



Working Instruction, Mechanical

Applicable for W710, Z710

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1 General

1.1 Phone Portions – Base and Flip

This document uses the hinge of the phone to divide the phone into two portions. The portion of the phone that contains the keypad will be referred as the base. The portion of the phone that contains the displays will be referred as the flip. The basic disassembly and reassembly procedures will be structured around these two distinct portions.



1.2 Using Hand and ESD Protection

When handling this product, keep all surfaces clean of dirt, dust, debris, and hand oil. Use appropriate ESD precautions when working on this product. The use of finger cots or gloves, an ESD mat, and an ESD wrist strap are required at minimum.

1.3 Protection of Displays, Lenses, and Windows

Any time the screen portion of a display assembly, the windows of a display cover, or a camera lens is unprotected and exposed, add a protective film over the exposed part to reduce the amount of dust, finger prints, debris, and/or damage that the part may obtain.



1.4 Acceptable Pry Tools

Whenever the phrase “pry tool” is used, a nylon pointer or a front opening tool may be used depending on the user’s preference.

1.5 Tools and Equipment

The following tools and equipment should be available while performing the procedures.

Standard Tools

- Torque Driver
- Nylon Pointer
- Style 2A Tweezers – Rounded Tip
- Dental Hook



Product Specific Tools

- Torx size 6 Bit (T6 bit)



1.6 General Cautions

The following cautions are considered to be generic for all products and will not be repeated in the Disassembly, Reassembly, and Replacements sections:

- **SWITCH OFF THE PHONE AND REMOVE ANY MEMORY STICK BEFORE THE START OF THE DISASSEMBLY!**
- **KEEP ALL CONTACT SURFACES CLEAN!**
- **BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, PRY TOOLS, ETC. TO AVOID SCRATCHES OR DAMAGES TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!**
- **BE CAREFUL NOT TO DAMAGE ANY CONTACT SPRINGS!**
- **REMEMBER TO REMOVE THE PROTECTION FOILS ON NEW PARTS SUCH AS THE FRONT COVER AND LCD!**
- **NEVER TOUCH THE DISPLAY GLASS!**

2 Disassembly

2.1 Base Portion Disassembly

The following subsections make up the “Base Portion Disassembly” procedure. These subsections are arranged in the order that they must be performed to properly disassemble the base portion of this product. Before starting disassembly, check whether there is a protective film over the two display windows. If one or both of the windows lack a protective film, clean the unprotected window(s) and add a protective film.

2.1.1 Battery Door Removal

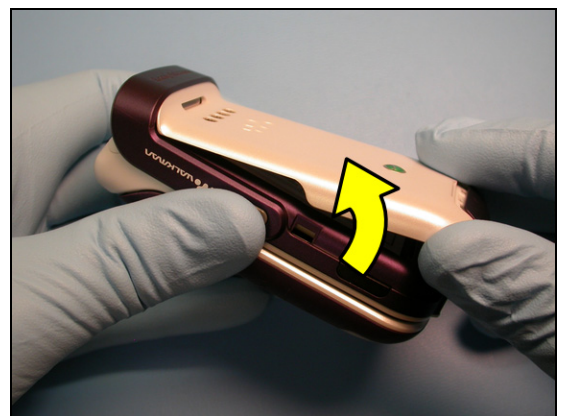
1. Position the phone with the battery door toward you.



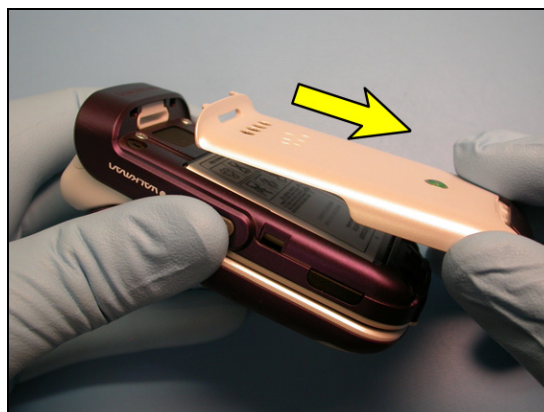
2. Slide the latch on the system connector end of the battery door in the direction shown.



3. Lift the end of the battery door containing the latch about 30 degrees from the phone as indicated.



4. Pull the battery door away from the phone as shown.



2.1.2 Battery Removal

All of the sections of the base portion disassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

NOTE! *DO NOT TAP THE PHONE AGAINST A HARD SURFACE IN AN ATTEMPT TO GET THE BATTERY OUT. DAMAGE TO THE PHONE MAY RESULT!*

1. Lift the end of the battery from the battery cavity using the access point indicated. Use a pry tool if needed.





2. Once the end of the battery being lifted is clear of the battery cavity, lift the battery from the phone and set it aside.



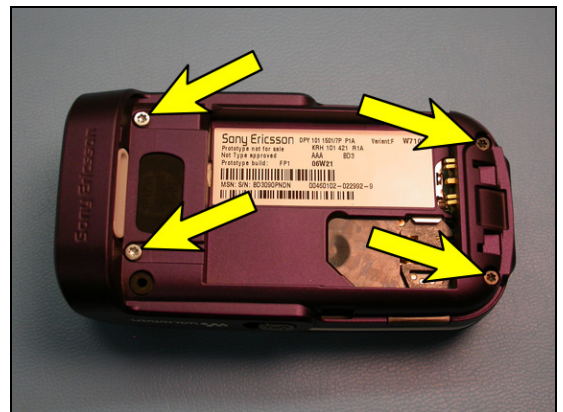
2.1.3 Outer Base Cover Removal

All of the sections of the base portion disassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Close the flip and base portions of the phone together.



2. Use a torque driver with a T6 bit to remove the four screws indicated.





3. Insert the flat end of a pry tool in the seam near the system connector where the inner and outer base covers come together.



4. Gently slide the pry tool along the seam until you reach the corner of the antenna cover. The two base covers should now be unlatched along that side.



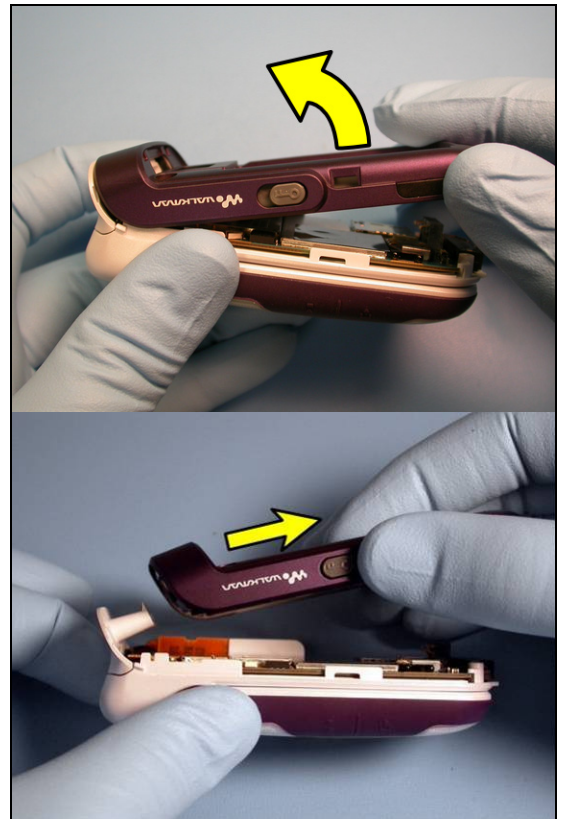
5. Repeat the previous two steps on the other side of the outer base cover.





6. Rotate the outer base cover up ~ 30 degrees from the rest of the phone and pull the lifted end of the outer base cover away from the phone as indicated to separate the outer base cover from the phone.

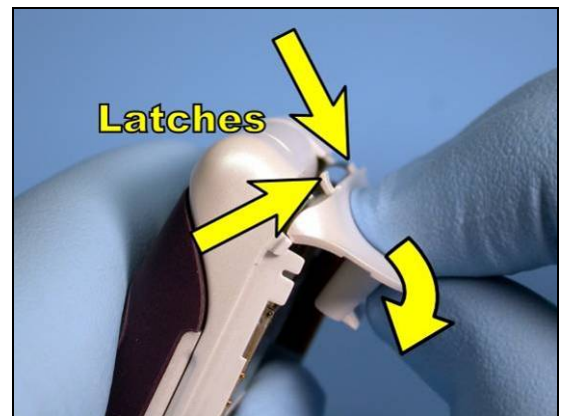
NOTE! THE VOLUME KEY, CAMERA KEY, ANTENNA COVER, REAR SPEAKER BOX, AND RF PLUG MAY FALL OUT WHILE REMOVING THE OUTER BASE COVER.



2.1.4 Antenna Cover Removal

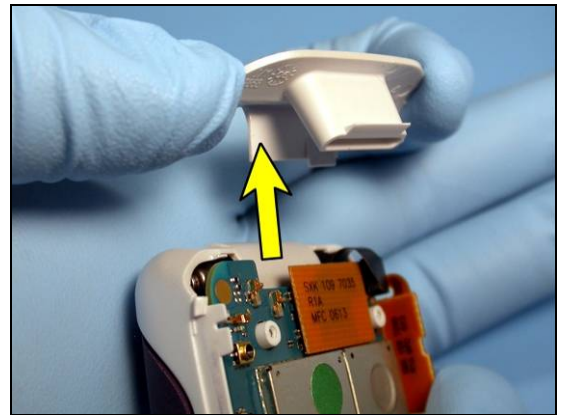
All of the sections of the base portion disassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Grip the antenna cover as indicated and rotate it toward the circuit board to release the latches on each side.





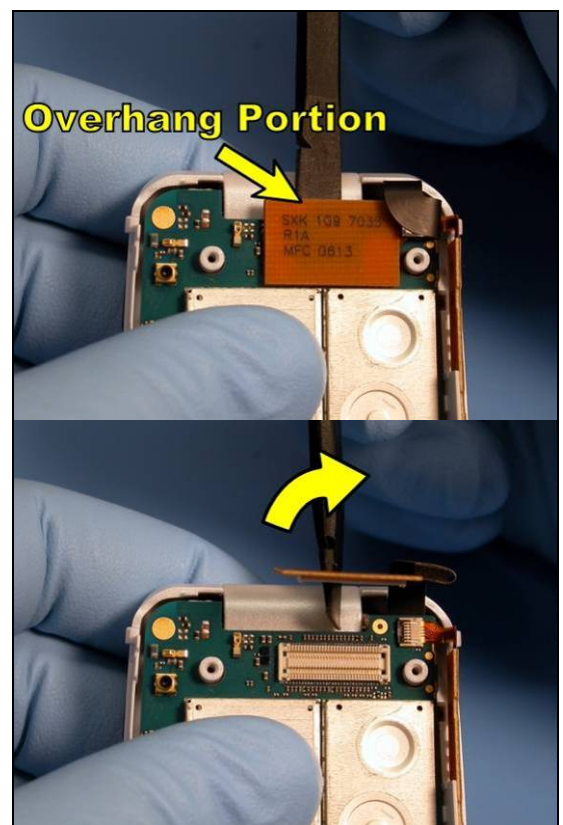
2. Remove the antenna cover by pulling the antenna cover directly away from the edge of the circuit board that is adjacent to it.



2.1.5 Circuit Board Removal

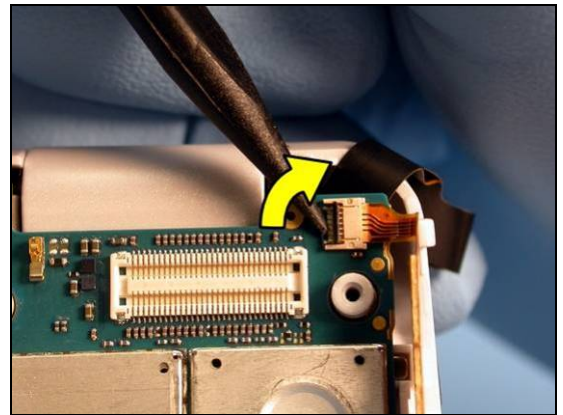
All of the sections of the base portion disassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Insert the flat end of a nylon pointer between the hinge cover and the portion of the flex film's board connection that overhangs the edge of the circuit board.
2. Hold the circuit board in place and disconnect the main flex film assembly from the circuit board by twisting the nylon pointer as shown.

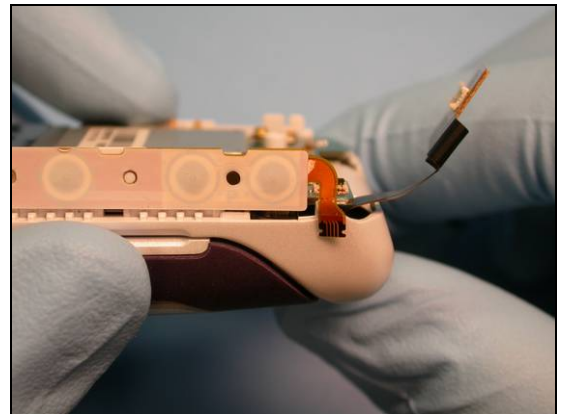




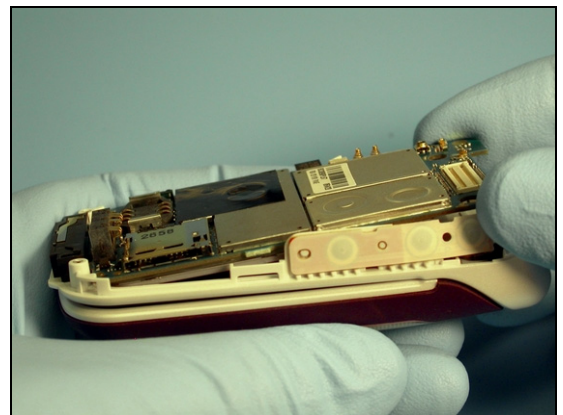
3. Rotate the black portion of the side key flex film's board connector 90 degrees toward the side key flex film assembly.



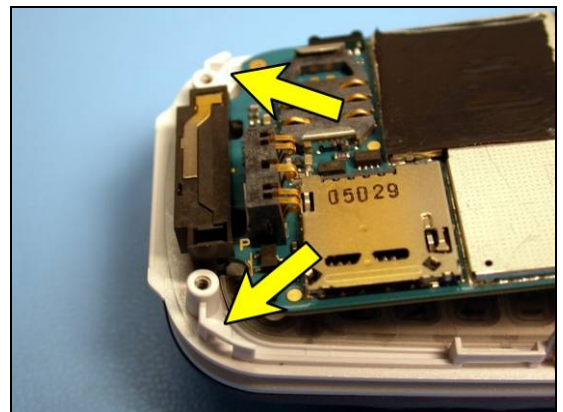
4. Using style 2A tweezers, remove connection portion of the side key flex film from its connector and position it on the outside of the phone as indicated.



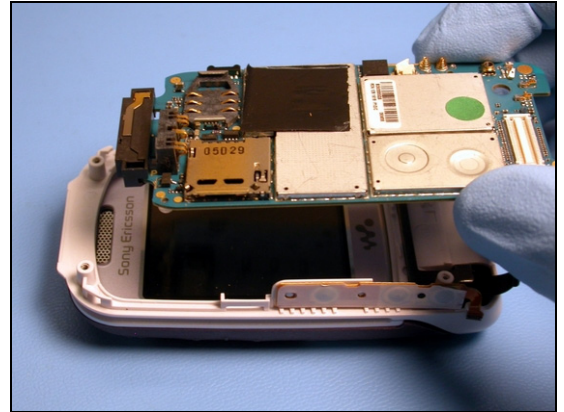
5. Lift the end of the circuit board near the hinge up from the phone just enough so that the board is clear of the two screw bosses indicated.



6. Slide the lifted circuit board 5 or 6 mm toward the hinge so that the edge of the board is clear of the two tabs indicated.



7. Lift the board from the phone.

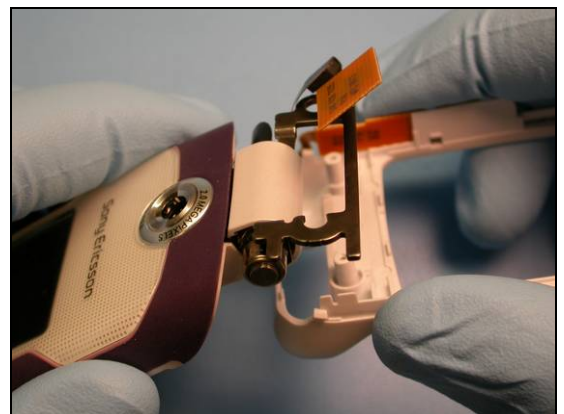


2.1.6 Inner Base Cover Removal

All of the sections of the base portion disassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Open the phone.
2. Slide the inner base cover directly away from the metal hinge until the inner base cover is separated from the flip portion of the phone.

NOTE! BE CAREFUL TO NOT DAMAGE THE MAIN FLEX ASSEMBLY.



2.2 Flip Portion Disassembly

The following subsections make up the “Flip Portion Disassembly” procedure. These subsections are arranged in the order that they must be performed to properly disassemble the flip portion of this product.

2.2.1 Perform Base Portion Disassembly

The base portion of this phone must be disassembled before the flip portion disassembly procedure can be performed.

2.2.2 Outer Flip Cover Removal

All of the sections of the flip portion disassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Insert the tip of a pair of style 2A tweezers behind the flip screw cover under the metal hinge as shown.

NOTE: FOR Z710, THE SCREW COVER HAS A NOTCH THAT YOU SHOULD PUT THE TIP OF YOUR TWEEZERS IN TO PRY IT OFF.





2. Rotate the tweezers away from the hinge to pry up the flip screw cover.



3. When the flip screw cover has been freed, lift it away from the phone with the tweezers. Repeat for the other screw cover.



4. Remove the two screws using a torque driver and T6 bit.



5. Insert the flat end of a nylon pointer between the inner and outer flip covers near where the screw was located. Pry away from the display to loosen the outer flip cover.





6. Insert the flat end of the nylon pointer in the gap and slide it along the seam until you reach the furthest end of the display area.
7. Repeat the previous two steps on the other side of the flip.



8. Slightly lift the freed end of the outer flip cover and wiggle the outer flip cover side to side to free it from the flip.

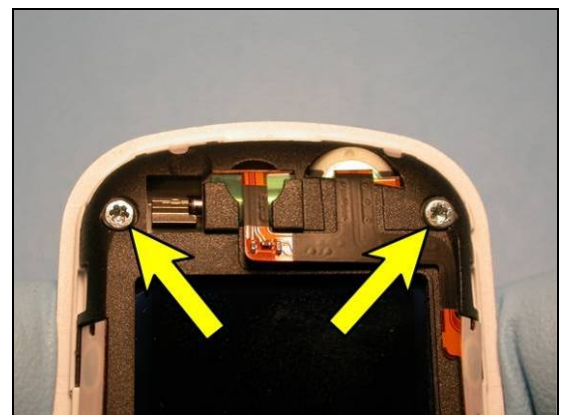


NOTE: FOR W710, THE CAMERA RING MAY FALL OUT.

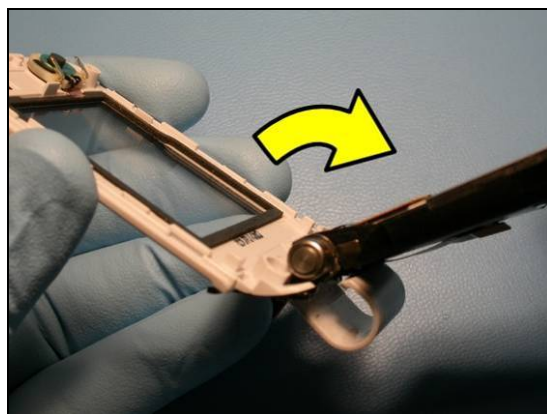
2.2.3 Inner Flip Cover Removal

All of the sections of the flip portion disassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

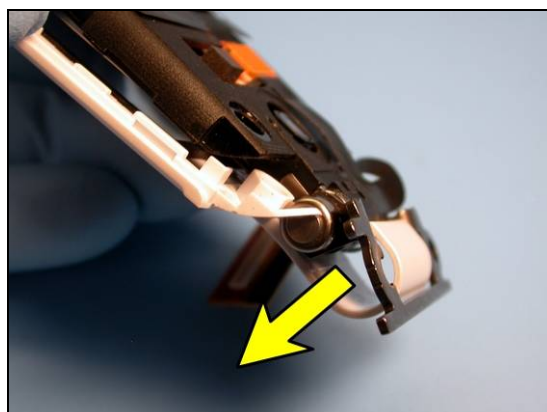
1. Remove the two screws indicated with a torque driver and T6 bit.



2. Rotate the inner flip cover ~120 degrees from the flip frame as shown.



3. Rotate the inner flip cover back down against the flip frame and pull the hinge cover portion of the inner flip cover through the opening between the hinge and the metal hinge arm as shown.



NOTE! *BE CAREFUL TO NOT DAMAGE THE MAIN FLEX FILM ASSEMBLY.*



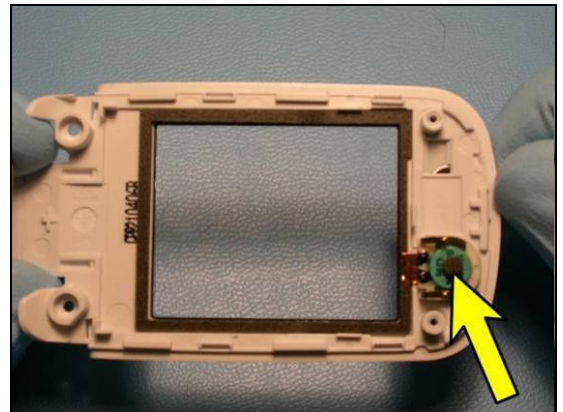
3 Reassembly

3.1 Flip Portion Reassembly

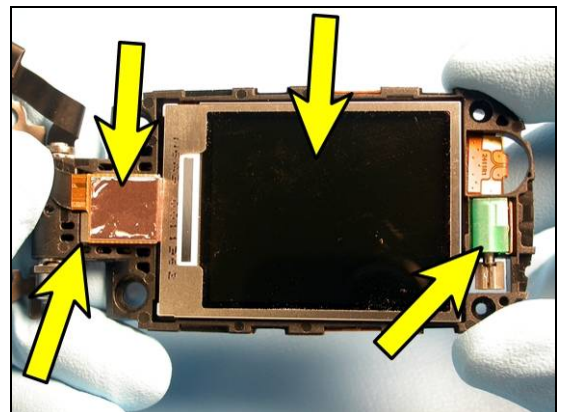
The following subsections make up the "Flip Portion Reassembly" procedure. These subsections are arranged in the order that they must be performed to properly reassemble the flip portion of this product

3.1.1 Inner Flip Cover Installation

1. Verify that the receiver is installed in the inner flip cover.



2. Make sure the camera, display, magnet, and vibrator are installed in the flip frame.



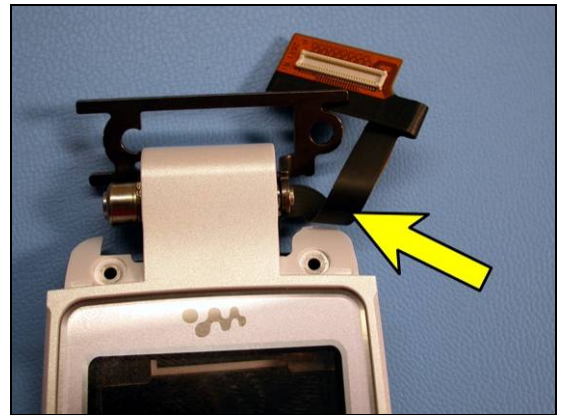
3. Push the hinge cover portion of the inner flip cover through the opening between the hinge and the hinge arm as shown.

NOTE! BE CAREFUL TO NOT DAMAGE THE MAIN FLEX FILM ASSEMBLY.





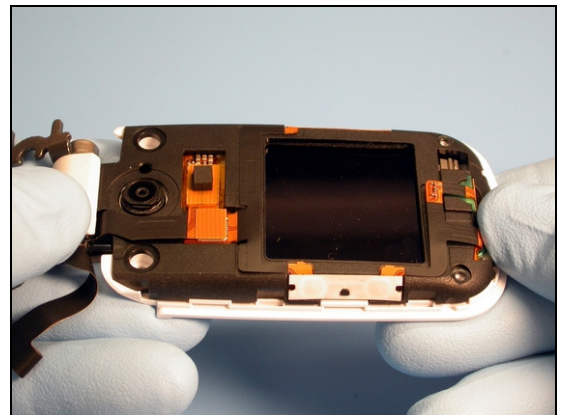
4. Position the main flex assembly between the hinge so that it won't get caught under the inner flip cover.



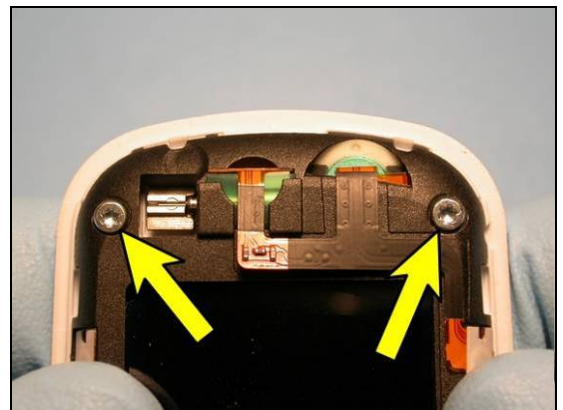
5. Slide the inner flip cover over the hinge as shown.



6. Mate the inner flip cover and flip frame assembly so that the features between the two components mesh properly.



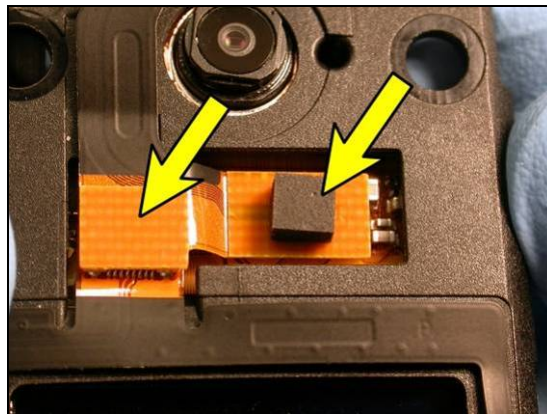
7. While holding the flip frame and inner flip cover together, install two 1.6MM X 4.5MM screws where shown with a T6 bit and torque driver set to 17 N*cm.



3.1.2 Outer Flip Cover Installation

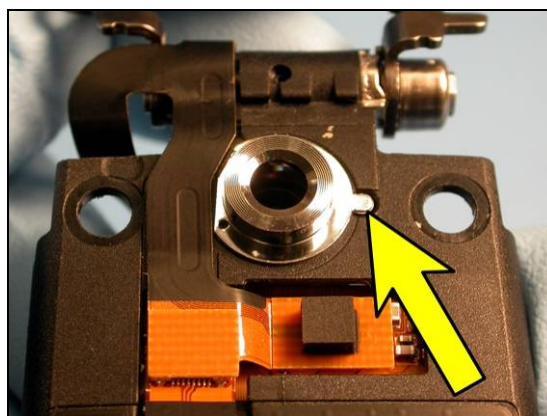
All of the sections of the flip portion reassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Make sure the main flex film assembly is connected to the display and flip flex film.



NOTE: *THIS STEP IS ONLY FOR W710.*

2. Install the camera ring into place in the flip frame. Make sure the alignment peg goes in the alignment hole as shown.



3. Bend the main flex film assembly in the loop shape shown.

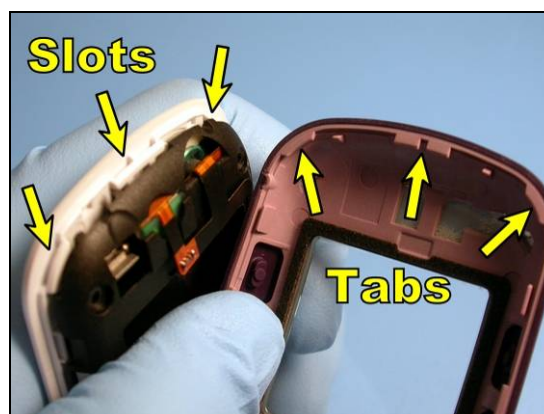
NOTE: *AVOID OVERSTRESSING THE FLEX FILM WHEN POSITIONING IT IN THE "LOOP" SHAPE. NON-VISIBLE DAMAGE TO THE FLEX FILM CAN OCCUR.*



4. Rotate the hinge to the closed position.



5. Position the outer flip cover over the end of the flip so that the alignment tabs on the outer flip cover line up with the slots on the end of the flip assembly.



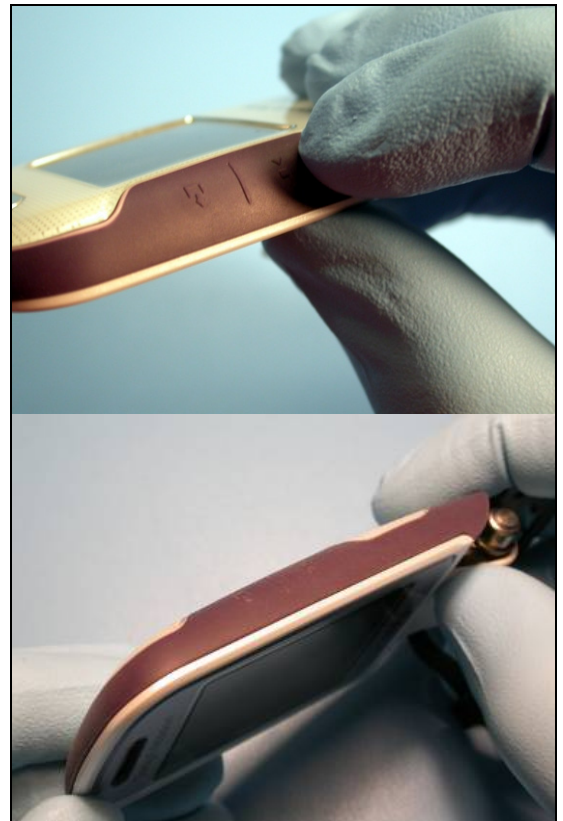
6. Press the end of the outer flip cover toward the hinge until the seam along the end of the flip is flush.



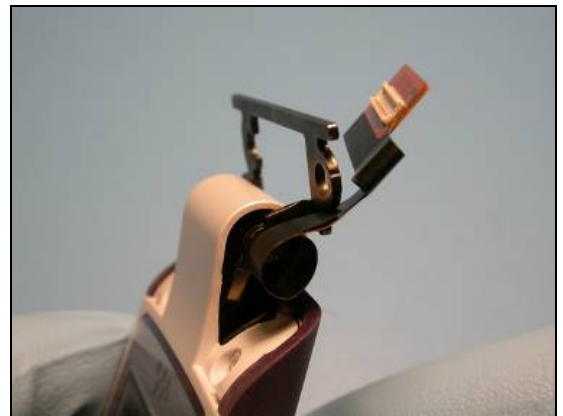


7. Press the outer flip cover down onto the flip and snap the seam along each edge of the flip assembly together.

NOTE! YOU MAY NEED TO PRESS IN ON THE SIDES OF THE OUTER FLIP COVER TO GET THE SEAMS ALONG THE SIDE OF THE FLIP TO MATE TOGETHER AS THEY SHOULD.

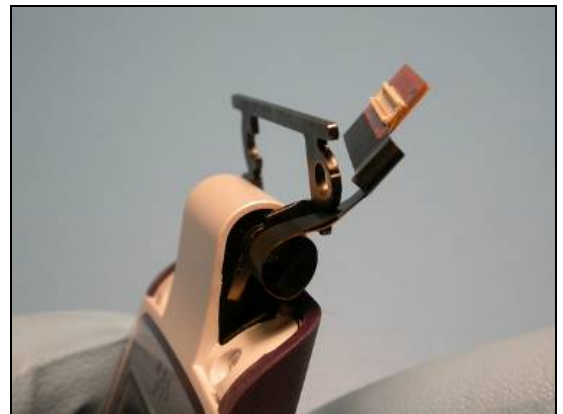


8. Rotate the hinge to the open position.



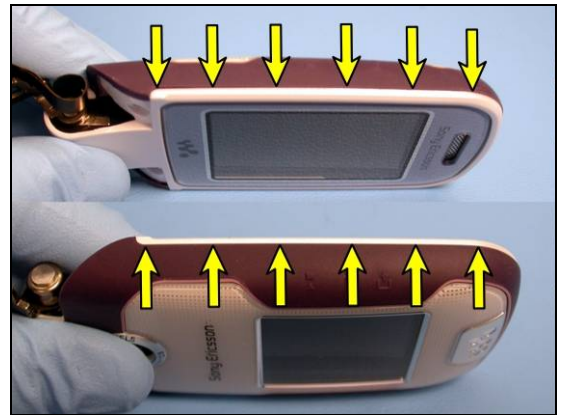
9. Reposition the main flex film assembly behind the hinge arm so it held in the loop shape shown.

NOTE: AVOID OVERSTRESSING THE FLEX FILM WHEN POSITIONING IT IN THE "LOOP" SHAPE. NON-VISIBLE DAMAGE TO THE FLEX FILM CAN OCCUR.

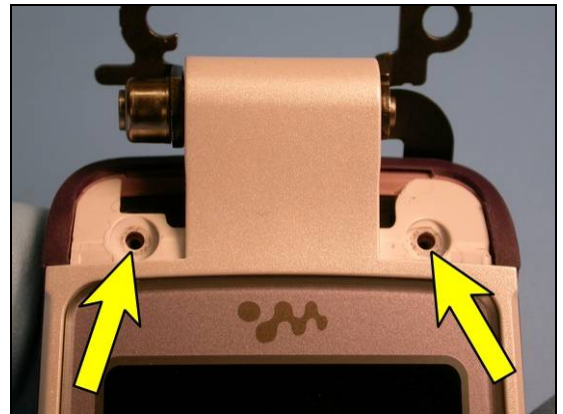




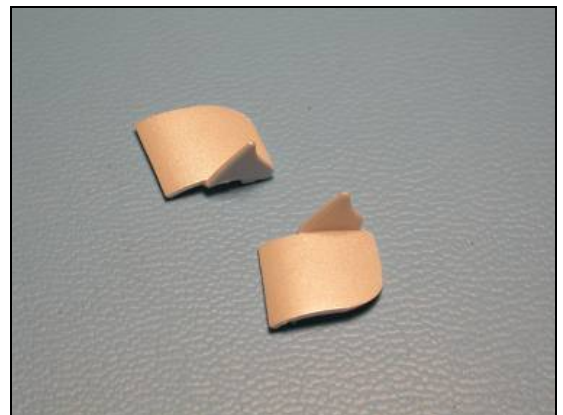
10. Hold the flip assembly together and inspect to make sure the seam is flush all the way around.



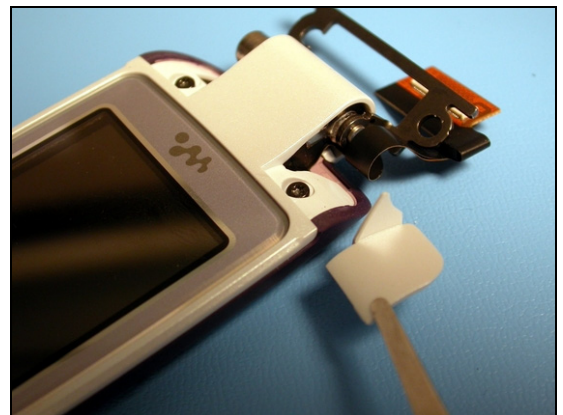
11. Install two 1.6MM X 5.1MM screws using a T6 bit and torque driver set to 17 N*cm.



12. Obtain two new flip screw covers.



13. Remove the protective covering from a new flip screw cover and using style 2A tweezers, position it as shown.

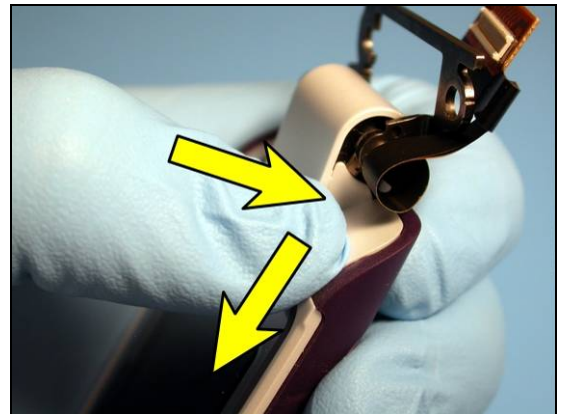




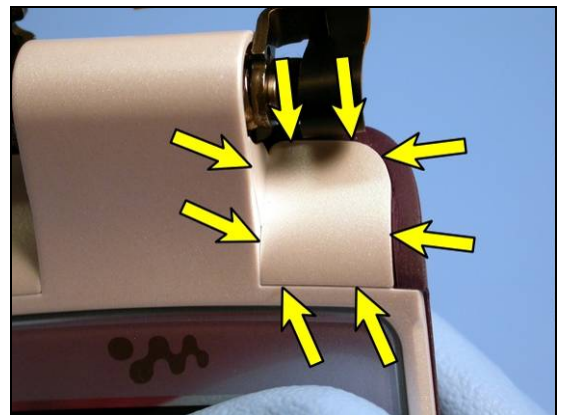
14. Position the screw cover so that its flange inserts in the corresponding area under the hinge as shown.



15. Press in and down so that the screw cover slides slightly toward the inner flip cover and seats itself.



16. Make sure the screw cover doesn't have gaps around it and that it is fully seated into place.
17. Press on the screw cover for 15 seconds so the a good adhesive bond between the screw cover and the inner flip cover is formed
18. Repeat for the other screw cover.



3.2 Base Portion Reassembly

The following subsections make up the “Base Portion Reassembly” procedure. These subsections are arranged in the order that they must be performed to properly reassemble the base portion of this product.

3.2.1 Perform Flip Portion Reassembly

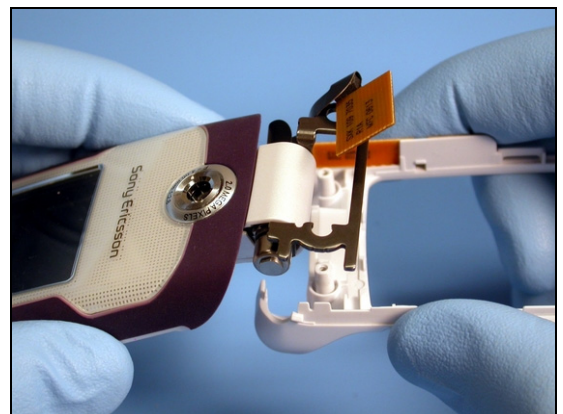
The flip portion of this phone must be reassembled before the base portion reassembly procedure can be performed.

3.2.2 Inner Base Cover Installation

1. Verify the metal hinge is in its open position and that the main flex film assembly is behind the metal hinge as indicated.

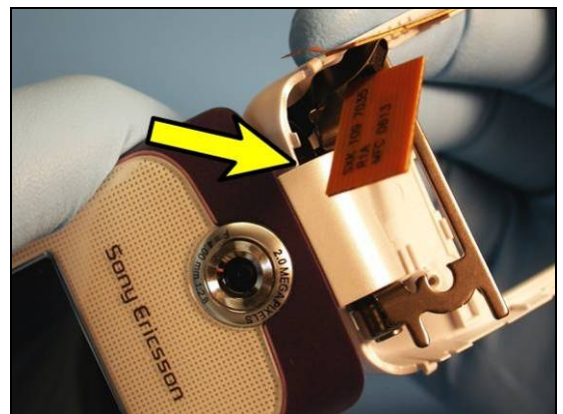


2. Orient the inner base cover to the flip assembly as shown.



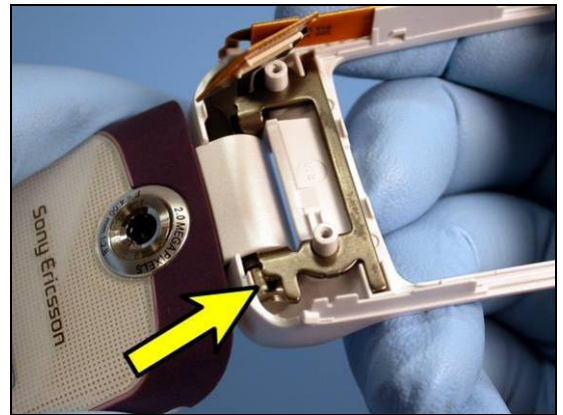
NOTE! *Be careful to not damage the main flex film assembly when assembling the inner base cover to the flip.*

3. Work the looped portion of the flex film into its cavity in the inner base cover so that the flex film does not get caught by the indicated corner of the inner base cover.

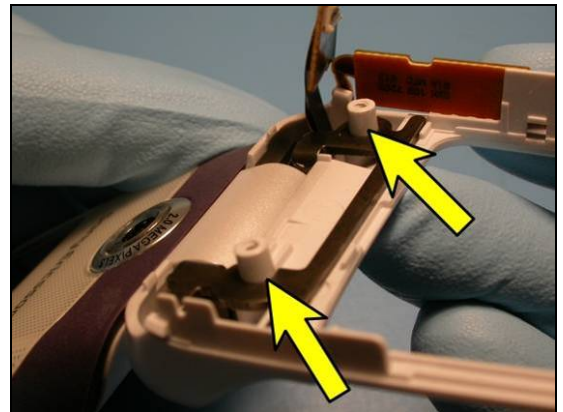




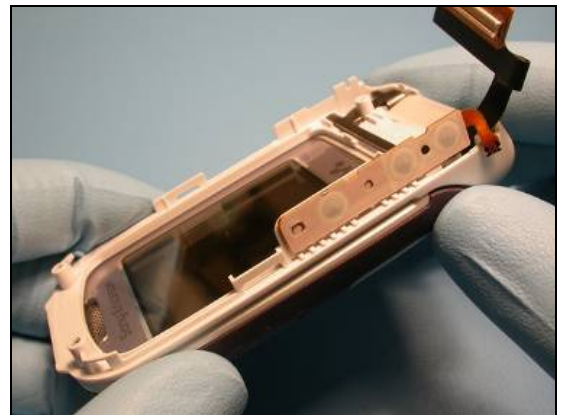
4. Insert the other side of the hinge into its cavity in the inner base cover.



5. Work the metal arm of the hinge down onto the inner base cover so that the two screw bosses pass through the corresponding holes in the hinge arm.



6. Close the flip and base portions of the phone.

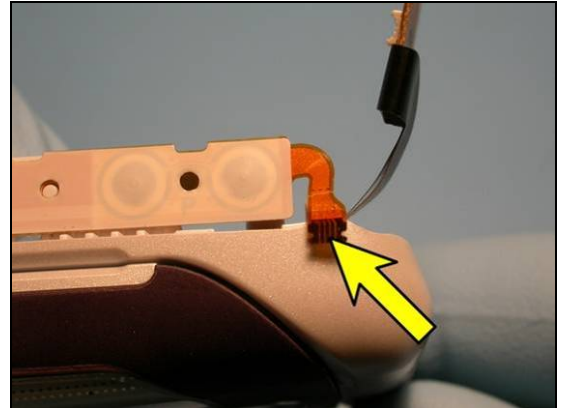




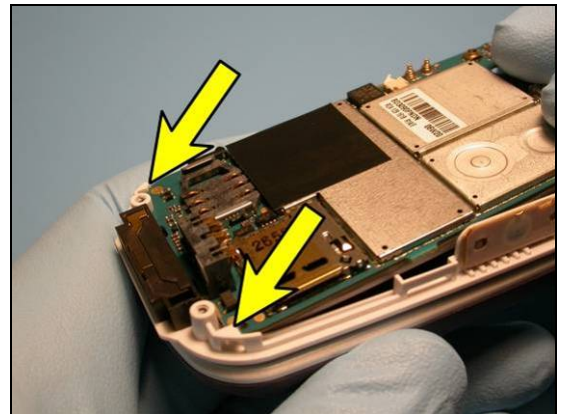
3.2.3 Circuit Board Installation

All of the sections of the base portion reassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

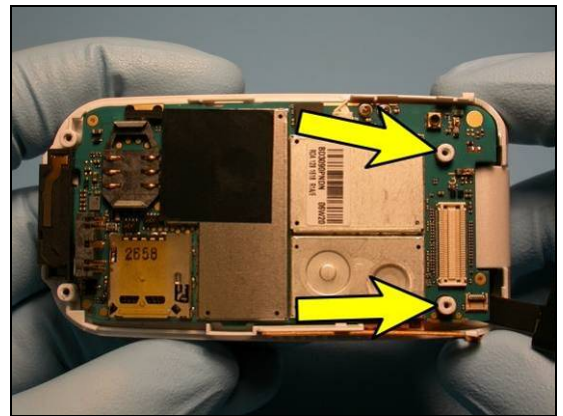
1. Using style 2A tweezers, position the board connection end of the side key flex film assembly out of the way as indicated.



2. Slide the system connector end of the circuit board into the inner base cover so that the board is under the two indicated alignment tabs.



3. Lay the circuit board down on the inner base cover. Make sure the screw bosses go through the corresponding opening in the circuit board.



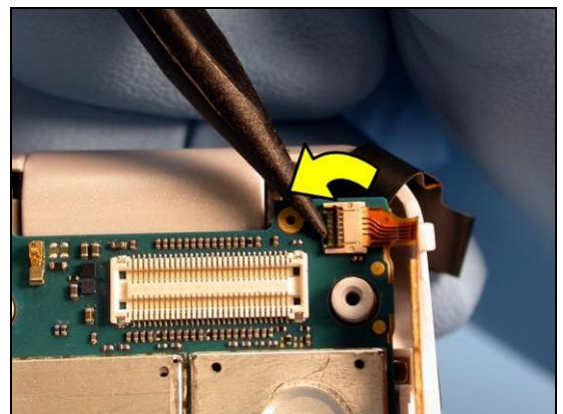
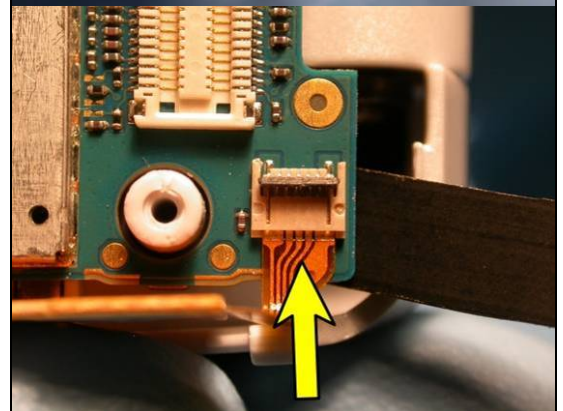
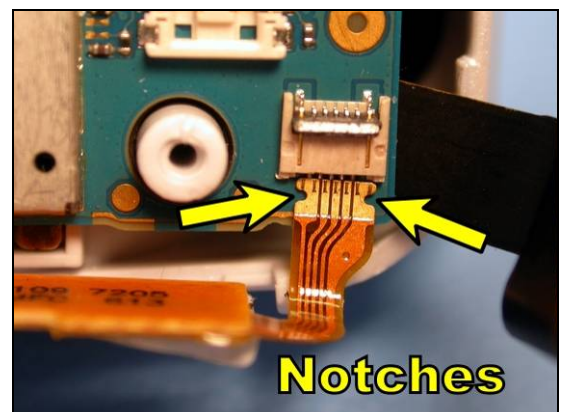
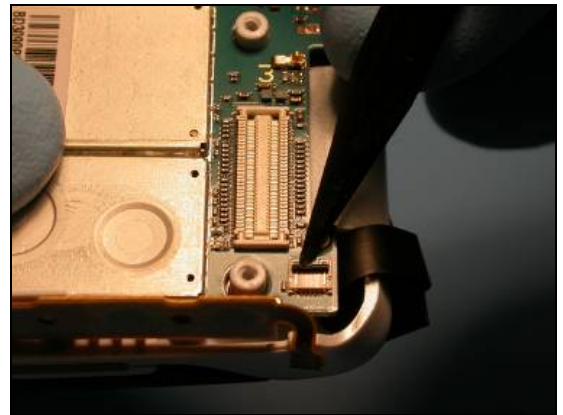


4. Make sure the black portion of the side key flex's board connector is rotated towards the side key flex film so that it forms a 90 degree angle to the circuit board.

NOTE! AVOID OVERSTRESSING THE SIDE KEY FLEX FILM WHEN POSITIONING IT IN ITS CIRCUIT BOARD CONNECTOR. NON-VISIBLE DAMAGE TO THE FLEX FILM CAN OCCUR.

5. Using style 2A tweezers, insert the side key flex film assembly into its connector until the notches cannot be seen.

6. Rotate the black portion of the side key flex's board connector back down onto the circuit board as shown.





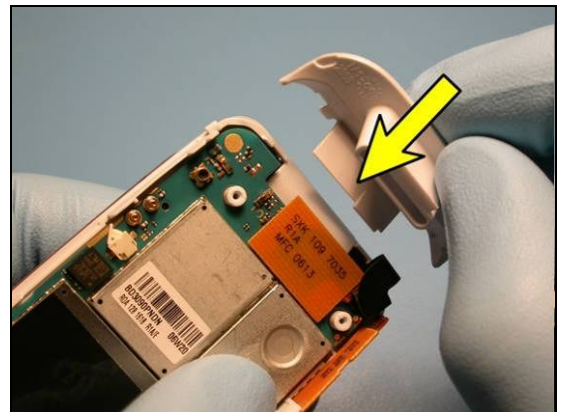
7. Plug the main flex film assembly into its board connector.



3.2.4 Antenna Cover Installation

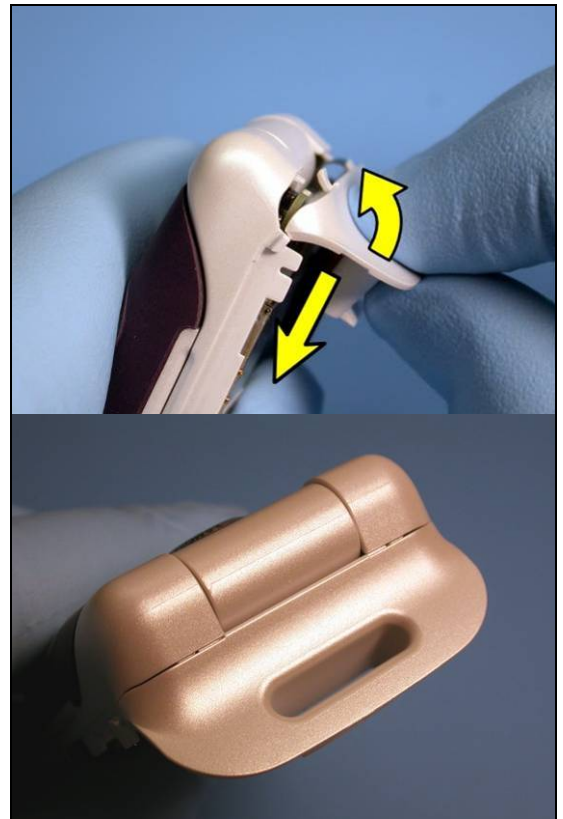
All of the sections of the base portion reassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Insert the antenna cover's large flat tab under the circuit board as indicated.





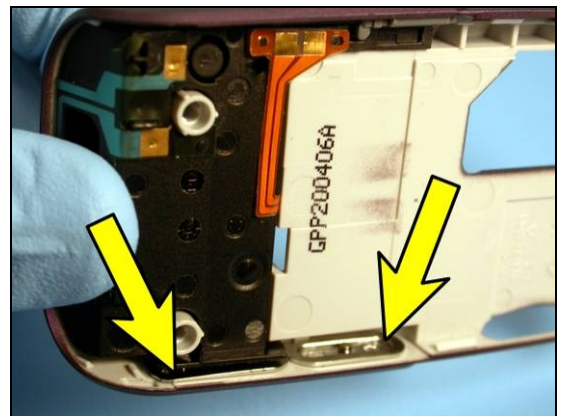
2. While pushing the antenna cover toward the circuit board, rotate the antenna cover so that its two tabs insert under the inner base cover.



3.2.5 Outer Base Cover Installation

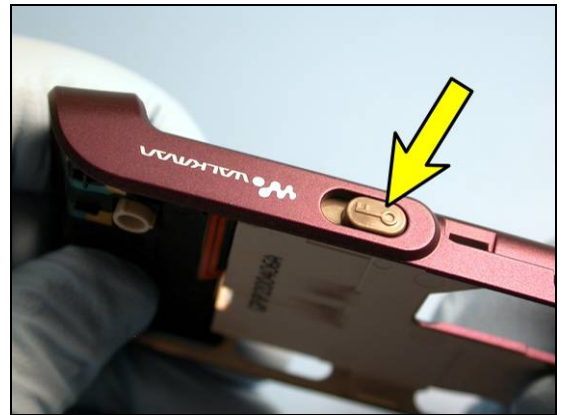
All of the sections of the base portion reassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Make sure the volume and camera keys are in the outer base cover as shown.

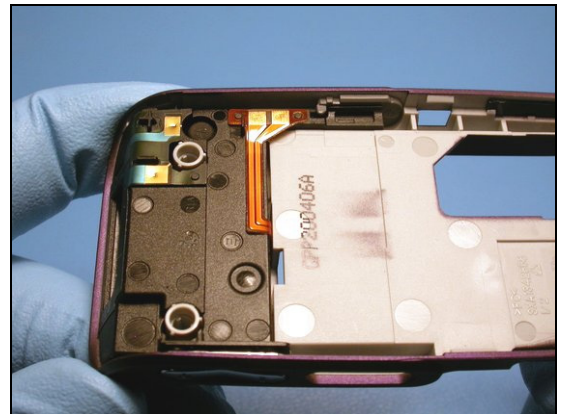




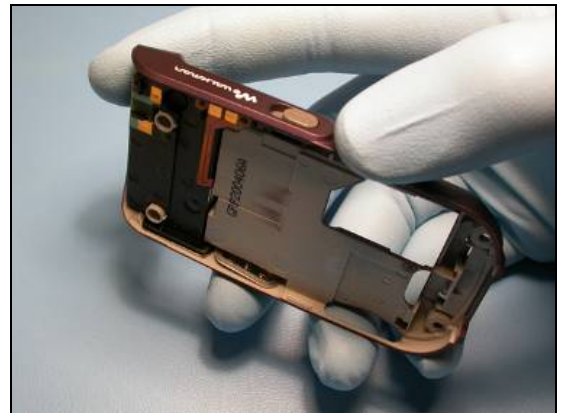
2. Make sure the phone lock key is in the position shown.



3. If the rear speaker box is not installed, insert it into the outer base cover as shown.



4. Hold the outer base cover as shown.

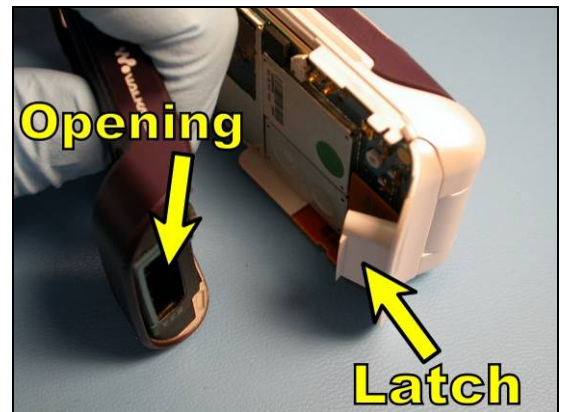


5. Hold the rest of the phone as shown. Be sure to hold the antenna cover in place.





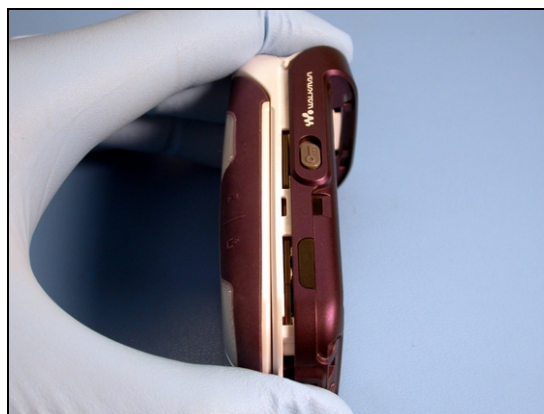
6. Insert the antenna cover's large latch into the corresponding opening in the outer base cover.



7. Make sure the side key flex film assembly is positioned above the volume and camera keys so as to not knock them out.



8. Rotate the two halves together. If any keys are out of place, do not force the two halves together.



9. Snap the outer base cover onto the inner base cover.



10. Make sure the antenna cover is seated properly.



11. Make sure the volume key, the camera key, and phone lock key respond correctly.





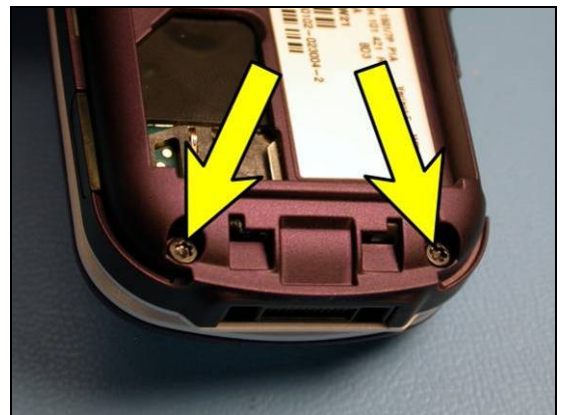
12. Verify that the RF plug is installed in the outer base cover.



13. Install two 1.6MM X 12MM screws at the locations indicated using a T6 bit and torque driver set to 23 N*cm.



14. Install two 1.6MM X 5.1MM screws at the locations indicated using a T6 bit and torque driver set to 17 N*cm.



3.2.6 Battery Installation

All of the sections of the base portion reassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Obtain a battery and position it so that the battery's contact pads are aligned to the battery contacts in the phone's battery cavity.



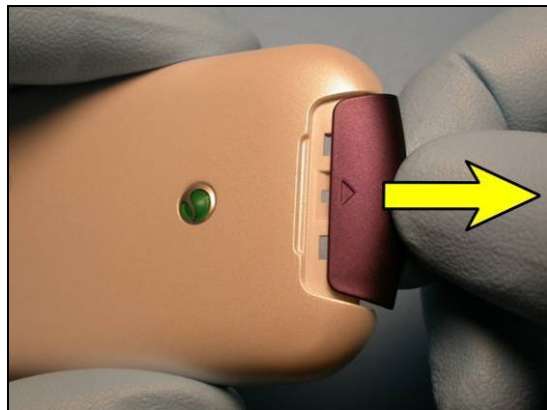
2. Press the battery into the battery cavity.



3.2.7 Battery Door Installation

All of the sections of the base portion reassembly preceding this section must be performed in sequential order before the steps listed below can be performed.

1. Make sure the battery latch has been moved in the direction indicated by the triangle that is on the latch as shown.



2. Insert the two battery door tabs indicated into the two slots in the outer base cover.



3. Lower the battery door onto the outer base cover and snap it into place.



4. Press the latch on the battery door toward the hinge as shown.



4 Part Replacement

NOTE: *BE SURE TO USE REPLACEMENT PARTS DESIGNED FOR THE PARTICULAR MODEL OF PHONE THAT YOU ARE WORKING WITH. SOME PARTS ARE SHARED BETWEEN W710 AND Z710, BUT NOT ALL.*

4.1 Battery Door

Perform the disassembly procedure from section 2.1.1

Obtain a new battery door.

Perform the reassembly procedure from section 3.2.7

4.2 Phone Label

4.2.1 Label Removal

Perform sections 2.1.1-2.1.2 of the base portion disassembly procedure.

1. Before removing the label, print a new label.

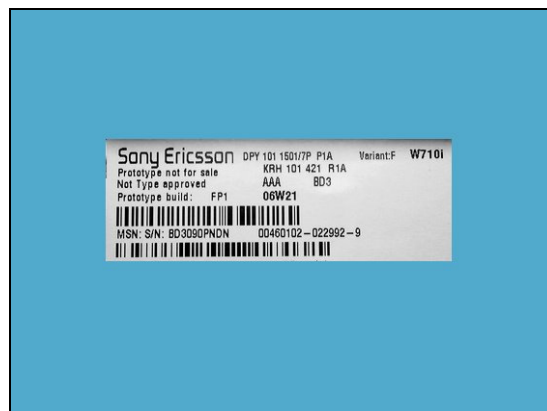
NOTE! *THE TEXT ON THE NEW LABEL MUST BE FULLY READABLE AND ALL BARCODES MUST BE SCANNABLE.*

NOTE! *LABELS ONLY HAVE TO BE REMOVED FROM THE PHONE IF THERE ARE ALREADY TWO OR MORE LABELS ON THE PHONE.*

NOTE! *HEATING UP THE OLD LABEL(S) WITH A HOT AIR DEVICE MAY MAKE REMOVING THEM EASIER.*

2. Carefully peel the old label from the bottom of the battery cavity.

NOTE! *MAKE SURE THAT ALL ADHESIVE RESIDUE IS REMOVED. CAREFULLY CLEAN OFF ANY REMAINING RESIDUE WITH ALCOHOL AND A LINT-FREE CLOTH.*



4.2.2 Label Installation

NOTE! NO MORE THAN TWO LABELS ARE ALLOWED STACKED ON TOP OF EACH OTHER IN THE BATTERY CAVITY. IF THERE ARE ALREADY TWO LABELS PRESENT, PERFORM THE LABEL REMOVAL PROCEDURE BEFORE CONTINUING.

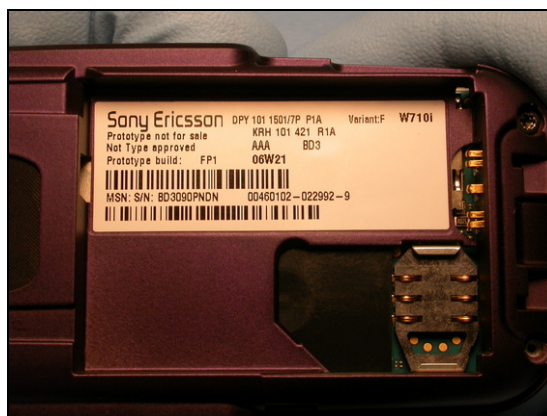
1. If a new label has not been created yet, then do so at this time.

NOTE! WHEN INSTALLING A NEW LABEL, BE VERY CAREFUL TO AVOID TOUCHING THE CONTACTS OF THE BATTERY CONNECTOR WITH THE ADHESIVE SIDE OF THE LABEL.

2. Using tweezers, orient the label as shown and place the end of the label that is adjacent to the battery contacts first. Then roll the rest of the label down onto the floor of the battery cavity.

3. Once the label is correctly positioned, carefully smooth it into place.

Starting at section 3.2.6, perform the remainder of the base portion reassembly procedure.





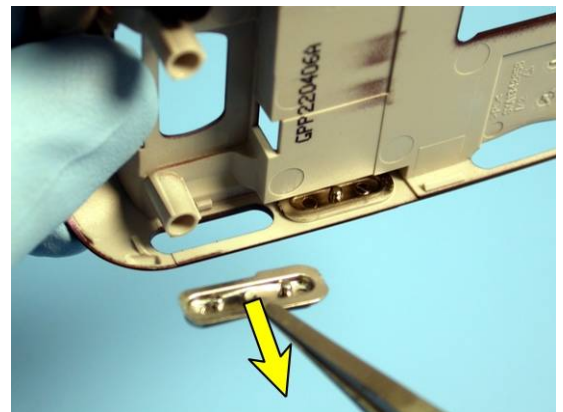
4.3 Outer Base Cover

Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

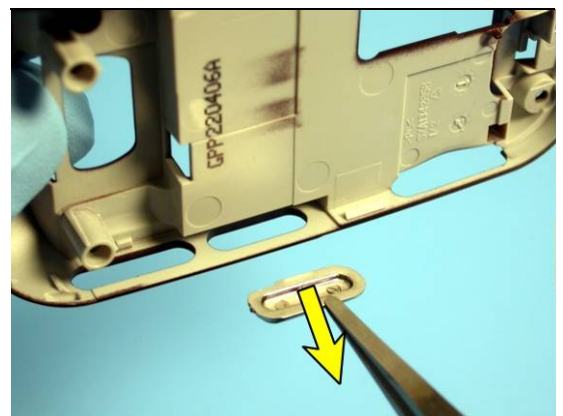
1. Make sure the phone lock key is in the position shown. Remove the speaker box by gripping it near the antenna and pulling it straight out of the outer base cover.



2. Use style 2A tweezers to remove the volume key from the outer base cover.



3. Use style 2A tweezers to remove the camera key from the outer base cover.

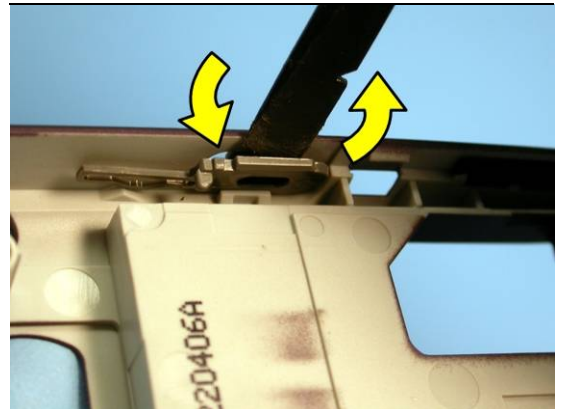




4. Use style 2A tweezers to pull the RF Plug from its hole in the outer base cover.

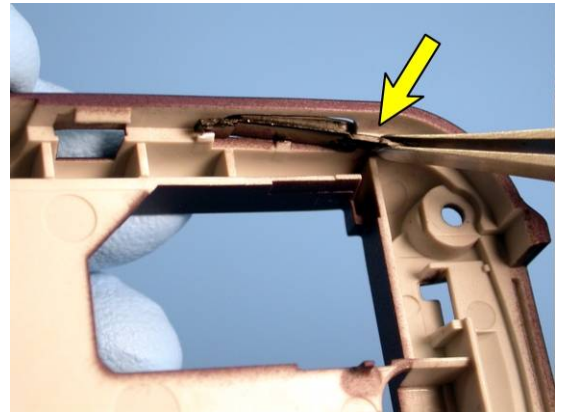


5. Insert the flat end of a nylon pointer where shown and twist it to dislodge the phone lock key, then use style 2A tweezers to remove it from the outer base cover.

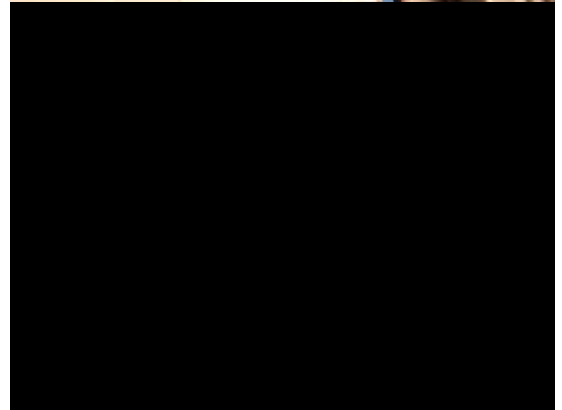




6. Use style 2A tweezers to dislodge the end of the IR window closest to the system connector opening in the outer base cover.



7. With a nylon pointer, push on the IR window from the outside of the outer base cover to remove it from its hole in the outer base cover.



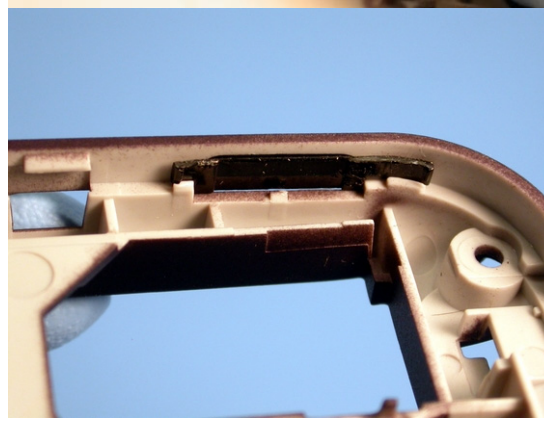
8. Obtain a new outer base cover.



9. Using style 2A tweezers, position the IR window as shown so that the edge indicated goes into its hole in the outer base cover first.

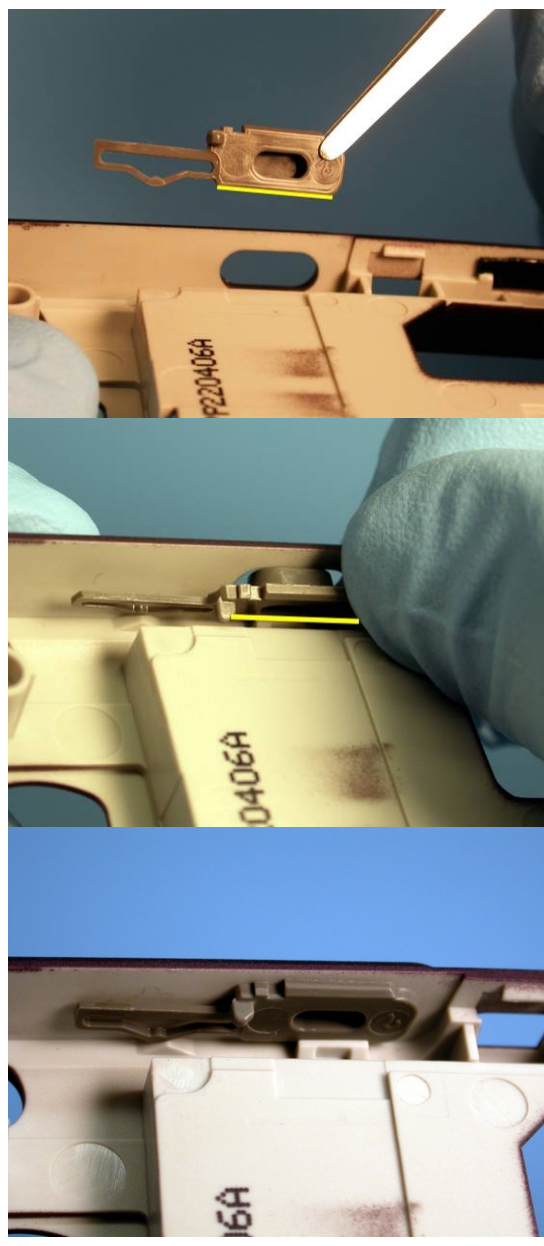


10. Press on the IR window so that it snaps into place in the outer base cover. Make sure the portions indicated snap behind the tabs.

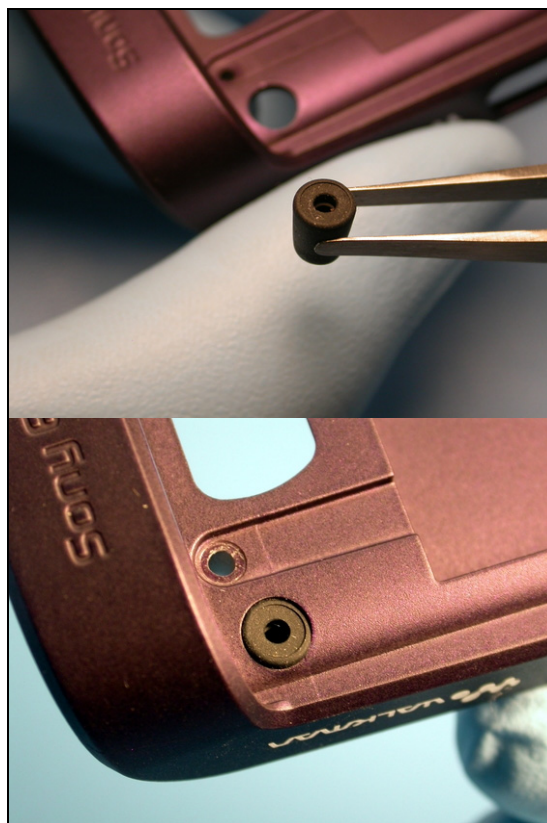


11. Use style 2A tweezers to position the phone lock key so that the edge indicated goes behind the retainer tab.

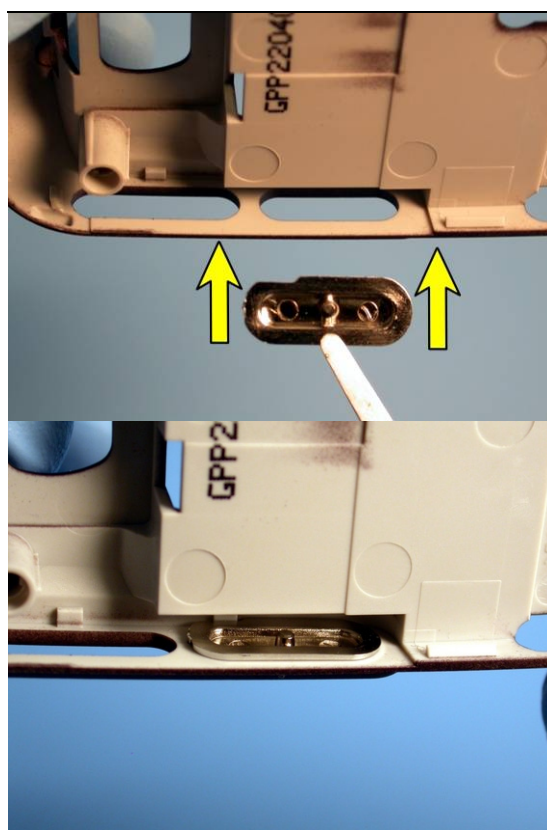
12. Press on the phone lock key so that it snaps into place in the outer base cover.



13. From the outside of the outer base cover, insert the RF plug into its hole so that the outer surface of the plug is flush with the outer surface of the outer base cover.

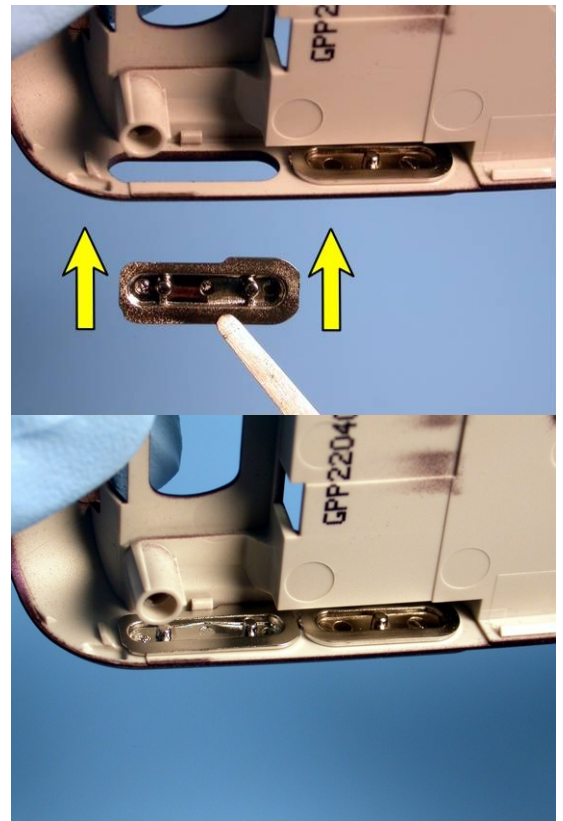


14. Using style 2A tweezers, insert the camera key into the outer base cover in the orientation shown.





15. Using style 2A tweezers, insert the volume key into the outer base cover in the orientation shown.



16. Make sure the phone lock key is in the position shown. Grip the speaker box near the antenna and insert it straight into the outer base cover. If it does not go in straight, it may knock out the RF plug or volume key.



17. Perform the label installation procedure from section 4.2.2

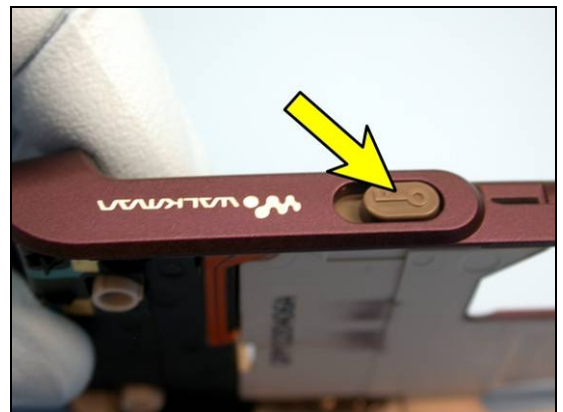
Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.



4.4 Rear Speaker Box

Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Make sure the phone lock key is in the position shown. Remove the speaker box by gripping it near the antenna and pulling it straight out of the outer base cover.

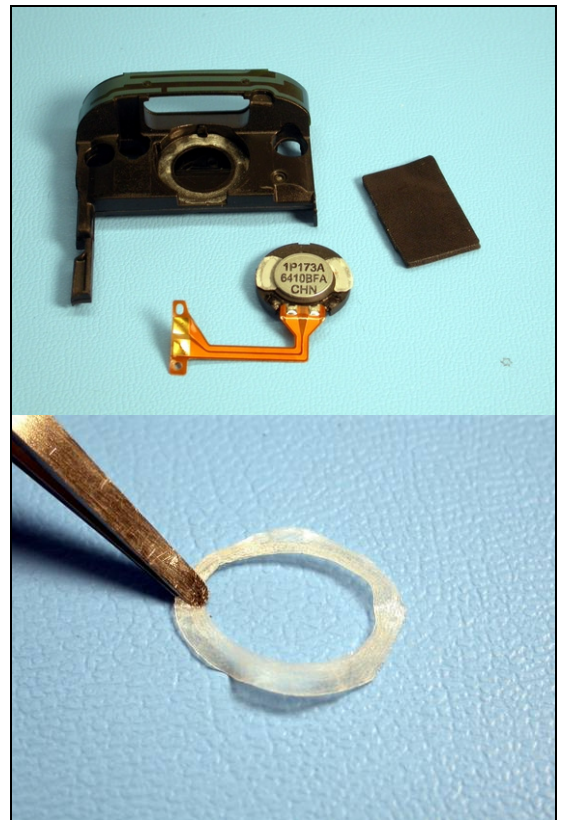


2. Obtain a new rear speaker box.





3. Obtain a new rear speaker, rear speaker adhesive ring, and rear speaker cloth.



4. Remove the adhesive ring from its protective backing and place it into the rear speaker cavity in the rear speaker box where indicated.

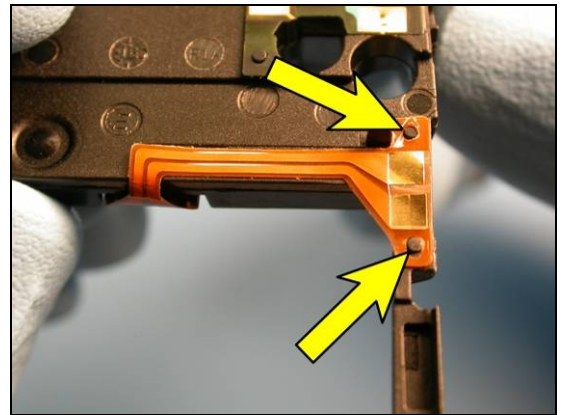


5. Place the rear speaker into the rear speaker cavity in the rear speaker box and press on the edges to make sure it sticks well.





6. Remove the protective cover from the rear speaker flex and wrap it around the rear speaker box as shown. Make sure the alignment pegs indicated go through the alignment holes in the flex.



7. Remove the rear speaker cloth from its protective backing and place it over the rear speaker in the orientation shown. The final location is highlighted.





8. Make sure the phone lock key is in the position shown. Grip the speaker box near the antenna and insert it straight into the outer base cover. If it does not go in straight, it may knock out the RF plug or volume key.

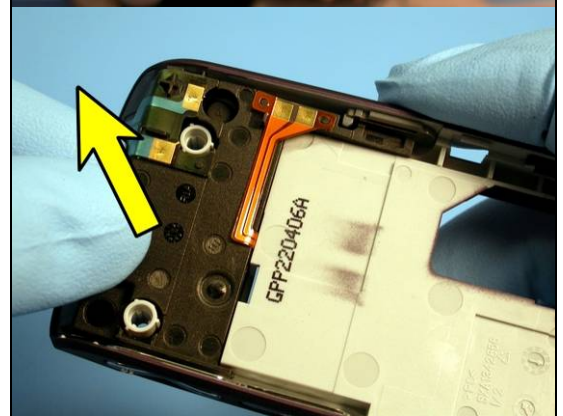
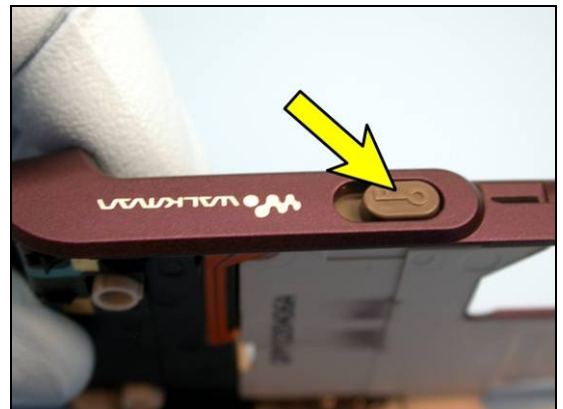
Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.



4.5 Rear Speaker Cloth

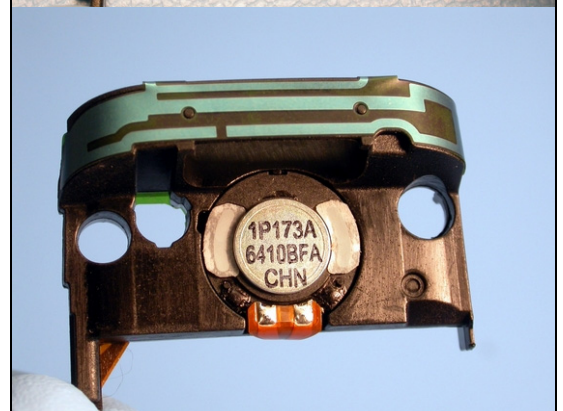
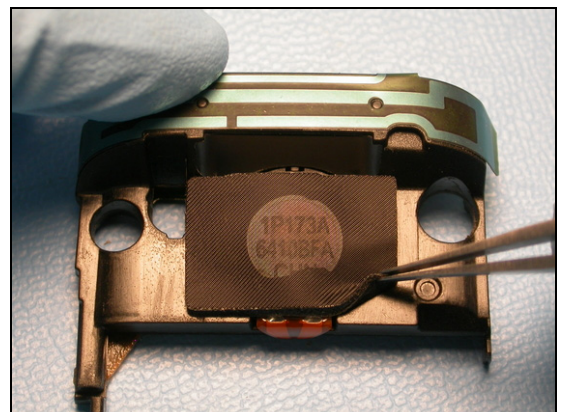
Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Make sure the phone lock key is in the position shown. Remove the speaker box by gripping it near the antenna and pulling it straight out of the outer base cover.

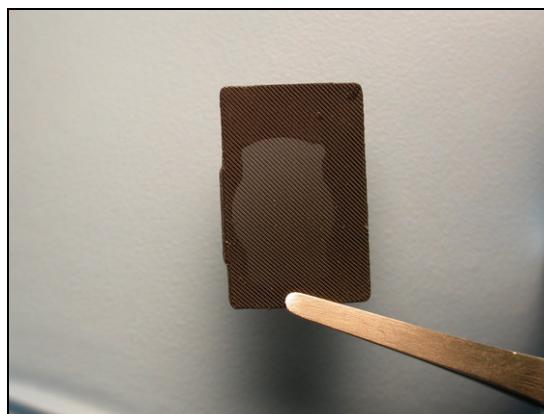


2. Use style 2A tweezers to pull the rear speaker cloth off of the rear speaker box. Clean off any adhesive residue with alcohol and a lint free wipe.

NOTE! AVOID DAMAGING THE REAR SPEAKER.



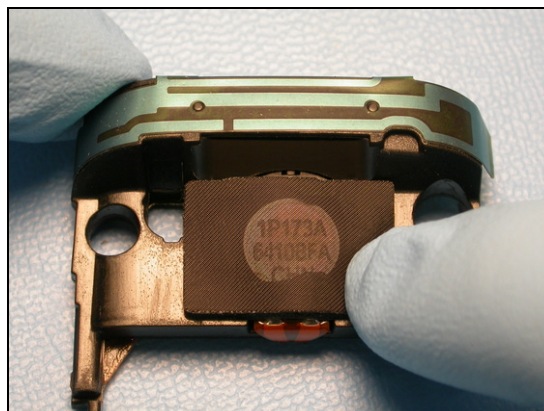
3. Obtain a new rear speaker cloth.



4. Remove the protective film from the rear speaker cloth and position the cloth onto the rear speaker box in the orientation shown. The final location of the cloth is highlighted.



5. Firmly press on the edges of the cloth to make sure it sticks well.





6. Make sure the phone lock key is in the position shown. Grip the speaker box near the antenna and insert it straight into the outer base cover. If it does not go in straight, it may knock out the RF plug or volume key.

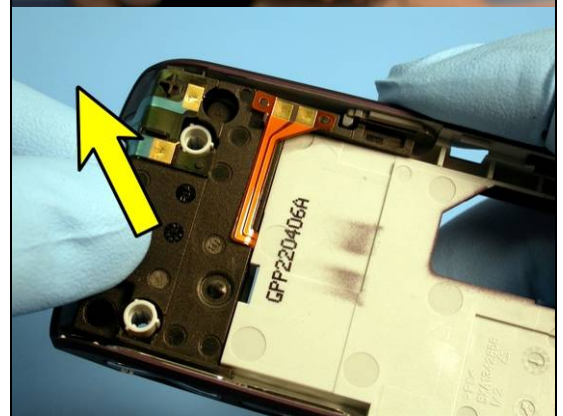
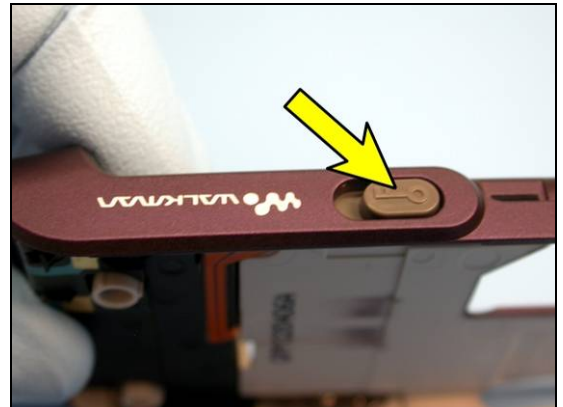
Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.



4.6 Rear Speaker

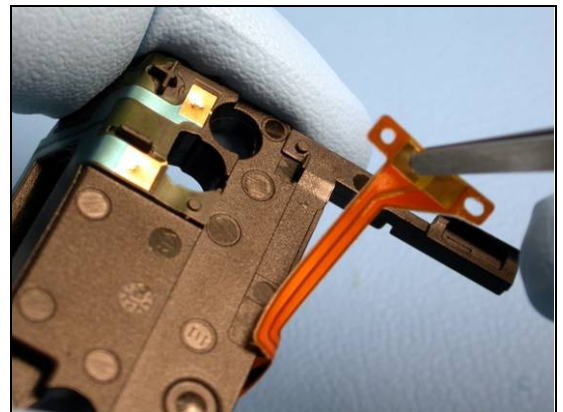
Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Make sure the phone lock key is in the position shown. Remove the speaker box by gripping it near the antenna and pulling it straight out of the outer base cover.



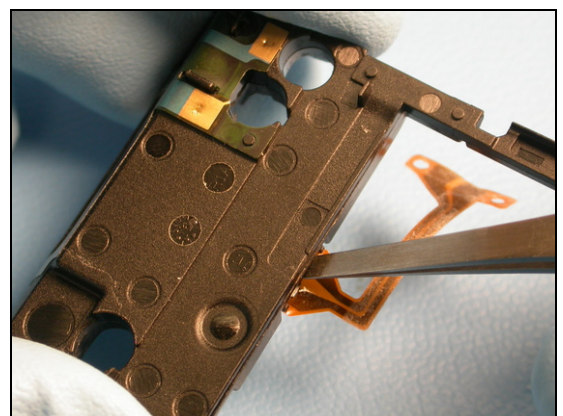
2. The rear speaker flex is adhered to the rear speaker box. Use style 2A tweezers to pull the rear speaker flex off of the rear speaker box.

NOTE! AVOID DAMAGING THE REAR SPEAKER BOX.



3. Use style 2A tweezers to remove the rear speaker from the rear speaker box by prying it out of the rear speaker cavity as shown.

NOTE! AVOID DAMAGING THE REAR SPEAKER BOX.



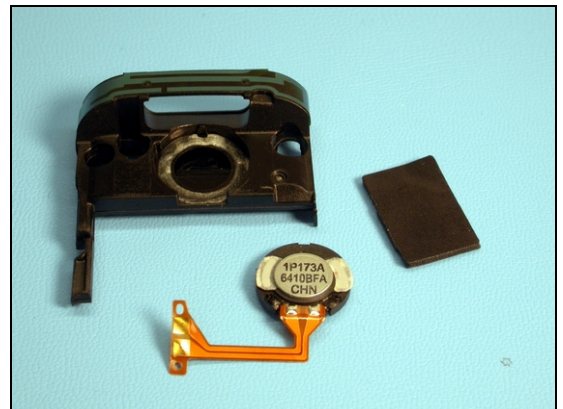


4. Using style 2A tweezers, remove the old adhesive ring. Use alcohol and a lint free wipe to remove any remaining adhesive residue.

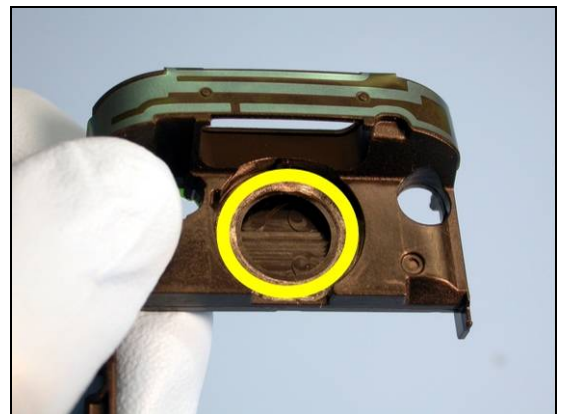
NOTE! *Be careful to not damage the rear speaker box.*



5. Obtain a new rear speaker, rear speaker adhesive ring, and rear speaker cloth.



6. Remove the adhesive ring from its protective backing and place it into the rear speaker cavity in the rear speaker box where indicated.

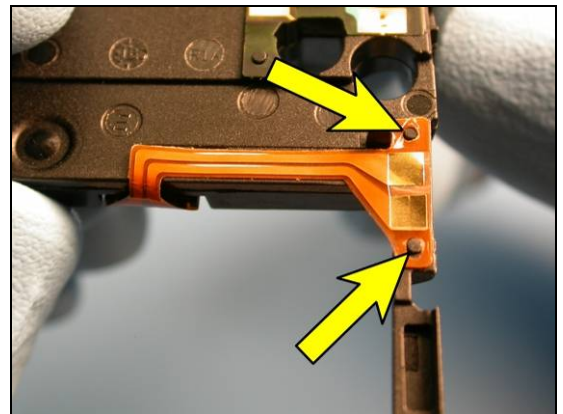




7. Place the rear speaker into the rear speaker cavity in the rear speaker box and press on the edges to make sure it sticks well.



8. Remove the protective cover from the rear speaker flex and wrap it around the rear speaker box as shown. Make sure the alignment pegs indicated go through the alignment holes in the flex.



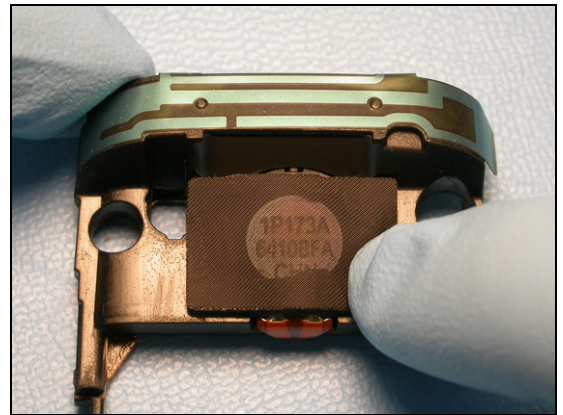
Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.

9. Remove the protective film from the rear speaker cloth and position the cloth onto the rear speaker box in the orientation shown. The final location of the cloth is highlighted.





10. Firmly press on the edges of the cloth to make sure it sticks well.



11. Make sure the phone lock key is in the position shown. Grip the speaker box near the antenna and insert it straight into the outer base cover. If it does not go in straight, it may knock out the RF plug or volume key.

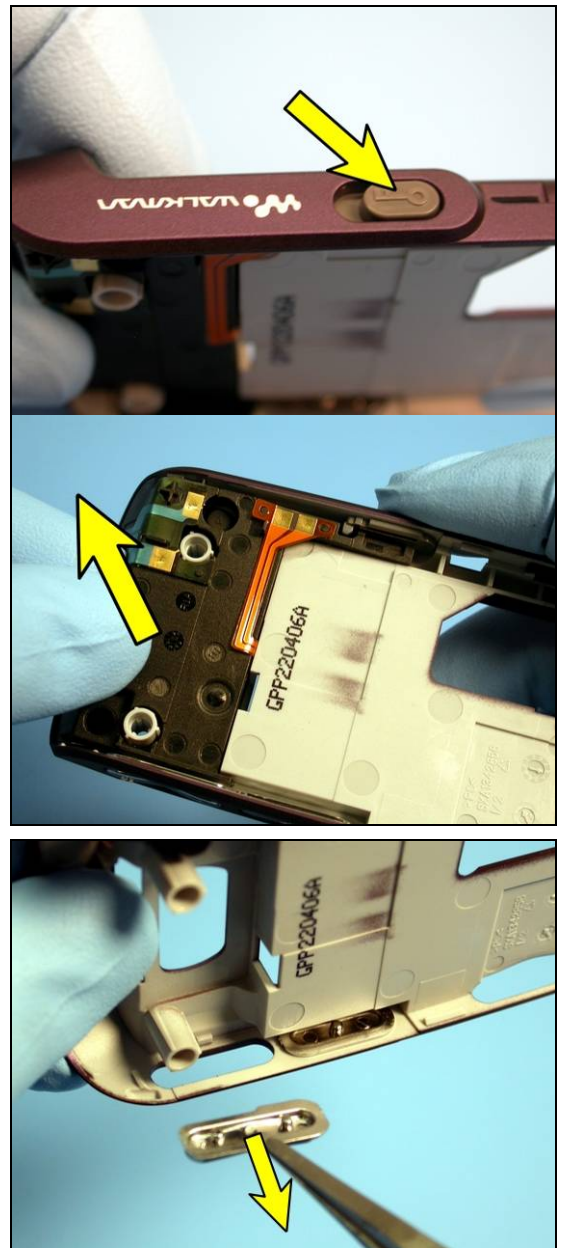
Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.



4.7 Volume Key

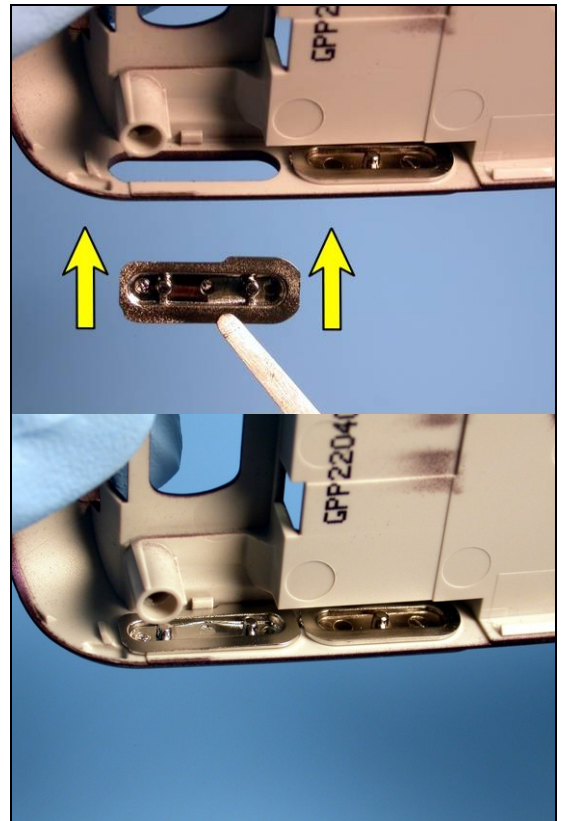
Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Make sure the phone lock key is in the position shown. Remove the speaker box by gripping it near the antenna and pulling it straight out of the outer base cover.
2. Use style 2A tweezers to remove the old volume key by lifting it out of the outer base cover.





3. Obtain a new volume key and insert it into the outer base cover so that it is oriented as shown.



4. Make sure the phone lock key is in the position shown. Grip the speaker box near the antenna and insert it straight into the outer base cover. If it does not go in straight, it may knock out the RF plug or volume key.

Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.

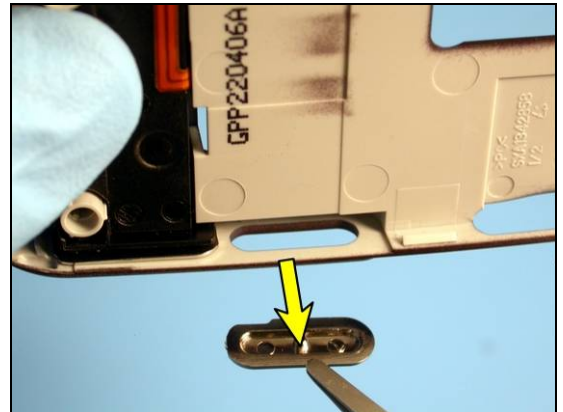




4.8 Camera key

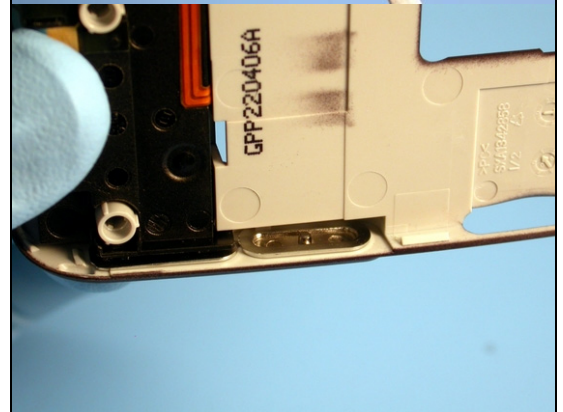
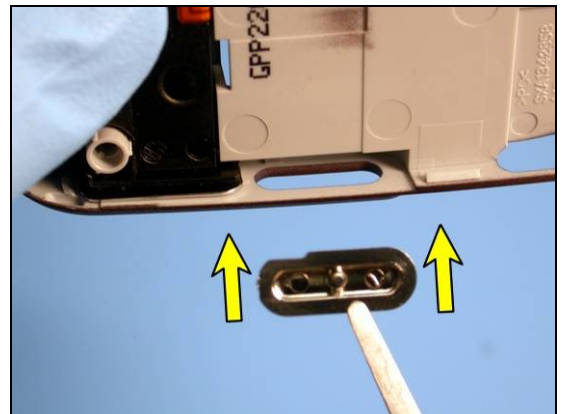
Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Use style 2A tweezers to remove the old camera key by lifting it out of the outer base cover.



2. Obtain a new camera key and insert it into the outer base cover so that it is oriented as shown.

Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.

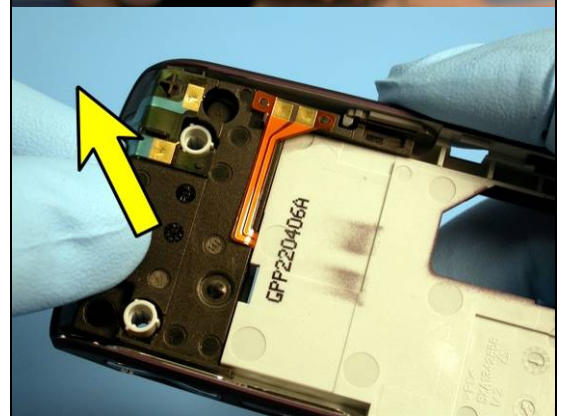
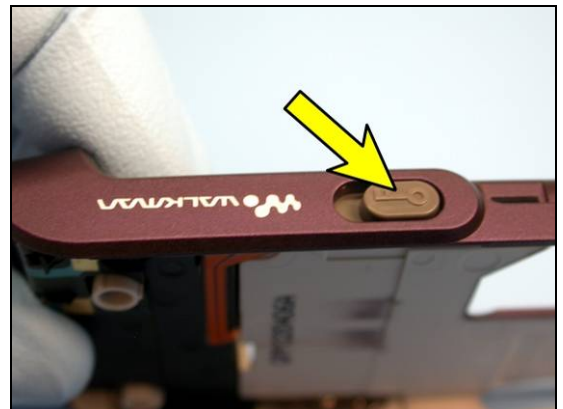




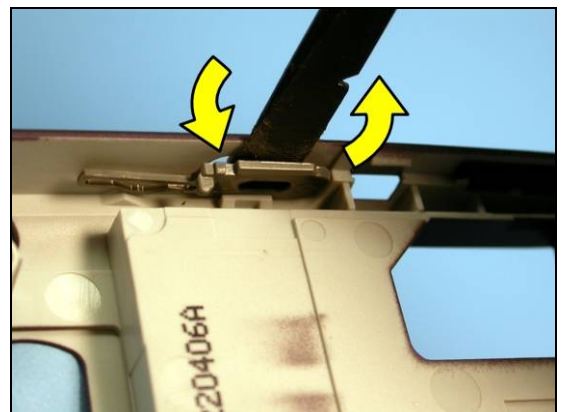
4.9 Phone Lock Key

Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Make sure the phone lock key is in the position shown. Remove the speaker box by gripping it near the antenna and pulling it straight out of the outer base cover.

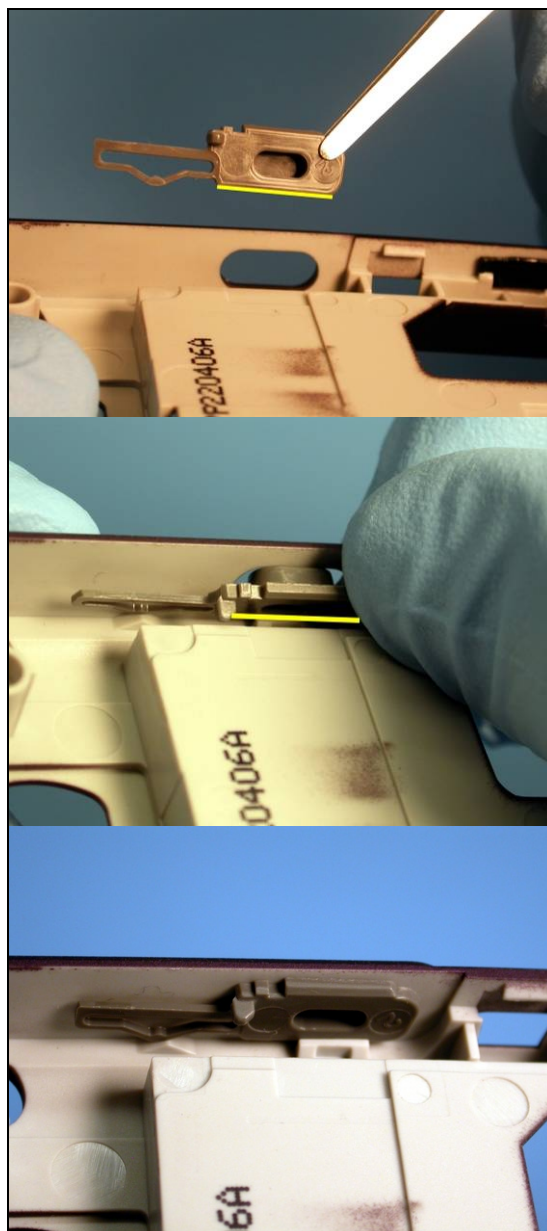


2. Insert the flat end of a nylon pointer where shown and twist it to dislodge the phone lock key, then use style 2A tweezers to remove it from the outer base cover.



3. Obtain a new phone lock key. Use style 2A tweezers to position the phone lock key so that the edge indicated goes behind the retainer tab.

4. Press on the phone lock key so that it snaps into place in the outer base cover.





5. Make sure the phone lock key is in the position shown. Grip the speaker box near the antenna and insert it straight into the outer base cover. If it does not go in straight, it may knock out the RF plug or volume key.

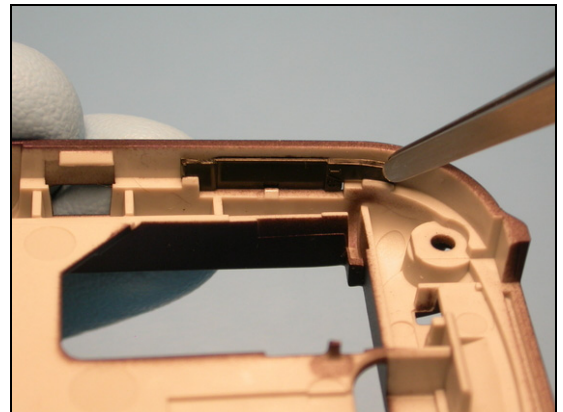
Perform the reassembly procedure from section 3.2.5



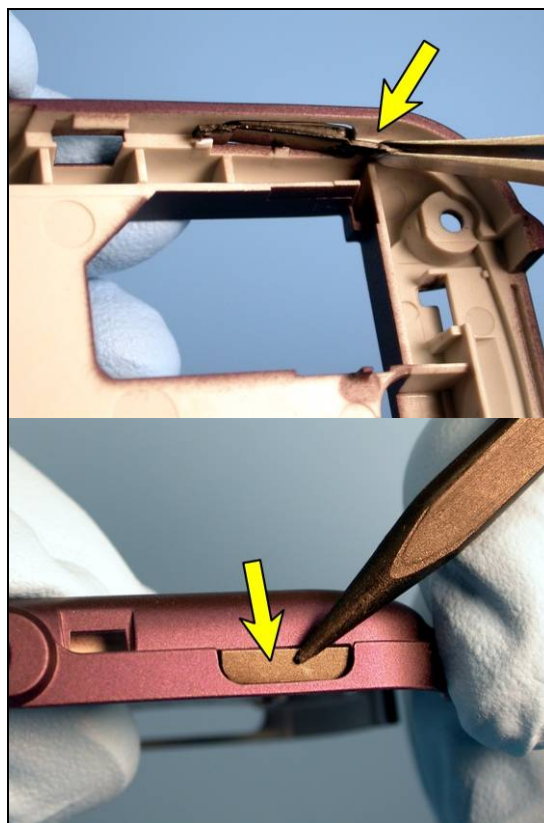
4.10 Infrared Window

Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Use style 2A tweezers to remove the infrared window by...



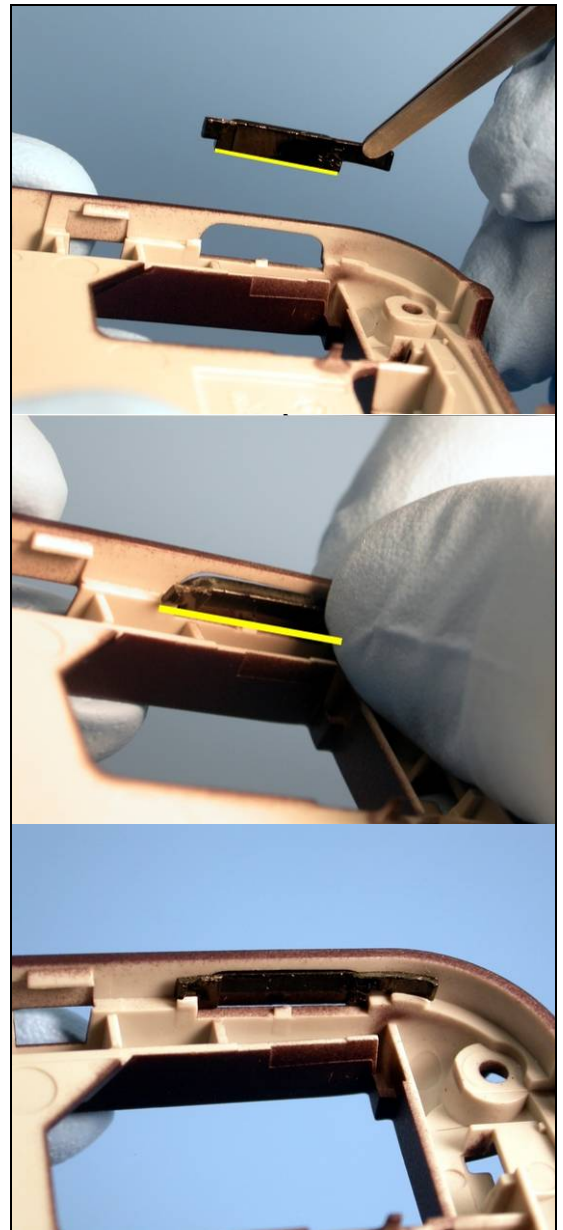
2. Use style 2A tweezers to dislodge the end of the IR window closest to the system connector opening in the outer base cover.
3. With a nylon pointer, push on the IR window from the outside of the outer base cover to remove it from its hole in the outer base cover.





4. Obtain a new IR window. Using style 2A tweezers, position the IR window as shown so that the edge indicated goes into its hole in the outer base cover first.
5. Press on the IR window so that it snaps into place in the outer base cover. Make sure the portions indicated snap behind the tabs.

Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.



4.11 Antenna Cover

Perform sections 2.1.1-2.1.4 of the base portion disassembly procedure.

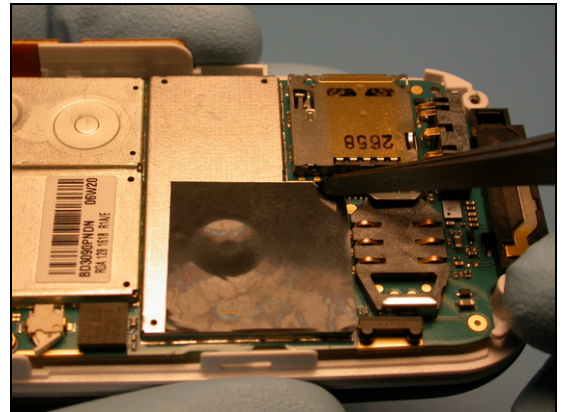
Obtain a new antenna cover.

Starting at section 3.2.4, perform the remainder of the base portion reassembly procedure.

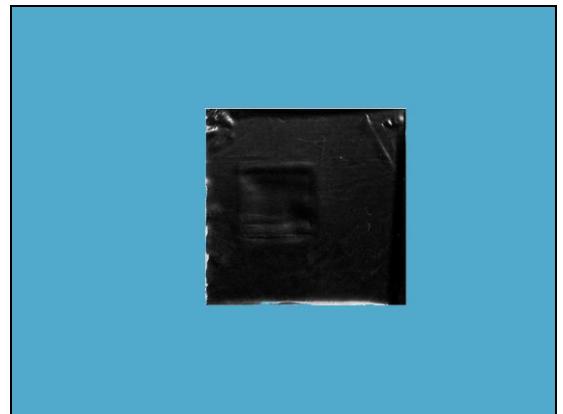
4.12 SIM Tape

Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

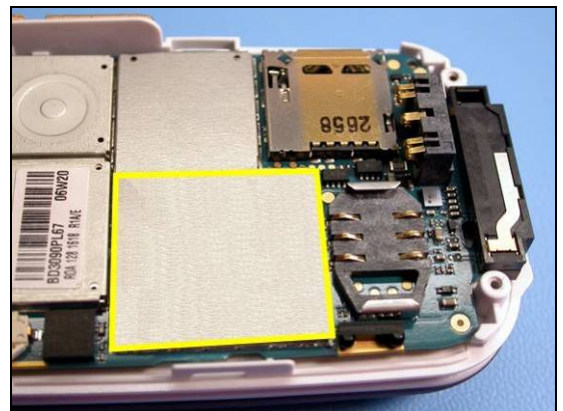
1. Use style 2A tweezers to peel the SIM tape off the shield can.



2. Obtain a new SIM tape.

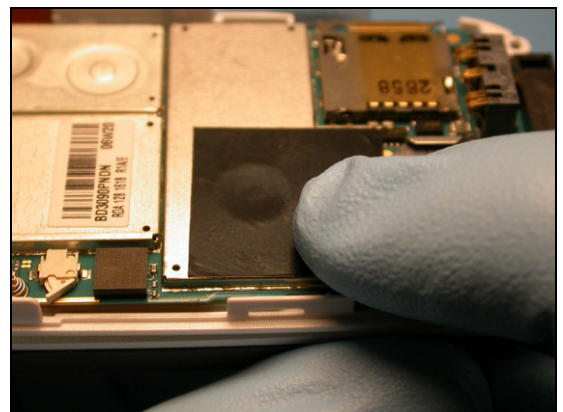


3. Using tweezers, position the SIM tape as shown. Line up the SIM tape with the shield can edges indicated. The final location for the tape is highlighted.



4. Press down on the SIM tape to make sure it sticks well.

Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.



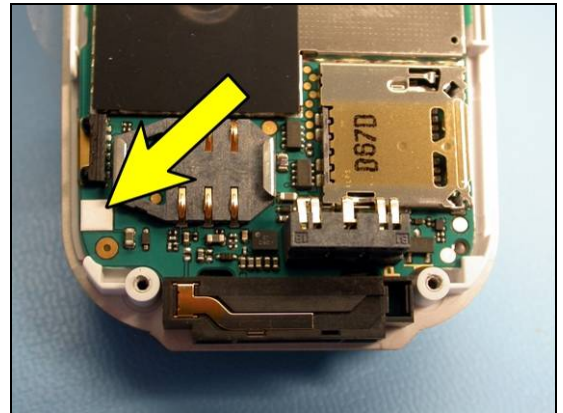


4.13 Liquid Intrusion Indicator

Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. If the liquid intrusion indicator is activated, handle the unit according to the instructions of your Sony Ericsson representative.

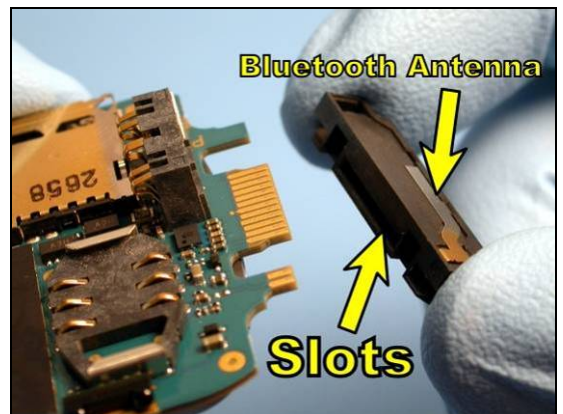
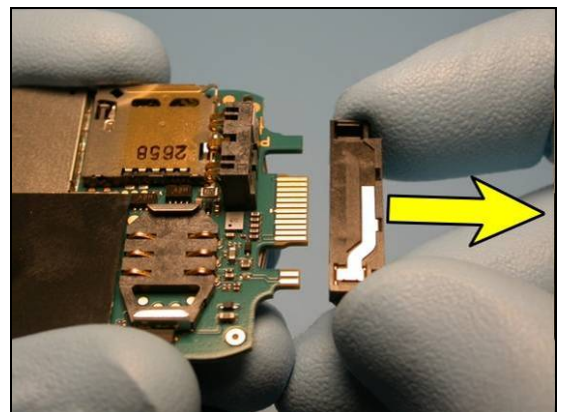
Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.



4.14 System Connector

Perform sections 2.1.1-2.1.5 of the base portion disassembly procedure.

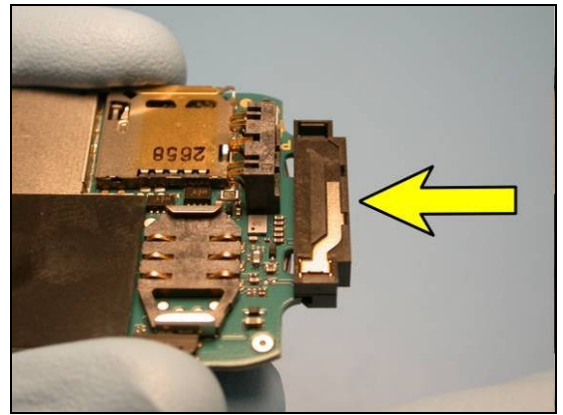
1. Grip the system connector on its ends and pull it straight off of the circuit board.
2. Obtain a new system connector and hold it so that the Bluetooth antenna is on the same side as the SIM connector as shown..





3. Slide the new system connector onto the edge of the circuit board so that the gold circuit board connectors go into their slots in the system connector.

Starting at section 3.2.3, perform the remainder of the base portion reassembly procedure.

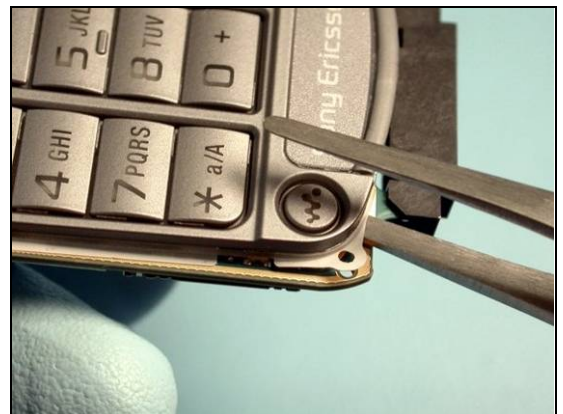


4.15 Keypad and Dome Array

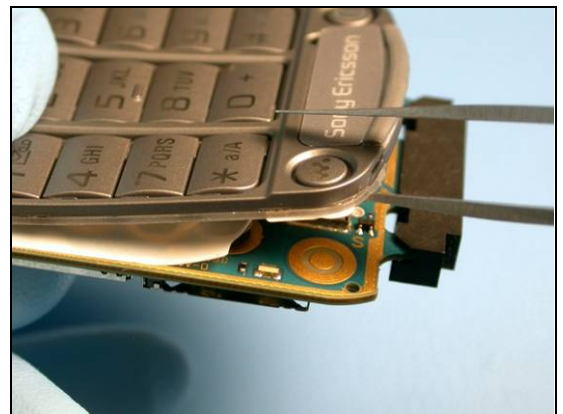
4.15.1 Removal

Perform sections 2.1.1-2.1.5 of the base portion disassembly procedure.

1. Insert one side of a pair of style 2A tweezers under the dome array as shown.

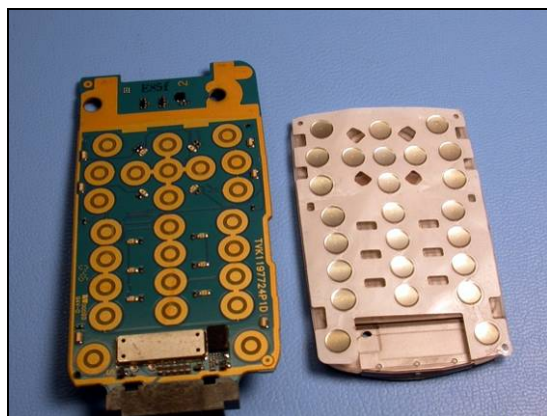


2. Lift the tweezers so that the corner of both the dome array and keypad pry off of the circuit board together.



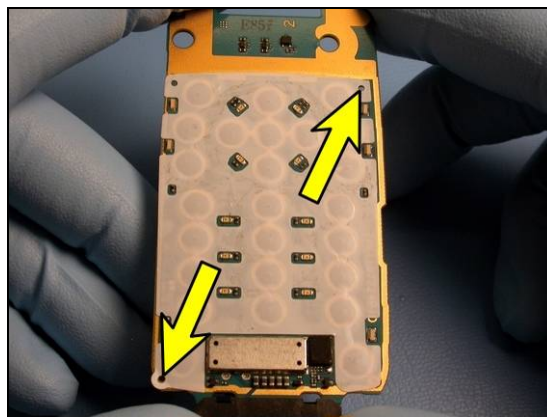


3. Pull the dome array and keypad at the same time as shown until they are separated from the circuit board. Use alcohol and a lint free cloth to clean any adhesive residue off of the circuit board, but be careful to not damage any of the components on the circuit board.



4.15.2 Installation

1. Obtain a new dome array and remove the protective film from its adhesive. Position it on the circuit board so that the two dome array holes indicated line up with holes in the circuit board. Make sure the LEDs on the circuit board line up with their holes in the dome array.



2. Except for the keypad, reassemble the phone by performing the reassembly procedures starting at section 3.2.3



3. Obtain a new keypad. Remove the protective film from its adhesive and position it over the dome array as shown. Be sure to insert the navigation key end of the keypad first as shown.





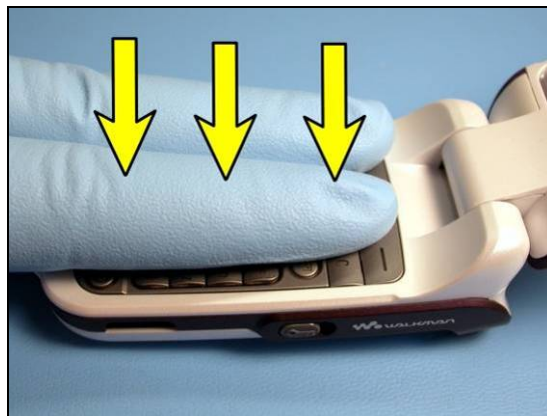
4. Lay the keypad down into its cavity in the inner base cover as shown. Make sure it is completely within its cavity.



5. Make sure there is not a gap at the top of the keypad.



6. Press down on the entire keypad surface for 30 seconds to make sure it sticks well.





7. Obtain a new flip bumper and remove it from its protective backing.
8. Position the flip bumper in the flip bumper cavity in the keypad. Make sure the flip bumper is completely in its cavity and not hanging over the side.



9. Press on the flip bumper to make sure it sticks well.



10. Obtain a new co-brand label and remove it from its protective backing.
11. Position the co-brand label in the co-brand label cavity in the keypad. Make sure the co-brand label is completely in its cavity and not hanging over the side.



12. Press on the co-brand label to make sure it sticks well.



No further reassembly is required.

4.16 Microphone Cloth

Perform sections 2.1.1-2.1.5 of the base portion disassembly procedure.

1. Perform the Keypad and Dome Array removal procedure from section 4.16.1

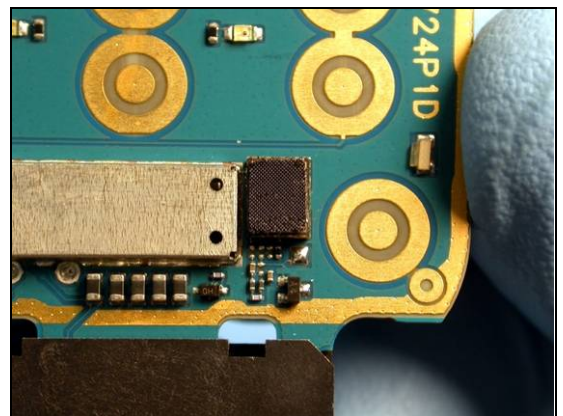
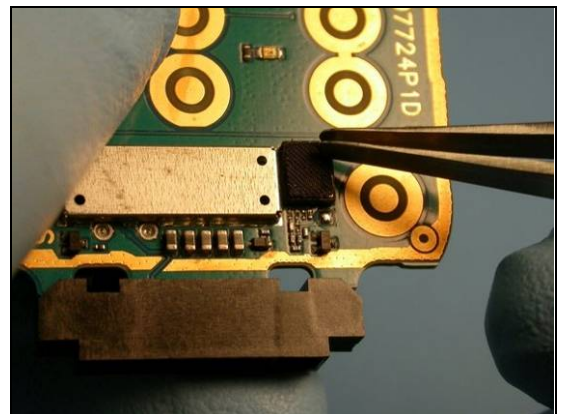
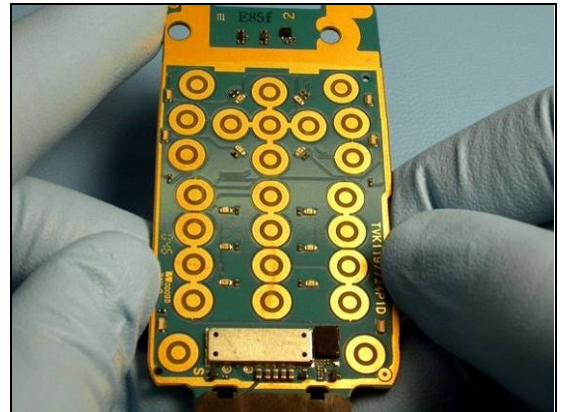
2. Using style 2A tweezers gently pull the microphone cloth off of the microphone.

NOTE! Be careful to not damage the microphone.

3. Obtain a new microphone cloth and remove the protective film from its adhesive. Position the microphone cloth so that it lines up with the microphone. Press it into place on the microphone so that a good bond is formed.

4. Perform the Keypad and Dome Array installation procedure from section 4.16.2

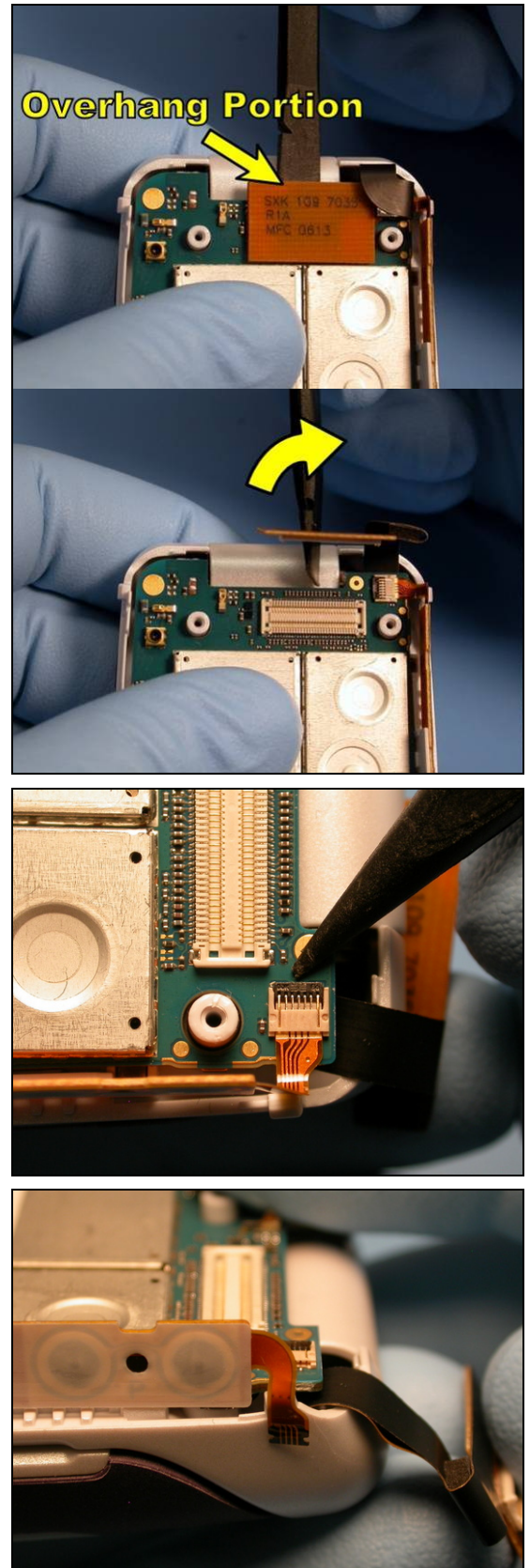
Starting at section 3.2.3, perform the remainder of the base portion reassembly procedure.



4.17 Side Key Flex Assembly

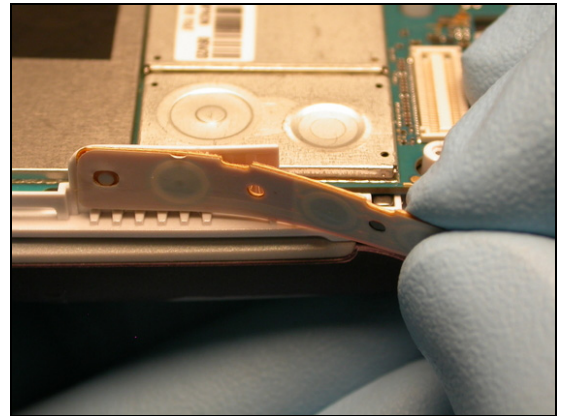
Perform sections 2.1.1-2.1.3 of the base portion disassembly procedure.

1. Insert the flat end of a nylon pointer between the hinge cover and the portion of the flex film's board connector that overhangs the edge of the circuit board.
2. Hold the circuit board in place and disconnect the main flex film assembly from the circuit board by twisting the nylon pointer as shown.
3. Rotate the black portion of the side key flex film's board connector 90 degrees toward the side key flex film assembly.
4. Using style 2A tweezers, remove the connection portion of the side key flex film from its connector and position it on the outside of the phone as indicated.

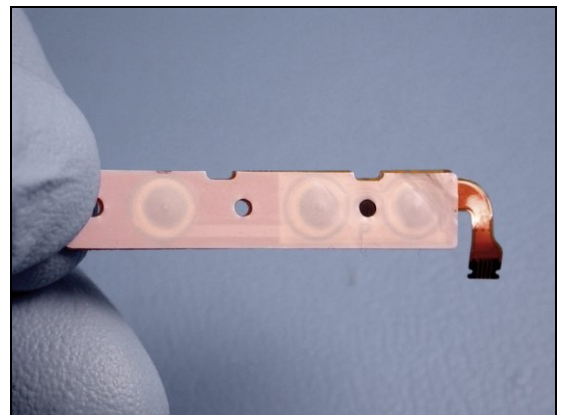




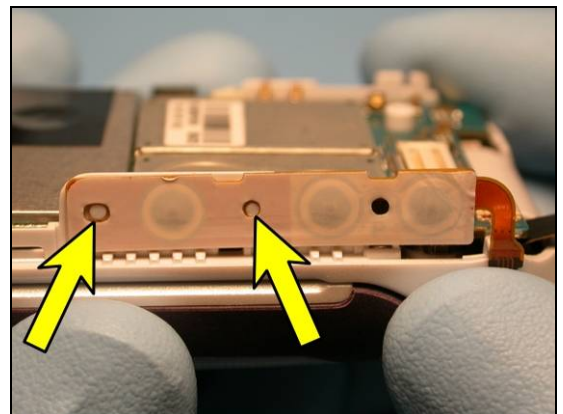
5. Pull the side key flex film assembly off its tab. Use alcohol and a lint free cloth to remove any adhesive residue from the tab.



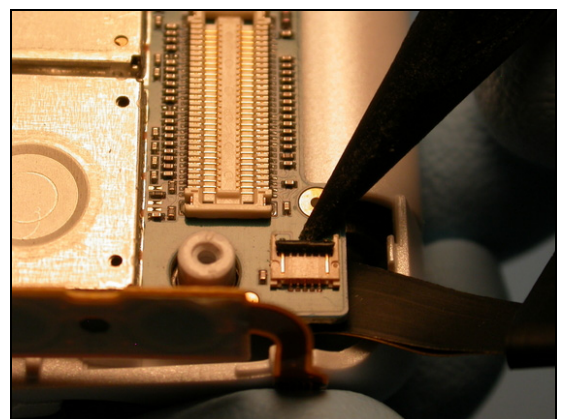
6. Obtain a new side key flex film assembly and remove the protective film from its adhesive.



7. Position the side key flex film assembly onto the support plate as shown. Make sure the alignment pegs go through the alignment holes.



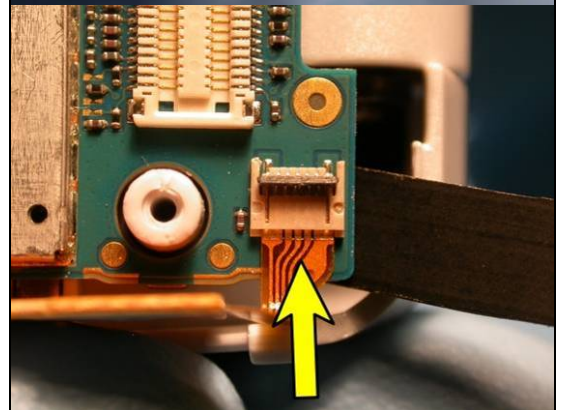
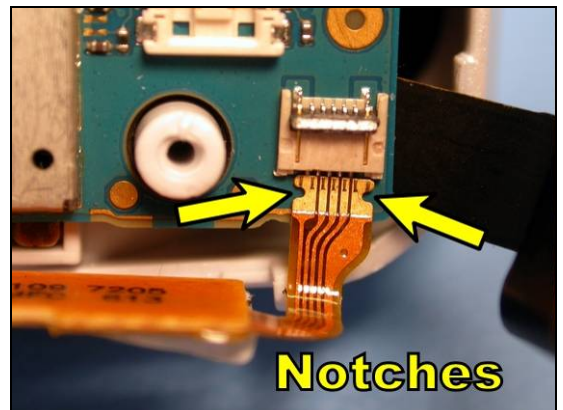
8. Make sure the black portion of the side key flex's board connector is rotated towards the side key flex film so that it forms a 90 degree angle to the circuit board.



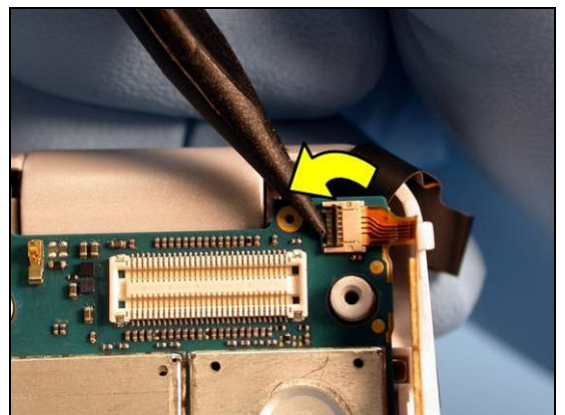


NOTE! AVOID OVERSTRESSING THE SIDE KEY FLEX FILM WHEN POSITIONING IT IN ITS CIRCUIT BOARD CONNECTOR. NON-VISIBLE DAMAGE TO THE FLEX FILM CAN OCCUR.

9. Using style 2A tweezers, insert the side key flex film assembly into its connector until the notches cannot be seen.

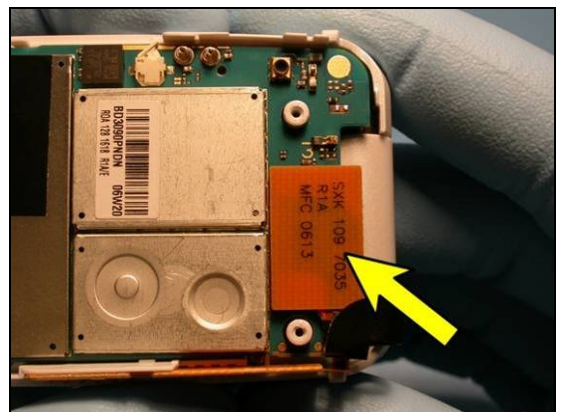


10. Rotate the black portion of the side key flex's board connector back down onto the circuit board as shown.



11. Plug the main flex film assembly into its board connector.

Starting at section 3.2.5, perform the remainder of the base portion reassembly procedure.





4.18 Co-Brand Label and Flip Bumper

No disassembly required.

1. Insert the tip of Style 2A tweezers under both the flip bumper and co-brand label as shown.

NOTE! *Be careful to not damage the inner base cover with the tweezers. Use a pry tool instead if necessary.*



2. Pry toward the keypad to lift the flip bumper and co-brand label together.



3. Use alcohol and a lint free cloth to remove any residue left by the flip bumper and co-brand label adhesive.





4. Obtain a new flip bumper and remove it from its protective backing.
5. Position the flip bumper in the flip bumper cavity in the keypad. Make sure the flip bumper is completely in its cavity and not hanging over the side.



6. Press on the flip bumper to make sure it sticks well.



7. Obtain a new co-brand label and remove it from its protective backing.
8. Position the co-brand label in the co-brand label cavity in the keypad. Make sure the co-brand label is completely in its cavity and not hanging over the side.



9. Press on the co-brand label to make sure it sticks well.

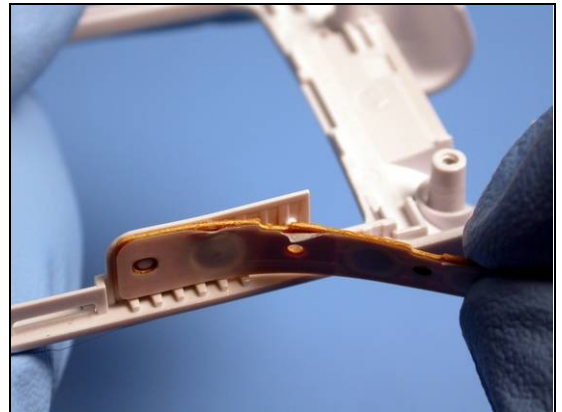


No further reassembly is required.

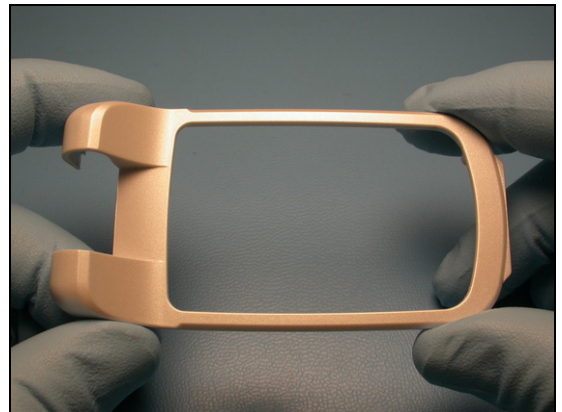
4.19 Inner Base Cover

Perform sections 2.1.1-2.1.6 of the base portion disassembly procedure.

1. Pull the side key flex film assembly off its tab on the old inner base cover.

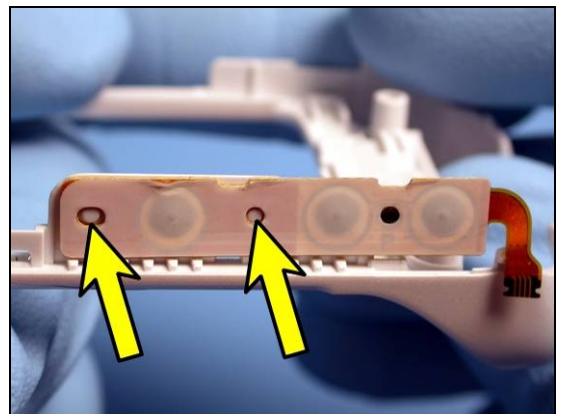


2. Obtain a new inner base cover.



3. Position the side key flex film assembly onto the support plate of the new inner base cover as shown. Make sure the alignment pegs go through the alignment holes. Press on the side key flex assembly to make sure it sticks well.

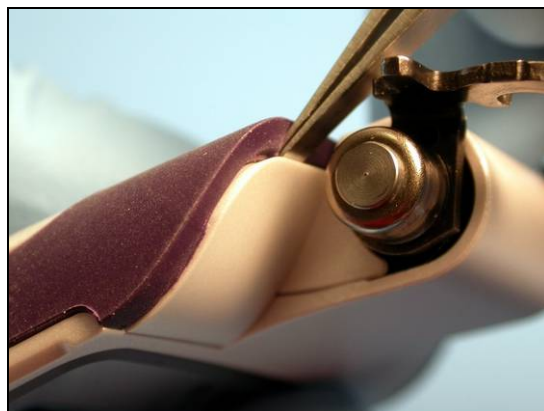
Starting at section 3.2.2, perform the remainder of the base portion reassembly procedure.



4.20 Flip Screw Cover

Perform sections 2.1.1-2.1.6 of the base portion disassembly procedure.

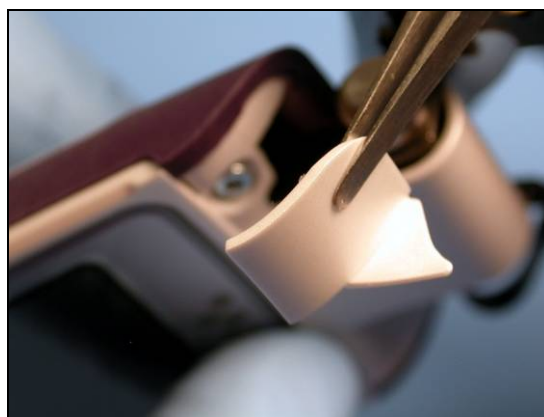
1. Insert the tip of a pair of style 2A tweezers behind the flip screw cover under the metal hinge as shown.



2. Rotate the tweezers away from the hinge to pry up the flip screw cover.



3. When the flip screw cover has been freed, lift it away from the phone with the tweezers.



4. Obtain a new flip screw cover and remove its protective backing.

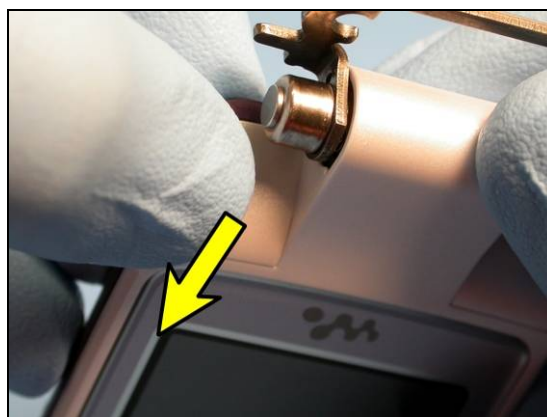




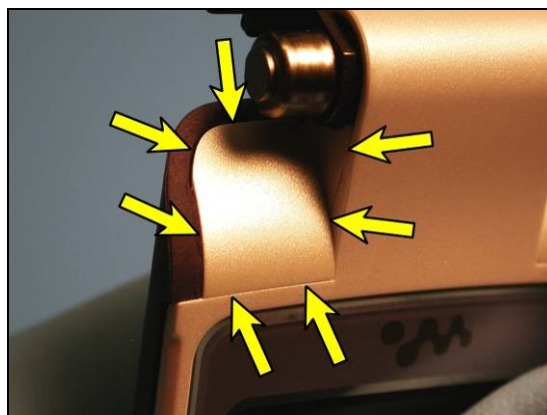
5. Using style 2A tweezers, position the screw cover so that its tab goes into place under the hinge as shown.



6. Seat the flip screw cover and press in and down toward the main display.

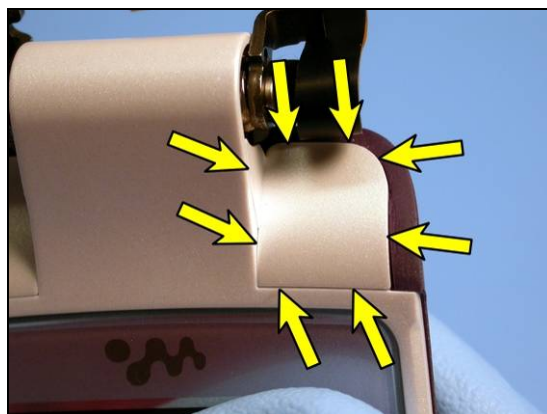


7. Make sure the flip screw cover is fully seated and that there are no gaps around it.



8. Repeat with the other flip screw cover.

Starting at section 3.1.2, perform the remainder of the base portion reassembly procedure.





4.21 Outer Flip Cover

Perform sections 2.1.1-2.2.2 of the base portion disassembly procedure.

Obtain a new Outer Flip Cover.

Starting at section 3.1.2, perform the remainder of the base portion reassembly procedure.

4.22 Camera Ring

NOTE: THIS SECTION IS FOR W710 ONLY.

Perform sections 2.1.1-2.2.2 of the base portion disassembly procedure.

Obtain a new Camera Ring.

Starting at section 3.1.2, perform the remainder of the base portion reassembly procedure.

4.23 Inner Flip Cover

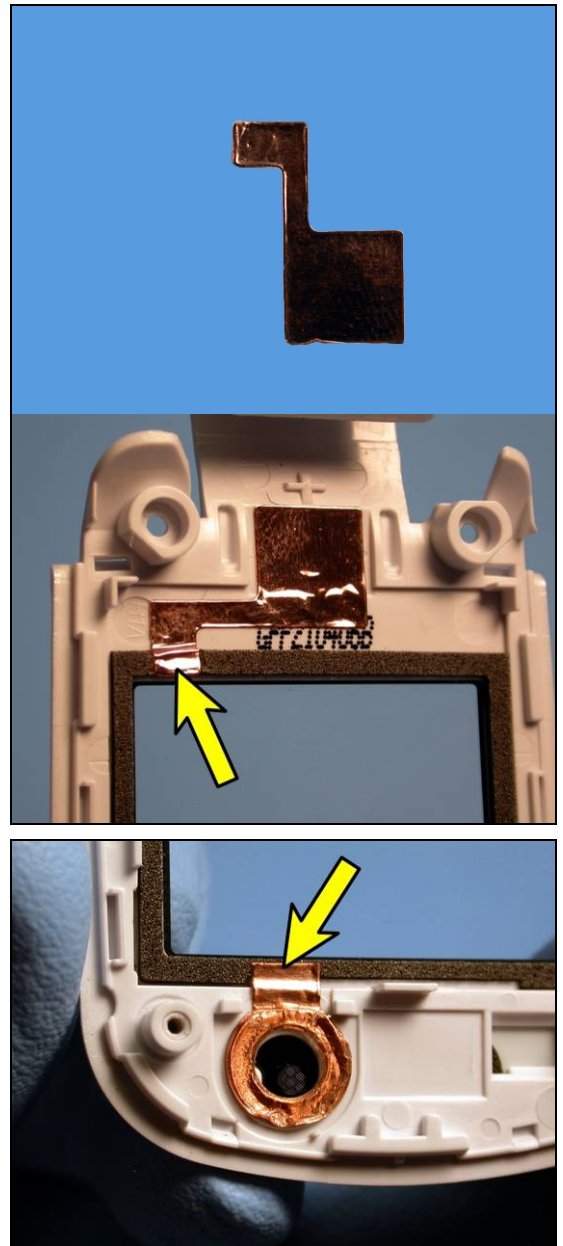
Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. Obtain a new inner flip cover.





2. Obtain a new inner flip cover tape and remove it from its protective backing.
3. Position the inner flip cover tape where shown so that the portion indicated goes over the foam. Make sure the tape does not extend onto the display window. Press on the tape to make sure it sticks well.
4. Obtain a new receiver tape and remove it from its protective backing. Place it as shown, making sure that the hole in the receiver tape lines up with the hole in the inner flip cover and that the tape extends onto the foam around the display window. Make sure the tape does not extend onto the display window.

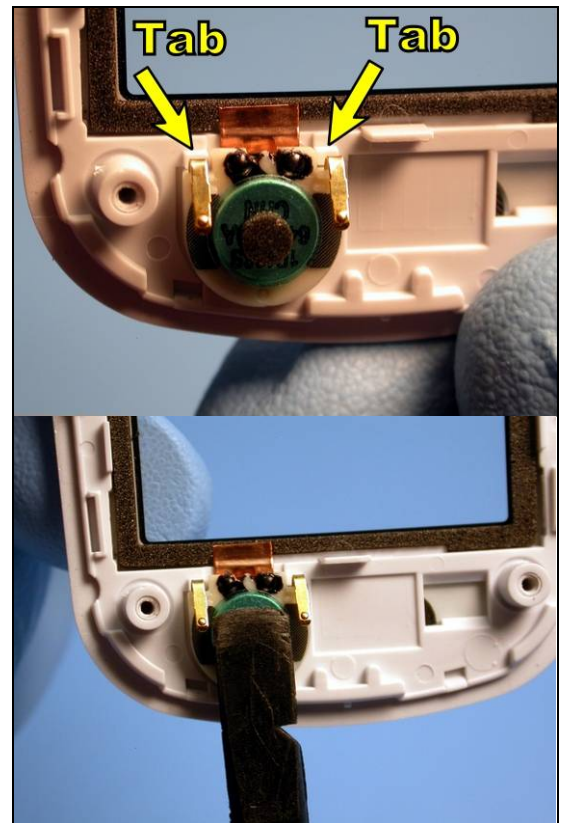




5. Obtain a new receiver and position with the contact finger side nearest to the display window. Make sure the receiver lines up with the two alignment tabs indicated.

6. Use the flat end of a nylon pointer to press the receiver so that it sticks well. Be careful to not press directly on the contact fingers.

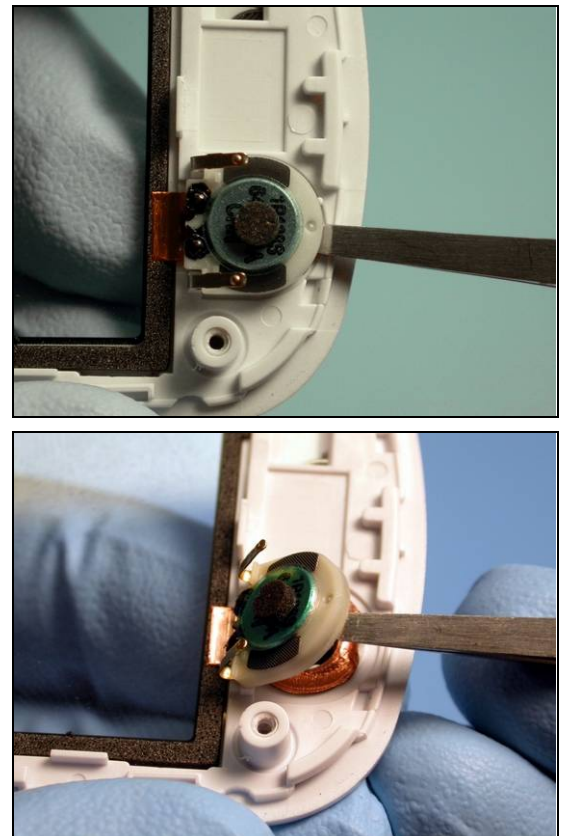
Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.



4.24 Receiver

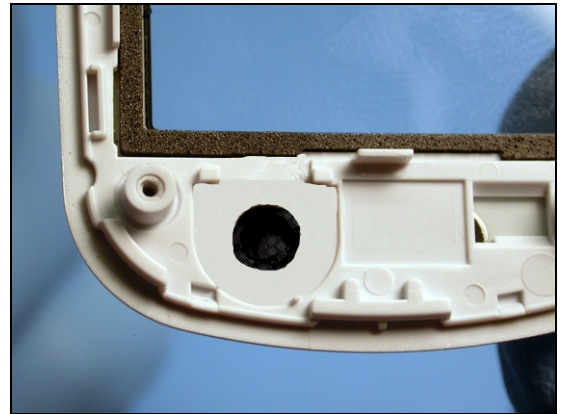
Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. Insert the tip of a pair of style 2A tweezers under the receiver where shown.
2. Use the tweezers to pry the receiver free from its location.

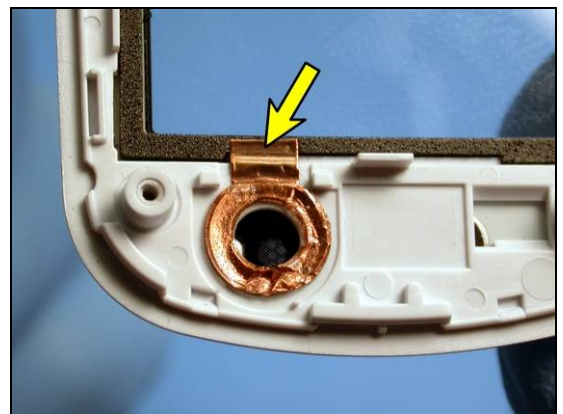




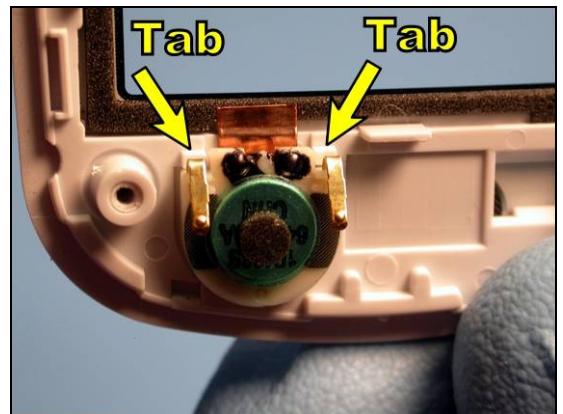
3. Using style 2A tweezers, remove the receiver tape. Use alcohol and a lint free wipe to remove any remaining adhesive residue.



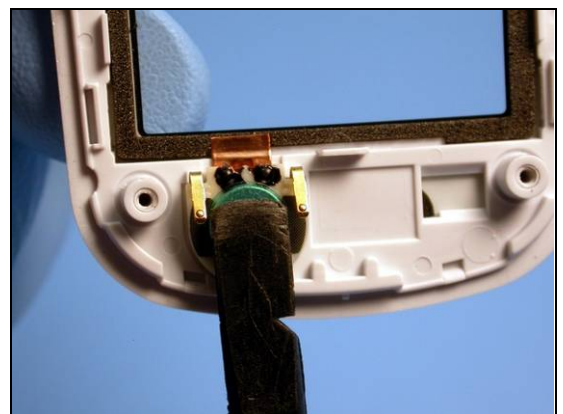
4. Obtain a new receiver tape and remove it from its protective backing. Place it as shown, making sure that the hole in the receiver tape lines up with the hole in the inner flip cover and that the tape extends onto the foam around the display window.



5. Obtain a new receiver and position with the contact finger side nearest to the display window.



6. Use the flat end of a nylon pointer to press the receiver so that it sticks well. Be careful to not press directly on the contact fingers.

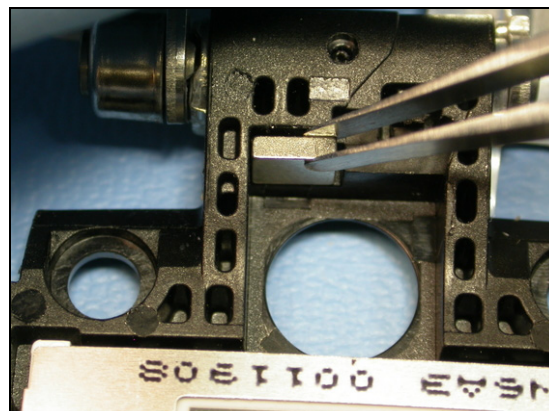


Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.

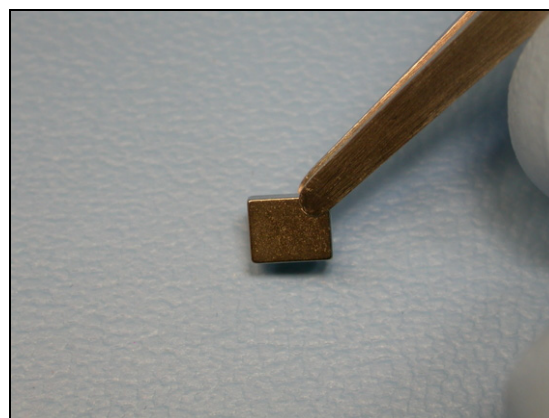
4.25 Magnet

Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. Use style 2A tweezers to remove the old magnet. Use alcohol and a lint free cloth to remove any adhesive residue.

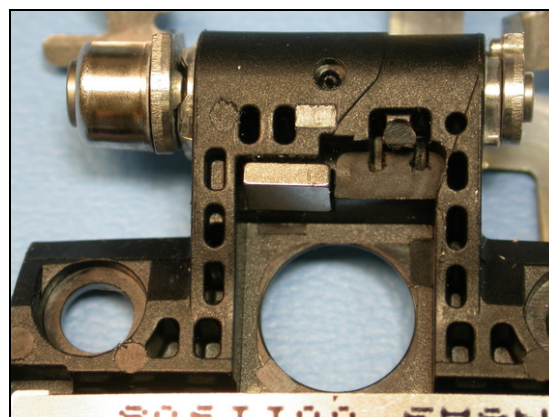


2. Obtain a new magnet.



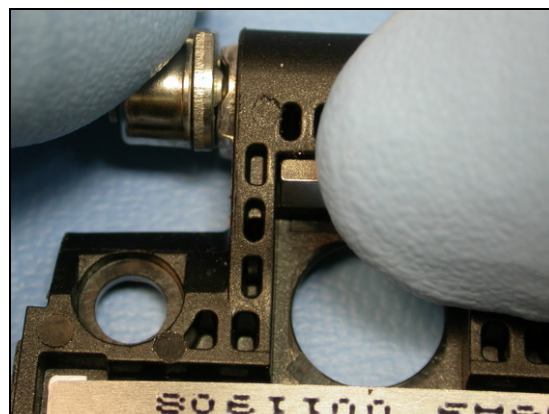
3. Remove the protective film from the magnet's adhesive and install it so that its long side matches with the long side of the magnet cavity. The magnet should completely fill the magnet cavity.

NOTE! AVOID CONTAMINATING THE MAGNET'S ADHESIVE.



4. Press the magnet firmly to make sure it sticks well.

Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.



4.26 Vibrator

Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. With the flip frame oriented as shown, locate the two holes indicated.
2. Using style 2A tweezers, press the vibrator from its cavity by pushing on the vibrator through the two holes.

NOTE! AVOID DAMAGING THE VIBRATOR'S CONTACTS.

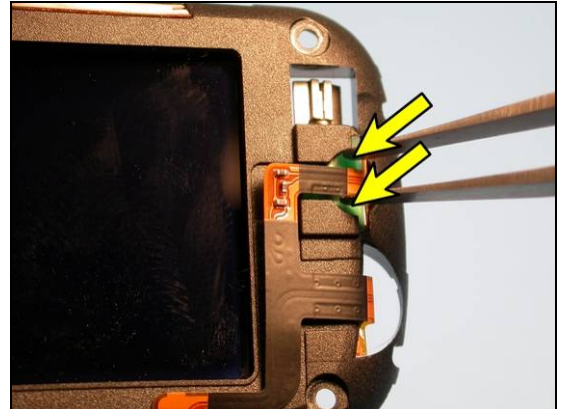
3. Obtain a new vibrator and hold it as shown so that the weight is oriented toward the edge of the flip frame.

4. Position the vibrator halfway into the vibrator cavity so that the lower contact finger is inside the cavity.

5. Using the flat end of a nylon pointer, compress the second contact finger slightly and slide the vibrator completely into the cavity. Be careful to not damage the contact fingers.

NOTE! MAKE SURE BOTH VIBRATOR CONTACTS FIT INTO THE PROPER PLACE. AVOID DAMAGING THE CONTACTS.

Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.

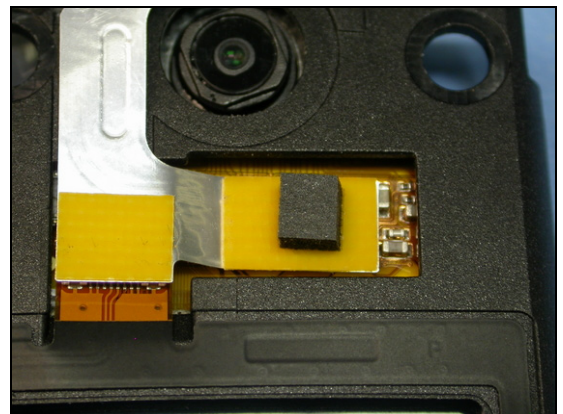
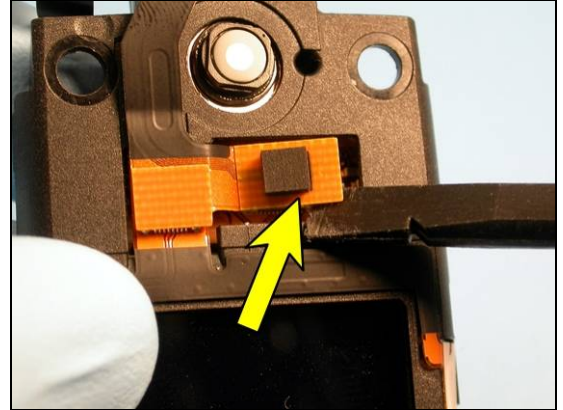


4.27 Display Assembly

Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. Orient the flip frame so that the small display is toward you, and so that your hand is under the large display.
2. Using a pry tool, disconnect the main flex assembly from the large display as shown. The large display will fall out of the back of the flip frame into your hand.
3. Obtain a new large display and insert it into the flip frame as shown.
4. While holding the large display in place, connect the main flex assembly to the display as shown.

Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.

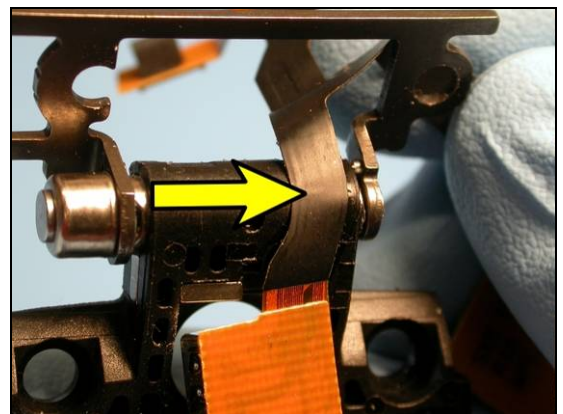
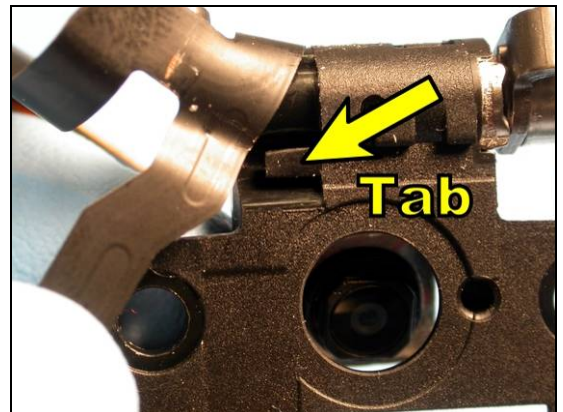
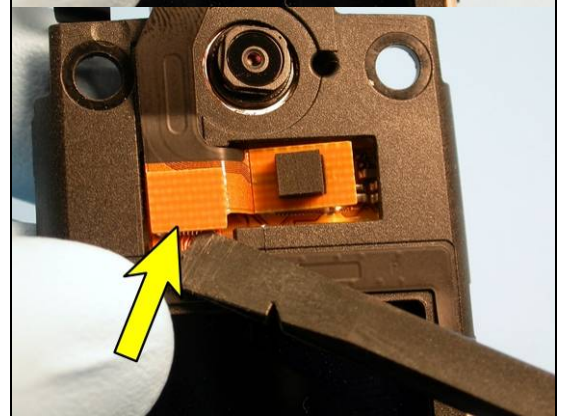
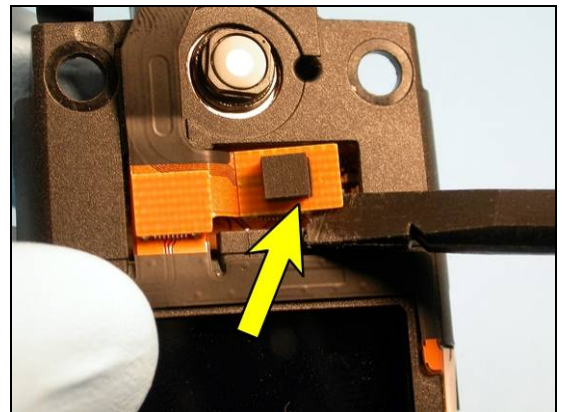




4.28 Main Flex Assembly

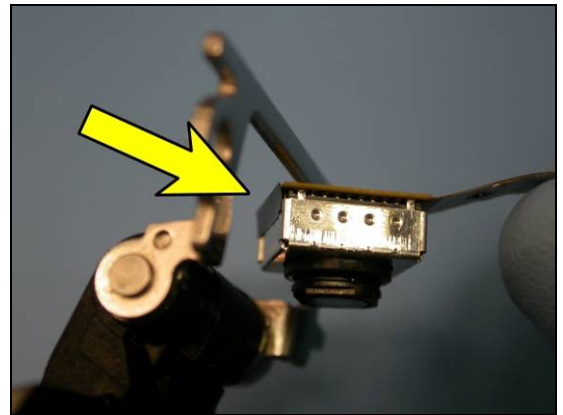
Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. Orient the flip frame so that the small display is toward you, and so that your hand is under the large display.
2. Using a pry tool, disconnect the main flex assembly from the large display and flip flex assembly as shown. The large display will fall out of the back of the flip frame into your hand. Set the display aside.
3. Remove the main flex from behind the restraining tab.
4. The main flex is adhered to the top of the hinge where shown. Pull it off of the hinge.

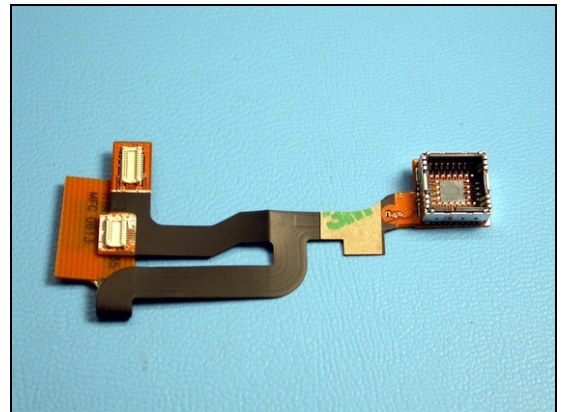




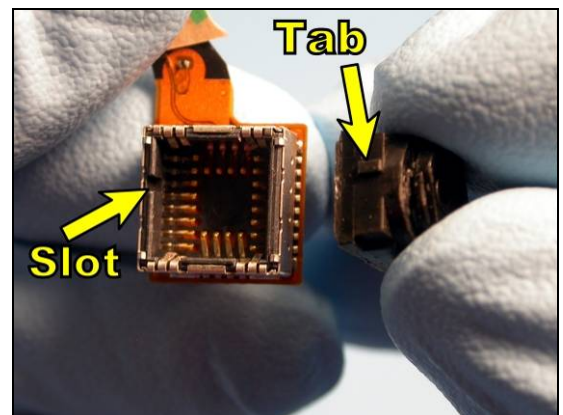
5. Remove the main flex by passing the camera module through the opening in the hinge.



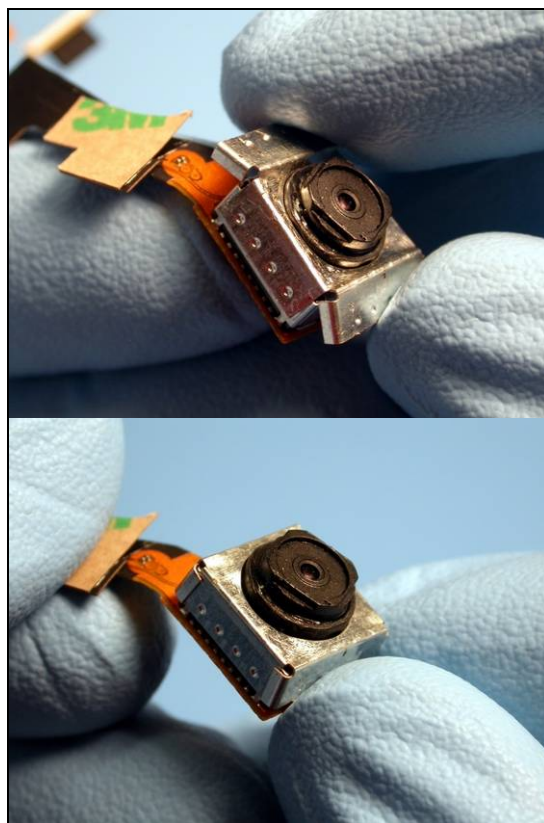
6. Obtain a new main flex assembly.



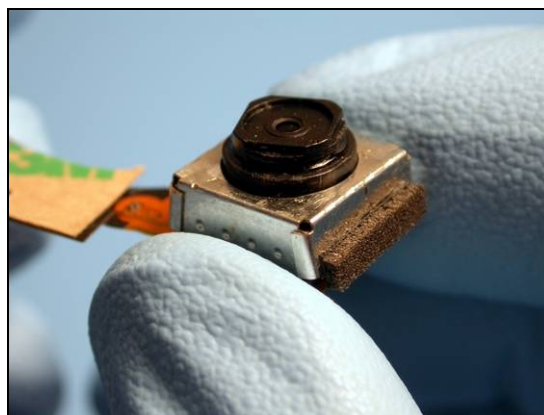
7. Obtain a new camera module and insert it into the camera socket so that the alignment tab goes into the alignment slot. The camera will only fit in this orientation.



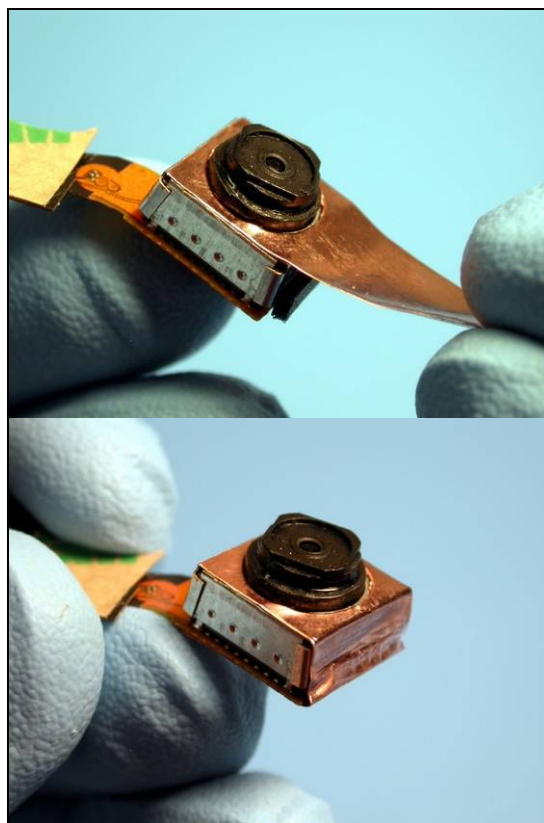
8. Obtain a new camera shield cover and place it over the camera in the orientation shown. Fold the shield cover wings down around the camera so that the camera is held in place securely.



9. Obtain a new camera foam pad and install it on the side of the camera opposite from the flex film.



10. Obtain a new camera tape and place the hole in the tape around the camera module. Fold the tape down and around the camera module so that it follows the contour of the foam pad.

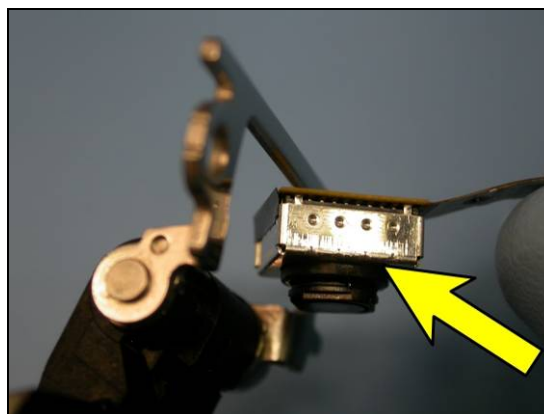


11. Obtain a new LCD connector pad and remove it from its protective backing. Place the pad in its location on the main flex to LCD connector and press to make sure it sticks well.



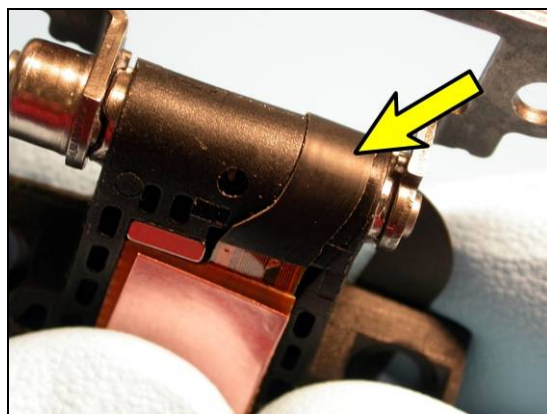
12. Pass the camera module through the opening in the metal hinge.

NOTE! BE CAREFUL TO NOT DAMAGE THE CAMERA.

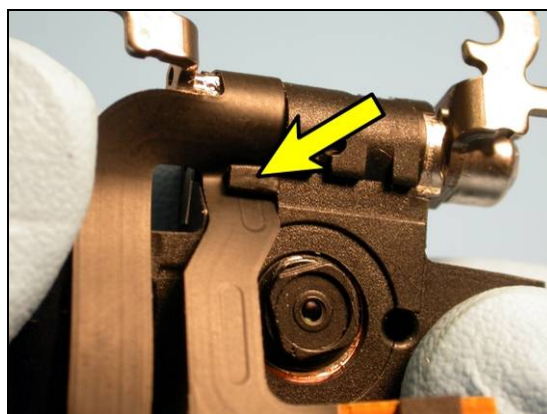




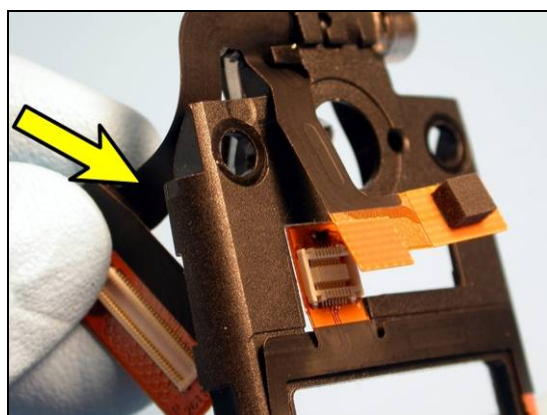
13. Insert the camera module into the camera cavity in the flip frame.
14. Hold the camera module in place and remove the protective film from the main flex assembly adhesive. Press the adhesive onto the hinge.



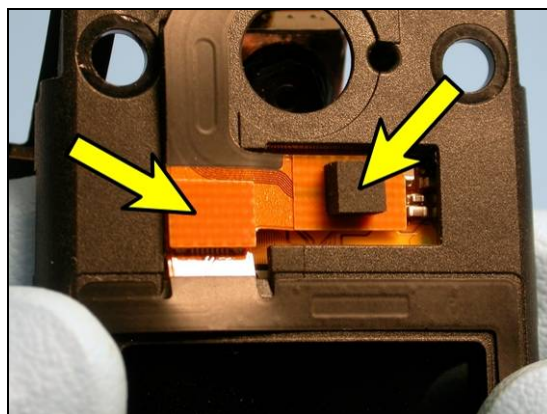
15. Position the main flex assembly beneath the retainer tab as shown.



16. Reposition the circuit board connector portion of the main flex assembly to the main display side of the flip frame. Be careful with the main flex film; do not over stress it as it can tear easily.



17. Hold the display into place in the flip frame. Connect the main flex assembly to the display and flip flex assembly as shown.



Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.

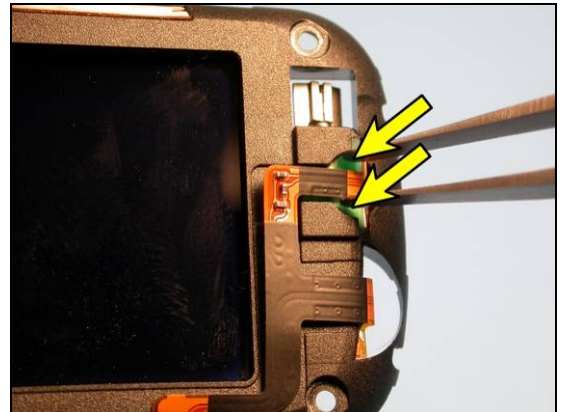


4.29 Flip Flex Assembly

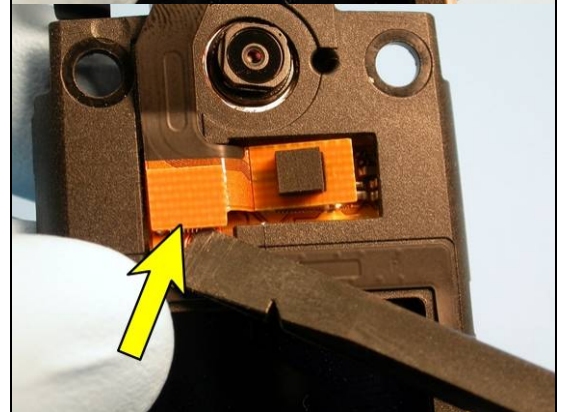
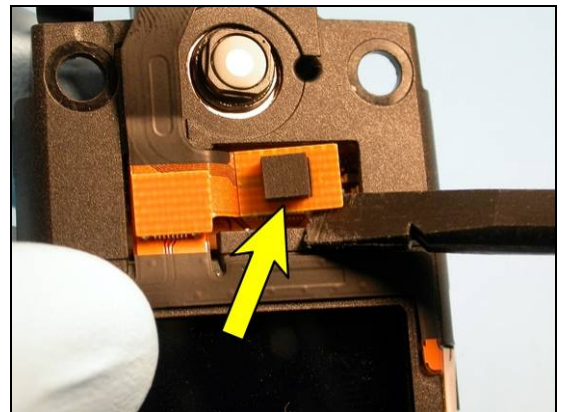
Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. With the flip frame oriented as shown, locate the two holes indicated.
2. Using style 2A tweezers, press the vibrator from its cavity by pushing on the vibrator through the two holes.

NOTE! AVOID DAMAGING THE VIBRATOR'S CONTACTS.

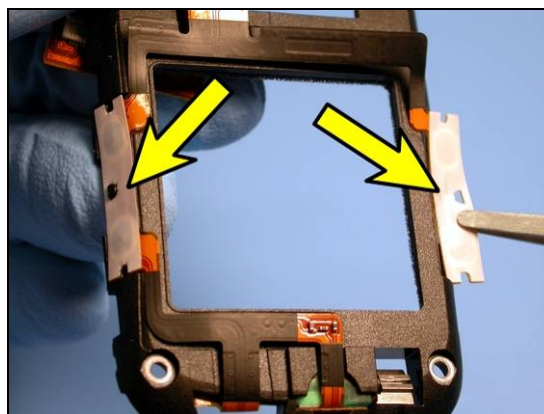


3. Orient the flip frame so that the small display is toward you, and so that your hand is under the large display.
4. Using a pry tool, disconnect the main flex assembly from the large display as shown. The large display will fall out of the back of the flip frame into your hand.

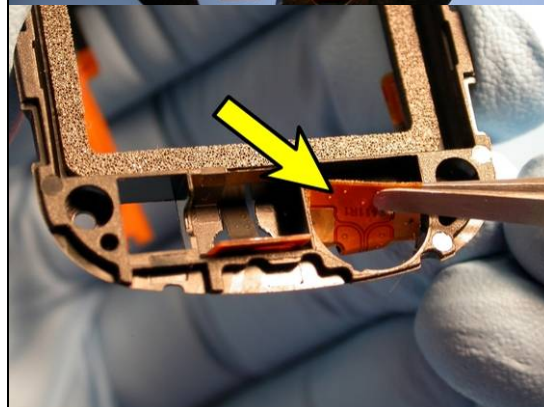




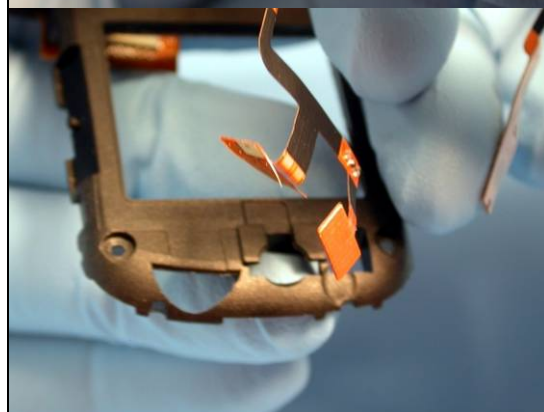
5. The flip flex assembly is adhered to the flip frame where indicated. Use style 2A tweezers to pull it off of the flip frame.



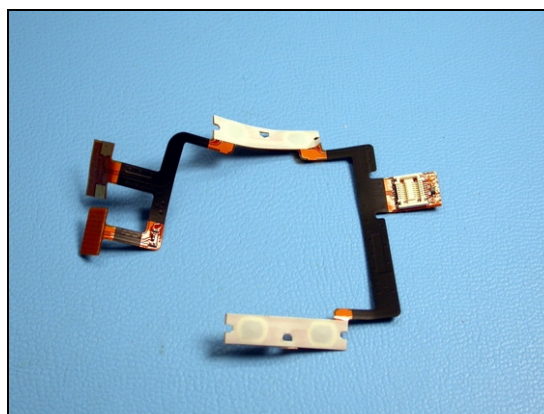
6. The receiver contact portion of the flip flex assembly is adhered to the flip frame. Use style 2A tweezers to pull it off of the flip frame.



7. Pull the vibrator and receiver contact portions of the flip flex assembly through their holes in the flip frame.



8. Obtain a new flip flex assembly.

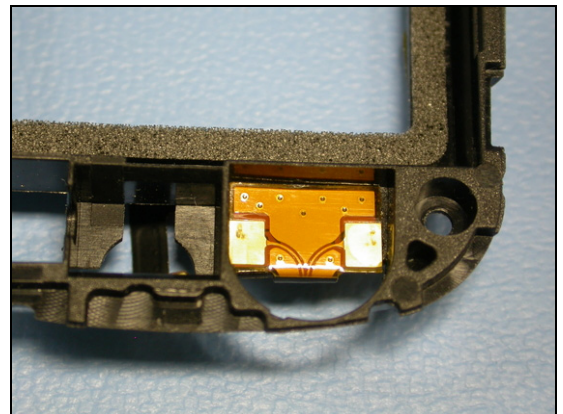




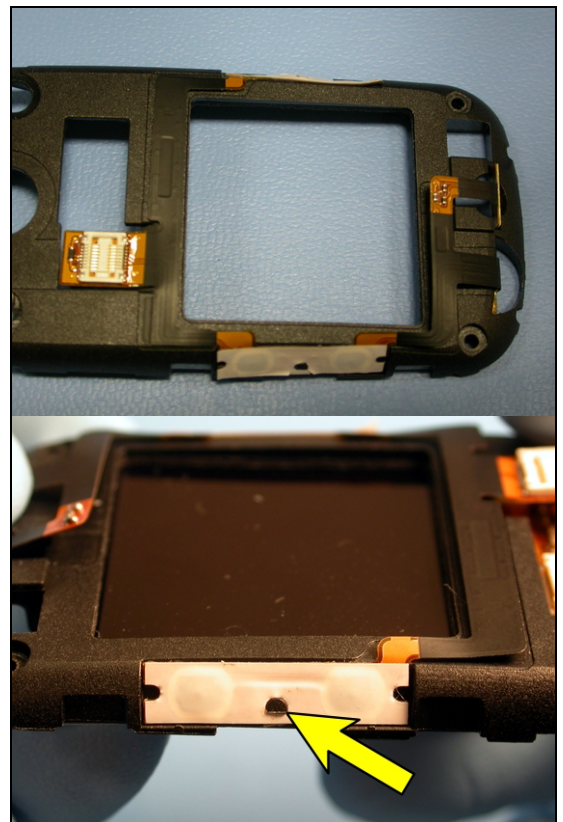
9. Using style 2A tweezers, position the receiver contact portion of the flip flex assembly through its opening in the flip frame as shown. Position the vibrator contact portion of the flex through its opening.



10. Remove the protective film from the receiver contact adhesive and use a pry tool to press the receiver contact portion down so that it sticks.

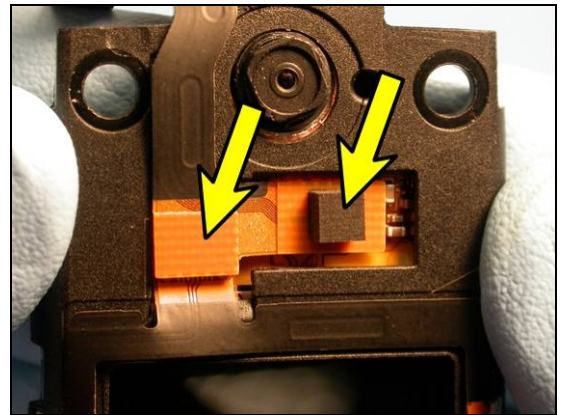


11. Remove any remaining protective film from adhesive areas and fold the flip flex assembly back onto the flip frame. Press the side key portions down over their alignment pegs. Repeat this for the other side of the flip flex assembly.

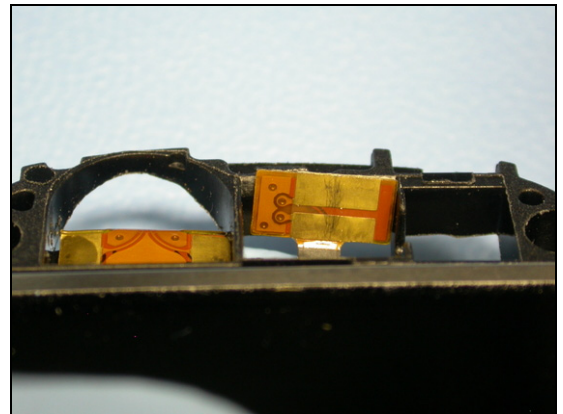




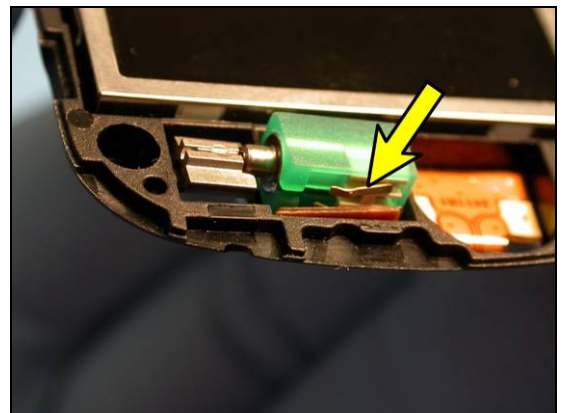
12. Insert the display into the flip frame and hold it in place. Connect the main flex assembly to the display and flip flex assembly as shown.



13. Make sure the vibrator contact portion of the flip flex assembly is positioned through the flip frame as shown.



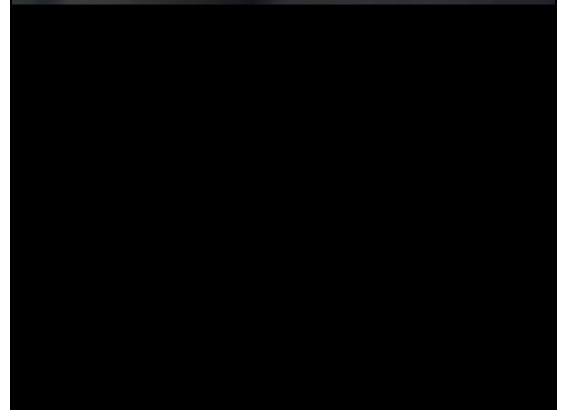
14. Position the vibrator halfway into the vibrator cavity so that the lower contact finger is inside the cavity.



15. Using the flat end of a nylon pointer, compress the second contact finger slightly and slide the vibrator completely into the cavity. Be careful to not damage the contact fingers.

NOTE! MAKE SURE BOTH VIBRATOR CONTACTS FIT INTO THE PROPER PLACE. AVOID DAMAGING THE CONTACTS.

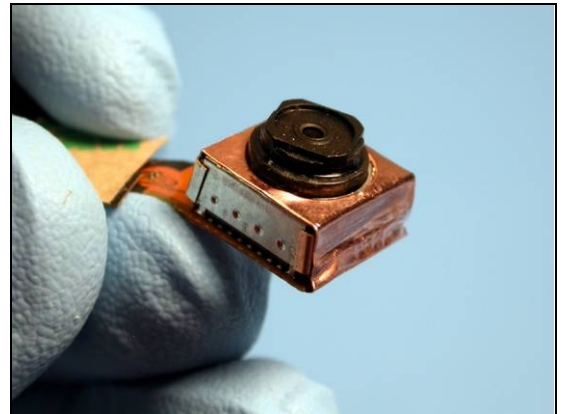
Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.





4.30 Camera Module

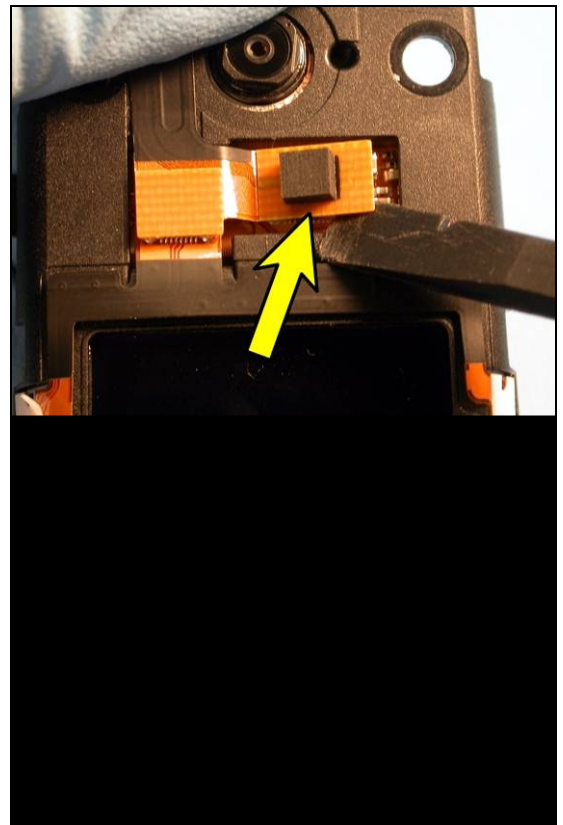
1. Camera module replacement is part of the main flex assembly replacement procedure. Perform the main flex assembly replacement procedure.



4.31 Flip Frame

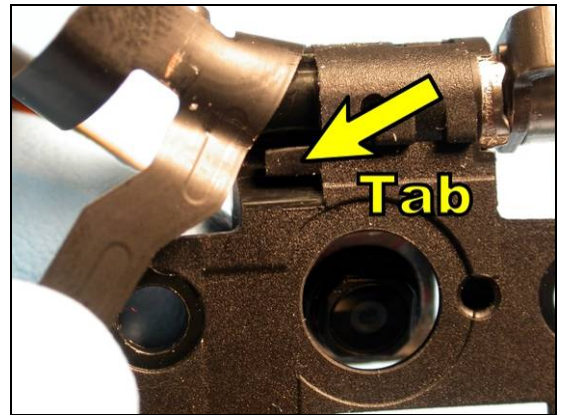
Perform sections 2.1.1-2.2.3 of the base portion disassembly procedure.

1. Orient the flip frame so that the small display is toward you, and so that your hand is under the large display.
2. Using a pry tool, disconnect the main flex assembly from the large display as shown. The large display will fall out of the back of the flip frame into your hand.

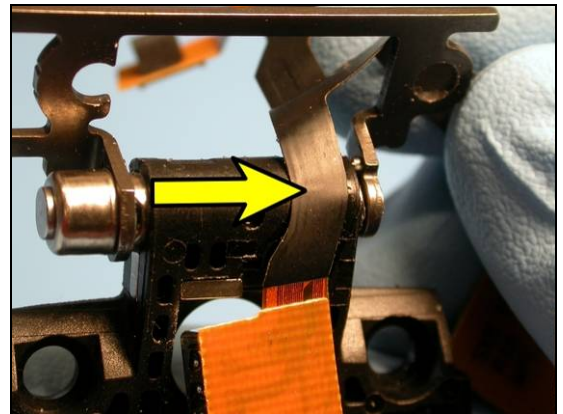




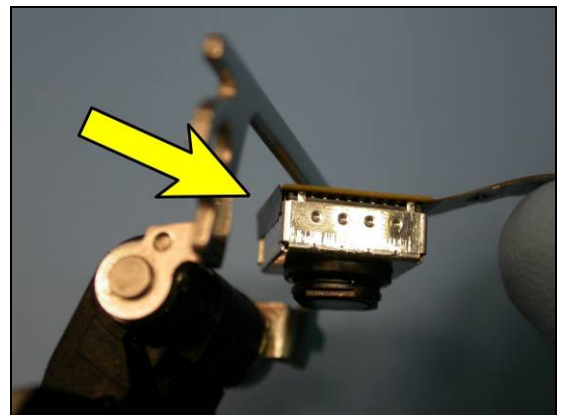
3. Remove the main flex from behind the restraining tab.



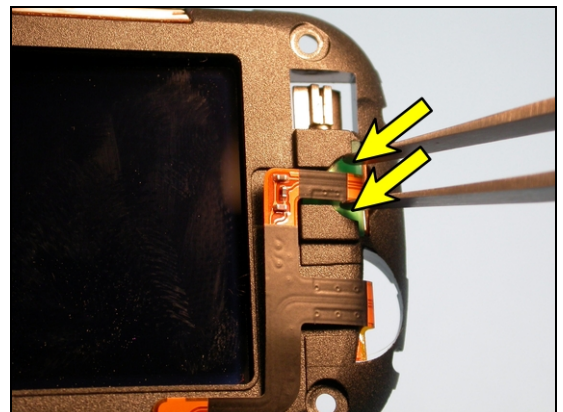
4. The main flex is adhered to the top of the hinge where shown. Pull it off of the hinge.



5. Remove the main flex by passing the camera module through the opening in the hinge.



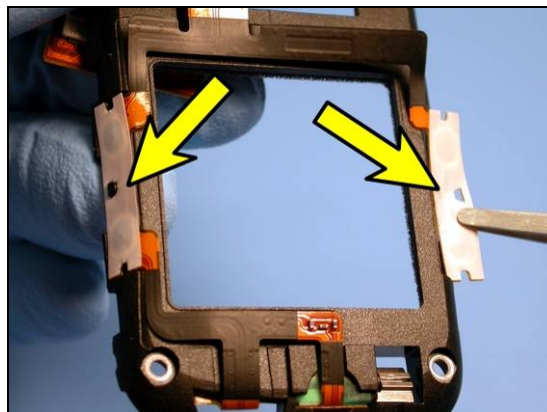
6. With the flip frame oriented as shown, locate the two holes indicated.
7. Using style 2A tweezers, press the vibrator from its cavity by pushing on the vibrator through the two holes.



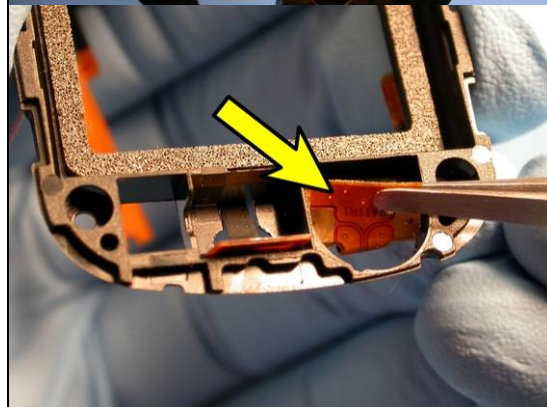
NOTE! BE CAREFUL TO NOT DAMAGE THE VIBRATOR CONTACTS.



8. The flip flex assembly is adhered to the flip frame where indicated. Use style 2A tweezers to pull it off of the flip frame.



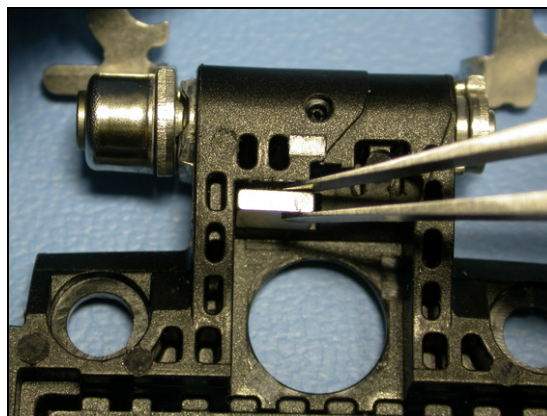
9. The receiver contact portion of the flip flex assembly is adhered to the flip frame. Use style 2A tweezers to pull it off of the flip frame.



10. Pull the vibrator and receiver contact portions of the flip flex assembly through their holes in the flip frame.

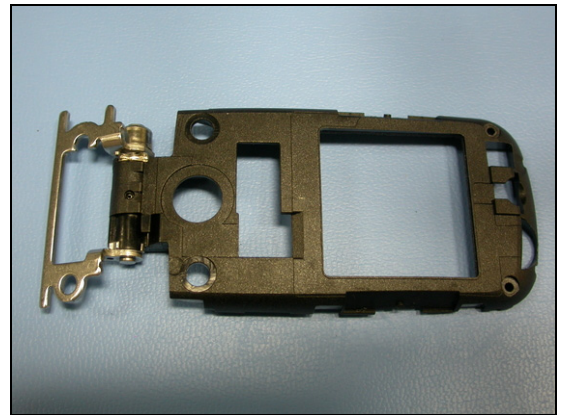


11. Use style 2A tweezers to remove the magnet. Use alcohol and a lint free cloth to remove any adhesive residue.



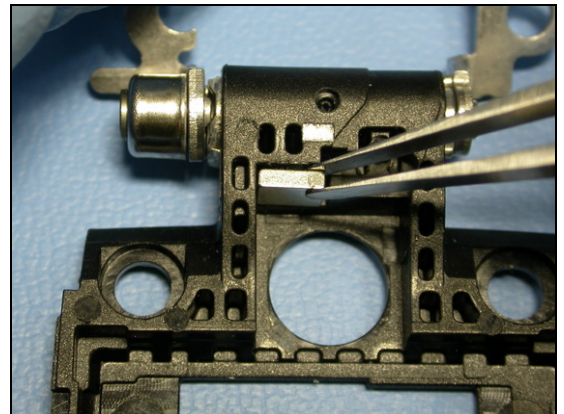


12. Obtain a new flip frame.

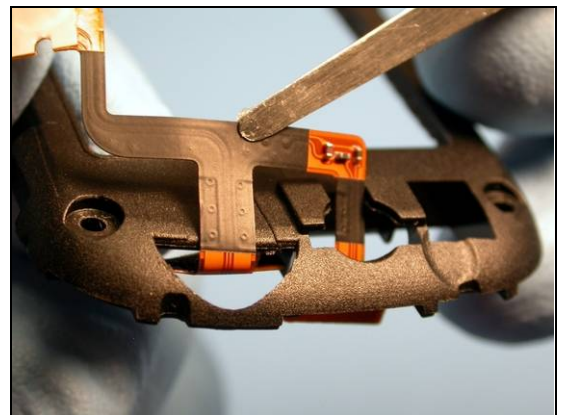


13. Install the magnet so that its long side matches with the long side of the magnet cavity. The magnet should completely fill the magnet cavity.

NOTE! AVOID CONTAMINATING THE MAGNET'S ADHESIVE.



14. Using style 2A tweezers, position the receiver contact portion of the flip flex assembly through its opening in the flip frame as shown. Position the vibrator contact portion of the flex through its opening.

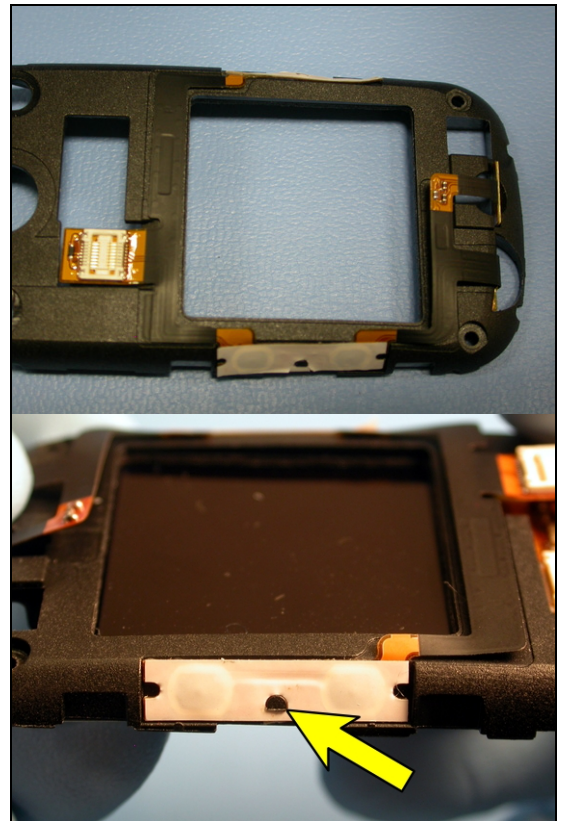


15. Use a pry tool to press the receiver contact portion down so that it sticks.

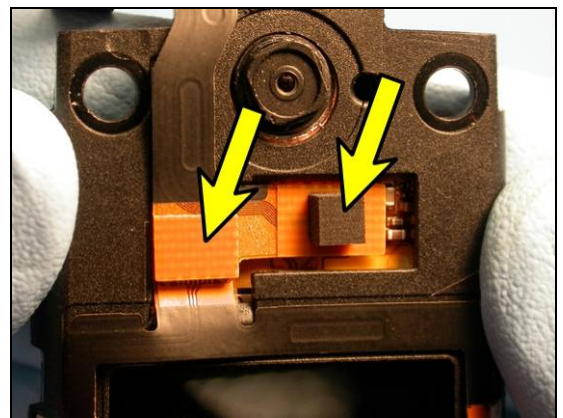




16. Remove any remaining protective film from adhesive areas and fold the flip flex assembly back onto the flip frame. Press the side key portions down over their alignment pegs. Repeat this for the other side of the flip flex assembly.

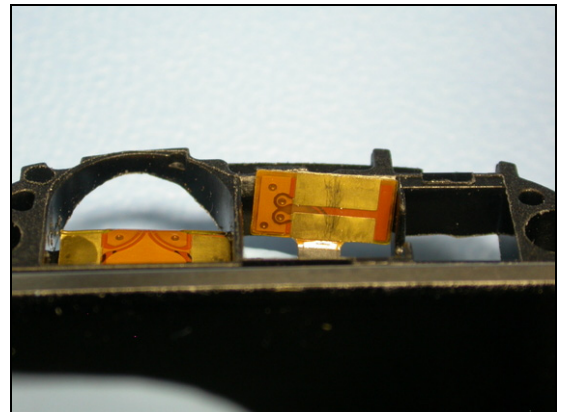


17. Hold the display into place in the flip frame. Connect the main flex assembly to the display and flip flex assembly as shown.

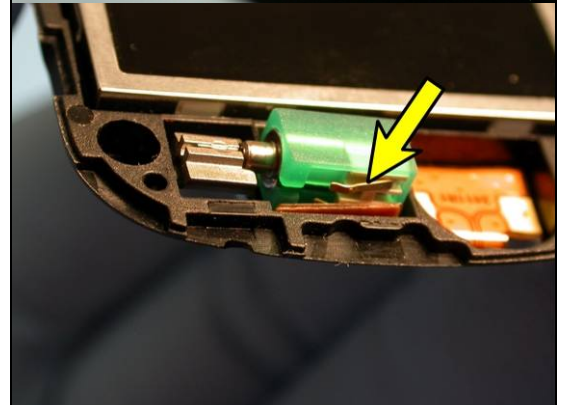




18. Make sure the vibrator contact portion of the flip flex assembly is positioned through the flip frame as shown.



19. Position the vibrator halfway into the vibrator cavity so that the lower contact finger is inside the cavity.



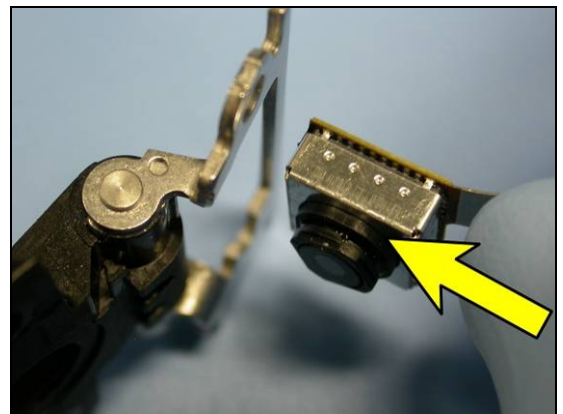
20. Using the flat end of a nylon pointer, compress the second contact finger slightly and slide the vibrator completely into the cavity. Be careful to not damage the contact fingers.



NOTE! BE CAREFUL TO NOT DAMAGE THE VIBRATOR CONTACTS.

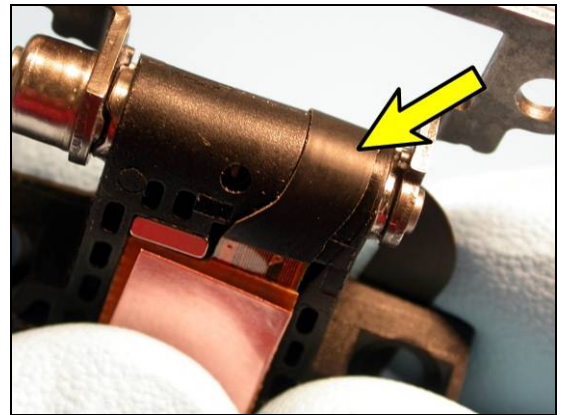
21. Pass the camera module through the opening in the metal hinge.

NOTE! BE CAREFUL TO NOT DAMAGE THE CAMERA.

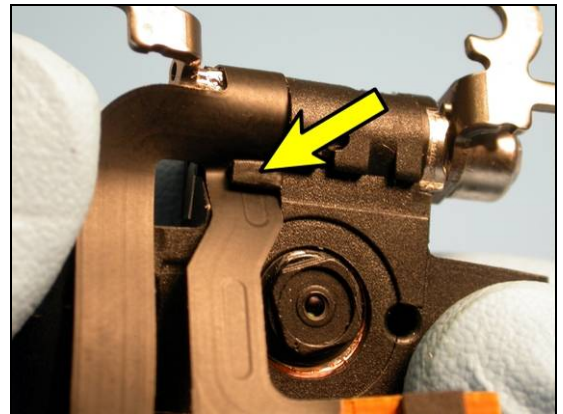




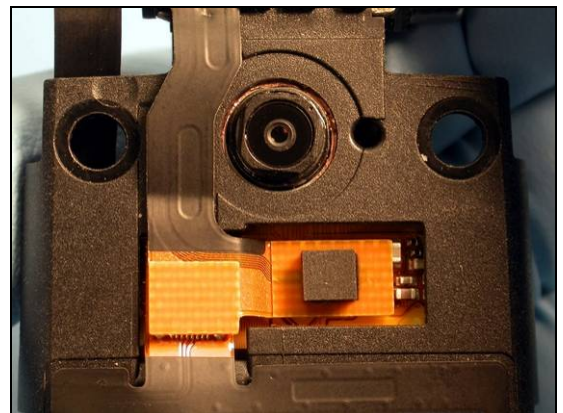
22. Press the adhesive portion of the main flex onto the hinge.



23. Position the main flex behind the retainer tab as shown.



24. Hold the display into place in the flip frame. Connect the main flex assembly to the display and flip flex assembly as shown.



Starting at section 3.1.1, perform the remainder of the base portion reassembly procedure.

5 Revision History

Rev.	Date	Changes / Comments
A	2006-Sept. 1	Initial Release
B	2006- Nov. 3	Due to system problem. No changes made on content