

SPEC

Spec No.	TQ3C-8EAF0-E1YAL22-00
Date	December 10, 2014

TYPE : TCG121XGLPBPNN-AN40

< 12.1 inch XGA transmissive color TFT with LED backlight
and constant current circuit for LED backlight >

CONTENTS

1. Application
2. Construction and outline
3. Mechanical specifications
4. Absolute maximum ratings
5. Electrical characteristics
6. Optical characteristics
7. Interface signals
8. Input timing characteristics
9. Lot number identification
10. Warranty
11. Precautions for use
12. Reliability test data
13. Outline drawing



KYOCERA DISPLAY CORPORATION

This specification is subject to change without notice.
Consult Kyocera before ordering.

Original Issue Date	Designed by: Engineering dept.			Confirmed by: QA dept.	
	Prepared	Checked	Approved	Checked	Approved
December 10, 2014	M. Koyama	Y. Kajiyama	W. Yano	O. Sato	T. Hamano

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page -
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Warning

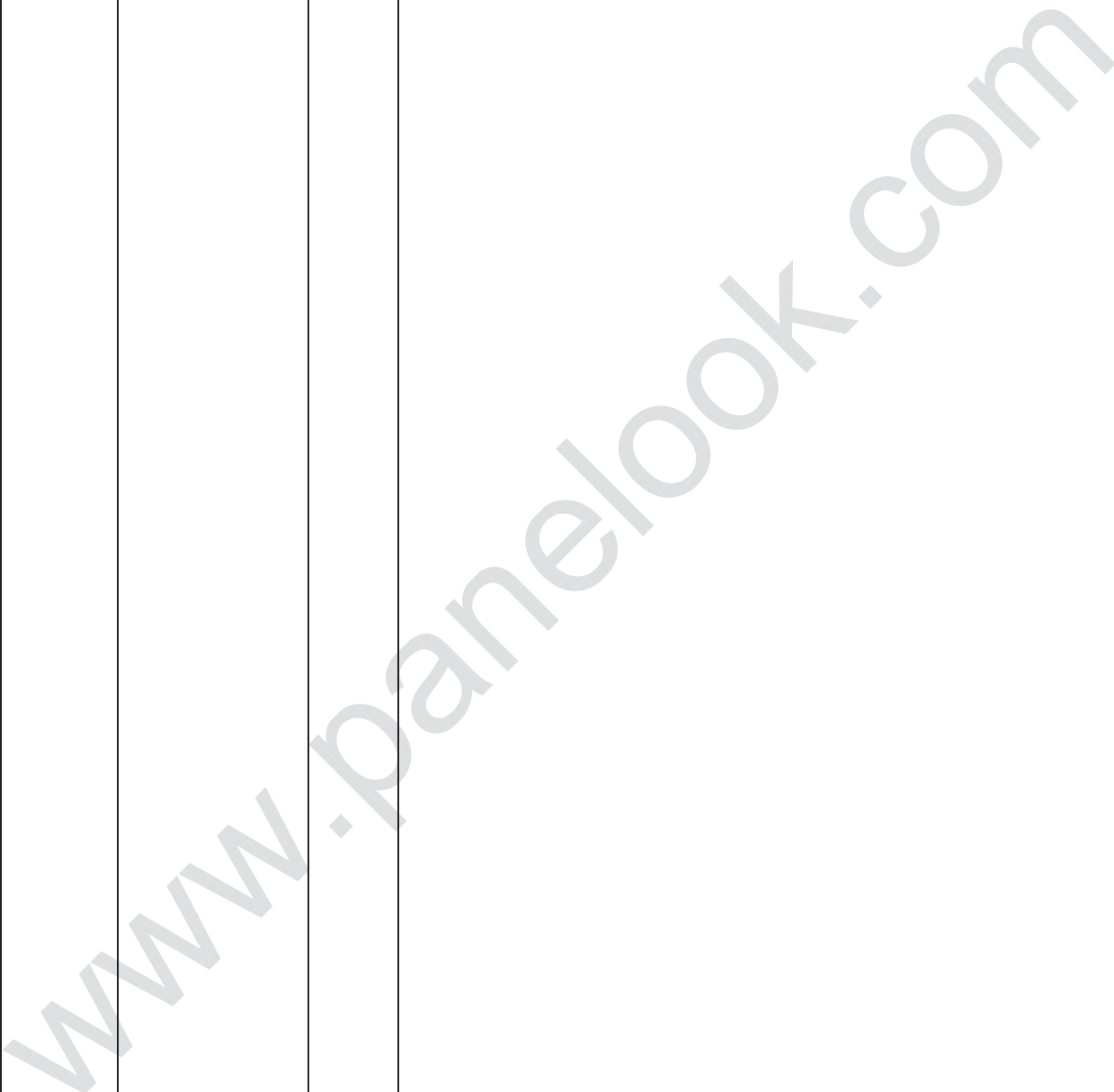
1. This Kyocera LCD module has been specifically designed for use only in electronic devices and industrial machines in the area of audio control, office automation, industrial control, home appliances, etc. The module should not be used in applications where the highest level of safety and reliability are required and module failure or malfunction of such module results in physical harm or loss of life, as well as enormous damage or loss. Such fields of applications include, without limitation, medical, aerospace, communications infrastructure, atomic energy control. Kyocera expressly disclaims any and all liability resulting in any way to the use of the module in such applications.
2. Customer agrees to indemnify, defend and hold Kyocera harmless from and against any and all actions, claims, damages, liabilities, awards, costs, and expenses, including legal expenses, resulting from or arising out of Customer's use, or sale for use, or Kyocera modules in applications.

Caution

1. Kyocera shall have the right, which Customer hereby acknowledges, to immediately scrap or destroy tooling for Kyocera modules for which no Purchase Orders have been received from the Customer in a two-year period.

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page -
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Revision record

Date		Designed by : Engineering dept.			Confirmed by : QA dept.	
		Prepared	Checked	Approved	Checked	Approved
Rev.No.	Date	Page	Descriptions			
						



Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 1
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1. Application

This document defines the specification of TCG121XGLPBPNN-AN40. (RoHS Compliant)

2. Construction and outline

LCD	: Transmissive color dot matrix type TFT
Backlight system	: LED
Polarizer	: Anti-Glare treatment
Interface	: LVDS
Additional circuit	: Timing controller, Power supply (3.3V input) With constant current circuit for LED Backlight(12V input)

3. Mechanical specifications

Item	Specification	Unit
Outline dimensions 1)	260.5(W)×203(H)×10.4(D)	mm
Active area	245.76(W)×184.32(H) (30.8cm/12.1 inch(Diagonal))	mm
Dot format	1,024×(B,G,R)(W)×768(H)	dot
Dot pitch	0.08(W)×0.24(H)	mm
Base color 2)	Normally Black	-
Mass	555	g

1) Projection not included. Please refer to outline for details.

2) Due to the characteristics of the LCD material, the color varies with environmental temperature.

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 2
-----------------------------------	---------------------------------	-----------

4. Absolute maximum ratings

4-1. Electrical absolute maximum ratings

Item		Symbol	Min.	Max.	Unit
Supply voltage(+3.3V)		V _{DD}	-0.3	3.95	V
Supply voltage(+12V)		V _{IN}	-0.3	14.0	V
Input signal Voltage 1)	RxIN _i +, RxIN _i - (i=0,1,2,3)	V _{I1}	-0.3	V _{DD} +0.3	V
	CK IN+, CK IN-	V _{I2}	-0.3	V _{DD} +0.3	V
	MODE, SC	V _{I3}	-0.3	V _{DD} +0.3	V
	BLBRT, BLEN	V _{I4}	-0.3	V _{IN}	V

- 1) V_{DD} must be supplied correctly within the range described in 5-1.

4-2. Environmental absolute maximum ratings

Item		Symbol	Min.	Max.	Unit
Operating temperature (Ambient) 1)		T _{OP} (Ambient)	-30	80	°C
Operating temperature (Panel) 2)		T _{OP} (Panel)	-30	80	°C
Storage temperature 3)		T _{STO}	-30	80	°C
Operating humidity 4)		H _{OP}	10	5)	%RH
Storage humidity 4)		H _{STO}	10	5)	%RH
Vibration		-	6)	6)	-
Shock		-	7)	7)	-

- 1) Operating temperature means a temperature which operation shall be guaranteed. Since display performance is evaluated at 25°C, another temperature range should be confirmed.
- 2) Panel surface temperature (all the surface).
- 3) Temp. = -30°C < 48h , Temp. = 80°C < 168h
Store LCD at normal temperature/humidity. Keep them free from vibration and shock.
An LCD that is kept at a low or a high temperature for a long time can be defective due to other conditions, even if the low or high temperature satisfies the standard.
(Please refer to "Precautions for Use" for details.)
- 4) Non-condensing
- 5) Temp. ≤ 40°C, 85%RH Max.
Temp. > 40°C, Absolute humidity shall be less than 85%RH at 40°C.

6)

Frequency	10~55 Hz	Acceleration value (0.3~9 m/s ²)
Vibration width	0.15mm	
Interval	10-55-10 Hz	1 minutes

2 hours in each direction X, Y, Z (6 hours total)

EIAJ ED-2531

- 7) Acceleration: 490 m/s², Pulse width: 11 ms
3 times in each direction: ±X, ±Y, ±Z
EIAJ ED-2531

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page 3
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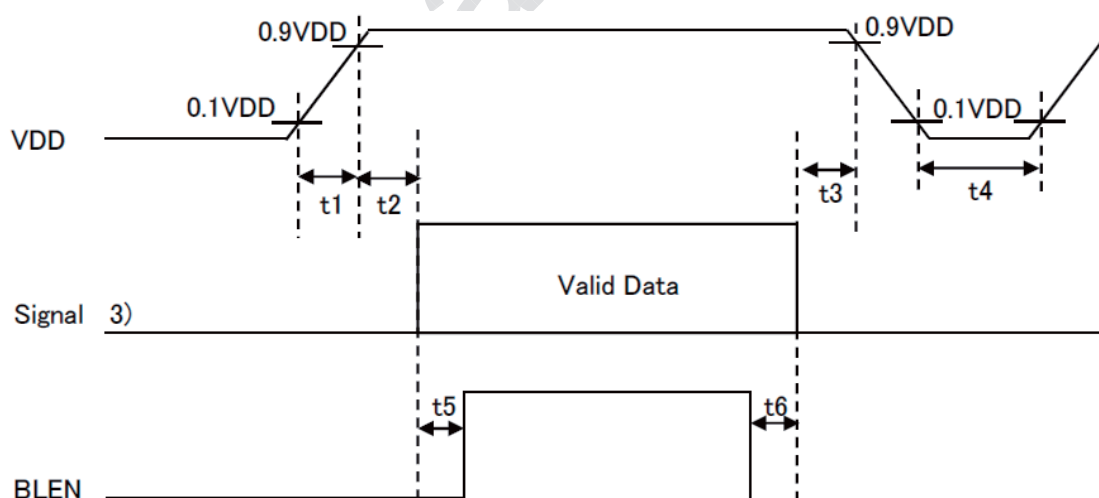
5. Electrical characteristics

5-1. LCD

Temp. = -30~80°C

Item	Symbol	Condition	Min.	Typ.	Max.	Unit
Supply voltage 1)	V_{DD}	-	3.0	3.3	3.6	V
Current consumption	I_{DD}	2)	-	300	390	mA
Permissible input ripple voltage	V_{RP}	$V_{DD}=3.3V$	-	-	100	mVp-p
Input signal voltage 3)	V_{IL}	"Low" level	0	-	$0.3V_{DD}$	V
	V_{IH}	"High" level	$0.7V_{DD}$	-	V_{DD}	V
Input leak current	I_{OL}	$V_{I3}=0V$	-10	-	10	μA
	I_{OH}	$V_{I3}=3.3V$	-	-	400	μA
LVDS Input voltage 4)	V_L	-	0	-	1.9	V
Differential input voltage	V_{ID}	-	200	-	600	mV
Differential input threshold voltage 4) 5)	V_{TL}	"Low" level	$V_{CM}-100$	-	-	mV
	V_{TH}	"High" level	-	-	$V_{CM}+100$	mV
Terminator	R_1	-	-	100	-	Ω
V_{DD} -turn-on conditions 1) 6)	t_1	-	0.1	-	20	ms
	t_2	-	10	-	-	ms
	t_3	-	0	-	-	ms
	t_4	-	2	-	-	s
	t_5	-	200	-	-	ms
	t_6	-	200	-	-	ms

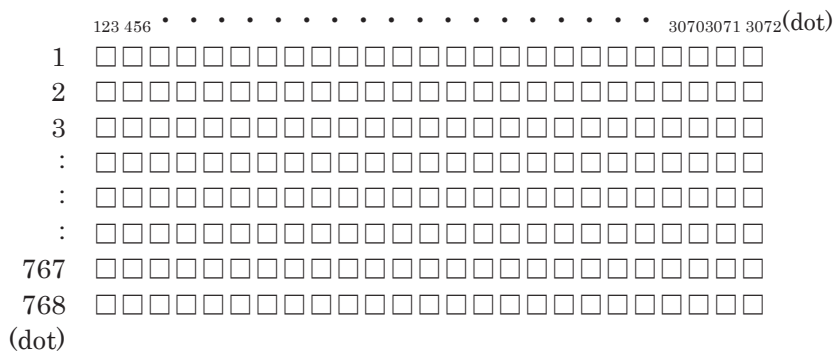
1) V_{DD} -turn-on conditions



Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 4
-----------------------------------	---------------------------------	-----------

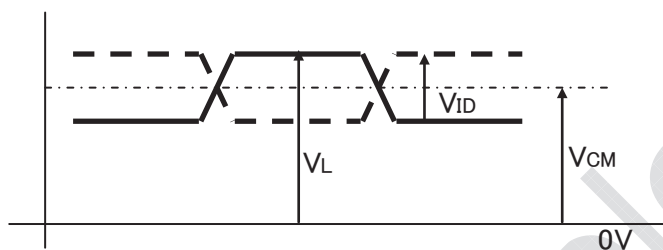
2) Display pattern:

V_{DD} = 3.3V, Temp. = 25°C



3) Input signal : MODE, SC

4) Input signal : RxIN3+, RxIN3-, RxIN2+, RxIN2-, RxIN1+, RxIN1-, RxIN0+, RxIN0-
CK IN+, CK IN-



5) V_{CM} : LVDS Common mode voltage (V_{CM}=1.25V)

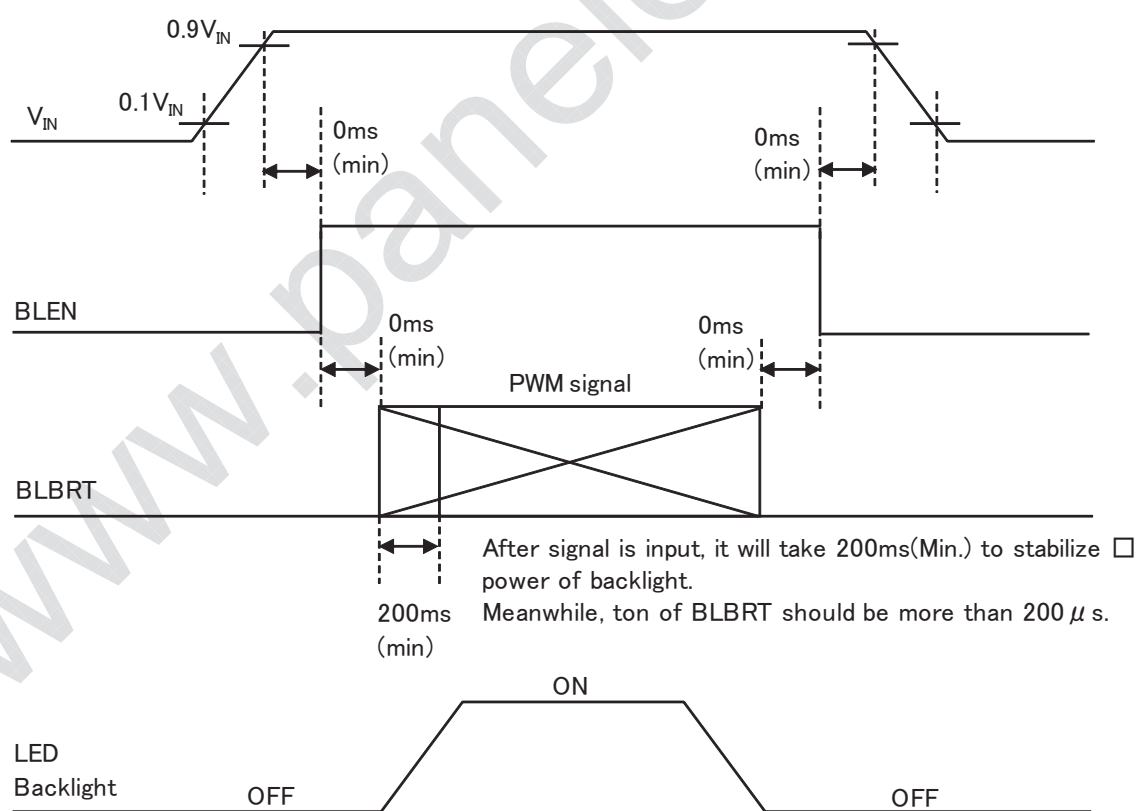
6) Please power on LVDS transmitter at the same time as V_{DD}, or LVDS transmitter should be powered on first.

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 5
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5-2. Constant current circuit for LED Backlight

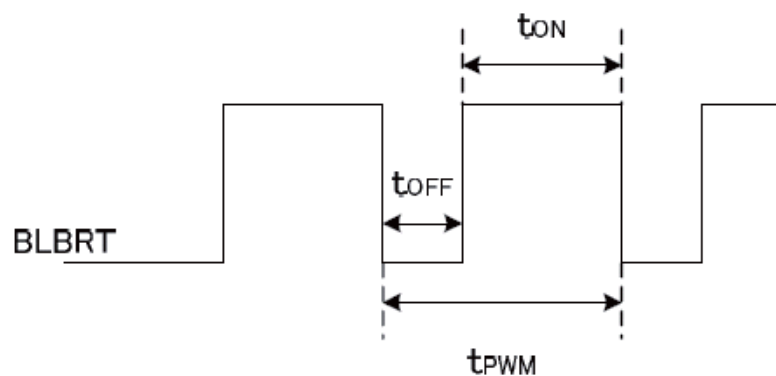
Temp. = -30~80°C

Item	Symbol	Condition	Min.	Typ.	Max.	Unit
Supply voltage 1)	V_{IN}	-	10.8	12.0	13.2	V
Current consumption	I_{IN}	2)	-	900	1,110	mA
Permissive input ripple voltage	V_{RP_BL}	$V_{IN}=12.0V$	-	-	100	mVp-p
BLBRT Input signal voltage	V_{IL_BLBRT}	"Low" level	0	-	0.8	V
	V_{IH_BLBRT}	"High" level	2.3	-	V_{IN}	V
BLBRT Input pull-down resistance	R_{IN_BLBRT}	-	100	300	500	k Ω
BLEN Input signal voltage	V_{IL_BLEN}	"Low" level	0	-	0.8	V
	V_{IH_BLEN}	"High" level	2.3	-	V_{IN}	V
BLEN Input pull-down resistance	R_{IN_BLEN}	-	100	300	500	k Ω
P W M Frequency 3)	f_{PWM}	-	200	-	10k	Hz
P W M Duty ratio 3)	D_{PWM}	$f_{PWM}=200Hz$	1	-	100	%
		$f_{PWM}=2kHz$	10	-	100	%
		$f_{PWM}=10kHz$	50	-	100	%
Operating life time 4), 5)	T	Temp.=25°C	-	70,000	-	h

1) V_{IN} -turn-on conditions2) $V_{IN} = 12V$, Temp. = 25°C, $D_{PWM} = 100\%$

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page 6
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3) PWM Timing Diagram



$t_{ON}, t_{OFF} \geq 50 \mu s$.

In case of lower frequency, the deterioration of the display quality, flicker etc., may occur.

- 4) When brightness decrease 50% of minimum brightness.
The average life of a LED will decrease when the LCD is operating at higher temperatures.
- 5) Life time is estimated data.(Condition : $I_F=(75)mA$, $T_a=25^\circ C$ in chamber).

Spec No.
TQ3C-8EAF0-E1YAL22-00

Part No.
TCG121XGLPBPN-AN40

Page
7

6. Optical characteristics

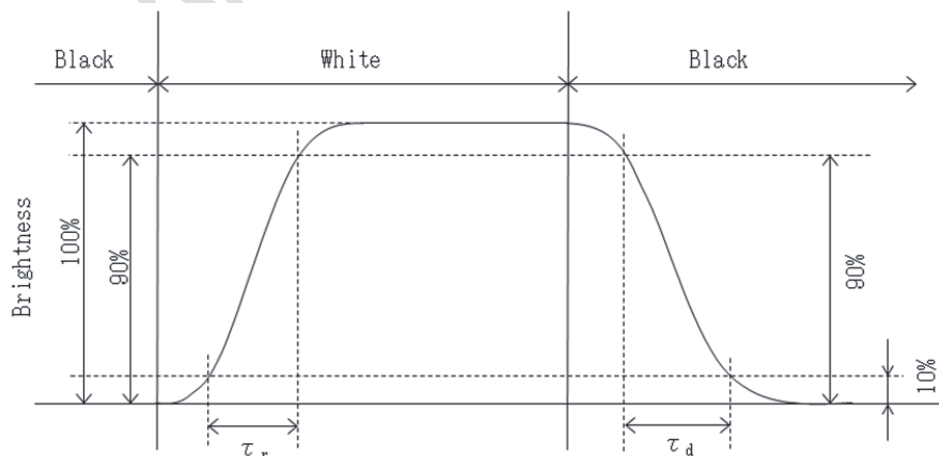
Measuring spot = ϕ 6.0mm, Temp. = 25°C

Item		Symbol	Condition	Min.	Typ.	Max.	Unit
Response time	Rise	τ_r	$\theta = \phi = 0^\circ$	-	18	-	ms
	Down	τ_d	$\theta = \phi = 0^\circ$	-	12	-	ms
Viewing angle range View direction		θ_{UPPER}	CR \geq 10	-	85	-	deg.
		θ_{LOWER}		-	85	-	
		ϕ_{LEFT}		-	85	-	deg.
		ϕ_{RIGHT}		-	85	-	
Contrast ratio	CR	$\theta = \phi = 0^\circ$	500	750	-	-	
Brightness	L	IF=(75)mA/Line	840	1,200	-	cd/m ²	
Chromaticity coordinates	Red	x	$\theta = \phi = 0^\circ$	0.550	0.600	0.650	-
		y		0.300	0.350	0.400	
	Green	x	$\theta = \phi = 0^\circ$	0.285	0.335	0.385	
		y		0.520	0.570	0.620	
	Blue	x	$\theta = \phi = 0^\circ$	0.100	0.150	0.200	
		y		0.070	0.120	0.170	
	White	x	$\theta = \phi = 0^\circ$	0.270	0.320	0.370	
		y		0.295	0.345	0.395	

6-1. Definition of contrast ratio

$$\text{CR(Contrast ratio)} = \frac{\text{Brightness with all pixels "White"}}{\text{Brightness with all pixels "Black"}}$$

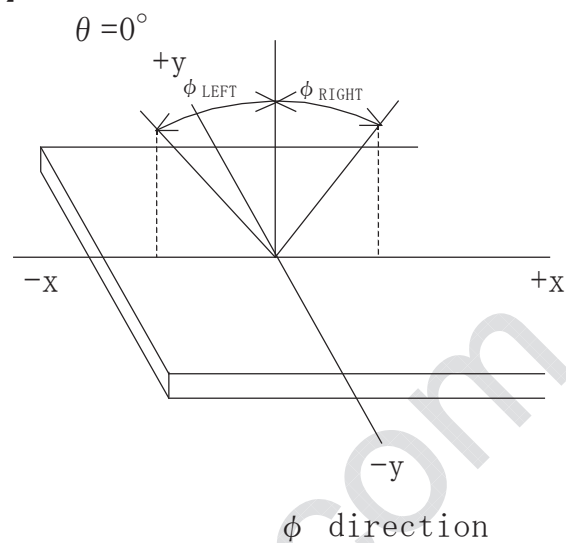
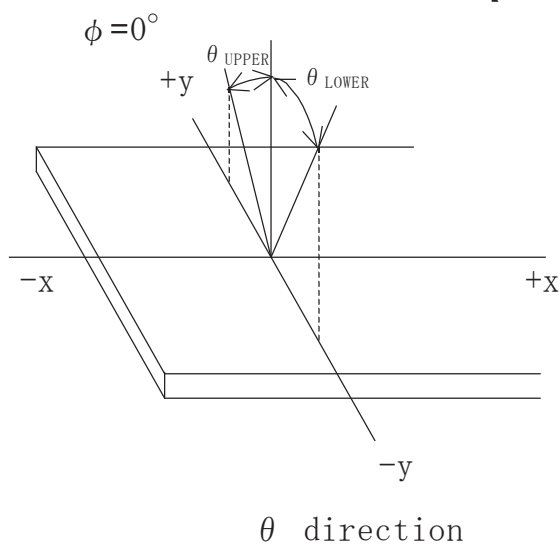
6-2. Definition of response time



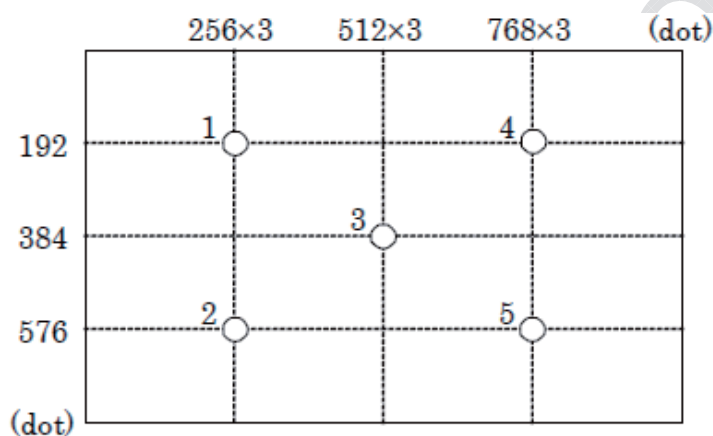
Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page 8
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6-3. Definition of viewing angle

【FPC side】



6-4. Brightness measuring points



- 1) Rating is defined as the white brightness at center of display screen(3).
- 2) 5 minutes after LED is turned on. (Ambient Temp.=25°C)

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page 9
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7. Interface signals

7-1. Interface signals

No.	Symbol	Description	Note
1	V _{DD}	+3.3V power supply	
2	V _{DD}	+3.3V power supply	
3	GND	GND	
4	GND	GND	
5	RxIN0-	LVDS receiver signal CH0(-)	LVDS
6	RxIN0+	LVDS receiver signal CH0(+)	LVDS
7	GND	GND	
8	RxIN1-	LVDS receiver signal CH1(-)	LVDS
9	RxIN1+	LVDS receiver signal CH1(+)	LVDS
10	GND	GND	
11	RxIN2-	LVDS receiver signal CH2(-)	LVDS
12	RxIN2+	LVDS receiver signal CH2(+)	LVDS
13	GND	GND	
14	CK IN1-	LVDS receiver signal CK(-)	LVDS
15	CK IN1+	LVDS receiver signal CK(+)	LVDS
16	GND	GND	
17	RxIN3-	LVDS receiver signal CH3(-)	LVDS
18	RxIN3+	LVDS receiver signal CH3(+)	LVDS
19	MODE	Bit data select signal(GND: 6bit mode, High: 8bit mode)	
20	SC	Scan direction control(GND: Normal, High: Reverse)	1)

LCD connector : 20186-020E-11F (I-PEX)
 Matching connector : 20197-020U-F (I-PEX)
 : 20197-T20U-F (I-PEX)

LVDS receiver : Embedded in ASIC

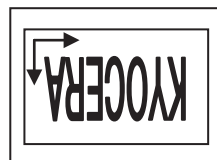
Matching LVDS transmitter : THC63LVDM83R(THine Electronics) or compatible

1) Scanning

SC : GND



SC : High



Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page 10
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7-2. LED

No.	Symbol	Description	Note
1	V _{IN}	+12V power supply	
2	V _{IN}	+12V power supply	
3	BLBRT	PWM signal(Brightness adjustment)	
4	BLEN	ON/OFF terminal voltage	
5	GND	GND	
6	GND	GND	

LCD connector : SM06B-SHLS-G-TF(LF)(SN) (JST)

Matching connector : SHLP-6V-S-B (JST)

Spec No.
TQ3C-8EAF0-E1YAL22-00

Part No.
TCG121XGLPBPNN-AN40

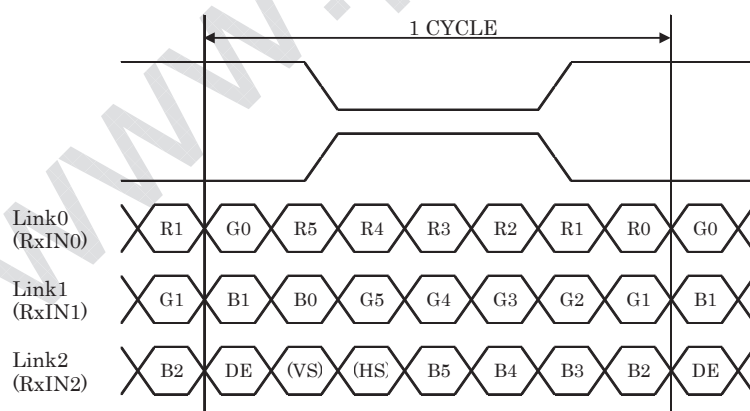
Page
11

7-3. Data mapping(6bit input)

1) Location of MODE (THC63LVDM83R(THine Electronics) or compatible)

Transmitter		MODE
Pin No.	Data	= L(GND)
51	TA0	R0(LSB)
52	TA1	R1
54	TA2	R2
55	TA3	R3
56	TA4	R4
3	TA5	R5(MSB)
4	TA6	G0(LSB)
6	TB0	G1
7	TB1	G2
11	TB2	G3
12	TB3	G4
14	TB4	G5(MSB)
15	TB5	B0(LSB)
19	TB6	B1
20	TC0	B2
22	TC1	B3
23	TC2	B4
24	TC3	B5(MSB)
27	TC4	(HS)
28	TC5	(VS)
30	TC6	DE
50	TD0	GND
2	TD1	GND
8	TD2	GND
10	TD3	GND
16	TD4	GND
18	TD5	GND
25	TD6	(NA)

MODE=L(GND)



DE : DATA ENABLE

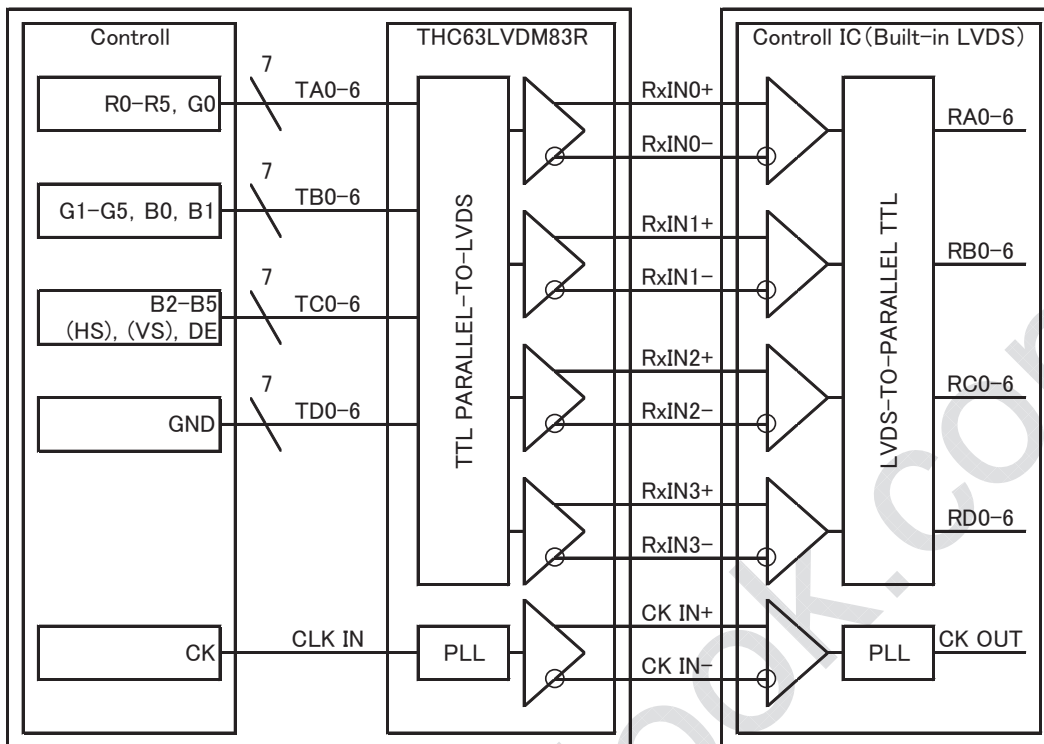
HS : H_{SYNC}

VS : V_{SYNC}

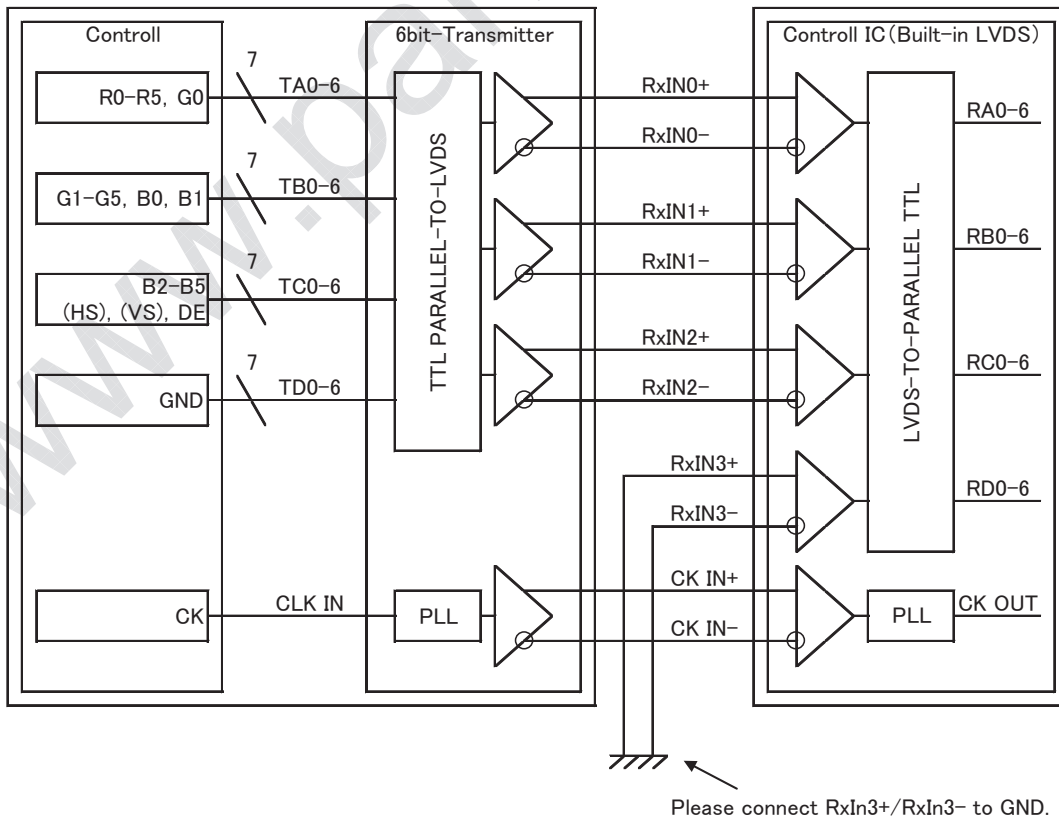
Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 12
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2) Block Diagram

MODE=L(GND)



When using “6-bit Transmitter”, please connect the unused channel of the control IC receiver as described in the diagram below.



Spec No.
TQ3C-8EAF0-E1YAL22-00

Part No.
TCG121XGLPBPN-AN40

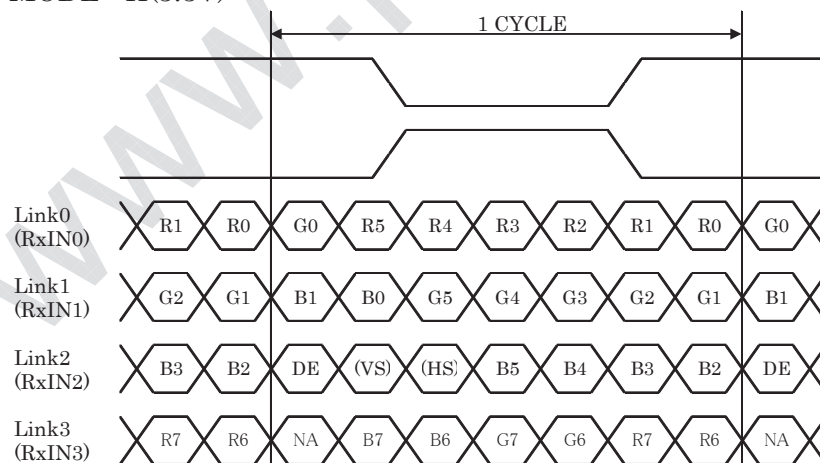
Page
13

7-4. Data mapping(8bit input)

1) Location of MODE (THC63LVDM83R(THine Electronics) or compatible)

Transmitter		MODE
Pin No.	Data	= H(3.3V)
51	TA0	R0(LSB)
52	TA1	R1
54	TA2	R2
55	TA3	R3
56	TA4	R4
3	TA5	R5
4	TA6	G0(LSB)
6	TB0	G1
7	TB1	G2
11	TB2	G3
12	TB3	G4
14	TB4	G5
15	TB5	B0(LSB)
19	TB6	B1
20	TC0	B2
22	TC1	B3
23	TC2	B4
24	TC3	B5
27	TC4	(HS)
28	TC5	(VS)
30	TC6	DE
50	TD0	R6
2	TD1	R7(MSB)
8	TD2	G6
10	TD3	G7(MSB)
16	TD4	B6
18	TD5	B7(MSB)
25	TD6	(NA)

MODE= H(3.3V)



DE : DATA ENABLE

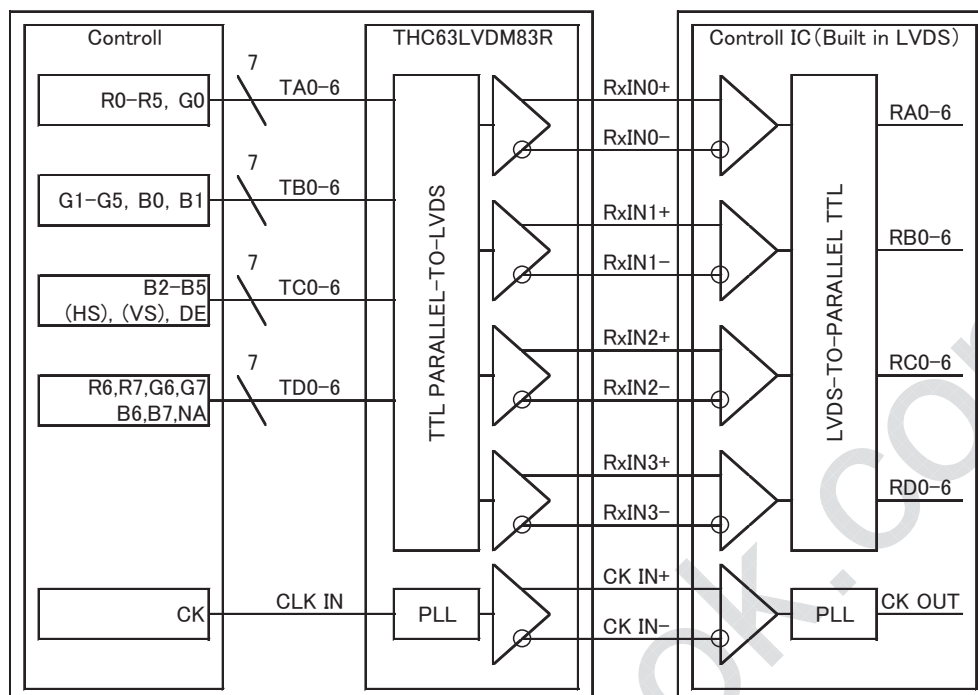
HS : H_{SYNC}

VS : V_{SYNC}

Spec No.	Part No.	Page
TQ3C-8EAF0-E1YAL22-00	TCG121XGLPBPNN-AN40	14

2) Block Diagram

MODE= H(3.3V)



Spec No.
TQ3C-8EAF0-E1YAL22-00

Part No.
TCG121XGLPBPN-AN40

Page
15

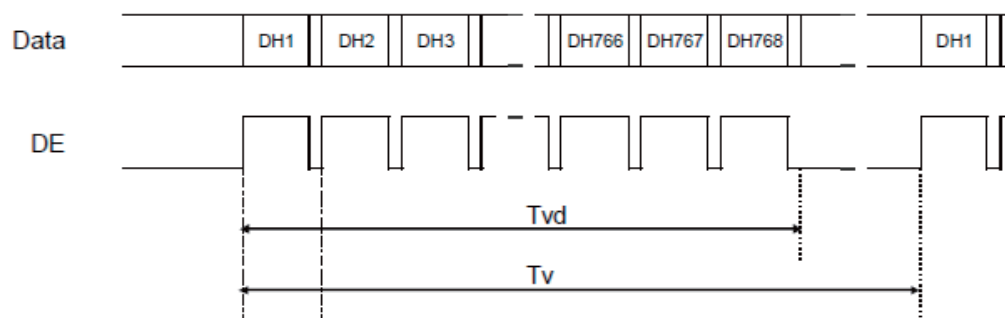
8. Input timing characteristics

8-1. Timing characteristics

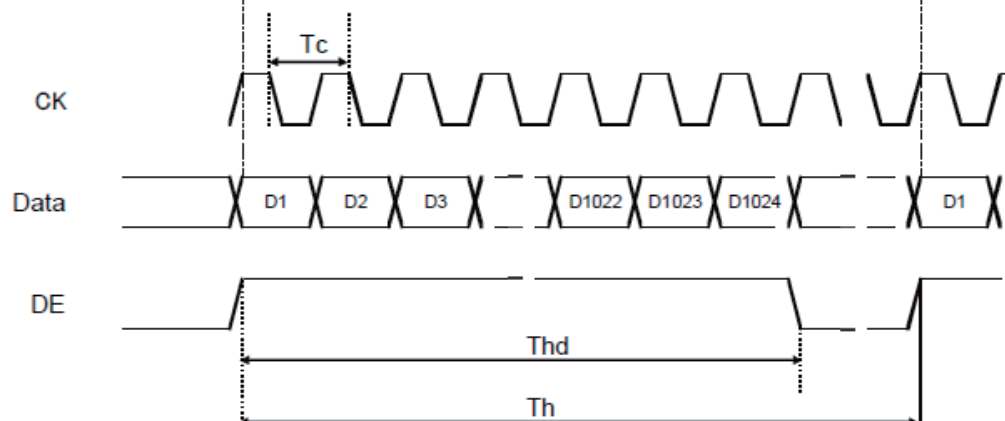
	Item	Symbol	Min.	Typ.	Max.	Unit	Note
Clock (CK)	Frequency	1/Tc	52	65	71	MHz	
Enable signal (DE)	Horizontal Period	Th	1,114	1,344	1,400	Dot	1)
			15.7	20.7	23.7	μ s	
	Horizontal display period	Thd	1,024			Tc	
	Vertical Period	Tv	778	806	845	Line	
Refresh rate	Vertical display period	Tvd	768			Th	2)
			fv	50	60	82	

- 1) Please set a clock frequency, a vertical dormant period, and the horizontal dormant period so that the Horizontal Period should not reach less than Min. value.
- 2) If the refresh rate reach less than Min. value, the deterioration of the display quality, flicker etc., may occur. ($f_v = 1/T_v$)

Vertical Timing Diagram

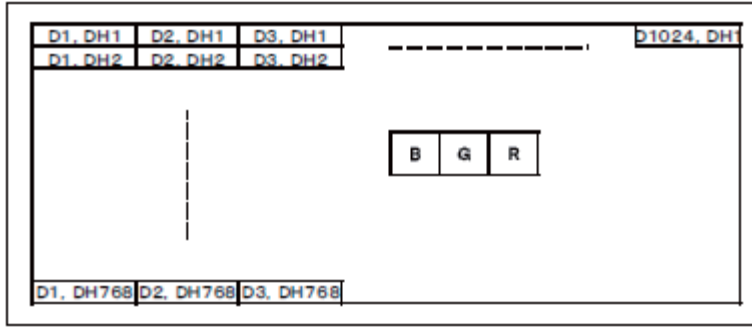


Horizontal Timing Diagram



Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page 16
-----------------------------------	--------------------------------	------------

8-2. Input Data Signals and Display position on the screen



Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 17
-----------------------------------	---------------------------------	------------

9. Lot number identification

The lot number shall be indicated on the back of the backlight case of each LCD.

TCG121XGLPBPNN-AN40 - □□ - □□ - □ MADE IN □□□□□
 ↓↓ ↓ ↓ ↓ ↓
 1 2 3 4 5

No1. - No5. above indicate

1. Year code
2. Month code
3. Date
4. Version Number
5. Country of origin (Japan or China)

Year	2014	2015	2016	2017	2018	2019
Code	4	5	6	7	8	9

Month	Jan.	Feb.	Mar.	Apr.	May	Jun.
Code	1	2	3	4	5	6

Month	Jul.	Aug.	Sep.	Oct.	Nov.	Dec.
Code	7	8	9	X	Y	Z

10. Warranty

10-1. Incoming inspection

Please inspect the LCD within one month after your receipt.

10-2. Production warranty

Kyocera warrants its LCD's for a period of 12 months from the ship date. Kyocera shall, by mutual agreement, replace or re-work defective LCD's that are shown to be Kyocera's responsibility.

Spec No.	Part No.	Page
TQ3C-8EAF0-E1YAL22-00	TCG121XGLPBPNN-AN40	18

11. Precautions for use

11-1. Installation of the LCD

- 1) A transparent protection plate shall be added to protect the LCD and its polarizer.
- 2) The LCD shall be installed so that there is no pressure on the LSI chips.
- 3) Since this product is wide viewing product, occurrence level of in-plane unevenness by the external stress is different compared to current normal viewing product. So there is a possibility that in-plane unevenness will be occurred by over twist, strain giving by attaching to LCD, and over pressure to touch panel. Please be careful of stress when designing the housing.
- 4) A transparent protection sheet is attached to the polarizer. Please remove the protection film slowly before use, paying attention to static electricity.

11-2. Static electricity

- 1) Since CMOS ICs are mounted directly onto the LCD glass, protection from static electricity is required.
- 2) Workers should use body grounding. Operator should wear ground straps.

11-3. LCD operation

- 1) The LCD shall be operated within the limits specified. Operation at values outside of these limits may shorten life, and/or harm display images.
- 2) Please select the best display pattern based on your evaluation because flicker, lines or nonuniformity or unevenness can be visible depending on display patterns.

11-4. Storage

- 1) The LCD shall be stored within the temperature and humidity limits specified.
Store in a dark area, and protect the LCD from direct sunlight or fluorescent light.
- 2) Always store the LCD so that it is free from external pressure onto it.

11-5. Usage

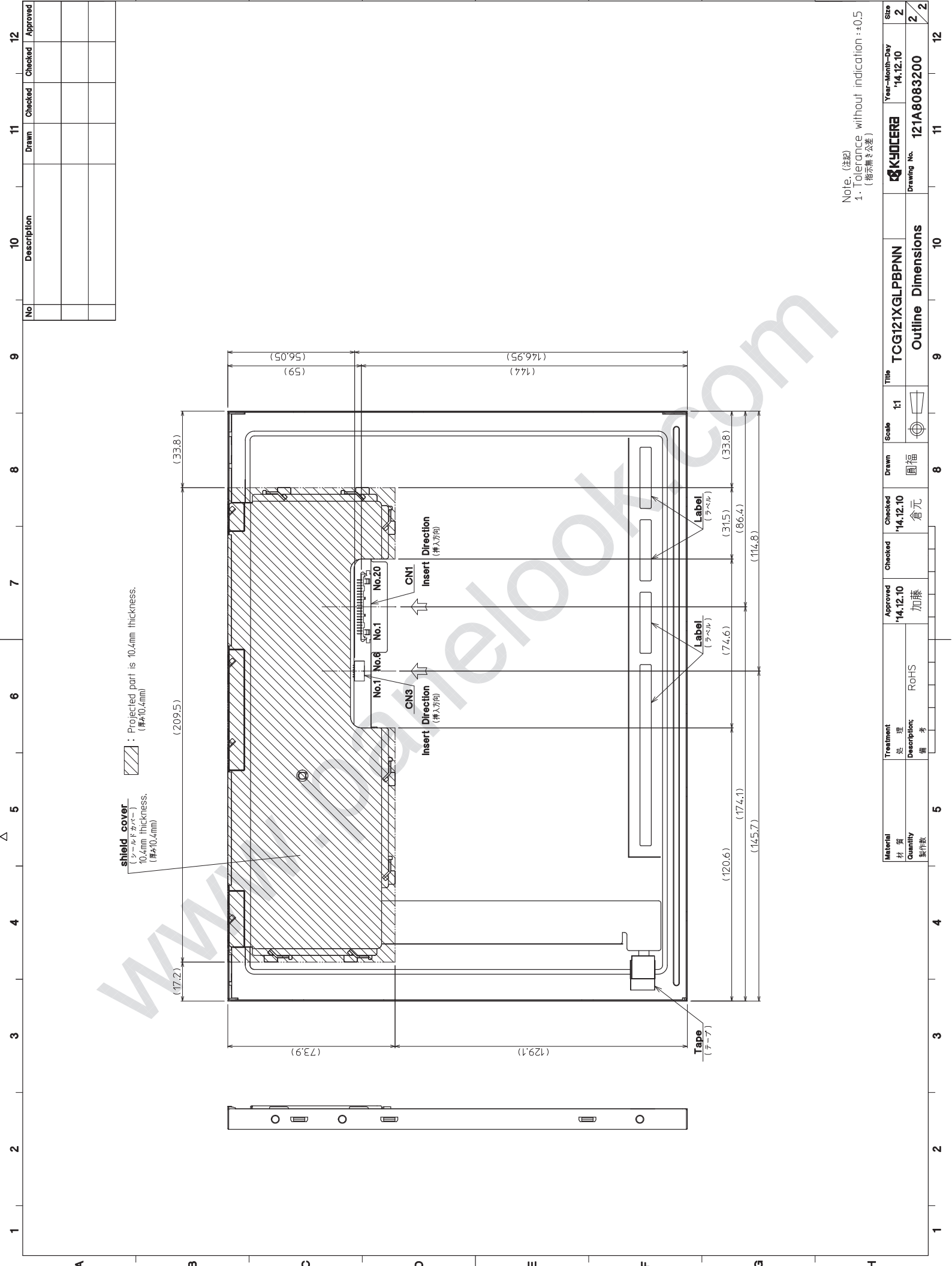
- 1) **DO NOT** store in a high humidity environment for extended periods. Polarizer degradation bubbles, and/or peeling off of the polarizer may result.
- 2) The front polarizer is easily scratched or damaged. Prevent touching it with any hard material, and from being pushed or rubbed.
- 3) The LCD screen may be cleaned by wiping the screen surface with a soft cloth or cotton pad using a little Ethanol.
- 4) Water may cause damage or discoloration of the polarizer. Clean condensation or moisture from any source immediately.
- 5) Always keep the LCD free from condensation during testing. Condensation may permanently spot or stain the polarizer.
- 6) Do not disassemble LCD because it will result in damage.
- 7) This Kyocera LCD has been specifically designed for use in general electronic devices, but not for use in a special environment such as usage in an active gas. Hence, when the LCD is supposed to be used in a special environment, evaluate the LCD thoroughly beforehand and do not expose the LCD to chemicals such as an active gas.
- 8) Please do not use solid-base image pattern for long hours because a temporary afterimage may appear. We recommend using screen saver etc. in cases where a solid-base image pattern must be used.
- 9) Liquid crystal may leak when the LCD is broken. Be careful not to let the fluid go into your eyes and mouth. In the case the fluid touches your body; rinse it off right away with water and soap.

Spec No. TQ3C-8EAF0-E1YAL22-00	Part No. TCG121XGLPBPN-AN40	Page 19
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12. Reliability test data

Test item	Test condition	Test time	Judgement
High temp. atmosphere	80°C	240h	Display function : No defect Display quality : No defect Current consumption : No defect
Low temp. atmosphere	-30°C	240h	Display function : No defect Display quality : No defect Current consumption : No defect
High temp. humidity atmosphere	40°C 90% RH	240h	Display function : No defect Display quality : No defect Current consumption : No defect
Temp. cycle	-30°C 0.5h R.T. 0.5h 80°C 0.5h	10cycles	Display function : No defect Display quality : No defect Current consumption : No defect
High temp. operation	80°C	500h	Display function : No defect Display quality : No defect Current consumption : No defect

- 1) Each test item uses a test LCD only once. The tested LCD is not used in any other tests.
- 2) The LCD is tested in circumstances in which there is no condensation.
- 3) The reliability test is not an out-going inspection.
- 4) The result of the reliability test is for your reference purpose only.
The reliability test is conducted only to examine the LCD's capability.



Note. (注記)
 1. Tolerance without indication : ±0.5
 (指示無き公差)

No.	Description	Drawn	Checked	Year-Month-Day	Size

Material	Treatment	Approved	Checked	Checked	Scale	Title	Year-Month-Day	Size
Material (材質)	Description (説明)	加藤	'14.12.10	倉元	1:1	TCG121XGLPBPNN	'14.12.10	2
Quantity (数量)	RoHS					Outline Dimensions		2
製作数	備考							2

Spec No.	TQ3C-8EAF0-E2YAL22-00
Date	December 10, 2014

KYOCERA INSPECTION STANDARD

TYPE : TCG121XGLPBPNN-AN40

KYOCERA DISPLAY CORPORATION

Original Issue Date	Designed by : Engineering dept.			Confirmed by : QA dept.	
	Prepared	Checked	Approved	Checked	Approved
December 10, 2014	M. Koyama	Y. Kajiyama	W. Yano	O. Sato	I. Hamano

Spec No.

TQ3C-8EAF0-E2YAL22-00

Part No.

TCG121XGLPBPN-AN40

Page

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Revision record

Date		Designed by : Engineering dept.			Confirmed by : QA dept.	
		Prepared	Checked	Approved	Checked	Approved
Rev.No.	Date	Page	Descriptions			

Spec No. TQ3C-8EAF0-E2YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 1
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Visuals specification

1) Note

		Note
General		1. Customer identified anomalies not defined within this inspection standard shall be reviewed by Kyocera, and an additional standard shall be determined by mutual consent. 2. This inspection standard about the image quality shall be applied to any defect within the effective viewing area and shall not be applicable to outside of the area. 3. Inspection conditions Luminance : 500 Lux min. Inspection distance : 300 mm. Temperature : 25 ± 5°C Direction : Directly above
Definition of inspection item	Dot defect	Bright dot defect The dot is constantly “on” when power applied to the LCD, even when all “Black” data sent to the screen. Inspection tool: 5% Transparency neutral density filter. Count dot: If the dot is visible through the filter. Don't count dot: If the dot is not visible through the filter.
		Black dot defect The dot is constantly “off” when power applied to the LCD, even when all “White” data sent to the screen. Similar size compared to bright dot.
		White dot (Circular/foreign particle) Pixel works electrically, however, circular/foreign particle makes dot appear to be “on” even when all “Black” data is sent to the screen.
		Adjacent dot Adjacent dot defect is defined as two or more bright dot defects or black dot defects.
	External inspection	Bubble, Scratch, Foreign particle (Polarizer, Cell, Backlight) Visible operating (all pixels “Black” or “White”) and non operating.
		Appearance inspection Does not satisfy the value at the spec.
Others	CFL wires Damaged to the CFL wires, connector, pin, functional failure or appearance failure.	
Definition of size	Definition of circle size $d = (a + b) / 2$	Definition of linear size

Spec No. TQ3C-8EAF0-E2YAL22-00	Part No. TCG121XGLPBPNN-AN40	Page 2
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2) Standard

Classification		Inspection item	Judgement standard																
Defect (in LCD glass)	Dot defect	Bright dot defect	Acceptable number : 4 Bright dot spacing : 5 mm or more																
		Black dot defect	Acceptable number : 5 Black dot spacing : 5 mm or more																
		2 dot join	Bright dot defect	Acceptable number : 2															
			Black dot defect	Acceptable number : 3															
		3 or more dots join	Acceptable number : 0																
		Total dot defects	Acceptable number : 5 Max																
	Others	White dot, Dark dot (Circle)	<table border="1"> <thead> <tr> <th>Size (mm)</th> <th colspan="2">Acceptable number</th> </tr> </thead> <tbody> <tr> <td>$d \leq 0.2$</td> <td colspan="2">(Neglected)</td> </tr> <tr> <td>$0.2 < d \leq 0.4$</td> <td colspan="2">5</td> </tr> <tr> <td>$0.4 < d \leq 0.5$</td> <td colspan="2">3</td> </tr> <tr> <td>$0.5 < d$</td> <td colspan="2">0</td> </tr> </tbody> </table>			Size (mm)	Acceptable number		$d \leq 0.2$	(Neglected)		$0.2 < d \leq 0.4$	5		$0.4 < d \leq 0.5$	3		$0.5 < d$	0
Size (mm)	Acceptable number																		
$d \leq 0.2$	(Neglected)																		
$0.2 < d \leq 0.4$	5																		
$0.4 < d \leq 0.5$	3																		
$0.5 < d$	0																		
External inspection (Defect on Polarizer or between Polarizer and LCD glass)	Polarizer (Scratch)	<table border="1"> <thead> <tr> <th>Width (mm)</th> <th>Length (mm)</th> <th>Acceptable number</th> </tr> </thead> <tbody> <tr> <td>$W \leq 0.1$</td> <td>—</td> <td>(Neglected)</td> </tr> <tr> <td rowspan="2">$0.1 < W \leq 0.3$</td> <td>$L \leq 5.0$</td> <td>(Neglected)</td> </tr> <tr> <td>$5.0 < L$</td> <td>0</td> </tr> <tr> <td>$0.3 < W$</td> <td>—</td> <td>0</td> </tr> </tbody> </table>			Width (mm)	Length (mm)	Acceptable number	$W \leq 0.1$	—	(Neglected)	$0.1 < W \leq 0.3$	$L \leq 5.0$	(Neglected)	$5.0 < L$	0	$0.3 < W$	—	0	
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	Polarizer (Bubble)	<table border="1"> <thead> <tr> <th>Size (mm)</th> <th colspan="2">Acceptable number</th> </tr> </thead> <tbody> <tr> <td>$d \leq 0.2$</td> <td colspan="2">(Neglected)</td> </tr> <tr> <td>$0.2 < d \leq 0.3$</td> <td colspan="2">5</td> </tr> <tr> <td>$0.3 < d \leq 0.5$</td> <td colspan="2">3</td> </tr> <tr> <td>$0.5 < d$</td> <td colspan="2">0</td> </tr> </tbody> </table>			Size (mm)	Acceptable number		$d \leq 0.2$	(Neglected)		$0.2 < d \leq 0.3$	5		$0.3 < d \leq 0.5$	3		$0.5 < d$	0	
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$0.5 < d$	0																		
Foreign particle (Circular shape)	<table border="1"> <thead> <tr> <th>Size (mm)</th> <th colspan="2">Acceptable number</th> </tr> </thead> <tbody> <tr> <td>$d \leq 0.2$</td> <td colspan="2">(Neglected)</td> </tr> <tr> <td>$0.2 < d \leq 0.4$</td> <td colspan="2">5</td> </tr> <tr> <td>$0.4 < d \leq 0.5$</td> <td colspan="2">3</td> </tr> <tr> <td>$0.5 < d$</td> <td colspan="2">0</td> </tr> </tbody> </table>			Size (mm)	Acceptable number		$d \leq 0.2$	(Neglected)		$0.2 < d \leq 0.4$	5		$0.4 < d \leq 0.5$	3		$0.5 < d$	0		
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Foreign particle (Linear shape) Scratch	<table border="1"> <thead> <tr> <th>Width (mm)</th> <th>Length (mm)</th> <th>Acceptable number</th> </tr> </thead> <tbody> <tr> <td>$W \leq 0.03$</td> <td>—</td> <td>(Neglected)</td> </tr> <tr> <td rowspan="3">$0.03 < W \leq 0.1$</td> <td>$L \leq 2.0$</td> <td>(Neglected)</td> </tr> <tr> <td>$2.0 < L \leq 4.0$</td> <td>3</td> </tr> <tr> <td>$4.0 < L$</td> <td>0</td> </tr> <tr> <td>$0.1 < W$</td> <td>—</td> <td>(According to circular shape)</td> </tr> </tbody> </table>			Width (mm)	Length (mm)	Acceptable number	$W \leq 0.03$	—	(Neglected)	$0.03 < W \leq 0.1$	$L \leq 2.0$	(Neglected)	$2.0 < L \leq 4.0$	3	$4.0 < L$	0	$0.1 < W$	—	(According to circular shape)
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