

Specification for Approval

Customer: _____

Model Name: _____

Supplier Approval			Customer approval
R&D Designed	R&D Approved	QC Approved	
<i>Peter</i>	<i>Peng Jun</i>		

Revision Record

REV NO.	REV DATE	CONTENTS	Note
A	2019-10-24	NEW ISSUE	

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1. Scope

This specification defines general provisions as well as inspection standards for TFT module supplied by AMSON electronics.

If the event of unforeseen problem or unspecified items may occur, naturally shall negotiate and agree to solution.

2. General Information

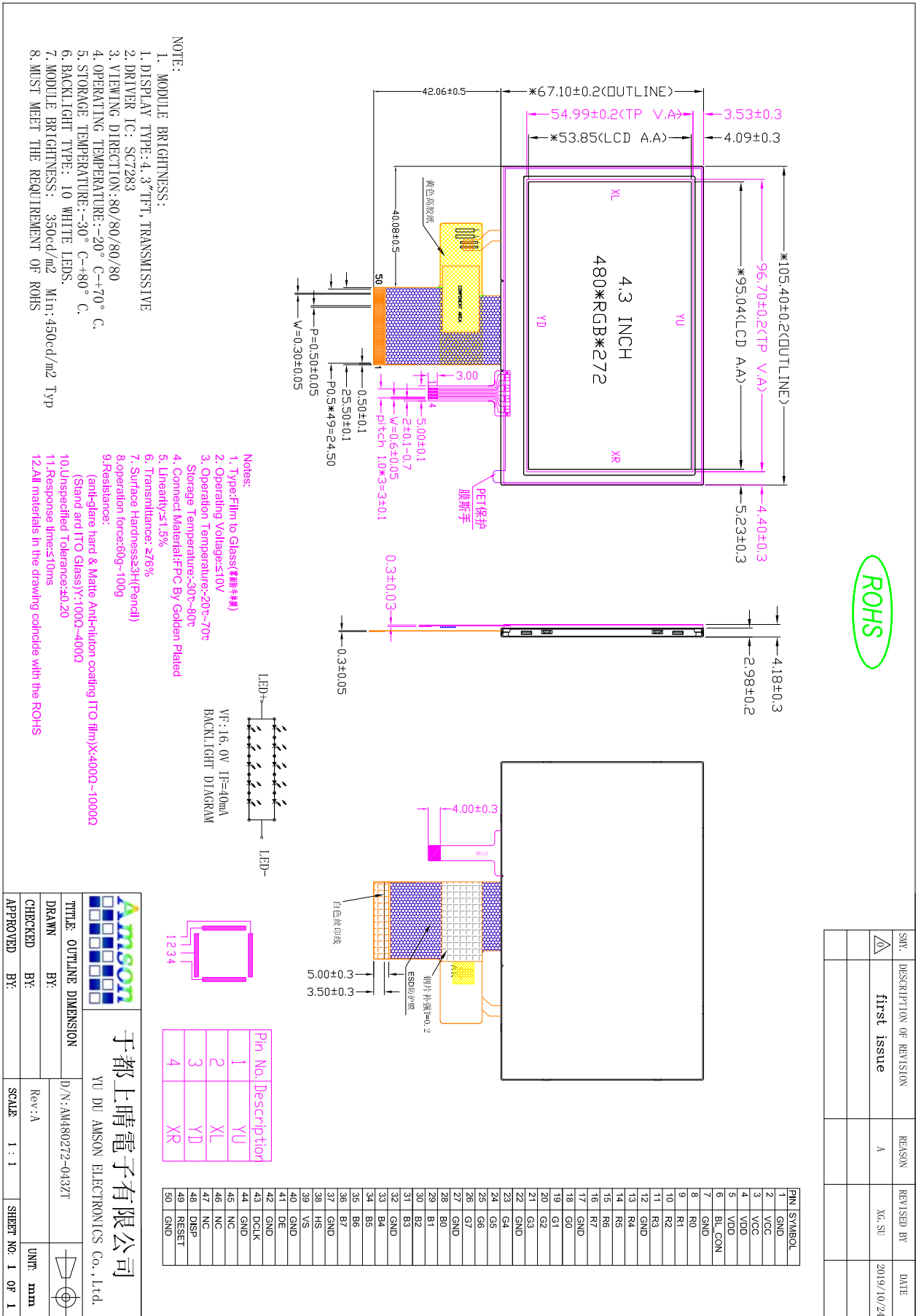
LCM

ITEM	STANDARD VALUES	UNITS
LCD type	4.3" TFT	--
Dot arrangement	480(RGB)×272	dots
Color filter array	RGB vertical stripe	--
Display mode	IPS / Transmission / Normally BALCK	-
Gray Scale Inversion Direction	80/80/80/80	--
Eyes Viewing Direction	ALL	
Driver IC	SC7283	--
Module size	105.40(W)×67.10(H)×4.18(T)	mm
Active area	95.04(W)×53.86(H)	mm
Interface	24bit RGB	--
Operating temperature	-20 ~ +70	°C
Storage temperature	-30 ~ +80	°C
Back Light	10 White LED	--

RTP

ITEM	STANDARD VALUES	UNITS
RTP type	Film + Glass + FPC	--
Surface hardness	3H	--
Transmittance	≥76%	--
RTP size	104.9(W)×65.9(H)×1.2(T)	mm
Active area	96.7(W)×55.99(H)	mm
Response Time	≤10ms	ms
Linearity	≤1.5%	%
Line writing life	100000	times
Operation force	60~100g	g
Resistance	X:400Ω ~ 1000Ω Y:100Ω ~ 400Ω	Ω

3. External Dimensions



4. Interface Description

PIN	PIN NAME	DESCRIPTION
1	GND	Power ground.
2, 3	VCC	Supply Voltage
4, 5	VDD	BL VIN Voltage
6	BL_CON	Common Voltage.
7	GND	Power ground.
8~11	R0~R3	Red Data Input
12	GND	Power ground.
13~16	R4~R7	Red Data Input.
17	GND	Power ground.
18~21	G0	Green Data Input
22	GND	Power ground.
23~26	G4	Green Data Input.
27	GND	Power ground.
28~31	B0	Blue Data Input
32	GND	Power ground.
33~36	B4	Blue Data Input.
37	GND	Power ground.
38	HS	Horizontal sync input. Negative polarity.
39	VS	Vertical sync input. Negative polarity.
40	GND	Power ground.
41	DE	Data Enable signal.
42	GND	Power ground.
43	DCLK	Clock input.
44	GND	Power ground.
45~47	NC.	Not connect.
48	DISP	STANDBY MODE. NORMALLY PULLED HIGH. DISP=H,NORMAL OPERATION.(DEFAULT) DISP=L, TIMING ,CONTORLLER , SOURCE DRIVER WILL TURN OFF,ALL OUTPUT ARE HIGH-Z
49	RESET	Global reset pin. Active low to enter reset state. Suggest to connecting with an RC reset circuit for stability. Normally pull high.(R=10KΩ, C=1μF)
50	GND	Power ground.

RTP

Pin	Symbol	Description.
1	YU	RTP Up
2	XL	RTP Left
3	YD	RTP Down
4	XR	RTP Right

5. Absolute Maximum Ratings

Item	Symbol	Min.	Max.	Unit
Power Supply Voltage	VCC	-0.3	3.6	V
	VDD	-0.3	18	V
Operating Temperature	T _{OP}	-20	70	°C
Storage Temperature	T _{ST}	-30	80	°C
Storage Humidity	HD	-	90	%RH

6. DC Characteristics

Item	Symbol	Min.	Typ.	Max.	Unit	Remark
Analog Supply Voltage	VCC	3.0	3.3	3.6	V	-
	VDD	3	5	12	V	-
Input High Voltage	V _{IH}	0.7VCC	-	VCC	V	-
Input Low Voltage	V _{IL}	GND	-	0.3 VCC	V	-
Output High Voltage	V _{OH}	0.8 VCC	-	VCC	V	-
Output Low Voltage	V _{OL}	GND	-	0.2 VCC	V	-
Logic Voltage	BL_PWM		3.3V		V	-
PWM Frequency	F _{pwm}	5		100	KHz	-

Note: Maximum current from RGB full-display

7. Timing Characteristics

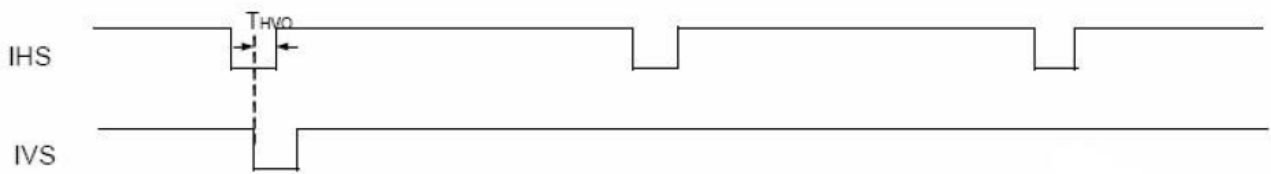
7.1 Parallel RGB Interface Timing Characteristics

Hsync and Vsync timing

CCIR601 timing waveform VS_POL=H, HS_POL=L in Register R2)

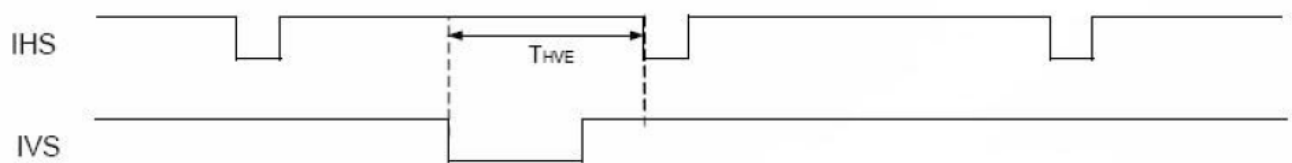
IHS and IVS timing

- Odd field



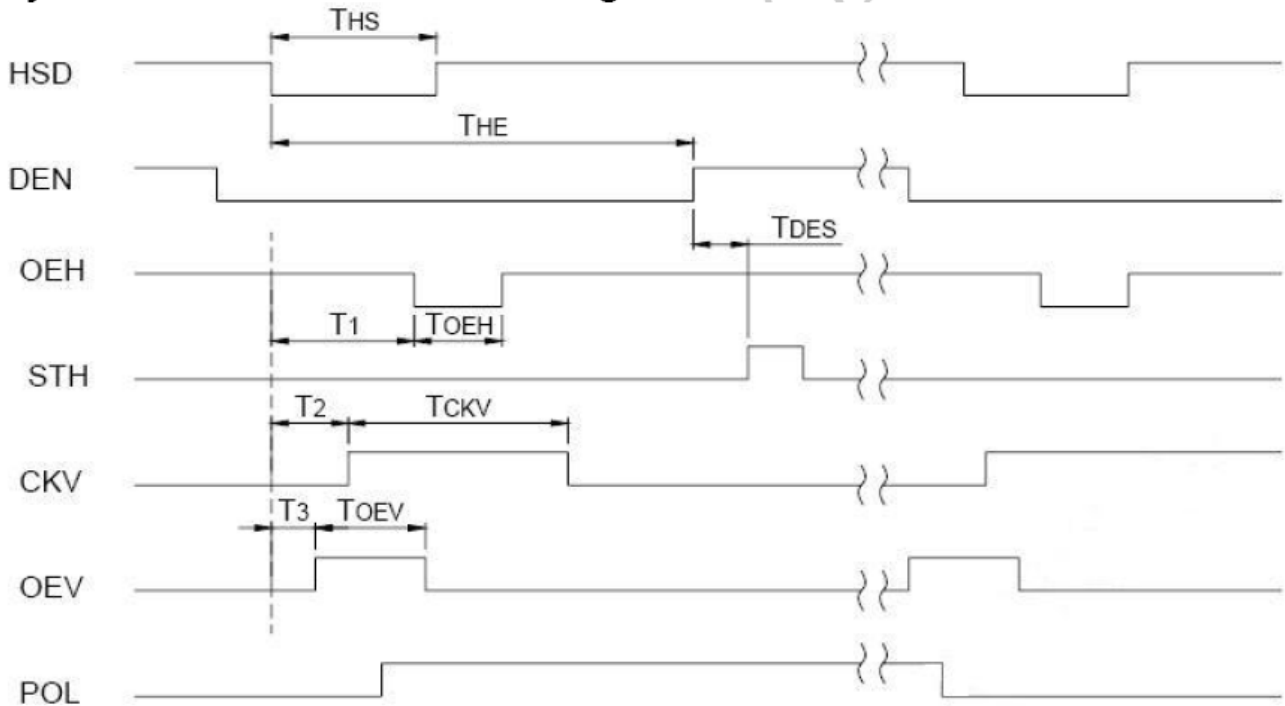
IHS and IVS waveforms in odd field

- Even field

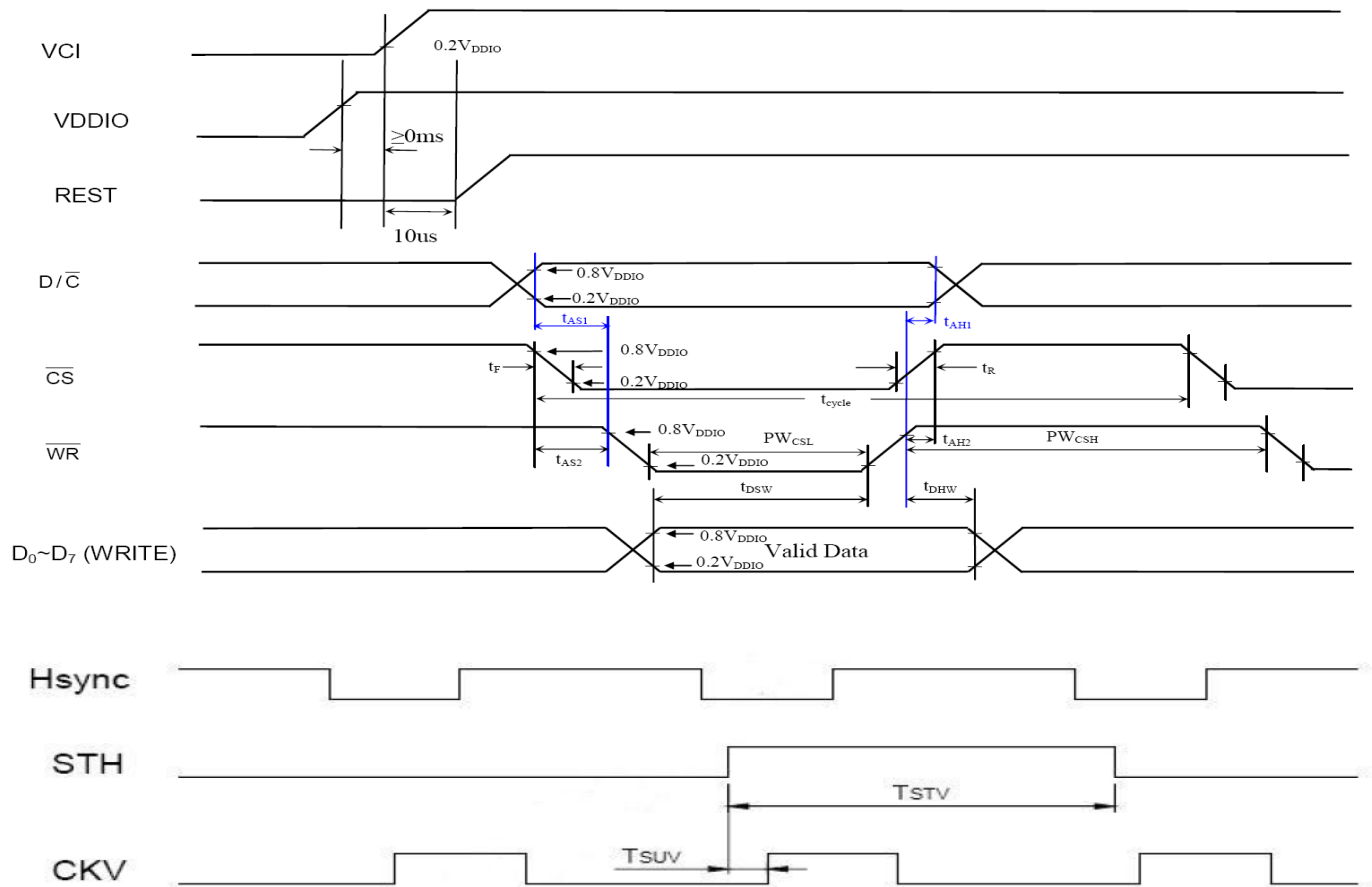


IHS and IVS waveforms in even field

Hsync and horizontal control timing waveform



Hsync and vertical shift clock timing waveform



7.2 AC Characteristic

VDD=VDDI= 3.3V, AGND= 0V

Item	Symbol	Min.	Typ.	Max.	Unit	Conditions
System operation timing						
VDD power source slew time	TPOR	-	-	20	ms	From 0V to 99% VDD
GRB pulse width	tRSTW	10	50	-	us	R=10Kohm, C=1uF
Input/ Output timing						
CLK pulse duty	Tcw	40	50	60	%	
Hsync width	Thw	1	-	-	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	10	-	-	ns	
DE setup time	Tdehd	10	-	-	ns	
SD output stable time	Tst	-	-	12	us	Output settled within +20mV Loading = 6.8k+28.2pF.
GD output rise and fall time	Tgst	-	-	6	us	Output settled (5%~95%), Loading = 4.7k+29.8pF
3-wire serial communication						
Delay between CSB and VSYNC	Tcv	1			us	
CS input setup time	Ts0	50			ns	
Serial data input setup time	Ts1	50			ns	
CS input hold time	Th0	50			ns	
Serial data input hold time	Th1	50			ns	
SCL pulse high width	Twh1	50			ns	
SCL pulse low width	Twl1	50			ns	
CS pulse high width	Tw2	400			ns	

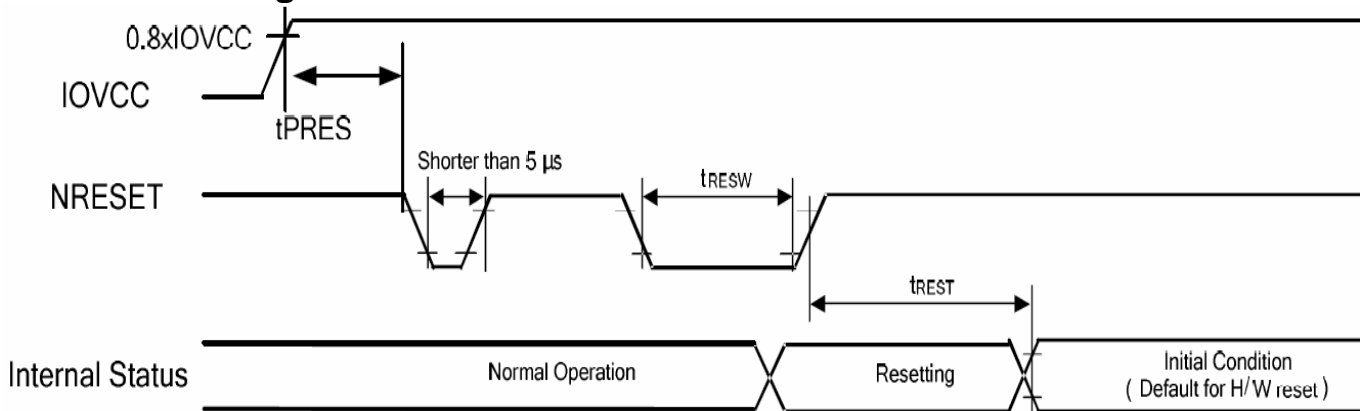
7.3 RGB Input Timing Table

Parallel 24-bit RGB Timing Table

Item	Symbol	Min.	Typ.	Max.	Unit	Remark
DCLK Frequency	Fclk	8	9	12	MHz	
DCLK Period	Tclk	83	111	125	Ns	
HSYNC	Period Time	Th	485	531	DCLK	
	Display Period	Thdisp		480	DCLK	
	Back Porch	Thbp	3	43	DCLK	By H_Blanking setting
	Front Porch	Thfp	2	8	DCLK	
	Pulse Width	Thw	2	4	DCLK	
VSYNC	Period Time	Tv	276	292	H	
	Display Period	Tvdisp		272	H	
	Back Porch	Tvbp	2	12	H	By V_Blanking setting
	Front Porch	Tvfp	2	8	H	
	Pulse Width	Tvw	2	4	H	

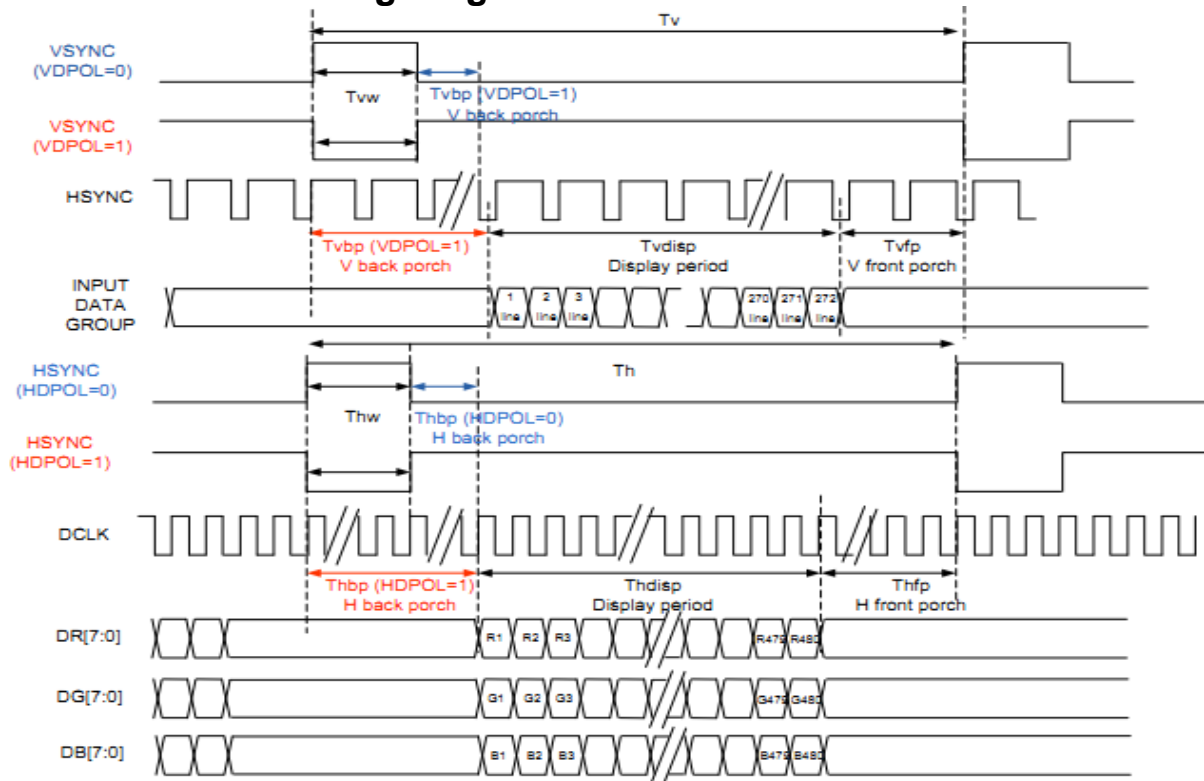
Note: It is necessary to keep Tvbp =12 and Thbp =43 in sync mode. DE mode is unnecessary to keep it.

7.4 Reset Timing Characteristics

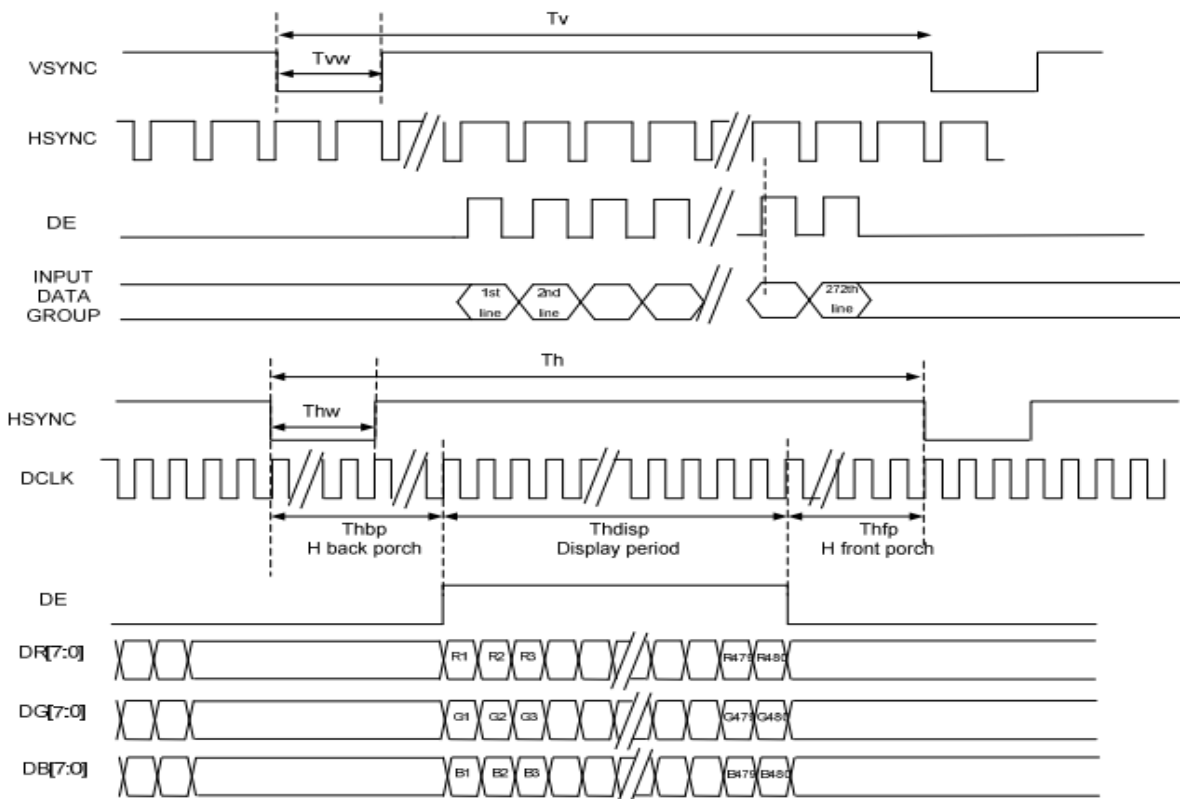


Symbol	Parameter	Related Pins	Spec.			Note	Unit
			Min.	Typ.	Max.		
tRESW	Reset low pulse width ⁽¹⁾	NRESET	10	-	-	-	μs
tREST	Reset complete time ⁽²⁾	-	5	-	-	When reset applied during STB OUT mode	ms
		-	120	-	-	When reset applied during STB mode	ms
tPRES	Reset goes high level after Power on time	NRESET & IOVCC	1	-	-	Reset goes high level after Power on	ms

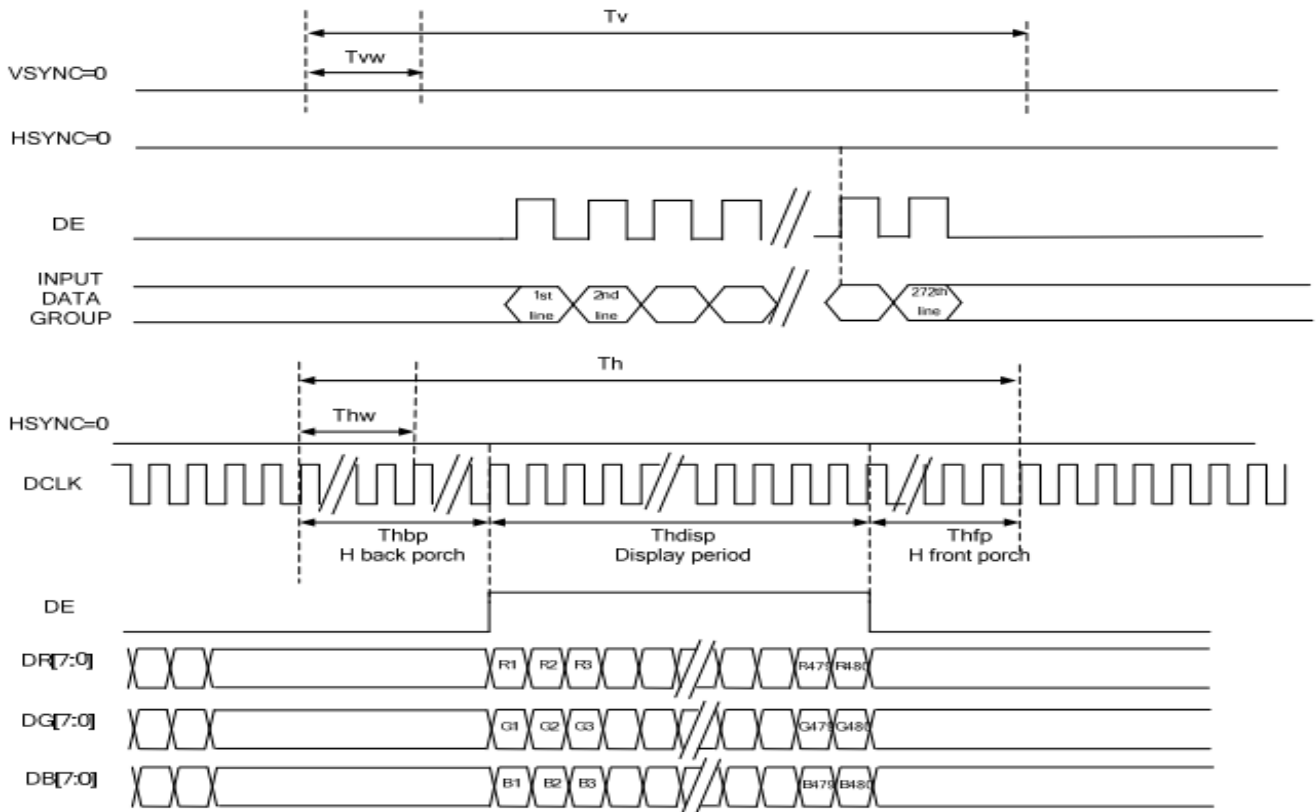
7.5 SYNC Mode timing Diagram



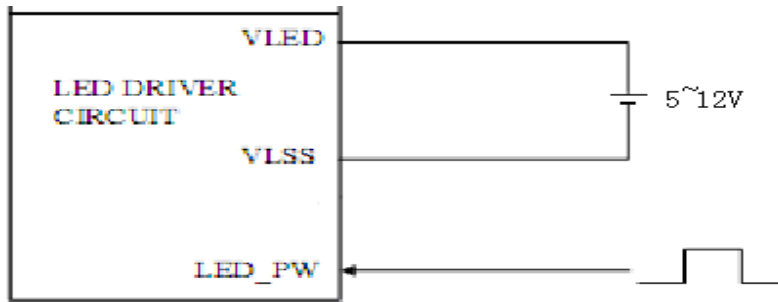
7.6 SYNC_DE Mode timing Diagram



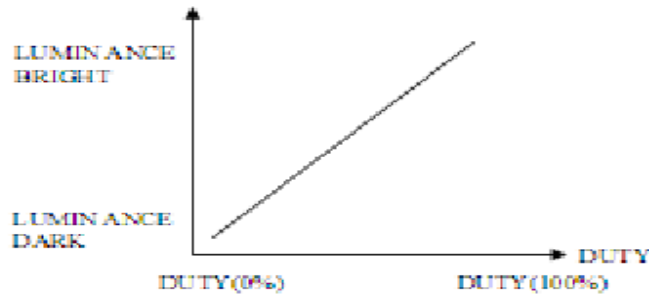
7.7 DE Mode timing Diagram



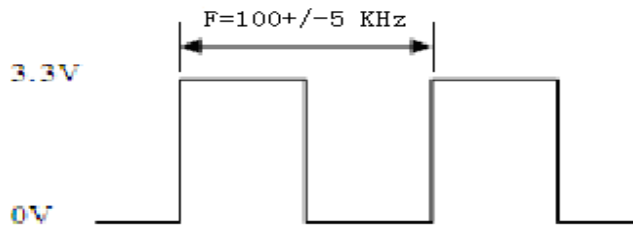
8. Backlight Characteristic



NOTE (1) : ADJUST THE PWM SIGNAL IN ORDER TO CONTROL LED BACKLIGHTS BRIGHTNESS. THE HIGHER THE DUTY CYCLE, THE HIGHER THE BRIGHTNESS LUMINANCE



NOTE (2) : PWM SIGNAL=0~3.3V • OPERATION FREQUENCY : 100+/-5 KHz

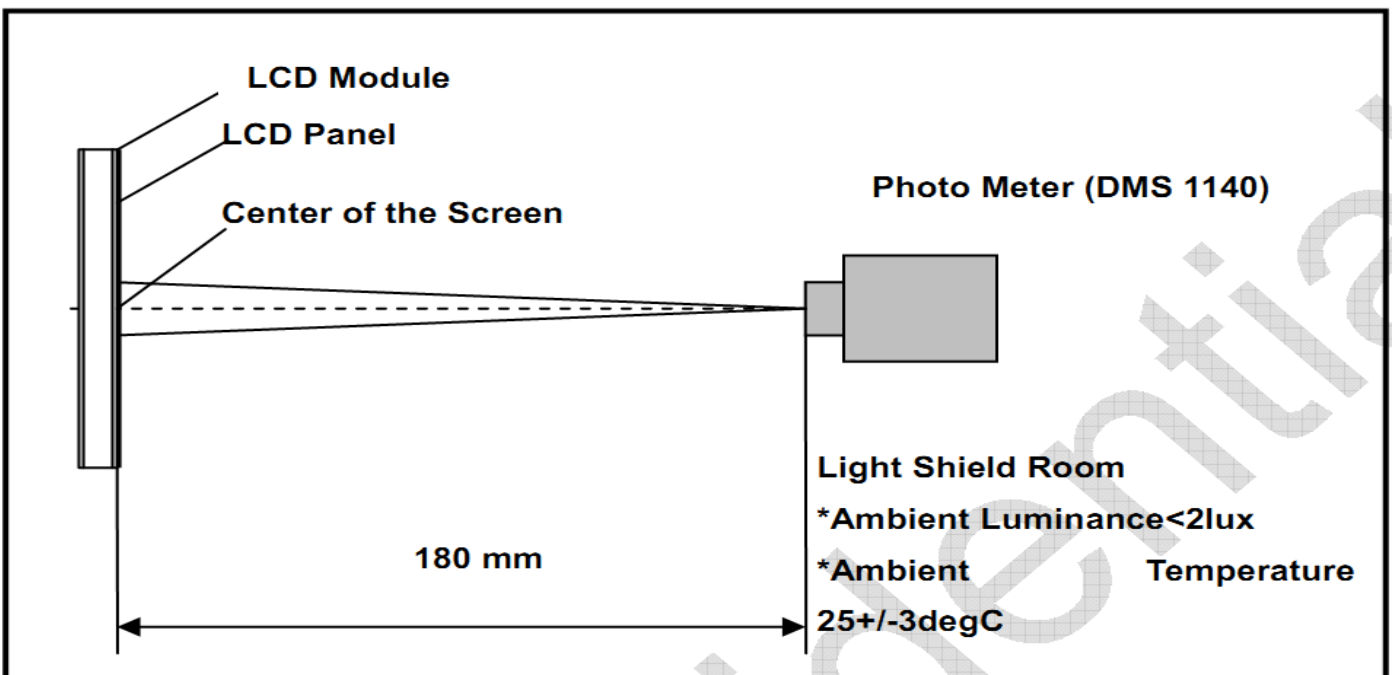


Item	Symbol	MIN	TYP	MAX	UNIT	NOTE
Backlight Power	LED_VCC	3	5	12	V	Ta = 25°C
Backlight Power	ILED_VCC	-	(0.15)	(0.2)	A	LED_VCC=5V
		-	(0.07)	(0.1)	A	LED_VCC=12V
EN Signal Voltage	VIH	1.2			V	
	VIL	GND		0.4	V	
PWM Frequency	LED_PWM	5		100	KHz	
Lifetime		50000	-	-	Hr	
Color	White					
Average Brightness	-	350	450	-	Cd/cm2	
Luminance uniformity	-	--	80	-	%	

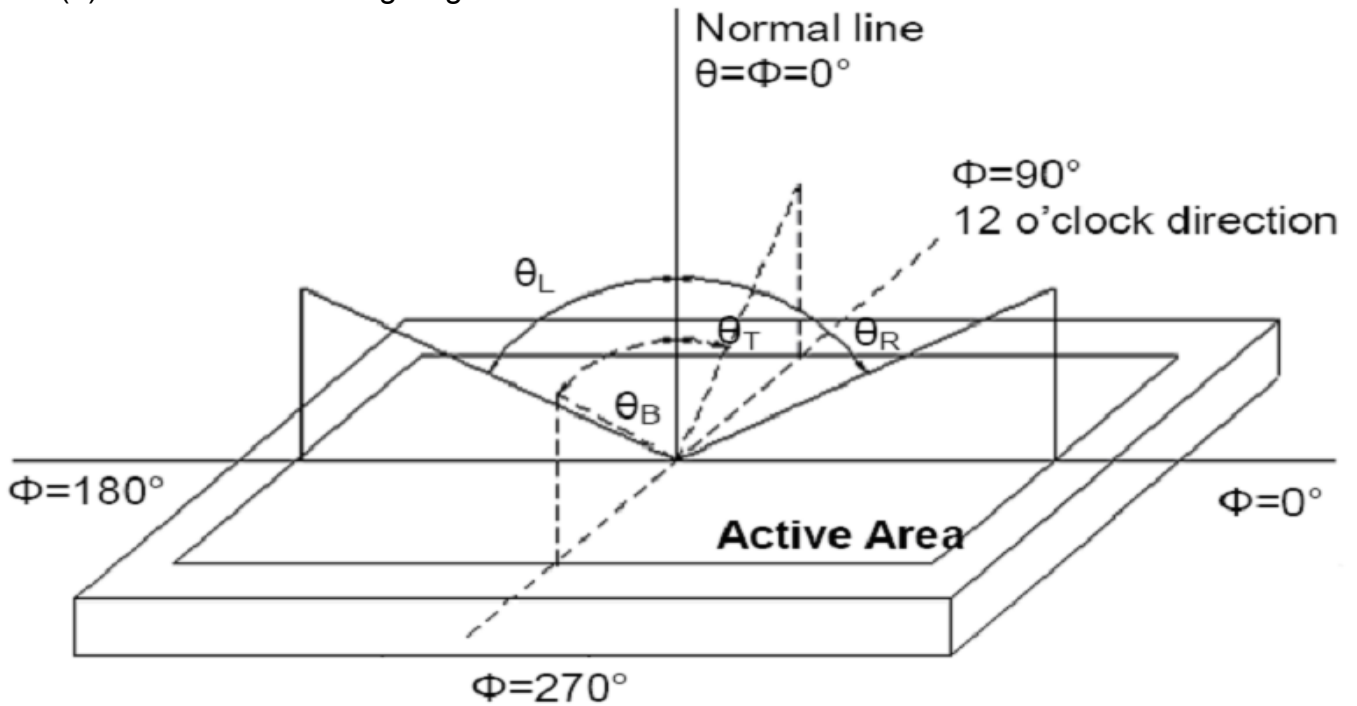
9. Optical Characteristics

Item	Conditions	Min.	Typ.	Max.	Unit	Note
Viewing Angle (CR>10)	Horizontal	θ_L	80	-	degree	(1),(2),(6)
		θ_R	80	-		
	Vertical	θ_T	80	-		
		θ_B	80	-		
Contrast Ratio	Center	600	800	-	-	(1),(3),(6)
Response Time	Rising	-	30	-	ms	(1),(4),(6)
	Falling	-	30	-	ms	
CF Color Chromaticity (CIE1931)	Red x	Typ. -0.05	0.5931	Typ. +0.05	-	(1), (6)
	Red y		0.3580		-	
	Green x		0.3396		-	
	Green y		0.5880		-	
	Blue x		0.1618		-	
	Blue y		0.1390		-	
	White x		0.3258		-	
	White y		0.3625		-	
NTSC	CIE1931	-	50	-	%	(1),(6)

Note (1) Measurement Setup: The LCD module should be stabilized at given temp. 25°C for 15 minutes to avoid abrupt temperature change during measuring. In order to stabilize the luminance, the measurement should be executed after lighting backlight for 15 minutes in a windless room.



Note (2) Definition of Viewing Angle



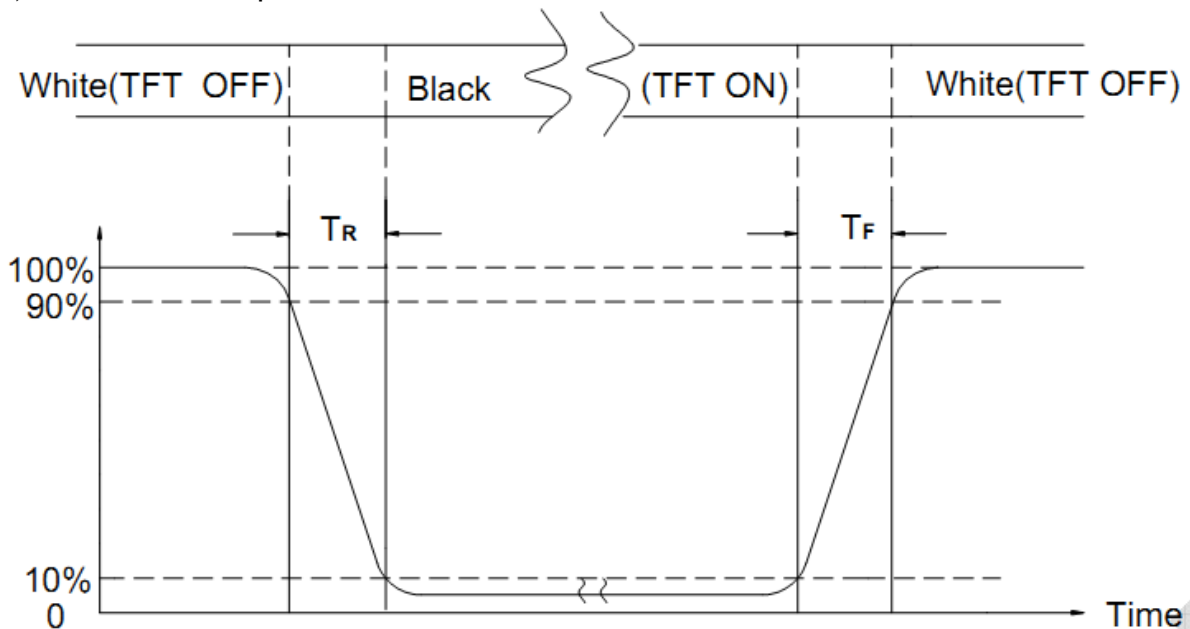
Note (3) Definition of Contrast Ratio (CR)

The contrast ratio can be calculated by the following expression

$$\text{Contrast Ratio (CR)} = L63 / L0$$

L63: Luminance of gray level 63, L0: Luminance of gray level 0

Note (4) Definition of response time



Note (5) Definition of Transmittance (Module is without signal input)

$$\text{Transmittance} = \text{Center Luminance of LCD} / \text{Center Luminance of Back Light} \times 100\%$$

Note (6) Definition of color chromaticity (CIE1931)

Color coordinates measured at the center point of LCD

10. Reliability Test Conditions and Methods

NO.	TEST ITEMS	TEST CONDITION	INSPECTION AFTER TEST
<input type="checkbox"/>	High Temperature Storage	80°C±2°C×96Hours	Inspection after 2~4hours storage at room temperature, the samples should be free from defects: 1, Air bubble in the LCD. 2, Seal leak. 3, Non-display. 4, Missing segments. 5, Glass crack. 6, Current IDD is twice higher than initial value. 7, The surface shall be free from damage. 8, The electric characteristic requirements shall be satisfied.
<input type="checkbox"/>	Low Temperature Storage	-30°C±2°C×96Hours	
<input type="checkbox"/>	High Temperature Operating	70°C±2°C×96Hours	
<input type="checkbox"/>	Low Temperature Operating	-20°C±2°C×96Hours	
<input type="checkbox"/>	Temperature Cycle(Storage)	-20°C ↔ 25°C ↔ 70°C (30min) (5min) (30min) ←—————→ 1cycle Total 10cycle	
<input type="checkbox"/>	Damp Proof Test (Storage)	50°C±5°C×90%RH×96Hours	
<input type="checkbox"/>	Vibration Test	Frequency:10Hz~55Hz~10Hz Amplitude:1.5M X,Y,Z direction for total 3hours (packing condition test will be tested by a carton)	
<input type="checkbox"/>	Drooping Test	Drop to the ground from 1M height one time every side of carton. (packing condition test will be tested by a carton)	
<input type="checkbox"/>	ESD Test	Voltage:±8KV,R:330Ω,C:150PF,Air Mode,10times	

REMARK:

- 1, The Test samples should be applied to only one test item.
- 2, Sample side 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 judge as a good part.
- 5, EL evaluation should be accepted from reliability test with humidity and temperature: Some defects such as black spot/blemish can happen by natural chemical reaction with humidity and Fluorescence EL has.
- 6, Failure Judgment Criterion: Basic Specification Electrical Characteristic, Mechanical Characteristic, Optical Characteristic.

11. Inspection Standard

11.1. QUALITY :

THE QUALITY OF GOODS SUPPLIED TO PURCHASER SHALL COME UP TO THE FOLLOWING STANDARD.

11.1.1. INSPECTION TOOLS AND INSTRUMENTS

Vernier calipers, film scales, multimeter, magnifying eyepiece, ND5%, luminance meter and so on.

11.1.2. THE METHOD OF PRESERVING GOODS

AFTER DELIVERY OF GOODS FROM AMSON TO PURCHASER. PURCHASER SHALL CONTROL THE LCM AT -10 TO 40 ,AND IT MIGHT BE DESIRABLE TO KEEP AT THE NORMAL ROOM TEMPERATURE AND HUMIDITY UNTIL INCOMING INSPECTION OR THROWING INTO PROCESS LINE.

11.1.3. INCOMING INSPECTION

(A) THE METHOD OF INSPECTION

IF PURCHASER MAKE AN INCOMING INSPECTION , A SAMPLING PLAN SHALL BE APPLIED ON THE CONDITION THAT QUALITY OF ONE DELIVERY SHALL BE REGARDED AS ONE LOT.

(B) THE STANDARD OF QUALITY

ISO-2859-1 (SAME AS MIL-STD-105E) ,LEVEL:II

CLASS	AQL(%)
CRITICAL	0.4 %
MAJOR	0.65 %
MINOR	1.5 %

EVERY ITEM SHALL BE INSPECTED ACCORDING TO THE CLASS.

(C) MEASURE

IF AS THE RESULT OF ABOVE RECEIVING INSPECTION , A LOT OUT IS DISCOVERED. PURCHASER SHALL BE INFORM SELLER OF IT WITHIN SEVEN DAYS. BUT FIRST SHIPMENT WITHIN FOURTEEN DAYS.

11.1.4. WARRANTY POLICY

AMSON WILL PROVIDE ONE-YEAR WARRANTY FOR THE PRODUCTS ONLY IF UNDER SPECIFICATION OPERATING CONDITIONS. AMSON WILL REPLACE NEW PRODUCTS FOR THESE DEFECT PRODUCTS WHICH UNDER WARRANTY PERIOD AND BELONG TO THE RESPONSIBILITY OF AMSON.

11.2. CHECKING CONDITION

11.2.1.CHECKING DIRECTION SHALL BE IN THE 45 DEGREE AREA TO FACE THE SAMPLE.

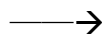
11.2.2.CHECKER SHALL SEE OVER 300±25 mm. WITH BARE EYES FAR FROM SAMPLE

11.2.3.Ambient Illumination:

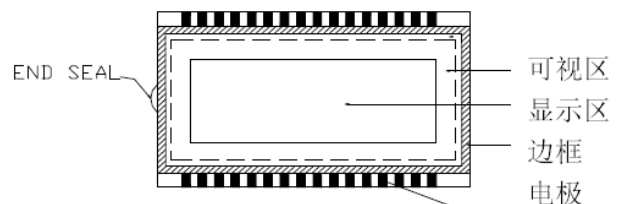
0 ~30 Lux for functional inspection

500 ~ 1200 Lux for external appearance inspection.

11.2.4. TEST AREA:



11.2.5. Inspection should be carried out with rope electrostatic ring and static finger cover (both hands except small fingers must be worn)



11.2.6. The inspector may make a visual inspection or a comparative examination with a film ruler and a magnifying eyepiece. Individual defects shall be determined according to the limited samples.

11.2.7. Functional testing uses electrical testing fixtures or test fixtures required by customers.

11.2.8. the ion fan should be used when testing.

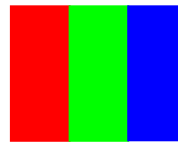
11.2.9. the principle of judgment

11.3.1 If the defect outside the visual area does not affect the assembly and display, it will be judged as a good product.

11.3.2 Poor definition

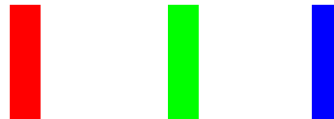
Pixel:

A combination of three sub-pixels
(Red + Green + Blue).



Dot:

Any of the sub-pixels
(Red or Green or Blue).



Bright and dark dots:

A point pixel (sub-pixel: R, G, B pixels) is lit or turned off during the display function test.

Highlights:

Usually considered to be shown on a black screen.

Dark spots:

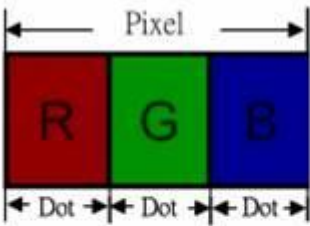
They are generally considered to be shown on R, G, B solid colors or white images.

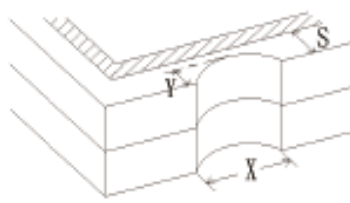
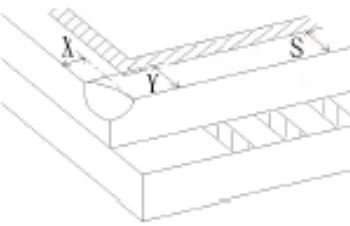
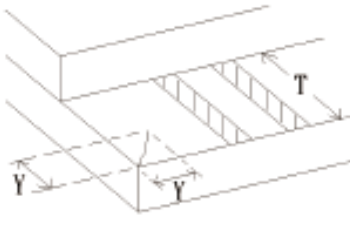
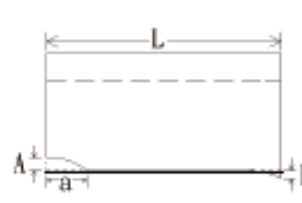
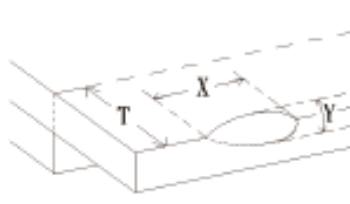
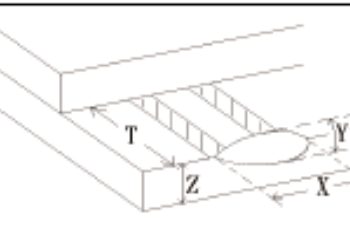
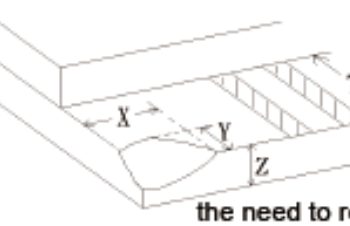
Neighborhood:

Two or three adjacent point pixels (dot: sub-pixel) connected together (R, G or G, B or B, R or RGB).

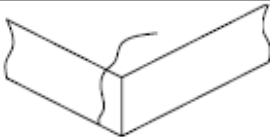
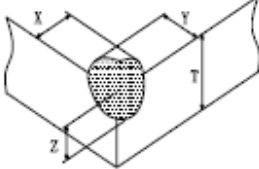
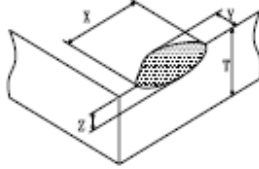
11.3. INSPECTION PLAN :

CLASS	ITEM	JUDGEMENT	CLASS
PACKING & INDICATE	1. OUTSIDE AND INSIDE PACKAGE	"MODEL NO." , "LOT NO." AND "QUANTITY" SHOULD INDICATE ON THE PACKAGE.	Minor
	2. MODEL MIXED AND QUANTITY	OTHER MODEL MIXED.....REJECTED QUANTITY SHORT OR OVER.....REJECTED	Critical
	3. PRODUCT INDICATION	"MODEL NO." SHOULD INDICATE ON THE PRODUCT	Major
ASSEMBLY	4. DIMENSION, LCD GLASS SCRATCH AND SCRIBE DEFECT.	ACCORDING TO SPECIFICATION OR DRAWING.	Major
APPEARANCE	5. VIEWING AREA	POLARIZER EDGE OR LCD'S SEALING LINE IS VISABLE IN THE VIEWING AREAREJECTED	Minor
	6. BLEMISH · BLACK SPOT · WHITE SPOT IN THE LCD AND LCD GLASS CRACKS	ACCORDING TO STANDARD OF VISUAL INSPECTION(INSIDE VIEWING AREA)	Minor
	7. BLEMISH · BLACK SPOT WHITE SPOT AND SCRATCH ON THE POLARIZER	ACCORDING TO STANDARD OF VISUAL INSPECTION(INSIDE VIEWING AREA)	Minor
	8. BUBBLE IN POLARIZER	ACCORDING TO STANDARD OF VISUAL INSPECTION(INSIDE VIEWING AREA)	Minor
	9. LCD'S RAINBOW COLOR	STRONG DEVIATION COLOR (OR NEWTON RING) OF LCD.....REJECTED. OR ACCORDING TO LIMITED SAMPLE (IF NEEDED, AND INSIDE VIEWING AREA)	Minor
ELECTRICAL	10. ELECTRICAL AND OPTICAL CHARACTERISTICS (CONTRAST· VOP· CHROMATICITY ... ETC)	ACCORDING TO SPECIFICATION OR DRAWING . (INSIDE VIEWING AREA)	Critical
	11.MISSING LINE	MISSING DOT· LINE · CHARACTERREJECTED	Critical
	12.SHORT CIRCUIT· WRONG PATTERN DISPLAY	NO DISPLAY · WRONG PATTERN DISPLAY · CURRENT CONSUMPTION OUT OF SPECIFICATION..... REJECTED	Critical
	13. DOT DEFECT (FOR COLOR AND TFT)	ACCORDING TO STANDARD OF VISUAL INSPECTION	Minor

NO.	CLASS	ITEM	JUDGEMENT																				
11.4.1	MINOR	BLACK AND WHITE SPOT FOREIGN MATERIEL DUST IN THE CELL BLEMISH SCRATCH	<p>(A) ROUND TYPE: unit : mm.</p> <table border="1"> <thead> <tr> <th>DIAMETER (mm.)</th> <th>ACCEPTABLE Q'TY</th> </tr> </thead> <tbody> <tr> <td>$\Phi \leq 0.15$</td> <td>Distance\geq1mm</td> </tr> <tr> <td>$0.15 < \Phi \leq 0.4$</td> <td>3 (Distance\geq15mm)</td> </tr> <tr> <td>$0.4 < \Phi$</td> <td>0</td> </tr> </tbody> </table> <p>NOTE: $\Phi=(\text{LENGTH}+\text{WIDTH})/2$</p> <p>(B) LINEAR TYPE: unit : mm.</p> <table border="1"> <thead> <tr> <th>LENGTH</th> <th>WIDTH</th> <th>ACCEPTABLE Q'TY</th> </tr> </thead> <tbody> <tr> <td>-----</td> <td>$W \leq 0.03$</td> <td>Distance\geq1mm</td> </tr> <tr> <td>$L \leq 4.0$</td> <td>$0.03 < W \leq 0.05$</td> <td>3 (Distance\geq15mm)</td> </tr> <tr> <td>-----</td> <td>$0.05 < W$</td> <td>FOLLOW ROUND TYPE</td> </tr> </tbody> </table>	DIAMETER (mm.)	ACCEPTABLE Q'TY	$\Phi \leq 0.15$	Distance \geq 1mm	$0.15 < \Phi \leq 0.4$	3 (Distance \geq 15mm)	$0.4 < \Phi$	0	LENGTH	WIDTH	ACCEPTABLE Q'TY	-----	$W \leq 0.03$	Distance \geq 1mm	$L \leq 4.0$	$0.03 < W \leq 0.05$	3 (Distance \geq 15mm)	-----	$0.05 < W$	FOLLOW ROUND TYPE
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11.4.2	MINOR	BUBBLE IN POLARIZER DENT ON POLARIZER	<p style="text-align: right;">unit : mm.</p> <table border="1"> <thead> <tr> <th>DIAMETER</th> <th>ACCEPTABLE Q'TY</th> </tr> </thead> <tbody> <tr> <td>$\Phi \leq 0.2$</td> <td>Distance\geq1mm</td> </tr> <tr> <td>$0.2 < \Phi \leq 0.5$</td> <td>3 (Distance\geq15mm)</td> </tr> <tr> <td>$0.5 < \Phi$</td> <td>0</td> </tr> </tbody> </table>	DIAMETER	ACCEPTABLE Q'TY	$\Phi \leq 0.2$	Distance \geq 1mm	$0.2 < \Phi \leq 0.5$	3 (Distance \geq 15mm)	$0.5 < \Phi$	0												
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11.4.3	MINOR	Dot Defect	<table border="1"> <thead> <tr> <th>Items</th> <th>ACC. Q'TY</th> </tr> </thead> <tbody> <tr> <td>Bright dot</td> <td>$N \leq 2$ (Distance\geq15mm)</td> </tr> <tr> <td>Dark dot</td> <td>$N \leq 3$ (Distance\geq15mm)</td> </tr> </tbody> </table> <p>Pixel Define :</p>  <p>Note 1: The definition of dot: The size of a defective dot over 1/2 of whole dot is regarded as one defective dot. Definition:$<1/2\text{dot}$ and visible by 5% ND filter $N \leq 5$</p> <p>Note 2: Bright dot: Dots appear bright and unchanged in size in which LCD panel is displaying under black pattern.</p> <p>Note 3: Dark dot: Dots appear dark and unchanged in size in which LCD panel is displaying under pure red, green, blue pattern.</p>	Items	ACC. Q'TY	Bright dot	$N \leq 2$ (Distance \geq 15mm)	Dark dot	$N \leq 3$ (Distance \geq 15mm)														
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11.4.4	MINOR	Mura	Not visible through 5% ND filter in 50% gray or judge by limit sample if necessary																				

NO.	CLASS	ITEM	JUDGEMENT
11.4.5	MINOR	LCD GLASS CHIPPING	 $X \geq 3\text{mm}$ $Y > S$ Reject
11.4.6	MINOR	LCD GLASS CHIPPING	 $X \text{ or } Y > S$ Reject
11.4.7	MAJOR	LCD GLASS GLASS CRACK	 Continuous burst NG Reject
11.4.8	MAJOR	LCD GLASS SCRIBE DEFECT	 ACCORDING TO DIMENSION
11.4.9	MINOR	LCD GLASS CHIPPING (ON THE TERMINAL AREA)	 $Y < 1/2Z$ $Y \geq 0.5\text{mm}$ Reject $X \geq 3\text{mm}$
11.4.10	MINOR	LCD GLASS CHIPPING (ON THE TERMINAL SURFACE)	 $Y < 1/2Z$ $Y \geq 0.5\text{mm}$ Reject $X \geq 3\text{mm}$
11.4.11	MINOR	LCD GLASS CHIPPING	 $X \geq 3\text{mm}$ $Y \geq T$ Reject If touch the electrode lines, the need to retain the two-thirds electrode lines

11.5 INSPECTION STANDARD OF TOUCH PANEL

NO.	CLASS	ITEMS		JUDGEMENT		
11.5.1	MAJOR	Touch Panel Crack			Reject	
11.5.2	MINOR	Touch Panel Chipping	Corner		$X \leq 2\text{mm}, Y \leq 2\text{mm}, Z < 1/2T$	Accept
			Edge		$X \leq 3\text{mm}, Y \leq 3\text{mm}, Z < 1/2T$	Accept
11.5.3	MINOR	Scratch Dust and Foreign materiel (Linear Type)		$W \leq 0.05, L \leq 20\text{mm}$	Accept	
				$0.05\text{mm} < W \leq 0.07\text{mm}; L \leq 10.0\text{mm}$ Distance between seratch $> 5.0\text{mm}$	Accept 3 ea Max.	
				$W > 0.07\text{mm}$	Reject	
11.5.4	MINOR	Scratch Dust and Foreign materiel (Round Type: $\Phi = (\text{Length} + \text{Width})/2$)		$\Phi \leq 0.25\text{mm}$	Accept	
				$0.25\text{mm} < \Phi \leq 0.35\text{mm}$ Distance between spots $> 5.0\text{mm}$	Accept 5 ea Max.	
				$\Phi > 0.35\text{mm}$	Reject	
11.5.5	MINOR	Touch Panel Dent / Fish Eyes		$\Phi \leq 0.35\text{mm}$	Accept	
				$0.35\text{mm} < \Phi \leq 1.0\text{mm}$ Distance $> 5.0\text{mm}$	Accept 3 ea Max.	
				$\Phi > 1.0\text{mm}$	Reject	
11.5.6	MINOR	Touch Panel Air Bubble		$\Phi \leq 0.2\text{mm}$	Accept	
				$0.2\text{mm} < \Phi \leq 0.5\text{mm}$ Distance between bubbles $> 5.0\text{mm}$	Accept 3 ea Max.	
				$\Phi > 0.5\text{mm}$	Reject	
11.5.7	MINOR	Touch Panel Printing area Scratch		$W \leq 0.05\text{mm}, L \leq 5\text{mm}$ Distance between scratch $> 5.0\text{mm}$	Accept 3 ea Max.	
				$W > 0.05\text{mm}$ or $L > 5\text{mm}$ ($W > 0.05$ Follow 11.5.4 Round type)	Reject	
11.5.8	MINOR	Touch Panel White Haze Mark / Dust		Can not be removed	Reject	

12. Handling Precautions

12.1 Mounting method

The LCD panel of AMSON TFT module consists of two thin glass plates with polarizers which easily be damaged. And since the module is so constructed as to be fixed by utilizing fitting holes in the printed circuit board.

Extreme care should be needed when handling the LCD modules.

12.2 Caution of LCD handling and cleaning

When cleaning the display surface, Use soft cloth with solvent

[Recommended below] and wipe lightly

- Isopropyl alcohol
- Ethyl alcohol

Do not wipe the display surface with dry or hard materials that will damage the polarizer surface.

Do not use the following solvent:

- Water
- Aromatics

Do not wipe ITO pad area with the dry or hard materials that will damage the ITO patterns

Do not use the following solvent on the pad or prevent it from being contaminated:

- Soldering flux
- Chlorine (Cl) , Sulfur (S)

If goods were sent without being silicon coated on the pad, ITO patterns could be damaged due to the corrosion as time goes on.

If ITO corrosion happens by miss-handling or using some materials such as Chlorine (Cl), Sulfur (S) from customer, Responsibility is on customer.

12.3 Caution against static charge

The LCD module uses C-MOS LSI drivers, so we recommend that you:

Connect any unused input terminal to power or ground, do not input any signals before power is turned on, and ground your body, work/assembly areas, and assembly equipment to protect against static electricity.

12.4 packing

- Module employs LCD elements and must be treated as such.
- Avoid intense shock and falls from a height.
- To prevent modules from degradation, do not operate or store them exposed direct to sunshine or high temperature/humidity

12.5 Caution for operation

- It is an indispensable condition to drive LCD's within the specified voltage limit since the higher voltage than the limit causes the shorter LCD life.
- An electrochemical reaction due to direct current causes LCD's undesirable deterioration, so that the use of direct current drive should be avoided.
- Response time will be extremely delayed at lower temperature than the operating temperature range and on the other hand at higher temperature LCD's show dark color in them. However those phenomena do not mean malfunction or out of order with LCD's, which will come back in the specified operation temperature.
- If the display area is pushed hard during operation, some font will be abnormally displayed but it resumes normal condition after turning off once.
- Slight dew depositing on terminals is a cause for electro-chemical reaction resulting in terminal open circuit.

Usage under the maximum operating temperature, 50%Rh or less is required.

12.6 storing

In the case of storing for a long period of time for instance, for years for the purpose or replacement use, the following ways are recommended.

- Storage in a polyethylene bag with the opening sealed so as not to enter fresh air outside in it. And with no desiccant.
- Placing in a dark place where neither exposure to direct sunlight nor light's keeping the storage temperature range.
- Storing with no touch on polarizer surface by the anything else.
[It is recommended to store them as they have been contained in the inner container at the time of delivery from us

12.7 Safety

- It is recommendable to crash damaged or unnecessary LCD's into pieces and wash off liquid crystal by either of solvents such as acetone and ethanol, which should be burned up later.
- When any liquid leaked out of a damaged glass cell comes in contact with your hands, please wash it off well with soap and water

13. Precaution for Use

13.1

A limit sample should be provided by the both parties on an occasion when the both parties agreed its necessity. Judgment by a limit sample shall take effect after the limit sample has been established and confirmed by the both parties.

13.2

On the following occasions, the handing of problem should be decided through discussion and agreement between responsible of the both parties.

- When a question is arisen in this specification
- When a new problem is arisen which is not specified in this specifications
- When an inspection specifications change or operating condition change in customer is reported to AMSON TFT , and some problem is arisen in this specification due to the change
- When a new problem is arisen at the customer's operating set for sample evaluation in the customer site.

14. Packing Method

TBD