

Display Elektronik GmbH

# DATA SHEET

TFT MODULE

DEM 296222A VTH-PW

1,75“ transfl. TFT

Product Specification

Version: 1

14.01.2025



## Contents

1. Block Diagram	5
2. Outline dimension	6
3. Input terminal Pin Assignment	7
4. LCD Optical Characteristics	9
4.1 Optical specification	9
5. Electrical Characteristics	12
5.1 Absolute Maximum Rating	12
5.2 DC Electrical Characteristics	12
5.3 LED Backlight Characteristics	13
6. AC Characteristics	15
6.1 Parallel 8080-series Interface Timing Characteristics	15
6.2 Display Serial Interface Timing Characteristics (3-line SPI system)	17
6.3 Display Serial Interface Timing Characteristics (4-line SPI system)	18
6.4 Parallel 18/16/6-bit RGB Interface Timing Characteristics	19
6.5 Reset Timing Characteristics	20
7. LCD Module Out-Going Quality Level	21
7.1 VISUAL & FUNCTION INSPECTION STANDARD	21
7.1.1 Inspection conditions	21
7.1.2 Definition	21
7.1.3 Sampling Plan	22
7.1.4 Criteria (Visual)	23
8. Reliability Test Result	27
9. Cautions and Handling Precautions	28
9.1 Handling and Operating the Module	28
9.2 Storage and Transportation.	28

**\* Description**

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

The resolution of a 1.75'TFT-LCD contains 296x222 pixels, and can display up to 65K/262K colors.

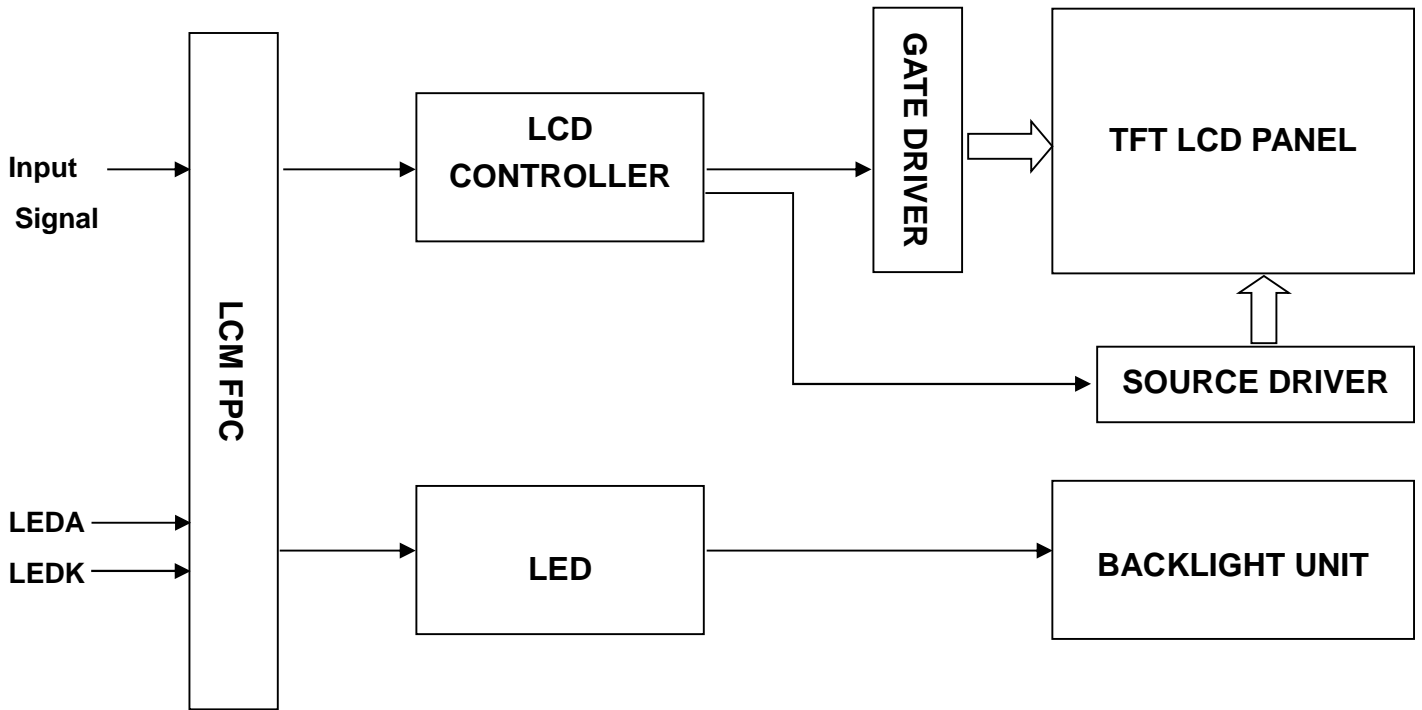
**\* Features**

General Information Items	Specification	Unit	Note
	Main Panel		
Display Area(AA)	35.52 x 26.64 (1.75 Inch)	mm	-
Driver Element	TFT Active Matrix	-	-
Display Colors	65k / 262k	colors	-
Number of Pixels	296 x RGB x 222	dots	-
Pixel Arrangement	RGB Vertical Stripe	-	-
Pixel Pitch	0.12 x 0.12	mm	-
Viewing Angle	Wide Viewing	o'clock	-
Controller IC	ILI9342 (Ilitek)	-	-
LCM Interface	8/9/16/18/24 BIT MCU 3/4-line SPI+16/18/24 BIT RGB 3-line/4-line Serial Interface	-	-
Display Mode	IPS, Transflective / Normally Black	-	-
Operating Temperature	-20 ~ +70	°C	-
Storage Temperature	-30 ~ +80	°C	-

**\* Mechanical Information**

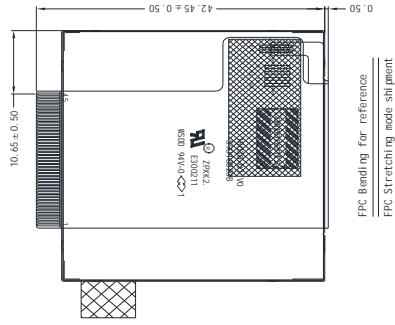
Item		Min.	Typ.	Max.	Unit	Note
Module Size	Horizontal(H)	-	42.07	-	mm	-
	Vertical(V)	-	38.71	-	mm	-
	Depth(D)	-	2.50	-	mm	-
Weight		-	8	-	g	-

### 1. Block Diagram

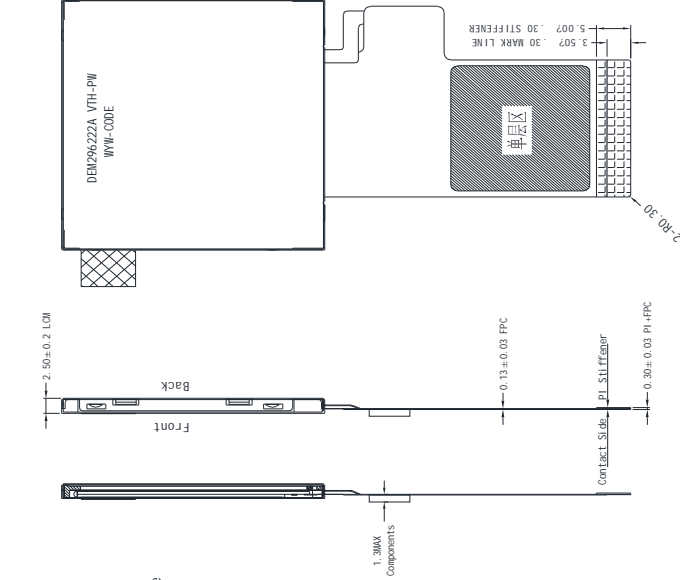


2. Outline Dimension

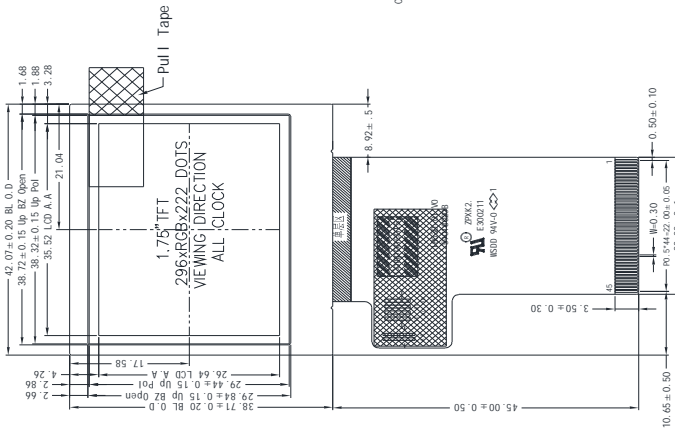
Bottom View



Side View



Front View



Pin No	Pin Name
1	GND
2	GND
3	IOVCC
4	VCI
5	IM3
6	IM1
7	IM0
8	SDA
9	VSYNC
10	HSYNC
11	DOTCLK
12	ENABLE
13	RD
14	WR&PHAS
15	RS(SPI-SL)
16	CS
17	RESET
18	DB17
19	DB16
20	DB15
21	DB14
22	DB13
23	DB12
24	DB11
25	DB10
26	DB9
27	DB8
28	DB7
29	DB6
30	DB5
31	DB4
32	DB3
33	DB2
34	DB1
35	DB0
36	NC
37	NC
38	LEDK
39	NC
40	LEDA
41	XR(INC)
42	YD(INC)
43	XL(INC)
44	YU(INC)
45	GND

NOTE: RGB interface

RGB Interface	DB Pin in use
16 BIT RGB interface	DB15-DB0
18 BIT RGB interface	DB17-DB0

NOTE: If used RGB mode must select serial interface

NOTE: MCU Interface SET for IM PINS.

IM0	IM1	IM3	Interface type	DB Pin in use
0	0	0	DB1 Typ. 8-bit interface	DB7-DB0
0	1	0	DB1 Typ. 16-bit interface	DB15-DB0
0	0	1	DB1 Typ. 8-bit interface	DB8-DB0
0	1	1	DB1 Typ. 16-bit interface	DB17-DB0
1	0	1	2-Wire I2C serial interface	SDA SCL CS
1	1	1	4-Wire I2C serial interface	SDA SCL CS RS

NOTE: If not use PINS fix to the GND, IOVCC or NC.



- NOTE:
1. DISPLAY TYPE: 1.75", TFT-LCD, 65K/262K COLORS
  2. DISPLAY MODE: NORMALLY BLACK, TRANSPARENT
  3. VIEWING DIRECTION: WIDE VIEWING
  4. LCM DRIVER IC: ILI9342C (COG)
  - LCM Interface: 3/4Serial, 8/16BIT MCU 3/4SPI+16/18BIT RGB
  5. VDD: 3.3V(TYP.), IOVCC: 1.8-3.3V
  6. OPERATING TEMP: -20° C TO 70° C
  - STORAGE TEMP: -30° C TO 80° C
  7. BACK LIGHT: LED WHITE, 6 LED, 40mA, 8.4-10.2V
  8. RoHS COMPLIANT.

### 3. Input terminal Pin Assignment

NO.	SYMBOL	DISCRIPTION	I/O
1	GND	Ground.	P
2	GND	Ground.	P
3	IOVCC	Supply voltage for logic I/O.(1.65-3.3V).	P
4	VCI	Supply voltage(3.3V).	P
5	IM3	MPU Parallel interface bus and serial interface select If use RGB Interface must select serial interface. Fix this pin at IOVCC and GND.	I
6	IM1		I
7	IM0		I
8	SDA	Serial input signal.The data is applied on the rising edge of the SCL signal. If not used, fix this pin at IOVCC or GND.	I
9	VSYNC	Frame synchronizing signal for RGB interface operation. fix this pin at IOVCC or GND when not in use.	I
10	HSYNC	Line synchronizing signal for RGB interface operation. fix this pin at IOVCC or GND when not in use	I
11	DOTCLK	Dot clock signal for RGB interface operation Fix this pin at IOVCC or GND when not in use.	I
12	ENABLE	Data enable signal for RGB interface operation. fix this pin at IOVCC or GND when not in use.	I
13	RD	8080-system : RD (read strobe signal)	I
14	WR	8080-system : WR (write strobe signal)	I
15	RS	Display data/command selection pin in parallel interface.	I
16	CS	Chip select input pin ("Low" enable).	I
17	RESET	This signal will reset the device and must be applied to properly initialize the chip.	I
18~35	DB17~DB0	18-bit parallel bi-directional data bus for MCU system and RGB interface mode . Fix to GND level when not in use	I
36	NC	No connection	-
37	NC	No connection	-
38	LED (K)	Cathode pin of backlight	P

39	NC	No connection	-
40	LED (A)	Anode pin OF backlight	P
41	XR(NC)	Touch panel Right Glass Terminal	A/D
42	YD(NC)	Touch panel Bottom Film Terminal	A/D
43	XL(NC)	Touch panel LEFT Glass Terminal	A/D
44	YU(NC)	Touch panel Top Film Terminal	A/D
45	GND	Ground.	P

## 4. LCD Optical Characteristics

### 4.1 Optical Specification

Item		Symbol	Condition	Min.	Typ.	Max.	Unit.	Note
Contrast Ratio		CR	$\Theta=0$	20 0	300	--		(1)(2)
Response Time	Rising	$T_{R+T_F}$	Normal Viewing Angle	--	25	50	msec	(1)(3)
	Falling							
Color Gamut		S(%)		40	50	--	%	
Reflection Ratio		R	$(\theta=\varphi=0^\circ)$	--	7	--	%	
Color Filter Chromaticity	White	$W_X$		-0.04	0.278	+0.04		(1)(4) CF glass
		$W_Y$			0.298			
	Red	$R_X$			0.581			
		$R_Y$			0.342			
	Green	$G_X$			0.325			
		$G_Y$			0.567			
	Blue	$B_X$			0.152			
		$B_Y$			0.081			
Viewing Angle	Hor.	$\Theta_L$	CR>10	--	80	--		(1)(4)
		$\Theta_R$			80			
	Ver.	$\Theta_U$			80			
		$\Theta_D$			80			
Option View Direction		Wide Viewing						

\*The data comes from the LCD specification.

#### Measuring Condition

Measuring surrounding: dark room

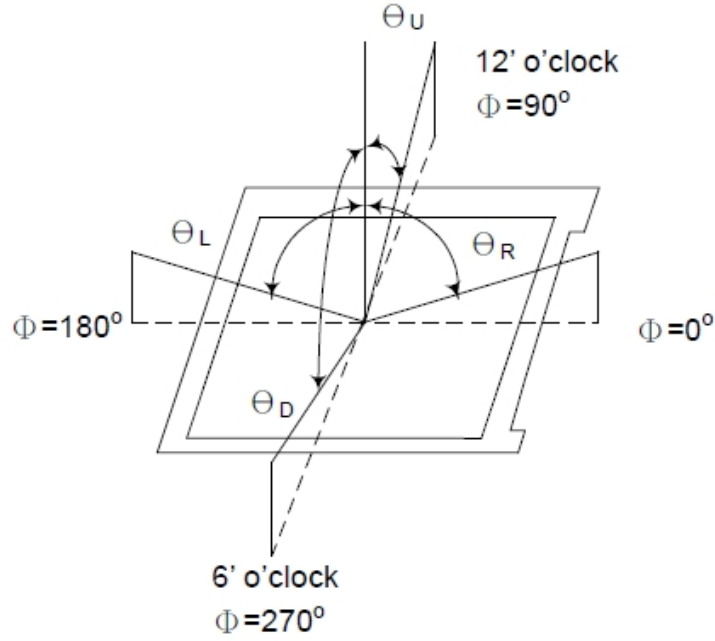
Ambient temperature:  $25^\circ\text{C} \pm 2^\circ\text{C}$

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.

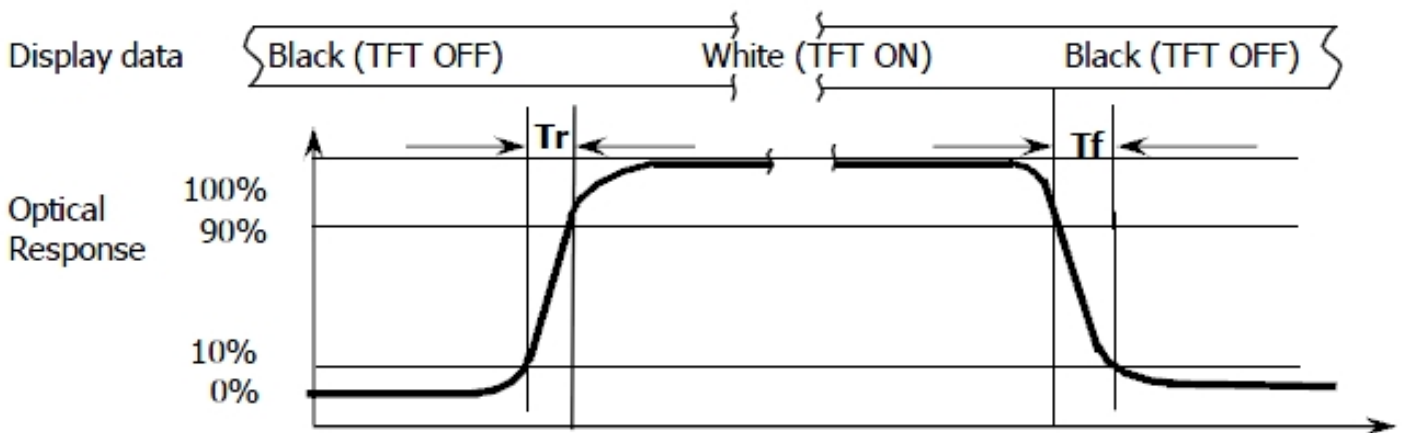
Note (1): Definition of Viewing Angle:



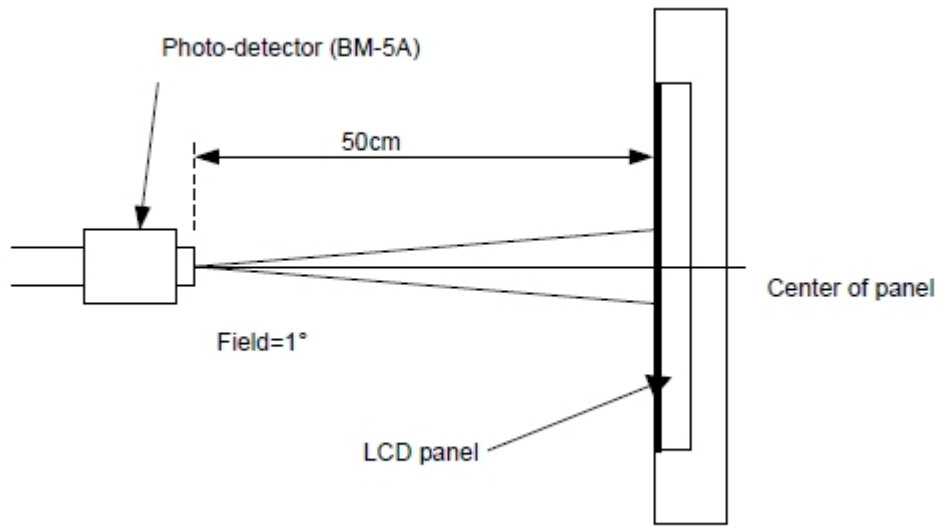
Note (2): Definition of Contrast Ratio(CR) :measured at the center point of panel

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

Note (3): Response Time



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



## 5. Electrical Characteristics

### 5.1 Absolute Maximum Rating

Characteristics	Symbol	Min.	Max.	Unit	Note
Digital Supply Voltage	VCI	-0.3	5.0	V	Note1
Digital Interface Supply Voltage	-	-0.3	4.0	V	Note1
Operating Temperature	T <sub>OP</sub>	-20	+70	°C	-
Storage Temperat		-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	VCI	2.5	3.3	3.6	V	-
Digital Interface Supply Voltage	IOVCC	1.65	1.8	3.3	V	-
Normal Mode Current	IDD	--	6	12	mA	-
Level Input Voltage	V <sub>IH</sub>	0.7*IOVCC	--	IOVCC+0.3	V	-
	V <sub>IL</sub>	GND-0.3	--	0.3*IOVCC	V	-
Level Output Voltage	V <sub>OH</sub>	IOVCC-0.4	--	--	V	-
	V <sub>OL</sub>	GND	--	GND+0.4	V	-

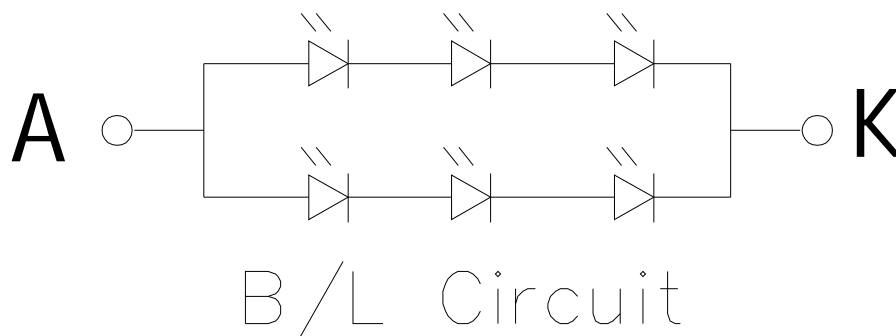
5.3 LED Backlight Characteristics

The Backlight System is edge-lighting type with 6 chips LED

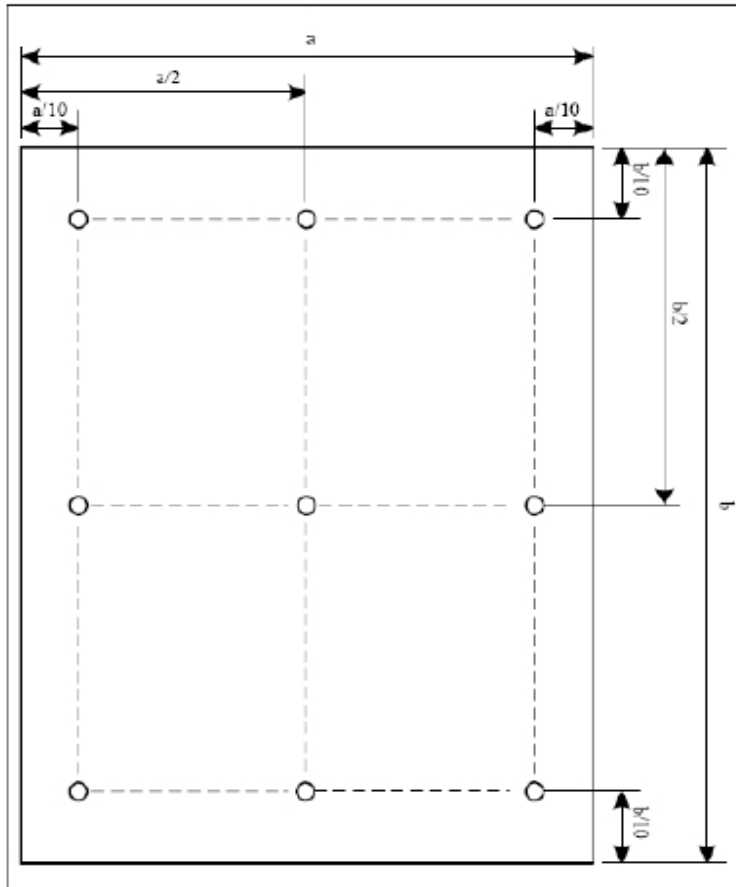
Item	Symbol	Min.	Typ.	Max.	Unit	Note
Forward Current	$I_F$	--	40	--	mA	-
Forward Voltage	$V_F$	--	9.6	--	V	-
LCM Luminance	LV	--	350	--	cd/m <sup>2</sup>	$I_F=40mA$
LED Lifetime	Hr	--	50000	--	Hour	Note1,2
Uniformity	Avg	80	--	--	%	Note3

Note1: LED life time (Hr) can be defined as the time in which it continues to operate under the condition:  $T_a=25^{\circ}C \pm 3^{\circ}C$ , typical  $I_L$  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  $T_a=25^{\circ}C$  and  $I_L=40mA$ . The LED lifetime could be decreased if operating  $I_L$  is larger than 40mA. The constant current driving method is suggested.



Note (3) Luminance Uniformity of these 9 points is defined as below:

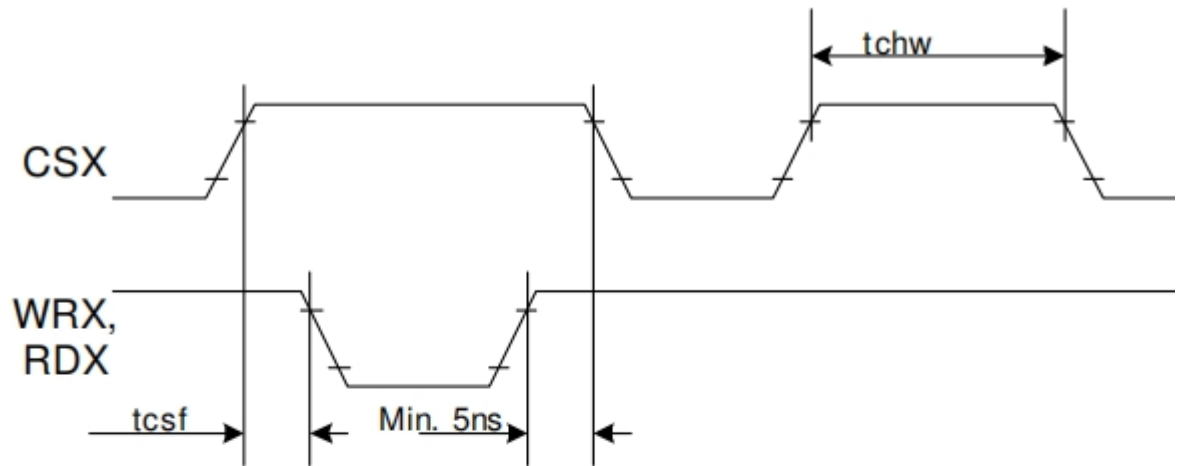


$$\text{Uniformity} = \frac{\text{minimum luminance in 9 points (1-9)}}{\text{maximum luminance in 9 points (1-9)}}$$

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

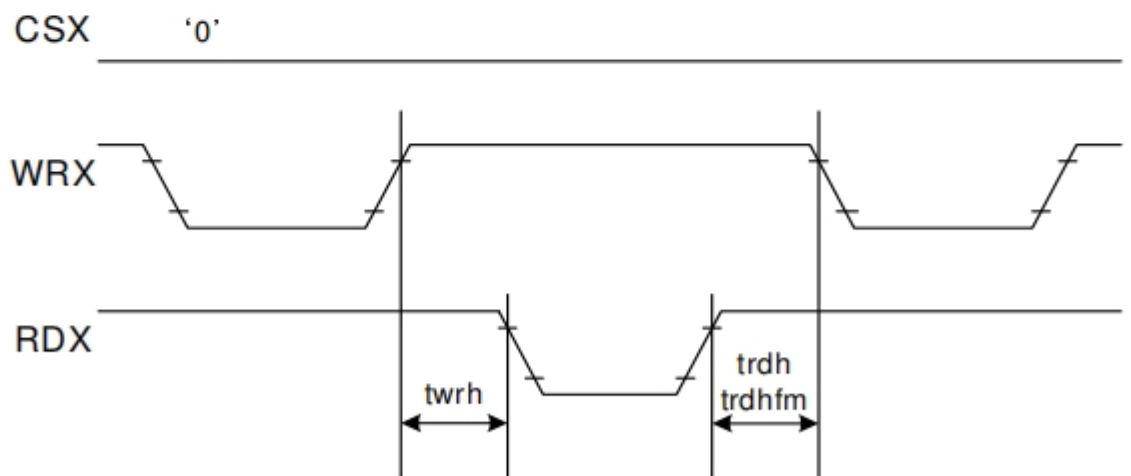


CSX timings :



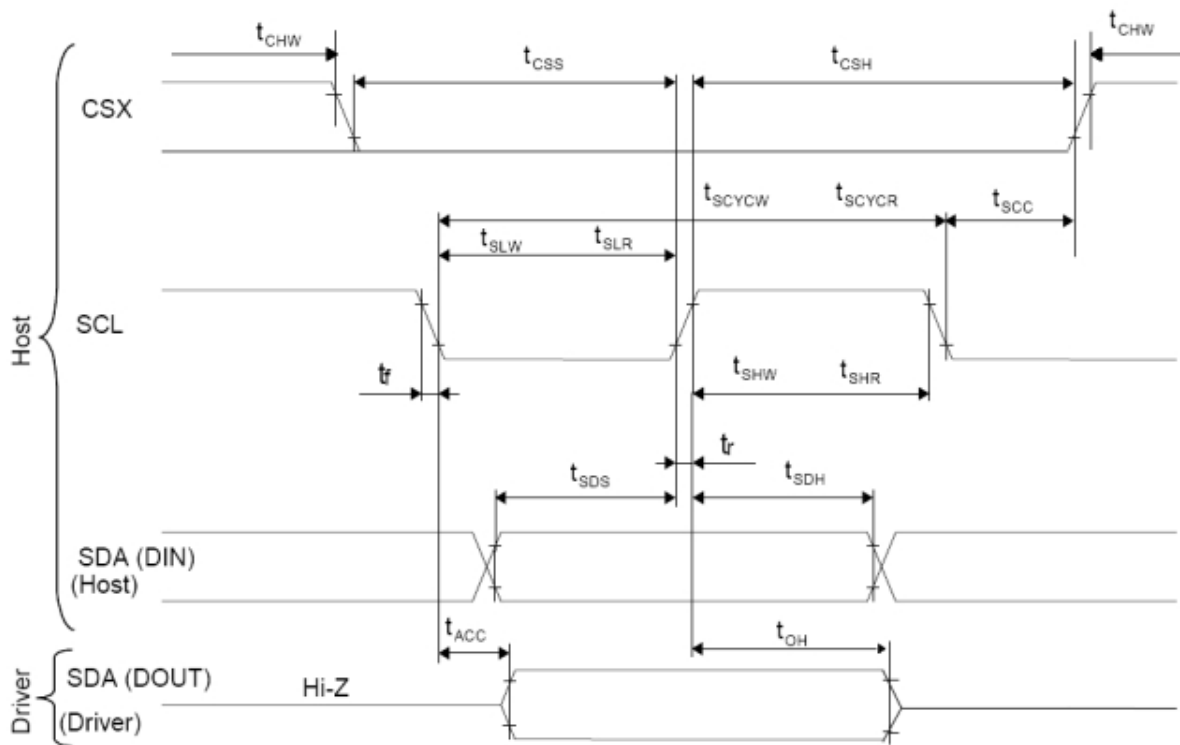
Note: Logic high and low levels are specified as 30% and 70% of IOVCC for Input signals.

Write to read or read to write timings:



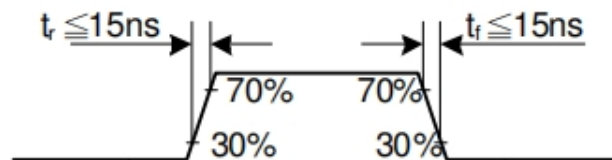
Note: Logic high and low levels are specified as 30% and 70% of IOVCC for Input signals.

6.2 Display Serial Interface Timing Characteristics (3-Line SPI System)

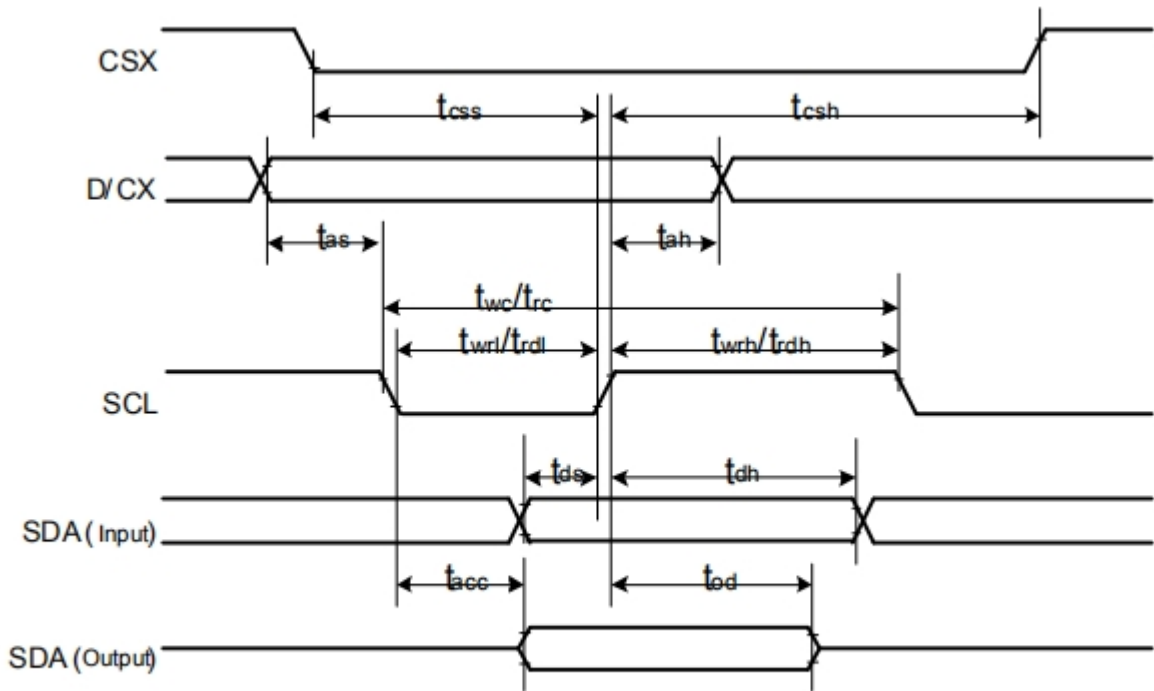


Signal	Symbol	Parameter	min	max	Unit	Description
SCL	tscycw	Serial Clock Cycle (Write)	100	-	ns	
	tshw	SCL "H" Pulse Width (Write)	35	-	ns	
	tslw	SCL "L" Pulse Width (Write)	35	-	ns	
	tscycr	Serial Clock Cycle (Read)	150	-	ns	
	tshr	SCL "H" Pulse Width (Read)	60	-	ns	
	tslr	SCL "L" Pulse Width (Read)	60	-	ns	
SDA (Input)	tsds	Data setup time (Write)	30	-	ns	
	tsdh	Data hold time (Write)	30	-	ns	
SDA (Output)	tacc	Access time (Read)	10	-	ns	
	toh	Output disable time (Read)	15	50	ns	
CSX	tsc	SCL-CSX	20	-	ns	
	tchw	CSX "H" Pulse Width	40	-	ns	
	tcss	CSX-SCL Time(write)	30	-	ns	
	tcsh		30	-	ns	

Note:  $T_a = 25\text{ }^\circ\text{C}$ ,  $IOVCC=1.65\text{V to }2.8\text{V}$ ,  $VCI=2.6\text{V to }3.3\text{V}$ ,  $AGND=GND=0\text{V}$

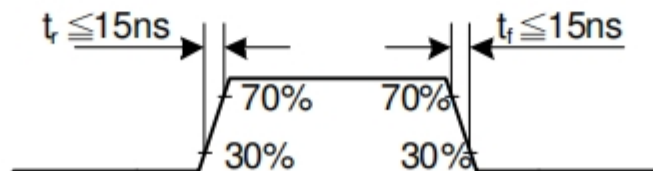


6.3 Display Serial Interface Timing Characteristics (4-Line SPI System)

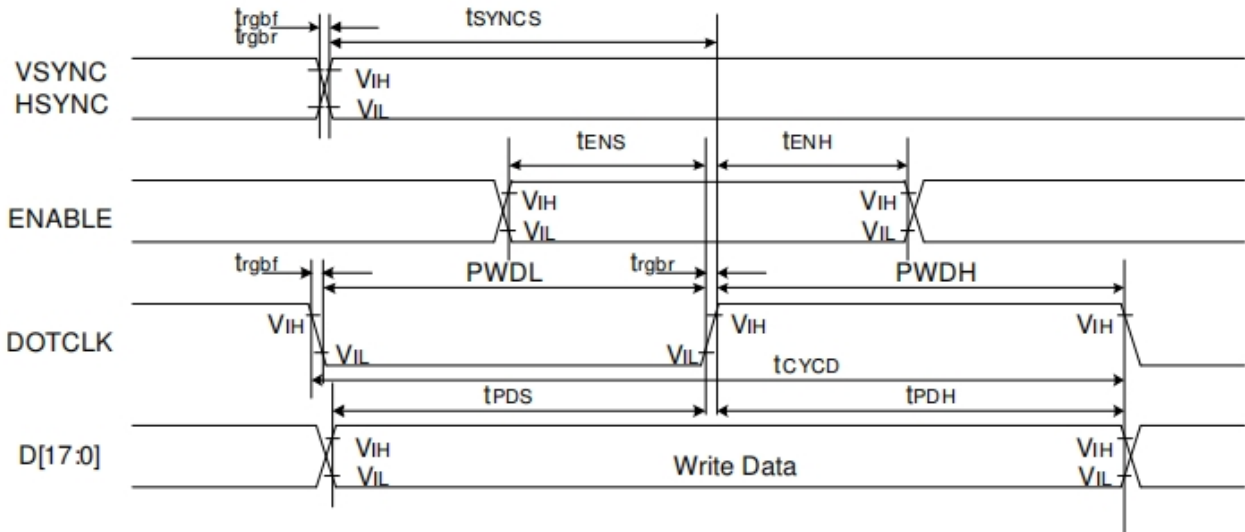


Signal	Symbol	Parameter	min	max	Unit	Description
CSX	$t_{css}$	Chip select time (Write)	30	-	ns	
	$t_{csh}$	Chip select hold time (write)	30	-	ns	
SCL	$t_{wc}$	Serial clock cycle (Write)	100	-	ns	
	$t_{wrh}$	SCL "H" pulse width (Write)	35	-	ns	
	$t_{wrl}$	SCL "L" pulse width (Write)	35	-	ns	
	$t_{rc}$	Serial clock cycle (Read)	150	-	ns	
	$t_{rdh}$	SCL "H" pulse width (Read)	60	-	ns	
	$t_{rdl}$	SCL "L" pulse width (Read)	60	-	ns	
D/CX	$t_{as}$	D/CX setup time	10	-		
	$t_{ah}$	D/CX hold time (Write / Read)	10	-		
SDA (Input)	$t_{ds}$	Data setup time (Write)	30	-	ns	
	$t_{dh}$	Data hold time (Write)	30	-	ns	
SDA (Output)	$t_{acc}$	Access time (Read)	-	50	ns	For maximum CL=30pF
	$t_{od}$	Output disable time (Read)	15	50	ns	For minimum CL=8pF

Note:  $T_a = 25\text{ }^\circ\text{C}$ ,  $IOVCC=1.65\text{V to }2.8\text{V}$ ,  $VCI=2.6\text{V to }3.3\text{V}$ ,  $AGND=GND=0\text{V}$

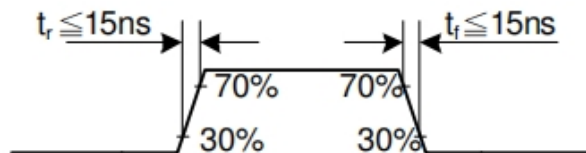


6.4 Parallel 18/16/6-Bit RGB Interface Timing Characteristics



Signal	Symbol	Parameter	min	max	Unit	Description	
VSYNC / HSYNC	$t_{SYNCS}$	VSYNC/HSYNC setup time	15	-	ns	18/16-bit bus RGB interface mode	
	$t_{SYNCH}$	VSYNC/HSYNC hold time	15	-	ns		
DE	$t_{ENS}$	DE setup time	15	-	ns		
	$t_{ENH}$	DE hold time	15	-	ns		
D[17:0]	$t_{POS}$	Data setup time	15	-	ns		
	$t_{PDH}$	Data hold time	15	-	ns		
DOTCLK	$PVDH$	DOTCLK high-level period	33	-	ns		
	$PVDL$	DOTCLK low-level period	33	-	ns		
	$t_{CYCD}$	DOTCLK cycle time(18 bit)	100	-	ns		
	$t_{r,br}, t_{r,brf}$	DOTCLK,HSYNC,VSYNC rise/fall time	-	15	ns		
VSYNC / HSYNC	$t_{SYNCS}$	VSYNC/HSYNC setup time	15	-	ns		6-bit bus RGB interface mode
	$t_{SYNCH}$	VSYNC/HSYNC hold time	15	-	ns		
DE	$t_{ENS}$	DE setup time	15	-	ns		
	$t_{ENH}$	DE hold time	15	-	ns		
D[17:0]	$t_{POS}$	Data setup time	15	-	ns		
	$t_{PDH}$	Data hold time	15	-	ns		
DOTCLK	$PVDH$	DOTCLK high-level pulse period	25	-	ns		
	$PVDL$	DOTCLK low-level pulse period	25	-	ns		
	$t_{CYCD}$	DOTCLK cycle time	50	-	ns		
	$t_{r,br}, t_{r,brf}$	DOTCLK,HSYNC,VSYNC rise/fall time	-	15	ns		

Note:  $T_a = -30$  to  $70$  °C,  $IOVCC=1.65V$  to  $2.8V$ ,  $VCI=2.6V$  to  $3.3V$ ,  $AGND=GND=0V$



6.5 Reset Timing Characteristics



Signal	Symbol	Parameter	Min	Max	Unit
RESX	$t_{RW}$	Reset pulse duration	10		$\mu$ S
	$t_{RT}$	Reset cancel		5 (note 1,5)	mS
				120 (note 1,6,7)	mS

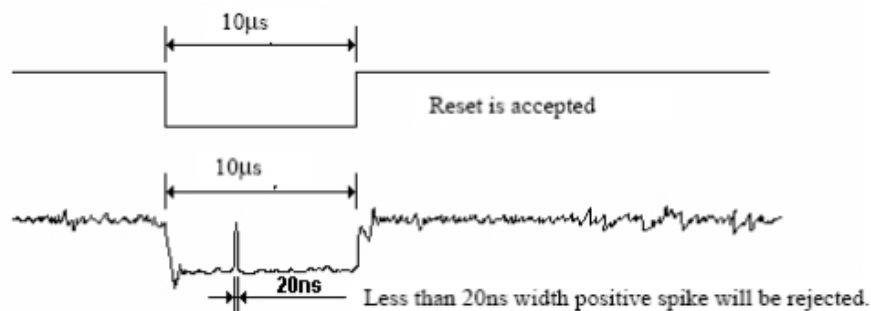
Note 1: The reset cancel includes also required time for loading ID bytes, VCOM setting and other settings from NV memory to registers. This loading is done every time when there is HW reset cancel time ( $t_{RT}$ ) within 5 ms after a rising edge of RESX.

Note 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 10us	Reset
Between 5us and 10us	Reset starts

Note 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.

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



Note 5: When Reset applied during Sleep In Mode.

Note 6: When Reset applied during Sleep Out Mode.

Note 7: It is necessary to wait 5msec after releasing RESX before sending commands. Also Sleep Out command cannot be sent for 120msec.

## 7. LCD Module Out-Going Quality Level

### 7.1 VISUAL & FUNCTION INSPECTION STANDARD

#### 7.1.1 Inspection Conditions

Inspection performed under the following conditions is recommended.

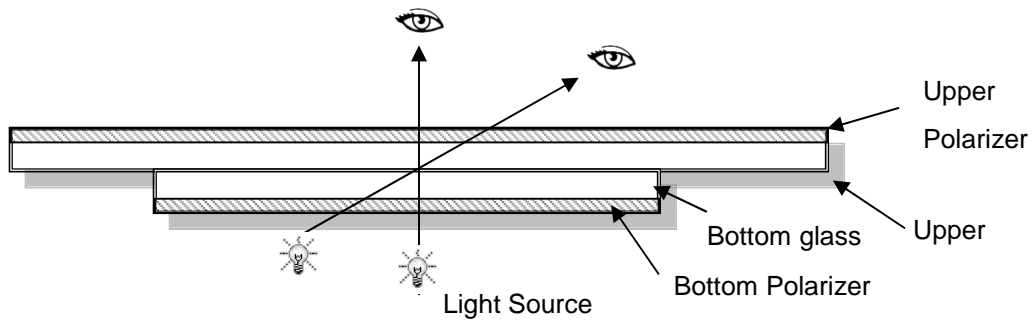
Temperature: 25°C ± 5°C

Humidity: 65%±10%RH

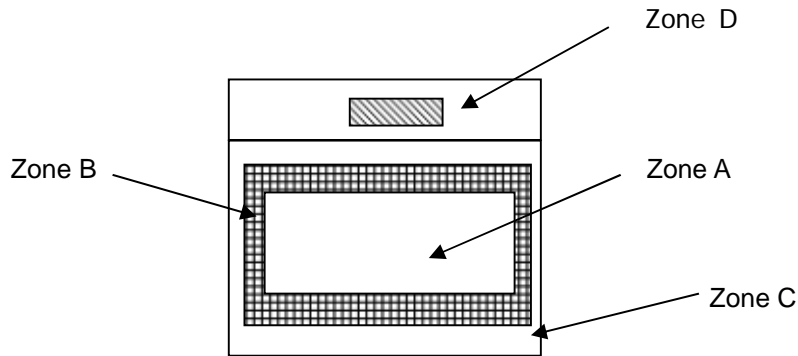
Viewing Angle: Normal Viewing Angle.

Illumination: Single fluorescent lamp (300 to 700Lux)

Viewing distance: 30-50cm



#### 7.1.2 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 affect product function or appearance after assembly by customer

## 7.1.3 Sampling Plan

According to GB/T 2828-2012: Normal Inspection, Class II

AQL:

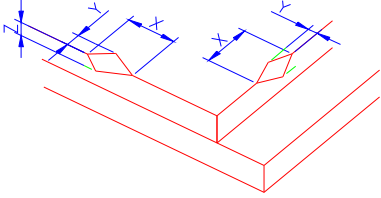
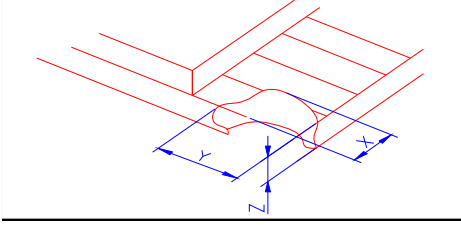
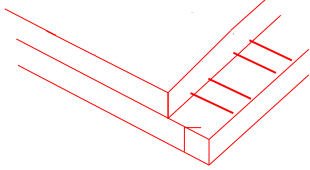
Major Defect	Minor Defect
0.65	1.5

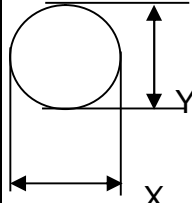
LCD: Liquid Crystal Display, LCM: Liquid Crystal Module

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, (Note1) Polarizer Air Bubble, Polarizer accidented spot and etc...	
6	Soldering appearance	Good soldering , Peeling off is not allowed and etc...	
7	LCD/Polarizer	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.

7.1.4 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="735 611 1433 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="810 1068 1353 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;">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;">1(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			$0.25 < \Phi \leq 0.4$	2(distance $\geq 10$ mm)		$\Phi > 0.4$	1(distance $\geq 10$ mm)			$\Phi > 0.4$	0		
	Zone Size (mm)	Acceptable Qty																												
		A	B	C																										
	$\Phi \leq 0.15$	Ignore																												
$0.15 < \Phi \leq 0.25$	Ignore																													
$0.25 < \Phi \leq 0.4$				2(distance $\geq 10$ mm)																										
$\Phi > 0.4$	1(distance $\geq 10$ mm)																													
$\Phi > 0.4$	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;">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;">1( 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			$0.25 < \Phi \leq 0.4$	2( distance $\geq 10$ mm)		$\Phi > 0.4$	1( distance $\geq 10$ mm)			$\Phi > 0.4$	0		
Zone Size (mm)	Acceptable Qty																													
	A	B	C																											
$\Phi \leq 0.15$	Ignore																													
$0.15 < \Phi \leq 0.25$	Ignore																													
$0.25 < \Phi \leq 0.4$				2( distance $\geq 10$ mm)																										
$\Phi > 0.4$	1( distance $\geq 10$ mm)																													
$\Phi > 0.4$	0																													
		③ Polarizer accidented spot																												
		<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 0.2</math></td> <td colspan="3" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>0.2 &lt; \Phi \leq 0.5</math></td> <td colspan="3" rowspan="2" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.5</math></td> <td colspan="2" style="text-align: center;">1( distance <math>\geq 10</math>mm)</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.5</math></td> <td colspan="3" style="text-align: center;">0</td> </tr> </tbody> </table>			Zone Size (mm)	Acceptable Qty			A	B	C	$\Phi \leq 0.2$	Ignore			$0.2 < \Phi \leq 0.5$	Ignore			$\Phi > 0.5$	1( distance $\geq 10$ mm)		$\Phi > 0.5$	0						
Zone Size (mm)	Acceptable Qty																													
	A	B	C																											
$\Phi \leq 0.2$	Ignore																													
$0.2 < \Phi \leq 0.5$	Ignore																													
$\Phi > 0.5$				1( distance $\geq 10$ mm)																										
$\Phi > 0.5$	0																													
		④ Polarizer Bubble																												
		<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 0.2</math></td> <td colspan="3" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>0.2 &lt; \Phi \leq 0.4</math></td> <td colspan="3" rowspan="2" style="text-align: center;">Ignore</td> </tr> <tr> <td style="text-align: center;"><math>0.4 &lt; \Phi \leq 0.5</math></td> <td colspan="2" style="text-align: center;">1(distance <math>\geq 10</math>mm)</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.5</math></td> <td colspan="3" style="text-align: center;">0</td> </tr> <tr> <td style="text-align: center;"><math>\Phi &gt; 0.5</math></td> <td colspan="3" style="text-align: center;">0</td> </tr> </tbody> </table>			Zone Size (mm)	Acceptable Qty			A	B	C	$\Phi \leq 0.2$	Ignore			$0.2 < \Phi \leq 0.4$	Ignore			$0.4 < \Phi \leq 0.5$	1(distance $\geq 10$ mm)		$\Phi > 0.5$	0			$\Phi > 0.5$	0		
Zone Size (mm)	Acceptable Qty																													
	A	B	C																											
$\Phi \leq 0.2$	Ignore																													
$0.2 < \Phi \leq 0.4$	Ignore																													
$0.4 < \Phi \leq 0.5$				1(distance $\geq 10$ mm)																										
$\Phi > 0.5$	0																													
$\Phi > 0.5$	0																													

3.0	LCD Pixel defect	<p>Pixel bad points</p> <table border="1" data-bbox="513 250 1479 987"> <thead> <tr> <th data-bbox="513 250 708 304">Item</th> <th data-bbox="711 250 1222 304">Zone A</th> <th data-bbox="1225 250 1479 304">Acceptable Qty</th> </tr> </thead> <tbody> <tr> <td data-bbox="513 309 708 465" rowspan="3">Bright dot</td> <td data-bbox="711 309 1222 362">Random</td> <td data-bbox="1225 309 1479 362">N≤2</td> </tr> <tr> <td data-bbox="711 367 1222 421">2 dots adjacent</td> <td data-bbox="1225 367 1479 421">N≤0</td> </tr> <tr> <td data-bbox="711 425 1222 479">3 dots adjacent</td> <td data-bbox="1225 425 1479 479">N≤0</td> </tr> <tr> <td data-bbox="513 483 708 640" rowspan="3">Dark dot</td> <td data-bbox="711 483 1222 537">Random</td> <td data-bbox="1225 483 1479 537">N≤3</td> </tr> <tr> <td data-bbox="711 542 1222 595">2 dots adjacent</td> <td data-bbox="1225 542 1479 595">N≤0</td> </tr> <tr> <td data-bbox="711 600 1222 654">3 dots adjacent</td> <td data-bbox="1225 600 1479 654">N≤0</td> </tr> <tr> <td data-bbox="513 658 708 936">Distance</td> <td data-bbox="711 658 1222 936">                     1. Minimum Distance Between Bright dots.                      2. Minimum Distance Between dark dots                      3. Minimum Distance Between dark and bright dot.                 </td> <td data-bbox="1225 658 1479 936">5mm</td> </tr> <tr> <td colspan="2" data-bbox="513 940 1222 987">Total bright and dark dot</td> <td data-bbox="1225 940 1479 987">N≤4</td> </tr> </tbody> </table> <p data-bbox="513 999 593 1032">Note:</p> <p data-bbox="513 1055 1455 1144">A) Bright dot: Dots appear bright and unchanged in size in which LCD panel is displaying under black pattern.</p> <p data-bbox="513 1160 1414 1249">B) Dark dot: Dots appear dark and unchanged in size in which LCD panel is displaying under pure red, green, blue picture.</p> <p data-bbox="513 1305 1007 1344">C) 2 dot adjacent = 1 pair = 2 dots</p> <p data-bbox="513 1355 625 1388">Picture:</p> <div data-bbox="643 1442 719 1500" data-label="Image"> </div> <p data-bbox="560 1547 767 1581">2 dot adjacent</p> <div data-bbox="1050 1442 1163 1500" data-label="Image"> </div> <p data-bbox="1002 1547 1209 1581">2 dot adjacent</p> <div data-bbox="651 1608 692 1720" data-label="Image"> </div> <p data-bbox="513 1738 849 1771">2 dot adjacent (vertical)</p> <div data-bbox="1058 1608 1241 1720" data-label="Image"> </div> <p data-bbox="992 1738 1295 1771">2 dot adjacent (slant)</p>	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
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																							

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)</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)	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			
		Width(mm)			Length(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																											
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.																										

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

## 8. Reliability Test Result

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, 96HR	
High Temperature Storage	80°C, 96HR	
Low Temperature Storage	-30°C, 96HR	
High Temperature & High Humidity Operating	+60°C, 90% RH ,96 hours.	
Thermal Shock (Non-operation)	-10°C,30 min ↔ +60°C,30 min, Change	
ESD test	C=150pF, R=330,5points/panel Air:±8KV, 5times; Contact:±6KV, 5 times;	
Vibration (Non-operation)	Frequency range:10~55Hz, Stroke:1.5mm Sweep:10Hz~55Hz~10Hz 2	
Box Drop Test	1 Corner 3 Edges 6	

## Remark:

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.

## **9. Cautions and Handling Precautions**

### **9.1 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.

### **9.2 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.