



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.

Basic product information

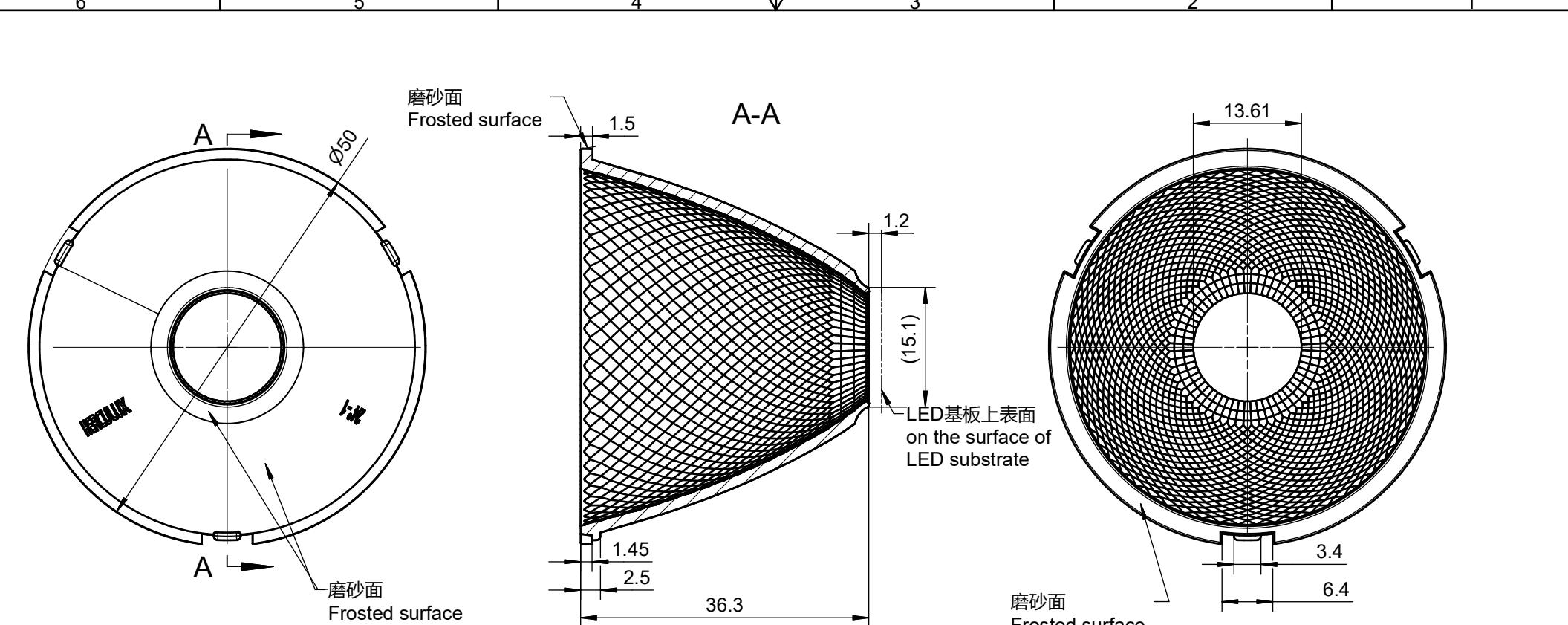
TEL: 0755-2937 1541

FAX: 0755-2907 5140

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

Date updated: 2023/8/1

Product Picture:	
Size(L*W*H/Φ*H):	Φ: 50mm*H: 36.3mm
Material:	PC aluminum plating
Efficiency:	\\
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 ≥ 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:

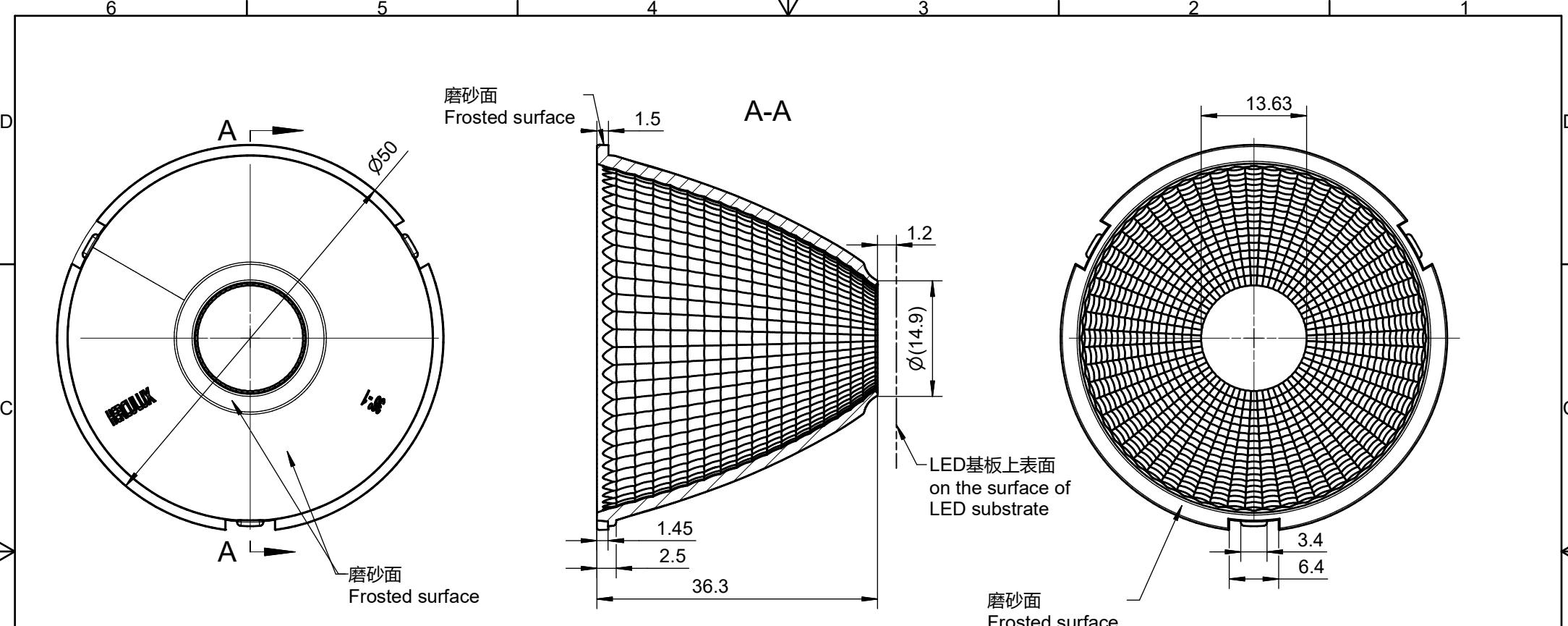
1. 未注圆角及拔模斜度按3D图。
2. 未注尺寸公差按右表。
3. 表面无飞边, 缩水, 气泡等缺陷。
- *4. 灯具采用胶圈防水时: 要求散热器与胶圈的接触面的粗糙度: $Ra < 3.2 \mu\text{m}$

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: $Ra < 3.2 \mu\text{m}$

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

2				4				
1				3				
序号 Item	更改标记 Change mark	更改内容 Change content	更改日期 Change date	签 名 Signature	序号 Item	更改标记 Change mark	更改内容 Change content	更改日期 Change date
光学设计 Optical design								
结构设计 Structural design								
审核 Verify								
审定 Approval								
材料 Material	PC 镀铝 PC aluminum plating							
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								
Part No. 1.08.12765								
CDHK								



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:

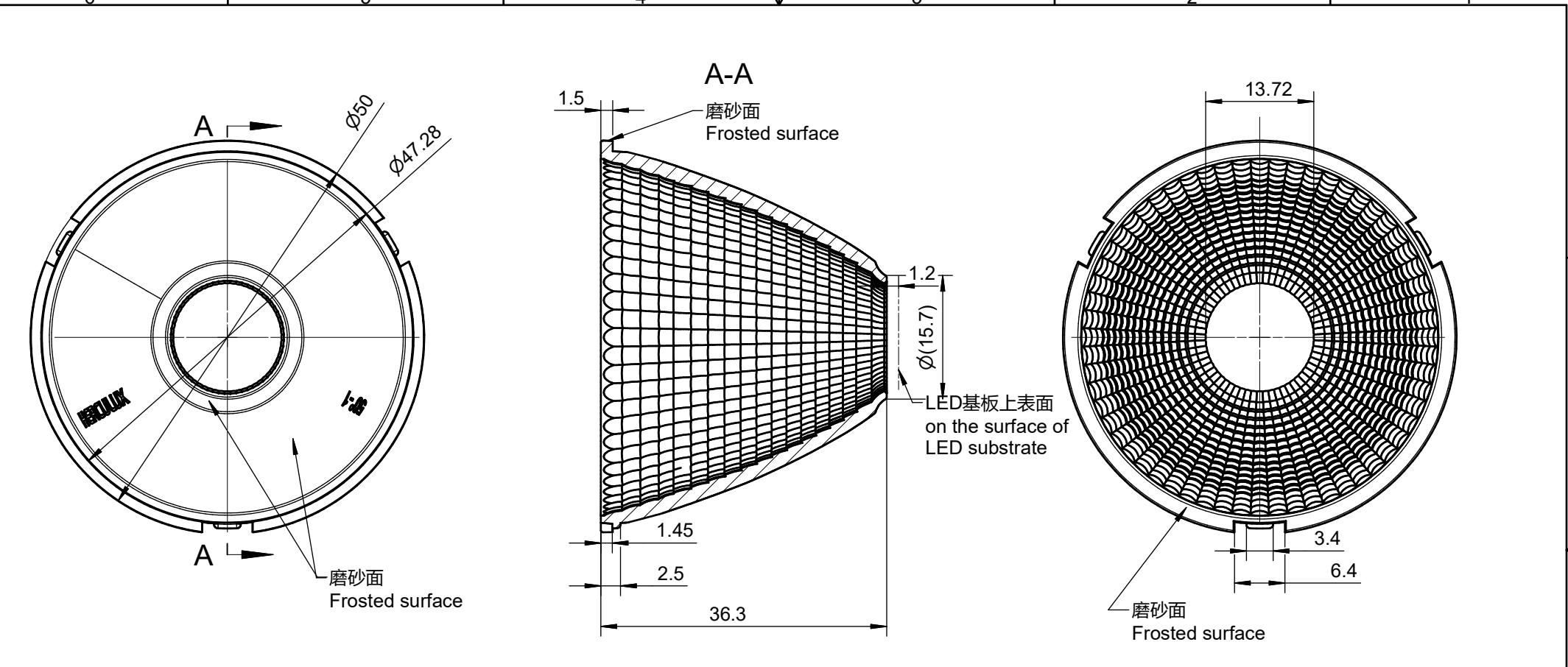
1. 未注圆角及拔模斜度按3D图。
2. 未注尺寸公差按右表。
3. 表面无飞边，缩水，气泡等缺陷。
- *4. 灯具采用胶圈防水时：要求散热器与胶圈的接触面的粗糙度： $R_a < 3.2\mu m$

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: $R_a < 3.2\mu m$

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 Beam angle range		透光率 Transmittance	
最小K值 Min K value		点胶类型 Gel type	
模具等级 Mold level	见图面 See drawing	备注 Remark	
2		4	
1		3	
序号 Item	更改标记 Change mark	更改内容 Change content	更改日期 Change date
光 学 设 计 Optical design			签 名 Signature
结 构 设 计 Structural design			序号 Item
审 核 Verify			更 改 标 记 Change mark
审 定 Approval			更 改 内 容 Change content
材料 Material	PC 镀铝 PC aluminum plating		更 改 期 限 Change date
Title: HK GY-50@36-36-D12-2#-1g-1		Drawing No. HK-GY-50@36-36-D12-2#-1g-1	
Part No.		1.08.13029	
CDHK			



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:

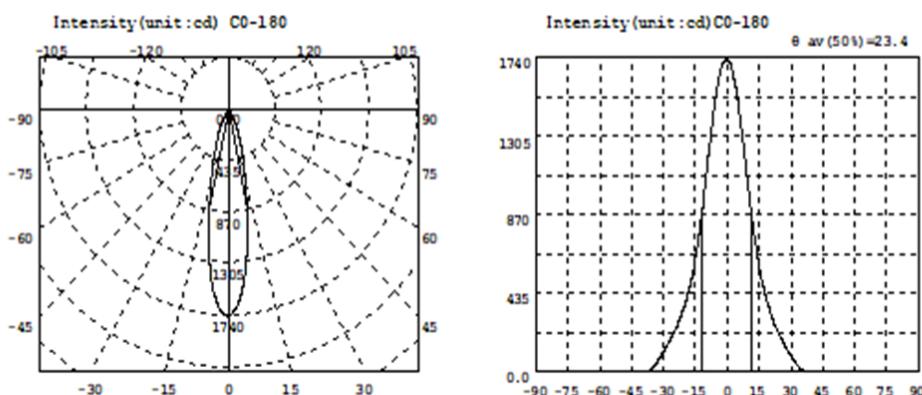
1. 未注圆角及拔模斜度按3D图。
2. 未注尺寸公差按右表。
3. 表面无飞边，缩水，气泡等缺陷。
- *4. 灯具采用胶圈防水时：要求散热器与胶圈的接触面的粗糙度： $Ra < 3.2\mu m$

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	2					4			
Basic size	Tolerance value	1					3			
<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									

光学设计 Optical design			Title: HK 光影50@36-50度反光杯 HK V 50@36-50 Degree reflective cup	Drawing No. HK-GY-50@36-50-D12-2#-1g-1
结构设计 Structural design			Part No.	1.08.33481
审核 Verify			Material:	CDHK PC 镀铝 PC aluminum plating



Intensity data:(deg , cd) CO-180

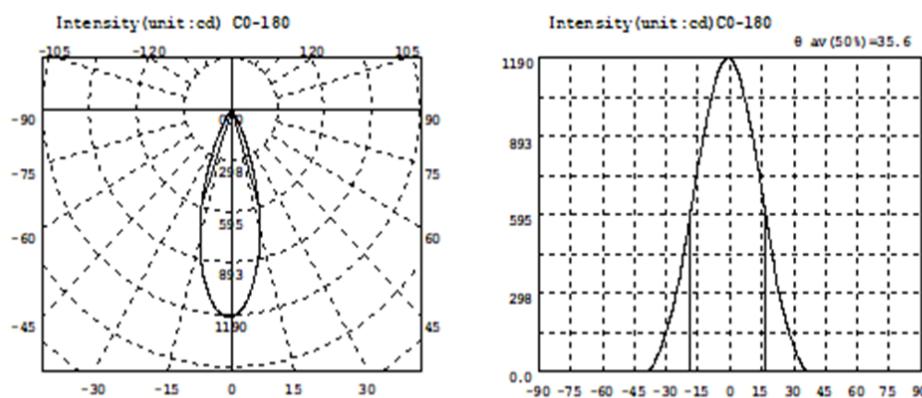
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.2712	-58.5	0.4293	-27.0	177.2	4.5	1538	36.0	5.975	67.5	0.3657
-88.5	0.2828	-57.0	0.4331	-25.5	208.1	6.0	1413	37.5	1.269	69.0	0.3570
-87.0	0.3056	-55.5	0.4558	-24.0	244.8	7.5	1268	39.0	0.8860	70.5	0.3503
-85.5	0.3166	-54.0	0.4858	-22.5	287.7	9.0	1113	40.5	0.7878	72.0	0.3411
-84.0	0.3277	-52.5	0.5063	-21.0	336.1	10.5	961.7	42.0	0.7083	73.5	0.3338
-82.5	0.3368	-51.0	0.5514	-19.5	391.9	12.0	820.9	43.5	0.6514	75.0	0.3316
-81.0	0.3497	-49.5	0.5649	-18.0	456.6	13.5	692.9	45.0	0.5908	76.5	0.3390
-79.5	0.3598	-48.0	0.6167	-16.5	533.4	15.0	585.0	46.5	0.5608	78.0	0.3485
-78.0	0.3496	-46.5	0.6641	-15.0	628.0	16.5	497.1	48.0	0.5345	79.5	0.3373
-76.5	0.3390	-45.0	0.7257	-13.5	742.4	18.0	426.3	49.5	0.5084	81.0	0.3422
-75.0	0.3398	-43.5	0.8075	-12.0	874.7	19.5	363.9	51.0	0.4886	82.5	0.3344
-73.5	0.3305	-42.0	0.8922	-10.5	1025	21.0	304.3	52.5	0.4939	84.0	0.3332
-72.0	0.3410	-40.5	1.011	-9.0	1182	22.5	259.7	54.0	0.4795	85.5	0.3164
-70.5	0.3514	-39.0	1.317	-7.5	1337	24.0	221.2	55.5	0.4385	87.0	0.2950
-69.0	0.3627	-37.5	4.455	-6.0	1473	25.5	185.5	57.0	0.4240	88.5	0.2961
-67.5	0.3729	-36.0	15.67	-4.5	1589	27.0	151.7	58.5	0.4041	90.0	0.3153
-66.0	0.3814	-34.5	33.76	-3.0	1673	28.5	119.8	60.0	0.3898		
-64.5	0.3926	-33.0	56.60	-1.5	1719	30.0	90.21	61.5	0.3783		
-63.0	0.3924	-31.5	82.90	0.0	1733	31.5	62.80	63.0	0.3815		
-61.5	0.3761	-30.0	112.0	1.5	1701	33.0	38.66	64.5	0.3703		
-60.0	0.4067	-28.5	144.0	3.0	1638	34.5	19.20	66.0	0.3743		

Electricity Parameter:

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

Optical Parameter (Distance=2.410m) :

Equivalent Luminous flux: Φ_{eff} = 417.31m Efficiency: Eff=124.29lm/W
 Diffuse angle: $\theta(25\%)$: 36.3deg $\theta(50\%)$: 23.4deg $\theta(75\%)$: 14.9deg $\theta(50\%)$: 23.4deg
 Diffuse angle: $\theta(25\%)$: 36.3deg $\theta(50\%)$: 23.4deg $\theta(75\%)$: 14.9deg $\theta(50\%)$: 23.4deg
 $I_{max}=1733cd$ (C=0.0deg, G=0.0deg) CO-180Plane $I_{max}= 1733cd$ (G=0.0deg)
 CO-180Plane $I_0= 1733cd$



Intensity data:(deg , cd) CO-180

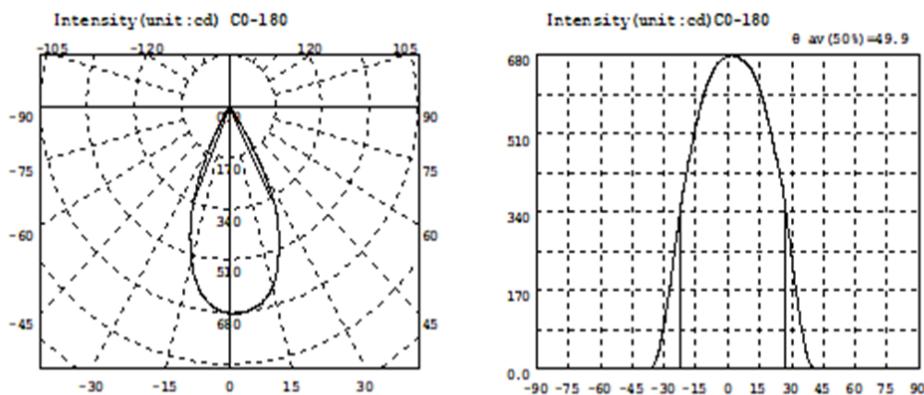
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.5223	-58.5	0.5712	-27.0	239.5	4.5	1119	36.0	6.178	67.5	0.4184
-88.5	0.4960	-57.0	0.5860	-25.5	290.1	6.0	1073	37.5	2.538	69.0	0.4256
-87.0	0.3816	-55.5	0.6220	-24.0	345.2	7.5	1017	39.0	2.031	70.5	0.3999
-85.5	0.3686	-54.0	0.6578	-22.5	410.4	9.0	962.1	40.5	1.852	72.0	0.4307
-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: ϕ_{eff} = 455.11lm Efficiency: Eff=135.531m/W
 Diffuse angle: $\theta(25\%)$: 48.3deg $\theta(50\%)$: 35.6deg $\theta(75\%)$: 23.1deg $\theta(50\%)$: 35.6deg
 Diffuse angle: $\theta(25\%)$: 48.4deg $\theta(50\%)$: 35.6deg $\theta(75\%)$: 23.1deg $\theta(50\%)$: 35.6deg
 $I_{max}=1190\text{cd}$ ($C=0.0\text{deg}$, $G=-1.0\text{deg}$) CO-180Plane $I_{max}= 1190\text{cd}$ ($G=-1.0\text{deg}$)
 CO-180Plane $I_0= 1188\text{cd}$



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:

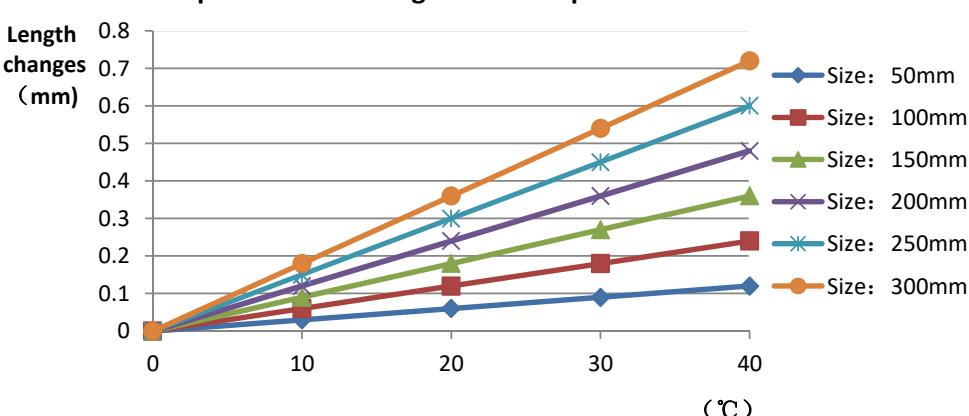
Current I: 0.1000A Power: 3.598W

Voltage V: 36.00V PF: 1.000

Optical Parameter (Distance=2.410m) :Equivalent Luminous flux: ϕ_{eff} = 405.81m Efficiency: Eff=112.80lm/WDiffuse angle: $\theta(25\%)$: 59.6deg $\theta(50\%)$: 49.9deg $\theta(75\%)$: 36.1deg $\theta(50\%)$: 49.9degDiffuse angle: $\theta(25\%)$: 59.6deg $\theta(50\%)$: 49.9deg $\theta(75\%)$: 36.1deg $\theta(50\%)$: 49.9deg

Imax=679.0cd (C=0.0deg, G=1.5deg) C0-180Plane Imax= 679.0cd (G=1.5deg)

C0-180Plane I0= 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 Test environment: In 20 °C -25 °C environment to achieve thermal									
		50			50.05	49.95	49.92	49.95	49.95	49.91	49.93	49.96											
		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			OK										
				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:		PC product size changes with temperature table 																					
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																							

Precautions:

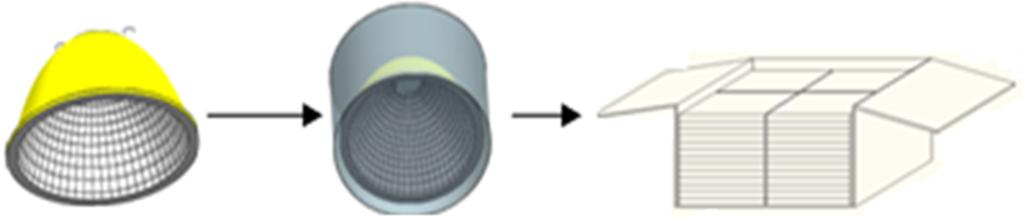
1. Please wear clean gloves during the lens assembly process to prevent the lens surface from being contaminated.
2. Try to avoid touching the total reflection surface when taking the lens.
3. The lens surface is contaminated. Only use a soft cotton cloth dipped in analytically pure neutral solvent to wipe gently. Do not wipe with industrial solvents (alcohol, isopropanol, acetone, ether, toluene, xylene, carbon tetrachloride, MMA Body, etc.).
4. The working temperature of the lens should be within the temperature resistance limit of the lens material. Exceeding the temperature resistance limit will cause the lens to crack or melt and affect the service life of the lens. It is recommended that the upper surface temperature of the LED colloid should be less than 120 degrees.

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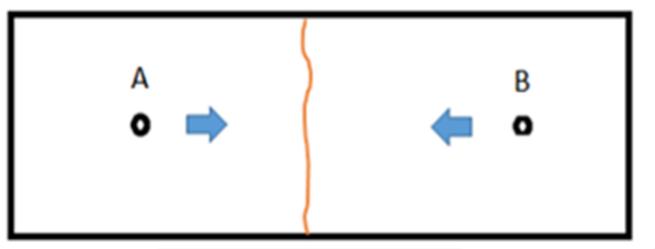
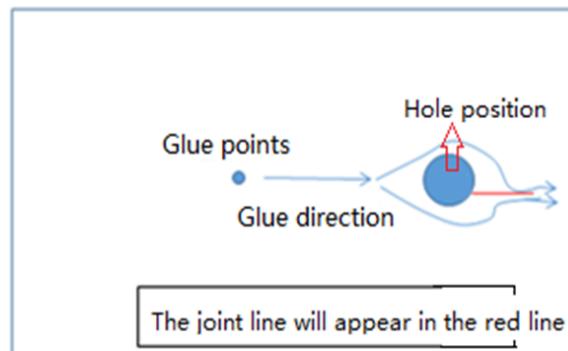
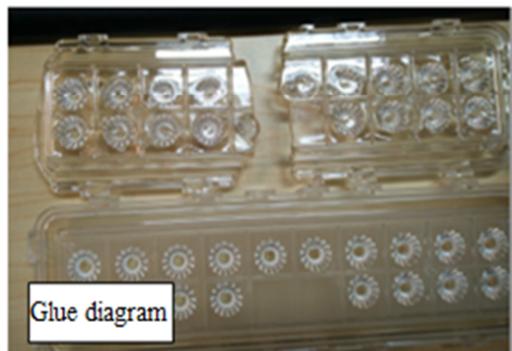
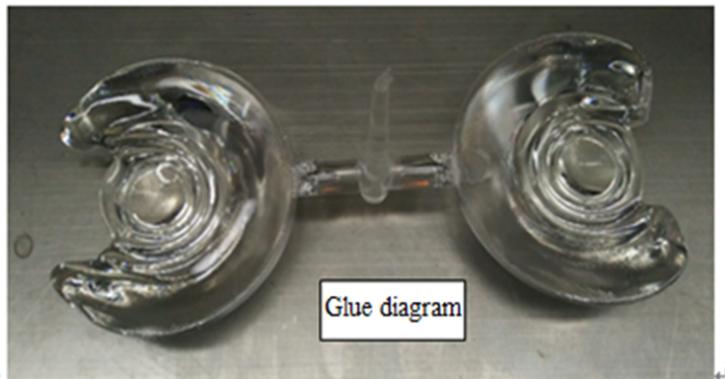
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PN	HK-GY-50@36-24-D12-2#-1g-1		Product Name	HK V 50@36-24 Degree reflective cup					
Product material	PC aluminum plating								
Package diagram									
Product packing	45	PCS/BAG	180	BAG/LAYER					
	4	Layer/Box	720	Piece/Box					
Packaging Materials	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:

synthetic



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	<p>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.</p> <p>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;</p>	Sample comparison, visual			✓

	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		✓	