

SONY

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Working Instructions

- mechanical -



Xperia™ Z2 Tablet

SGP511,SGP512,SGP521,SGP541,SGP551,SGP561

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5.24 Holder Relay LCD BtB..... 99

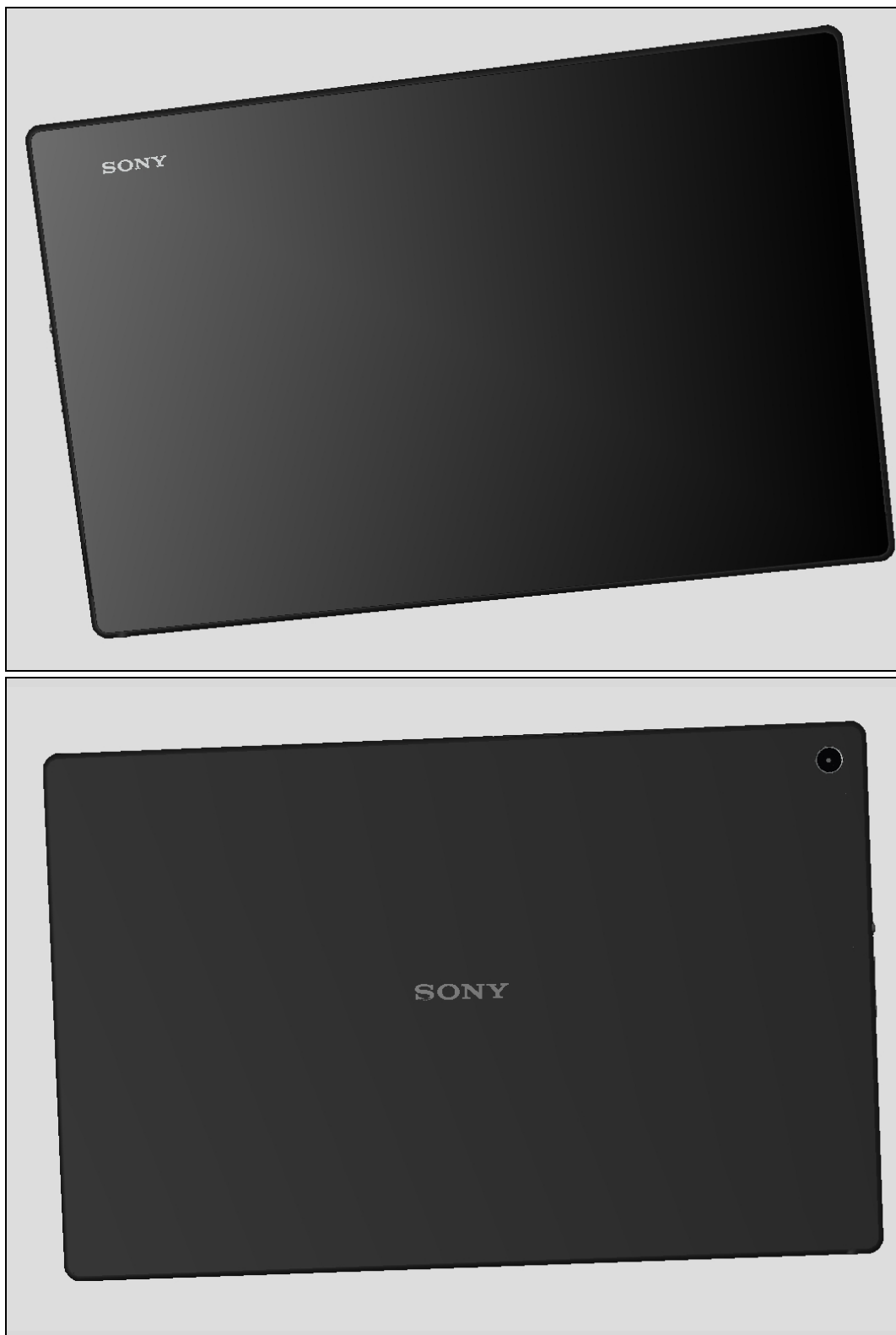
5.25 Display Assembly RoW 99

6 Revision History 104

*For general information about mechanical repair related issues, refer to
1220-1333: Generic Repair Manual - mechanical*

1 Exterior Views

1.1 SGP511,SGP512,SGP521,SGP541,SGP551,SGP561



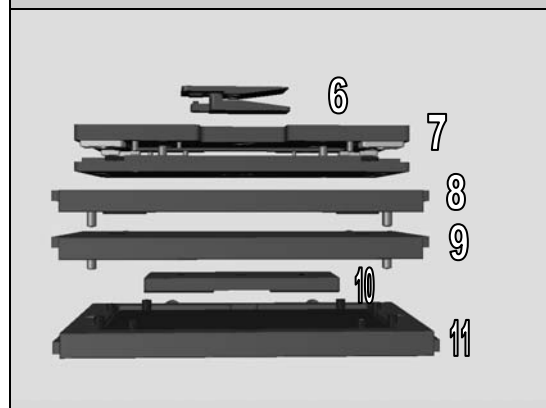
2 Tools

SPECIAL TOOLS

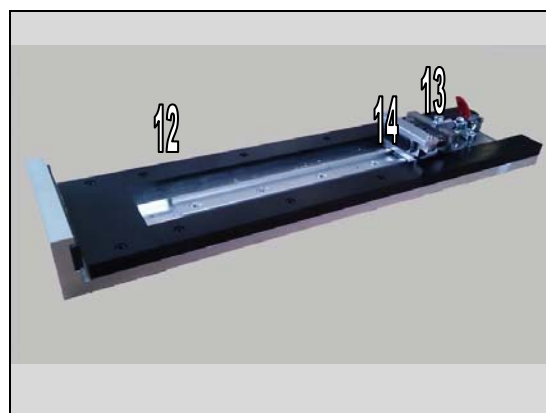
1. Torque Screwdriver
2. Front Opening Tool
3. Bits (JCIS No 0)
4. Flex Film Assembly Tool
5. Guitar Pick



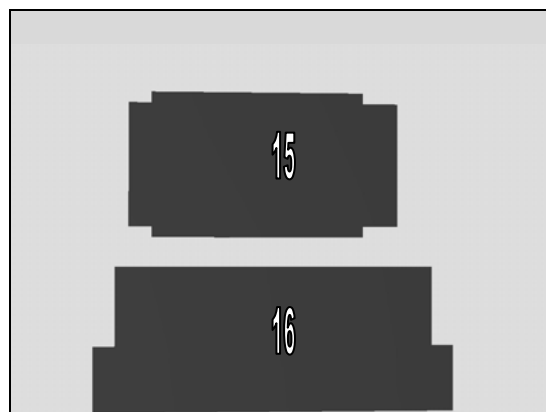
6. Press Tool Loudspeaker
7. Display Adhesive alignment Fixture
8. Display Press Top Inlay Edge
9. Display Press Top Inlay Corner
10. Battery Press Top Inlay
11. Bottom Press Inlay



12. Side Panel press
13. Side Panel Press Head
14. Side Panel Press Pad or Charge connector press pad



15. Sheet Disassembly_A
16. Sheet Disassembly_B



For part no on the tools above, refer to the 'Tools Catalogue/Matrix'!

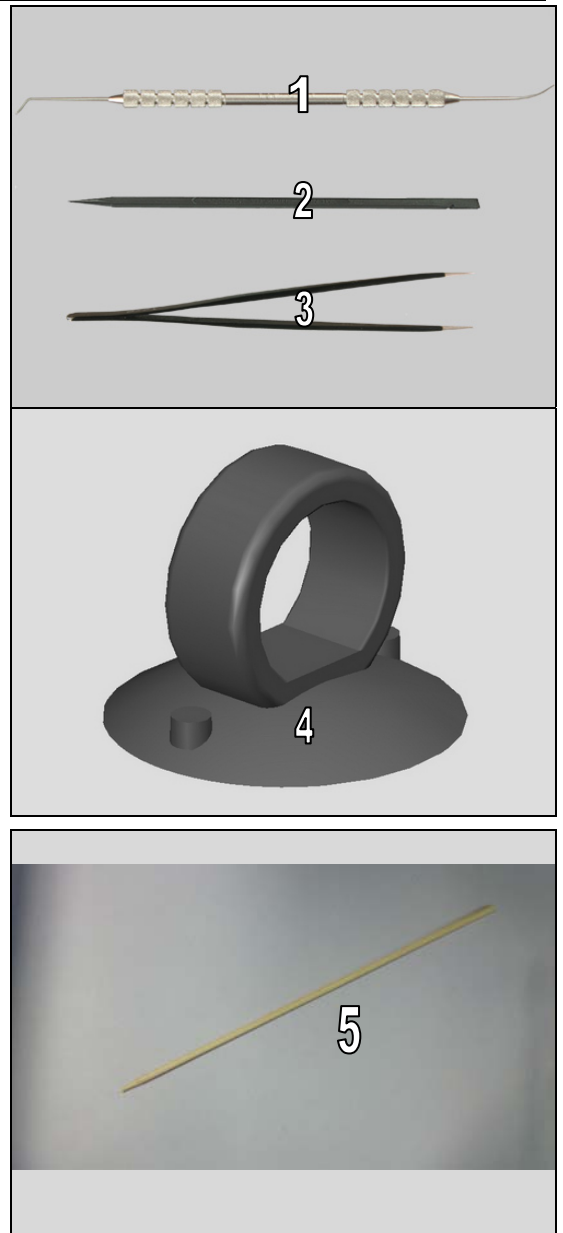
Tools

STANDARD TOOLS

1. Dentist Hook
2. Nylon Pointer
3. Tweezer

4. Suction cup

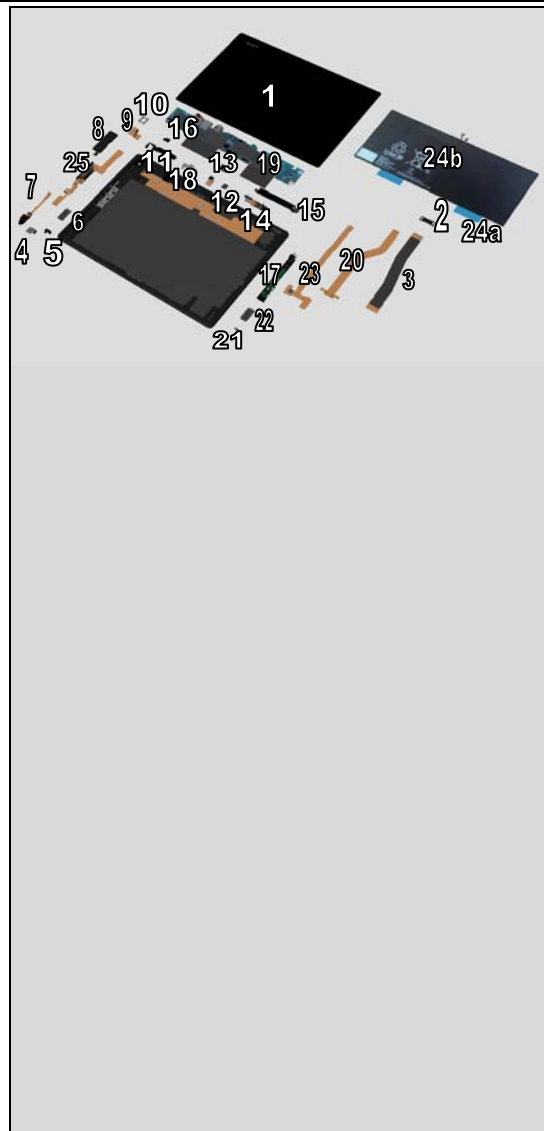
5. Bamboo Skewer



3 Disassembly

The Disassembly is done to the following modules:

1. Display Assembly RoW
2. Holder LCD Relay BtB
3. Relay LCD Flex
4. Plate Audio Jack
5. Holder Audio Jack
6. Cap SP Assembly (Left)
7. Audio Jack Flex
8. NFC antenna
9. Camera 8 MPixel
10. Holder Main CAM
11. BT + WLAN + GPS Antenna
12. Sheet Chat CAM
13. Camera 2 MPixel
14. Sensor Flex
15. Main Antenna
16. Holder PBA Screw
17. Carrier Frame Sub PBA
18. Plate USB
19. Main PBA
20. Magnetic charger flex
21. Cushion SPK R
22. Cap SP Assembly (Right)
23. SP Flex
24. Adhesive Battery (a) and Battery (b)
25. Key Flex module

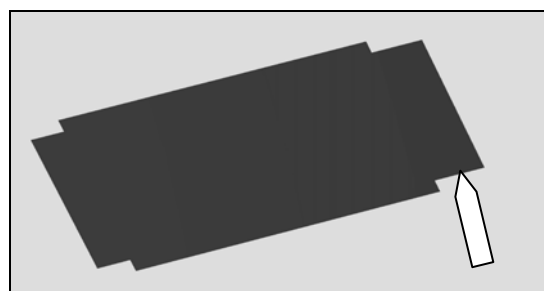
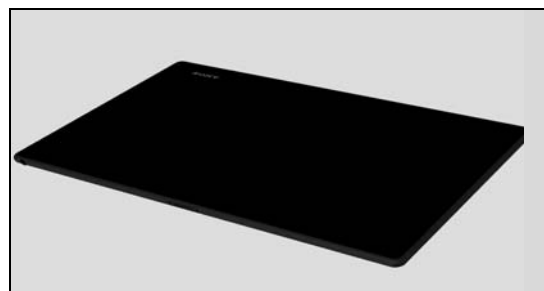


3.1 Display Assembly RoW

Warning! Use ESD Gloves with rubber and Safety Glasses when disassembly Display Assembly RoW.

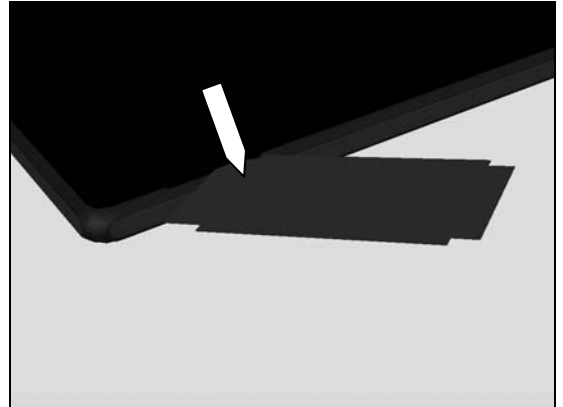
Use Sheet Disassembly_A when disassembly Display Assembly RoW.

Note! Start by using the side that have longer target.

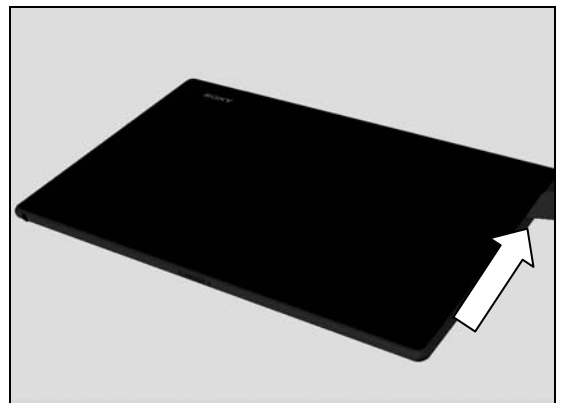


Disassembly

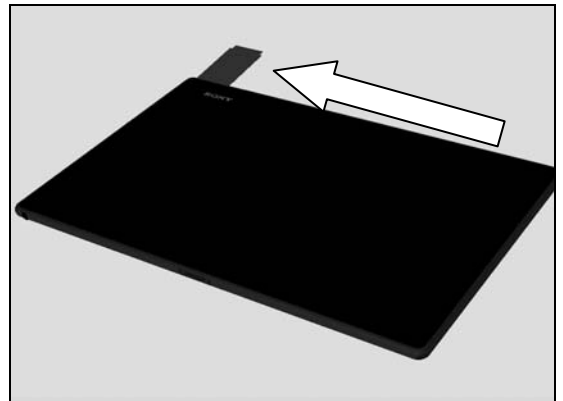
Start disassembly from the Speaker hole right



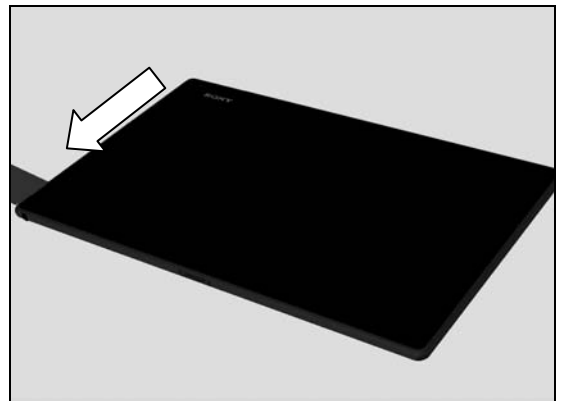
Use Sheet Disassembly_A and gently slide along the side



Slide along the top long side.

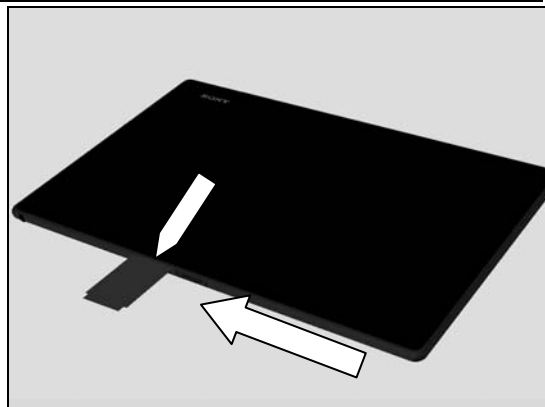


Left short side

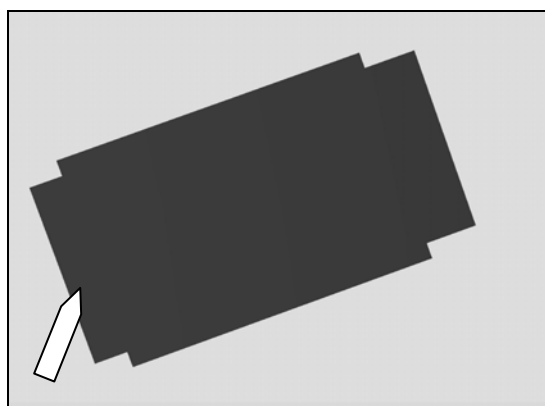


Disassembly

Then start from right bottom side and slide along bottom long side.
Note! Stop exactly where the Sheet Disassembly_A is positioned in the picture.

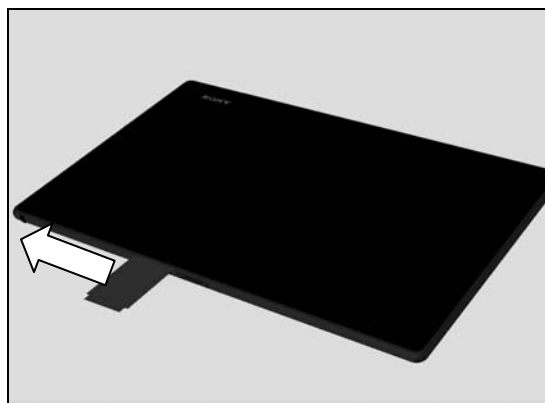


Use opposite side of the Sheet Disassembly_A.



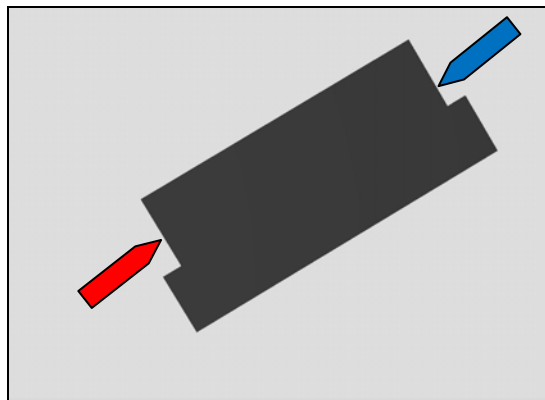
Finish bottom long side

Note! Use the short target of Sheet Disassembly_A



Use Sheet Disassembly_B

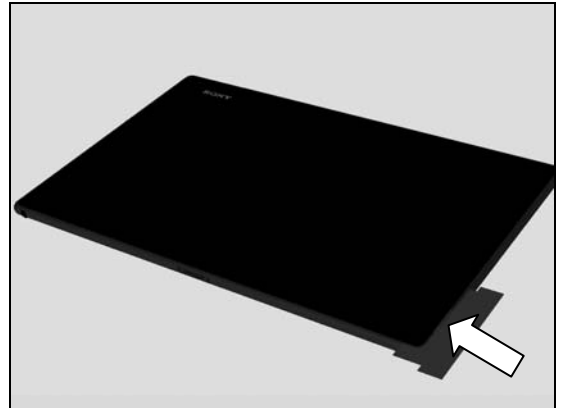
Note! Two side one longer target(Blue arrow) and one shorter target(Red arrow)



Disassembly

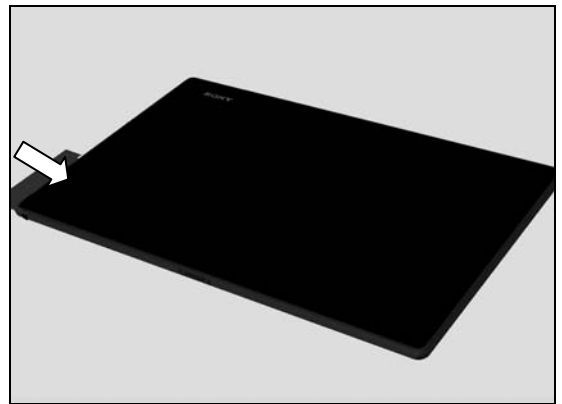
Insert the Sheet Disassembly_B bottom right side.

Note! Use the longer target of Sheet Disassembly_B

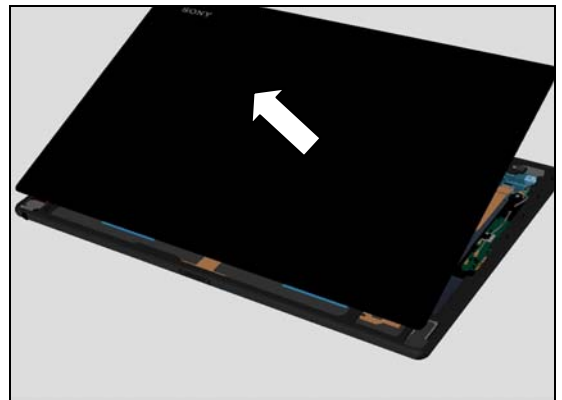


Insert the Sheet Disassembly_B bottom left side.

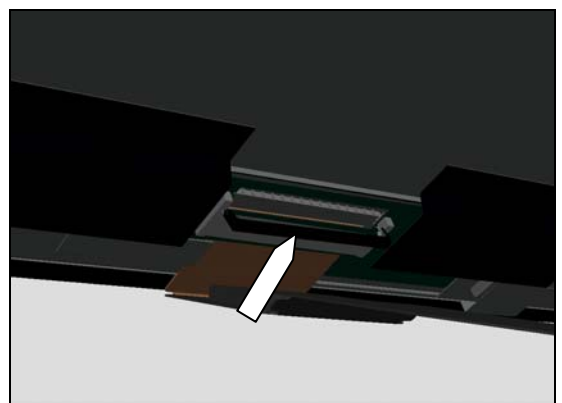
Note! Use the shorter target of Sheet Disassembly_B



Remove the Display Assembly RoW by hand in the direction of the arrow in the picture.

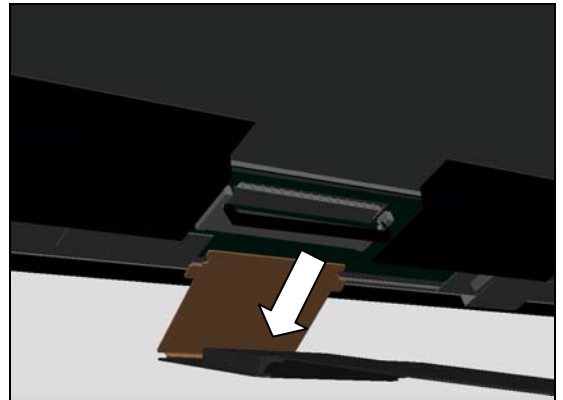


Use Flex Film Assembly Tool to disconnect Relay LCD Flex

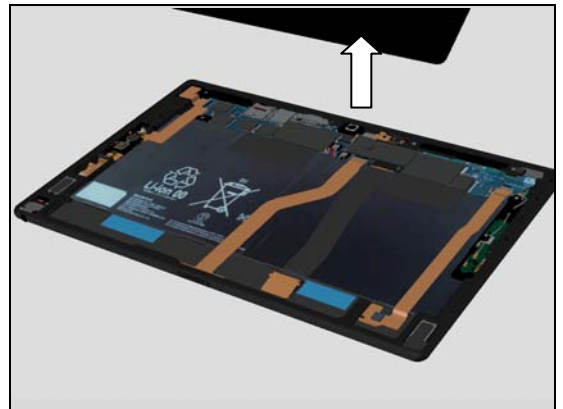


Disassembly

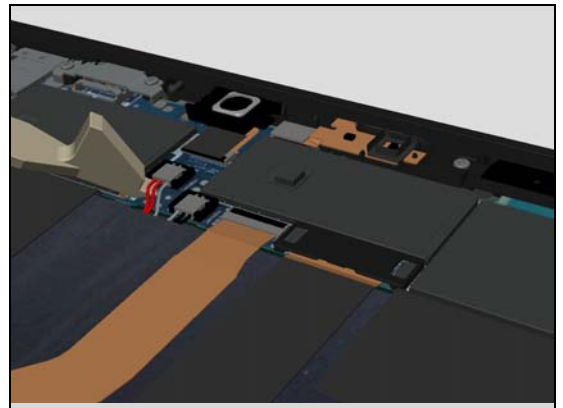
Remove the flex from ZIF connector



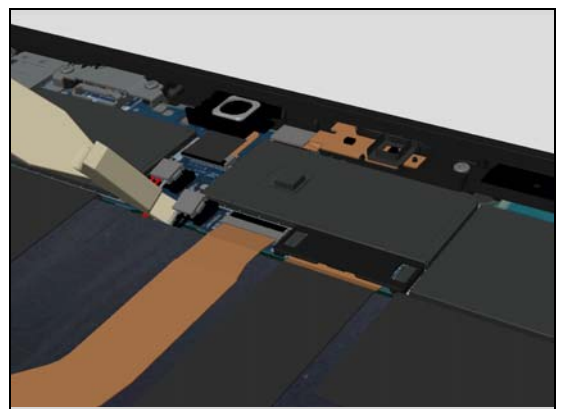
Lift up the Display Assembly RoW gently



Use Front Opening Tool to disconnect battery connector 1



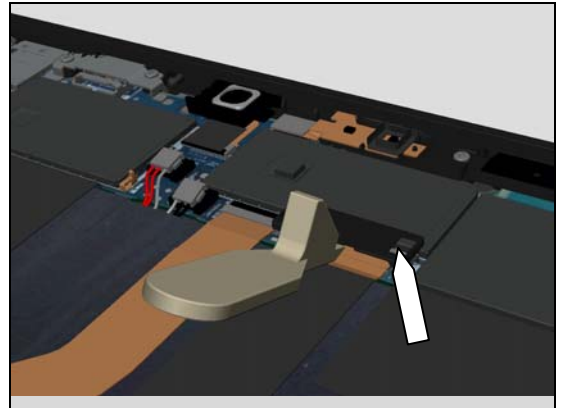
Use Front Opening Tool to disconnect battery connector 2



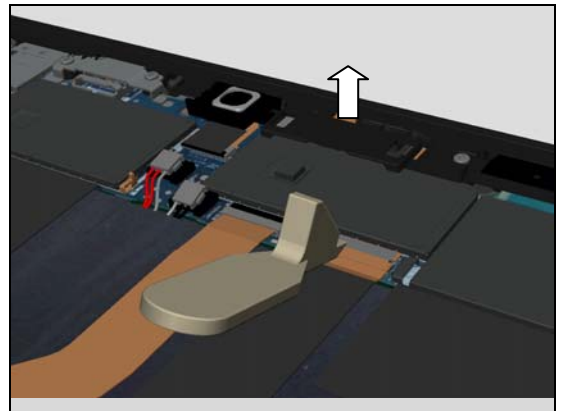
Disassembly

3.2 Holder LCD Relay BtB

Use Front Opening Tool to disconnect Holder LCD Relay BtB

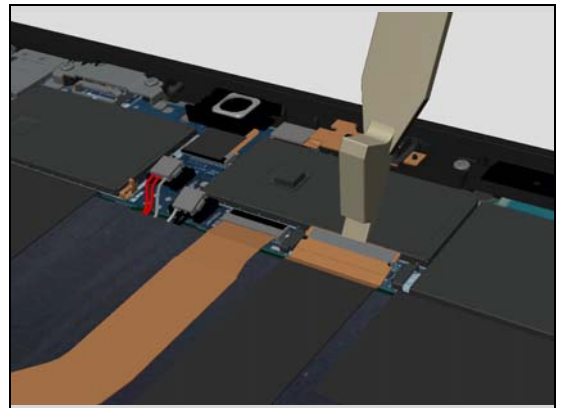


Remove Holder LCD Relay BtB with fingers



3.3 Relay LCD Flex

Use a Front Opening Tool to disconnect the BtB connector.



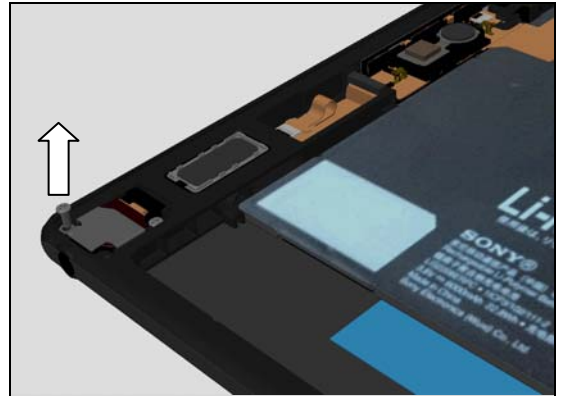
Remove the Relay LCD Flex



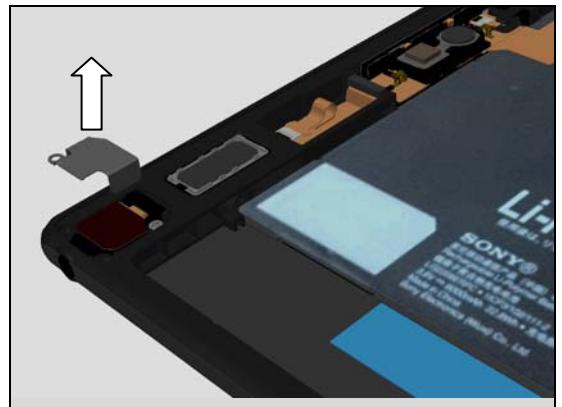
Disassembly

3.4 Plate Audio Jack

Remove the Screw 1.4X3.5 by using a screwdriver with Bits (JCIS No 0).

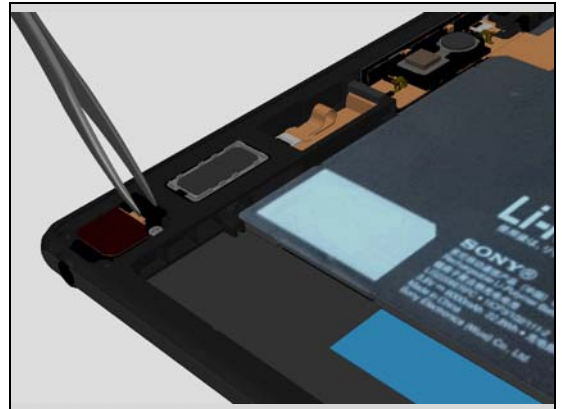


Remove the Plate Audio Jack with fingers

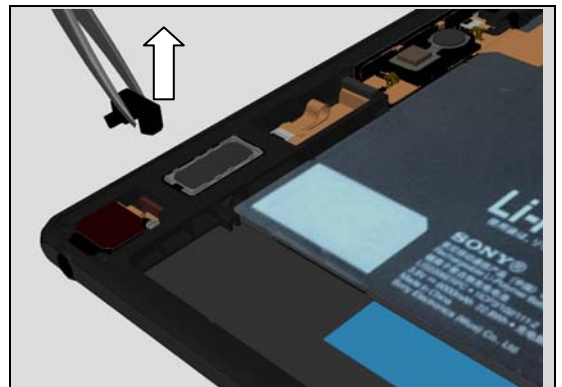


3.5 Holder Audio Jack

Use a pair of tweezers to remove the Holder Audio Jack.



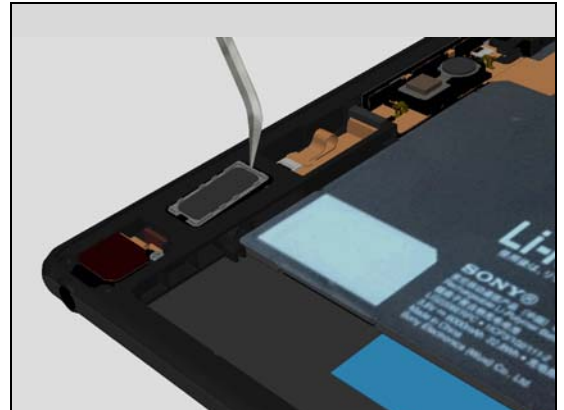
Remove the Holder Audio Jack with a pair of tweezers.



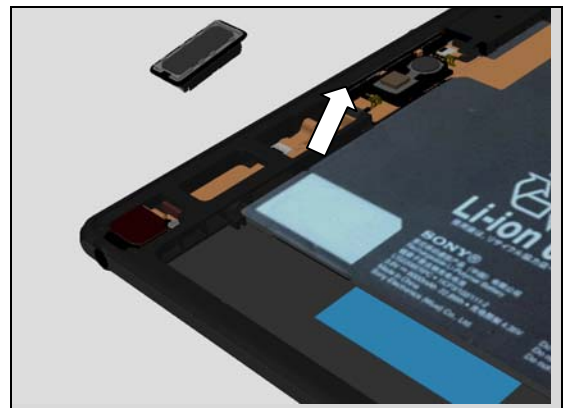
Disassembly

3.6 Cap SP Assembly (Left)

Use a dentist hook to detach the Cap SP Assembly.

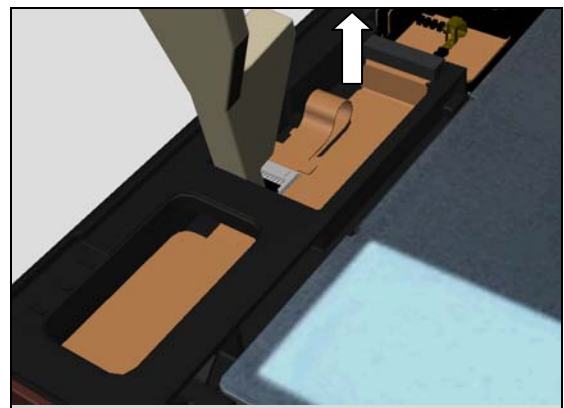


Remove the Cap SP Assembly with fingers



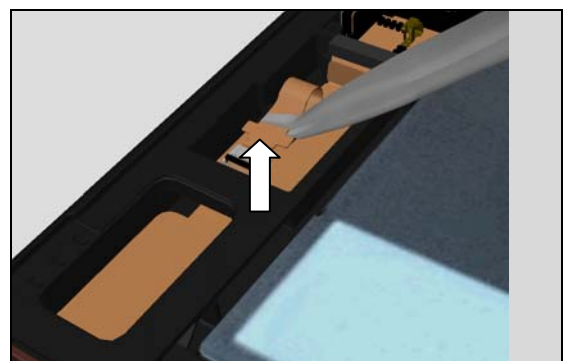
3.7 Audio Jack Flex

Use a Front Opening Tool to open the ZIF connector



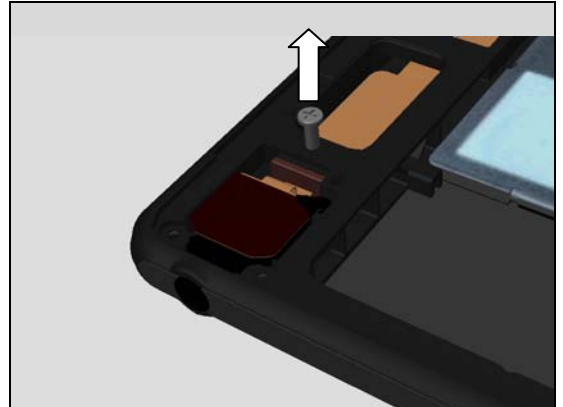
Insert the Flex Film Assembly Tool to release Audio Jack Flex.

Note! When removing Audio Jack Flex be careful not to damage connector or flex

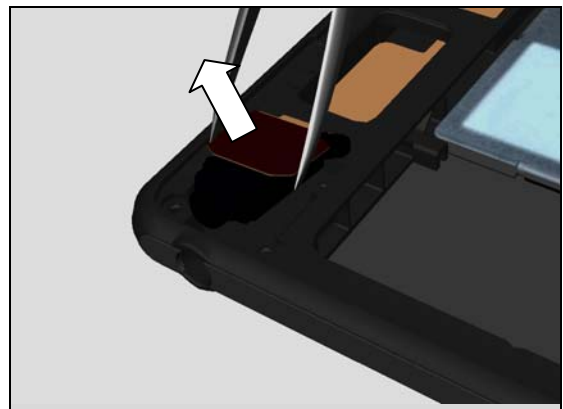
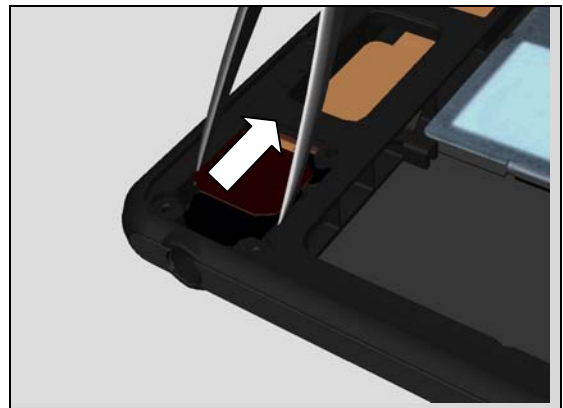


Disassembly

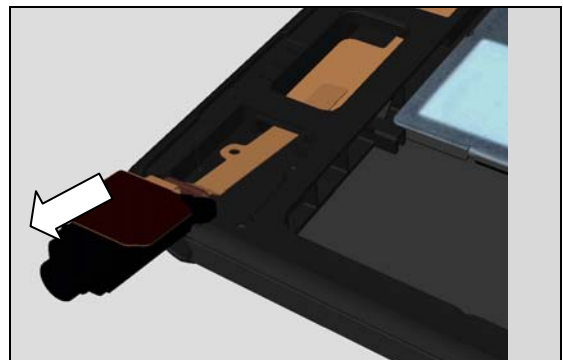
Remove the Screw 1.4X3.5 by using a screwdriver with Bits (JCIS No 0).



Remove the Audio Jack Flex with a pair of tweezers.



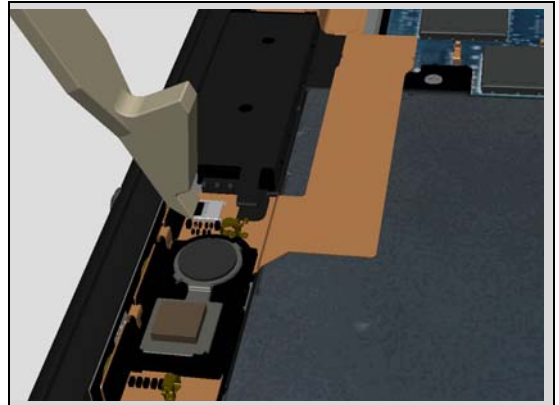
Caution not to damage the flex when removing it



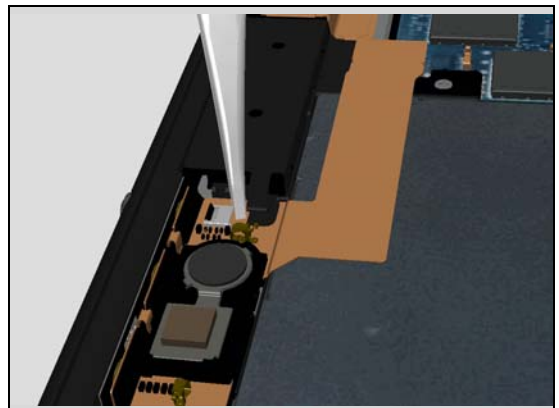
Disassembly

3.8 NFC antenna

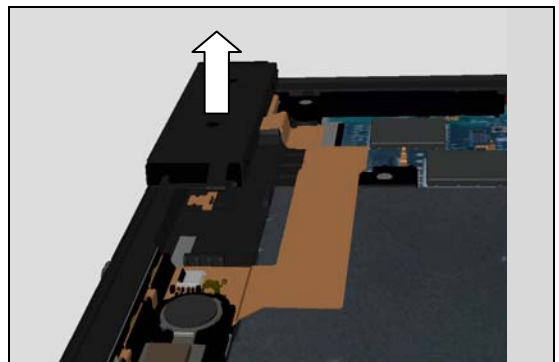
Use a Front Opening Tool to open the ZIF connector.



Remove the flex with a Flex Film Assembly Tool.

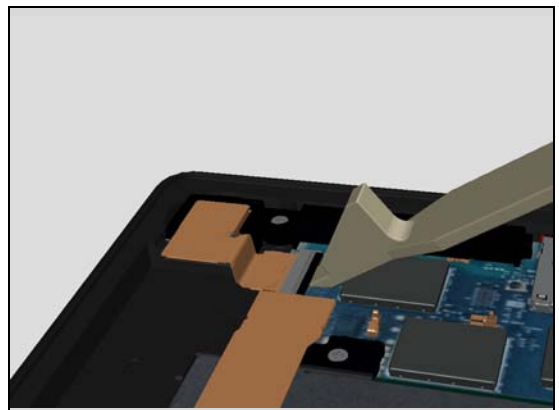


Remove the NFC antenna with fingers



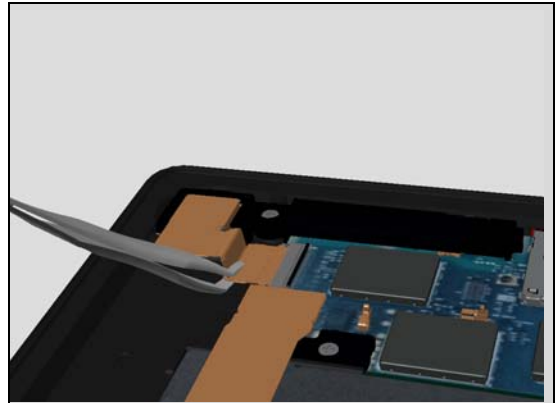
3.9 Camera 8 MPixel

Use a Front Opening Tool to disconnect the BtB connector.

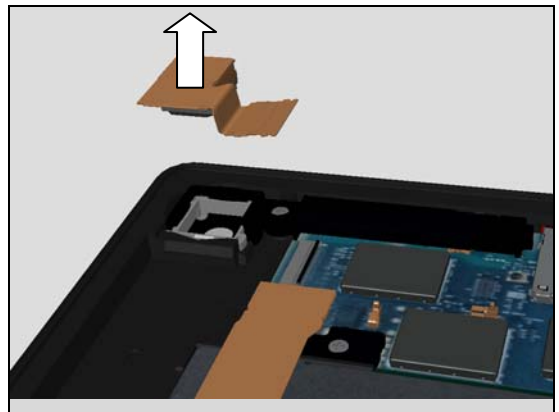


Disassembly

Remove the flex with a Flex Film Assembly Tool.

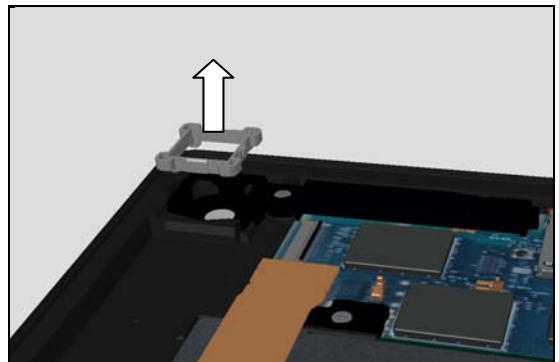


Remove the Camera 8 MPixel with fingers.



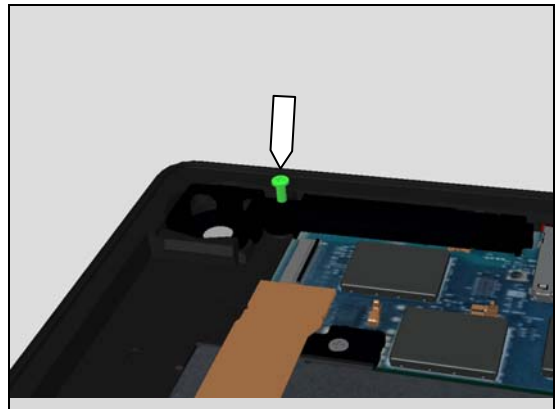
3.10 Holder Main CAM

Remove the Holder Main CAM with fingers.



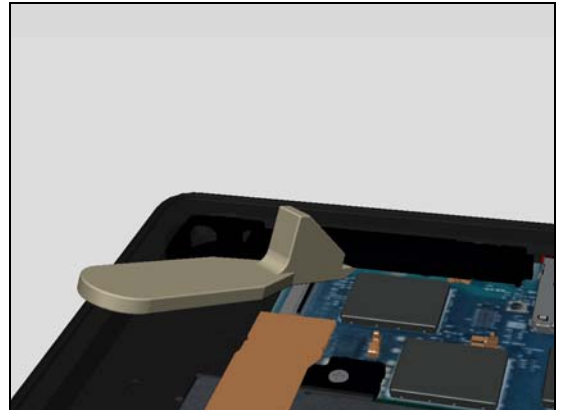
3.11 BT + WLAN +GPS Antenna

Remove the Screw M1.4X3.0 by using a screwdriver with Bits (JCIS No 0).

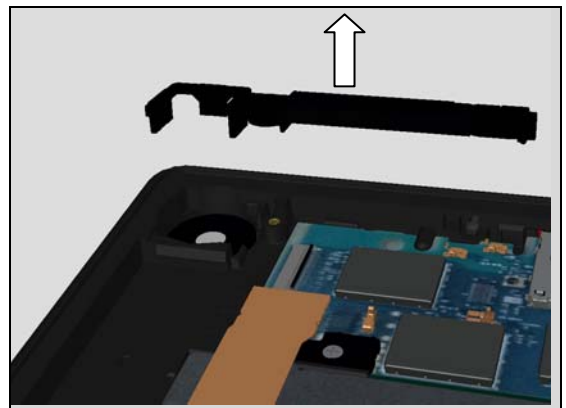


Disassembly

Use Front Opening Tool to detach the BT + WLAN + GPS Antenna



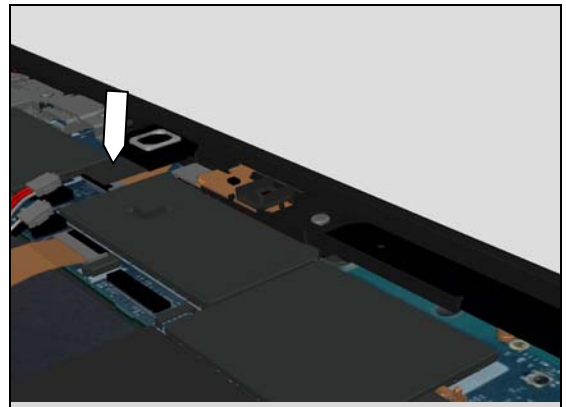
Remove the BT + WLAN + GPS Antenna with fingers



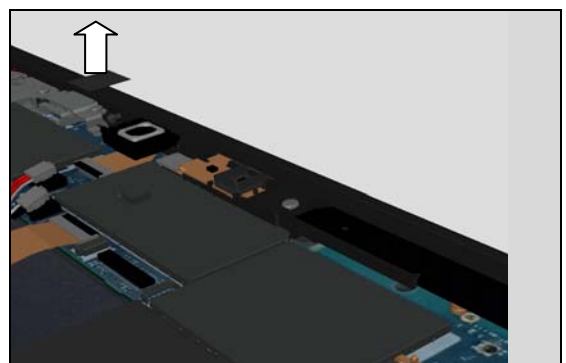
3.12 Sheet Chat CAM

Insert the Flex Film Assembly Tool to release Sheet Chat CAM.

Note! When removing Sheet Chat CAM be careful not to damage connector or flex



Remove the Sheet Chat CAM



Disassembly

3.13 Camera 2 MPixel

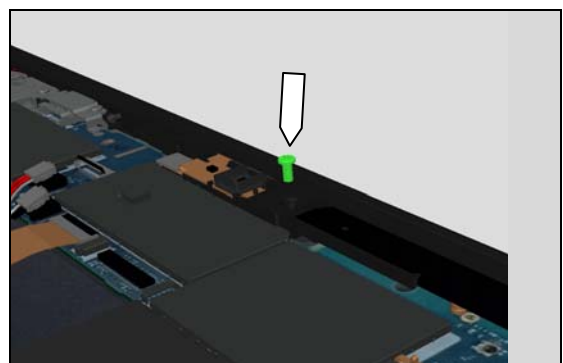
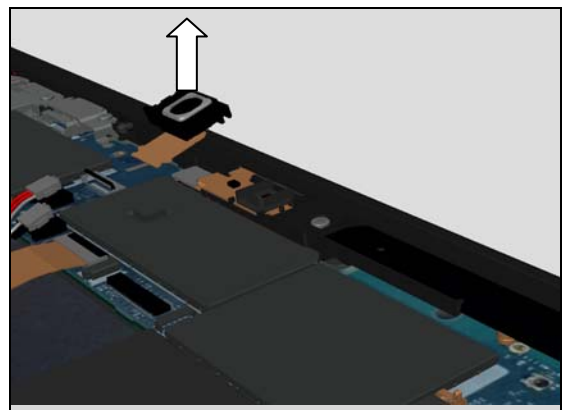
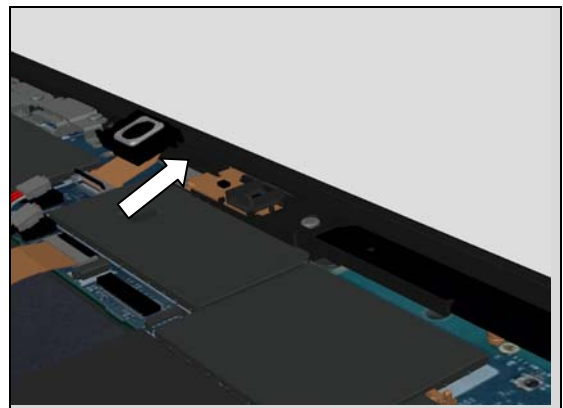
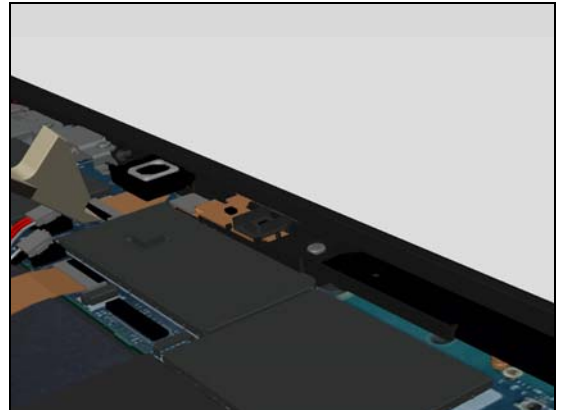
Use a Front Opening Tool to open ZIF connector.

Release the flex from the ZIF connector

Remove the Camera 2 MPixel with fingers

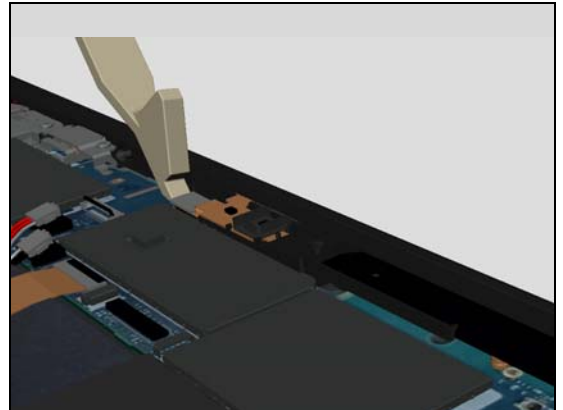
3.14 Sensor Flex

Remove the Screw M1.4X3.0 by using a screwdriver with Bits (JCIS No 0).

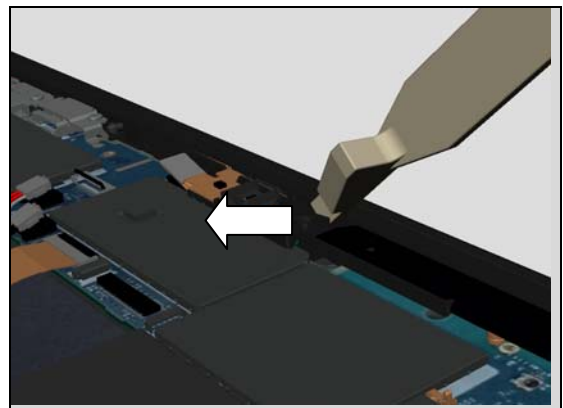


Disassembly

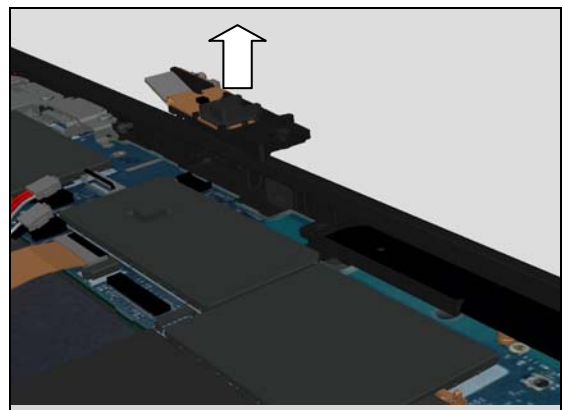
Use a Front Opening Tool to disconnect the BtB connector.



Use a Front Opening Tool to detach the Sensor Flex.

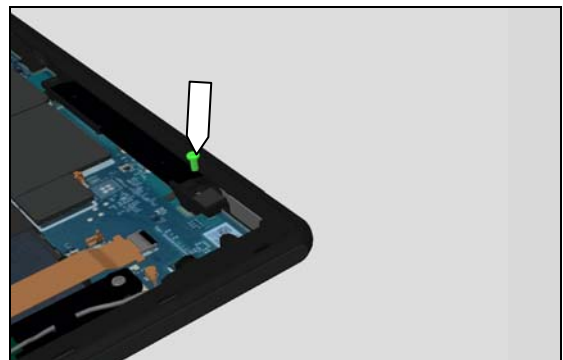


Remove the Sensor Flex with fingers.



3.15 Main Antenna

Remove the Screw M1.4X3.0 by using a screwdriver with Bits (JCIS No 0).

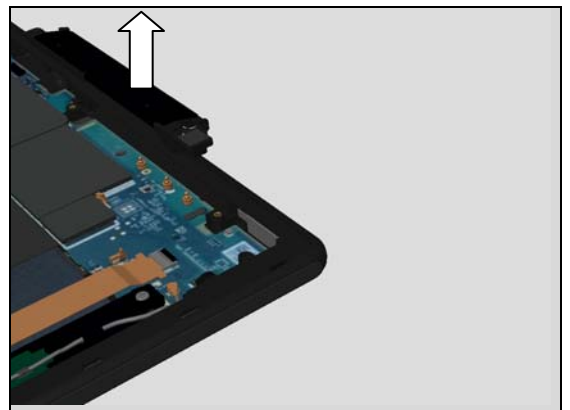


Disassembly

Use fingers to detach the Main Antenna.

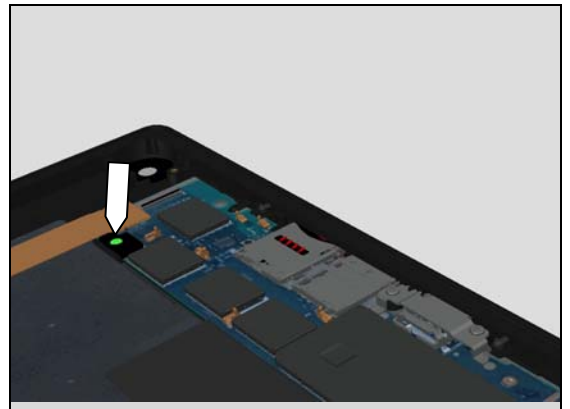


Remove Main Antenna with fingers.

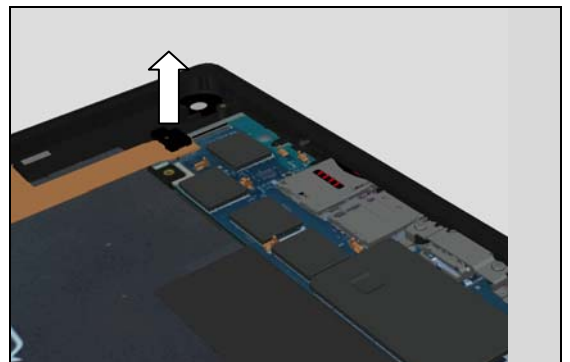


3.16 Holder PBA Screw

Remove the Screw Other Len:1.8 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).



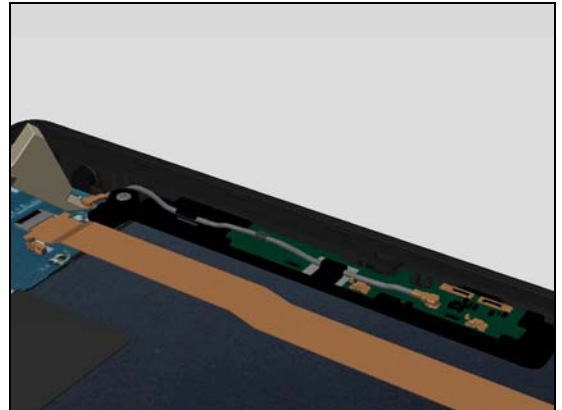
Remove the Holder PBA Screw with a pair of tweezers



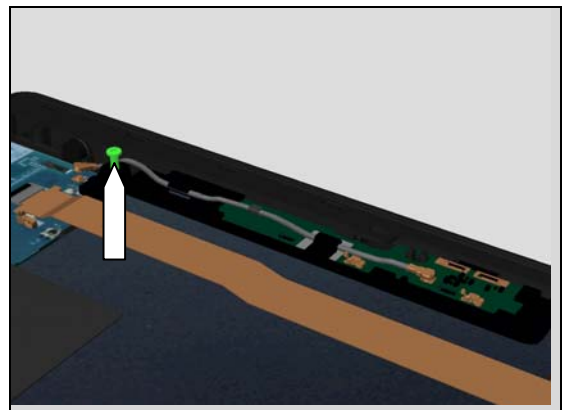
Disassembly

3.17 Carrier Frame Sub PBA

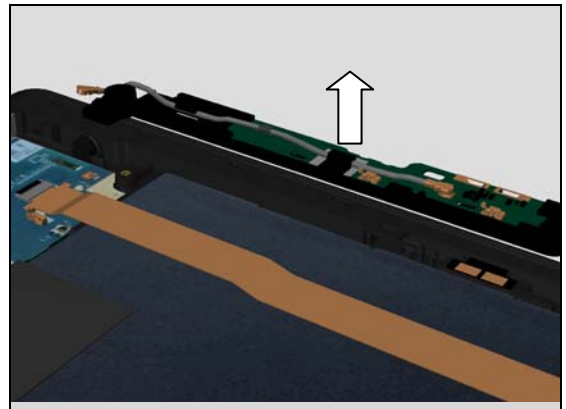
Use a Front Opening Tool to disconnect the RF Cable connector



Remove the Screw M1.4X3.0 by using a screwdriver with Bits (JCIS No 0).



Remove the Carrier Frame Sub PBA with fingers.



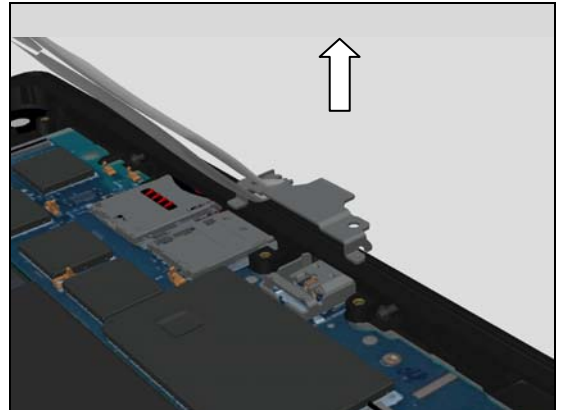
3.18 Plate USB

Remove the Screw M1.4X3.0 by using a screwdriver with Bits (JCIS No 0).



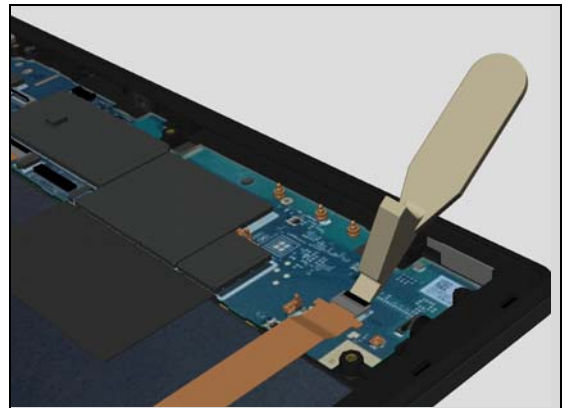
Disassembly

Remove the Plate USB with a pair of tweezers.

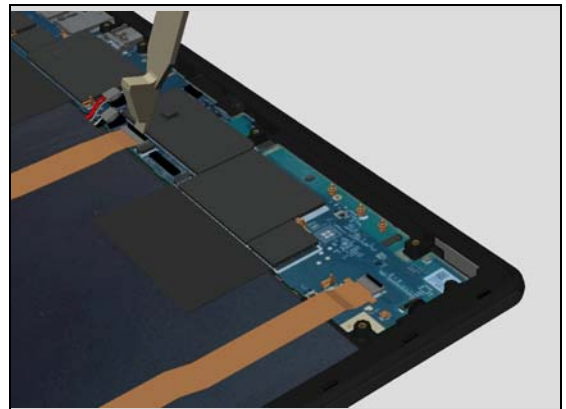


3.19 Main PBA

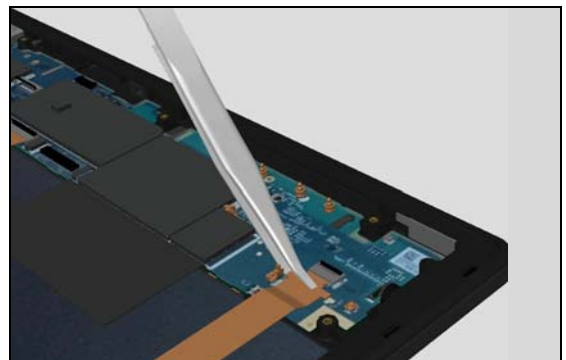
Use a Front Opening Tool to open the ZIF connector for SP Flex



Use a Front Opening Tool to open the ZIF connector for Magnet charger flex.

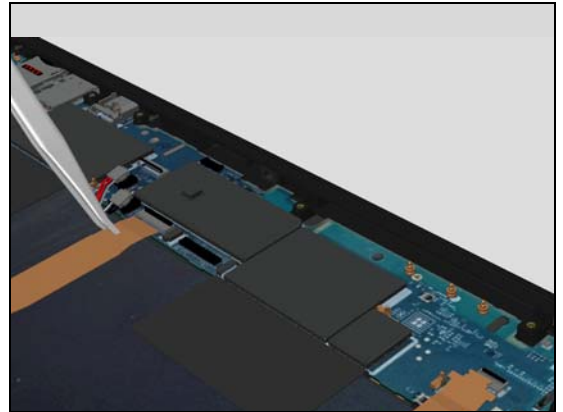


Remove SP Flex from connector with a Flex Film Assembly Tool.

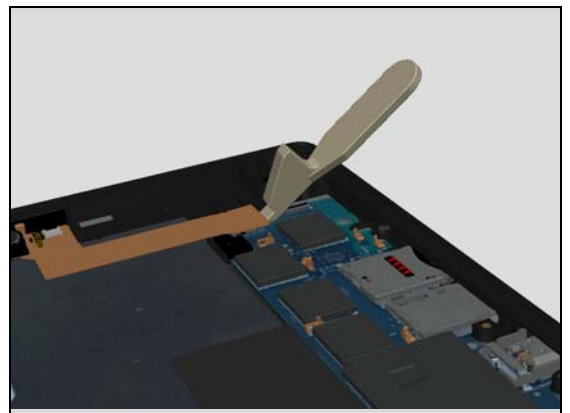


Disassembly

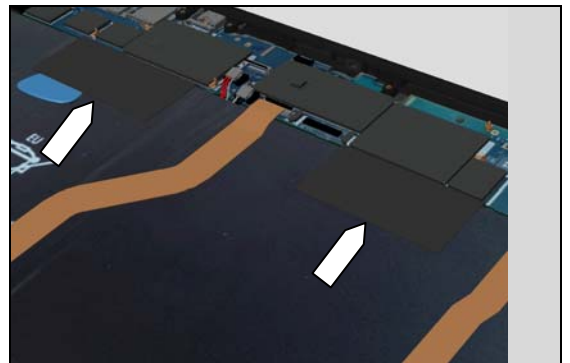
Remove Magnetic charger flex from connector with a Flex Film Assembly Tool.



Use a Front Opening Tool to disconnect the BtB connector of Key Flex module

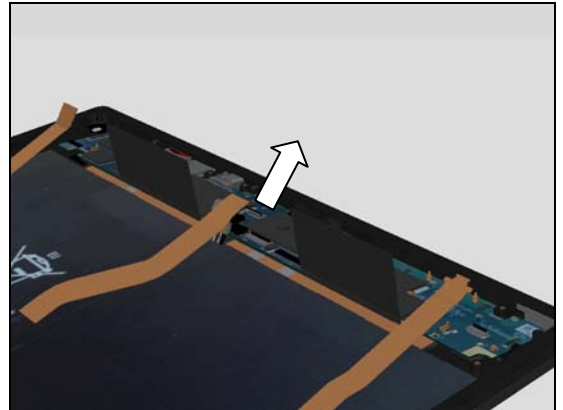


Release Graphite Sheet PBA from Battery with Guitar Pick.

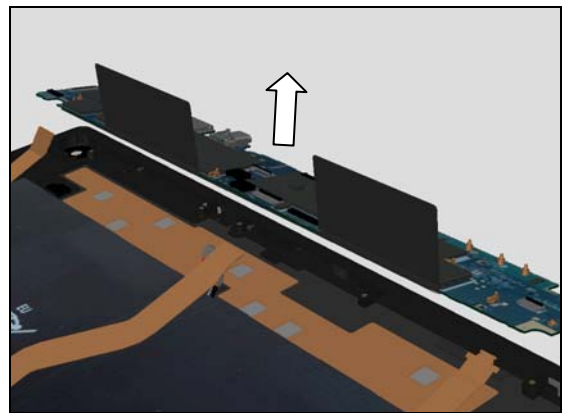


Disassembly

Release the Main PBA with fingers

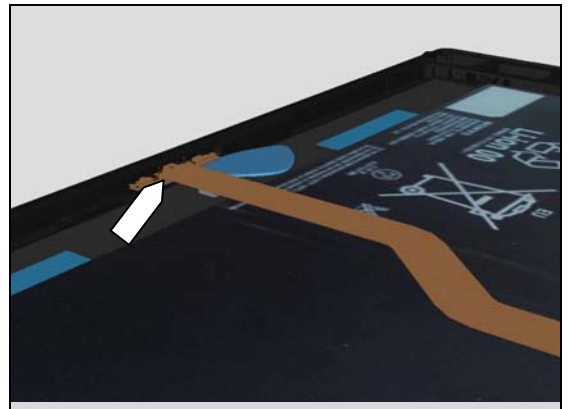


Remove it

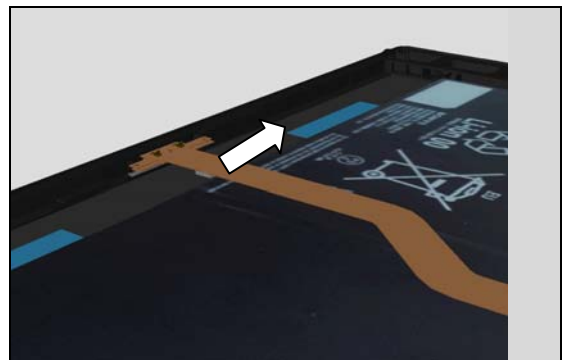


3.20 Magnetic charger flex

Release the Magnetic charger flex from the adhesive with Guitar Pick.



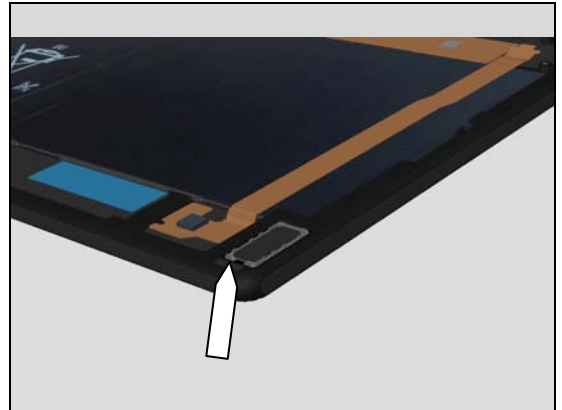
Remove the Magnetic charger flex with fingers.



Disassembly

3.21 Cushion SPK R

Use a dentist hook to detach the Cushion SPK R.

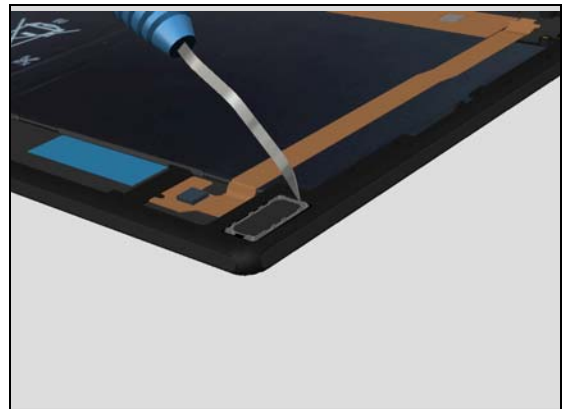


Remove the Cushion SPK R with a Flex Film Assembly Tool.



3.22 Cap SP Assembly (Right)

Use a dentist hook to detach the Cap SP Assembly.



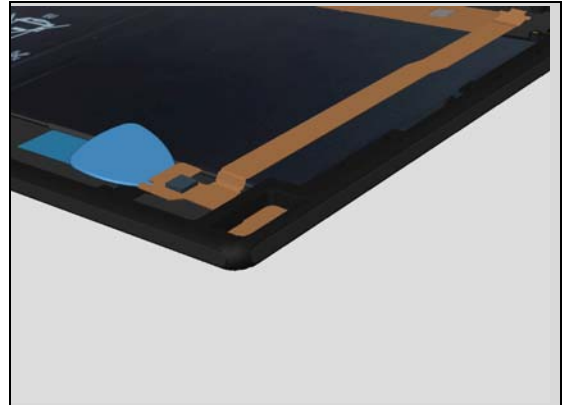
Remove the Cap SP Assembly with fingers.



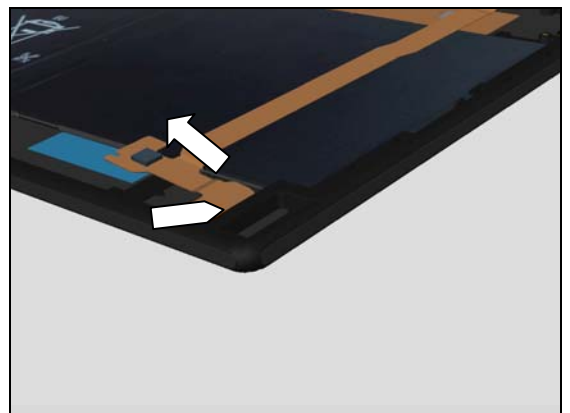
Disassembly

3.23 SP Flex

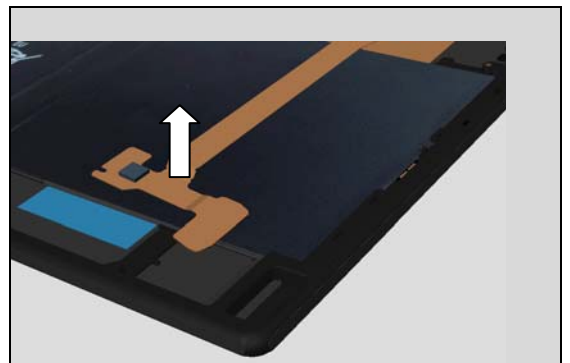
Release the SP Flex from the adhesive with Guitar Pick.



Detach the SP Flex to the left through the loudspeaker hole



Remove the SP Flex with fingers



Disassembly

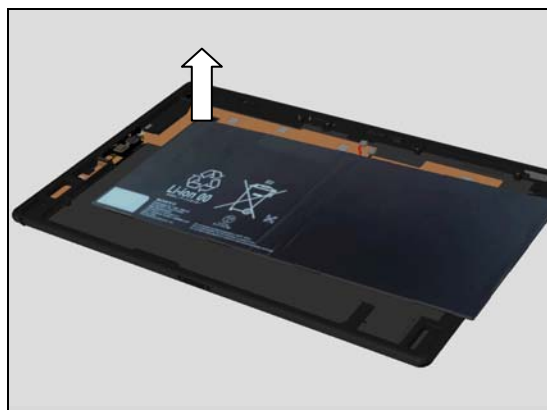
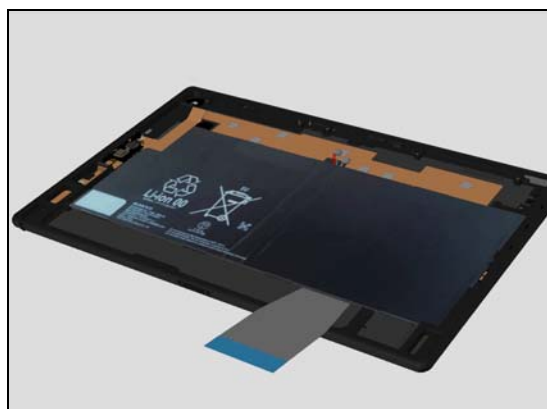
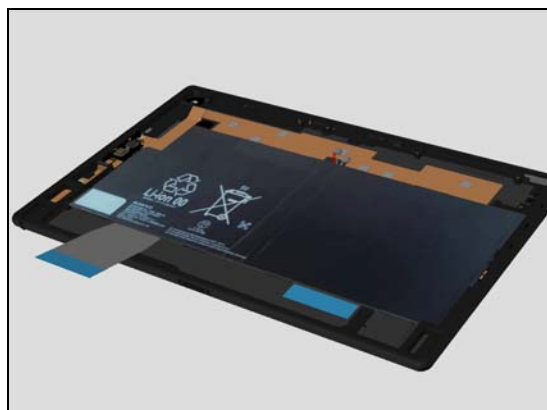
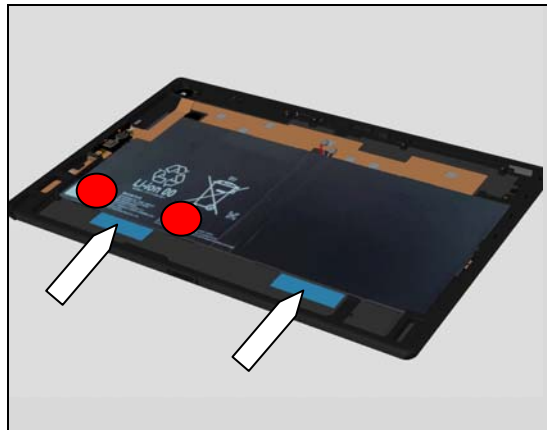
3.24 Adhesive Battery and Battery

Use your fingers to remove the Adhesive Battery one by one.

Note! Place fingers on the battery according to the red circles when removing Adhesive Battery.

Note! Pull the tabs slowly in a horizontal direction. Recommended speed is about 1 cm/sec

Remove the Battery with fingers.

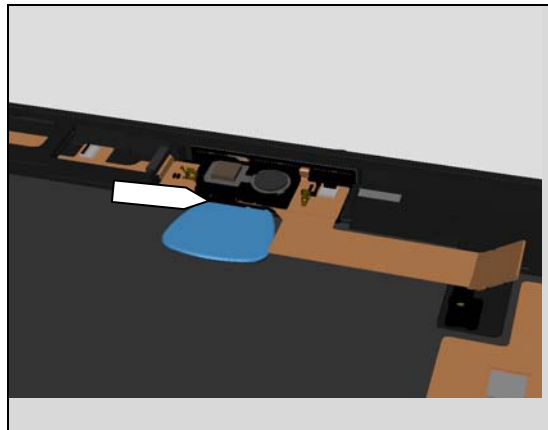


Disassembly

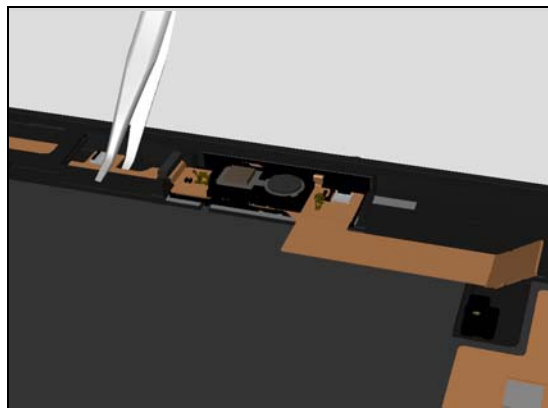
3.25 Key Flex module

Release the Key Flex module from the adhesive with Guitar Pick.

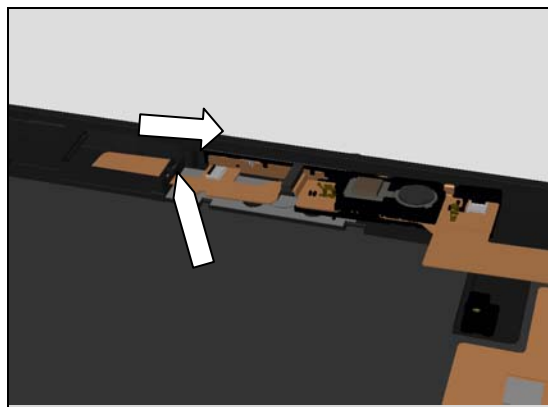
Note! Be very careful not to damage the flexes and release with Guitar Pick under the holder for Key Flex module



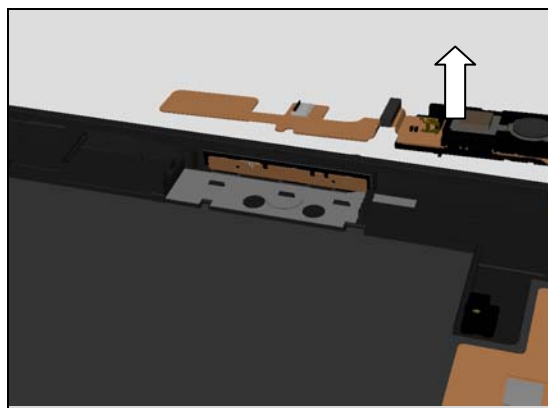
Release the flex around the ZIF connector from the adhesive with a Flex Film Assembly Tool.



Detach the Key Flex module to the right through the loudspeaker hole



Remove the Key Flex module with fingers



4 Replacement

4.1 Display Assembly RoW

Follow the 3.1 Disassembly instructions!

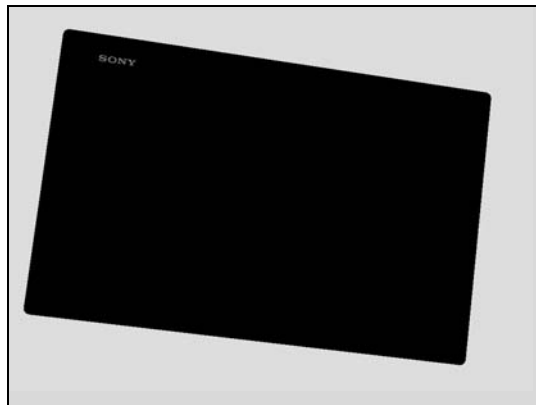
Note! If reuse of Display Assembly RoW follow 4.29 Removal Instruction

Prepare a new Display Assembly RoW.

Note! If reuse of Display Assembly RoW follow 4.29 Installation Instruction

Follow the 4.56 and 4.57 Installation instructions!

Follow the 5.25 Reassembly instructions!

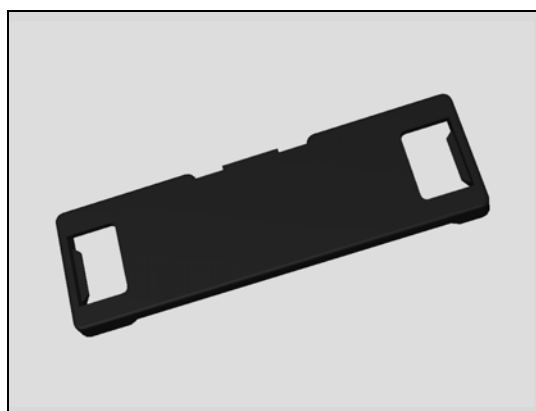


4.2 Holder LCD Relay BtB

Follow the 3.1 - 3.2 Disassembly instructions!

Prepare a new Holder LCD Relay BtB.

Follow the 5.24 - 5.25 Reassembly instructions!



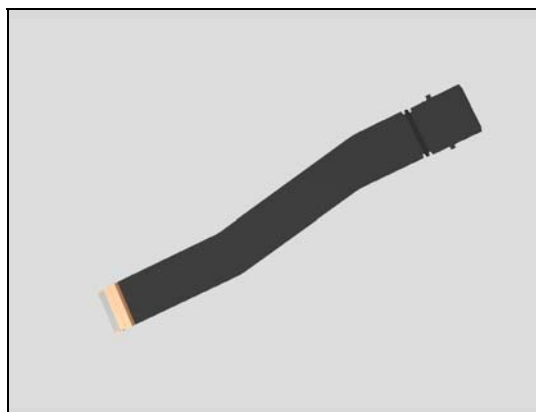
4.3 Relay LCD Flex

Follow the 3.1 - 3.3 Disassembly instructions!

Prepare a new Relay LCD Flex.

Follow the 4.39 Installation instructions!

Follow the 5.23 and 5.25 Reassembly instructions!

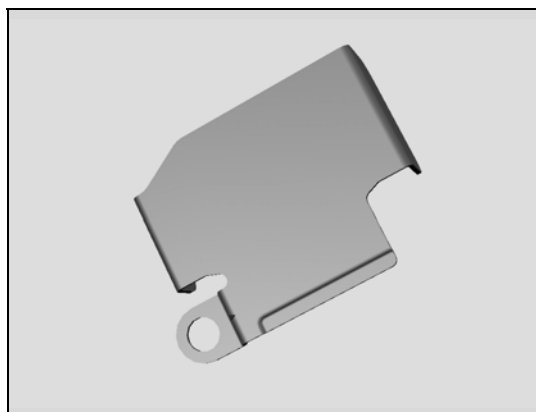


4.4 Plate Audio Jack

Follow the 3.1 and 3.4 Disassembly instructions!

Prepare a new Plate Audio Jack.

Follow the 5.22 and 5.25 Reassembly instructions!



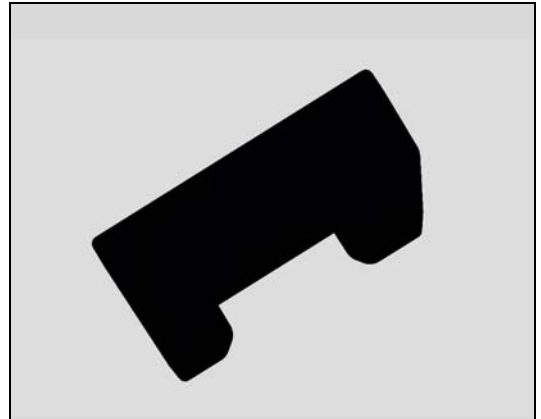
Replacement

4.5 Holder Audio Jack

Follow the 3.1 and 3.5 Disassembly instructions!

Prepare a new Holder Audio Jack.

Follow the 5.21 – 5.25 Reassembly instructions!



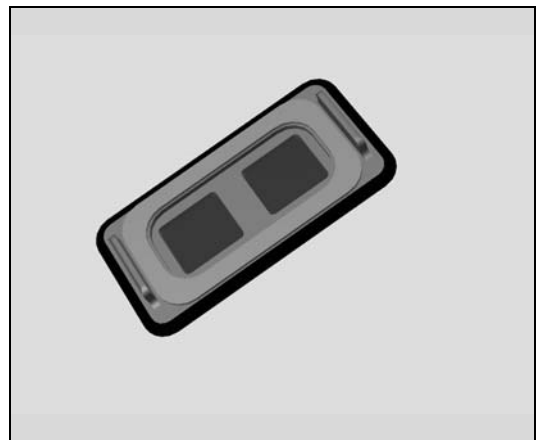
4.6 Cap SP Assembly (Left)

Follow the 3.1 and 3.6 Disassembly instructions!

Prepare a new Cap SP Assembly.

Follow the 4.44 Installation instructions!

Follow the 5.20 - 5.25 Reassembly instructions!

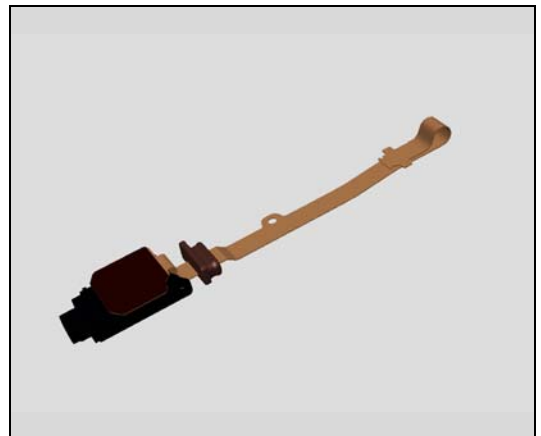


4.7 Audio Jack Flex

Follow the 3.1 and 3.4 - 3.7 Disassembly instructions!

Prepare a new Audio Jack Flex.

Follow the 5.19 and 5.25 Reassembly instructions!

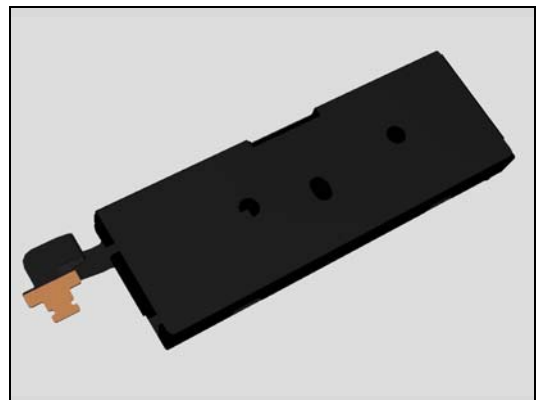


4.8 NFC antenna

Follow the 3.1 and 3.8 Disassembly instructions!

Prepare a new NFC antenna.

Follow the 5.18 and 5.25 Reassembly instructions!



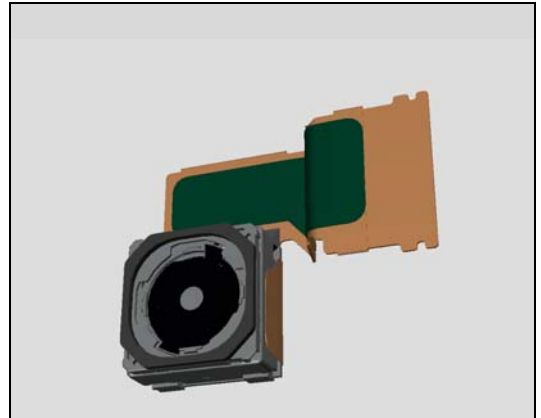
Replacement

4.9 Camera 8 MPixel

Follow the 3.1 and 3.9 Disassembly instructions!

Prepare a new Camera 8 MPixel.

Follow the 5.17 and 5.25 Reassembly instructions!

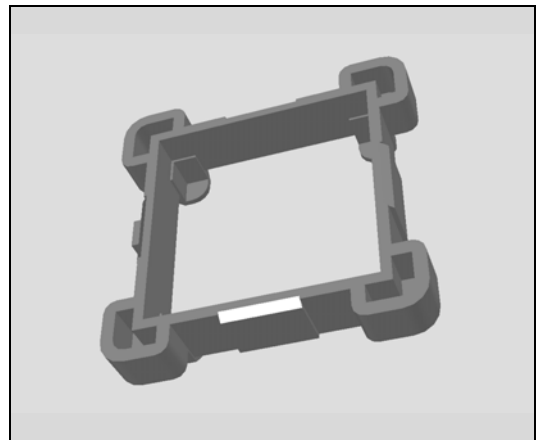


4.10 Holder Main CAM

Follow the 3.1 and 3.9 – 3.10 Disassembly instructions!

Prepare a new Holder Main CAM.

Follow the 5.16 – 5.17 and 5.25 Reassembly instructions!

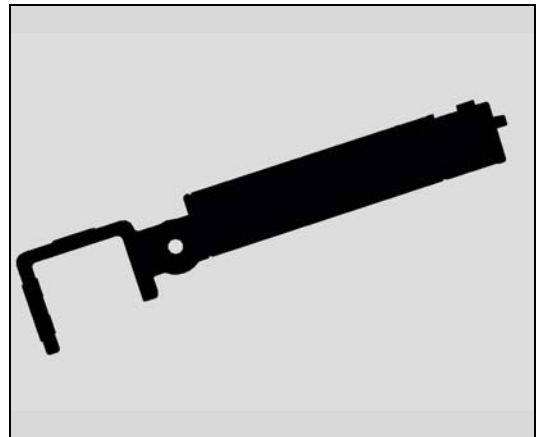


4.11 BT + WLAN + GPS Antenna

Follow the 3.1, 3.9 - 3.11 Disassembly instructions!

Prepare a new BT + WLAN + GPS Antenna.

Follow the 5.15 and 5.25 Reassembly instructions!



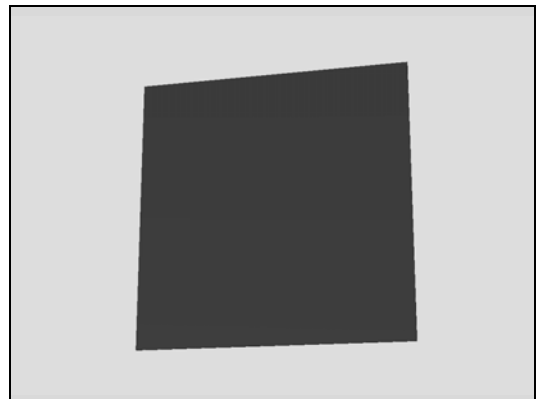
4.12 Sheet Chat CAM

Follow the 3.1 and 3.12 Disassembly instructions!

Scrap! Not to be reused!

Prepare a new Sheet Chat CAM.

Follow the 5.14 and 5.25 Reassembly instructions!



Replacement

4.13 Camera 2 MPixel

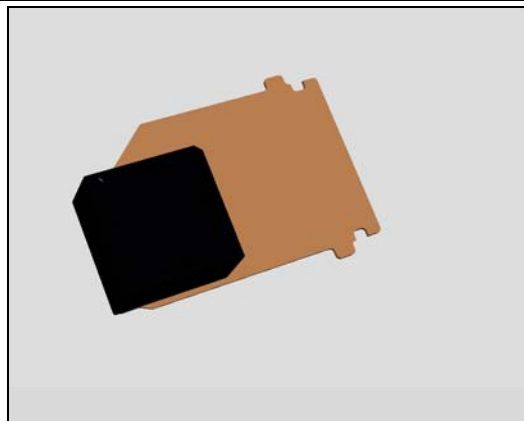
Follow the 3.1 and 3.12 - 3.13 Disassembly instructions!

Follow the 4.32 and 4.41 Removal instructions!

Prepare a new Camera 2 MPixel.

Follow the 4.34, 4.41 and 4.32 Installation instructions!

Follow the 5.13 – 5.14 and 5.25 Reassembly instructions!



4.14 Sensor Flex

Follow the 3.1 and 3.13 - 3.14 Disassembly instructions!

Prepare a new Sensor Flex.

Follow the 5.12 and 5.25 Reassembly instructions!



4.15 Main Antenna

Follow the 3.1 and 3.13 – 3.15 Disassembly instructions!

Prepare a new Main Antenna.

Follow the 5.11 – 5.12 and 5.25 Reassembly instructions!

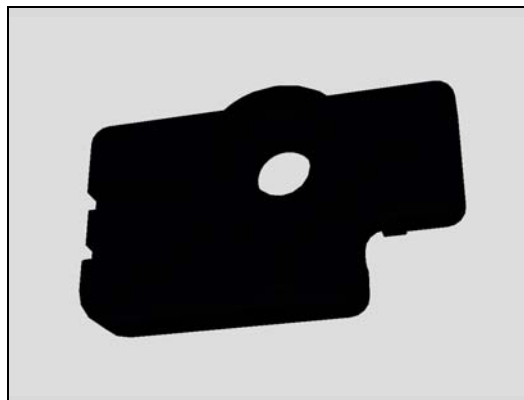


4.16 Holder PBA Screw

Follow the 3.1 and 3.16 Disassembly instructions!

Prepare a new Holder PBA Screw.

Follow the 5.10 and 5.25 Reassembly instructions!



Replacement

4.17 Carrier Frame Sub PBA

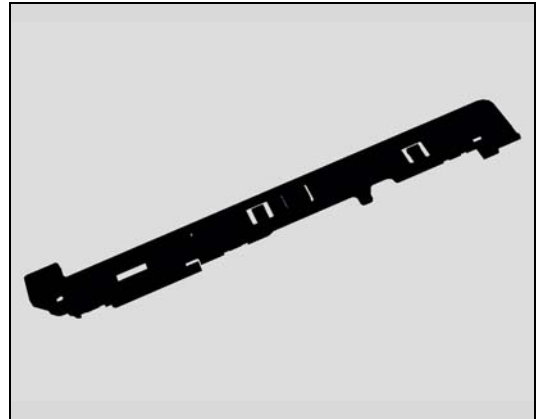
Follow the 3.1 and 3.17 Disassembly instructions!

Follow the 4.55 and 4.60 Removal instructions! (N/A for SGP511 and SGP512)

Prepare a new Carrier Frame Sub PBA.

Follow the 4.60 and 4.55 Installation instructions! (N/A for SGP511 and SGP512)

Follow the 5.9 and 5.25 Reassembly instructions!



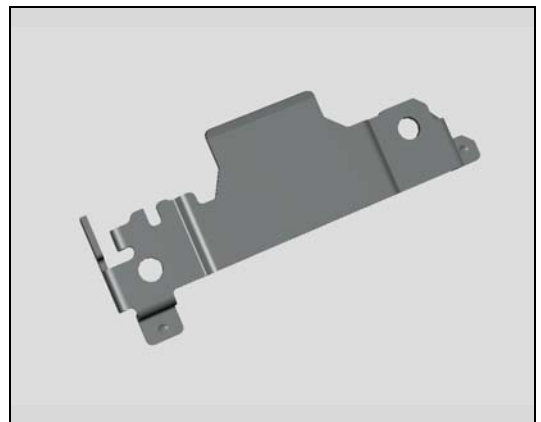
4.18 Plate USB

Follow the 3.1 and 3.18 Disassembly instructions!

Prepare a new Plate USB.

Follow the 4.62 Installation instructions!

Follow the 5.8 and 5.25 Reassembly instructions!



4.19 Main PBA

Follow the 3.1 – 3.3 and 3.9 - 3.19 Disassembly instructions!

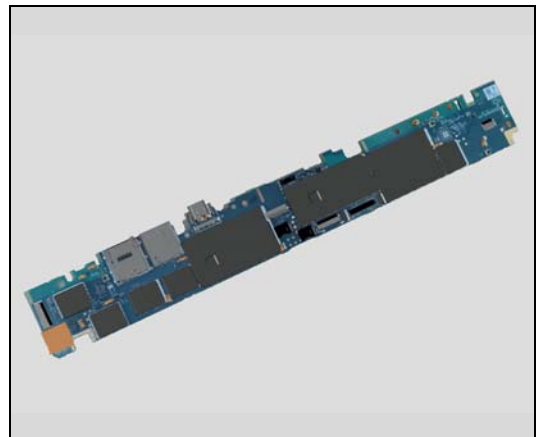
Follow the 4.40 and 4.59 Removal instructions!

Prepare a new Main PBA.

Follow the 4.62, 4.59 and 4.40 Installation instructions!

Follow the 5.7 – 5.17 and 5.23 - 5.25 Reassembly instructions!

Follow the Calibration in Trouble Shooting Application 1262-6643 - mechanical



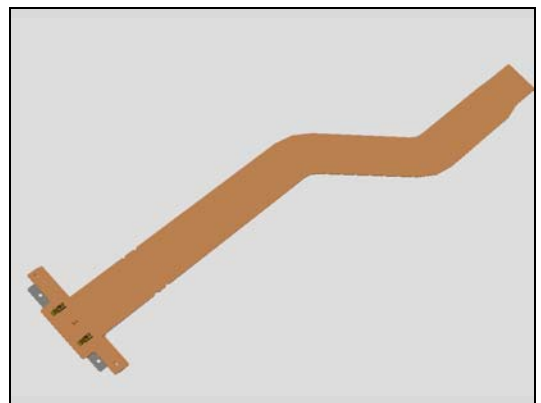
4.20 Magnetic charger flex

Follow the 3.1 and 3.20 Disassembly instructions!

Prepare a new Magnetic charger flex.

Follow the 4.39 Installation instructions!

Follow the 5.6 and 5.25 Reassembly instructions!



Replacement

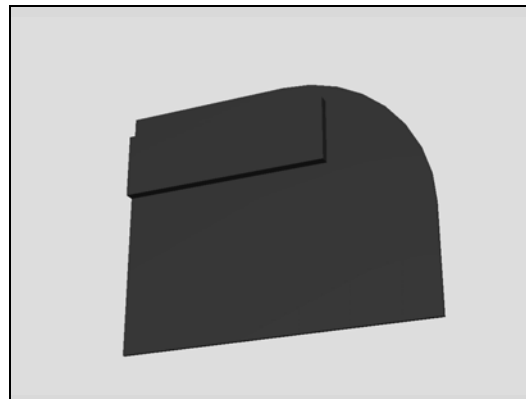
4.21 Cushion SPK R

Follow the 3.1 and 3.21 Disassembly instructions!

Scrap! Not to be reused!

Prepare a new Cushion SPK R.

Follow the 5.5 and 5.25 Reassembly instructions!



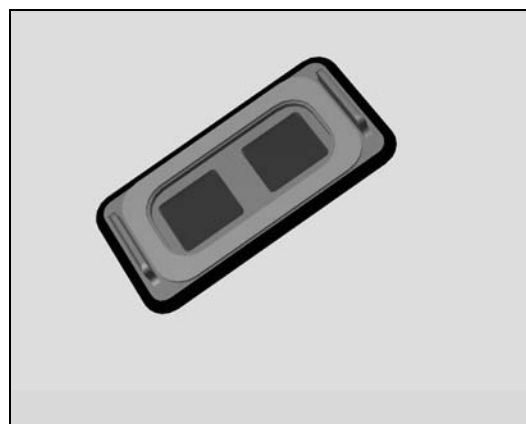
4.22 Cap SP Assembly (Right)

Follow the 3.1 and 3.22 Disassembly instructions!

Prepare a new Cap SP Assembly

Follow the 4.44 Installation instructions!

Follow the 5.4 and 5.25 Reassembly instructions!



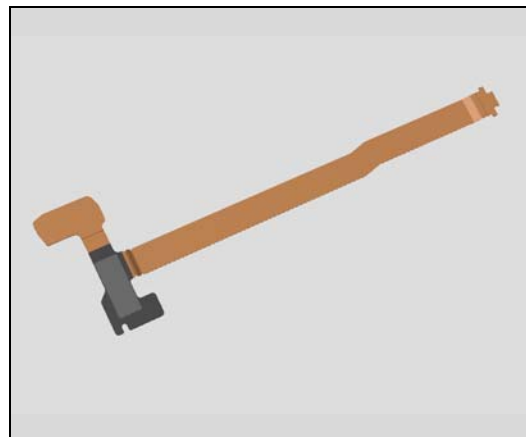
4.23 SP Flex

Follow the 3.1 and 3.22 – 3.23 Disassembly instructions!

Prepare a new SP Flex.

Follow the 4.39 Installation instructions!

Follow the 5.3 - 5.4 and 5.25 Reassembly instructions!



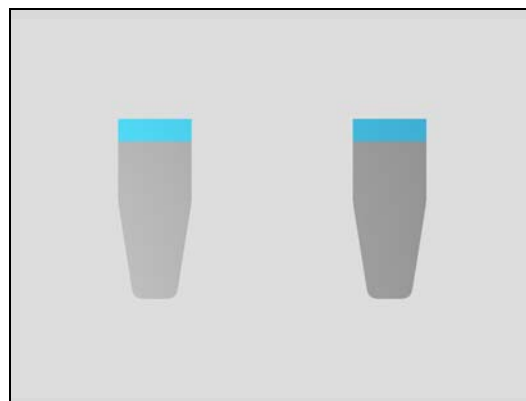
4.24 Adhesive Battery

Follow the 3.1 – 3.3 and 3.24 Disassembly instructions!

Scrap! Not to be reused!

Prepare a new Adhesive Battery.

Follow the 5.2 and 5.23 - 5.25 Reassembly instructions!



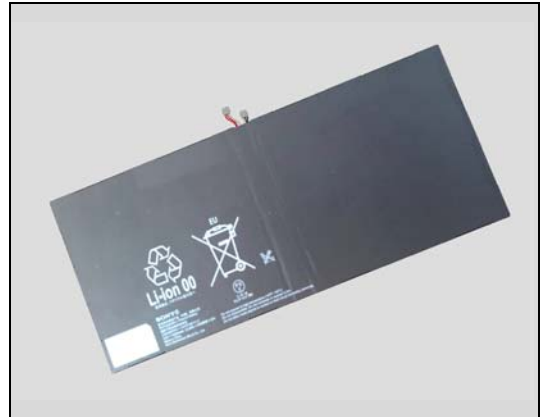
Replacement

4.25 Battery

Follow the 3.1 – 3.3 and 3.24 Disassembly instructions!

Prepare a new Battery.

Follow the 5.2 and 5.23 - 5.25 Reassembly instructions!



4.26 Key Flex module

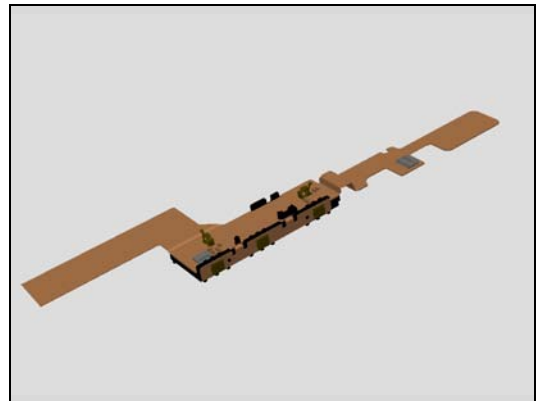
Follow the 3.1 – 3.3, 3.6 and 3.24- 3.25 Disassembly instructions!

Follow the 4.63 and 4.57 Removal instructions!

Prepare a new Key Flex module.

Follow the 4.33, 4.28, 4.42, 4.63 and 4.57 Installation instructions!

Follow the 5.1 – 5.2, 5.20 and 5.23 - 5.25 Reassembly instructions!



Replacement

4.27 Adhesive Panel Bottom Left L

*Follow the 4.47 Removal instructions!
Carry out the Removal as described below!
Prepare a new Adhesive Panel Bottom Left L!
Carry out the Installation as described below!
Follow the 4.47 Installation instructions!*

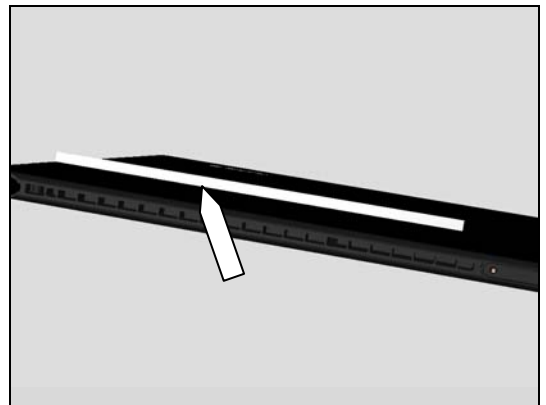
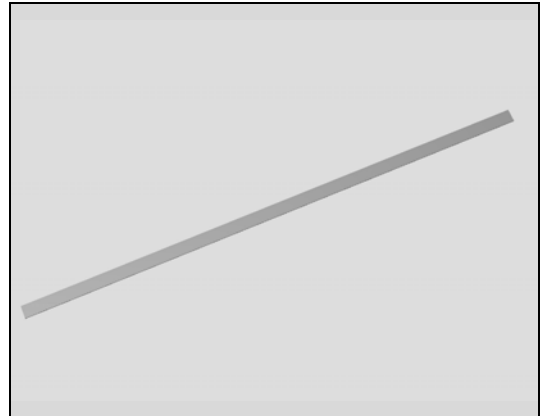
REMOVAL

Remove the Adhesive Panel Bottom Left L with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive Panel Bottom Left L with a Flex Film Assembly Tool on the Main Frame



Replacement

4.28 Adhesive Vibrator

Follow the 3.1 Disassembly instructions!

Follow the 4.63 Removal instructions!

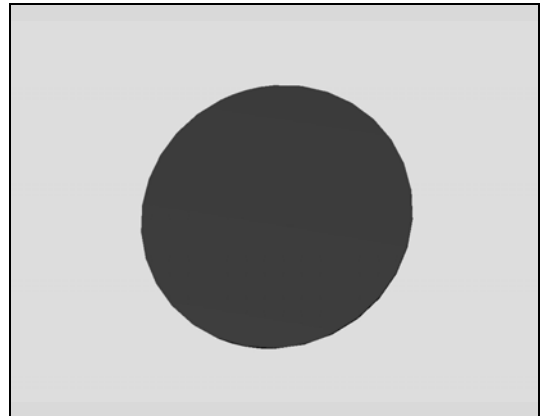
Carry out the Removal as described below!

Prepare a new Adhesive Vibrator!

Carry out the Installation as described below!

Follow the 4.63 Installation instructions!

Follow the 5.25 Reassembly instructions!



REMOVAL

Remove the Adhesive Vibrator by using Flex Film Assembly Tool.

Note! Only scrap if destroyed could be reused

INSTALLATION

Place a new Adhesive Vibrator with Flex Film Assembly Tool.



Replacement

4.29 Adhesive WR Window LCD

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Adhesive WR Window LCD!

Carry out the Installation as described below!

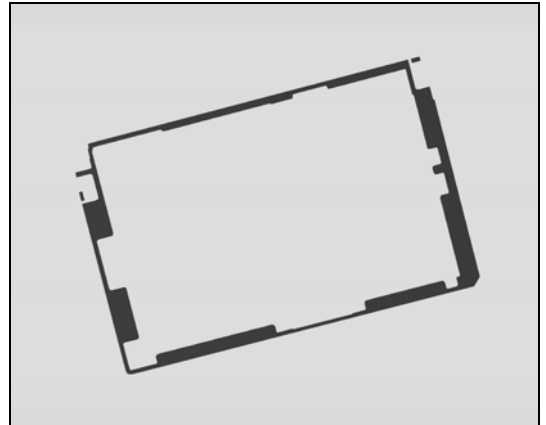
Follow the 5.25 Reassembly instructions!

REMOVAL

Detach to remove the Adhesive WP Speaker with Bamboo Skewer (**preferred**) or Nylon Pointer on both Display Assembly RoW and Main Frame.

Scrap! Not to be reused!

Note! It is very important that all adhesive is removed before installation because of WRT requirement.



Replacement

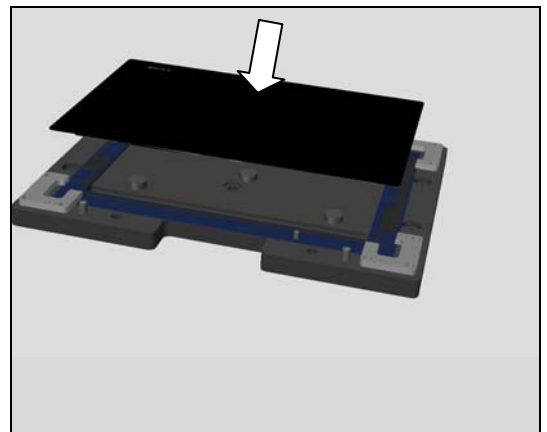
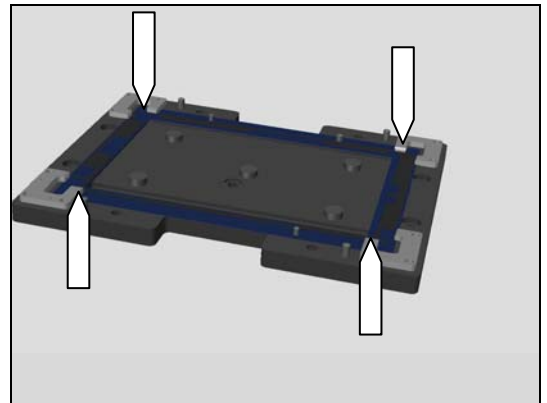
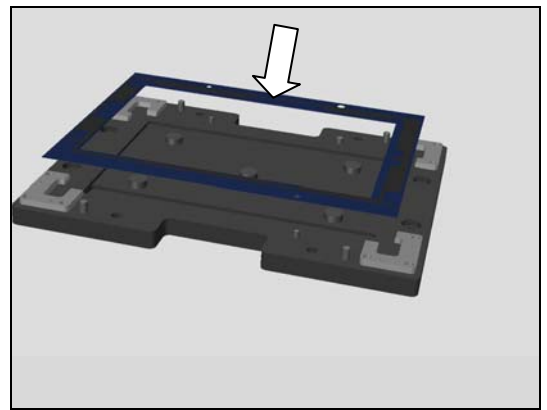
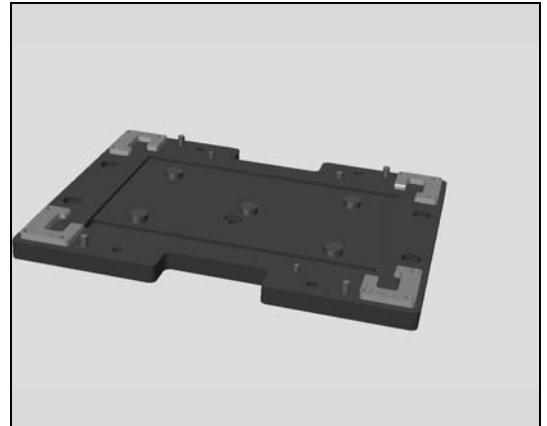
INSTALLATION

Start to use bottom plate of Display Adhesive alignment Fixture

Place a new Adhesive WR Window LCD with fingers

Secure the position of Adhesive WR Window LCD

Place the Display Assembly RoW with Suction cup and fingers

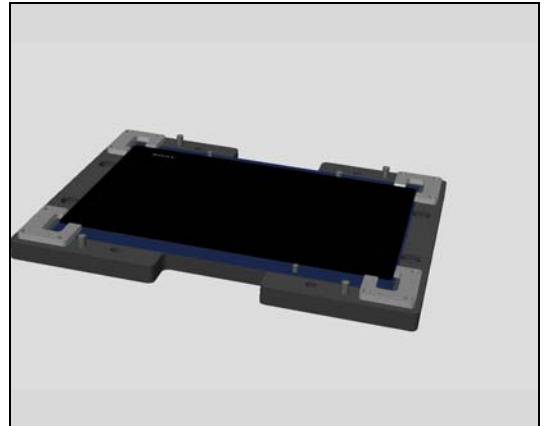


Replacement

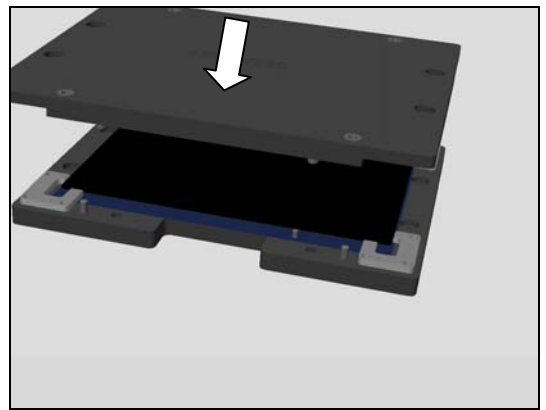
Secure the position in fixture

Use guiding pins for align the old Display Assembly RoW above the Adhesive WR Window LCD.

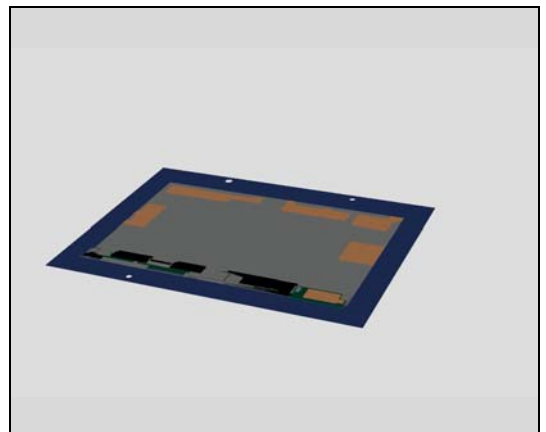
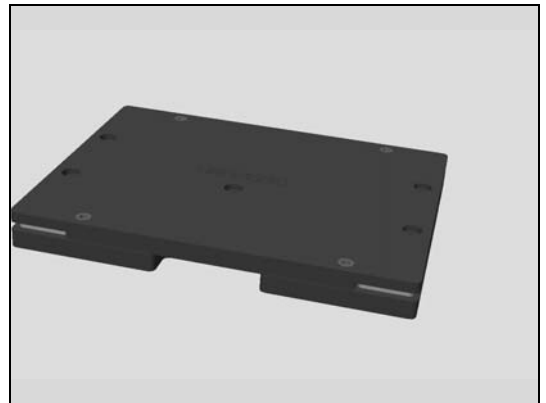
Important to make sure that old adhesive is removed before installation because of WRT requirement!



Take the upper plate of Display Adhesive alignment Fixture and position it on the bottom plate



Press by hand for 10 sec.



Replacement

4.30 Cap SIM

Carry out the Removal as described below!

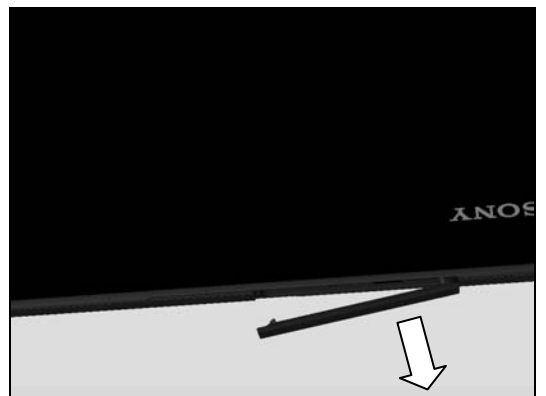
Prepare a new Cap SIM!

Carry out the Installation as described below!



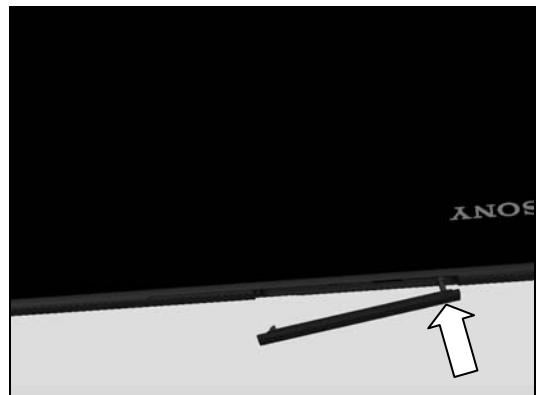
REMOVAL

Remove the Cap SIM with fingers

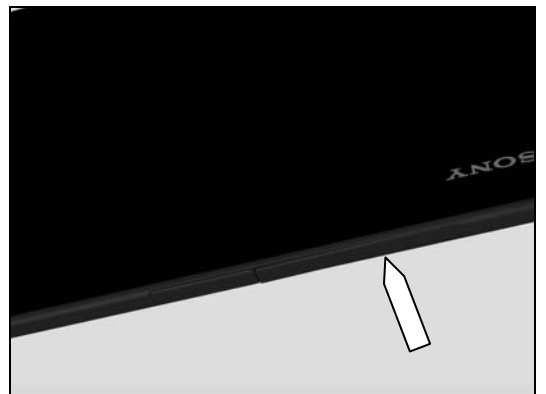


INSTALLATION

Place a new Cap SIM with fingers



Press it in place.



Replacement

4.31 Cap USB

Carry out the Removal as described below!

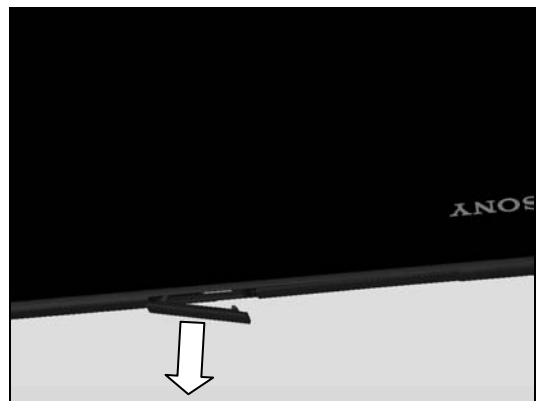
Prepare a new Cap USB!

Carry out the Installation as described below!



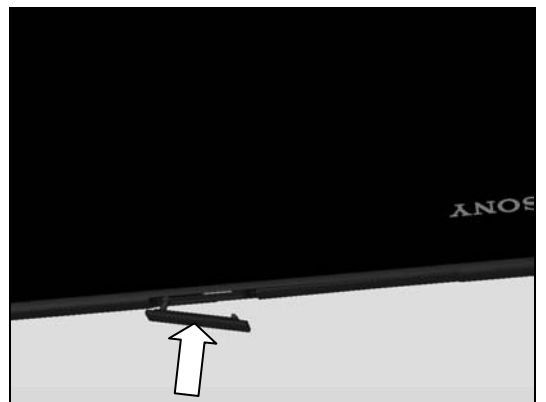
REMOVAL

Remove the Cap USB with fingers

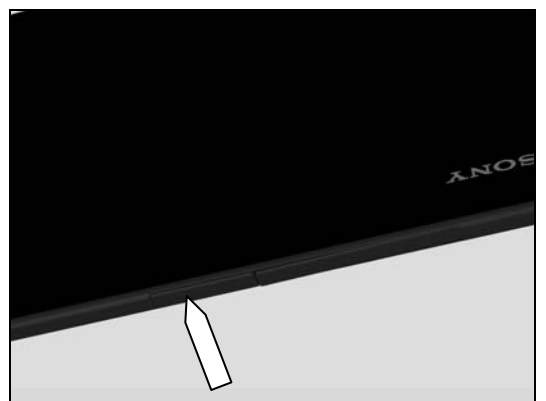


INSTALLATION

Place a new Cap USB with fingers



Press it in place



Replacement

4.32 Carrier Frame Chat Cam

Follow the 3.1 and 3.12 – 3.13 Disassembly instructions!

Carry out the Removal as described below!

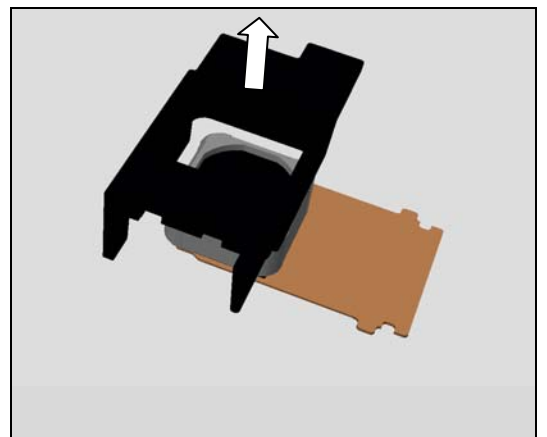
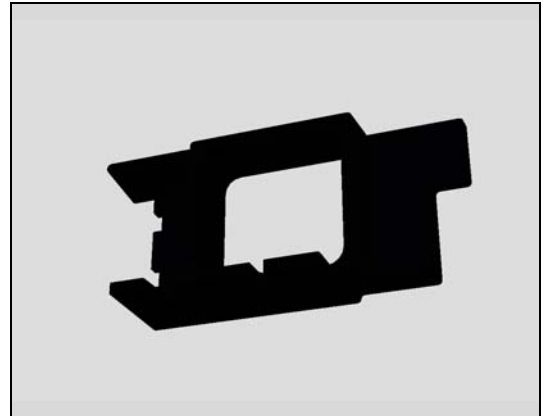
Prepare a new Carrier Frame Chat Cam!

Carry out the Installation as described below!

Follow the 5.13 -5.14 and 5.25 Reassembly instructions!

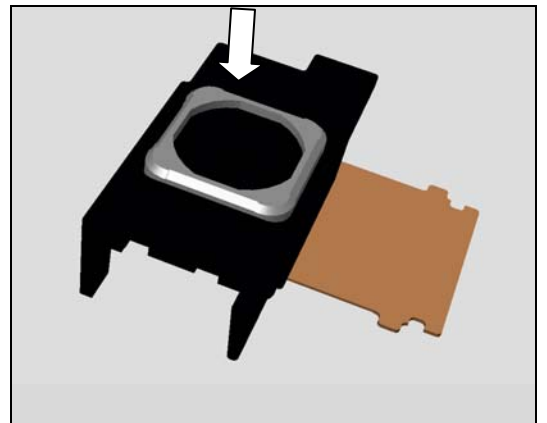
REMOVAL

Detach to remove the Carrier Frame Chat Cam with fingers



INSTALLATION

Place a new Carrier Frame Chat Cam using a fingers on the Camera 2 MPixel



Replacement

4.33 Cushion Back Vol L

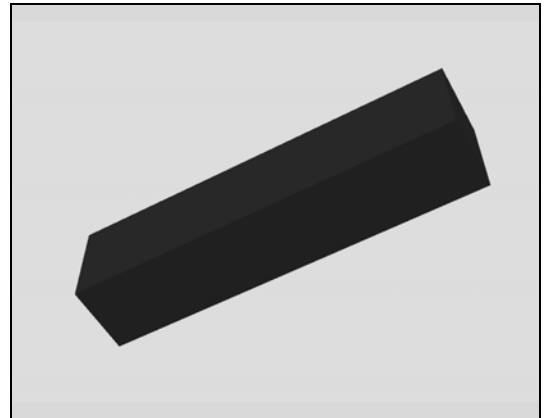
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Cushion Back Vol L!

Carry out the Installation as described below!

Follow the 5.25 Reassembly instructions!



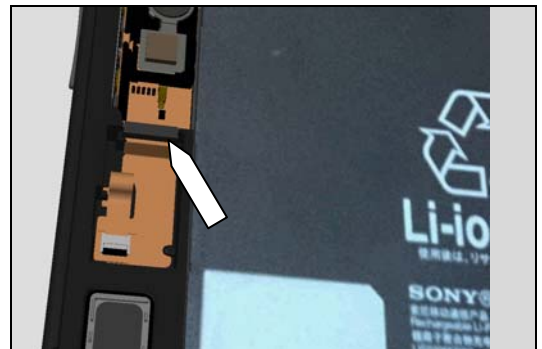
REMOVAL

Remove the Cushion Back Vol L with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Back Vol L with a Flex Film Assembly Tool on the Key Flex module



Replacement

4.34 Cushion Chat Cam

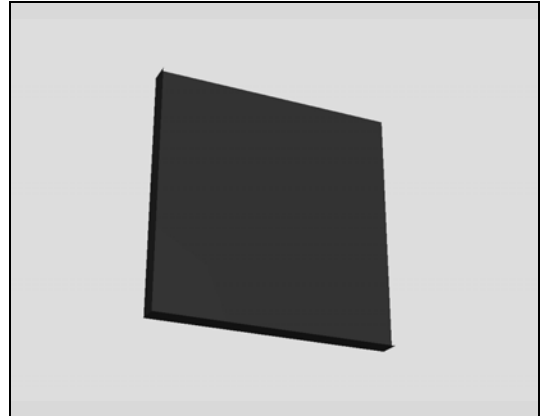
Follow the 3.1 and 3.12 – 3.13 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Cushion Chat Cam!

Carry out the Installation as described below!

Follow the 5.13 – 5.14 and 5.25 Reassembly instructions!



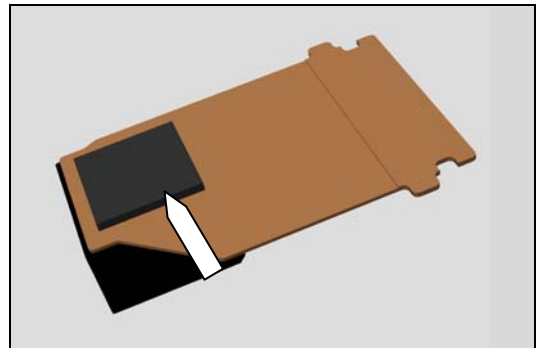
REMOVAL

Remove the Cushion Chat Cam with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Chat Cam with a Flex Film Assembly Tool on the Camera 2 MPixel.



Replacement

4.35 Cushion Relay LCD

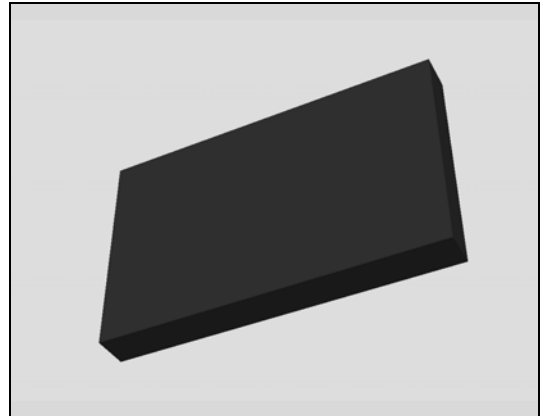
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Cushion Relay LCD

Carry out the Installation as described below!

Follow the 5.25 Reassembly instructions!



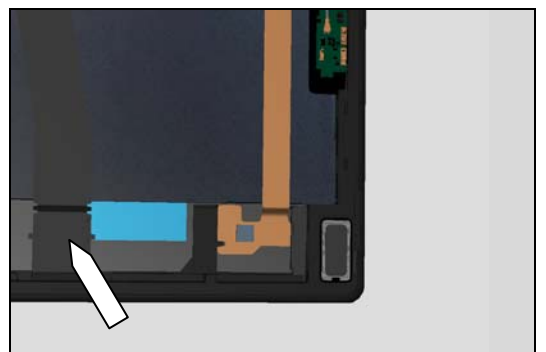
REMOVAL

Remove the Cushion Relay LCD with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Relay LCD with a Flex Film Assembly Tool to the Relay LCD Flex



Replacement

4.36 Diversity Antenna

Follow the 3.1, 3.7 and 3.24 Disassembly instructions!

Carry out the Removal as described below!

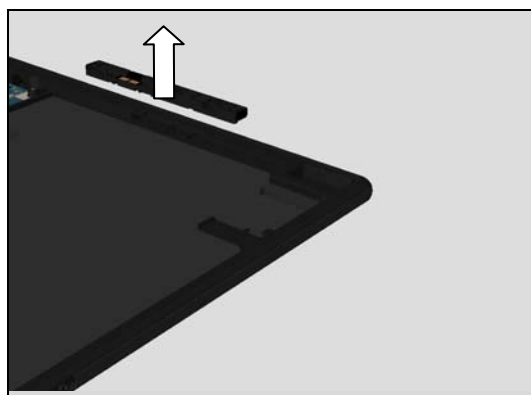
Prepare a new Diversity Antenna!

Carry out the Installation as described below!

Follow the 5.2, 5.19 and 5.25 Reassembly instructions!

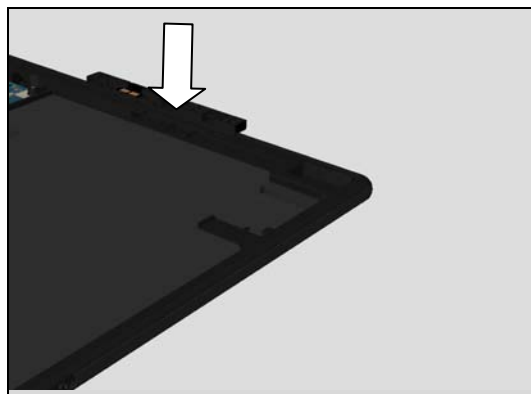
REMOVAL

Remove the Diversity Antenna with dentist hook

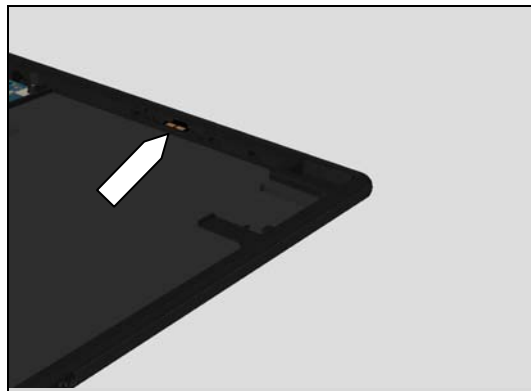


INSTALLATION

Place a new Diversity Antenna using the fingers on the Main Frame.



Note! Make sure the contact pads are visible and cleaned.



Replacement

4.37 Frame DTV

Follow the 3.1 Disassembly instructions!

Follow the 4.51 Removal instructions!

Carry out the Removal as described below!

Prepare a new Frame DTV!

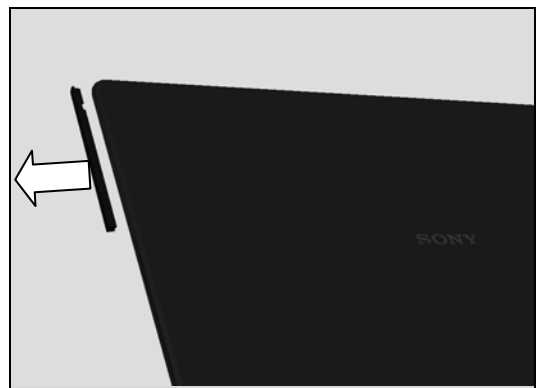
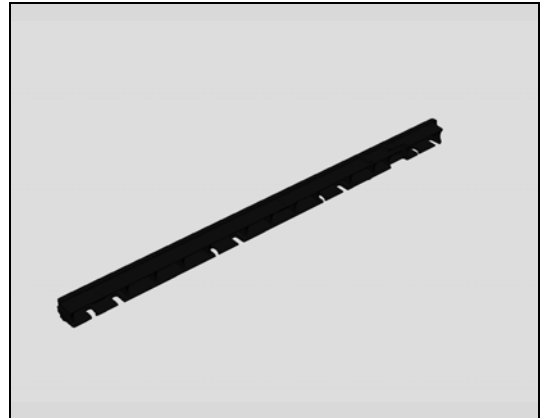
Carry out the Installation as described below!

Follow the 4.51 Installation instructions!

Follow the 5.25 Reassembly instructions!

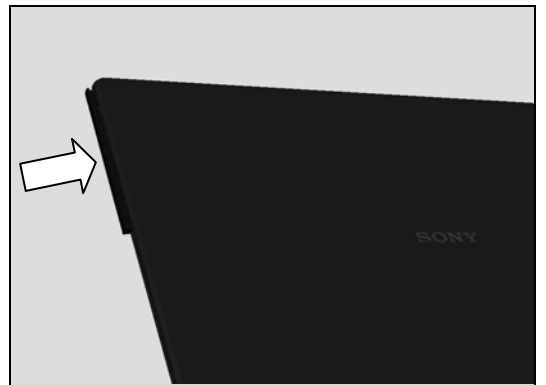
REMOVAL

Remove the Frame DTV with dentist hook.



INSTALLATION

Place a new Frame DTV using fingers on the Main Frame



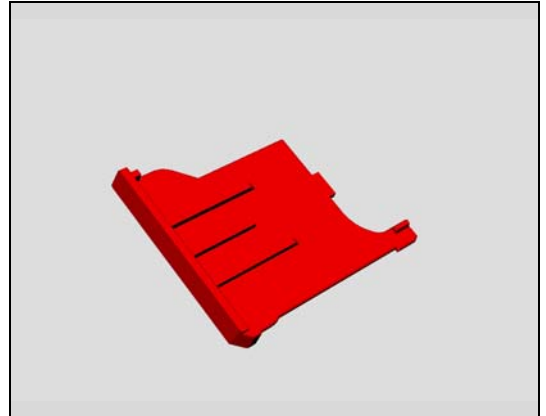
Replacement

4.38 Frame SIM (N/A SGP521,SGP541,SGP551 and SGP561)

Carry out the Removal as described below!

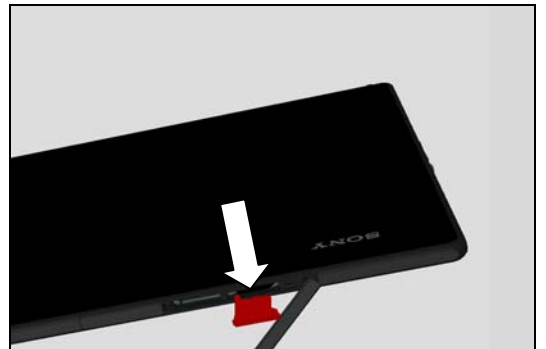
Prepare a new Frame SIM!

Carry out the Installation as described below!



REMOVAL

Remove the Frame SIM with a fingers

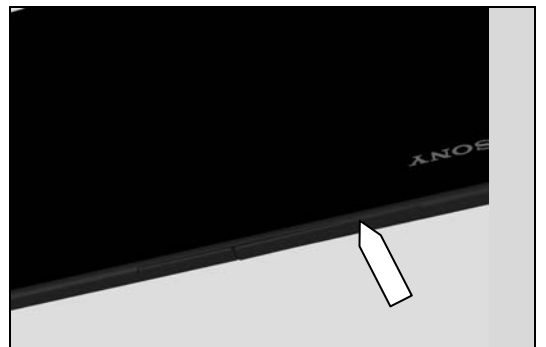


INSTALLATION

Place a new Frame SIM with fingers.



Close the Cap SIM



Replacement

4.39 Gasket Conductive FPC

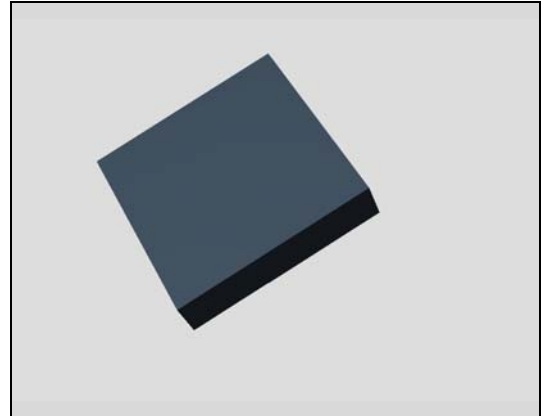
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Gasket Conductive FPC!

Carry out the Installation as described below!

Follow the 5.25 Reassembly instructions!



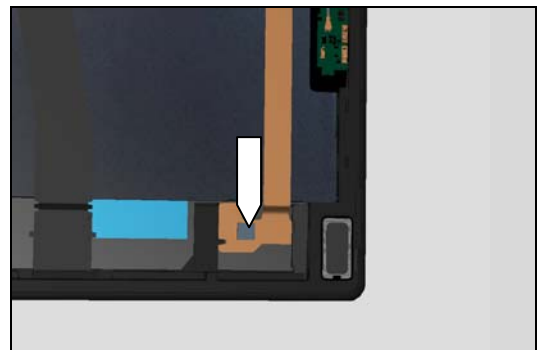
REMOVAL

Remove the Gasket Conductive FPC with a dentist hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Gasket Conductive FPC with a Flex Film Assembly Tool on the SP Flex



Replacement

4.40 Graphite Sheet PBA

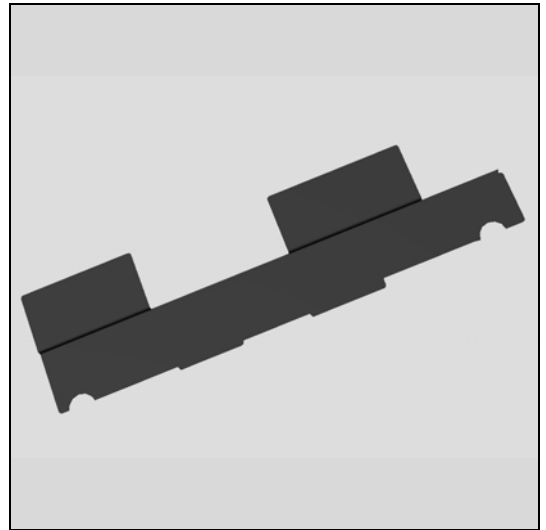
Follow the 3.1 - 3.3 and 3.9 – 3.19 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Graphite Sheet PBA!

Carry out the Installation as described below!

Follow the 5.7 – 5.17 and 5.23 - 5.25 Reassembly instructions!

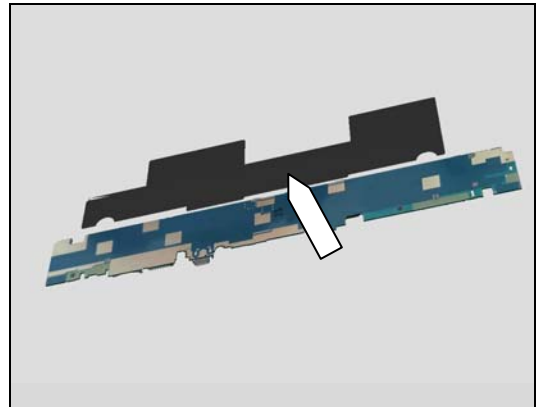


REMOVAL

Remove the Graphite Sheet PBA with fingers.

INSTALLATION

Place a new Graphite Sheet PBA with fingers on the Main PBA.



Replacement

4.41 Holder Chat Cam

Follow the 3.1 and 3.12 – 3.13 Disassembly instructions!

Follow the 4.32 Removal instructions!

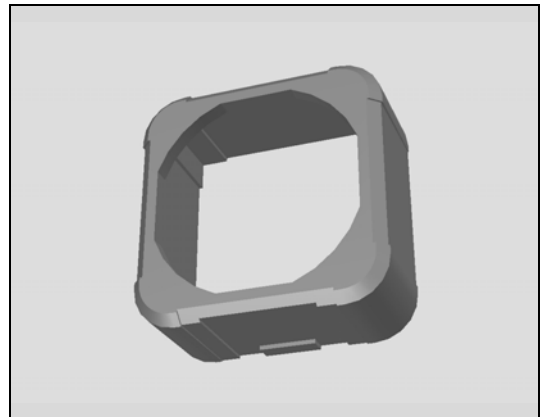
Carry out the Removal as described below!

Prepare a new Holder Chat Cam!

Carry out the Installation as described below!

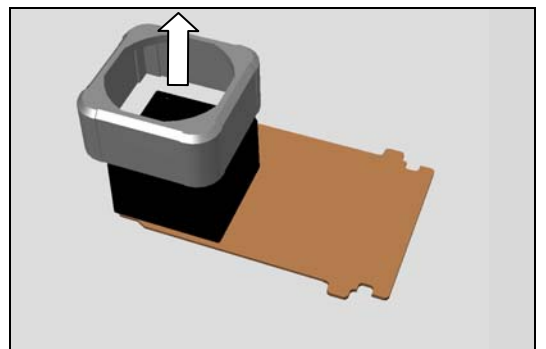
Follow the 4.32 Installation instructions!

Follow the 5.13 – 5.14 and 5.25 Reassembly instructions!



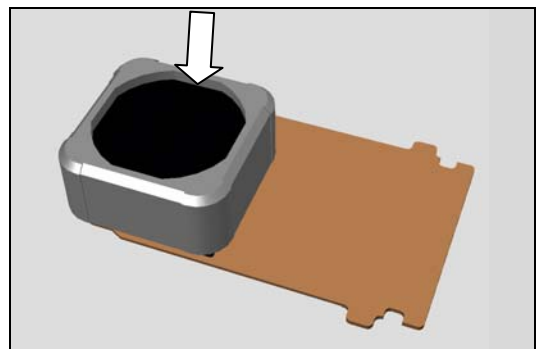
REMOVAL

Detach to remove the Holder Chat Cam with fingers.



INSTALLATION

Place a Holder Chat Cam with fingers on the Camera 2 MPixel.



Replacement

4.42 Holder Vibrator

Follow the 3.1 Disassembly instructions!

Follow the 4.58 Removal instructions!

Carry out the Removal as described below!

Follow the 4.63 and 4.28 (Note! Only if needed) Removal instructions!

Prepare a new Holder Vibrator!

Follow the 4.28 (Note! Only if needed) and 4.63 Installation instruction!

Carry out the Installation as described below!

Follow the 4.58 Installation instructions!

Follow the 5.25 Reassembly instructions!

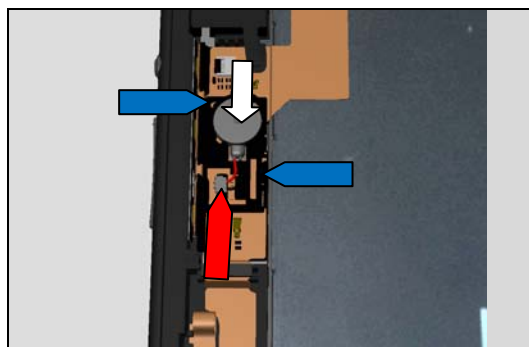
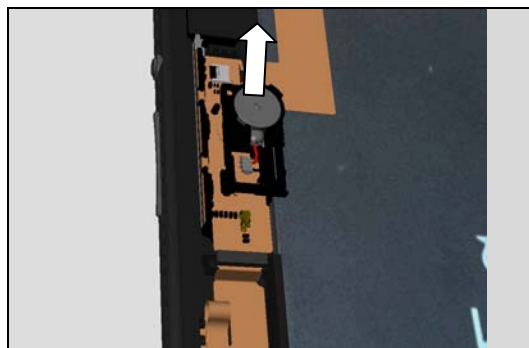
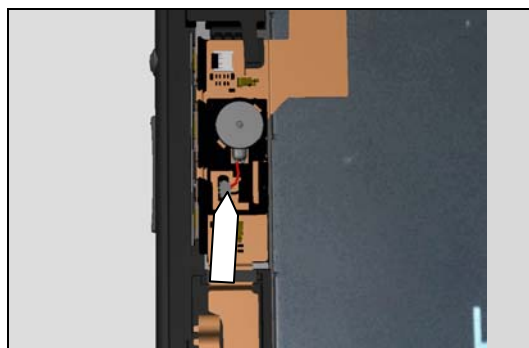
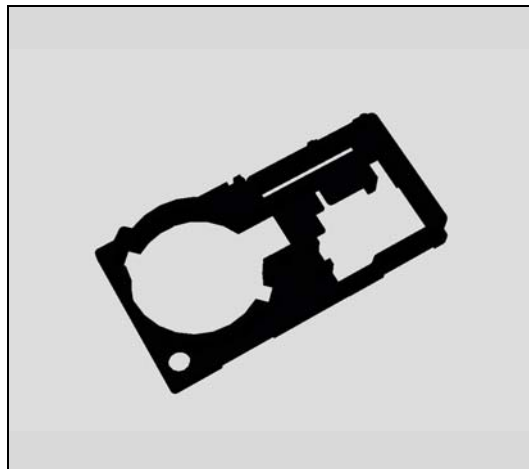
REMOVAL

Detach connector of Vibrator with a Front Opening Tool.

Remove Holder Vibrator with a Flex Film Assembly Tool

INSTALLATION

Place a new Holder Vibrator with fingers on the Key Flex module, see blue arrows. Then connect the Vibrator with finger, red arrow.



Replacement

4.43 Key Volume

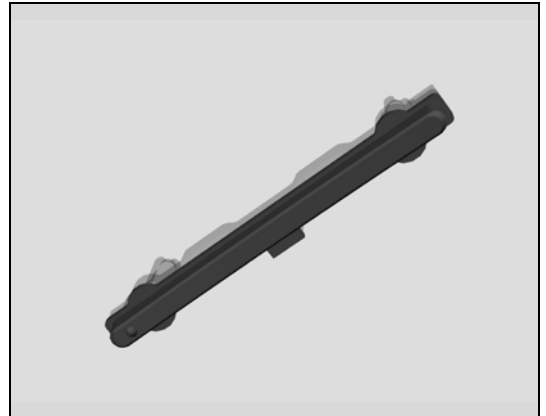
Follow the 4.49 Removal instructions!

Carry out the Removal as described below!

Prepare a new Key Volume!

Carry out the Installation as described below!

Follow the 4.49 Installation instructions!

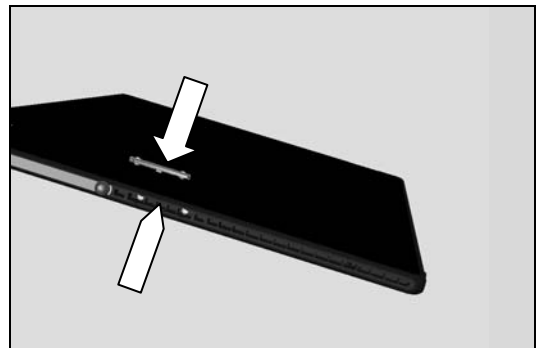


REMOVAL

Remove Key Volume with fingers.

INSTALLATION

Place a new Key Volume with fingers on the Main Frame



Replacement

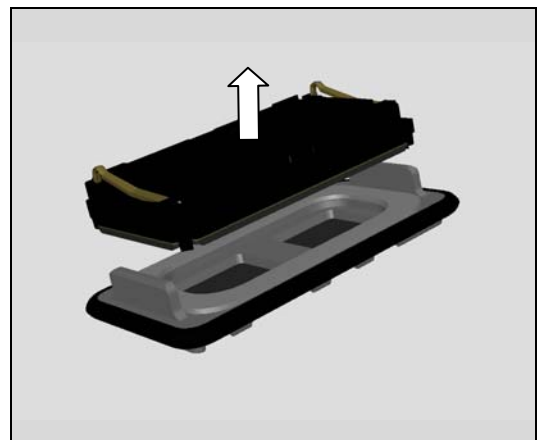
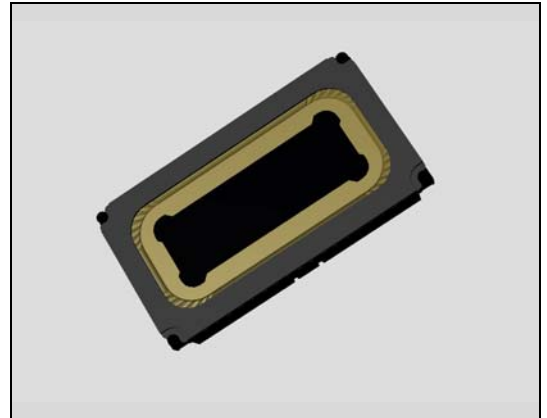
4.44 Loudspeaker + Ear Speaker

Follow the 3.1 and 3.6/3.22 Disassembly instructions!
 Carry out the Removal as described below!
 Prepare a new Loudspeaker + Ear Speaker!
 Carry out the Installation as described below!
 Follow the 5.4/5.20 and 5.25 Reassembly instructions!

REMOVAL

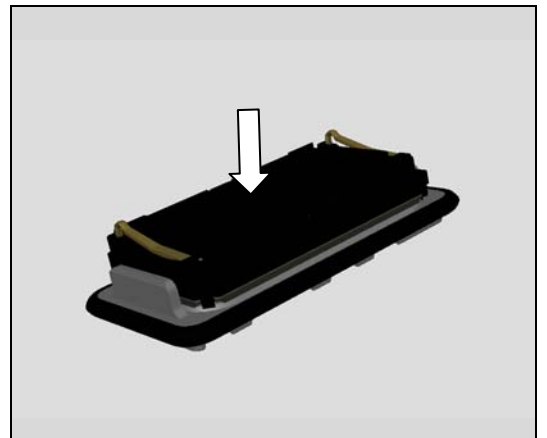
Remove the Loudspeaker + Ear Speaker with the Front Opening Tool.

Scrap! Not to be reused!



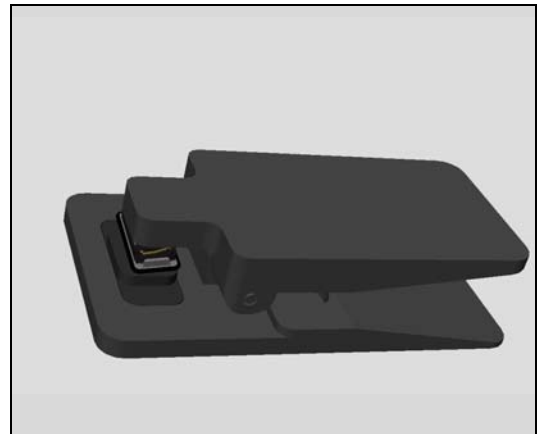
INSTALLATION

Place a new Loudspeaker + Ear Speaker with fingers.



Press to secure its attachment by using Press Tool Loudspeaker for five seconds.

Do not touch the contact pins!



Replacement

4.45 Magnetic charger connector

Follow the 3.1 Disassembly instructions!
 Carry out the Removal as described below!
 Prepare a new Magnetic charger connector!
 Carry out the Installation as described below!
 Follow the 5.25 Reassembly instructions!

REMOVAL

Push the two pads of *Magnetic charger connector* by using Flex Film Assembly Tool.

Scrap! Not to be reused!

Be careful! Do not damage the two pads of Magnetic charger flex.

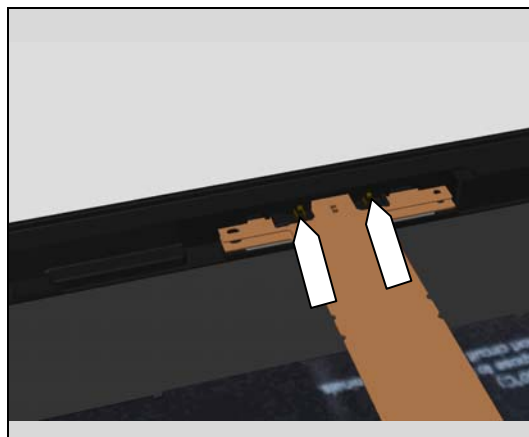
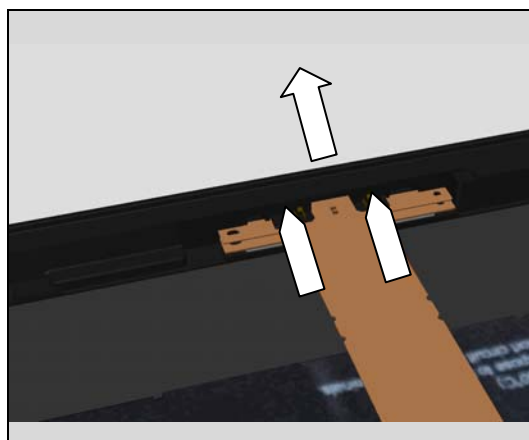
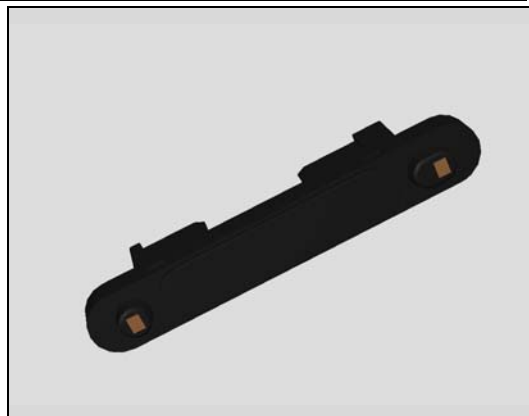
INSTALLATION

Mount a new Magnetic charger connector by fingers

Check and press the two pins into its cavities by using the Front Opening Tool.

Be careful! Do not damage the two pins on Magnetic charger flex.

Then use Side Panel press, Side Panel Press Head and Charge connector press pad with the force of 65N for ten seconds. According to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.46 Main Frame

Follow the 3.1 – 3.25 Disassembly instructions!

Follow the 4.43, 4.47, 4.61 Removal instructions!

Prepare a new Main Frame!

Follow the 4.27, 4.43, 4.45, 4.47, 4.48, 4.49, 4.50, 4.51, 4.52, 4.53, 4.54, 4.61 Installation instructions!

Follow the 5.1 - 5.25 Reassembly instructions!



Replacement

4.47 Panel Bottom Left L

Carry out the Removal as described below!

Follow the 4.27 Removal instructions!

Prepare a new Panel Bottom Left L!

Follow the 4.27 Installation instructions!

Carry out the Installation as described below!

REMOVAL

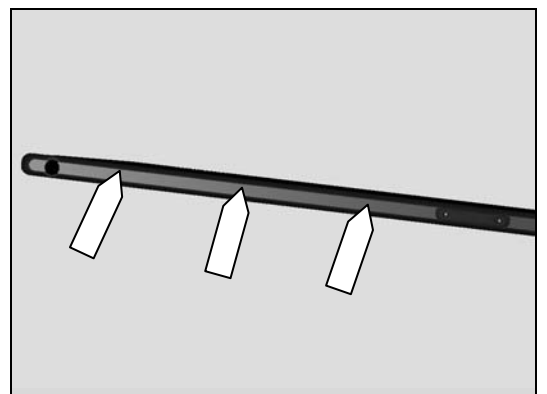
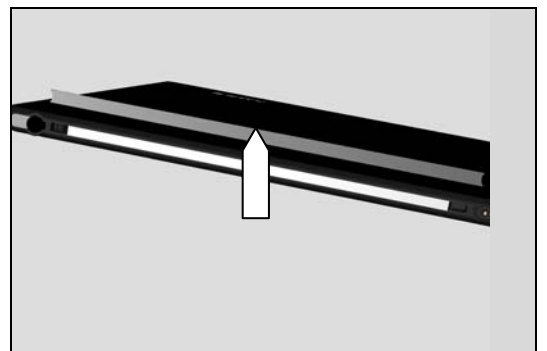
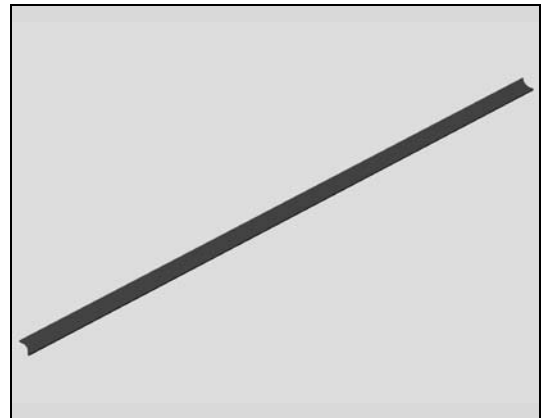
Remove the Panel Bottom Left L with the dentist hook

Be careful not to scratch the Panel Bottom Left L for reuse!

INSTALLATION

Place a new Panel Bottom Left L with a Flex Film Assembly Tool on the Main Frame

Use Side Panel press, Side Panel Press Head and Side Panel Press Pad with the force of 50N for ten seconds. Panel Bottom Left L should be pressed three times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



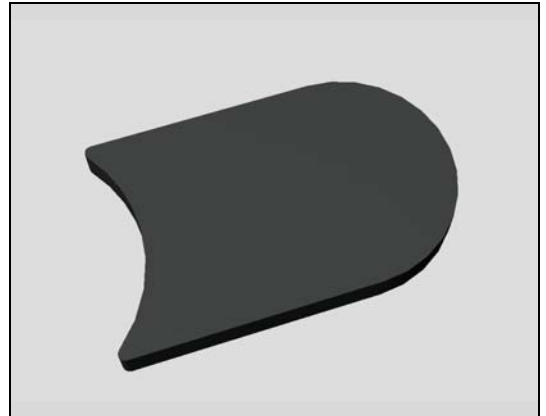
Replacement

4.48 Panel Bottom Left S

Carry out the Removal as described below!

Prepare a new Panel Bottom Left S!

Carry out the Installation as described below!



REMOVAL

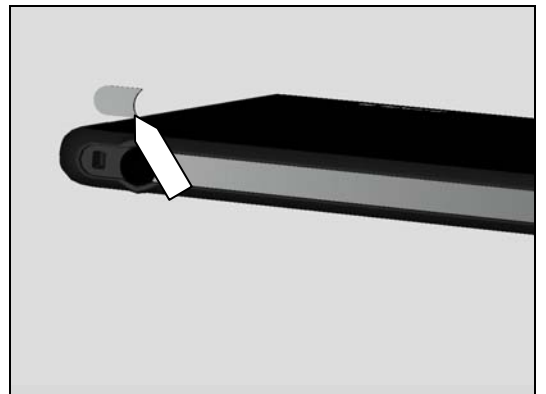
Remove the Panel Bottom Left S with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Panel Bottom Left S with a Flex Film Assembly Tool on the Main Frame.

Note! Press with finger for ten seconds for securing the Panel Bottom Left S.



Replacement

4.49 Panel Left Bottom

Carry out the Removal as described below!

Prepare a new Panel Left Bottom!

Carry out the Installation as described below!

REMOVAL

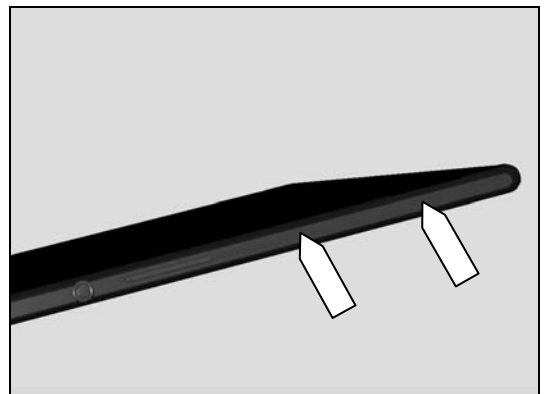
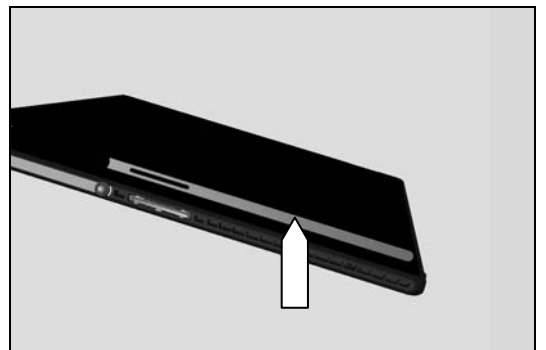
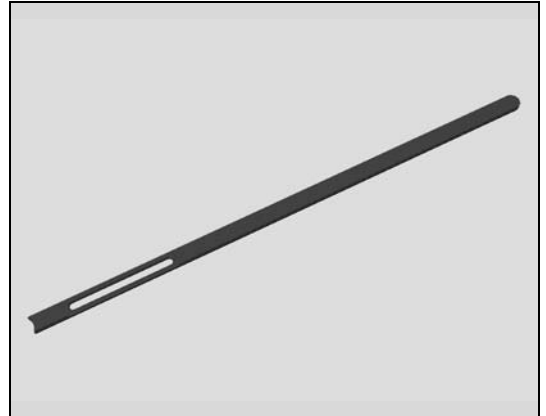
Remove the Panel Left Bottom with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Panel Left Bottom with a Flex Film Assembly Tool on the Main Frame

Use Side Panel press, Side Panel Press Head and Side Panel Press Pad with the force of 50N for ten seconds. Panel Left Bottom should be pressed two times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.50 Panel Left Top

Carry out the Removal as described below!

Prepare a new Panel Left Top!

Carry out the Installation as described below!

REMOVAL

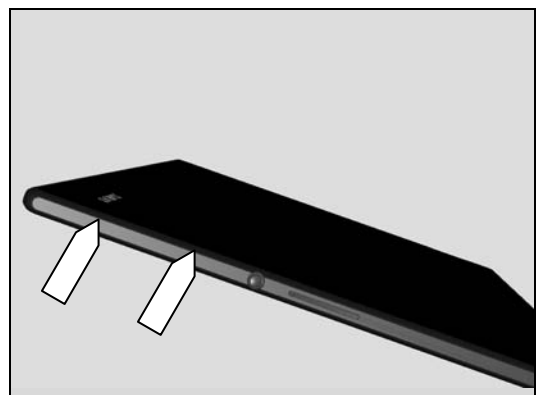
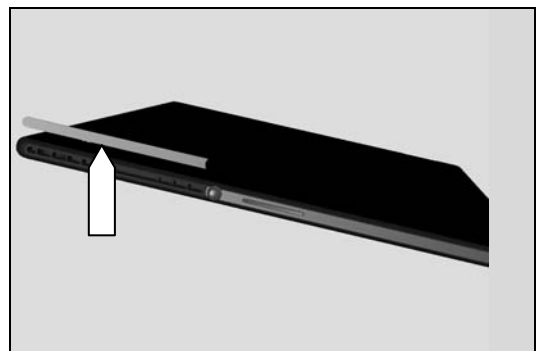
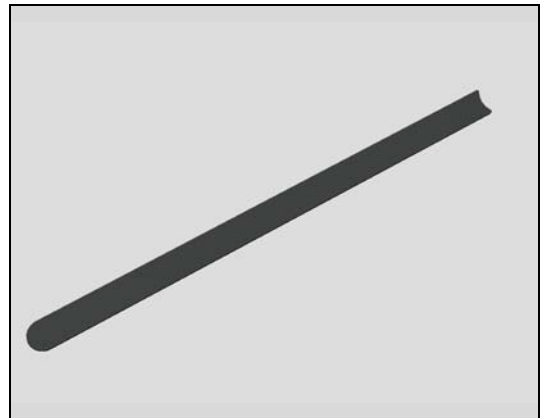
Remove the Panel Left Top with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Panel Left Top with a Flex Film Assembly Tool on the Main Frame

Use Side Panel press, Side Panel Press Head and Side Panel Press Pad with the force of 50N for ten seconds. Panel Left Top should be pressed two times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.51 Panel Right

Carry out the Removal as described below!

Prepare a new Panel Right!

Carry out the Installation as described below!

REMOVAL

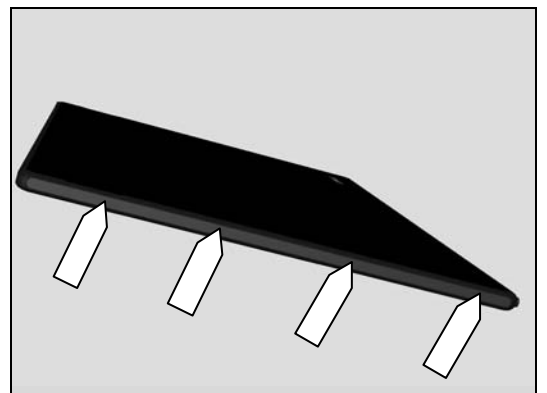
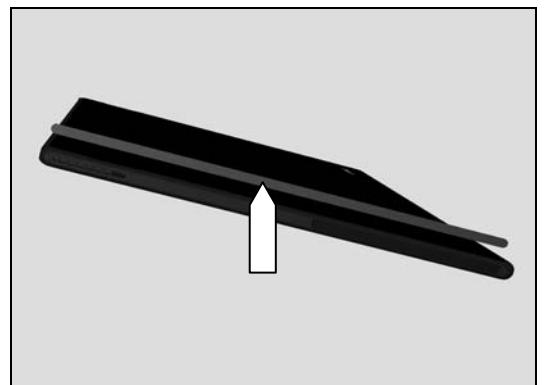
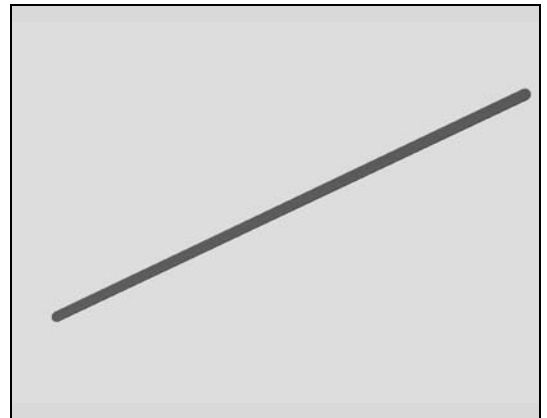
Remove the Panel Right with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Panel Right with a Flex Film Assembly Tool on the Main Frame

Use Side Panel press, Side Panel Press Head and Side Panel Press Pad with the force of 50N for ten seconds. Panel Right should be pressed four times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.52 Panel Top Left

Carry out the Removal as described below!

Prepare a new Panel Top Left!

Carry out the Installation as described below!

REMOVAL

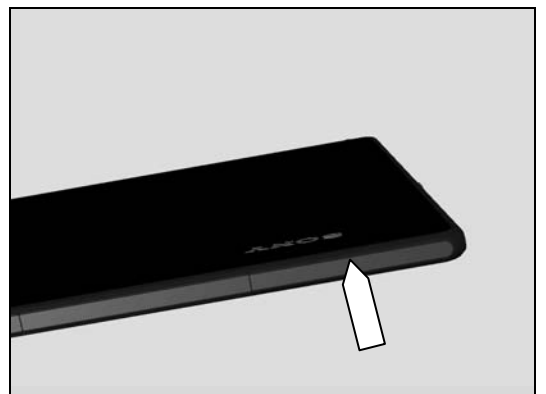
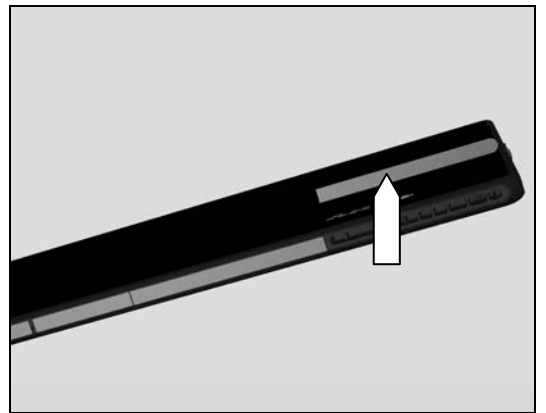
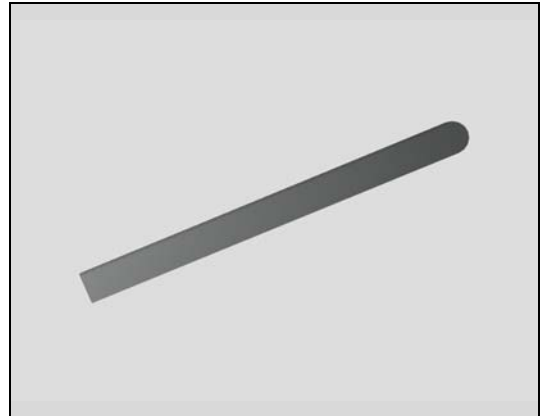
Remove the Panel Top Left with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Panel Top Left with a Flex Film Assembly Tool on the Main Frame.

Use Side Panel press, Side Panel Press Head and Side Panel Press Pad with the force of 50N for ten seconds. Panel Top Left should be pressed one time (see arrow) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.53 Panel Top Right

Carry out the Removal as described below!

Prepare a new Panel Top Right!

Carry out the Installation as described below!

REMOVAL

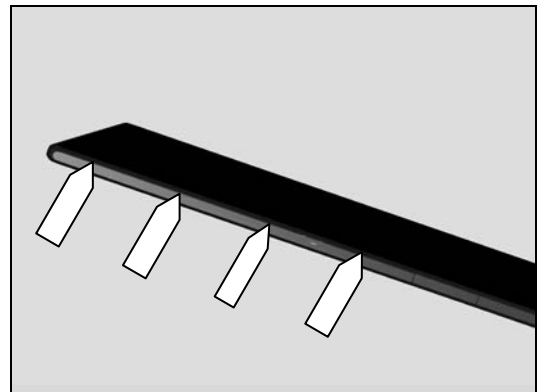
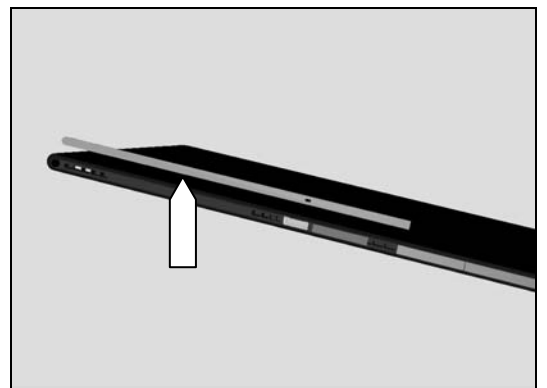
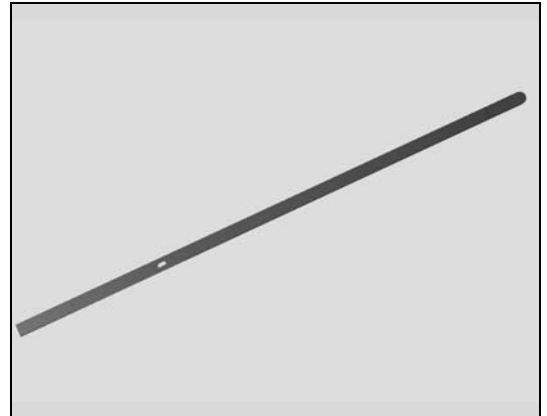
Remove the Panel Top Right with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Panel Top Right with a Flex Film Assembly Tool on the Main Frame

Use Side Panel press, Side Panel Press Head and Side Panel Press Pad with the force of 50N for 10 seconds. Panel Top Right should be pressed four times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.54 Panel WR Bottom

Carry out the Removal as described below!

Prepare a new Panel WR Bottom!

Carry out the Installation as described below!

REMOVAL

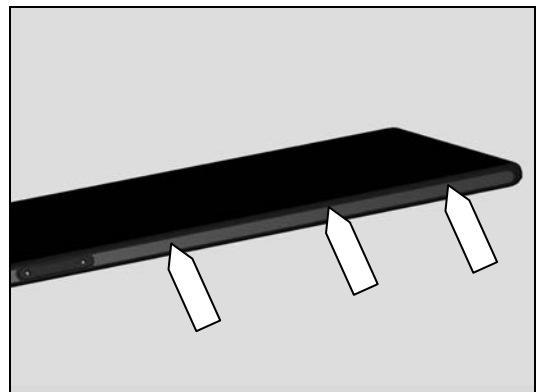
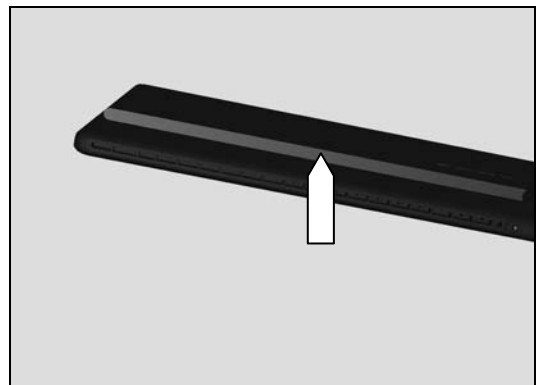
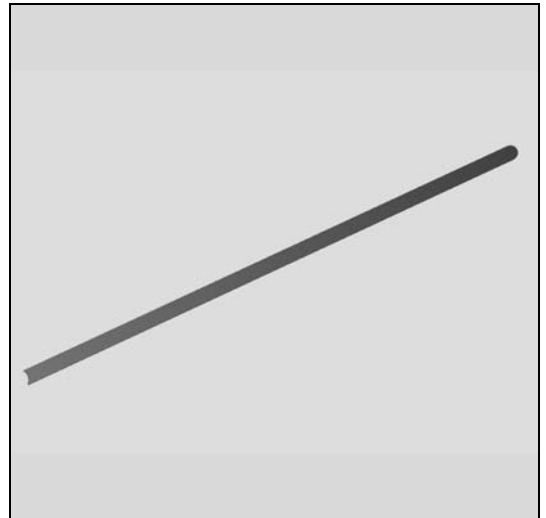
Remove the Panel WR Bottom with the dentist hook

Scrap! Not to be reused!

INSTALLATION

Place a new Panel WR Bottom with a Flex Film Assembly Tool on the Main Frame

Use Side Panel press, Side Panel Press Head and Side Panel Press Pad with the force of 50N for ten seconds. Panel WR Bottom should be pressed three times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.55 RF Cable (N/A SGP511,SGP512)

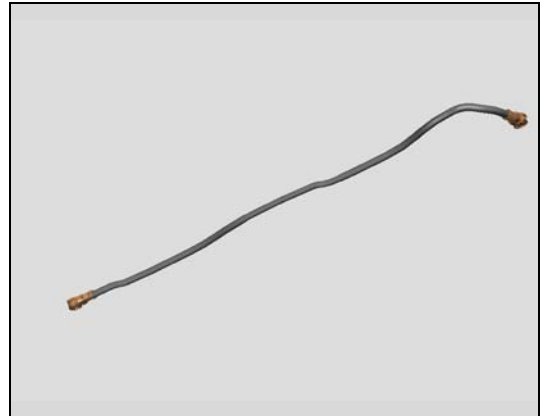
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new RF Cable!

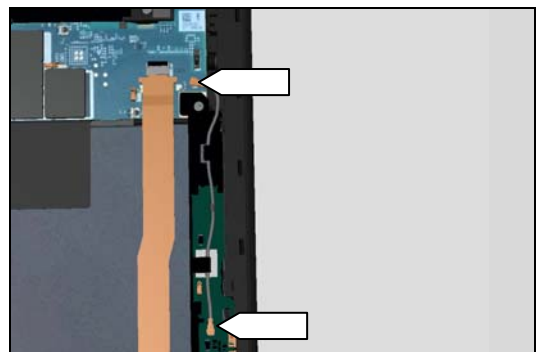
Carry out the Installation as described below!

Follow the 5.25 Reassembly instructions!



REMOVAL

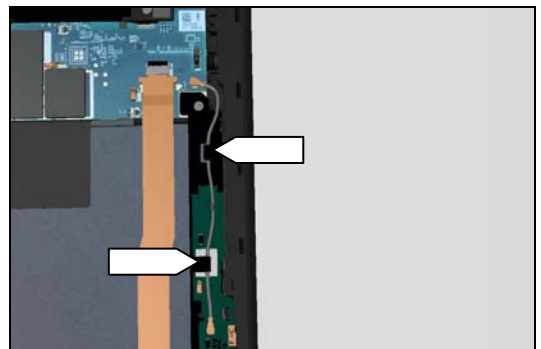
Detach the RF Cable connectors with Front Opening Tool and remove the RF Cable with fingers.



INSTALLATION

Place a new RF Cable using a Flex Film Assembly Tool.

Note! Important that the RF Cable is fastened under the holders on the Carrier Frame Sub PBA



Replacement

4.56 Sheet Window LCD Audio JACK

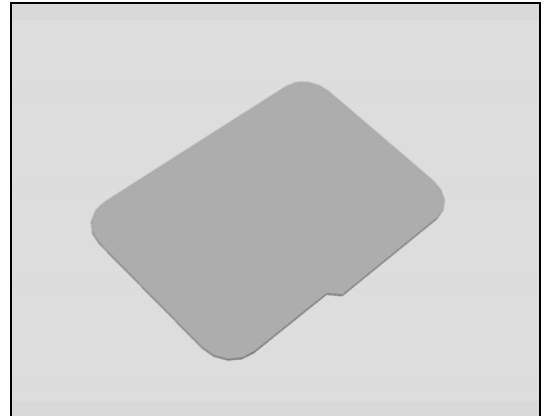
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Sheet Window LCD Audio JACK!

Carry out the Installation as described below!

Follow the 5.25 Reassembly instructions!



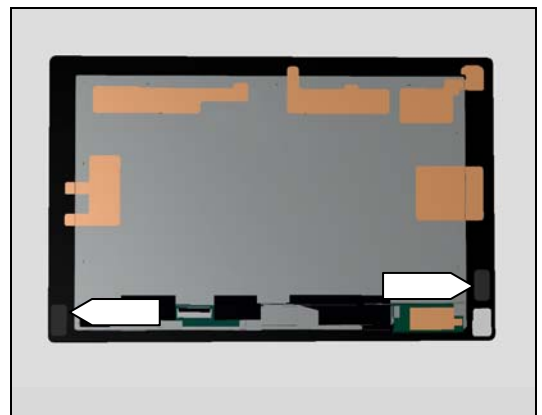
REMOVAL

Detach to remove the Sheet Window LCD Audio JACK with the dentist hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet Window LCD Audio JACK using a Flex Film Assembly Tool on the Display Assembly RoW.



Replacement

4.57 Sheet Window LCD SP

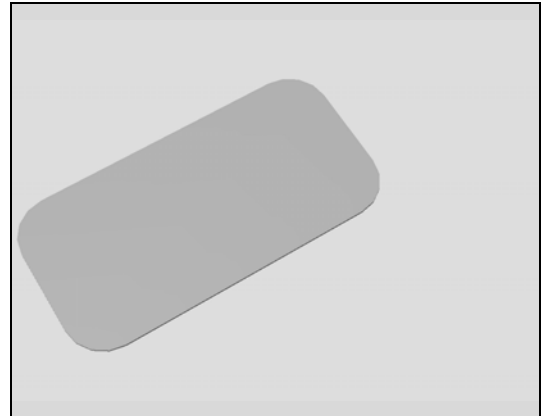
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Sheet Window LCD SP!

Carry out the Installation as described below!

Follow the 5.25 Reassembly instructions!



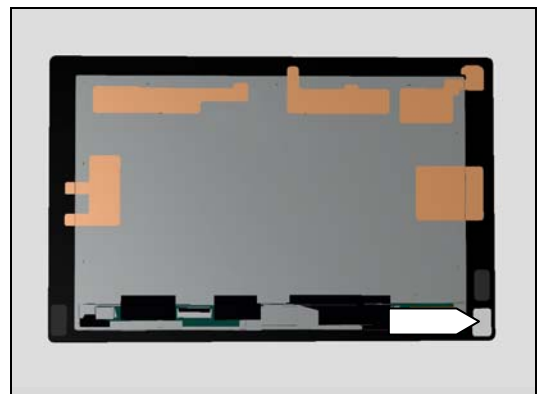
REMOVAL

Detach to remove the Sheet Window LCD SP with Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet Window LCD SP using a Flex Film Assembly Tool on the Display Assembly RoW.



Replacement

4.58 Shield Vibrator

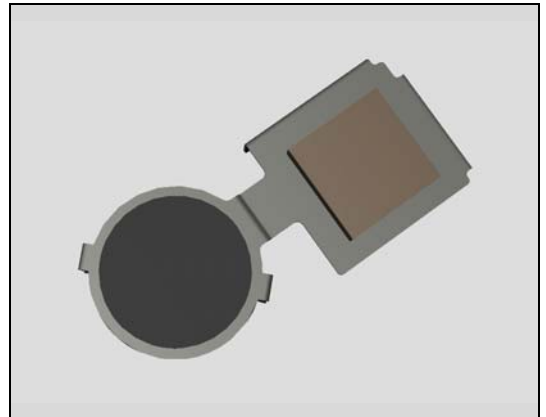
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Shield Vibrator!

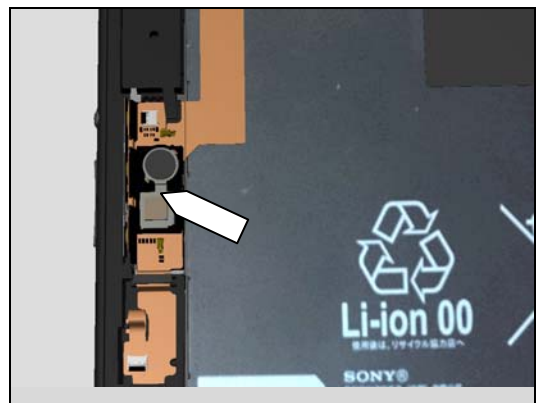
Carry out the Installation as described below!

Follow the 5.25 Reassembly instructions!



REMOVAL

Remove the Shield Vibrator with a pair of tweezers



INSTALLATION

Place a new Shield Vibrator using a Flex Film Assembly Tool on the Holder Vibrator.



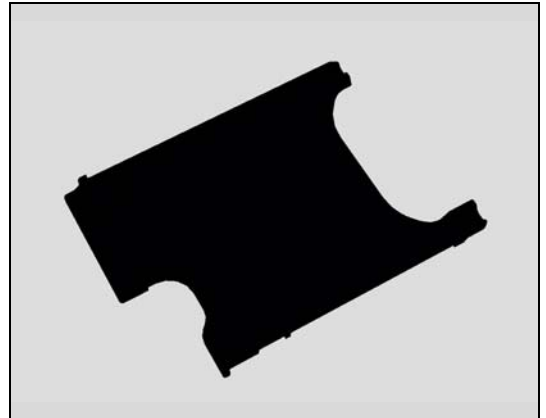
Replacement

4.59 SIM Tray (N/A SGP511 and SGP512)

Carry out the Removal as described below!

Prepare a new SIM Tray!

Carry out the Installation as described below!



REMOVAL

Remove the SIM Tray with fingers.

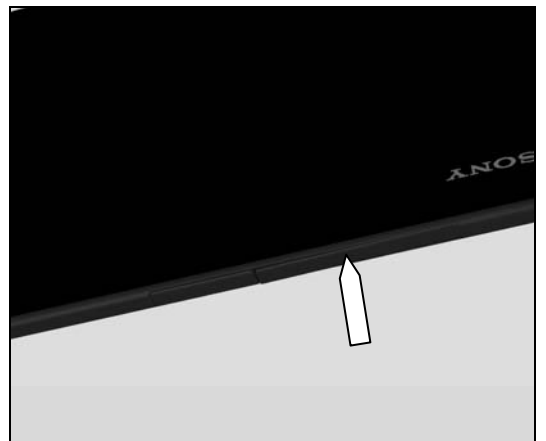


INSTALLATION

Place a new SIM Tray with fingers



Close the Cap SIM.



Replacement

4.60 Sub PBA (N/A SGP511,SGP512)

Follow the 3.1 and 3.17 Disassembly instructions!

Follow the 4.55 Removal instructions!

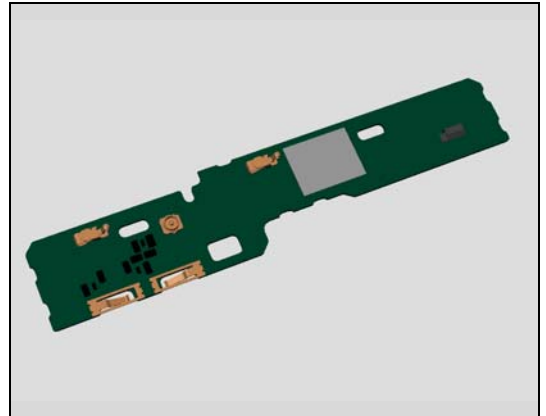
Carry out the Removal as described below!

Prepare a new Sub PBA!

Carry out the Installation as described below!

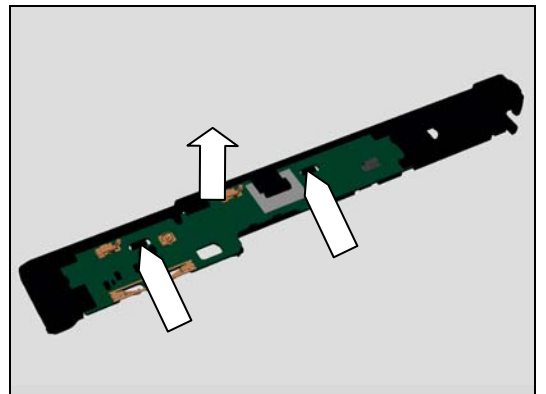
Follow the 4.55 Installation instructions!

Follow the 5.9 and 5.25 Reassembly instructions!



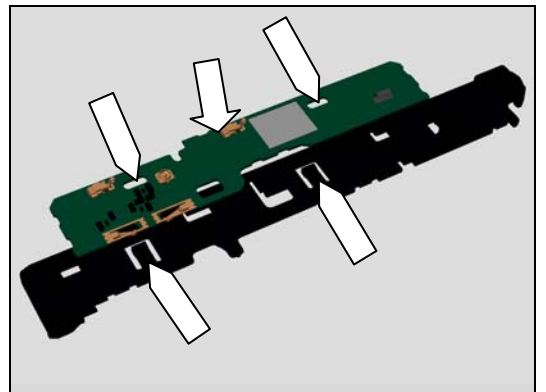
REMOVAL

Detach to remove the Sub PBA by pressing down the two holders on Carrier Frame Sub PBA with a pair of tweezers.



INSTALLATION

Place new Sub PBA using fingers on the Carrier Frame Sub PBA.



Replacement

4.61 Terminal DTV

Follow the 3.1 – 3.3 and 3.9 - 3.19 Disassembly instructions!

Follow the 4.51 and 4.37 Removal instructions!

Carry out the Removal as described below!

Prepare a new Terminal DTV.

Carry out the Installation as described below!

Follow the 4.37 and 4.51 Installation instructions!

Follow the 5.7 – 5.17 and 5.23 - 5.25 Reassembly instructions!

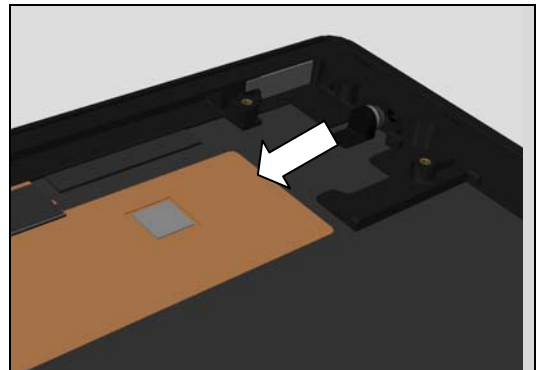


REMOVAL

Remove the Screw Other Len:1.8 Diam:1.4 M with Bits (JCIS No 0)

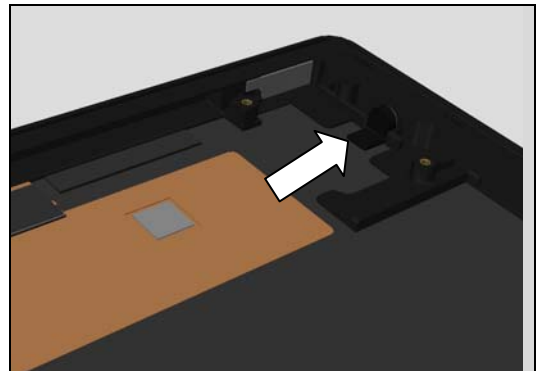


Remove the Terminal DTV with a pair of tweezers.



INSTALLATION

Place a new Terminal DTV to the Main Frame with fingers.
Apply 13 Ncm torque when tightening the Screw Other
Len:2.0 Diam:1.4 with Bits (JCIS No 0).



Re-Assembly

4.62 Water Indicator

Follow the 3.1 and 3.20 – 3.21 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Water Indicator!

Carry out the Installation as described below!

Follow the 5.5 – 5.6 and 5.25 Reassembly instructions!

REMOVAL

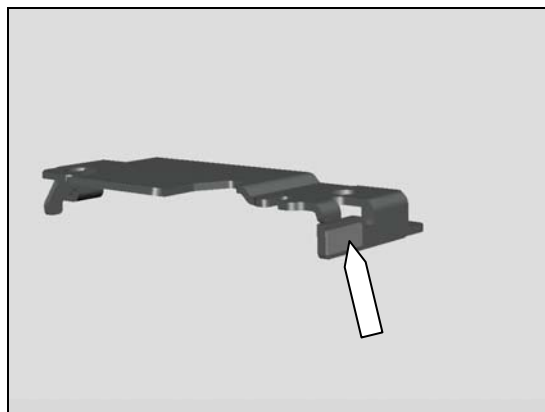
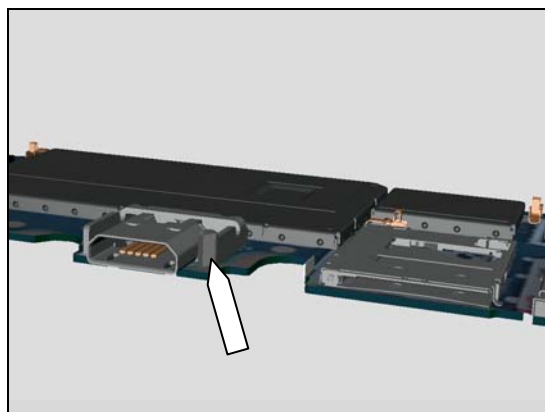
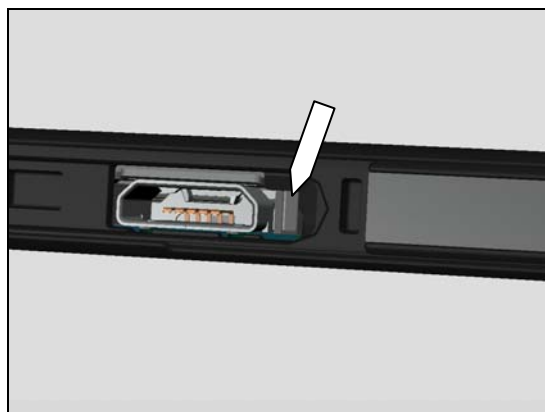
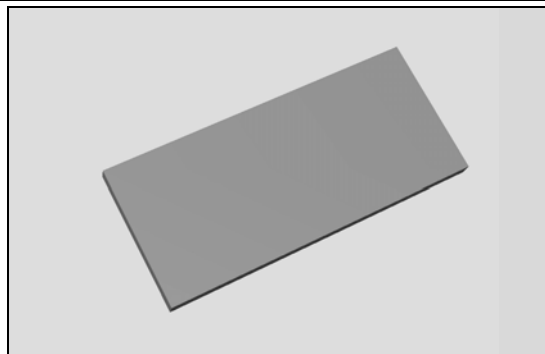
Remove the Water Indicator with a dentist hook.

INSTALLATION

Place a new Water Indicator with a pair of tweezers.

Water Indicator on USB contact

Water Indicator on Plate USB



Replacement

4.63 Vibrator

Follow the 3.1 Disassembly instructions!

Follow the 4.58, 4.42 and 4.28(Note!Only if needed) Removal instructions!

Carry out the Removal as described below!

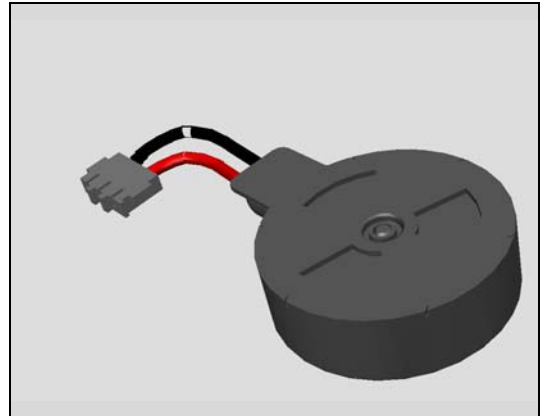
Prepare a new Vibrator!

Carry out the Installation as described below!

Follow the 4.28(Note!Only if needed), 4.42 and 4.58

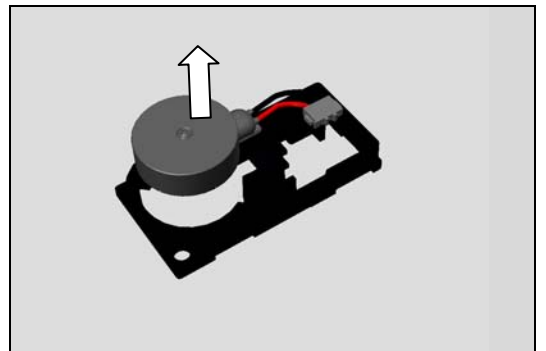
Installation instructions!

Follow the 5.25 Reassembly instructions!



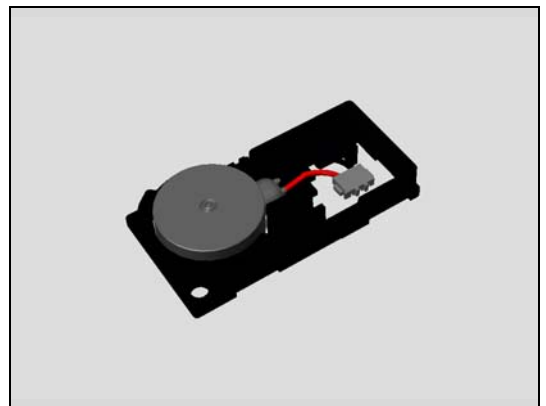
REMOVAL

Remove the Vibrator with fingers from Holder Vibrator.



INSTALLATION

Place new Vibrator using fingers into the Holder Vibrator.



Replacement

4.64 GPS Antenna (SGP561)

Follow the 3.1 – 3.3 and 3.9 - 3.19 Disassembly instructions!

Follow the 4.51 and 4.37 Removal instructions!

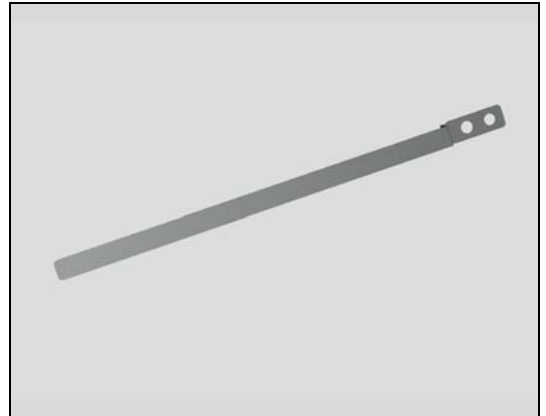
Carry out the Removal as described below!

Prepare a new GPS Antenna.

Carry out the Installation as described below!

Follow the 4.37 and 4.51 Installation instructions!

Follow the 5.7 – 5.17 and 5.23 - 5.25 Reassembly instructions!

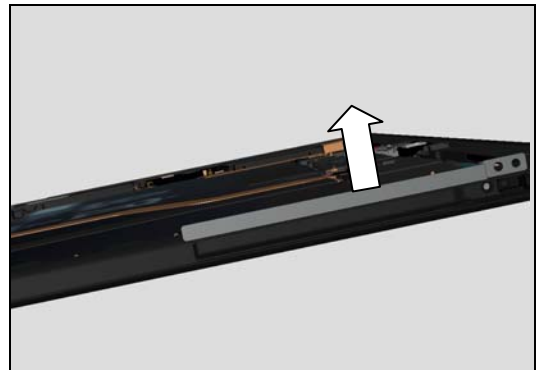


REMOVAL

Remove the Screw Other Len:2.0 Diam:1.4 M with Bits (JCIS No 0)

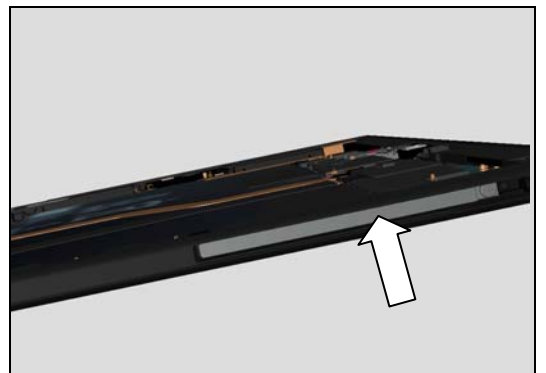


Remove the GPS Antenna with a pair of tweezers.



INSTALLATION

Place a new GPS Antenna to the Main Frame with fingers.
Apply 13 Ncm torque when tightening the Screw Other Len:2.0 Diam:1.4 with Bits (JCIS No 0).



Replacement

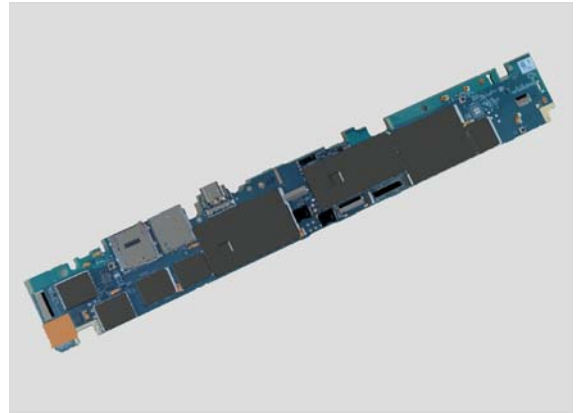
4.65 Board Swap - Replacement

Follow the 3.1 – 3.3 and 3.9 – 3.15 Disassembly instructions!

Follow the 4.19 Removal instructions!

Reuse the Camera 8 MPixel, Camera 2 MPixel, Graphite Sheet PBA and SIM Tray!

Replace the Swap Board.



Follow the 4.19 Installation instructions!

Follow the 5.25 Reassembly instructions!

Press the Key On/Off to power on the unit, place unit on flat desk and wait 4 minutes until system boot up has been completed.

Please DO NOT move the unit during starting up until "Select Language" menu is shown on the display!

After "Select Language" menu, turn off the unit.

Follow the calibrations in Trouble Shooting Application 1262-6643 – mechanical

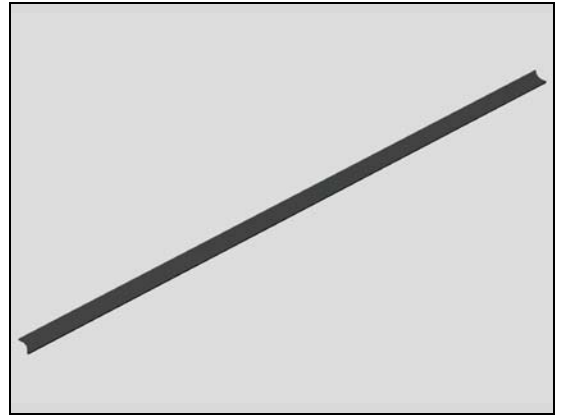
- Proximity Sensor Back (N/A SGP511 and SGP512)
- Accelerometer
- Gyroscope
- Noise cancelling

Replacement

4.66 Board Swap – Change Label

CHANGE PANEL BOTTOM LEFT L

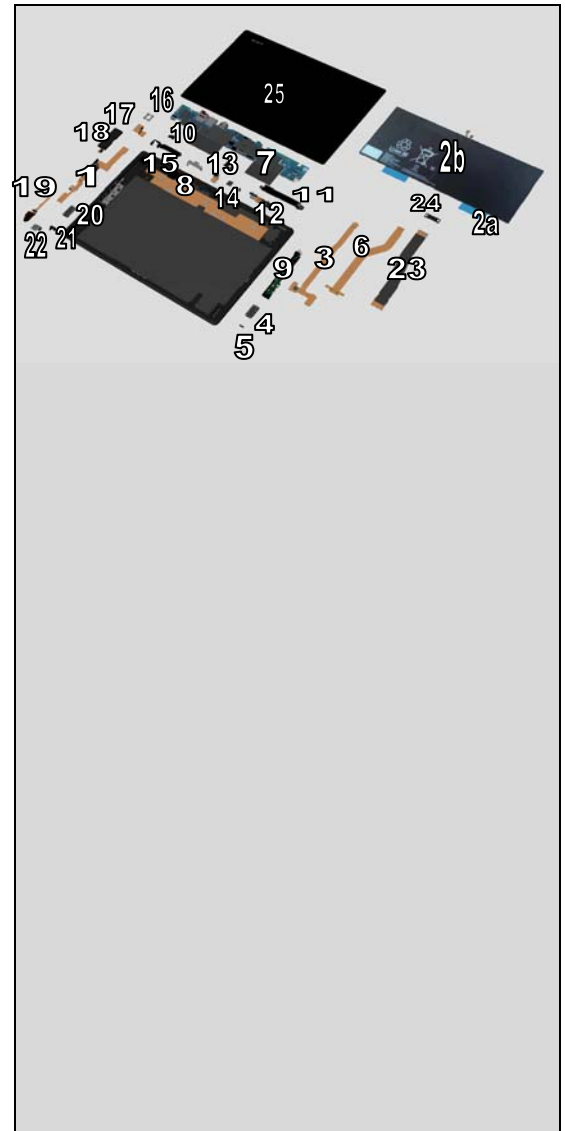
Follow the instructions in the 1221-5655 Generic Repair Manual – Build swap for change of label.



5 Re-Assembly

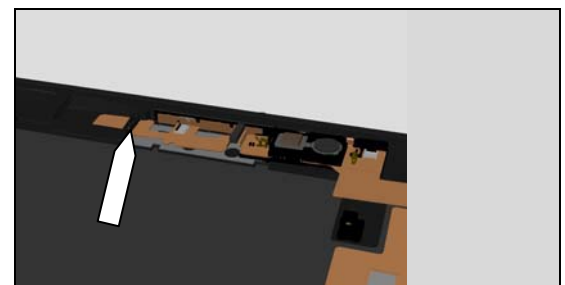
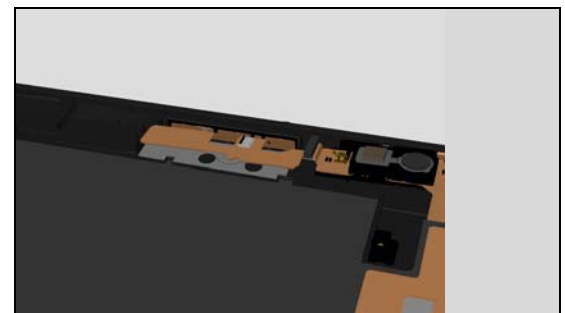
The Re-assembly is done to the following modules:

1. Key Flex module
2. Adhesive Battery (a) and Battery (b)
3. SP Flex
4. Cap SP Assembly (Right)
5. Cushion SPK R
6. Magnetic charger flex
7. Main PBA
8. Plate USB
9. Carrier Frame Sub PBA
10. Holder PBA Screw
11. Main Antenna
12. Sensor Flex
13. Camera 2 MPixel
14. Sheet Chat CAM
15. BT + WLAN + GPS Antenna
16. Holder Main CAM
17. Camera 8 MPixel
18. NFC antenna
19. Audio Jack Flex
20. Cap SP Assembly (Left)
21. Holder Audio Jack
22. Plate Audio Jack
23. Relay LCD Flex
24. Holder Relay LCD BtB
25. Display Assembly RoW



5.1 Key Flex module

Place the Key Flex module with fingers through the first carrier in Main Frame



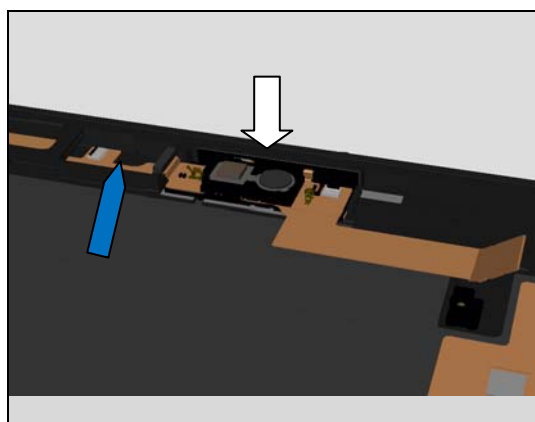
Re-Assembly

Place the Key Flex module with fingers through the second carrier in Main Frame



Position Key Flex module gently into the cavity.

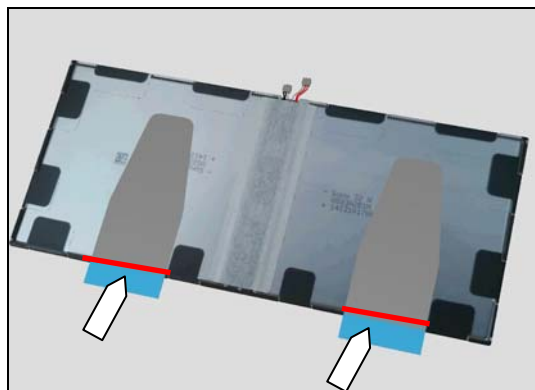
Note! Don't press the adhesive by the ZIF connector (Blue arrow)



5.2 Adhesive Battery and Battery

Reassembly Adhesive Battery on the Battery and press with fingers.

Note! The blue tab should be position exactly at the edge of the Battery, see red line in picture.

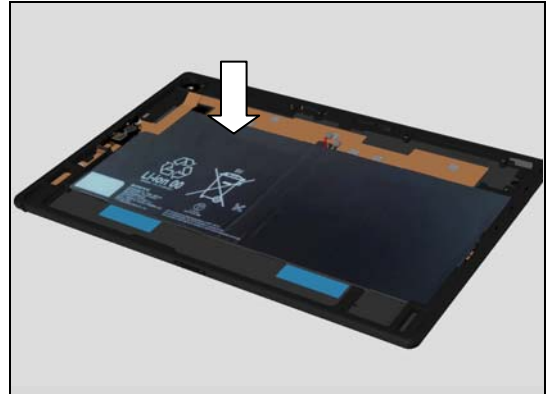


Position Battery using fingers



Re-Assembly

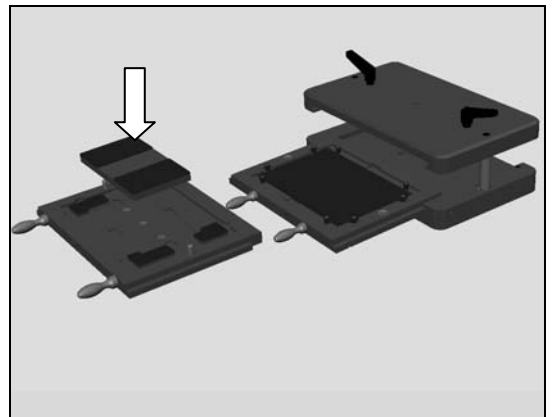
Secure Battery position using fingers



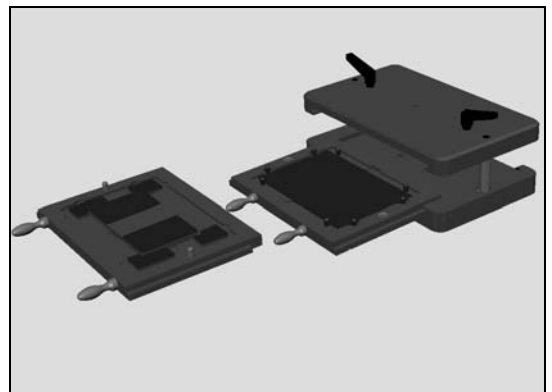
Upper inlay = Display Press Top Inlay Corner + Battery
Press Top Inlay

Lower inlay = Bottom Press Inlay

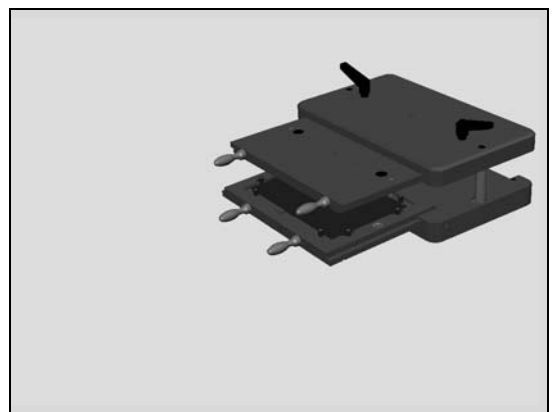
Add the Battery Press Top Inlay to Display Press Top Inlay
Corner



Secure the position of Battery Press Top Inlay on Display
Press Top Inlay Corner

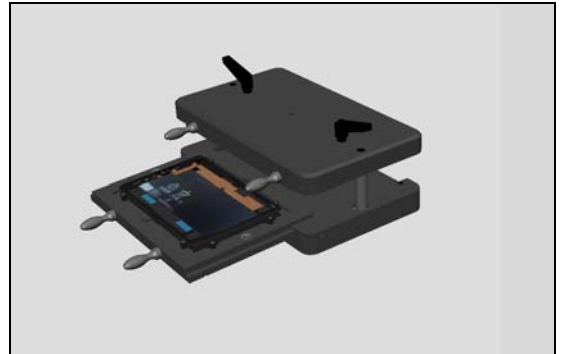


Insert Upper inlay

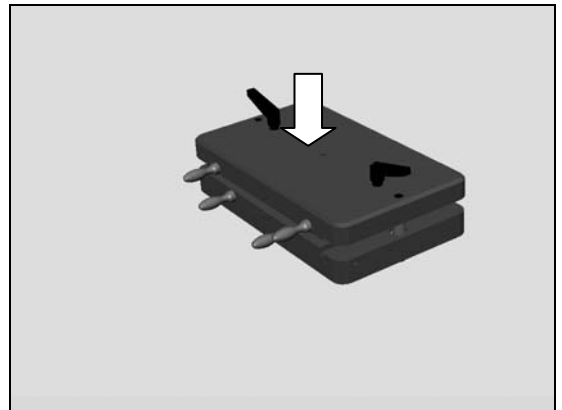


Re-Assembly

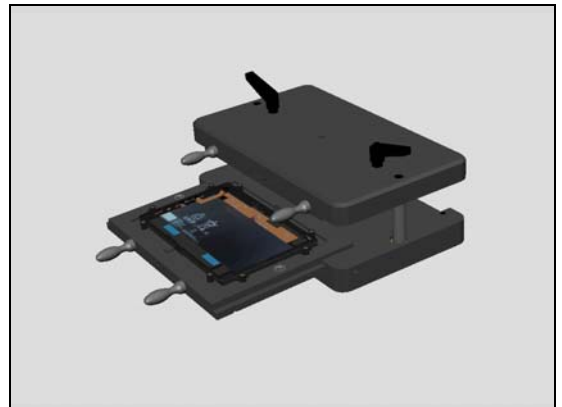
Place the tablet with Main Frame down and Power Button to the left in the Lower Inlay and follow the instruction in 1003-9107 Tool Catalogue – mechanical and document Toothed Rack Press Instruction for use.



Press it with a pressure value of 185N (+-10N) for ten seconds (pressure value is adjust from 300N because of the weight of the press fixture)



Battery is pressed



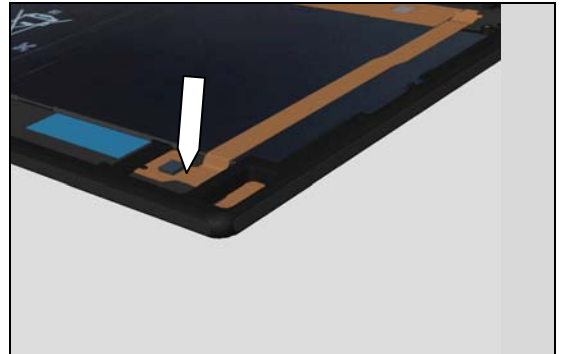
5.3 SP Flex

Place the SP Flex with fingers



Re-Assembly

Position SP Flex gently into the cavity

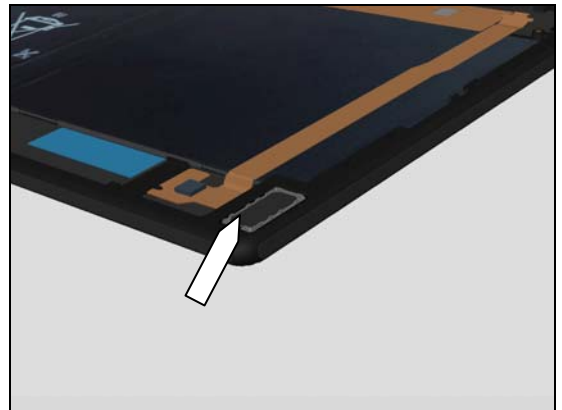


5.4 Cap SP Assembly (Right)

Place the Cap SP Assembly with fingers

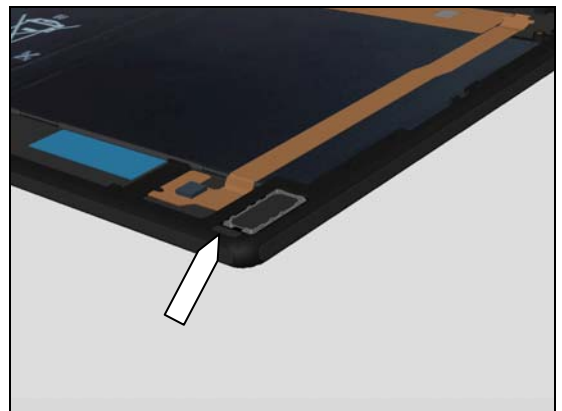


Position Cap SP Assembly gently into the cavity



5.5 Cushion SPK R

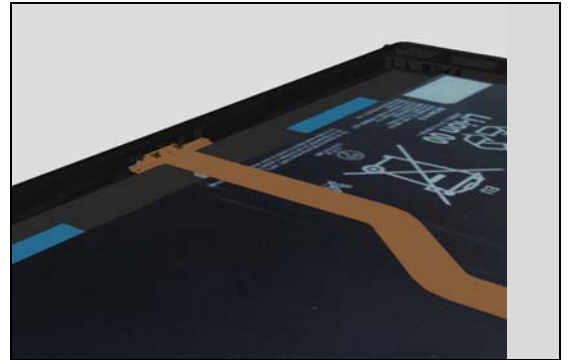
Place the Cushion SPK R with a Flex Film Assembly Tool.



Re-Assembly

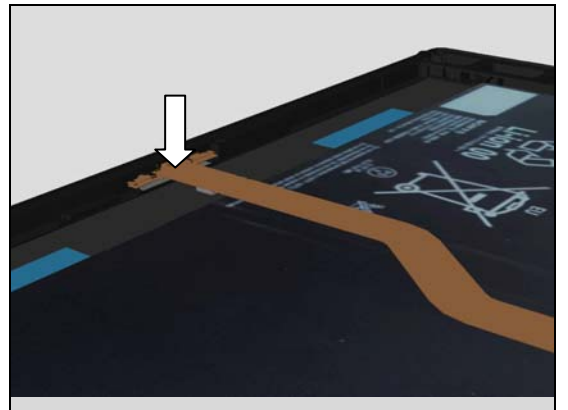
5.6 Magnetic charger flex

Position the Magnetic charger flex with fingers



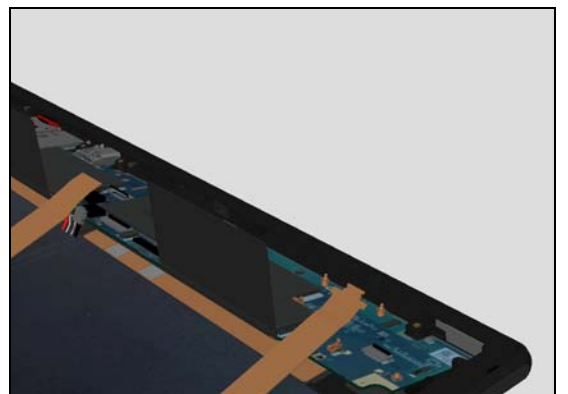
Check and press the two pins into its cavities by using the Front Opening Tool.

Be careful! Do not damage the two pins on Magnetic charger flex and pads on Magnetic charger connector.

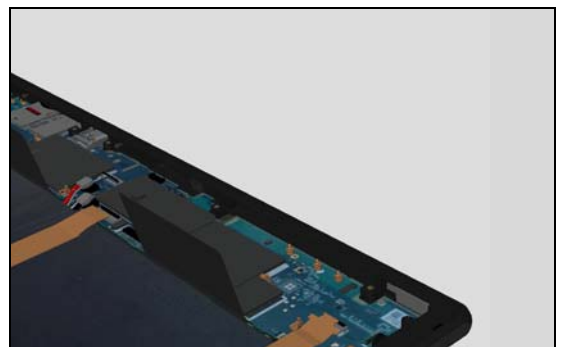


5.7 Main PBA

Position the Main PBA with fingers

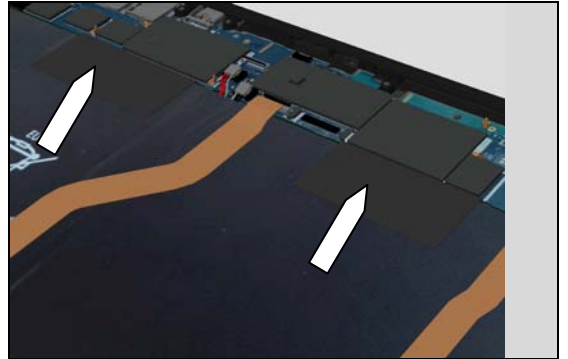


Secure Main PBA position using fingers

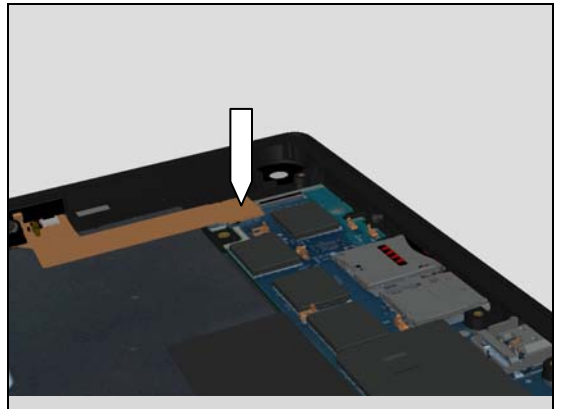


Re-Assembly

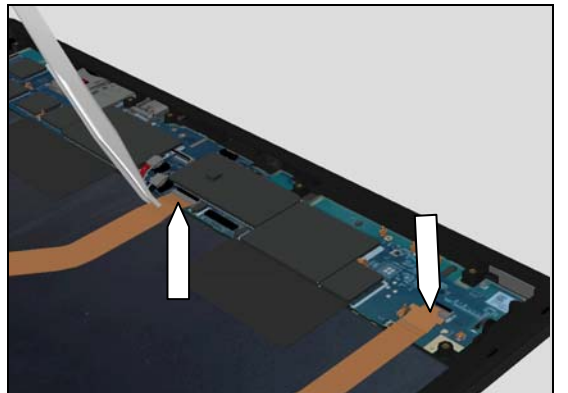
Fold down and attach the Graphic Sheet PBA



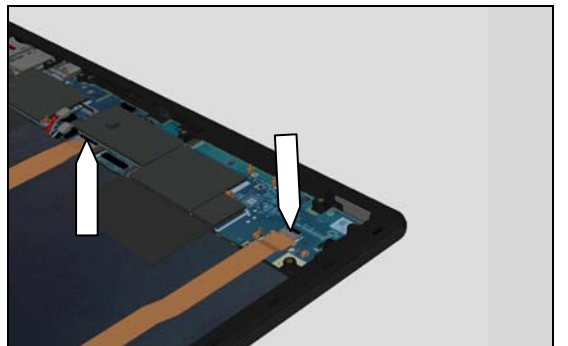
Press with fingers to secure the contact of BtB connector.



Use Flex Film Assembly Tool for secure the flexes into the ZIF contacts.



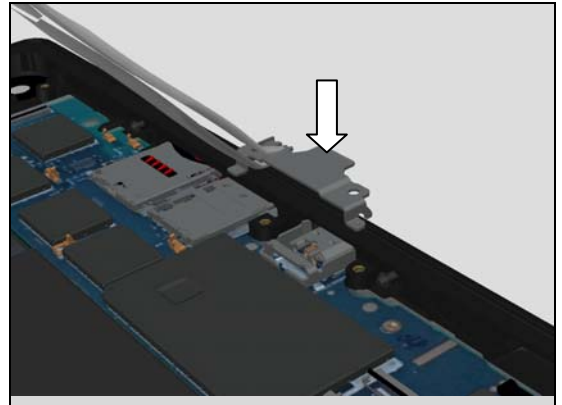
Close the ZIF contacts.



Re-Assembly

5.8 Plate USB

Place the Plate USB on Main PBA.

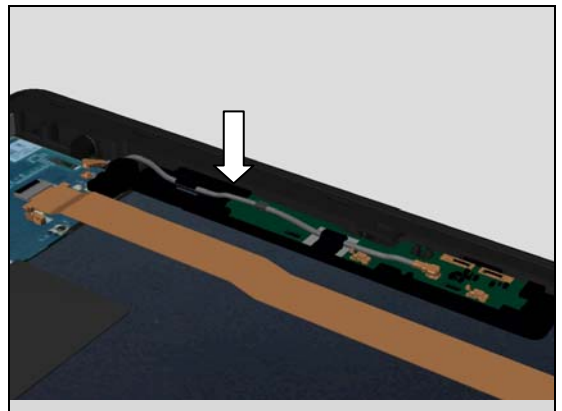


Apply 13 Ncm torque when tightening Screw M1.4X3.0 with Bits (JCIS No 0).

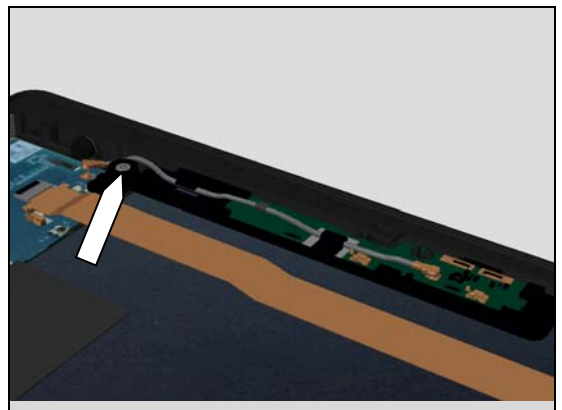


5.9 Carrier Frame Sub PBA

Position the Carrier Frame Sub PBA with fingers

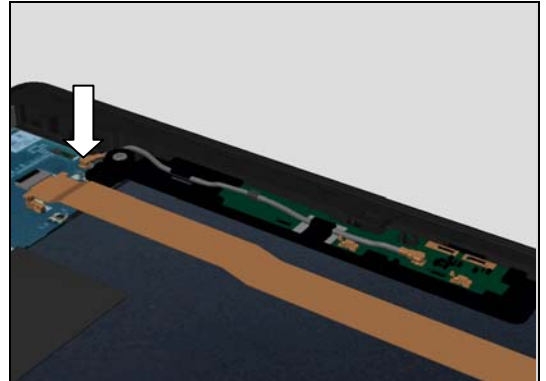


Apply 13 Ncm torque when tightening Screw M1.4X3.0 with Bits (JCIS No 0).



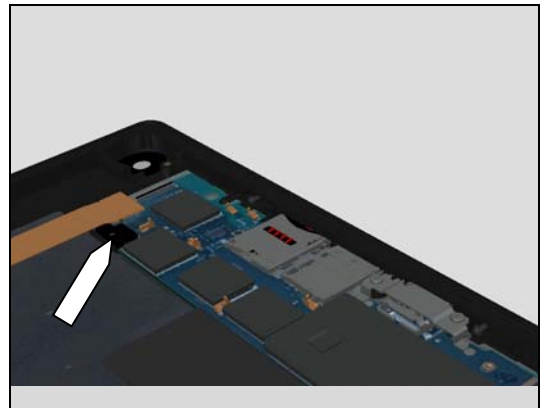
Re-Assembly

Press RF Cable connector with fingers

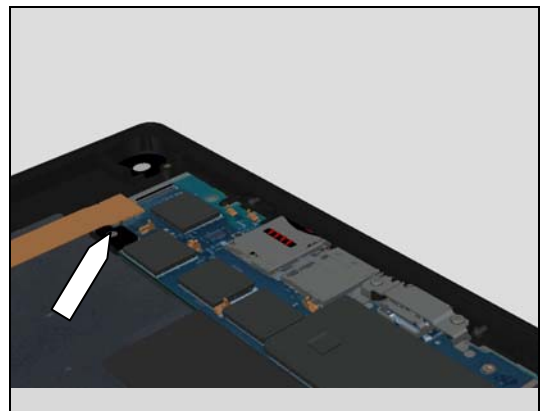


5.10 Holder PBA Screw

Position Holder PBA Screw with a pair of tweezers

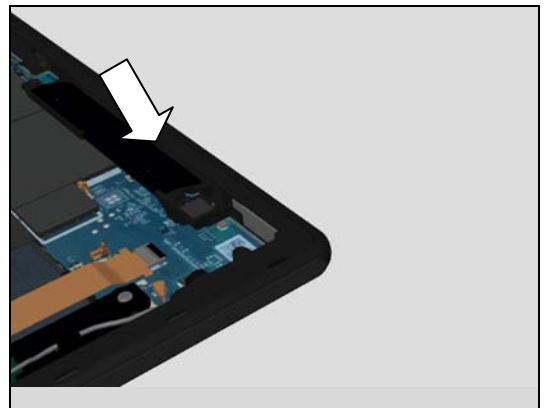


Apply 13 Ncm torque when tightening the Screw Other
Len:1.8 Diam:1.4 M with Bits (JCIS No 0).



5.11 Main Antenna

Place the Main Antenna into the cavity with fingers



Re-Assembly

Secure position with fingers

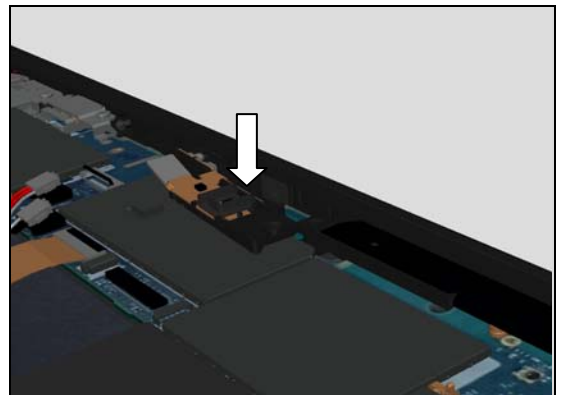


Apply 13 Ncm torque when tightening Screw M1.4X3.0 with Bits (JCIS No 0).

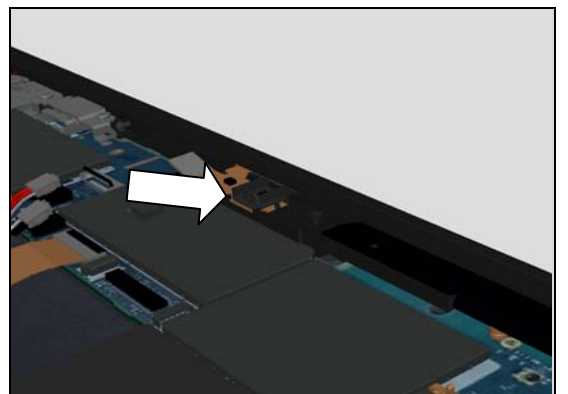


5.12 Sensor Flex

Place the Sensor Flex into the cavity with fingers

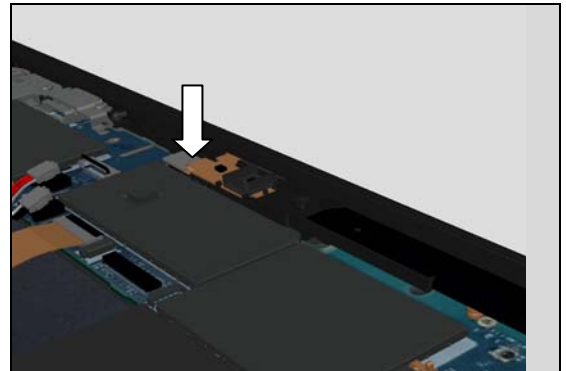


Secure position with fingers

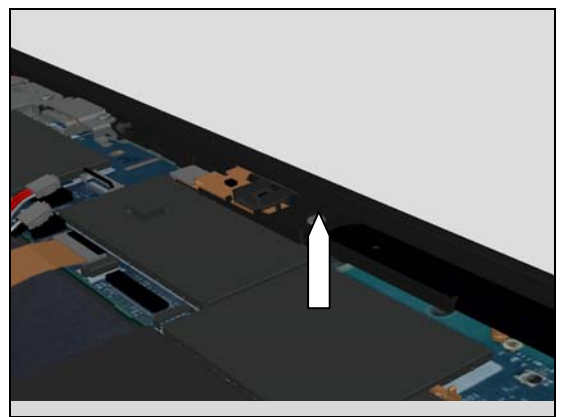


Re-Assembly

Press with fingers to secure the contact of BtB connector

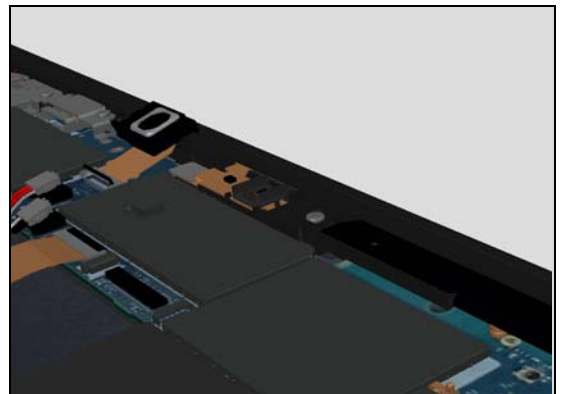


Apply 13 Ncm torque when tightening Screw M1.4X3.0 with Bits (JCIS No 0).

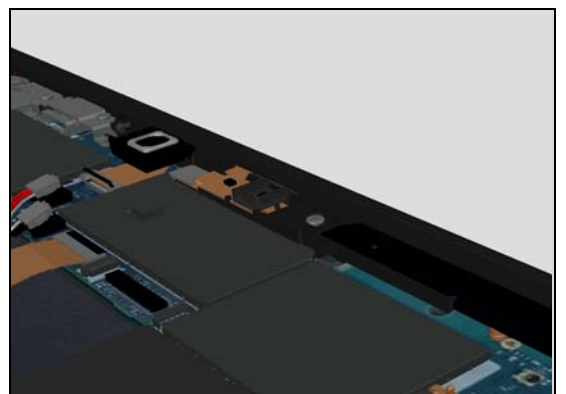


5.13 Camera 2 MPixel

Position Camera 2 MPixel with Flex Film Assembly Tool.

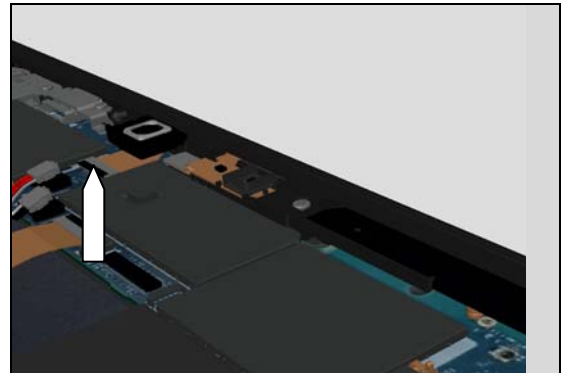


Use Flex Film Assembly Tool for secure the flex into the ZIF contact.



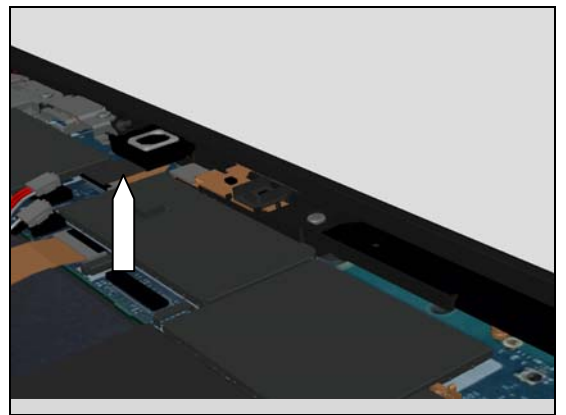
Re-Assembly

Close the ZIF contact.



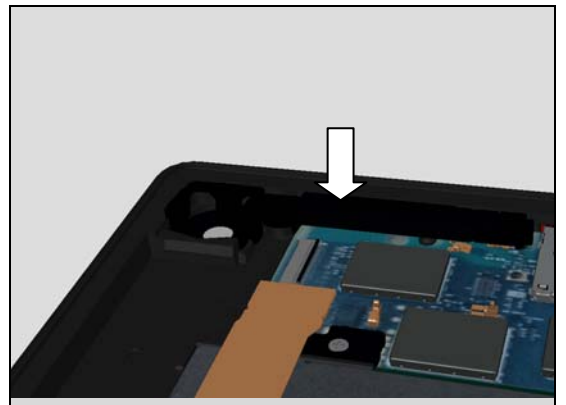
5.14 Sheet Chat CAM

Place the Sheet Chat CAM with a pair of tweezers.

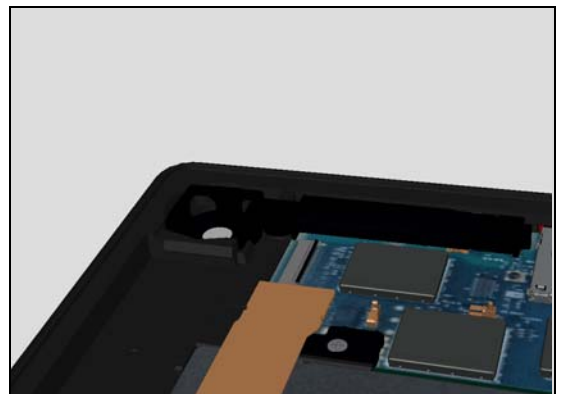


5.15 BT + WLAN + GPS Antenna

Place the BT + WLAN + GPS Antenna into the cavity with fingers



Secure position with fingers

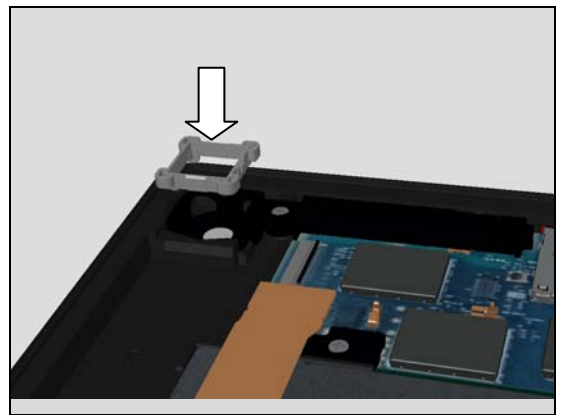
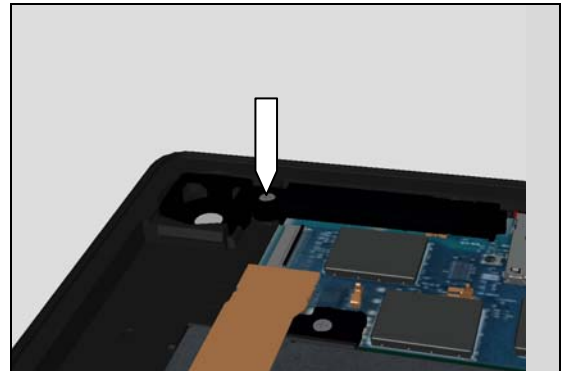


Re-Assembly

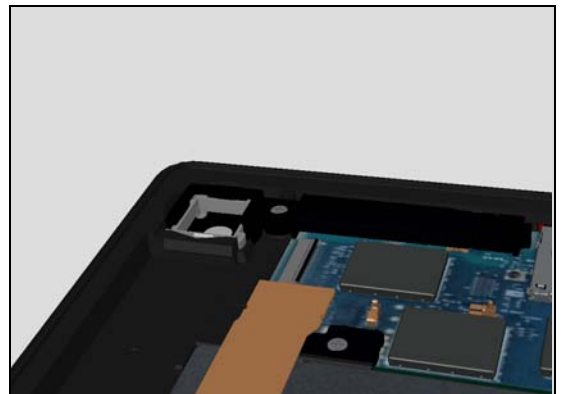
Apply 13 Ncm torque when tightening Screw M1.4X3.0 with Bits (JCIS No 0).

5.16 Holder Main CAM

Place the Holder Main CAM into the cavity with fingers

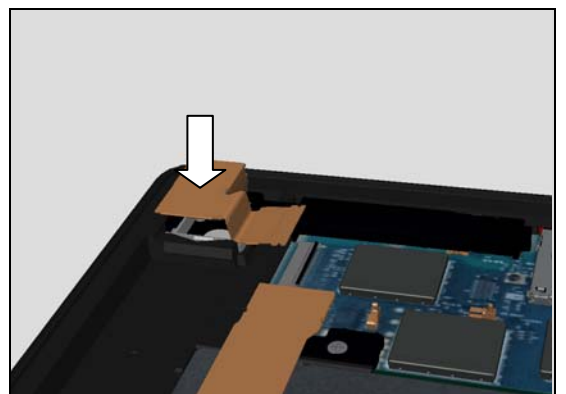


Secure position with fingers



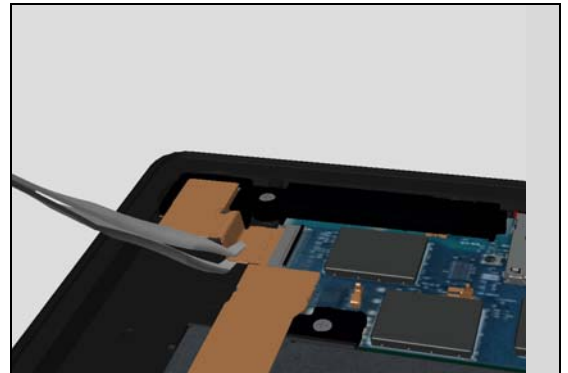
5.17 Camera 8 MPixel

Place the Camera 8 MPixel into the cavity with fingers

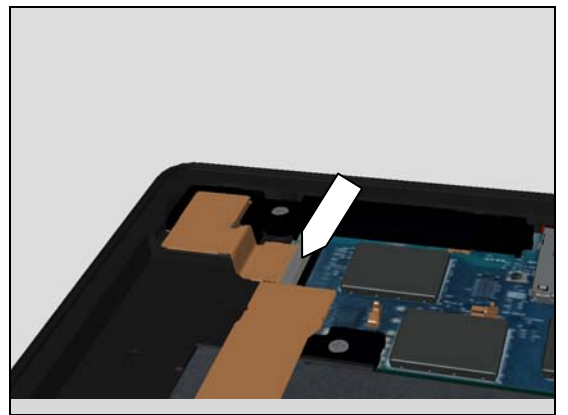


Re-Assembly

Use Flex Film Assembly Tool to secure the flex into the ZIF contact.

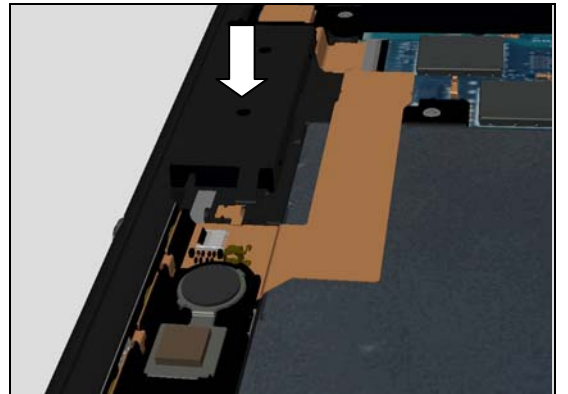


Close the ZIF contact.

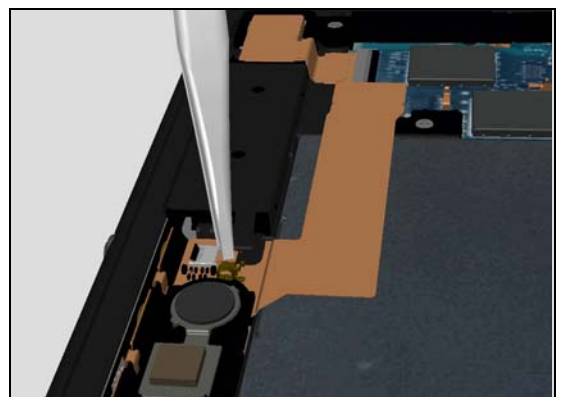


5.18 NFC antenna

Place the NFC antenna into the cavity with fingers

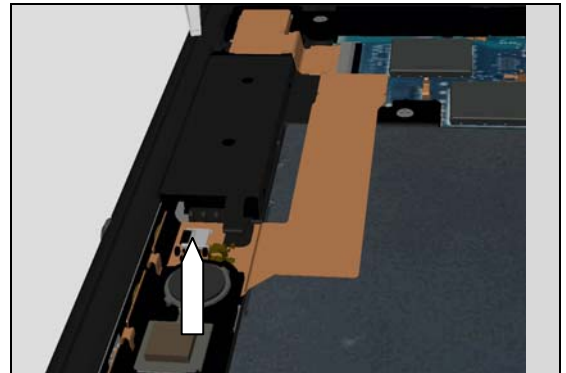


Use Flex Film Assembly Tool to secure the flex into the ZIF contact.



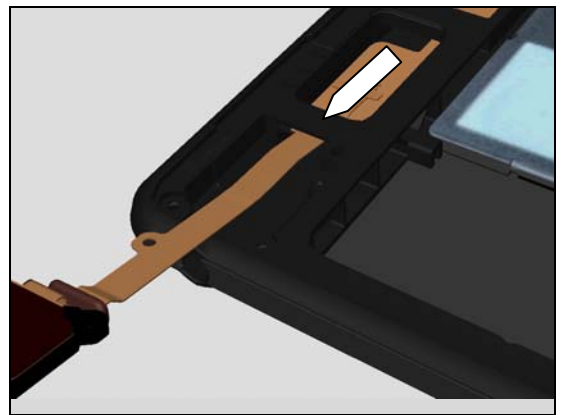
Re-Assembly

Close the ZIF contact.



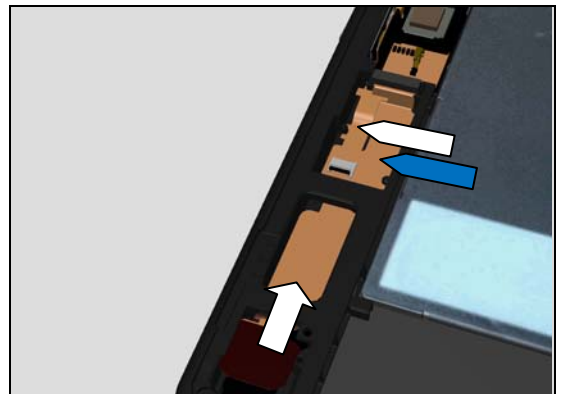
5.19 Audio Jack Flex

Place the Audio Jack Flex through the carrier in Main Frame

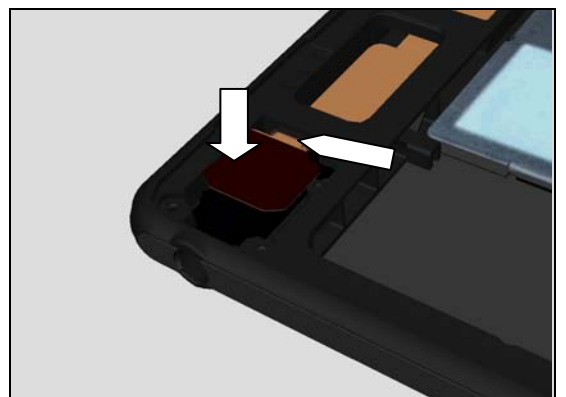


Note! Audio Jack Flex should be under the Key Flex module. To be able to connect to the ZIF contact on Key Flex module.

Then press the Key Flex module (see blue arrow) to attach adhesive.



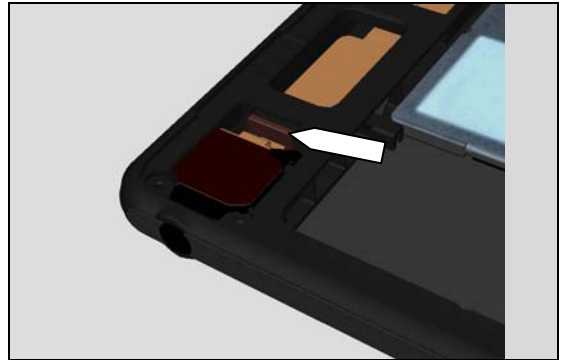
Place the Audio Jack Flex into the cavity with fingers and secure the WRT gasket against the carrier on Main Frame



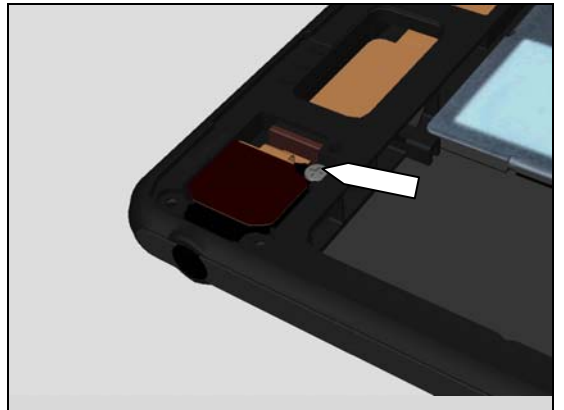
Re-Assembly

Secure the position of Audio Jack Flex

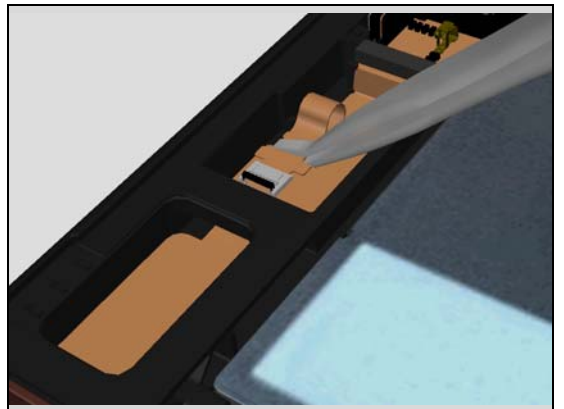
Note! Make sure the WRT gasket on Audio Jack Flex is sealed against Main Frame



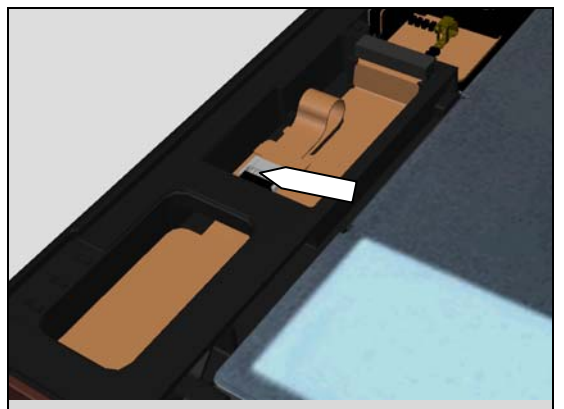
Apply 13 Ncm torque when tightening Screw 1.4X3.5 with Bits (JCIS No 0).



Use Flex Film Assembly Tool for secure the flex into the ZIF contact.



Close the ZIF contact.

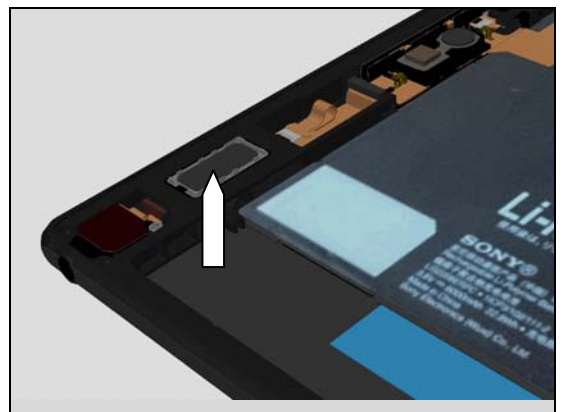
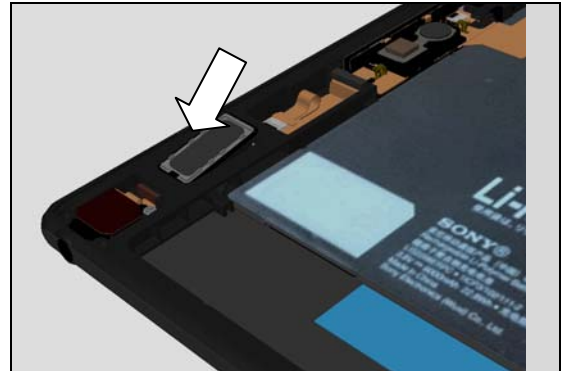


Re-Assembly

5.20 Cap SP Assembly (Left)

Place the Cap SP Assembly with fingers

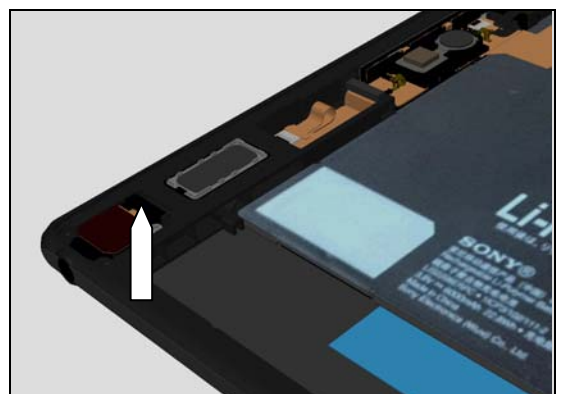
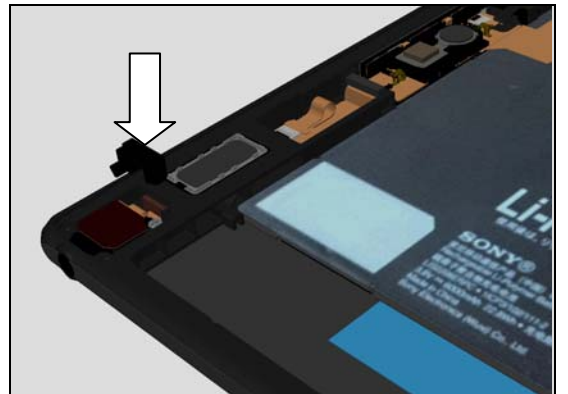
Position Cap SP Assembly gently into the cavity



5.21 Holder Audio Jack

Place the Holder Audio Jack with a pair of tweezers.

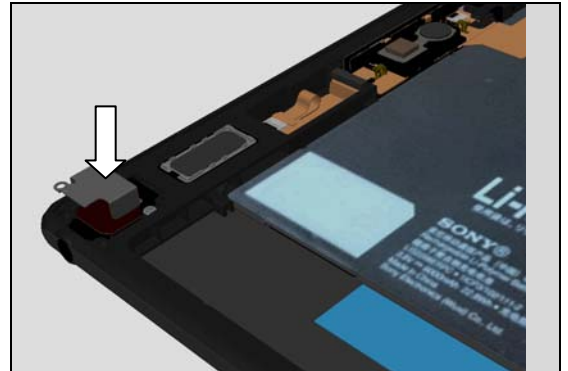
Secure Holder Audio Jack with fingers



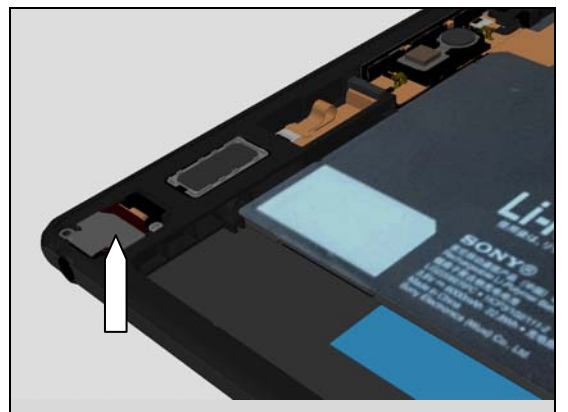
Re-Assembly

5.22 Plate Audio Jack

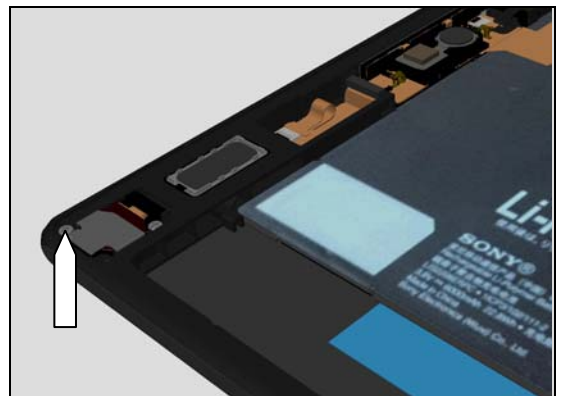
Place the Plate Audio Jack with a pair of tweezers.



Secure Plate Audio Jack with fingers

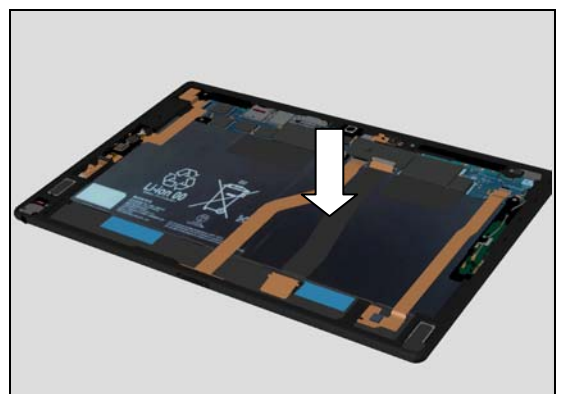


Apply 13 Ncm torque when tightening Screw 1.4X3.5 with Bits (JCIS No 0).



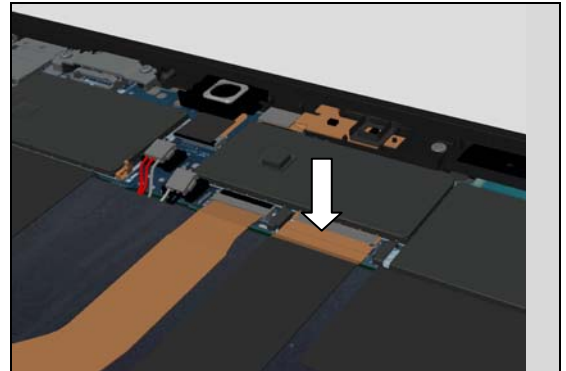
5.23 Relay LCD Flex

Position Relay LCD Flex with Flex Film Assembly Tool



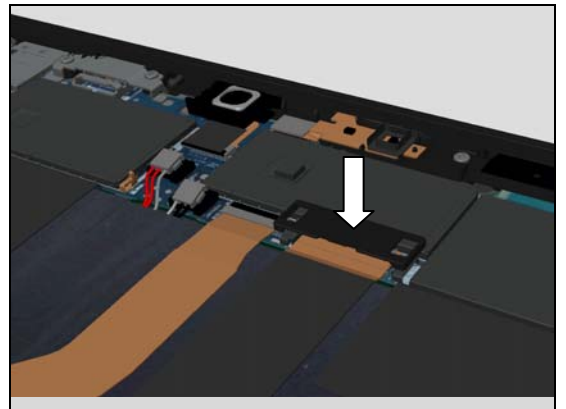
Re-Assembly

Press with fingers to secure the contact of BtB connector

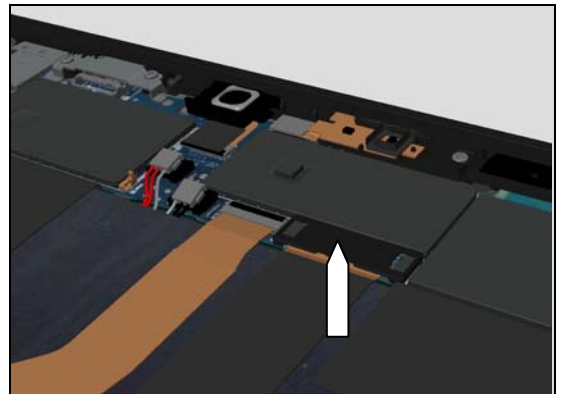


5.24 Holder Relay LCD BtB

Place the Holder Relay LCD BtB with fingers.

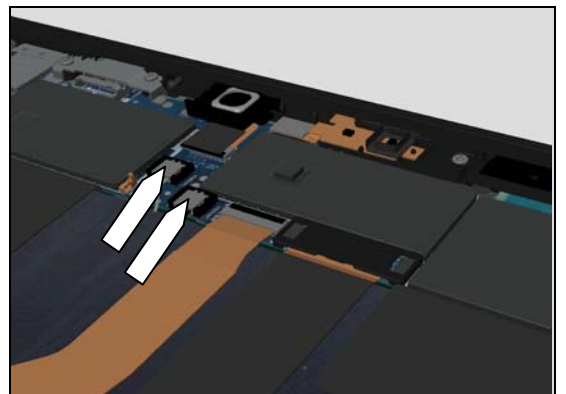


Press with fingers to secure the contact of Holder Relay LCD BtB



5.25 Display Assembly RoW

Press to secure the contact of battery connectors



Re-Assembly

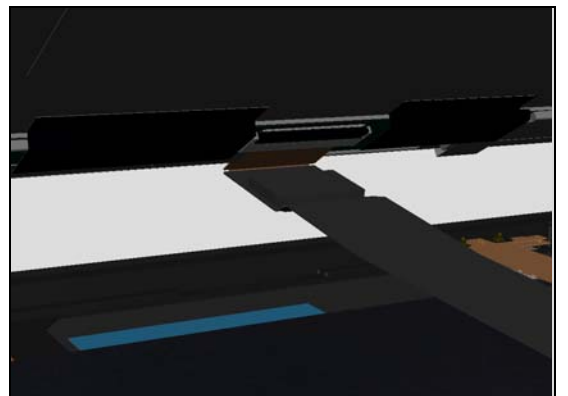
Position the Display Assembly RoW



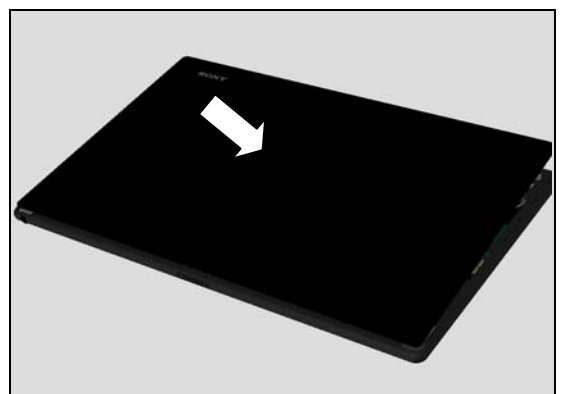
Use Flex Film Assembly Tool to secure the flex into the ZIF contact.



Close the ZIF contact.



Position Display Assembly RoW using fingers

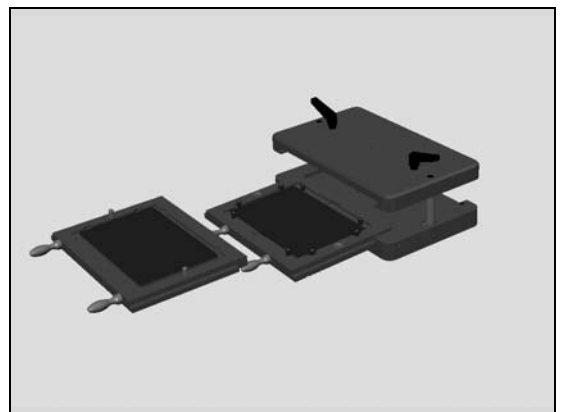


Re-Assembly

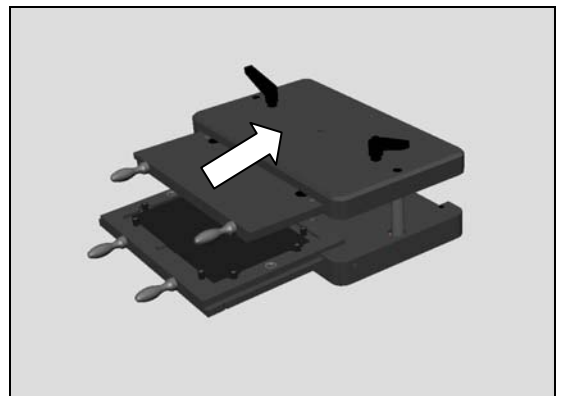
Secure Display Assembly RoW position using fingers



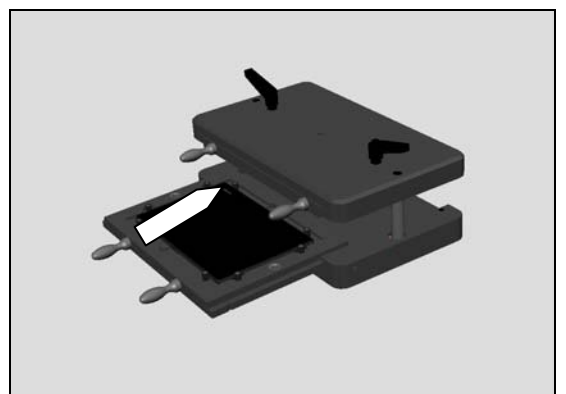
Upper inlay = Display Press Top Inlay Edges
Lower inlay = Bottom Press Inlay



Insert the Upper Inlay

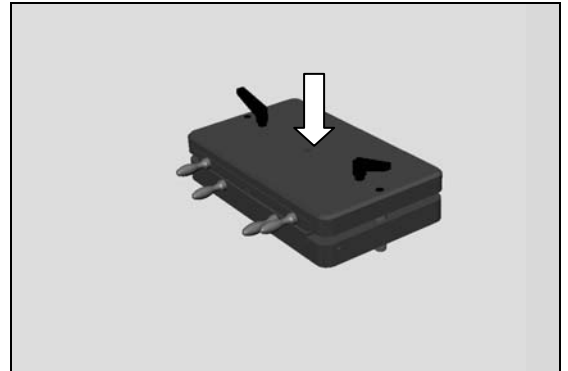


Place the unit with Display up and Sony brand top left of the Lower Inlay (see arrow) and follow the instruction in 1003-9107 Tool Catalogue – mechanical and document Toothed Rack Press Instruction for use.

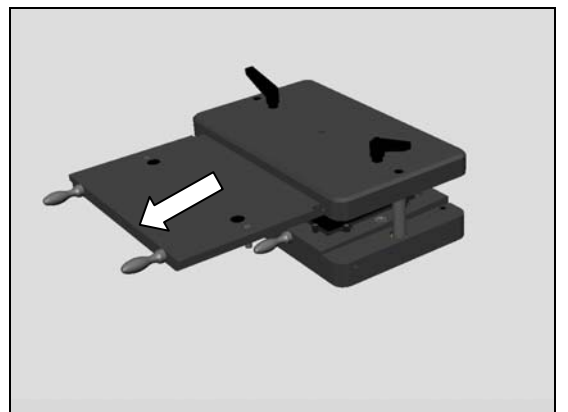


Re-Assembly

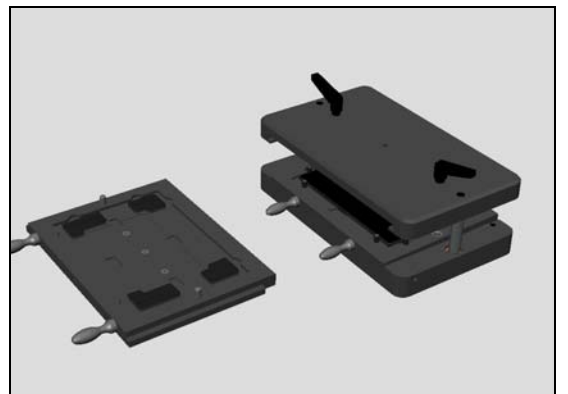
Press it with a pressure value of 930N (+-10N) for ten seconds (pressure value is adjust from 1040N because of the weight of the press fixture)



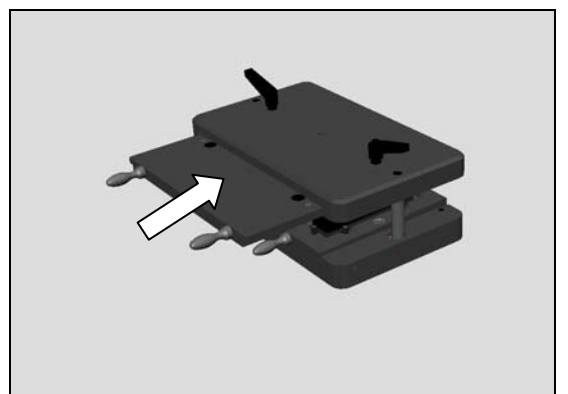
Take out Upper inlay



Upper inlay = Display Press Top Inlay Corner
Lower inlay = Bottom Press Inlay



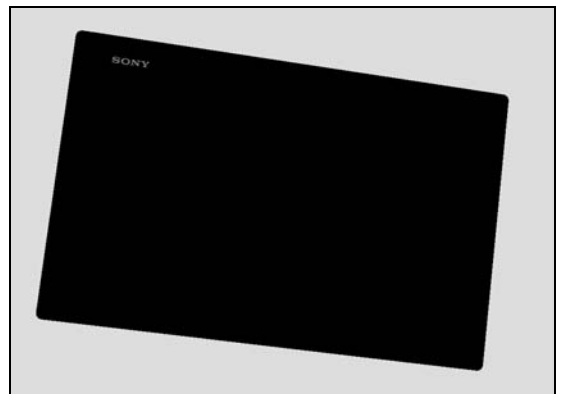
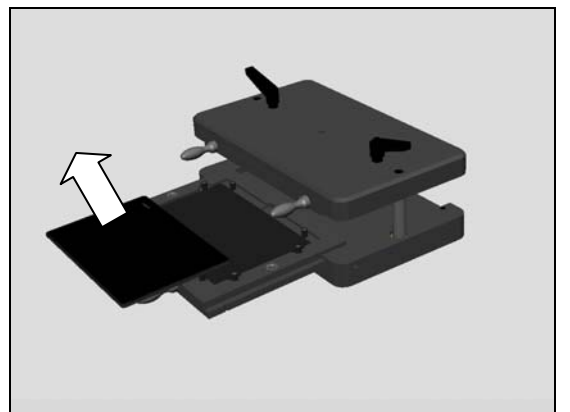
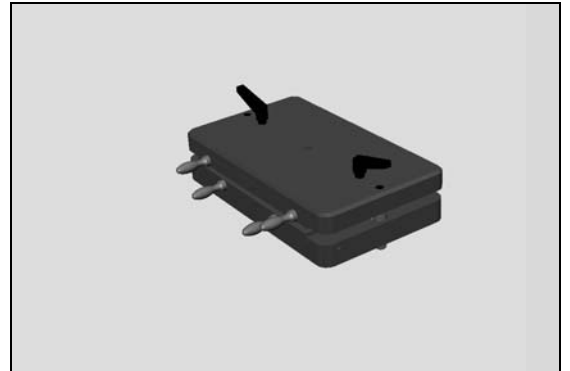
Insert Upper inlay



Re-Assembly

Press it with a pressure value of 370N (+-10) for ten seconds
(pressure value is adjust from 480N because of the weight of
the press fixture)

Take it out



6 Revision History

Rev.	Date	Changes / Comments
1	2014-Mars-18	Initial Release
2	2014-Mars-22	Updated Display press process in Reassembly chapter
3	2014-April-11	Updated with SGP551
4	2014-July-03	Updated with SGP561 and chapter 4.64