



**HERCULUX**  
恒坤光电

Chengdu HercuLux Photoelectric  
Technology Co.,Ltd  
**Product Approval**

Approval number:

Customer:

Manufacturer: Chengdu HercuLux Photoelectric Technology Co.,Ltd

PN	Code	Product
HK-GY-50@36-24-D12-2#-1g-1	1. 08. 12765	HK V 50@36-24 Degree reflective cup
HK-GY-50@36-36-D12-2#-1g-1	1. 08. 13029	HK V 50@36-36 Degree reflective cup
HK-GY-50@36-50-D12-2#-1g-1	1. 08. 33481	HK V 50@36-50 Degree reflective cup



Supplier confirmation				Client confirmation			
Proposed		DATE		Qualified <input type="checkbox"/>		DATE	
Project manager		DATE		Unqualified <input type="checkbox"/>			
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, lot industrial park 2 road HercuLux Photoelectric Park

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

Fax: 028-85887730

<http://www.herculux.com/>

Sales Dept: Shenzhen Nanshan District Nanshan Cloud Valley Innovation Industrial Park Comprehensive Service Building, 501-505

TEL: 0755-2937 1541

FAX: 0755-2907 5140

\*Approval In duplicate, for both supplier and customer.

Please use this product within the permitted range and environment according to the structure and material of the product. If the usage exceeds the recommended value, please test and verify by yourself. If the product is damaged due to out-of-range use, our company will not be responsible for the warranty.

#### Product material:

Customized products: The specifications and models of materials used are subject to the agreement between the two parties.

Conventional products: As a product that we continuously research and improve, under the premise of ensuring the quality and availability of the product, our company reserves the right to change the material. If the material specification and model change, without prior notice.

#### product data:

The measurement data and dimensional tolerances of the 2D drawings in the product data sheet of this acknowledgement are for reference only, and the final size shall prevail in kind.

The measurement data presented in this acknowledgment is a performance test of the product based on our company's internal test conditions and quality requirements, and the reported data is a typical value of the average results of multiple measurements. Therefore, in some cases, the actual product may deviate from the data provided. We reserve the right to notify you in advance of this data.

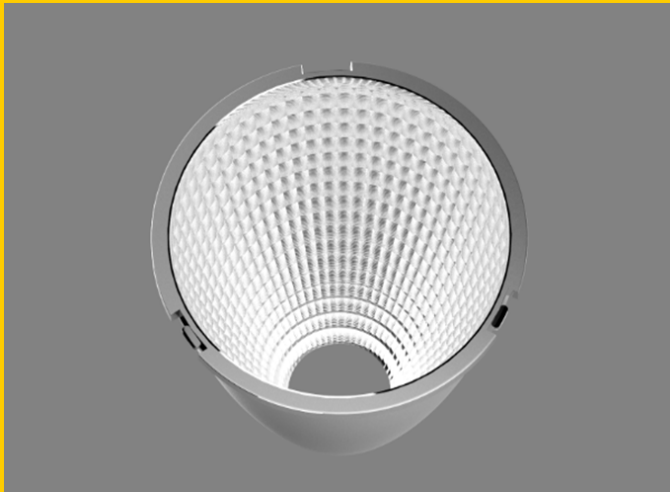
#### Product changes and improvements:

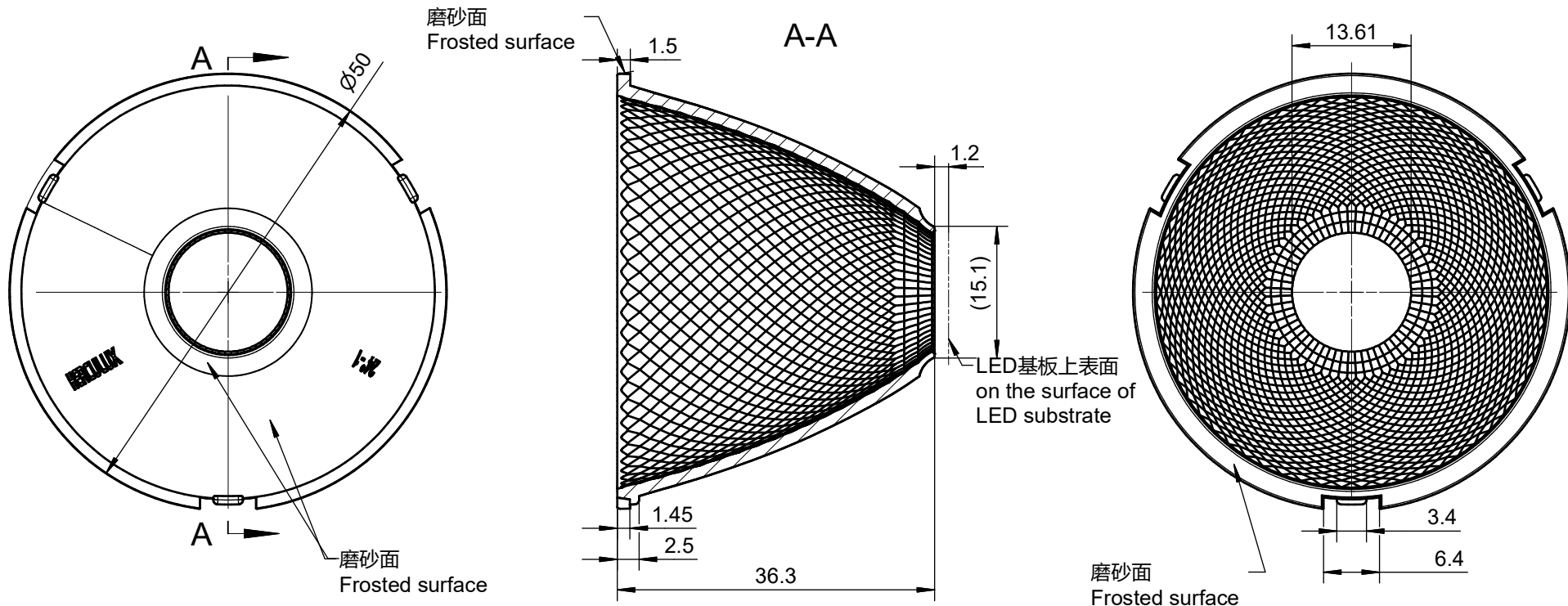
Changes and improvements of customized products are subject to the agreement between the two parties in the contract or technical documents.

As the conventional products that we continue to research and improve, our company reserves the right to make technical changes to its products, and reserves the right to make changes to data resulting from improvements without prior notice.

#### Operation cautions:

1. Please wear clean gloves during product assembly to prevent product surface contamination.
2. Try to avoid touching the optical surface of the lens when taking the lens.
3. When the surface of the product is polluted, please wipe it gently with a soft cotton cloth dipped in analytically pure neutral solvent. It is forbidden to use industrial solvents (alcohol, isopropanol, acetone, ether, toluene, xylene, carbon tetrachloride, MMA monomer, etc.) wipe.
4. The lens made of PC should not be exposed to direct sunlight in the storage and use environment. If the lens turns yellow or cracks due to long-term sunlight exposure, our company will not be responsible for the warranty.

Product Picture:	
Size(L*W*H/Φ*H):	Φ: 50mm*H: 36.3mm
Material:	PC aluminum plating
Effiency:	\
Temperature(Topr):	Material extreme temperature resistance: -40°C to +120°C long-term use temperature: -40°C to +100°C
FWHM:	24°、36°、50°
Matched LES:	D12
Recommended MAX power:	0%



注意光源支架选择：光源支架中间开孔需 $\geq 17$   
Pay attention to the selection of the light source bracket:  
The middle hole of the light source bracket needs to be  $\geq 17$

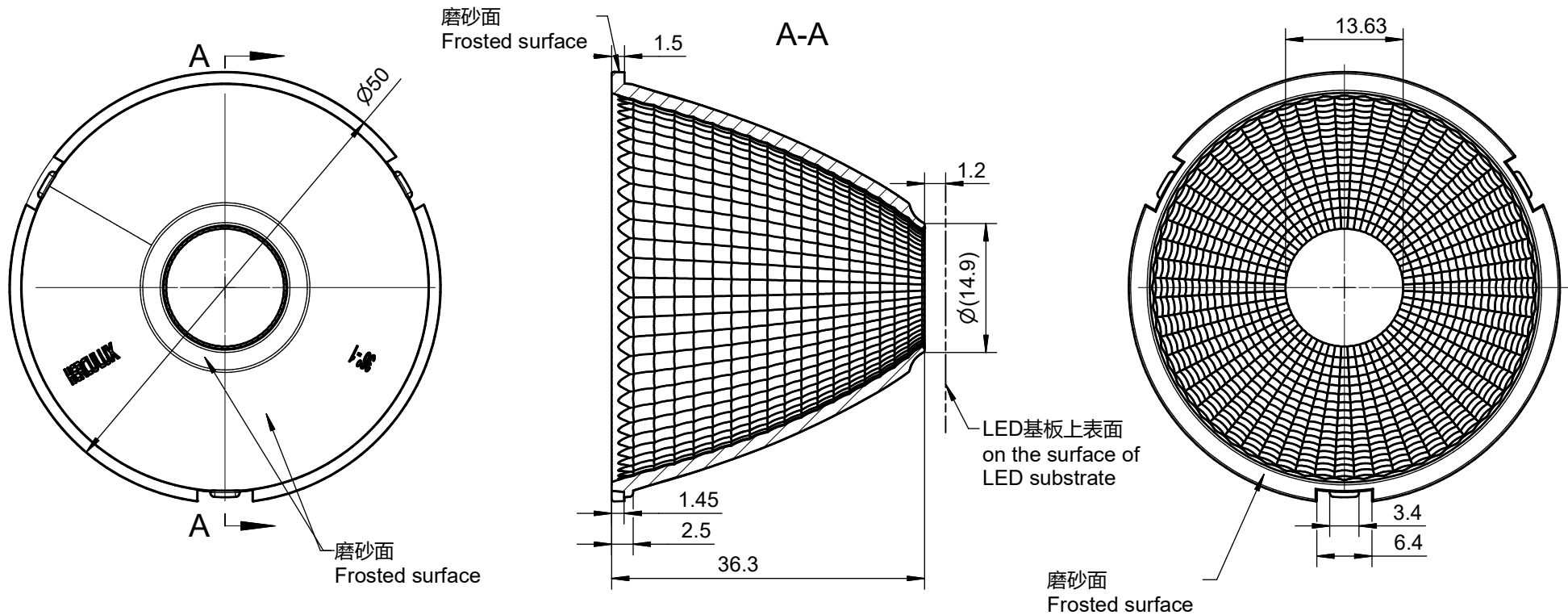
- 技术要求：
- 1、未注圆角及拔模斜度按3D图。
  - 2、未注尺寸公差按右表。
  - 3、表面无飞边，缩水，气泡等缺陷。
  - \*4、灯具采用胶圈防水时：要求散热器与胶圈的接触面的粗糙度：Ra<3.2 $\mu$ m

Technical remark:

- 1.Fillet and inclination not indicated according to 3D drawing.
- 2. Dimensional tolerances not indicated are shown in the right list.
- 3, The surface has no flash, shrinkage, bubbles and other defects.
- \*4. When the lamp adopts rubber ring for waterproofing: the roughness of the contact surface between the radiator and the rubber ring is required: Ra<3.2 $\mu$ m

出光角度范围		透过率	
Beam angle range		Transmittance	
最小K值		点胶类型	
Min K value		Gel type	
模具等级		备注	
Mold level		Remark	

2					4				
1					3				
序号	更改标记	更改内容	更改日期	签 名	序号	更改标记	更改内容	更改日期	签 名
Item	Change mark	Change content	Change date	Signature	Item	Change mark	Change content	Change date	Signature
光学设计			Title: HK 光影50@36-24度反光杯 HK V 50@36-24 Degree reflective cup				Drawing No. HK-GY-50@36-24-D12-2#-1g-1		
结构设计							Part No. 1.08.12765		
审核							CDHK		
材料			材料 PC 镀铝						
Approval			Material: PC aluminum plating						



注意光源支架选择：光源支架中间开孔需≥17  
Pay attention to the selection of the light source bracket:  
The middle hole of the light source bracket needs to be ≥ 17

- 技术要求:
- 1、未注圆角及拔模斜度按3D图。
  - 2、未注尺寸公差按右表。
  - 3、表面无飞边，缩水，气泡等缺陷。
  - \*4、灯具采用胶圈防水时：要求散热器与胶圈的接触面的粗糙度：Ra<3.2μm

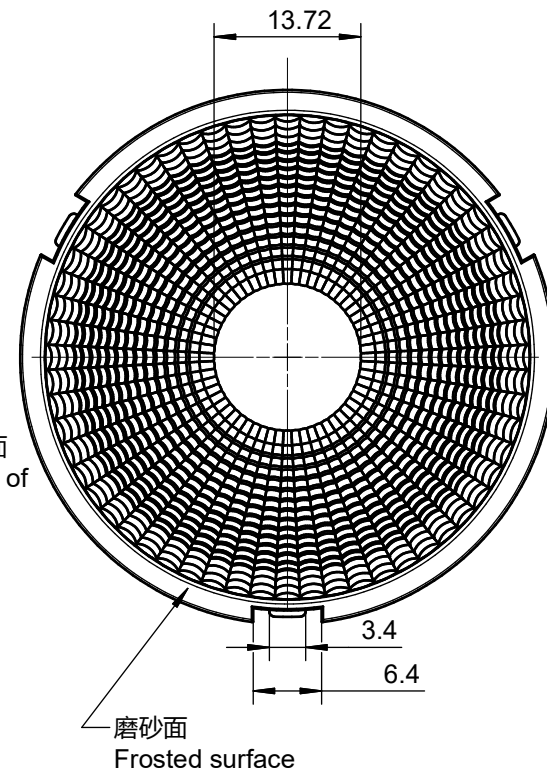
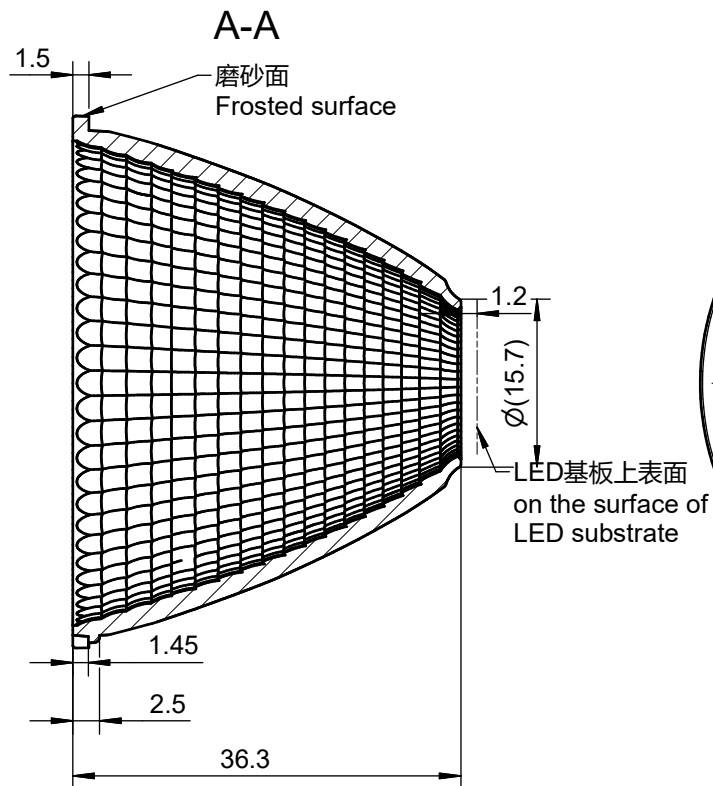
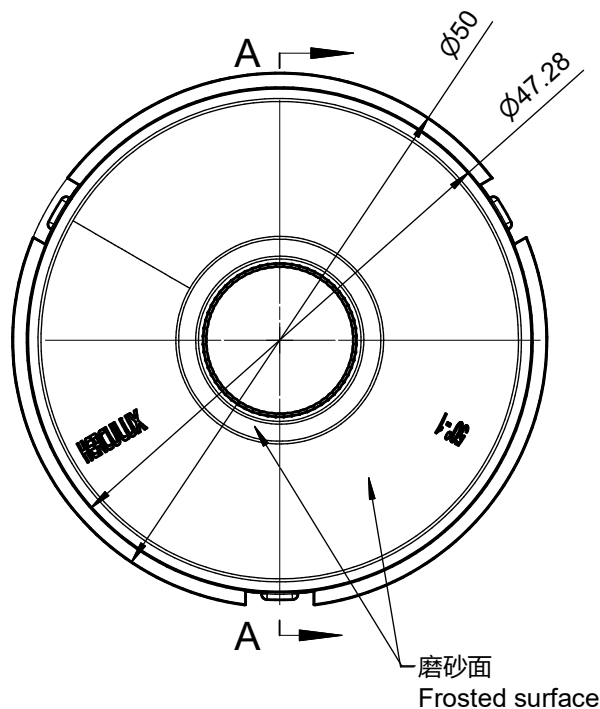
Technical remark:

- 1.Fillet and inclination not indicated according to 3D drawing.
- 2. Dimensional tolerances not indicated are shown in the right list.
- 3. The surface has no flash, shrinkage, bubbles and other defects.
- \*4. When the lamp adopts rubber ring for waterproofing: the roughness of the contact surface between the radiator and the rubber ring is required: Ra<3.2μm

表	
基本尺寸范围	公差值
Basic size	Tolerance value
<3	±0.1
3~10	±0.15
10~24	±0.20
24~65	±0.35
65~140	±0.50
140~250	±0.80
250~450	±1.2
>450	±2.0

出光角度范围		透过率	
Beam angle range		Transmittance	
最小K值		点胶类型	
Min K value		Gel type	
模具等级	见图面	备注	
Mold level	See drawing	Remark	

2					4				
1					3				
序号	更改标记	更改内容	更改日期	签 名	序号	更改标记	更改内容	更改日期	签 名
Item	Change mark	Change content	Change date	Signature	Item	Change mark	Change content	Change date	Signature
光学设计			Title: HK 光影50@36-36度反光杯 HK V 50@36-36 Degree reflective cup		Drawing No. HK-GY-50@36-36-D12-2#-1g-1		Part No. 1.08.13029		
结构设计									
审核									
Verify			材料   PC 镀铝		CDHK				
审定									
Approval			Material: PC aluminum plating						



注意光源支架选择：光源支架中间开孔需 $\geq 17$   
Pay attention to the selection of the light source bracket:  
The middle hole of the light source bracket needs to be  $\geq 17$

技术要求:

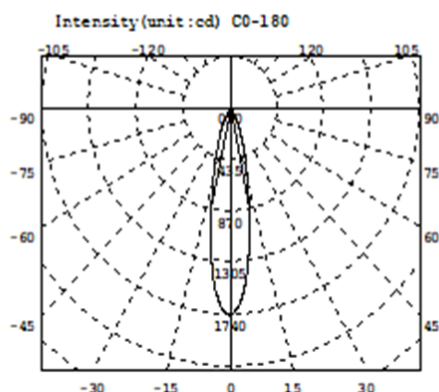
- 1、未注圆角及拔模斜度按3D图。
- 2、未注尺寸公差按右表。
- 3、表面无飞边，缩水，气泡等缺陷。
- \*4、灯具采用胶圈防水时：要求散热器与胶圈的接触面的粗糙度：Ra<3.2 $\mu$ m

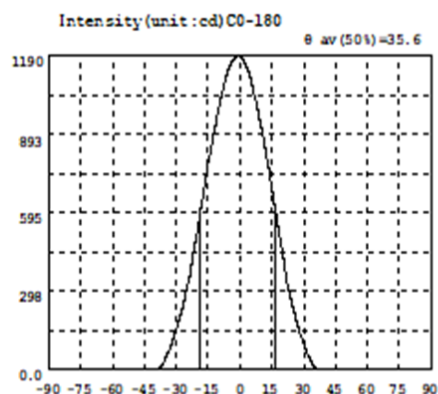
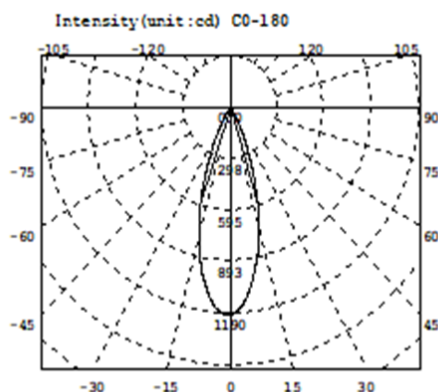
Technical remark:

- 1.Fillet and inclination not indicated according to 3D drawing.
2. Dimensional tolerances not indicated are shown in the right list.
- 3, The surface has no flash, shrinkage, bubbles and other defects.
- \*4. When the lamp adopts rubber ring for waterproofing: the roughness of the contact surface between the radiator and the rubber ring is required: Ra<3.2 $\mu$ m

基本尺寸	公差值
Basic size	Tolerance value
<3	$\pm 0.1$
3~10	$\pm 0.15$
10~24	$\pm 0.20$
24~65	$\pm 0.35$
65~140	$\pm 0.50$
140~250	$\pm 0.80$
250~450	$\pm 1.2$
>450	$\pm 2.0$

2						4					
1						3					
序号	更改标记	更改内容	更改日期	签名	序号	更改标记	更改内容	更改日期	签名	Title: HK 光影50@36-50度反光杯 HK V 50@36-50 Degree reflective cup	
Item	Change mark	Change content	Change date	Signature	Item	Change mark	Change content	Change date	Signature		
光学设计					结构					Drawing No. HK-GY-50@36-50-D12-2#-1g-1	
设计					审核					Part No. 1.08.33481	
结构					审定					CDHK	
审核					材料		PC 镀铝				
验证					Material		PC aluminum plating				
审批											





Intensity data:(deg , cd) C0-180

Α	I	Α	I	Α	I	Α	I	Α	I	Α	I
-90.0	0.5223	-58.5	0.5712	-27.0	239.5	4.5	1119	36.0	6.178	67.5	0.4184
-88.5	0.4960	-57.0	0.5860	-25.5	290.1	6.0	1073	37.5	2.538	69.0	0.4256
-87.0	0.3816	-55.5	0.6220	-24.0	345.2	7.5	1017	39.0	2.031	70.5	0.3999
-85.5	0.3686	-54.0	0.6578	-22.5	410.4	9.0	962.1	40.5	1.852	72.0	0.4307
-84.0	0.3578	-52.5	0.6927	-21.0	481.4	10.5	900.9	42.0	1.673	73.5	0.5954
-82.5	0.5795	-51.0	0.7463	-19.5	554.8	12.0	835.2	43.5	1.520	75.0	1.094
-81.0	1.013	-49.5	0.8103	-18.0	629.6	13.5	763.6	45.0	1.440	76.5	1.448
-79.5	1.354	-48.0	0.8870	-16.5	704.1	15.0	690.9	46.5	1.239	78.0	1.243
-78.0	1.383	-46.5	0.9920	-15.0	775.4	16.5	617.0	48.0	1.123	79.5	0.8364
-76.5	0.8177	-45.0	1.107	-13.5	844.9	18.0	542.2	49.5	1.021	81.0	0.4968
-75.0	0.4685	-43.5	1.267	-12.0	910.4	19.5	467.9	51.0	0.9231	82.5	0.3398
-73.5	0.4310	-42.0	1.461	-10.5	971.2	21.0	392.6	52.5	0.8262	84.0	0.3488
-72.0	0.4181	-40.5	1.732	-9.0	1027	22.5	323.1	54.0	0.7658	85.5	0.3567
-70.5	0.3949	-39.0	3.127	-7.5	1081	24.0	268.3	55.5	0.6752	87.0	0.5165
-69.0	0.4190	-37.5	10.64	-6.0	1124	25.5	217.8	57.0	0.6369	88.5	0.4438
-67.5	0.4218	-36.0	28.03	-4.5	1157	27.0	173.5	58.5	0.5922	90.0	0.3362
-66.0	0.4250	-34.5	52.45	-3.0	1179	28.5	134.7	60.0	0.5797		
-64.5	0.4396	-33.0	81.90	-1.5	1188	30.0	99.64	61.5	0.5320		
-63.0	0.4765	-31.5	115.7	0.0	1188	31.5	68.31	63.0	0.5096		
-61.5	0.5114	-30.0	153.5	1.5	1176	33.0	41.39	64.5	0.4841		
-60.0	0.5350	-28.5	196.1	3.0	1153	34.5	19.84	66.0	0.4836		

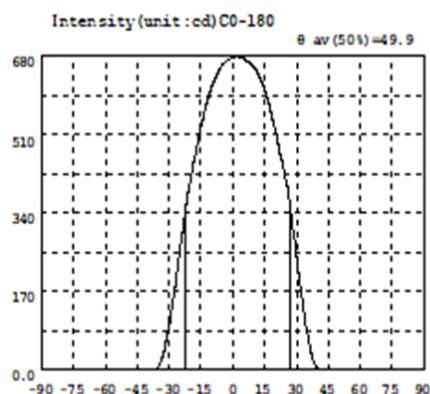
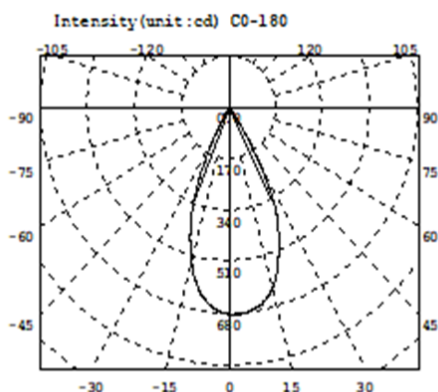
## Electricity Parameter:

Current I: 0.1000A Power: 3.358W  
Voltage V: 33.59V PF: 1.000

## Optical Parameter (Distance=2.559m):

Equivalent Luminous flux:  $\Phi_{\text{eff}} = 455.11\text{lm}$  Efficiency:  $\text{Eff} = 135.53\text{lm/W}$   
Diffuse angle: @ (25%): 48.3deg@ (50%): 35.6deg@ (75%): 23.1deg@ (50%): 35.6deg  
Diffuse angle: @ (25%): 48.4deg@ (50%): 35.6deg@ (75%): 23.1deg@ (50%): 35.6deg  
Imax=1190cd (C=0.0deg, G=-1.0deg) C0-180Plane Imax= 1190cd (G=-1.0deg)  
C0-180Plane I0= 1188cd





Intensity data:(deg , cd) C0-180

A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.6440	-58.5	0.4389	-27.0	187.5	4.5	676.1	36.0	57.23	67.5	0.4406
-88.5	0.6663	-57.0	0.4237	-25.5	237.3	6.0	672.6	37.5	28.17	69.0	0.4564
-87.0	0.6334	-55.5	0.4652	-24.0	289.8	7.5	667.2	39.0	9.935	70.5	0.4679
-85.5	0.6548	-54.0	0.4786	-22.5	339.9	9.0	660.6	40.5	3.348	72.0	0.5225
-84.0	0.4975	-52.5	0.5014	-21.0	383.7	10.5	652.4	42.0	1.447	73.5	0.8374
-82.5	0.4645	-51.0	0.5219	-19.5	422.5	12.0	641.2	43.5	0.9564	75.0	1.594
-81.0	0.4745	-49.5	0.5469	-18.0	458.5	13.5	625.8	45.0	0.7636	76.5	2.572
-79.5	0.5738	-48.0	0.5762	-16.5	493.1	15.0	607.2	46.5	0.7296	78.0	2.939
-78.0	1.123	-46.5	0.6720	-15.0	525.3	16.5	584.9	48.0	0.6692	79.5	2.720
-76.5	1.521	-45.0	0.6440	-13.5	556.2	18.0	559.0	49.5	0.6350	81.0	2.316
-75.0	1.905	-43.5	0.7005	-12.0	583.0	19.5	528.6	51.0	0.6021	82.5	1.896
-73.5	2.141	-42.0	0.7624	-10.5	605.5	21.0	497.6	52.5	0.5795	84.0	1.287
-72.0	1.641	-40.5	0.8586	-9.0	624.5	22.5	466.0	54.0	0.5699	85.5	0.5925
-70.5	0.7313	-39.0	0.9919	-7.5	640.6	24.0	433.2	55.5	0.5619	87.0	0.5498
-69.0	0.4204	-37.5	1.302	-6.0	653.2	25.5	398.2	57.0	0.5447	88.5	0.5625
-67.5	0.4169	-36.0	2.707	-4.5	662.6	27.0	355.0	58.5	0.5197	90.0	0.5751
-66.0	0.4095	-34.5	11.07	-3.0	669.5	28.5	300.4	60.0	0.5027		
-64.5	0.4195	-33.0	30.81	-1.5	674.4	30.0	247.7	61.5	0.4827		
-63.0	0.4278	-31.5	59.68	0.0	677.7	31.5	193.6	63.0	0.4711		
-61.5	0.4374	-30.0	95.79	1.5	679.0	33.0	142.0	64.5	0.4596		
-60.0	0.4485	-28.5	139.7	3.0	678.4	34.5	95.55	66.0	0.4357		

## Electricity Parameter:

Current I: 0.1000A Power: 3.598W

Voltage V: 36.00V PF: 1.000

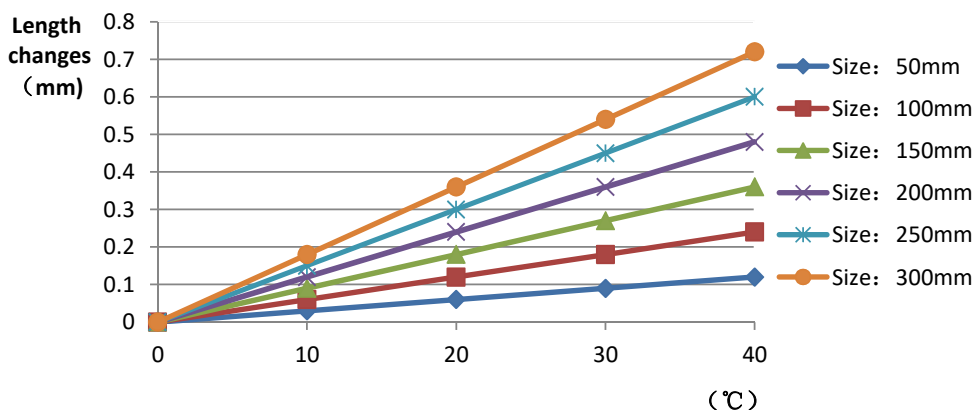
## Optical Parameter (Distance=2.410m) :

Equivalent Luminous flux:  $\Phi_{\text{eff}} = 405.8\text{lm}$  Efficiency:  $\text{Eff} = 112.80\text{lm/W}$ 

Diffuse angle: @ (25%): 59.6deg@ (50%): 49.9deg@ (75%): 36.1deg@ (50%): 49.9deg

Diffuse angle: @ (25%): 59.6deg@ (50%): 49.9deg@ (75%): 36.1deg@ (50%): 49.9deg

I<sub>max</sub>=679.0cd (C=0.0deg, G=1.5deg)C0-180Plane I<sub>max</sub>= 679.0cd (G=1.5deg)C0-180Plane I<sub>0</sub>= 677.7cd

1.Size		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Test result5	Test result6	Test result7	Test result8	Judgment	Remarks																																										
	diameter	50			50.05	49.95	49.92	49.95	49.95	49.91	49.93	49.96		Test environment: In 20 °C -25 °C environment to achieve thermal																																										
	height	36.3			36.44	36.48	36.46	36.45	36.44	36.48	36.46	36.45																																												
	thickness	1.5			1.58	1.67	1.66	1.63	1.53	1.62	1.59	1.56																																												
	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	PC aluminum plating						Color		Transparent				OK																																											
4.Optical index	Testing LED	CREE 1820																																																						
	The size and rated power of the light-emitting surface (LES) of the COB recommended by this lens should conform to the parameters in the product basic information table. 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					24.5	24.7	23.6	23.4	25	24.7	24.7	24.1																																											
	K-value					3.96	3.94	4.10	3.94	3.90	3.95	3.95	4.04																																											
	efficiency					86.0%	85.0%	85.0%	86.0%	85.1%	85.0%	85.0%	86.0%																																											
accuracy	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		<div>PC product size changes with temperature table</div> <div></div> <table><caption>PC product size changes with temperature table</caption><thead><tr><th>Size (mm)</th><th>0 °C</th><th>10 °C</th><th>20 °C</th><th>30 °C</th><th>40 °C</th></tr></thead><tbody><tr><td>Size: 50mm</td><td>0.00</td><td>0.02</td><td>0.05</td><td>0.08</td><td>0.12</td></tr><tr><td>Size: 100mm</td><td>0.00</td><td>0.04</td><td>0.10</td><td>0.18</td><td>0.25</td></tr><tr><td>Size: 150mm</td><td>0.00</td><td>0.06</td><td>0.15</td><td>0.28</td><td>0.38</td></tr><tr><td>Size: 200mm</td><td>0.00</td><td>0.08</td><td>0.20</td><td>0.35</td><td>0.48</td></tr><tr><td>Size: 250mm</td><td>0.00</td><td>0.10</td><td>0.25</td><td>0.45</td><td>0.60</td></tr><tr><td>Size: 300mm</td><td>0.00</td><td>0.12</td><td>0.30</td><td>0.55</td><td>0.72</td></tr></tbody></table>													Size (mm)	0 °C	10 °C	20 °C	30 °C	40 °C	Size: 50mm	0.00	0.02	0.05	0.08	0.12	Size: 100mm	0.00	0.04	0.10	0.18	0.25	Size: 150mm	0.00	0.06	0.15	0.28	0.38	Size: 200mm	0.00	0.08	0.20	0.35	0.48	Size: 250mm	0.00	0.10	0.25	0.45	0.60	Size: 300mm	0.00	0.12	0.30	0.55	0.72
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		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Test result5	Test result6	Test result7	Test result8	Judgment	Remarks	
1.Size	diameter	50			50.08	49.96	49.93	49.98	50.08	49.96	49.93	49.98		Test environment: In 20℃ -25℃ environment to achieve thermal	
	height	36.3			36.43	36.42	36.48	36.41	36.43	36.42	36.48	36.41			
	thickness	1.5			1.62	1.58	1.65	1.62	1.55	1.56	1.53	1.52			
	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		OK		
			No stains		No stains		No stains		No stains						
3.Material	PC aluminum plating						Color		Transparent				OK		
4.Optical index	Testing LED	CREE 1820													
	The size and rated power of the light-emitting surface (LES) of the COB recommended by this lens should conform to the parameters in the product basic information table. 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					36.5	36.7	35.6	36.5	35.8	37	35.6	36.7		
	K-value					2.5352	2.5033	2.50	2.50	2.51	2.5	2.50	2.50		
	efficiency					82.9%	84.0%	84.0%	84.0%	84.0%	84.0%	84.4%	84.0%		
accuracy	See the signature sample														
Comprehensive judgment	Qualified														
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iv></div><div></div><div></div></div><div><div></div>&lt;</div></div></div>													

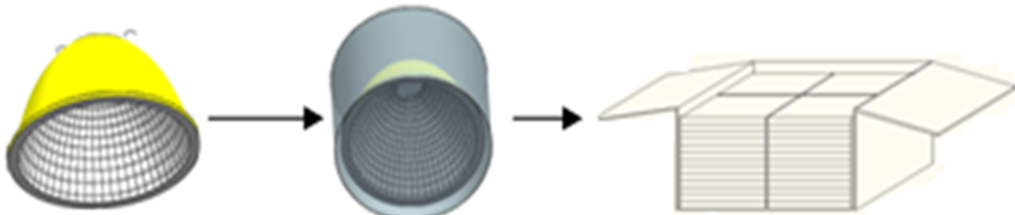
Precautions:

1. Please wear clean gloves during the lens assembly process to prevent the lens surface from being contaminated.
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		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Test result5	Test result6	Test result7	Test result8	Judgment	Remarks
1.Size	diameter	50			50.02	50	50	49.92	49.96	50.02	49.95	49.95		Test environment: In 20 ℃ -25 ℃ environment to achieve thermal
	height	36.3			36.25	36.39	36.23	36.26	36.23	36.23	36.32	36.25		
	thickness	1.5			1.41	1.41	1.36	1.33	1.32	1.36	1.41	1.41		
	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		OK	
			No stains		No stains		No stains		No stains					
3.Material	PC aluminum plating						Color		Transparent				OK	
4.Optical index	Testing LED	CREE 1820												
	The size and rated power of the light-emitting surface (LES) of the COB recommended by this lens should conform to the parameters in the product basic information table. 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					49.9	49.7	49.3	49.6	49.5	49.9	48.5	50.1	
	K-value													
	efficiency					83.8%	85.0%	85.0%	84.5%	84.5%	84.3%	84.5%	84.3%	
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Comprehensive judgment	Qualified													
Remarks:		<div><div>1、Tool Number: V-Vernier Caliper 2D-Quadratic H-Height Gauge M-Tool Microscope P-Needle T-Thick Gauge R-Radius Gauge E-Visual.</div><div>2、Ambient temperature on the size of the product refer to the table on the right</div></div> <div><div>PC product size changes with temperature table</div><div><div><div>Length changes (mm)</div><div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><div>0.8</div><div>0.7</div><div>0.6</div><div>0.5</div><div>0.4</div><div>0.3</div><div>0.2</div><div>0.1</div><div>0</div></div></div><div><div>0</div><div>10</div><div>20</div><div>30</div><div>40</div></div><div><div>Size: 50mm</div><div>Size: 100mm</div><div>Size: 150mm</div><div>Size: 200mm</div><div>Size: 250mm</div><div>Size: 300mm</div></div></div></div></div>												

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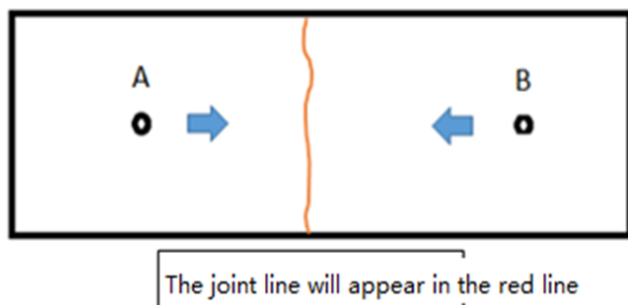
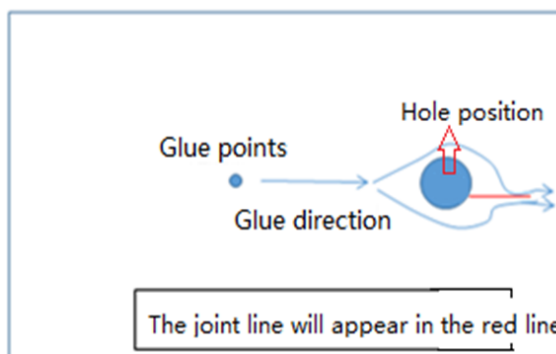
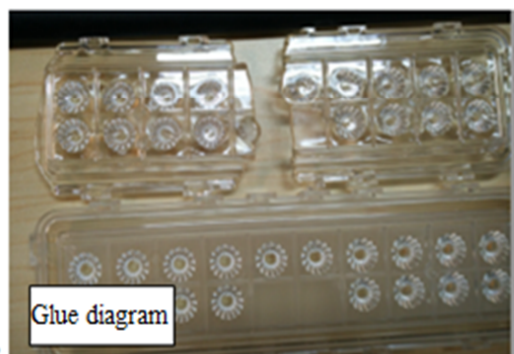
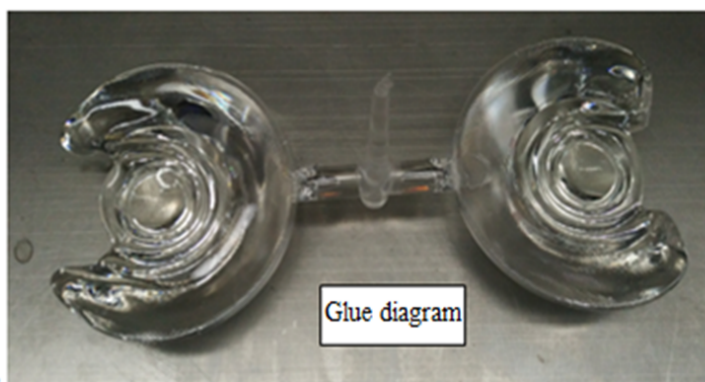
PN		HK-GY-50@36-24-D12-2#-1g-1	Product Name	HK V 50@36-24 Degree reflective cup			
Product material		PC aluminum plating					
Package diagram							
Product packing		45	PCS/BAG	180	BAG/LAYER		
		4	Layer/Box	720	Piece/Box		
Packaging Materials	NO.	Material Code	Item name	Specification	Single box usage	Unit	Remarks
	1	——	Plastic bags	——	16	BAG	
	2	2.06.0005	Box label	6.2cm*7.6cm	1	PCS	
	3	2.06.0007	Partition	39*29cm	5	PCS	
	4	2.06.00012	Carton	40*30*26cm	1	PCS	
Remarks	Scattered packaging is not subject to this specification						



## 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 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 <sup>2</sup>	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		√	