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LCDs MADE SIMPLE®

Ph. 480-503-4295 | NOPP@FocusLCD.com

TFT | CHARACTER | UWVD | FSC | SEGMENT | CUSTOM | REPLACEMENT

Character Display Module

Part Number

C162NLGFGSW6WT3CXAH

Overview

Character: 16x2 (49.7x25.3), FSTN,
Gray background, White Edge LED,
Bottom view, Wide temp, Transflective
(positive), 3.3V LCD, 3.0V LED,
Controller=ST7032, RoHS Compliant

1. Features

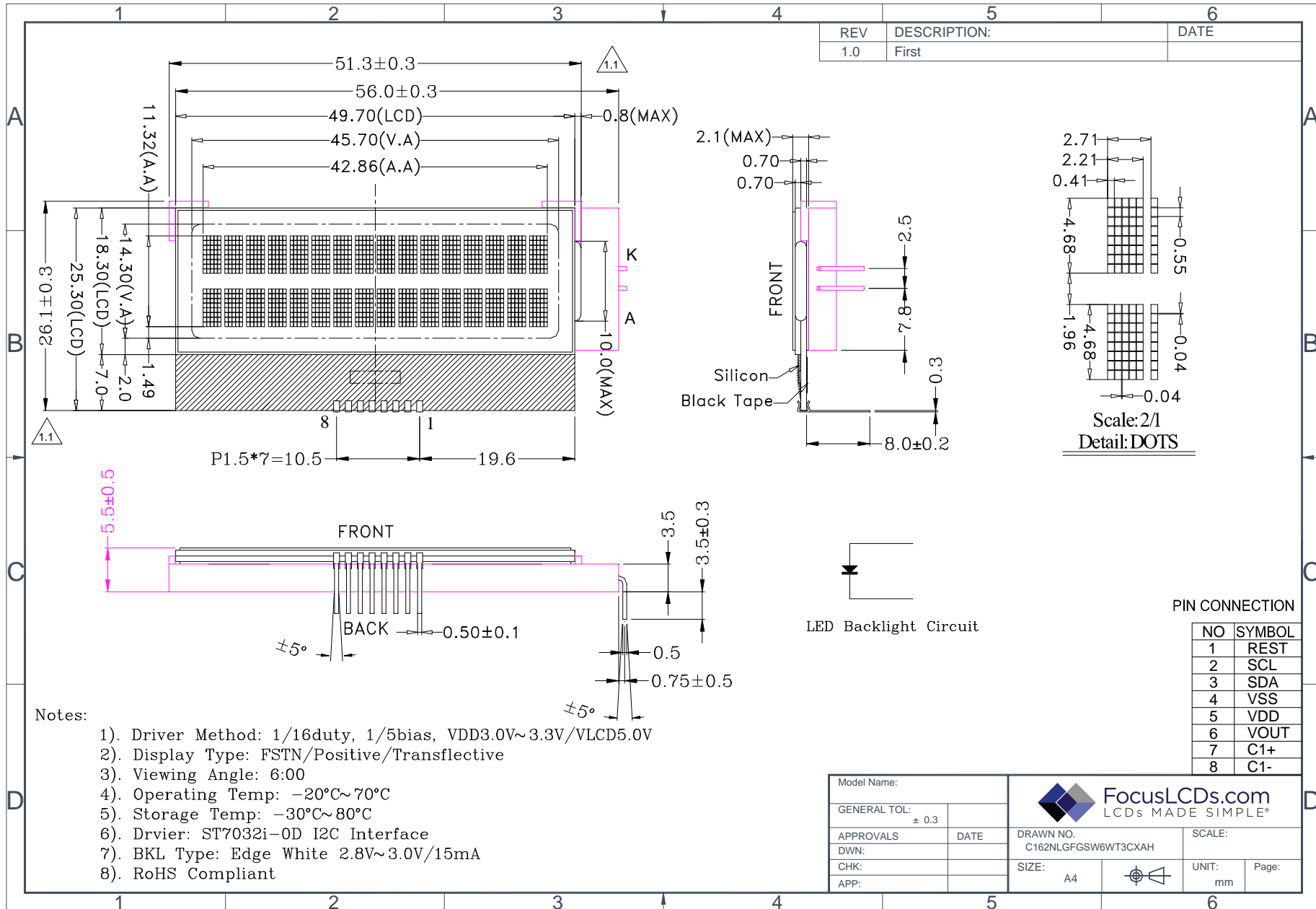
1. 5x8 dots with cursor
2. 16characters *2lines display
3. I2C MPU interfaces
4. Built-in controller (ST7032i-oD)
5. Display Mode & Backlight Variations
6. ROHS Compliant

LCD type	<input type="checkbox"/> TN			
	<input type="checkbox"/> FSTN	<input checked="" type="checkbox"/> FSTN Negative		
	<input type="checkbox"/> STN Yellow Green	<input type="checkbox"/> STN Gray	<input type="checkbox"/> STN Blue Negative	
View direction	<input checked="" type="checkbox"/> 6 O'clock		<input type="checkbox"/> 12 O'clock	
Rear Polarizer	<input type="checkbox"/> Reflective		<input checked="" type="checkbox"/> Transflective	<input type="checkbox"/> Transmissive
Backlight Type	<input type="checkbox"/> LED Array		<input type="checkbox"/> EL	<input type="checkbox"/> Internal Power
	<input checked="" type="checkbox"/> LED Edge		<input type="checkbox"/> CCFL	<input checked="" type="checkbox"/> External Power
Backlight Color	<input checked="" type="checkbox"/> White	<input type="checkbox"/> Blue	<input type="checkbox"/> Amber	<input type="checkbox"/> Yellow-Green
Temperature Range	<input type="checkbox"/> Normal		<input checked="" type="checkbox"/> Wide	<input type="checkbox"/> Super Wide
DC to DC circuit	<input checked="" type="checkbox"/> Build-in		<input type="checkbox"/> Not Build-in	
Touch screen	<input type="checkbox"/> With		<input checked="" type="checkbox"/> Without	
Font type	<input checked="" type="checkbox"/> English-Japanese	<input checked="" type="checkbox"/> English-European	<input type="checkbox"/> English-Russian	<input type="checkbox"/> Other

2. MECHANICAL SPECIFICATIONS

Module size	49.7mm(L)*25.3mm(W)* 5.5mm(H)
Viewing area	45.7mm(L)*14.3mm(W)
Character size	2.21mm(L)*4.68mm(W)
Character pitch	2.71mm(L)*6.64mm(W)
Weight	Approx.

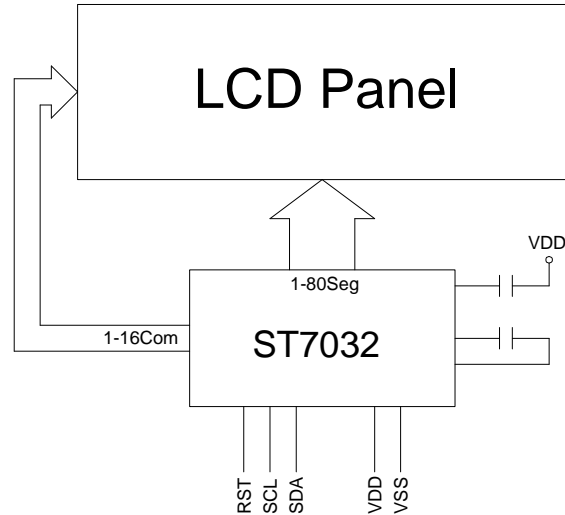
3. Outline dimension



4. Absolute maximum ratings

Item	Symbol	Standard			Unit
Power voltage	$V_{DD}-V_{SS}$	0	-	6.0	V
Input voltage	V_{IN}	VSS	-	VDD	
Operating temperature range	V_{OP}	-20	-	+70	°C
Storage temperature range	V_{ST}	-30	-	+80	

5. Block diagram



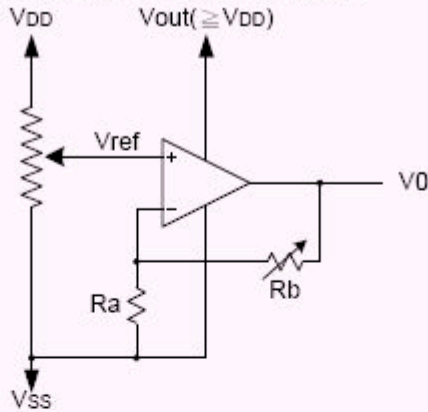
Capacitance 0.47uF~2.2uF

6. Interface pin description

Pin no.	Symbol	External connection	Function
1	RST	MPU	External reset PIN. Must be fixed to VDD low active.
2	SCL	MPU	Serial clock
3	SDA	MPU	Input data
4	Vss	Power supply	Signal ground for LCM
5	VDD		Power supply for logic for LCM
6	V_{OUT}		DC/DC voltage converter
7	C1+		For voltage booster circuit. External capacitor about 0.47uF~2.2Uf.
8	C1-		
A	LED+	LED BKL power supply	Power supply for BKL
K	LED-		Power supply for BKL

7. Contrast adjust

V0 voltage follower value calculation



$$V0 = \left(1 + \frac{R_b}{R_a}\right) * V_{ref}$$

$$\text{While } V_{ref} = V_{DD} * \left(\frac{\alpha + 36}{100}\right)$$

C5	C4	C3	C2	C1	C0	α
0	0	0	0	0	0	0
0	0	0	0	0	1	1
0	0	0	0	1	0	2
.						.
.						.
1	1	1	1	0	1	61
1	1	1	1	1	0	62
1	1	1	1	1	1	63

Rab2	Rab1	Rab0	1+Rb/Ra
0	0	0	1
0	0	1	1.25
0	1	0	1.5
0	1	1	1.8
1	0	0	2
1	0	1	2.5
1	1	0	3
1	1	1	3.75

8. Optical characteristics

FSTN type display module

Item	Symbol	Condition	Min.	Typ.	Max.	Unit	
Viewing angle (12 o'clock)	Left--Right	θ	Ta=25°C	-	60	-	deg
	Top--Bottom			-	80	-	
Contrast ratio	CR	Ta=25°C	3	5	-	-	
Response time	Rise		t _r	-	150	250	ms
	Tall	t _f	-	200	300		

9. Electrical characteristics

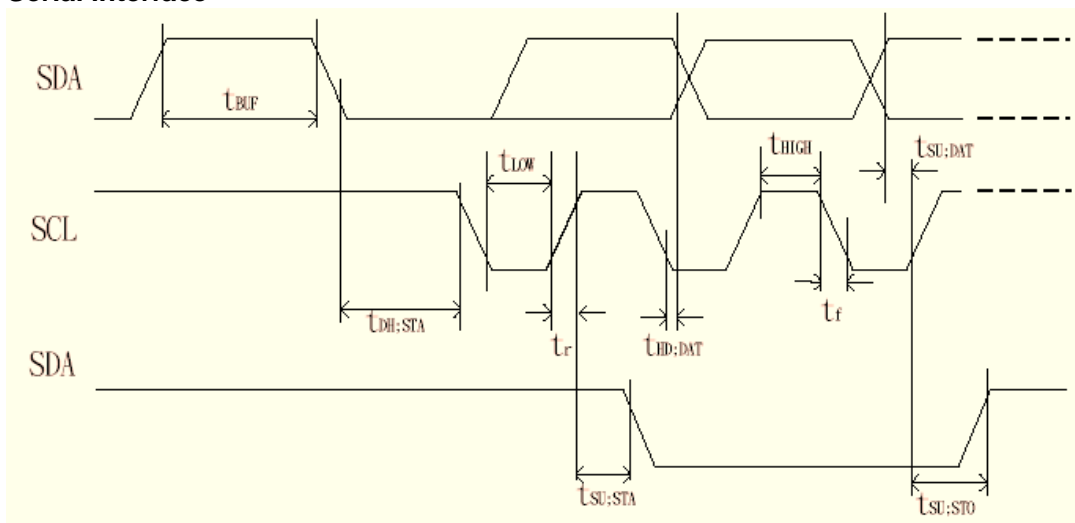
DC characteristics

Parameter	Symbol	Conditions	Min.	Typ.	Max.	Unit
Supply voltage for LCD	V _{DD} -V ₀	Ta =25°C	-	5.5	-	V
Input voltage	V _{DD}		2.7	3.0	3.3	
Supply current	I _{DD}	Ta=25°C, V _{DD} =3.0V	-	0.3	0.5	mA
Input leakage current	I _{LKG}		-	-	1.0	uA
"H" level input voltage	V _{IH}		2.2	-	V _{DD}	V
"L" level input voltage	V _{IL}	Twice initial value or less	0	-	0.6	
"H" level output voltage	V _{OH}	LOH=-0.25mA	2.4	-	-	
"L" level output voltage	V _{OL}	LOH=1.6mA	-	-	0.4	
Backlight supply voltage	V _F		-	3.0	-	
Backlight supply current	I _{LED}	V _F =3.0V		15		mA

10. Timing Characteristics

Item	Signal	Symbol	Condition	VDD=2.7 to 4.5V Rating		VDD=4.5 to 5.5V Rating		Units
				Min.	Max.	Min.	Max.	
SCL clock frequency	SCL	f_{SCLK}	—	DC	400	DC	400	KHz
SCL clock low period		t_{LOW}		1.3	—	1.3	—	us
SCL clock high period		t_{HIGH}		0.6	—	0.6	—	
Data set-up time	SI	$t_{SU,DAT}$	—	180	—	100	—	ns
Data hold time		$t_{HD,DAT}$		0	0.9	0	0.9	us
SCL,SDA rise time	SCL, SDA	t_r	—	$20+0.1C_b$	300	$20+0.1C_b$	300	ns
SCL,SDA fall time		t_f		$20+0.1C_b$	300	$20+0.1C_b$	300	
Capacitive load represent by each bus line		C_b	—	—	400	—	400	pf
Setup time for a repeated START condition	SI	$t_{SU,STA}$	—	0.6	—	0.6	—	us
Start condition hold time		$t_{HD,STA}$	—	0.6	—	0.6	—	us
Setup time for STOP condition		$t_{SU,STO}$	—	0.6	—	0.6	—	us
Bus free time between a Stop and START condition	SCL	t_{BUF}	—	1.3	—	1.3	—	us

Serial interface



- **Display Data RAM (DDRAM)**

Display data RAM (DDRAM) stores display data represented in 8-bit character codes. Its extended capacity is 80 x 8 bits, or 80 characters. The area in display data RAM (DDRAM) that is not used for display can be used as general data RAM. See Figure 7 for the relationships between DDRAM addresses and positions on the liquid crystal display.

The DDRAM address (A_{DD}) is set in the address counter (AC) as hexadecimal.

- **1-line display (N = 0) (Figure 8)**

When there are fewer than 80 display characters, the display begins at the head position. For example, if using only the ST7032, 16 characters are displayed. See Figure 8.

When the display shift operation is performed, the DDRAM address shifts. See Figure 9.

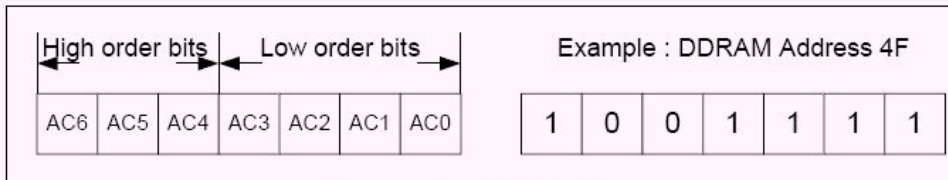


Figure 7. DDRAM Address

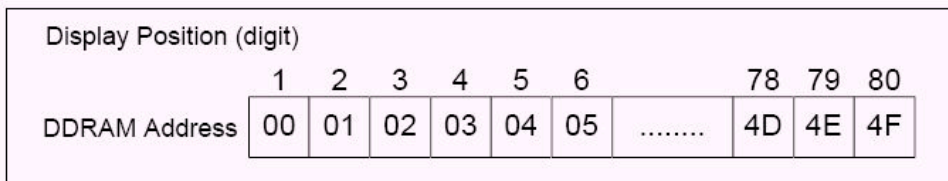


Figure 8. 1-Line Display

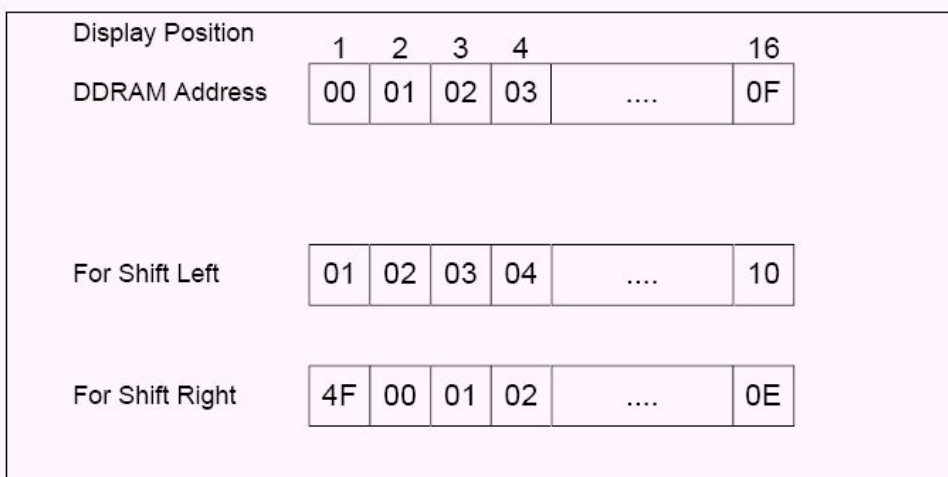


Figure 9. 1-Line by 16-Character Display Example

➤ **2-line display (N = 1) (Figure 10)**

Case 1: When the number of display characters is less than 40 . 2 lines, the two lines are displayed from the head. Note that the first line end address and the second line start address are not consecutive. See Figure 10.

Display Position										
	1	2	3	4	5	6	38	39	40
DDRAM Address	00	01	02	03	04	05	25	26	27
(hexadecimal)	40	41	42	43	44	45	65	66	67

Figure 10. 2-Line Display

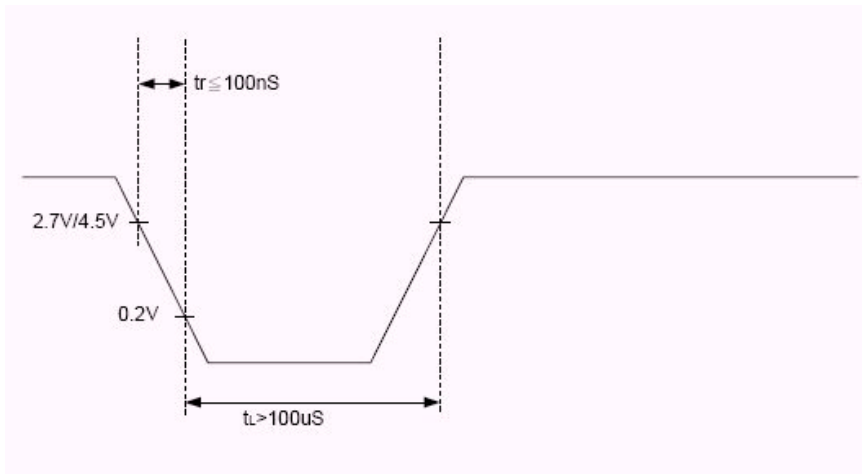
Case 2: For a 16-character . 2-line display See Figure 11.

When display shift operation is performed, the DDRAM address shifts. See Figure 11.

Display Position	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16
DDRAM Address	00	01	02	03	04	05	06	07	08	09	0A	0B	0C	0D	0E	0F
	40	41	42	43	44	45	46	47	48	49	4A	4B	4C	4D	4E	4F
For Shift Left	01	02	03	04	05	06	07	08	09	0A	0B	0C	0D	0E	0F	10
	41	42	43	44	45	46	47	48	49	4A	4B	4C	4D	4E	4F	50
For Shift Right	27	00	01	02	03	04	05	06	07	08	09	0A	0B	0C	0D	0E
	67	40	41	42	43	44	45	46	47	48	49	4A	4B	4C	4D	4E

Figure 11. 2-Line by 16-Character Display Example

Hardware reset (RST)



11. Instruction description

There are four categories of instructions that:

- Designate ST7032 functions, such as display format, data length, etc.
- Set internal RAM addresses
- Perform data transfer with internal RAM
- Others

➤ instruction table at “Normal mode”

(When “EXT” option pin connect to VDD, the instruction set follow below table)

Instruction	Instruction Code										Description	Instruction Execution Time		
	RS	R/W	DB7	DB6	DB5	DB4	DB3	DB2	DB1	DB0		OSC=380KHz	OSC=540kHz	OSC=700KHz
Clear Display	0	0	0	0	0	0	0	0	0	1	Write "20H" to DDRAM. and set DDRAM address to "00H" from AC	1.08 ms	0.76 ms	0.59 ms
Return Home	0	0	0	0	0	0	0	0	1	x	Set DDRAM address to "00H" from AC and return cursor to its original position if shifted. The contents of DDRAM are not changed.	1.08 ms	0.76 ms	0.59 ms
Entry Mode Set	0	0	0	0	0	0	0	1	I/D	S	Sets cursor move direction and specifies display shift. These operations are performed during data write and read.	26.3 us	18.5 us	14.3 us
Display ON/OFF	0	0	0	0	0	0	1	D	C	B	D=1:entire display on C=1:cursor on B=1:cursor position on	26.3 us	18.5 us	14.3 us
Cursor or Display Shift	0	0	0	0	0	1	S/C	R/L	x	x	S/C and R/L: Set cursor moving and display shift control bit, and the direction, without changing DDRAM data.	26.3 us	18.5 us	14.3 us
Function Set	0	0	0	0	1	DL	N	x	x	x	DL: interface data is 8/4 bits N: number of line is 2/1	26.3 us	18.5 us	14.3 us
Set CGRAM	0	0	0	1	AC5	AC4	AC3	AC2	AC1	AC0	Set CGRAM address in address counter	26.3 us	18.5 us	14.3 us
Set DDRAM address	0	0	1	AC6	AC5	AC4	AC3	AC2	AC1	AC0	Set DDRAM address in address counter	26.3 us	18.5 us	14.3 us
Read Busy flag and address	0	1	BF	AC6	AC5	AC4	AC3	AC2	AC1	AC0	Whether during internal operation or not can be known by reading BF. The contents of address counter can also be read.	0	0	0
Write data to RAM	1	0	D7	D6	D5	D4	D3	D2	D1	D0	Write data into internal RAM (DDRAM/CGRAM)	26.3 us	18.5 us	14.3 us
Read data from RAM	1	1	D7	D6	D5	D4	D3	D2	D1	D0	Read data from internal RAM (DDRAM/CGRAM)	26.3 us	18.5 us	14.3 us

Note:

Be sure the ST7032 is not in the busy state (BF = 0) before sending an instruction from the MPU to the ST7032. 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. Refer to Instruction Table for the list of each instruction execution time.

➤ **instruction table at "Extension mode"**

(when "EXT" option pin connect to VSS, the instruction set follow below table)

Instruction	Instruction Code										Description	Instruction Execution Time		
	RS	R/W	DB7	DB6	DB5	DB4	DB3	DB2	DB1	DB0		OSC=380KHz	OSC=540kHz	OSC=700KHz
Clear Display	0	0	0	0	0	0	0	0	0	1	Write "20H" to DDRAM. and set DDRAM address to "00H" from AC	1.08 ms	0.76 ms	0.59 ms
Return Home	0	0	0	0	0	0	0	0	1	x	Set DDRAM address to "00H" from AC and return cursor to its original position if shifted. The contents of DDRAM are not changed.	1.08 ms	0.76 ms	0.59 ms
Entry Mode Set	0	0	0	0	0	0	0	1	I/D	S	Sets cursor move direction and specifies display shift. These operations are performed during data write and read.	26.3 us	18.5 us	14.3 us
Display ON/OFF	0	0	0	0	0	0	1	D	C	B	D=1:entire display on C=1:cursor on B=1:cursor position on	26.3 us	18.5 us	14.3 us
Function Set	0	0	0	0	1	DL	N	DH	*0	IS	DL: interface data is 8/4 bits N: number of line is 2/1 DH: double height font IS: instruction table select	26.3 us	18.5 us	14.3 us
Set DDRAM address	0	0	1	AC6	AC5	AC4	AC3	AC2	AC1	AC0	Set DDRAM address in address counter	26.3 us	18.5 us	14.3 us
Read Busy flag and address	0	1	BF	AC6	AC5	AC4	AC3	AC2	AC1	AC0	Whether during internal operation or not can be known by reading BF. The contents of address counter can also be read.	0	0	0
Write data to RAM	1	0	D7	D6	D5	D4	D3	D2	D1	D0	Write data into internal RAM (DDRAM/CGRAM/ICONRAM)	26.3 us	18.5 us	14.3 us
Read data from RAM	1	1	D7	D6	D5	D4	D3	D2	D1	D0	Read data from internal RAM (DDRAM/CGRAM/ICONRAM)	26.3 us	18.5 us	14.3 us

Note * : this bit is for test command , and must always set to "0"

Instruction table 0(IS=0)

Cursor or Display Shift	0	0	0	0	0	1	S/C	R/L	x	x	S/C and R/L: Set cursor moving and display shift control bit, and the direction, without changing DDRAM data.	26.3 us	18.5 us	14.3 us
Set CGRAM	0	0	0	1	AC5	AC4	AC3	AC2	AC1	AC0	Set CGRAM address in address counter	26.3 us	18.5 us	14.3 us

Instruction table 1(IS=1)

Internal OSC frequency	0	0	0	0	0	1	BS	F2	F1	F0	BS=1:1/4 bias BS=0:1/5 bias F2~0: adjust internal OSC frequency for FR frequency.	26.3 us	18.5 us	14.3 us
Set ICON address	0	0	0	1	0	0	AC3	AC2	AC1	AC0	Set ICON address in address counter.	26.3 us	18.5 us	14.3 us
Power/ICON control/Contrast set	0	0	0	1	0	1	Ion	Bon	C5	C4	Ion: ICON display on/off Bon: set booster circuit on/off C5,C4: Contrast set for internal follower mode.	26.3 us	18.5 us	14.3 us
Follower control	0	0	0	1	1	0	Fon	Rab2	Rab1	Rab0	Fon: set follower circuit on/off Rab2~0: select follower amplified ratio.	26.3 us	18.5 us	14.3 us
Contrast set	0	0	0	1	1	1	C3	C2	C1	C0	Contrast set for internal follower mode.	26.3 us	18.5 us	14.3 us

13. Standard character pattern

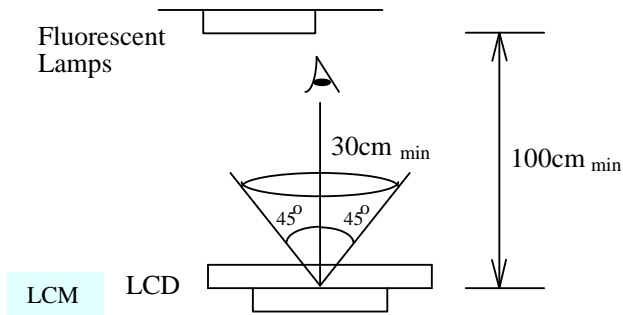
b7-b4 b3-b0	0000	0001	0010	0011	0100	0101	0110	0111	1000	1001	1010	1011	1100	1101	1110	1111
0000	f	A		0	@	P	>	F	G	E		-	9	3	6	
0001	J	+	!	1	A	Q	a	M	Q	æ	e	7	7	4	6	
0010	o	S	"	2	B	R	b	r	è	È	T	4	U	×	6	°
0011	P	7	#	3	C	S	c	S	À	À	J	9	T	E	0	°
0100	4	P	*	4	D	T	d	t	à	à	\	I	T	P	0	°
0101	↑	Δ	×	5	E	U	e	u	á	á	*	7	7	1	0	°
0110	↓	0	0	6	F	V	F	V	â	â	7	0	2	3	7	U
0111	→	Δ	'	7	G	W	g	w	ç	ç	7	7	×	7	R	×
1000	←	E	C	8	H	X	h	x	è	è	4	0	7	U	0	°
1001	Π	Π)	9	I	Y	i	y	é	é	0	7	U	U	1	×
1010	7	Σ	*	*	J	Z	j	z	ê	ê	0	0	0	0	0	×
1011	L	P	+	*	K	E	k	é	I	A	*	9	E	0	0	×
1100	U	0	,	<	L	7	l	l	í	A	0	0	0	0	0	×
1101	.	4	-	=	N	U	n	u	î	î	0	0	0	0	0	°
1110	0	0	.	>	N	0	n	0	ã	0	0	0	0	0	0	°
1111	0	0	/	?	0	0	0	0	ä	ä	0	0	0	0	0	°

14. QUALITY SPECIFICATIONS

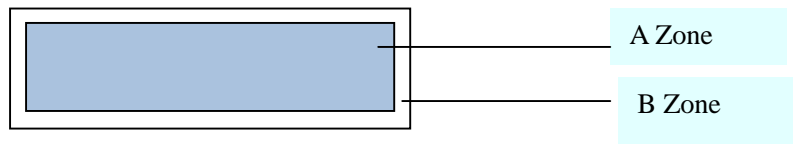
14.1 Standard of the product appearance test

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: Active display area (minimum viewing area).

B Zone: Non-active display area (outside viewing area).

14.2 Specification of quality assurance

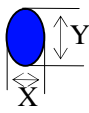
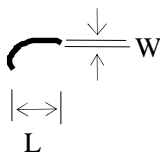
AQL inspection standard

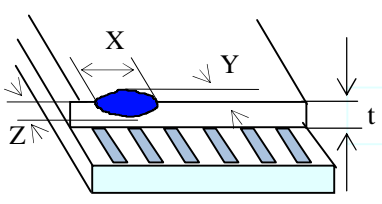
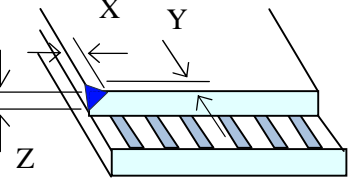
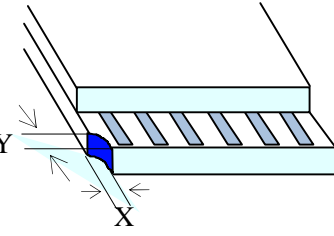
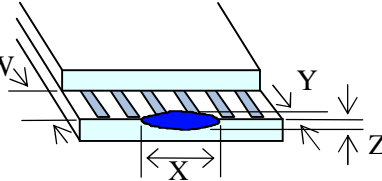
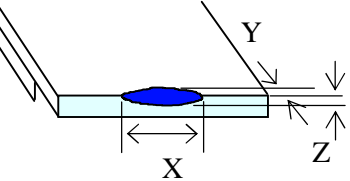
Sampling method: MIL-STD-105E, Level II, single sampling

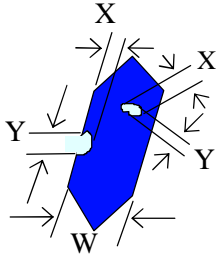
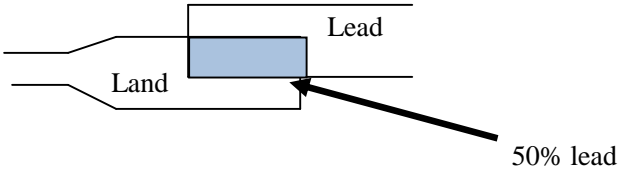
Defect classification **(Note: * is not including)**

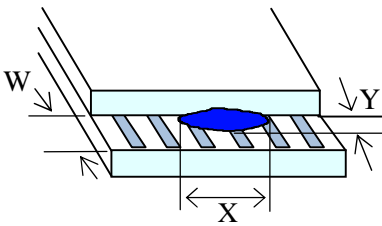
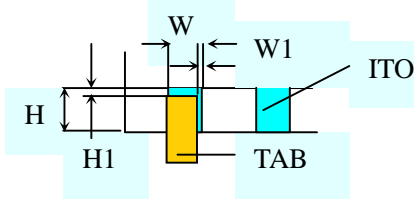
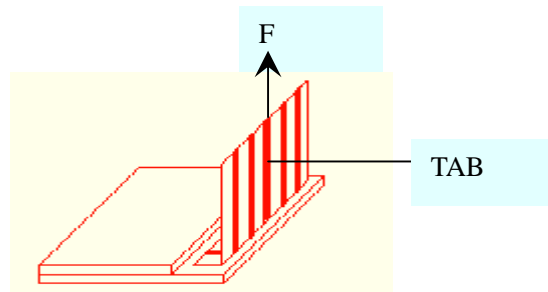
Classify	Item		Note	AQL
Major	Display state	Short or open circuit	1	0.65
		LC leakage		
		Flickering		
		No display		
		Wrong viewing direction		
		Contrast defect (dim, ghost)	2	
		Back-light	1,8	
	Non-display	Flat cable or pin reverse	10	
Wrong or missing component		11		
Minor	Display state	Background 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

No.	Item	Criterion																				
1	Short or open circuit	Not allow																				
	LC leakage																					
	Flickering																					
	No display																					
	Wrong viewing direction																					
	Wrong Back-light																					
2	Contrast defect	Refer to approval sample																				
	Background color deviation																					
3	Point defect, Black spot, dust (including Polarizer) $\phi = (X+Y)/2$	 <table border="1" data-bbox="861 862 1300 1164"> <thead> <tr> <th>Point Size</th> <th>Acceptable Qty.</th> </tr> </thead> <tbody> <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> </tbody> </table> <p style="text-align: right;">Unit: mm</p>	Point Size	Acceptable Qty.	$\phi \leq 0.10$	Disregard	$0.10 < \phi \leq 0.20$	3	$0.20 < \phi \leq 0.25$	2	$0.25 < \phi \leq 0.30$	1	$\phi > 0.30$	0								
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4	Line defect, Scratch	 <table border="1" data-bbox="790 1299 1340 1556"> <thead> <tr> <th colspan="2">Line</th> <th>Acceptable Qty.</th> </tr> <tr> <th>L</th> <th>W</th> <th></th> </tr> </thead> <tbody> <tr> <td>---</td> <td>$0.015 \geq W$</td> <td>Disregard</td> </tr> <tr> <td>$3.0 \geq L$</td> <td>$0.03 \geq W$</td> <td rowspan="2">2</td> </tr> <tr> <td>$2.0 \geq L$</td> <td>$0.05 \geq W$</td> </tr> <tr> <td>$1.0 \geq L$</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> </tbody> </table> <p style="text-align: right;">Unit: mm</p>	Line		Acceptable Qty.	L	W		---	$0.015 \geq W$	Disregard	$3.0 \geq L$	$0.03 \geq W$	2	$2.0 \geq L$	$0.05 \geq W$	$1.0 \geq L$	$0.1 > W$	1	---	$0.05 < W$	Applied as point defect
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5	Rainbow	Not more than two color changes across the viewing area.																				

No	Item	Criterion																																	
6	<p>Chip</p> <p>Remark:</p> <p>X: Length direction</p> <p>Y: Short direction</p> <p>Z: Thickness direction</p> <p>t: Glass thickness</p> <p>W: Terminal Width</p>	 <table border="1" data-bbox="933 324 1324 436"> <caption>Acceptable criterion</caption> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td>≤ 2</td> <td>0.5mm</td> <td>$\leq t/2$</td> </tr> </tbody> </table>  <table border="1" data-bbox="925 638 1324 750"> <caption>Acceptable criterion</caption> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td>≤ 2</td> <td>0.5mm</td> <td>$\leq t$</td> </tr> </tbody> </table>  <table border="1" data-bbox="933 929 1324 1086"> <caption>Acceptable criterion</caption> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td>≤ 3</td> <td>≤ 2</td> <td>$\leq t$</td> </tr> <tr> <td colspan="2">shall not reach to ITO</td> <td></td> </tr> </tbody> </table>  <table border="1" data-bbox="925 1310 1324 1422"> <caption>Acceptable criterion</caption> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td>Disregard</td> <td>≤ 0.2</td> <td>$\leq t$</td> </tr> </tbody> </table>  <table border="1" data-bbox="925 1601 1292 1713"> <caption>Acceptable criterion</caption> <thead> <tr> <th>X</th> <th>Y</th> <th>Z</th> </tr> </thead> <tbody> <tr> <td>≤ 5</td> <td>≤ 2</td> <td>$\leq t/3$</td> </tr> </tbody> </table>	X	Y	Z	≤ 2	0.5mm	$\leq t/2$	X	Y	Z	≤ 2	0.5mm	$\leq t$	X	Y	Z	≤ 3	≤ 2	$\leq t$	shall not reach to ITO			X	Y	Z	Disregard	≤ 0.2	$\leq t$	X	Y	Z	≤ 5	≤ 2	$\leq t/3$
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No.	Item	Criterion								
7	Segment pattern $W = \text{Segment width}$ $\phi = (X+Y)/2$	(1) Pin hole $\phi < 0.10\text{mm}$ is acceptable.  <table border="1" data-bbox="853 537 1316 712"> <thead> <tr> <th>Point Size</th> <th>Acceptable Qty</th> </tr> </thead> <tbody> <tr> <td>$\phi \leq 1/4W$</td> <td>Disregard</td> </tr> <tr> <td>$1/4W < \phi \leq 1/2W$</td> <td>1</td> </tr> <tr> <td>$\phi > 1/2W$</td> <td>0</td> </tr> </tbody> </table> <p style="text-align: right;">Unit: mm</p>	Point Size	Acceptable Qty	$\phi \leq 1/4W$	Disregard	$1/4W < \phi \leq 1/2W$	1	$\phi > 1/2W$	0
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8	Back-light	(1) The color of backlight should correspond its specification. (2) Not allow flickering								
9	Soldering	(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. 								
10	Wire	(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.								
11*	PCB	(1) Not allow screw rust or damage. (2) Not allow missing or wrong putting of component.								

No	Item	Criterion
12	Protruded W: Terminal Width	 <p>Acceptable criteria: $Y \leq 0.4$</p>
13	TAB	<p>1. Position</p>  <div style="border: 1px solid black; padding: 5px; width: fit-content; margin-left: auto; margin-right: auto;"> $W1 \leq 1/3W$ $H1 \leq 1/3H$ </div> <p>2. TAB bonding strength test</p>  <p>$P (=F/TAB \text{ bonding width}) \geq 650\text{gf/cm}$,(speed rate: 1mm/min) 5pcs per SOA (shipment)</p>
14	Total no. of acceptable Defect	<p>A. Zone</p> <p>Maximum 2 minor non-conformities per one unit. Defect distance: each point to be separated over 10mm</p> <p>B. Zone</p> <p>It is acceptable when it is no trouble for quality and assembly in customer's end product.</p>

14.3 Reliability of LCM

Reliability test condition:

Item	Condition	Time (hrs)	Assessment
High temp. Storage	80°C	48	No abnormalities in functions and appearance
High temp. Operating	70°C	48	
Low temp. Storage	-30°C	48	
Low temp. Operating	-20°C	48	
Humidity	40°C/ 90%RH	48	
Temp. Cycle	0°C ← 25°C → 50°C (30 min ← 5 min → 30min)	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.

14.4 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 isopropyl alcohol, ethyl alcohol or trichlorotrifluoroethane, 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 make any modification on the PCB without consulting LONGTECH
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: $280^{\circ}\text{C} \pm 10^{\circ}\text{C}$
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 V_o .
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.