



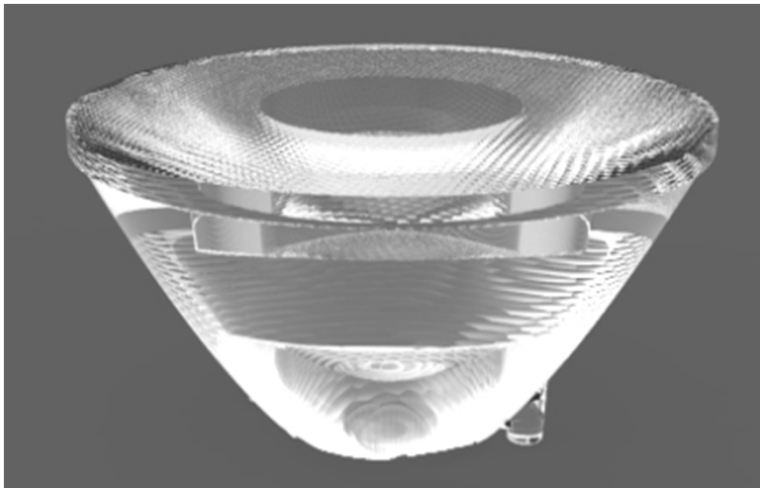
HERCULUX Chengdu HercuLux Photoelectric
 恒坤光电 Technology Co.,Ltd
Product Approval

Approval number :

Customer :

PN	Code	Product
HK-50@24-15-D9-01-1g-1	1. 01. 71114	HK 50@24-15° Lens
HK-50@24-24-D9-01-1g-1	1. 01. 71263	HK 50@24-24° Lens
HK-50@24-36-D9-01-1g-1	1. 01. 71264	HK 50@24-36° Lens
HK-50@24-50-D9-22-1g-1	1. 01. 81616	HK 50@24-50° Lens

Manufacturer : Chengdu HercuLux Photoelectric Technology Co.,Ltd



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

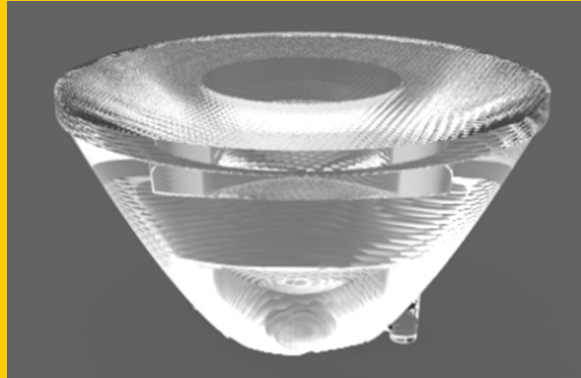
TEL: 0755-2937 1541

FAX: 0755-2907 5140

www.hkoptics.com

Date updated: 2020/5/29

Product Picture:



PN:

HK-50@24-15-D9-01-1g-1

Size(L*W*H/ Φ *H):

Φ :50mm; H:24mm

Material:

PC

Efficiency:

\

Temperature(Topr):

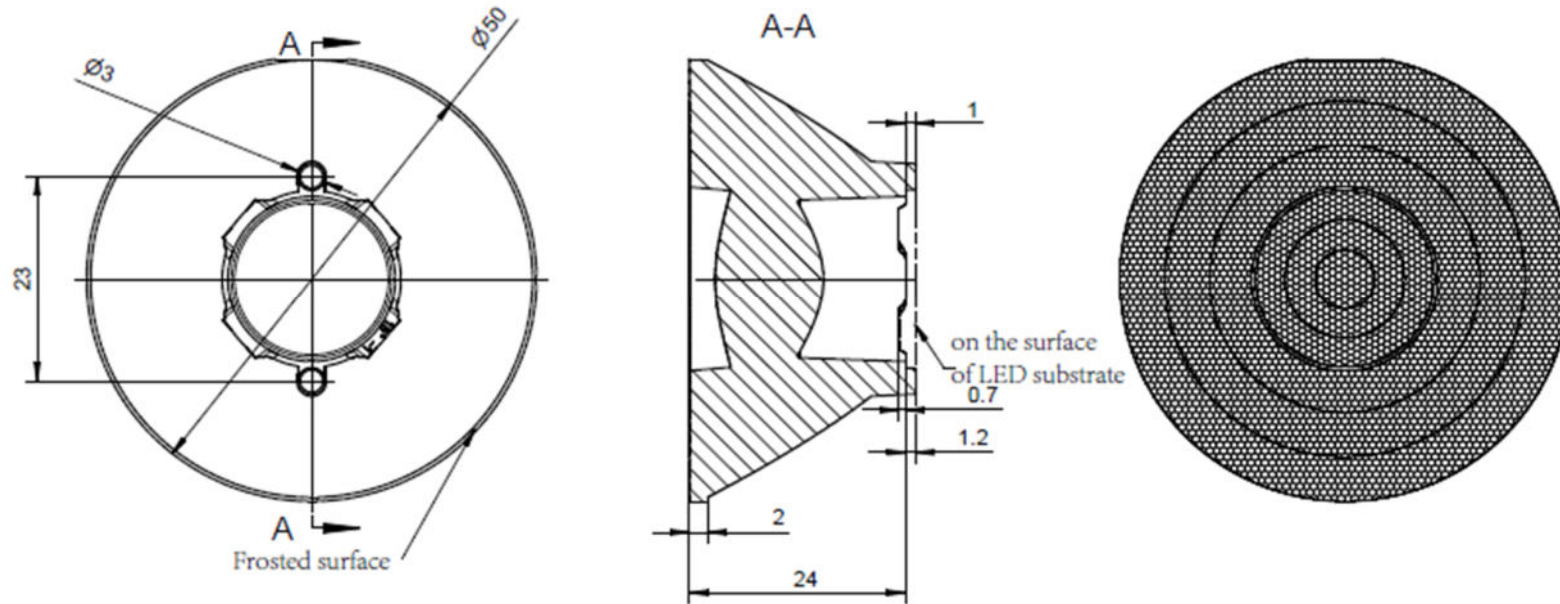
-40°C to +120°C

FWHM:

15°/24°/36°/50°

Matched LES:

D9

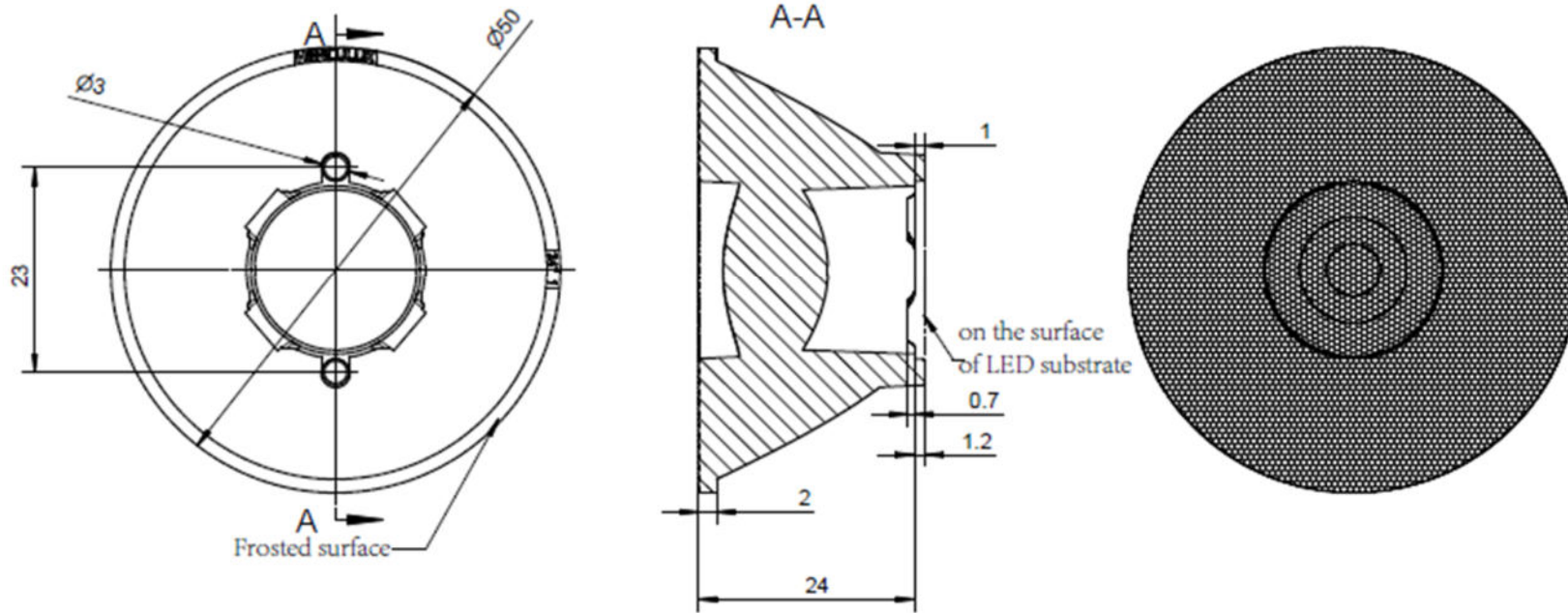


Technical remark:

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 50@24-15°Lens		HK-50@24-15-D9-01-1g-1		
Structure design			HK 50@24-15°Lens		1.01.71114		
Review					Number of drawing	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	

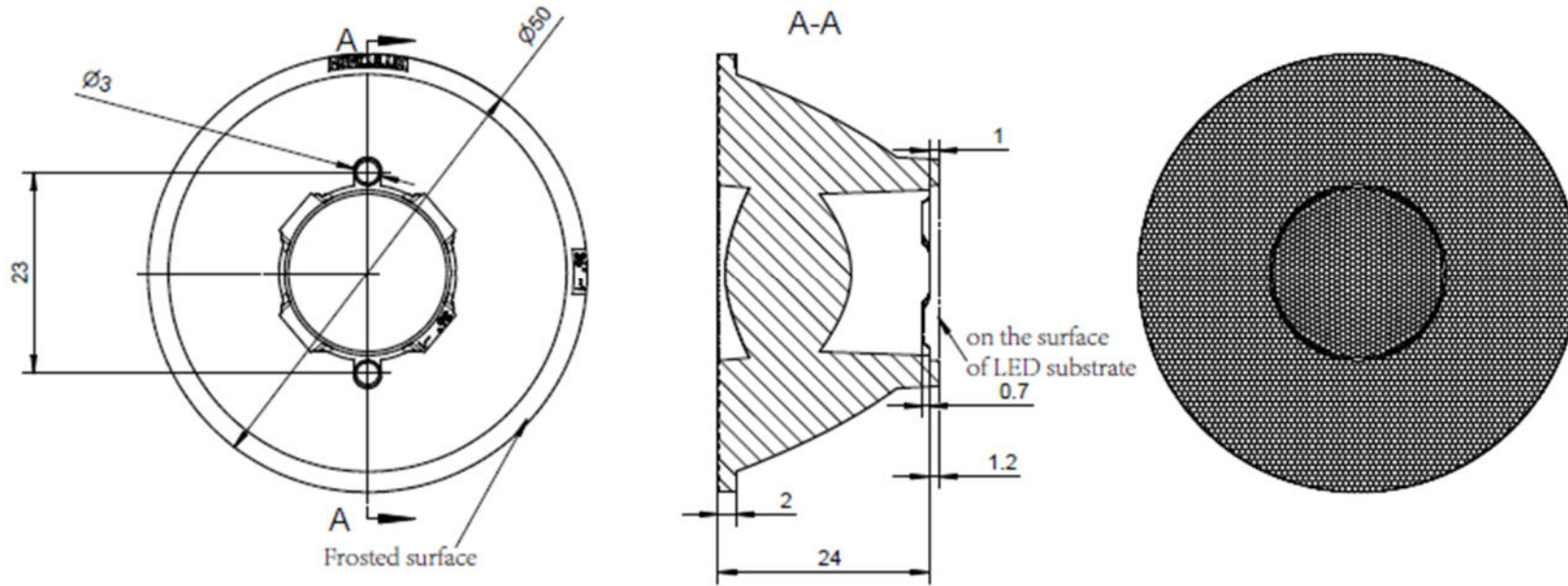


Technical remark:

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 50@24-24°Lens		HK-50@24-24-D9-01-1g-1		
Structure design			HK 50@24-24°Lens		1.01.71263		
Review					Number of drawing	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 value	±0.1	±0.15	±0.35	±0.50	±0.80	±1.2	±2.0	

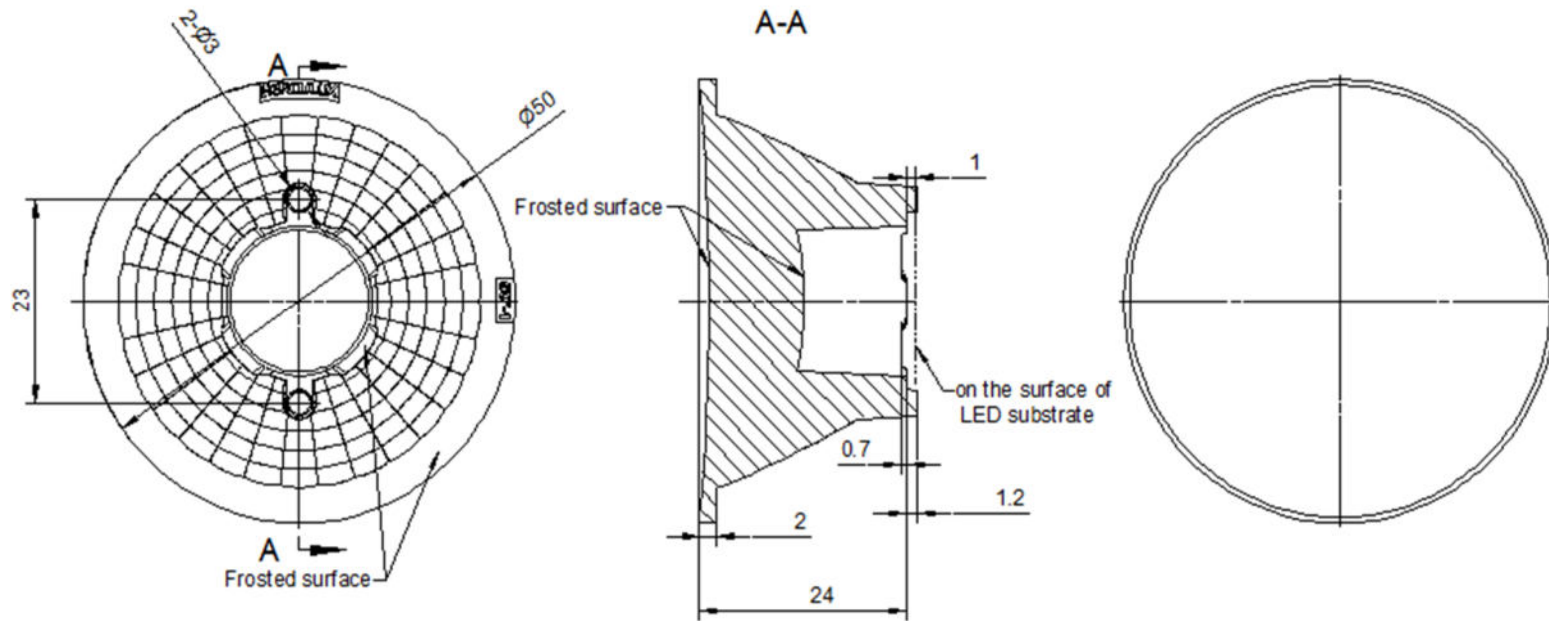


Technical remark:

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			HK 50@24-36°Lens		HK-50@24-36-D9-01-1g-1		
Structure design					1.01.71264		
Review					Number of drawing	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 value	±0.1	±0.15	±0.35	±0.50	±0.80	±1.2	±2.0	

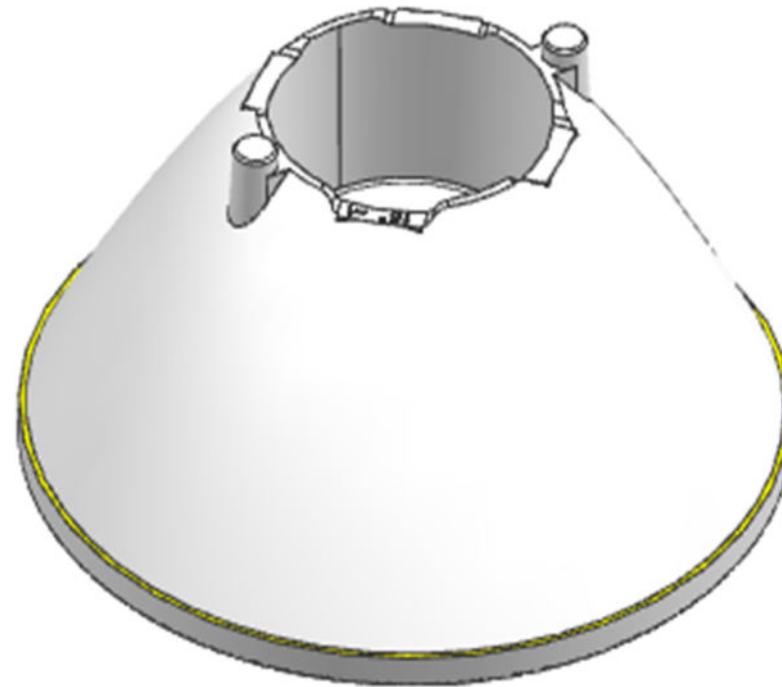
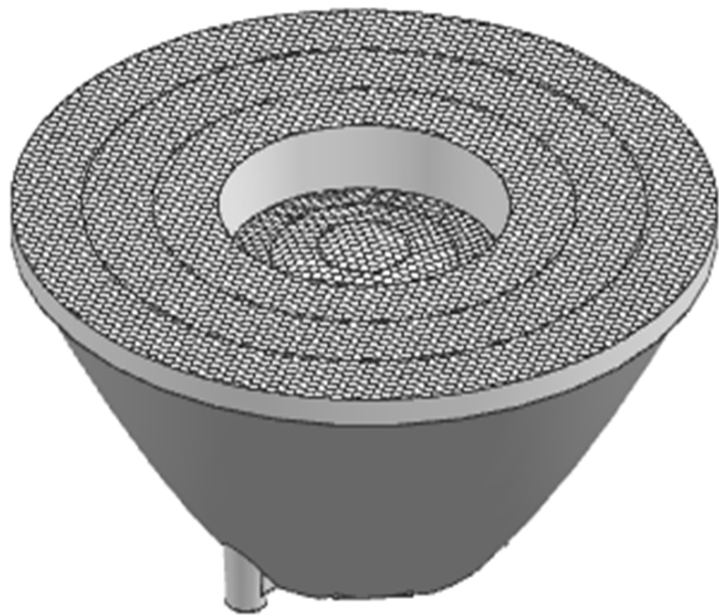


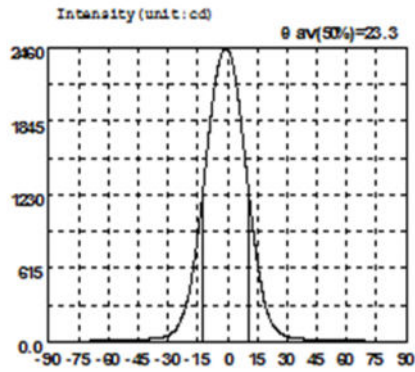
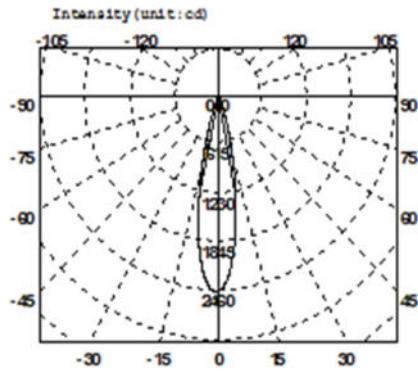
Technical remark:

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			HK 50@24-50°Lens		HK-50@24-50-D9-22-1g-1		
Structure design			HK 50@24-50°Lens		1.01.81616		
Review					number of drawing	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 value	±0.1	±0.15	±0.35	±0.50	±0.80	±1.2	±2.0	





Intensity data: (deg , cd) CO-180

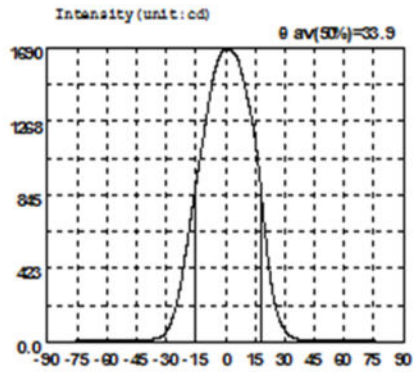
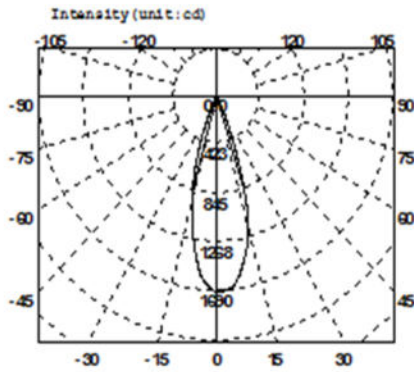
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.6369	-58.5	9.594	-27.0	85.42	4.5	2149	36.0	25.12	67.5	5.310
-88.5	0.8160	-57.0	10.29	-25.5	114.6	6.0	1960	37.5	22.60	69.0	4.545
-87.0	1.032	-55.5	11.02	-24.0	157.7	7.5	1738	39.0	20.67	70.5	4.009
-85.5	1.173	-54.0	11.76	-22.5	216.2	9.0	1503	40.5	19.11	72.0	3.567
-84.0	1.337	-52.5	12.50	-21.0	293.8	10.5	1272	42.0	17.83	73.5	3.159
-82.5	1.479	-51.0	13.22	-19.5	399.4	12.0	1054	43.5	16.72	75.0	2.807
-81.0	1.645	-49.5	13.92	-18.0	530.6	13.5	850.1	45.0	15.68	76.5	2.475
-79.5	1.813	-48.0	14.74	-16.5	692.3	15.0	668.9	46.5	14.77	78.0	2.266
-78.0	2.042	-46.5	15.54	-15.0	879.8	16.5	514.5	48.0	13.99	79.5	2.051
-76.5	2.325	-45.0	16.52	-13.5	1089	18.0	378.0	49.5	13.25	81.0	1.856
-75.0	2.659	-43.5	17.49	-12.0	1314	19.5	275.9	51.0	12.58	82.5	1.615
-73.5	3.020	-42.0	18.67	-10.5	1554	21.0	202.1	52.5	11.90	84.0	1.411
-72.0	3.452	-40.5	20.05	-9.0	1787	22.5	148.5	54.0	11.24	85.5	1.219
-70.5	3.938	-39.0	21.85	-7.5	2001	24.0	110.8	55.5	10.55	87.0	1.014
-69.0	4.535	-37.5	24.18	-6.0	2179	25.5	84.24	57.0	9.900	88.5	0.7382
-67.5	5.318	-36.0	27.22	-4.5	2316	27.0	66.07	58.5	9.300	90.0	0.6764
-66.0	6.132	-34.5	31.07	-3.0	2406	28.5	53.19	60.0	8.674		
-64.5	6.868	-33.0	36.13	-1.5	2448	30.0	44.04	61.5	8.055		
-63.0	7.559	-31.5	42.96	0.0	2446	31.5	37.20	63.0	7.481		
-61.5	8.263	-30.0	52.36	1.5	2396	33.0	32.13	64.5	6.864		
-60.0	8.922	-28.5	65.87	3.0	2296	34.5	28.22	66.0	6.129		

Electricity Parameter:

Current I: 0.1000A Power: 3.340W
 Voltage V: 34.40V PF: 1.000

Optical Parameter(Distance=2.559m):

Equivalent Luminous flux: Φ_{eff} = 507.8lm Efficiency: Eff=152.05lm/W
 Diffuse angle: θ (25%): 32.6deg θ (50%): 23.3deg θ (75%): 15.4deg θ (50%): 23.3deg
 Diffuse angle: θ (25%): 32.7deg θ (50%): 23.3deg θ (75%): 15.4deg θ (50%): 23.3deg
 I_{max}=2452cd (C=0.0deg, G=-1.0deg) CO-180Plane I_{max}= 2452cd(C=-1.0deg)
 CO-180Plane I₀= 2446cd



Intensity data: (deg , cd) CO-180

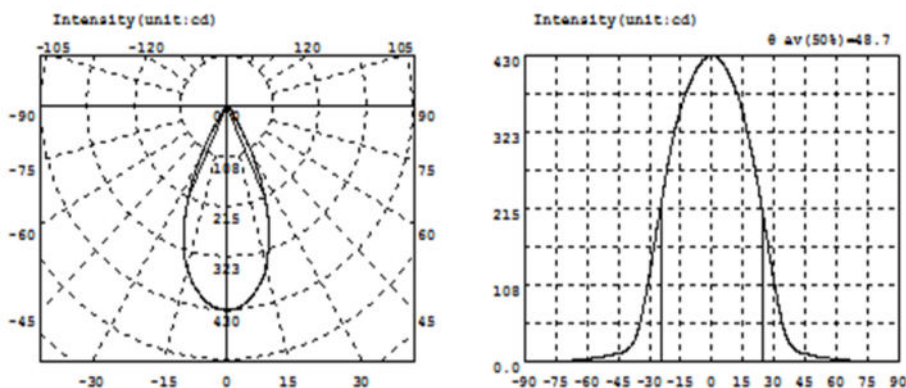
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.6779	-58.5	7.682	-27.0	127.7	4.5	1660	36.0	17.21	67.5	5.941
-88.5	0.8136	-57.0	8.131	-25.5	182.5	6.0	1629	37.5	13.75	69.0	5.367
-87.0	0.8479	-55.5	8.360	-24.0	249.9	7.5	1578	39.0	11.72	70.5	4.780
-85.5	0.8813	-54.0	8.306	-22.5	336.0	9.0	1511	40.5	10.71	72.0	4.162
-84.0	0.8929	-52.5	8.205	-21.0	445.1	10.5	1436	42.0	10.08	73.5	3.607
-82.5	0.9847	-51.0	8.083	-19.5	557.4	12.0	1357	43.5	9.558	75.0	3.135
-81.0	1.178	-49.5	7.852	-18.0	670.8	13.5	1269	45.0	9.192	76.5	2.766
-79.5	1.474	-48.0	7.769	-16.5	785.6	15.0	1161	46.5	9.088	78.0	2.445
-78.0	2.537	-46.5	7.897	-15.0	896.1	16.5	1026	48.0	9.270	79.5	2.260
-76.5	2.831	-45.0	8.227	-13.5	1008	18.0	865.3	49.5	9.638	81.0	2.081
-75.0	3.245	-43.5	8.721	-12.0	1115	19.5	687.2	51.0	9.853	82.5	1.9784
-73.5	3.762	-42.0	9.322	-10.5	1224	21.0	524.4	52.5	9.844	84.0	1.9421
-72.0	4.206	-40.5	10.03	-9.0	1333	22.5	383.7	54.0	9.751	85.5	1.9690
-70.5	4.667	-39.0	11.19	-7.5	1438	24.0	272.9	55.5	9.319	87.0	1.9604
-69.0	5.048	-37.5	12.95	-6.0	1526	25.5	195.5	57.0	8.640	88.5	1.8533
-67.5	5.258	-36.0	15.65	-4.5	1592	27.0	137.7	58.5	7.867	90.0	1.7694
-66.0	5.465	-34.5	19.86	-3.0	1638	28.5	96.02	60.0	7.315		
-64.5	5.720	-33.0	26.46	-1.5	1670	30.0	66.64	61.5	6.893		
-63.0	6.072	-31.5	37.37	0.0	1682	31.5	45.91	63.0	6.616		
-61.5	6.570	-30.0	55.24	1.5	1680	33.0	31.89	64.5	6.436		
-60.0	7.141	-28.5	84.29	3.0	1675	34.5	22.77	66.0	6.254		

Electricity Parameter:

Current I: 0.1000A Power: 3.310W
Voltage V: 33.09V PF: 1.000

Optical Parameter(Distance=2.410m):

Equivalent Luminous flux: $\Phi_{\text{eff}} = 566.01\text{lm}$ Efficiency: $\text{Eff} = 171.01\text{lm/W}$
Diffuse angle: $\text{@}(25\%): 43.3\text{deg}$ $\text{@}(50\%): 33.9\text{deg}$ $\text{@}(75\%): 23.5\text{deg}$ $\text{@}(50\%): 33.9\text{deg}$
Diffuse angle: $\text{@}(25\%): 43.3\text{deg}$ $\text{@}(50\%): 33.9\text{deg}$ $\text{@}(75\%): 23.5\text{deg}$ $\text{@}(50\%): 33.9\text{deg}$
 $I_{\text{max}} = 1682\text{cd}$ ($C = 0.0\text{deg}, G = 0.0\text{deg}$) $\text{CO-180Plane } I_{\text{max}} = 1682\text{cd}$ ($C = 0.0\text{deg}$)
 $\text{CO-180Plane } I_0 = 1682\text{cd}$



Intensity data: (deg, cd) C0-180

A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.3841	-58.5	5.216	-27.0	177.3	4.5	421.3	36.0	34.31	67.5	2.344
-88.5	0.4182	-57.0	5.809	-25.5	202.6	6.0	415.0	37.5	25.35	69.0	2.092
-87.0	0.4636	-55.5	6.460	-24.0	228.3	7.5	407.5	39.0	19.93	70.5	1.866
-85.5	0.5084	-54.0	7.230	-22.5	255.0	9.0	398.0	40.5	16.64	72.0	1.648
-84.0	0.5320	-52.5	8.025	-21.0	279.7	10.5	387.8	42.0	14.54	73.5	1.458
-82.5	0.6005	-51.0	8.852	-19.5	301.6	12.0	377.2	43.5	13.16	75.0	1.286
-81.0	0.7149	-49.5	9.715	-18.0	321.9	13.5	364.0	45.0	11.96	76.5	1.139
-79.5	0.8617	-48.0	10.69	-16.5	339.8	15.0	349.1	46.5	10.90	78.0	1.012
-78.0	0.9970	-46.5	11.70	-15.0	355.0	16.5	327.7	48.0	9.896	79.5	0.8898
-76.5	1.145	-45.0	12.73	-13.5	368.7	18.0	309.2	49.5	8.931	81.0	0.7651
-75.0	1.349	-43.5	13.89	-12.0	380.5	19.5	288.6	51.0	8.082	82.5	0.6794
-73.5	1.554	-42.0	15.41	-10.5	391.2	21.0	266.3	52.5	7.279	84.0	0.6356
-72.0	1.769	-40.5	17.85	-9.0	400.9	22.5	241.7	54.0	6.489	85.5	0.6341
-70.5	2.030	-39.0	21.90	-7.5	409.7	24.0	216.3	55.5	5.789	87.0	0.6553
-69.0	2.301	-37.5	28.63	-6.0	416.6	25.5	189.4	57.0	5.222	88.5	0.6137
-67.5	2.610	-36.0	39.46	-4.5	422.2	27.0	162.6	58.5	4.687	90.0	0.5886
-66.0	2.939	-34.5	55.63	-3.0	426.1	28.5	136.3	60.0	4.194		
-64.5	3.326	-33.0	76.00	-1.5	428.4	30.0	111.3	61.5	3.758		
-63.0	3.737	-31.5	99.18	0.0	429.3	31.5	86.75	63.0	3.328		
-61.5	4.177	-30.0	124.1	1.5	428.4	33.0	65.16	64.5	2.945		
-60.0	4.680	-28.5	150.4	3.0	425.7	34.5	47.35	66.0	2.632		

Electricity Parameter:

Current I: 0.1000A Power: 3.360W
Voltage V: 33.59V PF: 1.000

Optical Parameter (Distance=2.410m):

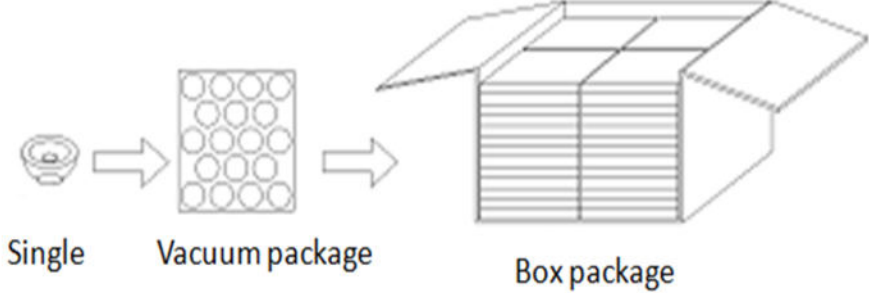
Equivalent Luminous flux: Φ_{eff}=281.5lm Efficiency: Eff=83.78lm/W
Diffuse angle: @ (25%): 61.2deg @ (50%): 48.7deg @ (75%): 34.8deg @ (50%): 48.7deg
Diffuse angle: @ (25%): 61.2deg @ (50%): 48.7deg @ (75%): 34.8deg @ (50%): 48.7deg
I_{max}=429.3cd (C=0.0deg, C=0.0deg) C0-180Plane I_{max}=429.3cd (C=0.0deg)
C0-180Plane I₀=429.3cd

		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks																																									
1.Size	diameter	50	/	/	50	50.04	50.04	50.01	/	Test environment: In 20 °C -25 °C environment to achieve thermal equilibrium after the test.																																									
	height	24	/	/	24.23	24.28	24.28	24.29	/																																										
	column diameter	3	/	/	2.92	2.9	2.92	2.95	/																																										
	Location column	23	/	/	23.03	23.09	23.09	23.02	/																																										
	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 1512																																																	
	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°	18°	18.1°	17.9°	/	OK																																											
	K-value	/	6.94	7.04	7.14	7.07	/																																												
	Efficiency	/	85.12%	84.51%	84.33%	83.25%	/																																												
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>																																																		
	<p style="text-align: center;">PC product size changes with temperature table</p> <table border="1"> <caption>Data for PC product size changes with temperature table</caption> <thead> <tr> <th>Temperature (°C)</th> <th>50mm</th> <th>100mm</th> <th>150mm</th> <th>200mm</th> <th>250mm</th> <th>300mm</th> </tr> </thead> <tbody> <tr> <td>0</td> <td>0.00</td> <td>0.00</td> <td>0.00</td> <td>0.00</td> <td>0.00</td> <td>0.00</td> </tr> <tr> <td>10</td> <td>0.05</td> <td>0.10</td> <td>0.15</td> <td>0.20</td> <td>0.25</td> <td>0.30</td> </tr> <tr> <td>20</td> <td>0.10</td> <td>0.15</td> <td>0.20</td> <td>0.25</td> <td>0.30</td> <td>0.35</td> </tr> <tr> <td>30</td> <td>0.15</td> <td>0.20</td> <td>0.25</td> <td>0.30</td> <td>0.35</td> <td>0.40</td> </tr> <tr> <td>40</td> <td>0.15</td> <td>0.25</td> <td>0.35</td> <td>0.45</td> <td>0.55</td> <td>0.78</td> </tr> </tbody> </table>										Temperature (°C)	50mm	100mm	150mm	200mm	250mm	300mm	0	0.00	0.00	0.00	0.00	0.00	0.00	10	0.05	0.10	0.15	0.20	0.25	0.30	20	0.10	0.15	0.20	0.25	0.30	0.35	30	0.15	0.20	0.25	0.30	0.35	0.40	40	0.15	0.25	0.35	0.45	0.55
Temperature (°C)	50mm	100mm	150mm	200mm	250mm	300mm																																													
0	0.00	0.00	0.00	0.00	0.00	0.00																																													
10	0.05	0.10	0.15	0.20	0.25	0.30																																													
20	0.10	0.15	0.20	0.25	0.30	0.35																																													
30	0.15	0.20	0.25	0.30	0.35	0.40																																													
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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	50	/	/	49.94	49.9	49.94	49.94	/	Test environment: In 20 °C -25 °C environment to achieve thermal equilibrium after the test.																																									
	height	24	/	/	24.16	23.96	24.02	24.14	/																																										
	column diameter	3	/	/	2.92	2.9	2.92	2.9	/																																										
	Location column	23	/	/	23.04	23.1	23.06	23.02	/																																										
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3.Material	PC				Color	Transparent			OK																																										
4.Optical index	Testing LED	cree 1512																																																	
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	FWHM	See light distribution curve																																																	
	angle	/	23.3°	23.5°	23.4°	23.4°	/	/																																											
	K-value	/	4.82	4.78	4.84	4.81	/																																												
	Efficiency	/	87.05%	86.98%	87.12%	86.50%	/	/																																											
Facula	See the signature sample																																																		
Comprehensive judgment	Qualified																																																		
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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	50	/	/	50.02	49.88	49.99	49.98	/	Test environment: In 20 °C -25 °C environment to achieve thermal equilibrium after the test.																																									
	height	24	/	/	24.09	24.1	24.13	24.08	/																																										
	column diameter	3	/	/	2.96	2.95	2.97	2.96	/																																										
	Location column	23	/	/	23.01	23.01	22.96	22.97	/																																										
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	FWHM	See light distribution curve																																																	
	angle	/	33.4°	34.5°	33.9°	33.8°	/	See the signature sample																																											
	K-value	/	2.97	2.95	2.84	3.01	/																																												
	Efficiency	/	86.88%	86.32%	86.14%	86.14%	/																																												
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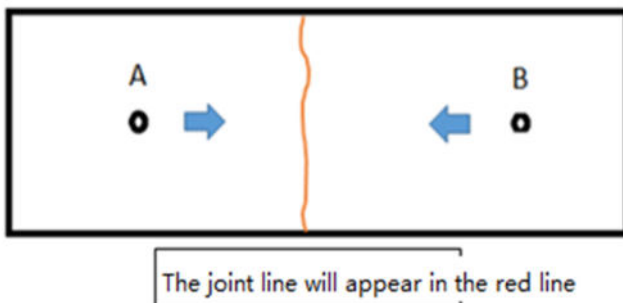
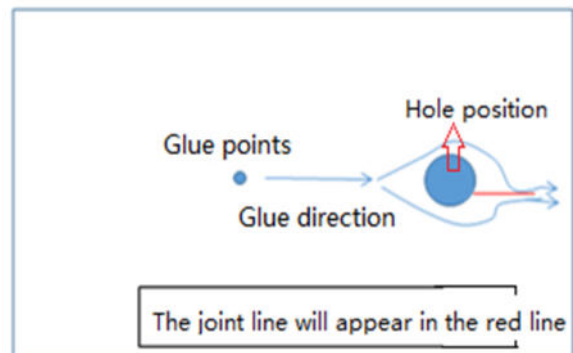
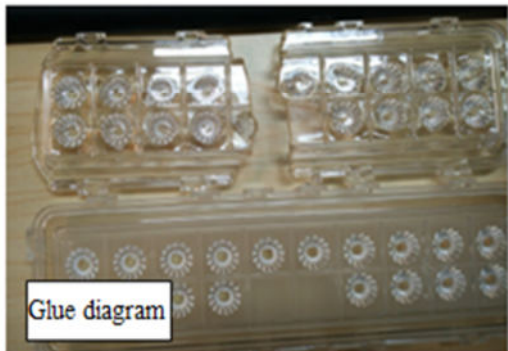
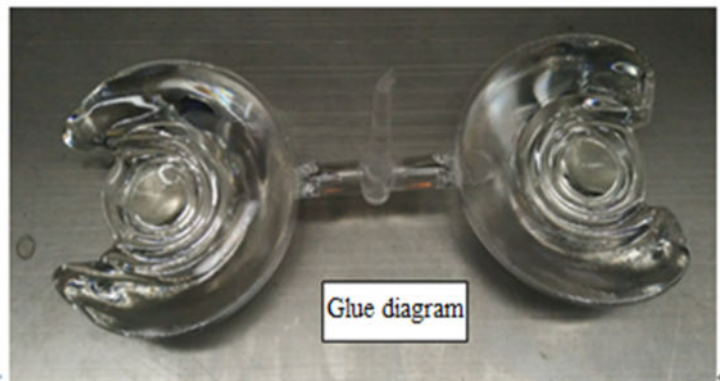
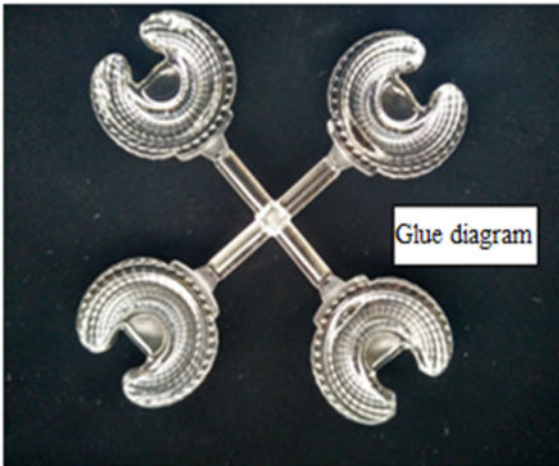
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	angle		48.7	49.9	48.8	49.5																																													
	K-value																																																		
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PN		HK-50@24-15-D9-01-1g-1		Product Name		HK 50@24-15°Lens	
Product material		PC		Customer			
Package diagram		 <p style="text-align: center;"> Single Vacuum package Box package </p>					
Product packing		14		A/ Box		4	
		10		Layer/Box		560	
Packaging Materials	NO.	Part No	Part name	Size	Dosage	Unit	Remarks
	1	2.07.0024-1	Blister box	23cm*21cm	40	BAG	
	2	2.08.0001	PE film	30cm*30cm	40	PCS	
	3	2.06.0005	Reel label paper	6.2cm*8cm	40	PCS	
	4	2.06.0005	Box label paper	6.2cm*9.2cm	1	PCS	
	5	2.06.0003	big plate	46.8cm*42.8cm	11	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 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		√	