



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

Approval number :

Customer :

Product : HK 3°Lens

Material Code : 1.01.71272

PN : HK-50@18-3-3535-20-1g-1

Manufacturer : Chengdu HercuLux Photoelectric Technology Co.,Ltd



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

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

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*Approval In duplicate , for both supplier and customer.



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Date updated: 2020/6/5

Product Picture:



PN:

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Size(L*W*H/ Φ *H):

Φ :50mm*H:17.8mm

Material:

PC

Effiency:

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Temperature(Topr):

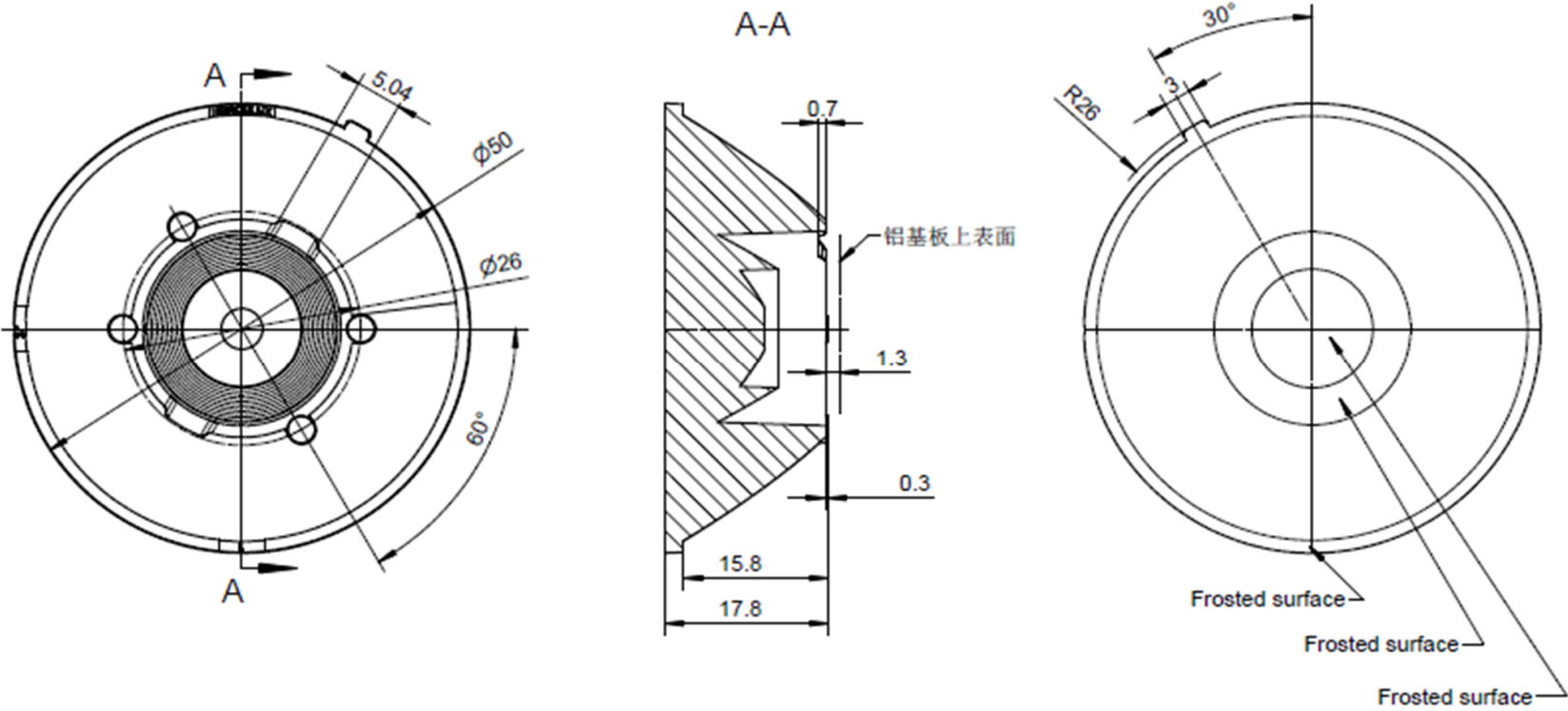
-40°C to +120°C

FWHM:

3°

Matched LES:

XPE /XHP35

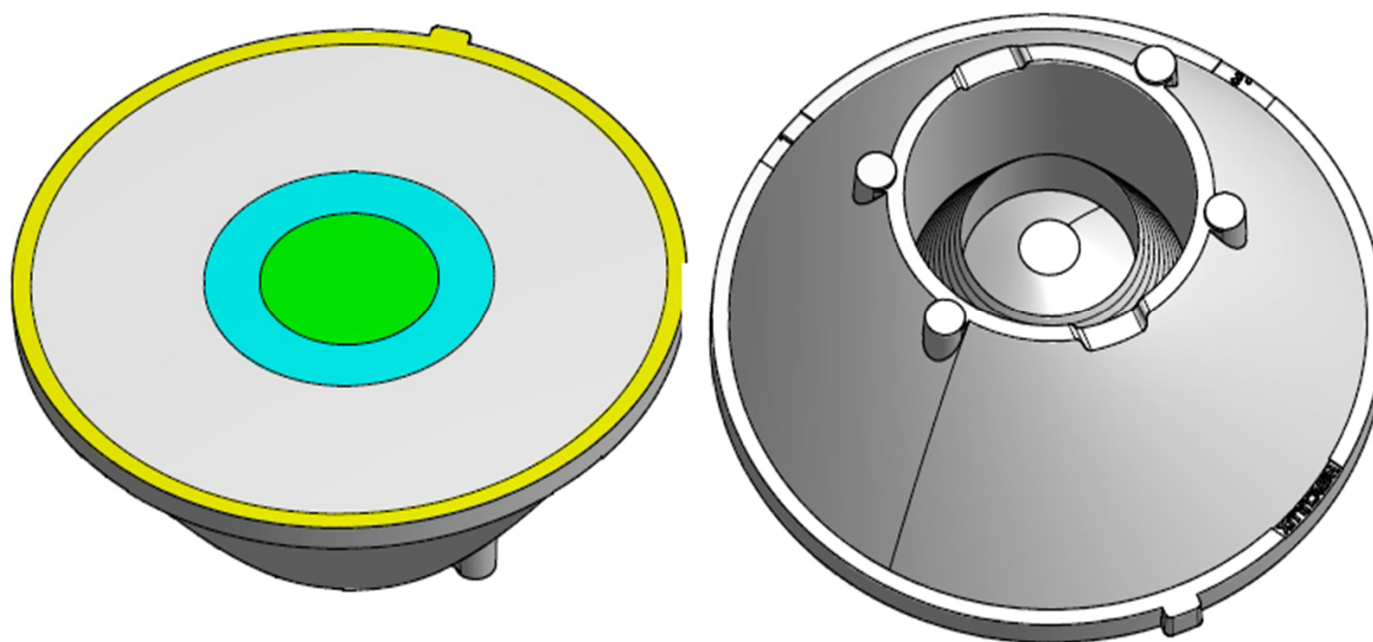


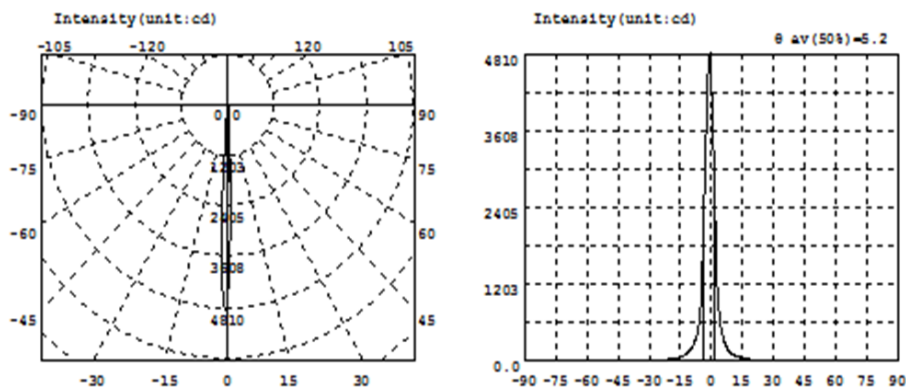
Technical remark:

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 3°Lens		HK-50@18-3-3535-20-1g-1		
Structure design					1.01.71272		
Review					umber of drawin	qty	weight
Validation				Material:	PC	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		





Intensity data: (deg , cd) C0-180

A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.2486	-58.5	1.801	-27.0	12.28	4.5	542.9	36.0	4.415	67.5	1.202
-88.5	0.2487	-57.0	1.886	-25.5	14.82	6.0	320.4	37.5	3.992	69.0	1.132
-87.0	0.2826	-55.5	1.987	-24.0	17.93	7.5	201.8	39.0	3.666	70.5	1.048
-85.5	0.3623	-54.0	2.120	-22.5	22.02	9.0	139.5	40.5	3.424	72.0	0.9689
-84.0	0.4526	-52.5	2.380	-21.0	27.33	10.5	102.4	42.0	3.175	73.5	0.8946
-82.5	0.5214	-51.0	2.539	-19.5	34.03	12.0	78.11	43.5	2.967	75.0	0.7987
-81.0	0.6219	-49.5	2.695	-18.0	42.68	13.5	60.90	45.0	2.793	76.5	0.7287
-79.5	0.6910	-48.0	2.784	-16.5	54.10	15.0	48.05	46.5	2.796	78.0	0.6571
-78.0	0.7816	-46.5	2.878	-15.0	68.35	16.5	38.01	48.0	2.804	79.5	0.5621
-76.5	0.8602	-45.0	3.161	-13.5	88.38	18.0	30.46	49.5	2.511	81.0	0.5020
-75.0	0.9621	-43.5	3.413	-12.0	117.4	19.5	24.46	51.0	2.211	82.5	0.4309
-73.5	1.043	-42.0	3.724	-10.5	162.6	21.0	19.91	52.5	2.001	84.0	0.3349
-72.0	1.131	-40.5	4.095	-9.0	234.4	22.5	16.37	54.0	1.828	85.5	0.2639
-70.5	1.210	-39.0	4.511	-7.5	357.0	24.0	13.47	55.5	1.731	87.0	0.2573
-69.0	1.281	-37.5	5.001	-6.0	605.8	25.5	11.11	57.0	1.655	88.5	0.2486
-67.5	1.382	-36.0	5.571	-4.5	1389	27.0	9.274	58.5	1.584	90.0	0.2271
-66.0	1.448	-34.5	6.231	-3.0	3132	28.5	8.179	60.0	1.528		
-64.5	1.518	-33.0	7.055	-1.5	4596	30.0	7.192	61.5	1.454		
-63.0	1.596	-31.5	7.966	0.0	4386	31.5	6.227	63.0	1.394		
-61.5	1.662	-30.0	8.860	1.5	2581	33.0	5.516	64.5	1.347		
-60.0	1.712	-28.5	10.34	3.0	1028	34.5	4.915	66.0	1.270		

Electricity Parameter:

Current I:	0.2000A	Power:	3.250W
Voltage V:	32.50V	PF:	1.000

Optical Parameter(Distance=2.410m) :

Equivalent Luminous flux: $\Phi_{\text{eff}} = 101.5 \text{ lm}$ Efficiency: $\text{Eff} = 31.26 \text{ lm/W}$

Diffuse angle: @ (25%): 7.4deg @ (50%): 5.2deg @ (75%): 3.2deg @ (50%): 5.2deg

Diffuse angle: @ (25%): 7.6deg @ (50%): 5.4deg @ (75%): 3.7deg @ (50%): 5.4deg

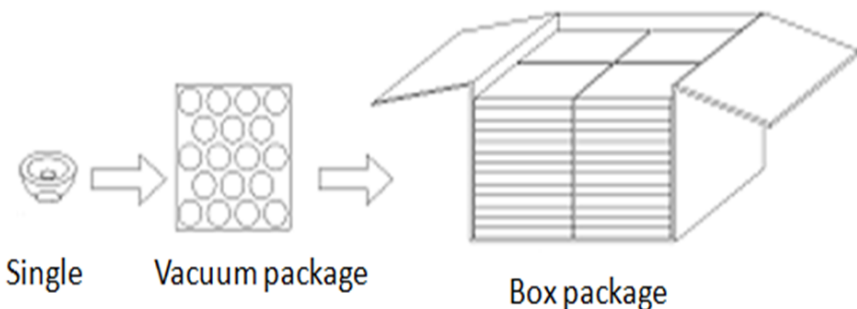
$I_{\max}=4803\text{cd}$ ($C=0.0\text{deg}$, $G=-1.0\text{deg}$)

C0-180Plane I_{max}= 4803cd (G=-1.0deg)

C0-180Plane I0= 4386cd

		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
1.Size	diameter	50			49.83	49.88	49.88	49.89		Test environment: In 20 ℃ -25 ℃ environment to achieve thermal equilibrium after the test.
	thickness	2			2.03	2.02	2.03	2.03		
	height	17.8			17.86	17.88	17.85	17.87		
	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				Color	Transparent		OK	
4.Optical index	Testing LED		cree xhp35							
	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									
	FWHM		See light distribution curve							
	angle (XHP35)			5.2	5	5	4.8			
	K-value (XHP35)			47.32	53.02	53.62	55.61			
Facula		See the signature sample								
Comprehensive judgment		Qualified								
Remarks:		PC product size changes with temperature table Length changes (mm) <								

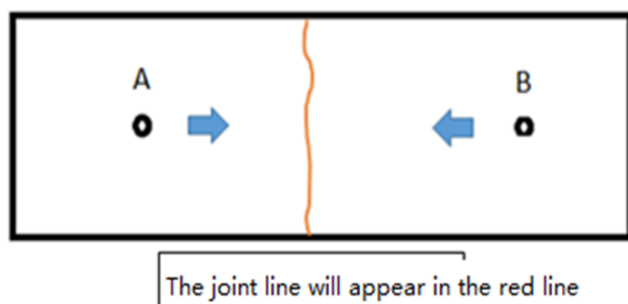
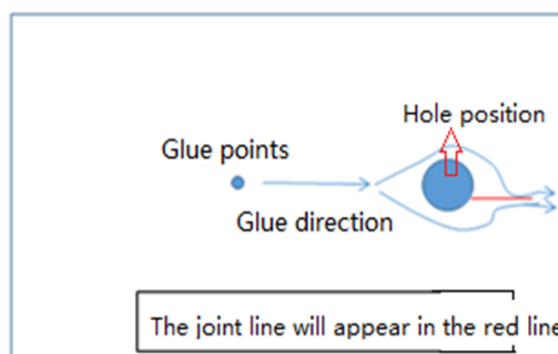
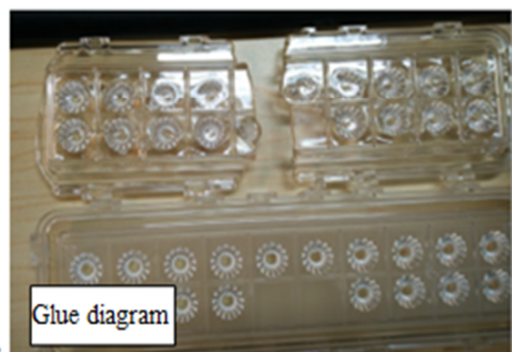
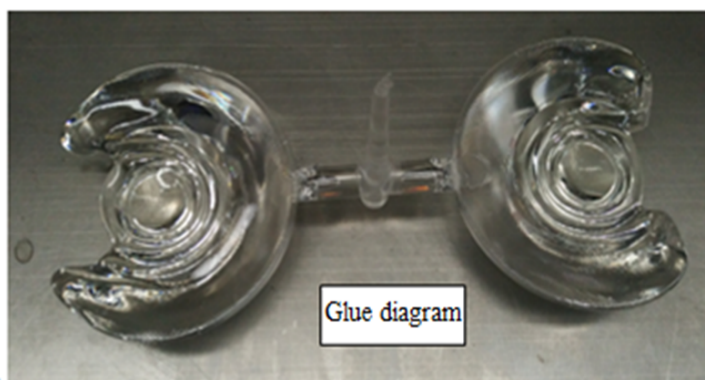


PN		HK-50@18-3-3535-20-1g-1		Product Name		HK 3°Lens	
Product material		PC		Customer			
Package diagram		 Single Vacuum package Box package					
Product packing		10	A/ Box	4	Box/Layer		
		11	Layer/Box	440	A/ Carton		
Packaging Materials	NO.	Part No	Part name	Size	Dosage	Unit	Remarks
	1	2.07.0081	Blister 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	2.06.0001	big carton	46.8cm*42.8cm*36cm	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

1.1.1 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		√	