ORIENT DISPLAY

Your Total LCD Solution Provider

http://www.orientdisplay.com

SPECIFICATION
FOR
LCD MODULE

MODULE NO: AFS240320TG-2.8-S000001
REVISION NO: 00

Customer's Approval:

	SIGNATURE	DATE
PREPARED BY (RD ENGINEER)	LHM	JUN-20-2011
CHECKED BY	Fr LI	JUN-20-2011
APPROVED BY	SEAN	JUN-20-2011

Orient Display (N.A.) Ltd.
145 Royal Crest Court Unit 42, Markham, ON, Canada L3R 9Z4
Tel: 905-477-1166 Fax: 905-477-1782

Orient Display (USA) Corp.
1315 NW Mall St. Suite 5, Issaquah, WA, USA 98027
Tel: 425-392-6880 Fax: 425-557-6560

DOCUMENT REVISION HISTORY

Version	DATE	DESCRIPTION	CHANGED BY
00	Jun-20-2011	First Issue	Lhm

CONTENTS

1. Features & Mechanical Specifications

Item	Contents	Unit
	LCD	
LCD Type	TFT / Transmissive / Normally White	--
Viewing direction	12 O'clock	--
Backlight	4 Chip White LED in parallel	--
Interface	8080-16bit parallel bus interface	--
Driver IC	HX8347-G	--
Outline Dimension	50.0(W) × 69.2(H) × 2.8(T)	mm
Glass area (W×H×T)	46.2 ×60.6 / 63.88 × 0.5	mm
Active area (W×H)	43.2 × 57.6	mm
Number of Dots	240(RGB) × 320	--
Dot pitch (W×H)	0.06 × 0.18	mm
Pixel pitch (W×H)	0.18 × 0.18	mm
Operating Temperature	-20 ～ +70	℃
Storage temperature	-30 ～ +80	℃

2. Dimensional Outline

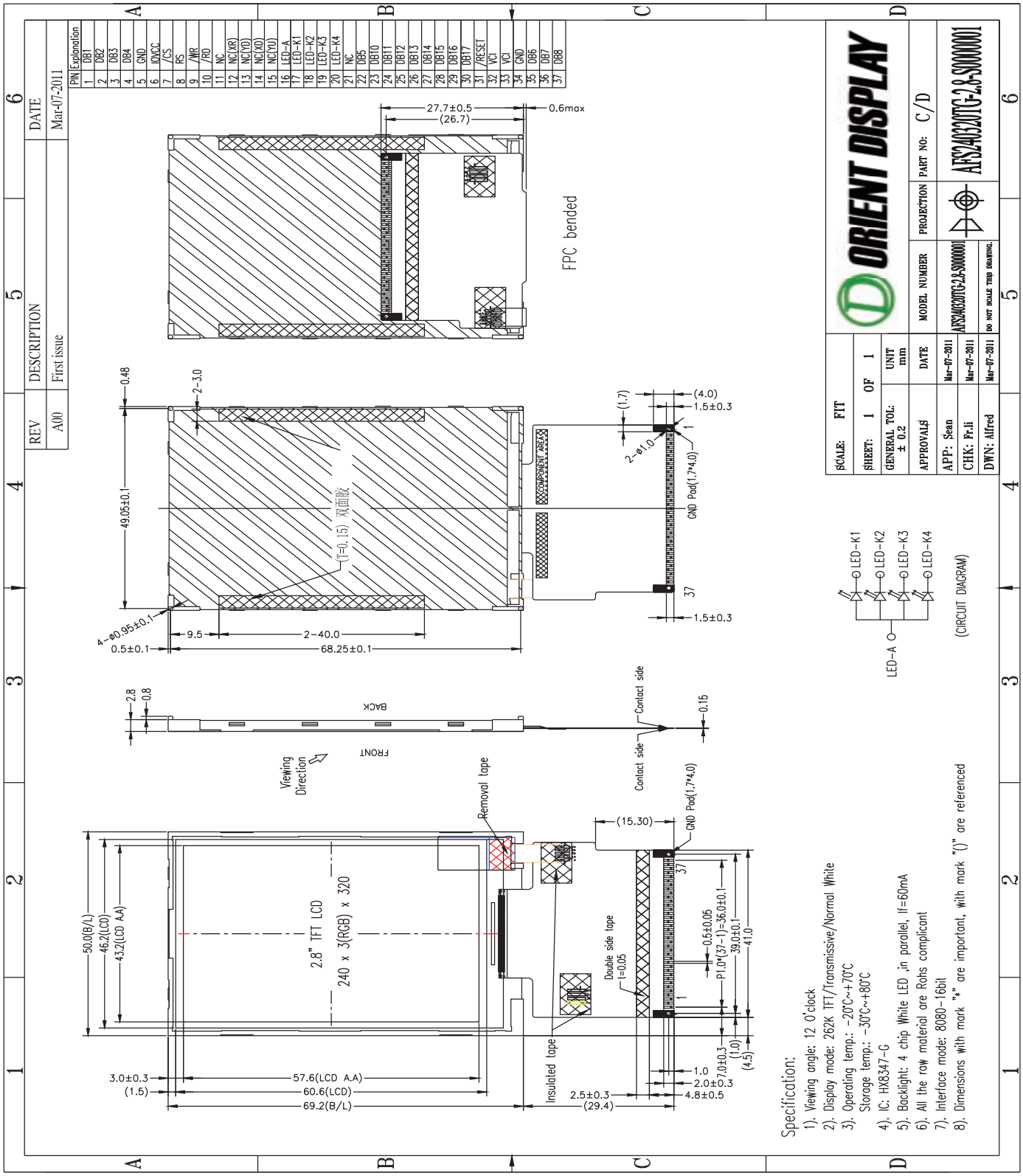


Figure 1. Dimensional outline

3. Block Diagram

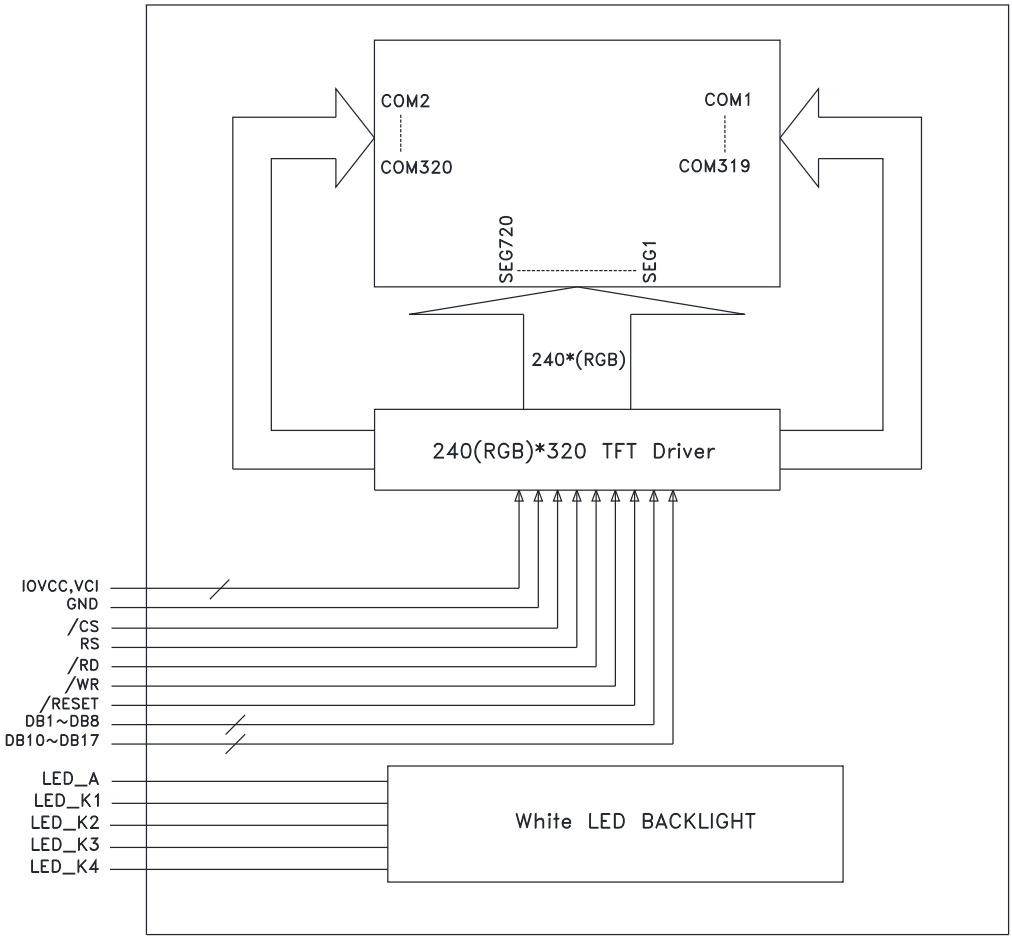


Figure 2. Block diagram

4. Pin Description

PIN No.	SYMBOL	Function
1~4	DB1~DB4	Data Bus
5	GND	Ground
6	IOVCC	Digital IO Pad power supply
7	/CS	Chip Select Signal (“Low” enable)
8	RS	Display data or command selection pin RS =’1’: display data or parameter. RS =’0’: command.
9	/WR	Write signal.
10	/RD	Read signal.
11	NC	No Connection
12	NC(XR)	No Connection
13	NC(YD)	No Connection
14	NC(XL)	No Connection
15	NC(YU)	No Connection
16	LED_A	Backlight LED Anode
17	LED_K1	Backlight LED1 Cathode
18	LED_K2	Backlight LED2 Cathode
19	LED_K3	Backlight LED3 Cathode
20	LED_K4	Backlight LED4 Cathode
21	NC	No Connection
22	DB5	Data Bus
23~30	DB10~DB17	Data Bus
31	/RESET	Reset pin. (Active Low)
32,33	VCI	Power supply
34	GND	Ground
35~37	DB6~DB8	Data Bus

Interface Note:

R1	R2	Interface Mode
Open	Short	8080-8bit interface: DB17~DB10
Short	Open	8080-16bit interface: DB17～DB10, DB8～DB1 (Default Mode)

1. Unused pins should connect to GND.
2. R1, R2 are SMT component on LCM FPC.

5. Absolute Maximum Ratings

Item	Symbol	Rating	Unit
System Voltage range	VCI	-0.3 to +4.6	V
I/O Supply Voltage range	IOVCC	-0.3 to +4.6	V
Operating Temperature range	TOP	-20 to +70	℃
Storage Temperature range	TST	-30 to +80	℃

6. Electrical Characteristics

DC Characteristics

Item	Symbol	Min.	Type.	Max.	Unit
System Voltage range	VCI	2.5	2.8	3.3	V
I/O Supply Voltage range	IOVCC	1.65	1.8	3.3	V

7. Backlight Characteristics

White LED × 4 **(Ta = 25°C)**

Item	Symbol	Condition	Min	Typ	Max	Unit
Forward Voltage	VF	IF = 60mA	-	3.2	-	V
Uniformity	△Bp	-	80	-	-	%
Luminance for LCD	Lv	IF = 60mA	1000	-	-	cd/m^2

8. Electro-Optical Characteristics

Light Source : C-light Ta=25℃

Item		Symbol	Condition	Min.	Typ.	Max.	Unit	Remark
View Angles		θT	CR≧10	60	70	-	Degree	Note 2
		θB		50	60	-		
		θL		60	70	-		
		θR		60	70	-		
Contrast Ratio		CR	θ=0°	400	500	-		Note1
Response Time		T_{ON}	25℃	-	25	30	ms	Note1 Note4
		T_{OFF}						
Chromaticity	White	x	C-light		0.298			Note5 Note1
		y			0.354			
	Red	x			0.649			
		y			0.323			
	Green	x			0.289			
		y			0.588			
	Blue	x			0.133			
		y			0.133			
NTSC					65	-	%	Note 5
Transmittance		T			5.7	-	%	Note1

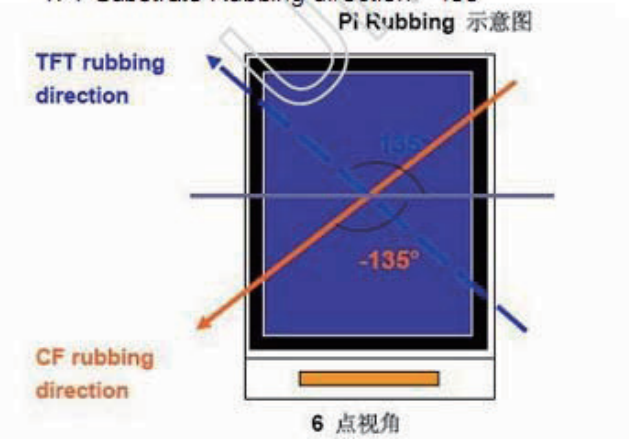
Test Conditions:

1. The ambient temperature is 25℃.
2. The test systems refer to Note 1 and Note 2.

b) Rubbing Direction

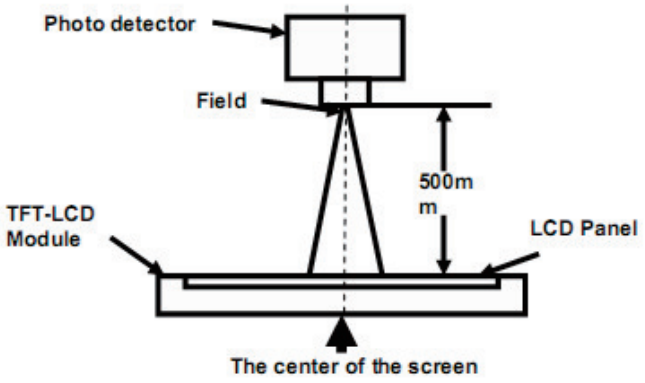
CF Substrate Rubbing direction：-135°

TFT Substrate Rubbing direction：135°



Note 1: Definition of optical measurement system.

The optical characteristics should be measured in dark room. After 5 minutes operation, the optical properties are measured at the center point of the LCD screen. All input terminals LCD panel must be ground when measuring the center area of the panel.



Item	Photo detector	Field
Contrast Ratio	SR-3A	1°
Chromaticity		
Response Time	BM-7A	2°

Note 2: Definition of viewing angle range and measurement system,

viewing angle is measured at the center point of the LCD by CONOSCOPE(ergo-80).

Viewing angle is measured With EWV Polarizer.

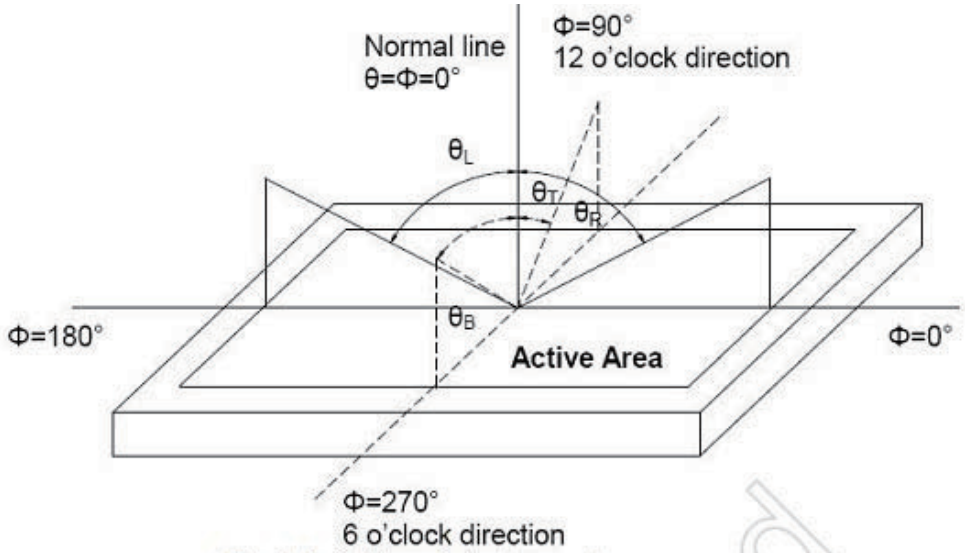


Fig. 1 Definition of viewing angle

Note 3: Definition of contrast ratio

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

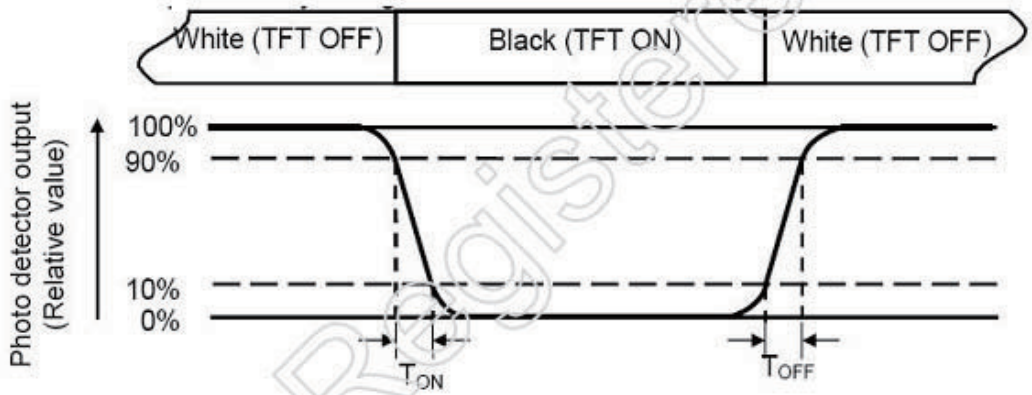
"White state ":The state is that the LCD should driven by Vwhite.

"Black state": The state is that the LCD should driven by Vblack.

Vwhite: To be determined Vblack: To be determined.

Note 4: Definition of Response time

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



Note 5: Definition of color chromaticity (CIE1931)

Color coordinates measured at center point of LCD.

9. Instruction Description

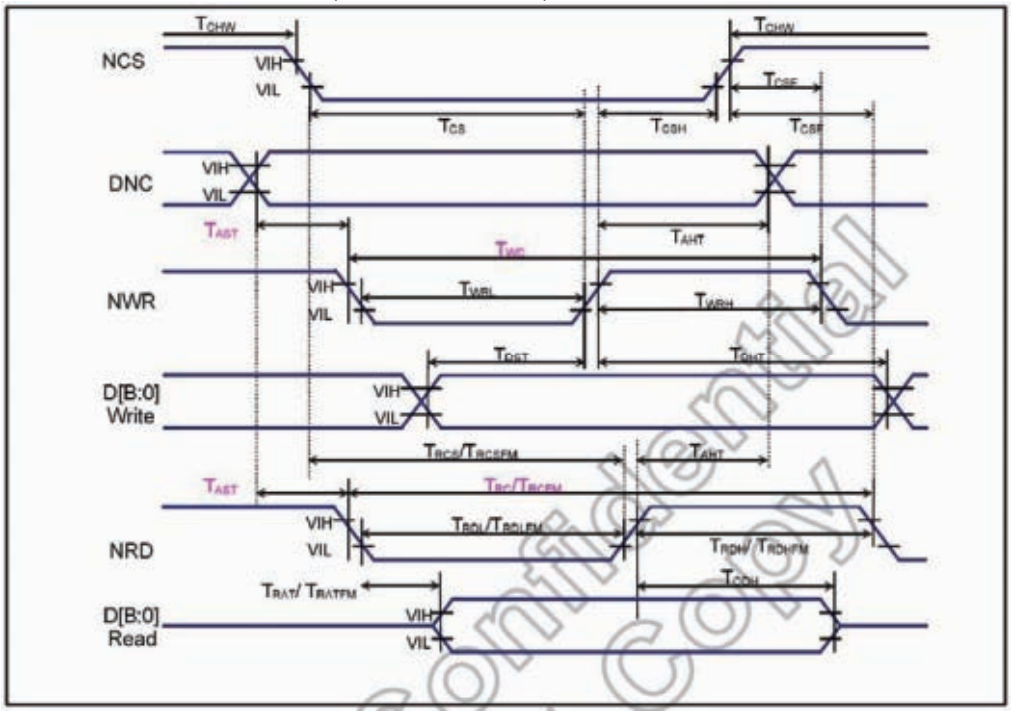
(Hex)	Operation Code	W/R	Upper Code	Lower Code								Comment
			D[17:8]	D7	D6	D5	D4	D3	D2	D1	D0	
00	Himax ID	R	-	0	1	1	1	0	1	0	1	-
01	Display Mode control	W/R	-	DP_STB(0)	DP_STB_S(0)	-	-	SCROL (0)	IDMON (0)	INVON (0)	PTLON (0)	-
02	Column address start 2	W/R	-	SC[15:8] (8'b0000_0000)								-
03	Column address start 1	W/R	-	SC[7:0] (8'b0000_0000)								-
04	Column address end 2	W/R	-	EC[15:8] (8'b0000_0000)								-
05	Column address end 1	W/R	-	EC[7:0] (8'b1110_1111)								-
06	Row address start 2	W/R	-	SP[15:8] (8'b0000_0000)								-
07	Row address start 1	W/R	-	SP[7:0] (8'b0000_00000)								-
08	Row address end 2	W/R	-	EP[15:8] (8'b0000_0001)								-
09	Row address end 1	W/R	-	EP[7:0] (8'b0011_1111)								-
0A	Partial area start row 2	W/R	-	PSL[15:8] (8'b0000_0000)								-
0B	Partial area start row 1	W/R	-	PSL[7:0] (8'b0000_00000)								-
0C	Partial area end row 2	W/R	-	PEL[15:8] (8'b0000_0001)								-
0D	Partial area end row 1	W/R	-	PEL[7:0] (8'b0011_1111)								-
0E	Vertical Scroll Top fixed area 2	W/R	-	TFA[15:8] (8'b0000_0000)								-
0F	Vertical Scroll Top fixed area 1	W/R	-	TFA[7:0] (8'b0000_0000)								-
10	Vertical Scroll height area 2	W/R	-	VSA[15:8] (8'b0000_0001)								-
11	Vertical Scroll height area 1	W/R	-	VSA[7:0] (8'b0100_0000)								-
12	Vertical Scroll Button area 2	W/R	-	BFA[15:8] (8'b0000_0000)								-
13	Vertical Scroll Button area 1	W/R	-	BFA [7:0] (8'b0000_0000)								-
14	Vertical Scroll Start address 2	W/R	-	VSP [15:8] (8'b0000_0000)								-
15	Vertical Scroll Start address 1	W/R	-	VSP [7:0] (8'b0000_0000)								-
16	Memory Access control	W/R	-	MY(0)	MX(0)	MV(0)	ML(0)	BGR(0)	-	-	-	-
17	COLMOD	W/R	-	CSEL[3:0] (4b'0110)				-	IFPF[2:0] (3b'110)			-
18	OSC Control 2	W/R	-	I/PI_RADJ1[3:0] (3b'0011)				N/P_RADJ0[3:0](4b'0100)				-
19	OSC Control 1	W/R	-	-	-	-	-	-	-	-	OSC_EN(0)	-
1A	Power Control 1	W/R	-	-	-	-	-	-	BT[2:0] (001)			-
1B	Power Control 2	W/R	-	-	-	VRH[5:0] (01_1011) 4.8V						-
1C	Power Control 3	W/R	-	-	-	-	-	-	AP[2:0] (011)			-
1D	Power Control 4	W/R	-	-	I/PI_FS0[2:0](100)			-	N/P_FS0[2:0])(100)			-
1E	Power Control 5	W/R	-	-	I/PI_FS1[2:0])(100)			-	N/P_FS1[2:0])(100)			-
1F	Power Control 6	W/R	-	GASEN(1)	VCOMG(0)	-	PON(0)	DK(1)	XDK(0)	DDVDH_TRI(0)	STB(1)	-
22	SRAM Write Control	W/R	SRAM Write									-
23	VCOM Control 1	W/R	-	VMF[7:0](1000_0000)								-
24	VCOM Control 2	W/R	-	VMH[7:0](0010_1111)								-
25	VCOM Control 3	W/R	-	VML[7:0](0101_0111)								-
26	Display Control 1	W/R	-	--	-	-	-	ISC[3:0](0001)				-
27	Display Control 2	W/R	-	PT[1:0](10)		PTV[1:0](10)		-	-	PTG(1)	REF(1)	-

(Hex)	Operation Code	W/R	Upper Code	Lower Code								Comment
			D[17:8]	D7	D6	D5	D4	D3	D2	D1	D0	
28	Display Control 3	W/R	-	-	-	GON(1)	DTE(0)	D[1:0] (00)		-	-	-
29	Frame Rate control 1	W/R	-	I/PI_RTN[3:0](1000)				N/P_RTN[3:0](1000)				-
2A	Frame Rate Control 2	W/R	-	-	-	I/PI_DIV[1:0](00)		-	-	N/P_DIV[1:0](00)		-
2B	Frame Rate Control 3	W/R	-	N/P_DUM[7:0] (8b'0001_1100)								-
2C	Frame Rate Control 4	W/R	-	I/PI_DUM[7:0] (8b'0001_1100)								-
2D	Cycle Control 1	W/R	-	GDON[7:0] (8'b0000_1101)								-
2E	Cycle Control 2	W/R	-	GDOF[7:0] (8'b0111_1000)								-
2F	Display inversion	W/R	-	-	I/PI_NW[2:0](3b'001)			-	N/P_NW[2:0] (3b'001)			-
31	RGB interface control 1	W/R	-	-	-	-	-	-	-	RCM[1:0](00)		-
32	RGB interface control 2	W/R	-	-	-	-	-	DPL (0)	HSPL (0)	VSPL (0)	EPL (0)	-
33	RGB interface control 3	W/R	-	HBP[7:0]								-
34	RGB interface control 4	W/R	-	HBP[9:8]		VBP[5:0]						-
36	Panel Characteristic	W/R	-	-	-	-	-	SS_Panel	GS_Panel	REV_Panel	BGR_Panel	-
38	OTP Control 1	W/R	-	OTP_PTM[1:0]		OTP_VARDJ[1:0]		OTP_POR	OTP_OTPEN	OTP_PPROG	OTP_PWE	-
39	OTP Control 2	W/R	-	-	-	-	-	-	OTP_YA2	OTP_YA1	OTP_YA0	-
3A	OTP Control 3	W/R	-	-	-	-	OTP_XA4	OTP_XA3	OTP_XA2	OTP_XA1	OTP_XA0	-
3B	OTP Control 4	R		OTPDATA7	OTPDATA6	OTPDATA5	OTPDATA4	OTPDATA3	OTPDATA2	OTPDATA1	OTPDATA0	
3C	CABC Control 1	W/R	-	DBV[7:0](8'h00)								-
3D	CABC Control 2	W/R	-	-	-	BCTRL (0)	-	DD (0)	BL (0)	-	-	-
3E	CABC Control 3	W/R	-	-	-	-	-	-	-	C1 (0)	C0 (0)	-
3F	CABC Control 4	W/R	-	CMB[7:0](8'h00)								-
40	r1 Control (1)	W/R	-	-	-	VRP0[5:0]						-
41	r1 Control (2)	W/R	-	-	-	VRP1[5:0]						-
42	r1 Control (3)	W/R	-	-	-	VRP2[5:0]						-
43	r1 Control (4)	W/R	-	-	-	VRP3[5:0]						-
44	r1 Control (5)	W/R	-	-	-	VRP4[5:0]						-
45	r1 Control (6)	W/R	-	-	-	VRP5[5:0]						-
46	r1 Control (7)	W/R	-	-	PRP0[6:0]							-
47	r1 Control (8)	W/R	-	-	PRP1[6:0]							-
48	r1 Control (9)	W/R	-	-	-	-	PKP0[4:0]					-
49	r1 Control (10)	W/R	-	-	-	-	PKP1[4:0]					-
4A	r1 Control (11)	W/R	-	-	-	-	PKP2[4:0]					-
4B	r1 Control (12)	W/R	-	-	-	-	PKP3[4:0]					-
4C	r1 Control (13)	W/R	-	-	-	-	PKP4[4:0]					-
50	r1 Control (14)	W/R	-	-	-	VRN0[5:0]						-
51	r1 Control (15)	W/R	-	-	-	VRN1[5:0]						-
52	r1 Control (16)	W/R	-	-	-	VRN2[5:0]						-
53	r1 Control (17)	W/R	-	-	-	VRN3[5:0]						-
54	r1 Control (18)	W/R	-	-	-	VRN4[5:0]						-
55	r1 Control (19)	W/R	-	-	-	VRN5[5:0]						-
56	r1 Control (20)	W/R	-	-	PRN0[6:0]							-
57	r1 Control (21)	W/R	-	-	PRN1[6:0]							-
58	r1 Control (22)	W/R	-	-	-	PKN0[4:0]						-
59	r1 Control (23)	W/R	-	-	-	PKN1[4:0]						-
5A	r1 Control (24)	W/R	-	-	-	PKN2[4:0]						-
5B	r1 Control (25)	W/R	-	-	-	PKN3[4:0]						-
5C	r1 Control (26)	W/R	-	-	-	PKN4[4:0]						-
5D	r1 Control (27)	W/R	-	CGMN1[1:0]		CGMN0[1:0]		CGMP1[1:0]		CGMP0[1:0]		-
60	TE Control	W/R	-	-	-		TE_mode(0)	TEOE(0)		-	-	-
61	ID1	W/R	-	ID17	ID16	ID15	ID14	ID13	ID12	ID11	ID10	-
62	ID2	W/R	-	ID27	ID26	ID25	ID24	ID23	ID22	ID21	ID20	-
63	ID3	W/R	-	ID37	ID36	ID35	ID34	ID33	ID32	ID31	ID30	-

(Hex)	Operation Code	W/R	Upper Code	Lower Code								Comment
			D[17:8]	D7	D6	D5	D4	D3	D2	D1	D0	
84	TE Output line2	W/R	-	TESEL15	TESEL14	TESEL 13	TESEL 12	TESEL11	TESEL10	TESEL9	TESEL8	-
85	TE Output line1	W/R	-	TESEL 7	TESEL 6	TESEL 5	TESEL 4	TESEL 3	TESEL 2	TESEL1	TESEL 0	-
E4	Power saving 1	W/R	-	EQ_S1[7:0]								-
E5	Power saving 2	W/R	-	EQ_S2[7:0]								-
E6	Power saving 3	W/R	-	EQ_S3[7:0]								-
E7	Power saving 4	W/R	-	EQ_S4[7:0]								-
E8	Source OP control_Normal	W/R	-	OPON_N[7:0]								-
E9	Source OP control_IDLE	W/R	-	OPON_I[7:0]								-
EA	Power control internal use (1)	W/R	-	STBA[15:8]								-
EB	Power control internal use (2)	W/R	-	STBA[7:0]								-
EC	Source control internal use (1)	W/R	-	PTBA[15:8]								-
ED	Source control internal use (2)	W/R	-	PTBA[7:0]								-
FF	Page select	W/R	-	-	-	-	-	-	-	PAGE_SEL[1:0] (00)		-

10. AC Characteristics

Parallel interface characteristics (8080-series MPU)



(VSSA=0V, IOVCC=1.65V to 3.3V, VCI=2.3V to 3.3V, T_A = -30 to 70° C)

Signal	Symbol	Parameter	Spec. Min.	Spec. Typ	Spec. Max.	Unit	Description
DNC_SCL	tAST	Address setup time	10	-	-	ns	-
	tAHT	Address hold time (Write/Read)	10	-	-		
NCS		Chip select "H" pulse width	0	-	-	ns	-
	tCS	Chip select setup time (Write)	15	-	-		
	tRCS	Chip select setup time (Read ID)	45	-	-		
	tRCSFM	Chip select setup time (Read FM)	355	-	-		
	tCSF	Chip select wait time (Write/Read)	10	-	-		
	tCSH	Chip select hold time	10	-	-		
NWR_SCL	tWC	Write cycle(1pixel for one write)	100	-	-	ns	-
	tWC	Write cycle (1 pixel for 2 or 3 write)	50				
	tWRH	Control pulse "H" duration	15	-	-		
	tWRL	Control pulse "L" duration	15	-	-		
NRD(ID)	tRC	Read cycle (ID)	160	-	-	ns	When read ID data
	tRDH	Control pulse "H" duration (ID)	90	-	-		
	tRDL	Control pulse "L" duration (ID)	45	-	-		
NRD(FM)	tRCFM	Read cycle (FM) (1pixel for one read)	600	-	-	ns	When read from frame memory
	tRCFM	Read cycle (FM) (1 pixel for 2 or 3 read)	400	-	-		
	tRDHFM	Control pulse "H" duration (FM)	90	-	-		
	tRDLFM	Control pulse "L" duration (FM)	355	-	-		
DB17 to DB0	tDST	Data setup time	10	-	-	ns	For maximum CL=30pF For minimum CL=8pF
	tDHT	Data hold time	10	-	-		
	tRAT	Read access time (ID)	-	-	100		
	tRATFM	Read access time (FM)	-	-	340		
	tODH	Output disable time	20		80		

Note: The input signal rise time ar) is specified at 15 ns or less.
Logic high and low levels ar 0% and 70% of IOVCC for input signals.

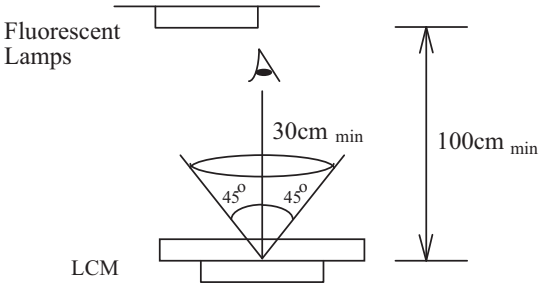
11.Quality Specifications

All The raw material are Rohs complicant.

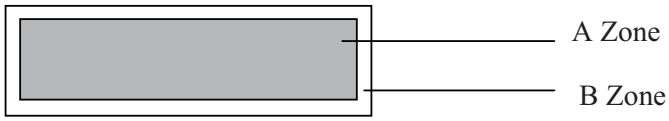
11.1 Standard of the product appearance test

Manner of appearance test: The inspection should be performed in using 20W x 2 fluorescent lamps. Distance between LCM and fluorescent lamps should be 100 cm or more. Distance between LCM and inspector eyes should be 30 cm or more.

Viewing direction for inspection is 45° from vertical against LCM.



Definition of zone:



A Zone: viewing area
B Zone: outside viewing area

11.2 Specification of quality assurance

AQL inspection standard

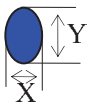
Sampling method: MIL-STD-105E, Level II, single sampling

Defect classification (Note: * is not including)

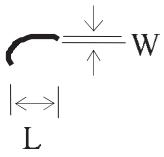
Classify	Item		Note	AQL
Major	Display state	Short or open circuit	1	0.65
		LC leakage		
		Flickering		
		No display		
		Wrong viewing direction		
		Contrast defect (dim, ghost)	2	
		Back-light	1,8	
	Non-display	Flat cable or pin reverse	10	
		Wrong or missing component	11	
Minor	Display state	Background color deviation	2	1.0
		Black spot and dust	3	
		Line defect, Scratch	4	
		Rainbow	5	
		Chip	6	
		Pin hole	7	
	Polarizer	Protruded	12	
		Bubble and foreign material	3	
	Soldering	Poor connection	9	
	Wire	Poor connection	10	
	TAB	Position, Bonding strength	13	

Note on defect classification

<table>
<tr><th>No.</th><th>Item</th><th>Criterion</th></tr>
<tr><td rowspan="6">1</td><td>Short or open circuit</td><td rowspan="6">Not allow</td></tr>
<tr><td>LC leakage</td></tr>
<tr><td>Flickering</td></tr>
<tr><td>No display</td></tr>
<tr><td>Wrong viewing direction</td></tr>
<tr><td>Wrong Back-light</td></tr>
<tr><td rowspan="2">2</td><td>Contrast defect</td><td rowspan="2">Refer to approval sample</td></tr>
<tr><td>Background color deviation</td></tr>
<tr><td>3</td><td>Point defect,
Black spot, dust
(including Polarizer)

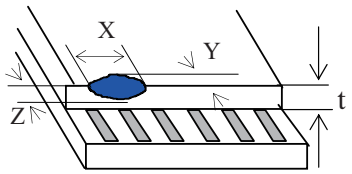
$\phi = (X+Y)/2$</td><td> 

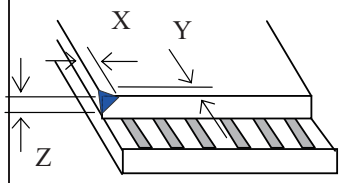
<table>
<tr><th>Point
Size</th><th>Acceptable Qty.</th></tr>
<tr><td>$\phi \leq 0.10$</td><td>Disregard</td></tr>
<tr><td>$0.10 < \phi \leq 0.20$</td><td>3</td></tr>
<tr><td>$0.20 < \phi \leq 0.25$</td><td>2</td></tr>
<tr><td>$0.25 < \phi \leq 0.30$</td><td>1</td></tr>
<tr><td>$\phi > 0.30$</td><td>0</td></tr>
</table>
Unit： mm</td></tr>
<tr><td>4</td><td>Line defect,

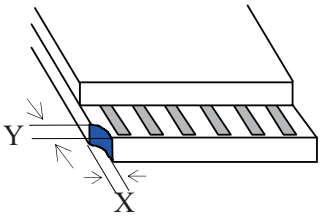
Scratch</td><td> 

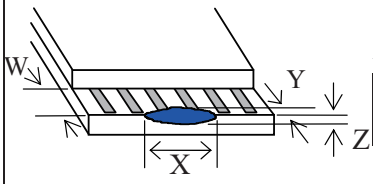
<table>
<tr><th colspan="2">Line</th><th>Acceptable Qty.</th></tr>
<tr><td>L</td><td>W</td><td></td></tr>
<tr><td>---</td><td>0.015≥W</td><td>Disregard</td></tr>
<tr><td>3.0≥L</td><td>0.03≥W</td><td rowspan="2">2</td></tr>
<tr><td>2.0≥L</td><td>0.05≥W</td></tr>
<tr><td>1.0≥L</td><td>0.1＞W</td><td>1</td></tr>
<tr><td>---</td><td>0.05<W</td><td>Applied as point defect</td></tr>
</table>
Unit: mm</td></tr>
<tr><td>5</td><td>Rainbow</td><td>Not more than two color changes across the viewing area.</td></tr>
</table>

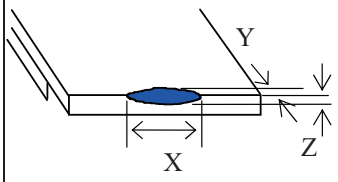
<table>
<tr><th>No</th><th>Item</th><th>Criterion</th></tr>
<tr><td>6</td><td>Chip

Remark:
X: Length direction
Y: Short direction
Z: Thickness direction
t: Glass thickness
W: Terminal Width</td><td>


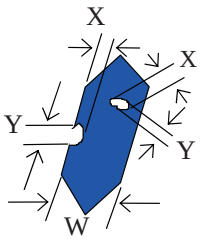
Acceptable criterion
<table>
<tr><th>X</th><th>Y</th><th>Z</th></tr>
<tr><td>≤2</td><td>0.5mm</td><td>≤t/2</td></tr>
</table>


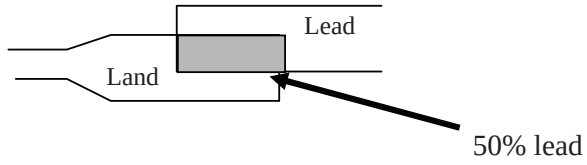
Acceptable criterion
<table>
<tr><th>X</th><th>Y</th><th>Z</th></tr>
<tr><td>≤2</td><td>0.5mm</td><td>≤t</td></tr>
</table>


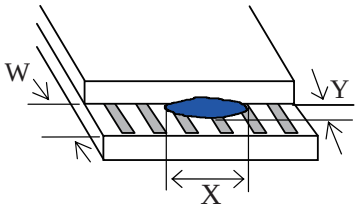
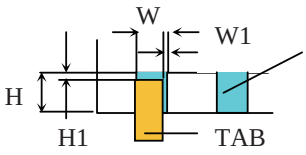
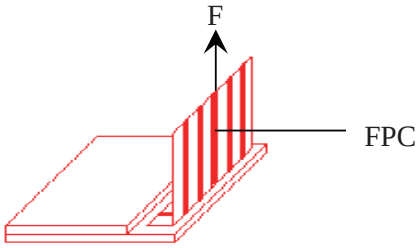
Acceptable criterion
<table>
<tr><th>X</th><th>Y</th><th>Z</th></tr>
<tr><td>≤3</td><td>≤2</td><td rowspan="2">≤t</td></tr>
<tr><td colspan="2">shall not reach to ITO</td></tr>
</table>


Acceptable criterion
<table>
<tr><th>X</th><th>Y</th><th>Z</th></tr>
<tr><td>Disregard</td><td>≤0.2</td><td>≤t</td></tr>
</table>


Acceptable criterion
<table>
<tr><th>X</th><th>Y</th><th>Z</th></tr>
<tr><td>≤5</td><td>≤2</td><td>≤t/3</td></tr>
</table>
</td></tr>
</table>

<table>
<tr><th>No.</th><th>Item</th><th>Criterion</th></tr>
<tr><td>7</td><td>Segment
pattern
W = Segment width
ϕ = (X+Y)/2</td><td>(1) Pin hole
ϕ < 0.10mm is acceptable.
 

<table>
<tr><th>Point Size</th><th>Acceptable Qty</th></tr>
<tr><td>ϕ ≤ 1/4W</td><td>Disregard</td></tr>
<tr><td>1/4W<ϕ≤1/2W</td><td>1</td></tr>
<tr><td>ϕ>1/2W</td><td>0</td></tr>
</table>
Unit: mm</td></tr>
<tr><td>8</td><td>Back-light</td><td>(1) The color of backlight should correspond its specification.
(2) Not allow flickering</td></tr>
<tr><td>9</td><td>Soldering</td><td>(1) Not allow heavy dirty and solder ball on PCB.
(The size of dirty refer to point and dust defect)
(2) Over 50% of lead should be soldered on Land.
 
</td></tr>
<tr><td>10</td><td>Wire</td><td>(1) Copper wire should not be rusted
(2) Not allow crack on copper wire connection.
(3) Not allow reversing the position of the flat cable.
(4) Not allow exposed copper wire inside the flat cable.</td></tr>
<tr><td>11*</td><td>PCB</td><td>(1) Not allow screw rust or damage.
(2) Not allow missing or wrong putting of component.</td></tr>
</table>

	o N m e	t I n o i r e t i r C
12	Protruded W: Terminal Width	 Acceptable criteria: Y ≤ 0.4
13	TAB	1. Position  W1≤1/3W H1≤1/3H 2 FPC bonding strength test  P (=F/FPC bonding width) ≥650gf/cm ,(speed rate: 1mm/min) 5pcs per SOA (shipment)
14	Total no. of acceptable Defect	A. Zone Maximum 2 minor non-conformities per one unit. Defect distance: each point to be separated over 10mm B. Zone It is acceptable when it is no trouble for quality and assembly in customer's end product.

11.3 Reliability of LCM

Reliability test condition:

Item	Condition	Time (hrs)	Assessment
High temp. Storage	60 °C	48	No abnormalities in functions and appearance
High temp. Operating	50 °C	48	
Low temp. Storage	-20 °C	48	
Low temp. Operating	-10°C	48	
Humidity	40 °C/ 90%RH	48	
Temp. Cycle	-20°C ← 25°C→ 80 °C (60 min← 5 min → 60min)	10cycles	

Recovery time should be 24 hours minimum. Moreover, functions, performance and appearance shall be free from remarkable deterioration within 50,000 hours under ordinary operating and storage conditions room temperature (20±8°C), normal humidity (below 65% RH), and in the area not exposed to direct sun light.

11.4 Precaution for using LCD/LCM

LCD/LCM is assembled and adjusted with a high degree of precision. Do not attempt to make any alteration or modification. The followings should be noted.

General Precautions:

1. LCD panel is made of glass. Avoid excessive mechanical shock or applying strong pressure onto the surface of display area.
2. The polarizer used on the display surface is easily scratched and damaged. Extreme care should be taken when handling. To clean dust or dirt off the display surface, wipe gently with cotton, or other soft material soaked with isoproply alcohol, ethyl alcohol or trichlorotriflorothane, do not use water, ketone or aromatics and never scrub hard.
3. Do not tamper in any way with the tabs on the metal frame.
4. Do not made any modification on the PCB without consulting Orient Display.
5. When mounting a LCM, make sure that the PCB is not under any stress such as bending or twisting. Elastomer contacts are very delicate and missing pixels could result from slight dislocation of any of the elements.
6. Avoid pressing on the metal bezel, otherwise the elastomer connector could be deformed and lose contact, resulting in missing pixels and also cause rainbow on the display.
7. Be careful not to touch or swallow liquid crystal that might leak from a damaged cell. Any liquid crystal adheres to skin or clothes, wash it off immediately with soap and water.

Static Electricity Precautions:

1. CMOS-LSI is used for the module circuit; therefore operators should be grounded whenever he/she comes into contact with the module.
2. Do not touch any of the conductive parts such as the LSI pads; the copper leads on the PCB and the interface terminals with any parts of the human body.
3. Do not touch the connection terminals of the display with bare hand; it will cause disconnection or defective insulation of terminals.
4. The modules should be kept in anti-static bags or other containers resistant to static for storage.
5. Only properly grounded soldering irons should be used.
6. If an electric screwdriver is used, it should be grounded and shielded to prevent sparks.
7. The normal static prevention measures should be observed for work clothes and working benches.
8. Since dry air is inductive to static, a relative humidity of 50-60% is recommended.

Soldering Precautions:

1. Soldering should be performed only on the I/O terminals.
2. Use soldering irons with proper grounding and no leakage.
3. Soldering temperature: 280°C$\pm$10°C
4. Soldering time: 3 to 4 second.
5. Use eutectic solder with resin flux filling.
6. If flux is used, the LCD surface should be protected to avoid spattering flux.
7. Flux residue should be removed.

Operation Precautions:

1. The viewing angle can be adjusted by varying the LCD driving voltage Vo.
2. Since applied DC voltage causes electro-chemical reactions, which deteriorate the display, the applied pulse waveform should be a symmetric waveform such that no DC component remains. Be sure to use the specified operating voltage.
3. Driving voltage should be kept within specified range; excess voltage will shorten display life.
4. Response time increases with decrease in temperature.
5. Display color may be affected at temperatures above its operational range.
6. Keep the temperature within the specified range usage and storage. Excessive temperature and humidity could cause polarization degradation, polarizer peel-off or generate bubbles.
7. For long-term storage over 40°C is required, the relative humidity should be kept below 60%, and avoid direct sunlight.

Limited Warranty

Orient Display's LCDs and modules are not consumer products, but may be incorporated by Orient Display's customers into consumer products or components thereof, Orient Display does not warrant that its LCDs and components are fit for any such particular purpose.

1. The liability of Orient Display is limited to repair or replacement on the terms set forth below. Orient Display will not be responsible for any subsequent or consequential events or injury or damage to any personnel or user including third party personnel and/or user. Unless otherwise agreed in writing between Orient Display and the customer, Orient Display will only replace or repair any of its LCD which is found defective electrically or visually when inspected in accordance with Orient Display general LCD inspection standard. (Copies available on request)
2. No warranty can be granted if any of the precautions state in handling liquid crystal display above has been disregarded. Broken glass, scratches on polarizer mechanical damages as well as defects that are caused accelerated environment tests are excluded from warranty.
3. In returning the LCD/LCM, they must be properly packaged; there should be detailed description of the failures or defect.