



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

Approval number :

Customer :

Product : HK 30°-56in 1 Lens

Material Code : 1.01.81428

PN : HK-260@09-30-3030-20-1g-56

Synthetic information: 1.07.81402_HK-257@02-0221-S

Manufacturer : Chengdu HercuLux Photoelectric Technology Co.,Ltd



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

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

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*Approval In duplicate , for both supplier and customer.



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Date updated: 2018/10/31

Product Picture:



PN:

HK-260@09-30-3030-20-1g-56

Size(L*W*H/Φ*H):

L : 259.98mm*W:69.98mm*H:9mm

Material:

PC

Effiency:

\

Temperature(Topr):

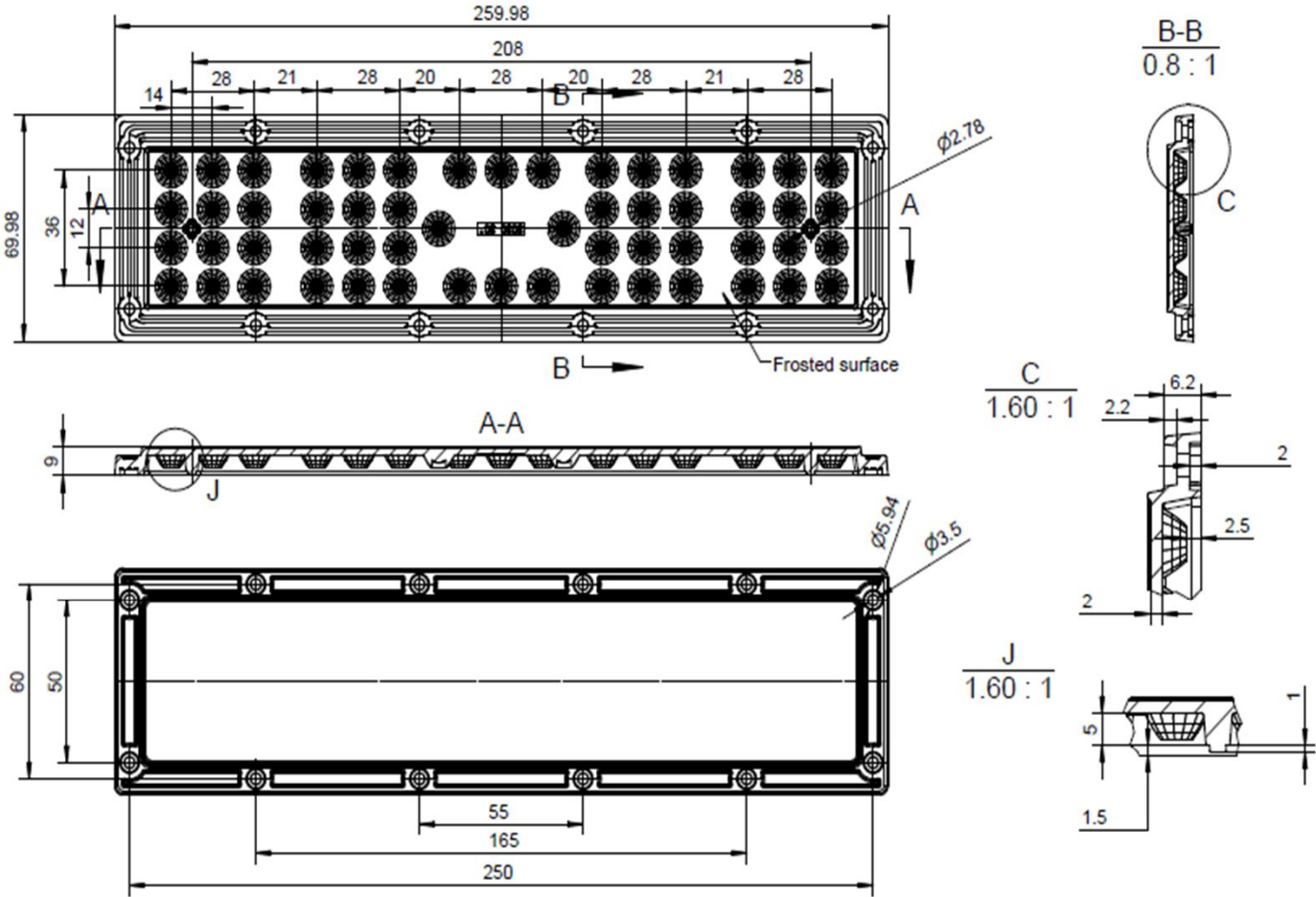
-40°C to +120°C

FWHM:

30°

Matched LES:

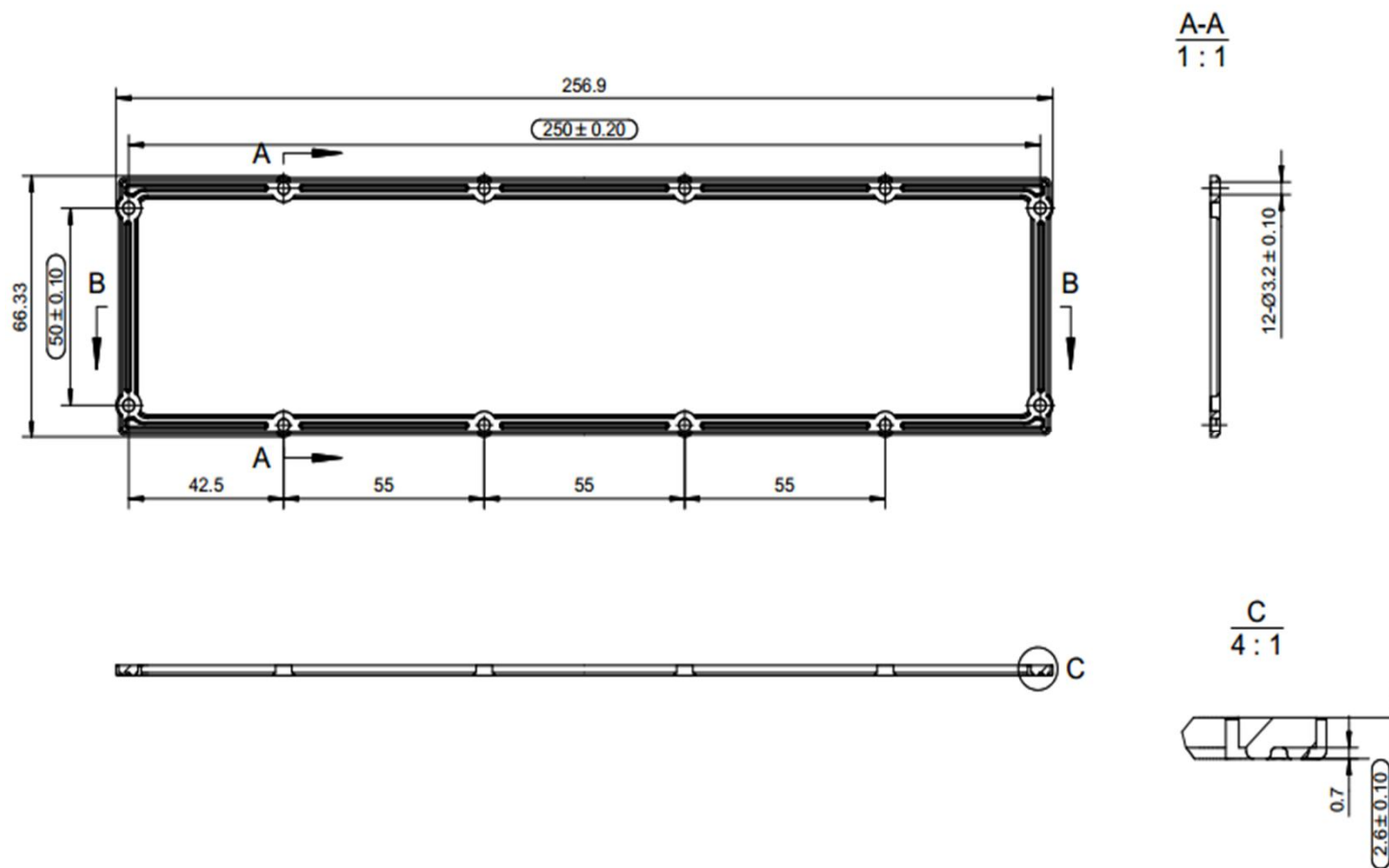
Lumileds 3030

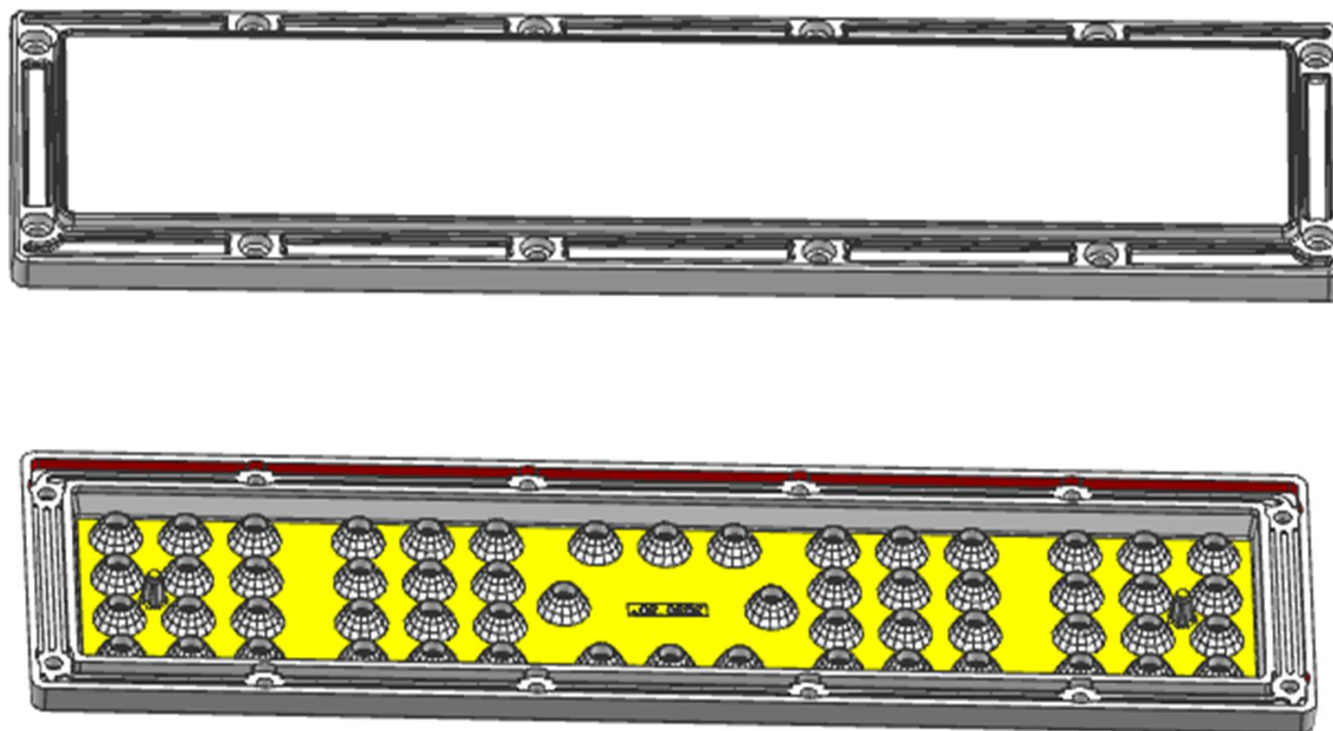


Technical Requirement:

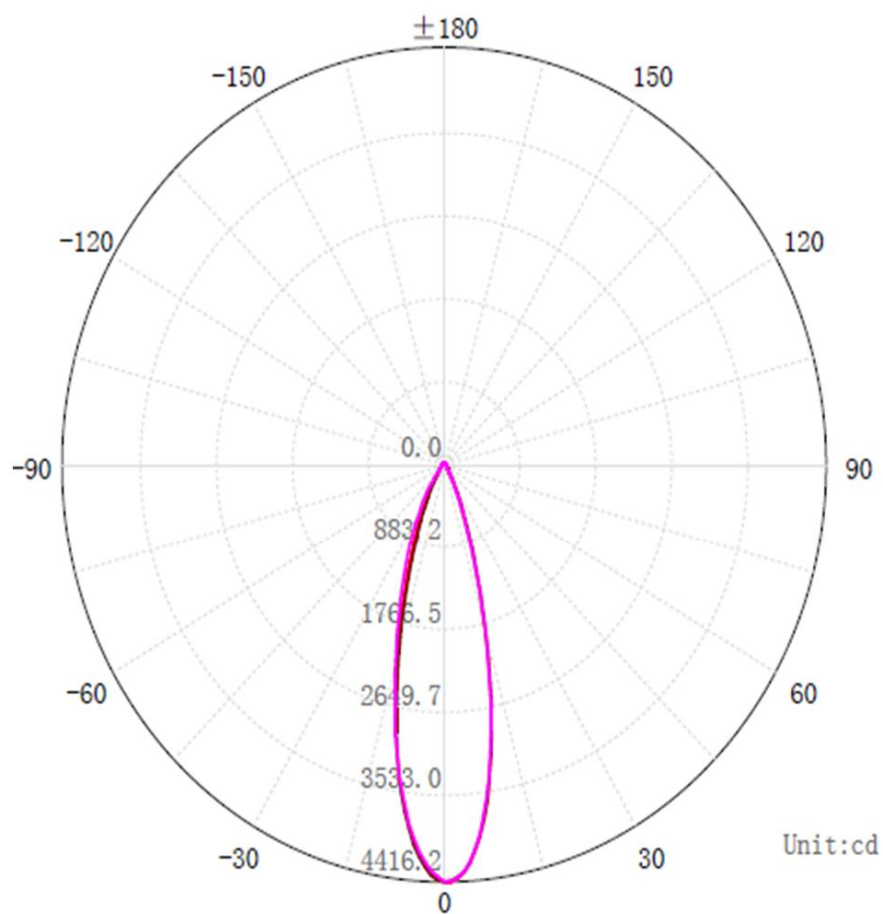
1. The surface don't have any defects of flash, shrink and bubble.
2. The uncharted fillet and pattern draft subject to the 3D drawing.
3. The uncharted dimensional tolerance subject to the 3D drawing.

Optical Design			HK 30° -56in 1 Lens	HK-260@09-30-3030-20-1g-56		1. 01. 81428
Structure Design				Pages	Qty	Weight
Assess				2		
Authorized			Material:	PC	CDHK	



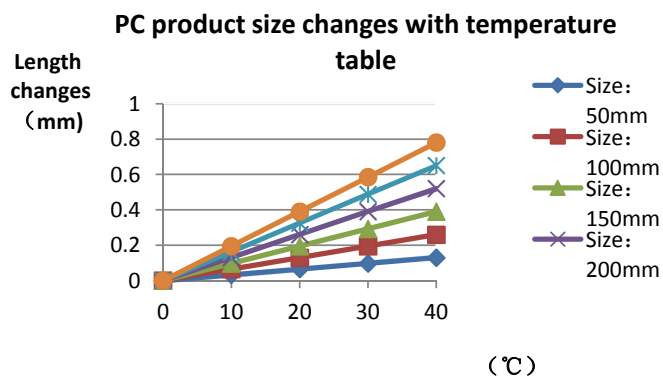


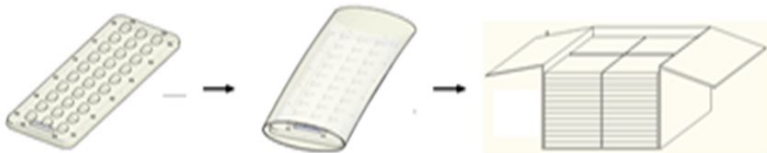
C Plane Distribution Diagram



C Plane	[50%MaxAng.]	[10%MaxAng.]
— C30.0_210.0 :	27.8	53.3
— C0.0_180.0 :	27.6	52.4
— C90.0_270.0 :	28.2	56.5

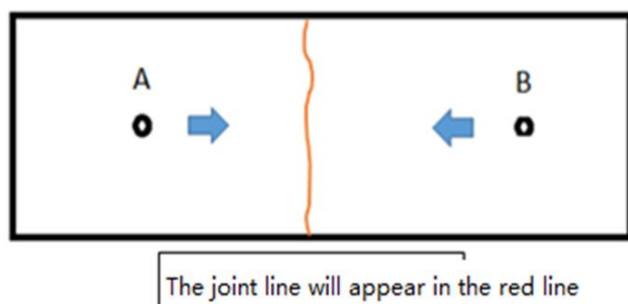
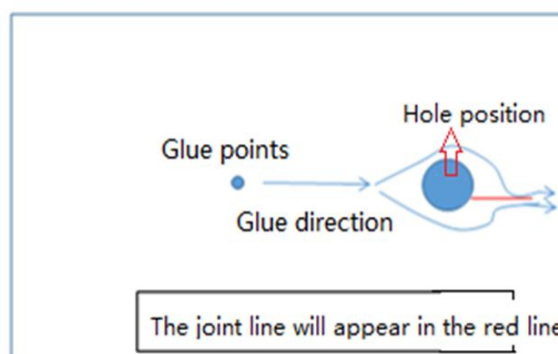
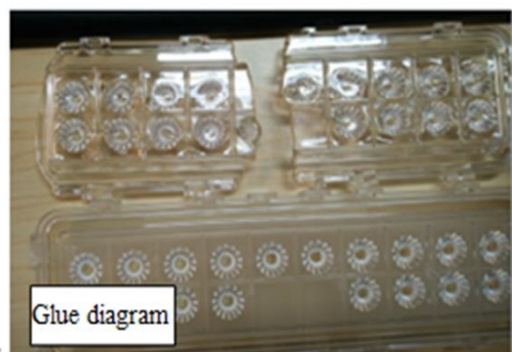
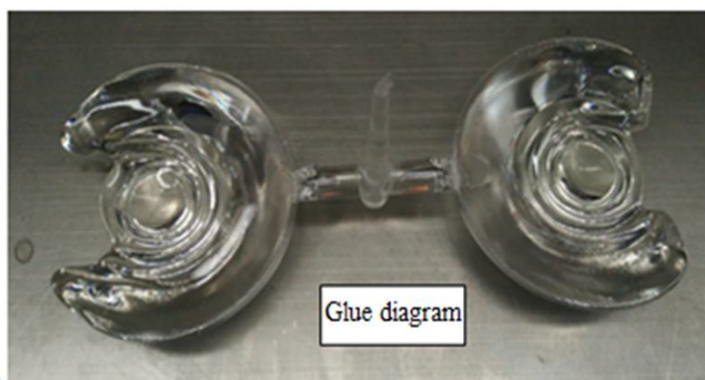
1.Size		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
	Post diameter	2.78	2.9	2.7	2.78	2.79				Test environment: In 20 ℃ -25 ℃ environment to achieve thermal equilibrium after the test.
	Positioning column spacing	208	208.4	208	208.22	208.21				
	The thickness of the	2.2	2.35	2.1	2.24	2.23				
	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		Lumileds 3030							
	FWHM		See light distribution curve							
	angle						27.6			
	K-value									
	Efficiency									
	Facula		See the signature sample							
Comprehensive judgment		Qualified								
Remarks:			PC product size changes with temperature table Length changes (mm) <							



PN		HK-260@09-30-3030-20-1g-56		Product Name		HK 30°-56in 1 Lens	
Product material		PC		Customer			
Package diagram							
Product packing		2	PCS/BAG		BAG/LAYER		
			Layer/Box		Piece/Box		
Packaging Materials	NO.	Material Code	Item name	Specification	Single box usage	Unit	Remarks
	1	—	Plastic bags	—		BAG	
	2	2.06.0005	Box label	6. 2cm*7. 6cm		PCS	
	3	2.06.0007	Partition	39*29cm		PCS	
	4	2.06.00012	Carton	40*30*26cm		PCS	
Remarks	The loose packing is not subject to this specification. Customer's requirements shall prevail (There are three layers of 24 bags for each layer and 5 bags for the top layer)						

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:



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;				

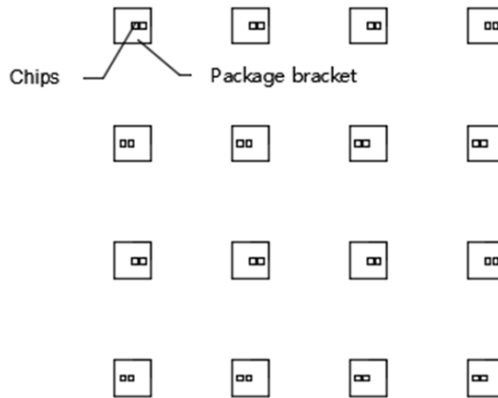
	2: The limited sample refers to the limit of a particular exceptionally developed sample. Limit the sample only for its specific point of exception to confirm; The priority is higher than the other criteria in this table. When there is a limited sample, the limit sample shall prevail.				
Raw edge	Not 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		√	

Description on the arrangement of light source suitable for SMD 3030 light source and body lens:

The chip position of most SMD 3030 light source packages in the market is not in the middle position. When fitting the body lens, it will affect the light distribution of the lens and cause the optical shape to shift. Therefore, when the light source plate is designed and arranged, the eccentric direction of the chip is arranged symmetrically, which can effectively reduce its influence on the light distribution. Sample layout proposal:

Example 1: as shown in the figure below, 16 chips in rows 1 and 3 are eccentric to the right, while those in rows 2 and 4 are eccentric to the left.



Example 2: as shown in the figure below, 16 chips in the first and second columns are eccentric to the right, while those in the third and fourth columns are eccentric to the left.

