

**Display Elektronik GmbH**

**TFT MODULE**

**DEM 480480G VMH-PW-N  
(C-TOUCH)**

**(ROUND 2,1“ TFT)**

Product Specification

Version: 0

17.01.2024



## Contents

1. Block Diagram	5
2. Outline dimension	6
3. Input terminal Pin Assignment	7
3.1 TFT PIN Assignment	7
3.2 CTP PIN Assignment	8
4. LCD Optical Characteristics	9
4.1 Optical specification	9
5. TFT Electrical Characteristics	12
5.1 Absolute Maximum Rating (Ta=25 VSS=0V)	12
5.2 DC Electrical Characteristics	12
5.3 LED Backlight Characteristics	13
6. AC Characreristics	16
6.1 Serial Interface Characteristics(3-Line serial)	16
6.2 RGB Interface Characteristics	17
6.3 Reset input timing	18
6.4 RGB Interface	20
6.4.1 RGB Color Format	21
6.4.2 RGB Interface Definition	22
6.4.3 RGB Interface Mode Selection	23
6.5 RGB Interface Timing	23
7. CTP Specification	25
7.1 Abectrical Charateristics	25
7.1.1 Absolute Maximum Rating	25
7.1.2 DC Electrical Characteristics	25
7.1.3 AC Characteristics	26
7.2 SYSTEM MANAGEMENT	27
7.2.1 Power Down	27
7.2.2 Reset	27
7.2.3 Power On/Off Sequence	27
8. LCD Module Out-Going Quality Level	25
8.1 VISUAL & FUNCTION INSPECTION STANDARD	26
8.1.1 Inspection conditions	26
8.1.2 Definition	26
8.1.3 Sampling Plan	27
8.1.4 Criteria (Visual)	28
9. Reliability Test Result	34
10. Cautions and Handling Precautions	35
10.1 Handling and Operating the Module	35
10.2 Storage and Transportation.	35

# **DEM 480480G VMH-PW-N(C-TOUCH) Product Specification**

## **\* Description**

This is a color active matrix TFT (Thin Film Transistor) LCD (liquid crystal display) that uses amorphous silicon TFT as a switching device. This module is composed of a transmissive type TFT-LCD Panel, capacitance touch panel, driver circuit, backlight unit.

The resolution of a 2.1" TFT-LCD contains 480xRGBx480 Pixels, and can display up to 16.7 Million colors.

## **\* Features**

General Information Items	Specification	Unit	Note
	Main Panel		
Display Area(AA)	53.28 x 53.28 (2.1 Inch)	mm	-
Driver Element	TFT Active Matrix	-	-
Display Colors	16.7 Million	colors	-
Number of Pixels	480 x RGB x 480	dots	-
TFT Pixel Arrangement	RGB Vertical Stripe	-	-
Pixel Pitch	0.111 x 0.111	mm	-
Viewing Angle	ALL	o'clock	-
TFT Controller IC	ST7701S (Sitronix)	-	-
LCM Interface	SPI + 16/18/24-BIT-RGB	-	-
Display Mode	IPS, Transmissive / Normally Black	-	-
Operating Temperature	-20°C ~ +70°C	°C	-
Storage Temperature	-30°C ~ +80°C	°C	-
Module Bonding Technology	Use Optical bonding between LCM and CTP	-	-

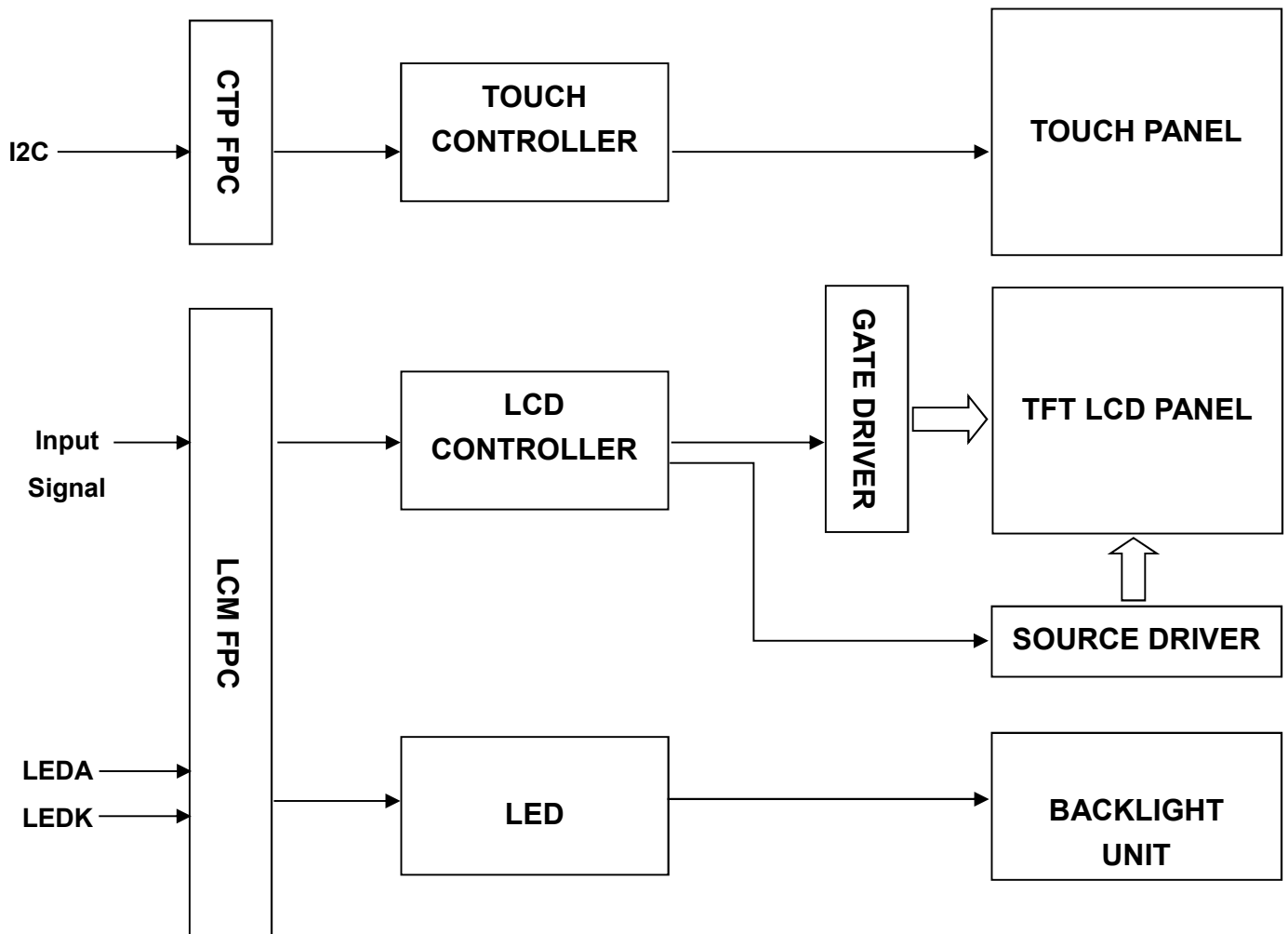
## **\*CTP Features**

General Information Items	Specification	Unit	Note
	Main Panel		
Resolution (HxV)	480 x 480	-	-
Structure	G+G	-	-
Controller IC	ST1633i (Sitronix)	-	-
Interface	I2C	-	-
Slave Address	0x55	-	Note1
Touch Mode	Five Points	-	-
Logic Level	3.3	V	-

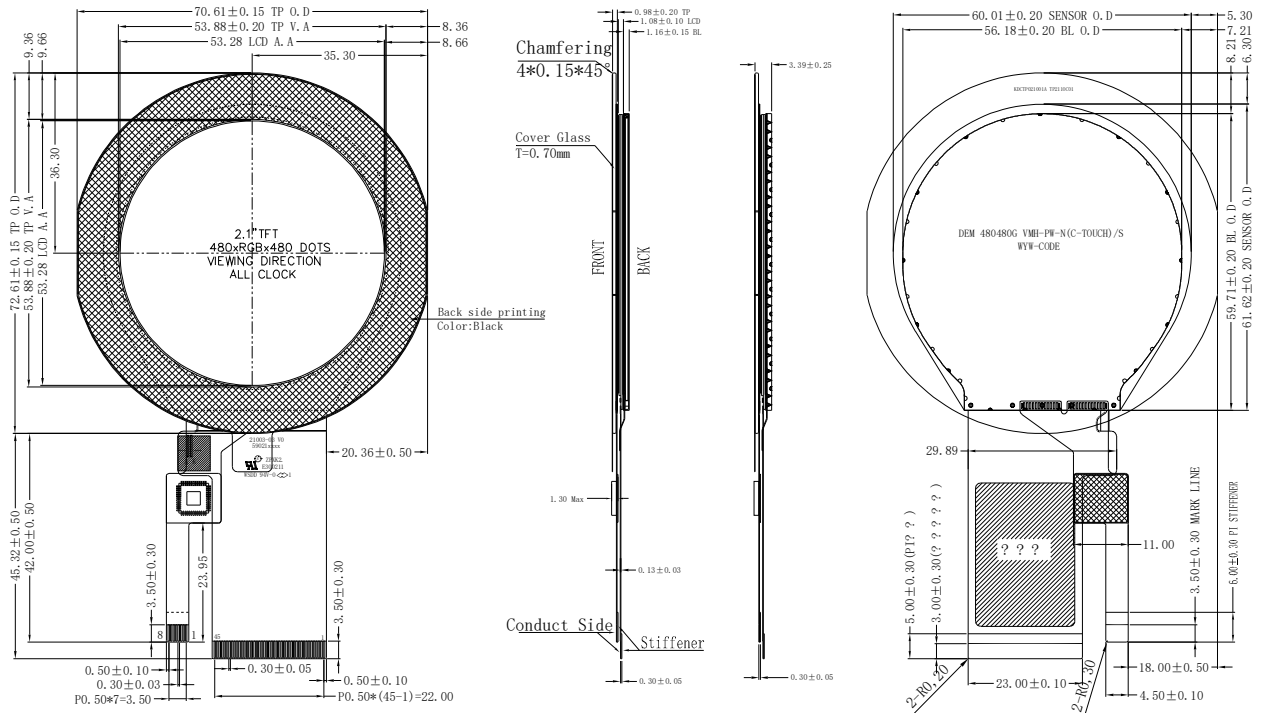
**\* Mechanical Information**

Item		Min.	Typ.	Max.	Unit	Note
Module Size	Horizontal(H)	-	70.61	-	mm	-
	Vertical(V)	-	72.61	-	mm	-
	Depth(D)	-	3.39	-	mm	-
Weight		-	21	-	g	-

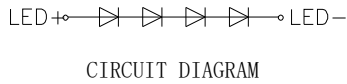
**1. Block Diagram**



## 2. Outline Dimension



Note: The opening of top case must be less than LCD POL 0.3mm at least, the LCD V.A is the Recommended opening of Lens.



NOTE: RGB interface DB Used.

RGB Interface	DB Pin in use
16 Bit RGB interface	DB20-DB16, DB13-DB8, DB4-DB0,
18 Bit RGB interface	DB21-DB16, DB13-DB8, DB5-DB0,
24 Bit RGB interface	DB23-DB0

NOTE: If used RGB mode must select serial interface!

NOTE:

- DISPLAY TYPE: 2.1", TFT-LCD, 16.7M COLORS
- DISPLAY MODE: NORMALLY BLACK/IPS
- VIEWING DIRECTION: ALL
- LCM DRIVER IC: ST7701S (COG)  
LCM Interface: 16/18/24BIT RGB
- Touch Mode: CTP  
Touch Driver IC: ST1633i  
Touch Interface: IIC  
Touch And LCM Bonding Technology: Optical Bonding
- VDD/VCI: 3.3V (TYP.), IOVCC: 1.65-3.3V
- OPERATING TEMP: -20° C TO 70° C  
STORAGE TEMP: -30° C TO 80° C
- BACK LIGHT: LED WHITE, 4 LED, 20mA, 11.2-12.8V
- RoHS COMPLIANT.

CTP PIN	PIN NAME
1	GND
2	NC
3	VDD-3.3V
4	SCL
5	SDA
6	INT
7	RST
8	GND

NO.	Pin Name
1	XR/NC
2	YD/NC
3	XL/NC
4	YU/NC
5	GND
6	GND
7	VCI
8	IOVCC
9	SDO
10	SDI
11	SCL
12	CS
13	RESET
14	DB23(R7)
15	DB22(R6)
16	DB21(R5)
17	DB20(R4)
18	DB19(R3)
19	DB18(R2)
20	DB17(R1)
21	DB16(R0)
22	DB15(G7)
23	DB14(G6)
24	DB13(G5)
25	DB12(G4)
26	DB11(G3)
27	DB10(G2)
28	DB9(G1)
29	DB8(G0)
30	DB7(B7)
31	DB6(B6)
32	DB5(B5)
33	DB4(B4)
34	DB3(B3)
35	DB2(B2)
36	DB1(B1)
37	DB0(B0)
38	DE
39	PCLK
40	HSYNC
41	VSYNC
42	NC
43	LEDK
44	NC
45	LEDA

**3. Input Terminal Pin Assignment**

**3.1 TFT PIN Assignment**

NO	SYMBOL	DISCRIPTION	I/O
1	XR(NC)	Touch panel Right Glass Terminal	--
2	YD(NC)	Touch panel Bottom Film Terminal	--
3	XL(NC)	Touch panel LIFT Glass Terminal	--
4	YU(NC)	Touch panel Top Film Terminal	--
5	GND	Ground.	P
6	GND	Ground.	P
7	VCI	Supply voltage (3.3V).	P
8	IOVCC	I/O power supply voltage.	P
9	SDO	SPI interface output pin.-The data is output on the falling edge of the SCL signal.-If not used, let this pin open.	O
10	SDI	Data lane in 1 data lane serial interface. The data is latched on the rising edge of the SCL signal.	I
11	SCL	This pin is used to select "Data or Command" in the parallel interface. When D/CX = '1', data is selected. When D/CX = '0', command is selected. This pin is used serial interface clock in 3-wire 9-bit / 4-wire 8-bit serial data interface. fix this pin at IOVCC or GND when not in use.	I
12	CS	Chip select input pin ("Low" enable). fix this pin at IOVCC or GND when not in use.	I
13	RESET	Reset pin. Setting either pin low initializes the LSI. Must be reset after power is supplied.	I
14-37	DB23-DB0	24-bit parallel bi-directional data bus for MCU system and RGB interface mode .Fix to GND level when not in use	I/O
38	DE	Data enable signal for RGB interface peration. fix this pin at IOVCC or GND when not in use.	I
39	PCLK	Dot clock signal for RGB interface operation. Fix this pin at IOVCC or GND when not in use.	I
40	HSYNC	Line synchronizing signal for RGB interface operation. fix this pin at IOVCC or GND when not in use.	I

41	VSYNC	Frame synchronizing signal for RGB interface operation. fix this pin at IOVCC or GND when not in use.	I
42	NC	Not Connected.	--
43	LEDK	Cathode pin of backlight.	P
44	NC	Not Connected.	--
45	LEDA	Anode pin of backlight.	P

### 3.2 CTP PIN Assignment

NO	SYMBOL	DISCRIPTION	I/O
1	GND	Ground	P
2	NC	No Connection	--
3	VDD	Supply voltage	P
4	SCL	I2C clock input	I
5	SDA	I2C data input and output	I
6	INT	External interrupt to the host	I
7	RST	External Reset, Low is active	I
8	GND	Ground	P



**4. LCD Optical Characteristics**

**4.1 Optical Specification**

Item	Symbol	Condition	Min.	Typ.	Max.	Unit.	Note
Contrast Ratio	CR	$\Theta=0$	800	1000	--	--	(1)(2)
Response Time	Rising	$T_{R+T_F}$	--	30	35	msec	(1)(3)
	Falling						
Color Gamut	S(%)	-	58	62	--	%	
Color Filter Chromaticity	White	$W_X$	-	-0.04	0.3062	+0.04	(1)(4) CF glass
		$W_Y$	-		0.3435		
	Red	$R_X$	-		0.6248		
		$R_Y$	-		0.3481		
	Green	$G_X$	-		0.3103		
		$G_Y$	-		0.5753		
	Blue	$B_X$	-		0.1484		
		$B_Y$	-		0.0646		
Viewing Angle	Hor.	$\Theta_L$	CR>10	80	85	--	(1)(4)
		$\Theta_R$		80	85	--	
	Ver.	$\Theta_U$		80	85	--	
		$\Theta_D$		80	85	--	
Option View Direction	ALL						

\*The data comes from the LCD specification.

**Measuring Condition**

Measuring surrounding: dark room

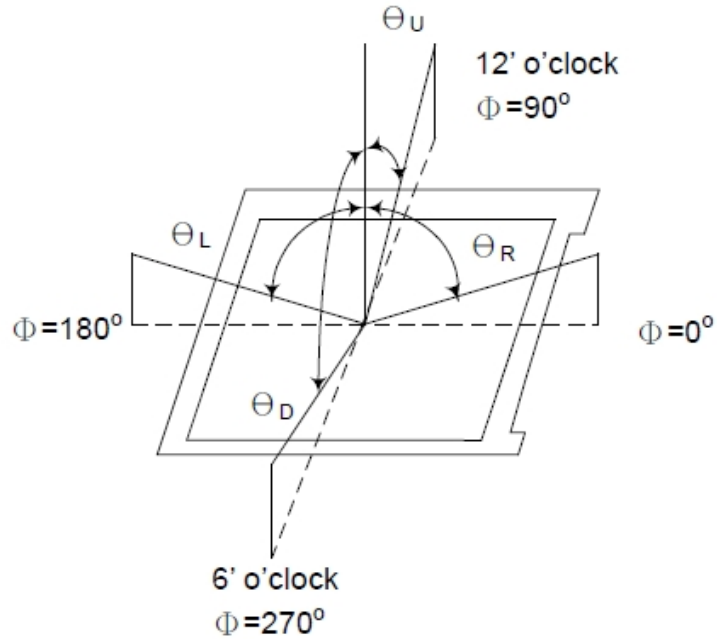
Ambient temperature: 25°C±2°C

15min. warm-up time.

**Measuring Equipment**

FPM520 of Westar Display technologies, INC., which utilized SR-3 for Chromaticity and BM-5A for other optical characteristics.

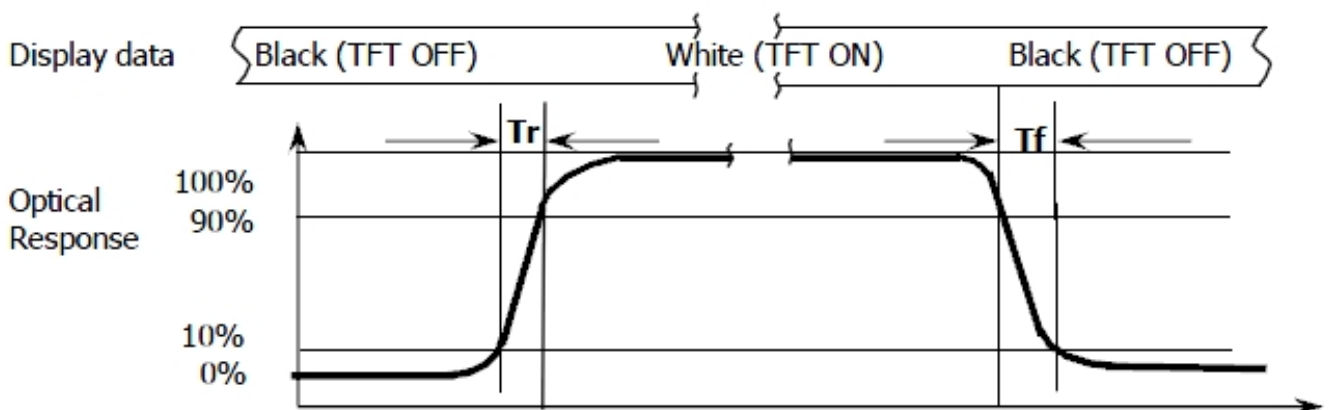
**Note (1):** Definition of Viewing Angle :



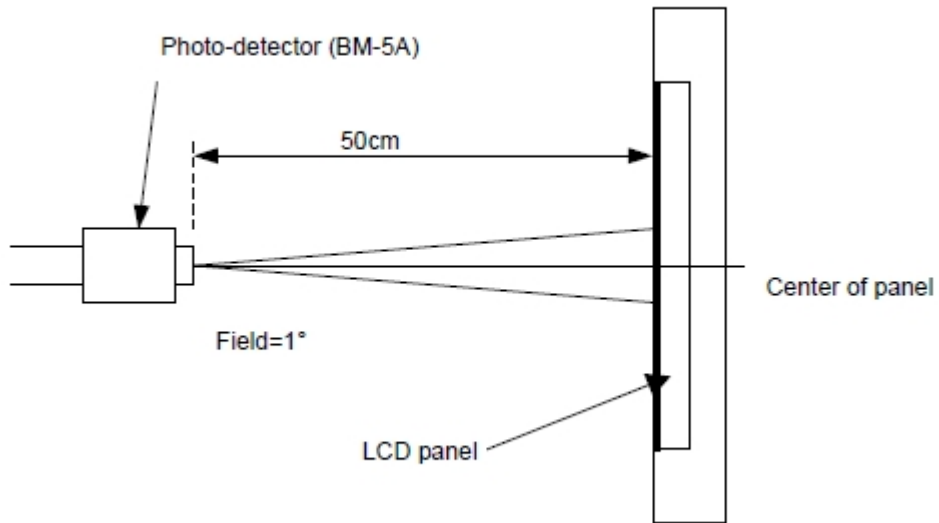
**Note (2):** Definition of Contrast Ratio(CR) :measured at the center point of panel

$$CR = \frac{\text{Luminance with all pixels white}}{\text{Luminance with all pixels black}}$$

**Note (3):** Response Time



**Note (4):** Definition of optical measurement setup



**5. TFT Electrical Characteristics****5.1 Absolute Maximum Rating (Ta=25 VSS=0V)**

Characteristics	Symbol	Min.	Max.	Unit	Note
Digital Supply Voltage	VDD/VCI	-0.3	4.6	V	Note1
Digital Supply Voltage	IOVCC	-0.3	4.6	V	-
Operating Temperature	T <sub>OP</sub>	-20	+70	°C	-
Storage Temperature	T <sub>ST</sub>	-30	+80	°C	-

NOTE1: If the absolute maximum rating of even is one of the above parameters is exceeded even momentarily, the quality of the product may be degraded. Absolute maximum ratings, therefore, specify the values exceeding which the product may be physically damaged. Be sure to use the product within the range of the absolute maximum ratings.

**5.2 DC Electrical Characteristics**

Characteristics	Symbol	Min.	Typ.	Max.	Unit	Note
Digital Supply Voltage	VDD	2.5	3.3	3.6	V	--
Digital Supply Voltage	IOVCC	1.65	1.8	3.3	V	--
Normal Mode Current Consumption	IDD	--	19	30	mA	--
Level Input Voltage	V <sub>IH</sub>	0.7 IOVCC	--	IOVCC	V	--
	V <sub>IL</sub>	-0.3	--	0.3 IOVCC	V	--
Level Output Voltage	V <sub>OH</sub>	0.8* IOVCC	--	IOVCC	V	--
	V <sub>OL</sub>	GND	--	0.2 IOVCC	V	--

**5.3 LED Backlight Characteristics**

The backlight system is edge-lighting type with 4 chips White LED

Item	Symbol	Min.	Typ.	Max.	Unit	Note
Forward Current	I <sub>F</sub>	--	20	--	mA	--
Forward Voltage	V <sub>F</sub>	--	12.8	--	V	--
LCM Luminance	L <sub>v</sub>	450	500	--	cd/m <sup>2</sup>	IF=20mA
LED Lifetime	Hr	50000			Hour	--
Uniformity	AVg	80	--	--	%	Note3

Note1: LED life time (Hr) can be defined as the time in which it continues to operate under the condition: Ta=25°C±3°C, typical IL value indicated in the above table until the brightness becomes less than 50%.

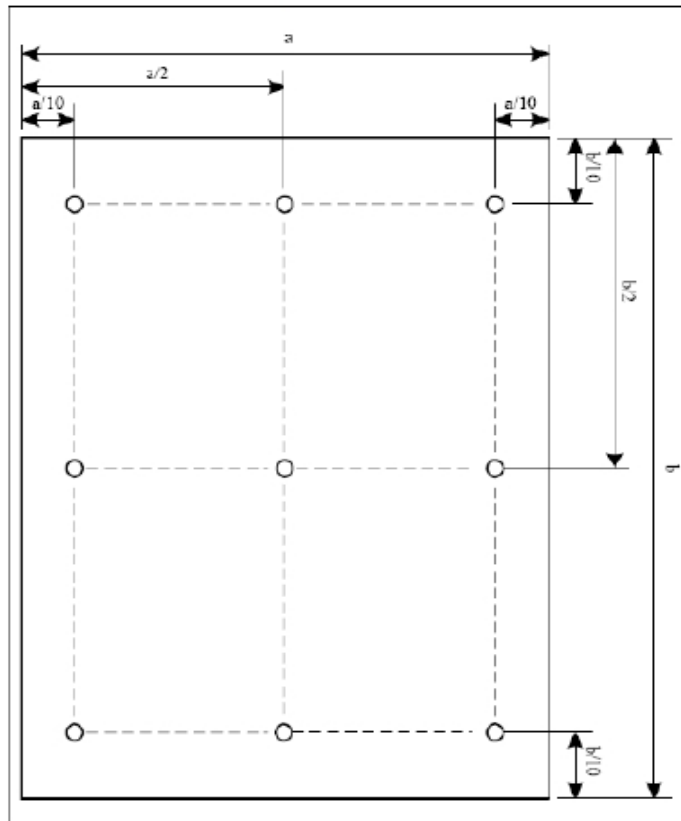
Note 2: The “LED life time” is defined as the module brightness decrease to 50% original brightness at Ta=25°C and IL=20mA. The LED lifetime could be decreased if operating IL is larger than 20mA.

The constant current driving method is suggested.



**CIRCUIT DIAGRAM**

NOTE 3: Luminance Uniformity of these 9 points is defined as below:

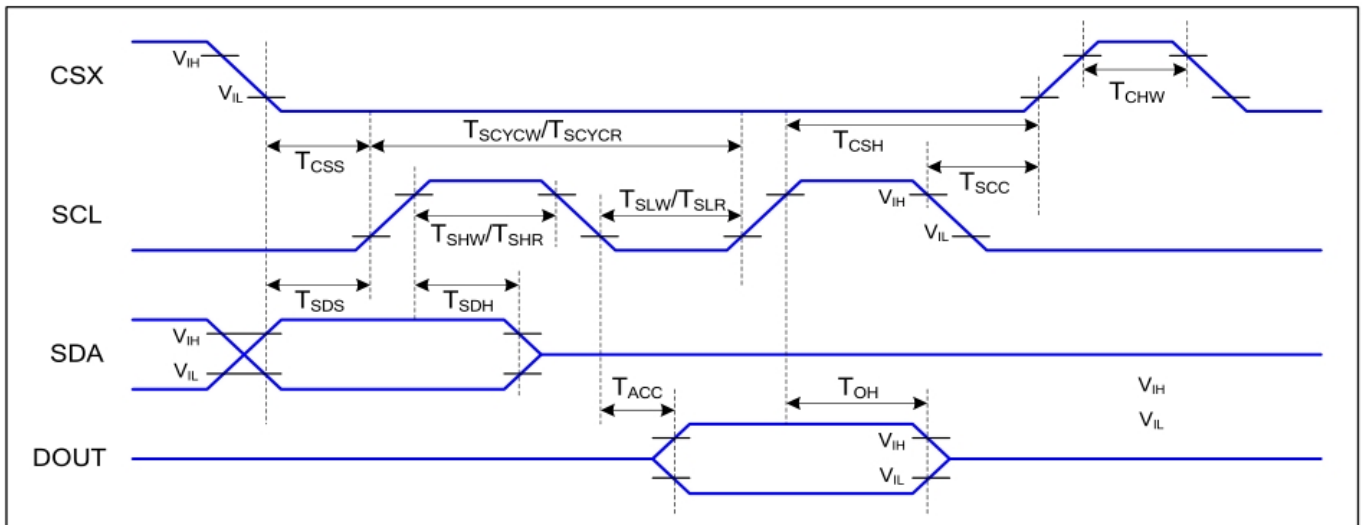


$$\text{Uniformity} = \frac{\text{minimum luminance in 9 points (1-9)}}{\text{maximum luminance in 9 points (1-9)}}$$

$$\text{Luminance} = \frac{\text{Total Luminance of 9 points}}{9}$$

**6. AC Characteristics**

**6.1 Serial Interface Characteristics (3-Line Serial):**



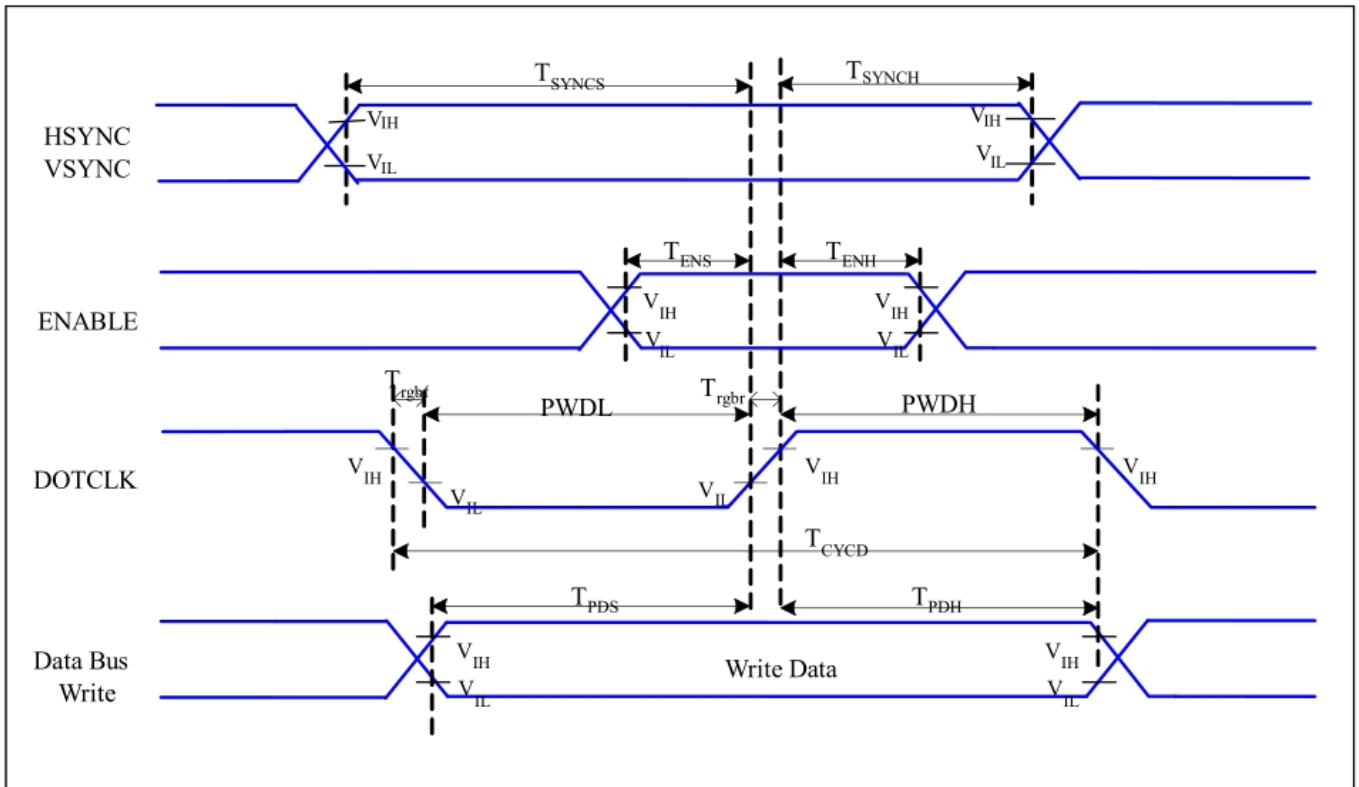
**3-Line Serial Interface Timing Characteristics**

*IOVCC=1.8V, VCI=2.8V, Ta=25°C*

Signal	Symbol	Parameter	Min	Max	Unit	Description
CSX	T <sub>CSS</sub>	Chip select setup time (write)	15		ns	
	T <sub>CSH</sub>	Chip select hold time (write)	15		ns	
	T <sub>CSS</sub>	Chip select setup time (read)	60		ns	
	T <sub>SCH</sub>	Chip select hold time (read)	60		ns	
	T <sub>CHW</sub>	Chip select "H" pulse width	40		ns	
SCL	T <sub>SCYCW</sub>	Serial clock cycle (Write)	66		ns	
	T <sub>SHW</sub>	SCL "H" pulse width (Write)	15		ns	
	T <sub>SLW</sub>	SCL "L" pulse width (Write)	15		ns	
	T <sub>SCYCR</sub>	Serial clock cycle (Read)	150		ns	
	T <sub>SHR</sub>	SCL "H" pulse width (Read)	60		ns	
	T <sub>SLR</sub>	SCL "L" pulse width (Read)	60		ns	
SDA (DIN)	T <sub>SDS</sub>	Data setup time	10		ns	
	T <sub>SDH</sub>	Data hold time	10		ns	

Note: The rising time and falling time (Tr, Tf) of input signal are specified at 15 ns or less. Logic high and low levels are specified as 30% and 70% of IOVCC for Input signals.

**6.2 RGB Interface Characteristics:**

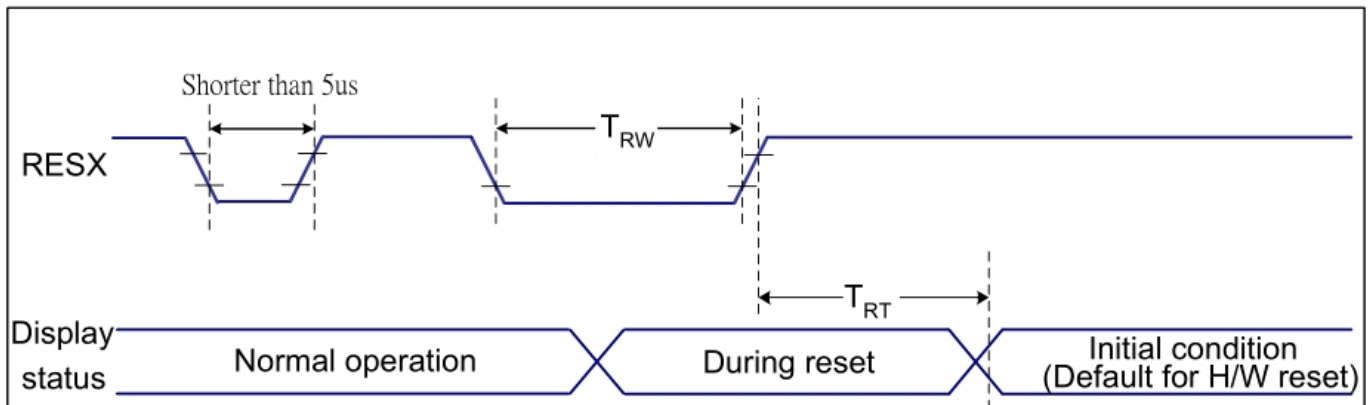


**RGB Interface Timing Characteristics**

Signal	Symbol	Parameter	MIN	MAX	Unit	Description
HSYNC, VSYNC	$T_{SYNCS}$	VSYNC, HSYNC Setup Time	5	-	ns	
ENABLE	$T_{ENS}$	Enable Setup Time	5	-	ns	
	$T_{ENH}$	Enable Hold Time	5	-	ns	
DOTCLK	PWDH	DOTCLK High-level Pulse Width	15	-	ns	
	PWDL	DOTCLK Low-level Pulse Width	15	-	ns	
	$T_{CYCD}$	DOTCLK Cycle Time	33	-	ns	
	$T_{rghr}, T_{rghf}$	DOTCLK Rise/Fall time	-	15	ns	
DB	$T_{PDS}$	PD Data Setup Time	5	-	ns	
	$T_{PDH}$	PD Data Hold Time	5	-	ns	



**6.3 Reset Input Timing:**



Related Pins	Symbol	Parameter	MIN	MAX	Unit
RESX	TRW	Reset pulse duration	10	-	us
	TRT	Reset cancel	-	5 (Note 1, 5)	ms
				120 (Note 1, 6, 7)	ms

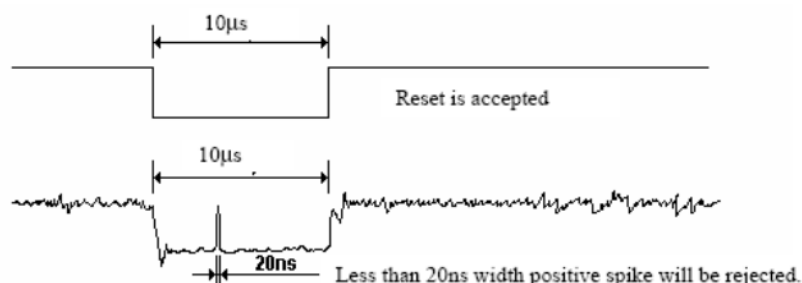
Notes:

1. The reset cancel includes also required time for loading ID bytes, VCOM setting and other settings from NVM (or similar device) to registers. This loading is done every time when there is HW reset cancel time ( $t_{RT}$ ) within 5 ms after a rising edge of RESX.
2. Spike due to an electrostatic discharge on RESX line does not cause irregular system reset according to the table below:

RESX Pulse	Action
Shorter than 5us	Reset Rejected
Longer than 9us	Reset
Between 5us and 9us	Reset starts

3. During the Resetting period, the display will be blanked (The display is entering blanking sequence, which maximum time is 120 ms, when Reset Starts in Sleep Out –mode. The display remains the blank state in Sleep In –mode.) and then return to Default condition for Hardware Reset.

4. Spike Rejection also applies during a valid reset pulse as shown below:



5. When Reset applied during Sleep In Mode.
6. When Reset applied during Sleep Out Mode.
7. It is necessary to wait 5msec after releasing RESX before sending commands. Also Sleep Out command cannot be sent for 120msec.

**6.4 RGB Interface**

The ST7701S support RGB interface Mode 1 and Mode 2. The interface signals as shown in table 6.3.1. The Mode 1 and Mode 2 function is select by setting in the Command 2, please reference application note. In RGB Mode 1, writing data to line buffer is done by PCLK and Video Data Bus (D[23:0]), when DE is high state. The external clocks (PCLK, VS and HS) are used for internal displaying clock. So, controller must always transfer PCLK, VS and HS signal to ST7701S.

In RGB Mode 2, back porch of Vsync is defined by VBP\_HVRGB [7:0] of RGBCTR command. And back porch of Hsync is defined by HBP\_HVRGB [7:0] of RGBCTR command. Front porch of Vsync are not setting by this mode.

RGB I/F Mode	PCLK	DE	VS	HS	DB[23:0]	Register for Blanking Porch setting
RGB Mode 1	Used	Used	Used	Used	Used	Not Used
RGB Mode 2	Used	Not Used	Used	Used	Used	Used

Symbol	Name	Description
PCLK	Pixel clock	Pixel clock for capturing pixels at display interface
HS	Horizontal sync	Horizontal synchronization timing signal
VS	Vertical sync	Vertical synchronization timing signal
DE	Data enable	Data enable signal (assertion indicates valid pixels)
DB[23:0]	Pixel data	Pixel data in 16-bit, 18-bit and 24-bit format

The Interface Signals of RGB Interface

**6.4.1 RGB Color Format**

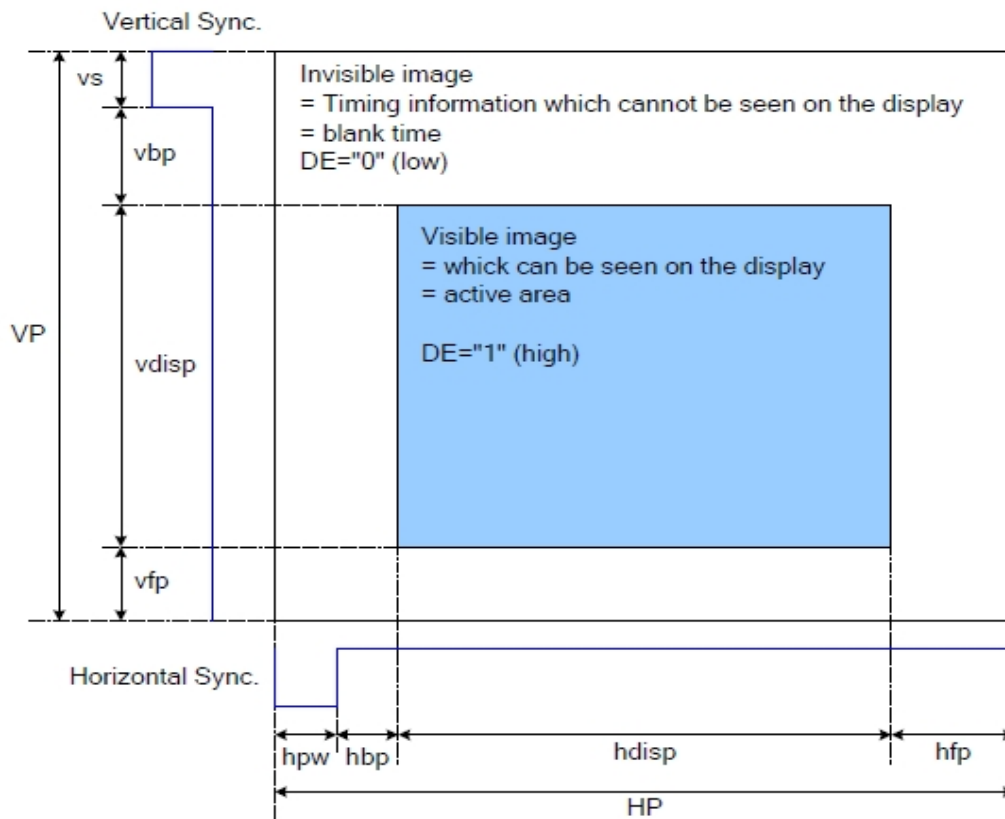
ST7701S supports two kinds of RGB interface, DE mode (mode 1) and HV mode (mode 2), and 16bit/18bit and 24 bit data format. When DE mode is selected and the VSYNC, HSYNC, DOTCLK, DE, D[23:0] pins can be used; when HV mode is selected and the VSYNC, HSYNC, DOTCLK, D[23:0] pins can be used. When using RGB interface, only serial interface can be selected.

Pad name	24 bits configuration VIPF[3:0]=0111	18 bits configuration VIPF[3:0]=0110		16 bits configuration VIPF[3:0]=0101
		MDT=0	MDT=1	
DB[23]	R7	Not used	Not used	Not used
DB[22]	R6	Not used	Not used	Not used
DB[21]	R5	R5	Not used	Not used
DB[20]	R4	R4	Not used	R4
DB[19]	R3	R3	Not used	R3
DB[18]	R2	R2	Not used	R2
DB[17]	R1	R1	R5	R1
DB[16]	R0	R0	R4	R0
DB[15]	G7	Not used	R3	Not used
DB[14]	G6	Not used	R2	Not used
DB[13]	G5	G5	R1	G5
DB[12]	G4	G4	R0	G4
DB[11]	G3	G3	G5	G3
DB[10]	G2	G2	G4	G2
DB[09]	G1	G1	G3	G1
DB[08]	G0	G0	G2	G0
DB[07]	B7	Not used	G1	Not used
DB[06]	B6	Not used	G0	Not used
DB[05]	B5	B5	B5	Not used
DB[04]	B4	B4	B4	B4
DB[03]	B3	B3	B3	B3
DB[02]	B2	B2	B2	B2
DB[01]	B1	B1	B1	B1
DB[00]	B0	B0	B0	B0

The Interface Color Mapping of RGB Interface

**6.4.2 RGB Interface Definition**

The display operation via the RGB interface is synchronized with the VSYNC, HSYNC, and DOTCLK signals. The data can be written only within the specified area with low power consumption by using window address function. The back porch and front porch are used to set the RGB interface timing.



**DRAM Access Area by RGB Interface**

Please refer to the following table for the setting limitation of RGB interface signals.

Parameter	Symbol	Min.	Typ.	Max.	Unit
DCLK frequency	FCLK	--	(17)	--	MHz
Horizontal Sync. Width	hpw	1	(8)	255	Clock
Horizontal Sync. Back Porch	hbp	1	(50)	255	Clock
Horizontal Sync. Front Porch	hfp	1	(10)	--	Clock
Vertical Sync. Width	vs	1	(8)	254	Line
Vertical Sync. Back Porch	vbp	1	(20)	254	Line
Vertical Sync. Front Porch	vfp	1	(10)	--	Line

Note: Typical value are related to the setting frame rate is 60Hz..

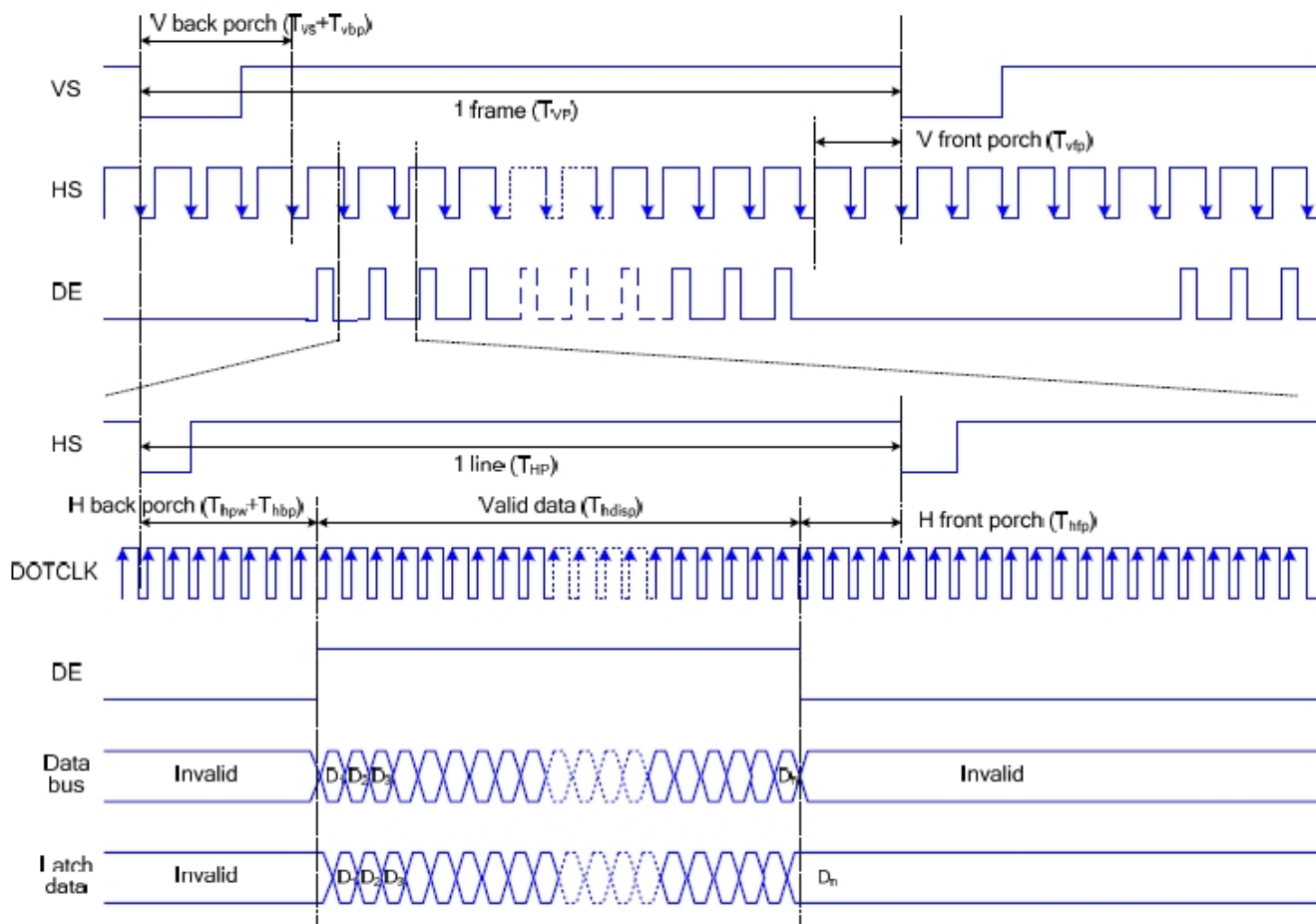
**6.4.3 RGB Interface Mode Selection**

ST7701S supports two kinds of RGB interface, DE mode and HV mode. The table shown below uses command C3h to select RGB interface mode.

DE/Sync	RGB Mode
0	DE mode
1	HV mode

**6.5 RGB Interface Timing**

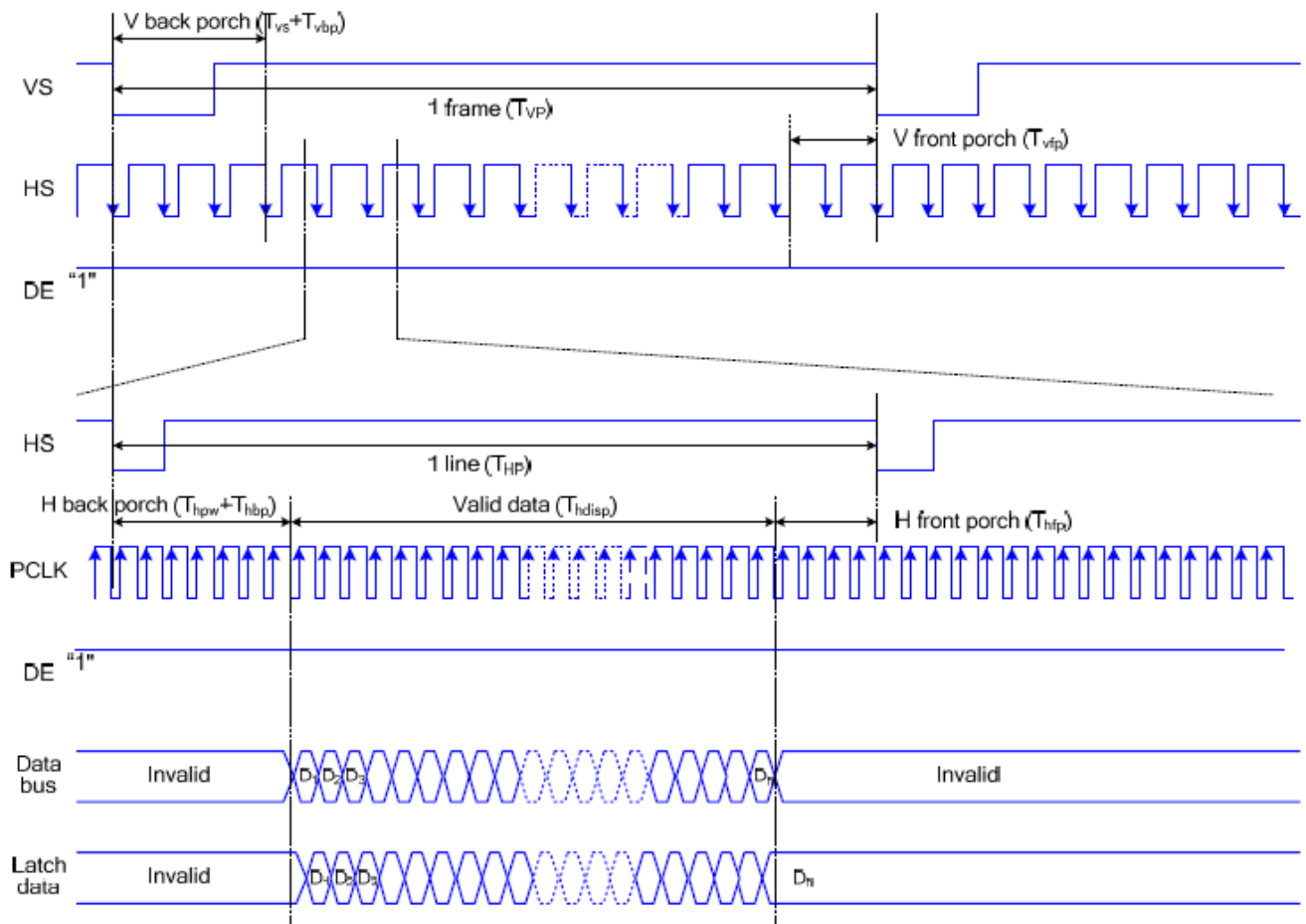
The timing chart of RGB interface DE mode is shown as follows.



Note: The setting of front porch and back porch in host must match that in IC as this mode.

**Timing Chart of Signals in RGB Interface DE Mode**

The Timing Chart of RGB Interface HV Mode is shown as follows.



**Timing Chart of RGB Interface HV mode**

**7. CTP Specification**

**7.1 Electrical Characteristics**

**7.1.1 Absolute Maximum Rating**

Item	Symbol	Min.	Max.	Unit	Note
Power Supply Voltage	VDD	-0.3	6	V	-
Operating Temperature	T <sub>OP</sub>	-20	+70	°C	-
Storage Temperature	T <sub>ST</sub>	-30	+80	°C	-

**7.1.2 DC Electrical Characteristics (Ta=25°C)**

(Ambient Temperature: 25°C, VDD=2.8V, VDDIO=1.8V or VDDIO=VDD)

Item	Min.	Typ.	Max.	Unit	Note
Power Supply Voltage/VDD	2.7	3.3	3.6	V	--
Normal Mode Operating Current	--	8.1	12.2	mA	--
Green Mode Operating Current	--	3.3	--	mA	--
Sleep Mode Operating Current	70	--	120	uA	--
Doze Mode Operating Current	--	0.78	--	mA	--
Digital Input Low Voltage / VIL	-0.3	--	0.25*VDD	V	--
Digital Input High Voltage / VIH	0.75*VDD	--	VDD+0.3	V	--
Digital Output Low Voltage/ VOL	--	--	0.15*VDD	V	--
Digital Output High Voltage/VOH	0.85*VDD	--	--	V	--

7.1.3 AC Characteristics

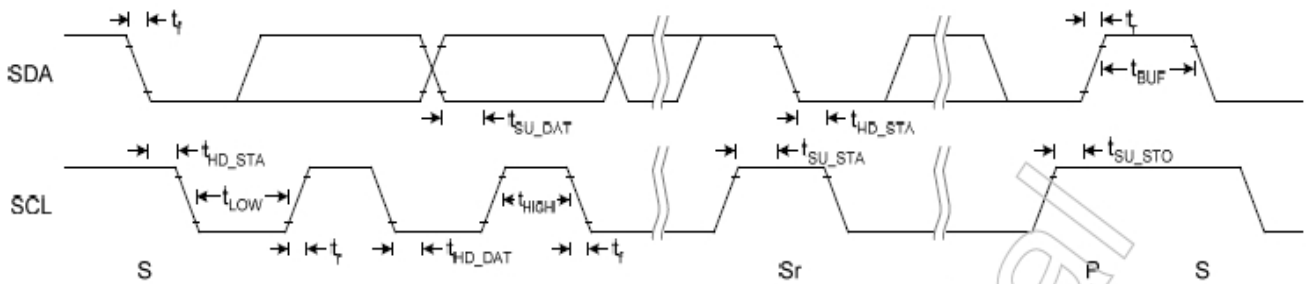


Figure 5-1 I2C Fast Mode Timing

Table 5-3 I2C Fast Mode Timing Characteristic

Conditions: VDD = 3.3V, GND = 0V, T<sub>A</sub> = 25°C

Symbol	Parameter	Rating			Unit
		Min.	Typ.	Max.	
$f_{SCL}$	SCL clock frequency	0	-	400	kHz
$t_{LOW}$	Low period of the SCL clock	1.3	-	-	us
$t_{HIGH}$	High period of the SCL clock	0.6	-	-	us
$t_f$	Signal falling time	-	-	300	ns
$t_r$	Signal rising time	-	-	300	ns
$t_{SU\_STA}$	Set up time for a repeated START condition	0.6	-	-	us
$t_{HD\_STA}$	Hold time (repeated) START condition. After this period, the first clock pulse is generated	0.6	-	-	us
$t_{SU\_DAT}$	Data set up time	100	-	-	ns
$t_{HD\_DAT}$	Data hold time	0	-	0.9	us
$t_{SU\_STO}$	Set up time for STOP condition	0.6	-	-	us
$t_{BUF}$	Bus free time between a STOP and START condition	1.3	-	-	us
$C_b$	Capacitive load for each bus line	-	-	400	pF



**7.2 SYSTEM MANAGEMENT**

**7.2.1 Power Down**

In power down mode, all of the clocks of ST1633i are stopped. The way to exit power down mode is by a hardware reset or I2C.

**7.2.2 Reset**

Master can reset ST1633i through RESET pin. RESET pin is low active and needs hold low for 1us to take effect.

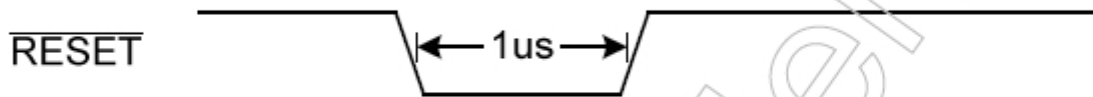


Figure 3-1  $\overline{\text{RESET}}$  Pin Low Pulse Width

**7.2.3 Power On/Off Sequence**

RESET pin should be held low before power on and power off. During power on, after both VDD and IOVDD reach normal voltage, RESET pin needs to be held low for 5ms to ensure internal block stable.

Note: IOVDD and VDD had connected together.

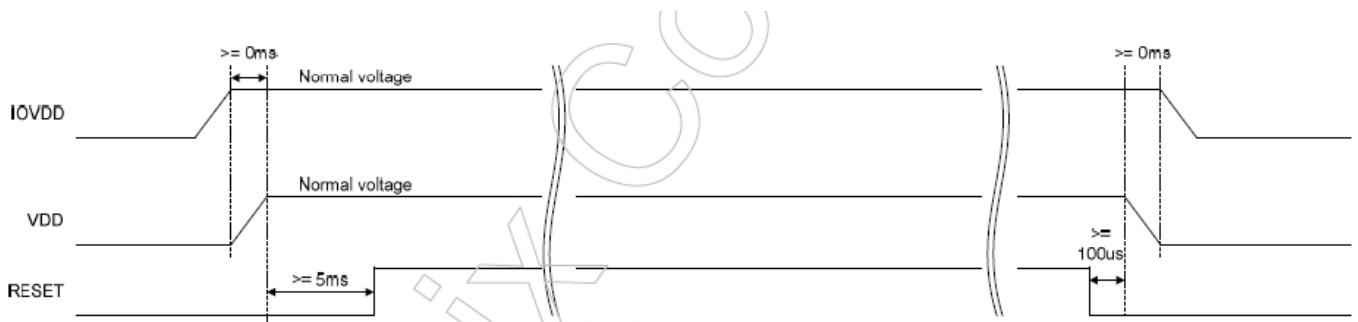


Figure 3-2 Power On/Off Sequence

**8. LCD Module Out-Going Quality Level**

**8.1 VISUAL & FUNCTION INSPECTION STANDARD**

**8.1.1 Inspection Conditions**

Inspection performed under the following conditions is recommended.

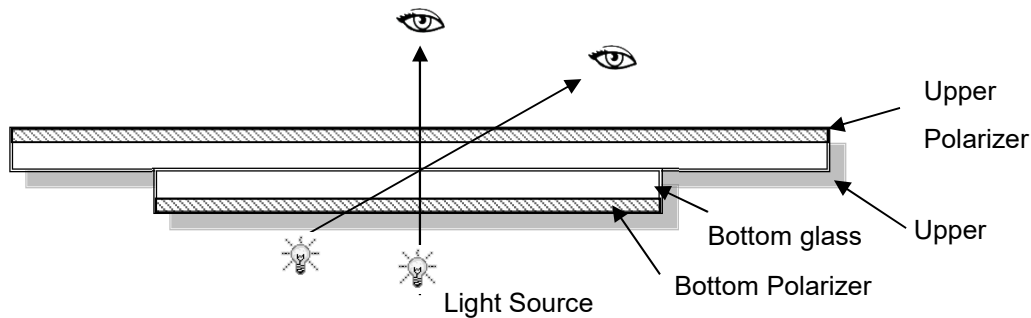
Temperature: 25°C±5°C

Humidity: 65%±10%RH

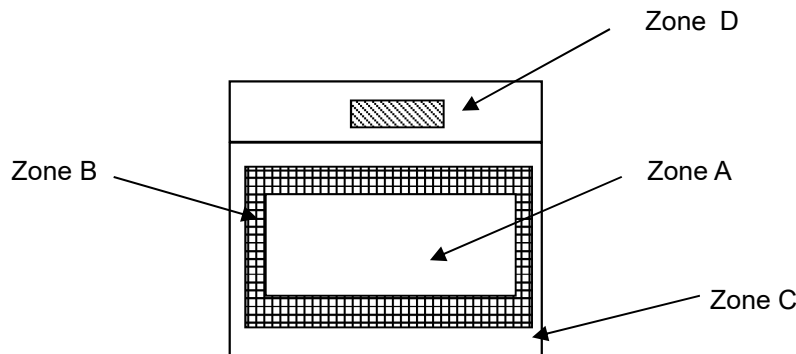
Viewing Angle: Normal viewing Angle.

Illumination: Single fluorescent lamp (300 to 700Lux)

Viewing distance: 30-50cm



**8.1.2 Definition**



Zone A : Effective Viewing Area(Character or Digit can be seen)

Zone B : Viewing Area except Zone A

Zone C : Outside (Zone A+Zone B) which can not be seen after assembly by customer .)

Zone D : IC Bonding Area

Note: As a general rule ,visual defects in Zone C can be ignored when it doesn't effect product function or appearance after assembly by customer

**8.1.3 Sampling Plan**

According to GB/T 2828-2012, normal inspection, Class II

AQL:

Major Defect	Minor Defect
0.65	1.5

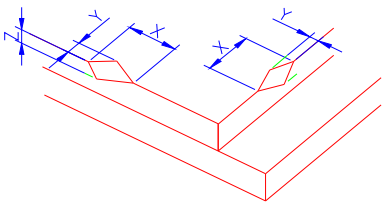
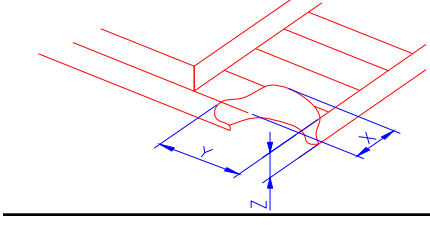
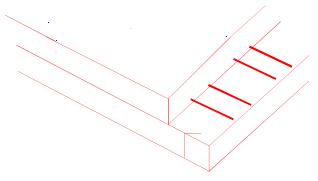
LCD: Liquid Crystal Display, LCM: Liquid Crystal Module

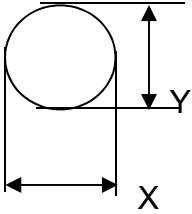
No	Items to be inspected	Criteria	Classification of defects
1	Functional defects	1) No display, Open or miss line 2) Display abnormally, Short 3) Backlight no lighting, abnormal lighting. etc...	Major
2	Missing	Missing components and etc...	
3	Outline dimension	Overall outline dimension beyond the drawing is not allowed, deformation and etc...	
4	Color tone	Color unevenness, refer to limited sample	Minor
5	Spot/Line defect	Light dot, Dim spot, (Note 1) Polarizer Air Bubble, Polarizer accidented spot and etc...	
6	Soldering appearance	Good soldering , Peeling off is not allowed and etc...	
7	LCD/Polarizer/CTP	Black/White spot/line, scratch, crack, etc.	


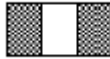

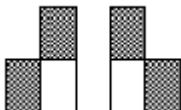
Note1: a) Light dot: Dots appear bright and unchanged in size in which LCD panel is displaying under black pattern.


b) Dim dot: Dots appear dark and unchanged in size in which LCD panel is displaying under pure red, green, blue picture.

**8.1.4 Criteria (Visual)**

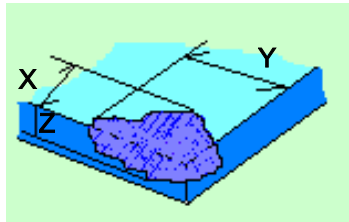
Number	Items	Criteria(mm)						
1.0 LCD Crack/Broken NOTE: X: Length Y: Width Z: Height L: Length of ITO, T: Height of LCD	(1) The edge of LCD broken	 <table border="1" data-bbox="751 611 1453 759"> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td>≤3.0mm</td> <td>&lt;Inner border line of the seal</td> <td>≤T</td> </tr> </tbody> </table>	X	Y	Z	≤3.0mm	<Inner border line of the seal	≤T
	X	Y	Z					
	≤3.0mm	<Inner border line of the seal	≤T					
(2) LCD corner broken	 <table border="1" data-bbox="831 1068 1374 1167"> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td>≤3.0mm</td> <td>≤L</td> <td>≤T</td> </tr> </tbody> </table>	X	Y	Z	≤3.0mm	≤L	≤T	
X	Y	Z						
≤3.0mm	≤L	≤T						
(3) LCD crack	 <p style="text-align: center;">Crack Not allowed</p>							

2.0	Spot defect	① light dot ( black/white spot , pinhole, stain, etc. )																												
		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th rowspan="2" style="text-align: center;">Zone Size (mm)</th> <th colspan="3" style="text-align: center;">Acceptable Qty</th> </tr> <tr> <th style="text-align: center;">A</th> <th style="text-align: center;">B</th> <th style="text-align: center;">C</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;"><math>\Phi \leq 0.15</math></td> <td colspan="3" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>0.15 &lt; \Phi \leq 0.25</math></td> <td colspan="3" rowspan="2" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>0.25 &lt; \Phi \leq 0.4</math></td> <td colspan="2" style="text-align: center;">3(distance <math>\geq 10</math>mm)</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.4</math></td> <td colspan="3" style="text-align: center;">2(distance <math>\geq 10</math>mm)</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.4</math></td> <td colspan="3" style="text-align: center;">0</td> </tr> </tbody> </table>			Zone Size (mm)	Acceptable Qty			A	B	C	$\Phi \leq 0.15$	Ignore			$0.15 < \Phi \leq 0.25$	Ignore			$0.25 < \Phi \leq 0.4$	3(distance $\geq 10$ mm)		$\Phi > 0.4$	2(distance $\geq 10$ mm)			$\Phi > 0.4$	0		
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$\Phi > 0.4$	0																													
$\Phi = (X+Y)/2$	② Dim spot ( light leakage, dent, dark spot, etc )																													
		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th rowspan="2" style="text-align: center;">Zone Size (mm)</th> <th colspan="3" style="text-align: center;">Acceptable Qty</th> </tr> <tr> <th style="text-align: center;">A</th> <th style="text-align: center;">B</th> <th style="text-align: center;">C</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;"><math>\Phi \leq 0.15</math></td> <td colspan="3" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>0.15 &lt; \Phi \leq 0.25</math></td> <td colspan="3" rowspan="2" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>0.25 &lt; \Phi \leq 0.4</math></td> <td colspan="2" style="text-align: center;">3( distance <math>\geq 10</math>mm)</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.4</math></td> <td colspan="3" style="text-align: center;">2( distance <math>\geq 10</math>mm)</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.4</math></td> <td colspan="3" style="text-align: center;">0</td> </tr> </tbody> </table>			Zone Size (mm)	Acceptable Qty			A	B	C	$\Phi \leq 0.15$	Ignore			$0.15 < \Phi \leq 0.25$	Ignore			$0.25 < \Phi \leq 0.4$	3( distance $\geq 10$ mm)		$\Phi > 0.4$	2( distance $\geq 10$ mm)			$\Phi > 0.4$	0		
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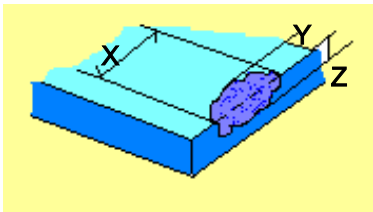
3.0	LCD Pixel defect	<p>Pixel bad points</p> <table border="1"> <thead> <tr> <th data-bbox="549 253 743 304">Item</th> <th data-bbox="743 253 1257 304">Zone A</th> <th data-bbox="1257 253 1498 304">Acceptable Qty</th> </tr> </thead> <tbody> <tr> <td data-bbox="549 304 743 465" rowspan="3">Bright dot</td> <td data-bbox="743 304 1257 360">Random</td> <td data-bbox="1257 304 1498 360">N≤2</td> </tr> <tr> <td data-bbox="743 360 1257 416">2 dots adjacent</td> <td data-bbox="1257 360 1498 416">N≤0</td> </tr> <tr> <td data-bbox="743 416 1257 465">3 dots adjacent</td> <td data-bbox="1257 416 1498 465">N≤0</td> </tr> <tr> <td data-bbox="549 465 743 633" rowspan="3">Dark dot</td> <td data-bbox="743 465 1257 521">Random</td> <td data-bbox="1257 465 1498 521">N≤3</td> </tr> <tr> <td data-bbox="743 521 1257 577">2 dots adjacent</td> <td data-bbox="1257 521 1498 577">N≤0</td> </tr> <tr> <td data-bbox="743 577 1257 633">3 dots adjacent</td> <td data-bbox="1257 577 1498 633">N≤0</td> </tr> <tr> <td data-bbox="549 633 743 943">Distance</td> <td data-bbox="743 633 1257 943">                     1. Minimum Distance Between Bright dots.                      2. Minimum Distance Between dark dots                      3. Minimum Distance Between dark and bright dot.                 </td> <td data-bbox="1257 633 1498 943">5mm</td> </tr> <tr> <td colspan="2" data-bbox="549 943 1257 999">Total bright and dark dot</td> <td data-bbox="1257 943 1498 999">N≤4</td> </tr> </tbody> </table> <p>Note:</p> <p>A) Bright dot: Dots appear bright and unchanged in size in which LCD panel is displaying under black pattern.</p> <p>B) Dark dot: Dots appear dark and unchanged in size in which LCD panel is displaying under pure red, green, blue picture.</p> <p>C) 2 dot adjacent = 1 pair = 2 dots</p> <p>Picture:</p> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>2 dot adjacent</p> </div> <div style="text-align: center;">  <p>2 dot adjacent</p> </div> </div> <div style="display: flex; justify-content: space-around; align-items: flex-start; margin-top: 20px;"> <div style="text-align: center;">  <p>2 dot adjacent (vertical)</p> </div> <div style="text-align: center;">  <p>2 dot adjacent (slant)</p> </div> </div>	Item	Zone A	Acceptable Qty	Bright dot	Random	N≤2	2 dots adjacent	N≤0	3 dots adjacent	N≤0	Dark dot	Random	N≤3	2 dots adjacent	N≤0	3 dots adjacent	N≤0	Distance	1. Minimum Distance Between Bright dots. 2. Minimum Distance Between dark dots 3. Minimum Distance Between dark and bright dot.	5mm	Total bright and dark dot		N≤4
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Total bright and dark dot		N≤4																							

4.0	Line defect (LCD /Polarizer backlight black/white line, scratch, stain)  W: width, L : length  N : Count	<table border="1"> <thead> <tr> <th rowspan="2">Width(mm)</th> <th rowspan="2">Length(m m)</th> <th colspan="3">Acceptable Qty</th> </tr> <tr> <th>A</th> <th>B</th> <th>C</th> </tr> </thead> <tbody> <tr> <td><math>\Phi \leq 0.05</math></td> <td>Ignore</td> <td colspan="2">Ignore</td> <td rowspan="3">Ignore</td> </tr> <tr> <td><math>0.05 &lt; W \leq 0.06</math></td> <td><math>L \leq 5.0</math></td> <td colspan="2">N<math>\leq</math>3</td> </tr> <tr> <td><math>0.06 &lt; W \leq 0.08</math></td> <td><math>L \leq 4.0</math></td> <td colspan="2">N<math>\leq</math>2</td> </tr> <tr> <td><math>W &gt; 0.08</math></td> <td colspan="3">Define as spot defect</td> <td></td> </tr> </tbody> </table>	Width(mm)	Length(m m)	Acceptable Qty			A	B	C	$\Phi \leq 0.05$	Ignore	Ignore		Ignore	$0.05 < W \leq 0.06$	$L \leq 5.0$	N $\leq$ 3		$0.06 < W \leq 0.08$	$L \leq 4.0$	N $\leq$ 2		$W > 0.08$	Define as spot defect			
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$W > 0.08$	Define as spot defect																											
5.0	Electronic Components SMT.	Not allow missing parts, solderless connection, cold solder joint, mismatch, The positive and negative polarity opposite																										
6.0	Display color& Brightness.	1. Color: Measuring the color coordinates, The measurement standard according to the datasheet or samples. 2. Brightness: Measuring the brightness of White screen, The measurement standard according to the datasheet or Samples.																										
7.0	LCD Mura/Waving/ Hot spot	Not visible through 5% ND filter in 50% gray or judge by limit sample if necessary.																										

8.0	CTP Related	CTP Cover sensor accidented black/white spot	<table border="1"> <thead> <tr> <th rowspan="2">Size <math>\Phi</math>(mm)</th> <th colspan="3">Acceptable Qty</th> </tr> <tr> <th>A</th> <th>B</th> <th>C</th> </tr> </thead> <tbody> <tr> <td><math>\Phi \leq 0.15</math></td> <td colspan="2">Ignore</td> <td rowspan="3">Ignore</td> </tr> <tr> <td><math>0.15 &lt; \Phi \leq 0.25</math></td> <td colspan="2">4 ( distance <math>\geq</math> 10mm )</td> </tr> <tr> <td><math>0.25 &lt; \Phi \leq 0.35</math></td> <td colspan="2">3 ( distance <math>\geq</math> 10mm )</td> </tr> <tr> <td><math>\Phi &gt; 0.35</math></td> <td colspan="3">0</td> </tr> </tbody> </table>	Size $\Phi$ (mm)	Acceptable Qty			A	B	C	$\Phi \leq 0.15$	Ignore		Ignore	$0.15 < \Phi \leq 0.25$	4 ( distance $\geq$ 10mm )		$0.25 < \Phi \leq 0.35$	3 ( distance $\geq$ 10mm )		$\Phi > 0.35$	0		
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		CTP Cover scratch	<table border="1"> <thead> <tr> <th rowspan="2">Width(mm)</th> <th rowspan="2">Ignore(mm)</th> <th colspan="3">Acceptable Qty</th> </tr> <tr> <th>A</th> <th>B</th> <th>C</th> </tr> </thead> <tbody> <tr> <td><math>\Phi \leq 0.05</math></td> <td>Ignore</td> <td colspan="3">Ignore</td> </tr> <tr> <td><math>0.05 &lt; W \leq 0.06</math></td> <td><math>L \leq 4.0</math></td> <td colspan="3"><math>N \leq 3</math></td> </tr> <tr> <td><math>0.06 &lt; W \leq 0.08</math></td> <td><math>L \leq 3.0</math></td> <td colspan="3"><math>N \leq 2</math></td> </tr> <tr> <td><math>0.08 &lt; W</math></td> <td colspan="4">Define as spot defect</td> </tr> </tbody> </table>	Width(mm)	Ignore(mm)	Acceptable Qty			A	B	C	$\Phi \leq 0.05$	Ignore	Ignore			$0.05 < W \leq 0.06$	$L \leq 4.0$	$N \leq 3$			$0.06 < W \leq 0.08$	$L \leq 3.0$	$N \leq 2$			$0.08 < W$	Define as spot defect			
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		CTP Cover Pinhole/ Lack of ink	<table border="1"> <thead> <tr> <th>Zone Size (mm)</th> <th>Acceptable Qty</th> </tr> </thead> <tbody> <tr> <td><math>\Phi \leq 0.2</math></td> <td>Ignore</td> </tr> <tr> <td><math>0.2 &lt; \Phi \leq 0.3</math></td> <td>4(distance <math>\geq 10</math>mm)</td> </tr> <tr> <td><math>0.3 &lt; \Phi \leq 0.4</math></td> <td>2(distance <math>\geq 10</math>mm)</td> </tr> <tr> <td><math>\Phi &gt; 0.4</math></td> <td>0</td> </tr> </tbody> </table>	Zone Size (mm)	Acceptable Qty	$\Phi \leq 0.2$	Ignore	$0.2 < \Phi \leq 0.3$	4(distance $\geq 10$ mm)	$0.3 < \Phi \leq 0.4$	2(distance $\geq 10$ mm)	$\Phi > 0.4$	0																		
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		Assembly deflection	beyond the edge of backlight $\leq 0.2$ mm																												
		CTP cover broken  X : length  Y : width  Z : height	<table border="1"> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td><math>X \leq 0.5</math>mm</td> <td><math>Y \leq 0.5</math>mm</td> <td>Z &lt; cover thickness s</td> </tr> </tbody> </table> <p>Circuitry broken is not allowed.</p> 	X	Y	Z	$X \leq 0.5$ mm	$Y \leq 0.5$ mm	Z < cover thickness s																						
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		CTP cover broken	X	Y	Z	
			X≤0.3mm	Y≤0.3mm	Z<cover thickness	
		X : length	* Circuitry broken is not allowed.			
		Y : width				
		Z : height				

Criteria ( functional items)

Number	Items	Criteria (mm)
1	No display	Not allowed
2	Missing segment	Not allowed
3	Short	Not allowed
4	Backlight no lighting	Not allowed

**9. Reliability Test Result**

Remark:

Item	Condition	Inspection after test
High Temperature Operating	70°C,96h	Inspection after 2~4hours storage at room temperature, the sample shall be free from defects: 1. Air bubble in the LCD; 2. Non-display; 3. Missing segments/line; 4. Glass crack; 5. Current IDD is twice higher than initial value.
Low Temperature Operating	-20°C, 96h	
High Temperature Storage	80°C, 96h	
Low Temperature Storage	-30°C, 96h	
High Temperature & High Humidity Operating	+60°C, 90% RH ,96h.	
Thermal Shock (Non-operation)	-10°C, 30 min ↔ +60°C, 30 min, Change time: 5min 20CYC.	
ESD Test	C=150pF, R=330, 5points/panel Air:±8kV, 5times; Contact:±6kV, 5 times; (Environment: 15°C~35°C, 30%~60%).	
Vibration (Non-operation)	Frequency range: 10~55Hz, Stroke:1.5mm Sweep:10Hz~55Hz~10Hz 2 hours for each direction of X.Y.Z. (6 hours for total) (Package condition).	
Box Drop Test	1 Corner 3 Edges 6 faces,80cm(MEDIUM BOX)	

1. The test samples should be applied to only one test item.
2. Sample size for each test item is 5~10pcs.
3. For Damp Proof Test, Pure water (Resistance > 10MΩ) should be used.
4. In case of malfunction defect caused by ESD damage, if it would be recovered to normal state after resetting, it would be judged as a good part.
5. Failure Judgment Criterion: Basic Specification, Electrical Characteristic, Mechanical Characteristic, Optical Characteristic.
6. The color fading mura of polarizing filter should not care.

## **10. Cautions and Handling Precautions**

### **10.1 Handling and Operating the Module**

- (1) When the module is assembled, it should be attached to the system firmly.  
Do not warp or twist the module during assembly work.
- (2) Protect the module from physical shock or any force. In addition to damage, this may cause improper operation or damage to the module and back-light unit.
- (3) Note that polarizer is very fragile and could be easily damaged. Do not press or scratch the surface.
- (4) Do not allow drops of water or chemicals to remain on the display surface.  
If you have the droplets for a long time, staining and discoloration may occur.
- (5) If the surface of the polarizer is dirty, clean it using some absorbent cotton or soft cloth.
- (6) The desirable cleaners are water, IPA (Isopropyl Alcohol) or Hexane.  
Do not use ketene type materials (ex. Acetone), Ethyl alcohol, Toluene, Ethyl acid or Methyl chloride. It might permanent damage to the polarizer due to chemical reaction.
- (7) If the liquid crystal material leaks from the panel, it should be kept away from the eyes or mouth. In case of contact with hands, legs, or clothes, it must be washed away thoroughly with soap.
- (8) Protect the module from static; it may cause damage to the CMOS ICs.
- (9) Use finger-stalls with soft gloves in order to keep display clean during the incoming inspection and assembly process.
- (10) Do not disassemble the module.
- (11) Protection film for polarizer on the module shall be slowly peeled off just before use so that the electrostatic charge can be minimized.
- (12) Pins of I/F connector shall not be touched directly with bare hands.
- (13) Do not connect, disconnect the module in the "Power ON" condition.
- (14) Power supply should always be turned on/off by the item 6.1 Power On Sequence & 6.2 Power Off Sequence

### **10.2 Storage and Transportation.**

- (1) Do not leave the panel in high temperature, and high humidity for a long time.  
It is highly recommended to store the module with temperature from 0°C to 35°C and relative humidity of less than 70%
- (2) Do not store the TFT-LCD module in direct sunlight.
- (3) The module shall be stored in a dark place. When storing the modules for a long time, be sure to adopt effective measures for protecting the modules from strong ultraviolet radiation, sunlight, or fluorescent light.
- (4) It is recommended that the modules should be stored under a condition where no condensation is allowed. Formation of dewdrops may cause an abnormal operation or a failure of the module.  
In particular, the greatest possible care should be taken to prevent any module from being operated where condensation has occurred inside.
- (5) This panel has its circuitry FPC on the bottom side and should be handled carefully in order not to be stressed.