




Quality Control System

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Uncoated lenses A++ inspection standard

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Quality Control System

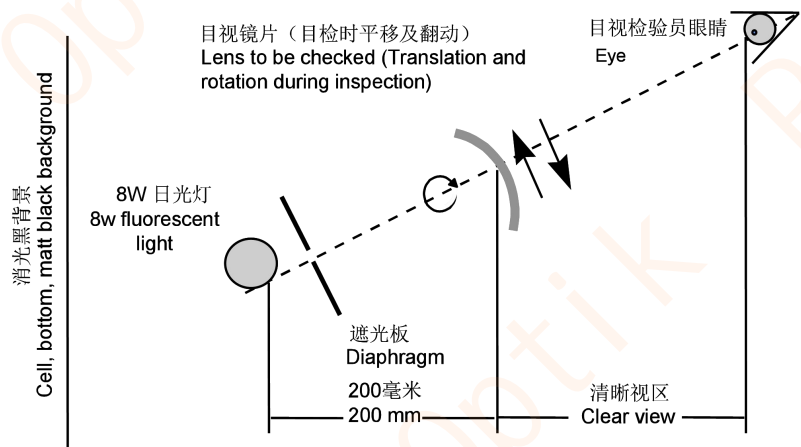
Uncoated lenses A++ inspection standard

1. SCOPE To define the acceptance criteria for aspect inspection.	2. FIELD OF APPLICATION Finished & semi-finished plastic lenses, able to be vacuum coated.
3. REFERENCES ISTM 04.001, ISTM 04.003 ISTM 02.020, DQO-QUA-I02.006	4. TERMINOLOGY MHI master: DQ issued maximum accepted scratch intensity that can be hid after coating. Only used for middle and high refractive index , NIKON/ESSILOR

5. Basic inspection

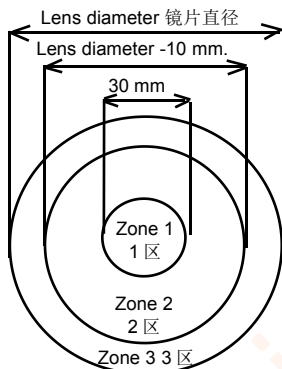
A lens should not present visible defects seen in ambient room light and white background (unless allowed by the standard) even before being checked using tighter inspection means.

6. INSPECTION METHOD



TRANSMISSION LIGHTING 光照装置图

7. INSPECTION METHOD



Zone	Spread defect	Intensity of Spot Defects					Total number of accept defect
		B2	B3	C1	C2	>C2	
1							[1]
2			1 dot				[4]
3	*	NC		≤2 dots			[5]

Accept

Not accept

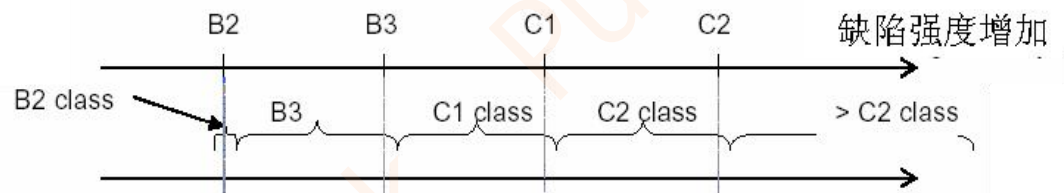
[n] Nb of accept defect

No acceptance for NIKON lens, others can be accepted one defect with C1 intensity except BS

* see QA accept stand lens

NC Non-considered

If defect is between Z1 and Z2, judge it as zone 1. If between Z2 and Z3, judge it as in zone 3.



For uncoated 1.5 AS + SF +1.55+1.6 S/AS/PC UNC	Defect reject std
<ul style="list-style-type: none"> scratch & stain according to MHI standard Crack at the facet 1 accept if less than 10 mm long 	<ul style="list-style-type: none"> 1. ≥C1 in Z1 2. ≥C2 in Z2 3. Black dots>standard 4. Extension defect in Z1

8. EDGE DEFECTS

All kinds of defects are acceptable at lens periphery(1mm).

-Crack: One acceptable<1 mm(if orientation is radial).

- Multiple cracks acceptable<0.5 mm(unlimited)

-Finished & front side of SF lens **Chip, Bubble or Delamination**: One is acceptable with a maximum size of: 8mm² ,2mm penetration max.

- Soft edge can not be accept.
- Flash not accepted if detachable.

9. For high index products

-Scratch: maximum intensity for scratches (even numerous) according to MHI scratch standard lens

-Only 1 B3 CO can be accepted in zone 2.

10. For Semi-finished products

10.1. SF lenses back surface

Chip, Bubbles and Delamination:

-Zone 1: No defect accepted more than C2 intensity

-Zone 2: 1 defect accepted, 5mm long max, No defect accepted under engraving areas

-Zone 3: all defects accepted up to 30mm long each, and 70mm cumulated 1/3 of SF thickness for chips and bubbles

All other defect can be accepted on the back side (or close to it) if they don't disturb the front surface measurement and inspection as well as lens internal inspection.

10.2. For Nikon Semi-finished products

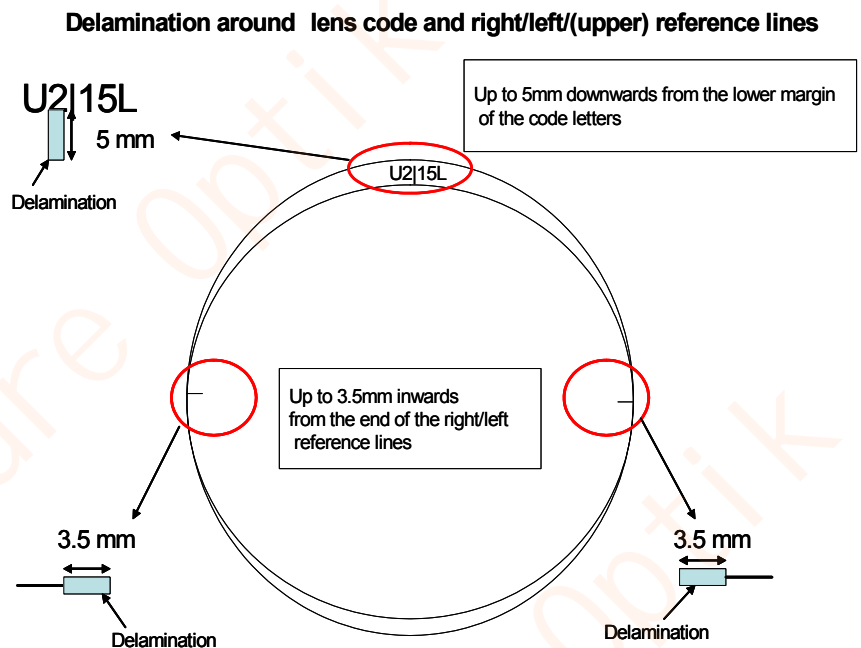
-Delamination around lens code and right/left/(upper) reference lines.

-Up to 5mm downwards from the lower margin of the code letters

-Up to 3.5mm inwards from the end of the right/left reference lines.

11. Inspection Rules

- Hold the lens by the edge with finger glove .
- Wipe the lens with a clean portion of cloth.
- Approximative inspection time is 4 to 8 seconds.



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