

## TABLE OF CONTENTS

<b>1.0 INTRODUCTION.....</b>	<b>1</b>
<b>2.0 ESD ISSUES IN THE FPD MANUFACTURING ENVIRONMENT.....</b>	<b>1</b>
2.1 DIRECT CONTACT PROCESS FIXTURE AND STAGE MATERIAL ANALYSIS.....	1
2.1.1 <i>Introduction</i> .....	1
2.1.2 <i>ESD Safe Material Analysis</i> .....	2
2.1.3 <i>Static Charge Generation by Stage Materials</i> .....	6
2.1.4 <i>Section Summary</i> .....	11
2.2 GLASS PLATE TRANSFER SYSTEM .....	11
2.2.1 <i>Introduction</i> .....	11
2.2.2 <i>ESD Damage in Transfer System</i> .....	12
2.2.3 <i>Section Summary</i> .....	16
2.3 GENERAL SOUCES OF ESD DAMGE IN FPD PRODUCTION .....	16
<b>3.0 FACTORY CONTROLS FOR FPD.....</b>	<b>16</b>
3.1 STATIC CHARGE CONTROL.....	16
3.1.1 <i>Limitations of General ESD Control</i> .....	16
3.1.2 <i>Other Material Properties</i> .....	16
3.2 CHARGE GENERATION .....	17
3.2.1 <i>Triboelectric Charging</i> .....	17
3.2.2 <i>Limits on Humidity Control of Charge Generation</i> .....	17
3.3 GROUNDING CONDUCTORS AND STATIC DISSIPATIVE MATERIALS.....	17
3.4 PERSONNEL STATIC CHARGE CONTROL.....	18
3.5 NEUTRALIZING CHARGE ON INSULATORS.....	18
3.6 IONIZATION .....	18
3.7 PROBLEMS WITH CONTROLLING STATIC CHARGE IN MANUFACTURING EQUIPMENT .....	19
3.8 STANDARDS.....	19
<b>4.0 OUTLOOK.....</b>	<b>19</b>
4.1 DISPLAY TECHNOLOGY FUTURE DEVELOPMENT TRENDS .....	20
4.2 QUANTUM DOTS .....	20
4.3 CURVED AND FLEXIBLE DISPLAYS .....	21
4.4 4K UHD AND HIGH RESOLUTION PPI DISPLAYS .....	21
4.5 LTPS AND IGZO .....	21
4.6 OLEDs .....	22
4.7 LCDs.....	22
4.8 TRANSPARENT DISPLAYS .....	22
4.9 GLASS SLIMMING .....	22

## Annexes

Annex A (Informative): Glass Plate Generation Sizes.....	24
Annex B (Informative): Abbreviations .....	25
Annex C (Informative): Bibliography.....	26
Annex D (Informative): Reference Documents.....	27

## Tables

Table 1: Lift Pin Resistance Measured Values Related to ESD Damage.....	3
Table 2: Lift Pin Resistance Measured Values for Different Materials .....	4
Table 3: Tested Stage Resistance Range.....	7
Table 4: Stage Material Properties .....	10
Table 5: Characteristics of Two Rollers in Transfer Units .....	15

## Figures

Figure 1: Failures Correlate with the Lift Pin Locations on Process Stage for 8th Generation Glass Substrate .....	2
Figure 2: TFT LCD ESD Damage Features .....	3
Figure 3: Schematic of Test (a) Glass and (b) Lift Pin .....	4
Figure 4: Test Setup for ESD Damage Occurrence During Lift Pin Contact.....	4
Figure 5: ESD Damage Occurrence versus Different (a) Resistance Ranges of Lift Pins, (b) Air Gap Spacing, and (c) Breakdown Damage Image of a 3 $\mu\text{m}$ Gap .....	6
Figure 6: Stage Equipment for the Glass Separation Test.....	6
Figure 7: Charge Generation Test Results for Different Stage Material Resistance for (a) Bare Glass and (b) Passivation Layer on Glass .....	8
Figure 8: Static Charge Voltages Increasing with the Number of Separations .....	8
Figure 9: Static Charge Generation Values on a Granite Stage with Different Surface Roughness .....	9
Figure 10: Static Charge Generation Values with Different Process Conditions (a) Separation Speed, (b) Vacuum Holding Pressures, and (c) Vacuum Time .....	11
Figure 11: Loupe Image of Point Defect.....	12
Figure 12: The Defect Map in Glass.....	12
Figure 13: Physical Failure Analysis of Defect.....	14
Figure 14: Schematic Diagram of Panel Structure .....	14
Figure 15: Transfer Unit Where the ESD Occurred.....	15