CONFIDENTIAL(B)

SPECIFICATION

OF

LIQUID CRYSTAL DISPLAY MODULE

UNITED RADIANT TECHNOLOGY CORP. 光聯科技 Dec-11-2024 品管部 QC DEPT.

CUSTOMER : URT-STD

Model No. : UMOH-9153MD-1T

Model version : 0

Document Revision : 5

CUSTOMER APPROVED SIGNATURE			

This specification need to be signed by purchaser or customer as a specification of products production and delivery from URT. Without signature of this specification , any purchase order for this model no. will be treated and considered that this specification is automatically acknowledged and accepted by purchaser or customer.

U.R.T. UNITED RADIANT TECHNOLOGY CORPORATION

Joe Wu	Ashin Chiu	Jenny Wang	Dec-11-2024
APPROVED	CHECKED	PREPARED	Date

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Revision record

Document Revision	Model No. Version No.	Description	Revision by
0	UMSH-9153MD-T Version No. 0		Peggy Ho Fong Jia Su 22-Jun-2016
1	UMSH-9153MD-1T Version No. 0	1. Add the resistive touch panel 2. Modify the module number for UMSH-9153MD-T to UMSH-9153MD-1T.	Peggy Ho Y.C. Lin 30-Nov-2017
2	UMSH-9153MD-1T Version No. 1	Modify the packing mode.	Peggy Ho Y.C. Lin 03-Oct-2018
3	UMSH-9153MD-1T Version No. 2	Add the inspection for TP newton ring.	Peggy Ho Y.C. Lin 28-Aug-2019
4	UMSH-9153MD-1T Version No. 3	Add the operating life of finger touch & pen sliding.	Peggy Ho Y.C. Lin 07-Aug-2020
5	UMOH-9153MD-1T Version No. 0	1. Change LCD and Driver IC 2. Modify the module number for UMSH-9153MD-1T to UMOH-9153MD-1T.	Micky Ko Eric Wang 11-Dec-2024

CONTENTS:

1. BASIC SPECIFICATION

1.1 Mechanical specifications

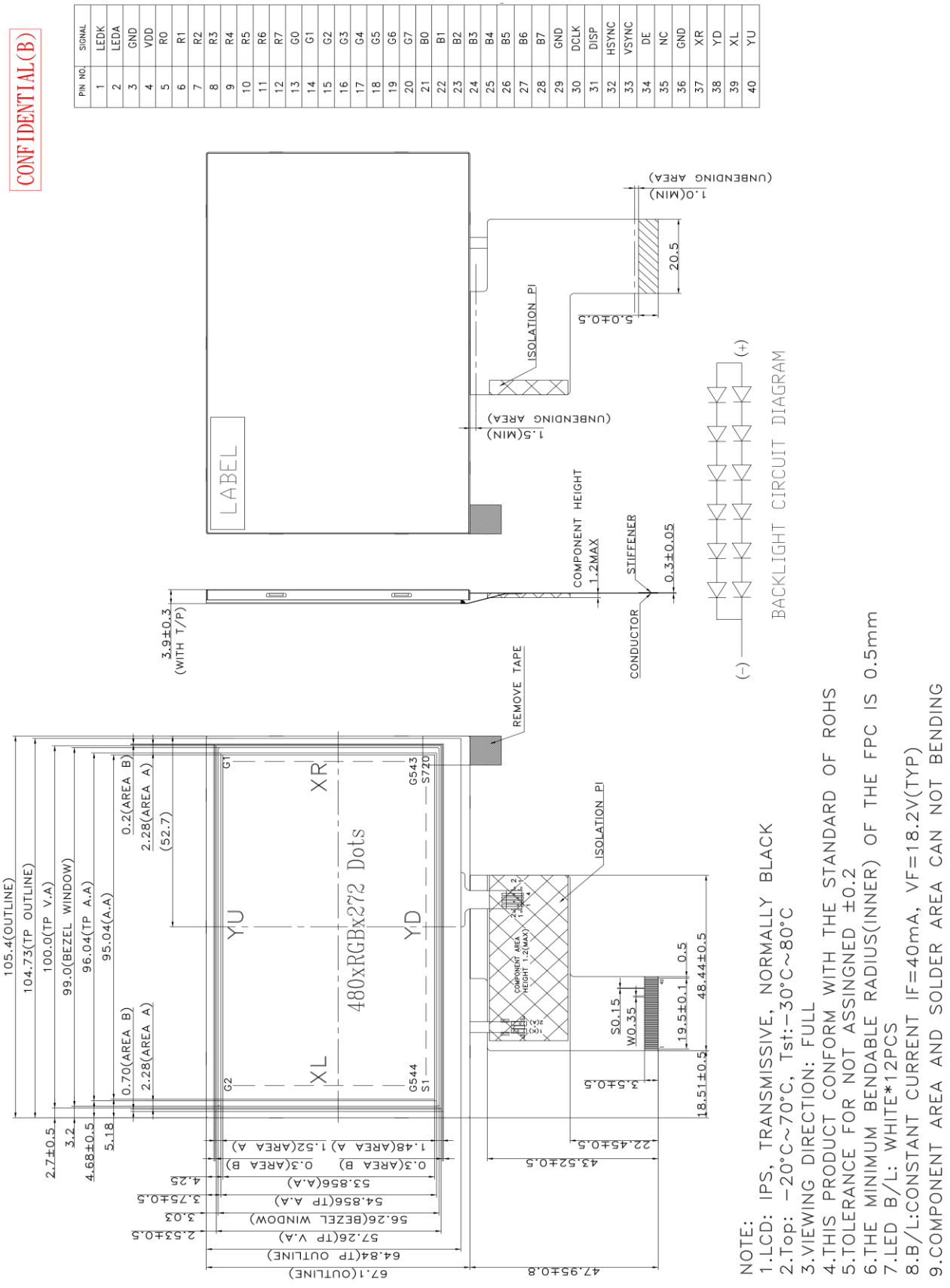
Items	Nominal Dimension	Unit
Active screen size	4.3” diagonal	-
Dot Matrix	480 x RGB x 272	Pixel
Module Size (W x H x T)	105.4 x 67.1 x 3.9	mm.
Active Area (W x H)	95.04 x 53.856	mm.
Pixel Size (W×H)	0.198 x 0.198	mm.
Color depth	16.7M	color
Interface	Parallel 24-bit RGB	-
Driving IC Package	COG	-
Module weight	52±10%	g

1.2 Display specification

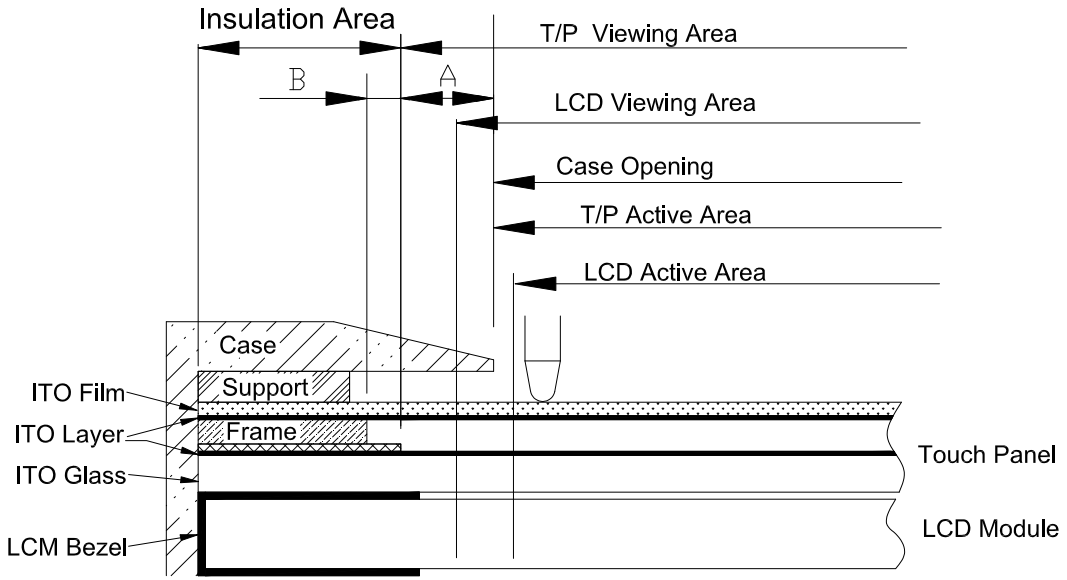
Display	Descriptions	Note
LCD Type	a-Si TFT	-
LCD Mode	Normally Black	-
Polarizer Mode	Transmissive	-
Polarizer Surface	ANTI-GLARE	-
Pixel arrangement	RGB-stripe	-
Backlight Type	LED	-
Viewing Direction(Gray inversion)	Free	-

*Color tone is slightly changed by temperature and driving voltage.

1.3 Outline dimension

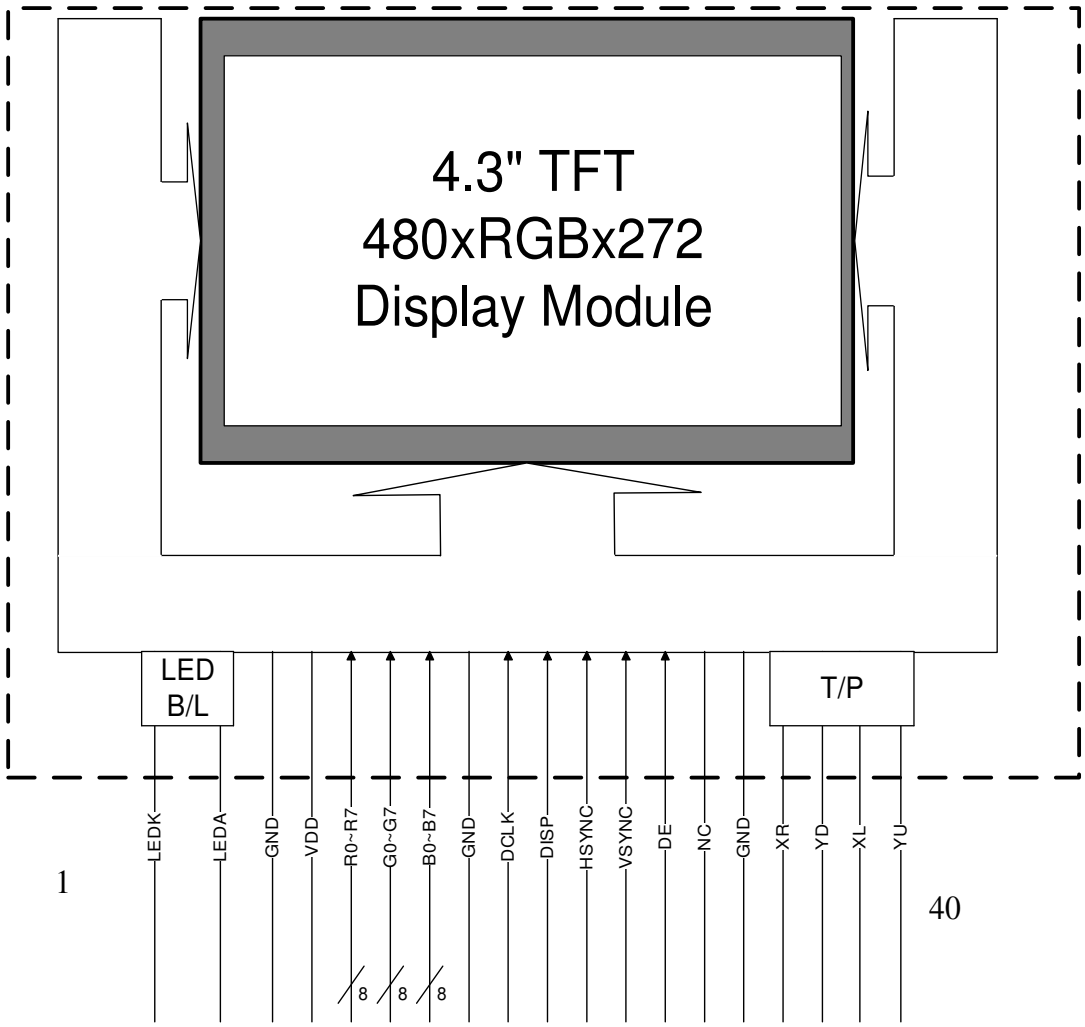


Attention for Assembly and Operation



(1) T/P Active Area : Means T/P guaranteed active area , where the feature and function of the T/P can be assured.
(2) Area A : Where the T/P can be operated but the feature and function are not guaranteed.
(3) Area B : This area is prohibited to contact , it is easy to hurt the ITO film and lose function once be touched .
(4) a. Customer should design the "Support " in between the case and T/P ,with sufficient thickness to ensure once the case was deformed or pressed unintendedly , the T/P can still work normally .
b. Support need to be designed within the frame size.
c. We suggest to the support thickness as 0.5mm , but customer should adapt suitable thickness according to the case deformation.
(5) The best design of customer's case opening is suggest ed to cover the LCD Viewing area and aligned with the T/P Active Area ,or in between the dimension of LCD Viewing area and T/P Active Area . But once if the LCD Viewing area was smaller than T/P Active Area ,then the case opening should be aligned with LCD Viewing area .
(6) Never use double sided tape or glue in between the support the ITO film , it will cause harm to ITO film or seperate the T/P with the ITO film.

1.4 Block diagram:



1.5 Interface Pin Connection :

Pin No.	Pin Symbol	I/O	Description
1	LEDK	P	Power for LED backlight cathode.
2	LEDA	P	Power for LED backlight anode.
3	GND	P	Power Ground.
4	VDD	P	Power Voltage.
5 ~ 12	R0 ~ R7	I	Red data signal.
13 ~ 20	G0 ~ G7	I	Green data signal.
21 ~ 28	B0 ~ B7	I	Blue data signal.
29	GND	P	Power Ground.
30	DCLK	I	Dot data clock.
31	DISP	I	Display on/off.
32	HSYNC	I	Horizontal sync signal.
33	VSYNC	I	Vertical sync signal.
34	DE	I	Data Enable.
35	NC	-	No connect.
36	GND	P	Power Ground.
37	XR	I/O	RTP XR.
38	YD	I/O	RTP YD.
39	XL	I/O	RTP XL.
40	YU	I/O	RTP YU.

2. ELECTRICAL CHARACTERISTICS

2.1 Absolute Maximum Ratings

Items	Symbol	Min.	Max.	Unit
Power supply voltage	VDD	-0.3	4.0	V
Operate temperature range	TOP	-20	70	℃
Storage temperature range	TST	-30	80	℃

*Note1 :

The operating temperature is for product's functionality, please pay attention to human injury when using the product under extreme temperature.

2.2 DC Characteristics

T_a= 25°C

Items	Symbol	Min.	Typ.	Max.	Unit	Condition
Supply voltage	VDD	3.0	3.3	3.6	V	-
Input Voltage	V_{IL}	0	-	0.3VDD	V	L level
	V_{IH}	0.7VDD	-	VDD	V	H level
Current consumption	I_{VDD}	-	-	40	mA	Note 1

*Note1 :
Measuring Condition:
Standard Value MAX.
Ta = 25°C
VDD -GND = 3.3V
Display Pattern

2.3 Back-light only Specification

PARAMETER	SYMBOL	MIN	TYP	MAX	Unit	Test Condition	NOTE
Supply Current	If	-	40	-	mA	Ta=25°C	-
Supply Voltage	Vf	-	18.2	-	V	Ta=25°C	-
Half-Life Time	Lf	-	50000	-	hrs	Ta=25°C	1

Note 1：**The "Half-Life Time" is defined as the LED chip brightness decreases to 50% than original brightness, Based on Ta 25±2°C,60±10% RH condition.**

2.4 AC Characteristics

Parallel RGB Input Timing Requirement

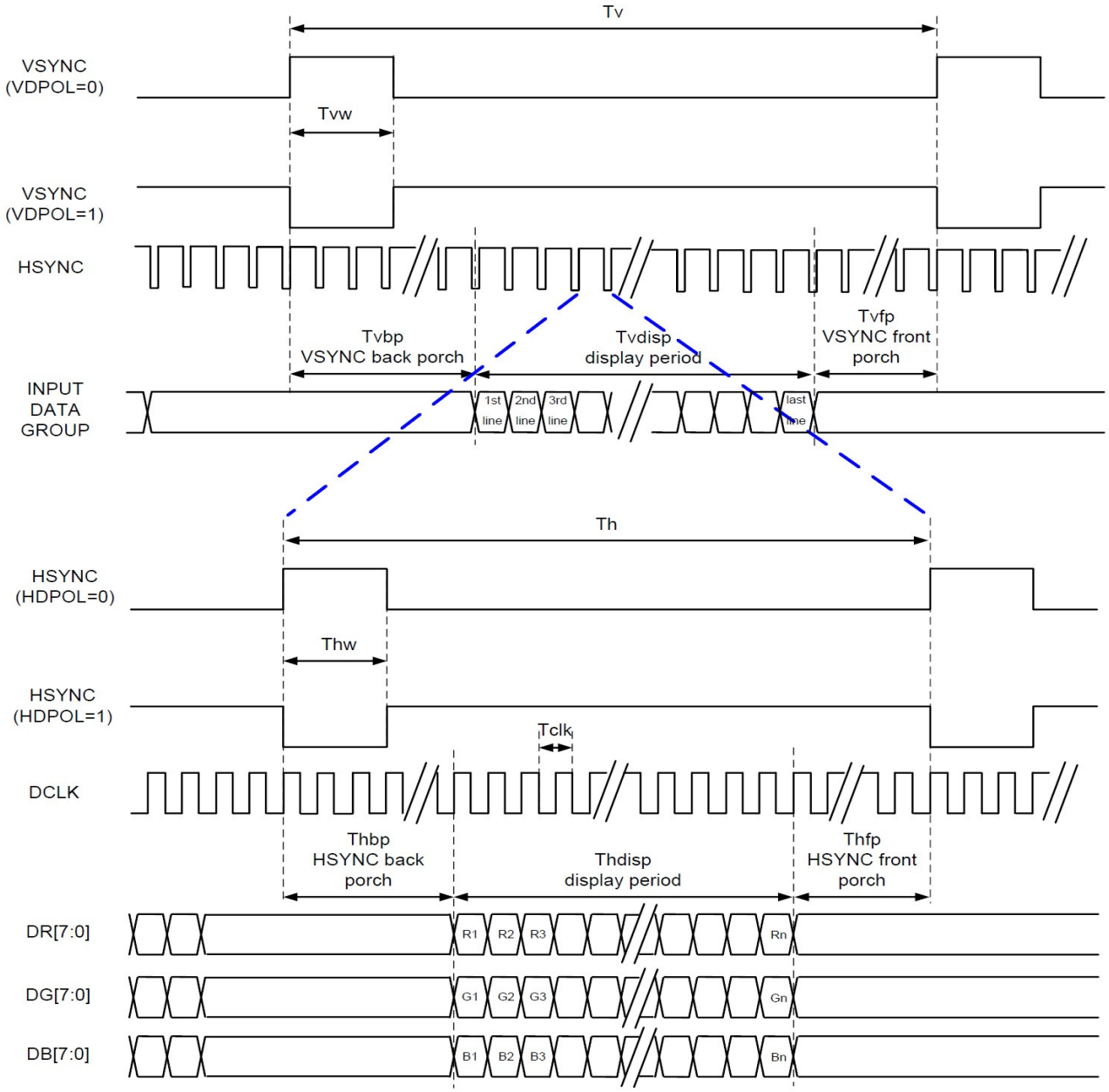
Parallel 24-bit RGB Input Timing (PVDD=VDD=VDDI= 3.3V, AGND= 0V, TA=25°C)

480RGB X 272 Resolution Timing Table							
Item		Symbol	Min.	Typ.	Max.	Unit	Remark
DCLK Frequency		Fclk	8	9	12	MHz	
DCLK Period		Tclk	83	111	125	ns	
HSYNC	Period Time	Th	485	531	598	DCLK	
	Display Period	Thdisp	-	480	-	DCLK	
	Back Porch	Thbp	3	43	43	DCLK	By H_BLANKING setting
	Front Porch	Thfp	2	8	75	DCLK	
	Pulse Width	Thw	2	4	75	DCLK	
VSYNC	Period Time	Tv	276	292	321	HSYNC	
	Display Period	Tvdisp	-	272	-	HSYNC	
	Back Porch	Tvbp	2	12	12	HSYNC	By V_BLANKING setting
	Front Porch	Tvfp	2	8	37	HSYNC	
	Pulse Width	Tvw	2	4	37	HSYNC	

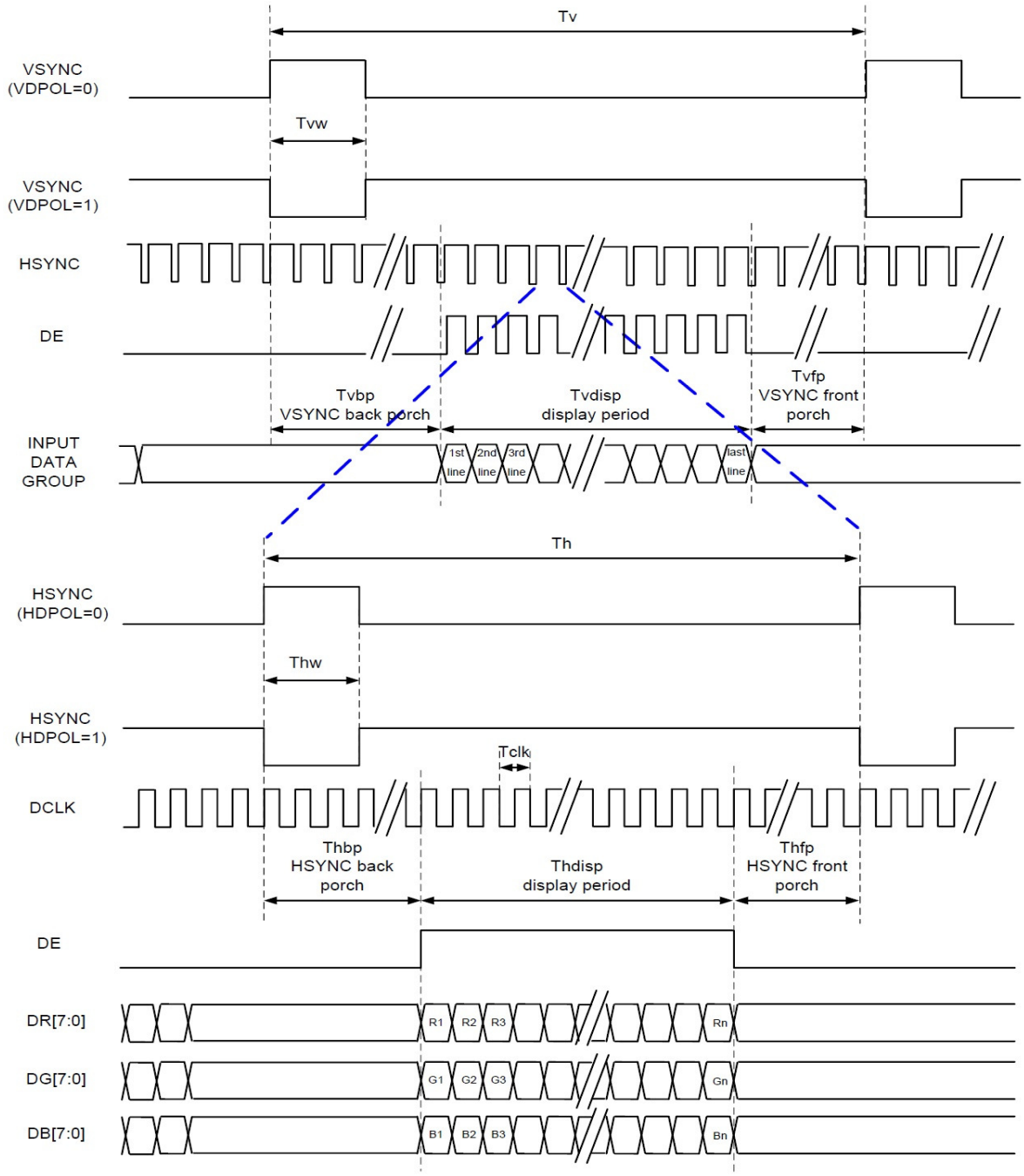
Note: It is necessary to keep Tvbp =12 and Thbp =43 in sync mode. DE mode is unnecessary to keep it.

Interface Timing Chart

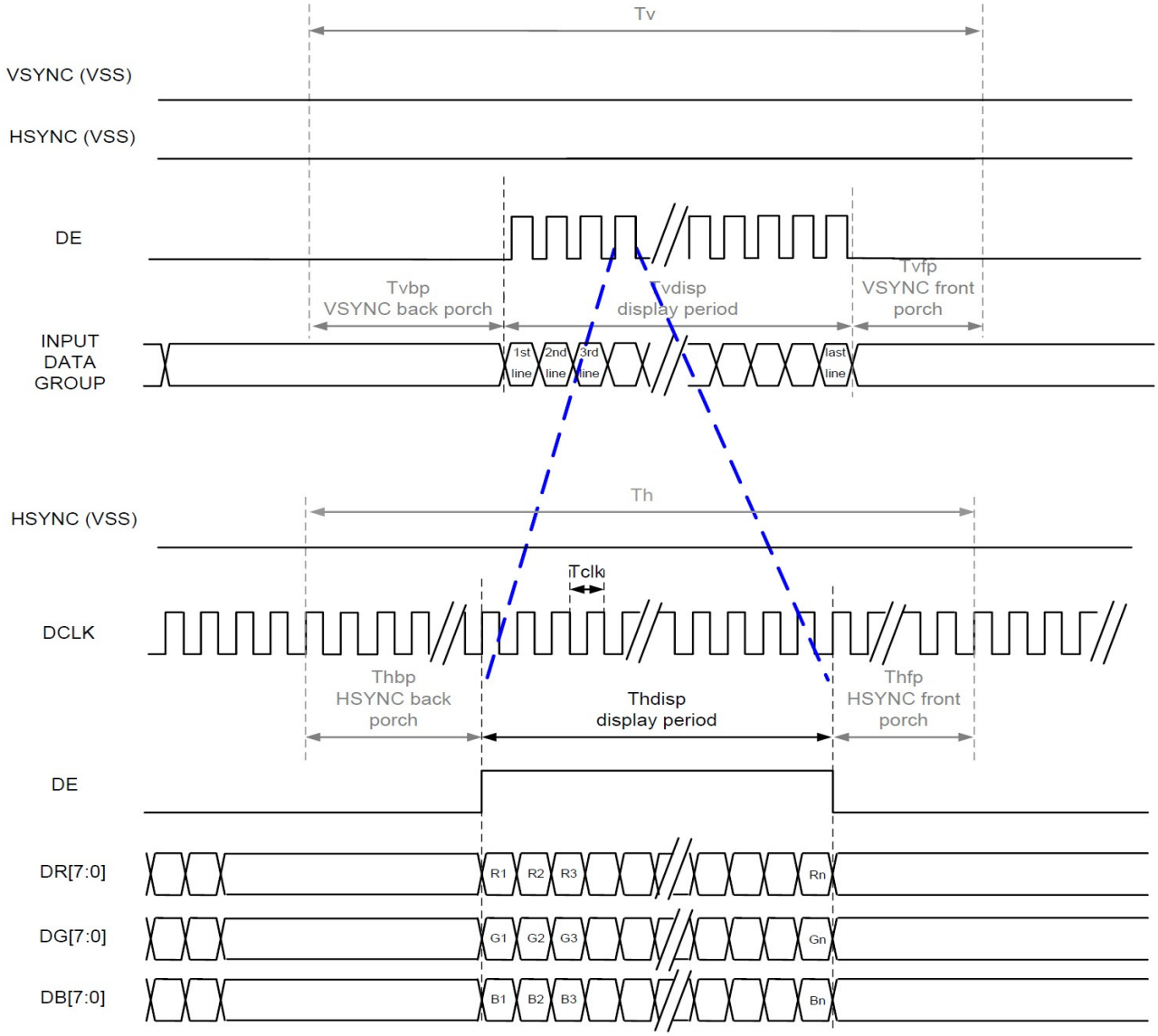
RGB Interface
SYNC Mode



SYNC-DE Mode


Tv
VSYNC (VDPOL=0)
Tvw
VSYNC (VDPOL=1)
HSYNC
DE
Tvbp VSYNC back porch
Tvdisp display period
Tvfp VSYNC front porch
INPUT DATA GROUP
1st line
2nd line
3rd line
last line
Th
HSYNC (HDPOL=0)
Thw
HSYNC (HDPOL=1)
Tclk
DCLK
Thbp HSYNC back porch
Thdisp display period
Thfp HSYNC front porch
DE
DR[7:0]
R1
R2
R3
Rn
DG[7:0]
G1
G2
G3
Gn
DB[7:0]
B1
B2
B3
Bn

DE Mode

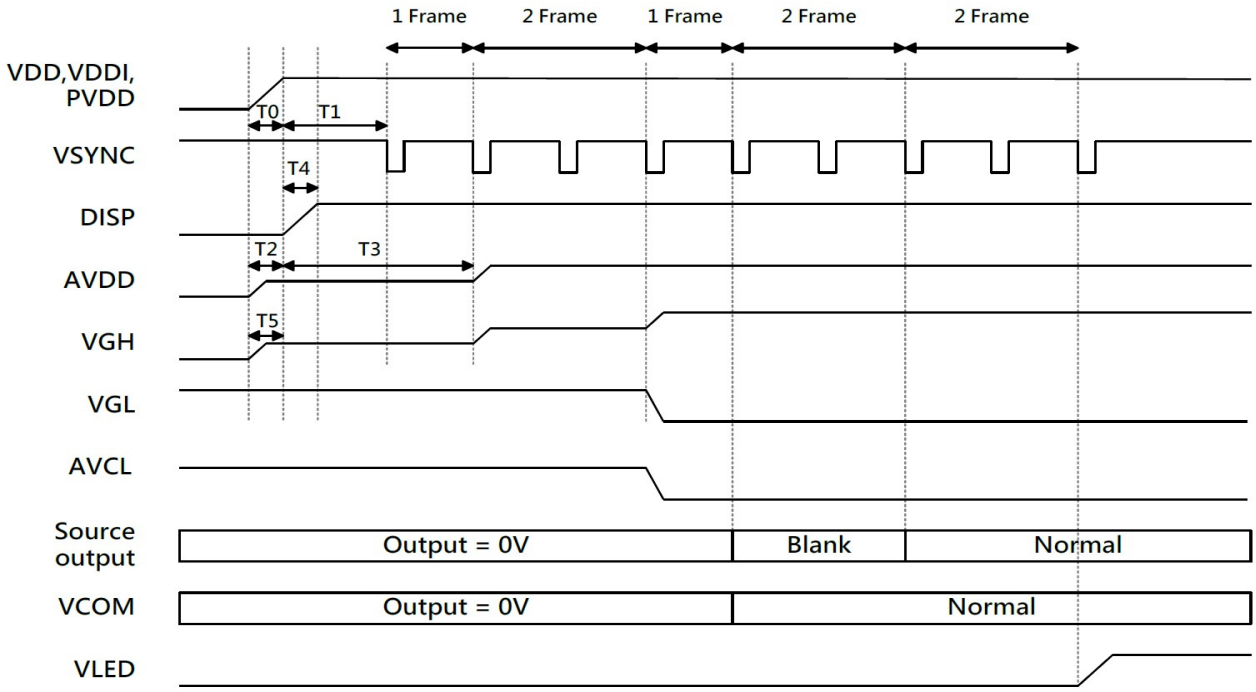


RGB Mode Selection Table	DCLK	HSYNC	VSYNC	DE
SYNC - DE Mode	Input	Input	Input	Input
SYNC Mode	Input	Input	Input	GND
DE Mode	Input	GND	GND	Input

Note: "Input" means these signals are driven by host side.

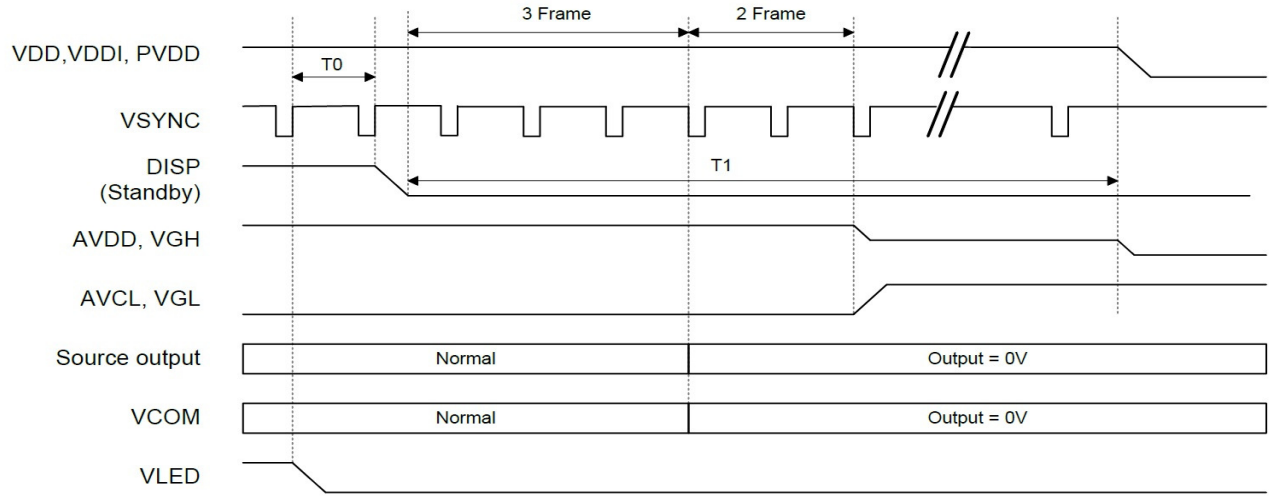
2.5 Power Sequence Timing

Power On Sequence



	Description	Min. Time
T0	Determined by the external power	
T1	Time from stable VDD, VDDI, PVDD set-up to the first VSYNC	T1=0
T2	Time from AVDD=0V to AVDD=3.3V	T2=T0
T3	Time from AVDD=3.3V to AVDD=6.0V	T3=T1+ (1*Frame)
T4	Time from stable VDD, VDDI, PVDD set-up to DISP asserted	T4=0
T5	Time from VGH=0V to VGH=3.3V	T5=T0

Power Off Sequence



Item	Description	Min. Time
T0	Time from backlight power off to DISP="L"	1*Frame
T1	Time from DISP="L" to LCM Power off	5*Frame

2.6 Touch Panel Specifications

2.6.1 Mechanical specifications

Items	Nominal Dimension	Unit
Module Size (W×H×T)	104.73±0.3 × 64.84±0.3	mm.
Viewing Area (W×H)	100.0±0.3 × 57.26±0.3	mm.
Active Area (W×H)	96.04±0.3 × 54.86±0.3	mm.
Thickness	1.15±0.2(without protective film)	mm.

2.6.2 Touch Panel Specifications

Display	Descriptions	Note
Type	4-wires Analog Resistive Touch Panel	-
Structure	Anti-glare ITO Film：T=0.188mm	-
	ITO Glass：T=0.7mm	-
Environment Characteristic	Operation Temperature：-20℃～70℃	-
	Storage Temperature：-30℃～80℃	-
Surface Hardness	＞3H	3H pencil, pressure 500g/45° (JIS-K5600)
Input mode	Stylus or Finger	-
Operation force	100g Max.	Stylus R0.8mm
Connector Type	FPC	-

2.6.3 Optical Characteristics:

Items	Descriptions	Note
Optical Characteristics	Haze Value：＜10%	-
Light Transmittance	Typ： ＞78%	Active Area

2.6.4 Mechanical Characteristics

Items	Descriptions	Note
FPC Strength (Vertical)	Strength≧500g/cm； Pull Rate：50mm/min	-
Steel Ball Drop Test	Φ9mm Steel Ball, 50cm height	No damage
Finger Touch	1,000K times	Operating life
Pen Sliding	100K times	Operating life

2.6.5 Electric Characteristics

Items	Descriptions	Note
(1) Linearity	X-axis≦±1.5% Y-axis≦±1.5%	Active Area toward inner 2mm
(2) Insulation Resistance	DC25V、≧20 MΩ	-
(3) Terminal Resistance	X-axis：350～1100Ω	-
	Y-axis：100～450Ω	-
(4) Response Time	≦10ms	-

2.6.6 Reliability Test

Items	Condition	Note
High Temperature Storage	80℃ ，200hrs	1
Low Temperature Storage	-30℃ ，200hrs	1
High Temperature and High Humidity Storage	60℃ 、90%RH ，100hrs	2
Thermal Shock	-20℃ ，30min←→ 70℃ ，30min 10Cycles	1

Note 1：The product move into the room temperature for at least 2 hours with no condensation.

Note 2：The product move into the room temperature for at least 24 hours with no condensation.

※ One single product test for only one item ; Function : Fulfill item Fulfill item (1),(2),(3) .

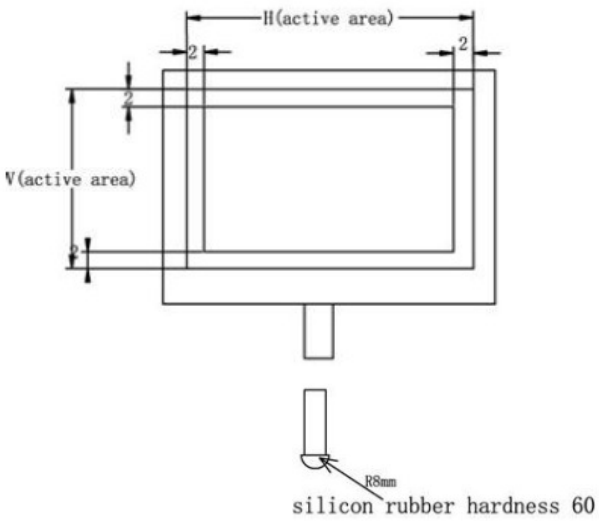
2.6.7 Durability Test

Items	Nominal Dimension
Finger Touch Test	Test position：any point in each side interval 2mm within active area. Test jig：R8.0mm silicon rubber, hardness 60° Test force：250gf Frequency：2 times/sec No function fail after 1000K times.
Pen Sliding Test	Test area：each side interval 3mm within active area. Test jig：R 0.8mm polyacetal pen. Input force：150gf. Freauencv：60 mm/sec. No function fail after 100K times. 1 time means sliding from A to B or B to A.

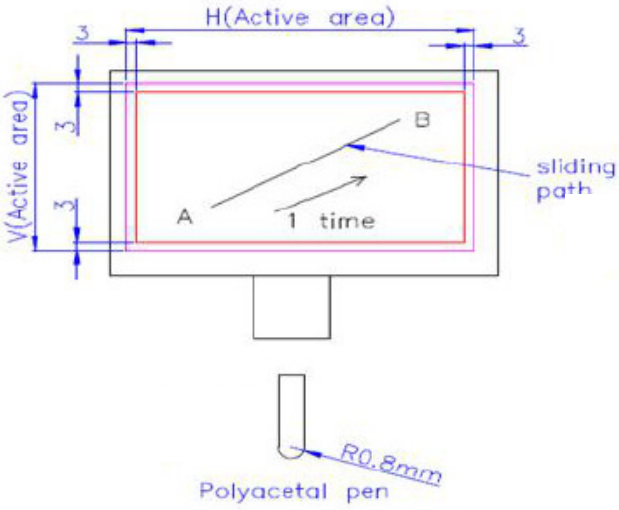
※ One single product test for only one item ; Function : Fulfill item Fulfill item (1),(2),(3) .

Durability Test Position：

(Finger Touch Test)



(Pen Sliding Test)



3. OPTICAL CHARACTERISTICS

3.1 Characteristics

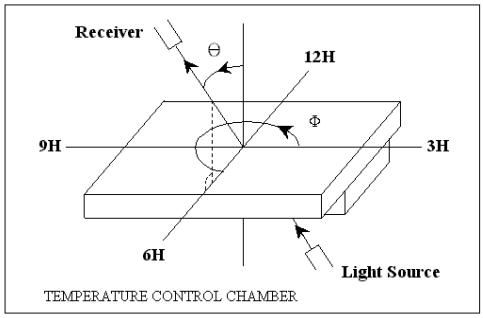
Electrical and Optical Characteristics

No.	Item			symbol / temp.		Min.	Typ.	Max.	Unit	Note
1	Response Time			Tr+Tf	25 ℃	-	30	35	ms	2
2	Viewing Angle	Hor.	Cr≧10	θ_{2+}	Φ = 0°	70	80	-	degree	3
				θ_{2-}	Φ = 180°	70	80	-		
		Ver.		θ_{1+}	Φ = 270°	70	80	-		
				θ_{1-}	Φ = 90°	70	80	-		
3	Contrast Ratio			Cr	25 ℃	700	800	-	-	4
4	Red x-code			Rx	25 ℃	0.548	0.598	0.648	-	5
	Red y-code			Ry		0.310	0.360	0.410		
	Green x-code			Gx		0.310	0.360	0.410		
	Green y-code			Gy		0.524	0.574	0.624		
	Blue x-code			Bx		0.096	0.146	0.196		
	Blue y-code			By		0.053	0.103	0.153		
	White x-code			Wx		0.273	0.323	0.373		
	White y-code			Wy		0.299	0.349	0.399		
	Brightness			Y		300	350	-	cd/m^2	
5	Brightness Uniformity				25 ℃	75	80	-	%	6

3.2 Definition of optical characteristics

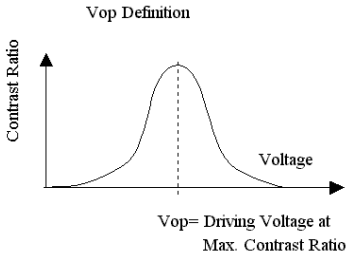
Measurement condition :

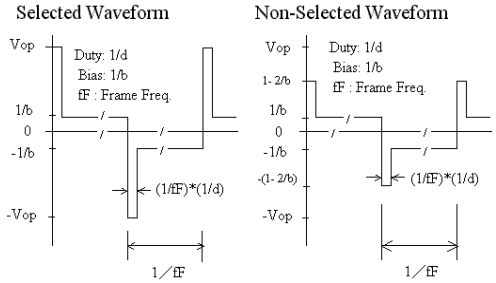
Transmissive and Transflective type



PHOTAL LCD-5000

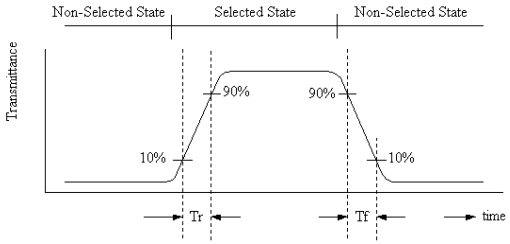
[Note 1] Definition of LCD Driving Vop and Waveform :



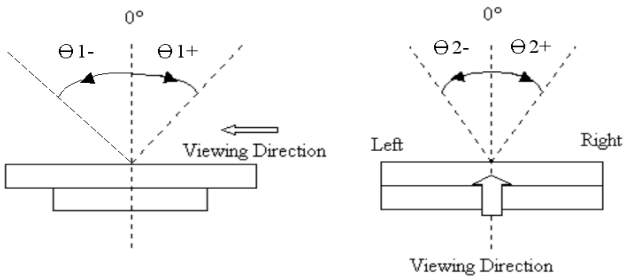


[Note 2] Definition of Response Time

for Negative type :

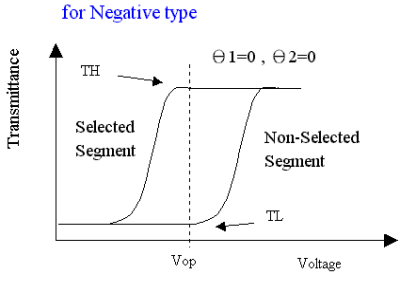


[Note 3] Definition of Viewing Angle :



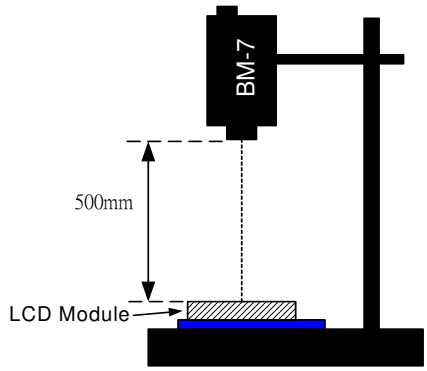
[Note 4] Definition of Contrast Ratio :

for Negative type

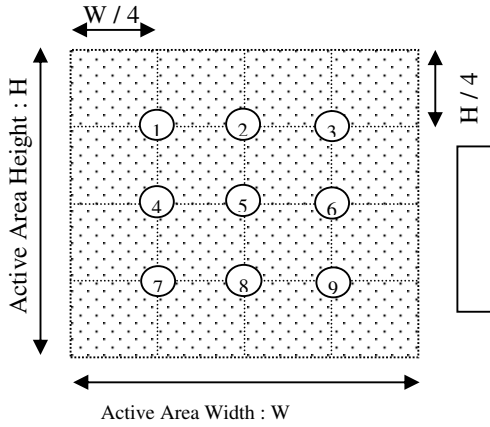


$$\text{Contrast Ratio} = \frac{TH}{TL}$$

[Note 5] Definition of measurement of Color Chromaticity and Brightness



[Note 6] Definition of Brightness Uniformity



$$\text{Brightness Uniformity} = \frac{\text{Minimum Brightness of Point 1~9}}{\text{Maximum Brightness of Point 1~9}}$$

4. RELIABILITY :

Item No	Items	Condition	Note
1	High temperature operating	70 ℃ , 200 hours	IEC60068-2-2 Note 1
2	Low temperature operating	-20 ℃ , 200 hours	IEC60068-2-1 Note 1
3	High temperature storage	80 ℃ , 200 hours	IEC60068-2-2 Note 1
4	Low temperature storage	-30 ℃ , 200 hours	IEC60068-2-1 Note 1
5	High temperature & humidity storage	60℃, 90%RH, 100 hours	IEC60068-2-78 Note 2
6	Thermal Shock storage	-30℃, 30min.<=> 80℃, 30min. 10 Cycles	IEC60068-2-14 Note 1
7	Vibration test	10 => 55 =>10 => 55 => 10 Hz , within 1 minute Amplitude : 1.5mm. 15 minutes for each Direction (X,Y,Z)	IEC60068-2-6
8	Drop test	>10Kg : 60 cm ; ≤10Kg : 80 cm 6 sides, 1 corner, 3edges, Free fall.	IEC60068-2-32

Note 1：The product move into the room temperature for at least 2 hours with no condensation.

Note 2：The product move into the room temperature for at least 24 hours with no condensation.

Note 3 : Please change the display picture (autorun) during operating mode. Avoid displaying static images

* One single product test for only one item.
* One single product test for only one item.
* Judgment after test : keep in room temperature for more than 2 hours.
  - Current consumption < 2 times of initial value
  - Function : work normally

5. PRODUCT HANDING AND APPLICATION

5.1 PRECAUTION FOR HANDLING LCM

- The LCD module contains a C-MOS LSI. People who operate the LCM should wear ESD protection equipment to prevent ESD hurt on products.
- Do not input any signal before power is turned on.
- Do not take LCM from its packaging bag until it is assembled.
- Peel off the LCM protective film slowly since static electricity may be generated.
- Hand Soldering : Soldering temperature less than 260℃,within 5 sec, at 5 mm. Away from pin connection.
- Do not touch the display surface or connection terminals area with bare hands. Smudges on the display surface reduce the insulation between terminals.
- Do not twist or bend the modules and also avoid any inappropriate external force on display surface during assembly.
- Do not expose LCM to organic solvent. IF clean the surface , wipe it gently with soft cloth dampened by alcohol.
- Do not attempt to wiped off the contact pads.
- Keep LCM panels away from direct sunlight or fluorescent light, , also avoid them in high-temperature & high humidity environment for a long period.
- It is an indispensable condition to drive LCD's within the specified voltage limit since the higher voltage then the limit cause the shorter LCD life.
- Do not drive LCM by DC voltage & avoid displaying at certain pattern for a long time otherwise it might cause image sticking.
- Response time will be extremely delayed at lower temperature then the operating temperature range and on the other hand at higher temperature LCD's how 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 operation temperature.
- If the display area is pushed hard during operation, some font will be abnormally displayed but it resumes normal condition after turning off once.
- Never use the LCD , LCM under 45 Hz , the liquid crystal will decomposition and cause perfectly damage on display !!
- Liquid in LCM is hazardous substance. In case a contact with liquid crystal material is occurred, be sure to immediately wash such material away by soap and water.
- The polarizer is easily damaged and should be handle with special care. Don't press or rub it with hard objects.

5.2 PRECAUTION FOR STORING

- Store the module in a dark room where must keep at 25±10℃ and 65%RH or less.
- Do not store the module in surroundings containing organic solvent or corrosive gas
- Store the module in an anti-electrostatic container or bag.

5.3 USING ON MEDICAL CARE , SAFETY OR HAZARDOUS APPLICATION OR SYSTEM

- For the application in medical care, safety and hazardous products or systems, an authorization from URT is required. URT will not responsible for any damage or loss which caused by the products without any authorization given by URT.
- This product is not allowed to be designed and used for military application and/or purpose.
- The delivery of this product to the countries and/or regions where the embargoes are imposed by U.N. is prohibited.
- The application and delivery of this product must comply with Strategic High-Tech Commodities (SHTC) export control and the sales to the embargoed and/or sanctioned countries or regions are strictly prohibited.

6. DATE CODE OF PRODUCTS

- Date code will be shown on each product :

- **YY MM DD - XXXX**

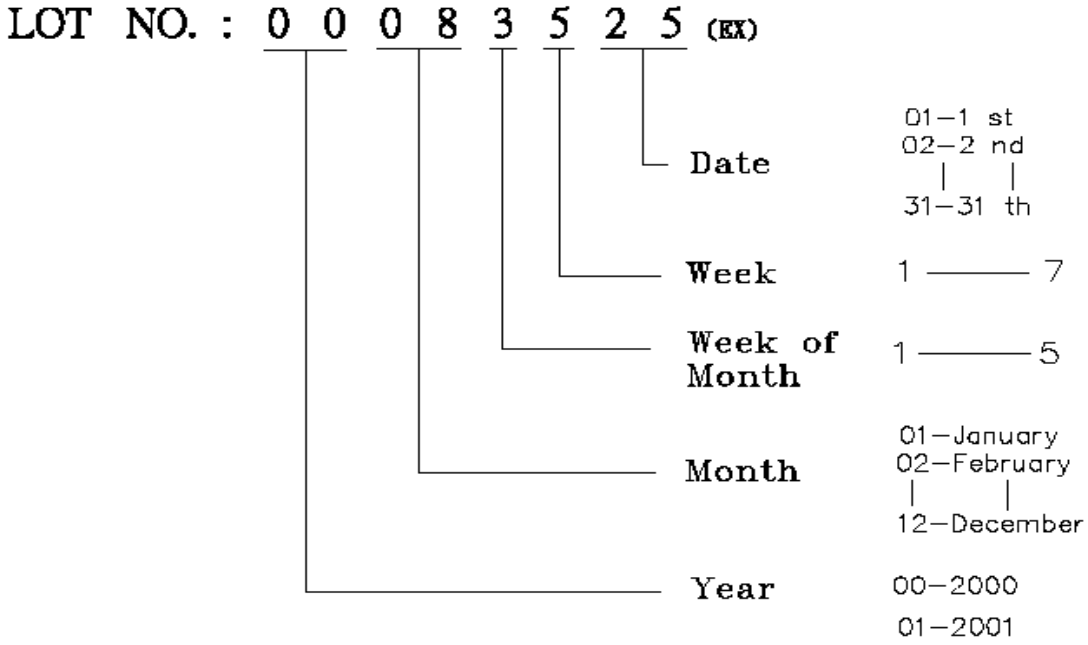
  Year Month Day - Serial no.

- Example: 141108 - 0003 ==> Year 2014, November,8th , Serial no.0003

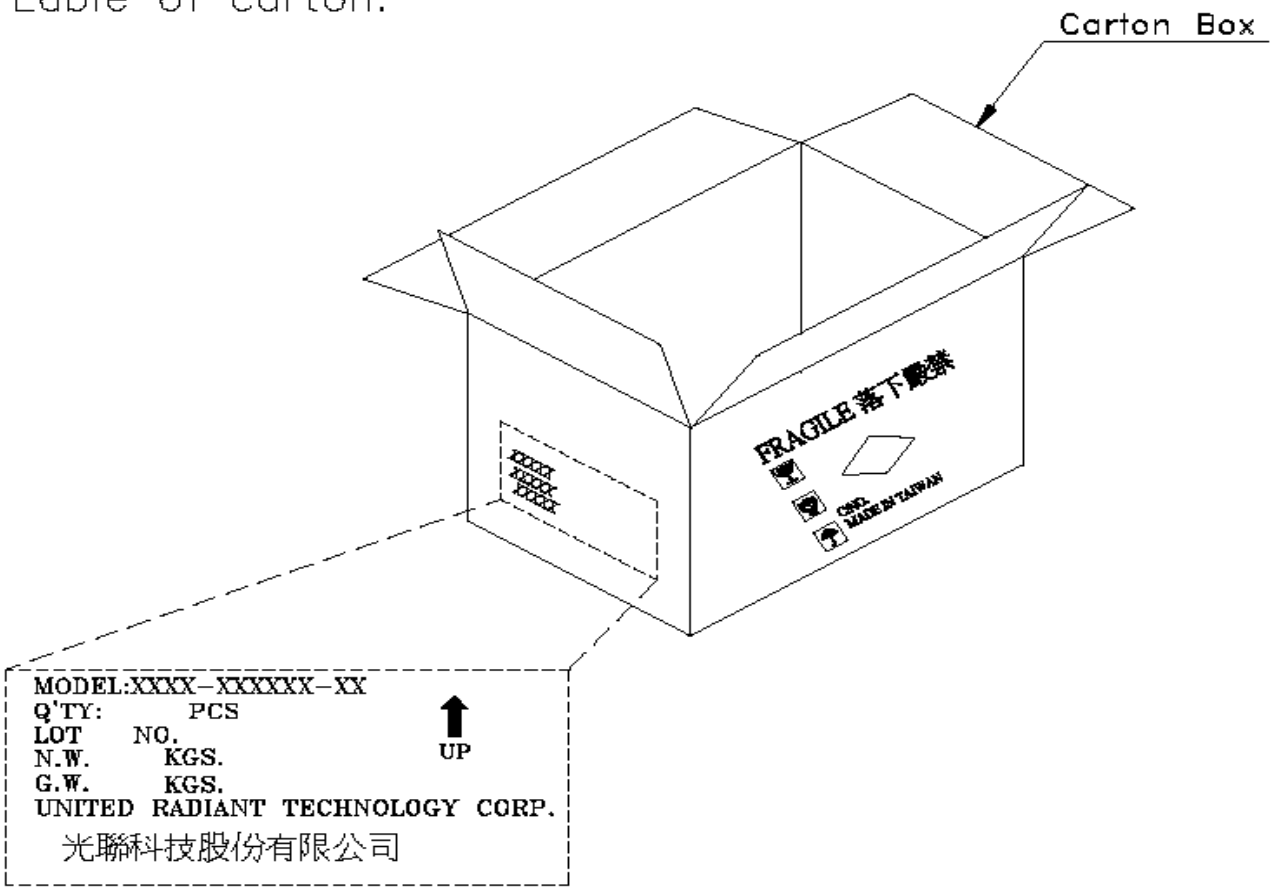
Note ： The lot no. attached on the packing box will be used for tracking once the part is too small to print the date code.

7. LOT NO

Instruction of lot number:



Lable of carton:



8. Inspection Standard

8.1 Quality :

The quality of goods supplied to purchaser shall come up to the following standard.

8.1.1 The Method Of Preserving Goods

After delivery of goods fromU.R.T. to purchaser. Purchaser shall control the LCM at -10 ℃ to 40 ℃ and it might be desirable to keep at the normal room temperature and humidity until incoming inspection or throwing into process line.

8.1.2 Incoming Insection

(A) The method of inspection

If purchaser make an incoming inspection, a sampling plan shall be applied on the condition that quality of one delivery shall be regarded as one lot.

(B) The standard of quality

ISO-2859-1 (SAME AS MIL-STD-105E) , LEVEL Ⅱ SINGLE PLAN.

Definition	AQL(%)
CRITICAL	0.4 %
MAJOR	0.65 %
MINOR	1.5 %

EVERY ITEM SHALL BE INSPECTED ACCORDING TO THE CLASS.

8.1.3 Warranty Policy

(A) U.R.T. will provied one-year warranty for the products only if under specification operating conditions. U.R.T. will replace good products for these defect products which under warranty period and belong to the responsibility of U.R.T.

(B) The warranty period starts from delivery date.

(C) Customer is responsible for proving delivery date when customer returns defective product which is out of warranty, otherwise, the warranty period will be based on date code.

8.2 Checking Condition

8.2.1. Viewing distance is approximately：30 ± 5 cm.

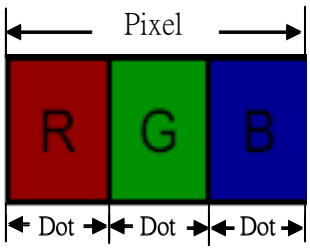
8.2.2. Viewing angle is normal to the LCD panel with 45°.

8.2.3. Ambient illuminance：2 pcs of 20W fluorescent lamps(distance to the sample >100 cm) or 1000±200 lux.

8.3. INSPECTION PLAN :

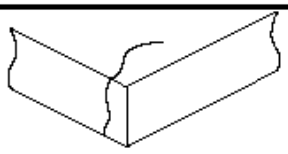
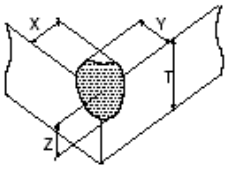
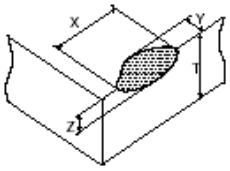
CLASS	ITEM	JUDGEMENT	CLASS
PACKING & INDICATE	1. OUTSIDE AND INSIDE PACKAGE	"MODEL NO." , "LOT NO." AND "QUANTITY" SHOULD INDICATE ON THE PACKAGE.	Minor
	2. MODEL MIXED AND QUANTITY	OTHER MODEL MIXED.....REJECTED QUANTITY SHORT OR OVER.....REJECTED	Critical
	3. PRODUCT INDICATION	(B) LINEAR TYPE: THE PRODUCT	Major
ASSEMBLY	4. DIMENSION, LCD GLASS SCRATCH AND SCRIBE DEFECT.	ACCORDING TO SPECIFICATION OR DRAWING.	Major
APPEARANCE	5. VIEWING AREA	POLARIZER EDGE OR LCD'S SEALING LINE IS VISABLE IN THE VIEWING AREA ……..REJECTED	Minor
	6. BLEMISH、BLACK SPOT、 WHITE SPOT IN THE LCD AND LCD GLASS CRACKS	ACCORDING TO STANDARD OF VISUAL INSPECTION (INSIDE VIEWING AREA)	Minor
	7. BLEMISH、BLACK SPOT WHITE SPOT AND SCRATCH ON THE POLARIZER	ACCORDING TO STANDARD OF VISUAL INSPECTION (INSIDE VIEWING AREA)	Minor
	8. BUBBLE IN POLARIZER	ACCORDING TO STANDARD OF VISUAL INSPECTION (INSIDE VIEWING AREA)	Minor
	9. LCD'S RAINBOW COLOR	STRONG DEVIATION COLOR (OR NEWTON RING) OF LCD.....REJECTED. OR ACCORDING TO LIMITED SAMPLE (IF NEEDED, AND INSIDE VIEWING AREA)	Minor
ELECTRICAL	10. ELECTRICAL AND OPTICAL CHARACTERISTICS (CONTRAST、VOP、 CHROMATICITY … ETC)	ACCORDING TO SPECIFICATION OR DRAWING . (INSIDE VIEWING AREA)	Critical
	11.MISSING LINE	MISSING DOT、LINE、CHARACTER ....REJECTED	Critical
	12.SHORT CIRCUIT、 WRONG PATTERN DISPLAY	NO DISPLAY、WRONG PATTERN DISPLAY、CURRENT CONSUMPTION OUT OF SPECIFICATION..... REJECTED	Critical
	13. DOT DEFECT (FOR COLOR AND TFT)	ACCORDING TO STANDARD OF VISUAL INSPECTION	Minor

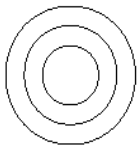
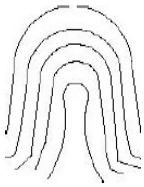
8.4. STANDARD OF VISUAL INSPECTION

<table>
<tr><th>NO.</th><th>CLASS</th><th>ITEM</th><th>JUDGEMENT</th></tr>
<tr><td>8.4.1</td><td>MINOR</td><td>BLACK AND WHITE SPOT
FOREIGN MATERIEL
DUST IN THE CELL
BLEMISH
SCRATCH</td><td>(A) ROUND TYPE: unit : mm.
<table><tr><th>DIAMETER (mm.)</th><th>ACCEPTABLE Q'TY</th></tr><tr><td>Φ ≦ 0.1</td><td>DISREGARD</td></tr><tr><td>0.1 < Φ ≦ 0.25</td><td>3 (Distance>5mm)</td></tr><tr><td>0.25 < Φ</td><td>0</td></tr></table>NOTE: Φ=(LENGTH+WIDTH)/2
(B) LINEAR TYPE: unit : mm.
<table><tr><th>LENGTH</th><th>WIDTH</th><th>ACCEPTABLE Q'TY</th></tr><tr><td>------</td><td>W ≦0.03</td><td>DISREGARD</td></tr><tr><td>L ≦ 5.0</td><td>0.03 < W ≦0.07</td><td>3 (Distance>5mm)</td></tr><tr><td>------</td><td>0.07 < W</td><td>FOLLOW ROUND TYPE</td></tr></table></td></tr>
<tr><td>8.4.2</td><td>MINOR</td><td>BUBBLE IN POLARIZER
DENT ON POLARIZER</td><td>unit : mm.
<table><tr><th>DIAMETER</th><th>ACCEPTABLE Q'TY</th></tr><tr><td>Φ ≦0.2</td><td>DISREGARD</td></tr><tr><td>0.2 < Φ ≦ 0.5</td><td>2 (Distance>5mm)</td></tr><tr><td>0.5 < Φ</td><td>0</td></tr></table></td></tr>
<tr><td>8.4.3</td><td>MINOR</td><td>Dot Defect</td><td><table><tr><th>Items</th><th>ACC. Q'TY</th></tr><tr><td>Bright dot</td><td>N≦ 4 (Distance>5mm)</td></tr><tr><td>Dark dot</td><td>N≦ 4 (Distance>5mm)</td></tr></table>Pixel Define :
 

Note 1: The definition of dot: The size of a defective dot over 1/2 of whole dot is regarded as one defective dot.
Note 2: Bright dot: Dots appear bright and unchanged in size in which LCD panel is displaying under black pattern.
Note 3: Dark dot: Dots appear dark and unchanged in size in which LCD panel is displaying under pure red, green ,blue pattern.</td></tr>
</table>

8.5 INSPECTION STANDARD OF TOUCH PANEL

NO.	CLASS	ITEMS		JUDGEMENT	
8.5.1	MAJOR	Touch Panel Crack			Reject
8.5.2	MINOR	Touch Panel Chipping	Corner		Not CNC Products: X≦2mm, Y≦2mm, Z＜1/2T — Accept CNC Products: For CNC Outline Dimension — Accept
			Edge		Not CNC Products: X≦3mm, Y≦3mm, Z＜1/2T — Accept CNC Products: For CNC Outline Dimension — Accept
8.5.3	MINOR	Scratch Dust and Foreign Material (Linear Type)		W≦0.05, L≦10mm	Accept
				0.05mm<W≦0.07mm；L≦5.0mm Distance between seratch＞5.0mm	Accept 3 ea Max.
				W>0.07mm	Reject
8.5.4	MINOR	Scratch Dust and Foreign Material (Round Type：Φ=(Length+Width)/2)		Φ≦0.15mm	Accept
				0.15mm＜Φ≦0.25mm Distance between seratch＞5.0mm	Accept 5 ea Max.
				Φ＞0.25mm	Reject
8.5.5	MINOR	Touch Panel Dent / Fish Eyes (Φ=(Length+Width)/2)		Φ≦0.35mm	Accept
				0.35mm＜Φ≦1.0mm Distance ＞5.0mm	Accept 3 ea Max.
				Φ＞1.0mm	Reject
8.5.6	MINOR	Touch Panel Air Bubble (Φ=(Length+Width)/2)		Φ≦0.15mm	Accept
				0.15mm＜Φ≦0.25mm Distance between bubbles＞5.0mm	Accept 3 ea Max.
				Φ＞0.25mm	Reject
8.5.7	MINOR	Touch Panel Printing area Scratch		W≦0.03, L≦10mm	Accept
				0.03mm＜W≦0.05mm, L≦5mm	Accept 3 ea Max.
				W＞0.05mm or L＞5mm (W>0.05 Follow 8.5.4 Round type)	Reject
8.5.8	MINOR	Touch Panel White Haze Mark / Dust		Can not be removed	Reject

NO.	CLASS	ITEMS	JUDEGMENT
8.5.9	MINOR	Inerratic Newton ring (For Resistive Touch Panel) 	1.Dimension of Newton ring > 1/3 V.A. area. Reject 2.Dimension of Newton ring < 1/3 V.A. area, not affect font effec Accept
		Atactic Newton ring (For Resistive Touch Panel) 	1.Dimension of Newton ring > 1/2 V.A. area. Reject 2.Dimension of Newton ring < 1/2 V.A. area, not affect font effec Accept
8.5.10	MINOR	Touch Panel Film Bulge	Not affect the transmittance and clarity under lighting ambient. Accept