

SPEC

Spec No.	TQ3C-8EAF0-E1YAA28-00
Date	June 10, 2011

TYPE : TCG070WVLPAFA-AA00

< 7.0 inch WVGA transmissive color TFT

with LED backlight / with touch panel. >

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KYOCERA CORPORATION
KAGOSHIMA HAYATO PLANT
LCD DIVISION

This specification is subject to change without notice.
Consult Kyocera before ordering.

Original Issue Date	Designed by: Engineering dept.			Confirmed by: QA dept.	
	Prepared	Checked	Approved	Checked	Approved
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Warning

1. This Kyocera LCD module has been specifically designed for use only in electronic devices and industrial machines in the area of audio control, office automation, industrial control, home appliances, etc. The module should not be used in applications where the highest level of safety and reliability are required and module failure or malfunction of such module results in physical harm or loss of life, as well as enormous damage or loss. Such fields of applications include, without limitation, medical, aerospace, communications infrastructure, atomic energy control. Kyocera expressly disclaims any and all liability resulting in any way to the use of the module in such applications.
2. Customer agrees to indemnify, defend and hold Kyocera harmless from and against any and all actions, claims, damages, liabilities, awards, costs, and expenses, including legal expenses, resulting from or arising out of Customer's use, or sale for use, or Kyocera modules in applications.

Caution

1. Kyocera shall have the right, which Customer hereby acknowledges, to immediately scrap or destroy tooling for Kyocera modules for which no Purchase Orders have been received from the Customer in a two-year period.

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Revision record

Date		Designed by : Engineering dept.			Confirmed by : QA dept.	
		Prepared	Checked	Approved	Checked	Approved
Rev.No.	Date	Page	Descriptions			

1. Application

This document defines the specification of TCG070WVLPAAFA-AA00. (RoHS Compliant)

2. Construction and outline

LCD	: Transmissive color dot matrix type TFT
Backlight system	: LED
Polarizer	: Anti-Glare treatment
Additional circuit	: Timing controller, Power supply (3.3V input) (without constant current circuit for LED Backlight)
Touch panel	: Analog type, Non-Glare treatment

3. Mechanical specifications

3-1. LCD

Item	Specification	Unit
Outline dimensions 1)	165(W)×(104.4)(H)×10(D)	mm
Active area	152.4(W)×91.44(H) (17.8cm/7.0 inch(Diagonal))	mm
Dot format	800×(R,G,B)(W)×480(H)	dot
Dot pitch	0.0635(W)×0.1905(H)	mm
Base color 2)	Normally White	-
Mass	250	g

1) Projection not included. Please refer to outline for details.

2) Due to the characteristics of the LCD material, the color varies with environmental temperature.

3-2. Touch panel

Item	Specification	Unit
Input	Radius-0.8 stylus or Finger	-
Actuation Force	0.5 ± 0.3	N
Transmittance	Typ. 80	%
Surface hardness	Pencil hardness 2H or more according	-

4. Absolute maximum ratings

4-1. Electrical absolute maximum ratings

Item	Symbol	Min.	Max.	Unit
Supply voltage	V _{DD}	-0.3	4.5	V
Input signal voltage 1)	V _{IN}	-0.3	4.5	V
LED forward current 2) 3)	I _F	-	100	mA
Supply voltage for touch panel	V _{TP}	0	6.0	V
Input current of touch panel	I _{TP}	0	0.5	mA

- 1) Input signal : CK, R0 ~ R5, G0 ~ G5, B0 ~ B5, H_{SYNC}, V_{SYNC}, ENAB, CM, SC
- 2) For each "AN-CA"
- 3) Do not apply reversed voltage.

4-2. Environmental absolute maximum ratings

Item	Symbol	Min.	Max.	Unit
Operating temperature 1)	T _{OP}	-20	70	°C
Storage temperature 2)	T _{STO}	-30	80	°C
Operating humidity 3)	H _{OP}	10	4)	%RH
Storage humidity 3)	H _{STO}	10	4)	%RH
Vibration	-	5)	5)	-
Shock	-	6)	6)	-

- 1) Operating temperature means a temperature which operation shall be guaranteed. Since display performance is evaluated at 25°C, another temperature range should be confirmed.
- 2) Temp. = -30°C < 48h , Temp. = 80°C < 168h
Store LCD at normal temperature/humidity. Keep them free from vibration and shock.
An LCD that is kept at a low or a high temperature for a long time can be defective due to other conditions, even if the low or high temperature satisfies the standard.
(Please refer to "Precautions for Use" for details.)

- 3) Non-condensing
- 4) Temp. 40°C, 85%RH Max.
Temp. > 40°C, Absolute humidity shall be less than 85%RH at 40°C.
- 5)

Frequency	10 ~ 55 Hz	Acceleration value (0.3 ~ 9 m/s ²)
Vibration width	0.15mm	
Interval	10-55-10 Hz	1 minutes

2 hours in each direction X, Y, Z (6 hours total)

EIAJ ED-2531

- 6) Acceleration: 490 m/s², Pulse width: 11 ms
3 times in each direction: ±X, ±Y, ±Z
EIAJ ED-2531

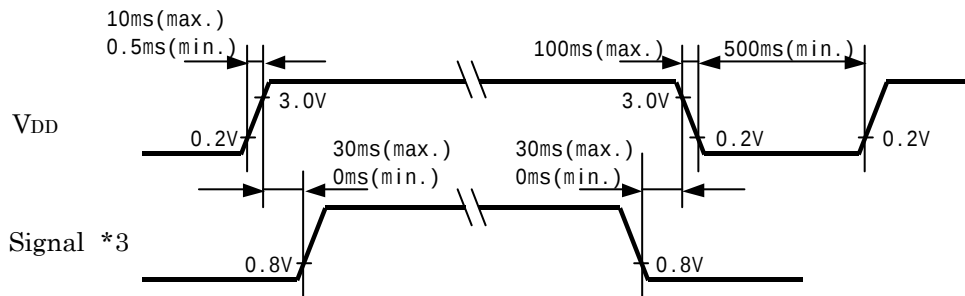
5. Electrical characteristics

5-1. LCD

Temp. = -20 ~ 70°C

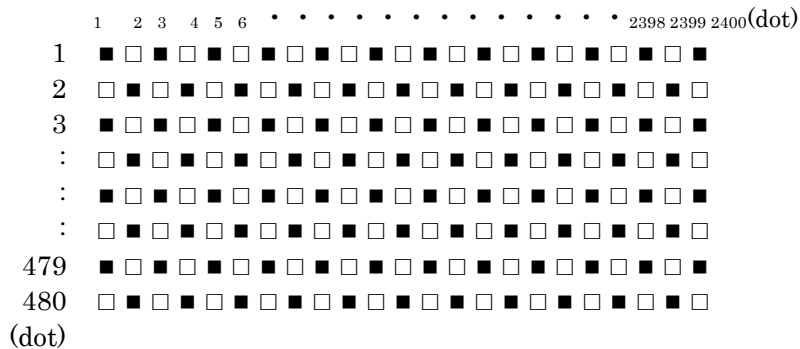
Item	Symbol	Condition	Min.	Typ.	Max.	Unit
Supply voltage 1)	V_{DD}	-	3.0	3.3	3.6	V
Current consumption	I_{DD}	2)	-	180	235	mA
Permissive input ripple voltage	V_{RP}	-	-	-	100	mVp-p
Input signal voltage	V_{IL}	"Low" level	0	-	0.8	V
	V_{IH}	"High" level	2.0	-	V_{DD}	V
	V_{IL}	"Low" level	0	-	0.3 V_{DD}	V
	V_{IH}	"High" level	0.7 V_{DD}	-	V_{DD}	V

1) V_{DD} -turn-on conditions



2) Display pattern:

$V_{DD} = 3.3V$, Temp. = 25°C



3) Input signal : CK, R0 ~ R5, G0 ~ G5, B0 ~ B5, H_{SYNC}, V_{SYNC}, ENAB, CM

4) Input signal : SC

5-2. Touch panel

Item	Specification
Supply voltage for touch panel	5.0V
Terminal resistance	xL ~ xR : 274Ω ~ 640Ω
	yU ~ yL : 183Ω ~ 428Ω
Linearity	less than ±2.0%
Insulation resistance	20MΩ or more at DC25V

6. Optical characteristics

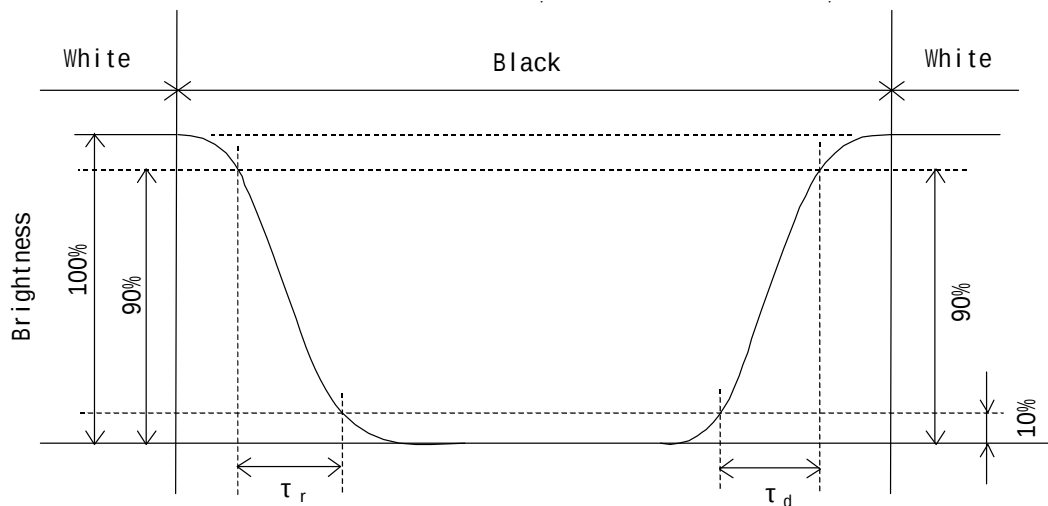
Measuring spot = ϕ 6.0mm, Temp. = 25°C

Item		Symbol	Condition	Min.	Typ.	Max.	Unit
Response time	Rise	τ_r	$\theta = \phi = 0^\circ$	-	5	-	ms
	Down	τ_d	$\theta = \phi = 0^\circ$	-	25	-	ms
Viewing angle range View direction : 12 o'clock (Gray inversion)		θ_{UPPER}	CR 10	-	60	-	deg.
		θ_{LOWER}		-	80	-	
		ϕ_{LEFT}		-	80	-	deg.
		ϕ_{RIGHT}		-	80	-	
Contrast ratio		CR	$\theta = \phi = 0^\circ$	700	1000	-	-
Brightness		L	IF=60mA/Line	190	270	-	cd/m ²
Luminance(Brightness)		LU	-	70	-	-	%
Chromaticity coordinates	Red	x	$\theta = \phi = 0^\circ$	0.550	0.600	0.650	-
		y		0.300	0.350	0.400	
	Green	x	$\theta = \phi = 0^\circ$	0.270	0.320	0.370	
		y		0.500	0.550	0.600	
	Blue	x	$\theta = \phi = 0^\circ$	0.100	0.150	0.200	
		y		0.070	0.120	0.170	
	White	x	$\theta = \phi = 0^\circ$	0.240	0.290	0.340	
		y		0.255	0.305	0.355	

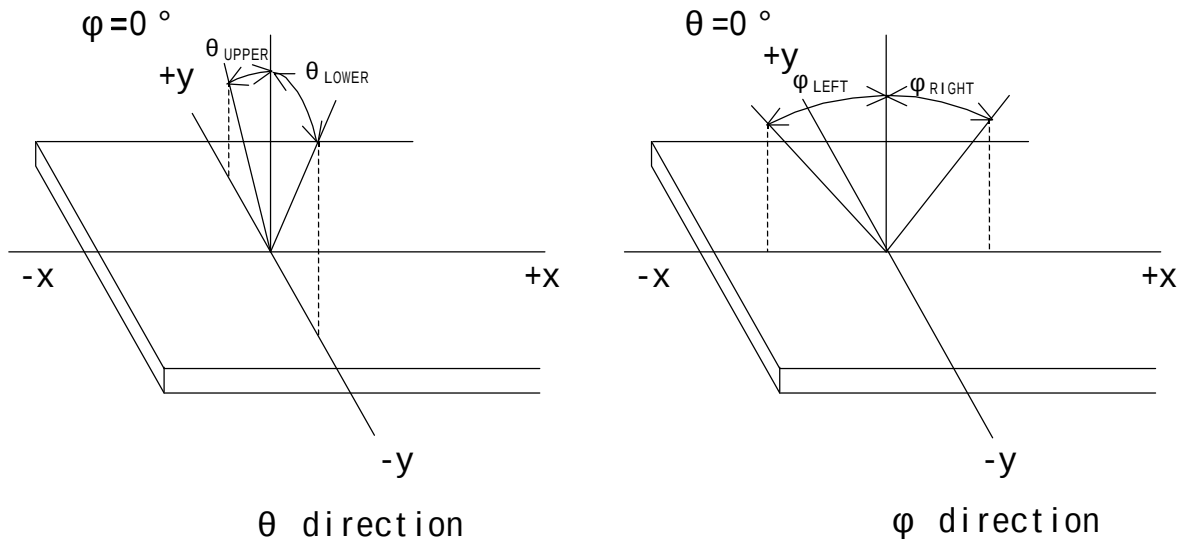
6-1. Definition of contrast ratio

$$CR(\text{Contrast ratio}) = \frac{\text{Brightness with all pixels "White"}}{\text{Brightness with all pixels "Black"}}$$

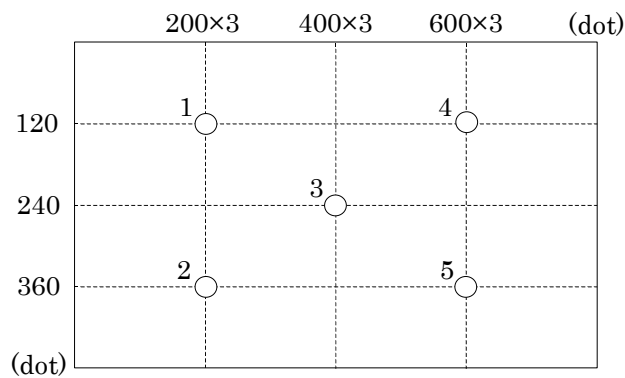
6-2. Definition of response time



6-3. Definition of viewing angle



6-4. Brightness measuring points



- 1) Rating is defined as the white brightness at center of display screen(3).
- 2) The brightness uniformity is calculated by using following formula.

$$\text{Brightness uniformity} = \frac{\text{Minimum brightness from 1 to 5}}{\text{Maximum brightness from 1 to 5}} \times 100 [\%]$$

- 3) 30 minutes after CFL is turned on. (Ambient Temp.=25)

7. Interface signals

7-1. LCD

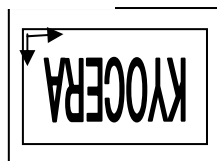
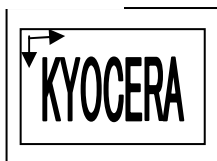
No.	Symbol	Description	Level
1	AN1	Anode1	
2	AN2	Anode2	
3	CA1	Cathode1	
4	CA2	Cathode2	
5	V _{DD}	3.3V power supply	
6	V _{DD}	3.3V power supply	
7	CM	Mode select signal(High or Open: Necessity of V _{H SYNC} , GND: Unnecessity of V _{H SYNC})	
8	ENAB	Data Enable (positive)	
9	V _{SYNC}	Vertical synchronous signal (negative)(fix low or high: when CM fixed to GND)	
10	H _{SYNC}	Horizontal synchronous signal (negative) (fix low or high: when CM fixed to GND)	
11	GND	GND	
12	B5	BLUE data signal (MSB)	
13	B4	BLUE data signal	
14	B3	BLUE data signal	
15	GND	GND	
16	B2	BLUE data signal	
17	B1	BLUE data signal	
18	B0	BLUE data signal (LSB)	
19	GND	GND	
20	G5	GREEN data signal (MSB)	
21	G4	GREEN data signal	
22	G3	GREEN data signal	
23	GND	GND	
24	G2	GREEN data signal	
25	G1	GREEN data signal	
26	G0	GREEN data signal (LSB)	
27	GND	GND	
28	R5	RED data signal (MSB)	
29	R4	RED data signal	
30	R3	RED data signal	
31	GND	GND	
32	R2	RED data signal	
33	R1	RED data signal	
34	R0	RED data signal (LSB)	
35	SC	Scan direction control(GND or Open: Normal, High: Reverse)	
36	GND	GND	
37	GND	GND	
38	CK	Sampling clock	
39	GND	GND	
40	GND	GND	

LCD connector : IMSA-9681S-40A-GF (IRISO)
 Recommended matching FFC or FPC : 0.5mm pitch

1) Scanning

SC : GND or Open

SC : High



7-2. Touch panel

No.	Symbol	Description
1	xR	x-Right terminal
2	yL	y-Lower terminal
3	xL	x-Left terminal
4	yU	y-Upper terminal

Touch panel side connector : 1mm pitch

Recommended matching connector : Series 9616 (IRISO)

: Series 9610 (IRISO)

: Series FMS (JST)

8. Input timing characteristics

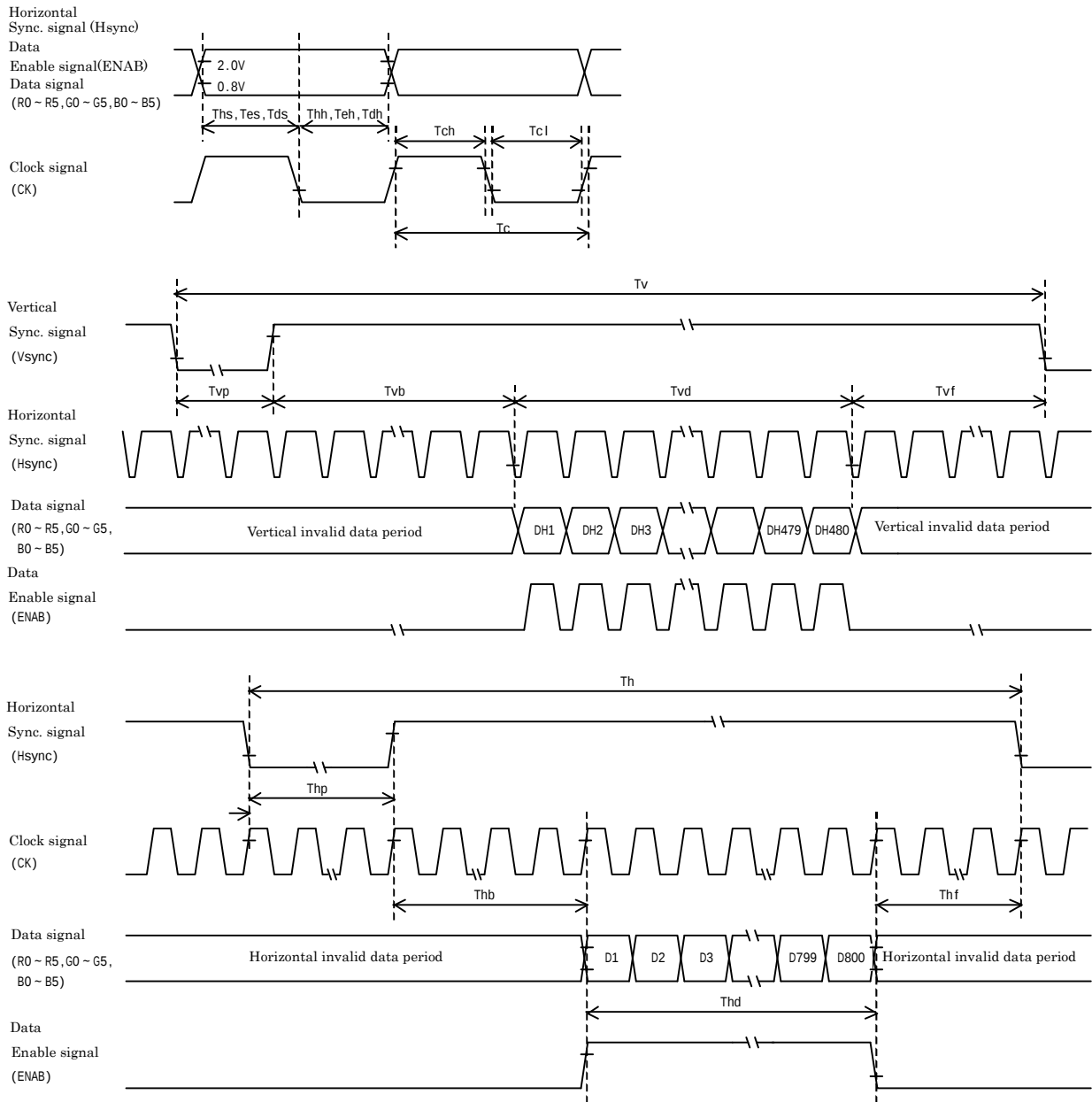
8-1. CM : High or Open (Necessity of V_{H SYNC})

8-1-1. Timing characteristics

Item		Symbol	Min.	Typ.	Max.	Unit	Note
Clock	Frequency	Fck	29.88	33.2	36.52	MHz	
	Period	Tc	27.4	30.1	33.5	ns	
	High time	Tch	12	-	-	ns	
	Low time	Tcl	12	-	-	ns	
Data	Set up time	Tds	5	-	-	ns	
	Hold time	Tdh	10	-	-	ns	
Data Enable	Set up time	Tes	5	-	-	ns	
	Hold time	Teh	10	-	-	ns	
Horizontal sync. signal	Set up time	Ths	5	-	-	ns	
	Hold time	Thh	10	-	-	ns	
	Period	Th	944	1056	1088	Tc	
			-	31.8	-	μs	
	Pulse width	Thp	4	128	-	Tc	
	Front porch	Thf	-	40	-	Tc	
	Back porch	Thb	7	88	-	Tc	
Horizontal display period		Thd	800			Tc	
Vertical sync. signal	Period	Tv	516	525	534	Th	
			14.7	16.6	17.4	ms	
	Pulse width	Tvp	1	2	-	Th	
	Front porch	Tvf	-	11	-	Th	
	Back porch	Tvb	4	32	-	Th	
Vertical display period		Tvd	480			Th	

- 1) In case of lower frequency, the deterioration of the display quality, flicker etc., may occur.
- 2) If CK is fixed to "H" or "L" level for certain period while ENAB is supplied, the panel may be damaged.
- 3) When dimming LED by PWM, please adjust LCD operating signal timing and LED driving frequency, to optimize the display quality. There is a possibility that flicker is observed by the interference of LCD operating signal timing and LED driving condition (especially driving frequency), even if the condition satisfies above timing specification.
- 4) Do not make Tv, Th, and Thp fluctuate.
- 5) CK count of each Horizontal Scanning Time should be always the same.
Vertical invalid data period should be "n" X "Horizontal Scanning Time" . (n: integer)
Frame period should be always the same.

8-1-2. Input timing characteristics



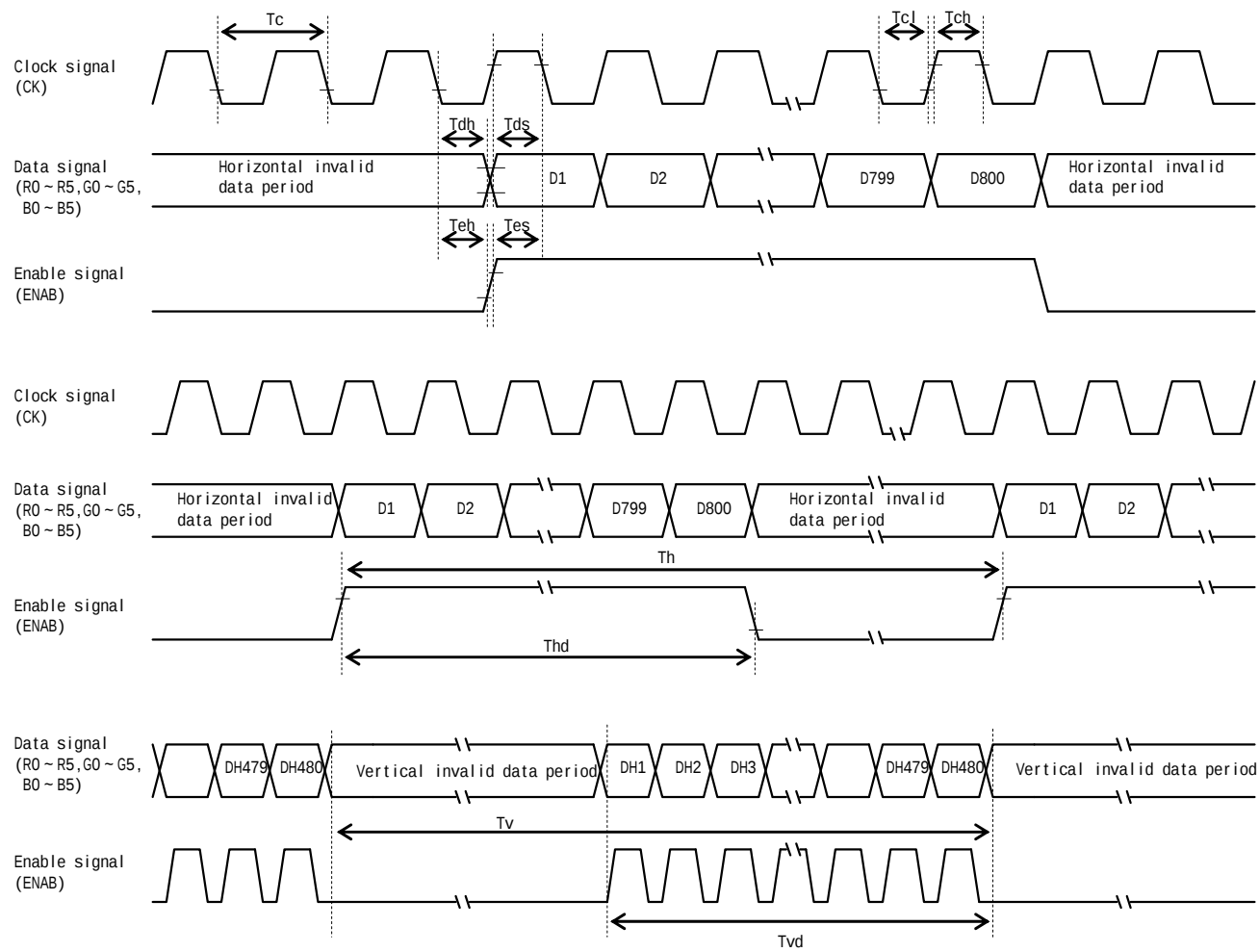
8-2 . CM : GND (Uunnecessity of V• H_{SYNC})

8-2-1. Timing characteristics

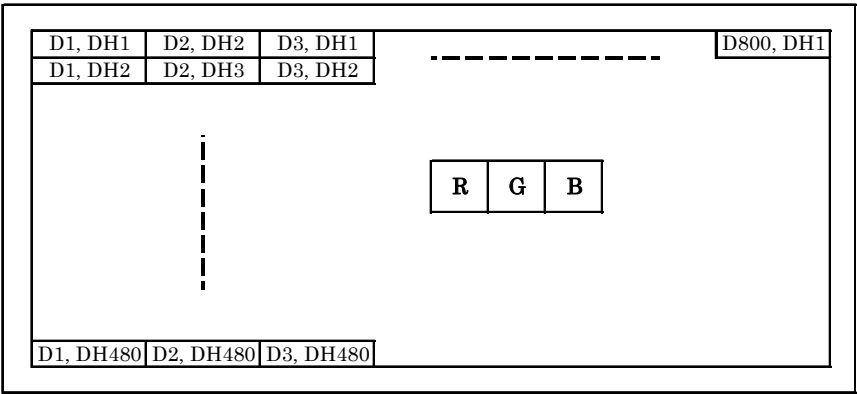
	Item	Symbol	Min.	Typ.	Max.	Unit	Note
Clock	Frequency	Fck	29.88	33.2	36.52	MHz	
	Period	Tc	27.4	30.1	33.5	ns	
	High time	Tch	12	-	-	ns	
	Low time	Tcl	12	-	-	ns	
Data	Set up time	Tds	5	-	-	ns	
	Hold time	Tdh	10	-	-	ns	
Enable	Set up time	Tes	5	-	-	ns	
	Hold time	Teh	10	-	-	ns	
	Period	Th	1024	1056	1088	Tc	
			-	31.8	-	μs	
	Horizontal display period	Thd	800			Tc	
	Period	Tv	487	525	550	Th	
			14.7	16.6	17.4	ms	
	Vertical display period	Tvd	480			Th	

- 1) In case of lower frequency, the deterioration of the display quality, flicker etc., may occur.
- 2) If CK is fixed to "H" or "L" level for certain period while ENAB is supplied, the panel may be damaged.
- 3) When dimming LED by PWM, please adjust LCD operating signal timing and LED driving frequency, to optimize the display quality. There is a possibility that flicker is observed by the interference of LCD operating signal timing and LED driving condition (especially driving frequency), even if the condition satisfies above timing specification.
- 4) Do not make Tv, Th, and Thp fluctuate.
- 5) CK count of each Horizontal Scanning Time should be always the same.
Vertical invalid data period should be "n" X "Horizontal Scanning Time" . (n: integer)
Frame period should be always the same.

8-2-2. Input timing characteristics



8-3. Input Data Signals and Display position on the screen



9. Backlight characteristics

Item	Symbol	Min.	Typ.	Max.	Unit	Note
Forward current 1)	IF	-	60	-	mA	Ta=-20 ~ 70°C
Forward voltage 1)	VF	-	12.6	14.7	V	IF=60mA, Ta=-20
		-	12.0	14.1	V	IF=60mA, Ta=25
		-	11.6	13.8	V	IF=60mA, Ta=70
Operating life time 2), 3)	T	-	70,000	-	h	IF=60mA, Ta=25

- 1) For each "AN-CA"
- 2) When brightness decrease 50% of minimum brightness.
The average life of a LED will decrease when the LCD is operating at higher temperatures.
- 3) Life time is estimated data.(Condition : IF=60mA, Ta=25 in chamber).
- 4) An input current below 15mA may reduce the brightness uniformity of the LED backlight.
This is because the amount of light from each LED chip is different. Therefore, please evaluate carefully before finalizing the input current.

10. Design guidance for analog touch panel

10-1. Electrical (In customer's design, please remember the following considerations.)

- 1) Do not use the current regulated circuit.
- 2) Keep the current limit with top and bottom layer. (Please refer to "Electrical absolute maximum ratings" for details.)
- 3) Analog touch panel can not sense two points touching separately.
- 4) A contact resistance is appeared at the touch point between top and bottom layer. After this resistance has stable read of the touch panel position data.
- 5) Because noise of inverter or peripheral circuits may interfere signal of touch panel itself it is necessary to design carefully in advance to avoid these noise problem.

10-2. Software

- 1) Do the "User Calibration".
- 2) "User Calibration" may be needed with long term using. Include "User Calibration" menu in your software.
- 3) When drawing a line with a stylus, there may be a slight discontinuity when the stylus passes over a spacer-dot. If necessary, please provide a compensation feature within your software.

10-3. Mounting on display and housing bezel

- 1) Do not use an adhesive tape to bond it on the front of touch panel and hang it to the housing bezel.
- 2) Never expand the touch panel top layer (PET-film) like a balloon by internal air pressure.
The life of the touch panel will be extremely short.
- 3) If a dew will be on the heat-sealed area or exposed traces at the end of a flexible tail, the migration of silver can occur. This will cause sometimes a short circuit.
- 4) Must maintain a gap between inside of bezel and touch panel to avoid malfunction or electrode damage of touch panel.

11. Lot number identification

The lot number shall be indicated on the back of the backlight case of each LCD.

TCG070WVLPAAFA-AA00 - □□ - □□ - □ MADE IN □□□□□
 ↓↓ ↓ ↓ ↓
 1 2 3 4 5

No1. - No5. above indicate 1. Year code 2. Month code 3. Date 4. Version Number 5. Country of origin (Japan or China)
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Year	2011	2012	2013	2014	2015	2016
Code	1	2	3	4	5	6

Month	Jan.	Feb.	Mar.	Apr.	May	Jun.
Code	1	2	3	4	5	6

Month	Jul.	Aug.	Sep.	Oct.	Nov.	Dec.
Code	7	8	9	X	Y	Z

12. Warranty

12-1. Incoming inspection

Please inspect the LCD within one month after your receipt.

12-2. Production warranty

Kyocera warrants its LCD's for a period of 12 months from the ship date. Kyocera shall, by mutual agreement, replace or re-work defective LCD's that are shown to be Kyocera's responsibility.

13. Precautions for use

13-1. Installation of the LCD

- 1) The LCD shall be installed so that there is no pressure on the LSI chips.
- 2) The LCD shall be installed flat, without twisting or bending.
- 3) Must maintain a gap between inside of bezel and touch panel to avoid malfunction or electrode damage of touch panel.
- 4) A transparent protection sheet is attached to the touch panel. Please remove the protection film slowly before use, paying attention to static electricity.

13-2. Static electricity

- 1) Since CMOS ICs are mounted directly onto the LCD glass, protection from static electricity is required.
- 2) Workers should use body grounding. Operator should wear ground straps.

13-3. LCD operation

- 1) The LCD shall be operated within the limits specified. Operation at values outside of these limits may shorten life, and/or harm display images.

13-4. Storage

- 1) The LCD shall be stored within the temperature and humidity limits specified.
Store in a dark area, and protect the LCD from direct sunlight or fluorescent light.
- 2) Always store the LCD so that it is free from external pressure onto it.

13-5. Usage

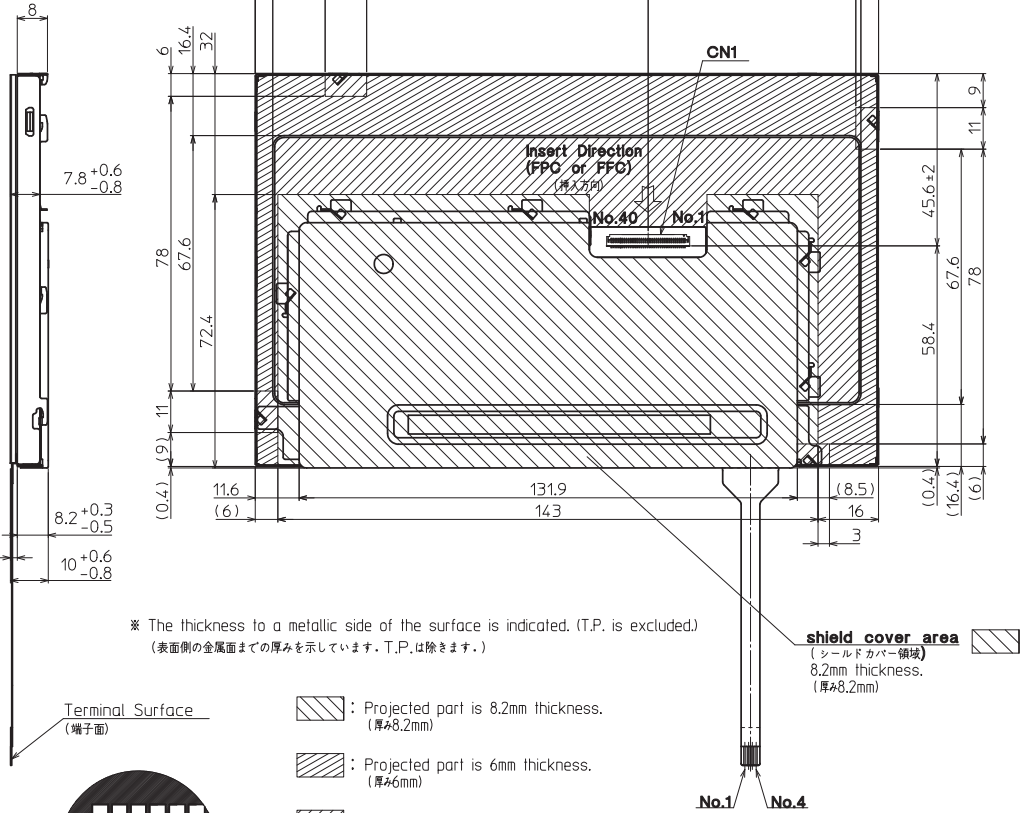
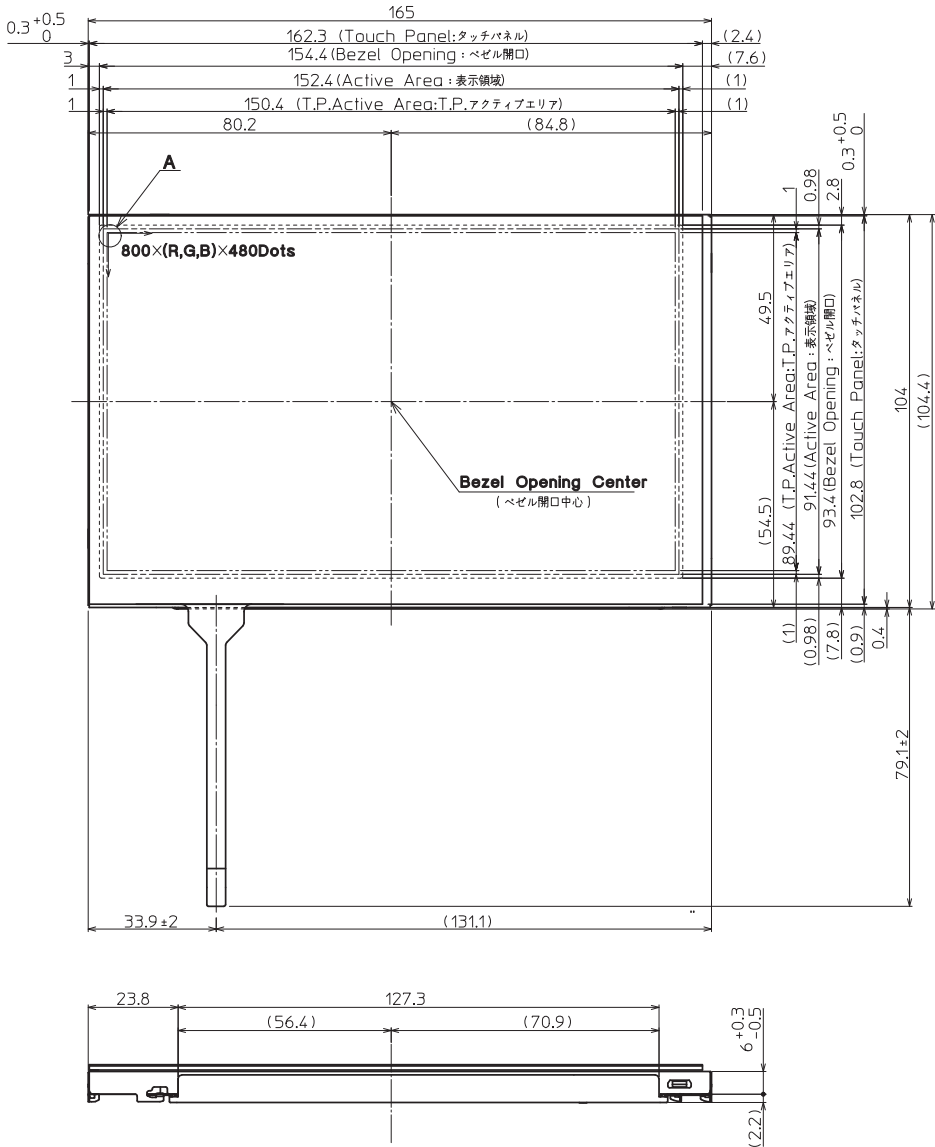
- 1) **DO NOT** store in a high humidity environment for extended periods. Polarizer degradation bubbles, and/or peeling off of the polarizer may result.
- 2) Do not push or rub the touch panel's surface with hard to sharp objects such as knives, or the touch panel may be scratched.
- 3) When the touch panel is dirty, gently wipe the surface with a soft cloth, sometimes moistened by mild detergent or alcohol. If a hazardous chemical is dropped on the touch panel by mistake, wipe it off right away to prevent human contact.
- 4) Touch panel edges are sharp. Handle the touch panel with enough care to prevent cuts.
- 5) Always keep the LCD free from condensation during testing. Condensation may permanently spot or stain the polarizer.
- 6) Do not disassemble LCD because it will result in damage.
- 7) This Kyocera LCD has been specifically designed for use in general electronic devices, but not for use in a special environment such as usage in an active gas. Hence, when the LCD is supposed to be used in a special environment, evaluate the LCD thoroughly beforehand and do not expose the LCD to chemicals such as an active gas.
- 8) Please do not use solid-base image pattern for long hours because a temporary afterimage may appear. We recommend using screen saver etc. in cases where a solid-base image pattern must be used.
- 9) Liquid crystal may leak when the LCD is broken. Be careful not to let the fluid go into your eyes and mouth. In the case the fluid touches your body; rinse it off right away with water and soap.

13. Reliability test data

Test item	Test condition	Test time	Judgement
High temp. atmosphere	80°C	240h	Display function : No defect Display quality : No defect Current consumption : No defect
Low temp. atmosphere	-30°C	240h	Display function : No defect Display quality : No defect Current consumption : No defect
High temp. humidity atmosphere	40°C 90% RH	240h	Display function : No defect Display quality : No defect Current consumption : No defect
Temp. cycle	-30°C 0.5h R.T. 0.5h 80°C 0.5h	10cycles	Display function : No defect Display quality : No defect Current consumption : No defect
High temp. operation	70°C	500h	Display function : No defect Display quality : No defect Current consumption : No defect
Point Activation life	Silicon rubber, Tip : R = 4.0 Hitting force 3N Hitting speed 2 time/s	one million times	Terminal resistance : No defect Insulation resistance : No defect Linearity : No defect Actuation Force : No defect

- 1) Each test item uses a test LCD only once. The tested LCD is not used in any other tests.
- 2) The LCD is tested in circumstances in which there is no condensation.
- 3) The reliability test is not an out-going inspection.
- 4) The result of the reliability test is for your reference purpose only.
The reliability test is conducted only to examine the LCD's capability.

No	Description	Drawn	Checked	Checked	Approved



※ The thickness to a metallic side of the surface is indicated. (T.P. is excluded.)
(表面側の金属面までの厚みを示しています。T.P.は除きます。)

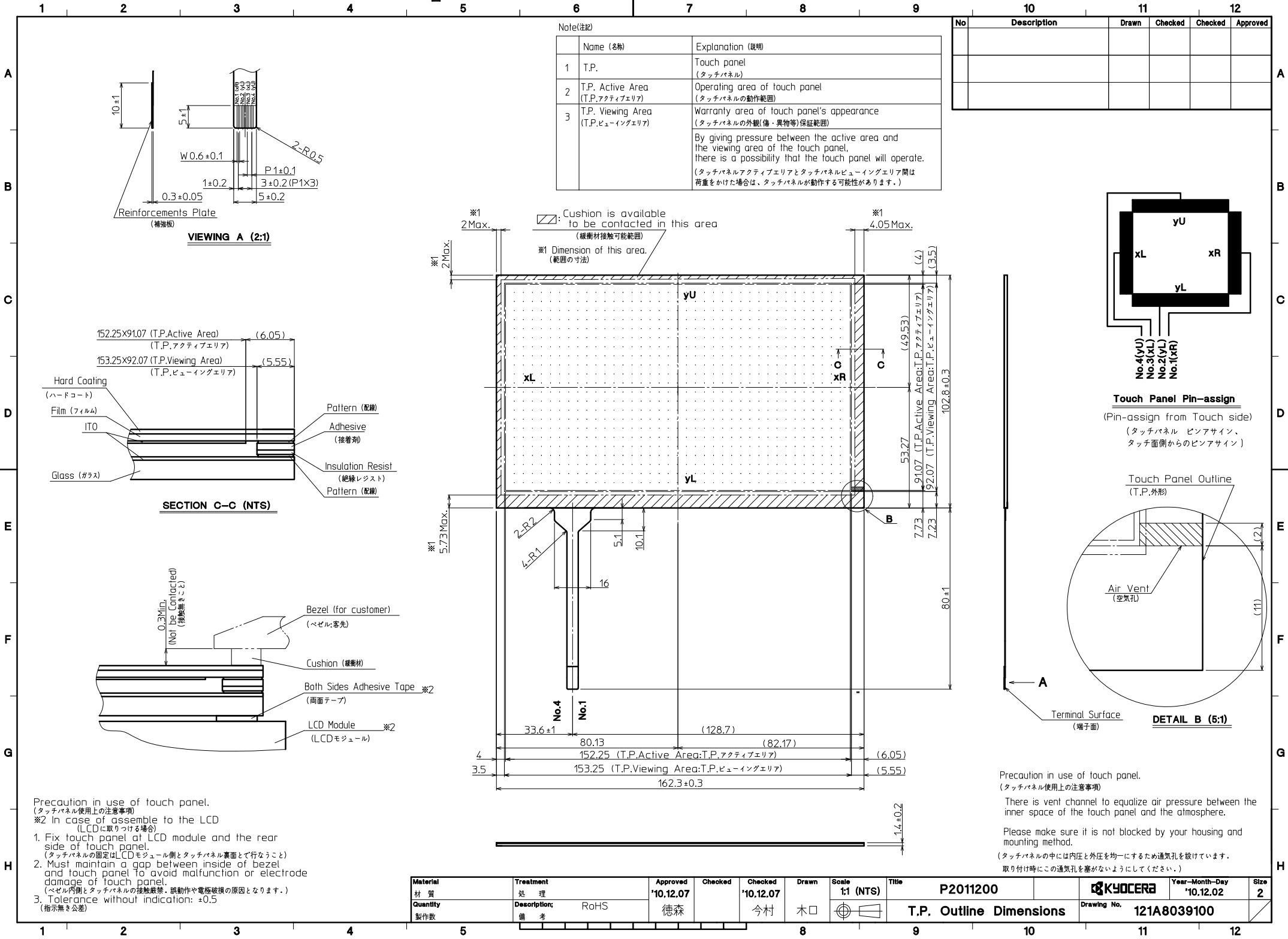
- Projected part is 8.2mm thickness.
(厚み8.2mm)
- Projected part is 6mm thickness.
(厚み6mm)
- Projected part is 5.5mm thickness.
(厚み5.5mm)



DETAIL A (Dot Size)
(NTS)

- Note. (注記)
- Connector CN1: IMSA-9681S-40A-GF (IRISO)
(コネクタ)
 - The information of LCD is displayed starting at the upper left hand corner, moving right then down to the lower right hand corner.
(LCDにおいて、画像データの表示は左上コーナーから始まり、右へ進み下へ進み右下コーナーへ向かう。)
 - Tolerance without indication : ±0.5
(指示無き公差)
 - Touch Panel P/N : P2011200 (121A8039100)

Material 材質	Treatment 処理	Approved '11.05.18	Checked	Checked '11.05.18	Drawn 圓福	Scale 1:1 (NTS)	Title TCG070WVLPAAFA	KYOCERA	Year-Month-Day '11.05.17	Size 2
Quantity 製作数	Description 備考	RoHS	朝倉	今村			Outline Dimensions	Drawing No. 121A8046200		



Spec No.	TQ3C-8EAF0-E2YAA28-00
Date	June 10, 2011

KYOCERA INSPECTION STANDARD

TYPE : TCG070WVLPAAFA-AA00

KYOCERA CORPORATION
LCD DIVISION

Original Issue Date	Designed by : Engineering dept.			Confirmed by : QA dept.	
	Prepared	Checked	Approved	Checked	Approved
June 10, 2011	<i>S. Hatamaka</i>	<i>Y. Ikeda</i>	<i>M. Fujitani</i>	<i>I. Hamano</i>	<i>T. Ishii</i>

Spec No.

TQ3C-8EAF0-E2YAA28-00

Part No.

TCG070WVLPAAFA-AA00

Page

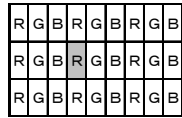
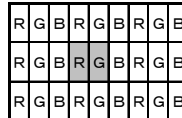
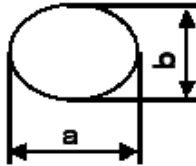
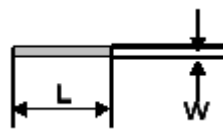
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Revision record

Date		Designed by : Engineering dept.			Confirmed by : QA dept.	
		Prepared	Checked	Approved	Checked	Approved
Rev.No.	Date	Page	Descriptions			

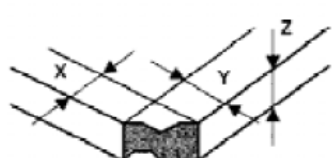
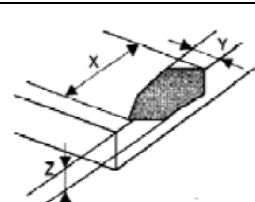
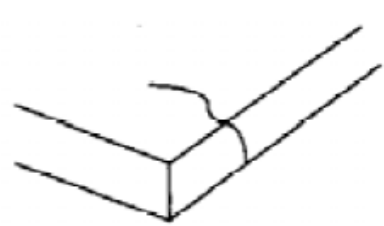
Visuals specification

1) Note

	Note		
General	- Customer identified anomalies not defined within this inspection standard shall be reviewed by Kyocera, and an additional standard shall be determined by mutual consent. - This inspection standard about the image quality shall be applied to any defect within the effective viewing area and shall not be applicable to outside of the area. - Inspection conditions - Luminance : 500 Lux min. - Inspection distance : 300 mm. - Temperature : 25 ± 5 - Direction : Directly above		
Definition of inspection item	Dot defect	Bright dot defect	The dot is constantly “on” when power applied to the LCD, even when all “Black” data sent to the screen. Inspection tool: 5% Transparency neutral density filter. Count dot: If the dot is visible through the filter. Don't count dot: If the dot is not visible through the filter. 
		Black dot defect	The dot is constantly “off” when power applied to the LCD, even when all “White” data sent to the screen.
		Adjacent dot	Adjacent dot defect is defined as two or more bright dot defects or black dot defects. 
	External inspection	Bubble, Scratch, Foreign particle (Polarizer, Cell, Backlight)	Visible operating (all pixels “Black” or “White”) and non operating.
		Appearance inspection	Does not satisfy the value at the spec.
	Others	LED wires	Damaged to the LED wires, connector, pin, functional failure or appearance failure.
	Definition of size	Definition of circle size  $d = (a + b) / 2$ Definition of linear size 	

2) Standard

Classification		Inspection item		Judgement standard		
Defect (in LCD glass)	Dot defect	Bright dot defect		Acceptable number : 4 Bright dot spacing : 5 mm or more		
		Black dot defect		Acceptable number : 5 Black dot spacing : 5 mm or more		
		2 dot join	Bright dot defect	Acceptable number : 2		
			Black dot defect	Acceptable number : 3		
		3 or more dots join		Acceptable number : 0		
		Total dot defects		Acceptable number : 5 Max		
	Others	White dot, Dark dot (Circle)				
				Size (mm)		Acceptable number
d 0.2				(Neglected)		
0.2 < d 0.4				5		
0.4 < d 0.5				3		
0.5 < d				0		
External inspection (Defect on Polarizer or between Polarizer and LCD glass)	Polarizer (Scratch)					
			Width (mm)		Length (mm)	Acceptable number
			W 0.1		-	(Neglected)
			0.1 < W 0.3	L 5.0		(Neglected)
				5.0 < L		0
	0.3 < W		-	0		
	Polarizer (Bubble)					
			Size (mm)		Acceptable number	
			d 0.2		(Neglected)	
			0.2 < d 0.3		5	
			0.3 < d 0.5		3	
	0.5 < d		0			
	Foreign particle (Circular shape)					
			Size (mm)		Acceptable number	
			d 0.2		(Neglected)	
			0.2 < d 0.4		5	
			0.4 < d 0.5		3	
	0.5 < d		0			
	Foreign particle (Linear shape) Scratch					
			Width (mm)		Length (mm)	Acceptable number
			W 0.03		-	(Neglected)
0.03 < W 0.1			L 2.0		(Neglected)	
			2.0 < L 4.0		3	
			4.0 < L		0	
0.1 < W			-	(According to circular shape)		

Inspection item	Judgement standard					
Scratch, Foreign particle (Touch screen portion)	(W = Width, L = Length, D = Diameter = (major axis + minor axis)/ 2)					
	Item	Width(mm)		Length(mm)	Acceptable number	
	Scratch	W	0.03	L 20	Neglected	
		0.03 < W	0.05	L 10	2pces within φ20mm	
		0.05 < W	0.08	L 6	2pces within φ20mm	
		0.08 < W	0.1	L 4	1pces within φ30mm	
	Foreign (line like)	W	0.05	Neglected	Neglected	
		0.05 < W	0.1	L 5	2pces within φ30mm	
	Foreign (circle like)	D	0.2	Neglected		
		0.2 < D	0.3	2pces within φ30mm		
Above are applied to the visible area.						
Unless there are foreign particle and damage affected seriously to the electrical performance out of the active area, we approve of this product.						
Glass crack (Touch screen portion)	Item	Size (mm)			Acceptable number	
	Conner crack			X	3	2 pcs /panel
				Y	3	
				Z	< t	
	Crack in other area than in corner			X	5	2 pcs /side
				Y	1.5	
				Z	< t	
	Progressive crack				0 pcs (NG even 1pcs)	
	Above are applied to the visible area.					
	Unless there are foreign particle and damage affected seriously to the electrical performance out of the active area, we approve of this product.					
Newton's ring	Neglected.					
	