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(19) **United States**(12) **Patent Application Publication****Hsiu et al.**(10) **Pub. No.: US 2002/0080322 A1**(43) **Pub. Date: Jun. 27, 2002**(54) **IN-LINE OPERATION SYSTEM AND FLOW
PLAN FOR MANUFACTURING LIQUID
CRYSTAL DISPLAY****Publication Classification**(51) **Int. Cl.⁷** **G02F 1/13**(52) **U.S. Cl.** **349/187**(76) Inventors: **Lin Yen Hsiu**, Tainan Hsien (TW);
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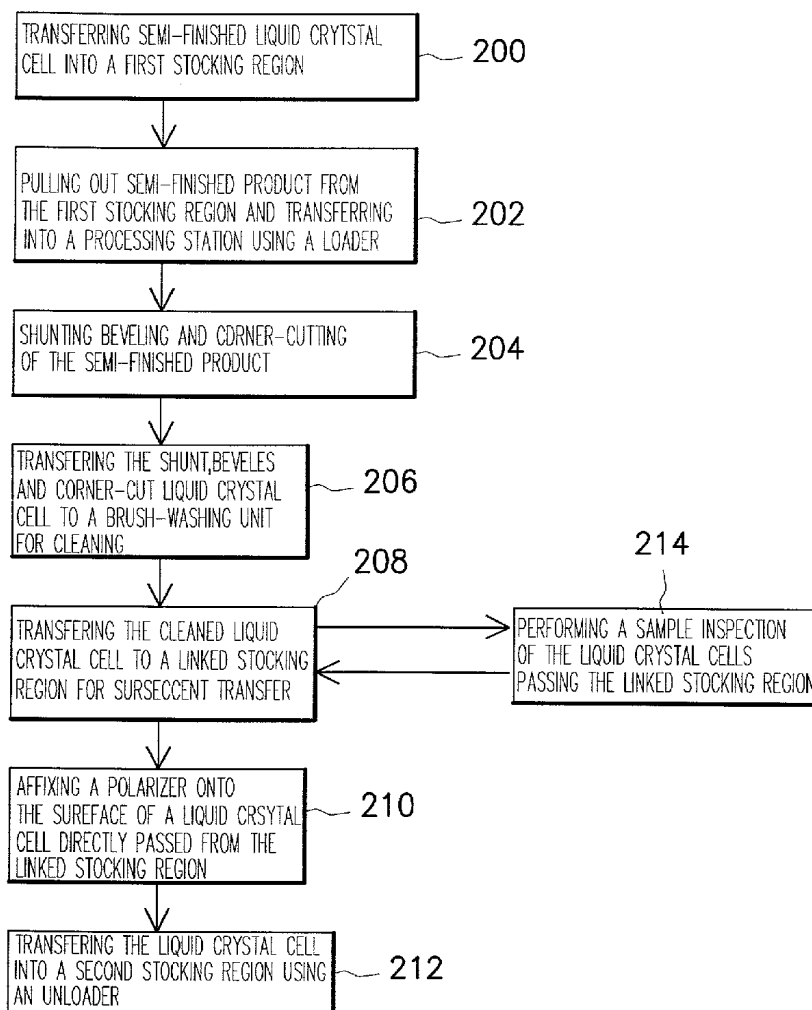
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Dec. 26, 2000 (TW)..... 89127829

(57) **ABSTRACT**

An in-line operation for manufacturing liquid crystal displays. First, a liquid crystal cell is pulled out from a first stocking region and placed inside a processing station by a loader. The liquid crystal cell is shunt, beveled and corner-cut by a shunt and bevel unit inside the processing station. The liquid crystal cell is next transferred directly to a brush-washing unit for cleaning. After cleaning, the semi-finished product is directly transferred from a linked stocking region to an affixing unit for attaching a polarizer onto the liquid crystal cell. The semi-finished product is transferred to a second stocking region by an unloader. Sample inspection can be carried out when the semi-finished product is still within the linked stocking region.



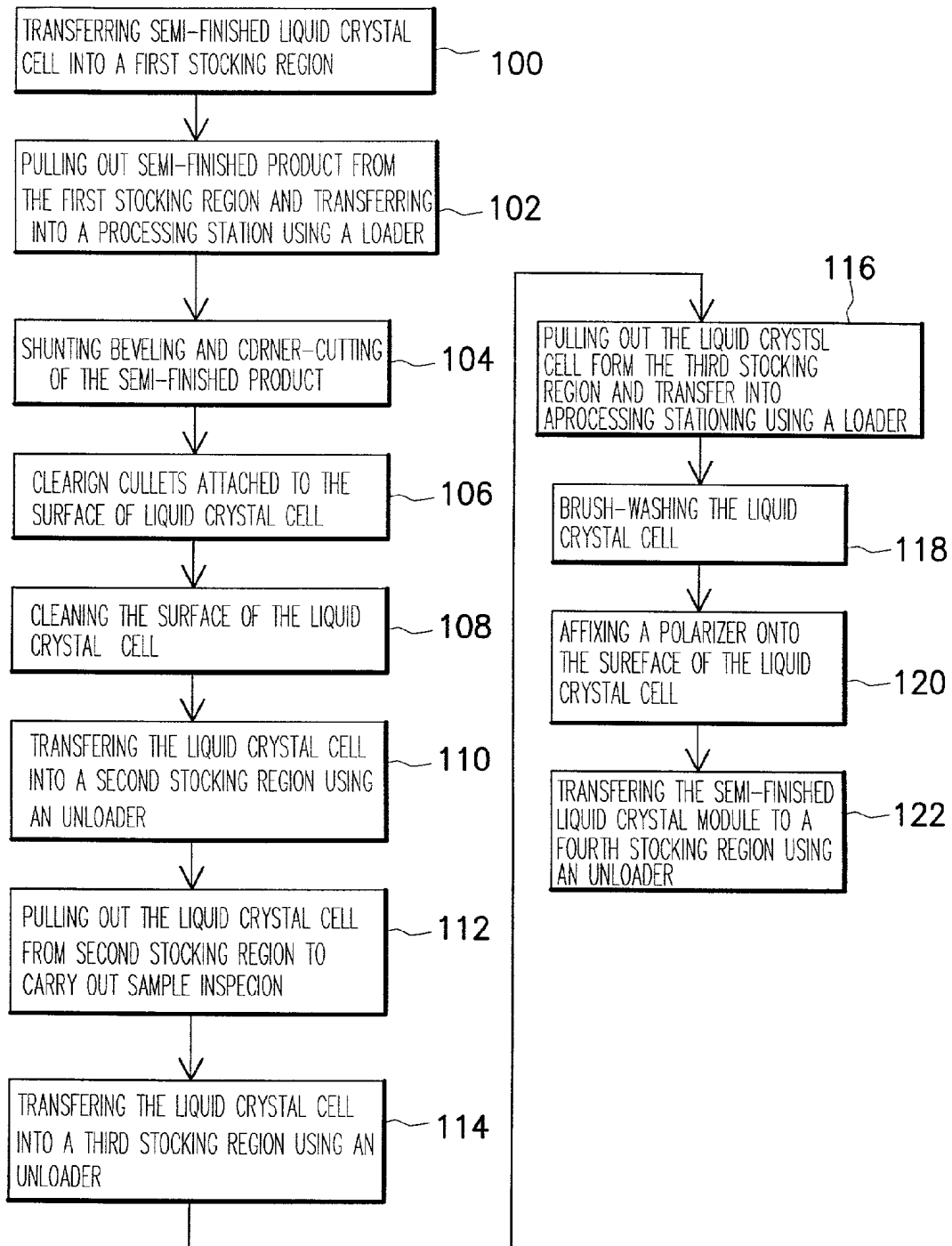


FIG. 1 (PRIOR ART)

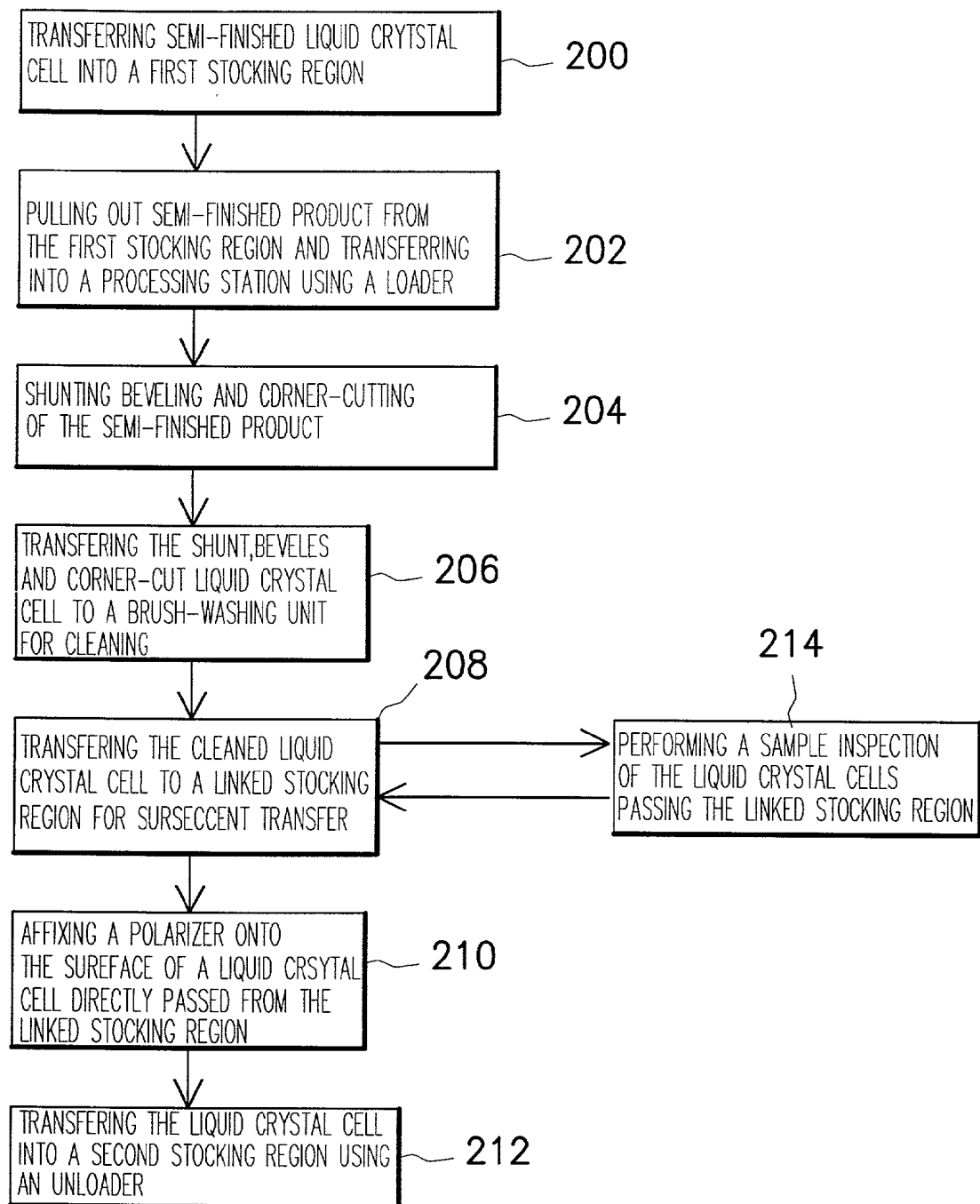


FIG. 2

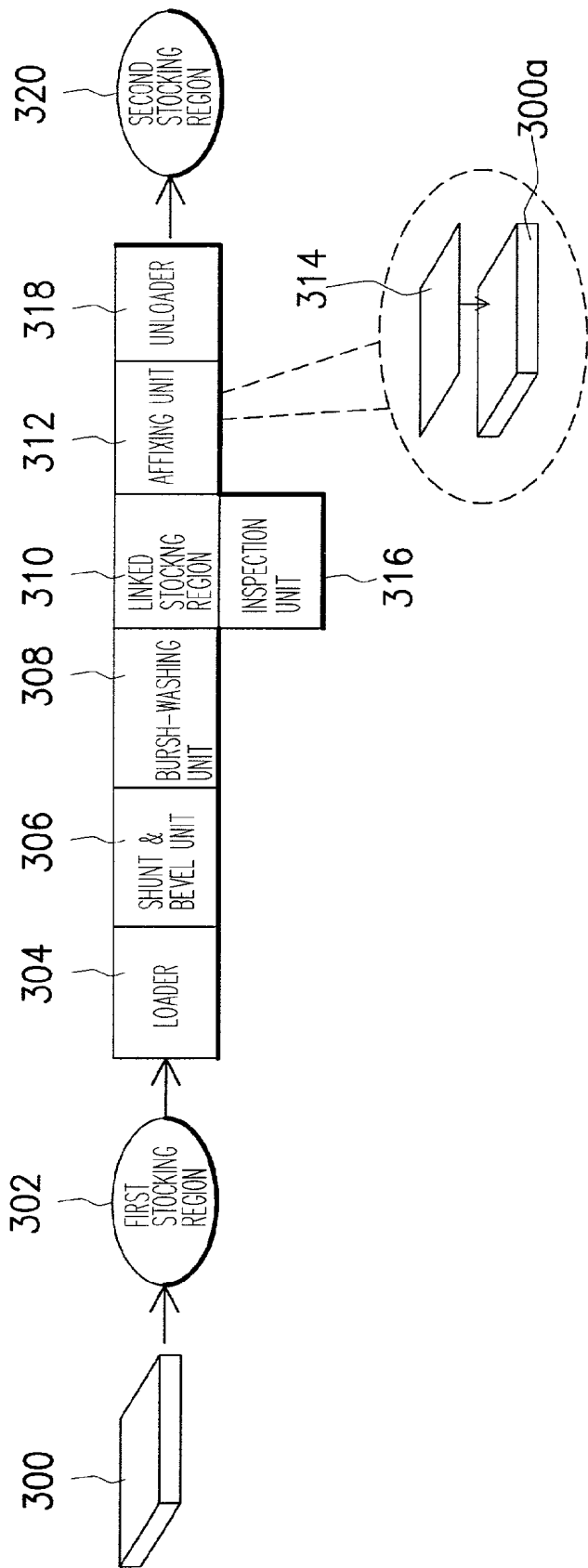


FIG. 3

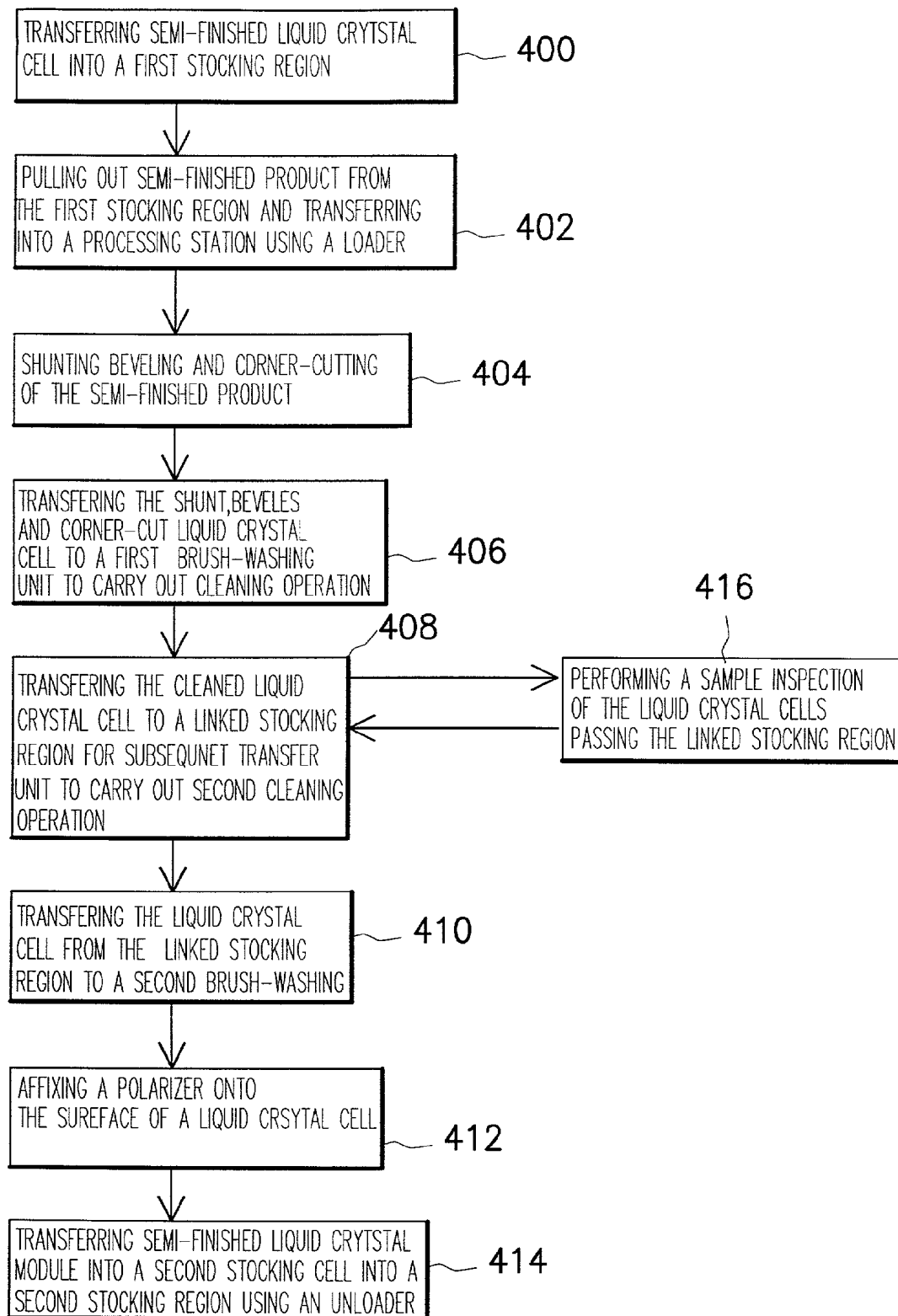


FIG. 4

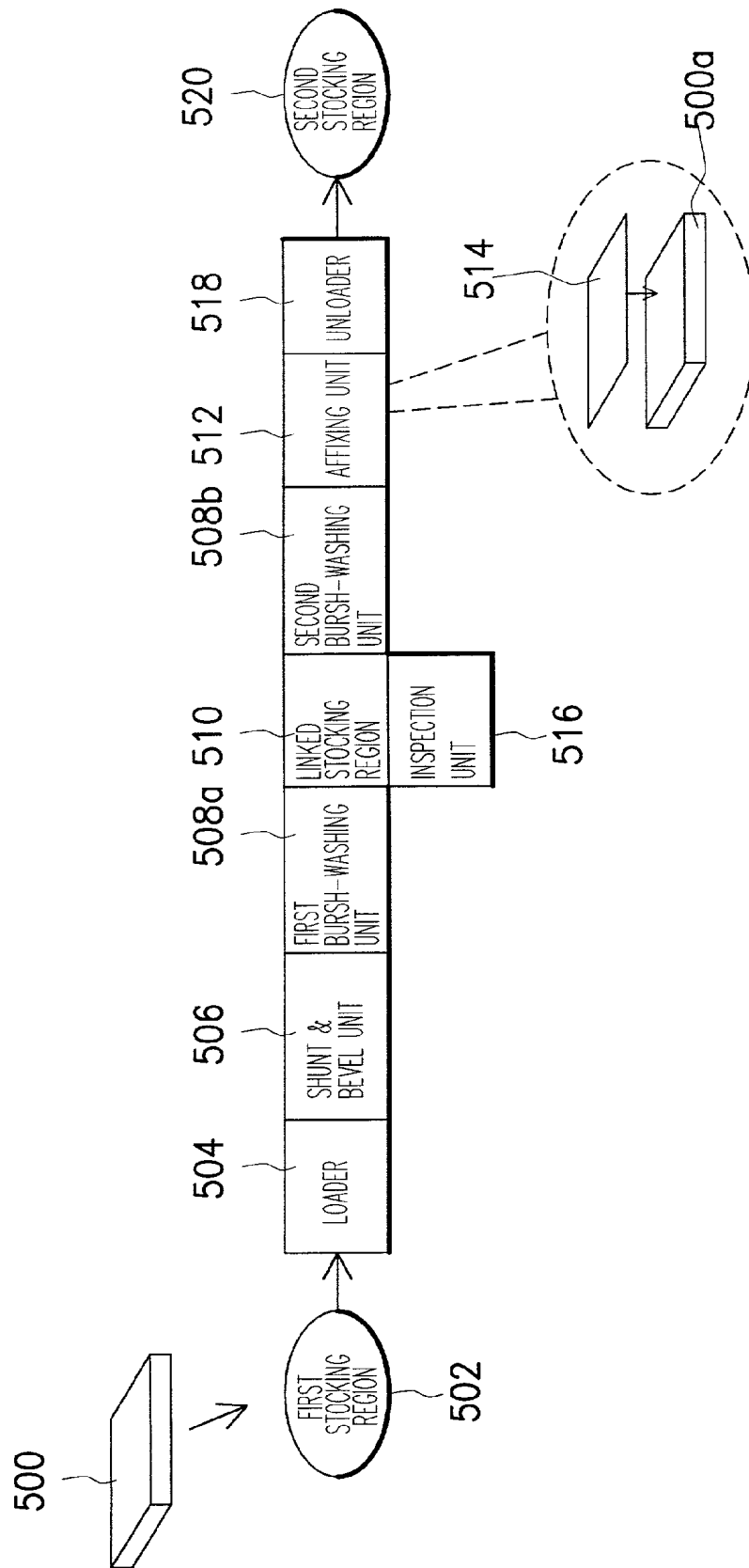


FIG. 5

IN-LINE OPERATION SYSTEM AND FLOW PLAN FOR MANUFACTURING LIQUID CRYSTAL DISPLAY

CROSS-REFERENCE TO RELATED APPLICATION

[0001] This application claims the priority benefit of Taiwan application serial no. 89127829, filed Dec. 26, 2000.

BACKGROUND OF THE INVENTION

[0002] 1. Field of Invention

[0003] The present invention relates to a method of manufacturing liquid crystal display (LCD). More particularly, the present invention relates to an in-line operation system and flow plan for manufacturing liquid crystal display.

[0004] 2. Description of Related Art

[0005] Liquid crystal display (LCD) is incorporated into a variety of consumer electronic and computer products such as portable televisions, mobile telephones, camcorders, notebook computers, desktop monitors and projection televisions. Major advantages of a LCD include its high-quality picture, light and streamline body, low voltage driver and low power consumption. Hence, LCD is gradually replacing cathode ray tube (CRT) as the preferred means of display.

[0006] The main body of a liquid crystal display is a liquid crystal unit consisting of two transparent panels and a layer of liquid crystal between the panels. At present, thin film transistor (TFT) is the dominant type of liquid crystal display. In general, the manufacturing of a TFT type LCD can be grouped into three stages: the production of the thin film transistor (TFT) array, the assembly of the liquid crystal cell and the fabrication of the liquid crystal module.

[0007] In the production of a TFT LCD, the production of a TFT array includes producing a thin film transistor panel. The assembly of the liquid crystal unit includes joining two thin film transistor panels together and injecting liquid crystal into the space between the panels to form a liquid crystal unit. The fabrication of the liquid crystal module includes attaching a polarizer to the liquid crystal display panel, connecting the circuit inside the liquid crystal display panel with a driver IC and installing of reflectors or back lights. Finally, burn-in testing is conducted after the module is formed.

[0008] At present, off-line operation is employed in the production of a liquid crystal display from liquid crystal cell assembly to liquid crystal module assembly. FIG. 1 is a flow chart showing the steps in a conventional off-line operation method for fabricating liquid crystal display from the assembly of liquid crystal cell to the assembly of liquid crystal module. As shown in step 100 of FIG. 1, the semi-finished product after liquid crystal is sealed in the space between liquid crystal panels is placed in a first stocking region. In step 102, the semi-finished product is pulled by a loader from the first stocking region. In step 104, the completely assembled liquid crystal cell is shunt-separated, beveled and corner-cut. In step 106, cullets that form due to the cutting, the beveling and the corner smoothing operations are removed. In step 108, the semi-finished is further cleaned by brush washing. In step 110, the semi-finished product is placed in a second stocking region using an unloader.

[0009] As shown in FIG. 1, the semi-finished product is pulled from the second stocking region in step 112 to perform a visual inspection after completing the steps for producing a liquid crystal cell. In step 114, the semi-finished product is placed in a third stocking region ready so that the semi-finished product can be pulled from the third stocking region when liquid crystal module needs to be fabricated. Hence, between the assembly of the liquid crystal cell and the assembly of the liquid crystal module, the semi-finished product is unloaded from the production line and stored in a stocking buffer, typical for an off-line operation.

[0010] To fabricate the liquid crystal module as shown in FIG. 1, the inspected liquid crystal display cell is pulled out from the third stocking region by a loader in step 116. In step 118, the liquid crystal cell is brush-washed to clean all the exposed surfaces. In step 120, a polarizer is affixed to the surface of the liquid crystal cell. In step 122, the semi-finished product is unloaded from the production line to a fourth stocking region ready for subsequent use.

[0011] However, because of the selection of off-line operation between the assembly of the liquid crystal cell and the assembly of liquid crystal module, a production line with a length of at least 50m to 60m is required.

SUMMARY OF THE INVENTION

[0012] Accordingly, one object of the present invention is to provide an in-line operation installation and flow plan that uses a linked stocking region to directly connect the assembly line for producing liquid crystal cell and the assembly line for producing liquid crystal module. By automating the transfer of semi-finished product between the two assembly lines, the number of stocking regions, processing machines and operators needed in the production line is reduced. By carrying out a single brush washing instead of a cullet cleaning and a brush washing operation, length of the production line can be reduced without affecting product yield. In addition, by linking an inspection cell with a connected stocking region, the semi-finished product can be inspected on line rather than off line in a full visual inspection. Without off line inspection, production time and area needed for production are reduced. Hence, product cycle is reduced, product yield is increased and production line administration is simplified.

[0013] This invention also provides an in-line operation for manufacturing liquid crystal displays. First, a liquid crystal cell is pulled out from a first stocking region and placed inside a processing station by a loader. The liquid crystal cell is shunt, beveled and corner-cut by a shunt and bevel unit inside the processing station. The liquid crystal cell is next transferred directly to a brush-washing unit for cleaning. After cleaning, the semi-finished product is directly transferred from a linked stocking region to an affixing unit for attaching a polarizer onto the liquid crystal cell. The semi-finished product is transferred to a second stocking region by an unloader. Sample inspection can be carried out when the semi-finished product is still within the linked stocking region. The inspected semi-finished product passing through the linked stocking region can be brush-washed a second time before transferring to the affixing unit for attaching a polarizer. The second brush-washing unit is inserted between the linked stocking region and the affixing unit.

[0014] In addition, this invention provides an in-line operation system that includes a stocking region for holding liquid crystal cell, a shunt and bevel unit, a brush-washing unit, a linked stocking region, an affixing unit, an inspection unit and a second stocking region for holding semi-finished liquid crystal module. The brush-washing unit, the inspection unit, the shunt and bevel unit, the linked stocking region are joined together. Furthermore, the shunt and bevel unit may include a directly attached loader while the affixing unit may include a directly attached unloader. A second brush-washing unit that joins up directly with the affixing unit and the linked stocking region may be added.

[0015] It is to be understood that both the foregoing general description and the following detailed description are exemplary, and are intended to provide further explanation of the invention as claimed.

BRIEF DESCRIPTION OF THE DRAWINGS

[0016] The accompanying drawings are included to provide a further understanding of the invention, and are incorporated in and constitute a part of this specification. The drawings illustrate embodiments of the invention and, together with the description, serve to explain the principles of the invention. In the drawings, **FIG. 1** is a flow chart showing the steps in a conventional off-line operation for fabricating liquid crystal display from the assembly of liquid crystal cell to the assembly of liquid crystal module;

[0017] **FIG. 2** is a flow chart showing the steps in an on-line operation for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and liquid crystal module according to a first preferred embodiment of this invention, **FIG. 3** is a schematic diagram showing an on-line operation system for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and liquid crystal module according to the first preferred embodiment of this invention;

[0018] **FIG. 4** is a flow chart showing the steps in an on-line operation for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and liquid crystal module according to a second preferred embodiment of this invention; and

[0019] **FIG. 5** is a schematic diagram showing an on-line operation system for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and liquid crystal module according to the second preferred embodiment of this invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0020] Reference will now be made in detail to the present preferred embodiments of the invention, examples of which are illustrated in the accompanying drawings. Wherever possible, the same reference numbers are used in the drawings and the description to refer to the same or like parts.

[0021] **FIG. 2** is a flow chart showing the steps in an on-line operation for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and liquid crystal module according to a first preferred embodiment of this invention. **FIG. 3** is a schematic diagram showing an on-line operation system for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and

liquid crystal module according to the first preferred embodiment of this invention.

[0022] In this invention, some of the steps for assembling a liquid crystal cell are similar to the conventional technique. When the liquid crystal is sealed inside liquid crystal display panels, fabrication of the liquid crystal cell is considered complete. As shown in **FIGS. 2 and 3**, a liquid crystal cell **300** is placed into a first stocking region **302** in step **200**. To carry out subsequent processing, the liquid crystal cell **300** is pulled out from the first stocking region **302**. The first stocking region **302**, for example, can be the interior of an automatic stocking machine.

[0023] In step **202**, a loader **304** is used to pull out the semi-finished liquid crystal cell **300** from the first stocking region **302**. In step **204**, the semi-finished liquid crystal cell **300** is transferred by the loader **304** into a shunting and beveling unit **306**. Inside the shunting and beveling unit **306**, the liquid crystal cell **300** is shunt, beveled and corner-cut. The shunt and bevel unit **306** and the loader **304** are directly joined together.

[0024] In step **206**, the shunt, beveled and corner-cut semi-finished liquid crystal cell is transferred directly from the shunt and bevel unit **306** to a brush-washing unit **308**. Any cullets formed on the liquid crystal cell inside the shunt and bevel unit **306** are cleared away. The brush-washing unit **308** and the shunt and bevel unit **306** are directly joined together. This invention uses a single brush-washing step **206** to replace the conventional method of performing a cullet-cleaning in step **106** and performing a brush washing in step **108** as shown in **FIG. 1**. Hence, one cullet-cleaning step is saved. In step **208**, the brush-washed semi-finished product is directly transferred from the brush-washing unit **308** to a linked stocking region **310**. From the linked stocking region **310**, the semi-finished product is distributed to other processing unit. The linked stocking region **310** and the brush-washing unit **308** are directly joined together. In addition, the interior of the linked stocking region **310** has clean-room control facilities.

[0025] In step **210**, the liquid crystal cell is directly transferred from the linked stocking region **310** to an affixing unit **312**. Inside the affixing unit **312**, a polarizer **314** is attached to one of the liquid crystal cell surface **300a** to carry out liquid crystal module assembly. The affixing unit **312** and the linked stocking region **310** are directly joined together.

[0026] One major aspect of this invention is the joining of the brush-washing unit with the affixing unit through the linked stocking region. Hence, the liquid crystal cell assembly line and the liquid crystal module assembly line are merged together. Consequently, the brush-cleaned semi-finished products can be directly transferred from the brush-washing unit to the affixing unit. The automatic transfer of semi-finished product between the liquid crystal cell assembly line and the liquid crystal module assembly line is what constitutes the in-line operation method according to this invention.

[0027] In addition, the linked stocking region **310** and an inspection unit **316** are directly joined together as shown in **FIG. 3**. A sample inspection such as a visual check of the semi-finished liquid crystal display can be carried out in the inspection unit **316** in step **214**. Any product containing

defects is removed from the production line for further treatment or rework. After treatment or rework, the semi-finished product can be returned to the inspection unit **316**. After proper inspection in the inspection unit **316**, the semi-finished product is transferred to the linked stocking region **310** to continue with the remaining processing steps. Furthermore, if there are errors in any one of the processing steps, the semi-finished products on the production line can be removed from the linked stocking region **310**. When the cause of error is removed, the reworked semi-finished product can be returned to the linked stocking region **310** so that the remaining operations can be carried out.

[0028] In step **212**, the polarizer affixed semi-finished product is pulled out from the affixing unit **312** and transferred to a second stocking region **320** by an unloader **318**. The unloader **318** and the affixing unit **312** are directly joined together. The second stocking region **320** is a stocking region for semi-finished products. For example, the second stocking region **320** can be an automatic stocking machine.

[0029] FIG. 4 is a flow chart showing the steps in an on-line operation for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and liquid crystal module according to a second preferred embodiment of this invention. FIG. 5 is a schematic diagram showing an on-line operation system for fabricating liquid crystal display by integrating the assembly of liquid crystal cell and liquid crystal module according to the second preferred embodiment of this invention.

[0030] In the second embodiment of this invention, a portion of the steps in the liquid crystal cell assembly and liquid crystal module assembly is identical to the first embodiment. When the liquid crystal is sealed inside liquid crystal display panels, fabrication of the liquid crystal cell is considered complete. As shown in FIGS. 4 and 5, a liquid crystal cell **500** is placed into a first stocking region **502** in step **400**. To carry out subsequent processing, the liquid crystal cell **500** is pulled out from the first stocking region **502**. The first stocking region **502**, for example, can be the interior of an automatic stocking machine. In step **402**, a loader **504** is used to pull out the semi-finished liquid crystal cell **500** from the first stocking region **502**. In step **404**, the semi-finished liquid crystal cell **500** is transferred by the loader **504** into a shunting and beveling unit **506**. Inside the shunting and beveling unit **506**, the liquid crystal cell **500** is shunt, beveled and corner-cut. The shunt and bevel unit **506** and the loader **504** are directly joined together.

[0031] In step **406**, the shunt, beveled and corner-cut semi-finished liquid crystal cell is transferred directly from the shunt and bevel unit **506** to a first brush-washing unit **508a**.

[0032] Any cullets formed on the liquid crystal cell inside the shunt and bevel unit **506** are cleared away. The first brush-washing unit **508a** and the shunt and bevel unit **506** are directly joined together. In this embodiment, a single brush-washing step is used instead of the conventional method of performing cullet-cleaning brush washing as shown in FIG. 1 to save one cullet-cleaning step. In step **408**, the brush-washed semi-finished product is directly transferred from the first brush-washing unit **508a** to a linked stocking region **510**. From the linked stocking region **510**, the semi-finished product is distributed to other pro-

cessing unit. The linked stocking region **510** and the first brush-washing unit **508a** are directly joined together. In addition, the interior of the linked stocking region **510** has clean-room control facilities.

[0033] In step **410**, the liquid crystal cell is directly transferred from the linked stocking region **510** to a second brush-washing unit **508b**. Inside the second brush-washing unit **508b**, surface of the liquid crystal cell is thoroughly cleansed. The second brush-washing unit **508b**, similar to the first brush-washing unit **508a**, is directly joined with the linked stocking region **510**. Similar to the first embodiment, the liquid crystal cell assembly line and the liquid crystal module assembly line are integrated together through the joining of the first brush-washing unit, the linked stocking region and the second brush-washing unit. The automatic transfer of semi-finished product between the liquid crystal cell assembly line and the liquid crystal module assembly line is what constitutes the in-line operation method according to this invention.

[0034] In step **412**, the cleaned liquid crystal cell is directly transferred from the second brush-washing unit **508b** to an affixing unit **512**. Inside the affixing unit **512**, a polarizer **514** is attached to one of the liquid crystal cell surface **500a** to carry out liquid crystal module assembly. The affixing unit **512** and the second brush-washing unit **508b** are directly joined together.

[0035] Similar to the first embodiment, the linked stocking region **510** and an inspection unit **516** are directly joined together as shown in FIG. 3. A sample inspection such as a visual check of the semi-finished liquid crystal display can be carried out in the inspection unit **516** in step **416**. Any product containing defects is removed from the production line for further treatment or rework. After treatment or rework, the semi-finished product can be returned to the inspection unit **516**. After proper inspection in the inspection unit **516**, the semi-finished product is transferred to the linked stocking region **510** to continue with the remaining processing steps.

[0036] In step **414**, the polarizer affixed semi-finished product is pulled out from the affixing unit **512** and transferred to a second stocking region **520** by an unloader **518**. The unloader **518** and the affixing unit **512** are directly joined together. The second stocking region **520** is a stocking region for semi-finished products. For example, the second stocking region **520** can be an automatic stocking machine.

[0037] According to the embodiment of this invention, the advantages of this invention can be summarized as follows:

[0038] 1. The in-line operation of this invention uses a linked stocking region to integrate the liquid crystal cell assembly line and the liquid crystal module assembly line together. Hence, semi-finished products can be automatically transferred between the two assembly lines, thereby saving a few automatic stocking machines, a number of loaders and unloaders for off-line operation, operators and hence reducing equipment and production cost.

[0039] 2. This invention not only uses the linked stocking region to join the liquid crystal cell assembly line and the liquid crystal module assembly line, but also uses a single brush-washing step instead of

separate cullet-cleaning and brush-washing step. Therefore, a cullet-cleaning machine is saved without affecting product quality. Since overall length of the production line is somewhere between 25m to 30m, the cost of investment, production management, production cycle is reduced.

[0040] 3. By joining the linked stocking region with an inspection cell, the semi-finished product passing the linked stocking region can be visually inspected without having to provide space and time for off-line inspection. Thus, production cost is reduced and product yield is increased.

[0041] It will be apparent to those skilled in the art that various modifications and variations can be made to the structure of the present invention without departing from the scope or spirit of the invention. In view of the foregoing, it is intended that the present invention cover modifications and variations of this invention provided they fall within the scope of the following claims and their equivalents.

What is claimed is:

1. An in-line operation for fabricating liquid crystal display, comprising the steps of:

pulling a liquid crystal cell from a stocking region;

transferring the liquid crystal cell to a shunt and bevel unit for carrying out shunting, beveling and corner-cutting operation;

transferring the liquid crystal cell to a brush-washing unit that joins directly with the shunt and bevel unit for brush-cleaning;

transferring the liquid crystal cell to a linked stocking region that joins directly with the brush-washing unit and then transferring the liquid crystal cell from the linked stocking region to an affixing unit that joins directly with the linked stocking region; and

attaching a polarizer onto a surface of the liquid crystal cell.

2. The in-line operation of claim 1, wherein the step of pulling out a liquid crystal cell from the stocking region includes using a loader.

3. The in-line operation of claim 1, wherein the step of transferring the liquid crystal cell into the linked stocking region further includes performing a sample inspection of the liquid crystal cell.

4. The in-line operation of claim 1, wherein after the step of transferring the liquid crystal cell into the linked stocking region but before attaching a polarizer inside the affixing unit, further includes cleaning the attach surface of the liquid crystal cell.

5. The in-line operation of claim 1, wherein after the step of attaching a polarizer onto the surface of a liquid crystal cell, further includes transferring the liquid crystal cell into a semi-finished product stocking region.

6. The in-line operation of claim 5, wherein the step of transferring the liquid crystal cell into the semi-finished product stocking region includes using an unloader.

7. An in-line operation system for fabrication liquid crystal display, comprising:

a loader for pulling out a plurality of liquid crystal cells from a first stocking region;

a shunt and bevel unit joined directly with the loader for shunting, beveling and corner-cutting each liquid crystal cell;

a brush-washing unit joined directly with the shunt and bevel unit for brush-cleaning each liquid crystal cell;

a linked stocking region joined directly with the brush-washing unit for transferring each liquid crystal cell;

an affixing unit joined directly with the linked stocking region for attaching a plurality of polarizers onto the respective surface of each liquid crystal cell; and

an unloader joined directly with the affixing unit for transferring the polarizer-attached liquid crystal cell to a second stocking region.

8. The in-line operation system of claim 7, wherein the system further includes an inspection unit joined directly with the linked stocking region for inspecting the passing liquid crystal cell.

9. An in-line operation system for fabricating a liquid crystal display, comprising:

a loader for pulling out a plurality of liquid crystal cells from a first stocking region;

a shunt and bevel unit joined directly with the loader for shunting, beveling and corner-cutting each liquid crystal cell;

a first brush-washing unit joined directly with the shunt and bevel unit for brush-cleaning each passing liquid crystal cell;

a linked stocking region joined directly with the first brush-washing unit for transferring each liquid crystal cell;

a second brush-washing unit joined directly with the linked stocking region for brush-cleaning each passing liquid crystal cell;

an affixing unit joined directly with the second brush-washing unit for attaching a plurality of polarizers onto the respective surface of each liquid crystal cell; and

an unloader joined directly with the affixing unit for transferring the polarizer-attached liquid crystal cell to a second stocking region.

10. The in-line operation system of claim 9, wherein the system further includes an inspection unit joined directly with the linked stocking region for inspecting the passing liquid crystal cell.

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专利名称(译)	用于制造液晶显示器的在线操作系统和流程图		
公开(公告)号	US20020080322A1	公开(公告)日	2002-06-27
申请号	US09/776959	申请日	2001-02-06
[标]申请(专利权)人(译)	阿秀LIN YEN MIKIYASU ISHII		
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发明人	HSIU, LIN YEN MIKIYASU, ISHII		
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优先权	089127829 2000-12-26 TW		
其他公开文献	US6498637		
外部链接	Espacenet USPTO		

摘要(译)

用于制造液晶显示器的在线操作。首先，从第一储存区域拉出液晶单元，并通过装载机将液晶单元放置在处理站内。液晶单元通过处理站内的分流器和斜面单元进行分流，斜切和切角。接下来将液晶盒直接转移到刷洗单元进行清洁。在清洁之后，将半成品直接从连接的储存区域转移到固定单元，以将偏振器附着到液晶单元上。通过卸载器将半成品转移到第二储存区域。当半成品仍在链接的库存区域内时，可以进行样品检查。

