



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-55@30-15-D9-21-1g-1	1. 01. 23084	HK 55@30-15° lens
HK-55@30-24-D9-21-1g-1	1. 01. 13028	HK 55@30-24° lens
HK-55@30-36-D9-21-1g-1	1. 01. 23085	HK 55@30-36° lens



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-

TEL: 0755-2937 1541

FAX: 0755-2907 5140

*Approval In duplicate, for both supplier and customer.

Disclaimer

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.

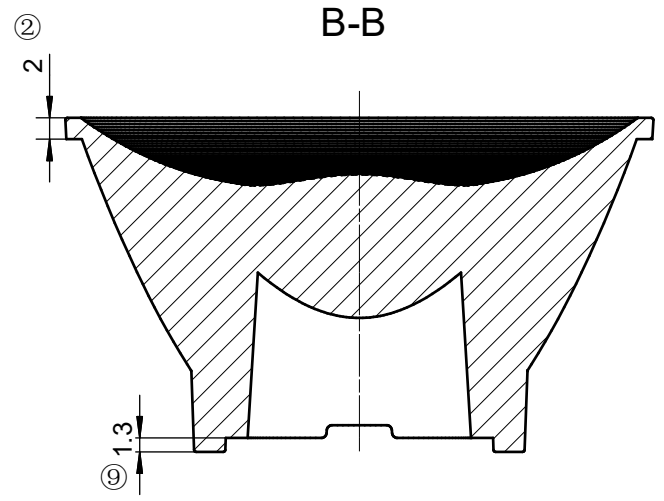
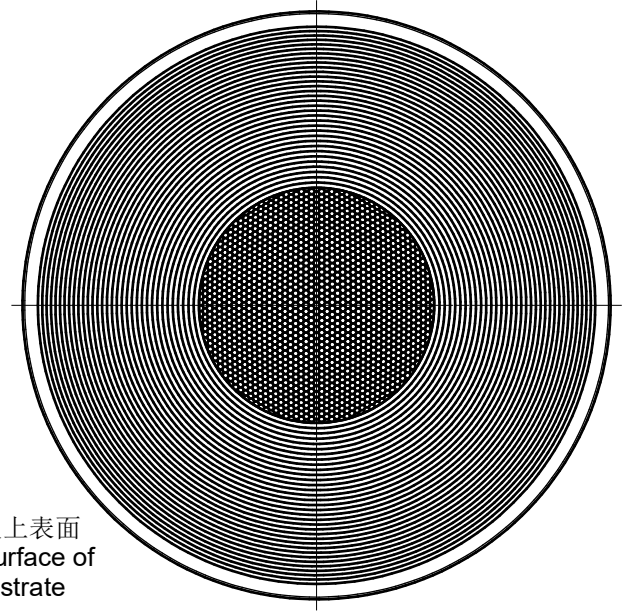
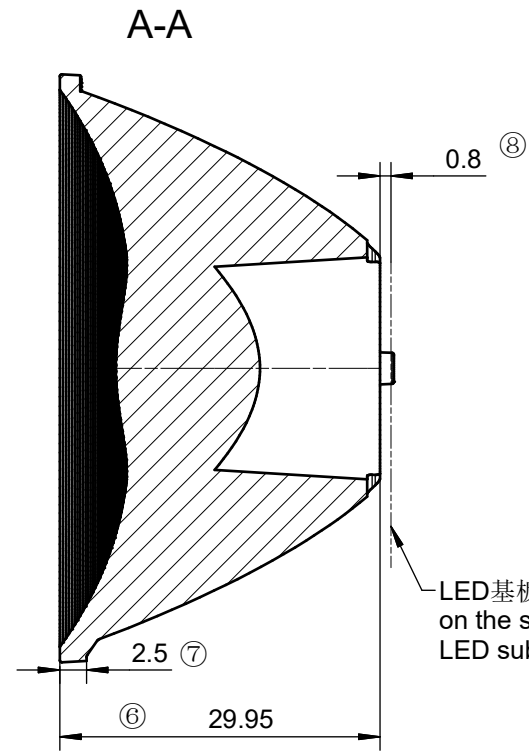
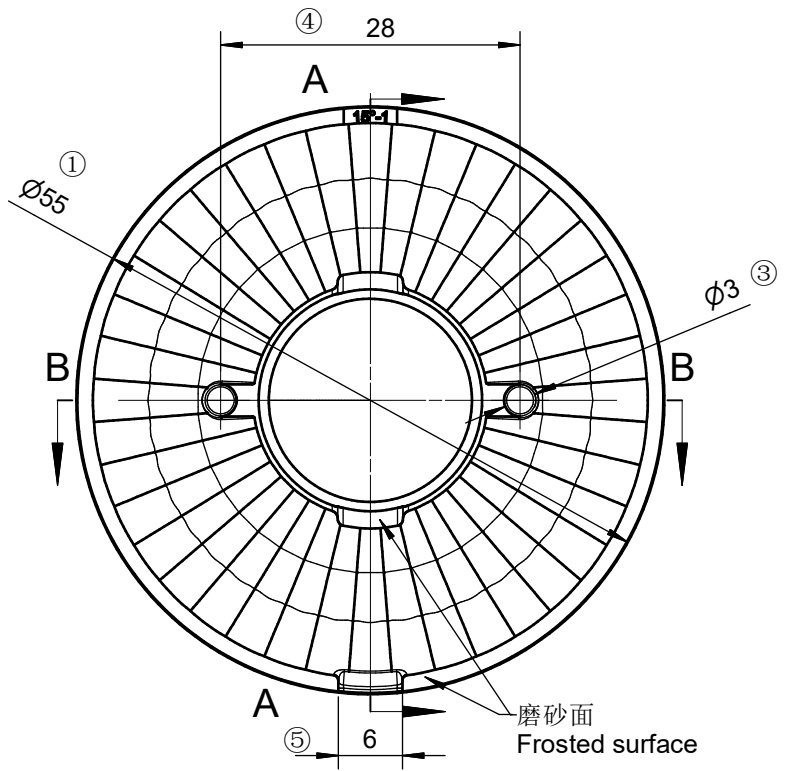
Operation cautions:

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

Product Picture:	
Size(L*W*H/Φ*H):	Φ:55mm; H:30.75mm
Material:	PMMA
Efficiency:	\
Temperature(Topr):	Material extreme temperature resistance: -40°C to +100°C long-term use temperature: -40°C to +80°C
FWHM:	15°、24°、36°
Matched LES:	LUMILEDS: 1204
Recommended MAX power:	Not more than 15W

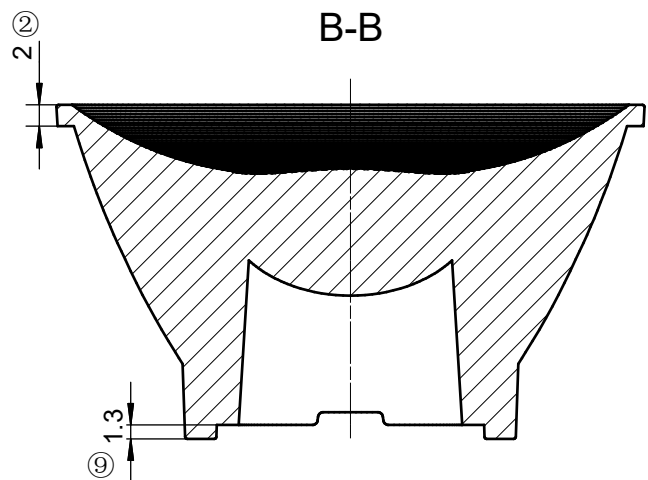
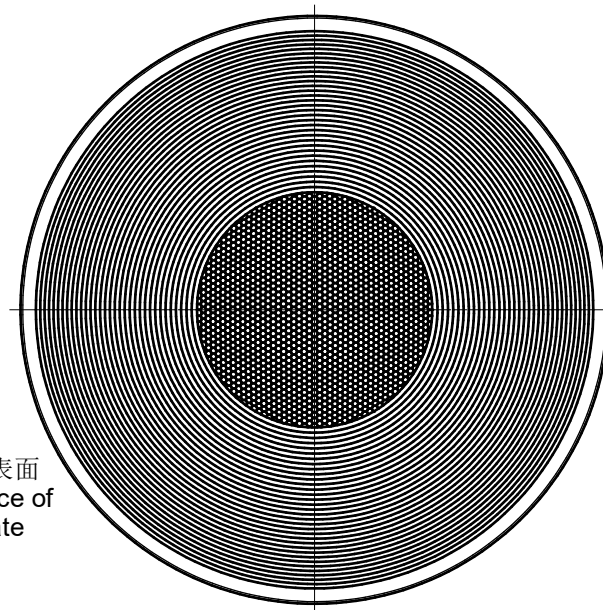
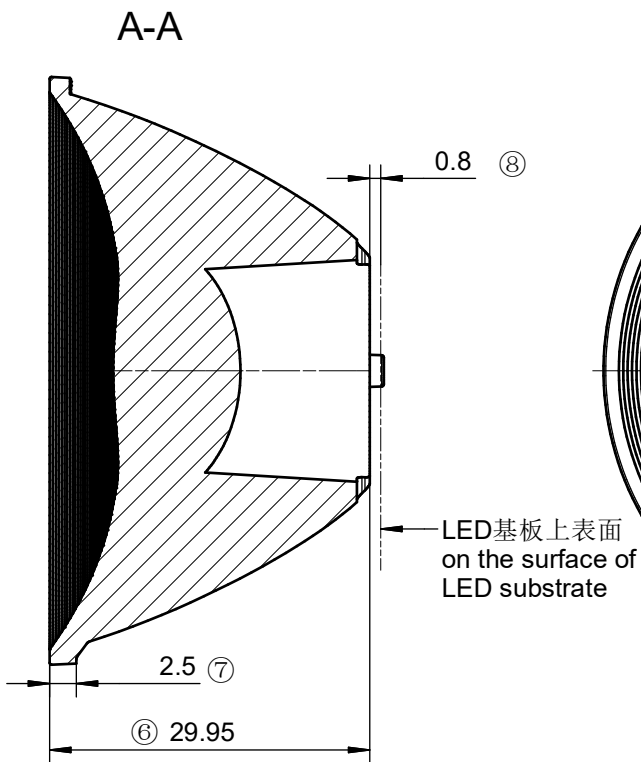
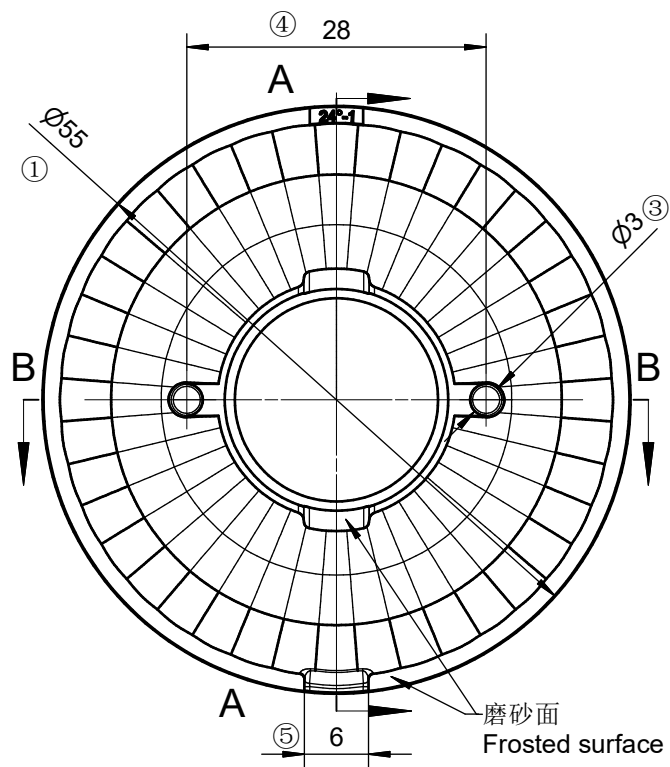


技术要求：
 1、未注圆角及拔模斜度按3D图。
 2、未注尺寸公差按右表。
 3、表面无飞边，缩水，气泡等缺陷。
 *4、灯具采用胶圈防水时：要求散热器与胶圈的接触面的粗糙度：Ra<3.2μm

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

基本尺寸	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

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
2					4				
1					3				
光学设计 Optical design					Title: HK 55@30-15度透镜 HK 55@30-15°Lens				
结构设计 Structural design					Drawing No. HK-55@30-15-D9-21-1g-1				
审核 Verify					Part No. 1.01.23084				
审定 Approval					材料 Material: PMMA CDHK				



技术要求:

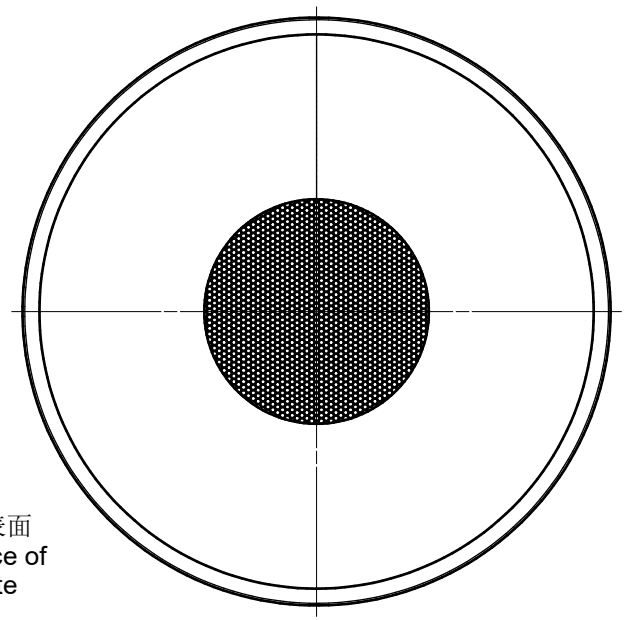
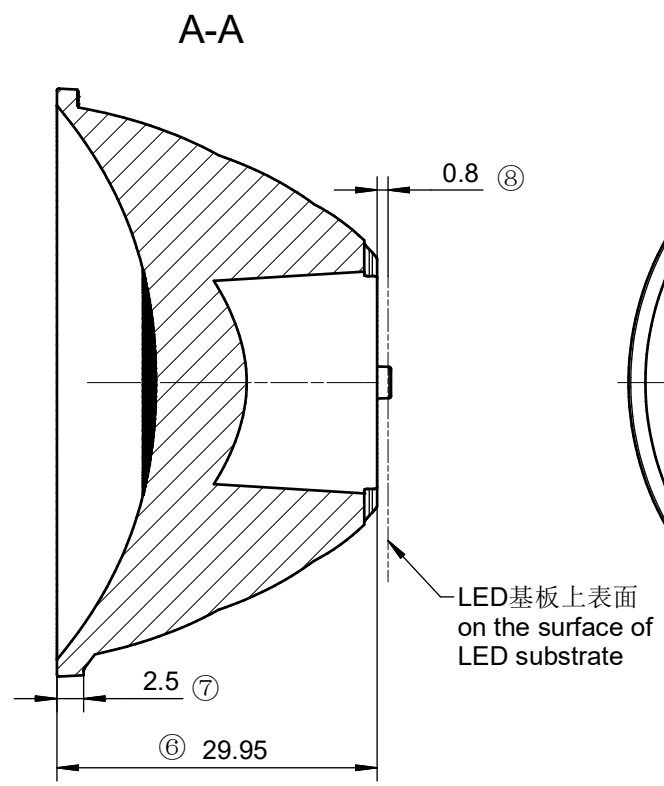
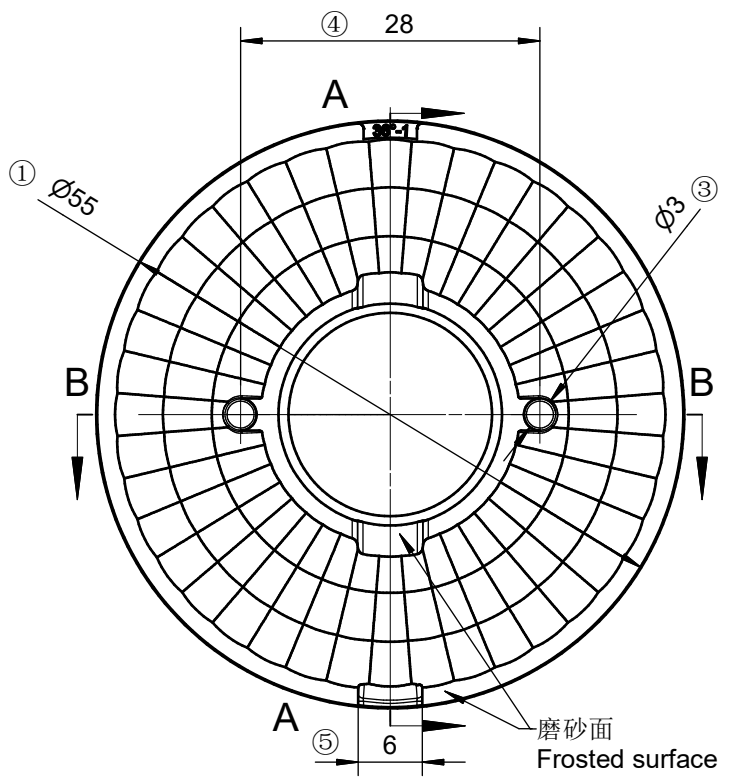
- 1、未注圆角及拔模斜度按3D图。
- 2、未注尺寸公差按右表。
- 3、表面无飞边，缩水，气泡等缺陷。
- *4、灯具采用胶圈防水时：要求散热器与胶圈的接触面的粗糙度：Ra<3.2μm

Technical remark:

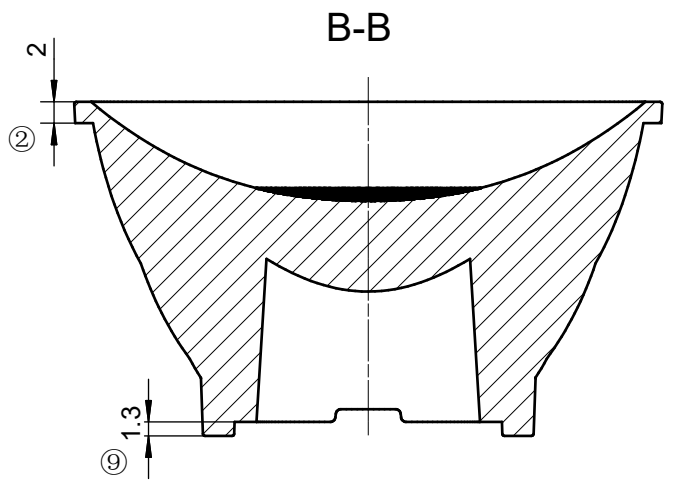
1. Fillet and inclination not indicated according to 3D drawing.
2. Dimensional tolerances not indicated are shown in the right list.
3. The surface has no flash, shrinkage, bubbles and other defects.
- *4. When the lamp adopts rubber ring for waterproofing: the roughness of the contact surface between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

基本尺寸	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

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
2					4				
1					3				
光学设计 Optical design 结构设计 Structural design 审核 Verify 审定 Approval					Title: HK 55@30-24度透镜 HK 55@30-24°Lens 材料 Material: PMMA				
					Drawing No. HK-55@30-24-D9-21-1g-1 Part No. 1.01.13028 CDHK				



LED基板上表面
on the surface of
LED substrate

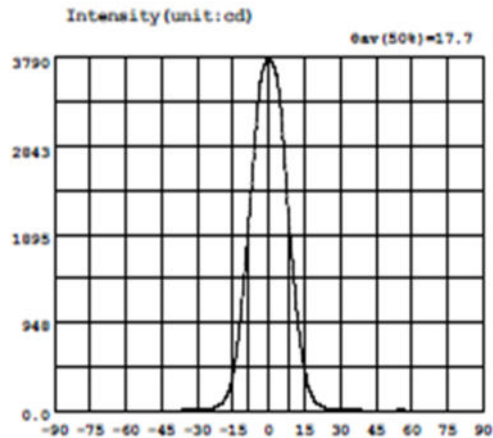
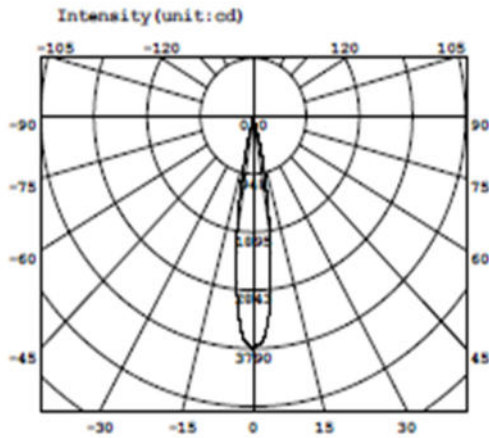


技术要求:
 1、未注圆角及拔模斜度按3D图。
 2、未注尺寸公差按右表。
 3、表面无飞边, 缩水, 气泡等缺陷。
 *4、灯具采用胶圈防水时: 要求散热器与胶圈的接触面的粗糙度: Ra<3.2μm

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

基本尺寸	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

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
2					4				
1					3				
光学设计 Optical design 结构设计 Structural design 审核 Verify 审定 Approval					Title: HK 55@30-36度透镜 HK 55@30-36°Lens 材料 Material: PMMA				
					Drawing No. HK-55@30-36-D9-21-1g-1 Part No. 1.01.23085 CDHK				



Intensity data:(deg , cd) C0-180

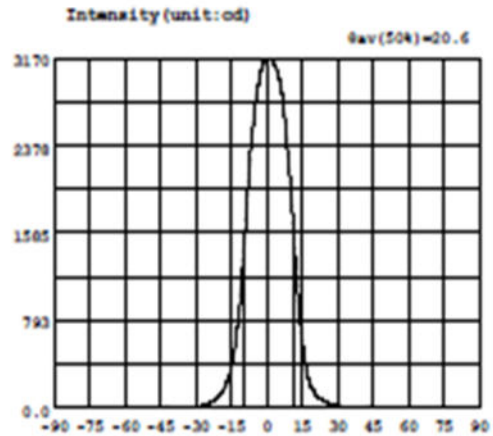
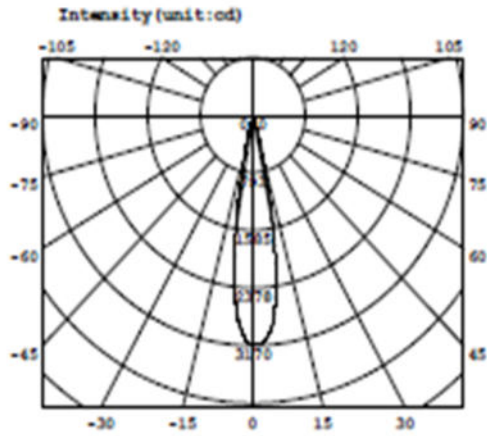
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.3051	-58.5	6.084	-27.0	14.95	4.5	3344	36.0	7.248	67.5	3.391
-88.5	0.3164	-57.0	6.101	-25.5	18.09	6.0	2924	37.5	6.770	69.0	2.823
-87.0	0.4519	-55.5	6.108	-24.0	24.24	7.5	2367	39.0	6.433	70.5	2.360
-85.5	0.5878	-54.0	6.081	-22.5	35.48	9.0	1858	40.5	6.000	72.0	2.009
-84.0	0.7019	-52.5	5.921	-21.0	54.68	10.5	1397	42.0	5.751	73.5	1.695
-82.5	0.8386	-51.0	5.658	-19.5	88.78	12.0	991.2	43.5	5.581	75.0	1.438
-81.0	0.9968	-49.5	5.448	-18.0	146.7	13.5	666.7	45.0	5.563	76.5	1.321
-79.5	1.078	-48.0	5.246	-16.5	241.9	15.0	434.2	46.5	5.578	78.0	1.236
-78.0	1.210	-46.5	5.204	-15.0	395.7	16.5	260.6	48.0	5.752	79.5	1.136
-76.5	1.291	-45.0	5.211	-13.5	644.9	18.0	164.8	49.5	5.945	81.0	1.002
-75.0	1.409	-43.5	5.278	-12.0	988.6	19.5	102.7	51.0	6.194	82.5	0.8535
-73.5	1.736	-42.0	5.417	-10.5	1412	21.0	64.39	52.5	6.404	84.0	0.6486
-72.0	2.052	-40.5	5.691	-9.0	1872	22.5	41.69	54.0	6.533	85.5	0.5392
-70.5	2.439	-39.0	5.931	-7.5	2359	24.0	30.07	55.5	6.556	87.0	0.4118
-69.0	2.888	-37.5	6.190	-6.0	2879	25.5	22.27	57.0	6.491	88.5	0.2848
-67.5	3.448	-36.0	6.571	-4.5	3319	27.0	16.59	58.5	6.335	90.0	0.2067
-66.0	4.097	-34.5	7.074	-3.0	3613	28.5	13.30	60.0	6.078		
-64.5	4.723	-33.0	7.979	-1.5	3725	30.0	12.13	61.5	5.732		
-63.0	5.117	-31.5	9.225	0.0	3782	31.5	10.58	63.0	5.305		
-61.5	5.476	-30.0	10.84	1.5	3723	33.0	8.415	64.5	4.762		
-60.0	5.779	-28.5	12.84	3.0	3625	34.5	7.514	66.0	4.074		

Electricity Parameter:

Current I: 0.1000A Power: 3.450W
Voltage V: 34.50V PF: 1.000

Optical Parameter(Distance=2.410m):

Equivalent Luminous flux: $\Phi_{eff} = 417.4lm$ Efficiency: $Eff=121.00lm/W$
Diffuse angle: @ (25%): 24.2deg@ (50%): 17.7deg@ (75%): 12.3deg@ (50%): 17.7deg
Diffuse angle: @ (25%): 24.2deg@ (50%): 17.7deg@ (75%): 12.3deg@ (50%): 17.7deg
 $I_{max}=3782cd$ (C=0.0deg,G=0.0deg) C0-180Plane $I_{max}= 3782cd$ (G=0.0deg)
C0-180Plane $I_0= 3782cd$



Intensity data:(deg , cd) C0-180

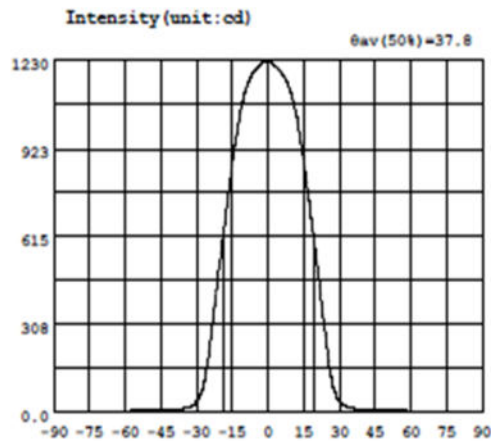
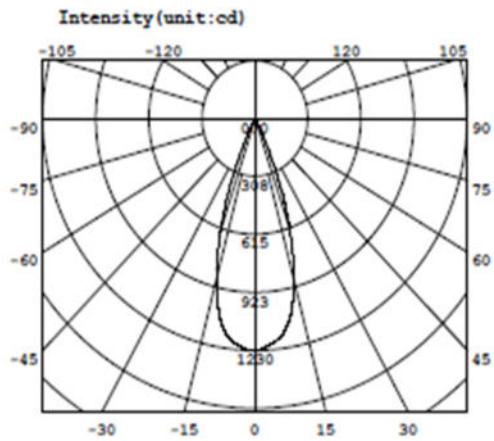
A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.2938	-58.5	5.731	-27.0	21.22	4.5	3028	36.0	7.395	67.5	3.328
-88.5	0.3163	-57.0	6.091	-25.5	31.13	6.0	2881	37.5	6.695	69.0	2.904
-87.0	0.3617	-55.5	6.412	-24.0	44.67	7.5	2620	39.0	6.165	70.5	2.482
-85.5	0.4858	-54.0	6.611	-22.5	63.35	9.0	2253	40.5	5.838	72.0	2.122
-84.0	0.6218	-52.5	6.760	-21.0	89.10	10.5	1808	42.0	5.600	73.5	1.817
-82.5	0.7583	-51.0	6.846	-19.5	125.1	12.0	1333	43.5	5.476	75.0	1.457
-81.0	0.8843	-49.5	6.822	-18.0	176.1	13.5	897.9	45.0	5.635	76.5	1.323
-79.5	1.021	-48.0	6.569	-16.5	251.1	15.0	576.4	46.5	5.941	78.0	1.236
-78.0	1.122	-46.5	6.375	-15.0	373.2	16.5	355.3	48.0	6.155	79.5	1.138
-76.5	1.224	-45.0	6.039	-13.5	565.2	18.0	228.5	49.5	6.349	81.0	1.039
-75.0	1.336	-43.5	5.662	-12.0	854.9	19.5	155.3	51.0	6.424	82.5	0.8950
-73.5	1.462	-42.0	5.415	-10.5	1261	21.0	108.2	52.5	6.422	84.0	0.7883
-72.0	1.791	-40.5	5.437	-9.0	1725	22.5	76.64	54.0	6.337	85.5	0.6508
-70.5	2.153	-39.0	5.692	-7.5	2178	24.0	54.92	55.5	6.156	87.0	0.5236
-69.0	2.520	-37.5	6.006	-6.0	2561	25.5	38.79	57.0	5.960	88.5	0.3877
-67.5	2.951	-36.0	6.458	-4.5	2837	27.0	26.99	58.5	5.708	90.0	0.2632
-66.0	3.408	-34.5	7.118	-3.0	3010	28.5	18.79	60.0	5.380		
-64.5	3.898	-33.0	7.829	-1.5	3119	30.0	13.62	61.5	4.975		
-63.0	4.384	-31.5	8.969	0.0	3158	31.5	10.62	63.0	4.576		
-61.5	4.838	-30.0	10.92	1.5	3159	33.0	9.049	64.5	4.184		
-60.0	5.287	-28.5	14.62	3.0	3120	34.5	8.027	66.0	3.767		

Electricity Parameter:

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

Optical Parameter(Distance=2.410m):

Equivalent Luminous flux: $\Phi_{eff} = 433.3lm$ Efficiency: $Eff=129.06lm/W$
Diffuse angle: @ (25%): 26.1deg@ (50%): 20.6deg@ (75%): 15.2deg@ (50%): 20.6deg
Diffuse angle: @ (25%): 26.1deg@ (50%): 20.6deg@ (75%): 15.3deg@ (50%): 20.6deg
Imax=3162cd (C=0.0deg,G=1.0deg) C0-180Plane Imax= 3162cd(G=1.0deg)
C0-180Plane I0= 3158cd



Intensity data: (deg , cd) C0-180

A	I	A	I	A	I	A	I	A	I	A	I
-90.0	0.3567	-58.5	6.262	-27.0	99.32	4.5	1200	36.0	12.94	67.5	3.174
-88.5	0.3693	-57.0	6.507	-25.5	170.2	6.0	1185	37.5	11.29	69.0	2.746
-87.0	0.5099	-55.5	6.770	-24.0	264.4	7.5	1164	39.0	10.19	70.5	2.258
-85.5	0.6762	-54.0	6.937	-22.5	373.0	9.0	1133	40.5	9.348	72.0	2.084
-84.0	0.8689	-52.5	7.028	-21.0	474.4	10.5	1090	42.0	8.757	73.5	1.994
-82.5	1.035	-51.0	7.102	-19.5	573.1	12.0	1033	43.5	8.368	75.0	1.843
-81.0	1.252	-49.5	7.172	-18.0	676.7	13.5	961.6	45.0	8.156	76.5	1.745
-79.5	1.481	-48.0	7.248	-16.5	778.0	15.0	878.1	46.5	7.965	78.0	1.611
-78.0	1.632	-46.5	7.485	-15.0	872.2	16.5	789.0	48.0	7.797	79.5	1.454
-76.5	1.787	-45.0	7.732	-13.5	956.9	18.0	689.3	49.5	7.611	81.0	1.339
-75.0	1.938	-43.5	7.954	-12.0	1030	19.5	587.5	51.0	7.486	82.5	1.067
-73.5	2.024	-42.0	8.207	-10.5	1093	21.0	488.9	52.5	7.368	84.0	0.9397
-72.0	2.101	-40.5	8.808	-9.0	1139	22.5	380.4	54.0	7.195	85.5	0.7164
-70.5	2.285	-39.0	9.434	-7.5	1170	24.0	279.6	55.5	6.961	87.0	0.5026
-69.0	2.679	-37.5	10.46	-6.0	1191	25.5	181.9	57.0	6.571	88.5	0.3091
-67.5	2.135	-36.0	11.93	-4.5	1205	27.0	104.8	58.5	6.287	90.0	0.3197
-66.0	3.767	-34.5	14.42	-3.0	1218	28.5	61.91	60.0	6.053		
-64.5	4.411	-33.0	18.69	-1.5	1227	30.0	39.09	61.5	5.567		
-63.0	4.981	-31.5	25.41	0.0	1230	31.5	26.79	63.0	5.042		
-61.5	5.497	-30.0	37.03	1.5	1225	33.0	19.74	64.5	4.435		
-60.0	5.962	-28.5	58.40	3.0	1212	34.5	15.52	66.0	3.869		

Electricity Parameter:

Current I: 0.1000A Power: 3.450W
Voltage V: 34.50V PF: 1.000

Optical Parameter(Distance=2.559m):

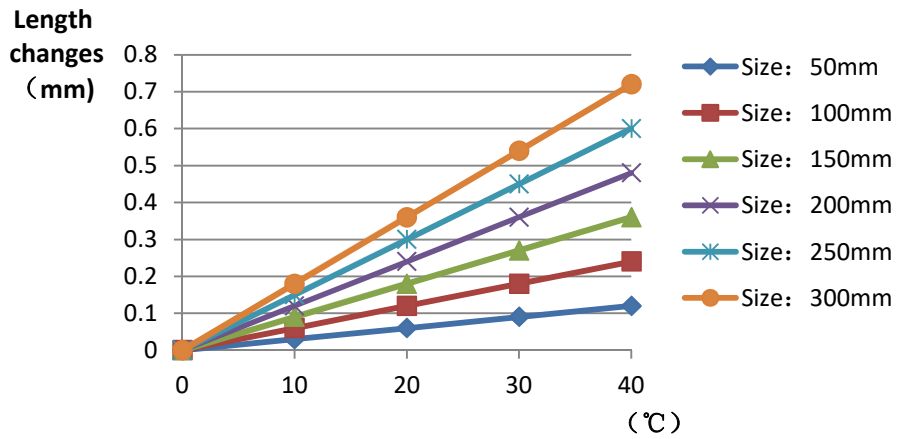
Equivalent Luminous flux: $\Phi_{eff} = 478.11m$ Efficiency: $Eff=138.60lm/W$
Diffuse angle: @ (25%): 46.8deg@ (50%): 37.8deg@ (75%): 28.3deg@ (50%): 37.8deg
Diffuse angle: @ (25%): 46.8deg@ (50%): 37.8deg@ (75%): 28.3deg@ (50%): 37.8deg
Imax=1230cd (C=0.0deg,G=-0.5deg) C0-180Plane Imax= 1230cd(G=-0.5deg)
C0-180Plane I0= 1230cd

		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
1.Size	diameter	55			55.2	55.24	55.2	55.24		Test environment : In 20 °C - 25 °C environment to achieve thermal equilibrium after the test.
	thickness	2			2.14	2.09	2.14	2.09		
	Registration mast	3			2.9	2.91	2.9	2.91		
	height	29.95			29.95	29.95	29.95	29.95		
	Location column	28			28.23	28.21	28.22	28.27		
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	PMMA				Color	Transparent		OK		
4.Optical index	Testing LED	LUMILEDS: 1204								
	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		17.7	17.7	18	17.9				
	K-value (CD/LM)		9.00	9.00	8.90	8.80				
Efficiency		92.00%	92.00%	92.00%	92.00%					
Facula	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

PMMA product size changes with temperature table



Precautions:

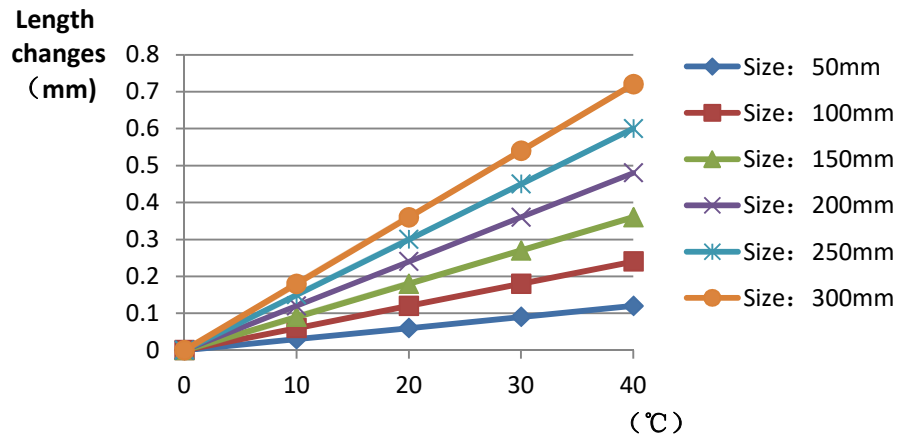
1. Please wear clean gloves during the lens assembly process to prevent the lens surface from being contaminated.
2. Try to avoid touching the total reflection surface when taking the lens.
3. The lens surface is contaminated. Only use a soft cotton cloth dipped in analytically pure neutral solvent to 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.

		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
1.Size	diameter	55			55.06	55.04	55.06	55.04		Test environment : In 20 °C - 25 °C environment to achieve thermal equilibrium after the test.
	thickness	2			2.06	2.09	2.06	2.09		
	Registration mast	3			2.92	3	2.92	3		
	height	29.95			30.01	30.01	30.01	30.01		
	Location column	28			28.09	28.17	28.09	28.17		
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	No stains		
3.Material	PMMA				Color	Transparent			OK	
4.Optical index	Testing LED	LUMINUS: CXM-9								
	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				20.5	20.6	20.7	20.8		
	K-value (CD/LM)				7.40	7.20	7.30	7.20		
Efficiency				92.00%	92.00%	92.00%	92.00%			
Facula	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

PMMA product size changes with temperature table



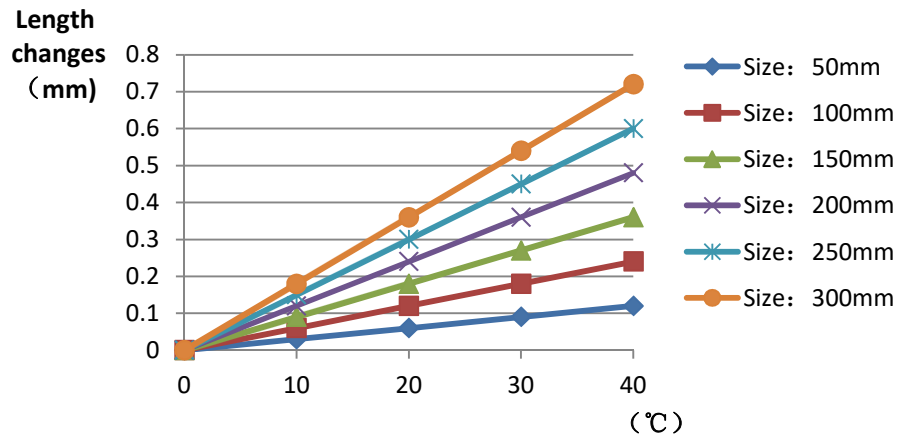
Precautions:

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.

		Standard size	Upper Size limit	Lower size limit	Test result1	Test result2	Test result3	Test result4	Judgment	Remarks
1.Size	diameter	55	/	/	55.21	55.17	55.21	55.17	/	Test environment : In 20 °C - 25 °C environment to achieve thermal equilibrium after the test.
	thickness	2	/	/	2.07	2.07	2.07	2.07	/	
	Registration mast	3	/	/	2.92	2.9	2.92	2.9	/	
	height	29.95	/	/	29.83	29.86	29.83	29.86	/	
	Location column	28	/	/	28.18	29.16	28.18	29.16	/	
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	No burr	OK	
			No stains	No stains	No stains	No stains	No stains			
3.Material	PMMA				Color	Transparent			OK	
4.Optical index	Testing LED	LUMILEDS: 1204								
	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	/	38.2	38.7	37.8	37.8	/			
	K-value (CD/LM)	/	2.50	2.40	2.50	2.50	/			
Efficiency	/	92.00%	92.00%	92.00%	92.00%	/				
Facula	See the signature sample									
Comprehensive judgment	Qualified									

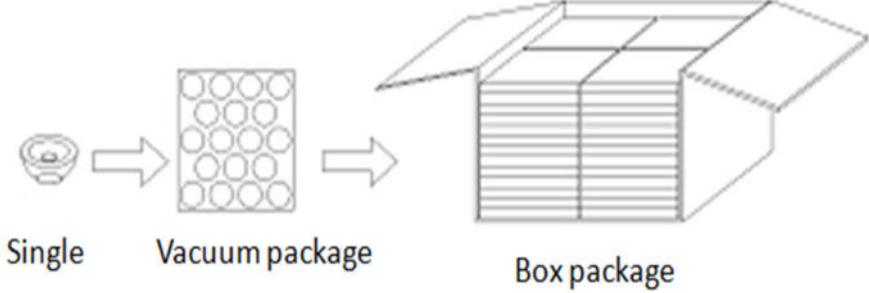
Remarks:
 1、 Tool Number: V-
 Vernier Caliper 2D-
 Quadratic H-Height
 Gauge M-Tool
 Microscope P-Needle T-
 Thick Gauge R-Radius
 Gauge E-Visual.
 2、 Ambient temperature
 on the size of the product
 refer to the table on the
 right

PMMA product size changes with temperature table



Precautions:

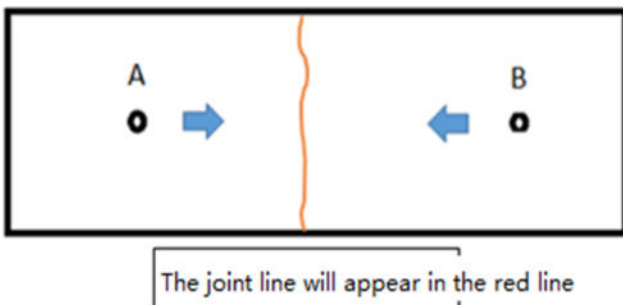
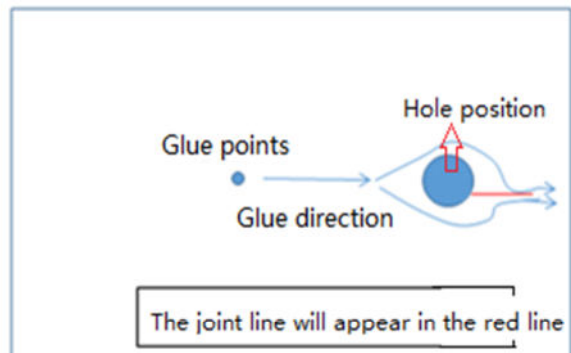
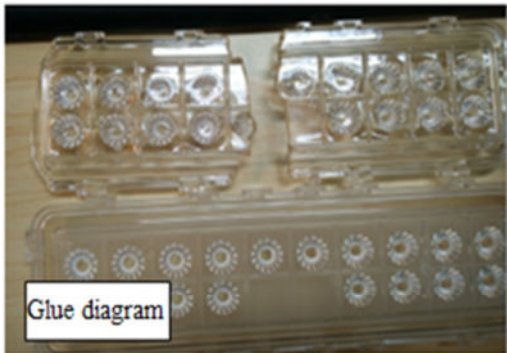
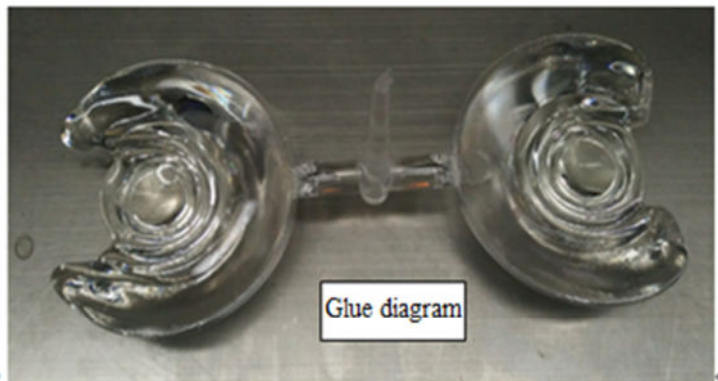
1. Please wear clean gloves during the lens assembly process to prevent the lens surface from being contaminated.
2. Try to avoid touching the total reflection surface when taking the lens.
3. The lens surface is contaminated. Only use a soft cotton cloth dipped in analytically pure neutral solvent to 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.

PN		HK-55@30-15-D9-21-1g-1	Product Name	HK 55@30-15°lens			
Product material		PMMA					
Package diagram		 <p style="text-align: center;">Single Vacuum package Box package</p>					
Product packing		9	A/ Box	4	pcs/Layer		
		9	Layer/Box	324	A/ Carton		
Packaging Materials	NO.	Part No	Part name	Size	Dosage	Unit	Remarks
	1	2.07.0078	Blister box	23cm*21cm	36	BAG	
	2	2.08.0001	PE film	30cm*30cm	36	PCS	
	3	2.06.0005	Reel label paper	6.2cm*8cm	36	PCS	
	4	2.06.0005	Box label paper	6.2cm*9.2cm	1	PCS	
	5	2.06.0003	big plate	46.8cm*42.8cm	10	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 $L \leq 10\text{mm}$, 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		√	