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Document Chinese Title: 12.1 " (G121 Series) 進料檢驗規範 (A grade)

Document English Title: Incoming Inspection Standard For 12.1 " (G121 Series) (A)

AU OPTRONICS CORPORATION
Specification
INCOMING INSPECTION STANDARD FOR
12.1" MODULES (A grade)
Model Name: G121 Series

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Customer	Checked and Approved by



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Inspection criteria's change record				
Version/ Effective Date (Approval)	Page	Inspection Item	Previous Inspection Spec	New Inspection Spec
2018 Nov. 27 th	All	All		G121 Series with VA type IIS
2018 Dec. 31 st	All	All		For G121 Series including of brightness over 1000 nits.
2020 Dec . 29	All	All		Update format



1. Scope:

1.1 The incoming inspection standards shall be applied to TFT-LCD Modules or TFT-LCD Modules with TP/Cover Lens (hereinafter called "Modules") that supplied by AU Optonics Corporation (hereinafter called "seller").

1.2 Specifications contains

- Electrical inspection specification
- Appearance specification

2. Incoming inspection:

The buyer shall inspect the Modules within the inspection period (ninety calendar days starting from the date of delivery.) The results of the inspection (acceptance or rejection) shall be recorded in writing and a copy will be promptly sent to the seller.

The buyer may, under reasonable commercial rejection procedures, reject an entire lot in the delivery involved. Within the inspection period, if the Modules in the lot show a number of unacceptable defects in accordance with this Incoming Inspection Standards, the buyer must notify the seller in writing of any such rejection promptly, within three business days during the inspection period.

If the buyer fails to notify the seller within the inspection period, the buyer's right to reject the Modules shall be lapsed and the Modules shall be deemed accepted by the buyer.

If any questions arise in regards to the judgement, the outcome shall be decided upon the consultation between both parties.

The buyer shall sign the IIS back to the seller once the buyer verifies the model completely and moves to the mass production stage. The seller has the right to follow internal specifications or ES (engineering sample) performances if the buyer fails to sign back to the seller.

3. Inspection sampling method:

Unless otherwise agree in writing, the method of incoming inspection shall be based on ANSI/ASQL Z1.4-2003.

3.1 Lot size: Quantity per shipment lot per model.

3.2 Sampling type: Normal inspection, single sampling.

3.3 Sampling level: Level II.

3.4 Acceptable quality level (AQL):

Major defect: AQL=1.0%.

Minor defect: AQL=2.5%.

4. Inspection instruments:

4.1 Pattern generator: LD-2000 or equivalent model.

4.2 Video board: AUO video board or equivalent. The output of the signal should comply with the specification provided by AUO.

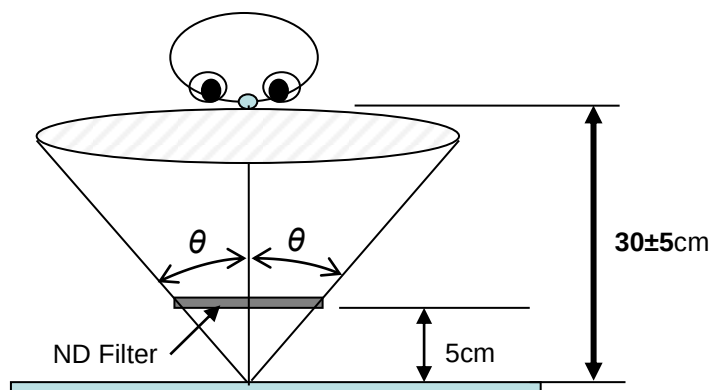
4.3 Luminance colorimeter: follow product specification

5. Inspection environment conditions:

5.1 Room temperature : **20 ~ 25 C.**

5.2 Humidity: **65±5% RH**.

5.3 Distance: **30±5 cm** in front of LCD unit with a viewing angle of $\theta = 10^\circ$. (refer to figure 1)



5.4 Take off the protector of polarizer while judging the display area.

5.5 if there is any question with the inspection, check the panel again-when powered on.

6. Classification of defects:

Defects are classified as major defects and minor defects according to the degree of defectiveness defined herein.

Major defects:

A major defect is a defect that is likely to result in failure, or to reduce materially the usability of the product for its intended purpose.

Minor defects:

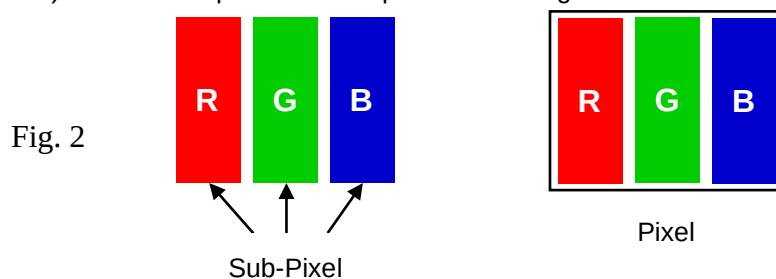
A minor defect is either a defect that is not likely to reduce materially the usability of the product for its intended purpose, or a departure from an intended purpose with little bearing on the effective use or operation of the product.

6.1 Electrical inspection specification

No.	Inspection Item		Max. acceptable number / Distance	Unit	Note
1	Bright dots	1 dot	2	dot	1, 2, 6
2		2 Adjacent dots	0	pair	4, 5, 6
3		3 Adjacent dots	0	pair	4, 5, 6
4		Over 3 Adjacent dots	0	pair	4, 5, 6
5		Distance between bright dots	-	mm	3
6		Total (1+2+3+4)	2	dot	

7	Dark dots	1 dot	3	dot	1, 2, 6
8		2 Adjacent dots	1	pair	4, 5, 6
9		3 Adjacent dots	0	pair	4, 5, 6
10		Over 3 Adjacent dots	0	pair	4, 5, 6
11		Distance between dark dots	≥ 15	mm	3
12		Total (7+8+9+10)	4	dot	
13	Bright dot and Dark dot	2 Adjacent dots	1	pair	4, 5, 6
14		Distance between dots	-	mm	3
15	Total amount of Dot Defects (1~13)		7	dot	
16	Line defect		Not allowed	-	
17	Mura		Use 6% ND filter (JND 2.3) or judged by equivalent limit sample Use 1% ND filter (JND 3.0) or judged by equivalent limit sample for Brightness over 1000 nits		6, 7

- Note 1) Definition of pixel and sub-pixel: refer to figure 2.



- Note 2) Bright dot and Small bright dot judgment criteria.

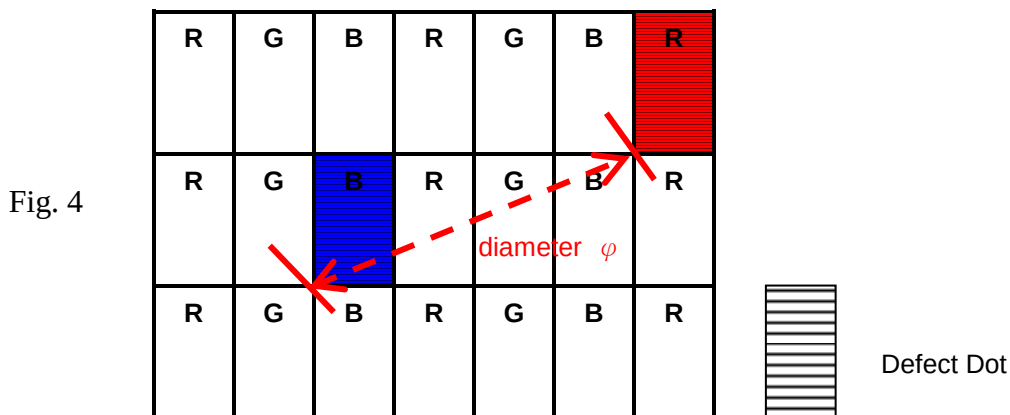
Judgment Criteria		Bright Dot Defect area	
		$> 1/2$ sub-pixel	$\leq 1/2$ sub-pixel
ND filter 10%	Visible	Bright Dot	Small Bright Dot
	Invisible	Small Bright Dot	N/A or SBD

The drawing of 1/2 area sub-pixel definition: The 1/2 area sub-pixel can be defined as below one or more of specific shapes (Fig. 3). The amount of small bright dots should be less or equal to 4.



Fig. 3

- Note 3) Definition of diameter ϕ as following:



- Note 4) Adjacent-dot defect should be observed under the same display pattern in any one of Black/Green/Blue/Red pattern.

Adjacent-dot defect : refer to Figure 5, dot 1,2,...,8 around A are all A's adjacent dots

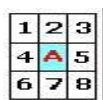


Fig. 5

- Note 5) In three (or more) adjacent dot defect, for any 3rd dot that adjacent to 2 continuous defective dots (can be of any combination of bright dots and dark dots), the 3rd dot, no matter how large it may be, should be viewed as a dot.
- Note 6) Inspection pattern: Standard inspection patterns of dot defect are listed below. AUO uses these patterns as standard criteria for judging dot defect. Please inform AUO if any other pattern is to be used to examine it.

Defect type	Ambient Luminance	Inspecting Pattern
Mura/ display non-uniformity	300~700 lux (standard 500)	L0/255 、 L92/255 、 L255/255
Bright Dot / Small Bright Dot		L0/255
Dark Dot		L255/255 、 Monotone Red 、 Green 、 Blue
BL particle/Scratch		L0/L255 、 L255/255
Polarizer particle/Scratch/Bubble		L0/L255 、 L255/255

Cosmetic defect		NA
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- Note 7) Unless specified in other written document or limit samples, Mura (display non-uniformity) should be inspected under the ND filter and be acceptable when it is invisible through ND filter.

ND filter use method: The inspection method of ND Filter - holding ND filter in front of the panel around 5 cm and examine the panel from 30 ± 5 cm in the front view for 3 seconds. (Fig. 1)

- Note 8) While operating over 50°C ambient temperature, there should be no function failure occur and Mura (display un-uniformity) should be invisible under 1 % ND filter applied.
- Note 9) Image Retention : 5 seconds test pattern and image retention must be disappeared in 5 seconds after pattern changed.

6.2 Scratches, dent, extraneous substances and Appearance inspection specification

Judge area	Judge item		Inspection specification			Judge criterion		
						Major	Minor	
Active area	Particles on the polarizer	Circular	Average diameter: D (mm)		Numbers			○
			D≤0.15		Disregarded			
			0.15<D≤0.50		n≤3			
			0.50<D		n=0			
		Linear	Width: W (mm) Length: L (mm)		Numbers			○
			W≤0.03	L≤0.5	Disregarded			
			0.03<W≤0.07	0.5<L≤2.0	n≤3			
			0.07<W	2.0<L	n=0			
	Scratch/Dent on the polarizer	Circular	Average diameter: D (mm)		Numbers			○
			D≤0.15		Disregarded			
			0.15<D≤0.50		n≤3			
			0.50<D		n=0			
		Linear	Width: W (mm) Length: L (mm)		Numbers			○
			W≤0.03	L≤0.5	Disregarded			
			0.03<W≤0.07	0.5<L≤2.0	n≤3			
			0.07<W	2.0<L	n=0			
	Bubble on the polarizer	Circular	Average diameter: D (mm)		Numbers			○
			D≤0.15		Disregarded			
			0.15<D≤0.50		n≤3			
			0.50<D		n=0			
	Extraneous substances	Circular	Average diameter: D (mm)		Numbers			○
			D≤0.15		Disregarded			
			0.15<D≤0.50		n≤3			
			0.50<D		n=0			

		Linear	Width: W (mm) Length: L (mm)		Numbers		○
			$W \leq 0.03$	$L \leq 0.5$	Disregarded		
			$0.03 < W \leq 0.07$	$0.5 < L \leq 2.0$	$n \leq 3$		
			$0.07 < W$	$2.0 < L$	$n = 0$		
From Active area outside 0.3mm	The end of polarizer		The defect can't be seen ,from active area outside 0.3mm				○
Bezel	Gap between front bezel and glass on all sides		$H < 0.8\text{mm}$ (Note 12)				○
	Scratches, Wrap and Sunken		No harm, dangerous				○
	Assembly Fail		Not allowed			○	
	Color Difference		Allowed (No harm, dangerous)				○
Label (S/N, B/L, WEEK)	No label		Not allowed			○	
	Invert label					○	
	Content Error					○	
	Dirt		Word can be read. Barcode can be scanned.				○
	Not clear						○
	Word out of shape						○
	Broken						○
	Crease						○
	Label overlapping						○
	Position						○
Screw	Not enough (Q'ty)		Not allowed			○	
	Loose		Not allowed			○	
Connector	Appearance		As long as no function issues CN can be allowed.			○	

- Note 9) Extraneous substances which can be wiped out, such as fingerprint and particles are not considered as a defect.
- Note 10) Defects on the Black Matrix are not considered as a defect.
- Note 11) Defect size definition: (Unit:mm). When $L \geq 2W$, defect count as liner defect.

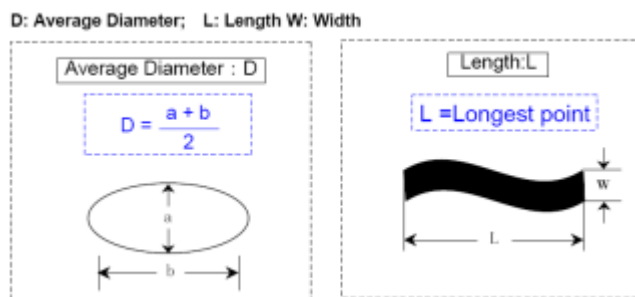


Fig. 6

- Note 12) The gap between front bezel and Polarizer.

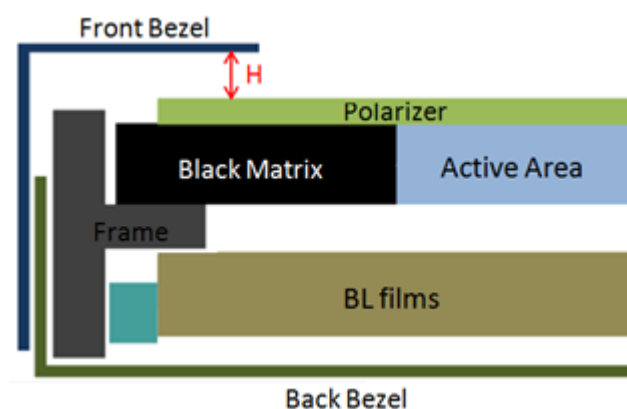
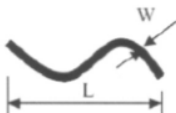
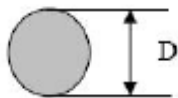


Fig. 7

6.3 Touch panel appearance inspection specification :

Defect Item and definition	
Defects count method 、 number and distance between defects	
A. Linear defects scale by the length / width 	
Size	Pass Criteria
$L \leq 3\text{mm}$ or $W \leq 0.1\text{mm}$	Ignore
$3\text{mm} < L \leq 8\text{mm}$ or $0.1\text{mm} < W \leq 0.2\text{mm}$	$N \leq 3$, $15\text{mm} < \text{distance}$
$L > 8\text{mm}$ or $W > 0.1\text{mm}$	Not Allowed
* Linear defects include Scratch / Line shape defect (Stain, Dirt, Dent, Foreign material)	
B. Dot defects is counted in active area only, and scaled by diameter “D” as below.	



Size	Acceptable Q'TY
$D \leq 0.2\text{mm}$	Ignore
$0.2\text{mm} < D \leq 0.5\text{ mm}$	$N \leq 3$, $15\text{mm} < \text{distance}$
$D > 0.5\text{ mm}$	Not Allowed

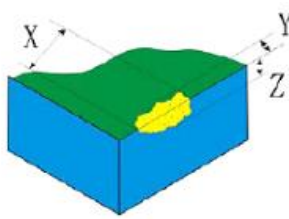
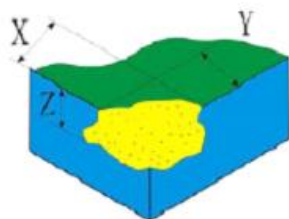
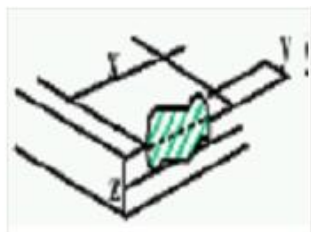
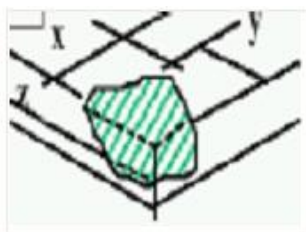
C. BM pin hole



Size	Acceptable Q'TY
$D \leq 0.1\text{mm}$	Ignore
$0.1\text{mm} < D \leq 0.2\text{ mm}$	$N \leq 2$ (distance $\geq 5\text{mm}$)
$D > 0.2\text{mm}$	Not Allowed

D. Chipping

	Judge item	Inspection specification
Glass	Wire (on array)	No damaged $\leq 1/3$ lead length of efficient circuit
	Edge	No extended crack
		Chipping in Corner : $X \leq 2\text{mm}, Y \leq 2\text{mm}, Z \leq 1/2$ Glass thickness (Fig.1)
		Chipping around the edge : $X \leq 5\text{mm}, Y \leq 2\text{mm}, Z \leq 1/2$ Glass thickness (Fig.2)



Glass crack

Glass crack



-No glass cracks of any kind allowed (including creeping/extending cracks)

Note 1 : Extraneous substances which can be wiped out, such as fingerprint and particles are not considered as a defect.

Note 2 : Defects on the Black Matrix (outside Active Area) are not considered as a defect.

7. Inspection judgement:

- 7-1 The judgement of the shipped lot (acceptance or rejection) should follow the sampling plan of ANSI/ASQLZ1.4-2003, single sampling, normal inspection, level II.
- 7-2 If the number of defects is equal to or less than the applicable acceptance level, the lot shall be accepted.
- 7-3 If the number of defects is more than the applicable acceptance level, the lot shall be rejected and the buyer should inform the seller of the result of incoming inspection in writing.

8. Precaution:

Please pay attention to the following items when you use the LCD Module with back-light unit.

- 8.1 During the Module's assembly, do not twist, bend or add unsuitable external force to the Module.
- 8.2 Do not use an air gun or blower to clean the Module during the Module's assembly to avoid the contamination of external dust or particles.
- 8.3 Only operate the Modules in the specified temperature range and a ventilated environment.
- 8.4 Avoid dust or oil mist during Module assembly.
- 8.5 Follow the correct power sequence while operating the Module. Module will be damaged otherwise.
- 8.6 Avoid electrical magnetic interference for higher safety and lesser noise.
- 8.7 Operate the Module in the specified temperature range as the temperature will affect the response time and brightness.
- 8.8 Avoid displaying the fixed pattern (especially the white pattern) for a long period of time as it will cause image sticking.
- 8.9 Be sure to turn off the power when connecting or disconnecting the circuit.
- 8.10 Avoid dirt and stain on the surface of modules. As it can easily scratch the surface polarizer.
- 8.11 Wipe off any moistures before operating the Modules as the dewdrop may damage the Modules.
- 8.12 Avoid drastic temperature changes, as the condensation or expansion reactions will damage (destroy) the polarizer.
- 8.13 Avoid exposing the modules under sunlight as the high temperature and humidity will degrade the performance.
- 8.14 Avoid any harmful materials/ components/ chemicals on the modules, such as acid or chlorine.
- 8.15 Connect grounded devices while operating the Module as the static electricity will damage the Module.
- 8.16 Disassemble or reassemble the Modules are forbidden.
- 8.17 Avoid direct contact on the rear side as the backlight's high voltage will cause electrical shocks.
- 8.18 Avoid strong vibration or shock on the Module as they will damage the Module.
- 8.19 Store the Modules in suitable environment with regular packing.



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- 8.20 Do not press on the surface (either front or rear side) of the Module as it will lead to non-uniformity or other function issues. Be cautious of the broken Module to avoid damages.
- 8.21 Softly tear the sticking tape of the protective film to prevent bezel out of shape and non-uniform display.

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