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<i>Chris Wu</i>		VERSION : 2
CUSTOMER ACCEPTANCE SPECIFICATIONS		
MODEL NO. : <u>ET035013DMA</u> (RoHS) FOR MESSRS : _____		
CUSTOMER'S APPROVAL DATE : _____ BY : _____		

EMERGING DISPLAY
TECHNOLOGIES CORPORATION

MODEL NO.

ET035013DMA

VERSION

2

PAGE

0-1

RECORDS OF REVISION

DOC . FIRST ISSUE

SEP.26, 2018

DATE

REVISED
PAGE
NO.

SUMMARY

NOV.12, 2018

1

2. MECHANICAL SPECIFICATIONS
ADD (4) VIEWING AREA: 71.6W * 54H mm

2

3.1 ELECTRICAL ABSOLUTE MAXIMUM RATINGS

ITEM	SYMBOL	MIN.	MAX.	UNIT	REMARK
LED BACKLIGHT POWER DISSIPATION	PD	—	(465)	mW	—
LED BACKLIGHT FORWARD CURRENT	I _{LED}	—	(30)	mA	—
LED BACKLIGHT REVERSE VOLTAGE	VR	—	(30)	V	—

ITEM	SYMBOL	MIN.	MAX.	UNIT	REMARK
LED BACKLIGHT POWER DISSIPATION	PD	—	465	mW	—
LED BACKLIGHT FORWARD CURRENT	I _{LED}	—	30	mA	—
LED BACKLIGHT REVERSE VOLTAGE	VR	—	30	V	—

10

7. OUTLINE DIMENSIONS
MARK △ : MODIFY POLARIZER DIMENSION & ADD PULL TAPE
ADD V.A. DIMENSION

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1. GENERAL SPECIFICATIONS

1.1 DATA SHEET FOR CONTROLLER/DRIVER

PLEASE REFER TO :

SITRONIX ST7272A-G4

1.2 MATERIAL SAFETY DESCRIPTION

ASSEMBLIES SHALL COMPLY WITH EUROPEAN ROHS REQUIREMENTS, INCLUDING PROHIBITED MATERIALS/COMPONENTS CONTAINING LEAD, MERCURY, CADMIUM, HEXAVALENT CHROMIUM, POLYBROMINATED BIPHENYLS (PBB) AND POLYBROMINATED DIPHENYL ETHERS (PBDE)

2. MECHANICAL SPECIFICATIONS

(1) DISPLAY SIZE	-----	3.5 inch
(2) NUMBER OF DOTS	-----	320W * (RGB) * 240H DOTS
(3) MODULE SIZE	-----	76.8W * 63.8H * 3.3D mm (WITHOUT FPC)
(4) VIEWING AREA	-----	71.6W * 54H mm
(5) ACTIVE AREA	-----	70.08W * 52.56H mm
(6) DOT SIZE	-----	0.073W * 0.219H mm
(7) PIXEL SIZE	-----	0.219W * 0.219H mm
(8) LCD TYPE	-----	TFT , TRANSMISSIVE, NORMALLY BLACK
(9) COLOR	-----	16.7M
(10) VIEWING DIRECTION	-----	SUPER WIDE VIEW
(11) BACK LIGHT	-----	LED , COLOR : WHITE
(12) INTERFACE MODE	-----	RGB 24BIT PARALLEL (DE/SYNC MODE)

3. ABSOLUTE MAXIMUM RATINGS

3.1 ELECTRICAL ABSOLUTE MAXIMUM RATINGS

ITEM	SYMBOL	MIN.	MAX.	UNIT	REMARK
POWER SUPPLY VOLTAGE	VDD	-0.3	4	V	—
IO SUPPLY VOLTAGE	VDDI	-0.3	4	V	—
STATIC ELECTRICITY	—	—	—	V	NOTE (1)
LED BACKLIGHT POWER DISSIPATION	PD	—	465	mW	—
LED BACKLIGHT FORWARD CURRENT	ILED	—	30	mA	—
LED BACKLIGHT REVERSE VOLTAGE	VR	—	30	V	—

NOTE (1) : LCM SHOULD BE GROUND DURING HANDLING LCM.

3.2 ENVIRONMENTAL ABSOLUTE MAXIMUM RATINGS

ITEM	OPERATING		STORAGE		REMARK
	MIN.	MAX.	MIN.	MAX.	
AMBIENT TEMPERATURE	-20°C	70°C	-30°C	80°C	NOTE (1) , (2)
HUMIDITY	NOTE (3)		NOTE (3)		WITHOUT CONDENSATION
VIBRATION	—	2.45m/s ² (0.25G)	—	11.76m/s ² (1.2G)	5~20Hz , 1HR 20~500Hz(20Hz) , 1HR 20~500Hz(500Hz) , 1HR X,Y,Z,TOTAL 3HRS
SHOCK	—	29.4m/s ² (3G)	—	490m/s ² (50G)	10 ms XYZ DIRECTIONS 1 TIME EACH
CORROSIVE GAS	NOT ACCEPTABLE		NOT ACCEPTABLE		

NOTE (1) : Ta AT -30°C : WILL BE 48HRS MAX .

80°C : WILL BE 168HRS MAX .

NOTE (2) : BACKGROUND COLOR CHANGES SLIGHTLY DEPENDING ON AMBIENT TEMPERATURE THIS PHENOMENON IS REVERSIBLE .

NOTE (3) : Ta ≤ 60°C : 90%RH MAX (96HRS MAX).

Ta > 60°C : ABSOLUTE HUMIDITY MUST BE LOWER THAN THE HUMIDITY OF 90%RH AT 60°C(96HRS MAX).

4. ELECTRICAL CHARACTERISTICS

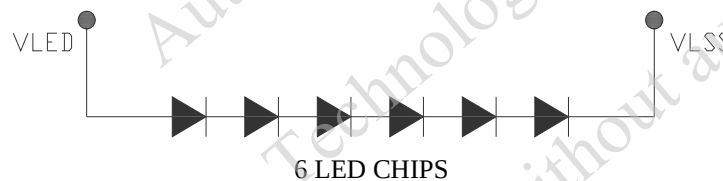
Ta = 25 °C

ITEM	SYMBOL	CONDITION	MIN.	TYP.	MAX.	UNIT	REMARK
ANALOG POWER SUPPLY	VDD	—	3.0	3.3	3.6	V	
DIGITAL POWER SUPPLY	VDDI	—	3.0	3.3	3.6	V	
LOGIC HIGH INPUT VOLTAGE	VIH	H LEVEL	0.7VDDI	—	—	V	NOTE (1)
LOGIC LOW INPUT VOLTAGE	VIL	L LEVEL	—	—	0.3VDDI	V	NOTE (1)
LOGIC HIGH OUTPUT VOLTAGE	VOH	IOL=-1.0mA	VDDI-0.4	—	VDDI	V	
LOGIC LOW OUTPUT VOLTAGE	VOL	IOL=+1.0mA	VSS	—	VSS+0.4	V	
ANALOG OPERATING CURRENT	IDD	VDD=3.3V	—	20	30	mA	NOTE (2)
DIGITAL OPERATING CURRENT	IDDI	VDDI=3.3V	—	1	2	mA	NOTE (2)
POWER SUPPLY FOR LED BACKLIGHT	VLED-VLSS	ILED=20mA	—	18.0	18.6	V	NOTE (1)
LED LIFE TIME	—	ILED=20mA	30K	40K	—	HRS	NOTE (5) NOTE (6)

NOTE (1) : APPLIED TO TERMINALS /RESET, B7~B0, G7~G0, R7~R0, DCLK, HSYNC, VSYNC, ENB, SHUT.

NOTE (2) : THE DISPLAY PATTERN IS ALL "WHITE".

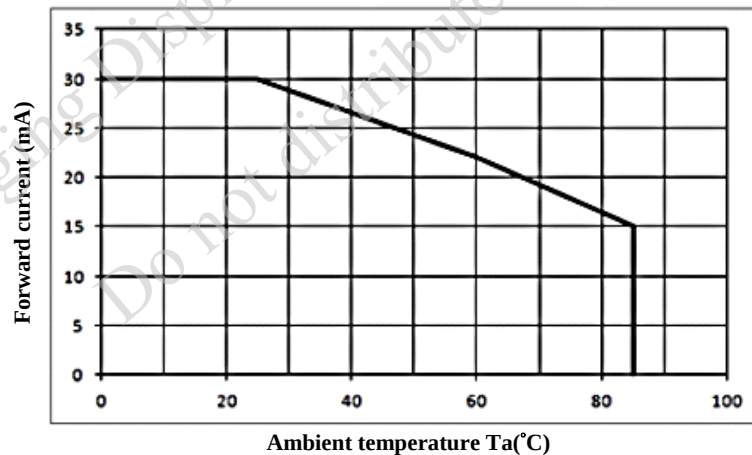
NOTE (3) : INTERNAL CIRCUIT DIAGRAM OF BACKLIGHT



6 LED CHIPS

NOTE (4) : AMBIENT TEMP .VS. ALLOWABLE FORWARD CURRENT.(PER LED)

Forward current derating curve VS.Ambient temperature



NOTE (5) : CONDITIONS; TA=25 °C, CONTINUOUS LIGHTING.

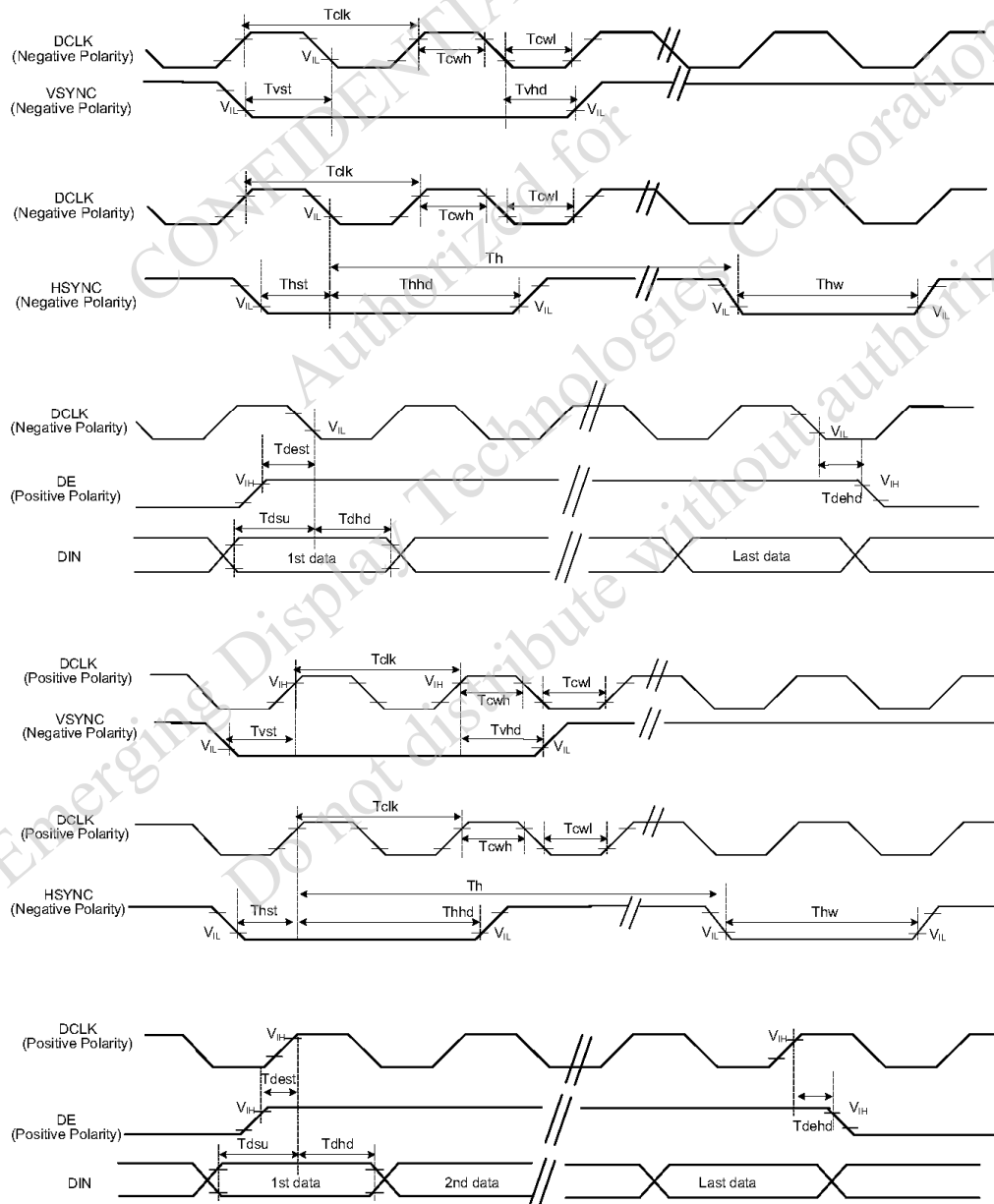
NOTE (6) : DEFINITIONS OF LIFE TIME :

LCM LUMINANCE BECOMES HALF OF THE INITIAL VALUE.

5. TIMING CHARACTERISTICS

5.1 PIXEL TIMING

ITEM	SYMBOL	MIN.	TYP.	MAX.	UNIT
CLK PULSE DUTY	Tclk	40	50	60	%
HSYNC WIDTH	Thw	2	—	—	DCLK
HSYNC PERIOD	Th	55	60	65	us
VSYNC SETUP TIME	Tvst	12	—	—	ns
VSYNC HOLD TIME	Tvhd	12	—	—	ns
HSYNC SETUP TIME	Thst	12	—	—	ns
HSYNC HOLD TIME	Thhd	12	—	—	ns
DATA SETUP TIME	Tdsu	12	—	—	ns
DATA HOLD TIME	Tdhd	12	—	—	ns
DE SETUP TIME	Tdest	12	—	—	ns
DE HOLD TIME	Tdehd	12	—	—	ns

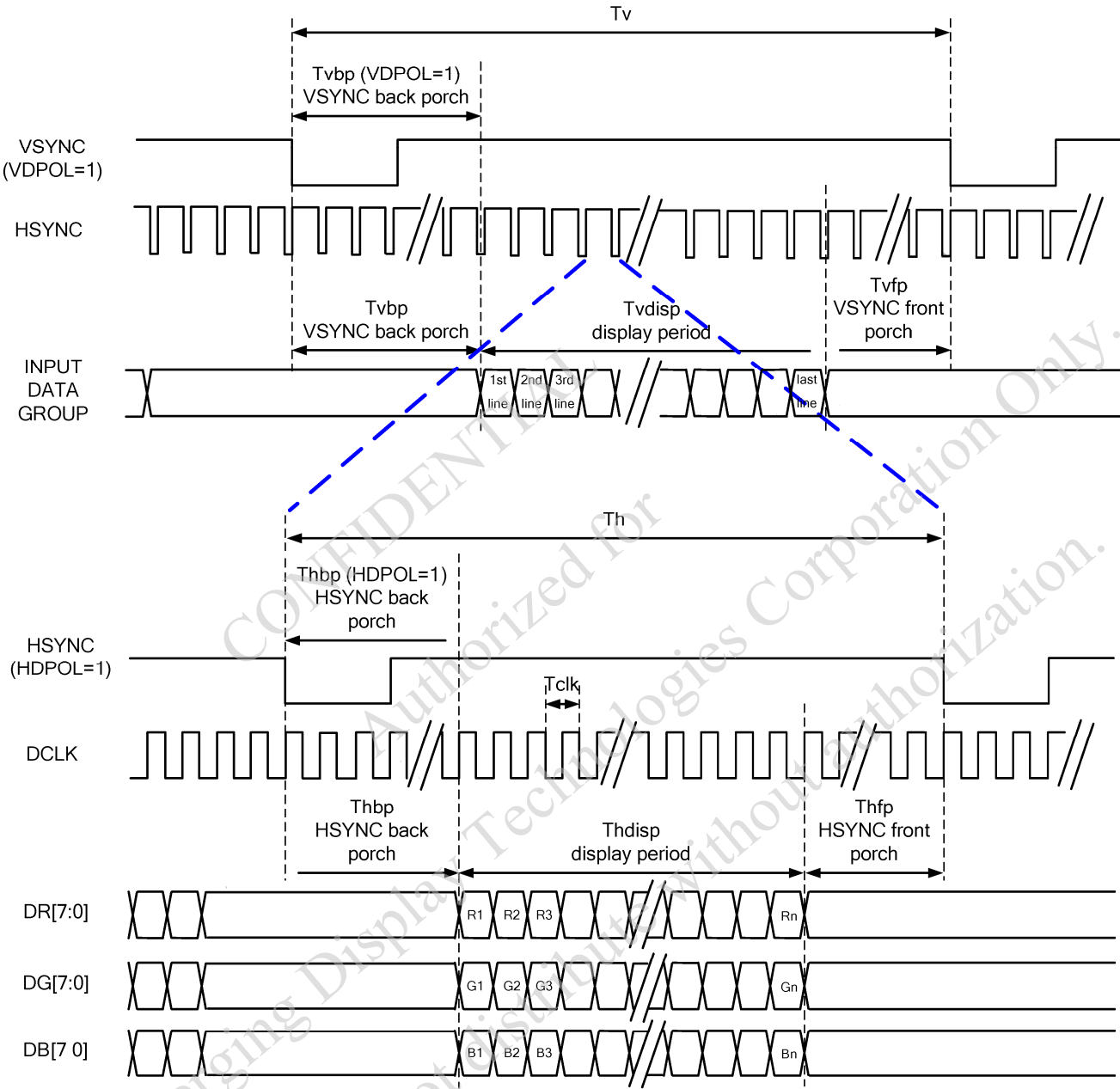


5.2 PARALLEL 24-bit RGB INPUT TIMING TABLE

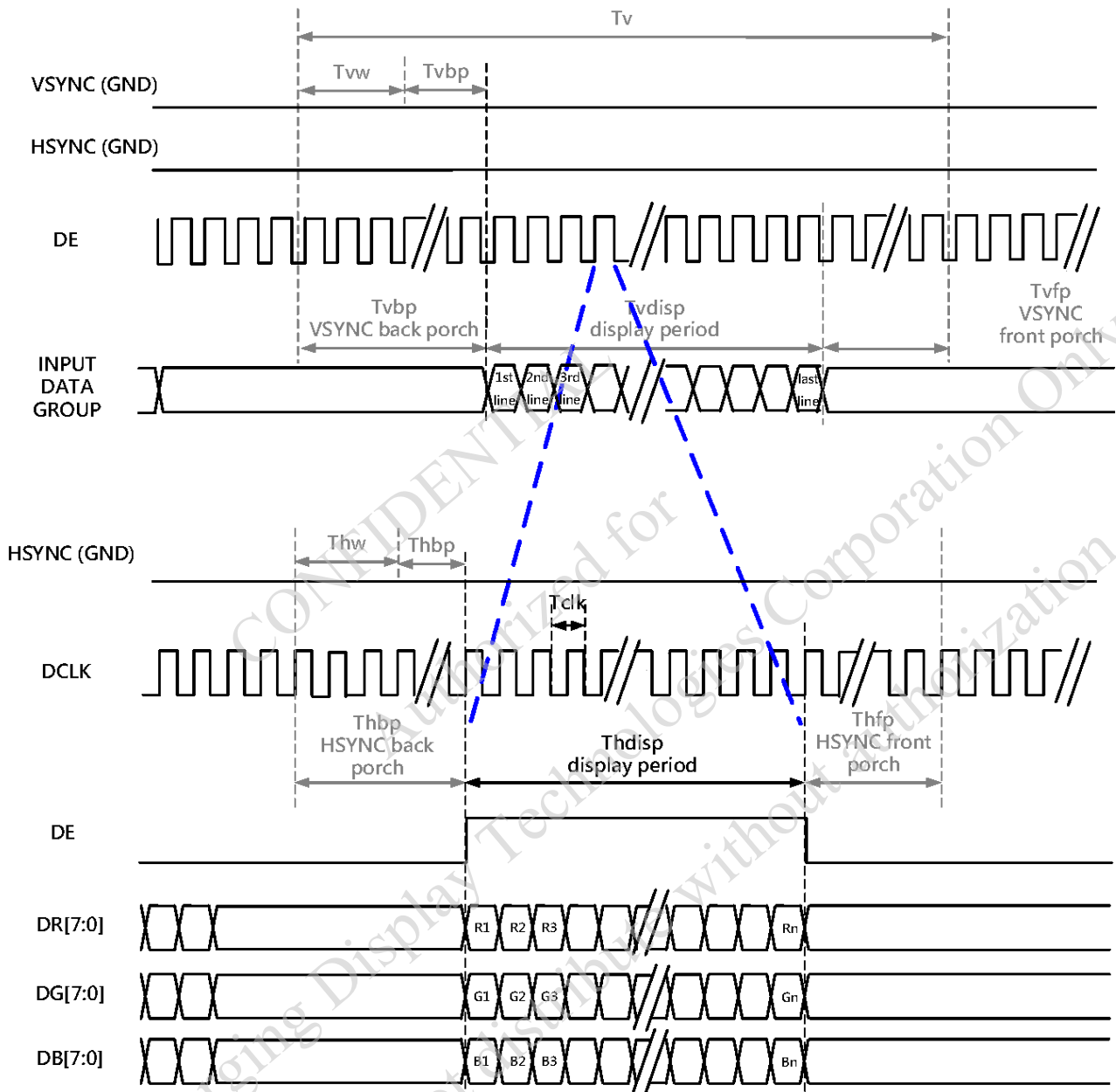
ITEM	SYMBOL	MIN.	TYP.	MAX.	UNIT	NOTE
DCLK FREQUENCY	Fclk	5	6	8	MHz	
DCLK PERIOD	Tclk	125	167	200	ns	
HSYNC	PERIOD TIME	Th	325	371	438	DCLK
	DISPLAY PERIOD	Thdisp	—	320	—	DCLK
	BACK PORCH	Thbp	3	43	43	DCLK
	FRONT PORCH	Thfp	2	8	75	DCLK
	PULSE WIDTH	Thw	2	4	43	DCLK
VSYNC	PERIOD TIME	Tv	244	260	289	HSYNC
	DISPLAY PERIOD	Tvdisp	—	240	—	HSYNC
	BACK PORCH	Tvbp	2	12	12	HSYNC
	FRONT PORCH	Tvfp	2	8	37	HSYNC
	PULSE WIDTH	Tvw	2	4	12	HSYNC

NOTE: IT IS NECESSARY TO KEEP Tvbp =12 AND Thbp =43 IN SYNC MODE. DE MODE IS UNNECESSARY TO KEEP IT.

5.3 PARALLEL RGB INTERFACE (SYNC MODE)



5.4 PARALLEL RGB INTERFACE (DE MODE)



6. OPTICAL CHARACTERISTICS (NOTE 1)

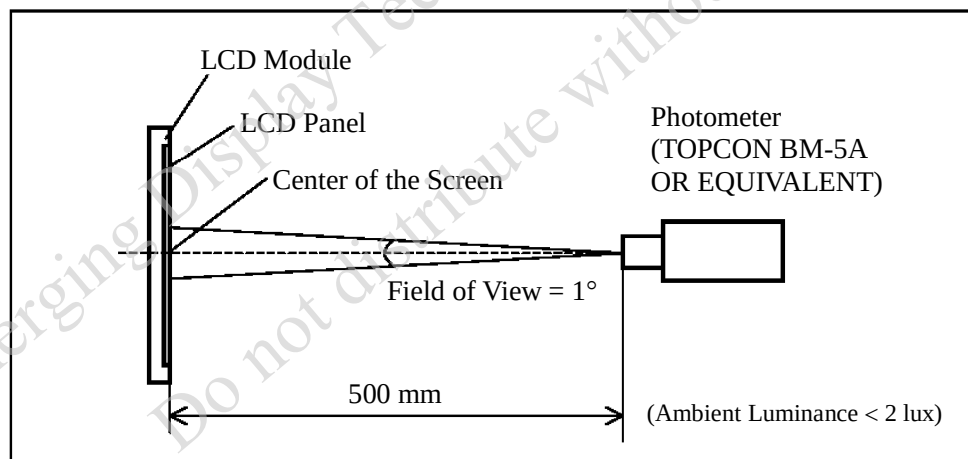
6.1 OPTICAL CHARACTERISTICS

Ta=25±2°C

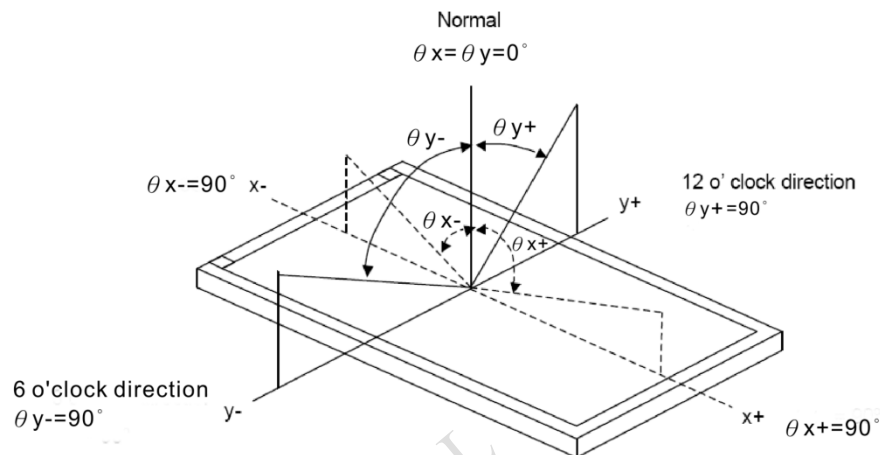
ITEM		SYMBOL	CONDITION		MIN.	TYP.	MAX.	UNIT	REMARK
VIEWING ANGLE		θy+	CR≥10	θx=0°	70	80	—	deg	NOTE (2) NOTE (3)
		θy-			70	80	—	deg	
		θx+		θy=0°	70	80	—	deg	
		θx-			70	80	—	deg	
CONTRAST RATIO (CENTER)		CR	θx=0°, θy=0°		600	800	—	—	NOTE (3)
RESPONSE TIME		T _R (rise)			—	10	20	msec	NOTE (4)
		T _F (fall)			—	15	30	msec	NOTE (4)
COLOR OF CIE COORDINATE (CENTER)	WHITE	W _x	θx=0°, θy=0° VDD=3.3V VDD1=3.3V ILED=20mA	0.28	0.33	0.38	—	NOTE (5)	
		W _y		0.30	0.35	0.40			
	RED	R _x		0.57	0.62	0.67	—		
		R _y		0.30	0.35	0.40			
	GREEN	G _x		0.32	0.37	0.42	—		
		G _y		0.54	0.59	0.64			
	BLUE	B _x		0.09	0.14	0.19	—		
		B _y		0.03	0.08	0.13			
THE BRIGHTNESS OF MODULE(CENTER)		B		450	500	—	cd/m ²	NOTE (6)	
THE UNIFORMITY OF MODULE		—		70	—	—	%	NOTE (6)	

NOTE (1) : TEST EQUIPMENT SETUP :

AFTER STABILIZING AND LEAVING THE PANEL ALONE AT A GIVEN TEMPERATURE FOR 30 MINUTES. MEASUREMENT SHOULD BE EXECUTED IN A STABLE, WINDLESS, AND DARK ROOM.



NOTE (2) : DEFINITION OF VIEWING ANGLE :



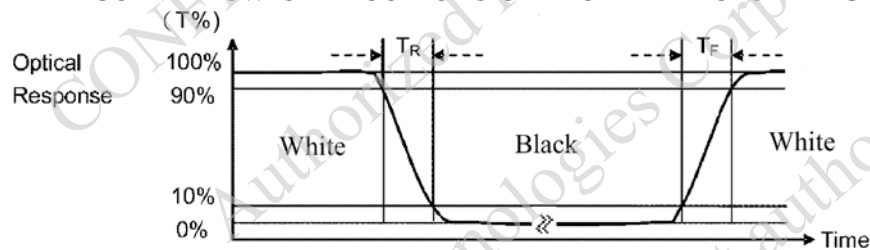
NOTE (3) : DEFINITION OF CONTRAST RATIO (CR) :

MEASURED AT THE CENTER POINT OF MODULE

$$\text{CONTRAST RATIO (CR)} = \frac{\text{BRIGHTNESS MEASURED WHEN LCD IS AT "WHITE STATE"}}{\text{BRIGHTNESS MEASURED WHEN LCD IS AT "BLACK STATE"}}$$

NOTE (4) : DEFINITION OF RESPONSE TIME : T_R AND T_F

THE FIGURE BELOW IS THE OUTPUT SIGNAL OF THE PHOTO DETECTOR.



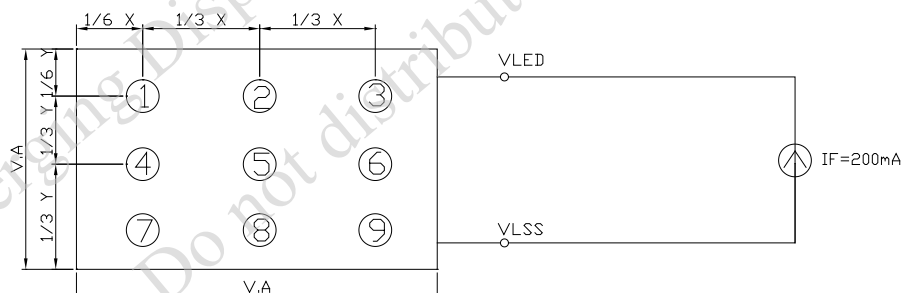
NOTE (5) : DEFINITION OF COLOR CHROMATICITY

(a) THE 100% TRANSMISSION IS DEFINED AS THE TRANSMISSION OF LCD PANEL WHEN ALL THE INPUT TERMINALS OF MODULE ARE ELECTRICALLY POWERED ON.

(b) MEASURED AT THE CENTER POINT OF MODULE

NOTE (6) : MEASURED THE BRIGHTNESS OF WHITE STATE AT CENTER POINT.

NOTE (7) : (a) DEFINITION OF BRIGHTNESS UNIFORMITY

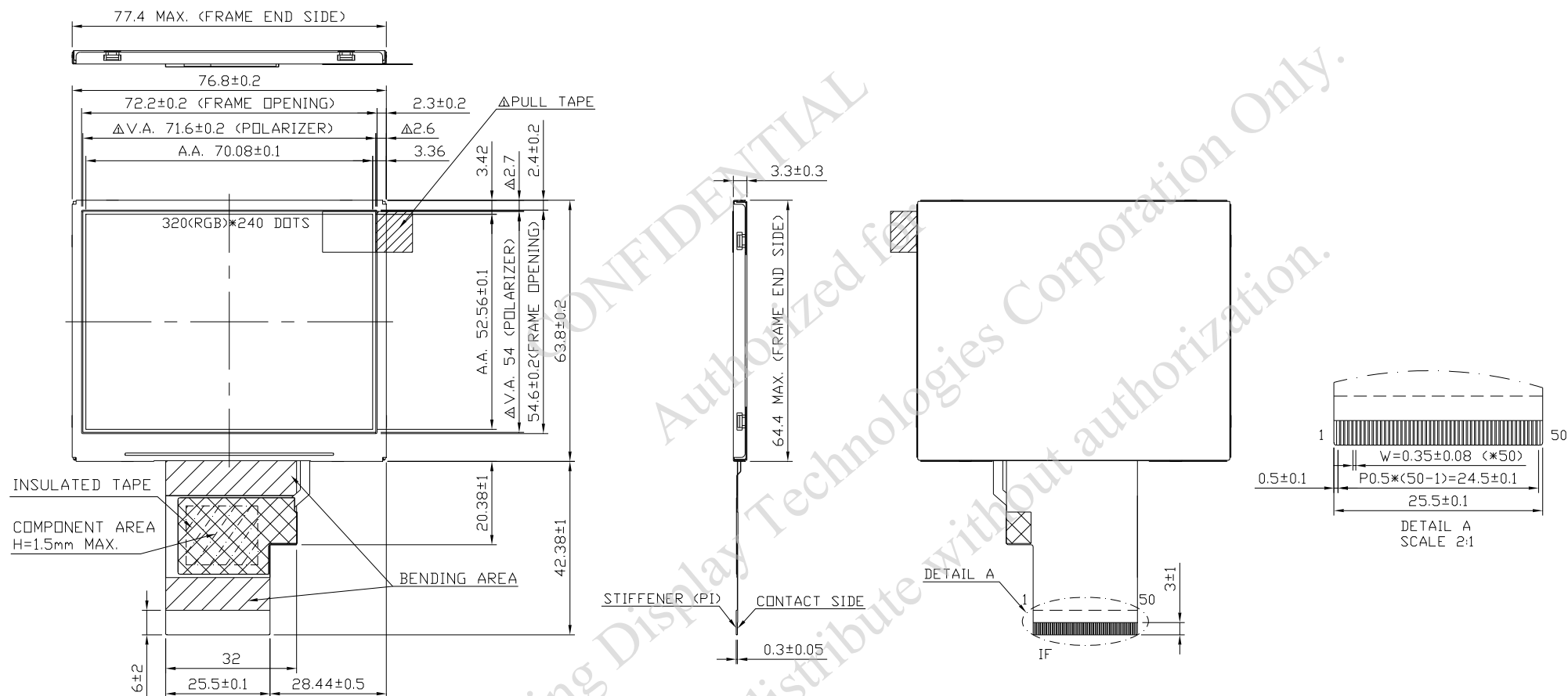


UNIT : mm

(b) THE BRIGHTNESS UNIFORMITY CALCULATING METHOD

$$\text{UNIFORMITY} = \frac{\text{MINIMUM BRIGHTNESS}}{\text{MAXIMUM BRIGHTNESS}} \times 100\%$$

7. OUTLINE DIMENSIONS



UNIT : mm

SCALE : NTS

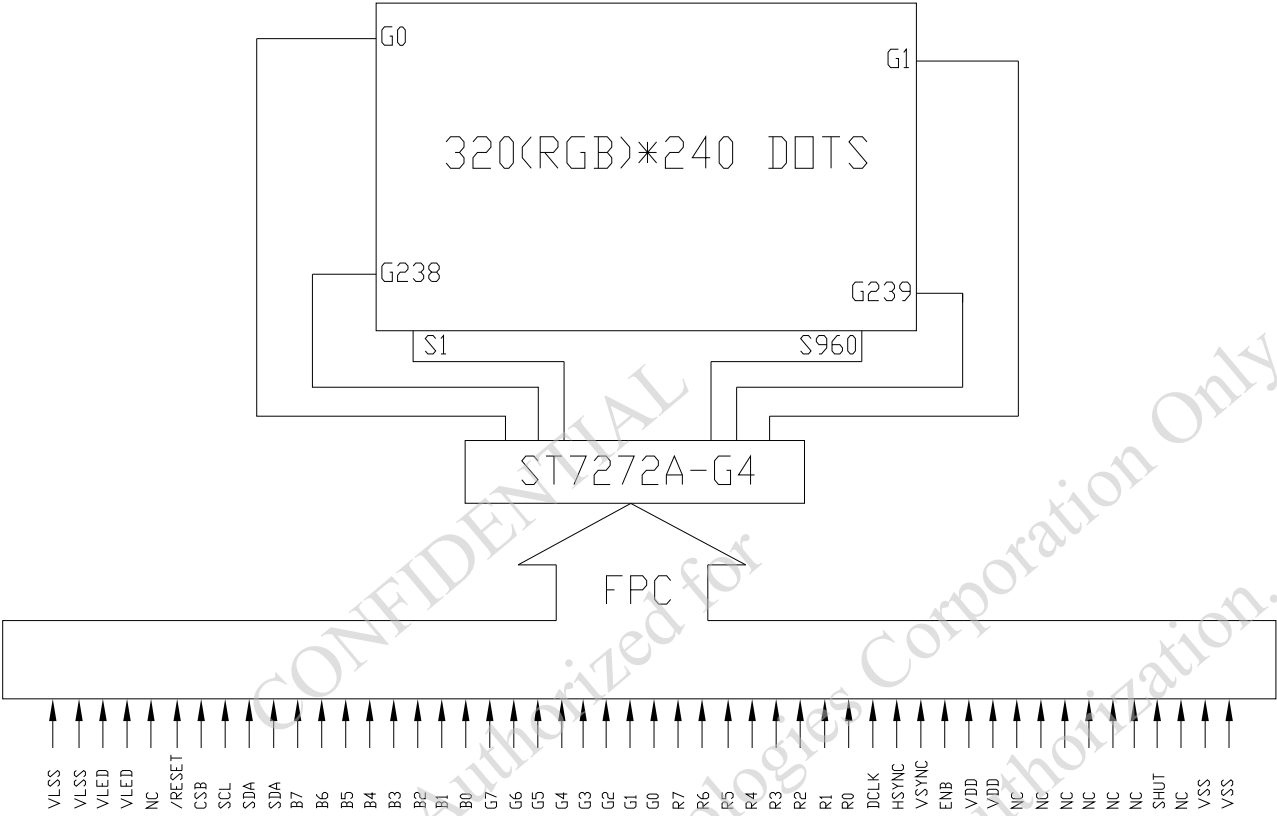
NOT SPECIFIED LENGTH TOLERANCE IS $\pm$ 0.3

NOTE :

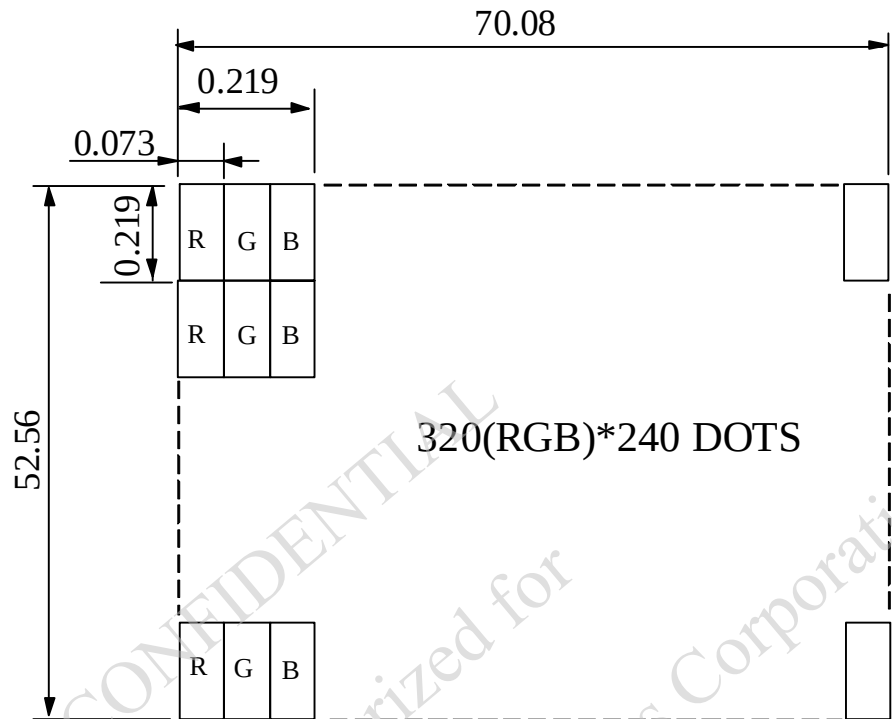
1.RECOMMEND MATCH CONNECTOR KYOCERA:04 6299 050 SERIES

2.MARK Δ MODIFY (NUMBER NOTE MODIFY VERSION)

8. BLOCK DIMENSION



9. DETAIL DRAWING OF DOT MATRIX



UNIT : mm
SCALE : NTS
NOT SPECIFIED TOLERANCE IS ± 0.1
DOTS MATRIX TOLERANCE IS ± 0.01

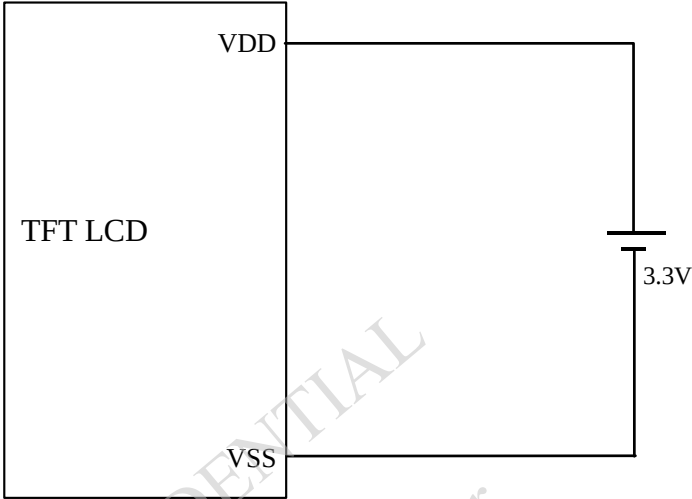
10. INTERFACE SIGNALS

PIN NO.	SYMBOL	I/O/P	FUNCTION
1	VLSS	P	POWER SUPPLY FOR LED BACKLIGHT (CATHODE)
2	VLSS	P	POWER SUPPLY FOR LED BACKLIGHT (CATHODE)
3	VLED	P	POWER SUPPLY FOR LED BACKLIGHT (ANODE)
4	VLED	P	POWER SUPPLY FOR LED BACKLIGHT (ANODE)
5	NC	—	NON CONNECTION
6	/RESET	I	HARDWARE RESET
7	CSB	I	SPI INTERFACE CHIP SELECT BAR
8	SCL	I	SPI INTERFACE DATA CLOCK
9	SDA	I	SPI INTERFACE DATA
10	SDA	O	SPI INTERFACE DATA
11	B7	I	BLUE DATA BIT 7
12	B6	I	BLUE DATA BIT 6
13	B5	I	BLUE DATA BIT 5
14	B4	I	BLUE DATA BIT 4
15	B3	I	BLUE DATA BIT 3
16	B2	I	BLUE DATA BIT 2
17	B1	I	BLUE DATA BIT 1
18	B0	I	BLUE DATA BIT 0
19	G7	I	GREEN DATA BIT 7
20	G6	I	GREEN DATA BIT 6
21	G5	I	GREEN DATA BIT 5
22	G4	I	GREEN DATA BIT 4
23	G3	I	GREEN DATA BIT 3
24	G2	I	GREEN DATA BIT 2
25	G1	I	GREEN DATA BIT 1
26	G0	I	GREEN DATA BIT 0
27	R7	I	RED DATA BIT 7
28	R6	I	RED DATA BIT 6
29	R5	I	RED DATA BIT 5
30	R4	I	RED DATA BIT 4
31	R3	I	RED DATA BIT 3
32	R2	I	RED DATA BIT 2
33	R1	I	RED DATA BIT 1
34	R0	I	RED DATA BIT 0
35	DCLK	I	DOT DATA CLOCK

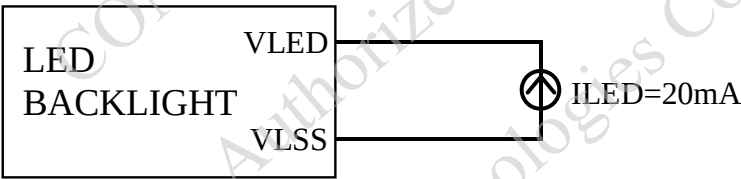
PIN NO.	SYMBOL	I/O/P	FUNCTION	
36	HSYNC	I	HORIZONTAL SYNC INPUT	DE MODE : HSYNC, VSYNC FLOATING SYNC MODE : ENB FLOATING
37	VSYNC	I	VERTICAL SYNC INPUT	
38	ENB	I	DATA ENABLE INPUT	
39	VDD	P	ANALOG POWER SUPPLY	
40	VDD	P	ANALOG POWER SUPPLY	
41	NC	—	NON CONNECTION	
42	NC	—	NON CONNECTION	
43	NC	—	NON CONNECTION	
44	NC	—	NON CONNECTION	
45	NC	—	NON CONNECTION	
46	NC	—	NON CONNECTION	
47	SHUT	I	DISPLAY SHUT DOWN PIN TO PUT THE DRIVER INTO SLEEP MODE. CONNECT TO VCC FOR SLEEP MODE. CONNECT TO VSS FOR NORMAL OPERATING MODE.	
48	NC	—	NON CONNECTION	
49	VSS	P	GROUND	
50	VSS	P	GROUND	

11. POWER SUPPLY

11.1 POWER SUPPLY FOR LCM



11.2 POWER SUPPLY FOR LED BACKLIGHT



12. INSPECTION CRITERIOIN

12.1 APPLICATION

THIS INSPECTION STANDARD IS TO BE APPLIED TO THE LCD MODULE DELIVERED FROM EMERGING DISPLAY TECHNOLOGIES CORP.(E.D.T) TO CUSTOMERS

12.2 INSPECTION CONDITIONS

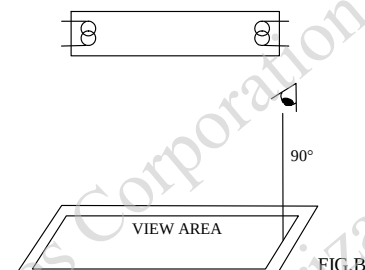
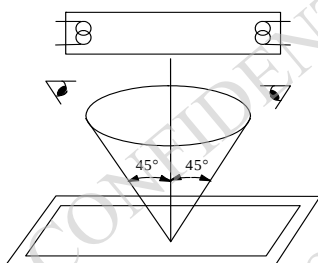
12.2.1 (1)OBSERVATION DISTANCE : 45 ± 5 cm

(2)VIEWING ANGLE : $\pm 45^\circ$

$\pm 15^\circ$ (FOR SECTION WITHIN VIEWING AREA), REFER TO FIG.A

90° (FOR SECTION OUTSIDE OF VIEWING AREA), REF TO FIG.B
PERPENDICULAR TO MODULE SURFACE

VIEWING ANGLE SHOULD BE SMALLER THAN 45°



THE INSPECTION CRITERIA IS ACCORDING TO LINE OF SIGHT. INSPECTION SHALL BE MADE WITHIN THE HALF SECTION OF THE VIEWING CONE GENERATED BY LINE SEGMENT OF 45° WITH RESPECTS TO THE VERTICAL AXIS FROM CENTER VERTEX OF LCD, THE FLUORESCENT LAMP AND THE CONE AXIS MUST BE PERPENDICULAR TO THE LCD SURFACE.

IF THE DEFECTS ARE OUTSIDE OF VIEWING AREA, IT SHALL BE INSPECTED BY 90° WITH RESPECTS TO THE VERTICAL AXIS FROM EDGE OF VIEWING AREA.

12.2.2 ENVIRONMENT CONDITIONS :

AMBIENT TEMPERATURE		$25 \pm 5^\circ\text{C}$
AMBIENT HUMIDITY		$65 \pm 20\% \text{RH}$
AMBIENT ILLUMINATION	COSMETIC INSPECTION	600~800 Lux
	FUNCTIONAL INSPECTION	300~500 Lux
INSPECTION TIME		10 secs

12.2.3 INSPECTION LOT

QUANTITY PER DELIVERY LOT FOR EACH MODEL

12.2.4 INSPECTION METHOD

A SAMPLING INSPECTION SHALL BE MADE ACCORDING TO THE FOLLOWING PROVISIONS TO JUDGE THE ACCEPTABILITY

(a)APPLICABLE STANDARD :

ANSI/ ASQ Z1.4 NORMAL INSPECTION LEVEL II

(b)AQL : MAJOR DEFECT : AQL 0.65

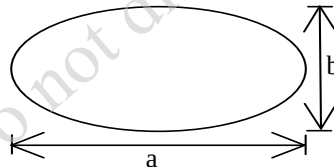
MINOR DEFECT : AQL 1.0

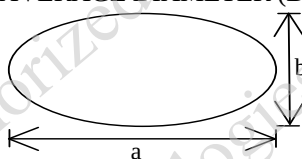
12.3 INSPECTION STANDARDS

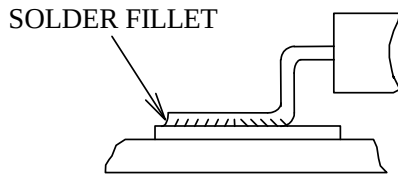
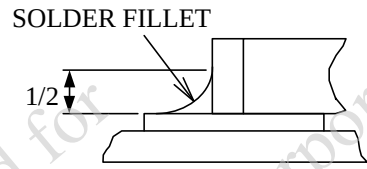
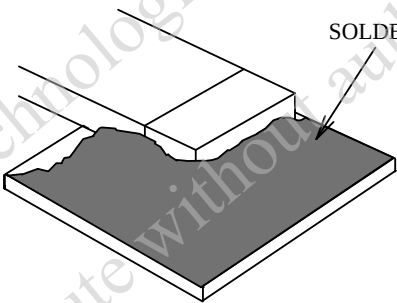
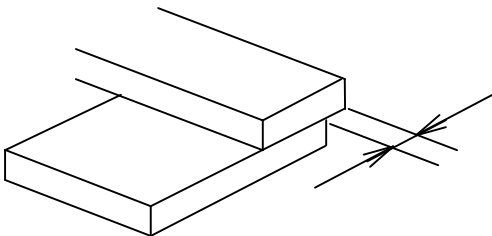
12.3.1 VISUAL DEFECTS CLASSIFICATION

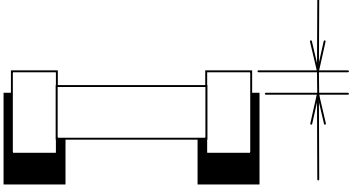
TYPE OF DEFECT	INSPECTION ITEM	DEFECT FEATURE	AQL
MAJOR DEFECT	1.DISPLAY ON	• DEFECT TO MISS SPECIFIED DISPLAY FUNCTION, FOR ALL AND SPECIFIED DOTS - EX: DISCONNECTION, SHORT CIRCUIT ETC	0.65
	2.BACKLIGHT	• NO LIGHT • FLICKERING AND OTHER ABNORMAL ILLUMINATION	
	3.DIMENSIONS	• SUBJECT TO INDIVIDUAL ACCEPTANCE SPECIFICATIONS	
MINOR DEFECT	1.DISPLAY ZONE	• BLACK/WHITE SPOT • BUBBLES ON POLARIZER • NEWTON RING • BLACK/WHITE LINE • SCRATCH • CONTAMINATION • UNEVEN COLOR SPREAD	1.0
	2.BEZEL ZONE	• STAINS • SCRATCHES • FOREIGN MATTER	
	3.SOLDERING	• INSUFFICIENT SOLDER • SOLDERED IN INCORRECT POSITION • CONVEX SOLDERING SPOT • SOLDER BALLS • SOLDER SCRAPS	
	4.DISPLAY ON (ALL ON)	• LIGHT LINE	

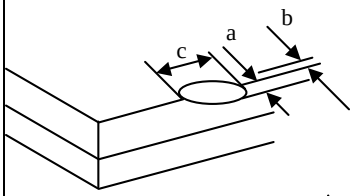
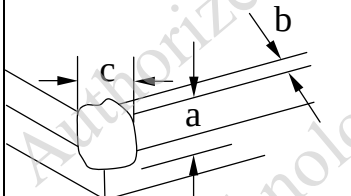
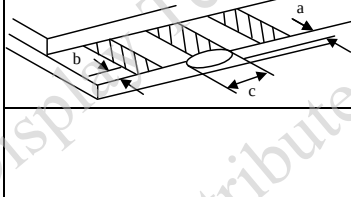
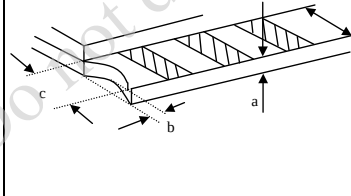
12.3.2 MODULE DEFECTS CLASSIFICATION

NO.	ITEM	CRITERIA												
1	DISPLAY ON INSPECTION	(1)INCORRECT PATTERN (2)MISSING SEGMENT (3)DIM SEGMENT (4)OPERATING VOLTAGE BEYOND SPEC												
2	OVERALL DIMENSIONS	(1)OVERALL DIMENSION BEYOND SPEC												
3	DOT DEFECT	(1)INSPECTION PATTERN: FULL WHITE, FULL BLACK, RED, GREEN AND BLUE SCREENS. (2) <table><tr><th>ITEMS</th><th>ACCEPTABLE COUNT</th></tr><tr><td>BRIGHT DOT</td><td>$N \leq 2$</td></tr><tr><td>DARK DOT</td><td>$N \leq 3$</td></tr><tr><td>TOTAL BRIGHT AND DARK DOTS</td><td>$N \leq 4$</td></tr></table> NOTE : 1. THE DEFINITION OF DOT : THE SIZE OF A DEFECTIVE DOT OVER 1/2 OF WHOLE DOT IS REGARDED AS ONE DEFECTIVE DOT. 2. BRIGHT DOT : DOTS APPEAR BRIGHT AND UNCHANGED IN SIZE IN WHICH LCD PANEL IS DISPLAYING UNDER BLACK PATTERN. 3. DARK DOT : DOTS APPEAR DARK AND UNCHANGED IN SIZE IN WHICH LCD PANEL IS DISPLAYING UNDER PURE RED, GREEN, BLUE PICTURE.	ITEMS	ACCEPTABLE COUNT	BRIGHT DOT	$N \leq 2$	DARK DOT	$N \leq 3$	TOTAL BRIGHT AND DARK DOTS	$N \leq 4$				
ITEMS	ACCEPTABLE COUNT													
BRIGHT DOT	$N \leq 2$													
DARK DOT	$N \leq 3$													
TOTAL BRIGHT AND DARK DOTS	$N \leq 4$													
4	FOREIGN BLACK/WHITE/ BRIGHT LINE/ SCRATCH OF VIEWING AREA	<table><tr><th>LENGTH : L</th><th>WIDTH : W</th><th>PERMISSIBLE NO.</th></tr><tr><td>$L \leq 0.3$</td><td>$W \leq 0.05$</td><td>IGNORE</td></tr><tr><td>$0.3 < L \leq 3.0$</td><td>$0.05 < W \leq 0.1$</td><td>4</td></tr><tr><td>$3.0 < L$</td><td>$0.1 < W$</td><td>NONE</td></tr></table> WIDTH : W mm, LENGTH : L mm	LENGTH : L	WIDTH : W	PERMISSIBLE NO.	$L \leq 0.3$	$W \leq 0.05$	IGNORE	$0.3 < L \leq 3.0$	$0.05 < W \leq 0.1$	4	$3.0 < L$	$0.1 < W$	NONE
LENGTH : L	WIDTH : W	PERMISSIBLE NO.												
$L \leq 0.3$	$W \leq 0.05$	IGNORE												
$0.3 < L \leq 3.0$	$0.05 < W \leq 0.1$	4												
$3.0 < L$	$0.1 < W$	NONE												
5	FOREIGN MATTER \ BLACK SPOTS \ WHITE SPOTS \ DENT (INCLUDING LIGHT LEAKAGE DUE TO POLARIZING PLATES PINHOLES, ETC.)	<table><tr><th>AVERAGE DIAMETER (mm): D</th><th>NUMBER OF PIECES PERMITTED</th></tr><tr><td>$D \leq 0.15$</td><td>IGNORE</td></tr><tr><td>$0.15 < D \leq 0.5$</td><td>4</td></tr><tr><td>$0.5 < D$</td><td>NONE</td></tr></table> NOTE : DIAMETER $D=(a+b)/2$ 	AVERAGE DIAMETER (mm): D	NUMBER OF PIECES PERMITTED	$D \leq 0.15$	IGNORE	$0.15 < D \leq 0.5$	4	$0.5 < D$	NONE				
AVERAGE DIAMETER (mm): D	NUMBER OF PIECES PERMITTED													
$D \leq 0.15$	IGNORE													
$0.15 < D \leq 0.5$	4													
$0.5 < D$	NONE													

NO.	ITEM	CRITERIA																								
6	BUBBLES OF POLARIZER /DIRT/DENT /SURFACE STAINS/ CF FAIL	<table><tr><td></td><td>AVERAGE DIAMETER (mm) : D</td><td>NUMBER OF PIECES PERMITTED</td></tr><tr><td rowspan="3">BUBBLE ON THE POLARIZER</td><td>D ≤ 0.25</td><td>IGNORE</td></tr><tr><td>0.25 < D ≤ 0.5</td><td>N ≤ 5</td></tr><tr><td>0.5 < D</td><td>NONE</td></tr><tr><td rowspan="3">DIRT / DENT / SURFACE STAINS</td><td>D < 0.25</td><td>IGNORE</td></tr><tr><td>0.25 < D ≤ 0.35</td><td>N ≤ 3</td></tr><tr><td>0.35 < D</td><td>NONE</td></tr><tr><td rowspan="3">CF FAIL / SPOT</td><td>D < 0.1</td><td>IGNORE</td></tr><tr><td>0.1 < D ≤ 0.3</td><td>N ≤ 3</td></tr><tr><td>0.3 < D</td><td>NONE</td></tr></table>		AVERAGE DIAMETER (mm) : D	NUMBER OF PIECES PERMITTED	BUBBLE ON THE POLARIZER	D ≤ 0.25	IGNORE	0.25 < D ≤ 0.5	N ≤ 5	0.5 < D	NONE	DIRT / DENT / SURFACE STAINS	D < 0.25	IGNORE	0.25 < D ≤ 0.35	N ≤ 3	0.35 < D	NONE	CF FAIL / SPOT	D < 0.1	IGNORE	0.1 < D ≤ 0.3	N ≤ 3	0.3 < D	NONE
			AVERAGE DIAMETER (mm) : D	NUMBER OF PIECES PERMITTED																						
		BUBBLE ON THE POLARIZER	D ≤ 0.25	IGNORE																						
			0.25 < D ≤ 0.5	N ≤ 5																						
			0.5 < D	NONE																						
		DIRT / DENT / SURFACE STAINS	D < 0.25	IGNORE																						
			0.25 < D ≤ 0.35	N ≤ 3																						
			0.35 < D	NONE																						
		CF FAIL / SPOT	D < 0.1	IGNORE																						
			0.1 < D ≤ 0.3	N ≤ 3																						
0.3 < D	NONE																									
NOTE : (1)POLARIZER BUBBLE IS DEFINED AS THE BUBBLE APPEARS ON ACTIVE DISPLAY AREA. THE DEFECT OF POLARIZER BUBBLE SHALL BE IGNORED IF THE POLARIZER BUBBLE APPEARS ON THE OUTSIDE OF ACTIVE DISPLAY AREA. (2)THE EXTRANEIOUS SUBSTANCE IS DEFINED AS IT CAN BE OBSERVED WHEN THE MODULE IS POWER ON. (3)THE DEFINITION OF AVERAGE DIAMETER, D IS DEFINED AS FOLLOWING. AVERAGE DIAMETER (D)=(a+b)/2																										
																										
7	LINE DEFECT ON DISPLAY	OBVIOUS VERTICAL OR HORIZONTAL LINE DEFECT IS NOT ALLOWED																								
8	MURA ON DISPLAY	IT'S OK IF MURA IS SLIGHT VISIBLE THROUGH 5% ND FILTER																								
9	UNEVEN COLOR SPREAD, COLORATION	(1)TO BE DETERMINED BASED UPON THE STANDARD SAMPLE.																								
10	BEZEL APPEARANCE	(1)BEZEL MAY NOT HAVE RUST, BE DEFORMED OR HAVE FINGER PRINTS STAINS OF OTHER CONTAMINATION. (2)BEZEL MUST COMPLY WITH JOB SPECIFICATIONS.																								
11	PCB	(1)THERE MAY NOT BE MORE THAN 2mm OF SEALANT OUTSIDE THE SEAL AREA ON THE PCB, AND THERE SHOULD BE NO MORE THAN THREE PLACES. (2)NO OXIDATION OR CONTAMINATION PCB TERMINALS. (3)PARTS ON PCB MUST BE THE SAME AS ON THE PRODUCTION CHARACTERISTIC CHART. THERE SHOULD BE NO WRONG PARTS, MISSING PARTS OR EXCESS PARTS. (4)THE JUMPER ON THE PCB SHOULD CONFORM TO THE PRODUCT CHARACTERISTIC CHART. (5)IF SOLDER GETS ON BEZEL TAB PADS, LED PAD, ZEBRA PAD OR SCREW HOLD PAD, MAKE SURE IT IS SMOOTHED DOWN.																								

NO.	ITEM	CRITERIA
12	SOLDERING	(1)NO SOLDERING FOUND ON THE SPECIFIED PLACE (2)INSUFFICIENT SOLDER (a)LSI, IC A POOR WETTING OF SOLDER IS BETWEEN LOWER BEND OR "HEEL" OF LEAD AND PAD  (b)CHIP COMPONENT · SOLDER IS LESS THAN 50% OF SIDES AND FRONT FACE WETTING  · SOLDER WETS 3 SIDES OF TERMINAL, BUT LESS THAN 25% OF SIDES AND FRONT SURFACE AREA ARE COVERED  (3)PARTS ALIGNMENT (a)LSI, IC LEAD WIDTH IS MORE THAN 50% BEYOND PAD OUTLINE 

NO.	ITEM	CRITERIA
12	SOLDERING	(b)CHIP COMPONENT COMPONENT IS OFF CENTER, AND MORE THAN 50% OF THE LEADS IS OFF THE PAD OUTLINE  (4)NO UNMELTED SOLDER PASTE MAY BE PRESENT ON THE PCB. (5)NO COLD SOLDER JOINTS, MISSING SOLDER CONNECTIONS, OXIDATION OR ICICLE. (6)NO RESIDUE OR SOLDER BALLS ON PCB. (7)NO SHORT CIRCUITS IN COMPONENTS ON PCB.
13	BACKLIGHT	(1)NO LIGHT (2)FLICKERING AND OTHER ABNORMAL ILLUMINATION (3)SPOTS OR SCRATCHES THAT APPEAR WHEN LIT MUST BE JUDGED USING LCD SPOT, LINES AND CONTAMINATION STANDARDS. (4)BACKLIGHT DOESN'T LIGHT OR COLOR IS WRONG.
14	GENERAL APPEARANCE	(1)NO OXIDATION, CONTAMINATION, CURVES OR, BENDS ON INTERFACE PIN (OLB) OF TCP. (2)NO CRACKS ON INTERFACE PIN (OLB) OF TCP. (3)NO CONTAMINATION, SOLDER RESIDUE OR SOLDER BALLS ON PRODUCT. (4)THE IC ON THE TCP MAY NOT BE DAMAGED, CIRCUITS. (5)THE UPPERMOST EDGE OF THE PROTECTIVE STRIP ON THE INTERFACE PIN MUST BE PRESENT OR LOOK AS IF IT CAUSE THE INTERFACE PIN TO SEVER. (6)THE RESIDUAL ROSIN OR TIN OIL OF SOLDERING (COMPONENT OR CHIP COMPONENT) IS NOT BURNED INTO BROWN OR BLACK COLOR. (7)SEALANT ON TOP OF THE ITO CIRCUIT HAS NOT HARDENED. (8)PIN TYPE MUST MATCH TYPE IN SPECIFICATION SHEET. (9)LCD PIN LOOSE OR MISSING PINS. (10)PRODUCT PACKAGING MUST THE SAME AS SPECIFIED ON PACKAGING SPECIFICATION SHEET. (11)PRODUCT DIMENSION AND STRUCTURE MUST CONFORM TO PRODUCT SPECIFICATION SHEET. (12)THE APPEARANCE OF HEAT SEAL SHOULD NOT ADMIT ANY DIRT AND BREAK.

NO.	ITEM	CRITERIA									
15	CRACKED GLASS	THE LCD WITH EXTENSIVE CRACK IS NOT ACCEPTABLE									
		GENERAL GLASS CHIP :  <table><tr><th>a</th><th>b</th><th>c</th></tr><tr><td>$\leq t/2$</td><td>< VIEWING AREA</td><td>$\leq 1/8X$</td></tr><tr><td>$t/2 >, \leq 2t$</td><td>$\leq W/2$</td><td>$\leq 1/8X$</td></tr></table> *W=DISTANCE BETWEEN SEALANT AREA AND LCD PANEL EDGE X = LCD SIDE LENGTH t = GLASS THICKNESS	a	b	c	$\leq t/2$	< VIEWING AREA	$\leq 1/8X$	$t/2 >, \leq 2t$	$\leq W/2$	$\leq 1/8X$
		a	b	c							
		$\leq t/2$	< VIEWING AREA	$\leq 1/8X$							
$t/2 >, \leq 2t$	$\leq W/2$	$\leq 1/8X$									
CORNER PART :  <table><tr><th>a</th><th>b</th><th>c</th></tr><tr><td>$\leq t/2$</td><td>< VIEWING AREA</td><td>$\leq 1/8X$</td></tr><tr><td>$> t/2, \leq 2t$</td><td>$\leq W/2$</td><td>$\leq 1/8X$</td></tr></table> *W=DISTANCE BETWEEN SEALANT AREA AND LCD PANEL EDGE X = LCD SIDE LENGTH t = GLASS THICKNESS	a	b	c	$\leq t/2$	< VIEWING AREA	$\leq 1/8X$	$> t/2, \leq 2t$	$\leq W/2$	$\leq 1/8X$		
a	b	c									
$\leq t/2$	< VIEWING AREA	$\leq 1/8X$									
$> t/2, \leq 2t$	$\leq W/2$	$\leq 1/8X$									
CHIP ON ELECTRODE PAD  <table><tr><th>a</th><th>b</th><th>c</th></tr><tr><td>$\leq t$</td><td>$\leq 0.5\text{mm}$</td><td>$\leq 1/8X$</td></tr></table> * X=LCD SIDE WIDTH t=GLASS THICKNESS	a	b	c	$\leq t$	$\leq 0.5\text{mm}$	$\leq 1/8X$					
a	b	c									
$\leq t$	$\leq 0.5\text{mm}$	$\leq 1/8X$									
 <table><tr><th>a</th><th>b</th><th>c</th></tr><tr><td>$\leq t$</td><td>$\leq 1/8X$</td><td>$\leq L$</td></tr></table> *X=LCD SIDE WIDTH t = GLASS THICKNESS L=ELECTRODE PAD LENGTH ①IF GLASS CHIPPING THE ITO TERMINAL, OVER 2/3 OF THE ITO MUST REMAIN AND BE, INSPECTED ACCORDING TO ELECTRODE TERMINAL SPECIFICATIONS ②IF THE PRODUCT WILL BE HEAT SEALED BY THE CUSTOMER, THE ALIGNMENT MARK MUST NOT BE DAMAGED	a	b	c	$\leq t$	$\leq 1/8X$	$\leq L$					
a	b	c									
$\leq t$	$\leq 1/8X$	$\leq L$									

13. RELIABILITY TEST

13.1 STANDARD SPECIFICATIONS FOR RELIABILITY OF LCD MODULE

NO.	ITEM	DESCRIPTION
1	HIGH TEMPERATURE OPERATION	THE SAMPLE SHOULD BE ALLOWED TO STAND AT +70°C FOR 240 HRS
2	LOW TEMPERATURE OPERATION	THE SAMPLE SHOULD BE ALLOWED TO STAND AT -20°C FOR 240 HRS
3	HIGH TEMPERATURE STORAGE	THE SAMPLE SHOULD BE ALLOWED TO STAND AT +80°C FOR 240 HRS
4	LOW TEMPERATURE STORAGE	THE SAMPLE SHOULD BE ALLOWED TO STAND AT -30°C FOR 240 HRS
5	HIGH TEMPERATURE /HUMIDITY TEST STORAGE	THE SAMPLE SHOULD BE ALLOWED TO STAND AT 60°C , 90% RH 240 HRS
6	THERMAL SHOCK (NON-OPERATION)	THE SAMPLE SHOULD BE ALLOWED TO STAND THE FOLLOWING 10 CYCLES OF OPERATION:
7	ESD (ELECTROSTATIC DISCHARGE) (NON-OPERATION)	AIR DISCHARGE $\pm 12KV$ CONTACT DISCHARGE $\pm 8KV$ (ACCORDING TO IEC-61000-4-2)

NOTE (1) : THE TEST SAMPLES HAVE RECOVERY TIME FOR 2 HOURS AT ROOM TEMPERATURE BEFORE THE FUNCTION CHECK. IN THE STANDARD CONDITIONS, THERE IS NO DISPLAY FUNCTION NG ISSUE OCCURRED.

13.2 TESTING CONDITIONS AND INSPECTION CRITERIA

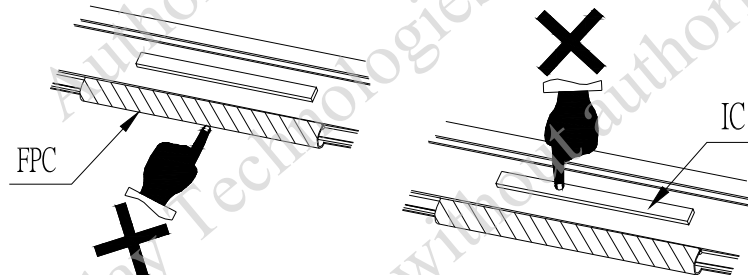
FOR THE FINAL TEST THE TESTING SAMPLE MUST BE STORED AT ROOM TEMPERATURE FOR 24 HOURS, STANDARD SPECIFICATIONS FOR RELIABILITY HAVE BEEN EXECUTED IN ORDER TO ENSURE STABILITY.

NO.	ITEM	TEST MODEL	INSPECTION CRITERIA
1	CURRENT CONSUMPTION	REFER TO SPECIFICATION	THE CURRENT CONSUMPTION SHOULD CONFORM TO THE PRODUCT SPECIFICATION.
2	CONTRAST	REFER TO SPECIFICATION	AFTER THE TESTS HAVE BEEN EXECUTED, THE CONTRAST MUST BE LARGER THAN HALF OF ITS INITIAL VALUE PRIOR TO THE TESTS.
3	APPEARANCE	VISUAL INSPECTION	DEFECT FREE

14. CAUTION

14.1 OPERATION

- 14.1.1 DO NOT CONNECT OR DISCONNECT MODULES TO OR FROM THE MAIN SYSTEM WHILE POWER IS BEING SUPPLIED .
- 14.1.2 USE THE MODULE WITHIN SPECIFIED TEMPERATURE ; LOWER TEMPERATURE CAUSES THE RETARDATION OF BLINKING SPEED OF THE DISPLAY ; HIGHER TEMPERATURE MAKES OVERALL DISPLAY DISCOLOR. WHEN THE TEMPERATURE RETURNS TO NORMALITY, THE DISPLAY WILL OPERATE NORMALLY .
- 14.1.3 ADJUST THE LC DRIVING VOLTAGE TO OBTAIN THE OPTIMUM CONTRAST.
- 14.1.4 POWER ON SEQUENCE INPUT SIGNALS SHOULD NOT BE SUPPLIED TO LCD MODULE BEFORE POWER SUPPLY VOLTAGE IS APPLIED AND REACHES THE SPECIFIED VALUE .
IF ABOVE SEQUENCE IS NOT FOLLOWED , CMOS LSIS OF LCD MODULES MAY BE DAMAGED DUE TO LATCH - UP PROBLEM .
- 14.1.5 NOT ALLOWED TO INFLICT ANY EXTERNAL STRESS AND TO CAUSE ANY MECHANICAL INTERFERENCE ON THE BENDING AREA OF FPC DURING THE TAIL BENDING BACKWARDS!
DO NOT STRESS FPC AND IC ON THE MODULE!



14.2 HANDLING

- 14.2.1 USE A GROUNDED SOLDERING IRON WHEN SOLDERING CONNECTOR I/O TERMINALS . FOR SOLDERING OR REPAIRING, TAKE PRECAUTION AGAINST THE TEMPERATURE OF THE SOLDERING IRON AND THE SOLDERING TIME TO PREVENT PEELING OFF THE THROUGH-HOLE-PAD .
- 14.2.2 DO NOT DISASSEMBLE . EDT SHALL NOT BE HELD RESPONSIBLE IF THE MODULE IS DISASSEMBLED AND UPON THE REASSEMBLY THE MODULE FAILED .
- 14.2.3 DO NOT CHARGE STATIC ELECTRICITY , AS THE CIRCUIT OF THIS MODULE CONTAINS CMOS LSIS. A WORKMAN'S BODY SHOULD ALWAYS BE STATIC-PROTECTED BY USE OF AN ESD STRAP. WORKING CLOTHES FOR SUCH PERSONNEL SHOULD BE OF STATIC-PROTECTED MATERIAL .
- 14.2.4 ALWAYS GROUND THE ELECTRICALLY-POWERED DRIVER BEFORE USING IT TO INSTALL THE LCD MODULE. WHILE CLEANING THE WORK STATION BY VACUUM CLEANER, DO NOT BRING THE SUCKING MOUTH NEAR THE MODULE ; STATIC ELECTRICITY OF THE ELECTRICALLY-POWERED DRIVER OR THE VACUUM CLEANER MAY DESTROY THE MODULE .
- 14.2.5 DON'T GIVE EXTERNAL SHOCK.
- 14.2.6 DON'T APPLY EXCESSIVE FORCE ON THE SURFACE.
- 14.2.7 LIQUID CRISTAL IN LCD IS HAZARDOUS SUBSTANCE. MUST NOT LICK AND SWALLOW.
WHEN THE LIQUID IS ATTACH TO YOUR, SKIN, CLOTH ETC.
WASH IT OUT THOROUGHLY AND IMMEDIATELY.
- 14.2.8 DON'T OPERATE IT ABOVE THE ABSOLUTE MAXIMUM RATING.
- 14.2.9 STORAGE IN A CLEAN ENVIRONMENT, FREE FROM DUST, ACTIVE GAS, AND SOLVENT.
- 14.2.10 STORE WITHOUT ANY PHYSICAL LOAD.
- 14.2.11 REWIRING: NO MORE THAN 3 TIMES.