

## PRODUCT SPECIFICATION

### 20X4 CHARACTERSLCD MODULE MODEL: C2004A1SBX6B-J0 Ver:1.1

<◇> Preliminary Specification

<◆> Finally Specification

|                            |              |
|----------------------------|--------------|
| <b>CUSTOMER'S APPROVAL</b> |              |
| <b>CUSTOMER :</b>          |              |
| <b>SIGNATURE:</b>          | <b>DATE:</b> |
|                            |              |

| APPROVED<br>BY | PM<br>REVIEWED | PD<br>REVIEWED | PREPARED<br>BY |
|----------------|----------------|----------------|----------------|
| <br>2018.1.4   |                |                | 潘远良            |

## Revision Status

| Version  | Revise Date | Page | Content               | Modified By |
|----------|-------------|------|-----------------------|-------------|
| Ver. 1.0 | 2017.10.26  |      | First Issued          |             |
| Ver. 1.1 | 2018.01.02  |      | Improve the backlight |             |
|          |             |      |                       |             |
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## 1. Features

The features of LCD are showed as follows

- \* Display mode : STN/Yellow-Green/Tranflective/Positive
- \* Drive IC : UC17066-03(English/Russian)
- \* Display format : 20\*4Characters
- \* Interface Input Data : 8 Bit or 4Bit MPU
- \* Driving Method : 1/16Duty, 1/4 Bias
- \* Viewing Direction : 6 O'clock
- \* Backlight : LED/ Yellow-Green
- \*Sample NO. : C2004A1SBX6B-J0\_01/20171226

## 2. MECHANICAL SPECIFICATIONS

| Item              | Specification                | Unit |
|-------------------|------------------------------|------|
| Module Size       | 146(W) x62.5(H) x 13.6MAX(T) | mm   |
| View display area | 123.5(W) x43 (H)             | mm   |
| Activity Area     | 118.84 (W) x38.47(H)         | mm   |
| Character Font    | 5x8dots                      | -    |
| Character Size    | 4.84W) x 9.22 (H)            | mm   |
| Character Pitch   | 6.00(W)x9.75(H)              | mm   |
| Dot size          | 0.92(W) x1.10(H)             | mm   |
| Dot Pitch         | 0.98(W) x 1.16(H)            | mm   |

## 3. ELECTRICAL SPECIFICATIONS

### 3-1 ABSOLUTE MAXIMUM RATINGS

| Item                         | Symbol                   | Standard Value |      |              | Unit |
|------------------------------|--------------------------|----------------|------|--------------|------|
|                              |                          | Min.           | Typ. | Max.         |      |
| Supply Voltage For Logic     | $V_{DD} - V_{SS}$        | -0.3           | -    | 7            | V    |
| Supply Voltage For LCD Drive | $V_{LCD} = V_{DD} - V_0$ | $V_{DD}-10$    | -    | $V_{DD}+0.3$ | V    |
| Input Voltage                | $V_{in}$                 | -0.3           | -    | $V_{DD}+0.3$ | V    |
| Operating Temp.              | $T_{op}$                 | -20            | -    | +70          | °C   |
| Storage Temp.                | $T_{st}$                 | -30            | -    | +80          | °C   |

\*. NOTE: The response time will be extremely slow when the operating temperature is around  $-10^{\circ}\text{C}$ , and the background will become darker at high temperature operating.

### 3-2 ELECTRICAL CHARACTERISTICS

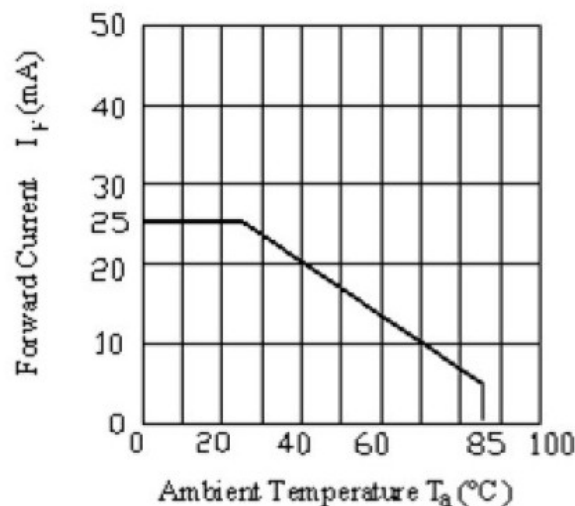
| Item                 |           | Symbol            | Test Condition   | Min.   | Typ. | Max. | Unit |
|----------------------|-----------|-------------------|--|--------|------|------|------|
| Logic supply Voltage |           | $V_{DD} - V_{SS}$ | $T_a = 25\text{ }^\circ\text{C}$<br>$V_{DD}=5V \pm 10\%$ | 4.5    | 5    | 5.5  | V    |
| LCD Drive Voltage    |           | $V_{LCD}$         |  | 4.0    | 4.3  | 4.6  | V    |
| Input Voltage        | "H" Level | $V_{IH}$          |  | 0.7VDD | -    | VDD  | V    |
|                      | "L" Level | $V_{IL}$          |  | -0.3   | -    | 0.55 | V    |
| Frame Frequency      |           | $f_{FLM}$         |  | -      | 84.4 | -    | Hz   |
| Current Consumption  |           | $I_{DD}$          |  | -      | 2.8  | -    | mA   |

### 3-3BACKLIGHT3-3-1. Absolute Maximum Ratings

| Item              | Symbol   | Condition                      | Min. | Typ. | Max.    | Unit |
|-------------------|----------|--------------------------------|------|------|---------|------|
| Forward Current   | $I_{fm}$ | $T_a=25\text{ }^\circ\text{C}$ | -    | -    | 60*2    | mA   |
| Reverse Voltage   | VR       |                                | -    | -    | 5       | V    |
| Power Dissipation | PD       |                                | -    | -    | 103.5*2 | mW   |

### 3-3-2. Electrical-optical Characteristics

| Item   | Symbol      | Condition   | Min. | Typ. | Max. | Unit              |
|--|-------------|---|------|------|------|-------------------|
| Forward Voltage  | VF          | $I_f=90\text{mA}$<br>$T_a=25\text{ }^\circ\text{C}$ | 2.8  | 3.0  | 3.2  | V                 |
| Average Luminous Intensity<br>(measured without LCD panel) | $I_v$       |   | 400  | 600  | -    | cd/m <sup>2</sup> |
| Peak wave length   | $\lambda P$ |   | 569  | 572  | 575  | nm                |



The brightness is measured without LCD panel

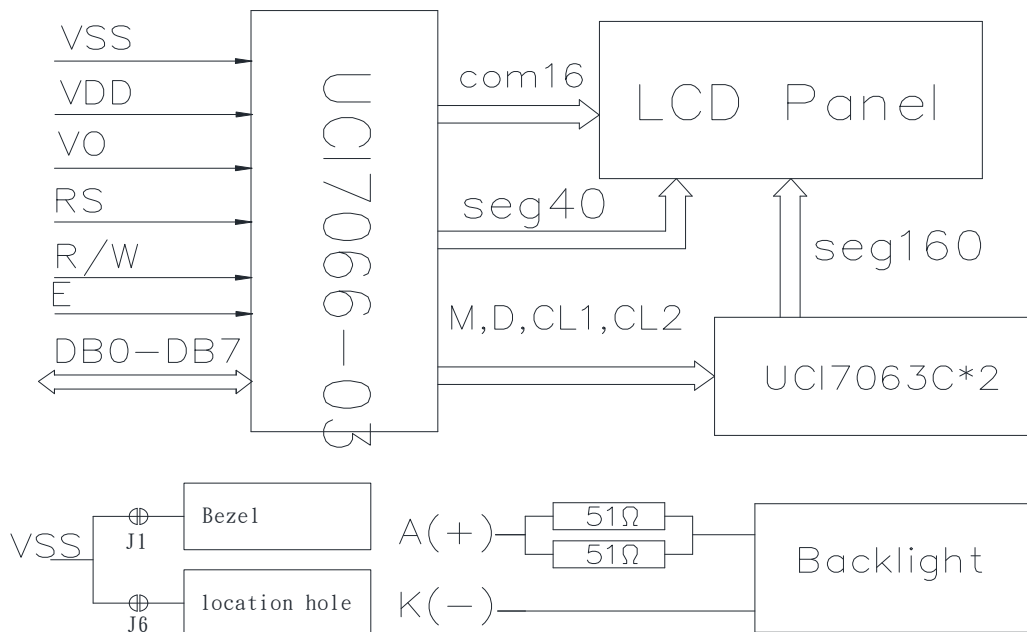
For operation above 25 °C, The  $I_{fm}$  &  $P_d$  must be derated, the current derating is  $-0.36 \times 3\text{mA}/^\circ\text{C}$  for DC drive and  $-0.86 \times 3\text{mA}/^\circ\text{C}$  for Pulse drive, the Power dissipation is  $-0.75 \times 3\text{mW}/^\circ\text{C}$ . The product working current must not more than the 60% of the  $I_{fm}$  or  $I_{fp}$  according to the working temperature.

## 4. TERMINAL FUNCTIONS AND BLOCK DIAGRAM

### 4-1 INTERFACE PIN FUNCTION DESCRIPTION

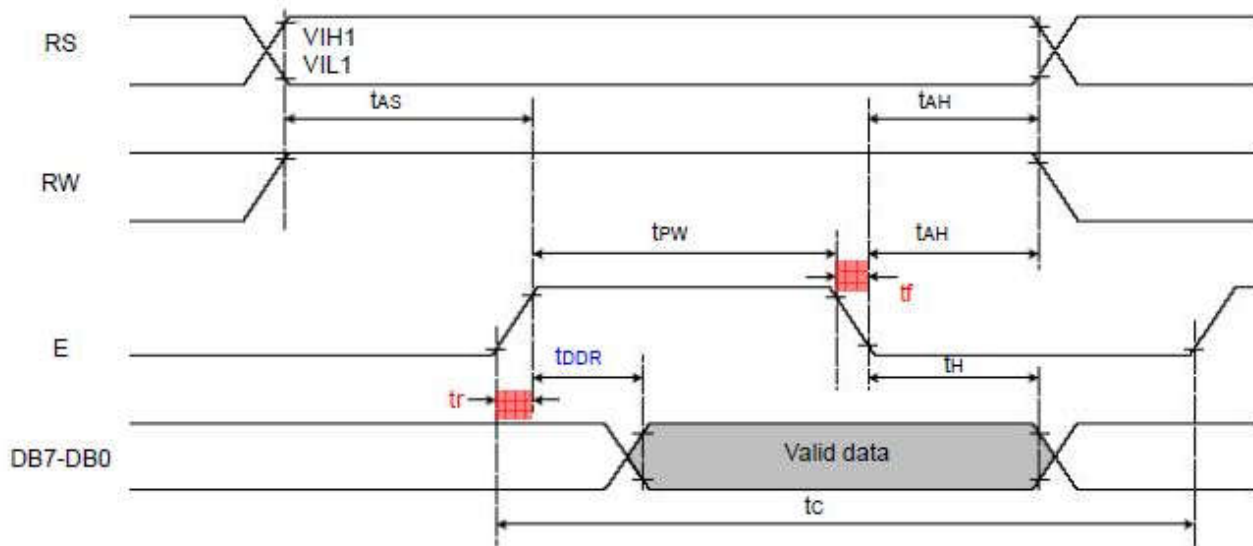
| PIN NO. | SYMBOL  | FUNCIONS  |
|---------|---------|---|
| 1       | VSS     | Ground  |
| 2       | VDD     | Supply voltage for logical circuit  |
| 3       | VO      | Supply voltage for LCD driving  |
| 4       | RS      | A signal for selecting registers.<br>1: Data Register (for read and write)<br>0: Instruction Register (for write) |
| 5       | R/W     | A signal for selecting read or write actions.1: Read, 0: Write.   |
| 6       | E       | A enable signal for reading or writing data.  |
| 7-14    | DB0~DB7 | 8 Bit Data Bus  |
| 15      | A       | Backlight (+5.0V)   |
| 16      | K       | Backlight (-)   |
| 17      | NC      | No connect  |
| 18      | NC      | No connect  |

### 4-2 BLOCK DIAGRAM

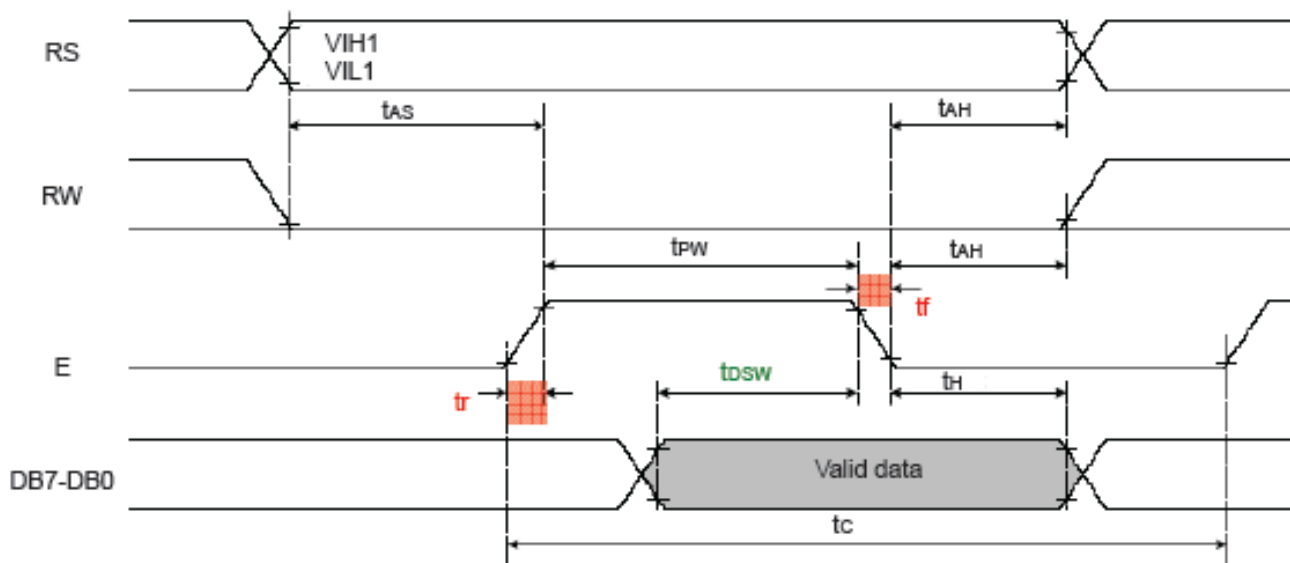


## 5. TIMING CHARACTERISTICS

### 5-1 Reading data from UCI7066U to MPU

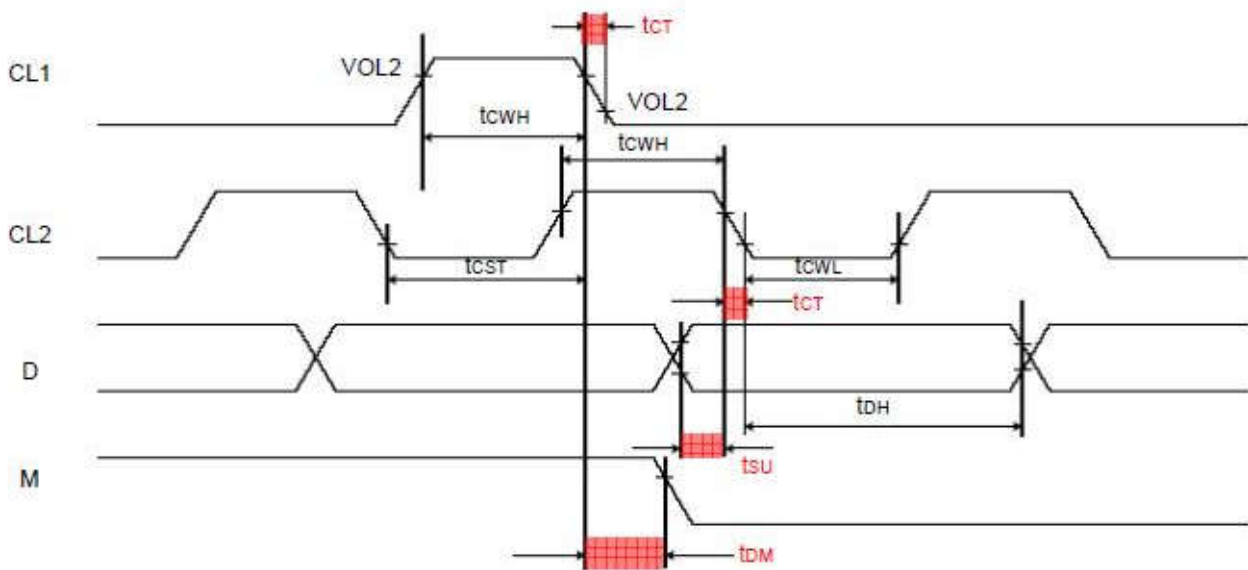


### 5-2 Writing data from MPU to UCI7066U

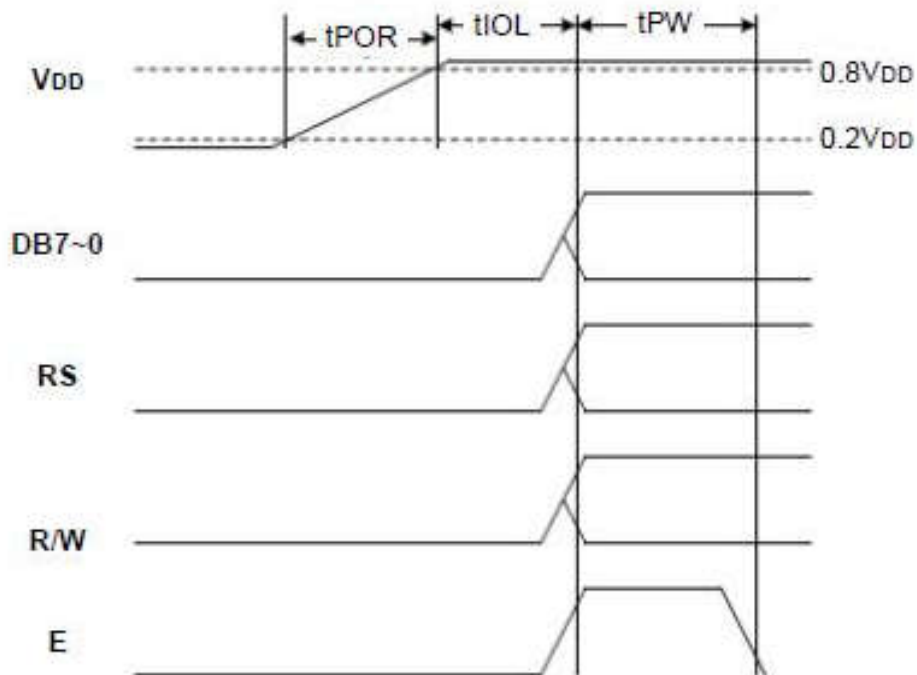


(6800 Write data to UCi7066c)

### 5-3 With External Driver



### 5-4 Power Supply Conditions



| Symbol    | Characteristics    | Description  | Min | Typ. | Max. | Unit |
|-----------|--------------------|--|-----|------|------|------|
| $t_{POR}$ | Power Rise time    | Power rise time that will trigger internal POR circuit | 0.1 |      | 100  | mS   |
| $t_{IOL}$ | I/O Low time       | The period that I/O is kept LOW                        | 40  |      |      | mS   |
| $t_{PW}$  | Enable Pulse width | Please refer to the following tables                   |     |      |      |      |



## 5-5 Parameter

TA = 25°C, Vcc=4.5V~5V

| Symbol  | Characteristic          | Test Condition | Min. | Typ. | Max. | Unit |
|---|-------------------------|----------------|------|------|------|------|
| <b>Internal Clock Operation</b>                 |                         |                |      |      |      |      |
| fosc  | OSC Frequency           | R=91KΩ         | 190  | 270  | 350  | KHz  |
| <b>External Clock Operation</b>                 |                         |                |      |      |      |      |
| fEX   | External Frequency      | --             | 125  | 270  | 410  | KHz  |
|   | Duty Cycle              | --             | 45   | 50   | 55   | %    |
| tr, tf  | Rising/Falling Time     | --             | --   | --   | 0.2  | μs   |
| <b>Write Mode (MPU writes data to UCi7066)</b>  |                         |                |      |      |      |      |
| tc  | Enable Cycle Time       | Pin E          | 1200 | --   | --   | nS   |
| tpw   | Enable Pulse Width      | Pin E          | 140  | --   | --   | nS   |
| tr, tf  | Rising/Falling Time     | Pin E          | --   | --   | 25   | nS   |
| tAS   | Address Setup Time      | Pin: RS, RW, E | 0    | --   | --   | nS   |
| tAH   | Address Hold Time       | Pin: RS, RW, E | 10   | --   | --   | nS   |
| tDSW  | Data Setup Time         | Pin: DB7~DB0   | 40   | --   | --   | nS   |
| tH  | Data Hold Time          | Pin: DB7~DB0   | 10   | --   | --   | nS   |
| <b>Read Mode (MPU reads data from UCi7066)</b>  |                         |                |      |      |      |      |
| tc  | Enable Cycle Time       | Pin E          | 1200 | --   | --   | nS   |
| tpw   | Enable Pulse Width      | Pin E          | 140  | --   | --   | nS   |
| tr, tf  | Rising/Falling Time     | Pin E          | --   | --   | 25   | nS   |
| tAS   | Address Setup Time      | Pin: RS, RW, E | 0    | --   | --   | nS   |
| tAH   | Address Hold Time       | Pin: RS, RW, E | 10   | --   | --   | nS   |
| tDDR  | Data Setup Time         | Pin: DB7~DB0   | --   | --   | 100  | nS   |
| tH  | Data Hold Time          | Pin: DB7~DB0   | 10   | --   | --   | nS   |
| <b>Interface Mode with LCD Driver (UCi7065)</b> |                         |                |      |      |      |      |
| tcWH  | Clock Pulse Width, High | Pin: CL1, CL2  | 800  | --   | --   | nS   |
| tcWL  | Clock Pulse Width, Low  | Pin: CL1, CL2  | 800  | --   | --   | nS   |
| tcST  | Clock Setup Time        | Pin: CL1, CL2  | 500  | --   | --   | nS   |
| tsu   | Data Setup Time         | Pin: D         | 300  | --   | --   | nS   |
| tOH   | Data Hold Time          | Pin: D         | 300  | --   | --   | nS   |
| tDM   | M Delay Time            | Pin: M         | 0    | --   | 2000 | nS   |

## 6.COMMAND LIST

The following is a list of host commands supported by UCi7066

**R/S**: 0: Control, 1: Data      **W/R**: 0: Write Cycle, 1: Read Cycle      **D7-D0**: -: Don't Care

| #                     | Command                    | RS | R/W | D7 | D6   | D5   | D4   | D3   | D2   | D1   | D0   | Action   |
|-----------------------|----------------------------|----|-----|----|------|------|------|------|------|------|------|--|
| 1                     | Clear Display              | 0  | 0   | 0  | 0    | 0    | 0    | 0    | 0    | 0    | 1    | Clear the screen   |
| 2                     | Return Home                | 0  | 0   | 0  | 0    | 0    | 0    | 0    | 0    | 1    | -    | Move cursor to HOME  |
| 3                     | Set Entry Mode             | 0  | 0   | 0  | 0    | 0    | 0    | 0    | 1    | I/D  | S    | I/D: Left / Right<br>S: Shift OFF/ON                           |
| 4                     | Display ON/OFF             | 0  | 0   | 0  | 0    | 0    | 0    | 1    | D    | C    | B    | D: Display OFF / ON<br>C: Cursor OFF / ON<br>B: Blink OFF / ON |
| 5                     | Cursor or Display Shift    | 0  | 0   | 0  | 0    | 0    | 1    | S/C  | R/L  | -    | -    | S/C: Screen / Cursor<br>R/L Right / Left                       |
| 6                     | Set Function               | 0  | 0   | 0  | 0    | 1    | DL   | N    | F    | -    | -    | DL: 4-bit / 8-bit,<br>N: 1-line / 2-line<br>F: 5x8 / 5x11      |
| 7                     | Set CGRAM address          | 0  | 0   | 0  | 1    | AC5  | AC4  | AC3  | AC2  | AC1  | AC0  |  |
| 8                     | Set DDRAM address          | 0  | 0   | 1  | AC12 | AC11 | AC10 | AC9  | AC8  | AC7  | AC6  |  |
| 9                     | Read Busy Flag and address | 0  | 1   | BF | AC19 | AC18 | AC17 | AC16 | AC15 | AC14 | AC13 |  |
| 10                    | Write data to RAM          | 1  | 0   | D7 | D6   | D5   | D4   | D3   | D2   | D1   | D0   | Write data to RAM  |
| 11                    | Read data from RAM         | 1  | 1   | D7 | D6   | D5   | D4   | D3   | D2   | D1   | D0   | Read data from RAM   |
| <b>For S8/S9 Mode</b> |                            |    |     |    |      |      |      |      |      |      |      |  |
| 12                    | Status Read                | 1  | 1   | 0  | 0    | 0    | 0    | 0    | 0    | 0    | 0    | Read status  |
|                       |                            | 0  | 1   | BF | AC19 | AC18 | AC17 | AC16 | AC15 | AC14 | AC13 |  |

### Note:

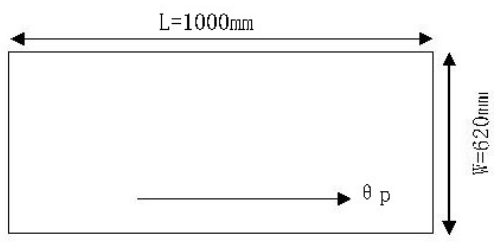
Ensure that UCi7066 is not in the BUSY state (BF = 0) before sending an instruction from the MPU to the UCi7066. If an instruction is sent without checking the busy flag, the time between the first instruction and next instruction will take much longer than the instruction time itself.

# 7. CHARACTER GENERATOR ROM

No. 7066-03

| Upper<br>4 bits<br>Lower<br>4 bits | 0000 | 0001 | 0010 | 0011 | 0100 | 0101 | 0110 | 0111 | 1000 | 1001 | 1010 | 1011 | 1100 | 1101 | 1110 | 1111 |
|------------------------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| 0000                               | ☐    | ☐    | ☐    | 0    | 1    | 2    | 3    | 4    | 5    | 6    | 7    | 8    | 9    | ☐    | ☐    | ☐    |
| 0001                               | ☐    | ☐    | !    | 1    | 2    | 3    | 4    | 5    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 0010                               | ☐    | ☐    | "    | 2    | 3    | 4    | 5    | 6    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 0011                               | ☐    | ☐    | #    | 3    | 4    | 5    | 6    | 7    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 0100                               | ☐    | ☐    | *    | 4    | 5    | 6    | 7    | 8    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 0101                               | ☐    | ☐    | %    | 5    | 6    | 7    | 8    | 9    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 0110                               | ☐    | ☐    | &    | 6    | 7    | 8    | 9    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 0111                               | ☐    | ☐    | '    | 7    | 8    | 9    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1000                               | ☐    | ☐    | (    | 8    | 9    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1001                               | ☐    | ☐    | )    | 9    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1010                               | ☐    | ☐    | *    | :    | ;    | ;    | ;    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1011                               | ☐    | ☐    | +    | ;    | ;    | ;    | ;    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1100                               | ☐    | ☐    | ,    | <    | ;    | ;    | ;    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1101                               | ☐    | ☐    | -    | =    | ;    | ;    | ;    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1110                               | ☐    | ☐    | .    | >    | ;    | ;    | ;    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |
| 1111                               | ☐    | ☐    | /    | ?    | ;    | ;    | ;    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    | ☐    |

## 8. Polaroid

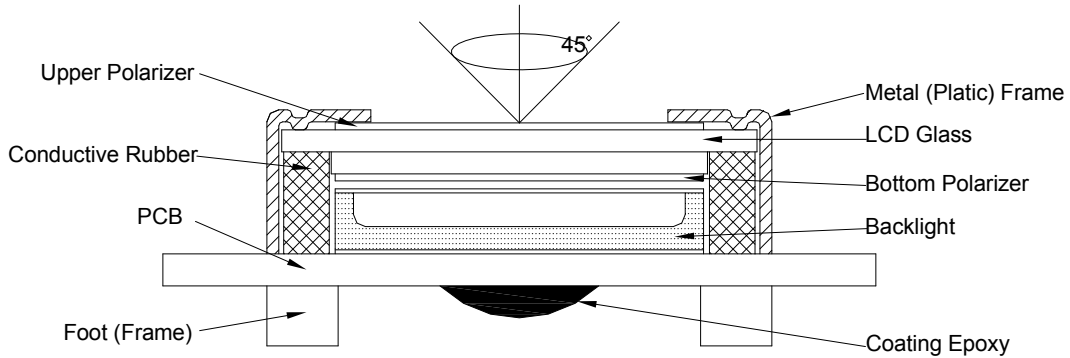
| Part no   |                 | HN1822MA  |  |
|-----------|-----------------|---|--|
| structure |                 | size  |  |
| 1         | Release film    |  <p style="text-align: center;">*release film upwards; <math>\theta_p</math>=<br/>Polaroid absorb the shaft</p> |  |
| 2         | Sticker         |   |  |
| 3         | TAC             |   |  |
| 4         | PVA             |   |  |
| 5         | TAC             |   |  |
| 6         | Sticker         |   |  |
| 7         | Reflective Film |   |  |

| item                                   |   | unit    | spec value | notes                   |
|--|---|---------|------------|-------------------------|
| size                                   | length  | mm      | 1000(±10)  |                         |
|  | width   | mm      | 620(±10)   |                         |
| thickness                              | effective thickness   | μm      | 280±10%    |                         |
|  | Release film  | μm      | 38±10%     |                         |
| Strip Force                            | To glasses  | gf/25mm | Above 500g |                         |
|  | Release film  | gf/25mm | Under 20g  |                         |
| Transmittance                          | Monomer transmittance   | %       | 42.0±1.5   | The original panel data |
|  | Rectangular transmittance   | %       | ≤2.0       | The original panel data |
|  | 380nm transmittance   | %       | ≤1.0       |                         |
| Angle                                  | Cutting Angle   | °       | 90±1.0     |                         |
|  | Absorption of shaft Angle   | °       | ±2.0       |                         |
| BENDING                                |   | mm      | ≤±50       |                         |
| Hue                                    | L   | NBS     | 65.0±2.0   | The original panel data |
|  | a   | NBS     | -1.97±2.0  | The original panel data |
|  | b   | NBS     | 2.98±2.0   | The original panel data |
| degree of polarization                 |   | %       | ≥99.0      | The original panel data |
| apparent defect (above Diameter 150μm) |   |         | ≤13/pcs    |                         |
| 80℃*500Hr                              | (post-testing)Transmittance≥99.0%   |         |            |                         |
| 60℃*90%RH*500Hr                        | Monomer transmittance change value≤3.0%                                       |         |            |                         |
|  | Hue change value≤3.0<br>No separation, no foam, stripping (within edge 0.5mm) |         |            |                         |

## 9. QUALITY SPECIFICATIONS

### 9-1. LCM Appearance and Electric inspection Condition

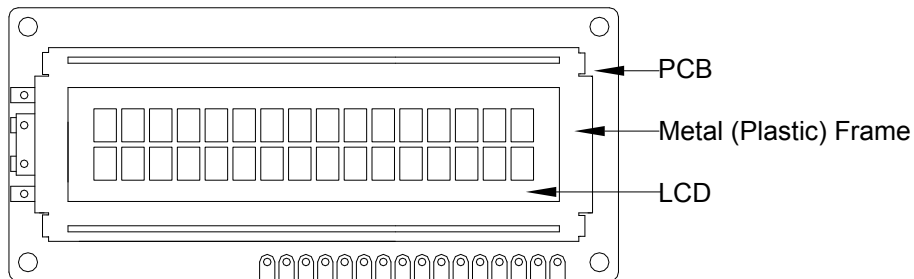
1. Inspection will be done by placing LCM 30cm away from inspector's eyeballs under normal illumination.



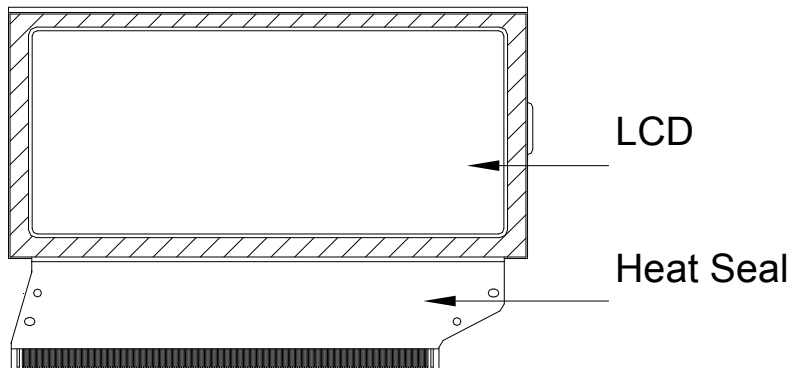
2. View Angle: with in 45° around perpendicular line.

### 9-2. Definition

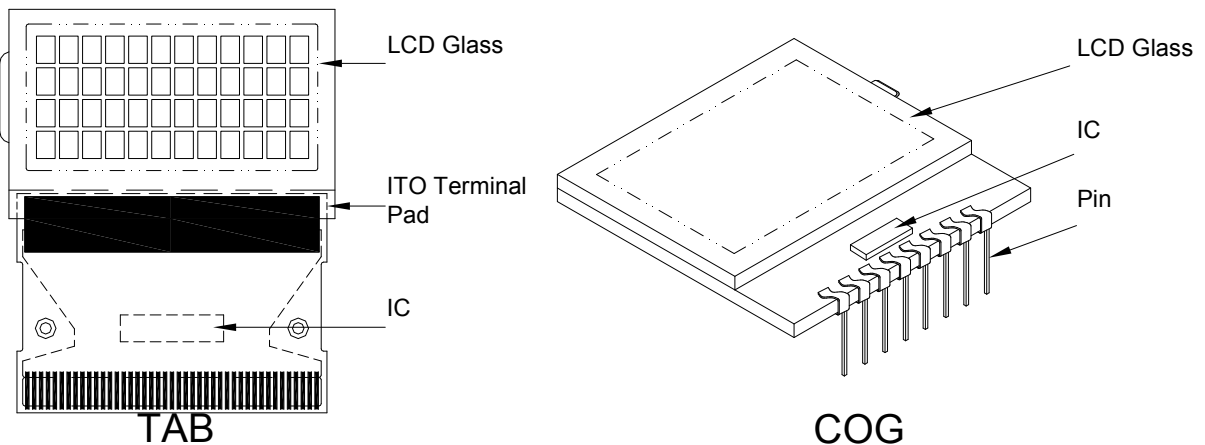
#### 1. COB



#### 2. Heat Seal



#### 3. TAB and COG



### 9-3. Sampling Plan and Acceptance

#### 1. Sampling Plan

MIL - STD - 105E ( || ) ordinary single inspection is used.

#### 2. Acceptance

Major defect: AQL = 0.65%

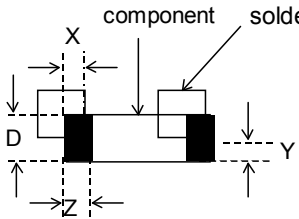
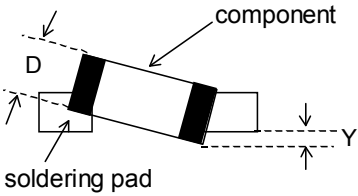
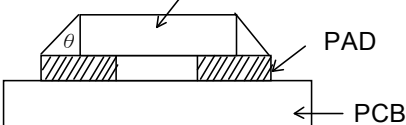
Minor defect: AQL = 1.5%

### 9-4. Criteria

#### 1. COB

| Defect | Inspection Item               | Inspection Standards   |        |
|--------|-------------------------------|--|--------|
| Major  | PCB copper flakes peeling off | Any copper flake in viewing Area should be greater than 1.0mm <sup>2</sup> | Reject |
| Major  | Height of coating epoxy       | Exceed the dimension of drawing  | Reject |
| Major  | Void or hole of coating epoxy | Expose bonding wire or IC  | Reject |
| Major  | PCB cutting defect            | Exceed the dimension of drawing  | Reject |

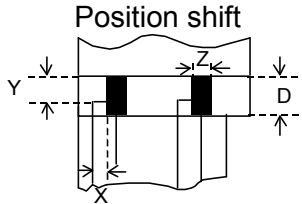
#### 2. SMT

| Defect | Inspection Item   | Inspection Standards            |                  |
|--------|---|---------------------------------|------------------|
| Minor  | Component marking not readable  |                                 | Reject           |
| Minor  | Component height  | Exceed the dimension Of drawing | Reject           |
| Major  | Component solder defect (missing , extra, wrong component or wrong orientation)                                 |                                 | Reject           |
| Minor  | Component position shift<br> | $X < 3/4Z$<br>$Y > 1/3D$        | Reject<br>Reject |
| Minor  | Component tilt<br>           | $Y > 1/3D$                      | Reject           |
| Minor  | Insufficient solder<br>      | $\theta \leq 20^\circ$          | Reject           |

### 3. Metal (Plastic) Frame

| Defect   | Inspection Item                                | Inspection Standards            |                       |                              |
|--|--|---------------------------------|-----------------------|------------------------------|
| Major  | Crack / breakage                               | Anywhere                        |                       |                              |
|  |  | Reject                          |                       |                              |
| Minor  | Frame Scratch                                  | W                               | L                     | Acceptable of Scratch        |
|  |  | $w < 0.1\text{mm}$              | Any                   | Ignore                       |
|  |  | $0.1 \leq w < 0.2\text{mm}$     | $L \leq 5.0\text{mm}$ | 2                            |
|  |  | $0.2 \leq w < 0.3\text{mm}$     | $L \leq 3.0\text{mm}$ | 1                            |
|  |  | $w \geq 0.3\text{mm}$           | Any                   | 0                            |
| Note : 1. Above criteria applicable to scratch lines with distance greater than 5mm.<br>2. Scratch on the back side of frame (not visible) can be ignored .            |  |                                 |                       |                              |
| Minor  | Frame Dent , Prick<br>$\Phi = \frac{L + W}{2}$ |                                 |                       | Acceptable of Dents / Pricks |
|  |  | $\Phi \leq 1.0\text{mm}$        |                       | 2                            |
|  |  | $1.0 < \Phi \leq 1.5\text{mm}$  |                       | 1                            |
|  |  | $1.5\text{mm} < \Phi$           |                       | 0                            |
| Note : 1. Above criteria applicable to any two dents / pricks with distance greater than 5mm<br>2. Dent / prick on the back side of frame (not visible) can be ignored |  |                                 |                       |                              |
| Minor  | Frame Deformation                              | Exceed the dimension of drawing |                       |                              |
| Minor  | Metal Frame Oxidation                          | Any rust                        |                       |                              |

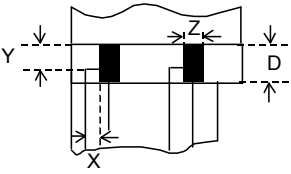
### 4. Flexible Film Connector (FFC)

| Defect | Inspection Item   | Inspection Standards        |            |
|--------|---|-----------------------------|------------|
| Minor  | Tilted soldering  | Within the angle $+5^\circ$ | Acceptable |
| Minor  | Uneven solder joint /bump   |                             | Reject     |
| Minor  | Hole<br>$\Phi = \frac{L + W}{2}$  | Expose the conductive line  | Reject     |
|        |   | $\Phi > 1.0\text{mm}$       | Reject     |
| Minor  |  <p>Position shift</p> | $Y > 1/3D$                  | Reject     |
|        |   | $X > 1/2Z$                  | Reject     |

### 5. Screw

| Defect | Inspection Item      | Inspection Standards             |        |
|--------|----------------------|----------------------------------|--------|
| Major  | Screw missing/loosen |                                  | Reject |
| Minor  | Screw oxidation      | Any rust                         | Reject |
| Minor  | Screw deformation    | Difficult to accept screw driver | Reject |

### 6. Heatseal、TCP、FPC

| Defect | Inspection Item   | Inspection Standards        |        |
|--------|---|-----------------------------|--------|
| Major  | Scratch expose conductive layer   |                             | Reject |
| Minor  | HS Hole $\Phi = \frac{L+W}{2}$  | $\Phi > 0.5\text{mm}$       | Reject |
| Major  | Adhesion strength   | Less than the specification | Reject |
| Minor  | Position shift<br> | $Y > 1/3D$                  | Reject |
|        |   | $X > 1/2Z$                  | Reject |
| Major  | Conductive line break   |                             | Reject |

### 7. LED Backing Protective Film and Others

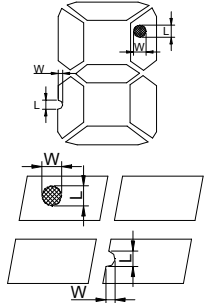
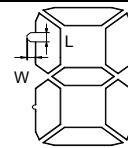
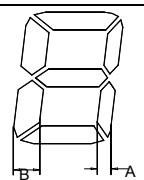
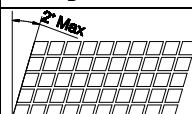
| Defect | Inspection Item      | Inspection Standards  |        |
|--------|----------------------|---|--------|
| Minor  | LED dirty, prick     | Acceptable number of units  |        |
|        |                      | $\Phi \leq 0.10\text{mm}$   | Ignore |
|        |                      | $0.10 < \Phi \leq 0.15\text{mm}$  | 2      |
|        |                      | $0.15 < \Phi \leq 0.2\text{mm}$   | 1      |
|        |                      | $\Phi > 0.2\text{mm}$   | 0      |
|        |                      | The distance between any two spots should be $\geq 5\text{mm}$<br>Any spot/dot/void outside of viewing area is acceptable |        |
| Minor  | Protective film tilt | Not fully cover LCD   | Reject |
| Major  | COG coating          | Not fully cover ITO circuit   | Reject |

### 8. Electric Inspection

| Defect | Inspection Item | Inspection Standards |        |
|--------|-----------------|----------------------|--------|
| Major  | Short           |                      | Reject |
| Major  | Open            |                      | Reject |



### 9. Inspection Specification of LCD

| Defect | Inspect Item   | Inspection Standards  |  |                                  |                                  |               |
|--------|--|---|--|----------------------------------|----------------------------------|---------------|
|        |  | W   | $W \leq 0.03$  | $0.03 < W \leq 0.05$             | $W > 0.05$                       |               |
| Minor  | Linear Defect<br>* Glass Scratch<br>* Polarizer Scratch<br>* Fiber and Linear material   | L   | $L < 5$  | $L < 3$                          | Any                              |               |
|        |  | ACC. NO.  | 1  | 1                                | Reject                           |               |
|        |  | Note  | L is the length and W is the width of the defect                                     |                                  |                                  |               |
|        |  |   |  |                                  |                                  |               |
| Minor  | Black Spot and Polarizer Pricked<br>* Foreign material between glass and polarizer or glass and glass<br>* Polarizer hole or protuberance by external force  | $\Phi$  | $\Phi \leq 0.1$  | $0.1 < \Phi \leq 0.15$           | $0.15 < \Phi \leq 0.2$           | $\Phi > 0.2$  |
|        |  | ACC. NO.  | 3EA / 100mm <sup>2</sup>   | 2                                | 1                                | 0             |
|        |  | Note  | $\Phi$ is the average diameter of the defect.<br>Distance between two defects >10mm. |                                  |                                  |               |
|        |  |   |  |                                  |                                  |               |
| Minor  | White Spot and Bubble in polarizer<br>* Unobvious transparent foreign material between glass and glass or glass and polarizer<br>* Air protuberance between polarizer and glass                      | $\Phi$  | $\Phi \leq 0.3$  | $0.3 < \Phi \leq 0.5$            | $0.5 < \Phi$                     |               |
|        |  | ACC. NO.  | 3EA / 100mm <sup>2</sup>   | 1                                | 0                                |               |
|        |  | Note  | $\Phi$ is the average diameter of the defect.<br>Distance between two defects >10mm. |                                  |                                  |               |
|        |  |   |  |                                  |                                  |               |
| Minor  | Segment Defect<br>   | $\Phi$  | $\Phi \leq 0.10$   | $0.10 < \Phi \leq 0.20$          | $0.20 < \Phi \leq 0.25$          | $\Phi > 0.25$ |
|        |  | ACC. NO.  | 3EA / 100mm <sup>2</sup>   | 2                                | 1                                | 0             |
|        |  | Note  | W is more than 1/2 segment width   |                                  |                                  | Reject        |
|        |  |   | $\Phi = \frac{L + W}{2}$<br>Distance between two defect is 10mm                      |                                  |                                  |               |
| Minor  | Protuberant Segment<br><br>$\Phi = (L + W) / 2$   | $\Phi$  | $\Phi \leq 0.10$   | $0.10 < \Phi \leq 0.20$          | $0.20 < \Phi \leq 0.25$          | $\Phi > 0.25$ |
|        |  | W   | Glue   | $W \leq 1/2$ Seg<br>$W \leq 0.2$ | $W \leq 1/2$ Seg<br>$W \leq 0.2$ | Ignore        |
|        |  | ACC. NO.  | 3EA / 100mm <sup>2</sup>   | 2                                | 1                                | 0             |
|        |  |   |  |                                  |                                  |               |
| Minor  | Assembly Mis-alignment<br><br> | 1. Segment  |  |                                  |                                  |               |
|        |  | B   | $B \leq 0.4\text{mm}$  | $0.4 < B \leq 1.0\text{mm}$      | $B > 1.0\text{mm}$               |               |
|        |  | B-A   | $B-A < 1/2B$   | $B-A < 0.2$                      | $B-A < 0.25$                     |               |
|        |  | Judge   | Acceptable   | Acceptable                       | Acceptable                       |               |
|        |  | 2. Dot Matrix   |  |                                  |                                  |               |
|        |  |   | Deformation > 2°   |                                  |                                  | Reject        |
| Minor  | Stain on LCD Panel Surface   | Accept when stains can be wiped lightly with a soft cloth or a similar one. Otherwise, judged according to the above items: "Black spot" and "White Spot" |  |                                  |                                  |               |

## 10. RELIABILITY

| No | Item                        | Condition   | Quantity | Criteria         |
|----|-----------------------------|---|----------|------------------|
| 1  | High Temperature Operating  | 70°C, 96Hrs   | 2        | GB/T2423.2-2008  |
| 2  | Low Temperature Operating   | -20°C, 96Hrs  | 2        | GB/T2423.1-2008  |
| 3  | High Humidity               | 60°C, 90%RH, 96Hrs  | 2        | GB/T2423.3-2006  |
| 4  | High Temperature Storage    | 80°C, 96Hrs   | 2        | GB/T2423.2-2008  |
| 5  | Low Temperature Storage     | -30°C, 96Hrs  | 2        | GB/T2423.1-2008  |
| 6  | Thermal Cycling Test        | -20°C, 60min~70°C, 60min, 20 cycles.  | 2        | GB/T2423.22-2012 |
| 7  | Packing vibration           | Frequency range:10Hz~50Hz<br>Acceleration of gravity:5G<br>X,Y,Z 30 min for each direction. | 2        | GB/T5170.14-2009 |
| 8  | Electrical Static Discharge | Air: ±8KV 150pF/330 Ω 5 times   | 2        | GB/T17626.2-2006 |
|    |                             | Contact: ±4KV 150pF/330 Ω 5 times   |          |                  |
| 9  | Drop Test (Packaged)        | Height:80 cm,1 corner, 3 edges, 6 surfaces.   | 2        | GB/T2423.8-1995  |

Note:1) Above conditions are suitable for our company standard products.

2) For restrict products, the test conditions listed as above must be revised.

## 11. HANDLING PRECAUTION

### (1) Mounting Method

The panel of the LCD Module consists of two thin glass plates with polarizers which easily get damaged since the Module is fixed by utilizing fitting holes in the printed circuit board. Extreme care should be taken when handling the LCD Modules.

### (2) Caution of LCD handling & cleaning

When cleaning the display surface, use soft cloth with solvent (recommended below) and wipe lightly.

- Isopropyl alcohol
- Ethyl alcohol
- Trichlorotrifluoro ethane

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

Do not use the following solvent:

- Water
- Ketone
- Aromatics

### (3) Caution against static charge

The LCD Module use C-MOS LSI drivers, so we recommend that you connect any unused input terminal to VDD or VSS, do not input any signals before power is turned on. Ground your body, Work/assembly table. And assembly equipment to protect against static electricity.

### (4) Packaging

- Modules use 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 directly to sunshine or high temperature/humidity.

### (5) Caution for operation

- It is indispensable to drive LCD's within the specified voltage limit since the higher voltage than the limit shorten LCD life. An electrochemical reaction due to direct current causes LCD deterioration, Avoid the use of direct current drive.
- 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 range.
- If the display area is pushed hard during operation, some font will be abnormally displayed but it resumes normal condition after turning off once.
- A slight dew depositing on terminals is a cause for electro-chemical reaction resulting in terminal open circuit.

Usage under the relative condition of 40°C, 50%RH or less is required.

### (6) Storage

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 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 is. Keeping temperature in the specified storage temperature range.
- Storing with no touch on polarizer surface by anything else. (It is recommended to store them as they have been contained in the inner container at the time of delivery)

### (7) Safety

- It is recommendable to crash damaged or unnecessary LCD into pieces and wash off liquid crystal by using solvents such as acetone and ethanol. Which should be burned up later.

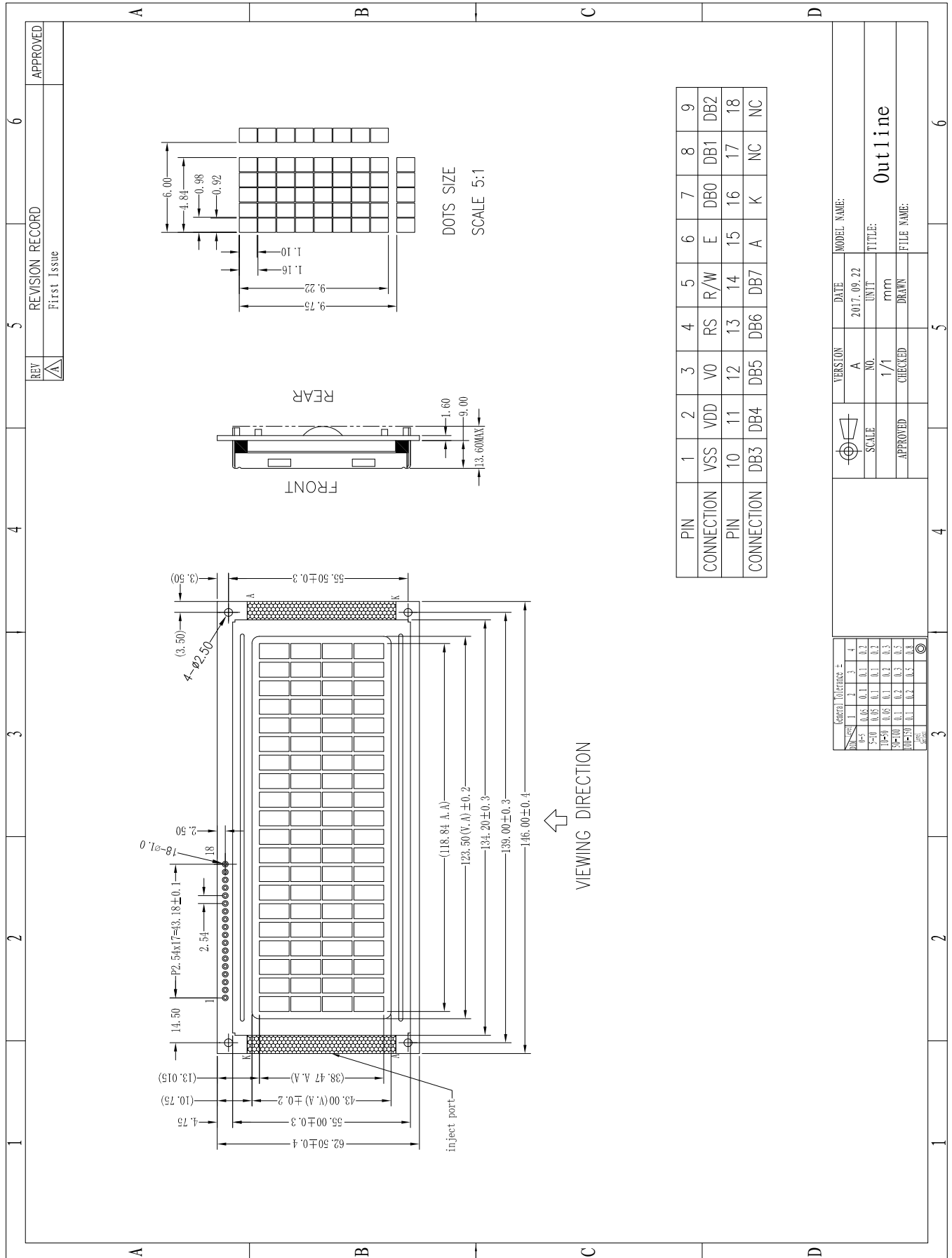
When any liquid crystal leaked out of a damaged glass cell comes in contact with your hands, please wash it off well with soap and water.

### (8) Other

- After the product shipped, any product quality issues must be feedback within three months, otherwise, we will not be responsible for the subsequent or consequential events.

# 12. OUTLINE DIMENSION

NOTE : The dimension with" ( ) " is reference



|                 |            |             |
|-----------------|------------|-------------|
| REVISION RECORD | DATE       | MODEL NAME: |
| REV: A          | 2017.09.22 |             |
| First Issue     | UNIT       | TITLE:      |
|                 | mm         | Outline     |
|                 | CHECKED    | FILE NAME:  |
|                 | DRAWN      |             |