



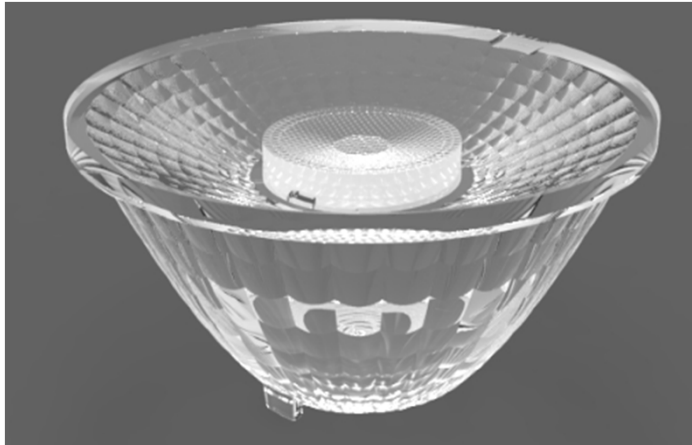
HERCULUX Chengdu HercuLux Photoelectric
恒坤光电 Technology Co.,Ltd
Product Approval

Approval number :

Customer :

Manufacturer : Chengdu HercuLux Photoelectric Technology Co.,Ltd

PN	Code	Product
HK-45@21-15-D6-20-1g-1	1. 01. 71248	45@21-15° lens
HK-45@21-24-10W-21-1g-1	1. 01. 71217	45@21-24° lens
HK-45@21-36-D6-20-1g-1	1. 01. 71252	45@21-36° lens
HK-45@21-60-D6-21-1g-1	1. 01. 81522	45@21-60° lens



Supplier confirmation				Client confirmation			
Proposed		DATE		Qualified <input type="checkbox"/>		DATE	
Project manager		DATE		Unqualified <input type="checkbox"/>		DATE	
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)

Fax : 028-85887730

www.hkoptics.com

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

TEL: 0755-2937 1541

FAX: 0755-2907 5140

*Approval In duplicate , for both supplier and customer.



HERCULUX
恒坤光电

Product Approval

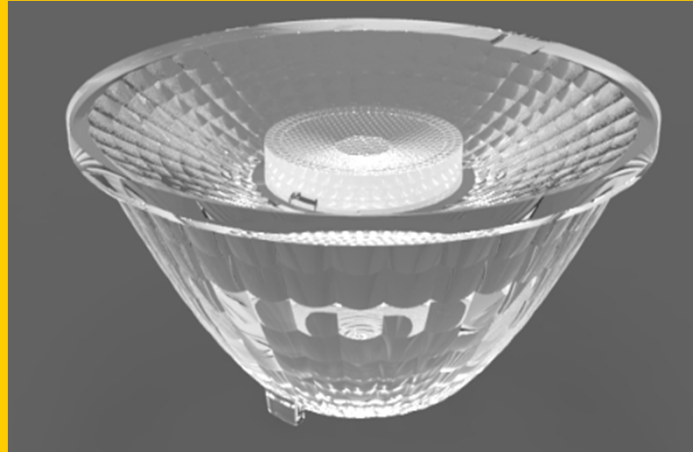
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FAX: 0755-2907 5140

www.hkoptics.com

Date updated: 2020/6/23

Product Picture:



PN: HK-45@21-15-D6-20-1g-1

Size(L*W*H/ Φ *H): Φ :45mm; H:21.15mm

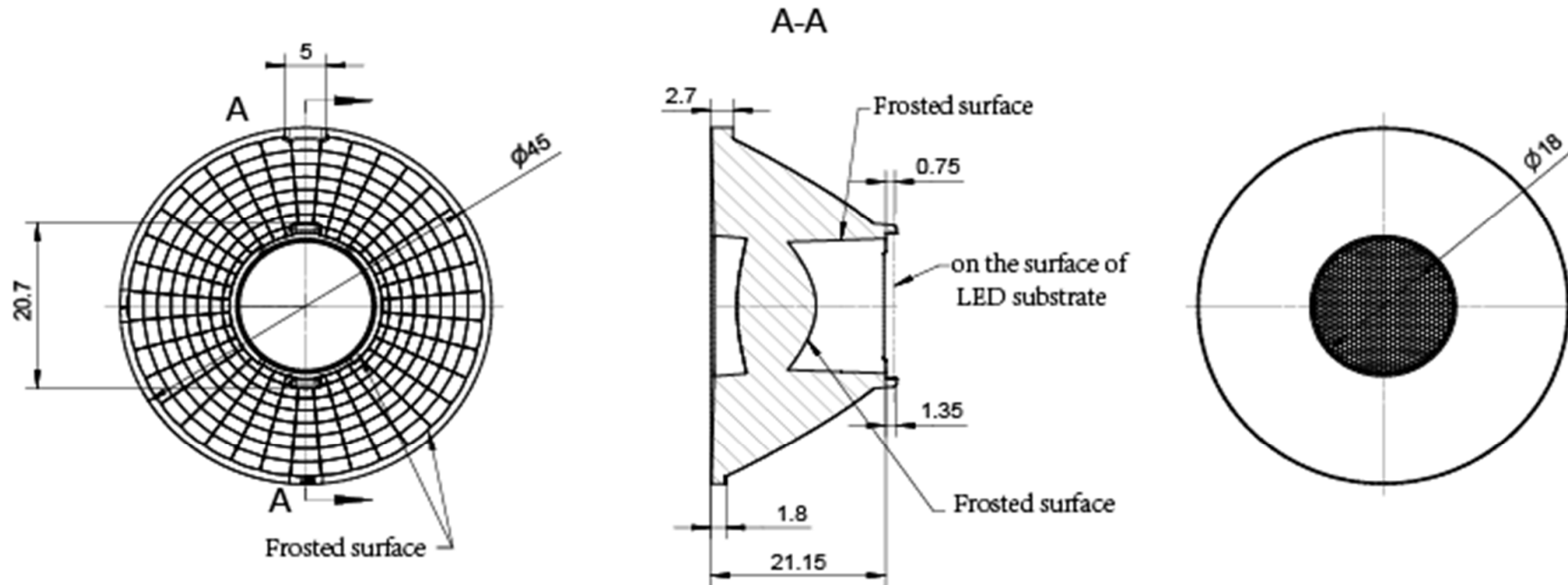
Material: PMMA

Efficiency: \

Temperature(Topr): -40°C to +80°C

FWHM: 15°、24°、36°、60°

Matched LES: D6

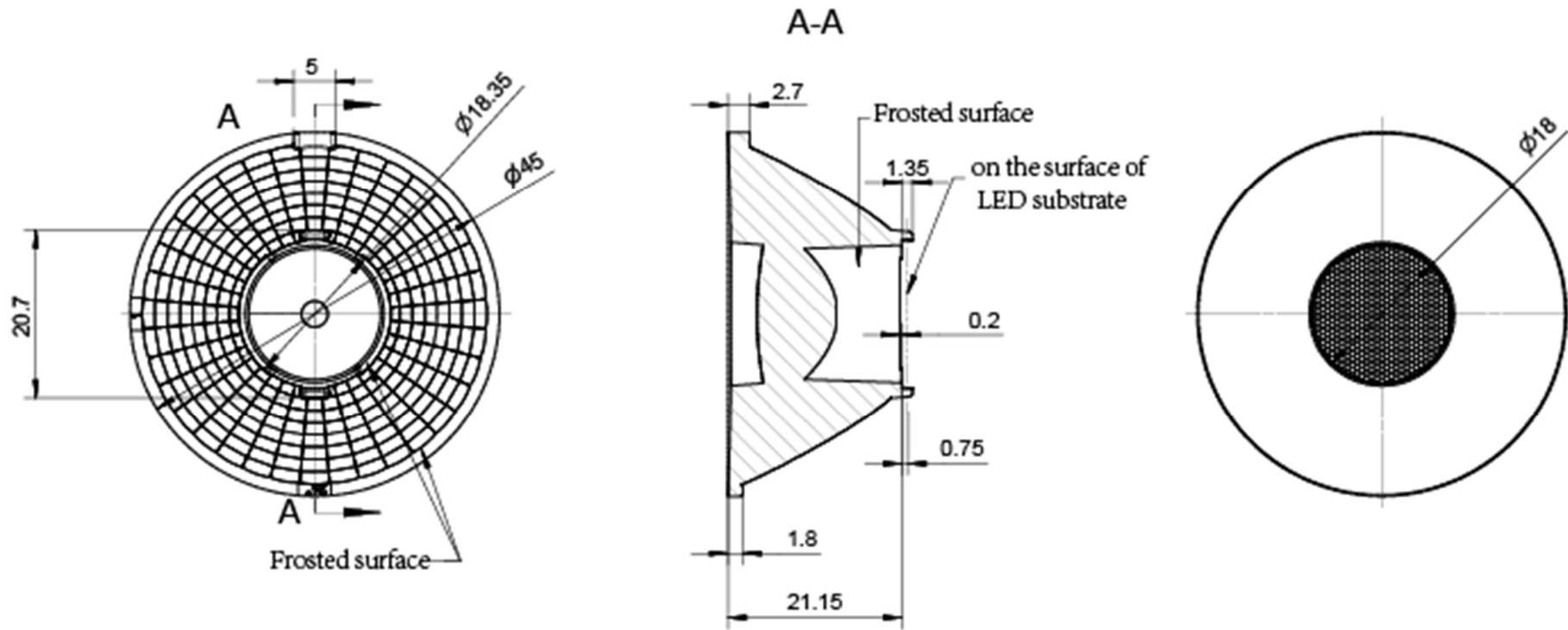


Technical remark:

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			45@21-15° lens		HK-45@21-15-D6-20-1g-1		
Structure design					1.01.71248		
Review				number of drawing	qty	weight	
Validation			Material:	PMMA	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	

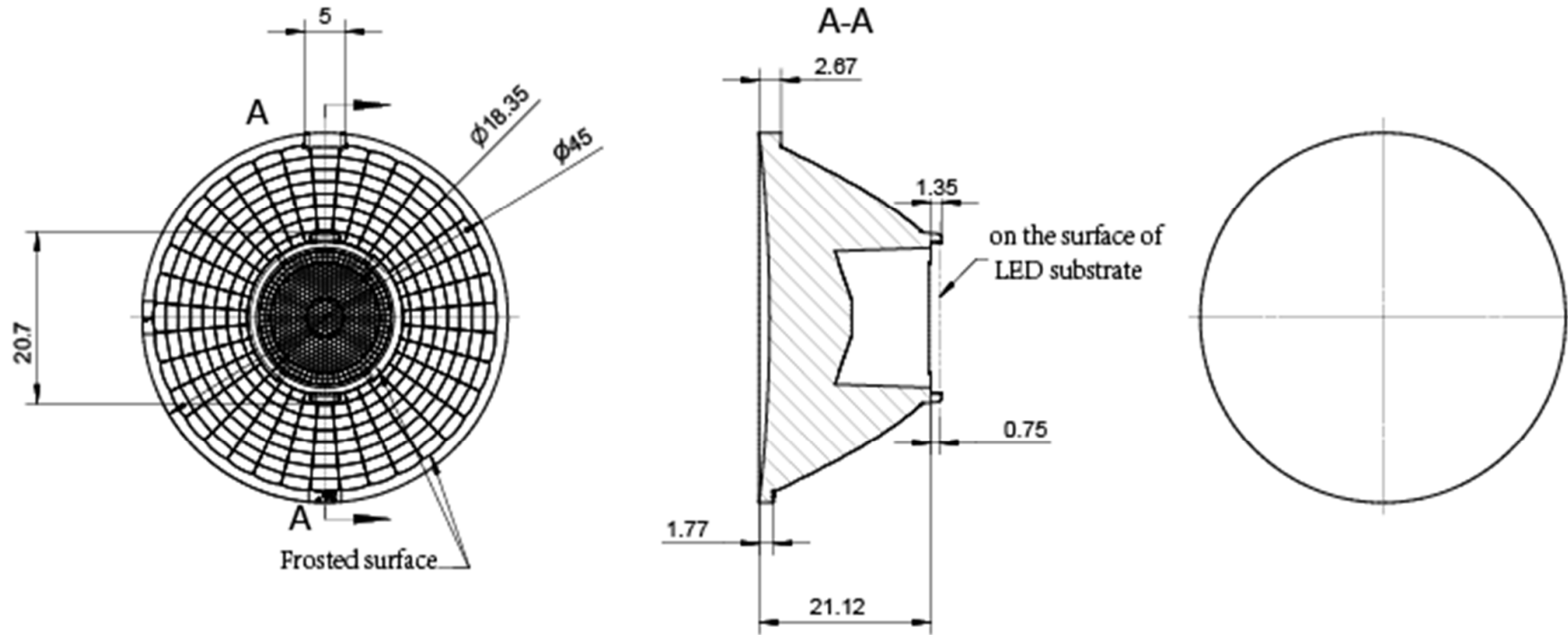


Technical remark:

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			45@21-24 ^g lens		HK-45@21-24-10W-21-1g-1		
Structure design					1.01.71217		
Review					Number of drawing	qty	weight
Validation			Material:	PMMA	CDHK		

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

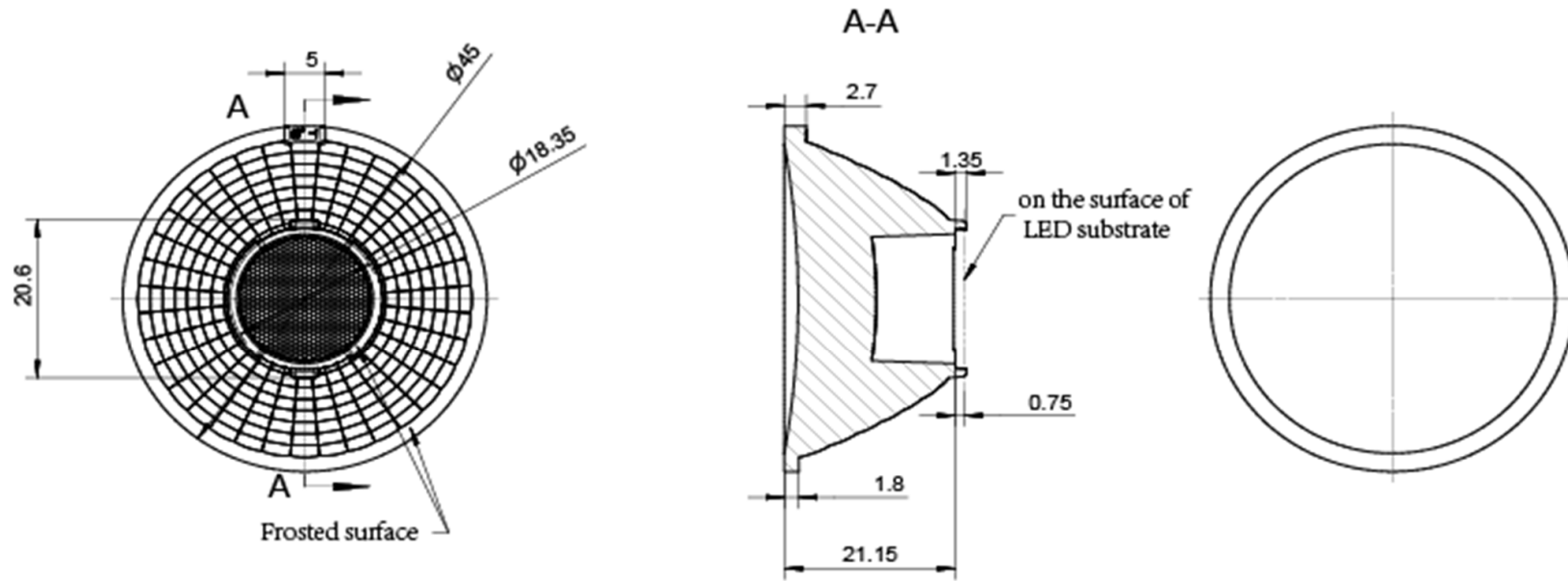


Technical remark:

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			45@21-36° lens		HK-45@21-36-D6-20-1g-1		
Structure design					1.01.71252		
Review				number of drawing	qty	weight	
Validation			Material:	PMMA	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	

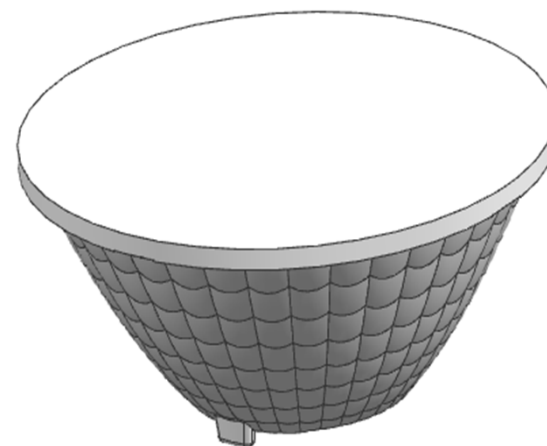
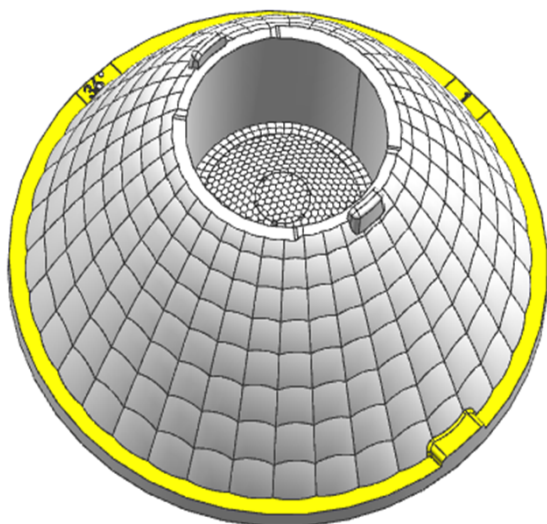


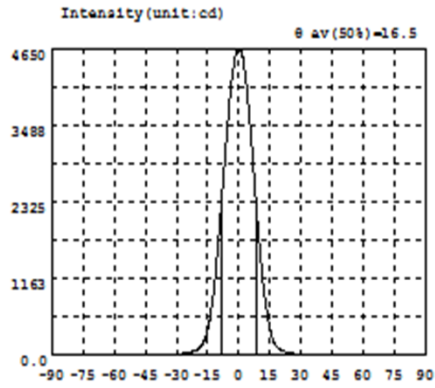
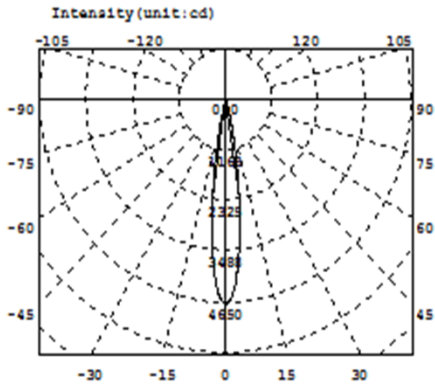
Technical remark:

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			45@21-60° lens		HK-45@21-60-D6-21-1g-1		
Structure design					1.01.81522		
Review					Number of drawing	qty	weight
Validation			Material:	PMMA	CDHK		

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





Intensity data: (deg , cd) CO-180

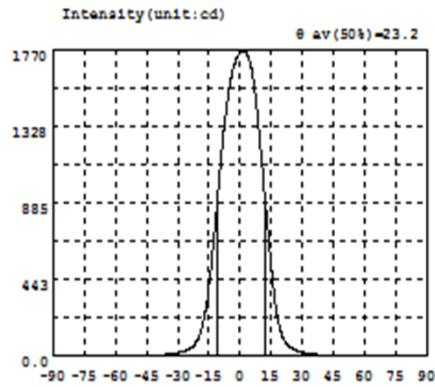
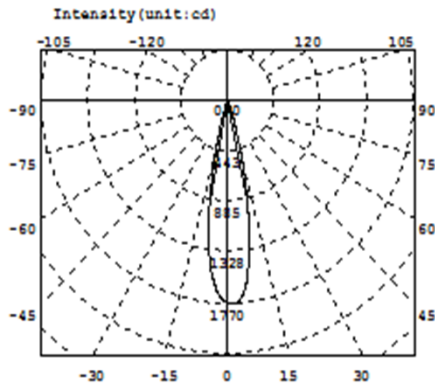
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.8700	-58.5	7.034	-27.0	27.25	4.5	3822	36.0	12.11	67.5	4.679
-88.5	1.017	-57.0	7.144	-25.5	34.40	6.0	3263	37.5	11.06	69.0	4.169
-87.0	1.164	-55.5	7.263	-24.0	44.54	7.5	2635	39.0	10.30	70.5	3.691
-85.5	1.254	-54.0	7.314	-22.5	58.96	9.0	2018	40.5	9.700	72.0	3.174
-84.0	1.300	-52.5	7.388	-21.0	76.14	10.5	1462	42.0	9.194	73.5	2.552
-82.5	1.390	-51.0	7.472	-19.5	103.6	12.0	1003	43.5	8.823	75.0	2.111
-81.0	1.469	-49.5	7.556	-18.0	154.8	13.5	650.3	45.0	8.578	76.5	1.826
-79.5	1.560	-48.0	7.656	-16.5	245.2	15.0	405.1	46.5	8.405	78.0	1.666
-78.0	1.652	-46.5	7.776	-15.0	396.3	16.5	231.3	48.0	8.266	79.5	1.583
-76.5	1.859	-45.0	7.986	-13.5	645.8	18.0	143.2	49.5	8.217	81.0	1.539
-75.0	2.204	-43.5	8.226	-12.0	1007	19.5	94.27	51.0	8.053	82.5	1.457
-73.5	2.724	-42.0	8.591	-10.5	1494	21.0	69.71	52.5	7.907	84.0	1.371
-72.0	3.256	-40.5	9.083	-9.0	2062	22.5	54.91	54.0	7.808	85.5	1.333
-70.5	3.718	-39.0	9.678	-7.5	2662	24.0	42.88	55.5	7.711	87.0	1.185
-69.0	4.151	-37.5	10.48	-6.0	3283	25.5	33.66	57.0	7.562	88.5	0.9711
-67.5	4.671	-36.0	11.57	-4.5	3842	27.0	27.17	58.5	7.383	90.0	0.8846
-66.0	5.149	-34.5	12.98	-3.0	4284	28.5	22.53	60.0	7.078		
-64.5	5.658	-33.0	14.59	-1.5	4560	30.0	19.29	61.5	6.664		
-63.0	6.106	-31.5	16.52	0.0	4650	31.5	16.94	63.0	6.223		
-61.5	6.493	-30.0	18.92	1.5	4551	33.0	15.08	64.5	5.703		
-60.0	6.847	-28.5	22.31	3.0	4269	34.5	13.46	66.0	5.200		

Electricity Parameter:

Current I: 0.1000A Power: 2.900W
Voltage V: 29.00V PF: 1.000

Optical Parameter (Distance=2.410m):

Equivalent Luminous flux: Φ_{eff} = 466.7lm Efficiency: Eff = 160.94lm/W
Diffuse angle: @ (25%) : 22.8deg @ (50%) : 16.5deg @ (75%) : 10.8deg @ (50%) : 16.5deg
Diffuse angle: @ (25%) : 22.8deg @ (50%) : 16.5deg @ (75%) : 10.8deg @ (50%) : 16.5deg
Imax=4650cd (C=0.0deg,G=0.0deg) CO-180Plane Imax= 4650cd(G=0.0deg)
CO-180Plane IO= 4650cd



Intensity data: (deg , cd) C0-180

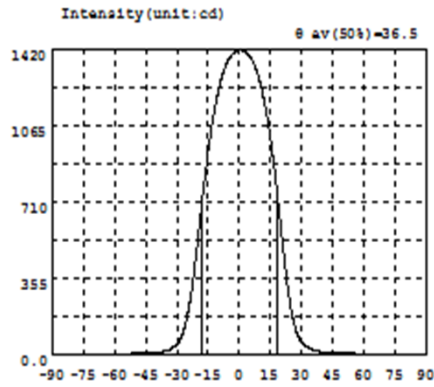
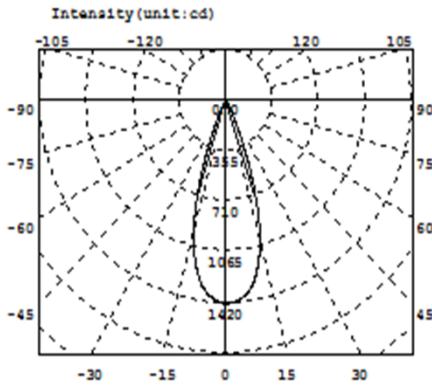
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.3390	-58.5	4.373	-27.0	31.90	4.5	1704	36.0	12.12	67.5	2.834
-88.5	0.4071	-57.0	4.596	-25.5	38.62	6.0	1617	37.5	10.65	69.0	2.517
-87.0	0.5093	-55.5	4.798	-24.0	47.89	7.5	1481	39.0	9.575	70.5	2.213
-85.5	0.6109	-54.0	4.970	-22.5	61.96	9.0	1310	40.5	8.841	72.0	1.908
-84.0	0.7132	-52.5	5.186	-21.0	84.36	10.5	1112	42.0	8.463	73.5	1.609
-82.5	0.8252	-51.0	5.650	-19.5	123.1	12.0	903.5	43.5	7.934	75.0	1.348
-81.0	0.9162	-49.5	6.085	-18.0	185.1	13.5	696.0	45.0	7.470	76.5	1.159
-79.5	1.053	-48.0	6.358	-16.5	276.0	15.0	507.5	46.5	7.021	78.0	1.067
-78.0	1.177	-46.5	6.729	-15.0	408.6	16.5	338.4	48.0	6.633	79.5	0.9282
-76.5	1.324	-45.0	7.105	-13.5	575.9	18.0	221.4	49.5	6.090	81.0	0.8264
-75.0	1.496	-43.5	7.508	-12.0	766.5	19.5	145.1	51.0	5.484	82.5	0.7683
-73.5	1.781	-42.0	7.803	-10.5	968.8	21.0	100.0	52.5	5.227	84.0	0.6709
-72.0	2.055	-40.5	8.193	-9.0	1166	22.5	73.46	54.0	5.027	85.5	0.5690
-70.5	2.348	-39.0	8.760	-7.5	1343	24.0	56.61	55.5	4.839	87.0	0.4771
-69.0	2.621	-37.5	9.653	-6.0	1488	25.5	45.05	57.0	4.605	88.5	0.3978
-67.5	2.917	-36.0	10.87	-4.5	1599	27.0	36.79	58.5	4.409	90.0	0.3288
-66.0	3.230	-34.5	12.36	-3.0	1677	28.5	29.36	60.0	4.202		
-64.5	3.512	-33.0	14.19	-1.5	1726	30.0	23.31	61.5	3.990		
-63.0	3.737	-31.5	16.62	0.0	1754	31.5	19.19	63.0	3.766		
-61.5	3.943	-30.0	20.20	1.5	1762	33.0	16.31	64.5	3.506		
-60.0	4.168	-28.5	25.88	3.0	1750	34.5	14.00	66.0	3.176		

Electricity Parameter:

Current I: 0.1000A Power: 2.810W
Voltage V: 28.10V PF: 1.000

Optical Parameter (Distance=2.410m):

Equivalent Luminous flux: Φ_{eff} = 314.6lm Efficiency: Eff = 111.98lm/W
Diffuse angle: @ (25%): 30.1deg @ (50%): 23.2deg @ (75%): 16.5deg @ (50%): 23.2deg
Diffuse angle: @ (25%): 30.3deg @ (50%): 23.2deg @ (75%): 16.6deg @ (50%): 23.2deg
Imax=1763cd (C=0.0deg,G=1.0deg) C0-180Plane Imax= 1763cd(G=1.0deg)
C0-180Plane I0= 1754cd



Intensity data: (deg , cd) C0-180

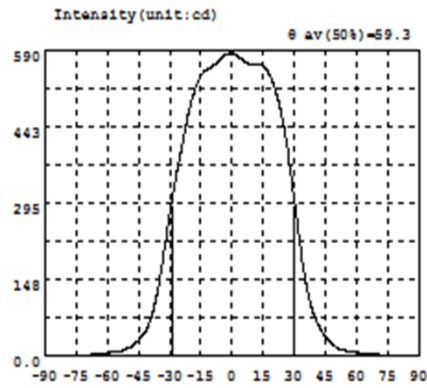
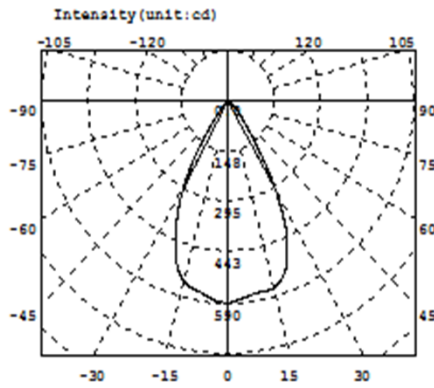
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.6242	-58.5	6.895	-27.0	110.3	4.5	1391	36.0	23.15	67.5	5.645
-88.5	0.7007	-57.0	7.207	-25.5	164.3	6.0	1371	37.5	19.23	69.0	5.152
-87.0	0.7269	-55.5	7.608	-24.0	237.5	7.5	1341	39.0	16.59	70.5	4.646
-85.5	0.8790	-54.0	8.167	-22.5	331.1	9.0	1300	40.5	14.86	72.0	4.133
-84.0	0.8539	-52.5	8.663	-21.0	446.9	10.5	1245	42.0	13.75	73.5	3.567
-82.5	0.9441	-51.0	9.043	-19.5	575.4	12.0	1176	43.5	13.01	75.0	3.039
-81.0	1.139	-49.5	9.782	-18.0	705.3	13.5	1095	45.0	12.51	76.5	2.566
-79.5	1.549	-48.0	10.33	-16.5	833.0	15.0	1001	46.5	12.09	78.0	2.077
-78.0	2.045	-46.5	10.49	-15.0	948.5	16.5	890.3	48.0	11.75	79.5	1.756
-76.5	2.478	-45.0	10.68	-13.5	1049	18.0	766.4	49.5	11.12	81.0	1.497
-75.0	2.907	-43.5	10.93	-12.0	1133	19.5	633.8	51.0	10.65	82.5	1.246
-73.5	3.413	-42.0	11.45	-10.5	1207	21.0	504.0	52.5	10.12	84.0	1.067
-72.0	3.936	-40.5	12.40	-9.0	1270	22.5	369.1	54.0	9.508	85.5	1.057
-70.5	4.371	-39.0	13.76	-7.5	1319	24.0	263.1	55.5	8.924	87.0	0.9951
-69.0	4.720	-37.5	15.81	-6.0	1354	25.5	181.3	57.0	8.355	88.5	0.9681
-67.5	5.136	-36.0	19.05	-4.5	1381	27.0	123.3	58.5	7.822	90.0	0.9197
-66.0	5.520	-34.5	23.66	-3.0	1400	28.5	84.92	60.0	7.432		
-64.5	5.912	-33.0	30.23	-1.5	1412	30.0	61.16	61.5	7.152		
-63.0	6.214	-31.5	39.59	0.0	1418	31.5	45.87	63.0	6.896		
-61.5	6.480	-30.0	53.49	1.5	1414	33.0	35.75	64.5	6.543		
-60.0	6.682	-28.5	75.39	3.0	1409	34.5	28.54	66.0	6.112		

Electricity Parameter:

Current I: 0.1000A Power: 3.348W
Voltage V: 33.50V PF: 1.000

Optical Parameter (Distance=2.559m):

Equivalent Luminous flux: # eff= 531.8lm Efficiency: Eff=158.87lm/W
Diffuse angle: @ (25%): 44.7deg @ (50%): 36.5deg @ (75%): 27.2deg @ (50%): 36.5deg
Diffuse angle: @ (25%): 44.7deg @ (50%): 36.5deg @ (75%): 27.2deg @ (50%): 36.5deg
Imax=1418cd (C=0.0deg,G=0.0deg) C0-180Plane Imax= 1418cd(G=0.0deg)
C0-180Plane IO= 1418cd



Intensity data: (deg , cd) C0-180

A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.5478	-58.5	7.419	-27.0	345.7	4.5	572.5	36.0	129.7	67.5	4.493
-88.5	0.5988	-57.0	8.150	-25.5	376.8	6.0	568.3	37.5	103.8	69.0	4.053
-87.0	0.6244	-55.5	8.944	-24.0	407.4	7.5	565.1	39.0	84.44	70.5	3.632
-85.5	0.6760	-54.0	10.02	-22.5	437.7	9.0	563.1	40.5	68.99	72.0	3.095
-84.0	0.7782	-52.5	11.44	-21.0	467.1	10.5	562.6	42.0	55.86	73.5	2.710
-82.5	0.8799	-51.0	14.05	-19.5	492.0	12.0	562.9	43.5	45.73	75.0	2.401
-81.0	0.9826	-49.5	16.99	-18.0	512.4	13.5	562.2	45.0	37.50	76.5	2.144
-79.5	1.107	-48.0	20.35	-16.5	528.3	15.0	559.1	46.5	30.09	78.0	1.959
-78.0	1.227	-46.5	25.04	-15.0	540.7	16.5	552.1	48.0	24.21	79.5	1.898
-76.5	1.507	-45.0	31.17	-13.5	547.9	18.0	542.6	49.5	19.79	81.0	1.850
-75.0	1.791	-43.5	38.44	-12.0	552.5	19.5	528.4	51.0	15.75	82.5	1.750
-73.5	2.186	-42.0	46.71	-10.5	556.2	21.0	509.7	52.5	13.31	84.0	1.673
-72.0	2.562	-40.5	57.81	-9.0	560.6	22.5	485.8	54.0	11.90	85.5	1.643
-70.5	2.979	-39.0	74.03	-7.5	565.2	24.0	458.4	55.5	10.77	87.0	1.619
-69.0	3.325	-37.5	95.62	-6.0	571.5	25.5	427.7	57.0	9.800	88.5	1.566
-67.5	3.786	-36.0	122.4	-4.5	576.7	27.0	387.4	58.5	8.737	90.0	1.481
-66.0	4.250	-34.5	155.8	-3.0	581.4	28.5	342.9	60.0	7.703		
-64.5	4.758	-33.0	196.1	-1.5	583.3	30.0	297.6	61.5	6.847		
-63.0	5.297	-31.5	233.0	0.0	584.3	31.5	250.0	63.0	6.155		
-61.5	5.954	-30.0	274.4	1.5	581.7	33.0	203.5	64.5	5.558		
-60.0	6.638	-28.5	311.0	3.0	576.8	34.5	162.7	66.0	4.971		

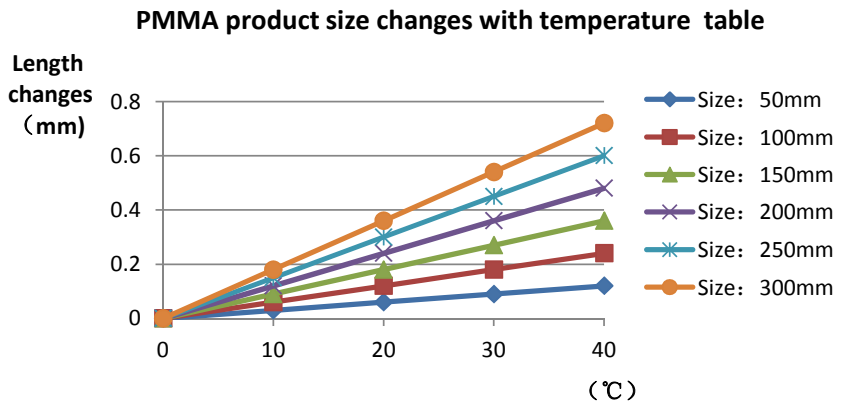
Electricity Parameter:

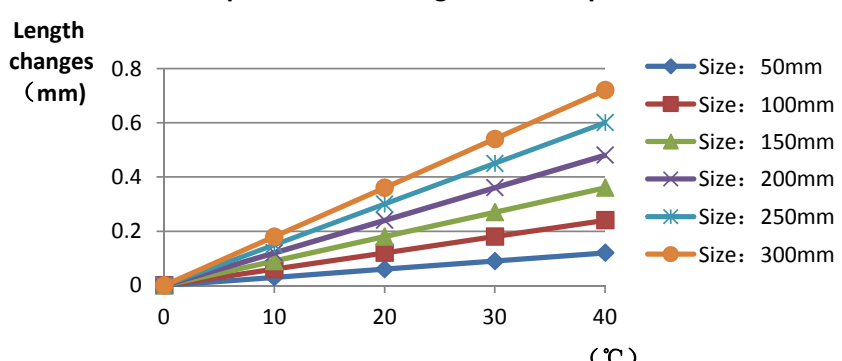
Current I: 0.1000A Power: 2.900W
Voltage V: 29.00V PF: 1.000

Optical Parameter (Distance=2.559m):

Equivalent Luminous flux: Φ_{eff} = 535.3lm Efficiency: Eff = 184.62lm/W
Diffuse angle: @ (25%): 70.0deg @ (50%): 59.3deg @ (75%): 47.4deg @ (50%): 59.3deg
Diffuse angle: @ (25%): 70.0deg @ (50%): 59.3deg @ (75%): 47.4deg @ (50%): 59.3deg
 I_{max} = 584.3cd (C=0.0deg, G=0.0deg) C0-180Plane I_{max} = 584.3cd (C=0.0deg)
C0-180Plane I_0 = 584.3cd

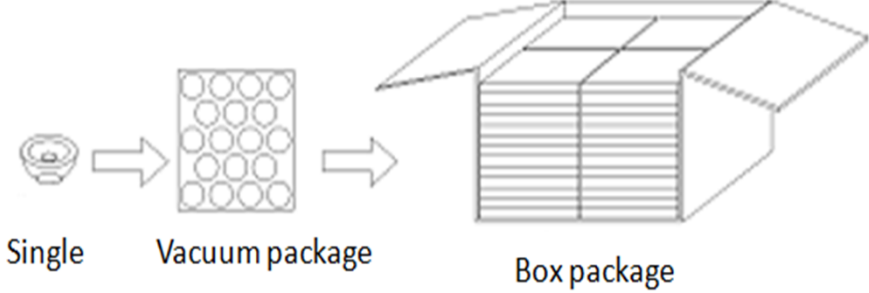
		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
1.Size	diameter	45			44.98	45.02	44.99	45.01		Test environment: In 20 °C -25 °C environment to achieve thermal equilibrium after the test.
	height	21.12			21.25	21.26	21.28	21.28		
	thickness	1.8			1.8	1.8	1.76	1.85		
	column	18.35			18.3	18.33	18.29	18.32		
	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	No burr	No burr	OK	
			No stains	No stains	No stains	No stains	No stains			
3.Material	PMMA				Color	Transparent			OK	
4.Optical index	Testing LED	0								
	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		16.8	16.7	16.9	16.5				
	K-value		9.43	9.27	9.34	9.73				
	Efficiency		88.70%	88.95%	88.60%	87.59%				
Facula	See the signature sample									
Comprehensive judgment	Qualified									
Remarks:	<p>1、 Tool Number: V-Vernier Caliper 2D-Quadratic H-Height Gauge M-Tool Microscope P-Needle T-Thick Gauge R-Radius Gauge E-Visual.</p> <p>2、 Ambient temperature on the size of the product refer to the table on the right</p>									
Precautions:	<p>1、 Wear clean gloves during lens assembly to prevent contamination of the lens surface.</p> <p>2、 Take the lens try to avoid touching the total reflection surface.</p> <p>3、 When the lens surface contamination, you can only gently wipe with soft cotton sticky neat neutral solvent, not allowed to wipe with industrial solvents.</p> <p>4、 The working temperature of the lens should be within the temperature limit of the lens material. Exceeding the temperature limit will cause damage to the lens and affect the service life of the lens.</p>									



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	FWHM	See light distribution curve																																																		
	angle		23.2	23.5	23.8	23.7																																														
	K-value		5.60	5.54	5.39	3.38																																														
	Efficiency		89.07%	89.27%	89.24%	88.85%																																														
Facula	See the signature sample																																																			
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Remarks:	<p>1、 Tool Number: V-Vernier Caliper 2D-Quadratic H-Height Gauge M-Tool Microscope P-Needle T-Thick Gauge R-Radius Gauge E-Visual.</p> <p>2、 Ambient temperature on the size of the product refer to the table on the right</p>																																																			
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		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks																																										
1.Size	diameter	45			45.04	44.92	44.89	45.01		Test environment: In 20 °C -25 °C environment to achieve thermal equilibrium after the test.																																										
	height	21.15			21.2	21.25	21.21	21.24																																												
	thickness	1.77			1.88	2	1.92	1.8																																												
	column	18.35			18.39	18.38	18.37	18.4																																												
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	FWHM	See light distribution curve																																																		
	angle		36.6	36.1	35.7	36.5																																														
	K-value		2.64	2.71	2.75	2.67																																														
	Efficiency		92.20%	90.19%	91.74%	92.11%																																														
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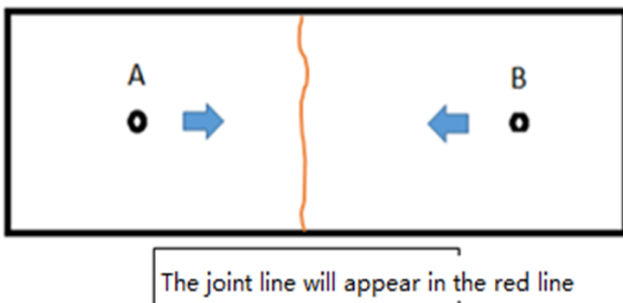
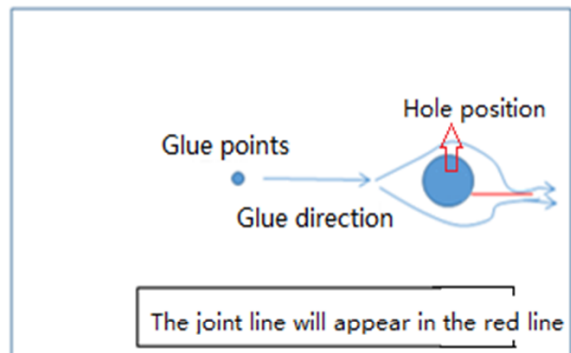
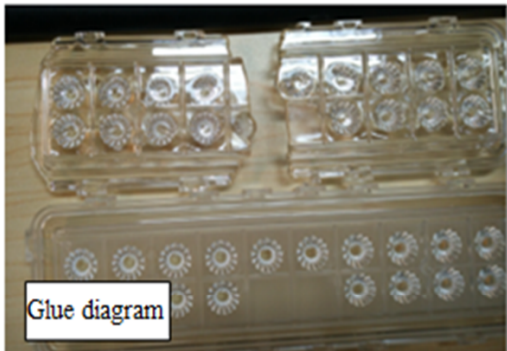
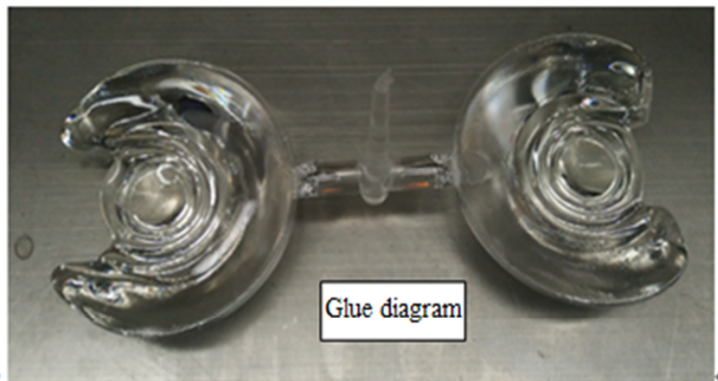
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1.Size	diameter	45	/	/	45.1	45.08	45.09	45.11	/	Test environment: In 20 °C -25 °C environment to achieve thermal equilibrium after the test.																																										
	height	21.12	/	/	21.3	21.29	21.37	21.35	/																																											
	thickness	1.8	/	/	1.8	1.8	1.76	1.85	/																																											
	column	18.35	/	/	18.45	18.48	18.49	18.48	/																																											
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	angle	/	59.3	60.2	59.8	59.8	/																																													
	K-value	/	/	/	/	/	/																																													
	Efficiency	/	94.31%	94.15%	94.12%	93.94%	/																																													
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PN	HK-45@21-15-D6-20-1g-1		Product Name	45@21-15° lens			
Product material	PMMA		Customer				
Package diagram	 <p style="text-align: center;"> Single Vacuum package Box package </p>						
Product packing	18	A/ Box	4	pcs/Layer			
	11	Layer/Box	792	A/ Carton			
Packaging Materials	NO.	Part No	Part name	Size	Dosage	Unit	Remarks
	1	2.07.0066	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	2.06.0015	big flat carton	48cm*44cm*19cm	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:

Syntner



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 ≤ 10mm, 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 $100 \times 100\text{mm}$ 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 $50 \times 50\text{ mm}$ area	Visual		√	