



Working Instruction, Mechanical

Applicable for Z310

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1 Introduction



1.1 Equipment

SPECIAL TOOLS

- NTZ 122 459 Torque screwdriver (or equivalent)
- NTZ 122 288 Torx bit no. 5
- NTZ 122 521 Flex film assembly tool
- NTZ 112 302/2 Front opening tool



STANDARD TOOLS

Standard tools have to be locally purchased

- Dentist hook
- Blunt pair of tweezers
- Guitar pick



LABEL EQUIPMENT

The following special equipment is required when replacing or installing a new label:

- Hot air flow solder station
- Zebra printer connected to computer



OTHER EQUIPMENT

- ESD-wristband
- ESD-gloves
- Isopropyl alcohol
- Air blower



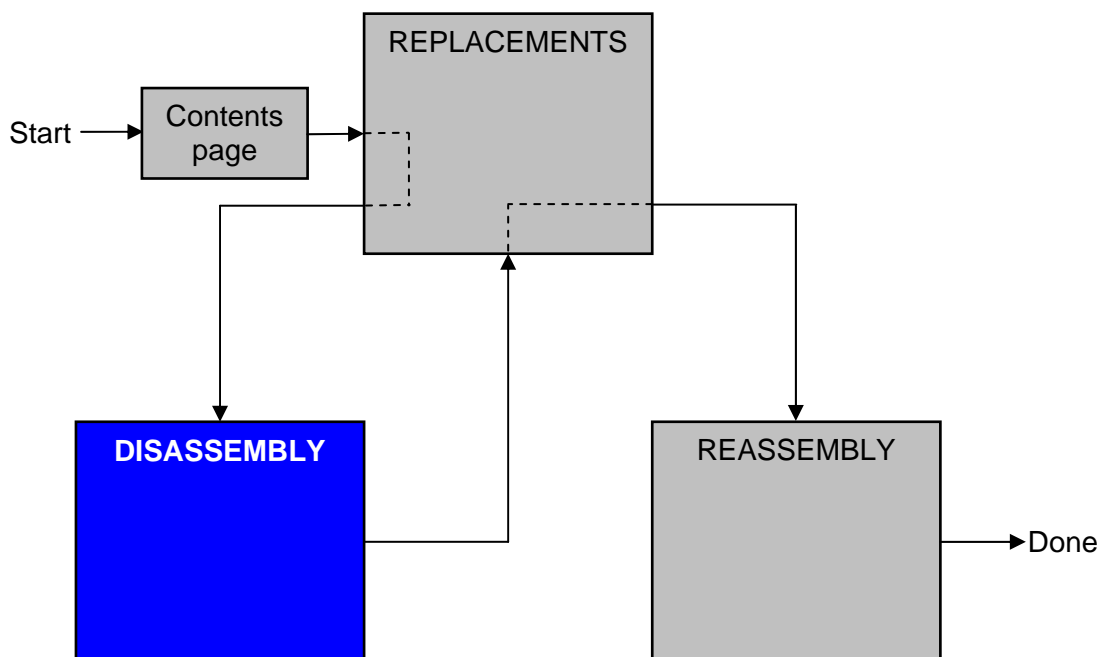
1.2 General cautions

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

- **TURN OFF THE PHONE AND REMOVE THE SIM CARD BEFORE STARTING THE DISASSEMBLY!**
- **KEEP ALL CONTACT SURFACES CLEAN!**
- **BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, OPENING TOOLS, GUITAR PICK 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 LCD!**
- **NEVER TOUCH THE DISPLAY GLASS!**
- **USE AIR BLOW EQUIPMENT TO KEEP THE FRONT WINDOW AND DISPLAY MODULE DUST FREE!**

2 Disassembly

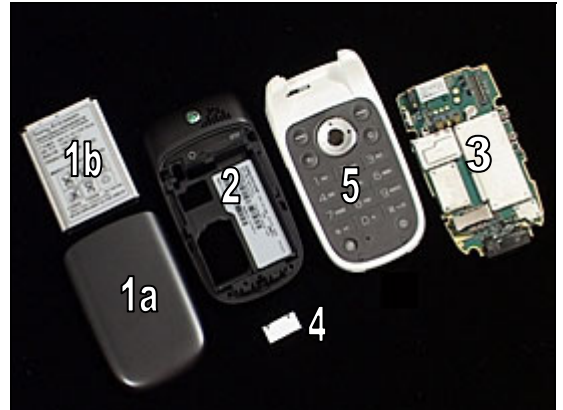
When you are going to replace a part being listed in *Replacements*, the instruction of that section usually begins by directing you to this *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before returning to *Replacements* for the actual replacement.



2.1 Lower unit

The disassembly is done in the following order:

1. Battery Cover (a) & Battery (b)
2. Lower Frame
3. PBA
4. Water Protection Tape
5. Lower Front



2.1.1 Battery Cover & Battery

Release the Battery Cover.



Remove the Battery Cover.



Grab the Battery and pull it up.



Remove the Battery.



2.1.2 Lower Frame

Use Torx bit no 5 to remove the four screws.



Use tweezers and pull the snap hook outwards to release the Lower Frame.



Use tweezers and pull the snap hook outwards to release the Lower Frame.



Use a guitar pick and slide upwards and downwards to release the Lower Frame from the Lower Front.

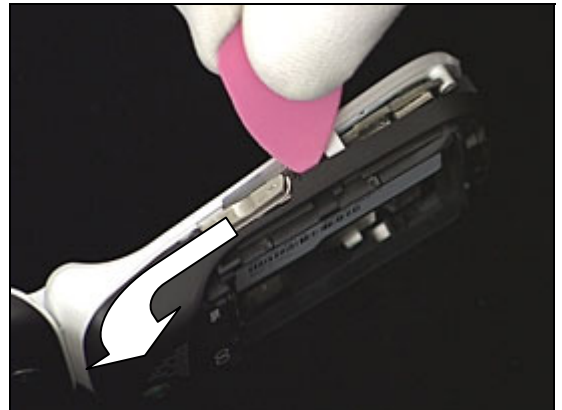
THIS NEEDS TO BE DONE ON THE OPPOSITE SIDE ALSO!



Lower Frame *continued*

BE VERY CAREFUL NOT TO DAMAGE THE COMPONENTS ON THE PCB DURING THIS PROCEDURE!

Use a guitar pick and slide upwards and downwards to release the Lower Frame from the Lower Front.



Use your fingers and wiggle the Lower Frame upwards to release it from the Lower Front.

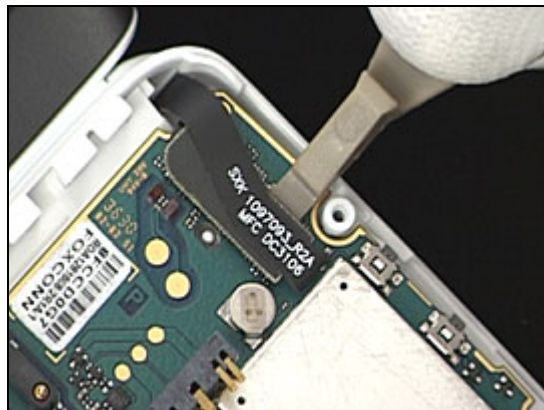


Remove the Lower Frame.

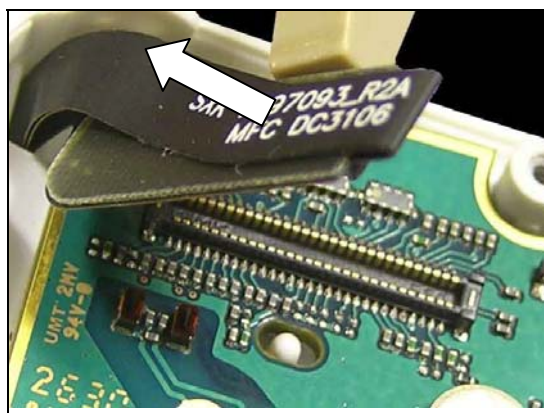


2.1.3 PBA

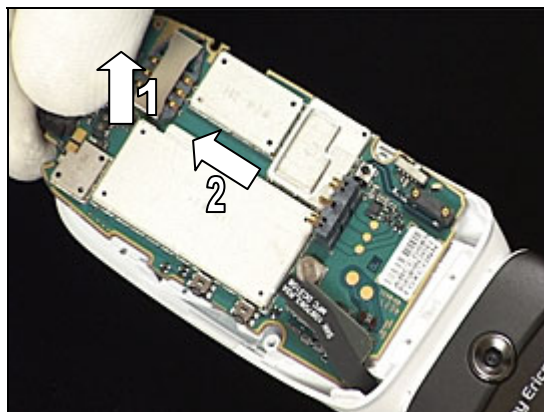
Position a front opening underneath the 60 pin BtB Connector.



Use a front opening tool and pull it upwards to disconnect the 60 pin BtB Connector.



Use your fingers to remove the PBA, according to the arrows in the picture.



2.1.4 Water Protective Tape

Use tweezers to remove the Water Protective Tape.



2.1.5 Lower Front

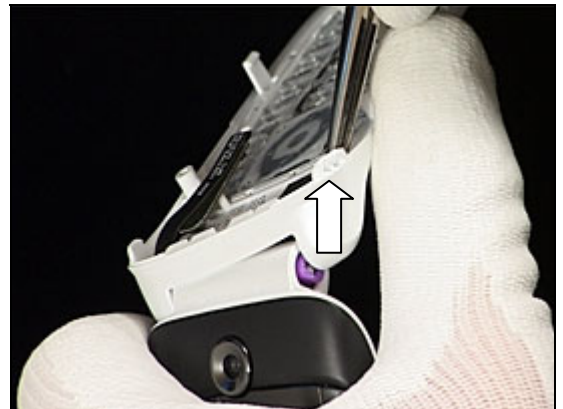
The Hinge mechanism is positioned according to the picture.



Use tweezers to push the Hinge mechanism into the hinge hole.



While pressing the Hinge mechanism into the hinge hole, use your thumb to push the Lower Front downwards to release it.



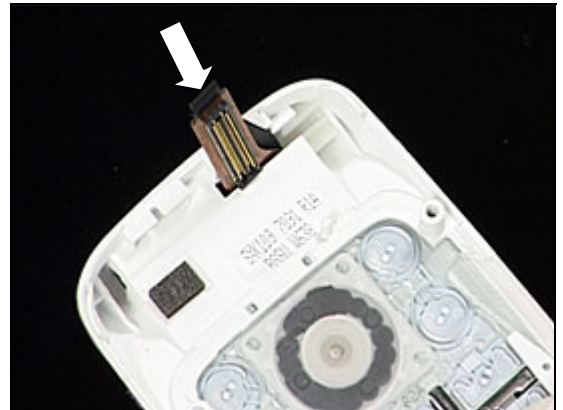
The Lower Front is now released from the Hinge mechanism.

THE LOWER FRONT IS STILL ATTACHED TO THE FPC ASSY!



Lower Front *continued*

Use your fingers to push the FPC Assy through the hole.



Remove the Lower Front.



2.2 Upper unit

The disassembly is done in the following order:

1. U-Cover
2. Screw Covers
3. Upper Frame
4. LCM, Main + Sub-LCD
5. Hinge Plug
6. FPC



2.2.1 U-Cover

Use a guitar pick and slide upwards and downwards to release the U-Cover.



Use a guitar pick and slide upwards and downwards to release the U-Cover.



Remove the U-Cover.



2.2.2 Screw Covers

Use a dentist hook to remove the Screw Cover.

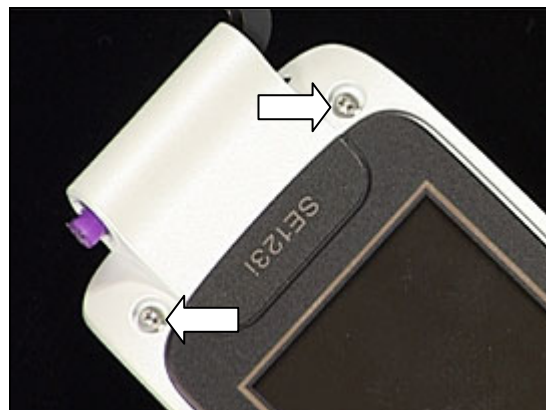


Use a dentist hook to remove the Screw Cover.



2.2.3 Upper Frame

Use Torx bit no 5 to remove the two screws.



Use Torx bit no 5 to remove the two screws.



Use a guitar pick and slide upwards and downwards to release the Upper Frame.



Use a guitar pick and slide upwards and downwards to release the Upper Frame.



Upper Frame *continued*

Remove the Upper Frame.



2.2.4 LCM, Main/Sub LCD

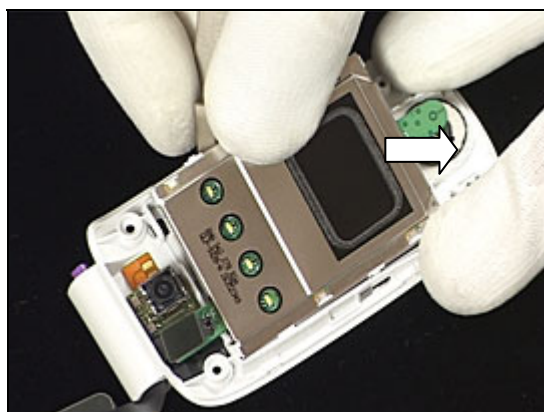
Use a front opening and pull the BtB Connector upwards to disconnect it.



Use a front opening tool to release the LCM, Main and Sub LCD from its cavity.



Remove the LCM, Main and Sub LCD.

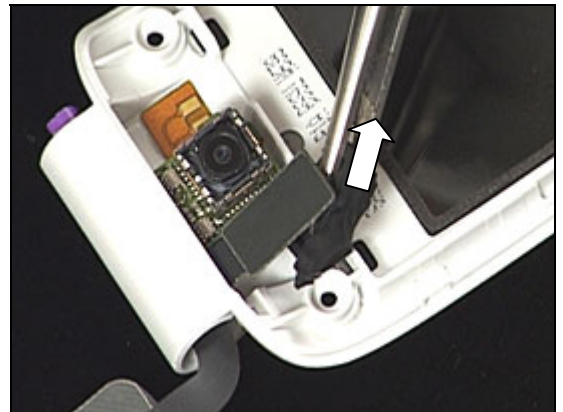


2.2.5 Hinge Plug

The Hinge Plug is positioned according to the picture.



Use tweezers to remove the Hinge Plug.

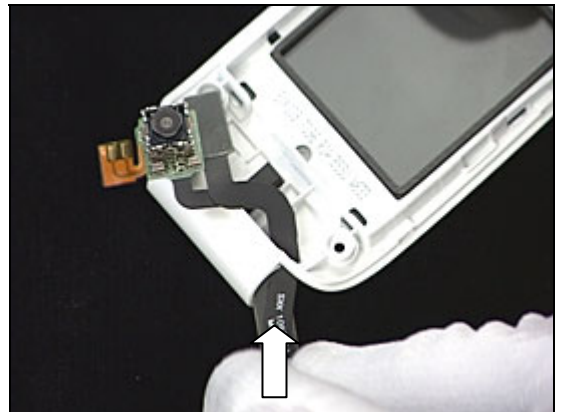


2.2.6 FPC

Use a flex film assembly tool to release the FPC Assy.



Use your fingers to push the FPC Assy through the hole.



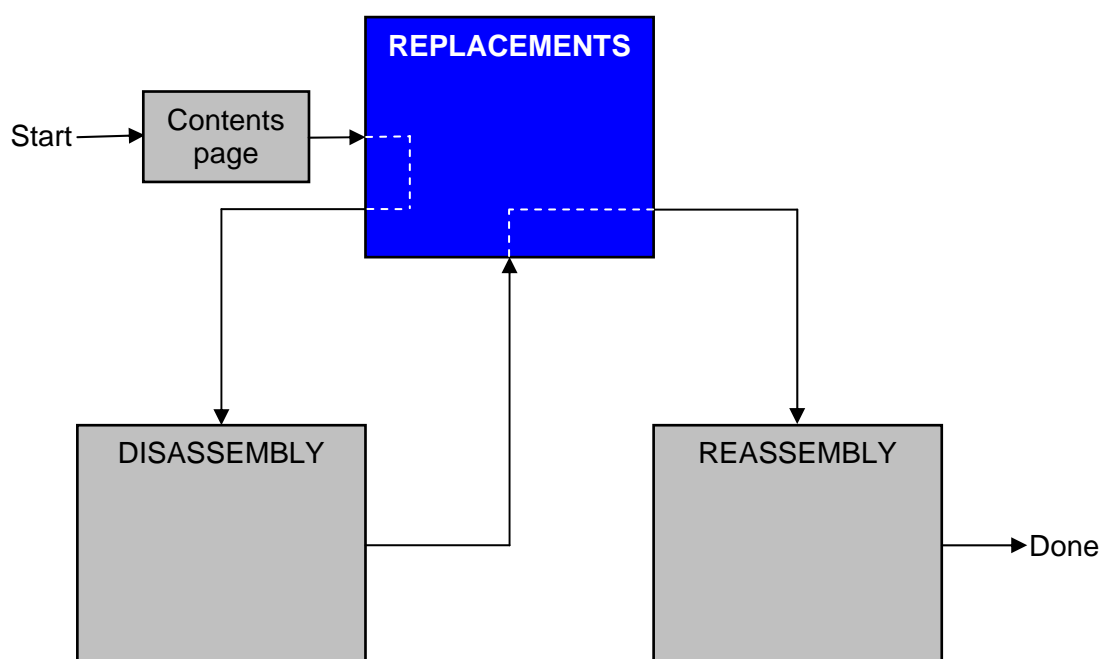
3 Replacements

Search for the part to be replaced on the Contents page and go to that instruction to be found in this *Replacements* section.

The instruction usually begins by directing you to the *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before the actual replacement.

Go back to this *Replacements* section and carry out the instruction.

The instruction usually ends by directing you to the *Reassembly* section with a specification of the instructions you have to carry out in order to reassemble the phone.



3.1 Battery Cover

Follow the 2.1.1 Disassembly instructions!

Prepare the new *battery cover*.

Follow the 4.2.5 Reassembly instructions!

3.2 Lower Frame

Follow the 2.1.1 – 2.1.2 Disassembly instructions!

Prepare the new *lower frame*.

Follow the 4.2.4 – 4.2.5 Reassembly instructions!

3.3 Water Protective Tape

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

Prepare the new *water protective tape*.

Follow the 4.2.2 – 4.2.5 Reassembly instructions!

3.4 Lower Front

Follow the 2.1.1 – 2.1.5 Disassembly instructions!

Prepare the new *lower front*.

Follow the 4.2.1 – 4.2.5 Reassembly instructions!

3.5 U-Cover

Follow the 2.2.1 Disassembly instructions!

Prepare the new *u-cover*.

Follow the 4.1.6 Reassembly instructions!

3.6 Screw Covers

Follow the 2.2.2 Disassembly instructions!

Prepare the new *screw covers*.

Follow the 4.1.5 Reassembly instructions!

3.7 Upper Frame

Follow the 2.2.1 – 2.2.3 Disassembly instructions!

Prepare the new *upper frame*.

Follow the 4.1.4 – 4.1.6 Reassembly instructions!

3.8 LCM, Main + Sub-LCD

Follow the 2.2.1 – 2.2.4 Disassembly instructions!

Prepare the new LCM.

Follow the 4.1.3 – 4.1.6 Reassembly instructions!

3.9 Hinge Plug

Follow the 2.2.1 – 2.2.5 Disassembly instructions!

Prepare the new hinge plug.

Follow the 4.1.2 – 4.1.6 Reassembly instructions!

3.10 FPC

Follow the 2.1.1 – 2.2.6 Disassembly instructions!

Prepare the new upper outer cover.

Follow the 4.1.1 – 4.2.5 Reassembly instructions!

3.11 Upper Front

Follow the 2.1.1 – 2.2.6 Disassembly instructions!

Prepare the new upper inner cover.

Follow the 4.1.1 – 4.2.5 Reassembly instructions!

3.12 Volume Key

REMOVAL

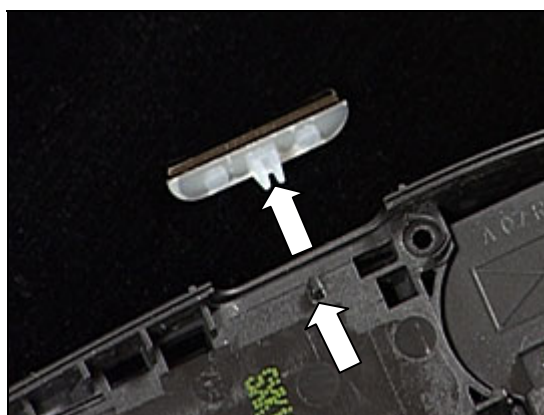
Follow the 2.1.1 – 2.1.2 Disassembly instructions!

Use tweezers to remove the Volume Key.

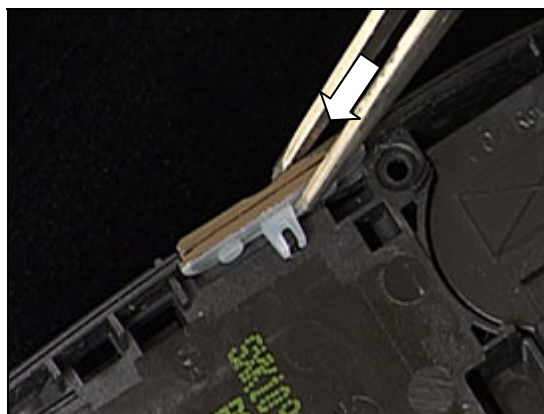


INSTALLATION

The Lower Frame has a gap which fits the gap of the Volume Key.



Use tweezers to position the Volume Key.



Visually inspect that the Volume is correctly positioned.

Follow the 4.2.4 – 4.2.5 Reassembly instructions!



3.13 IrDA Window

REMOVAL

Follow the 2.1.1 –2.1.2 Disassembly instructions!

Use tweezers to remove the IrDA Window.



INSTALLATION

Use tweezers to position the IrDA Window.



Visually inspect that the IrDA Window is correctly positioned.

Follow the 4.2.4 – 4.2.5 Reassembly instructions!

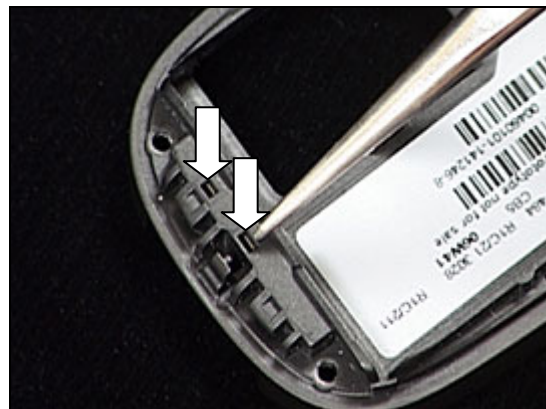


3.14 Bluetooth Antenna

REMOVAL

Follow the 2.1.1 –2.1.2 Disassembly instructions!

Use tweezers and release the Bluetooth Antenna by pushing it through the holes.



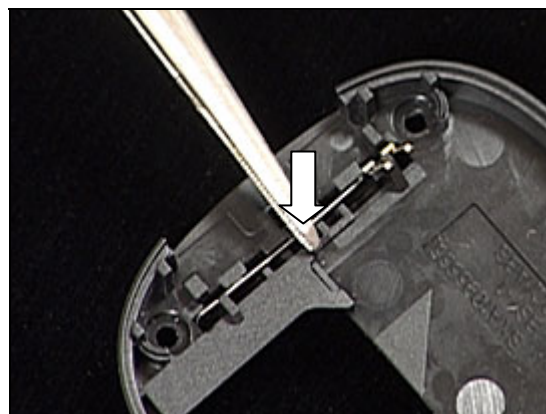
Use tweezers to remove the Bluetooth Antenna.



INSTALLATION

BE CAREFUL NOT TO DAMAGE THE BLUETOOTH ANTENNA SPRINGS!

Use tweezers to position the Bluetooth Antenna.



Visually inspect that the Bluetooth Antenna is correctly positioned.

Follow the 4.2.4 – 4.2.5 Reassembly instructions!

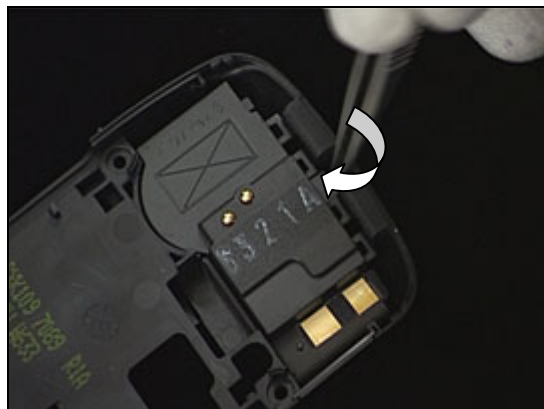


3.15 Loudspeaker Box

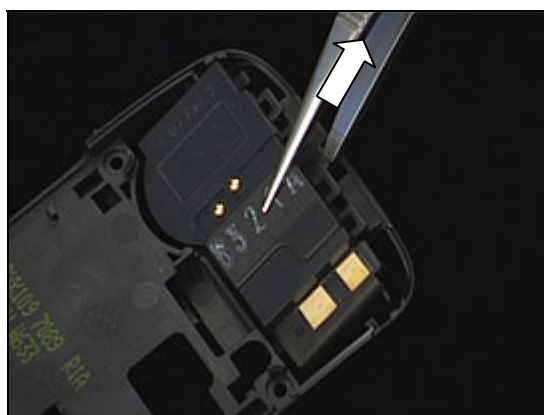
REMOVAL

Follow the 2.1.1 –2.1.2 Disassembly instructions!

Use tweezers and push them underneath the Loudspeaker Box.



Use tweezers to remove the Loudspeaker Box.



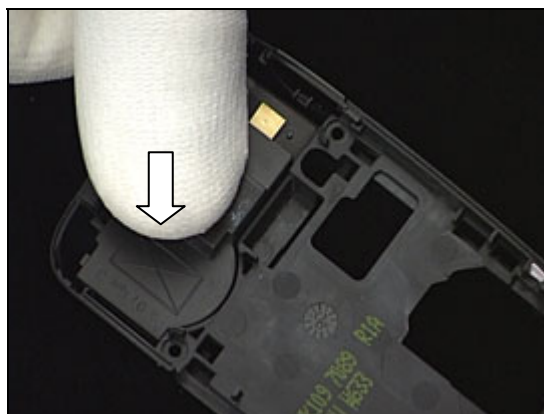
INSTALLATION

Position the Loudspeaker Box.



Use your thumb and press the Loudspeaker Box into the cavity.

Follow the 4.2.4 – 4.2.5 Reassembly instructions!

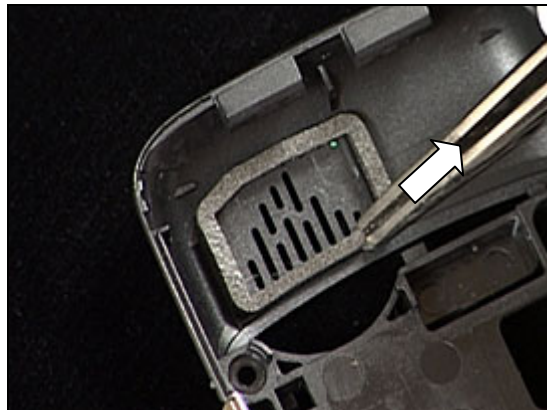


3.16 Speaker Gasket

REMOVAL

*Follow the 2.1.1 –2.1.2 Disassembly instructions!
Follow the 3.15 Removal instructions!*

Use tweezers to remove the Speaker Gasket.
Clean the Lower Front with Isopropyl alcohol.



INSTALLATION

USE A NEW SPEAKER GASKET!

Use tweezers to position the Speaker Gasket.



Visually inspect that the Speaker Gasket is correctly positioned.

*Follow the 3.15 Installation instructions!
Follow the 4.2.4 – 4.2.5 Reassembly instructions!*

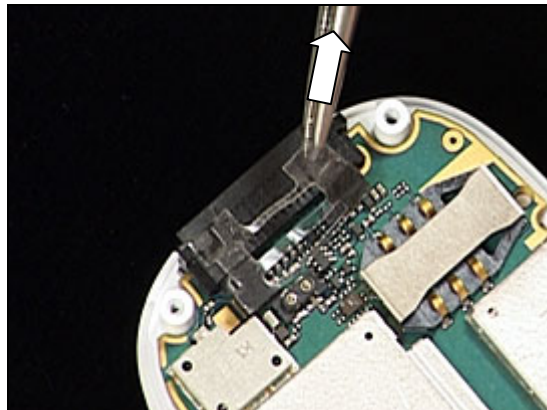


3.17 Dust Gasket, System Connector

REMOVAL

Follow the 2.1.1 –2.1.2 Disassembly instructions!

Use tweezers to position the Dust Gasket, System Connector.

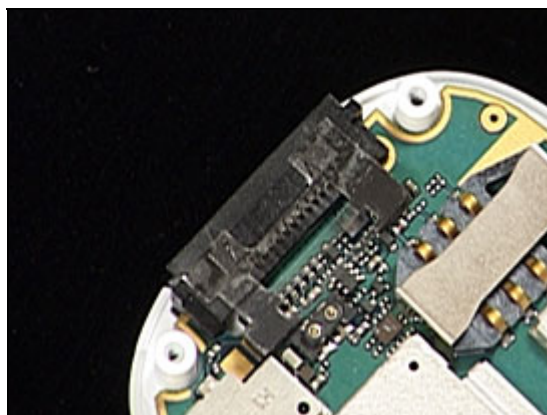


INSTALLATION

USE A NEW DUST GASKET, SYSTEM CONNECTOR!

Use tweezers to position the Dust Gasket, System Connector.

Follow the 4.2.4 – 4.2.5 Reassembly instructions!

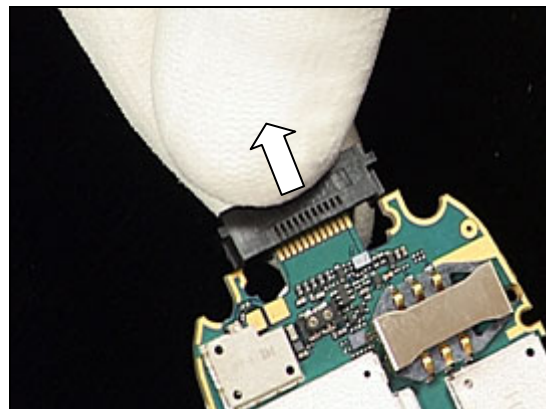


3.18 System Connector

REMOVAL

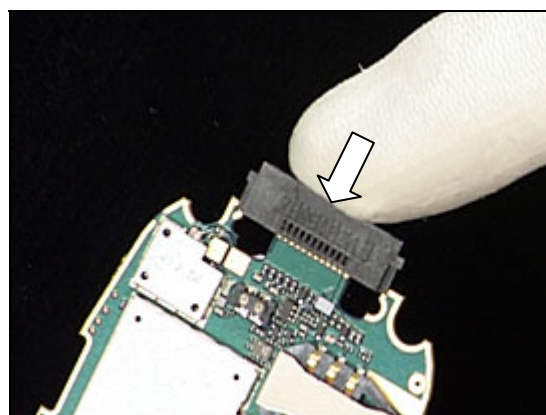
*Follow the 2.1.1 –2.1.3 Disassembly instructions!
Follow the 3.17 Removal instructions!*

Use your fingers to remove the System Connector.



INSTALLATION

Use your fingers to position the System Connector.



Visually inspect that the System Connector is correctly positioned.

*Follow the 3.17 Installation instructions!
Follow the 4.2.3 – 4.2.5 Reassembly instructions!*

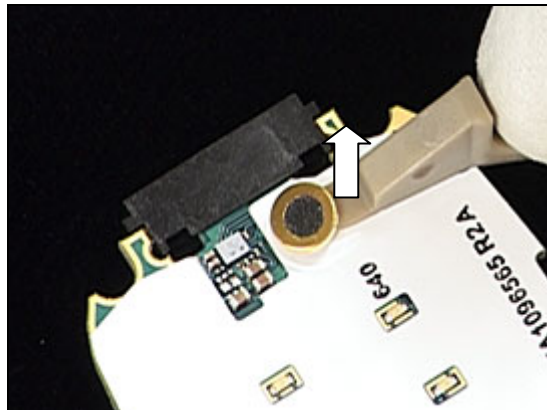


3.19 Microphone

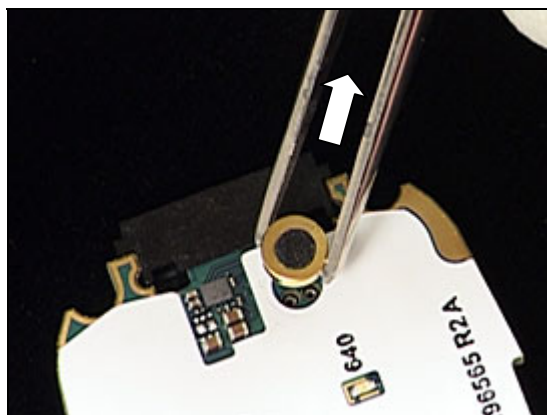
REMOVAL

Follow the 2.1.1 –2.1.3 Disassembly instructions!

Use a front opening tool and pull the Microphone upwards to release it.

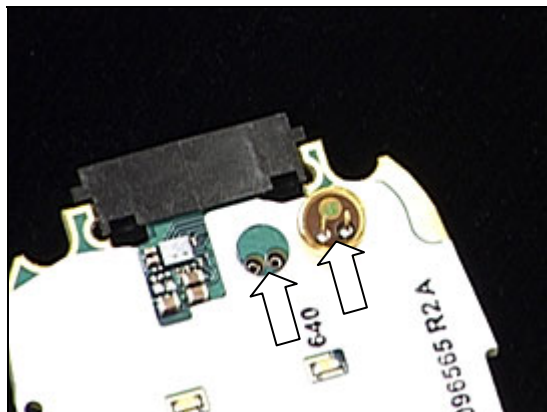


Use tweezers to remove the Microphone.



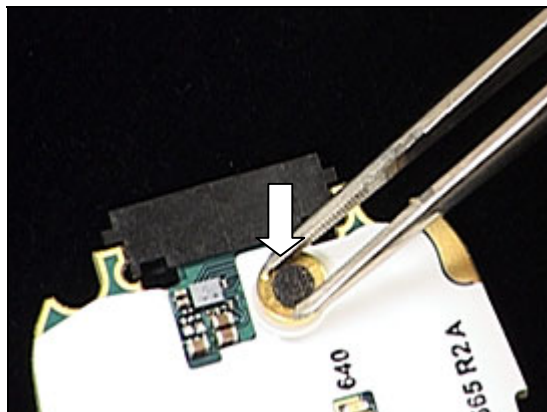
INSTALLATION

The Microphone connectors shall go through the via holes.



Use tweezers to position the Microphone.

Follow the 4.2.3 – 4.2.5 Reassembly instructions!

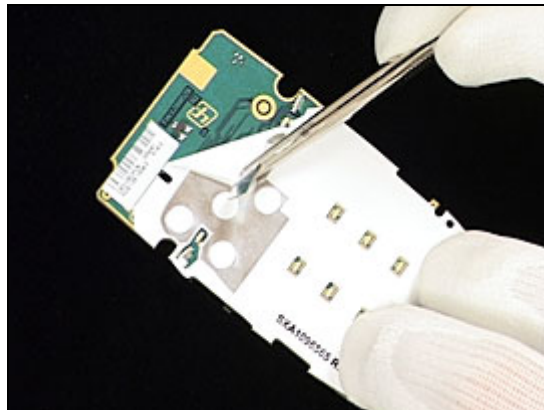


3.20 Dome Foil

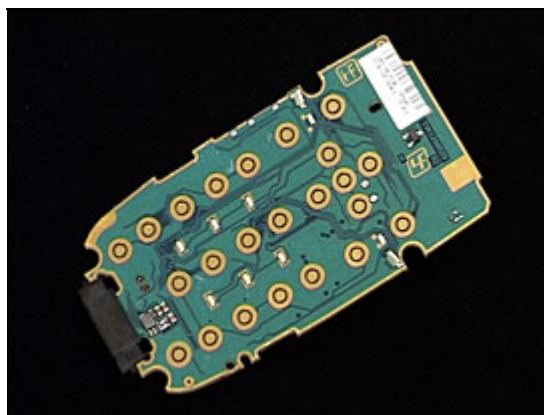
REMOVAL

*Follow the 2.1.1 –2.1.3 Disassembly instructions!
Follow the 3.19 Removal instructions!*

BE CAREFUL NOT TO DAMAGE THE PBA!
Use tweezers to remove the Dome Foil.



Clean all pads on the PBA with Isopropyl alcohol.

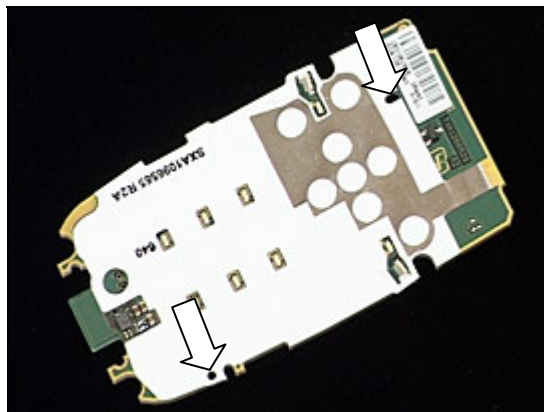


INSTALLATION

THE PBA HAS GUIDING HOLES WHICH SHALL FIT THE DOME FOIL!

Position the Dome Foil.

*Follow the 3.19 Installation instructions!
Follow the 4.2.3 – 4.2.5 Reassembly instructions!*



3.21 Poron Cushion, Lower Front

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

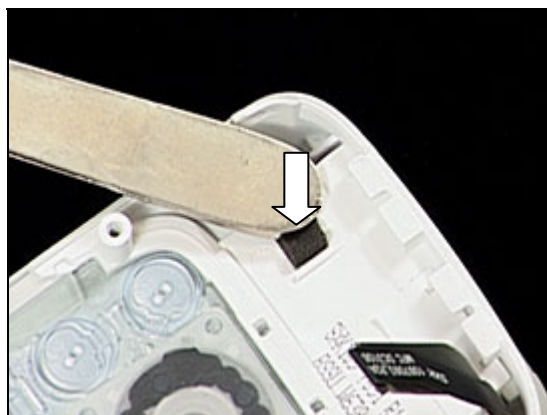
Use tweezers to remove the Poron Cushion.
Clean the Lower Front with Isopropyl alcohol.



INSTALLATION

USE A NEW PORON CUSHION!

Use tweezers to position the Poron Cushion.



Visually inspect that the Poron Cushion is correctly positioned.

Follow the 4.2.3 – 4.2.5 Reassembly instructions!



3.22 Navigation Key

REMOVAL

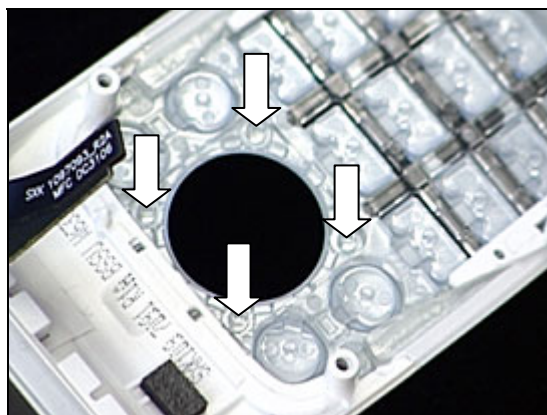
Follow the 2.1.1 –2.1.3 Disassembly instructions!

Use tweezers to remove the Navigation Key.



INSTALLATION

THE KEYPAD HAS FOUR GUIDING PINS!

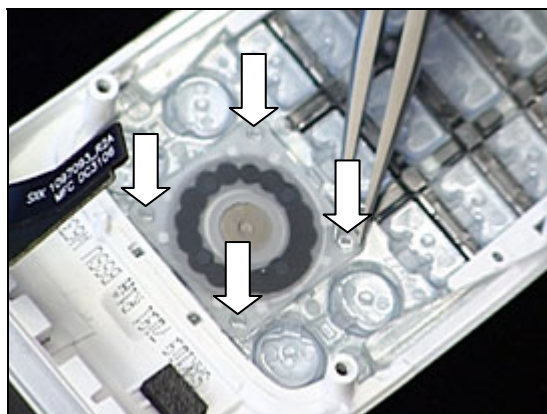


Use tweezers to position the Navigation Key.



Use tweezers to press the Navigation Key into the four guiding pins.

Follow the 4.2.3 – 4.2.5 Reassembly instructions!



3.23 Keyboard

REMOVAL

Follow the 2.1.1 –2.1.3 Disassembly instructions!

Follow the 3.22 Removal instructions!

Use your fingers and release the Keypad by pressing it out through the Lower Front.

Use you fingers and remove the Keypad.

INSTALLATION

Use your fingers and position the Keypad.

Use you fingers to press the Keypad into the Lower Front.



Keyboard *continued*

DO THE FOLLOWING INSTRUCTION 3 TIMES!

Press and slide your fingers around the Keyboard to attach it to the Lower Frame.

Follow the 3.22 Installation instructions!

Follow the 4.2.3 – 4.2.5 Reassembly instructions!

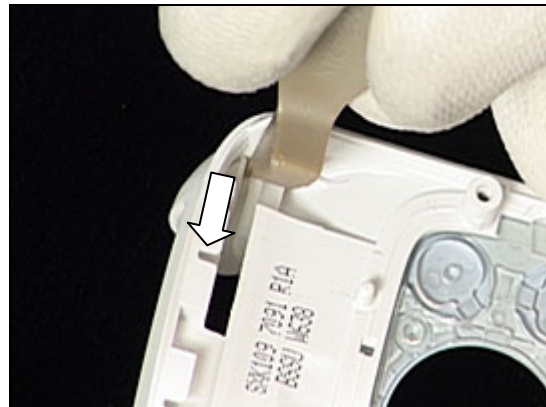


3.24 Dummy Hinge

REMOVAL

Follow the 2.1.1 –2.1.5 Disassembly instructions!

Use a front opening tool and push the Dummy Hinge outwards in order to release it.



Remove the Dummy Hinge.



INSTALLATION

Use your fingers and press the Dummy Hinge into its position.



Visually inspect that the Dummy Hinge is correctly positioned.

Follow the 4.2.1 – 4.2.5 Reassembly instructions!



3.25 Sub Window

REMOVAL

Follow the 2.2.1 –2.2.3 Disassembly instructions!

THE SUB WINDOW IS ATTACHED TO THE UPPER FRAME WITH SNAP HOOKS!

Use your fingers and press the Sub Window outwards, according to the arrows in the picture.



INSTALLATION

Position the Sub Window.



Use your fingers and press the Sub Window into its position.

Follow the 4.1.4 – 4.1.6 Reassembly instructions!



3.26 Magical Front Icons

REMOVAL

*Follow the 2.2.1 –2.2.3 Disassembly instructions!
Follow the 3.25 Removal instructions!*

Use tweezers to remove the Magical Front Icons.

Clean the Upper Frame with Isopropyl alcohol.

INSTALLATION

Use tweezers to position the Magical Front Icons.

Use your fingers and press the Magical Front Icons so it attaches to the Upper Frame.

*Follow the 3.25 Installation instructions!
Follow the 4.1.4 – 4.1.6 Reassembly instructions!*



3.27 Camera Ring

REMOVAL

Follow the 2.2.1 – 2.2.3 Disassembly instructions!
Follow the 3.25 – 3.26 Removal instructions!

Use tweezers to remove the Camera Ring.



INSTALLATION

Use tweezers to position the Camera Ring.



Visually inspect that the Camera Ring is correctly positioned.

Follow the 3.26 – 3.25 Installation instructions!
Follow the 4.1.4 – 4.1.6 Reassembly instructions!



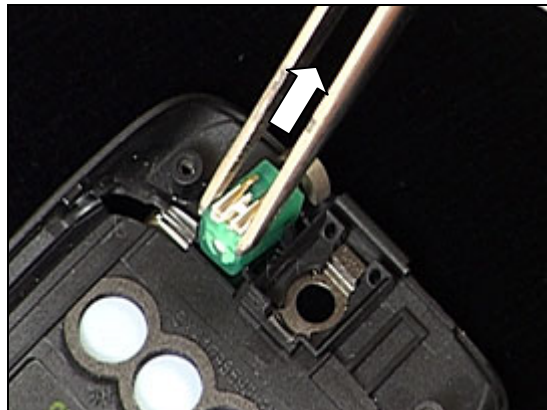
3.28 Vibrator

REMOVAL

Follow the 2.2.1 – 2.2.3 Disassembly instructions!

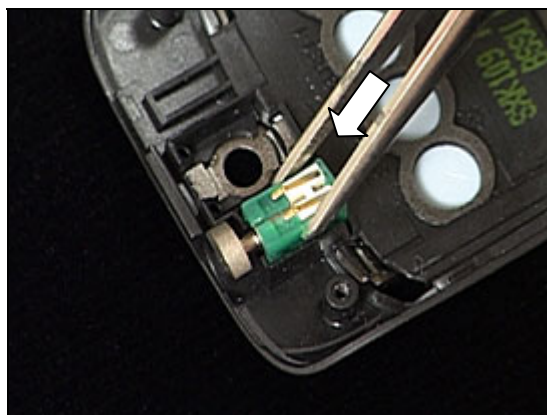
DO NOT LIFT THE VIBRATOR IN THE FLYING WHEEL!

Use tweezers to remove the Vibrator.



INSTALLATION

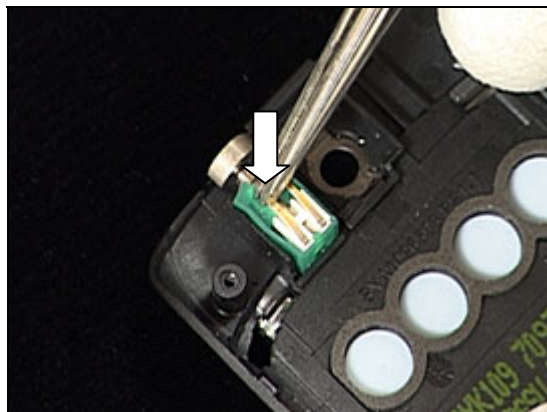
Use tweezers to position the Vibrator.



DO NOT TOUCH THE VIBRATOR SPRINGS!

Use tweezers and press the Vibrator into its cavity.

Follow the 4.1.4 – 4.1.6 Reassembly instructions!



3.29 Dust Gasket, Sub LCD

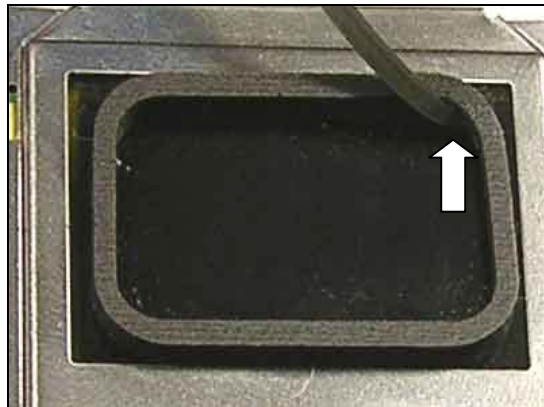
REMOVAL

Follow the 2.2.1 – 2.2.3 Disassembly instructions!

BE CAREFUL NOT TO DAMAGE THE SUB LCD!

Use a dentist hook to remove the Dust Gasket.

Clean the Sub LCD with Isopropyl alcohol.

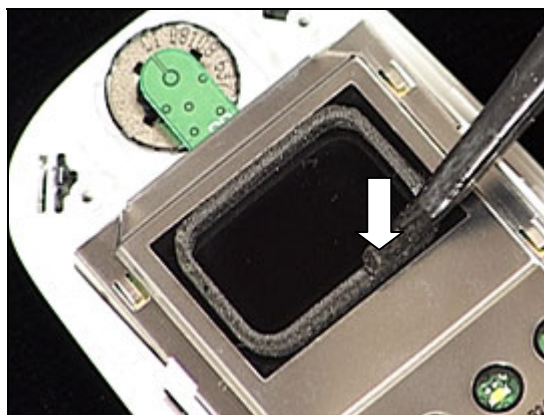


INSTALLATION

BE CAREFUL NOT TO DAMAGE THE SUB LCD!

Use tweezers to position the Dust Gasket.

Follow the 4.1.4 – 4.1.6 Reassembly instructions!



3.30 Dust Gasket, Main LCD

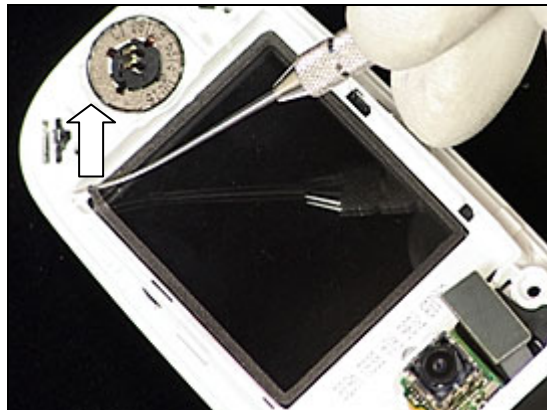
REMOVAL

Follow the 2.2.1 – 2.2.4 Disassembly instructions!

BE CAREFUL NOT TO DAMAGE THE MAIN LCD WINDOW!

Use a dentist hook to remove the Dust Gasket.

Clean the Main LCD Window with Isopropyl alcohol.

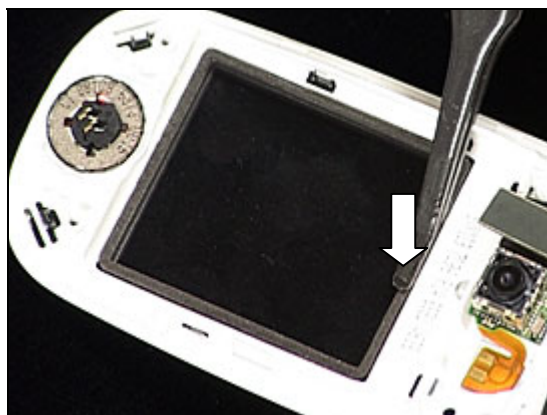


INSTALLATION

BE CAREFUL NOT TO DAMAGE THE MAIN LCD WINDOW!

Use tweezers to position the Dust Gasket.

Follow the 4.1.3 – 4.1.6 Reassembly instructions!



3.31 Ear Speaker

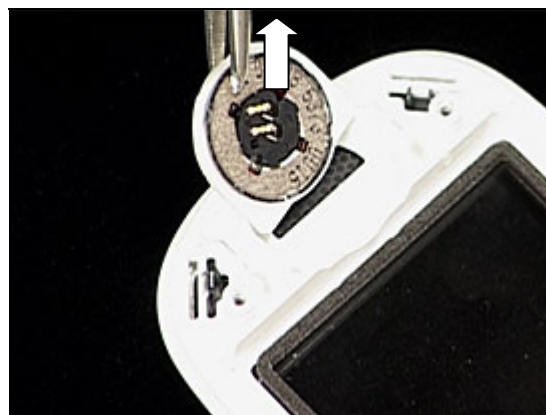
REMOVAL

Follow the 2.2.1 –2.2.4 Disassembly instructions!

Use a dentist hook to release the Ear Speaker.



Use tweezers to remove the Ear Speaker.



INSTALLATION

BE CAREFUL NOT TO DAMAGE THE EAR SPEAKER SPRINGS!

Use tweezers to position the Ear Speaker.



Visually inspect that the Ear Speaker is correctly positioned.

Follow the 4.1.3 – 4.1.6 Reassembly instructions!



3.32 Hinge Mechanism

REMOVAL

Follow the 2.1.1 – 2.2.6 Disassembly instructions!

Use tweezers and press the Hinge Mechanism out from the hinge hole.



Remove the Hinge Mechanism.



INSTALLATION

Use your fingers to position the Hinge Mechanism.



Use tweezers to press the Hinge Mechanism into the hinge hole.

Follow the 4.1.1 – 4.2.5 Reassembly instructions!



3.33 Operator Key

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

Follow the 3.22 – 3.23 Removal instructions!

Use tweezers to remove the Operator Key.

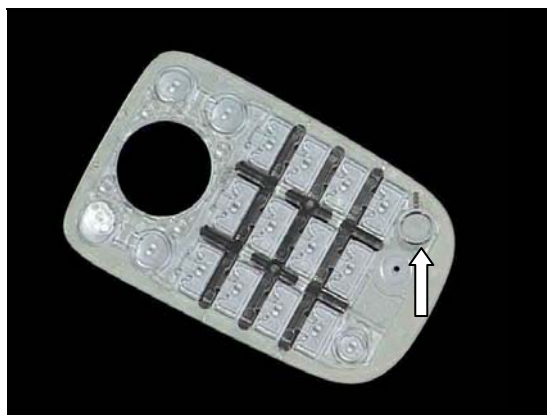
INSTALLATION

USE A NEW OPERATOR KEY!

Use tweezers to position the Operator Key.

Follow the 3.22 – 3.23 Installation instructions!

Follow the 4.2.3 – 4.2.5 Reassembly instructions!



3.34 Support Pad for Camera

REMOVAL

Follow the 2.1.1 – 2.2.6 Disassembly instructions!

Use tweezers to remove the Support Pad.



INSTALLATION

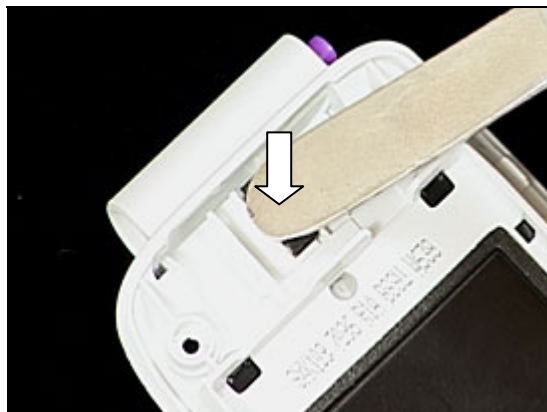
USE A NEW SUPPORT PAD!

Position the Support Pad.



Use tweezers to press the Support Pad into place.

Follow the 4.1.1 – 4.2.5 Reassembly instructions!



3.35 Co-Brand Label

REMOVAL

Use a dentist hook to remove the Co-Brand Label.



Clean the Upper Frame with Isopropyl alcohol.



INSTALLATION

USE A NEW CO-BRAND LABEL!

Use your fingers to attach the Co-Brand Label into its cavity.



Visually inspect that the Co-Brand Label is correctly positioned.



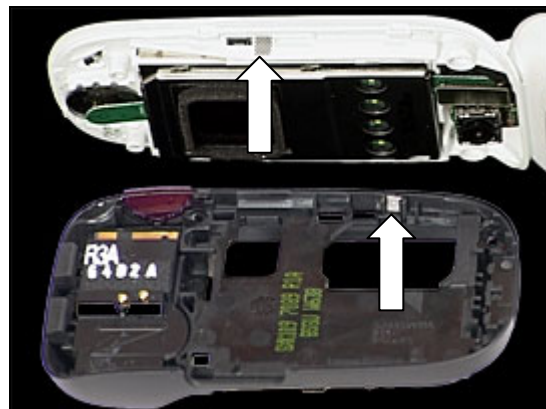
3.36 Liquid Intrusion Indicator

INSPECTION

There are two Liquid Intrusion Indicators located on the Upper Front and the Lower Frame.

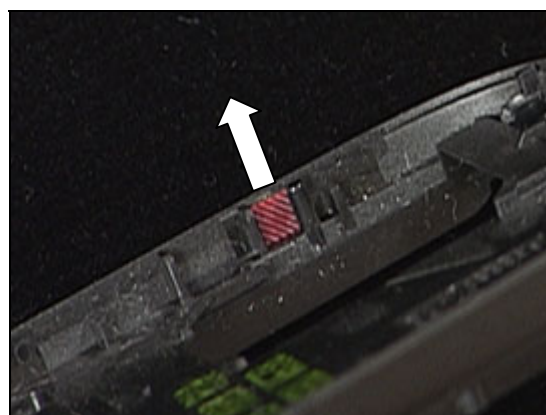
To get access to and to inspect the indicators:

Follow the 2.1.1 – 2.1.2 and 2.2.1 – 2.2.3 Disassembly instructions!



REMOVAL

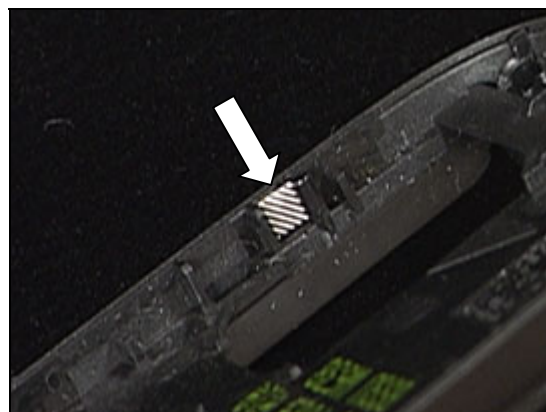
Remove the activated *liquid intrusion indicator* with the dentist hook and the tweezers.



INSTALLATION

Attach the new *liquid intrusion indicator* with the tweezers and the dentist hook.

Follow the 4.1.4 – 4.1.6 & 4.2.4 – 4.2.5 Reassembly instructions!



3.37 Label

Follow the 2.1.1 Disassembly instructions!

- Read the old label and/or write the information into the "Label make" program before removal
- Note the position of the label before removal
- Heat up the label by using hot air, if needed
- Carefully remove the label without causing scratches
- If there still are residues, clean the surface with isopropyl alcohol

- Check that the proper label format is loaded in the Zebra printer
- Write a new label by using the program "Label make" and check that the printing is OK
- Take the new label and place it onto the frame as in the adjacent picture

ONE LABEL ONLY IS ALLOWED!

Follow the 4.2.5 Reassembly instructions!



3.38 Shield Can Insulation Label

Follow the 2.1.1 Disassembly instructions!

- Use a pair of tweezers to lift the label

- Place the label according to picture

Follow the 4.2.5 Reassembly instructions!

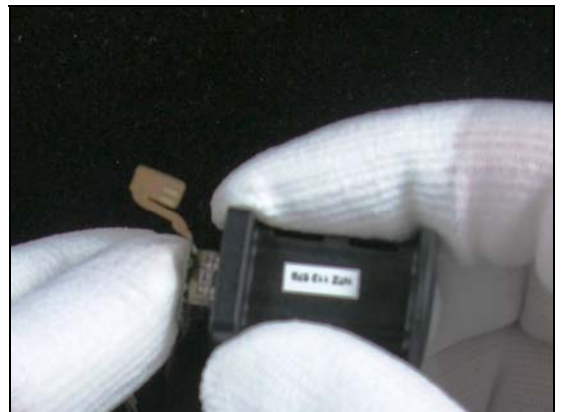
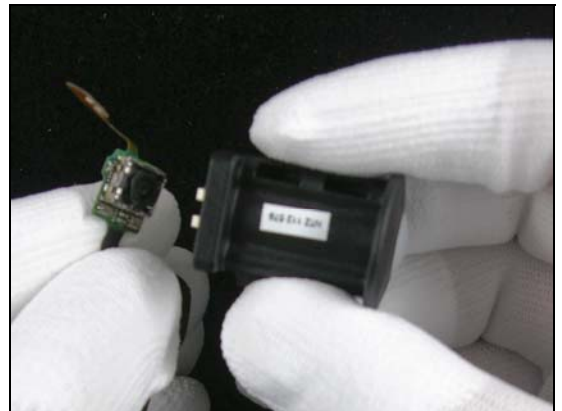


3.39 Camera

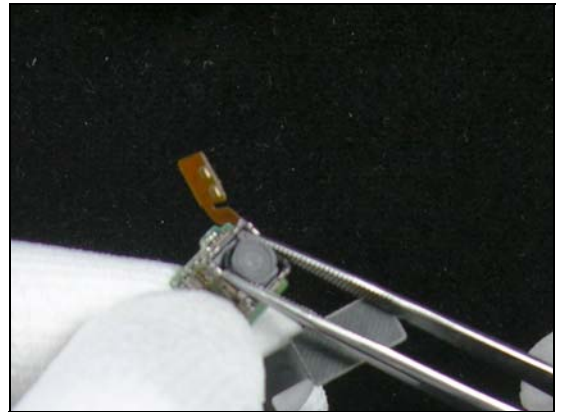
REMOVAL

Use the camera removing tool NTZ 112 579.

Push the tool in to the bottom of the camera socket and wiggle it a little.

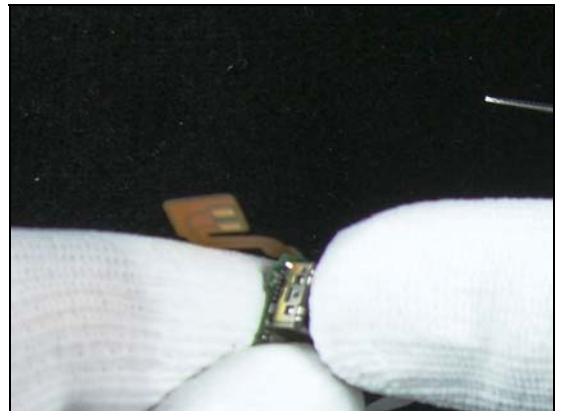


Make sure all the hooks has snapped of and lift up the camera whit a pair of tweezers.



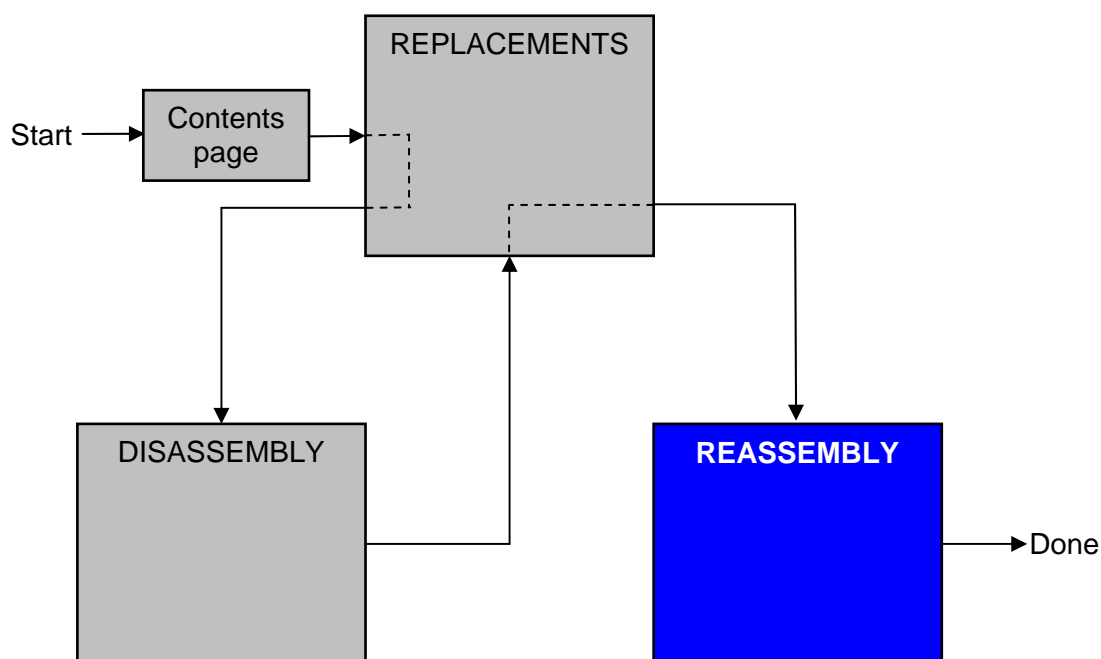
INSTALLATION:

Push the new camera in to place and make sure that the hooks snaps in.



4 Reassembly

After replacing a part being listed in Replacements, the instruction of that section usually ends by directing you to this Reassembly section with a specification of the instructions you have to carry out in order to reassemble the phone.



4.1 Upper unit

The reassembly is done in the following order:

1. FPC
2. Hinge Plug
3. LCM, Main + Sub-LCD
4. Upper Frame
5. Screw Covers
6. U-Cover



4.1.1 FPC

Use a flex film assembly tool to slide the FPC Assy through hole.



Position the FPC Assy according to the picture.

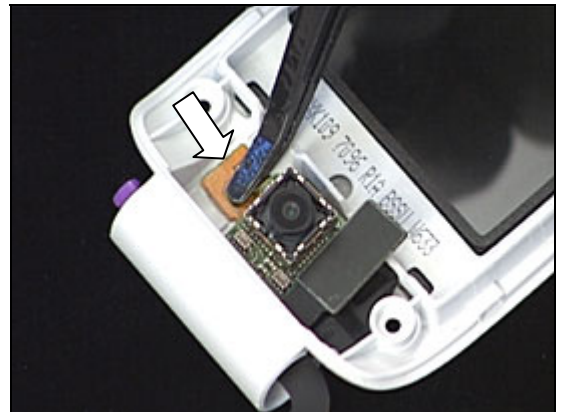


4.1.2 Hinge Plug

Use tweezers to position the Hinge Plug.



Use a flex film assembly tool to press the FPC Assy flex film into its place.

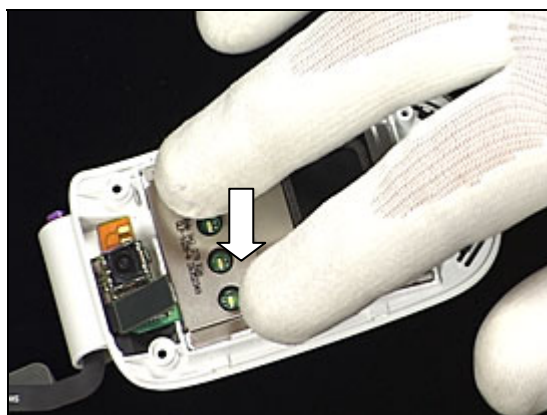


4.1.3 LCM, Main/Sub LCD

Position the LCM, Main and Sub LCD into its cavity.



Use your fingers to press the LCM, Main and Sub LCD into its place.



Use your fingers and press on the BtB Connector to connect it to the LCM, Main and Sub LCD.



4.1.4 Upper Frame

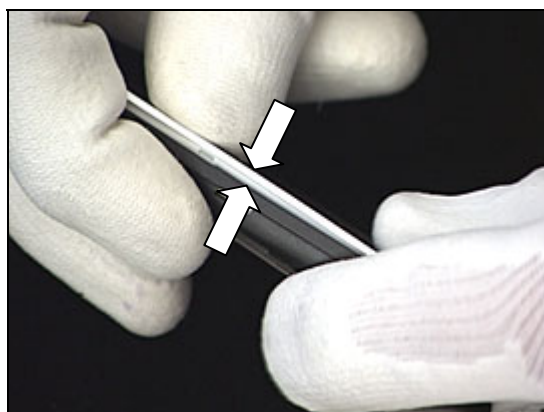
Position the Upper Frame.



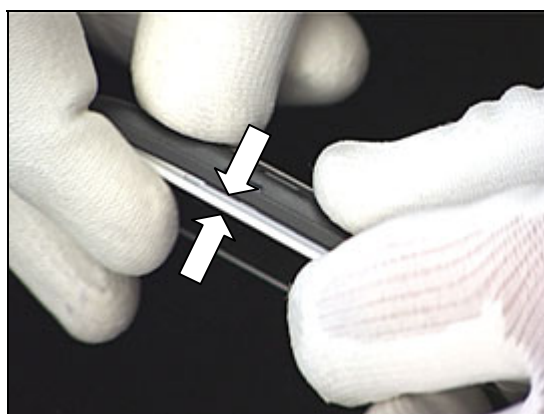
Press with your fingers on the Upper Front to snap it to the Upper Frame.



Use your fingers to press the Upper Frame into the Upper Front.



Use your fingers to press the Upper Frame into the Upper Front.



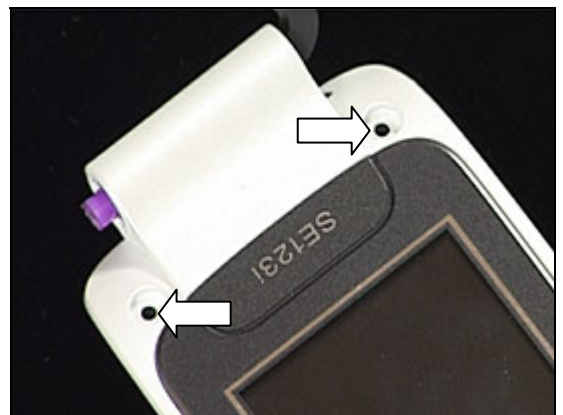
Upper Frame *continued*

USE NEW SCREWS!

Use Torx bits no 5 to tighten the two screws using the torque 17 ± 2 Ncm.

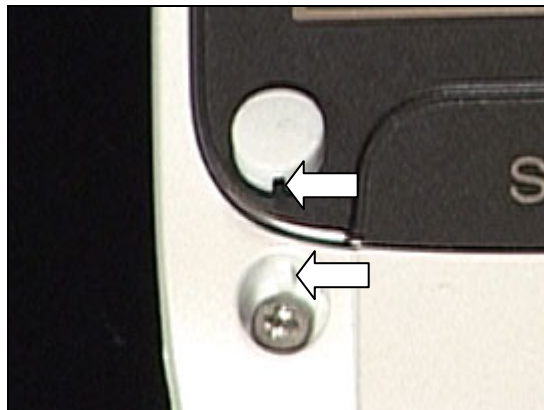
**USE NEW SCREWS!**

Use Torx bits no 5 to tighten the two screws using the torque 17 ± 2 Ncm.



4.1.5 Screw Covers

THE SCREW HOLE HAS A GUIDING PIN WHICH SHALL FIT THE SCREW COVER GAP!



Use tweezers to position the Screw Covers into the screw holes.



Use tweezers and press the Screw Cover into the screw hole.



Use tweezers and press the Screw Cover into the screw hole.



4.1.6 U-Cover

Position the U-Cover on the Upper Front.



Use your fingers and press on the U-Cover so it snap fits onto the Upper Front.



Visually inspect that the U-Cover is correctly positioned.



4.2 Lower unit

The reassembly is done in the following order:

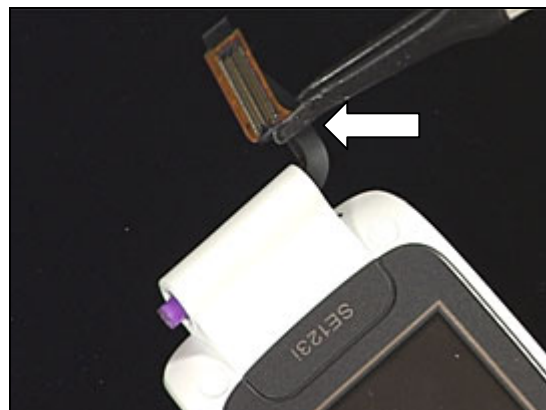
1. Lower Front
2. Water Protection Tape
3. PBA
4. Lower Frame
5. Battery (a) & Battery Cover (b)



4.2.1 Lower Front

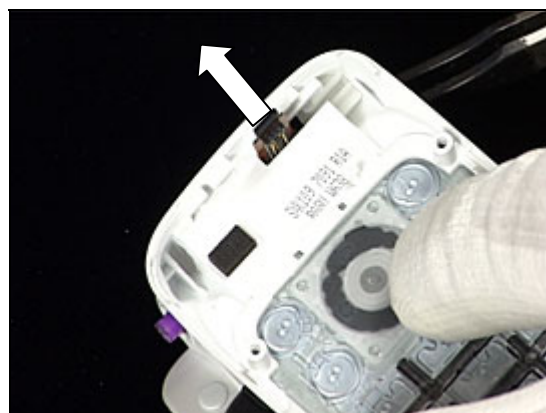
BE CAREFUL NOT TO DAMAGE THE 60 BTB CONNECTOR!

Use a flex film assembly tool and grab the FPC Assy in the flex film.



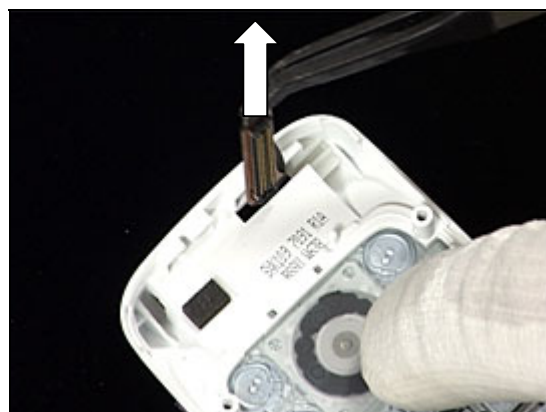
BE CAREFUL NOT TO DAMAGE THE 60 BTB CONNECTOR!

Use a flex film assembly tool and slide the FPC Assy through the hole.



BE CAREFUL NOT TO DAMAGE THE 60 BTB CONNECTOR!

Use a flex film assembly tool and slide the FPC Assy through the hole.



Slide the FPC Assy into the Dummy Hinge.

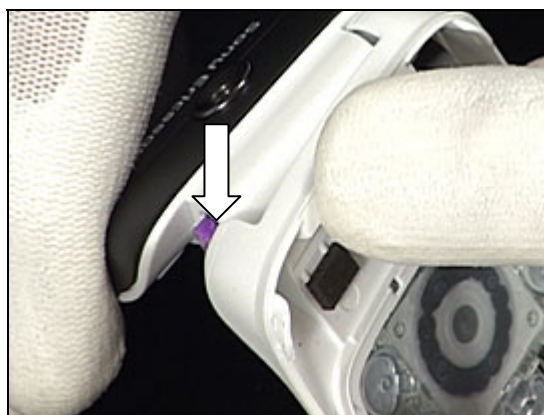


Lower Front *continued*

Use your fingers and press on the Lower Front to slightly bend it onto the hinge.



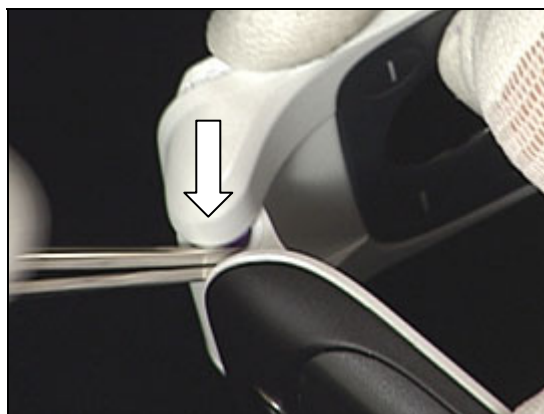
Position the Lower Front onto the hinge.



Use tweezers to press the Hinge Mechanism into the hinge hole.



While pressing the Hinge Mechanism into the hinge hole, press the Lower Front onto the Hinge.

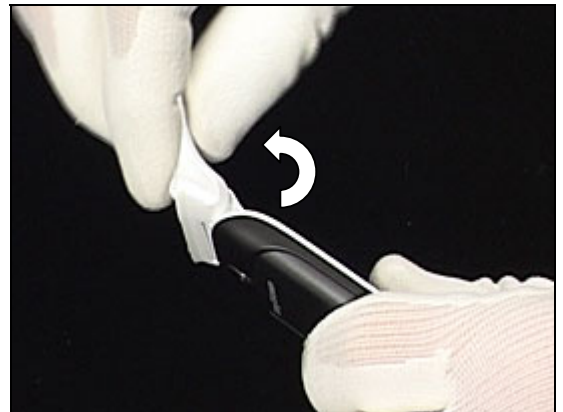


Lower Front *continued*

Visually inspect that the Lower Front is correctly positioned.



Open the phone so that the Hinge Mechanism snap fits the Lower Front onto the Upper Half.

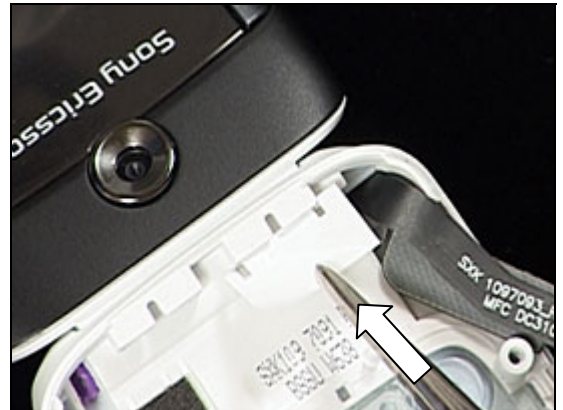


4.2.2 Water Protective Tape

USE A NEW WATER PROTECTIVE TAPE!

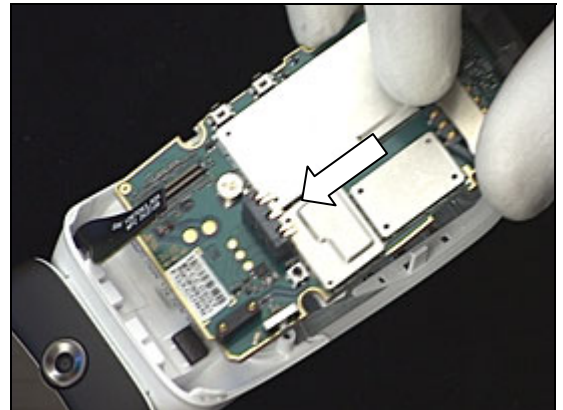
Use tweezers to position the Water Protective Tape.

Visually inspect that the Water Protective Tape is correctly positioned.



4.2.3 PBA

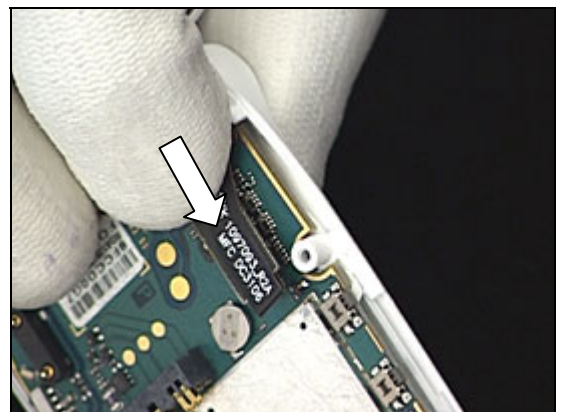
Use your fingers to position the PBA.



Visually inspect that the PBA is correctly positioned.

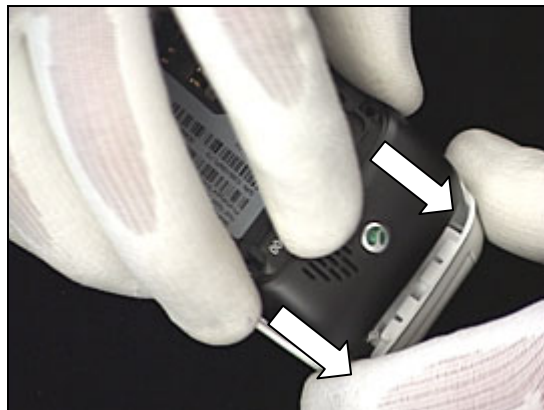


Use your fingers to connect the 60 pin BtB Connector to the PBA.

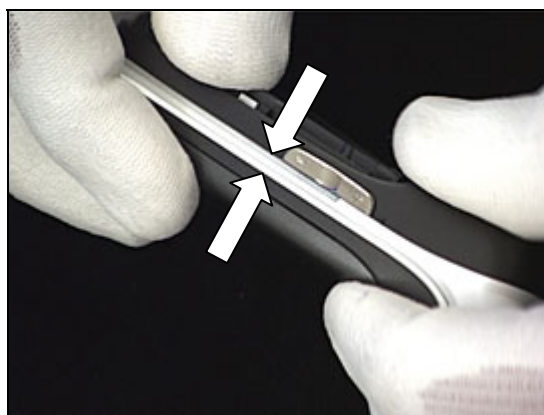


4.2.4 Lower Frame

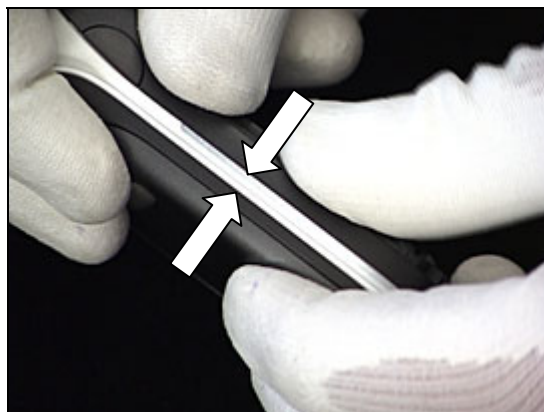
Use your fingers and slide the Lower Frame onto the Lower Front.



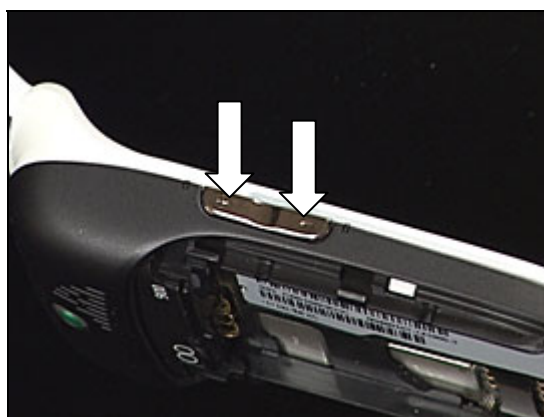
Use your fingers and press the Lower Frame onto the Lower Front.



Use your fingers and press the Lower Frame onto the Lower Front.



MAKE SURE THAT THE VOLUME KEY HAS CLICK FEELING!



Lower Frame *continued*

USE NEW SCREWS!

Use Torx bits no 5 to tighten the four screws using the torque 17 ± 2 Ncm.



4.2.5 Battery & Battery Cover

Position the Battery into the Lower Frame.



Use your fingers to press the Battery down into its cavity.



Use your fingers to slide the Battery Cover onto the Lower Frame.



Use your fingers to slide the Battery Cover onto the Lower Frame.

Visually inspect that the PBA is correctly positioned.



5 Revision history

Rev.	Date	Changes / Comments
A	2007-02-14	First release
B	2007-03-28	Equipment chapter updated
C	2007-07-11	Caution text added to the Disassembly section 2.1.2 (Lower Frame)
D	2007-08-22	Added camera replacement
E	2007-09-03	Placement of insulation label added