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# SPECIFICATION

**DG-T320240-027**

☐ Preliminary Specification

☐ Final Specification



**CUSTOMER:**

**Made By:**

**Checked By:**

**Approved By:**

**Quality:**

**Date:**

**Note:**

**Approved By:**

**Date:**

**Note:**

## Records of Revision

[illegible]

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# Contents

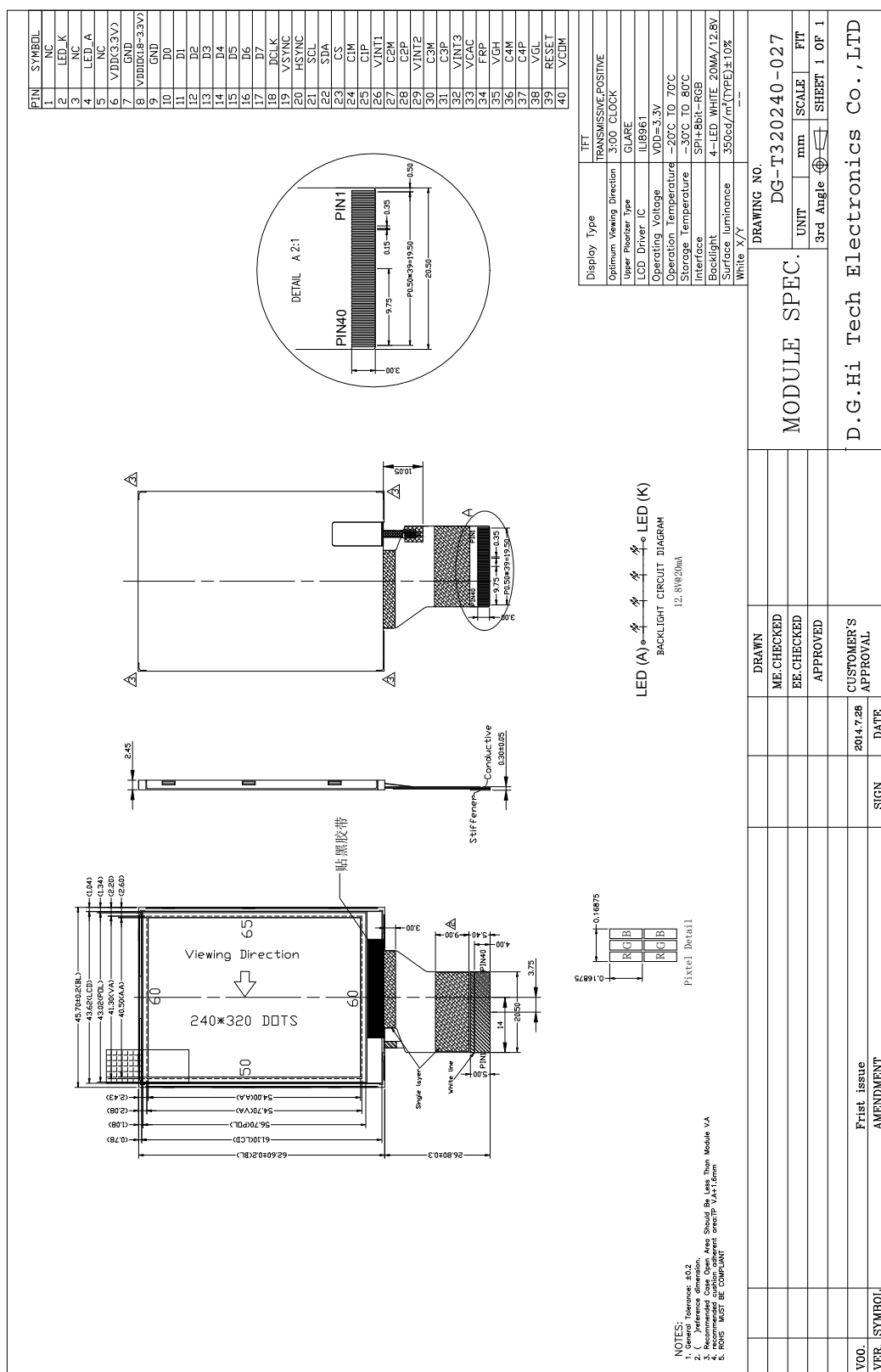
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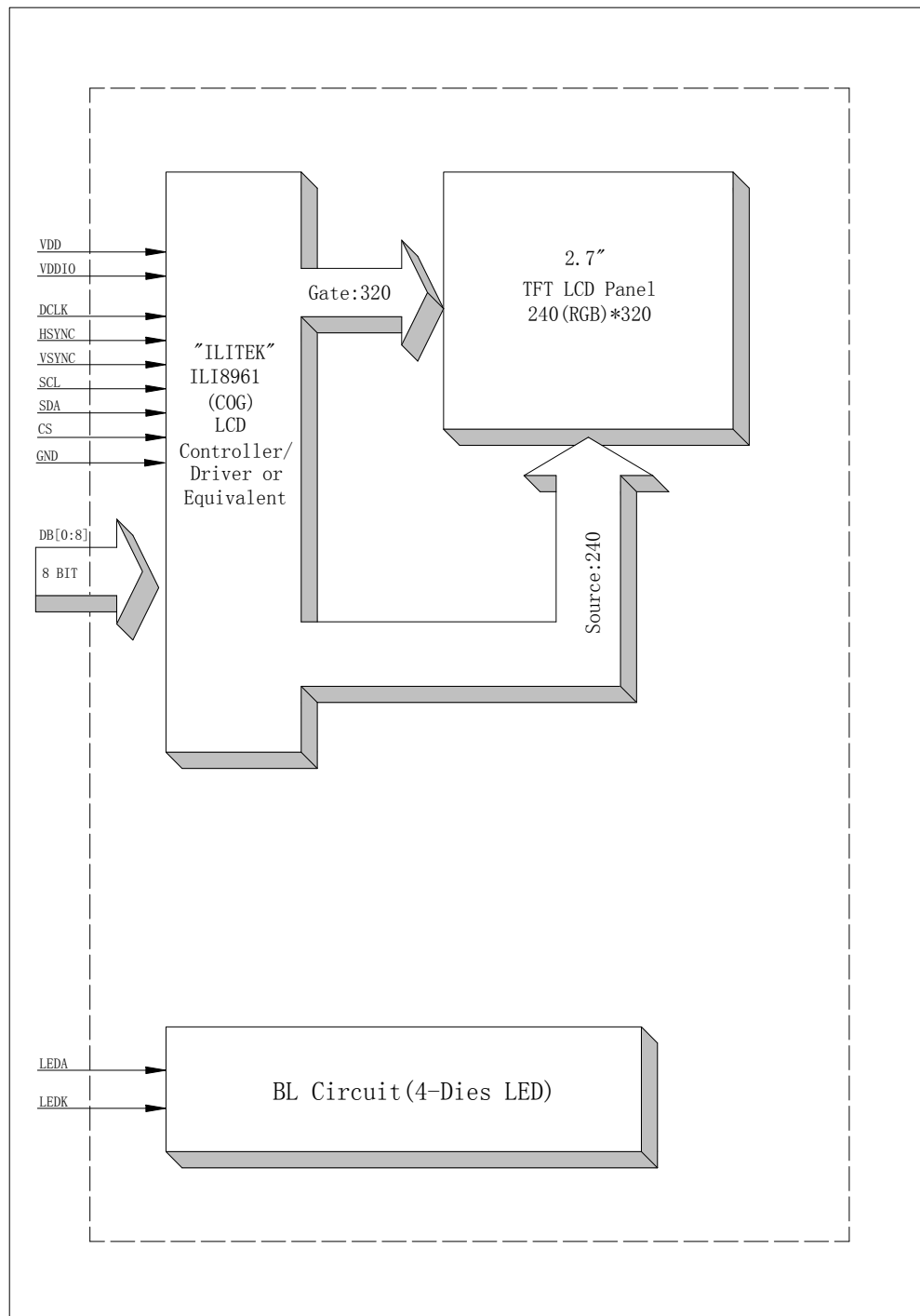
# 1. General Specification

Item	Contents	Unit
LCD TYPE	TFT/TRANSMISSIVE	
MODULE SIZE (W*H*T)	45.70*62.60*2.45	MM
ACTIVE SIZE (W*H)	40.50*54.00	MM
PIXEL PITCH (W*H)	0.16875*0.16875	MM
NUMBER OF DOTS	240*320	
DIVER IC	ILI8961	
INTERFACE TYPE	SPI+8 BIT RGB	
TOP POLARIZER TYPE	ANTI-GLARE	
RECOMMEND VIEWING DIRECTION	3	O’CLOCK
GRAY SCALE INVERSION DIRECTION	9	O’CLOCK
COLORS	262K	
BACKLIGHT TYPE	4-DIES WHITE LED	
TOUCH PANEL TYPE	WITHOUT	

## 2. Mechanical Drawing



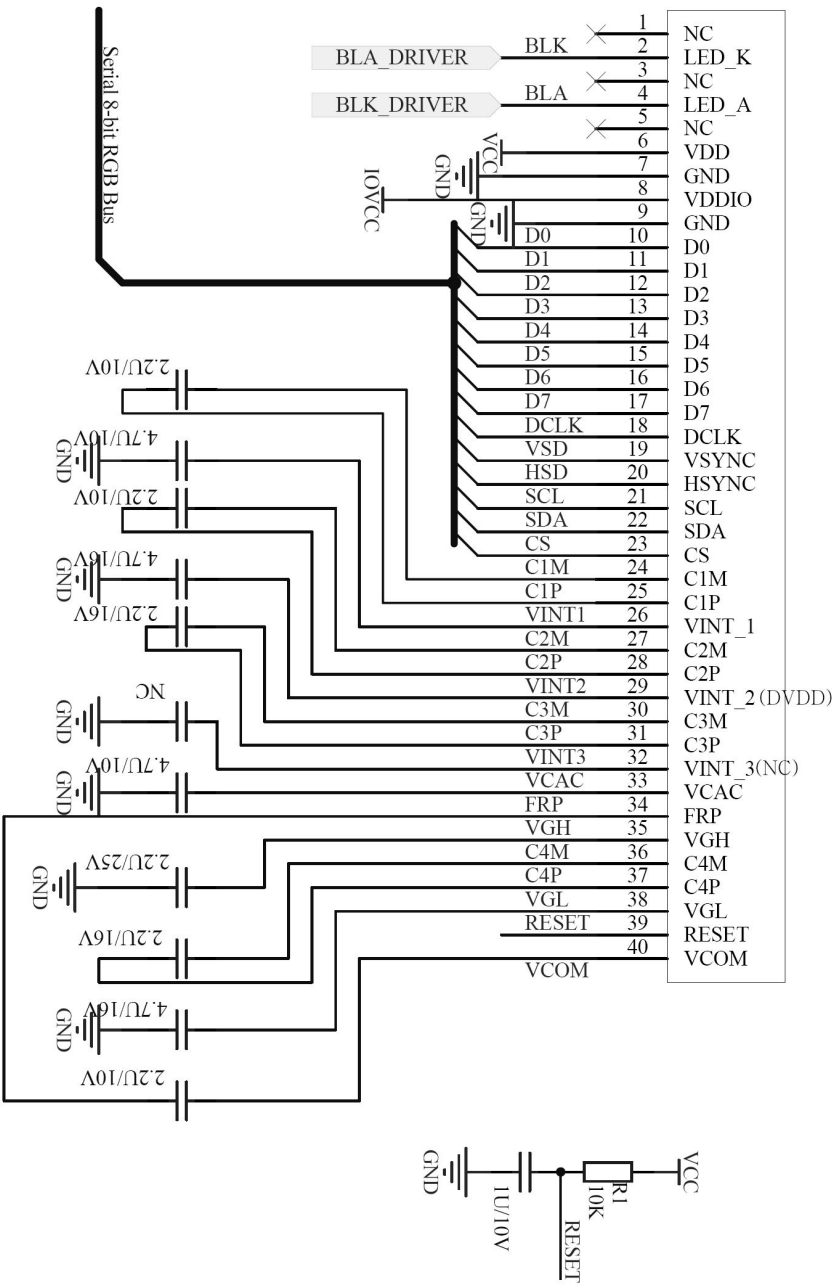
### 3. Block Diagram



## 4. Interface Pin Function

Pin No.	Symbol	Description
1	NC	No Connect
2	LED_K	Cathode of backlight
3	NC	No Connect
4	LED_A	Anode of backlight
5	NC	No Connect
6	VDD(3.3V)	Power supply
7	GND	Ground
8	VDDIO(1.8-3.3V)	Power supply for digital
9	GND	Ground
10	D0	Data bus
11	D1	Data bus
12	D2	Data bus
13	D3	Data bus
14	D4	Data bus
15	D5	Data bus
16	D6	Data bus
17	D7	Data bus
18	DCLK	Pixel clock signal in RGB interface.
19	VSYNC	Vertical signal in RGB interface.
20	HSYNC	Horizon signal in RGB interface
21	SCL	Serial clock input signal
22	SDA	Serial data input signal
23	CS	Chip select signal
24	C1M	Pins to connect capacitors for power circuit
25	C1P	
26	VINT1	
27	C2M	
28	C2P	
29	VINT2	
30	C3M	
31	C3P	
32	VINT3	
33	VCAC	
34	FRP	Frame polarity output(Capacitor connect to VCOM)
35	VGH	Positive power supply for gate driver(+18v)
36	C4M	Pins to connect capacitors for power circuit
37	C4P	
38	VGL	Negative power supply for gate driver(-16v)
39	RESET	Reset signal
40	VCOM	VCOM pin

Application circuit:





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## 5. Absolute Maximum Ratings

Parameter	Symbol	Min	Max	Unit
Supply voltage for analog	VDD	-0.3	4.6	V
Supply voltage for logic	VDDIO	-0.3	4.6	V
Supply current (One LED)	I <sub>LED</sub>		30	mA
Operating temperature	T <sub>OP</sub>	-20	+70	°C
Storage temperature	T <sub>ST</sub>	-30	+80	°C

Note: The absolute maximum rating values of this product are not allowed to be exceeded at any times. Should a module be used with any of the absolute maximum ratings exceeded, the characteristics of the module may not be recovered, or in an extreme case, the module may be permanently destroyed.

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## 6. Electrical Characteristics

### 6.1 Input Power

Item	Symbol	Min	Typ.	Max	Unit	Applicable terminal
Supply Voltage for Analog	VDD	2.5	2.8	3.3	V	
Supply Voltage for Logic	VDDIO	1.65	1.8/2.8	3.3	V	
Input Voltage	V <sub>IL</sub>	GND	-	0.3VDDIO	V	
	V <sub>IH</sub>	0.8 VDDIO	-	VDDIO		
Input leakage Current	I <sub>LKG</sub>	-1		1	μA	

### 6.2 Backlight Driving Conditions

Item	Symbol	Value			Unit	Remark
		Min.	Typ.	Max.		
Voltage for LED Backlight	V <sub>F</sub>	-	12.8	-	V	I <sub>L</sub> =20mA
Current for LED Backlight	I <sub>L</sub>		20	-	mA	
Power Consumption	P		0.256		W	
LED Life Time		30,000			Hr	Note

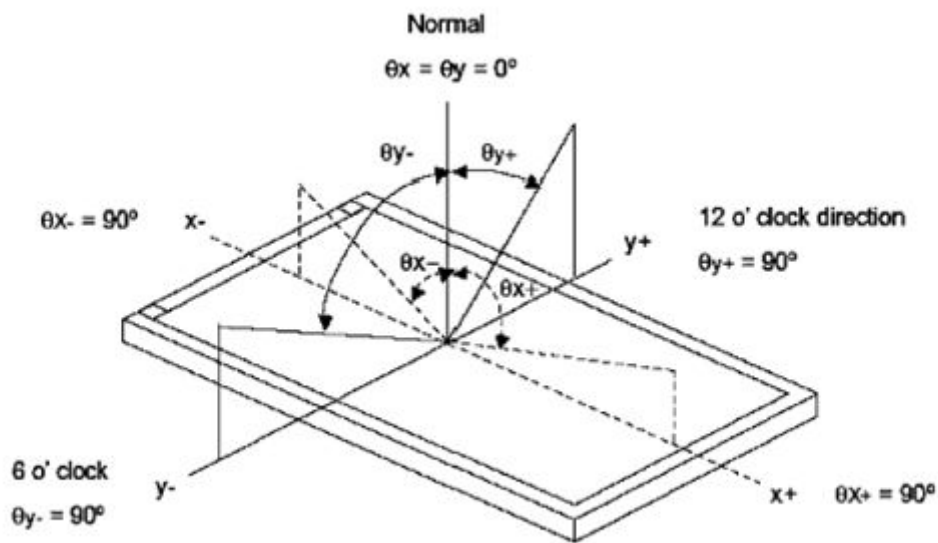
**Note:** Brightness to be decreased to 50% of the initial value at ambient temperature TA=25°C

## 7. Optical Characteristics

ITEM		SYMBOL	CONDITIONS	SPECIFICATIONS			UNIT	NOTE
				MIN	TYP.	MAX		
Luminance		L	$I_L = 20\text{mA}$		350		$\text{Cd/m}^2$	
Contrast Ratio		CR	$\theta = 0^\circ$		400			
Response Time		$T_{\text{ON+}}$ $T_{\text{OFF}}$	$25^\circ\text{C}$		30		ms	
CIE Color Coordinate	Red	$X_R$	Viewing normal angle					
		$Y_R$						
	Green	$X_G$						
		$Y_G$						
	Blue	$X_B$						
		$Y_B$						
	White	$X_W$			TBD			
		$Y_W$			TBD			
Viewing Angle	Hor.	$\theta_{X+}$	$CR \geq 10$		20		Degree	
		$\theta_{X-}$			50			
	Ver.	$\theta_{Y+}$			45			
		$\theta_{Y-}$			45			
Uniformity	Un			80			%	

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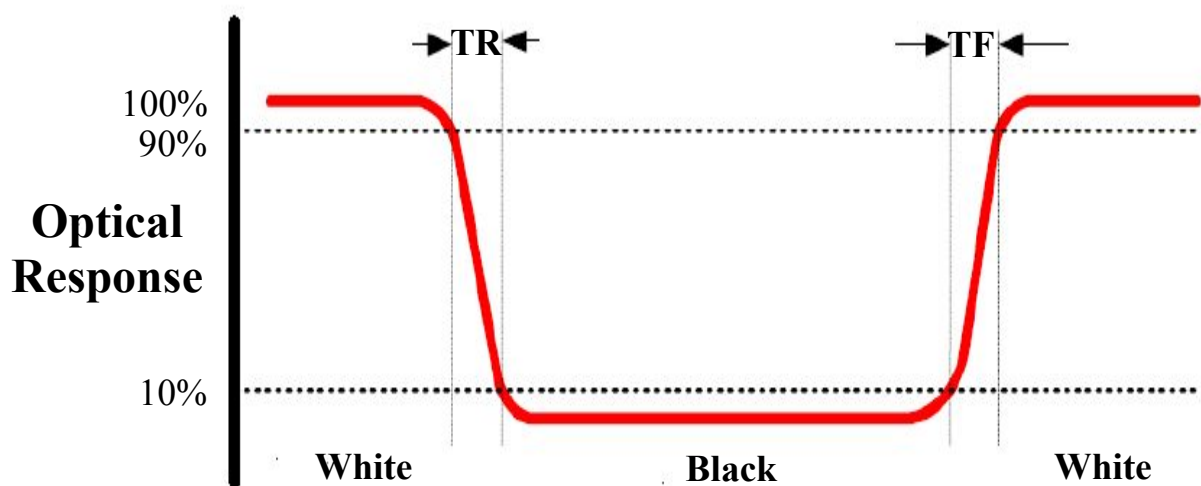
**Note 1: Definition of Viewing Angle  $\theta_x$  and  $\theta_y$ :**



**Note 2: Definition of contrast ratio CR:**

$$CR = \frac{\text{Luminance of white state}}{\text{Luminance of black state}}$$

**Note 3: Definition of Response Time( $T_r$ ,  $T_f$ )**

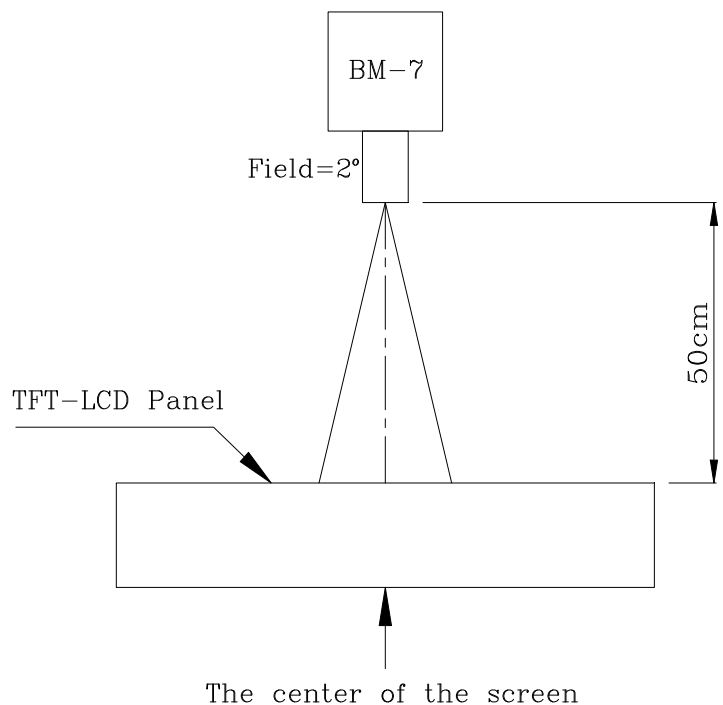


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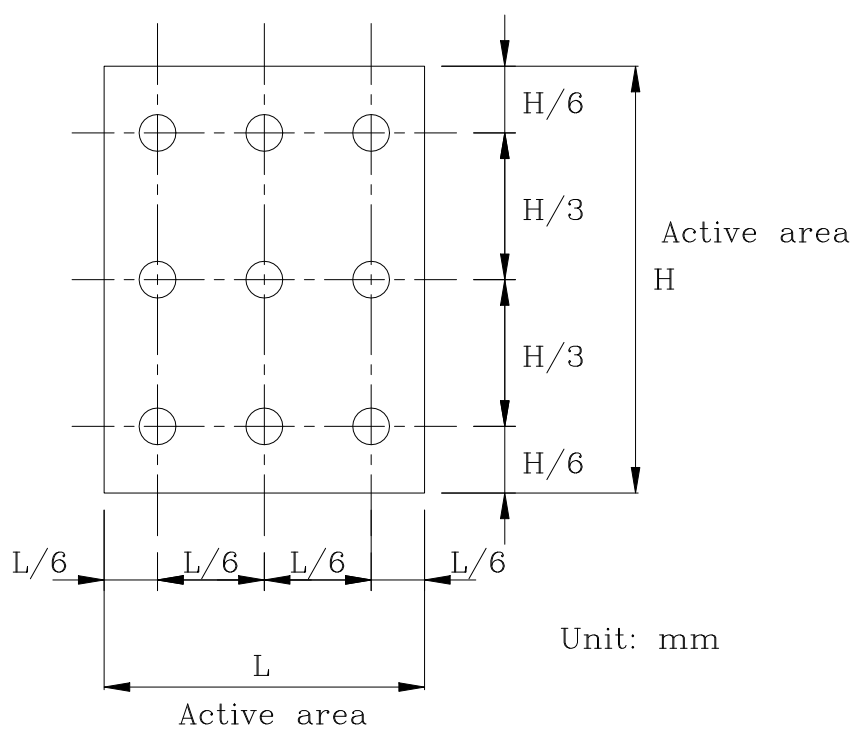
## Note 4: Definition of Luminance

### ①The Brightness Test Equipment Setup

Field= $2^{\circ}$  (As measuring “black” image, field= $2^{\circ}$  is the best testing condition)

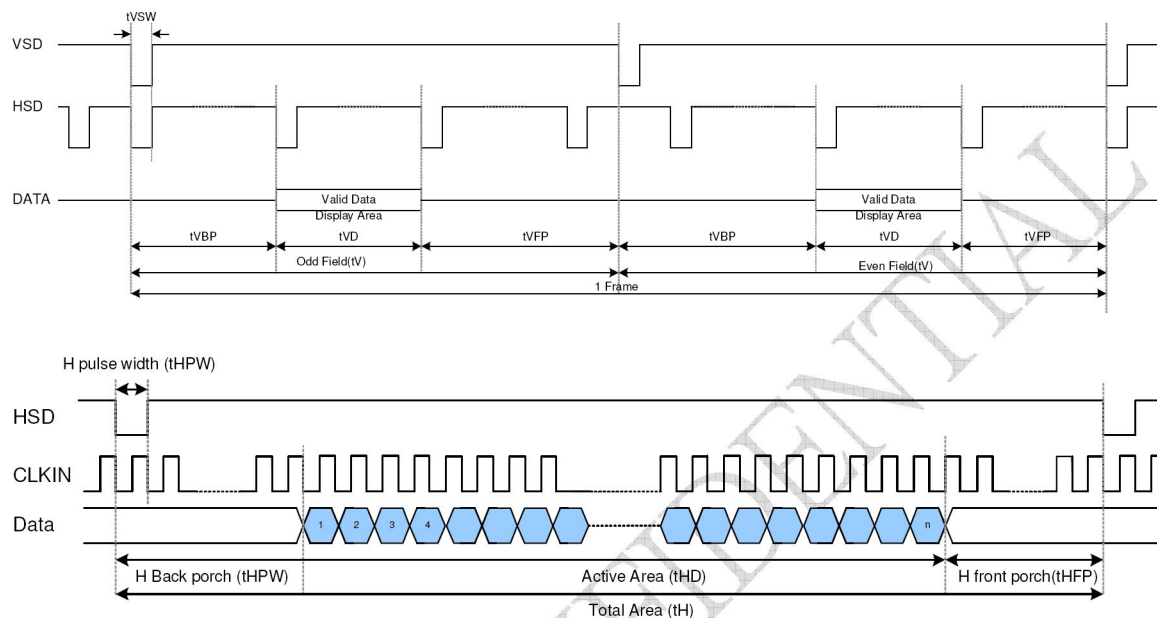


### ②The Brightness Test Point Setup



## 8. Timing Characteristics

### 8.1 RGB interface characteristic



Parameter	Symbol	Interface			Unit
		Min.	Typ.	Max.	
CLKIN frequency	fCLKIN	13.5	27	27.19	MHz
HSD period	tH	1024	1716	1728	CLKIN
HSD display period	tHD		960		CLKIN
HSD back porch	tHBP	50	70	255	CLKIN
HSD front porch	tHFP	14	686	718	CLKIN
HSD pulse width	tHSW	1	1	tHBP-1	CLKIN
VSD period time	tV	242.5	262.5	450.5	H
Vertical display area	tVD		240		H
VSD back porch	tVBP	1	21	31	H
		1.5	21.5	31.5	
VSD front porch	tVFP	1.5	1.5	179.5	H
		1	1	179	
VSD pulse width	tVSW	1CLKIN	1CLKIN	6H	
1 Frame		485	525	901	H

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## 9. Standard Specification for Reliability

### 9.1 Standard Specification for Reliability of LCD Module

No.	Item	Description
01	High temperature operation	The sample should be allowed to stand at 70°C for 120 hours under driving condition and then returning it to normal temperature condition, and allowing it stand for 2 hours.
02	Low temperature operation	The sample should be allowed to stand at -20°C for 120 hours under driving condition and then returning it to normal temperature condition, and allowing it stand for 2 hours.
03	High temperature storage	The sample should be allowed to stand at 80°C for 240 hours under no-load condition, and then returning it to normal temperature condition, and allowing it stand for 2 hours.
04	Low temperature storage	The sample should be allowed to stand at -30°C for 240 hours under no-load condition, then returning it to normal temperature condition, and allowing it stand for 2 hours.
05	Moisture storage	The sample should be allowed to stand at 60°C,90%RH MAX for 240 hours under no-load condition, then taking it out and drying it at normal temperature for 2 hours.
06	Thermal shock storage	The sample should be allowed to stand the following 10 cycles : -30°C for 30 minutes → normal temperature for 5 minutes → +80°C for 30 minutes → normal temperature for 5 minutes, as one cycle.
07	Packing vibration	Frequency range : 10Hz ~ 55Hz Amplitude of vibration : 1.5mm Sweep time: 12 min X,Y,Z 2 hours for each direction.
08	Packing drop test	According to ASTM-D-5327.
09	Electrical Static Discharge	Air: ±4KV 150pF/330Ω 5 times
		Contact: ±2KV 150pF/330Ω 5 time

\*Sample size for each test item is 3~5pcs

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## 9.2 Testing Conditions and Inspection Criteria

For the final test, the testing sample must be stored at room temperature for 24 hours. After the tests listed in Table 9.2, standard specifications for reliability will be executed in order to ensure stability.

No.	Item	Test Model	In section Criteria
01	Current Consumption	Refer To Specification	The current consumption should conform to the product specification.
02	Contrast	Refer To Specification	After the tests have been executed, the contrast must be larger than half of its initial value prior to the tests.
03	Appearance	Visual inspection	Defect free.

## 9.3 MTBF

MTBF	Functions, performance, appearance, etc. shall be free from remarkable deterioration within 50,000 hours under ordinary operating and storage conditions room temperature ( $25\pm5^{\circ}\text{C}$ ), normal humidity ( $50\pm10\%$ RH), and in area not exposed to direct sun light.
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## 10. Specification of Quality Assurance

This standard of Quality Assurance confirms to the quality of LCD module products supplied by DGHT.

### 10.1 Quality Test

Before delivering, the supplier should conduct the following tests to confirm the quality of products.

- Electrical-Optical Characteristics: According to the individual specification to test the product.
- Appearance Characteristics: According to the individual specification to test the product.
- Reliability Characteristics: According to the definition of reliability on the specification for testing products.

### 10.2 Delivery Test

Before delivering, the supplier should conduct the delivery test.

- Test method: According to MIL-STD105E.General Inspection Level II take a single Time.
- The defects classify of AQL as following:  
Major defect: AQL = 0.65  
Minor defect: AQL = 2.5  
Total defects: AQL = 2.5

### 10.3 Non-conforming Analysis & Deal With Manners

#### 10.3.1 Non-conforming Analysis

- Purchaser should provide the data detail of non-conforming sample and the non-conforming.
- After receiving the data detail from purchaser, the analysis of non-conforming should be finished within two weeks.
- If the analysis can't be finished on time, supplier must notice purchaser 3 days in advance.

#### 10.3.2 Disposition of non-conforming

- If any product defect be found during assembling, supplier must change the good for every defect after confirmation.
- Both supplier and customer should analyze the reason and discuss the disposition of non-conforming when the reason of nonconforming is not sure.

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## 10.4 Agreement items

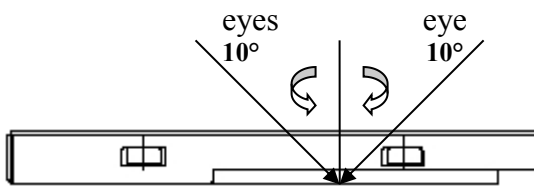
Both parties should negotiate together when the following problems happen.

- There is any problem of standard of quality assurance, and both sides should agree that it must be modified.
- There is any argument item which does not record in the standard of quality assurance.
- Any other special problem.

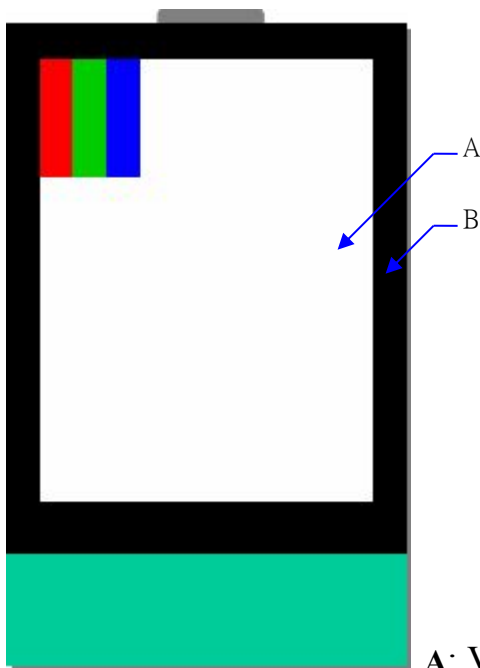
## 10.5 Standard of The Product Appearance Test

### 10.5.1 Manner of appearance test

- The test must be under 20W × 2 or 40W fluorescent light, and the distance of view must be at  $30 \pm 5$ cm.
- When test the model of transmissive product must add the reflective plate.
- The test direction is base on around  $10^\circ$  of vertical line.
- Temperature:  $25 \pm 5^\circ\text{C}$  Humidity:  $60 \pm 10\%\text{RH}$



- Definition of area:



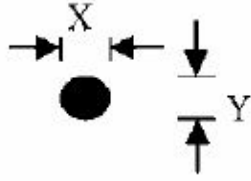
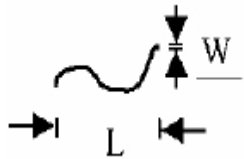
A: Viewing area B: Outside viewing area

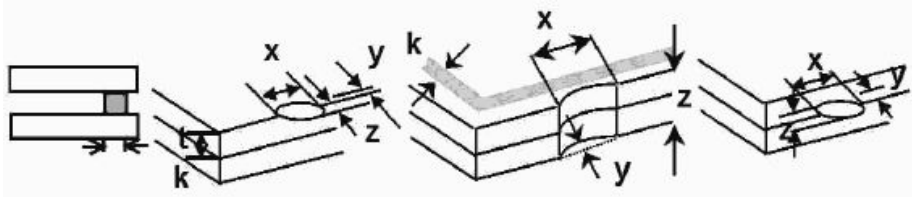
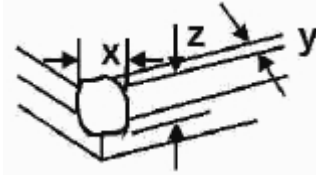
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### **10.5.2 Basic principle**

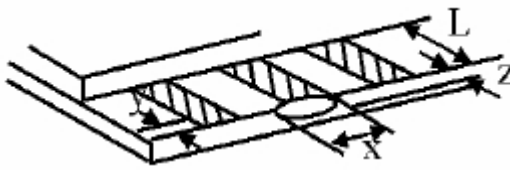
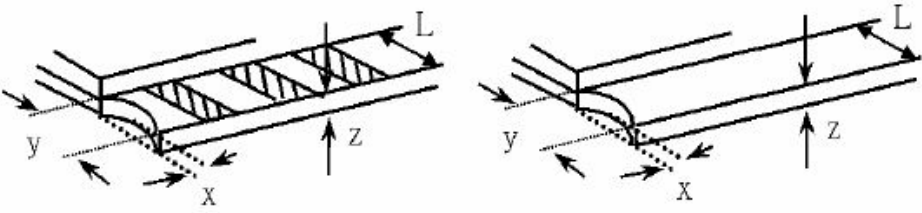
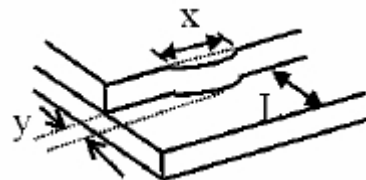
- When the standard can not be described, AQL will be applied.
- The sample of the lowest acceptable quality level must be negotiated by both supplier and customer when any dispute happened.
- New item must be added on time when it is necessary.

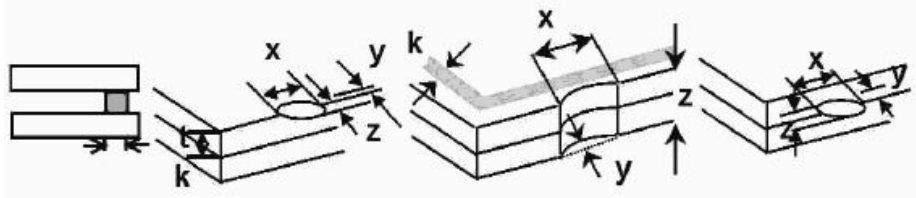
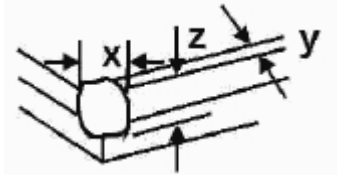
## 10.6 Inspection Specification

NO.	Item	Criterion	AQL														
01	Electrical Testing	1.1 Missing vertical, horizontal segment, segment contrast defect. 1.2 Missing character, dot or icon. 1.3 Display malfunction. 1.4 No function or no display. 1.5 Current consumption exceeds product specifications. 1.6 LCD viewing angle defect. 1.7 Mixed product types. 1.8 Flicker	0.65														
02	Black or White spots or Bright spots or Color spots on LCD (Display only)	2.1 White and black or color spots on display $\cong 0.25\text{mm}$ , no more than Five spots. 2.2 Densely spaced: No more than three spots within 3mm.	2.5														
03	LCD and Touch Panel black spots, white spots, contamination (non – display)	3.1 Round type: As following drawing $\Phi = (X+Y) / 2$ <div></div> <table><thead><tr><th>Size(mm)</th><th>Acceptable Q'ty</th></tr></thead><tbody><tr><td><math>\Phi \cong 0.10</math></td><td>Accept no dense</td></tr><tr><td><math>0.10 &lt; \Phi \cong 0.20</math></td><td>2</td></tr><tr><td><math>0.20 &lt; \Phi \cong 0.25</math></td><td>2</td></tr><tr><td><math>0.25 &lt; \Phi \cong 0.30</math></td><td>1</td></tr><tr><td><math>0.30 &lt; \Phi</math></td><td>0</td></tr></tbody></table> <p>* Densely spaced: No more than two spots within 3mm.</p>	Size(mm)	Acceptable Q'ty	$\Phi \cong 0.10$	Accept no dense	$0.10 < \Phi \cong 0.20$	2	$0.20 < \Phi \cong 0.25$	2	$0.25 < \Phi \cong 0.30$	1	$0.30 < \Phi$	0	2.5		
		Size(mm)	Acceptable Q'ty														
$\Phi \cong 0.10$	Accept no dense																
$0.10 < \Phi \cong 0.20$	2																
$0.20 < \Phi \cong 0.25$	2																
$0.25 < \Phi \cong 0.30$	1																
$0.30 < \Phi$	0																
		3.2 Line type: (As following drawing) <div></div> <table><thead><tr><th>Length(mm)</th><th>Width(mm)</th><th>Acceptable Q'ty</th></tr></thead><tbody><tr><td>---</td><td><math>W \cong 0.02</math></td><td>Accept no dense</td></tr><tr><td><math>L \cong 3.0</math></td><td><math>0.02 &lt; W \cong 0.05</math></td><td rowspan="2">2</td></tr><tr><td><math>L \cong 2.5</math></td><td><math>0.03 &lt; W \cong 0.08</math></td></tr><tr><td>---</td><td><math>0.08 &lt; W</math></td><td>Rejection</td></tr></tbody></table> <p>* Densely spaced: No more than two lines within 3mm.</p>	Length(mm)	Width(mm)	Acceptable Q'ty	---	$W \cong 0.02$	Accept no dense	$L \cong 3.0$	$0.02 < W \cong 0.05$	2	$L \cong 2.5$	$0.03 < W \cong 0.08$	---	$0.08 < W$	Rejection	2.5
Length(mm)	Width(mm)	Acceptable Q'ty															
---	$W \cong 0.02$	Accept no dense															
$L \cong 3.0$	$0.02 < W \cong 0.05$	2															
$L \cong 2.5$	$0.03 < W \cong 0.08$																
---	$0.08 < W$	Rejection															

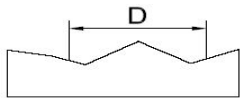
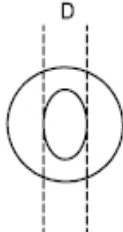
NO.	Item	Criterion			AQL
04	Polarizer bubbles	If bubbles are visible, judge using black spot specifications, not easy to find, must check in specify direction	Size Φ(mm)	Acceptable Q'ty	2.5
			Φ ≦ 0.20	Accept no dense	
			0.20< Φ ≦ 0.50	3	
			0.50< Φ ≦ 1.00	2	
			1.00< Φ	0	
			Total Q'ty	3	
05	Scratches	Follow NO.3 -2 Line Type.			
06	Chipped glass	Symbols: x: Chip length    y: Chip width    z: Chip thickness k: Seal width    t: Glass thickness    a: LCD side length L: Electrode pad length 6.1 General glass chip: 6.1.1 Chip on panel surface and crack between panels:			2.5
					
		z: Chip thickness	y: Chip width	x: Chip length	
		Z ≦ 1/2t	Not over viewing area	x ≦ 1/8a	
		1/2t< z ≦ 2t	Not exceed 1/3k	x ≦ 1/8a	
		⊙ Unit:    mm ⊙ If there are 2 or more chips, x is the total length of each chip 6.1.2 Corner crack:			
					
		z: Chip thickness	y: Chip width	x: Chip length	
		Z ≦ 1/2t	Not over viewing area	x ≦ 1/8a	
		1/2t< z ≦ 2t	Not exceed 1/3k	x ≦ 1/8a	
		⊙ Unit:    mm ⊙ If there are 2 or more chips, x is the total length of each chip			

NO.	Item	Criterion	AQL
08	Cracked glass	The LCD with extensive crack is not acceptable.	2.5
09	Backlight elements	9.1 Illumination source flickers when lit. 9.2 Spots or scratches that appear when lit must be judged. Using LCD spot, lines and contamination standards. 9.3 Backlight doesn't light or color is wrong.	2.5 2.5 0.65
10	Bezel	Bezel must comply with product specifications.	2.5
11	PCB、COB	11.1 COB seal may not have pinholes larger than 0.2mm or contamination. 11.2 COB seal surface may not have pinholes through to the IC. 11.3 The height of the COB should not exceed the height indicated in the assembly diagram. 11.4 There may not be more than 2mm of sealant outside the seal area on PCB. And there should be no more than three places. 11.5 Parts on PCB must be the same as on the production characteristic chart, There should be no wrong parts, missing parts or excess parts. 11.6 The jumper on the PCB should conform to the product characteristic chart.	2.5 2.5 2.5 2.5 0.65 0.65
12	FPC	12.1 FPC terminal damage $\leq$ 1/2 FPC terminal width and can not affect the function , we judge accept. 12.2 FPC alignment hole damage $\leq$ 1/2 alignment area and can not affect the function , we judge accept.	2.5 2.5
13	Soldering	13.1 No cold solder joints, missing solder connections, oxidation or icicle. 13.2 No short circuits in components on PCB or FPC.	2.5 0.65

NO.	Item	Criterion	AQL																
07	Glass crack	<p>Symbols:  x: Chip length    y: Chip width    z: Chip thickness  k: Seal width    t: Glass thickness    a: LCD side length  L: Electrode pad length</p> <p>7.2 Protrusion over terminal:  7.2.1 Chip on electrode pad:</p>  <table> <tr> <td>y: Chip width</td> <td>x: Chip length</td> <td>z: Chip thickness</td> </tr> <tr> <td><math>y \leq 0.5\text{mm}</math></td> <td><math>x \leq 1/8a</math></td> <td><math>0 &lt; z \leq t</math></td> </tr> </table> <p>7.2.2  Non-conductive portion:</p>  <table> <tr> <td>y: Chip width</td> <td>x: Chip length</td> <td>z: Chip thickness</td> </tr> <tr> <td><math>y \leq L</math></td> <td><math>x \leq 1/8a</math></td> <td><math>0 &lt; z \leq t</math></td> </tr> </table> <p>⊙ If there chipped area touches the ITO terminal, over 2/3 of the ITO must remain and be inspected according to electrode terminal specifications.  ⊙ If the product will be heat sealed by the customer, the alignment mark must not be damaged.</p> <p>7.2.3 Substrate protuberance and internal crack</p>  <table> <tr> <td>y: width</td> <td>x: length</td> </tr> <tr> <td><math>y \leq 1/3L</math></td> <td><math>X \leq a</math></td> </tr> </table>	y: Chip width	x: Chip length	z: Chip thickness	$y \leq 0.5\text{mm}$	$x \leq 1/8a$	$0 < z \leq t$	y: Chip width	x: Chip length	z: Chip thickness	$y \leq L$	$x \leq 1/8a$	$0 < z \leq t$	y: width	x: length	$y \leq 1/3L$	$X \leq a$	2.5
		y: Chip width	x: Chip length	z: Chip thickness															
		$y \leq 0.5\text{mm}$	$x \leq 1/8a$	$0 < z \leq t$															
		y: Chip width	x: Chip length	z: Chip thickness															
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$y \leq 1/3L$	$X \leq a$																		

NO.	Item	Criterion	AQL												
14	Touch Panel Chipped glass	<p>Symbols:  x: Chip length      y: Chip width      z: Chip thickness  k: Seal width      t: Touch Panel Total thickness      a: LCD side length  L: Electrode pad length</p> <p>14.1 General glass chip:  14.1.1 Chip on panel surface and crack between panels:</p>  <table> <tr> <td>z: Chip thickness</td> <td>y: Chip width</td> <td>x: Chip length</td> </tr> <tr> <td><math>Z \leq t</math></td> <td><math>\leq 1/2 k</math> and not over viewing area</td> <td><math>x \leq 1/8a</math></td> </tr> </table> <p>⊙ Unit: mm  ⊙ If there are 2 or more chips, x is the total length of each chip</p> <p>14.1.2 Corner crack:</p>  <table> <tr> <td>z: Chip thickness</td> <td>y: Chip width</td> <td>x: Chip length</td> </tr> <tr> <td><math>z \leq t</math></td> <td><math>\leq 1/2 k</math> and not over viewing area</td> <td><math>x \leq 1/8a</math></td> </tr> </table> <p>⊙ Unit: mm  ⊙ If there are 2 or more chips, x is the total length of each chip</p>	z: Chip thickness	y: Chip width	x: Chip length	$Z \leq t$	$\leq 1/2 k$ and not over viewing area	$x \leq 1/8a$	z: Chip thickness	y: Chip width	x: Chip length	$z \leq t$	$\leq 1/2 k$ and not over viewing area	$x \leq 1/8a$	2.5
z: Chip thickness	y: Chip width	x: Chip length													
$Z \leq t$	$\leq 1/2 k$ and not over viewing area	$x \leq 1/8a$													
z: Chip thickness	y: Chip width	x: Chip length													
$z \leq t$	$\leq 1/2 k$ and not over viewing area	$x \leq 1/8a$													



NO.	Item	Criterion	AQL										
15	Touch Panel(Fish eye、dent and bubble on film)	<table> <tr> <th>SIZE(mm)</th> <th>Acceptable Q'ty</th> </tr> <tr> <td><math>\Phi \leq 0.2</math></td> <td>Accept no dense</td> </tr> <tr> <td><math>0.2 &lt; D \leq 0.4</math></td> <td>5</td> </tr> <tr> <td><math>0.4 &lt; D \leq 0.5</math></td> <td>2</td> </tr> <tr> <td><math>0.5 &lt; D</math></td> <td>0</td> </tr> </table> <div>   </div>	SIZE(mm)	Acceptable Q'ty	$\Phi \leq 0.2$	Accept no dense	$0.2 < D \leq 0.4$	5	$0.4 < D \leq 0.5$	2	$0.5 < D$	0	2.5
SIZE(mm)	Acceptable Q'ty												
$\Phi \leq 0.2$	Accept no dense												
$0.2 < D \leq 0.4$	5												
$0.4 < D \leq 0.5$	2												
$0.5 < D$	0												
16	Touch Panel Newton ring	Newton ring dimension $\leq 1/2$ touch panel area and not affect font and line distortion( $\leq 2.5\%$ ) , it is acceptable.	2.5										
17	Touch Panel Linearity	Less than 2.5% is acceptable.	2.5										
18	LCD Ripple	Touch the touch panel , can not see the LCD ripple. Pen: R 1.0mm silicon rubber. Operation Force: 80g	2.5										
19	General appearance	19.1 Pin type must match type in specification sheet. 19.2 LCD pin loose or missing pins. 19.3 Product packaging must the same as specified on packaging specification sheet. 19.4 Product dimension and structure must conform to product specification sheet.	0.65 0.65 0.65 0.65										

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## 11. Handling Precaution

### 11.1 Handling of LCM

- Avoid external shock.
- Don't apply excessive force on the surface.
- Liquid in LCD is hazardous substance, do not lick or swallow. When the liquid is attaching to your hand, skin, cloth, etc., wash it thoroughly and immediately.
- Don't operate it above the absolute maximum rating.
- Don't disassemble the LCM.
- The operators should wear protections whenever he/she comes into contact with the module. Never 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.
- The modules should be kept in antistatic bags or other containers resistant to static for storage.
- The module is coated with a film to protect the display surface, be careful when peeling off this protective film since static electricity may be generated.

### 11.2 Storage

- Store it in an ambient temperature of  $25\pm 10^{\circ}\text{C}$ , and in a relative humidity of  $50\pm 10\%\text{RH}$ . Don't expose to sunlight or fluorescent light.
- Store it in a clean environment, free from dust, active gas, and solvent.
- Store it in anti-static electricity container.
- Store it without any physical load.

### 11.3 Soldering

- Use only soldering irons with proper grounding and no leakage.
- Iron: no higher than  $280\pm 10^{\circ}\text{C}$  and less than 3 sec during hand soldering.
- Rewiring: no more than 2 times.

## 12. Packing Method

----TBD