

ZETTLER DISPLAYS

SPECIFICATIONS FOR LIQUID CRYSTAL DISPLAY

CUSTOMER APPROVAL			
※ PART NO. : <u>ATM0700L76 (ZETTLER DISPLAYS) SPEC V1.3</u>			
APPROVAL		COMPANY CHOP	
CUSTOMER COMMENTS			

ZETTLER DISPLAYS ENGINEERING APPROVAL		
DESIGNED BY	CHECKED BY	APPROVED BY
XW	GZC	GZH

REVISION RECORD

REVISION	REVISION DATE	PAGE	CONTENTS
PRELIMINARY	2021-04-09		FIRST ISSUE
	2021-04-25	20	ADJUST THE CONNECTOR STRUCTURE POSITION
V1.0	2021-04-29		FORMAL SPECIFICATION
V1.1	2021-07-15	10	UPDATE LED USAGE CONDITIONS
V1.2	2021-08-20	3,20,21	UPDATED WEIGHT, DRIVER IC, PACKAGING SPECIFICATIONS
V1.3	2022-01-21	3	UPDATED TFT DRIVER IC INFORMATION

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1. GENERAL SPECIFICATIONS

Item	Specification	Remark
1. LCD size	7.0 inch(Diagonal)	
2. Driver element	a-Si TFT active matrix	
3. Resolution	800x480	
4. Display mode	Normally black, IPS, Transmissive	
5. Dot Pitch (W*H)	0.0635mm(W) x 0.1905mm(H)	
6. Pixel pitch(W*H)	0.1905mm(W) x 0.1905mm(H)	
7. Active Area(W*H)	152.4mm(W) x 91.44mm(H)	
8. Module size (W*H)	170.0mm(W) x 110.0mm(H) x 9.0mm(D)	Note 1
9. Surface treatment	Anti-glare / 3H	
10. Color arrangement	RGB-stripe	
11. Color	16.7M / 262K	
12. Viewing angle (L/R/T/B)	85/85/85/85	
13. Interface	4-lane / 3-lane LVDS interface VESA/JEIDA compatible	
14. LCD controller	HX8290-A-LT / HX8290-A02-LT (source) HX8664-B (gate)	
15. LCM brightness	1100cd/m2 Typ.	
16. Backlight driving condition	12V	
17. Touch panel	Without touch panel	
18. Touch controller	Without touch IC	
19. Operation temperature	-40~85 °C	
20. Weight	190 g	
21. RoHS	RoHS compliant	

Note 1: Please refer to mechanical drawing.

2. PIN ASSIGNMENT

Connector on board: DF14H-20P-1.25H(HIROSE)

Mating connector: DF14-20S-1.25C(HIROSE) DF14-2628SCF(terminal)

Mating LVDS transmitter: THC63LVDM83R (Thine electronics) or compatible

Pin No.	Symbol	Function	Level	Note
1,2	VCC	Power for digital circuit	P	
3,4	GND	Power ground	P	
5	RXIN0-	LVDS channel 0 negative	I	
6	RXIN0+	LVDS channel 0 positive	I	
7	GND	Power ground	P	
8	RXIN1-	LVDS channel 1 negative	I	
9	RXIN1+	LVDS channel 1 positive	I	
10	GND	Power ground	P	
11	RXIN2-	LVDS channel 2 negative	I	
12	RXIN2+	LVDS channel 2 positive	I	
13	GND	Power ground	P	
14	RXCKIN-	LVDS clock negative	I	
15	RXCKIN+	LVDS clock positive	I	
16	GND	Power ground	P	
17	RXIN3-	LVDS channel 3 negative	I	
18	RXIN3+	LVDS channel 3 positive	I	
19	MODE	Low=ISP 6 compatibility mode High=ISP 8 bit compatibility mode	I	
20	SC	Scan direction control Low=Normal; High=Reverse	I	NOTE1

I: input, O: output, P: Power

Note 1: Refer to the structure drawing for instructions

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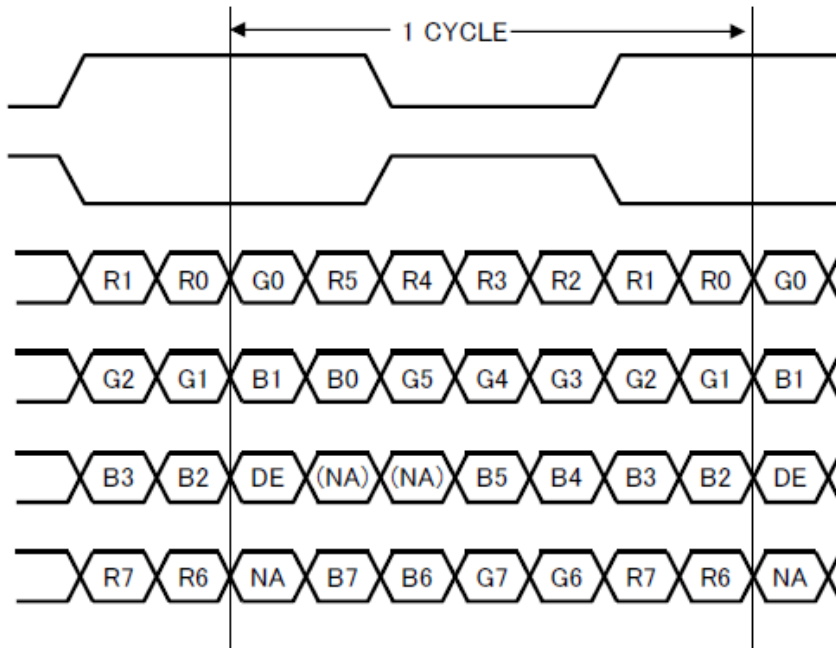
Data mapping

1)8 bit input

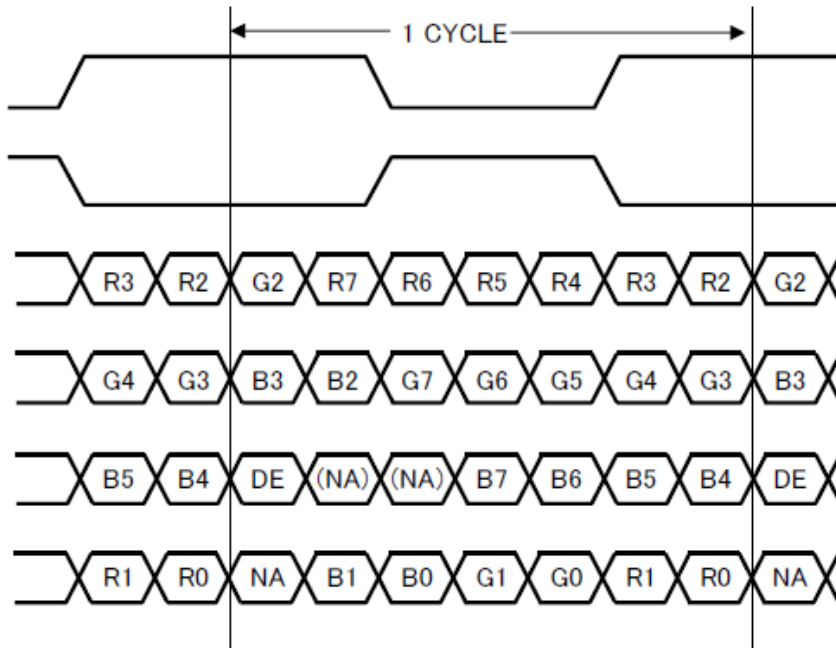
Example mating connector: THC64LVDM83R(Thine electronics) or compatible

Transmitter		20Pin SELLVDS	
Pin No	Data	= H(3.3V)	= L(GND) or Open
51	TA0	R0 (LSB)	R2
52	TA1	R1	R3
54	TA2	R2	R4
55	TA3	R3	R5
56	TA4	R4	R6
3	TA5	R5	R7 (MSB)
4	TA6	G0 (LSB)	G2
6	TB0	G1	G3
7	TB1	G2	G4
11	TB2	G3	G5
12	TB3	G4	G6
14	TB4	G5	G7 (MSB)
15	TB5	B0 (LSB)	B2
19	TB6	B1	B3
20	TC0	B2	B4
22	TC1	B3	B5
23	TC2	B4	B6
24	TC3	B5	B7 (MSB)
27	TC4	(NA)	(NA)
28	TC5	(NA)	(NA)
30	TC6	DE	DE
50	TD0	R6	R0 (LSB)
2	TD1	R7 (MSB)	R1
8	TD2	G6	G0 (LSB)
10	TD3	G7 (MSB)	G1
16	TD4	B6	B0 (LSB)
18	TD5	B7 (MSB)	B1
25	TD6	(NA)	(NA)

< SELLVDS = H(3.3V) >



< SELLVDS = L(GND) or Open >



DE: DATA ENABLE

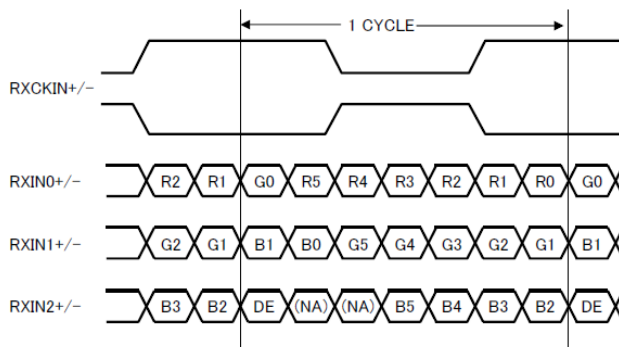
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2) 6 bit input

Example mating connector: THC63LVDM83R(Thine electronics) or compatible

Transmitter		20Pin SELLVDS	
Pin No	Data	= H(3.3V)	= L(GND) or Open
51	TA0	-	R0 (LSB)
52	TA1	-	R1
54	TA2	-	R2
55	TA3	-	R3
56	TA4	-	R4
3	TA5	-	R5 (MSB)
4	TA6	-	G0 (LSB)
6	TB0	-	G1
7	TB1	-	G2
11	TB2	-	G3
12	TB3	-	G4
14	TB4	-	G5 (MSB)
15	TB5	-	B0 (LSB)
19	TB6	-	B1
20	TC0	-	B2
22	TC1	-	B3
23	TC2	-	B4
24	TC3	-	B5 (MSB)
27	TC4	-	(NA)
28	TC5	-	(NA)
30	TC6	-	DE
50	TD0	-	GND
2	TD1	-	GND
8	TD2	-	GND
10	TD3	-	GND
16	TD4	-	GND
18	TD5	-	GND
25	TD6	-	(NA)

< SELLVDS = L(GND) or Open >

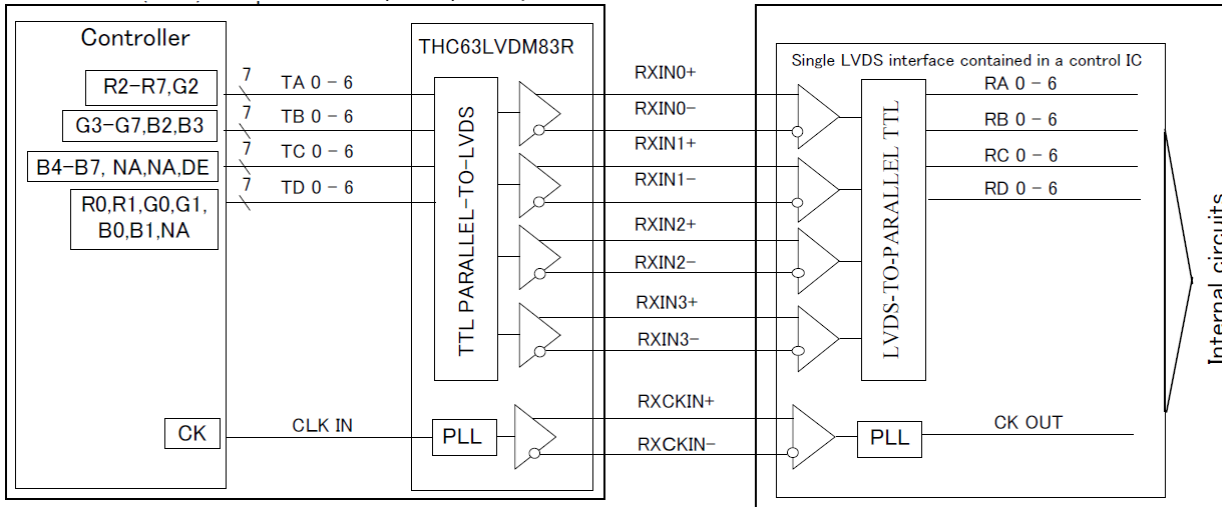


DE: DATA ENABLE

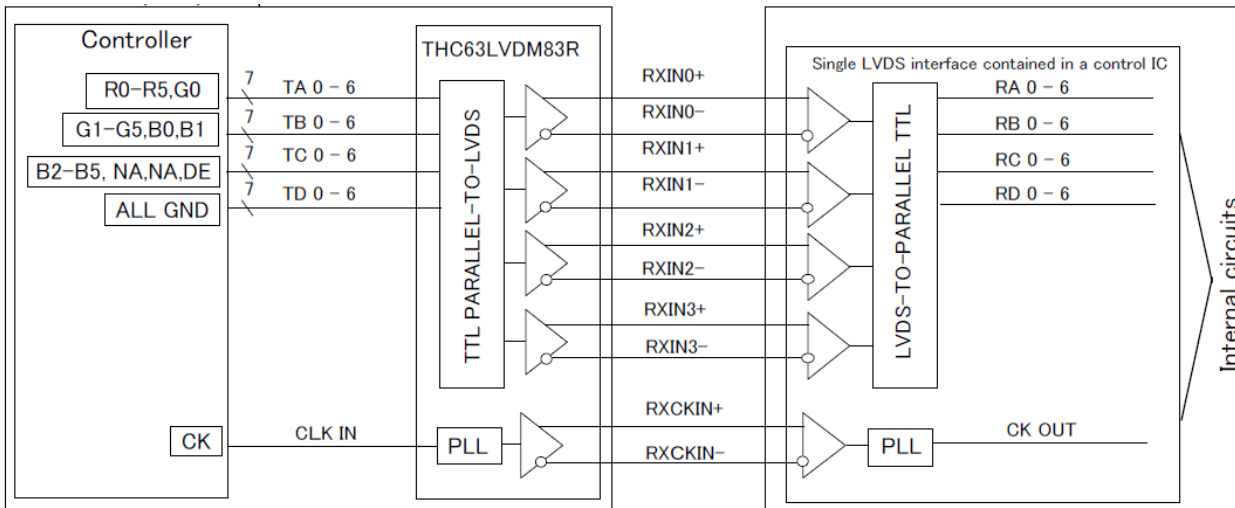
NA: Not Available

ATM0700L76(ZETTLER DISPLAYS)TFT MODULE SPEC V1.2

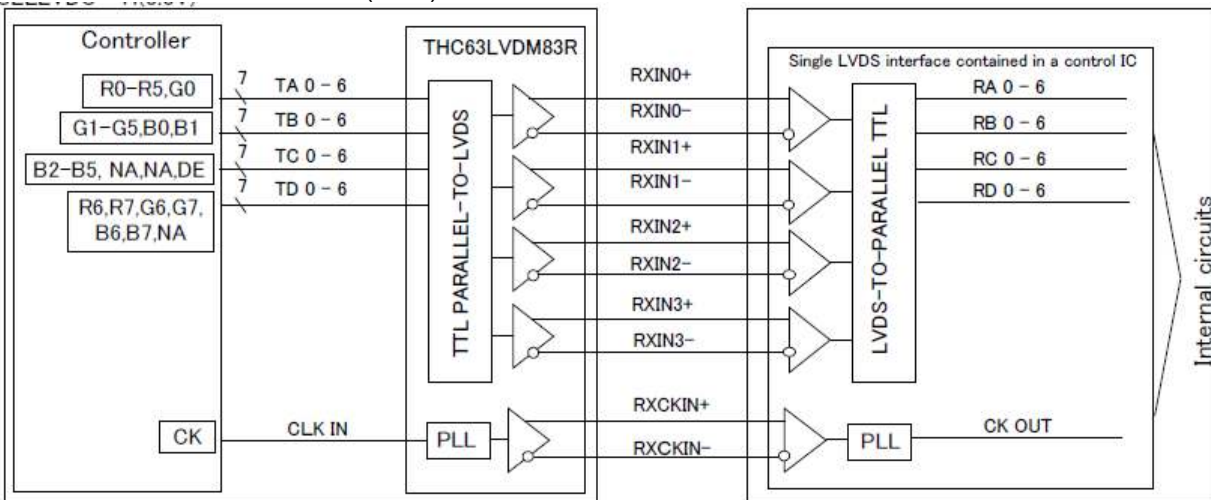
8bit JEIDA mode, SELLVDS = L(GND) or Open :



6bit VESA mode, SELLVDS = L(GND) or Open:



8bit VESA mode, SELLVDS = H(3.3V):



3. Operating Specification

3.1 ABSOLUTE MAXIMUM RATINGS

Item	Symbol	Values		Unit	Remark
		Min.	Max.		
Power Voltage	V_{CC}	-0.3	5.0	V	
LVDS input voltage	V_{IL}	-0.3	$V_{CC}+0.3$	V	
Operation Temperature	T_{OP}	-40	85	°C	
Storage Temperature	T_{ST}	-40	85	°C	
LED Reverse Voltage	V_R	-	1.2	V	Each LED Note 2
LED Forward Current	I_F		25	mA	Each LED

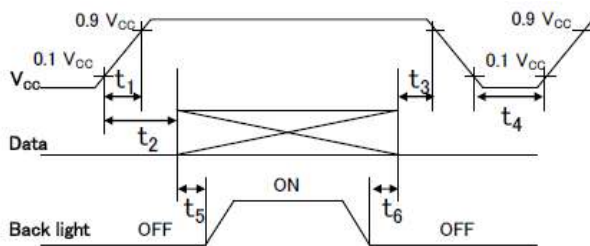
Note 1: The absolute maximum rating values of this product are not allowed to be exceeded at any times. Should a module be used with any of the absolute maximum ratings exceeded, the characteristics of the module may not be recovered, or in an extreme case, the module may be permanently destroyed.

Note 2: V_R Conditions: Zener Diode 20mA

3.1.1 Typical Operation Conditions

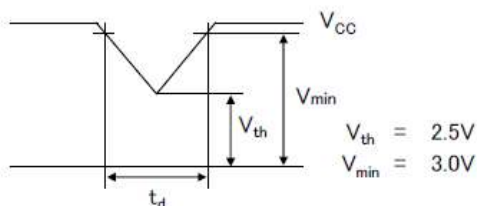
Item	Symbol	Values			Unit	Remark
		Min.	Typ.	Max.		
Power Voltage	V_{CC}	3.0	3.3	3.6	V	Note 1
Current dissipation	I_{CC}		65	130	mA	
Input voltage range	V_L	0	--	2.4	V	LVDS
Permissible input ripple voltage	V_{RP}	--	--	$V_{CM}+100$	mV	$V_{CC}=3.3V$
Differential input Threshold voltage	High	--	--	$V_{CM}+100$	mV	$V_{CM}=1.2V$
	Low	--	$V_{CM}-100$	--	mV	
Terminal resistor	R_T	--	100	--	Ω	

Note 1:



- $0 < t_1 \leq 10ms$
- $0 < t_2 \leq 100ms$
- $0 < t_3 \leq 1s$
- $1s \leq t_4$
- $180ms \leq t_5$
- $5ms \leq t_6$

Vcc-dip conditions



- $V_{th} < V_{CC} \leq V_{min}$
- $t_d \leq 10ms$
- $V_{CC} < V_{th}$

Vcc-dip conditions should also follow the On-off conditions for supply voltage

3.1.2 Backlight driving conditions

Item	Symbol	Values			Unit	Remark
		Min.	Typ.	Max.		
Voltage for Backlight circuit	V_L	10.8	12	13.2	V	Note 1
Current for Backlight circuit	I_L	--	450	520	mA	
Power for Backlight circuit	P_L	--	5400	6864	mw	
BLEN Input Low Voltage	EN_{Low}			0.4	V	
BLEN Input High Voltage	EN_{High}	1.4			V	
PWM Dimming Range	PWM	1		100	%	
PWM Frequency	F_{PDIM}	200		200K	Hz	
LED life time	--	80000	100000	--	Hr	Note 2

Note 1: LED power supply voltage is defined as 25°C

Note 2: The "LED life time" is defined as the module brightness decrease to 50% original brightness at $T_a=25^\circ\text{C}$

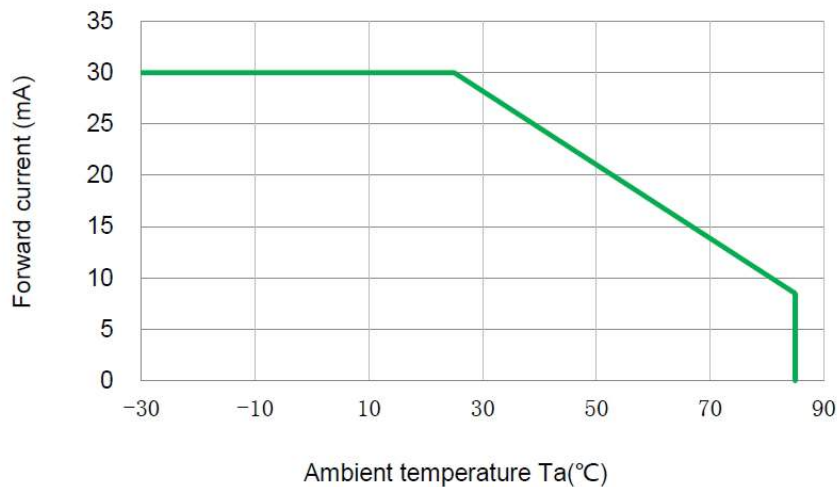
PCBA-side Connector: FI-S6P-HFE(JAE)

Mating connector: FI-S6S(JAE)

Pin No.	Symbol	Function	Level	Note
1	VLED	12V Power Supply Input Voltage	P	
2	VLED	12V Power Supply Input Voltage	P	
3	GLED	GND	P	
4	GLED	GND	P	
5	BLEN	Backlight ON-OFF (High:ON, Low: OFF)	I	
6	PWM	Light Dimming control PWM	I	

Note : For LED(single LED) Working temperature, please refer to the following figure

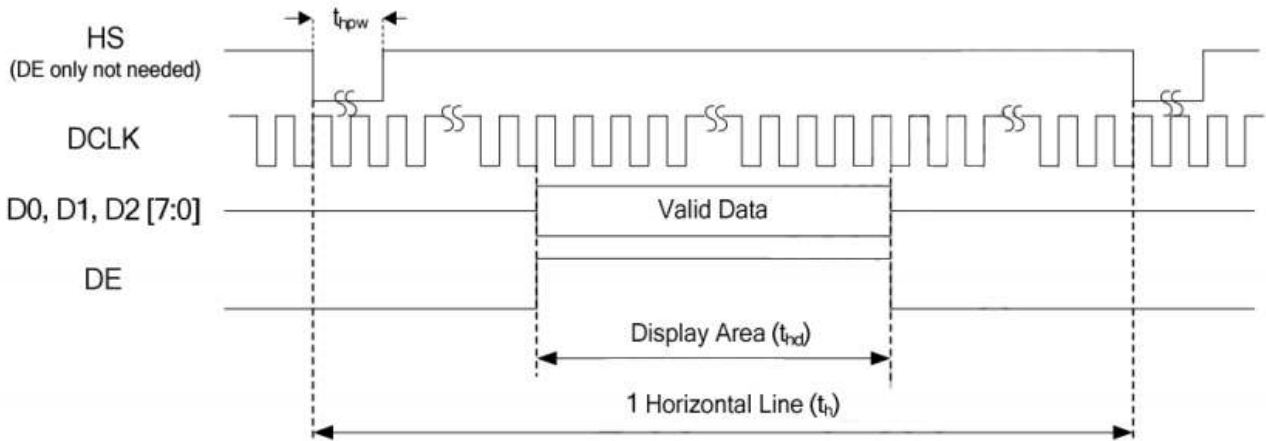
Fig.5 Forward current VS. Ambient temperature



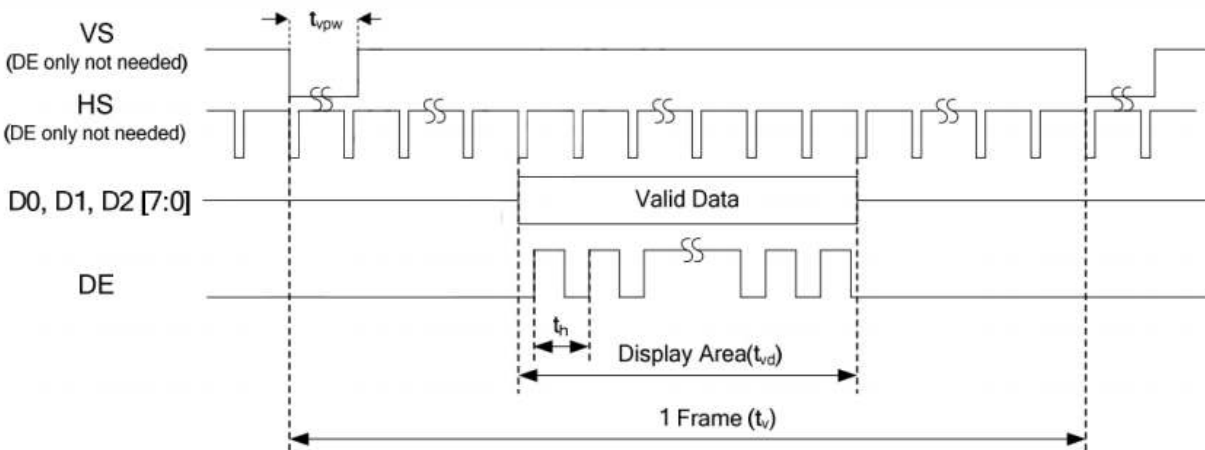
3.2 Power Sequence and timing

3.2.1 Timing

• Horizontal



• Vertical

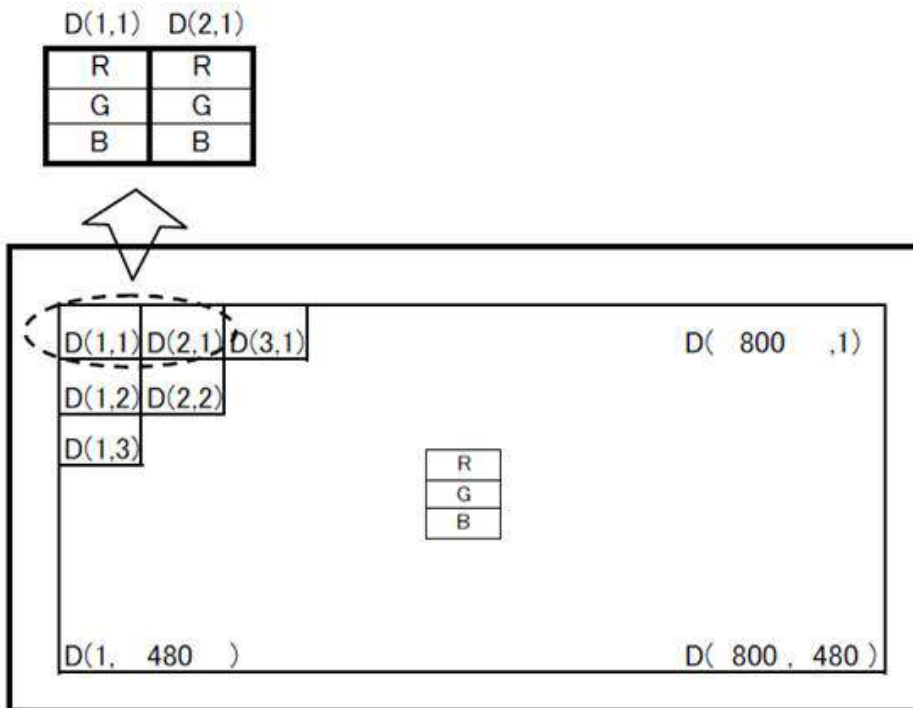


Item	Symbol	Values			Unit	Remark
		Min.	Typ.	Max.		
Horizontal Display Area	thd	--	800	--	DCLK	
DCLK Frequency	fclk	24.2	24.9	38.9	MHz	
One Horizontal Line	th	829	842	1040	DCLK	
HS Pulse Width	thpw	10	12	255	DCLK	
HS Blanking	thb	5	16	255	DCLK	
HS Front Porch	thfp	24	26	260	DCLK	

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Item	Symbol	Values			Unit	Remark
		Min.	Typ.	Max.		
Vertical Display Area	tvd	--	480	--	TH	
VS Period Time	tv	487	493	624	TH	
VS Pulse Width	tvpw	1	3	20	TH	
VS Blanking	tvb	2	5	255	TH	
VS Front Porch	tvfp	5	8	260	TH	

3.2.2 Input data signals and Display Position on the screen



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3.2.2 Input signals, Basic Display Colors and Gray Scale of Each Color

	Colors & Gray scale	Data signal																								
		Gray Scale	R0	R1	R2	R3	R4	R5	R6	R7	G0	G1	G2	G3	G4	G5	G6	G7	B0	B1	B2	B3	B4	B5	B6	B7
Basic Color	Black	—	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	Blue	—	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	X	X	1	1	1	1	1	1
	Green	—	0	0	0	0	0	0	0	0	X	X	1	1	1	1	1	1	0	0	0	0	0	0	0	0
	Cyan	—	0	0	0	0	0	0	0	0	X	X	1	1	1	1	1	1	X	X	1	1	1	1	1	1
	Red	—	X	X	1	1	1	1	1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	Magenta	—	X	X	1	1	1	1	1	1	0	0	0	0	0	0	0	0	X	X	1	1	1	1	1	1
	Yellow	—	X	X	1	1	1	1	1	1	X	X	1	1	1	1	1	1	0	0	0	0	0	0	0	0
	White	—	X	X	1	1	1	1	1	1	X	X	1	1	1	1	1	1	X	X	1	1	1	1	1	1
Gray Scale of Red	Black	GS0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	↑	GS1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	Darker	GS2	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	↑	↑	↑							↑							↑									
	↓	↓	↓							↓							↓									
	Brighter	GS250	1	0	0	1	1	1	1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	↓	GS251	1	1	0	1	1	1	1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	Red	GS252	X	X	1	1	1	1	1	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
Gray Scale of Green	Black	GS0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	↑	GS1	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	Darker	GS2	0	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	↑	↑	↑							↑							↑									
	↓	↓	↓							↓							↓									
	Brighter	GS250	0	0	0	0	0	0	0	0	1	0	0	1	1	1	1	1	0	0	0	0	0	0	0	0
	↓	GS251	0	0	0	0	0	0	0	0	1	1	0	1	1	1	1	1	0	0	0	0	0	0	0	0
	Green	GS252	0	0	0	0	0	0	0	0	X	X	1	1	1	1	1	1	0	0	0	0	0	0	0	0
Gray Scale of Blue	Black	GS0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	↑	GS1	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0	0
	Darker	GS2	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	0	0	0	0	0	0
	↑	↑	↑							↑							↑									
	↓	↓	↓							↓							↓									
	Brighter	GS250	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	0	0	1	1	1	1	1
	↓	GS251	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	1	1	0	1	1	1	1	1
	Blue	GS252	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	X	X	1	1	1	1	1	1

0 :Low level voltage 1 :High level voltage X :Don't care

Each basic color can be displayed in 253 gray scales from 8 bit data signals. According to the combination of total 24 bit data signals, the 16-million-color display can be achieved on the screen.

4.0 OPTICAL SPECIFICATIONS

Item	Symbol	Condition	Values			Unit	Remark
			Min.	Typ.	Max.		
Viewing Angle (CR ≥ 10)	θ_L	$\Phi=180^\circ$ (9 O'CLOCK)	70	85	--	degree	Note 1
	θ_R	$\Phi=0^\circ$ (3 O'CLOCK)	70	85	--		
	θ_T	$\Phi=90^\circ$ (12 O'CLOCK)	70	85	--		
	θ_B	$\Phi=270^\circ$ (6 O'CLOCK)	70	85	--		
Response Time	T_{ON}	Normal $\Theta=\Phi=0^\circ$	--	10	15	msec	Note 3
	T_{OFF}		--	20	25	msec	Note 3
Contrast Ratio	CR		700	900	--	--	Note 4
Color Chromaticity	W_X		0.26	0.31	0.36	--	Note 2
	W_Y		0.29	0.34	0.39	--	Note 5 Note 6
Luminance	L		880	1100	--	cd/m ²	Note 6
Luminance Uniformity	YU		75	80	--	%	Note 7

Test Conditions:

1. PWM=100%, the ambient temperature is 25°C.
2. The test systems refer to Note 2.

Note 1: Definition of viewing angle range

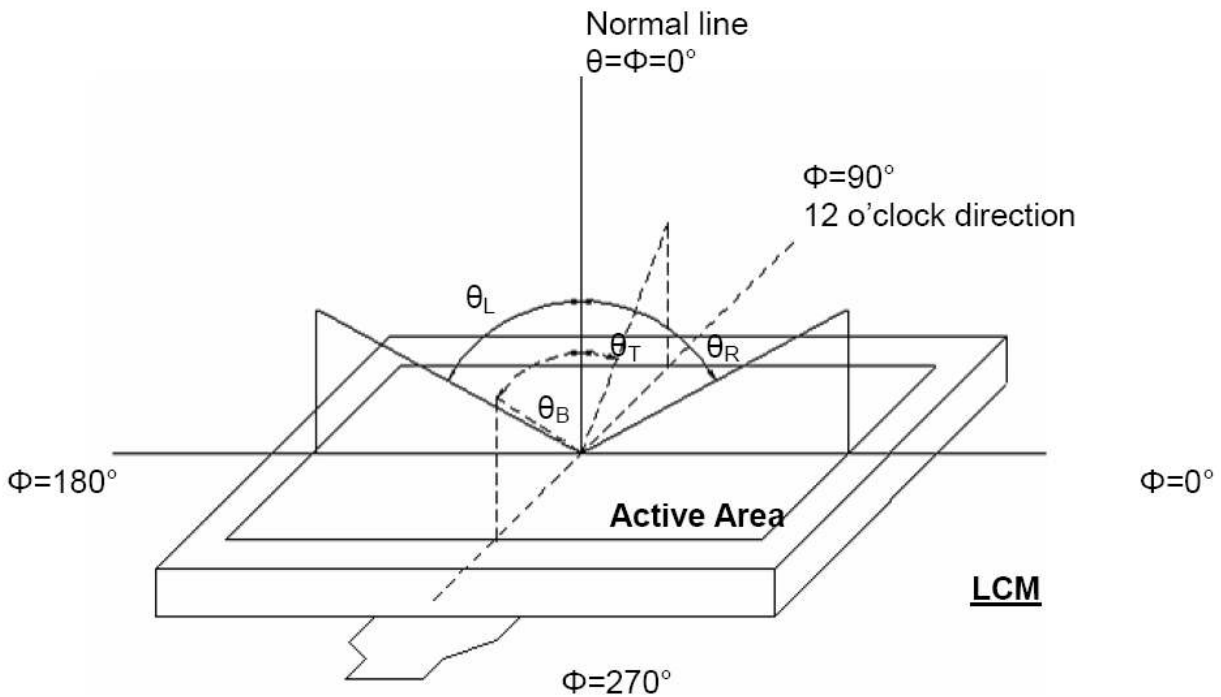


Figure 4.1 Definition of viewing angle.

Note 2: Definition of optical measurement system.

The optical characteristics should be measured in dark room. After 30 minutes operation, the optical properties are measured at the center point of the LCD screen. (Response time is measured by Photo detector TOPCON)

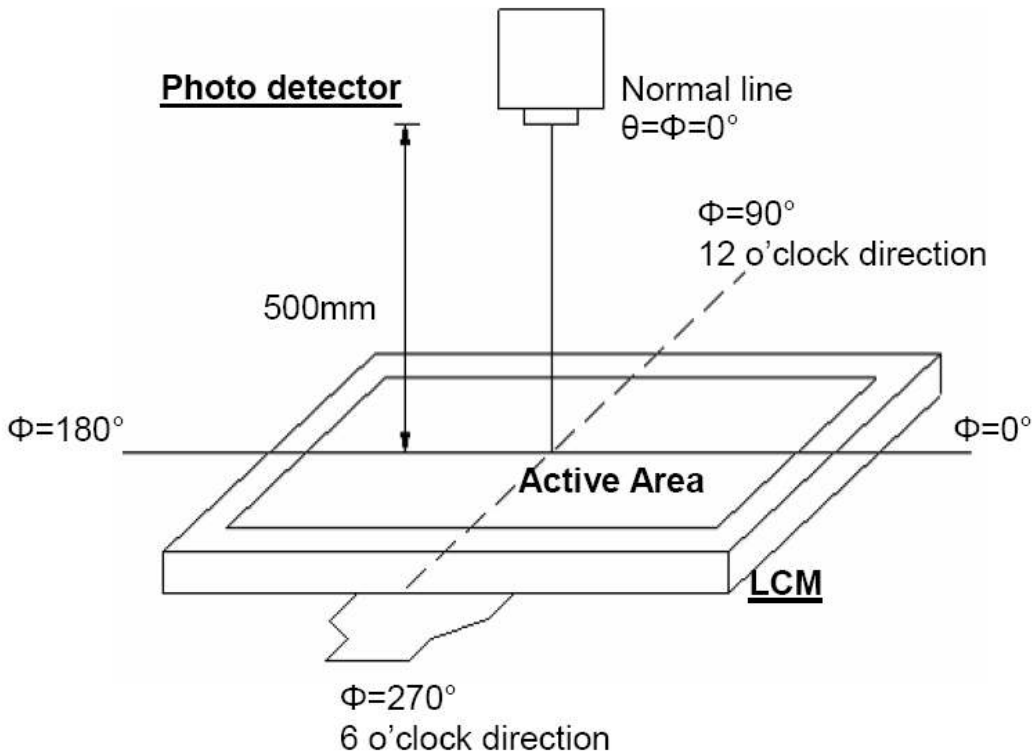


Figure 4.2 Optical measurement system setup

Note 3: Definition of Response time

The response time is defined as the LCD optical switching time interval between "White" state and "Black" state. Rise time (T_{ON}) is the time between photo detector output intensity changed from 90% to 10%. And fall time (T_{OFF}) is the time between photo detector output intensity changed from 10% to 90%.

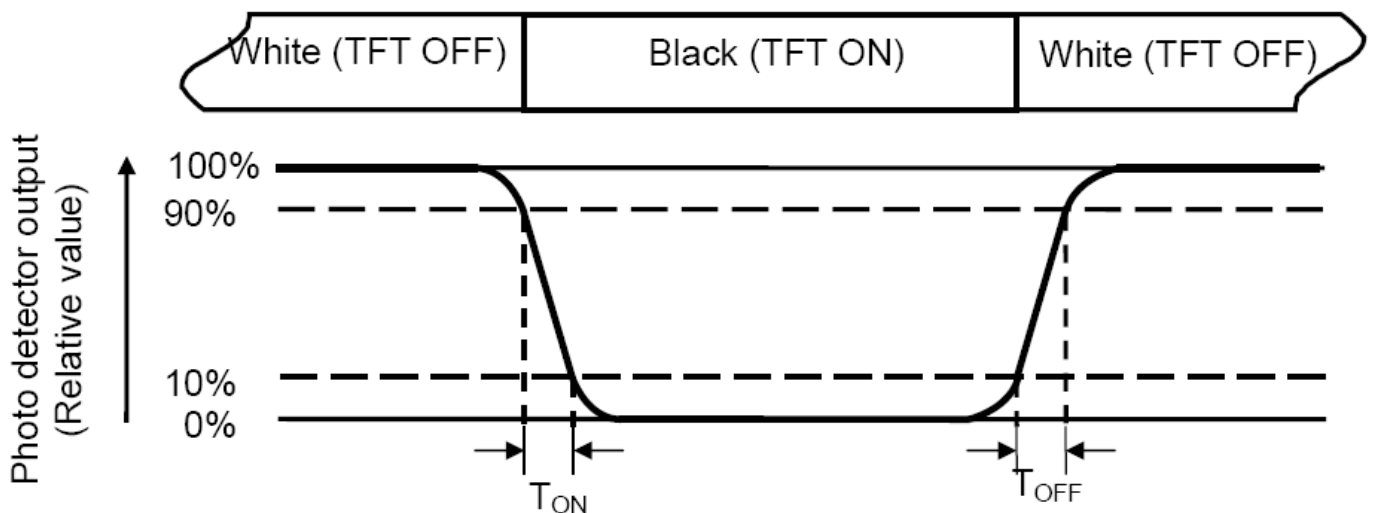


Figure 4.3 Definition of response.

Note 4: Definition of contrast ratio

$$\text{Contrast ratio(CR)} = \frac{\text{Luminance measured when LCD on the "white" state}}{\text{Luminance measured when LCD on the "black" state}}$$

Note 5: Definition of color chromaticity (CIE1931)

Color coordinates measured at center point of LCD.

Note 6: All input terminals LCD panel must be ground while measuring the center area of the panel.

Note 7: Definition of Luminance Uniformity

Active area is divided into 9 measuring areas (Refer to Fig. 4-4).Every measuring point is placed at the center of each measuring area.

$$\text{Luminance Uniformity (Yu)} = \frac{B_{min}}{B_{max}}$$

L-----Active area length W----- Active area width

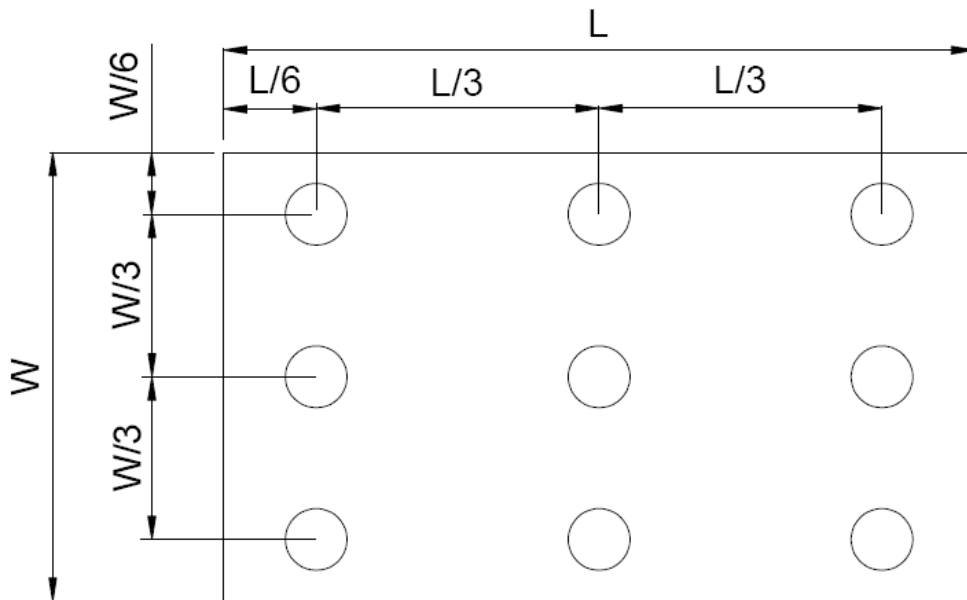


Figure 4.3 Definition of measuring points.

Bmax: The measured maximum luminance of all measurement position.

Bmin: The measured minimum luminance of all measurement position.

5. RELIABILITY TEST

Item	Test Condition Item	Remark
High temperature storage	Ta= 85 °C 240hrs	Note 1 Note 4
Low temperature storage	Ta=-40 °C 240hrs	Note 1 Note 4
High temperature operation	Ts= 85 °C 240hrs	Note 2 Note 4
Low temperature operation	Ts=-40 °C 240hrs	Note 1 Note 4
High temperature/High humidity operation	90% RH 60°C 240hrs	Note 4
Thermal Shock	-30°C/30 min ~ +80°C/30 min for a total 100 cycles, Start with cold temperature and end with high temperature.	Note 4
Vibration test	Freq:10~55~10Hz Amplitude:1.5mm 2 hours for each direction of X,Y,Z (6 hours for total)	
Mechanical shock	100G 6ms,±X, ±Y, ±Z 3 times for each direction	
Package vibration test	Random Vibration : 0.015G*G/Hz from 5-200HZ, -6dB/Octave from 200-500HZ 2 hours for each direction of X. Y. Z. (6 hours for total)	
Package drop test	Height:60 cm 1 corner, 3 edges, 6 surfaces	
Electro static discharge	± 2KV, Human Body Mode, 100pF/1500Ω	

Note 1: Ta is the ambient temperature of samples.

Note 2: Ts is the temperature of panel's surface.

Note 3: In the standard condition, there shall be no practical problem that may affect the display function. After the reliability test, the product only guarantees operation, but don't guarantee all of the cosmetic specification.

Note 4: Before cosmetic and function test, the product must have enough recovery time, at least 2 hours at room temperature.

6. PRECAUTION FOR USING LCM

1. When design the product with this LCD Module, make sure the viewing angle matches to its purpose of usage.
2. As LCD panel is made of glass substrate, Dropping the LCD module or banging it against hard objects may cause cracking or fragmentation. Especially at corners and edges.
3. Although the polarizer of this LCD Module has the anti-glare coating, always be careful not to scratch its surface. Use of a plastic cover is recommended to protect the surface of polarizer.
4. If the LCD module is stored at below specified temperature, the LC material may freeze and be deteriorated. If it is stored at above specified temperature, the molecular orientation of the LC material may change to Liquid state and it may not revert to its original state. Excessive temperature and humidity could cause polarizer peel off or bubble. Therefore, the LCD module should always be stored within specified temperature range.
5. Saliva or water droplets must be wiped off immediately as those may leave stains or cause color changes if remained for a long time. Water vapor will cause corrosion of ITO electrodes.
6. If the surface of LCD panel needs to be cleaned, wipe it swiftly with cotton or other soft cloth. If it is not still clean enough, blow a breath on the surface and wipe again.
7. The module should be driven according to the specified ratings to avoid malfunction and permanent damage. Applying DC voltage cause a rapid deterioration of LC material. Make sure to apply alternating waveform by continuous application of the M signal. Especially the power ON/OFF sequence should be kept to avoid latch-up of driver LSIs and DC charge up to LCD panel.
8. Mechanical Considerations
 - a) LCM are assembled and adjusted with a high degree of precision. Avoid excessive shocks and do not make any alterations or modifications. The following should be noted.
 - b) Do not tamper in any way with the tabs on the metal frame.
 - c) Do not modify the PCB by drilling extra holes, changing its outline, moving its components or modifying its pattern.

9. Static Electricity

a) Operator

Wear the electrostatics shielded clothes because human body may be statically charged if not ware shielded clothes. Never touch any of the conductive parts such as the LSI pads; the copper leads on the PCB and the interface terminals with any parts of the human body.

b) Equipment

There is a possibility that the static electricity is charged to the equipment, which has a function of peeling or friction action (ex: conveyer, soldering iron, working table). Earth the equipment through proper resistance (electrostatic earth: 1×10^8 ohm).

Only properly grounded soldering irons should be used.

If an electric screwdriver is used, it should be well grounded and shielded from commutator sparks.

The normal static prevention measures should be observed for work clothes and working benches; for the latter conductive (rubber) mat is recommended.

c) Floor

Floor is the important part to drain static electricity, which is generated by operators or equipment.

There is a possibility that charged static electricity is not properly drained in case of insulating floor. Set the electrostatic earth (electrostatic earth: 1×10^8 ohm).

d) Humidity

Proper humidity helps in reducing the chance of generating electrostatic charges. Humidity should be kept over 50%RH.

e) Transportation/storage

The storage materials also need to be anti-static treated because there is a possibility that the human body or storage materials such as containers may be statically charged by friction or peeling.

The modules should be kept in antistatic bags or other containers resistant to static for storage.

f) Soldering

Soldering anything to this TFT display would void the warranty.

g) Others

The laminator (protective film) is attached on the surface of LCD panel to prevent it from scratches or stains. It should be peeled off slowly using static eliminator.

Static eliminator should also be installed to the workbench to prevent LCD module from static charge.

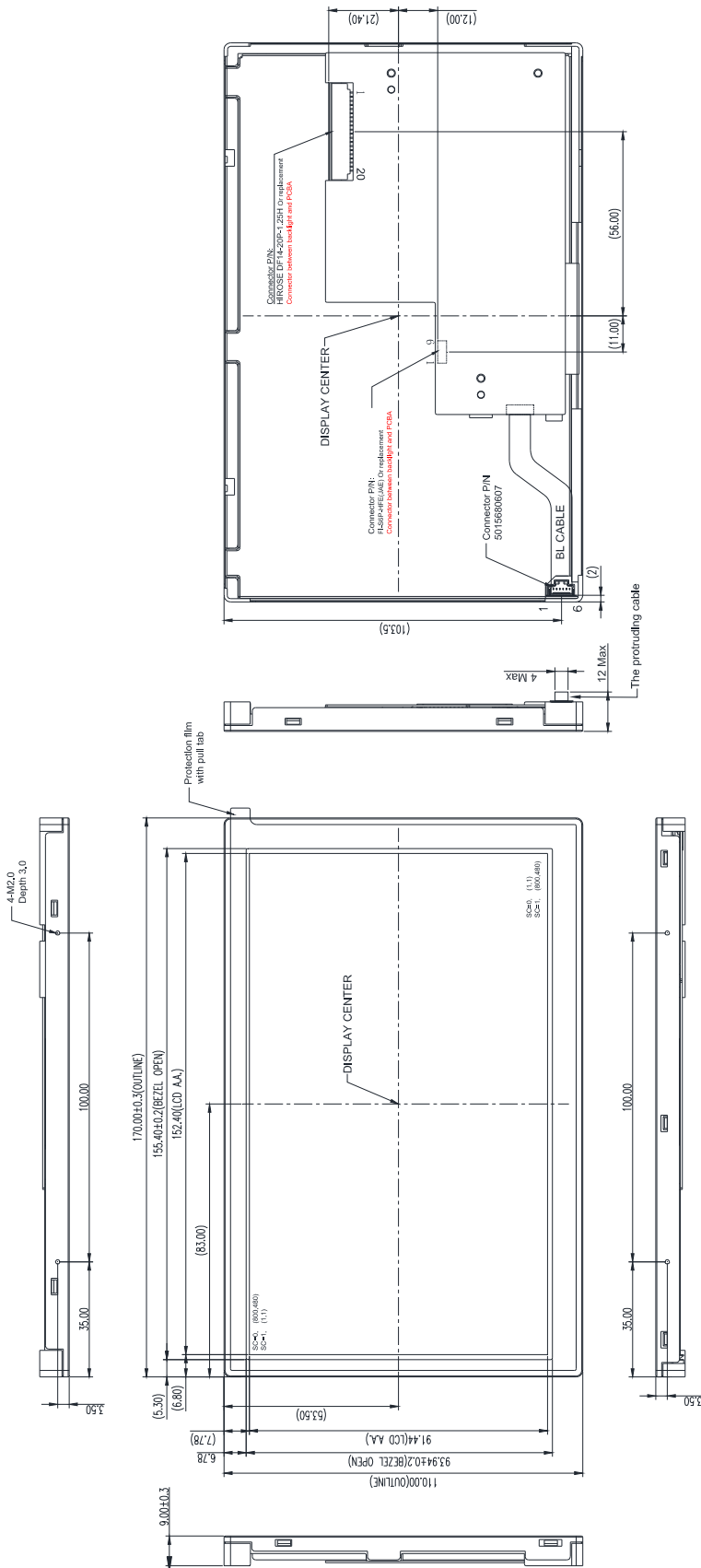
10. Operation

- a) Driving voltage should be kept within specified range; excess voltage shortens display life.
- b) Response time increases with decrease in temperature.
- c) Display may turn black or dark blue at temperatures above its operational range; this is (however not pressing on the viewing area) may cause the segments to appear "fractured".
- d) Mechanical disturbance during operation (such as pressing on the viewing area) may cause the segments to appear "fractured".

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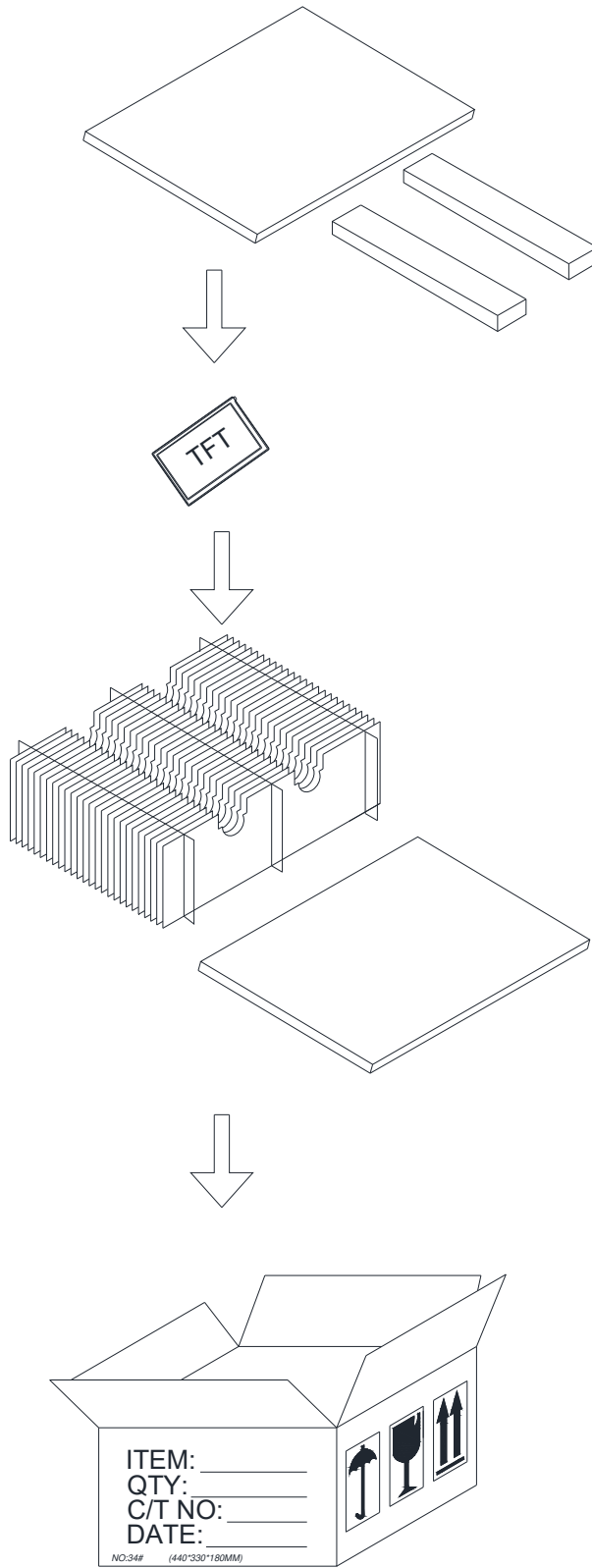
11. If any fluid leaks out of a damaged glass cell, wash off any human part that comes into contact with soap and water. The toxicity is extremely low but caution should be exercised at all the time.
12. Disassembling the LCD module can cause permanent damage and it should be strictly avoided.
13. LCD retains the display pattern when it is applied for long time (Image retention). To prevent image retention, do not apply the fixed pattern for a long time. Image retention is not a deterioration of LCD. It will be removed after display pattern is changed.
14. Do not use any materials, which emit gas from epoxy resin (hardener for amine) and silicone adhesive agent (dealcohol or deoxym) to prevent discoloration of polarizer due to gas.
15. Avoid the exposure of the module to the direct sunlight or strong ultraviolet light for a long time.

7. MECHANICAL DRAWING



Note: Dimensions marked with "()" are for reference.
General tolerance: ± 0.3

8. PACKAGE DRAWING



9. INSPECTION SPECIFICATION

1. SCOPE SPECIFICATIONS CONTAIN

- 1.1 DISPLAY QUALITY EVALUATION
- 1.2 MECHANICS SPECIFICATION

2. SAMPLING PLAN

UNLESS THERE IS OTHER AGREEMENT, THE SAMPLING PLAN FOR INCOMING INSPECTION SHALL FOLLOW MIL-STD-105E.

- 2.1 LOT SIZE: QUANTITY PER SHIPMENT AS ONE LOT (DIFFERENT MODEL AS DIFFERENT LOT).
- 2.2 SAMPLING TYPE: NORMAL INSPECTION, SINGLE SAMPLING.
- 2.3 SAMPLING LEVEL: LEVEL II.
- 2.4 AQL: ACCEPTABLE QUALITY LEVEL
 - MAJOR DEFECT: AQL=0.65
 - MINOR DEFECT: AQL=1.0

3. PANEL INSPECTION CONDITION

- 3.1 ENVIRONMENT:
 - ROOM TEMPERATURE: 25±5°C.
 - HUMIDITY: 65±5% RH.
 - ILLUMINATION: 300 ~ 700 LUX.
- 3.2 INSPECTION DISTANCE:
 - 35±5 CM
- 3.3 INSPECTION ANGLE:
 - THE VISION OF INSPECTOR SHOULD BE PERPENDICULAR TO THE SURFACE OF THE MODULE.
- 3.4 INSPECTION TIME:
 - PERCEPTIBILITY TEST TIME: 20 SECONDS MAX.

4. DISPLAY QUALITY

- 4.1 FUNCTION RELATED:
 - THE FUNCTION DEFECTS OF LINE DEFECT, ABNORMAL DISPLAY, AND NO DISPLAY ARE CONSIDERED MAJOR DEFECTS.
- 4.2 BRIGHT/DARK DOTS:

Defect Type	Specification	Major	Minor
Bright Dots	$N \leq 2$		●
Dark Dots	$N \leq 3$		●
Total Bright and Dark Dots	$N \leq 4$		●

Note: 1:

The definition of dot: The size of a defective dot over 1/2 of whole dot is regarded as one defective dot.

Bright dot: Dots appear bright and unchanged in size in which LCD panel is displaying under black pattern.

The bright dot defect must be visible through 2% ND filter

Dark dot: Dots appear dark and unchanged in size in which LCD panel is displaying under pure red, green, blue pattern.

4.3 Pixel Definition:

R	G	B	R	G	B	R	G	B			Dot Defect
R	G	B	R	G	B	R	G	B			Adjacent Dot Defect
R	G	B	R	G	B	R	G	B			Cluster

Note 1:

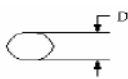
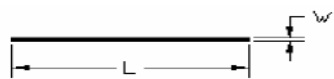
If pixel or partial sub-pixel defects exceed 50% of the affected pixel or sub-pixel area, it shall be considered as 1 defect.

Note 2:

There should be no distinct non-uniformity visible through 2% ND Filter within 2 sec inspection times.

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4.4 Visual Inspection specifications:

<u>Defect Type</u>		<u>Specification Size</u>	<u>Count(N)</u>	Major	Minor	
Dot Shape (Particle · Scratch and Bubbles in display area) 		$D \leq 0.25 \text{ mm}$	Ignored			
		$0.25\text{mm} < D \leq 0.5\text{mm}$	$N \leq 3$		•	
		$D > 0.5\text{mm}$	$N=0$			
Newton Ring (Only for Touch panel)		$D \leq 70\text{mm}$	$N \leq 4$		•	
		$D > 70\text{mm}$	$N=0$			
TSP Fish Eyes (Only for Touch panel) (Bubble/Dent)		$0.1\text{mm} < D \leq 0.2\text{mm}$	$N \leq 4$			
		$0.2\text{mm} < D \leq 0.3\text{mm}$	$N \leq 3$		•	
		$0.3 < D \leq 0.4$	$N \leq 2$			
Line Shape (Particles · Scratch · Lint and Bubbles in display area) 		$W \leq 0.01 \text{ mm}$	Ignored			
		$0.01\text{mm} < W \leq 0.05\text{mm}$ and $L \leq 3\text{mm}$	$N \leq 3$		•	
		$W > 0.05\text{mm}$ or $L > 3 \text{ mm}$	$N=0$			
Bubble in cell (active area)		It should be found by eyes			•	
Bezel	Scratch	No harm			•	
	Dirt				•	
	Wrap				•	
	Sunken				•	
Label	No label	No			•	
	Inverted label				•	
	Broken				•	
	Dirt			Word can be read.		•
	Not clear					•
	Word out of shape			No		•
	Mistake			No		•
	Position			Be attached on right position		•
Screw	Not enough	No			•	
	Limp	No			•	

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Connector	Connection status	No bend on pins and damage		•
FPC/FFC	Broken	No		•

Note: Extraneous substance and scratch not affecting the display of image, for instance, extraneous substance under polarizer film but outside the display area, or scratch on metal bezel and backlight module or polarizer film outside the display area, shall not be considered as defective or non-conforming.