



**LOGIC**  
TECHNOLOGIES

## PRODUCT SPECIFICATION

### DESCRIPTION

TFT Module – 2.2”  
240x (RGB) x 320

### PART NUMBER

LTTD240320022-L6-TF

### VERSION

1.0

ROHS COMPLIANT



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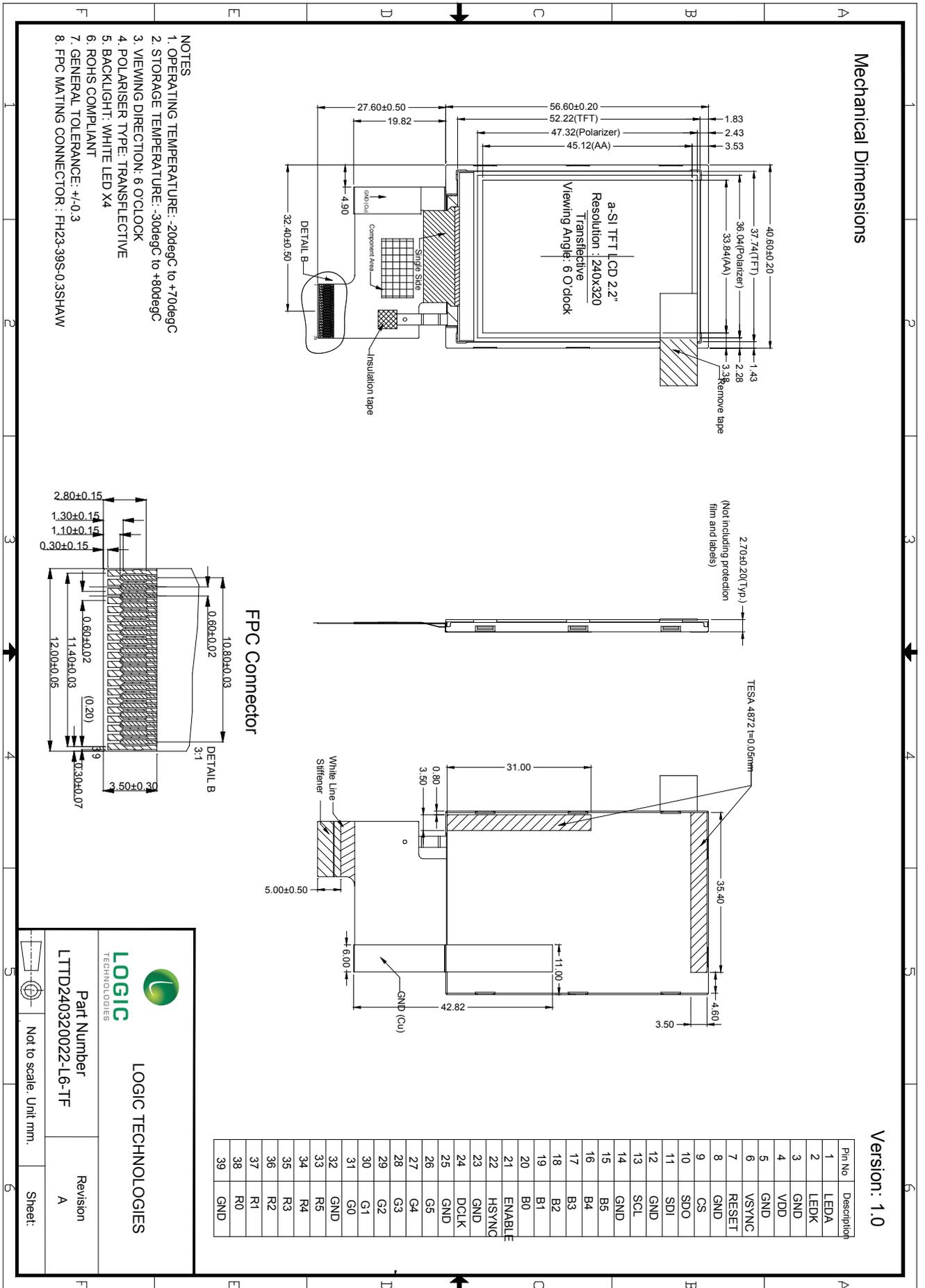
- GENERAL INFORMATION

| Item  | Contents                   | Unit              |
|---|----------------------------|-------------------|
| LCD Type  | TFT Transflective          | Note 1            |
| Technology  | a-Si TFT                   | ---               |
| Viewing Direction<br>(IC on 6:00 side)            | 6:00                       | O'clock (Note 2)  |
| Viewing Angle<br>(Gray Scale Inversion Direction) | 12:00                      | O'clock           |
| Module dimensions (W x H x T)                     | 40.6 x 56.6 x 2.7          | mm                |
| Active area (W x H)                               | 33.84 x 45.12              | mm                |
| Number of pixels                                  | 240 RGB x 320              | ---               |
| Pixel pitch                                       | 0.141x0.141                | mm                |
| Pixel Configuration                               | R.G.B. Vertical Stripe     | mm                |
| Colours   | 262K                       | ---               |
| Contrast ratio                                    | 120 (typical)              | ---               |
| Backlight   | 4 LED (Serial)             | ---               |
| Backlight Brightness                              | 90 (typical)               | cd/m <sup>2</sup> |
| Controller  | ILI9341                    | ---               |
| Interface   | 18-bit RGB interface+3 SPI | ---               |
| Operating temperature                             | -20 to +70                 | °C                |
| Storage temperature                               | -30 to +80                 | °C                |

Note 1: ECB Transflective mode

Note 2: Viewing direction same as LTTD240320022-L3-TF anyway.

MECHANICAL DIMENSIONS



Version: 1.0

| Pin No | Description |
|--------|-------------|
| 1      | LEDA        |
| 2      | LEDK        |
| 3      | GND         |
| 4      | VDD         |
| 5      | GND         |
| 6      | VSYN        |
| 7      | RESET       |
| 8      | GND         |
| 9      | CS          |
| 10     | SDO         |
| 11     | SDI         |
| 12     | GND         |
| 13     | SCL         |
| 14     | GND         |
| 15     | B5          |
| 16     | B4          |
| 17     | B3          |
| 18     | B2          |
| 19     | B1          |
| 20     | B0          |
| 21     | ENABLE      |
| 22     | HSYNC       |
| 23     | GND         |
| 24     | DCLK        |
| 25     | GND         |
| 26     | G5          |
| 27     | G4          |
| 28     | G3          |
| 29     | G2          |
| 30     | G1          |
| 31     | G0          |
| 32     | GND         |
| 33     | R5          |
| 34     | R4          |
| 35     | R3          |
| 36     | R2          |
| 37     | R1          |
| 38     | R0          |
| 39     | GND         |

**LOGIC TECHNOLOGIES**

Part Number: LTTD240320022-L6-TF

Revision: A

Not to scale. Unit: mm.

Sheet: \_\_\_\_\_

- ABSOLUTE MAXIMUM RATINGS

| Parameter             | Symbol  | Min.  | Max. | Unit | Note |
|-----------------------|---|-------|------|------|------|
| Supply Voltage        | VDD   | - 0.3 | 4.6  | V    |      |
| Input Signal Voltage  | R0~R5,G0~G5,B0~B5,<br>ENABLE,DCLK,HSYNC,<br>VSYNC,/CS,SCL,SDI,SDO/RESET | - 0.3 | 4.6  | V    |      |
| Operating Temperature | T <sub>OPR</sub>  | - 20  | 70   | °C   |      |
| Storage temperature   | T <sub>ST</sub>   | - 30  | 80   | °C   |      |

- ELECTRICAL CHARACTERISTICS

| Item                 | Symbol          | Test Condition         | Min.               | Typ. | Max.               | Unit | Remark |
|----------------------|-----------------|------------------------|--------------------|------|--------------------|------|--------|
| Logic supply Voltage | VDD             | Ta = 25 °C             | 2.7                | 3.0  | 3.3                | V    |        |
| Input Voltage        | "H" Level       | Ta = 25 °C<br>VDD = 3V | 0.8V <sub>DD</sub> | -    | V <sub>DD</sub>    | V    |        |
|                      | "L" Level       |                        | V <sub>SS</sub>    | -    | 0.2V <sub>DD</sub> | V    |        |
| Output Voltage       | "H" Level       |                        | 0.7V <sub>DD</sub> | -    | V <sub>DD</sub>    | V    |        |
|                      | "L" Level       |                        | V <sub>SS</sub>    | -    | 0.3V <sub>DD</sub> | V    |        |
| Current of VDD       | I <sub>DD</sub> |                        | -                  | TBD  | -                  | mA   | Note 1 |

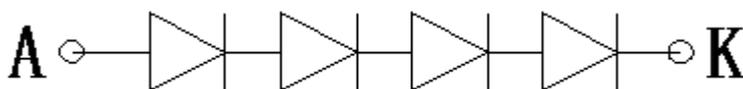
Note 1: To test the current dissipation, use "all Black Pattern" testing pattern.

- BACKLIGHT CHARACTERISTICS

| Item                        | Symbol         | Min.  | Typ.  | Max. | Unit | Condition |
|-----------------------------|----------------|-------|-------|------|------|-----------|
| Forward Current             | I <sub>F</sub> | ---   | 20    | --   | mA   | Note 1    |
| Forward Current Voltage     | V <sub>F</sub> | ---   | 12.8  | ---  | V    | Note 2    |
| Backlight Power Consumption | WBL            | ---   | 256   | --   | mW   | Note 1    |
| LED Lifetime                | ---            | 10000 | 20000 | ---  | Hrs  | Note 3    |

Note 1: The LED driving condition is defined for total backlight consumption.

Note 2: Forward Voltage adjusting should depend on Forward Current setting.



Note 3: Optical performance should be evaluated at Ta=25 °C only.

If the LEDs are driven by high current, high ambient temperature & humidity condition, the lifetime of the LEDs will be reduced. Operating life means brightness reduces to 50% of initial brightness. Typical operating lifetime is estimated data.

- ELECTRO-OPTICAL CHARACTERISTICS

| Item                   | Symbol           | Condition               | Min. | Typ. | Max. | Unit              | Refer  | Note |
|------------------------|------------------|-------------------------|------|------|------|-------------------|--------|------|
| Response Time          | T <sub>ON</sub>  | 25°C                    | ---  | 15   | 30   | ms                | Fig 1  | 4    |
|                        | T <sub>OFF</sub> |                         | ---  | 20   | 30   |                   |        |      |
| Contrast ratio         | Cr               | $\theta=0^\circ$        | 100  | 120  | ---  | ---               | Fig 2  | 1    |
| Uniformity             | U                | ---                     | 70   | 80   | ---  | %                 | Fig 2  | 3    |
| NTSC                   | ---              | Backlight is on         | ---  | 30   | ---  | %                 |        |      |
| Surface Luminance      | Lv               |                         | 80   | 90   | ---  | cd/m <sup>2</sup> | Fig 2  | 2    |
| Viewing angle ratio    |                  | $\varnothing=90^\circ$  | ---  | 48   | 53   | deg               | Fig 3  | 6    |
|                        |                  | $\varnothing=270^\circ$ | ---  | 45   | 50   |                   |        |      |
|                        |                  | $\varnothing=0^\circ$   | ---  | 45   | 50   |                   |        |      |
|                        |                  | $\varnothing=180^\circ$ | ---  | 40   | 45   |                   |        |      |
| CIE (x,y) chromaticity | White            | x                       | ---  | 0.31 | ---  | ---               | Fig 2. | 5    |
|                        |                  | y                       | ---  | 0.30 | ---  |                   |        |      |
| Reflectance            |                  |                         |      | 6.8  |      | %                 | Fig 4  |      |

Note1. Contrast ratio (CR) is defined mathematically in Figure 2.

$$\text{Contrast Ratio} = \frac{\text{Average Surface Luminance with all white pixels (P1, P2, P3, P4, P5)}}{\text{Average Surface Luminance with all black pixels (P1, P2, P3, P4, P5)}}$$

Note 2. Surface luminance is the LCD surface from the surface with all pixels displaying white. For more information see figure 2.

$$L_v = \text{Average Surface Luminance with all white pixels (P1, P2, P3, P4, P5...)}$$

Note 3. Uniformity of surface luminance, White, is defined mathematically in figure 2.

$$\text{White} = \frac{\text{Minimum Surface Luminance with all white pixels (P1, P2, P3, P4, P5)}}{\text{Maximum Surface Luminance with all white pixels (P1, P2, P3, P4, P5)}}$$

Note 4. Response time is the time required for the display to transition from white to black (rise time Tr) and from black to white (decay or fall time, Tf). The industry standard test equipment used is the Autronic-Melcher's Conoscope.

Note 5. Without backlight, CIE (x,y) chromaticity. The x,y value is determined by measuring luminance at each test position 1 through 5, then calculating the average value.

Note 6. The Viewing angle is the angle at which the contrast ratio is greater than 2. For a TFT module, the contrast ratio is greater than 10. The angles are determined for the horizontal or 'x' axis and the vertical or 'y' axis with respect to the 'z' axis, being the LCD surface reference. Also see figure 3.

Note 7. For viewing angle and response time testing, the testing data is based on Autronic-Melcher's BM-7A. For the contrast ratio, surface luminance, luminance uniformity and chromaticity (CIE), the test data is based on the industry's standard SR-3A photo detector.

Note 8. For TFT modules, grey scale reversing occurs in the opposite direction of the panel viewing angle.

Figure 1. Definition of response time

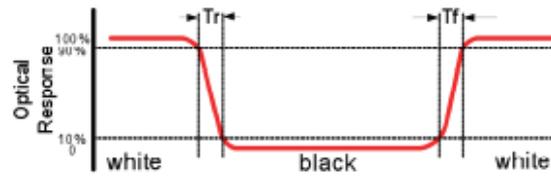


Figure 2. Measuring contrast ratio, surface luminance, luminance uniformity and CIE (chromaticity.)

A: 5mm. B: 5mm. H, V: Active area. Light spot size  $\theta=7\text{mm}$ , 500mm distance from the LCD surface to the detector lens.

Measurement instrument is Topcon's luminance meter BM-7.

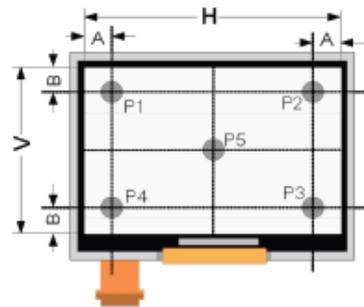


Figure 3. Definition of viewing angle

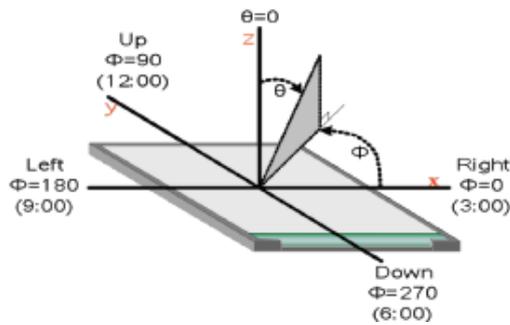
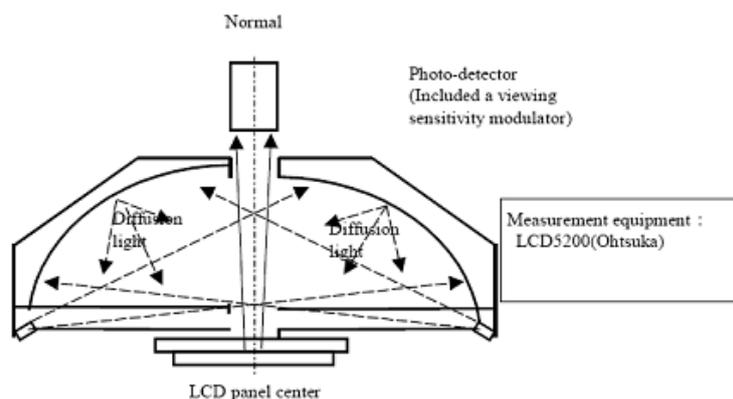


Figure 4. Definition of Reflectance measurement system



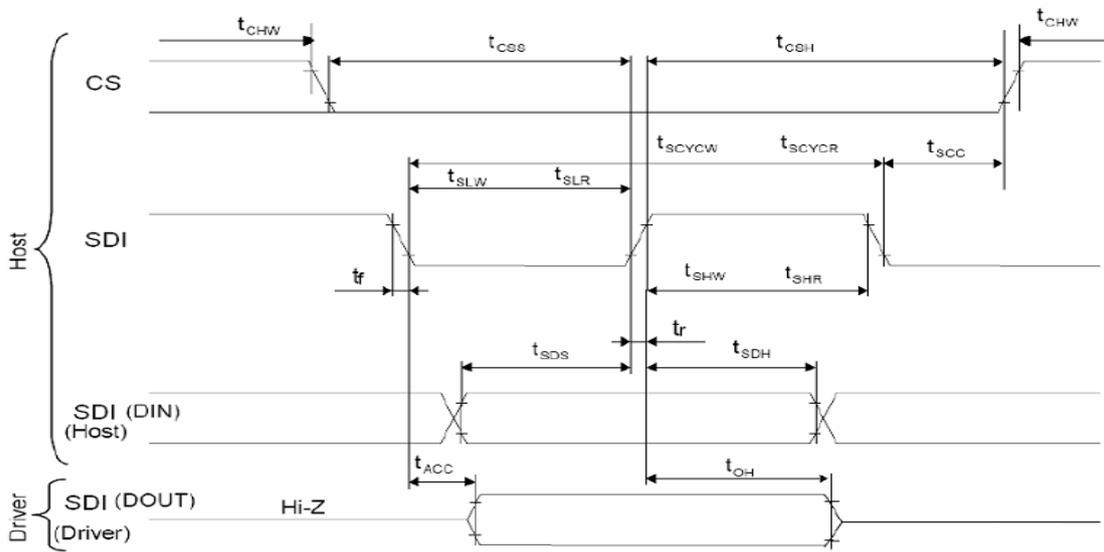
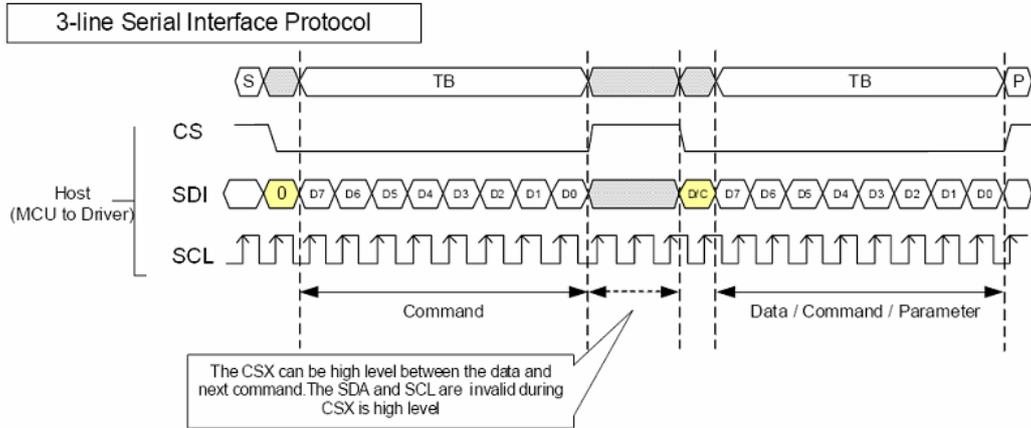
- INTERFACE DESCRIPTION

| <b>Recommended connector: FH23-39S-0.3SHW (HIROSE)</b> |               |            |   |             |
|--|---------------|------------|---|-------------|
| <b>No</b>  | <b>Symbol</b> | <b>I/O</b> | <b>Description</b>                      | <b>Note</b> |
| 1  | LEDA          | I          | Power supply for LED(High voltage)      |             |
| 2  | LEDK          | I          | Power supply for LED(Low voltage)       |             |
| 3  | GND           | P          | Ground                                  |             |
| 4  | VDD           | P          | Power supply of gate driver(high level) |             |
| 5  | GND           | P          | Ground                                  |             |
| 6  | VSYNC         | I          | Vertical sync. signal                   |             |
| 7  | RESET         | I          | Reset Enable                            |             |
| 8  | GND           | P          | Ground                                  |             |
| 9  | CS            | I          | SPI Chip select                         |             |
| 10   | SDO           | O          | SPI serial Data output                  |             |
| 11   | SDI           | I          | SPI serial Data input                   |             |
| 12   | GND           | P          | Ground                                  |             |
| 13   | SCL           | I          | SPI serial interface clock              |             |
| 14   | GND           | P          | Ground                                  |             |
| 15   | B5            | I          | Blue data signal                        |             |
| 16   | B4            | I          | Blue data signal                        |             |
| 17   | B3            | I          | Blue data signal                        |             |
| 18   | B2            | I          | Blue data signal                        |             |
| 19   | B1            | I          | Blue data signal                        |             |
| 20   | B0            | I          | Blue data signal                        |             |
| 21   | ENABLE        | I          | ata enable signal                       |             |
| 22   | HSYNC         | I          | Horizontal sync signal                  |             |
| 23   | GND           | P          | Ground                                  |             |
| 24   | DCLK          | I          | Data sampling clock signal              |             |
| 25   | GND           | P          | Ground                                  |             |
| 26   | G5            | I          | Green data signal                       |             |
| 27   | G4            | I          | Green data signal                       |             |
| 28   | G3            | I          | Green data signal                       |             |
| 29   | G2            | I          | Green data signal                       |             |
| 30   | G1            | I          | Green data signal                       |             |
| 31   | G0            | I          | Green data signal                       |             |
| 32   | GND           | P          | Ground                                  |             |
| 33   | R5            | I          | Red data signal                         |             |
| 34   | R4            | I          | Red data signal                         |             |
| 35   | R3            | I          | Red data signal                         |             |
| 36   | R2            | I          | Red data signal                         |             |
| 37   | R1            | I          | Red data signal                         |             |
| 38   | R0            | I          | Red data signal                         |             |
| 39   | GND           | P          | Ground                                  |             |

Note: I/O definition: I-----Input ;O---Output ;P----Power

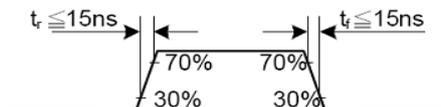
• TIMING CHART and DATA

• 3-line Serial Interface Protocol and Timing

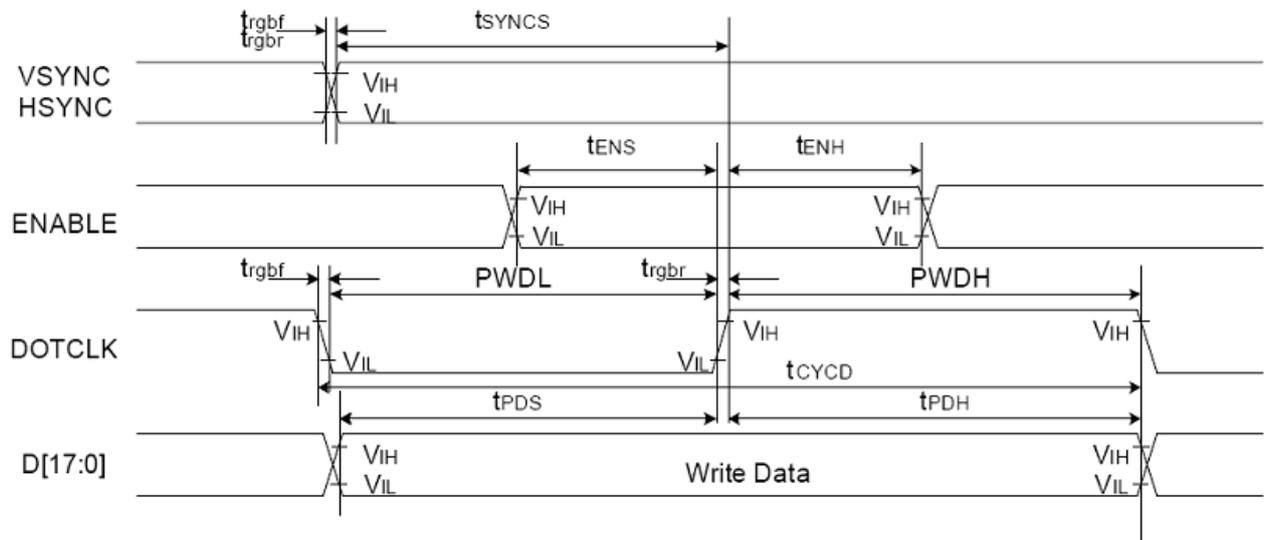


| Signal        | Symbol             | Parameter                         | min | max | Unit | Description                      |                              |
|---------------|--------------------|-----------------------------------|-----|-----|------|----------------------------------|------------------------------|
| VSYNC / HSYNC | $t_{SYNCS}$        | VSYNC/HSYNC setup time            | 15  | -   | ns   | 18/16-bit bus RGB interface mode |                              |
|               | $t_{SYNCH}$        | VSYNC/HSYNC hold time             | 15  | -   | ns   |                                  |                              |
| DE            | $t_{ENS}$          | DE setup time                     | 15  | -   | ns   |                                  |                              |
|               | $t_{ENH}$          | DE hold time                      | 15  | -   | ns   |                                  |                              |
| D[17:0]       | $t_{POS}$          | Data setup time                   | 15  | -   | ns   |                                  |                              |
|               | $t_{PDH}$          | Data hold time                    | 15  | -   | ns   |                                  |                              |
| DOTCLK        | PWDH               | DOTCLK high-level period          | 15  | -   | ns   |                                  |                              |
|               | PWDL               | DOTCLK low-level period           | 15  | -   | ns   |                                  |                              |
|               | $t_{CYCD}$         | DOTCLK cycle time                 | 100 | -   | ns   |                                  |                              |
|               | $t_{qtr}, t_{qbr}$ | DOTCLK,HSYNC,VSYNC rise/fall time | -   | 15  | ns   |                                  |                              |
| VSYNC / HSYNC | $t_{SYNCS}$        | VSYNC/HSYNC setup time            | 15  | -   | ns   |                                  | 6-bit bus RGB interface mode |
|               | $t_{SYNCH}$        | VSYNC/HSYNC hold time             | 15  | -   | ns   |                                  |                              |
| DE            | $t_{ENS}$          | DE setup time                     | 15  | -   | ns   |                                  |                              |
|               | $t_{ENH}$          | DE hold time                      | 15  | -   | ns   |                                  |                              |
| D[17:0]       | $t_{POS}$          | Data setup time                   | 15  | -   | ns   |                                  |                              |
|               | $t_{PDH}$          | Data hold time                    | 15  | -   | ns   |                                  |                              |
| DOTCLK        | PWDH               | DOTCLK high-level pulse period    | 15  | -   | ns   |                                  |                              |
|               | PWDL               | DOTCLK low-level pulse period     | 15  | -   | ns   |                                  |                              |
|               | $t_{CYCD}$         | DOTCLK cycle time                 | 100 | -   | ns   |                                  |                              |
|               | $t_{qtr}, t_{qbr}$ | DOTCLK,HSYNC,VSYNC rise/fall time | -   | 15  | ns   |                                  |                              |

Note:  $T_a = -30$  to  $70$  °C,  $V_{DDI}=1.65V$  to  $3.3V$ ,  $V_{CI}=2.5V$  to  $3.3V$ ,  $AGND=VSS=0V$

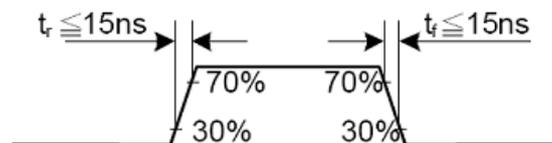


• RGB Interface Timing

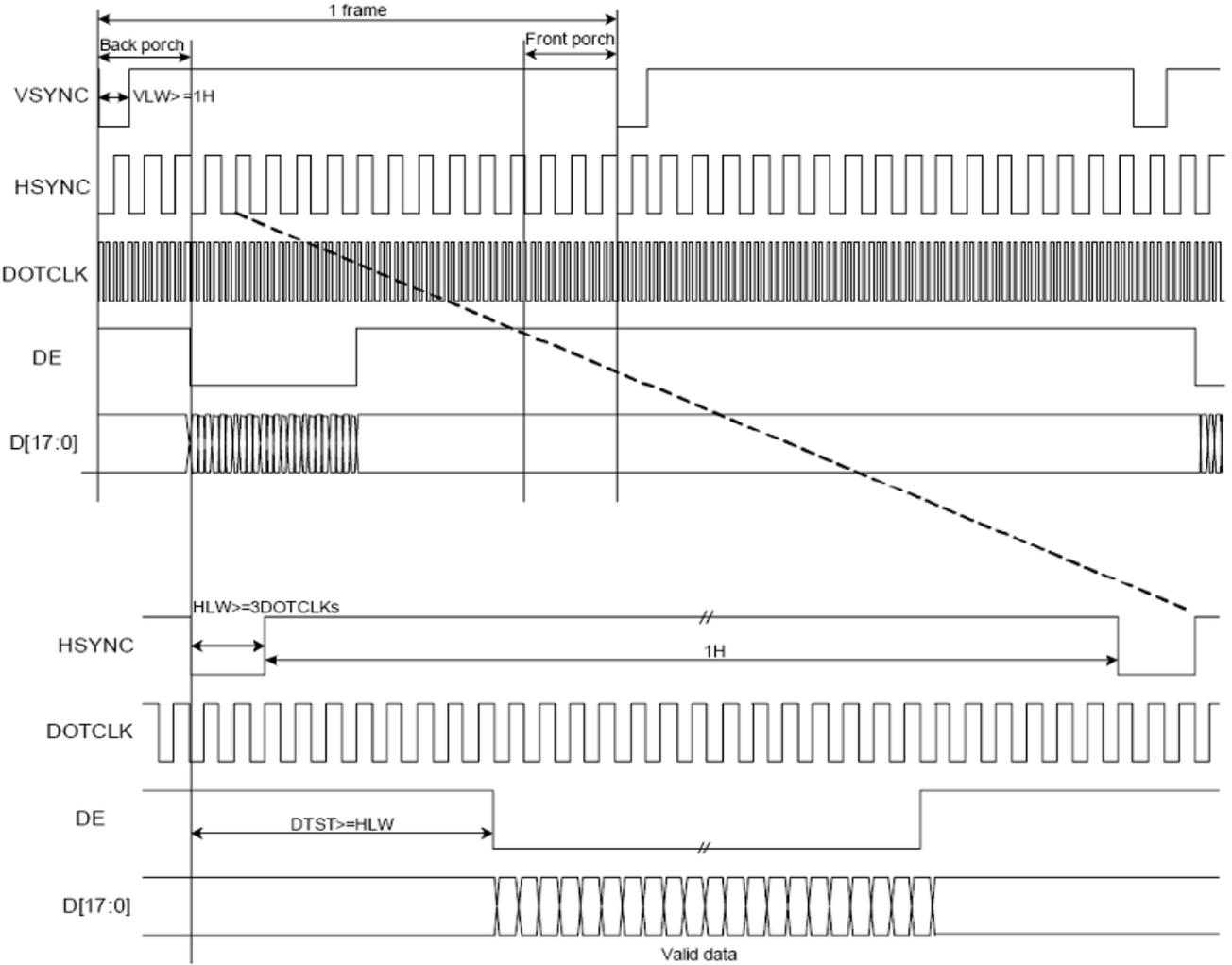


| Signal        | Symbol               | Parameter                         | min | max | Unit | Description                      |                              |
|---------------|----------------------|-----------------------------------|-----|-----|------|----------------------------------|------------------------------|
| VSYNC / HSYNC | $t_{SYNCS}$          | VSYNC/HSYNC setup time            | 15  | -   | ns   | 18/16-bit bus RGB interface mode |                              |
|               | $t_{SYNCH}$          | VSYNC/HSYNC hold time             | 15  | -   | ns   |                                  |                              |
| DE            | $t_{ENS}$            | DE setup time                     | 15  | -   | ns   |                                  |                              |
|               | $t_{ENH}$            | DE hold time                      | 15  | -   | ns   |                                  |                              |
| D[17:0]       | $t_{POS}$            | Data setup time                   | 15  | -   | ns   |                                  |                              |
|               | $t_{PDH}$            | Data hold time                    | 15  | -   | ns   |                                  |                              |
| DOTCLK        | $PWDH$               | DOTCLK high-level period          | 15  | -   | ns   |                                  |                              |
|               | $PWDL$               | DOTCLK low-level period           | 15  | -   | ns   |                                  |                              |
|               | $t_{CYCD}$           | DOTCLK cycle time                 | 100 | -   | ns   |                                  |                              |
|               | $t_{grbr}, t_{grbf}$ | DOTCLK,HSYNC,VSYNC rise/fall time | -   | 15  | ns   |                                  |                              |
| VSYNC / HSYNC | $t_{SYNCS}$          | VSYNC/HSYNC setup time            | 15  | -   | ns   |                                  | 6-bit bus RGB interface mode |
|               | $t_{SYNCH}$          | VSYNC/HSYNC hold time             | 15  | -   | ns   |                                  |                              |
| DE            | $t_{ENS}$            | DE setup time                     | 15  | -   | ns   |                                  |                              |
|               | $t_{ENH}$            | DE hold time                      | 15  | -   | ns   |                                  |                              |
| D[17:0]       | $t_{POS}$            | Data setup time                   | 15  | -   | ns   |                                  |                              |
|               | $t_{PDH}$            | Data hold time                    | 15  | -   | ns   |                                  |                              |
| DOTCLK        | $PWDH$               | DOTCLK high-level pulse period    | 15  | -   | ns   |                                  |                              |
|               | $PWDL$               | DOTCLK low-level pulse period     | 15  | -   | ns   |                                  |                              |
|               | $t_{CYCD}$           | DOTCLK cycle time                 | 100 | -   | ns   |                                  |                              |
|               | $t_{grbr}, t_{grbf}$ | DOTCLK,HSYNC,VSYNC rise/fall time | -   | 15  | ns   |                                  |                              |

Note:  $T_a = -30$  to  $70$  °C,  $V_{DDI}=1.65V$  to  $3.3V$ ,  $V_{CI}=2.5V$  to  $3.3V$ ,  $AGND=V_{SS}=0V$



The timing chart of 18-/16-bit RGB interface mode is shown as below

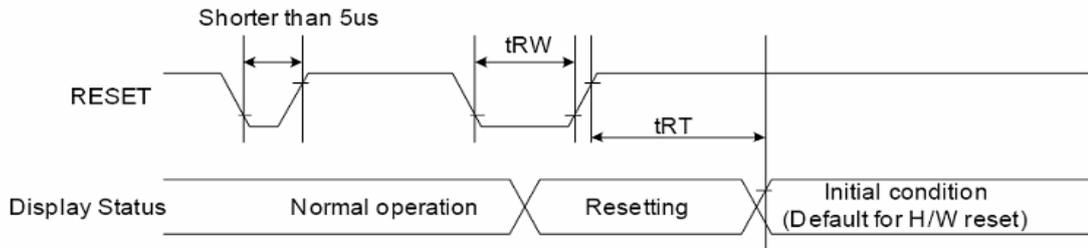


VLW : VSYNC Low Width  
 HLW : HSYNC Low Width  
 DTST : Data Transfer Startup Time

Note 1: The DE signal is not needed when RGB interface SYNC mode is selected.

Note 2: VSPL='0'. HSPL='0'. DPL='0' and EPL='1' of "Interface Mode Control (B0h)" command.

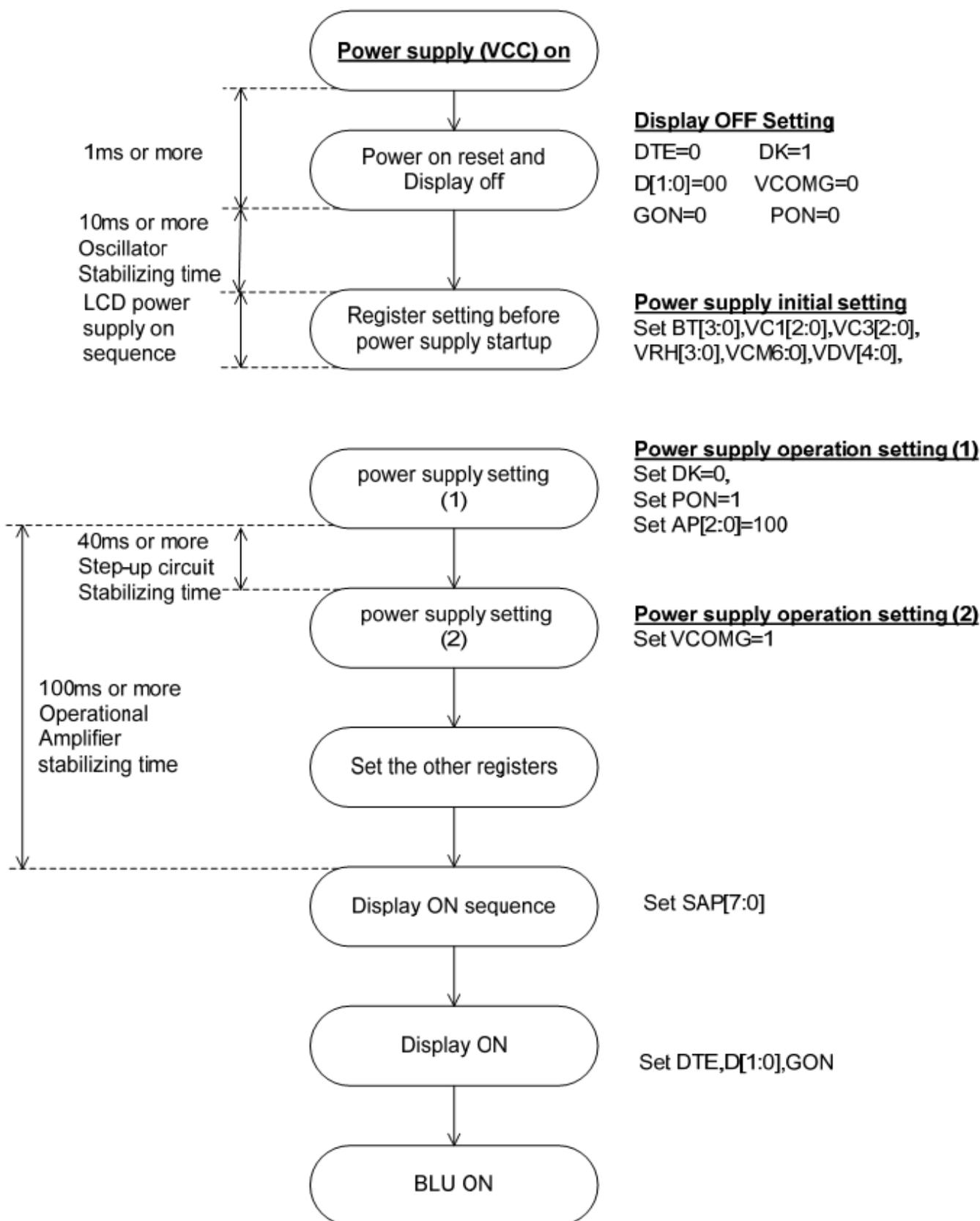
- Reset Timing



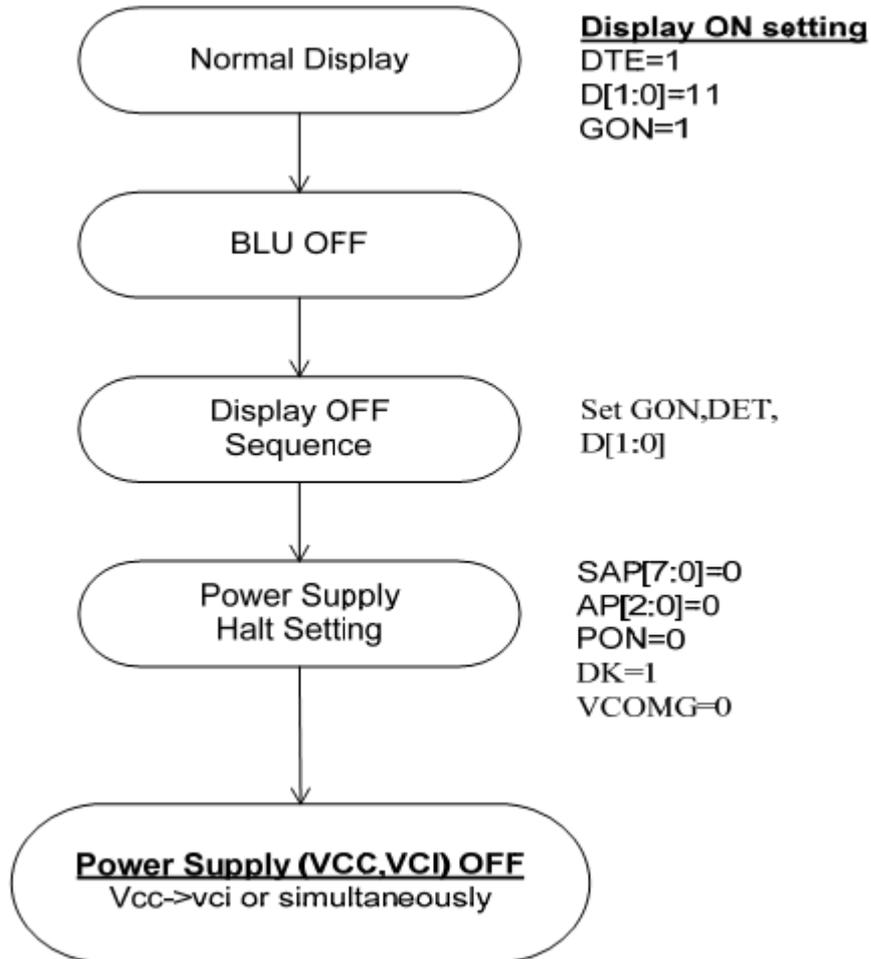
| Signal | Symbol | Parameter            | Min | Max | Unit |
|--------|--------|----------------------|-----|-----|------|
| RESET  | tRW    | Reset pulse duration | 10  |     | uS   |
|        | tRT    | Reset cancel         |     | 5   | mS   |
|        |        |                      |     | 120 | mS   |

• Power On/Off Sequence

Power On Sequence



Power Off Sequence



• RELIABILITY TESTING

| NO. | Item                                     | Condition  | Criteria  |
|-----|--|--|---|
| 1   | High Temperature Operating               | 70°C +/-2°C, 240Hrs  | IEC60068-2-1<br>GB2423.2  |
| 2   | Low Temperature Operating                | -20°C +/-2°C, 240Hrs   | IEC60068-2-1<br>GB2423.1  |
| 3   | High Temperature Storage                 | 80°C +/-2°C, 240Hrs  | IEC60068-2-1<br>GB2423.2  |
| 4   | Low Temperature Storage                  | -30°C +/-2°C, 240Hrs   | IEC60068-2-1<br>GB2423.2  |
| 5   | High Temperature & High Humidity Storage | +40°C, 90% RH max,240 hours  | IEC60068-2-3,<br>GB/T2423.3   |
| 6   | Thermal Shock (Non-operation)            | -30°C 30 min~+80°C 30 min,<br>Change time:5min, 20 Cycle   | Start with cold temperature,<br>End with high temperature,<br>EC60068-2-14,GB2423.22—<br>87 |
| 7   | Vibration (non operating)                | Frequency range:10~55Hz,<br>Stroke:1.5mm<br>Sweep:10Hz~55Hz~10Hz 1 hours<br>for each direction of X.Y.Z.<br>(3 hours for total)          | IEC60068-2-6<br>GB/T2423.10   |
| 8   | Drop Test (packaged)                     | Height:80 cm,1 corner, 3 edges, 6 surfaces   | IEC60068-2-32<br>GB/T2423.8   |
| 9   | Shock (non-operation)                    | 60G 6ms, ±X,±Y,±Z 3 times for each direction   | IEC60068-2-27<br>GB/T2423.5   |
| 10  | ESD (operation)                          | C=150pF, R=330Ω · 5points/panel<br>Air:± 8KV, 5times;<br>Contact:± 4KV, 5 times;<br>( Environment: 15°C~35°C,<br>30%~60%, 86Kpa~106Kpa ) | IEC61000-4-2<br>GB/T17626.2—1998  |

Notes:

1. Test samples are applied to one test item.
2. Sample size for each test item is 2-10pcs.
3. For humidity testing, a pure water resistance of >10MW should be used.
4. (a) In the case of a malfunction caused by ESD damage, if the LCM returns to it's normal state after resetting, the item is considered to have passed the ESD test.  
(b) It is recommended to use an anti-static blower ( ionizer ) to reduce the electro-static voltage in the working area.  
(c) When removing the protection film from the LCM panel, peel off the film slowly (more than 1sec) while blowing the ioniser towards the peeling area to minimize ESD. This will reduce the risk of damaging the electrical circuitry.
5. If it is installed, please use the automatic test mode on the LCM &/or demonstration box when testing.

## • INSPECTION CRITERIA

This specification is designed to be used as the standard acceptance/rejection criteria for normal LCM products.

### 1. Sampling plan.

The sampling plan according to GB/T 2828.1-2003 / ISO2859-16 1999 and ANSI/ASQC Z1.4 1993, normal level 2 and based on:

- Major defect: AQL 0.65
- Minor defect: AQL 1.5

### 2. Inspection condition

- The viewing distance for cosmetic inspection is approximately 30cm with the naked eye, and under an environment of 20-40W light intensity, in all directions, within 45° against a perpendicular line. (Normal temperature 20-25°C and normal humidity 60+/-15 RH.)
- Driving voltage - The Vop value from which the most optimal contrast can be obtained near the specified Vop in the specification (within +/-0.5V of the typical value at 25°C.)

### 3. Definition of inspection zone in LCD.

Zone A: active area

Zone B: viewing area except Zone A (Zone A + Zone B = Minimum viewing area)

Zone C: outside viewing area (invisible area after assembling customer's product.

Figure 4

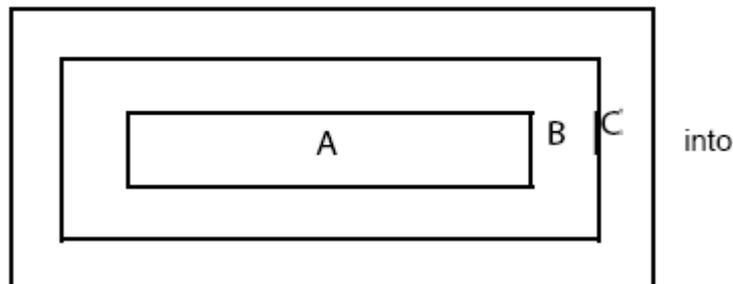


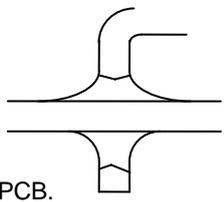
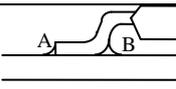
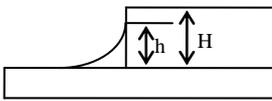
Figure 4 inspection zones in an LCD

Note: As a general rule visual defects in Zone C are permissible when there is no visual effect once assembled into the customer's product.

• INSPECTION STANDARD

| No. | Item                   | Judgment Criteria  | Partition |
|-----|------------------------|--|-----------|
| 1   | All functional defects | 1) No display<br>2) Display abnormal<br>3) Missing vertical or horizontal segment<br>4) Short circuit<br>5) Backlight not working, flickering and abnormal light | Major     |
| 2   | Missing                | Missing component  | Major     |
| 3   | Outline dimension      | Overall outline dimension beyond the drawing dimension is not allowed  | Major     |

• COSMETIC CRITERIA

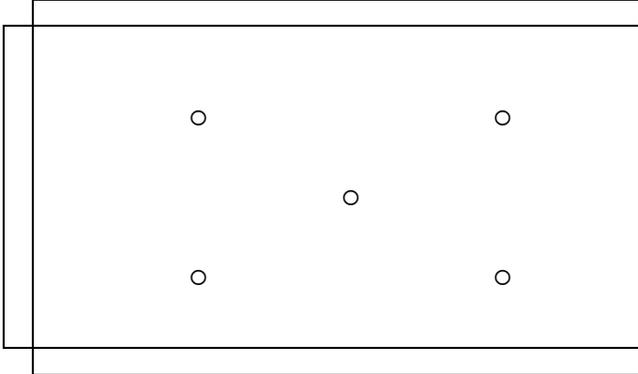
| No. | Item                                 | Judgment Criteria   | Partition                        |
|-----|--------------------------------------|---|----------------------------------|
| 1   | Difference in Spec.                  | None allowed  | Major                            |
| 2   | Pattern peeling                      | No substrate pattern peeling and floating   | Major                            |
| 3   | Soldering defects                    | No soldering missing<br>No soldering bridge<br>No cold soldering  | Major<br>Major<br>Major          |
| 4   | Resist flaw on substrate             | Invisible copper foil (∅0.5mm or more) on substrate pattern   | Minor                            |
| 5   | Accretion of metallic Foreign matter | No soldering dust<br>No accretion of metallic foreign matters (Not exceed ∅0.2mm)   | Minor<br>Minor                   |
| 6   | Stain                                | No stain to spoil cosmetic badly  | Minor                            |
| 7   | Plate discoloring                    | No plate fading, rusting and discoloring  | Minor                            |
| 8   | 1. Lead parts                        | a. Soldering side of PCB<br>Solder to form a 'Filet' all around the lead.<br>Solder should not hide the lead form perfectly. (too much)<br>b. Components side<br>( In case of 'Through Hole PCB' )<br>  | Minor                            |
|     | 2. Flat packages                     | Solder to reach the Components side of PCB.<br>Either 'toe' (A) or 'heel' (B) of the lead to be covered by 'Filet'.<br>Lead form to be assume over solder.<br>   | Minor                            |
|     | 3. Chips                             | $(3/2) H \geq h \geq (1/2) H$<br>   | Minor                            |
| 9   | Solder ball/solder splash            | a) The spacing between solder ball and the conductor or solder pad $h \geq 0.13\text{mm}$ .<br>The diameter of the solder ball $d \leq 0.15\text{mm}$ .<br>b) The quantity of solder balls or solder splashes isn't more than 5 in 600mm <sup>2</sup> .<br>c) Solder balls / splashes do not violate minimum electrical clearance<br>d) Solder balls/splashes must be not be able to be dislodged with normal product usage | Minor<br>Minor<br>Major<br>Minor |

• **COSMETIC CRITERIA (non-operating)**

| No.           | Defect                        | Judgment Criteria   | Classification |                               |         |           |               |   |               |   |         |   |       |
|---------------|-------------------------------|---|----------------|-------------------------------|---------|-----------|---------------|---|---------------|---|---------|---|-------|
| 1             | Spots                         | In accordance with Screen Cosmetic Criteria (Operating) No.1.   | Minor          |                               |         |           |               |   |               |   |         |   |       |
| 2             | Lines                         | In accordance with Screen Cosmetic Criteria (Operating) No.2.   | Minor          |                               |         |           |               |   |               |   |         |   |       |
| 3             | Bubbles in polarizer          | <table border="1"> <thead> <tr> <th>Size : d mm</th> <th>Acceptable Qty in active area</th> </tr> </thead> <tbody> <tr> <td>d ≤ 0.3</td> <td>Disregard</td> </tr> <tr> <td>0.3 &lt; d ≤ 1.0</td> <td>3</td> </tr> <tr> <td>1.0 &lt; d ≤ 1.5</td> <td>1</td> </tr> <tr> <td>1.5 &lt; d</td> <td>0</td> </tr> </tbody> </table> | Size : d mm    | Acceptable Qty in active area | d ≤ 0.3 | Disregard | 0.3 < d ≤ 1.0 | 3 | 1.0 < d ≤ 1.5 | 1 | 1.5 < d | 0 | Minor |
| Size : d mm   | Acceptable Qty in active area |   |                |                               |         |           |               |   |               |   |         |   |       |
| d ≤ 0.3       | Disregard                     |   |                |                               |         |           |               |   |               |   |         |   |       |
| 0.3 < d ≤ 1.0 | 3                             |   |                |                               |         |           |               |   |               |   |         |   |       |
| 1.0 < d ≤ 1.5 | 1                             |   |                |                               |         |           |               |   |               |   |         |   |       |
| 1.5 < d       | 0                             |   |                |                               |         |           |               |   |               |   |         |   |       |
| 4             | Scratch                       | In accordance with spots and lines operating cosmetic criteria. When the light reflects on the panel surface, the scratches are not to be remarkable.   | Minor          |                               |         |           |               |   |               |   |         |   |       |
| 5             | Allowable density             | Above defects should be separated more than 30mm each other.  | Minor          |                               |         |           |               |   |               |   |         |   |       |
| 6             | Coloration                    | Not to be noticeable coloration in the viewing area of the LCD panels.<br>Back-lit type should be judged with back-lit on state only.   | Minor          |                               |         |           |               |   |               |   |         |   |       |
| 7             | Contamination                 | Not to be noticeable.   | Minor          |                               |         |           |               |   |               |   |         |   |       |

• **COSMETIC CRITERIA (operating)**

| No.           | Defect                        | Judgment Criteria   | Classification |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
|---------------|-------------------------------|---|----------------|-------------------------------|---------|-----------|---------------|---|---------------|---|---------|---|-------------|-------------------------------|---------|-----------|---------------|---|---------------|---|---------|---|-------|
| 1             | Spots                         | <p>A) Clear</p> <table border="1"> <thead> <tr> <th>Size : d mm</th> <th>Acceptable Qty in active area</th> </tr> </thead> <tbody> <tr> <td>d ≤ 0.1</td> <td>Disregard</td> </tr> <tr> <td>0.1 &lt; d ≤ 0.2</td> <td>6</td> </tr> <tr> <td>0.2 &lt; d ≤ 0.3</td> <td>2</td> </tr> <tr> <td>0.3 &lt; d</td> <td>0</td> </tr> </tbody> </table> <p>Note : Including pin holes and defective dots which must be within one pixel size.</p> <p>B) Unclear</p> <table border="1"> <thead> <tr> <th>Size : d mm</th> <th>Acceptable Qty in active area</th> </tr> </thead> <tbody> <tr> <td>d ≤ 0.2</td> <td>Disregard</td> </tr> <tr> <td>0.2 &lt; d ≤ 0.5</td> <td>6</td> </tr> <tr> <td>0.5 &lt; d ≤ 0.7</td> <td>2</td> </tr> <tr> <td>0.7 &lt; d</td> <td>0</td> </tr> </tbody> </table> | Size : d mm    | Acceptable Qty in active area | d ≤ 0.1 | Disregard | 0.1 < d ≤ 0.2 | 6 | 0.2 < d ≤ 0.3 | 2 | 0.3 < d | 0 | Size : d mm | Acceptable Qty in active area | d ≤ 0.2 | Disregard | 0.2 < d ≤ 0.5 | 6 | 0.5 < d ≤ 0.7 | 2 | 0.7 < d | 0 | Minor |
| Size : d mm   | Acceptable Qty in active area |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| d ≤ 0.1       | Disregard                     |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 0.1 < d ≤ 0.2 | 6                             |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 0.2 < d ≤ 0.3 | 2                             |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 0.3 < d       | 0                             |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| Size : d mm   | Acceptable Qty in active area |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| d ≤ 0.2       | Disregard                     |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 0.2 < d ≤ 0.5 | 6                             |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 0.5 < d ≤ 0.7 | 2                             |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 0.7 < d       | 0                             |   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 2             | Lines                         | <p>A) Clear</p> <p>Note : ( ) - Acceptable Qty in active area<br/>L - Length (mm)<br/>W - Width (mm)<br/>∞ - Disregard</p> <p>B) Unclear</p>  | Minor          |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 3             | Rubbing line                  | Not to be noticeable.   |                |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |
| 4             | Allowable density             | Above defects should be separated more than 10mm each other.  | Minor          |                               |         |           |               |   |               |   |         |   |             |                               |         |           |               |   |               |   |         |   |       |

|   |   |  |       |
|---|---|--|-------|
| 5 | Rainbow   | Not to be noticeable.  | Minor |
| 6 | Dot size  | To be 95% ~ 105% of the dot size (Typ.) in drawing.<br>Partial defects of each dot (ex. pin-hole) should be treated as 'spot'.<br>(see Screen Cosmetic Criteria (Operating) No.1)  | Minor |
| 7 | Uneven brightness<br>(only back-lit type<br>module) | <p>Uneven brightness must be <math>B_{MAX} / B_{MIN} \leq 2</math></p> <p>- <math>B_{MAX}</math> : Max. value by measure in 5 points<br/>- <math>B_{MIN}</math> : Min. value by measure in 5 points</p> <p>Divide active area into 4 vertically and horizontally.<br/>Measure 5 points shown in the following figure.</p>  <p>○ : Measuring points</p> | Minor |

## Note :

- (1) Size :  $d = (\text{long length} + \text{short length}) / 2$
- (2) The limit samples for each item have priority.
- (3) Complex defects are defined item by item, but if the number of defects are defined in above table, the total number should not exceed 10.
- (4) In case of 'concentration', even the spots or the lines of 'disregarded' size should not allowed.  
Following three situations should be treated as 'concentration'.
  - 7 or over defects in circle of  $\varnothing 5\text{mm}$ .
  - 10 or over defects in circle of  $\varnothing 10\text{mm}$ .
  - 20 or over defects in circle of  $\varnothing 20\text{mm}$ .

- PRECAUTIONS FOR USING LCD MODULES

- HANDLING PRECAUTIONS

(1) The panel is made of glass. Do not subject it to a mechanical shock by dropping it or impact.

(2) If the display panel is damaged and the liquid crystal substance leaks out, be sure not to get any in your mouth. If the substance contacts your skin or clothes, wash it off using soap and water.

(3) Do not apply excessive force to the display surface or the adjoining areas since this may cause the color tone to vary.

(4) The polarizer covering the display surface of the LCD module is soft and easily scratched. Handle this polarizer carefully.

(5) If the display surface becomes contaminated, breathe on the surface and gently wipe it with a soft dry cloth. If it is heavily contaminated, moisten cloth with one of the following solvents :

- Isopropyl alcohol
- Ethyl alcohol

(6) Solvents other than those above-mentioned may damage the polarizer. Especially, do not use the following.

- Water
- Ketone
- Aromatic solvents

(7) Exercise care to minimize corrosion of the electrode. Water droplets, moisture condensation or a current flow in a high-humidity environment, accelerate corrosion of the electrodes.

(8) Install the LCD Module by using the mounting holes. When mounting the LCD module make sure it is free of twisting, warping and distortion. In particular, do not forcibly pull or bend the I/O cable or the backlight cable.

(9) Do not attempt to disassemble or process the LCD module.

(10) NC terminal should be open. Do not connect anything.

(11) If the logic circuit power is off, do not apply the input signals.

(12) To prevent destruction of the elements by static electricity, be careful to maintain an optimum work environment.

- Be sure to ground the body when handling the LCD modules.
- Tools required for assembling, such as soldering irons, must be properly grounded.
- To reduce the amount of static electricity generated, do not conduct assembling and other work under dry conditions.
- The LCD module is coated with a film to protect the display surface. Exercise care when peeling off this protective film since static electricity may be generated.

- STORAGE PRECAUTIONS

When storing the LCD modules, avoid exposure to direct sunlight or to the light of fluorescent lamps. Keep the modules in bags (avoid high temperature / high humidity and low temperatures below the stated storage temperature of the LCM specification).

- OTHER

Liquid crystals solidify under low temperature (below the storage temperature range) leading to defective orientation or the generation of air bubbles (black or white). Air bubbles may also be generated if the module is subject to a low temperature.

If the LCD modules have been operating for a long time showing the same display patterns, the display patterns may remain on the screen as ghost images and a slight contrast irregularity may also appear. A normal operating status can be regained by suspending use for some time. It should be noted that this phenomenon does not adversely affect performance reliability.

To minimize the performance degradation of the LCD modules resulting from destruction caused by static electricity etc., exercise care to avoid holding the following sections when handling the modules.

- Exposed area of the printed circuit board.
- Terminal electrode sections.

- USING LIQUID CRYSTAL DISPLAY MODULES

An LCD is composed of glass and polarizer. Pay attention to the following items when handling.

(1) Please keep the temperature within specified range for use and storage. Polarization degradation, bubble generation or polarizer peel-off may occur with high temperature and high humidity.

(2) Do not touch, push or rub the exposed polarisers with anything harder than an HB pencil lead (glass, tweezers, etc.).

(3) N-hexane is recommended for cleaning the adhesives used to attach front/rear polarisers and reflectors made of organic substances that may be damaged by chemicals such as acetone, toluene, ethanol and isopropyl alcohol.

(4) When the display surface becomes dusty, wipe gently with absorbent cotton or other soft material like chamois soaked in petroleum benzene. Do not scrub hard to avoid damaging the display surface.

(5) Wipe off saliva or water drops immediately, contact with water over a long period of time may cause deformation or color fading.

(6) Avoid contacting oil and fats.

(7) Condensation on the surface and contact with terminals due to cold will damage, stain or dirty the polarisers. After products are tested at low temperature they must be warmed up in a container before coming in contact with room temperature air.

(8) Do not put or attach anything on the display area to avoid leaving marks on.

(9) Do not touch the display with bare hands. This will stain the display area and degrade the insulation between the terminals.

(10) As glass is fragile. It tends to become chipped during handling especially on the edges.

(11) Mounting Method

The panel of the LCD Module consists of two thin glass plates with polarizers, which easily get damaged. Since the Module is fixed by utilizing fitting holes in the printed circuit board.

Extreme care should be taken when handling the LCD Modules.

(12) Caution against static charge

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

- PRECAUTIONS FOR SOLDERING

|                  | Manual Soldering                    | Machine Drag Soldering              | Machine Pre-soldering                                       |
|------------------|-------------------------------------|-------------------------------------|---|
| Non ROHS Product | 290°C ~ 350°C<br>Speed : 3 ~ 5 mm/s | 330°C ~ 350°C<br>Speed : 4 ~ 8mm/s  | 300°C ~ 330°C<br>Time : 3 ~ 6S<br>Pressure : 0.8 to 1.2Mpa  |
| RoHS Product     | 340°C ~ 370°C<br>Time : 3 ~ 5S.     | 350°C ~ 370°C<br>Time : 4 ~ 8 mm/S. | 330°C ~ 360°C<br>Time : 3 ~ 6S.<br>Pressure : 0.8 ~ 1.2Mpa. |

(1) If solder flux is used, be sure to remove any remaining flux after finishing the soldering process. (This does not apply in the case of a non-halogen type of flux.) It is recommended that you protect the LCD surface with a cover during the soldering process to prevent any damage due to the flux sparks.

(2) When soldering a backlight panel and PCB, the panel and PCB should not be detached more than 3 times. The temperature determines this number and time conditions as mentioned in the above table, although there may be some variance depending on the actual temperature of the soldering iron.

(3) When removing a backlight panel from the PCB, ensure the solder has completely melted; otherwise the solder pads on the backlight panel and/or PCB may be damaged.

- CAUTIONS FOR OPERATION

(1) It is recommended to drive LCDs within their specified voltage limit since the higher voltage than the upper limit shortens the LCD life. An electrochemical reaction due to direct current causes the LCD to deteriorate. Therefore, avoid the use of direct current drive.

(2) Response time will be extremely delayed at lower temperatures than the operating temperature range. At higher temperatures LCD's will experience a dark color. However those phenomena do not mean a malfunction or the LCD's. Once the LCDs are returned to the specified operating temperature range, the response time and coloration should return to the normal state.

(3) If the display area is physically pressed hard during it's operation, some pixels may be abnormally displayed, but should return to their normal condition after resetting the LCM.

(4) Moisture sitting on the LCM terminals is a cause for an electro-chemical reaction resulting in a terminal open circuit. Usage under the relative condition of 40°C, 50%RH or less is therefore required.

- SAFETY

(1) It is recommended to crush any damaged or unnecessary LCDs into pieces and wash off the liquid crystal by using solvents such as acetone and ethanol, which should then be burned up later.

(2) When any liquid crystal has leaked out of a damaged glass cell and comes in contact with skin, please wash it off well with soap and water.

- WARRANTY

Unless otherwise agreed between Logic Technologies Ltd and the customer, Logic Technologies will replace or repair any of its products that are found to be functionally defective when inspected in accordance with Logic Technologies' acceptance criteria (copies available upon request) for a period of one year from date of shipment. Cosmetic/visual defects must be returned to Logic Technologies within 90 days of shipment. Confirmation of such date shall be based on freight documents. The warranty liability of Logic Technologies is limited to the repair and/or replacement on the terms set forth above. Logic Technologies will not be responsible for any subsequent or consequential losses and/or events.

#### Returning products under warranty

No warranty can be granted if the precautions stated above have been disregarded. The typical examples of violations are:

- Broken LCD glass.
- PCB eyelet's damaged or modified.
- PCB conductors damaged.
- Circuit modified in any way, including addition of components.
- PCB tampered with by grinding, engraving or painting varnish.
- Soldering to or modifying the bezel in any manner.

Product repairs will be invoiced to the customer upon mutual agreement. Products must be returned with sufficient description of the failures and/or defects. Any connectors or cable installed by the customer must be removed completely without damaging the PCB eyelet's, conductors and terminals.