.802	-13.5	884.5	18.0	295.5	49.5	7.578	81.0	1.679
-75.0	3.114	-43.5	10.62	-12.0	1090	19.5	206.9	51.0	7.120	82.5	1.435
-73.5	3.410	-42.0	11.63	-10.5	1302	21.0	136.2	52.5	6.755	84.0	1.227
-72.0	3.715	-40.5	12.95	-9.0	1514	22.5	93.10	54.0	6.457	85.5	0.9646
-70.5	3.997	-39.0	14.49	-7.5	1719	24.0	68.68	55.5	6.193	87.0	0.8338
-69.0	4.302	-37.5	16.38	-6.0	1909	25.5	52.19	57.0	5.965	88.5	0.7301
-67.5	4.622	-36.0	18.68	-4.5	2077	27.0	41.98	58.5	5.764	90.0	0.7006
-66.0	4.900	-34.5	21.55	-3.0	2204	28.5	34.78	60.0	5.560		
-64.5	5.196	-33.0	25.15	-1.5	2277	30.0	29.34	61.5	5.346		
-63.0	5.462	-31.5	29.72	0.0	2289	31.5	25.09	63.0	5.129		
-61.5	5.677	-30.0	35.71	1.5	2240	33.0	21.74	64.5	4.879		
-60.0	5.856	-28.5	43.77	3.0	2135	34.5	19.06	66.0	4.572		

Electricity Parameter:

Current I: 0.1000A Power: 3.310W
Voltage V: 33.09V PF: 1.000

Optical Parameter (Distance=2.559m):

Equivalent Luminous flux: $\Phi_{\text{eff}} = 414.41\text{lm}$ Efficiency: $\text{Eff} = 125.22\text{lm/W}$
Diffuse angle: @ (25%): 31.0deg @ (50%): 22.1deg @ (75%): 14.0deg @ (50%): 22.1deg
Diffuse angle: @ (25%): 31.0deg @ (50%): 22.2deg @ (75%): 14.1deg @ (50%): 22.2deg
 $\text{Imax} = 2293\text{cd}$ (C=0.0deg, G=-0.5deg) C0-180Plane $\text{Imax} = 2293\text{cd}$ (G=-0.5deg)
C0-180Plane $\text{I0} = 2289\text{cd}$



Intensity data: (deg , cd) C0-180

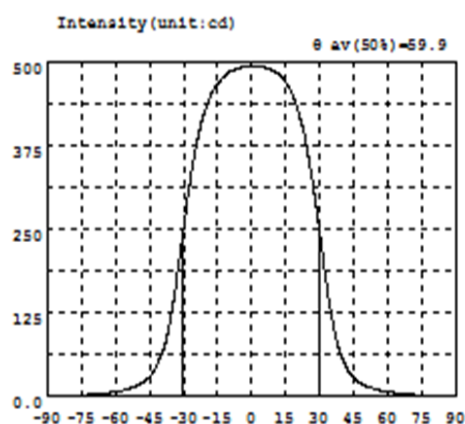
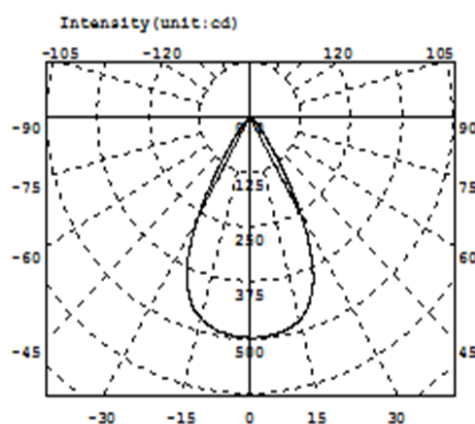
θ	I	θ	I	θ	I	θ	I	θ	I	θ	I
-90.0	1.082	-58.5	6.364	-27.0	108.6	4.5	1100	36.0	25.07	67.5	3.997
-88.5	1.197	-57.0	6.751	-25.5	160.9	6.0	1078	37.5	21.92	69.0	3.630
-87.0	1.325	-55.5	7.160	-24.0	216.8	7.5	1044	39.0	19.16	70.5	3.281
-85.5	1.478	-54.0	7.637	-22.5	280.1	9.0	1000	40.5	16.88	72.0	2.976
-84.0	1.723	-52.5	8.188	-21.0	349.7	10.5	946.6	42.0	15.07	73.5	2.703
-82.5	1.977	-51.0	8.821	-19.5	424.1	12.0	882.4	43.5	13.66	75.0	2.423
-81.0	2.155	-49.5	9.516	-18.0	504.5	13.5	804.5	45.0	12.40	76.5	2.178
-79.5	2.309	-48.0	10.33	-16.5	588.2	15.0	719.1	46.5	11.26	78.0	1.935
-78.0	2.526	-46.5	11.29	-15.0	675.2	16.5	631.0	48.0	10.27	79.5	1.718
-76.5	2.731	-45.0	12.23	-13.5	762.9	18.0	547.4	49.5	9.452	81.0	1.595
-75.0	2.936	-43.5	13.38	-12.0	844.7	19.5	464.0	51.0	8.713	82.5	1.382
-73.5	3.189	-42.0	14.88	-10.5	915.4	21.0	374.0	52.5	8.058	84.0	1.170
-72.0	3.434	-40.5	16.60	-9.0	974.4	22.5	298.2	54.0	7.492	85.5	0.9870
-70.5	3.678	-39.0	18.61	-7.5	1021	24.0	231.8	55.5	6.974	87.0	0.8465
-69.0	4.000	-37.5	20.78	-6.0	1059	25.5	171.1	57.0	6.536	88.5	0.7201
-67.5	4.287	-36.0	23.81	-4.5	1087	27.0	119.5	58.5	6.175	90.0	0.6879
-66.0	4.421	-34.5	27.92	-3.0	1107	28.5	81.29	60.0	5.767		
-64.5	4.731	-33.0	33.55	-1.5	1120	30.0	59.25	61.5	5.355		
-63.0	5.112	-31.5	41.50	0.0	1124	31.5	44.85	63.0	4.934		
-61.5	5.499	-30.0	54.07	1.5	1123	33.0	35.75	64.5	4.573		
-60.0	5.966	-28.5	74.30	3.0	1114	34.5	29.56	66.0	4.251		

Electricity Parameter:

Current I: 1.000A Power: 3.500W
Voltage V: 35.00V PF: 1.000

Optical Parameter (Distance=2.559m):

Equivalent Luminous flux: Φ_{eff}=418.8lm Efficiency: Eff=119.67lm/W
Diffuse angle: @ (25%): 45.2deg @ (50%): 34.6deg @ (75%): 24.7deg @ (50%): 34.6deg
Diffuse angle: @ (25%): 45.2deg @ (50%): 34.6deg @ (75%): 24.7deg @ (50%): 34.6deg
I_{max}=1125cd (C=0.0deg, G=0.5deg) C0-180Plane I_{max}=1125cd (G=0.5deg)
C0-180Plane I₀=1124cd



Intensity data: (deg , cd) C0-180

A	I	A	I	A	I	A	I	A	I	A	I
-90.0	1.006	-58.5	8.457	-27.0	326.1	4.5	491.9	36.0	104.3	67.5	4.359
-88.5	1.031	-57.0	9.479	-25.5	356.2	6.0	490.3	37.5	81.73	69.0	3.768
-87.0	1.121	-55.5	10.69	-24.0	382.8	7.5	489.2	39.0	65.06	70.5	3.326
-85.5	1.223	-54.0	12.21	-22.5	404.3	9.0	487.6	40.5	52.94	72.0	2.933
-84.0	1.325	-52.5	13.98	-21.0	422.1	10.5	484.5	42.0	42.05	73.5	2.568
-82.5	1.389	-51.0	15.93	-19.5	437.0	12.0	480.6	43.5	33.49	75.0	2.187
-81.0	1.427	-49.5	18.15	-18.0	449.8	13.5	475.3	45.0	27.84	76.5	1.825
-79.5	1.504	-48.0	20.93	-16.5	459.9	15.0	468.5	46.5	23.46	78.0	1.566
-78.0	1.647	-46.5	24.71	-15.0	467.1	16.5	460.4	48.0	20.29	79.5	1.445
-76.5	1.944	-45.0	29.52	-13.5	473.5	18.0	449.5	49.5	17.74	81.0	1.390
-75.0	2.288	-43.5	36.18	-12.0	478.5	19.5	435.4	51.0	15.68	82.5	1.364
-73.5	2.647	-42.0	45.55	-10.5	482.5	21.0	419.2	52.5	13.69	84.0	1.289
-72.0	3.042	-40.5	57.06	-9.0	486.1	22.5	400.0	54.0	11.95	85.5	1.189
-70.5	3.455	-39.0	69.46	-7.5	488.1	24.0	374.7	55.5	10.55	87.0	1.026
-69.0	3.916	-37.5	88.32	-6.0	489.8	25.5	345.6	57.0	9.412	88.5	0.9809
-67.5	4.477	-36.0	112.3	-4.5	491.3	27.0	314.7	58.5	8.422	90.0	0.9184
-66.0	4.937	-34.5	141.5	-3.0	492.4	28.5	279.8	60.0	7.521		
-64.5	5.449	-33.0	176.3	-1.5	493.7	30.0	241.8	61.5	6.717		
-63.0	6.051	-31.5	214.7	0.0	494.3	31.5	202.5	63.0	6.034		
-61.5	6.735	-30.0	253.0	1.5	494.2	33.0	164.4	64.5	5.457		
-60.0	7.510	-28.5	291.6	3.0	493.4	34.5	131.7	66.0	4.953		

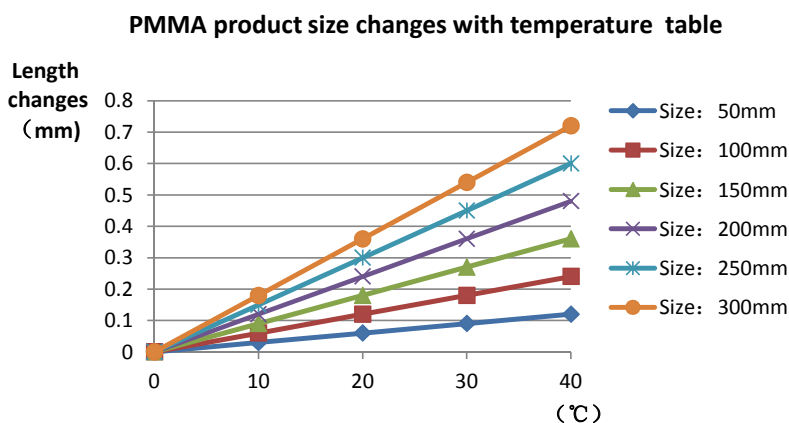
Electricity Parameter:

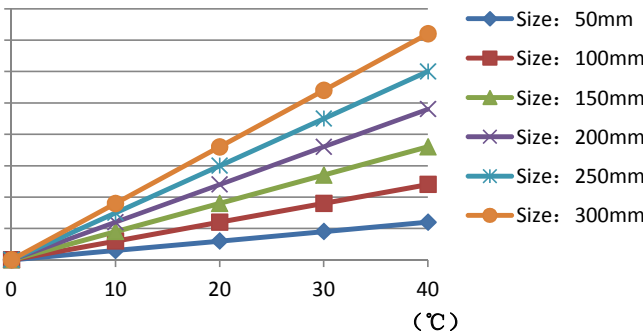
Current I: 0.3490A Power: 3.320W
Voltage V: 33.20V PF: 1.000

Optical Parameter (Distance=2.559m):

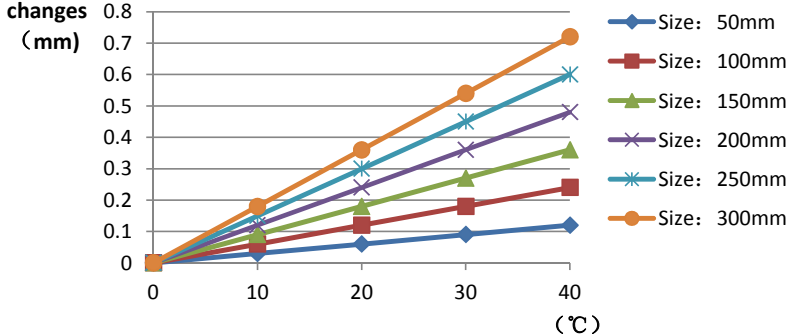
Equivalent Luminous flux: $\Phi_{\text{eff}} = 465.11\text{lm}$ Efficiency: $\text{Eff} = 140.11\text{lm/W}$
Diffuse angle: @ (25%): 70.2deg @ (50%): 59.9deg @ (75%): 48.8deg @ (50%): 59.9deg
Diffuse angle: @ (25%): 70.2deg @ (50%): 59.9deg @ (75%): 48.8deg @ (50%): 59.9deg
 $\text{I}_{\text{max}} = 494.4\text{cd}$ (C=0.0deg, G=0.5deg) C0-180Plane $\text{I}_{\text{max}} = 494.4\text{cd}$ (G=0.5deg)
C0-180Plane $\text{I}_0 = 494.3\text{cd}$

		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks																																										
1.Size	diameter	55			55.17	55.13	55.17	55.12		Test environment: In 20℃ -25℃ environment to achieve thermal equilibrium after the test.																																										
	height	2			2.12	2.1	2.12	2.15																																												
	thickness	23.7			23.725	23.725	23.8	23.78																																												
	Gate shear can not affect the appearance of the lamp																																																			
	See attachment "Appearance Inspection Standards"																																																			
2.Appearance Quality		See attachment "Appearance Inspection Standards"	E	No burr	No burr	No burr	No burr	OK																																												
				No stains	No stains	No stains	No stains																																													
3.Material		PMMA-8N				Color	Transparent			OK																																										
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	FWHM	See light distribution curve																																																		
	angle					15.3°	15.1°	15.2	15.3																																											
	K-value					9.47	9.19	9.13	9.42																																											
	Efficiency					86.95%	87.31%	87.31%	87.83%																																											
	Facula	See the signature sample																																																		
Comprehensive judgment		Qualified																																																		
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2.Appearance Quality		See attachment "Appearance Inspection Standards"	E	No burr		No burr	No burr	No burr	OK																																											
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	FWHM	See light distribution curve																																																		
	angle					22.3	22.2	22.3	22.2																																											
	K-value					6.11	6.16	6.06	6.11																																											
	Efficiency					91.50%	91.70%	91.50%	91.40%																																											
Facula		See the signature sample																																																		
Comprehensive judgment		Qualified																																																		
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1.Size		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
	diameter	55			54.98	55.01	55.09	55.01		Test environment: In 20℃ -25℃ environment to achieve thermal equilibrium after the test.
	height	2			2.04	2.05	2.09	2.09		
	thickness	23.7			23.81	23.84	23.82	23.8		
	Gate shear can not affect the appearance of the lamp									
	See attachment "Appearance Inspection Standards"									
2.Appearance Quality		See attachment "Appearance Inspection Standards"	E	No burr	No burr	No burr	No burr	OK		
				No stains	No stains	No stains	No stains			
3.Material		PMMA-8N				Color	Transparent		OK	
4.Optical index	Testing LED		D9							
	The recommended size and power rating of the LED light source recommended for this lens should be comparable to the source of the test, if it is required to be out of range. According to the heat dissipation capability of the lamp and the actual conditions of the use environment, the lens should be fully tested and tested to prevent the lens life.									
	FWHM		See light distribution curve							
	angle			34.7°	34.9°	35.5°	35°			
	K-value			2.71	2.66	2.54	2.68			
	Efficiency			91.00%	91.22%	90.96%	90.96%			
Facula		See the signature sample								
Comprehensive judgment		Qualified								
Remarks:			1、 Tool Number: V-Vernier Caliper 2D-Quadratic H-Height Gauge M-Tool Microscope P-Needle T-Thick Gauge R-Radius Gauge E-Visual. 2、 Ambient temperature on the size of the product refer to the table on the right PMMA product size changes with temperature table Length changes (mm) 0.8 0.7 0.6 0.5 0.4 0.3 0.2 0.1 0 0 10 20 30 40 (℃) Size: 50mm Size: 100mm Size: 150mm Size: 200mm Size: 250mm Size: 300mm							
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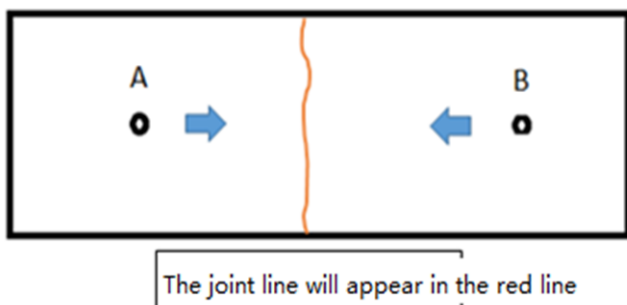
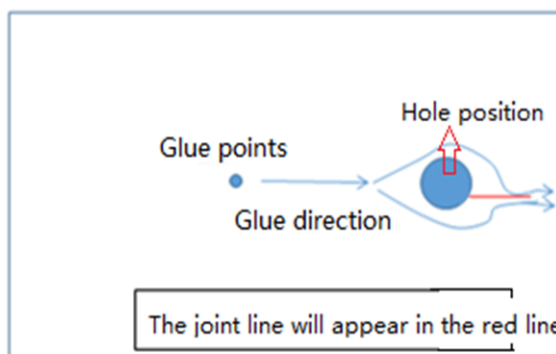
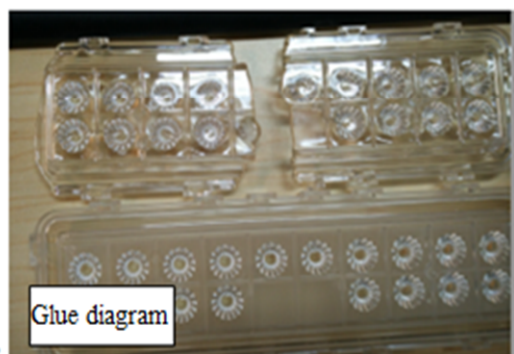
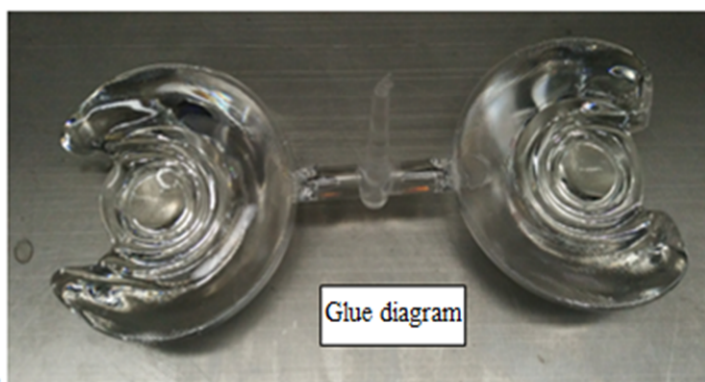
1.Size		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
	diameter	55			54.89	54.91	54.89	54.88		Test environment: In 20℃ -25℃ environment to achieve thermal equilibrium after the test.
	height	2			2.03	2.04	2.05	2.05		
	thickness	23.7			23.88	23.85	23.82	23.84		
	Gate shear can not affect the appearance of the lamp									
	See attachment "Appearance Inspection Standards"									
2.Appearance Quality		See attachment "Appearance Inspection Standards"	E	No burr	No burr	No burr	No burr	OK		
				No stains	No stains	No stains	No stains			
3.Material		PMMA-8N				Color	Transparent		OK	
4.Optical index	Testing LED		D9							
	The recommended size and power rating of the LED light source recommended for this lens should be comparable to the source of the test, if it is required to be out of range. According to the heat dissipation capability of the lamp and the actual conditions of the use environment, the lens should be fully tested and tested to prevent the lens life.									
	FWHM		See light distribution curve							
	angle			59.9°	60.2°	60°	60.3°			
	K-value									
	Efficiency			90.00%	91.00%	90.50%	91.00%			
Facula		See the signature sample								
Comprehensive judgment		Qualified								
Remarks: 1、Tool Number: V-Vernier Caliper 2D-Quadratic H-Height Gauge M-Tool Microscope P-Needle T-Thick Gauge R-Radius Gauge E-Visual. 2、Ambient temperature on the size of the product refer to the table on the right			PMMA product size changes with temperature table Length changes (mm)  Size: 50mm Size: 100mm Size: 150mm Size: 200mm Size: 250mm Size: 300mm (℃)							
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PN		HK-55@24-15-D9-20-1g-1		Product Name		HK-55@24-15°Lens	
Product material		PMMA-8N		Customer			
Package diagram		Single Vacuum package Box package					
Product packing		10	A/ Box	4	Box/Layer		
		11	Layer/Box	440	A/ Carton		
Packaging Materials	NO.	Part No	Part name	Size	Dosage	Unit	Remarks
	1	2.07.0041	Blister box	23cm*21cm	44	BAG	
	2	2.08.0001	PE film	30cm*30cm	44	PCS	
	3	2.06.0005	Reel label paper	6.2cm*8cm	44	PCS	
	4	2.06.0005	Box label paper	6.2cm*9.2cm	1	PCS	
	5	2.06.0003	big plate	46.8cm*42.8cm	12	PCS	
	6	2.06.0011	big carton	48cm*44cm*37cm	1	PCS	
Remarks	The loose packing is not subject to this specification. Customer's requirements shall prevail						

Special notice

When glue pass through holes, columns and other structures, or part of the thin structure, will form a weld line. The product which uses multi-point injection welding line will appear because of the combination of sol, as shown below:

Synthesis



Please note :

The appearance of lines in the structure of the product as well as at the screw hole is a normal phenomenon, will not affect the actual use of the product, and can not be avoided at this stage.

Appearance inspection standards

1 Operating procedures

1.1.1 Sampling standards, sampling plan and AQL

Test level : GB/T2828.1-2012 The first part is according to the acceptance quality limit (AQL) retrieval batch inspection sampling plan, general inspection level II level, CR class defect coefficient 0, MA defect rejection level AQL = 0.65, MI class defect rejection level AQL = 1.0; defect level please see 5.4.

2 Code table

Code	Code description	Unit	Code		Code description	Unit
N	Amount/pcs	pcs	D		Diameter	mm
L	Length	mm	H		Depth	mm
W	Width	mm	DS		Distance	mm
S	Proportion	mm ²	SS		Offset	mm

3 Test conditions

3.1 Sight distance and working hours: Sight distance should be 30-35cm, each side of the inspection time does not exceed 12s, the visual angle of 45-135 degrees;

3.2 Light: 2x40w cool white fluorescent lamp, the light source is 500-550mm away from the lens surface; in order to make the appearance defect can be correctly recognized, the illumination should be 500-1000Lux, and the observation time is 10 seconds.

3.3 Visual inspection staff should be 1.0 (including corrected visual acuity) above, no color blindness, color weakness.

4 Appearance inspection standards

Test items	Judging standard	Inspection equipment	Defect level		
		Testing method	MI	MA	CR
Check the sample	When start the machine and process, all products have to check the appearance of the sample, the appearance of the sample is divided into qualified samples and limited samples.	Sample comparison , visual			√
	1: Qualified sample refers to the appearance and structure standard of the product which recognized by the client, the sample size should be confirmed before mass production;				

	2: The limited sample refers to the limit of a particular exceptionally developed sample. Limit the sample only for its specific point of exception to confirm; The priority is higher than the other criteria in this table. When there is a limited sample, the limit sample shall prevail.				
Raw edge	Not allowed to affect the size and assembly	Visual, point card		√	
Scratch	1: Non-optical surface and non-exposed surface scratches should be visually insignificant and the length is less than 1/10 of the maximum surface size.	Visual, point card, calipers		√	
Fingerprint	Fingerprints are not allowed on all products	Visual		√	
Foreign objects, black spots, white spots	The product may not be attached to foreign objects, including oil, fiber, dregs of water gap and so on				√
Deformation	Insufficient filling shall not affect the appearance of the assembly and the exposed surfaces.	Visual, feeler			√
Poor ejection	Products may not appear bad ejection, including no convex top, thimble printed on the assembly surface shall not be higher than the product surface, non-assembled surface thimble height should not exceed the product size tolerances; thimble printing should be less than the product surface and no more than 0.3; thimble surface treatment should be consistent with the product side.	Visual, point card		√	
	Ejection strain: the optical surface and the appearance of the exposed surface after assembly are not allowed to have a strain, and the structural surface does not allow visual obvious strain.				
Insufficient filling	Insufficient filling shall not affect the appearance of the assembly and the exposed surfaces , The signature sample shall prevail.	Visual, point card		√	
Shrink	When the entire surface of the product shrinks, the optical properties and dimensions must meet the requirements, and the visual will not significantly affect the appearance.Part shrink reference point defects	Visual, point card		√	
Flow marks、Welding line	1 : Product does not allow the presence of flow marks and welding lines unless the structure can not be avoided;	Visual		√	
	2: The remaining flow marks shall not appear in the optical surface, a single $L \leq 10\text{mm}$, no more than two				

Bubble	No bubbles are allowed	Visual		√	
Foreign objects, black spots, white spots	Not obvious or $D \leq 0.3\text{mm}$ black spots and foreign bodies in the area of 100x100mm not more than 1; Exceeded foreign matter black spots is judged bad.	Visual, point card	√		
Damaged	No damage is allowed	Visual			√
Cold glue	Optical surface may not have cold glue, non-optical surface cold glue should meet the visual is not obvious.	Visual	√		
Bad incision	1: Do not affect the product size, shall not penetrate the optical surface, the cut should be smooth;	Visual			√
	2: Laser cutting products, the optical surface burns shall not occur after the processing is completed. Beading must not affect product installation				
	3: Three molds and hot runner gate shall not appear residue.				
Scrub	Scrub surface should be uniform, off the scrub phenomenon should not be obvious , A single off scrub imprint requires $D \leq 1\text{ mm}$ and no more than 1 area within a 50x50 mm area	Visual		√	