



**Display Future Ltd**

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## **LCD MODULE SPECIFICATION**

**Model: DF-TFR0352FB-M1**

**This module uses ROHS materials**

### **For customer acceptance**

Customer		date
Approved		
Comments		

The standard product specification may change without prior notice in order to improve performance or quality. Please contact Display Future Ltd for updated specification and product status before design for the standard product or release of the order.

Revision	1.2
Engineering	
Date	2018/01/4
Our Reference	

## REVISION RECORD

[illegible]

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**■ GENERAL INFORMATION**

Item	Contents	Unit
LCD type	TFT/Transflective	/
Size	3.5	Inch
Viewing direction	6:00(without image inversion and least brightness change)	O' Clock
Gray scale inversion direction	12:00(contrast peak located at)	O' Clock
LCM (W × H × D )	64.00×85.00×4.2	mm <sup>3</sup>
Active area (W×H)	53.64×71.52	mm <sup>2</sup>
Pixel pitch (W×H)	0.2235×0.2235	mm <sup>2</sup>
Number of dots	240 (RGB) × 320	/
Driver IC	ILI9341V	/
Backlight type	6 LEDs	/
Interface type	18-bit RGB+SPI	/
Color depth	262K	/
Pixel configuration	R.G.B vertical stripe	/
Surface treatment	HC	/
Input voltage	2.8	V
With/Without TSP	Without TSP	/
Weight	TBD	g

Note 1: RoHS compliant;

Note 2: LCM weight tolerance: ± 5% .

[illegible]

## ■ABSOLUTE MAXIMUM RATINGS

GND=0V, Ta=25°C

Item	Symbol	Min	Max	Unit	Remark
Supply Voltage	VSHD	-0.3	4.6	V	
Driver supply voltage	VGH-VGL	-0.3	+32.0	V	
Logic input voltage range	VIN	-0.3	VSHD + 0.3	V	
Logic output voltage range	VO	-0.3	VSHD + 0.3	V	
Operating temperature	Top	-20	70	°C	Note1
Storage temperature	Tst	-30	80	°C	Note1

Note1: The parameter is for driver IC (gate driver, source driver) only.

Note2: Signals include R0~R5, G0~G5, B0~B5, DCLK, Hsync, Vsync, Reset, CS, SDI, SCL, .ENABLE

## ■ELECTRICAL CHARACTERISTICS

### DC CHARACTERISTICS

GND=0V, Ta=25°C

Item	Symbol	Min	Typ	Max	Unit	Remark
Supply voltage	VCC	2.5	2.8	3.3	V	
Gate on voltage	VGH	13.5	15.0	16.5	V	
Gate off voltage	VGL	-11.0	-10.0	-9.0	V	
Input Signal Voltage	Low Level	V <sub>IL</sub>	0	-	0.3xVCC	R0~R5; G0~G5; B0~B5 DOTCLK; Hsync; Vsync ENABLE; R/L; U/D
	High Level	V <sub>IH</sub>	0.7xVCC	-	VCC	
Current of VSHD Power supply	I <sub>CC</sub>	-	15	-	mA	Note 1

Note1: For different LCM, the value may have a bit of difference.

Note2: To test the current dissipation, use "all Black Pattern".

## ■ BACKLIGHT CHARACTERISTICS

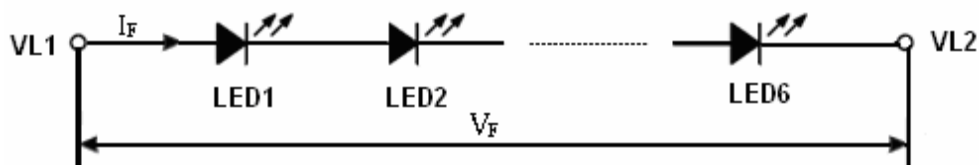
Ta = 25°C

Item	Symbol	Min	Typ	Max	Unit	Remark
Forward Current	I <sub>F</sub>	-	20	-	mA	
Forward Voltage	V <sub>BL</sub>	-	19.2	-	V	
Backlight Power Consumption	W <sub>BL</sub>	-	384	-	mW	
Life Time	-	30,000	-	-	Hrs	Note 3

Note 1: I<sub>F</sub> is defined for one channel LED. There are total three LED channels in back light unit

Note 2: Optical performance should be evaluated at Ta=25°C only.

Note 3: If LED is driven by high current, high ambient temperature &amp; humidity condition. The life time of LED will be reduced. Operating life means brightness goes down to 50% initial brightness. Typical operating life time is estimated data.



LED connection of backlight

## ■ELECTRO-OPTICAL CHARACTERISTICS

### DRIVING THE BACKLIGHT CONDITION

Item	Symbol	Condition	Min	Typ	Max	Unit	Remark	Note
Response time	Tr +Tf	$\theta=0^{\circ}$ $\varnothing=0^{\circ}$	-	35	-	ms	Fig.1	4
Contrastratio	Cr		100	150	-	—	FIG 2.	1
Surface Luminance	Lv	Ta=25℃	60	80	-	cd/m <sup>2</sup>	FIG 2.	2
Viewing angle range	$\theta$	$\varnothing=90^{\circ}$	55	60	-	deg	FIG 3.	6
		$\varnothing=270^{\circ}$	40	45	-	deg	FIG 3.	
		$\varnothing=0^{\circ}$	45	50	-	deg	FIG 3.	
		$\varnothing=180^{\circ}$	40	45	-	deg	FIG 3.	
CIE (x, y) chromaticity	White x	Ta=25℃	-	0.301	-		FIG 2.	5
	White y		-	0.321	-			

### NOT DRIVING THE BACKLIGHT CONDITION

Item	Symbol	Condition	Min	Typ	Max	Unit	Remark	Note
Contrastratio	Cr	$\varnothing=0^\circ$ Ta=25℃	-	6.5	-	—	FIG 2.	1
Reflectance			-	7.0	-	%	FIG 2.	3
Viewing angle range	$\theta$	$\varnothing = 90^\circ$	-	60	-	deg	FIG 3.	6
		$\varnothing = 270^\circ$	-	60	-	deg	FIG 3.	
		$\varnothing = 0^\circ$	-	60	-	deg	FIG 3.	
		$\varnothing = 180^\circ$	-	55	-	deg	FIG 3.	
CIE (x, y) chromaticity	White x	Ta=25℃	-	0.310	-		FIG 2.	5
	White y		-	0.320	-			

Test Conditions:

1.  $I_F=20\text{mA}$ ,  $V_F=19.2\text{V}$ , the ambient temperature is 25℃.
2. The test systems refer to Note 1 and Note 2.

Note 1. Contrast Ratio(CR) is defined mathematically as For more information see FIG 2.:

$$\text{Contrast Ratio} = \frac{\text{Average Surface Luminance with all white pixels (P}_1, \text{P}_2, \text{P}_3, \text{P}_4, \text{P}_5)}{\text{Average Surface Luminance with all black pixels (P}_1, \text{P}_2, \text{P}_3, \text{P}_4, \text{P}_5)}$$

Note 2. Surface luminance is the LCD surface from the surface with all pixels displaying white. For more information see FIG 2.

$$L_v = \text{Average Surface Luminance with all white pixels (P}_1, \text{P}_2, \text{P}_3, \text{P}_4, \text{P}_5)$$

Note 3. The uniformity in surface luminance,  $\delta$  WHITE is determined by measuring luminance at each test position 1 through 5, and then dividing the maximum luminance of 5 points luminance by minimum luminance of 5 points luminance. For more information see FIG 2.

$$\delta \text{ WHITE} = \frac{\text{Minimum Surface Luminance with all white pixels (P}_1, \text{P}_2, \text{P}_3, \text{P}_4, \text{P}_5)}{\text{Maximum Surface Luminance with all white pixels (P}_1, \text{P}_2, \text{P}_3, \text{P}_4, \text{P}_5)}$$

Note 4. Response time is the time required for the display to transition from White to black(Rise Time, Tr) and from black to white(Decay Time, Tf). For additional information see FIG 1. The test equipment is Autronic-Melchers's ConoScope. Series

Note 5. CIE (x, y) chromaticity, The x,y value is determined by measuring luminance at each test position 1 through 5, and then make average value

Note 6. Viewing angle is the angle at which the contrast ratio is greater than 2. For TFT module the contrast ratio is greater than 10. The angles are determined for the horizontal or x axis and the vertical or y axis with respect to the z axis which is normal to the LCD surface. For more information see FIG 3.

Note 7. For Viewing angle and response time testing, the testing data is base on Autronic-Melchers's ConoScope. Series Instruments. For contrast ratio, Surface Luminance, Luminance uniformity, CIE The test data is base on TOPCON's BM-5 photo detector.

Note 8. For TFT module, Gray scale reverse occurs in the direction of panel viewing angle.

FIG.1. The definition of Response Time

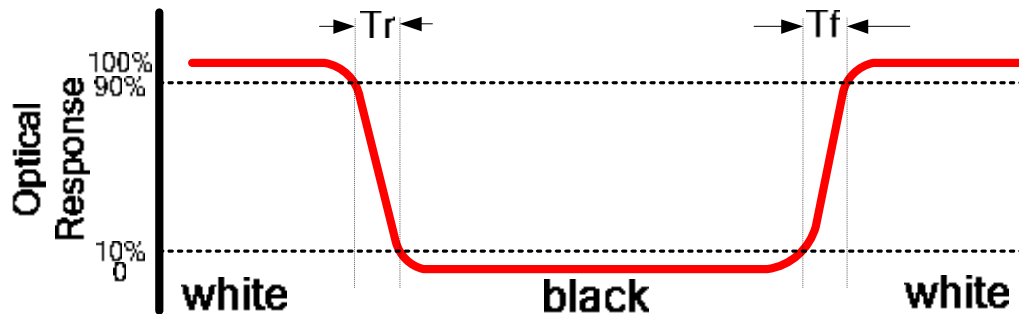


FIG.2. Measuring method for Contrast ratio, surface luminance, Luminance uniformity, CIE (x, y) chromaticity

A : 5 mm  
 B : 5 mm  
 H, V : Active Area  
 Light spot size  $\varnothing=5\text{mm}$ , 500mm distance from the LCD surface to detector lens  
 measurement instrument is TOPCON's luminance meter BM-5

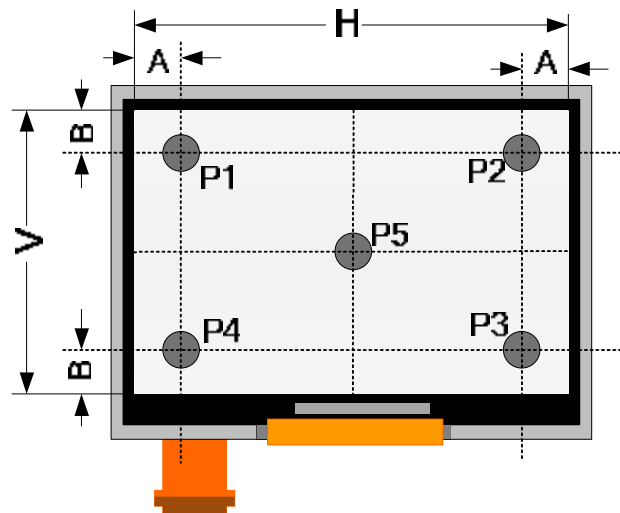
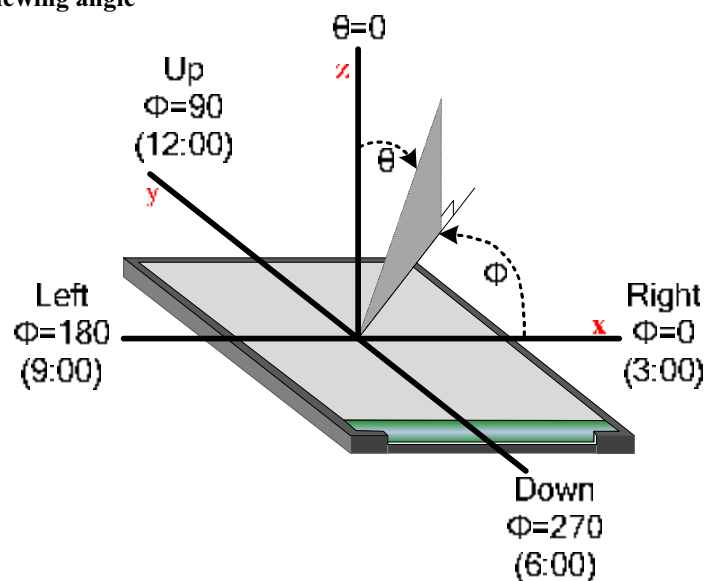


FIG.3. The definition of viewing angle





## ■ INTERFACE DESCRIPTION

### 1 J1 Pin Assignment

Connector type: FH12A-50S-0.5SH

No	Symbol	I/O	Description	Comment
1	VL1	P	Power supply for LED(High voltage)	
2	GND	P	Ground	
3	VL2	P	Power supply for LED(Low voltage)	
4	GND	P	Ground	
5	VSHD	P	Power supply for digital	
6	GND	P	Ground	
7	GND	P	Ground	
8	GND	P	Ground	
9	VSYNC	I	Vertical sync. in RGB mode	
10	GND	P	Ground	
11	RESET	I	Reset(Low active)	
12	GND	P	Ground	
13	GND	P	Ground	
14	GND	P	Ground	
15	CS	I	Chip select input(Low enable)	
16	GND	P	Ground	
17	SDO	O	Serial data output	
18	SDI	I	Serial data input	
19	GND	P	Ground	
20	SCL	I	Serial interface clock	
21	GND	P	Ground	
22	B5	I	Blue data input(MSB)	
23	B4	I	Blue data input	
24	B3	I	Blue data input	
25	B2	I	Blue data input	
26	B1	I	Blue data input	
27	B0	I	Blue data input(LSB)	
28	ENAB	I	Data enable in RGB mode	
29	GND	P	Ground	
30	HSYNC	I	Horizontal sync. in RGB mode	
31	GND	P	Ground	
32	DCLK	I	Pixel clock signal in RGB mode	
33	GND	P	Ground	
34	G5	I	Green data input(MSB)	
35	G4	I	Green data input	
36	G3	I	Green data input	
37	G2	I	Green data input	
38	G1	I	Green data input	
39	G0	I	Green data input(LSB)	
40	GND	P	Ground	
41	R5	I	Red data input(MSB)	
42	R4	I	Red data input	
43	R3	I	Red data input	
44	R2	I	Red data input	

45	R1	I	Red data input	
46	R0	I	Red data input(LSB)	
47	GND	P	Ground	
48	GND	P	Ground	
49	GND	P	Ground	
50	GND	P	Ground	

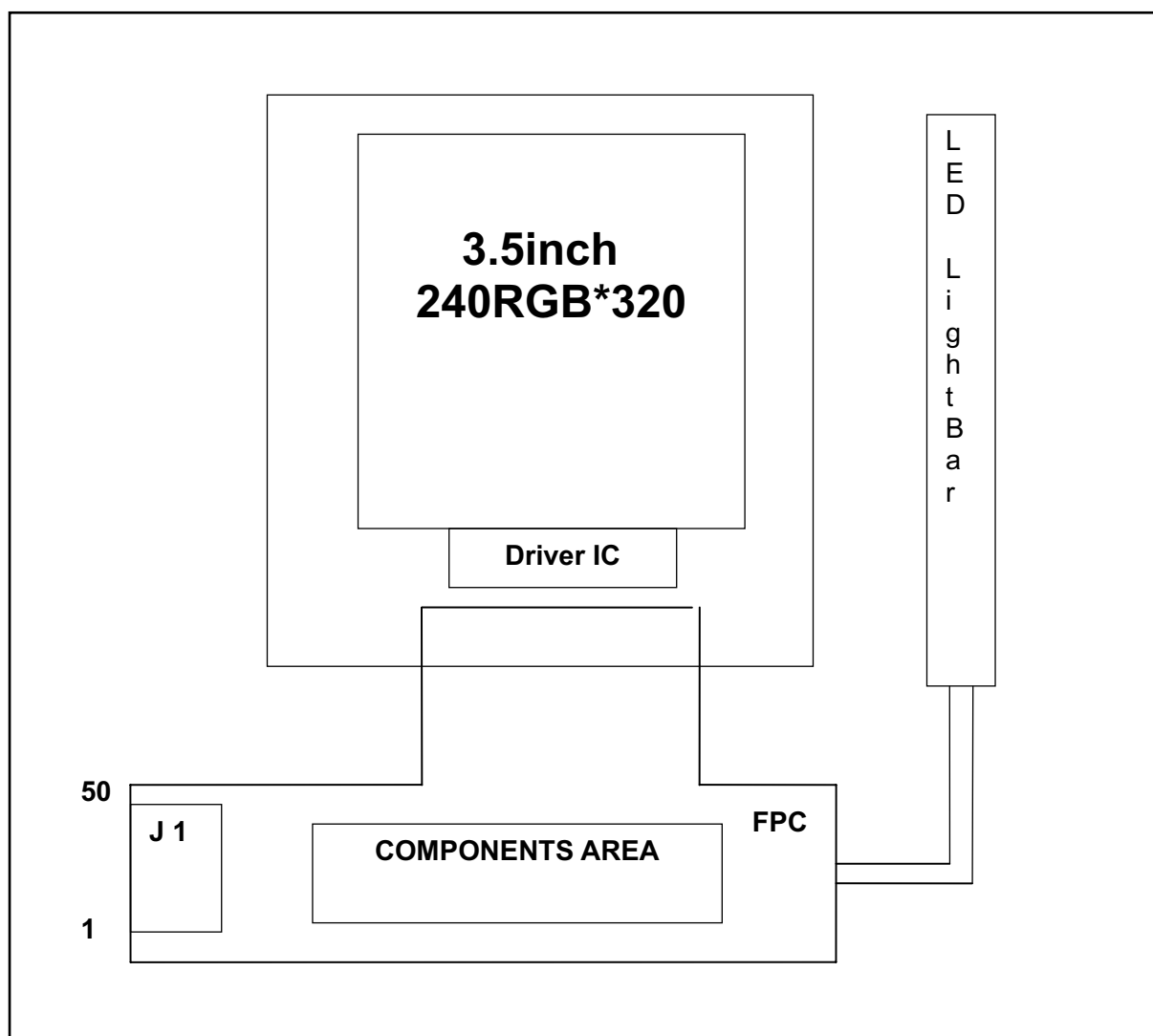
Note1: I/O definition:

I----Input O----Output P----Power/Ground

## 2 Touch panel Pin Assignment

Pin	Symbol	I/O	Description	Remark
1	YU	O	Y+ Channel input	
2	XR	O	X+ Channel input	
3	YD	O	Y- Channel input	
4	XL	O	X- Channel input	

## ■ BLOCK DIAGRAM



## ■ APPLICATION NOTES

### 1. Data input timing

#### 1.1 Signal AC Timing

(VSHD=2.5~3.2V, Ta=25°C)

Signal	Symbol	Parameter	min	max	Unit
VSYNC / HSYNC	$t_{SYNCS}$	VSYNC/HSYNC setup time	15	-	ns
	$t_{SYNCH}$	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	PWDH	DOTCLK high-level period	15	-	ns
	PWDL	DOTCLK low-level period	15	-	ns
	$t_{CYCD}$	DOTCLK cycle time	100	-	ns
	$t_{rgrbr}, t_{rgrbf}$	DOTCLK, HSYNC, VSYNC rise/fall time	-	15	ns

Table 1.1 RGB Interface Characteristics

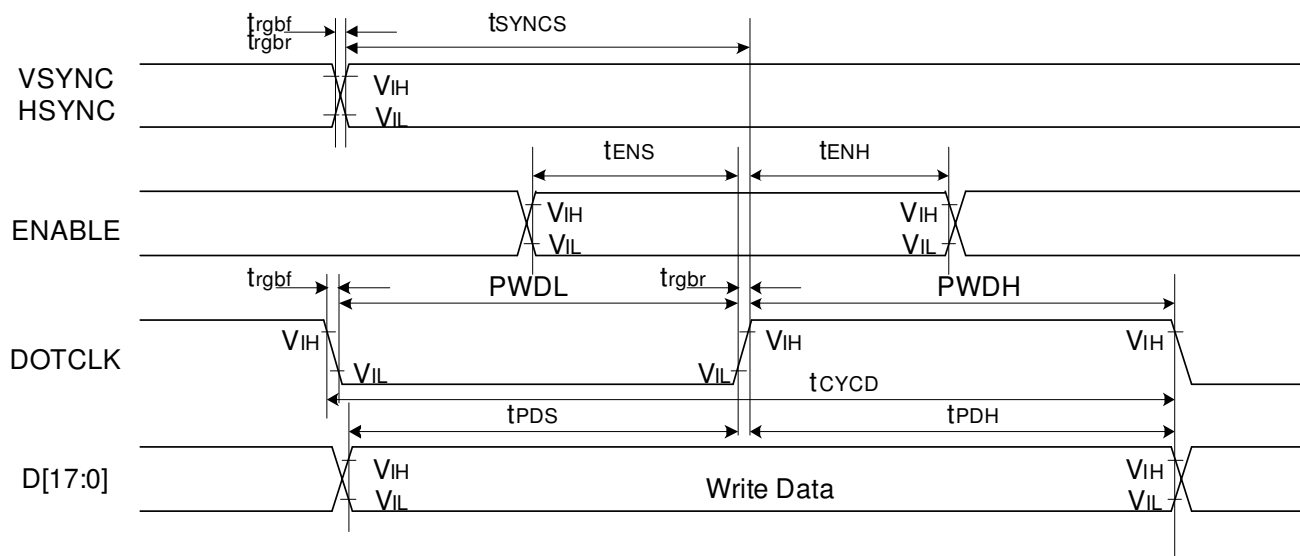


Fig.1-1 RGB Interface Timing

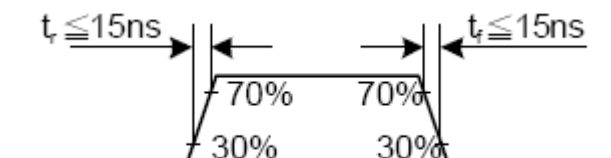


Fig.1-2 Input signal's rise and fall times

## 1.2 Recommend RGB Interface Timing

(VSHD=2.5~3.2V, Ta=25°C)

Parameter	Symbol	Symbol	Min	Typ	Max	Unit	Remark
DCLK	DCLK frequency	fDCYC	-	5.64	10	MHz	
	DCLK period	tDCYC	100	177.15	-	ns	
HSYNC	Horizontal	Thd	240			DCLK	
	1horizontalline	Th	-	310	-		
	Horizontal blank	Thb	56	60	-		
	Horizontal front porch	Thfp	2	10	16		
VSYNC	Vertical display area	Tvd	320			Line	
	Vsync period time	Tv	-	328	-		
	Vsync blank	Tvb	2	4	-		
	Vsync Front porch	Tvfp	2	4	-		

Tab.1-2 Recommend Input Timing (DCLK, HSYNC, VSYNC, ENAB)

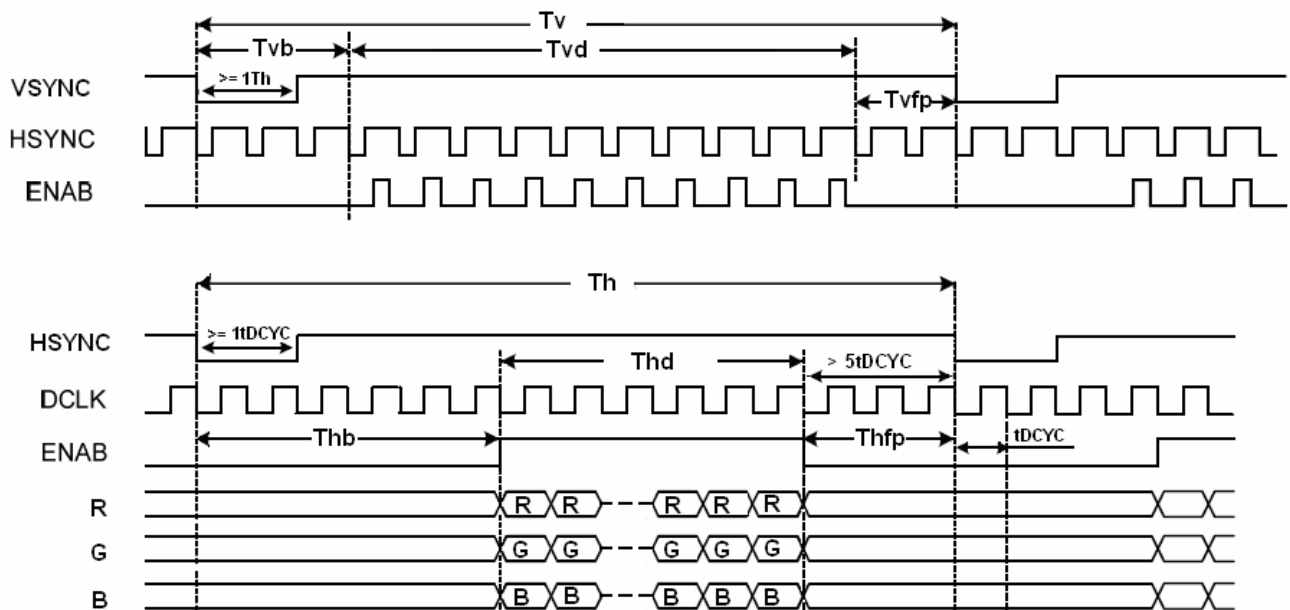
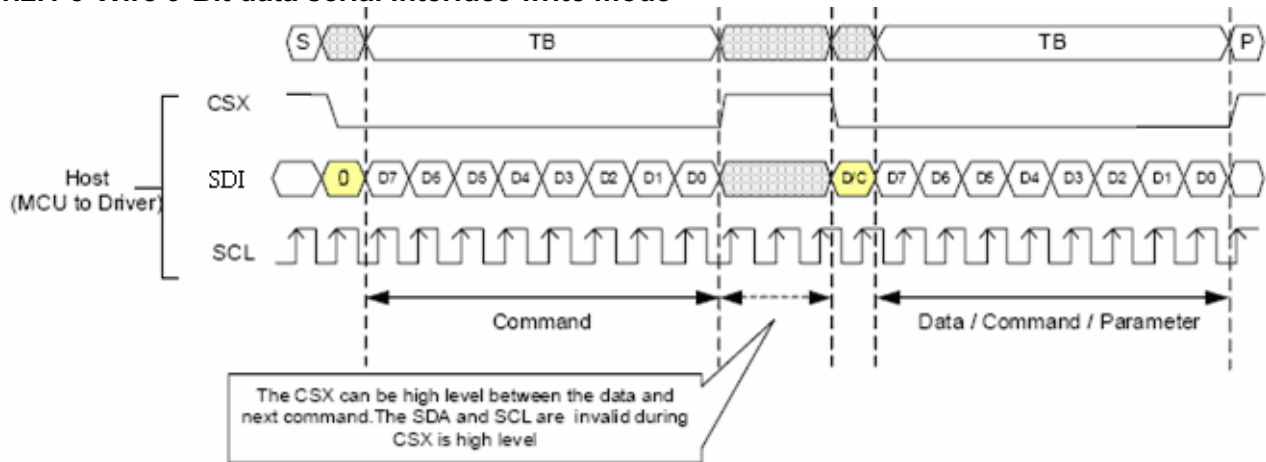


Fig.1-3 Recommend RGB Interface Timing

## 1.2 3-Wire 9-BIT Serial Interface

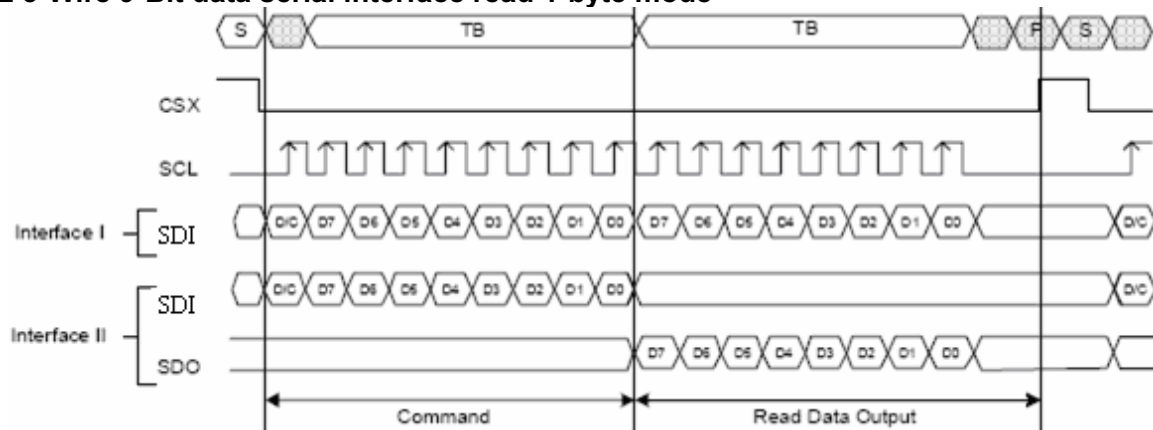
### 1.2.1 3-Wire 9-Bit data serial interface write mode



**Figure. 1-4 3-Wire 9-Bit Serial Interface I Bus Protocol, Write to Register or Display RAM**

Note: D/C =0, Transfer Command; D/C =1, Transfer Data.

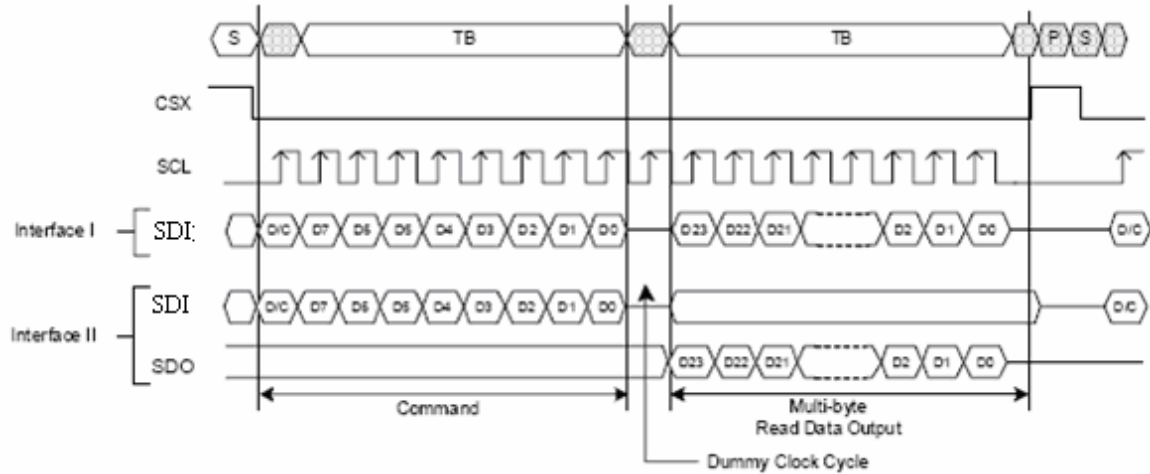
### 1.2.2 3-Wire 9-Bit data serial interface read 1-byte mode



**Figure. 1-5 3-Wire 9-Bit Serial Interface I/II Bus Protocol, Read 1-Byte From Register**

Note: D/C=0, Transfer Command; D/C=1, Transfer Data.

### 1.2.3 3-Wire 9-Bit data serial interface read 3-byte mode



**Figure. 1-6 3-Wire 9-Bit Serial Interface I/II Bus Protocol, Read 3-Byte From Register**

Note: D/C=0, Transfer Command; D/C=1, Transfer Data.

### 1.2.4 3-Wire 9-Bit serial interface Timing

(VSHD=2.5~3.2V, Ta=25°C)

Parameter	Symbol	Conditions	Min	Max	Unit	Remark
Serial Clock Cycle(Write)	tscycw	SCL	100	-	ns	
SCL "H" pluse width(Write)	tshw	SCL	40	-	ns	
SCL "L" pluse width(Write)	tslw	SCL	40	-	ns	
Data setup time(Write)	tsds	SDI	30	-	ns	
Data hold time(Write)	tsdh	SDI	30	-	ns	
Serial Clock Cycle(Read)	tscycr	SCL	150	-	ns	
SCL "H" pluse width(Read)	tshr	SCL	60	-	ns	
SCL "L" pluse width(Read)	tslr	SCL	60	-	ns	
Access time	tacc	SDO(Read)	10		ns	
Output disable time	toh	SDO(Read)	10	50	ns	
CS "H" pluse width	tch	CS	40	-	ns	
CS-SCL time	tcss	CS (Write)	60	-	ns	
	tcsh	CS (Write)	65	-	ns	

**Tab.1-3 AC Characteristics of 3-Wire 9-Bit Serial Interface**

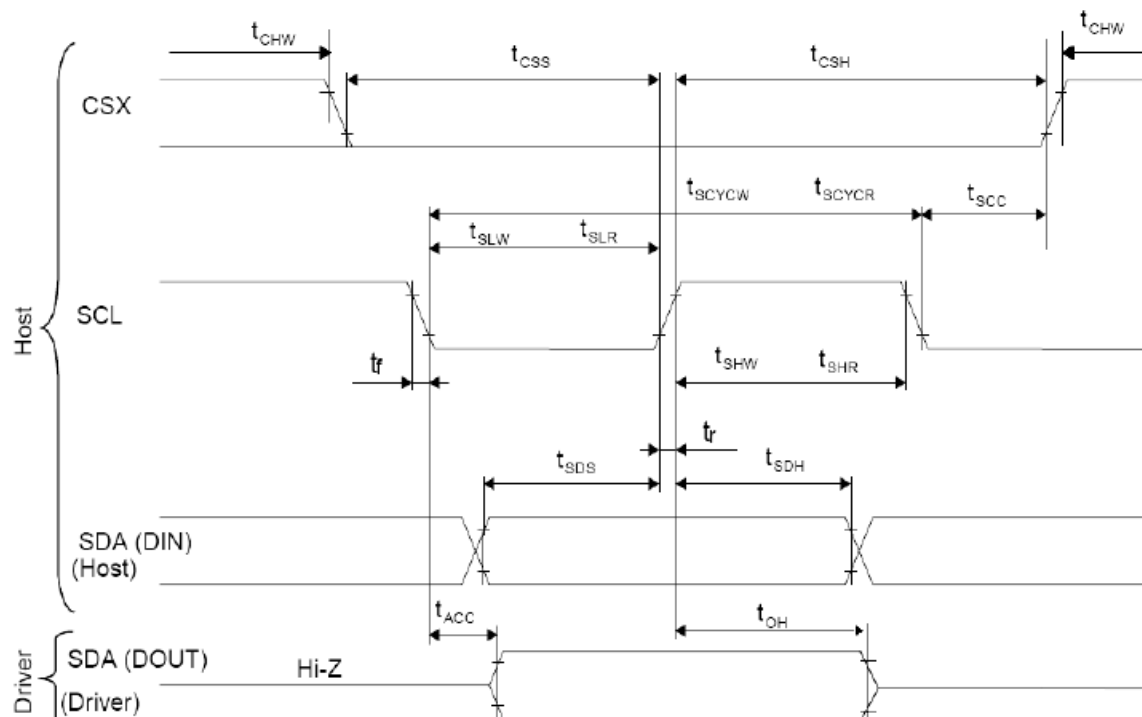


Fig.1-7 AC Characteristics of 3-Wire 9-Bit Serial Interface timing

### 1.3 Reset Timing

Parameter	Symbol	MIN	TYP	MAX	Unit	Remark
RESET	tRW	10	-	-	us	-
	tRT	-	-	5	ms	note 1
		-	-	120	ms	note 2

Tab.1-4 Reset input timing

Note1: When Reset applied during Sleep In Mode.

Note2: When Reset applied during Sleep Out Mode.

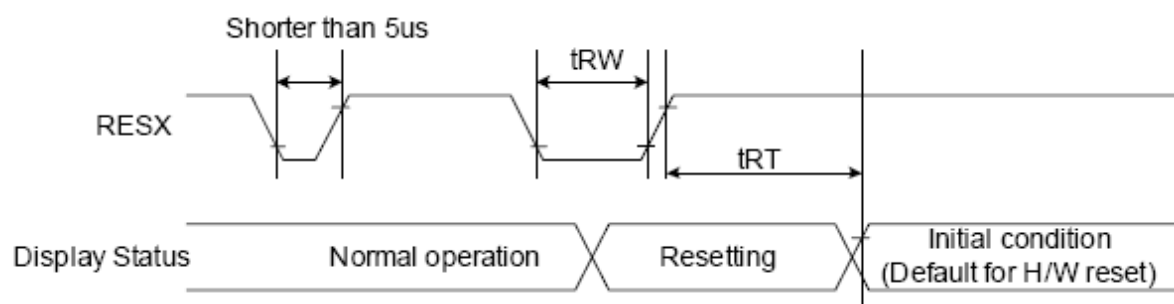


Fig.1-8 Reset timing

### 1.5 Power ON/OFF Sequence

Item	Symbol	Min	Typ	Max	Unit	Remark
VSHD to RESET2 ending/ RESET2 starting to VSHD	t1	10			ms	
RESET2 ending to SPI starting/ SPI ending to RESET2 starting	t2	10	-	50	ms	
SPI starting to RGB starting/ RGB ending to SPI ending	t3	20	-	50	ms	
RGB starting to BLU starting/ BLU ending to RGB ending	t4	50	-	-	ms	
RGB ending to RESET1 starting	t5	20	-	-	ms	

Table 5.5 Power on/off sequence

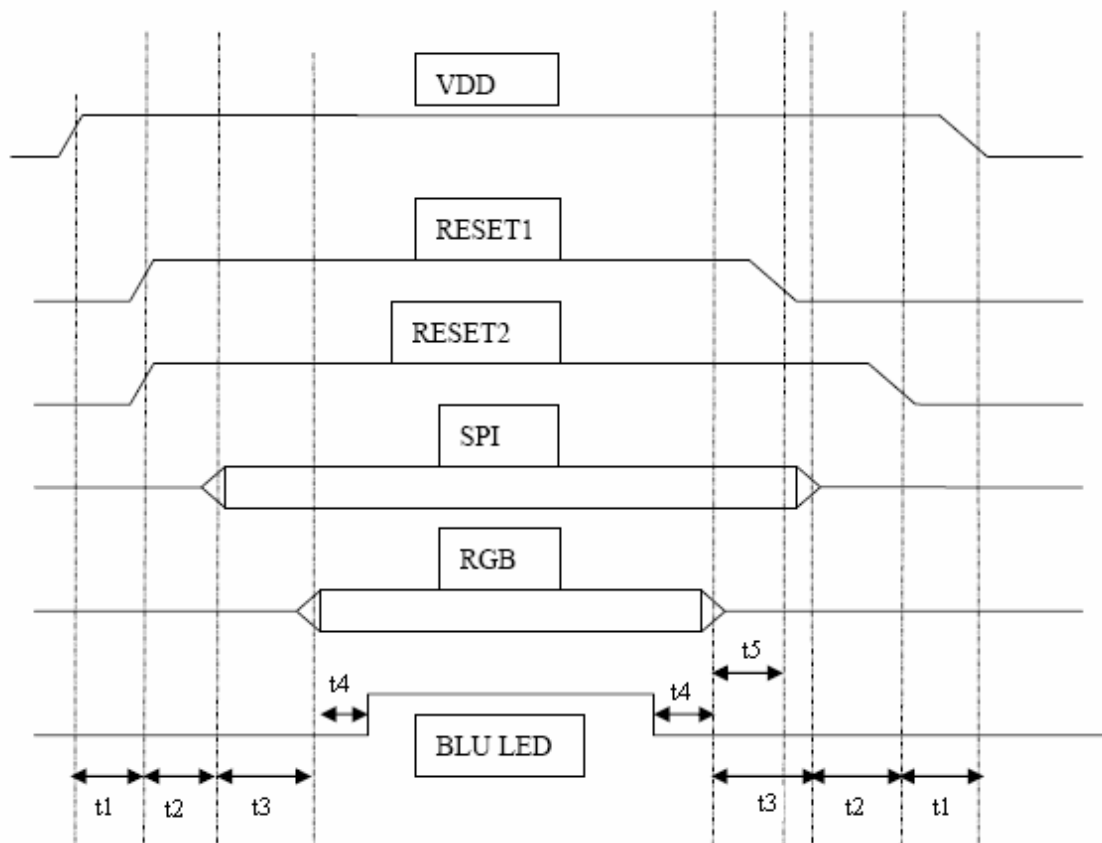


Figure 1.5 Power on/off sequence

Note1: RESET1 Power down in sleep out mode.

Note2: RESET2 Power down in sleep in mode.



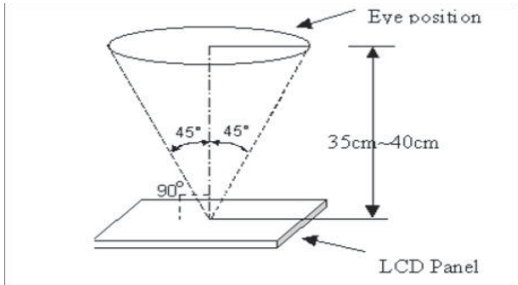
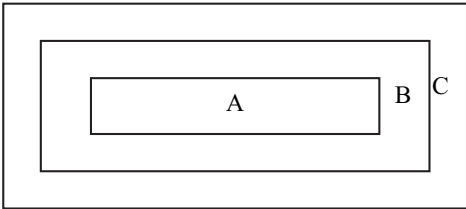
## ■ RELIABILITY TEST

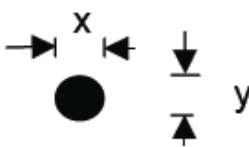
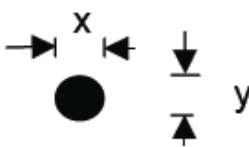
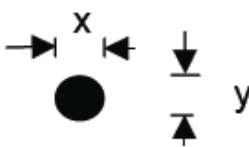
No.	Test Item	Test Condition	Remark
1	High Temperature Storage	$80 \pm 2^{\circ}\text{C}/240$ hours	IEC60068-2-1 GB2423.2
2	Low Temperature Storage	$-30 \pm 2^{\circ}\text{C}/240$ hours	IEC60068-2-1 GB2423.1
3	High Temperature Operating	$70 \pm 2^{\circ}\text{C}/240$ hours	IEC60068-2-1 GB2423.2
4	Low Temperature Operating	$-20 \pm 2^{\circ}\text{C}/240$ hours	IEC60068-2-1 GB2423.1
5	Temperature Cycle storage	$-30 \pm 2^{\circ}\text{C} \sim 25 \sim 70 \pm 2^{\circ}\text{C} \times 20$ cycles (30min.) (5min.) (30min.)	Start with cold temperature, End with high temperature, IEC60068-2-14 GB2423.22
6	Damp proof Test operating	$40^{\circ}\text{C} \pm 5^{\circ}\text{C} \times 90\%\text{RH}/240$ hours	IEC60068-2-78 GB/T2423.3
7	Vibration Test (non-operation)	Frequency range:10Hz~55Hz, Stroke:1.5mm Sweep:10Hz~55Hz~10Hz 2hours for each direction of X,Y,Z(6 hours for total)	IEC60068-2-6 GB/T2423.10
8	Package drop test	Height:60cm,1 corner,3 edges,6 surfaces	IEC60068-2-32,GB2423.8
9	ESD test (operation)	C=150pF,R=330 $\Omega$ ,5points/panel Air: $\pm 8\text{KV}$ ,5times Contact: $\pm 4\text{KV}$ ,5times(Environment: $15^{\circ}\text{C} \sim 35^{\circ}\text{C}$ ,30%~60%,86Kpa~106Kpa)	IEC61000-4-2 GB/T17626.2
10	Shock(non-operation)	100G 6ms, $\pm X, \pm Y, \pm Z$ 3times each direction	IEC60068-2-27 GB/T2423.5



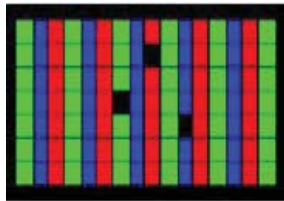
Note 1:Ts is the temperature of panel's surface.

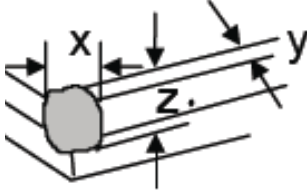
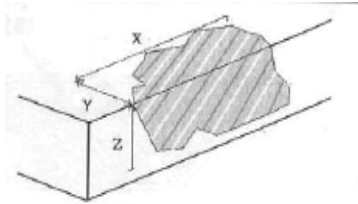
Note 2:Ta is the ambient temperature of sample.

## ■ INSPECTION CRITERION

OUTGOING QUALITY STANDARD	PAGE 1 OF 5
TITLE:FUNCTIONAL TEST & INSPECTION CRITERIA	
<p>This specification is made to be used as the standard acceptance/rejection criteria for TFT module.</p> <p>1 Sample plan</p> <p>1.1 Lot size: Quantity per shipment lot per model</p> <p>1.2 Sampling type: Normal inspection,Single sampling</p> <p>1.3 Inspection level: II</p> <p>1.4 Sampling table: MIL-STD-105D</p> <p>1.5 Acceptable quality level (AQL)</p> <p>Major defect: AQL=0.65</p> <p>Minor defect: AQL=1.50</p> <p>2. Inspection condition</p> <p>2.1 Ambient conditions:</p> <p>a. Temperature: Room temperature <math>25 \pm 5^{\circ}\text{C}</math></p> <p>b. Humidity: <math>(60 \pm 10) \% \text{RH}</math></p> <p>c. Illumination: Single fluorescent lamp non-directive (300 to 700 Lux)</p> <p>2.2 Viewing distance:</p> <p>The distance between the LCD and the inspector' s eyes shall be at least <math>35 \pm 5 \text{cm}</math>.</p> <p>2.3 Viewing Angle</p> <p>U/D: <math>45^{\circ} / 45^{\circ}</math> , L/R: <math>45^{\circ} / 45^{\circ}</math></p> <div data-bbox="392 1196 911 1480">  </div> <p>3. Definition of Inspection Item.</p> <p>3.1 Definition of inspection zone in LCD.</p> <div data-bbox="384 1592 852 1800">  </div> <p>Zone A: character/Digit area</p> <p>Zone B: viewing area except Zone A (ZoneA+ZoneB=minimum Viewing area)</p> <p>Zone C: Outside viewing area (invisible area after assembly in customer's product)</p> <p>Fig.1 Inspection zones in an LCD.</p>	

OUTGOING QUALITY STANDARD		PAGE 2 OF 5																																	
TITLE:FUNCTIONAL TEST & INSPECTION CRITERIA																																			
<p>Note: As a general rule, visual defects in Zone C are permissible, when it is no trouble for quality and assembly of customer’s product.</p> <p>4. Inspection standards</p> <p>Defects are classified as majot defects and minor defects according to the degree of defectiveness defined herein.</p> <p>4.1 Major defect</p> <table><tr><th>Item No</th><th>Items to be inspected</th><th colspan="2">Inspection Standard</th></tr><tr><td>4.1.1</td><td>All functional defects</td><td colspan="2">1) No display 2) Display abnormally 3) Short circuit 4) Line defect 5) Excess power consumption</td></tr><tr><td>4.1.2</td><td>Missing</td><td colspan="2">Missing function component</td></tr><tr><td>4.1.3</td><td>Crack</td><td colspan="2">Glass crack</td></tr></table> <p>4.2 Minor defect</p> <table><tr><th>Item No</th><th>Items to be inspected</th><th colspan="2">Inspection standard</th></tr><tr><td rowspan="5">4.2.1</td><td rowspan="5">Spot Defect Including Black spot White spot Pinhole Foreign particle Polarizer dirt</td><td colspan="2">For dark/white spot is defined <math display="block">\varphi = (x+y) / 2</math></td></tr><tr><td>Size <math>\varphi(\text{mm})</math></td><td>Acceptable Quantity</td></tr><tr><td><math>\varphi \leq 0.15</math> 2mm(min) apart</td><td>Ignore</td></tr><tr><td><math>0.15 &lt; \varphi \leq 0.25</math> 5mm(min) apart</td><td>3</td></tr><tr><td><math>0.25 &lt; \varphi</math></td><td>Not allowed</td></tr></table>				Item No	Items to be inspected	Inspection Standard		4.1.1	All functional defects	1) No display 2) Display abnormally 3) Short circuit 4) Line defect 5) Excess power consumption		4.1.2	Missing	Missing function component		4.1.3	Crack	Glass crack		Item No	Items to be inspected	Inspection standard		4.2.1	Spot Defect Including Black spot White spot Pinhole Foreign particle Polarizer dirt	For dark/white spot is defined $\varphi = (x+y) / 2$ 		Size $\varphi(\text{mm})$	Acceptable Quantity	$\varphi \leq 0.15$ 2mm(min) apart	Ignore	$0.15 < \varphi \leq 0.25$ 5mm(min) apart	3	$0.25 < \varphi$	Not allowed
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OUTGOING QUALITY STANDARD			PAGE 3 OF 5	
TITLE:FUNCTIONAL TEST & INSPECTION CRITERIA				
4.2.2	Line Defect Including Black line White line Scratch	Define: 		
		Width(mm) Length(mm)	Acceptable Quantity	
		W≤0.05 and L≤10	Ignore	
		0.05 < W≤0.08 and L≤10 3mm(min) apart	3	
		0.08 < W≤0.10 and L≤5 3mm(min) apart	1	
		0.10 < W or 10 < L	Not allowed	
		4.2.3	Polarizer Dent/Bubble	Size ϕ(mm)
ϕ≤0.25	Ignore			
Non visible area	Ignore			
0.25 < ϕ≤0.40 5mm(min) apart	2			
0.40 < ϕ	Not allowed			
4.2.4	Electrical Dot Defect	Bright and Black dot define:  and 		
		Inspection pattern: Full white, Full black, Red, green and blue screens		
		Item	Acceptable Quantity	
		Black dot defect	2	
		Bright dot defect	0	
		Total Dot	2	

OUTGOING QUALITY STANDARD		PAGE 4 OF 5	
TITLE:FUNCTIONAL TEST & INSPECTION CRITERIA			
4.2.5	Touch panel chips	 <p>1. Corner chips:</p>	
		Size(mm)	Acceptable Quantity
		$X \leq 3\text{mm}$ $Y \leq 3\text{mm}$ $Z \leq T$	Ignore T: Glass thickness X: Length Y: Width Z: thickness
		 <p>2. Side chips:</p>	
		Size(mm)	Acceptable Quantity
		$X \leq 5\text{mm}$ $Y \leq 3\text{mm}$ $Z \leq T$	Ignore T: Glass thickness X: Length Y: Width Z: thickness

OUTGOING QUALITY STANDARD	PAGE 5 OF 5
TITLE:FUNCTIONAL TEST & INSPECTION CRITERIA	
<p>Note:</p> <ol style="list-style-type: none"><li>1. Dot defect is defined as the defective area of the dot area is larger than 50% of the dot area.</li><li>2. The distance between black dot defects or black and bright dot defects should be more than 5mm apart. The distance between two bright dot defects should be more than 15mm apart</li><li>3. Polarizer bubble is defined as the bubble appears on active display area. The defect of polarizer bubble shall be ignored if the polarizer bubble appears on the outside of active display area.</li><li>4. Mura is checker by 6% ND filter.</li><li>5. Foreign particle on the surface of the LCM should be ignore.</li></ol>	

## ■ PRECAUTIONS FOR USING LCD MODULES

### Handling Precautions

(1) The display panel is made of glass and polarizer. As glass is fragile. It tends to become or chipped during handling especially on the edges. Please avoid dropping or jarring. Do not subject it to a mechanical shock by dropping it or impact.

(2) If the display panel is damaged and the liquid crystal substance leaks out, be sure not to get any in your mouth. If the substance contacts your skin or clothes, wash it off using soap and water.

(3) Do not apply excessive force to the display surface or the adjoining areas since this may cause the color tone to vary. Do not touch the display with bare hands. This will stain the display area and degraded insulation between terminals (some cosmetics are determined to the polarizer).

(4) The polarizer covering the display surface of the LCD module is soft and easily scratched. Handle this polarizer carefully. Do not touch, push or rub the exposed polarizers with anything harder than an HB pencil lead (glass, tweezers, etc.). Do not put or attach anything on the display area to avoid leaving marks on. Condensation on the surface and contact with terminals due to cold will damage, stain or dirty the polarizer. After products are tested at low temperature they must be warmed up in a container before coming is contacting with room temperature air.

(5) If the display surface becomes contaminated, breathe on the surface and gently wipe it with a soft dry cloth. If it is heavily contaminated, moisten cloth with one of the following solvents

- Isopropyl alcohol
- Ethyl alcohol

Do not scrub hard to avoid damaging the display surface.

(6) Solvents other than those above-mentioned may damage the polarizer. Especially, do not use the following.

- Water
- Ketone
- Aromatic solvents

Wipe off saliva or water drops immediately, contact with water over a long period of time may cause deformation or color fading. Avoid contacting oil and fats.

(7) Exercise care to minimize corrosion of the electrode. Corrosion of the electrodes is accelerated by water droplets, moisture condensation or a current flow in a high-humidity environment.

(8) Install the LCD Module by using the mounting holes. When mounting the LCD module make sure it is free of twisting, warping and distortion. In particular, do not forcibly pull or bend the I/O cable or the backlight cable.

(9) Do not attempt to disassemble or process the LCD module.

(10) NC terminal should be open. Do not connect anything.

(11) If the logic circuit power is off, do not apply the input signals.

(12) Electro-Static Discharge Control, Since this module uses a CMOS LSI, the same careful attention should be paid to electrostatic discharge as for an ordinary CMOS IC. To prevent destruction of the elements by static electricity, be careful to maintain an optimum work environment.

- Before remove LCM from its packing case or incorporating it into a set, be sure the module and your body have the same electric potential. Be sure to ground the body when handling the LCD modules.

- Tools required for assembling, such as soldering irons, must be properly grounded. make certain the AC power source for the soldering iron does not leak. When using an electric screwdriver to attach LCM, the screwdriver should be of ground potentiality to minimize as much as possible any transmission of electromagnetic waves produced sparks coming from the commutator of the motor.

- To reduce the amount of static electricity generated, do not conduct assembling and other work under dry conditions. To reduce the generation of static electricity be careful that the air in the work is not too dried. A relative humidity of 50%-60% is recommended. As far as possible make the electric potential of your work clothes and that of the work bench the ground potential

- The LCD module is coated with a film to protect the display surface. Exercise care when peeling off this protective film since static electricity may be generated

(13) Since LCM has been assembled and adjusted with a high degree of precision, avoid applying excessive shocks to the module or making any alterations or modifications to it.

- Do not alter, modify or change the shape of the tab on the metal frame.
- Do not make extra holes on the printed circuit board, modify its shape or change the positions of components to be attached.
- Do not damage or modify the pattern writing on the printed circuit board.
- Absolutely do not modify the zebra rubber strip (conductive rubber) or heat seal connector.
- Except for soldering the interface, do not make any alterations or modifications with a soldering iron.
- Do not drop, bend or twist LCM.

#### Handling precaution for LCM

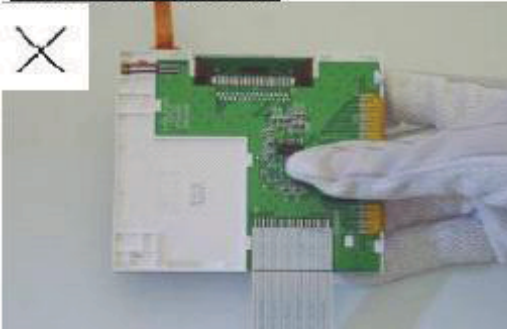
LCM is easy to be damaged.  
Please note below and be careful for handling!

##### **Correct handling:**

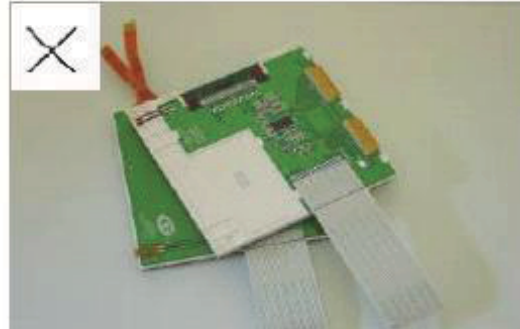


As above picture, please handle with anti-static gloves around LCM edges.

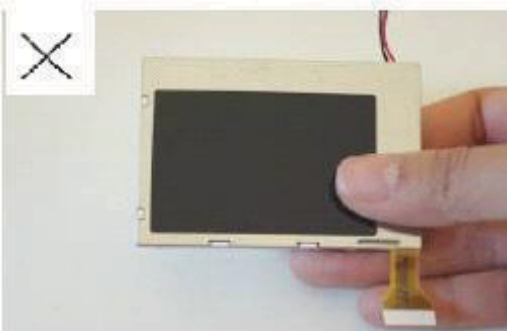
##### **Incorrect handling:**



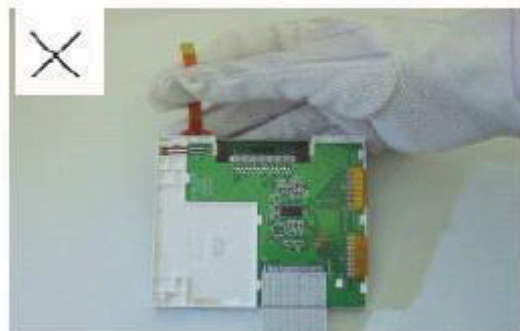
Please don't touch IC directly.



Please don't stack LCM.



Please don't hold the surface of panel.

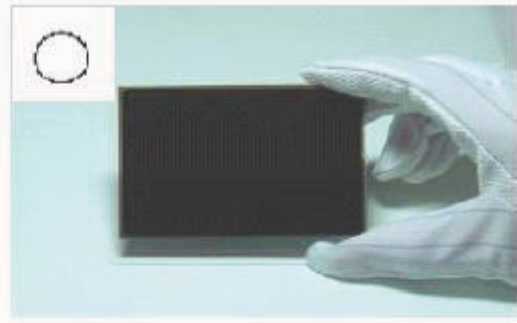


Please don't stretch interface of output, such as FPC cable.



**Handling precaution for LCD**

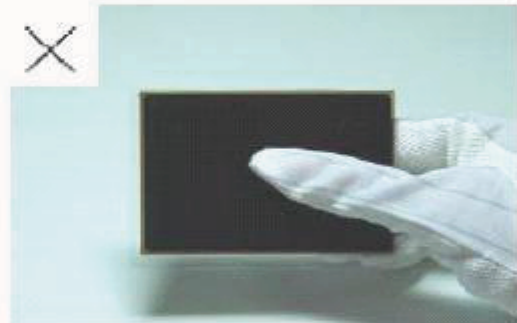
LCD is easy to be damaged.  
Please note below and be careful for handling!

**Correct handling:**

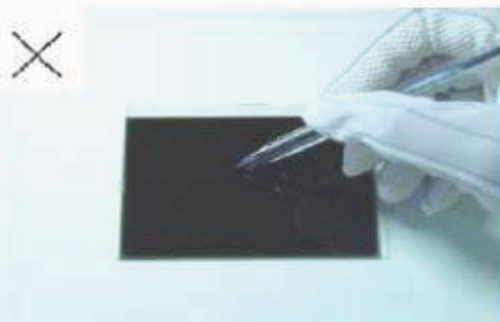
As above photo, please handle with anti-static gloves around LCD edges.

**Incorrect handling:**

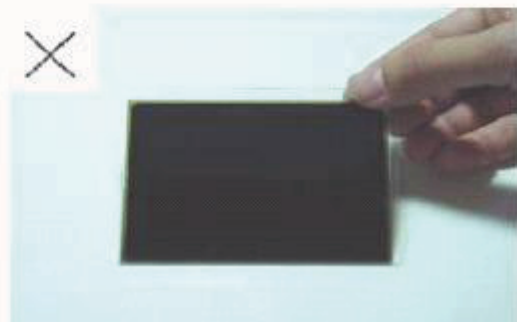
Please don't stack the LCDS.



Please don't hold the surface of LCD.



Please don't operate with sharp stick such as pens.



Please don't touch ITO glass without anti-static gloves.

## Storage Precautions

When storing the LCD modules, the following precaution is necessary.

- (1) Store them in a sealed polyethylene bag. If properly sealed, there is no need for the dessicant.
- (2) Store them in a dark place. Do not expose to sunlight or fluorescent light, keep the temperature between 0°C and 35°C, and keep the relative humidity between 40%RH and 60%RH.
- (3) The polarizer surface should not come in contact with any other objects. (We advise you to store them in the anti-static electricity container in which they were shipped.

### Others

Liquid crystals solidify under low temperature (below the storage temperature range) leading to defective orientation or the generation of air bubbles (black or white). Air bubbles may also be generated if the module is subject to a low temperature.

If the LCD modules have been operating for a long time showing the same display patterns, the display patterns may remain on the screen as ghost images and a slight contrast irregularity may also appear. A normal operating status can be regained by suspending use for some time. It should be noted that this phenomenon does not adversely affect performance reliability.

To minimize the performance degradation of the LCD modules resulting from destruction caused by static electricity etc., exercise care to avoid holding the following sections when handling the modules.

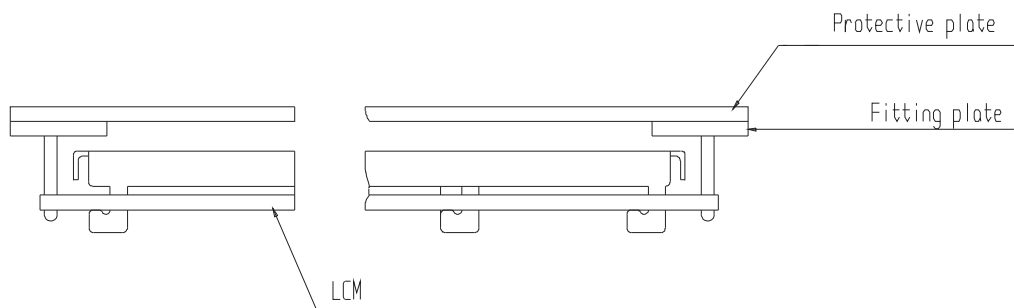
- Exposed area of the printed circuit board.
- Terminal electrode sections.

## USING LCD MODULES

### Installing LCD Modules

The hole in the printed circuit board is used to fix LCM as shown in the picture below. Attend to the following items when installing the LCM.

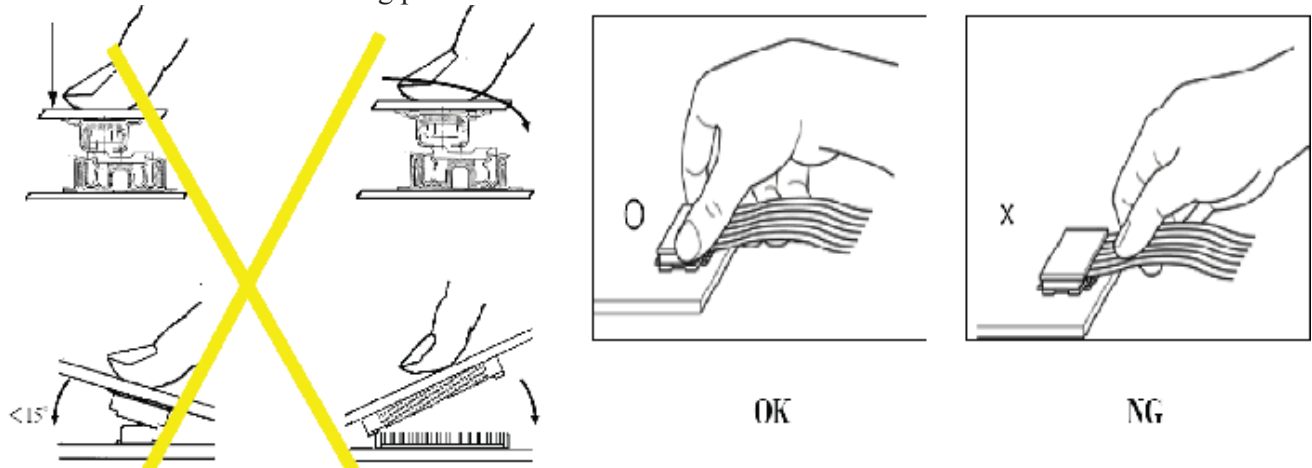
- (1) Cover the surface with a transparent protective plate to protect the polarizer and LC cell.



- (2) When assembling the LCM into other equipment, the spacer to the bit between the LCM and the fitting plate should have enough height to avoid causing stress to the module surface, refer to the individual specifications for measurements. The measurement tolerance should be  $\pm 0.1\text{mm}$ .

### Precaution for assemble the module with BTB connector:

Please note the position of the male and female connector position, don't assemble or assemble like the method which the following picture shows



**Precaution for soldering to the LCM**

	Hand soldering	Machine drag soldering	Machine press soldering
No ROHS product	290°C ~350°C. Time : 3-5S.	330°C ~350°C. Speed : 4-8 mm/s.	300°C ~330°C. Time : 3-6S. Press: 0.8~1.2Mpa
ROHS product	340°C ~370°C. Time : 3-5S.	350°C ~370°C. Time : 4-8 mm/s.	330°C ~360°C. Time : 3-6S. Press: 0.8~1.2Mpa

(1) If soldering flux is used, be sure to remove any remaining flux after finishing to soldering operation. (This does not apply in the case of a non-halogen type of flux.) It is recommended that you protect the LCD surface with a cover during soldering to prevent any damage due to flux spatters.

(2) When soldering the electroluminescent panel and PC board, the panel and board should not be detached more than three times. This maximum number is determined by the temperature and time conditions mentioned above, though there may be some variance depending on the temperature of the soldering iron.

(3) When remove the electroluminescent panel from the PC board, be sure the solder has completely melted, the soldered pad on the PC board could be damaged.

**Precautions for Operation**

(1) Viewing angle varies with the change of liquid crystal driving voltage (VLCD). Adjust VLCD to show the best contrast.

(2) It is an indispensable condition to drive LCD's within the specified voltage limit since the higher voltage then the limit cause 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.

(3) 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 operating temperature.

(4) If the display area is pushed hard during operation, the display will become abnormal. However, it will return to normal if it is turned off and then back on.

(5) A 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.

(6) Input each signal after the positive/negative voltage becomes stable.

(7) Please keep the temperature within specified range for use and storage. Polarization degradation, bubble generation or polarizer peel-off may occur with high temperature and high humidity.

**Safety**

(1) It is recommended to crush damaged or unnecessary LCDs into pieces and wash them off with solvents such as acetone and ethanol, which should later be burned.

(2) If any liquid leaks out of a damaged glass cell and comes in contact with the hands, wash off thoroughly with soap and water.

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- (1) It is recommended to crush damaged or unnecessary LCDs into pieces and wash them off with solvents such as acetone and ethanol, which should later be burned.
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**Limited Warranty**

Unless agreed otherwise between Display Future Ltd and customer, Display Future will replace or repair any of its LCD modules which are found to be functionally defective when inspected in accordance with LCD acceptance standards (copies available upon request) for a period of one year from date of production. Cosmetic/visual defects must be returned within 90 days of the shipment. Confirmation of such date shall be based on data code on the product.

The warranty liability of Display Future limited to repair and/or replacement on the terms set forth above. Display Future will not be responsible for any subsequent or consequential events.

**Return LCM under warranty**

No warranty can be granted if the precautions stated above have been disregarded. The typical examples of violations are :

- Broken LCD glass.
- PCB eyelet is damaged or modified.
- PCB conductors damaged.
- Circuit modified in any way, including addition of components.
- PCB tampered with by grinding, engraving or painting varnish.
- Soldering to or modifying the bezel in any manner.

Module repairs will be invoiced to the customer upon mutual agreement. Modules must be returned with sufficient description of the failures or defects. Any connectors or cable installed by the customer must be removed completely without damaging the PCB eyelet, conductors and terminals.

**■ PRIOR CONSULT MATTER**

- 1.①For Display Future standard products, we keep the right to change material and processes for improving the product, without notice to our customers.  
②For OEM products, if any change is needed, which may affect the product property, we will consult with our customer in advance.
2. If you have special requirement about reliability condition, please let us know before you start the test on our samples.