



Module Incoming Inspection Standard

Confidential

Part Number: P0840XGF1MA00

Version: 1.0

TFT-LCD Module Incoming Inspection Standard

Customer: All

Module Name: P0840XGF1MA00

Version: 1.0

Issue Date: 2021/7/1

Customer:

Approved by	Notes

TIANMA Confirmed:

Prepared by	Checked by	Approved by
BinWang	LongpinDeng	



Module Incoming Inspection Standard

Confidential

Part Number: P0840XGF1MA00

Version: 1.0

Revision History

[illegible]

	Module Incoming Inspection Standard		
	Confidential	Part Number: P0840XGF1MA00	Version: 1.0

Table of Contents

1. Scope	5
2. Incoming Inspection.....	5
3. Inspection Sampling Method	5
4. Inspection Conditions	5
5. Inspection Criteria.....	7
5.1 Major defect – Features	7
5.2 Minor defect – Display	7
5.3 Minor defect – Exterior.....	9
5.4 Minor defect – CTP	11
6. Mechanics specification.....	12
7. Precaution	14



1. Scope

The incoming inspection standards shall be applied to TFT-LCD Modules (hereinafter called "Modules") that supplied by Tianma Micro-Electronics Corporation.

2. Incoming Inspection

The customer shall inspect the modules within twenty calendar days of the delivery date (the "inspection period") at its own cost. The result of the inspection (acceptance or rejection) shall be recorded in writing, and a copy of this writing will be promptly sent to the seller, If the results of the inspecting from buyer does not send to the seller within twenty calendar days of the delivery date. The modules shall be regards as acceptance.

Should the customer fail to notify the seller within the inspection period, the buyers right to reject the modules. Shall be lapsed and the modules shall be deemed to have been accepted by the buyer.

3. Inspection Sampling Method

- 3.1 Lot size: Quantity per shipment lot per model
- 3.2 Sampling type: Normal inspection, Single sampling
- 3.3 Inspection level: II
- 3.4 Sampling table: GB/T 2828.1, test level II
- 3.5 Acceptable quality level (AQL)

Major defect: AQL=0.65

Minor defect: AQL=1.00

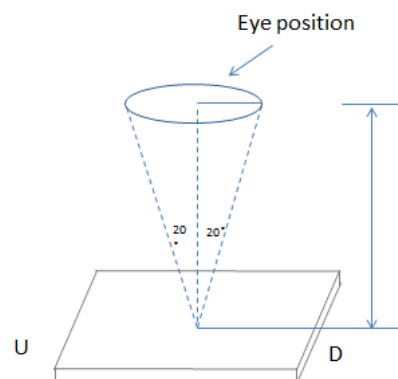
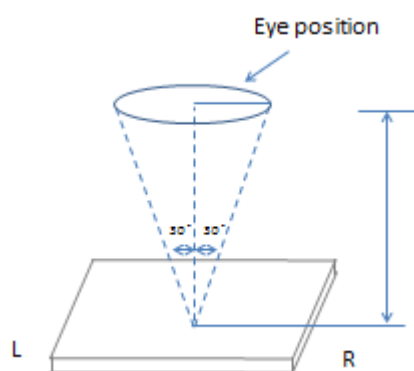
4. Inspection Conditions

4.1 Ambient conditions:

- a. Temperature: Room temperature $25\pm 5^{\circ}\text{C}$
- b. Humidity: $(60\pm 10)\% \text{RH}$
- c. Illumination: Appearance 600 Lux minimum, Display 100 ± 50 Lux (The luminance at an inspection desk surface with single non-directive fluorescent lamp).

4.2 Viewing distance: The distance between the LCD and the inspector's eyes shall be at least 30±5cm.

4.3 Viewing Angle: U/D: 20°/20°, L/R: 30°/30°



5. Inspection Criteria

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

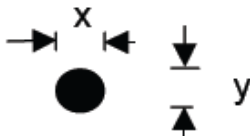
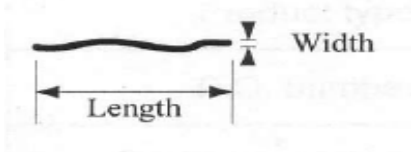
5.1 Major defect – Features

Item No	Items to be inspected	Inspection Standard
5.1.1	All functional defects	1) No display 2) Display abnormally 3) line defect
5.1.2	Missing	Missing function component
5.1.3	Crack	Glass Crack

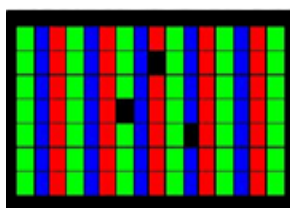
5.2 Minor defect – Display

Item No	Items to be inspected	Inspection standard
---------	-----------------------	---------------------

	Module Incoming Inspection Standard		
	Confidential	Part Number: P0840XGF1MA00	Version: 1.0

5.2.1	Spot Defect Including: Black spot White spot Foreign particle Polarizer dirt Cell particle	For dark/white spot is defined $\varphi = (x + y) / 2$  dots distance=DS	
		Size φ (mm)	Acceptable Quantity
		$\varphi \leq 0.25$	Ignore
		$0.25 < \varphi \leq 0.5$	3 (DS ≥ 5 mm)
		$0.5 < \varphi$	Not allowed
5.2.2	Line Defect Including: Black line White line Scratch	Define:  Line defect distance ≥ 5 mm	
		Width(mm) Length(mm)	Acceptable Quantity
		$W \leq 0.05$	Ignore
		$0.05 < W \leq 0.1,$ $L \leq 5.0$	4 (DS ≥ 5 mm)
		$0.1 < W$ or $L > 5.0$	Not allowed
5.2.3	Electrical Dot Defect	Bright: check in black&51/255 Black dot: check in R&G&B Bright and Black dot define:	

	Module Incoming Inspection Standard		
	Confidential	Part Number: P0840XGF1MA00	Version: 1.0

		 and 		
		Item		Acceptable Quantity
		Dark dot defect		5
		Bright dot defect		2
		Total Dot		5
		DBP (double bright point)		1
		DDP (double dark point)		0
		Distance between dark dot		>15mm
5.2.4	Tiny bright dot Dense tiny highlights	$\Phi<0.25\text{mm}$		ND 6% judgment, clustered is not allowed (clustered mean $N>5$, $D\leq 5$)
5.2.5	Mura	Invisible under 6% ND filter in 24/63 (102/256) grayscale pattern, and black pattern. If necessary, building limited sample.		
5.3.5	Light leakage	TN	51/255	Not allowed
		SFT	34/255	

5.3 Minor defect – Exterior

5.3.1	Polarizer Dent/Bubble	Size $\varphi(\text{mm})$	Acceptable Quantity
		$\varphi \leq 0.25$	Ignore
		$0.25 < \varphi \leq 0.5$	3 ($DS \geq 5\text{mm}$)
		$0.5 < \varphi$	Not allowed

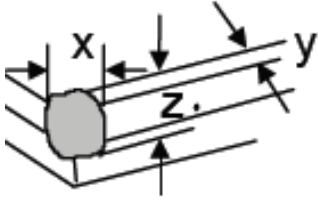
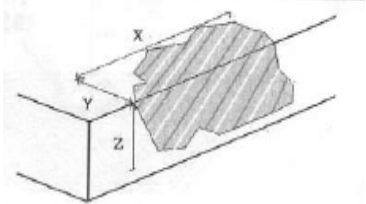


Module Incoming Inspection Standard

Confidential

Part Number: P0840XGF1MA00

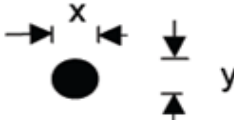
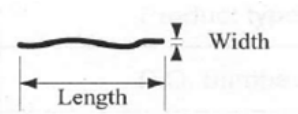
Version: 1.0

5.3.2	FPC	Broken	Not allowed
		FPC kink, indentation, Top wound, scratch	naked wire, hole is not allowed, Invisible copper line
		Connect broken (no crack, no short circuit, no dead fold, not inflict function)	Don't control
		The surface of the dirt	Don't control
5.3.3	Bonding IC	Bareness is not allowed	
5.3.4	B/L Frame Broken, Oil pollution	Broken, Oil pollution	Not allowed
		Scratch, indelible	Ignore
		Bump point	Does not affect the use of allowed
5.3.5	Protective Film	Top injury, scratch, Wear scar	Undamaged polarizer, ignore
		Can wipe dirt, particle	ignore
5.3.6	Glass Defect	1. Corner Fragment: 	
		Size(mm)	Acceptable Quantity
		$X \leq 3.0\text{mm}$, $Y \leq 3.0\text{mm}$, $Z \leq T$	Ignore T: Glass thickness X: Length, Y: Width, Z: thickness
		2. Side Fragment: 	

	Module Incoming Inspection Standard		
	Confidential	Part Number: P0840XGF1MA00	Version: 1.0

		Size(mm)	Acceptable Quantity
		$X \leq 6.0\text{mm},$ $Y \leq 1.0\text{mm},$ $Z \leq T$	Ignore T: Glass thickness X: Length, Y: Width, Z: Thickness

5.4 Minor defect – CTP

5.4.1	Touch panel spot Including: Black spot, White spot, Assemble dirt, Foreign particle	Define : $\varphi = (x + y) / 2$ 	
		Size φ (mm)	Acceptable Quantity
		$\varphi \leq 0.25$	Ignore
		$0.25 < \varphi \leq 0.5$	3 (DS $\geq 5\text{mm}$)
		$0.5 < \varphi$	Not allowed
5.4.2	Line defect Including: Black line, White line, Scratch, Assemble dirt	Define: 	
		Width(mm) Length(mm)	Acceptable Quantity
		$W \leq 0.05$	Ignore
		$0.05 < W \leq 0.1,$ $L \leq 5.0$	4 (DS $\geq 5\text{mm}$)
		$0.1 < W \text{ or } L > 5.0$	Not allowed

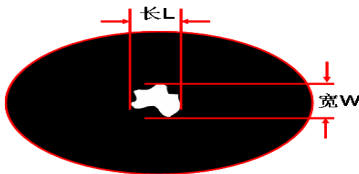
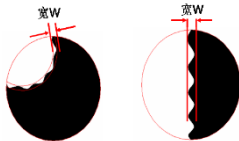
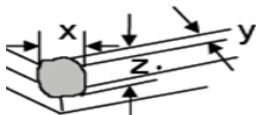
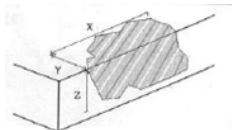


Module Incoming Inspection Standard

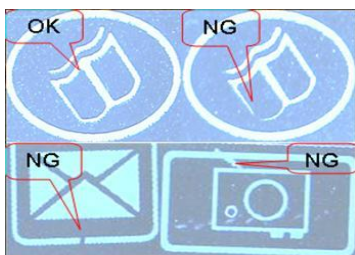
Confidential

Part Number: P0840XGF1MA00

Version: 1.0

5.4.3	Pin hole Including leakage printing dirt	Define :  直径D(Diameter)=1/2(L+W)		
		Size D (mm)		
		Acceptable Quantity		
		D≤0.2		
		Ignore		
		D>0.2		
		Not allowed		
5.4.4	Dent / convex	Size D (mm)		
		Acceptable Quantity		
		D≤0.2		
		Ignore		
		0.2<D≤0.5		
		3 (DS≥5mm)		
		D>0.5		
		Not allowed		
5.4.5	Ink Jag	Define: 		
		Size w (mm)		
		Acceptable Quantity		
		Window area	W≤0.2	
			Ignore	
			W>0.2	
Not allowed				
Edge area	W≤0.3			
	Ignore			
	W>0.3			
	Not allowed			
5.4.6	Touch panel surface fragment	Corner Fragment: Side Fragment:  		
		Size w (mm)		
		Acceptable Quantity		

	Module Incoming Inspection Standard		
	Confidential	Part Number: P0840XGF1MA00	Version: 1.0

		$X \leq 0.30$ $Y \leq 0.30$ $Z \leq T$	2/per side X: Length, Y: Width, Z: Thickness
5.4.7	LED Hole/ Camera eye/IR/ICON printing ink dot	Size w (mm)	Acceptable Quantity
		$D \leq 0.1$	Ignore
		$0.1 < D \leq 0.15$	1/nit
		$D > 0.15$	Not allowed
5.4.8	Printing Ink color	The printing ink color should be consistent with design drawing (or customer standard sample).	
5.4.9	Screen fonts/logos/symbols		Font/logo silky smooth/no jagged/shadow/penetration/wear/displacement/broken line and wire defects
5.4.10	Logo Ink jag	$\varphi \leq 0.1$	Ignore
		$0.1 < \varphi \leq 0.2$	1
		$0.2 < \varphi$	Not allowed
5.4.11	Spot and line defect on the backside of cover lens	Spot (Including white dot, Black dot) Line defect (Including white line, Black line, Scratch) Ink Jag	Don't control

Note:

1. Dot defect is defined as the defective area of the dot area is larger than 50% of the dot area.
2. Polarizer bubble is defined as the bubble appears on active display area. The defect of polarizer bubble shall be ignored if the polarizer bubble appears on the outside of active



display area.

3. ND application method: the parallel vertical distance between ND and panel is 3~5cm, the distance of eyes look squarely to the panel is 30 ± 5 cm
4. Foreign particle on the surface of the LCM should be ignored.
5. Displaying foreign body points using single eye determination
6. AA (Active Area) area, the display area, ie, the effective product display area, is a poor type of control area for the electrical measurement display. VA (View Area) area, viewable area, that is, the area that can be visually seen after the product is installed on the customer's entire machine.

6. Mechanics specification

As for the outside dimension, weight of the modules, please refer to product specification for more details.

7. Precaution

Please pay attention to the following items when you use the LCD Modules:

- 7.1 Do not twist or bend the module and prevent the unsuitable external force for display module during assembly.
- 7.2 Adopt measures for good heat radiation. Be sure to use the module with in the specified temperature.
- 7.3 Avoid dust or oil mist during assembly.
- 7.4 Following the correct power sequence while operating. Do not apply the invalid signal, otherwise, it will cause improper shut down and damage the module.
- 7.5 Less EMI: it will be more safety and less noise.
- 7.6 Please operate module in suitable temperature. The response time & brightness will drift by different temperature.
- 7.7 Avoid to display the fixed pattern (exclude the white pattern) in a long period, otherwise, it will cause image stains.
- 7.8 Be sure to turn off the power when connection of disconnecting the circuit.
- 7.9 Polarizer scratches easily, please handle it carefully.
- 7.10 Display surface never likes dirt of stains.
- 7.11 A dewdrop may lead to destruction. Please wipe off and moisture before using module.
- 7.12 Sudden temperature changes cause condensation, and it will cause polarizer damaged.



Module Incoming Inspection Standard

Confidential

Part Number: P0840XGF1MA00

Version: 1.0

-
- 7.13 High temperature and humidity may degrade performance. Please do not expose the module to the direct sunlight and so on.
- 7.14 Acetic acid or chlorine compounds are not friends with TFT display module.
- 7.15 Static electricity will damage the module, please do not touch the module without any grounded device.
- 7.16 Do not disassemble and reassemble the module by self.
- 7.17 Be careful do not touch the rear side directly.
- 7.18 Not strong vibration or shock. It will cause module broken.
- 7.19 Storage the modules in suitable environment with regular packing.
- 7.20 Be careful or injury from a broken display module.
- 7.21 Please avoid the pressure adding to the surface (front or rear side) of modules, because it will cause the display non-uniformity of other function issue.