



Working Instruction, Mechanical

Applicable for Z320

CONTENTS

1	Introduction	3
1.1	Equipment	4
1.2	General cautions	5
1.3	Adhesives	5
2	Disassembly	6
2.1	Overview	6
2.1.1	Battery Cover and Battery	7
2.1.2	Lower Frame Assembly	8
2.1.3	PCBA	9
2.1.4	Style-Up Cover	10
2.1.5	Upper Frame Assembly	11
2.1.6	Flex Assembly	12
2.1.7	Upper Inner Cover and Lower Inner Cover	15
3	Replacements	16
3.1	Battery Cover	17
3.2	Style-Up Cover	17
3.3	Lower Frame Assembly	17
3.4	Upper Frame Assembly	17
3.5	Lower Inner Cover	18
3.6	Upper Inner Cover	18
3.7	Flex Assembly	18
3.8	Main Hinge	18
3.9	Rotation Lock	18
3.10	Dummy Hinge	19
3.11	Liquid Intrusion Indicator	19
3.12	Volume Key	20
3.13	Antenna Assembly	21
3.14	System Connector	22
3.15	Dome Sheet	23
3.16	Speaker	24
3.17	Vibrator	25
3.18	Camera Rubber	26
3.19	Camera Lens	27
3.20	Camera	28
3.21	Receiver	30
3.22	Hinge Spring Connector	31



3.23 Operator Key	32
3.24 Keypad	33
3.25 Co-Brand Plate	35
3.26 Receiver Plate	36
3.27 LCD Module	37
3.28 Main Window Assembly	38
3.29 KRH Label	40
4 Reassembly	41
4.1 Overview	41
4.1.1 Upper Inner Cover and Lower Inner Cover	42
4.1.2 Flex Assembly	43
4.1.3 Upper Frame Assembly	46
4.1.4 Style-Up Cover	48
4.1.5 PCBA	49
4.1.6 Lower Frame Assembly	51
4.1.7 Battery and Battery Cover	52
5 Revision history	54

1 Introduction

Z320

Note: There are three colors available for Z320: Crimson Red, Dark Silver and Atlantic Blue



1.1 Equipment

SPECIAL TOOLS

- NTZ 112 459 Torque Screwdriver
- NTZ 112 478 Torx Bit #5
- NTZ 112 1067 Camera Removal Tool
- NTZ 112 521 Flex film assembly tool
- NTZ 112 302/2 Front opening Tool
- NTZ 112 590 Guitar Pick (Plectrum)



STANDARD TOOLS

Standard tools text:

- Dentist Hook
- Pair of tweezers



ESD EQUIPMENT

Protect the phone from ESD damages whenever it has been opened by using:

- ESD-wristband
- ESD-gloves



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





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:

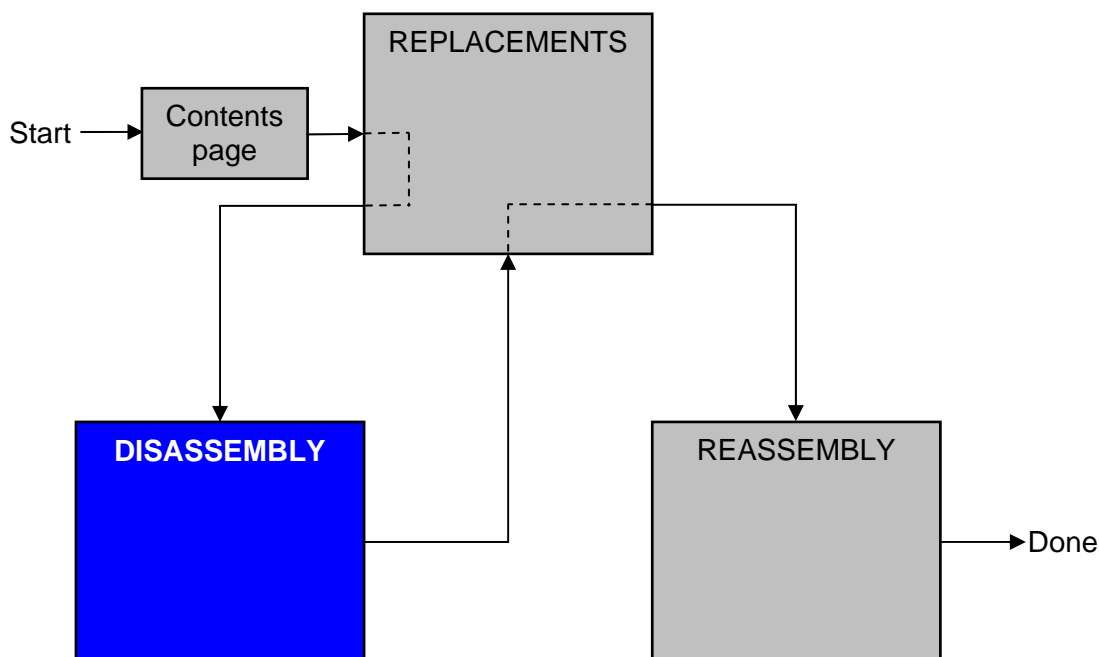
- **SWITCH OFF THE PHONE AND REMOVE ANY MEMORY STICK BEFORE THE START OF THE DISASSEMBLY!**
- **KEEP ALL CONTACT SURFACES CLEAN!**
- **BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, OPENING TOOLS, GUITAR PICK ETC. TO AVOID SCRATCHES OR DAMAGES TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!**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

1.3 Adhesives

Use a dentist hook and/or the tweezers to remove old adhesives.
Clean the surface with isopropyl alcohol before attaching new adhesives.

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 Overview

The disassembly is done in the following sequence:

1. Battery Cover (a) and Battery (b)
2. Lower Frame Assembly
3. PCBA
4. Style-up Cover
5. Upper Frame Assembly
6. Flex Assembly
7. Upper Inner Cover (a) and Lower Inner Cover (b)



2.1.1 Battery Cover and Battery

BE CAREFUL NOT TO SCRATCH THE SURFACE!

Open the Battery Cover Latch



Lift up Battery Cover



Lift up the Battery



2.1.2 Lower Frame Assembly

Use Torx bit no. 5 to remove the five screws.



Use a Guitar Pick to release the snap hook.



Slide along the bottom of the phone all the way to the IrDA window to release the snap hooks.

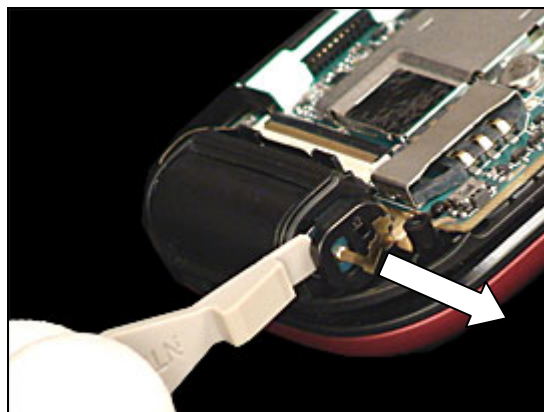


Lift up Lower Frame Assembly from the bottom to remove it from Lower Inner Cover

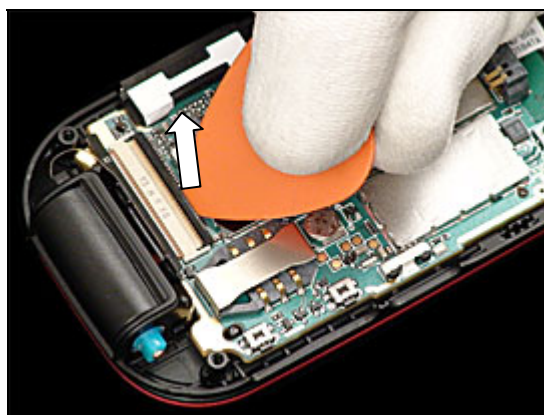


2.1.3 PCBA

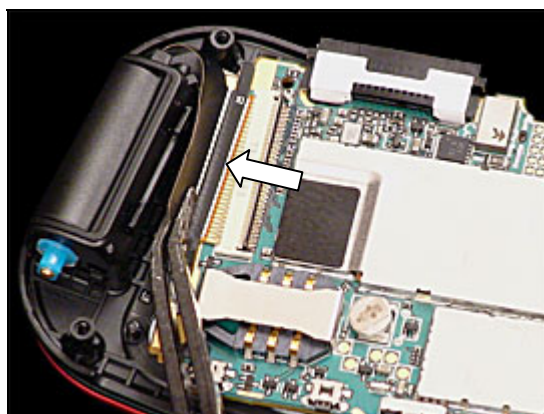
Use a Front Opening Tool to release the Rotation Lock



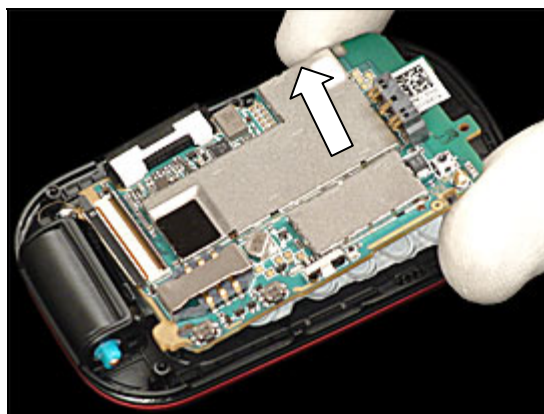
Release the lock of ZIF Connector with a Guitar Pick



Use the Flex Assembly Tool to separate the PCBA from the Flex Assembly



Lift up the PCBA



2.1.4 Style-Up Cover

Use a Guitar Pick to release snap hooks on the Style-Up Cover

Do NOT SLIDE ALONG THE BOTTOM OF THE STYLE-UP COVER TO AVOID DAMAGING THE RECEIVER MESH.

Remove the Style-up cover from the Upper Frame Assembly



2.1.5 Upper Frame Assembly

Use Torx bit no. 5 to remove the five screws.



Use a Guitar Pick to slide along the side and release the snap hooks.

REPEAT THE PROCEDURE ON THE OPPOSITE SIDE!

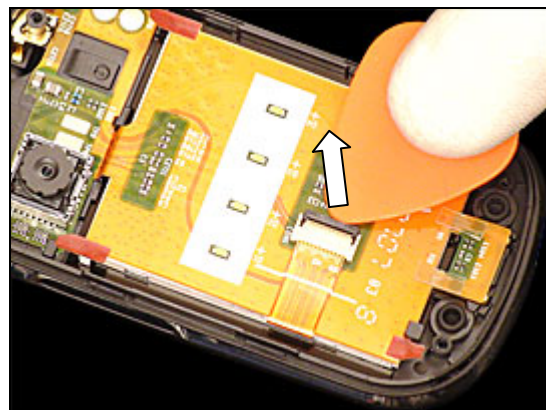


Lift up Upper Frame Assembly from the lower part and remove it.

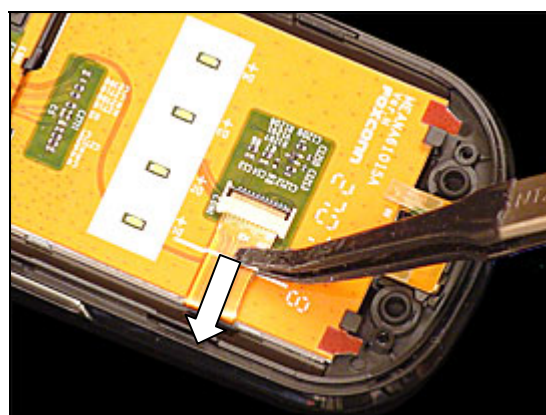


2.1.6 Flex Assembly

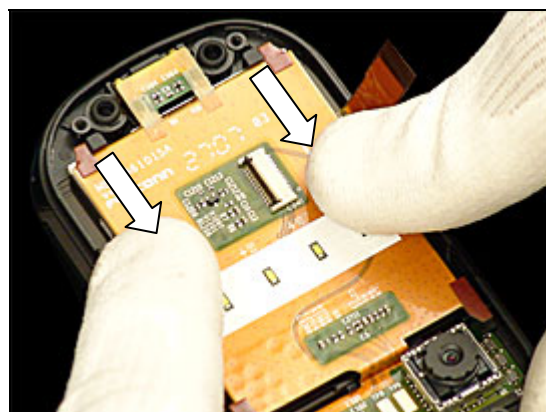
Use a Guitar Pick to release the lock of ZIF Connector.



Use the Flex film Assembly tool to remove the flex film from the ZIF Connector.



Use your fingers to pull the Flex Assembly out from the two hooks of the upper frame



Use finger to lift up the Flex Assembly

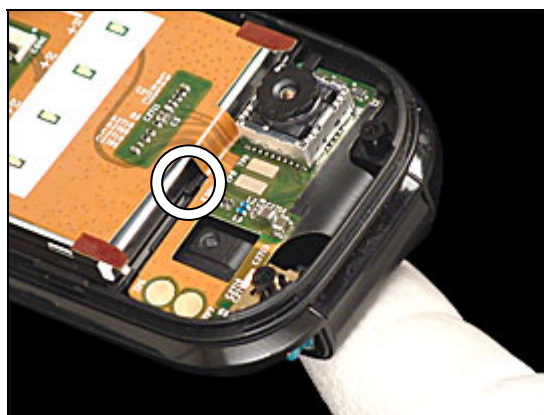


Flex Assembly *continued*

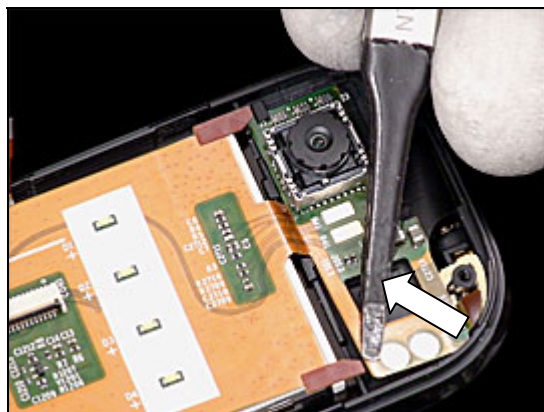
Use the Front Opening Tool to push the lower flex in order to release it from the middle snap hook



Note the released Flex Assembly from the hook



Use the Flex film assembly tool to remove it from the snap close to the Hinge Spring Connector.



Use the Flex film assembly tool to remove it from the two snap hooks close to the Camera.



Flex Assembly *continued*

Use the Front Opening Tool to release the Dummy Hinge from Lower Inner Cover



BE VERY CAREFUL NOT TO DAMAGE THE FLEX ASSEMBLY DURING THIS PROCEDURE!

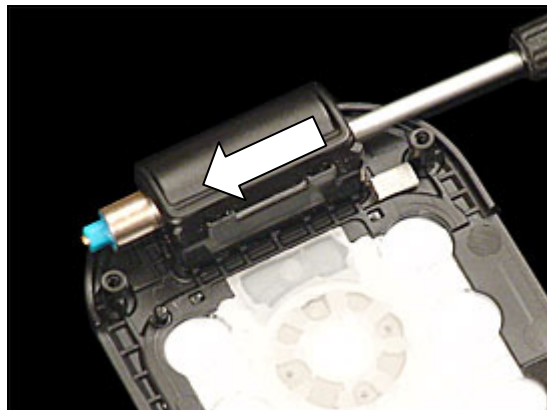
Use your fingers to pull out the Flex Assembly from the hinge area.

Remove the Flex Assembly.



2.1.7 Upper Inner Cover and Lower Inner Cover

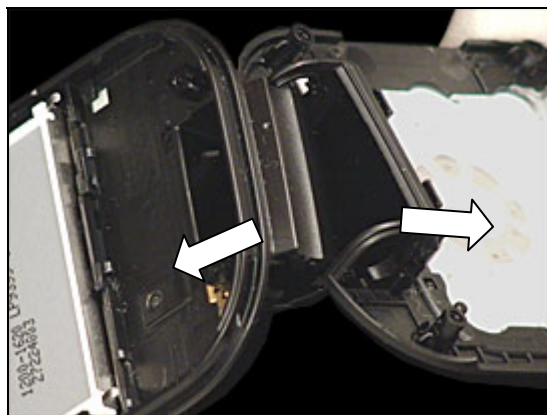
Use a screw driver to push out the Main Hinge.



Open up the phone to 90 degrees



Use your fingers to separate the Upper Inner Cover and the Lower Inner Cover.



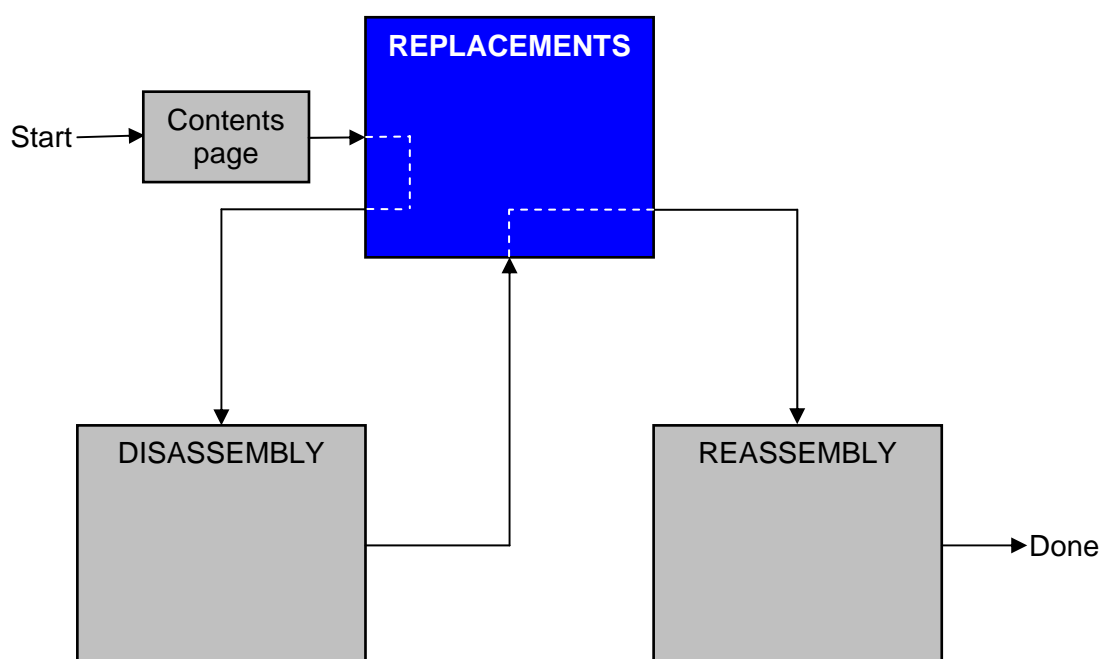
3 Replacements

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 instruction!

Prepare a new Battery Cover.

Follow the 4.1.7 Reassembly instruction!

3.2 Style-Up Cover

Follow the 2.1.4 Disassembly instruction!

Prepare a new Style-Up Cover.

Follow the 4.1.4 Reassembly instructions!

3.3 Lower Frame Assembly

Follow the 2.1.1 – 2.1.2 Disassembly instructions!

Prepare a new Lower Frame Assembly.

Follow the 4.1.6 – 4.1.7 Reassembly instructions!

3.4 Upper Frame Assembly

Follow the 2.1.4 – 2.1.5 Disassembly instructions!

1. Prepare a new Upper Frame Assembly.
2. **Reuse** the **Vibrator** and the **Camera Rubber** from the old assembly.
 - a. Follow the 3.17 and 3.18 Replacement Instructions
3. Use a **new Speaker!**
 - a. Follow the 3.16 Replacement Instruction.

Follow the 4.1.3 – 4.1.4 Reassembly instructions!

3.5 Lower Inner Cover

Follow the 2.1.1 – 2.1.7 Disassembly instructions!

1. Prepare a new Lower Inner Cover.
2. Use a **new Keypad!**
 - b. Follow the 3.24 Replacement Instructions

Follow the 4.1.1 – 4.1.7 Reassembly instructions!

3.6 Upper Inner Cover

Follow the 2.1.1 – 2.1.7 Disassembly instructions!

1. Prepare a new Upper Inner Cover.
2. Use **new Co-Brand and Receiver Plates!**
 - c. Follow the 3.25 and 3.26 Replacement Instructions.

Follow the 4.1.1 – 4.1.7 Reassembly instructions!

3.7 Flex Assembly

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

Prepare a new Flex Assembly.

Follow the 4.1.2 – 4.1.7 Reassembly instructions!

3.8 Main Hinge

Follow the 2.1.1 – 2.1.7 Disassembly instructions!

Prepare a new Main Hinge.

Follow the 4.1.1 – 4.1.7 Reassembly instructions!

3.9 Rotation Lock

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

Prepare a new Rotation Lock.

Follow the 4.1.5 – 4.1.7 Reassembly instructions!

3.10 Dummy Hinge

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

Prepare a new Dummy Hinge.

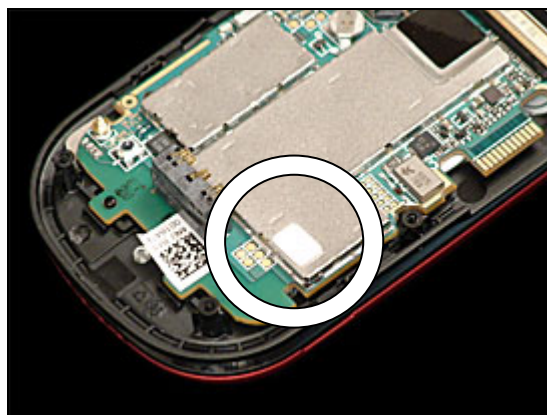
Follow the 4.1.2 – 4.1.7 Reassembly instructions!

3.11 Liquid Intrusion Indicator

Follow the 2.1.1 – 2.1.2 Disassembly instructions!

1. Remove the old label with a pair of tweezers
2. Prepare a new Liquid Intrusion Indicator label
3. Use a pair of tweezers to mount the new label on top of the Shielding Frame

Follow the 4.1.6 – 4.1.7 Reassembly instructions!

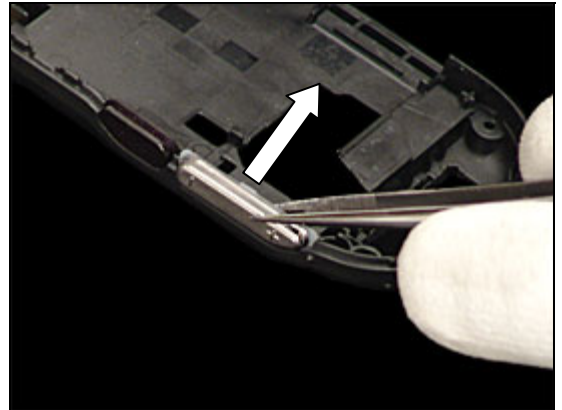


3.12 Volume Key

REMOVAL

Follow the 2.1.1 – 2.1.2 Disassembly instructions!

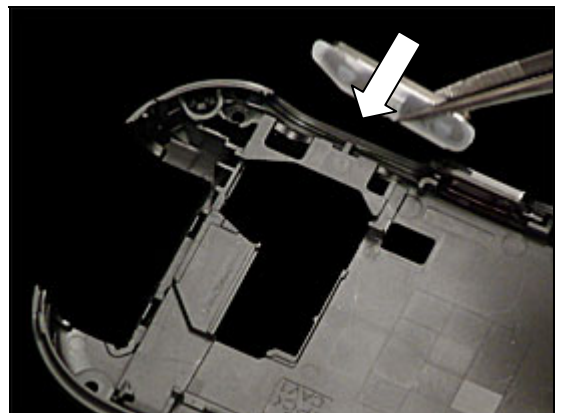
Remove the Volume Key with a pair of tweezers.



INSTALLATION

Insert the Volume Key into the cavity with a pair of tweezers

Follow the 4.1.6 – 4.1.7 Reassembly instructions!

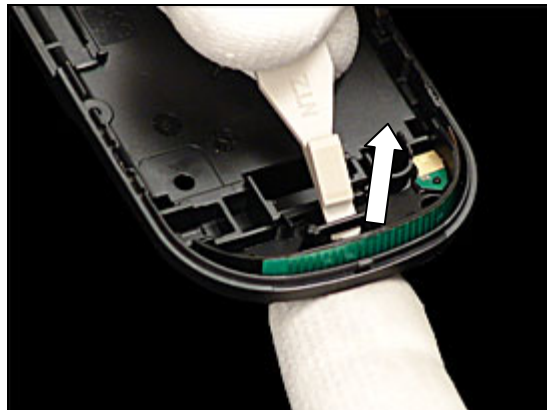


3.13 Antenna Assembly

REMOVAL

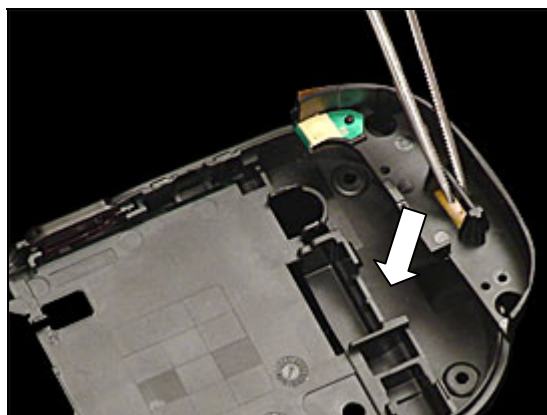
Follow the 2.1.1 – 2.1.2 Disassembly instructions!

Use a Front Opening Tool to release the Antenna Assembly from Lower Frame Assembly

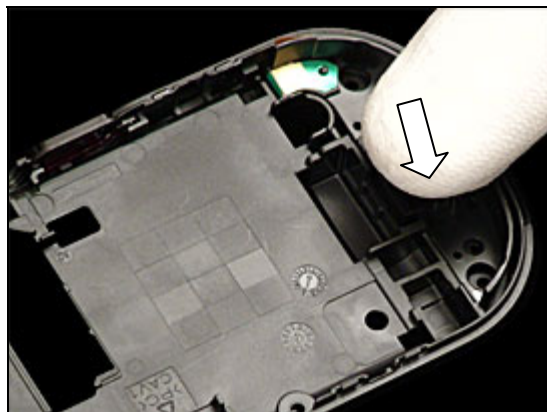


INSTALLATION

Use a pair of tweezers to align the Antenna Assembly into the cavity.

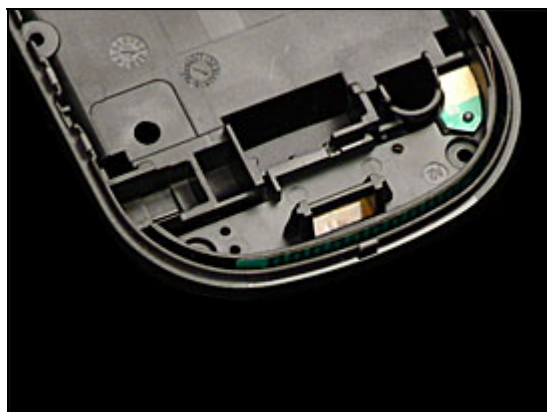


Push the Antenna Assembly with your fingers until you hear a 'Click' sound.



Visually inspect that the Antenna Assembly is correctly installed.

Follow the 4.1.6 – 4.1.7 Reassembly instructions!

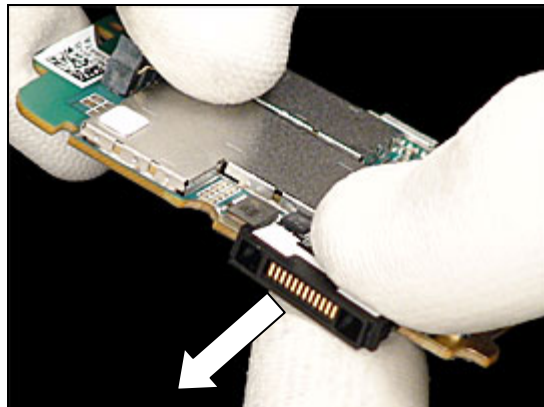


3.14 System Connector

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

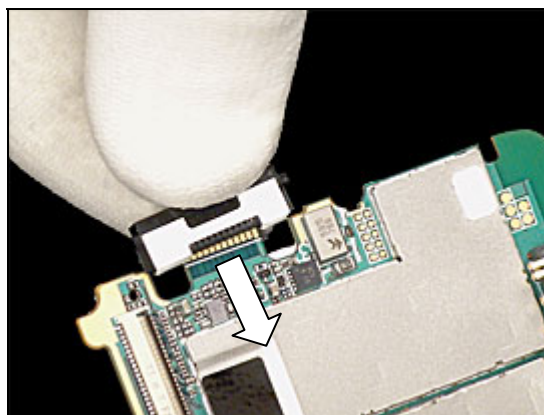
Pull the System Connector away from PCBA.



INSTALLATION

Push the System Connector into PCBA.

Follow the 4.1.5 – 4.1.7 Reassembly instructions!

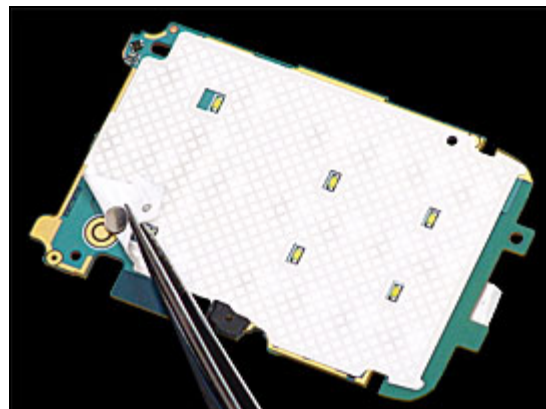


3.15 Dome Sheet

REMOVAL

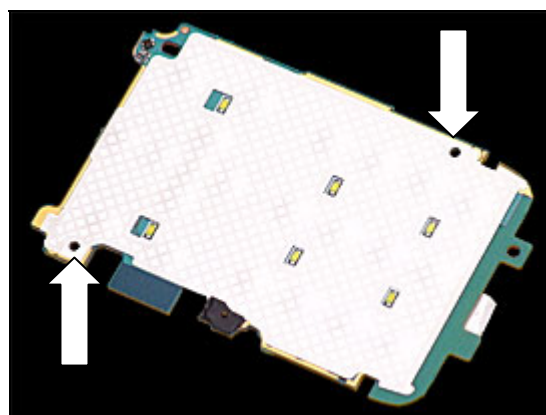
Follow the 2.1.1 – 2.1.3 Disassembly instructions!

1. Remove the System Connector
 - a. Follow the 3.14 Replacement Instructions
2. Use the tweezers to peel off the Dome Sheet array.



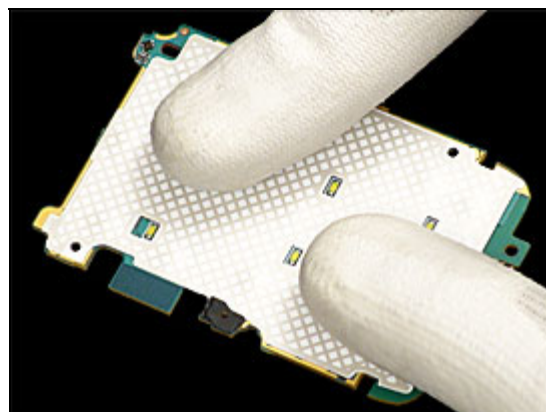
INSTALLATION

Align the new Dome Sheet with the two holes on the PCBA



1. Press down the Dome Sheet with your fingers to fasten the adhesive.
2. Install the System Connector
 - a. Follow the 3.14 Replacement Instructions.

Follow the 4.1.5 – 4.1.7 Reassembly instructions!



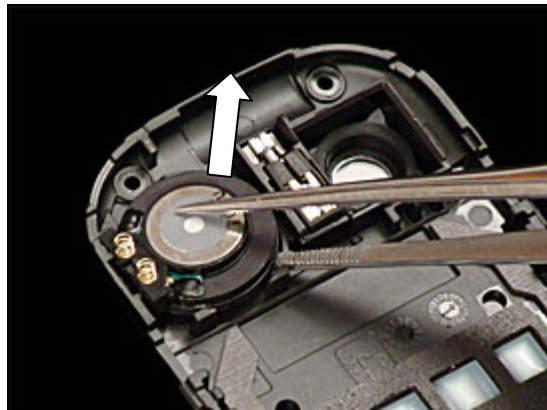
3.16 Speaker

REMOVAL

Follow the 2.1.4 – 2.1.5 Disassembly instructions!

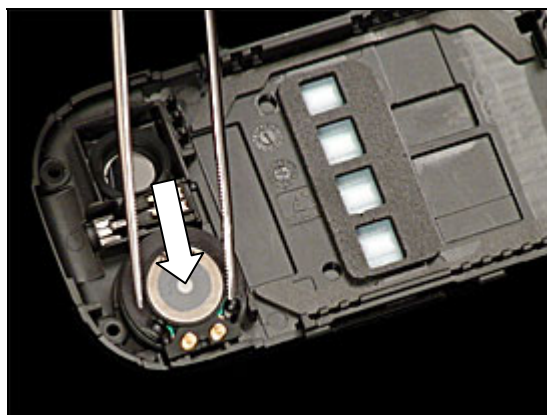
Use tweezers to remove the Speaker

Clean all adhesive residue with Isopropyl alcohol.



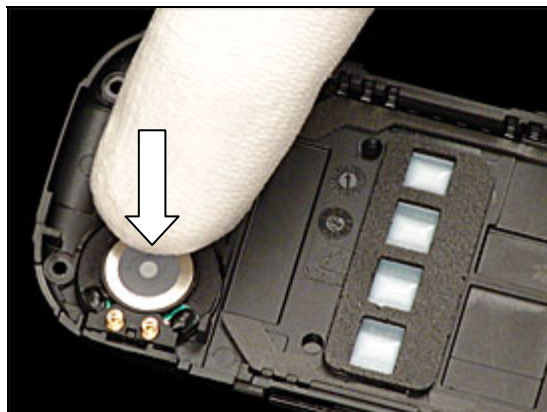
INSTALLATION

Use tweezers to align the Speaker



Press down the Speaker with your fingers to fasten the adhesive.

Follow the 4.1.3 – 4.1.4 Reassembly instructions!

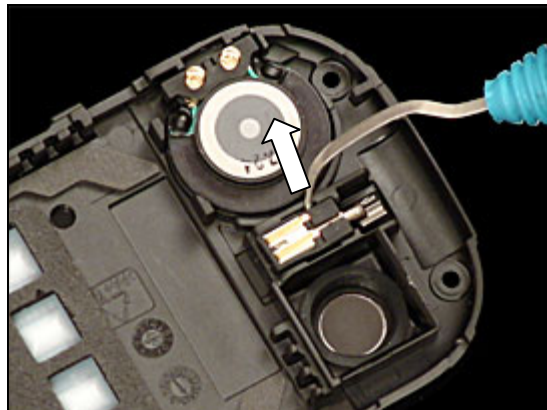


3.17 Vibrator

REMOVAL

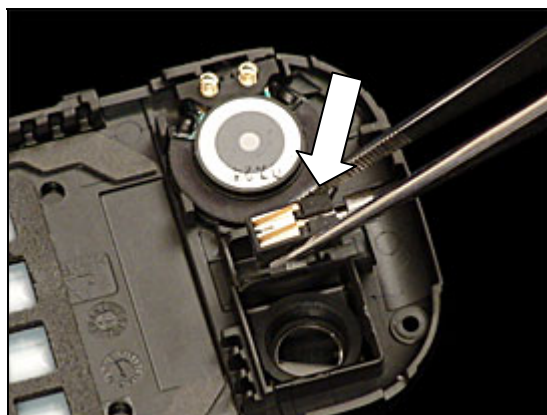
Follow the 2.1.4 – 2.1.5 Disassembly instructions!

Use a dentist hook to remove the Vibrator



INSTALLATION

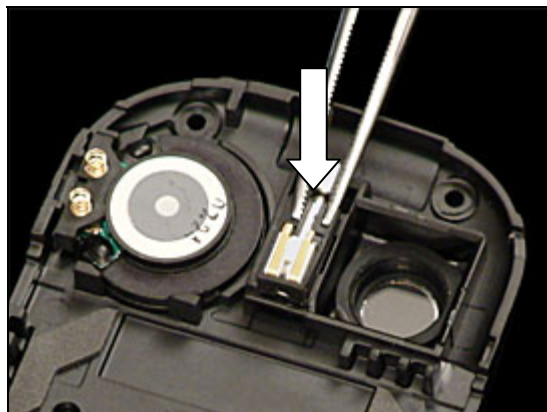
Use tweezers to align the Vibrator



BE CAREFUL NOT TO DAMAGE THE VIBRATOR CONTACT SPRINGS!

Use tweezers to press down the Vibrator into the cavity

Follow the 4.1.3 – 4.1.4 Reassembly instructions!

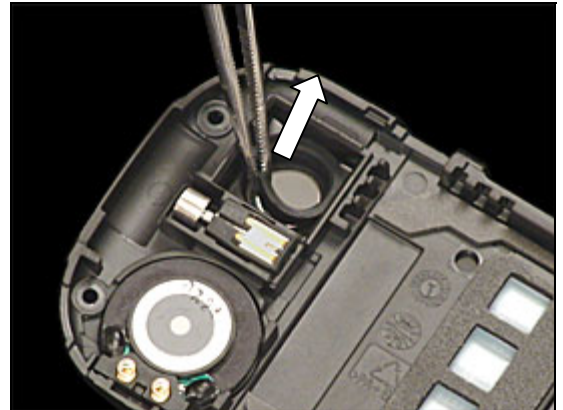


3.18 Camera Rubber

REMOVAL

Follow the 2.1.4 – 2.1.5 Disassembly instructions!

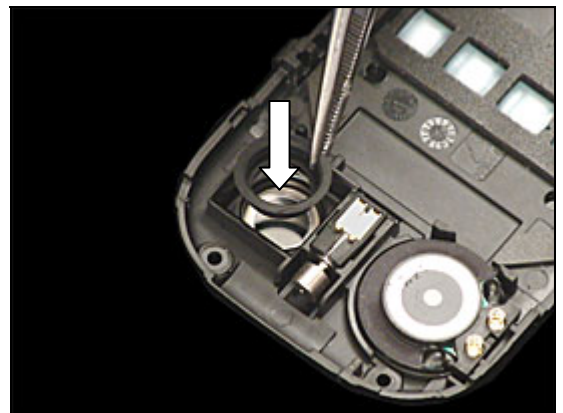
Use tweezers to remove the Camera Rubber



INSTALLATION

Use tweezers to install the Camera Rubber into the camera lens cavity.

Follow the 4.1.3 – 4.1.4 Reassembly instructions!



3.19 Camera Lens

REMOVAL

Follow the 2.1.4 – 2.1.5 Disassembly instructions!

Follow the 3.18 Replacement Instruction to remove the Camera Rubber from the Upper Frame Assembly

- Use the Front Opening Tool to push the Camera Lens out from the cavity.
- Clean all adhesive residue with Isopropyl alcohol

INSTALLATION

- Install new Camera Lens adhesive on the Camera Lens
- Use tweezers to install the Camera Lens into the camera lens cavity.

Follow the 3.18 Replacement Instruction to install the Camera Rubber into the Upper Frame Assembly

Follow the 4.1.3 – 4.1.4 Reassembly instructions!

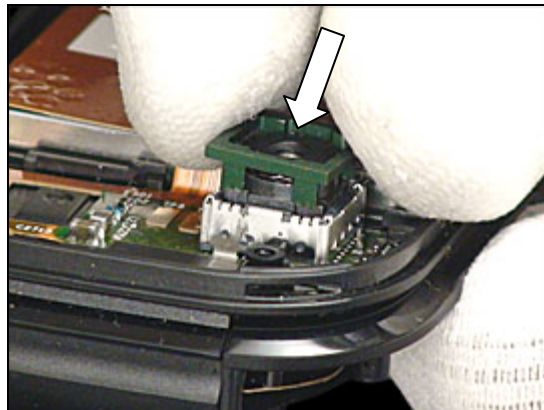


3.20 Camera

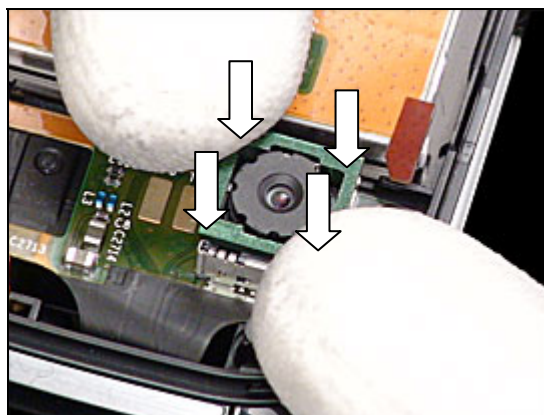
REMOVAL

Follow the 2.1.4 – 2.1.5 Disassembly instructions!

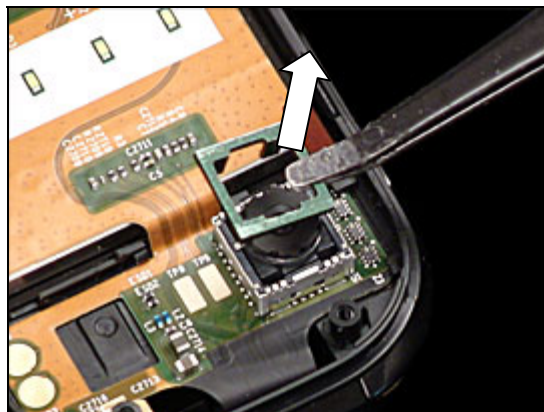
Place a Camera Removal Tool on top of the Camera and the Camera socket.



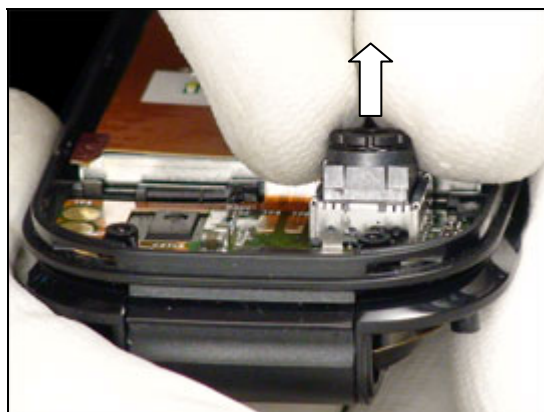
Use your fingers to press the Camera Removal Tool until you hear a 'Click' sound.



Use tweezers to remove the Camera Removal Tool



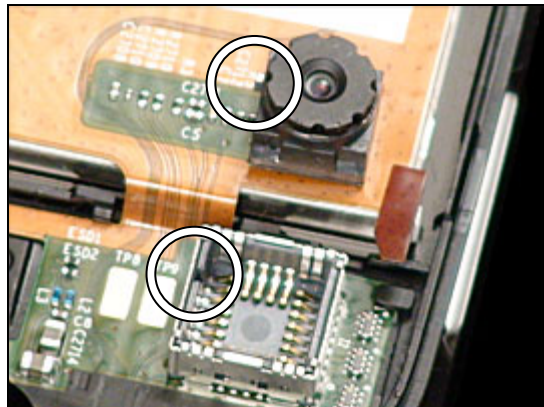
Use your fingers to remove the Camera from the socket



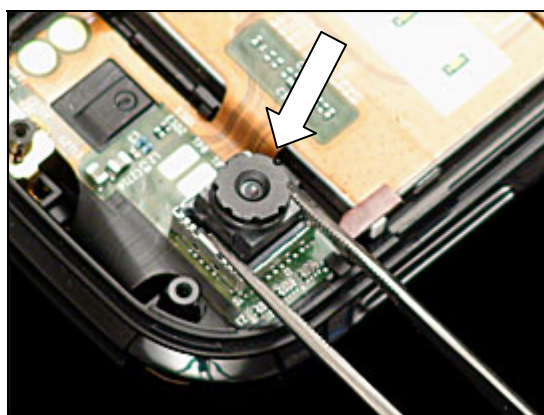
Camera *continued*

INSTALLATION

Note: There is a pin on the Camera that fits into the gap on the socket

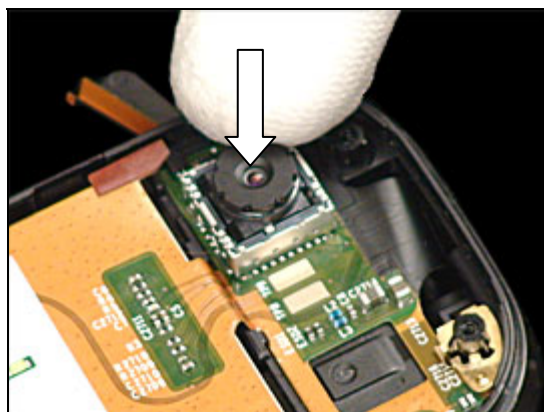


Use tweezers to align the Camera into the socket



Use your fingers to press down the Camera into the socket until you hear a 'Click' sound.

Follow the 4.1.3 – 4.1.4 Reassembly instructions!



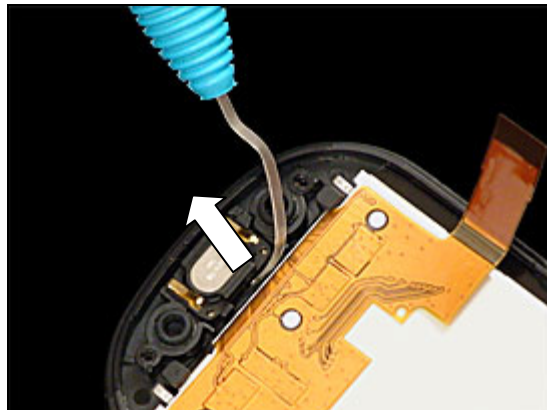
3.21 Receiver

REMOVAL

Follow the 2.1.4 – 2.1.5 Disassembly instructions!

Use a dentist hook to remove the Receiver from the upper front.

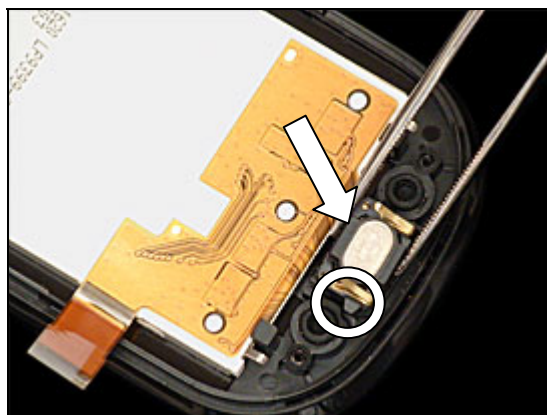
Clean all adhesive residue with Isopropyl alcohol.



INSTALLATION

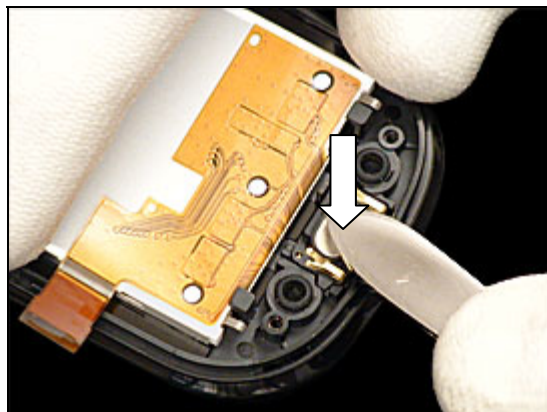
Use tweezers to align the Receiver into the cavity.

Note the Guiding pin!



Press down the Receiver with the back of a pair of tweezers to fasten the adhesive.

Follow the 4.1.3 – 4.1.4 Reassembly instructions!

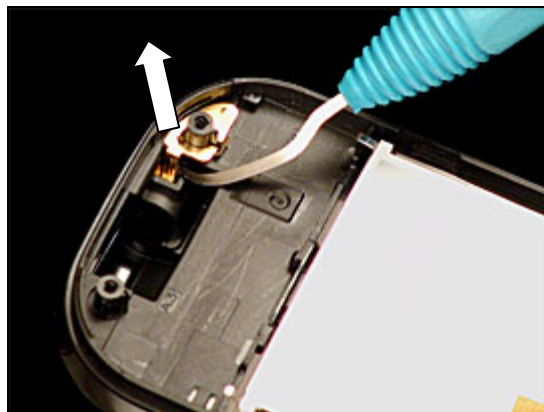


3.22 Hinge Spring Connector

REMOVAL

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

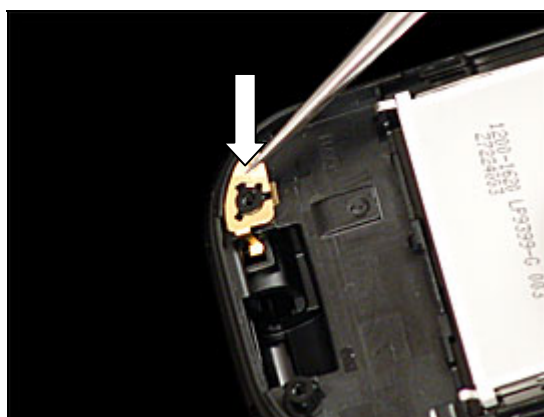
Use a dentist hook to remove the Hinge Spring Connector from the upper front



INSTALLATION

Use tweezers to install a **new** Hinge Spring Connector

Follow the 4.1.2 – 4.1.7 Reassembly instructions



3.23 Operator Key

REMOVAL

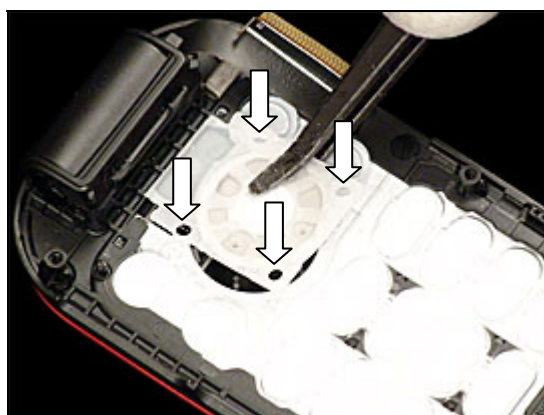
Follow the 2.1.1 – 2.1.3 Disassembly instructions!

Use your fingers to press down and release the Operator Key from the Keypad



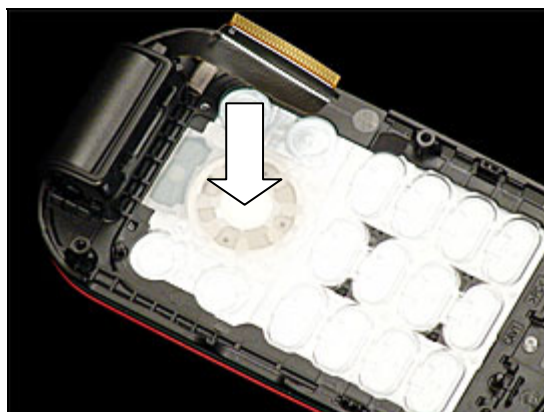
INSTALLATION

Use tweezers to align the Operator Key with the four pins on the Keypad



Press carefully with your fingers to install the Operator Key and inspect that it is correctly installed.

Follow the 4.1.5 – 4.1.7 Reassembly instructions!

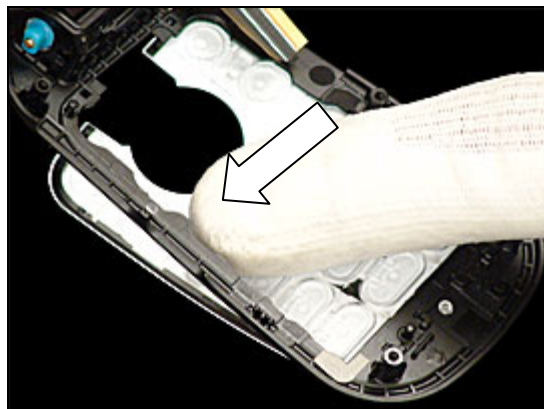


3.24 Keypad

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

Use your fingers to carefully separate the Keypad from the Lower Inner Cover



Lift up the Keypad

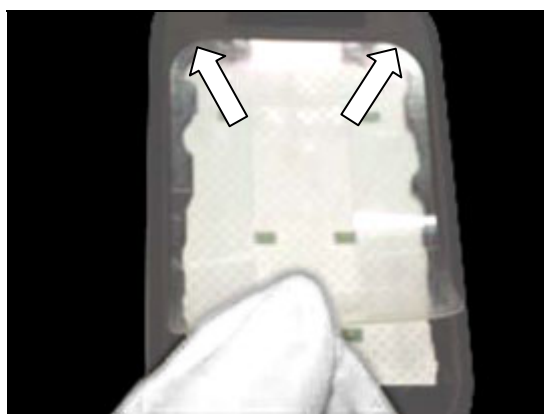


Clean all adhesive residues on the Lower Inner Cover with Isopropyl alcohol.



INSTALLATION

Use your fingers to align new Keypad Adhesive on the Lower Inner Cover



Keypad *continued*

1. Align the Keypad with the two guiding holes
2. Press down the Keypad with your fingers to fasten the adhesive along the sides.

Follow the 4.1.5 – 4.1.7 Reassembly instructions!



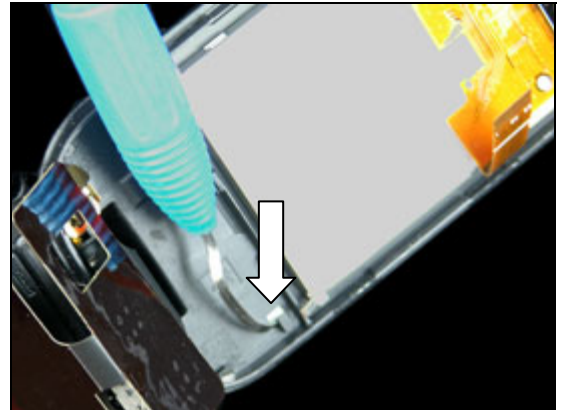
3.25 Co-Brand Plate

REMOVAL

Follow the 2.1.4 – 2.1.6 Disassembly instructions!

NOTE: The Flex Assembly does not need to be removed completely for the removal. Loose it from the snap hooks and fold it back over the hinge to access the Co-Brand Plate

Use a Dentist Hook to release the Co-Brand Plate from the inside of the Upper Inner Cover



Use tweezers to remove the Co-Brand



INSTALLATION

1. Clean all adhesive residues on the Lower Inner Cover with Isopropyl alcohol.
2. Align a new Co-Brand Plate Adhesive with tweezers



Use your fingers to align a new Co-Brand Plate on the Upper Inner Cover

Follow the 4.1.2 – 4.1.4 Reassembly instructions!



3.26 Receiver Plate

REMOVAL

Use a Front Opening tool to release the Receiver Plate from the Upper Inner Cover

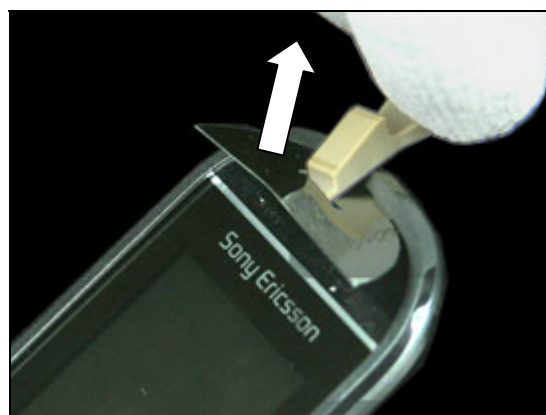
BE CAREFUL NOT TO DAMAGE THE RECEIVER MESH DURING THE PROCEDURE!

Pull up the Receiver Plate

INSTALLATION

1. Clean all adhesive on the Lower Inner Cover with Isopropyl alcohol.
2. Align a new Receiver Plate Adhesive with tweezers

Use your fingers to align a new Receiver Plate on the Upper Inner Cover



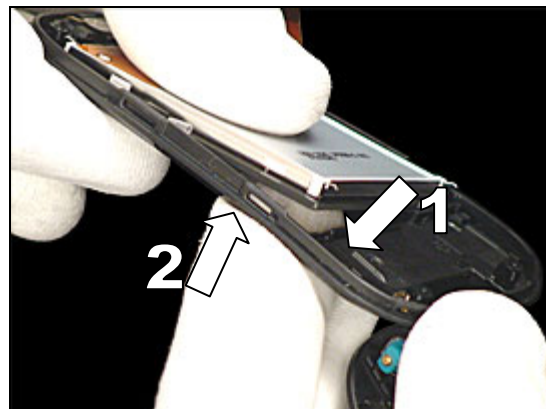
3.27 LCD Module

REMOVAL

Follow the 2.1.4 – 2.1.6 Disassembly instructions!

1. Use your fingers to **carefully** bend the Lower Inner Cover
2. Unsnap the Main Window Assembly (with LCD Module) from the Upper Inner Cover

Pull up the Main Window Assembly (with LCD Module) from the lower part to remove it.



INSTALLATION

Align the new Main Window Assembly (with LCD Module) under the two hooks

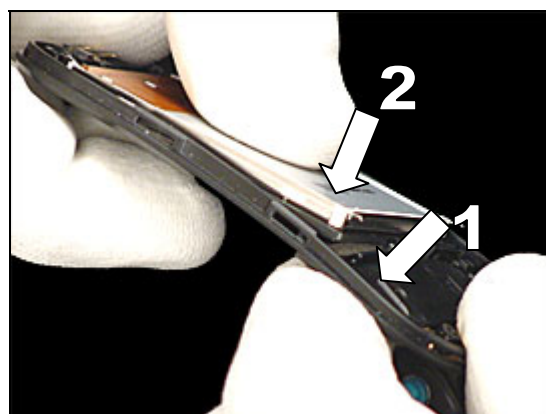


BE CAREFUL NOT TO DAMAGE THE LCD MODULE DURING THIS PROCEDURE.

ANY PRESSURE DIRECTLY UNDER THE MAIN WINDOW ASSEMBLY WILL BREAK THE LCD MODULE!

1. Bend the Front Cover **carefully**
2. Snap the Main Window Assembly into place.

Follow the 4.1.2 – 4.1.4 Reassembly instructions!



3.28 Main Window Assembly

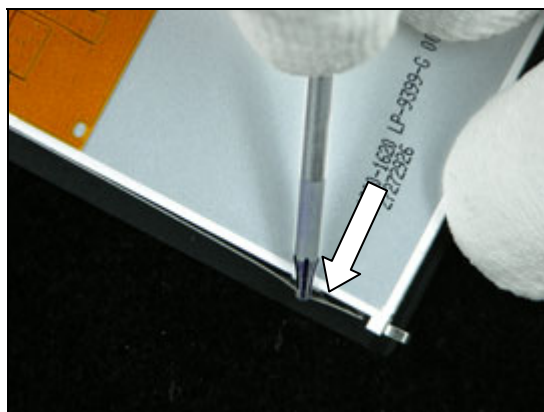
REMOVAL

Follow the 2.1.4 – 2.1.6 Disassembly instructions!

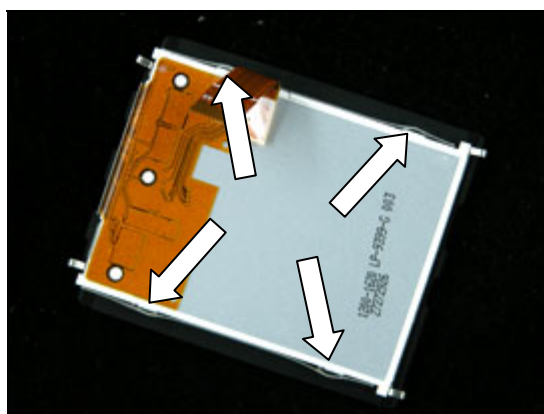
Follow the 3.27 Replacement Instruction to remove the Main Window Assembly from the Upper Inner Cover.

Use a screwdriver to release the Metal carrier from the snap hooks on the LCD Module

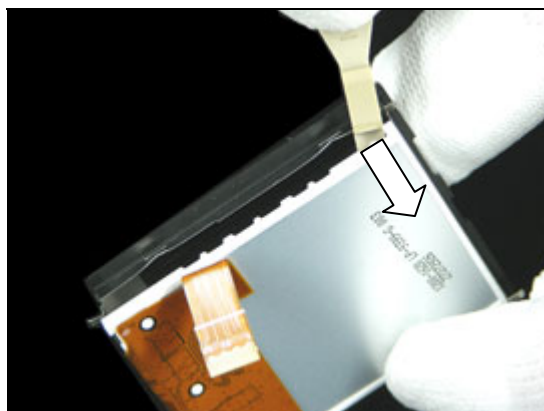
BE CAREFUL NOT TO DAMAGE THE LCD MODULE DURING THE PROCEDURE!



Note the released snap hooks



Use the Front Opening Tool to remove the LCD from the metal carrier and the Main Window Assembly

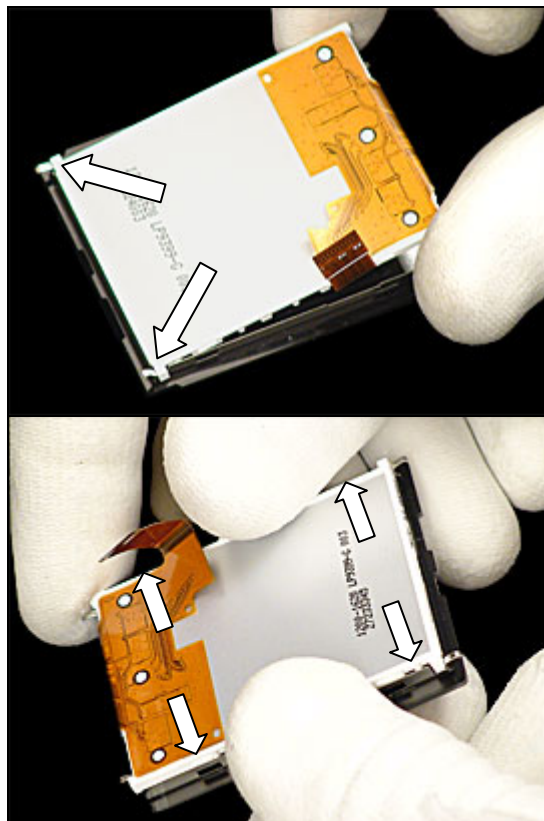


Main Window Assembly *continued*

INSTALLATION

1. Prepare a **new** Main Window Assembly
2. **Reuse** the old LCD Module and align the two hooks to the metal carrier

Use your fingers to press the LCD Module into the Main Window Assembly until you hear a 'Click' sound



Follow the 3.27 Replacement Instruction to install the Main Window Assembly to the Upper Inner Cover.

Follow the 4.1.2 – 4.1.4 Reassembly instructions!

3.29 KRH 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.

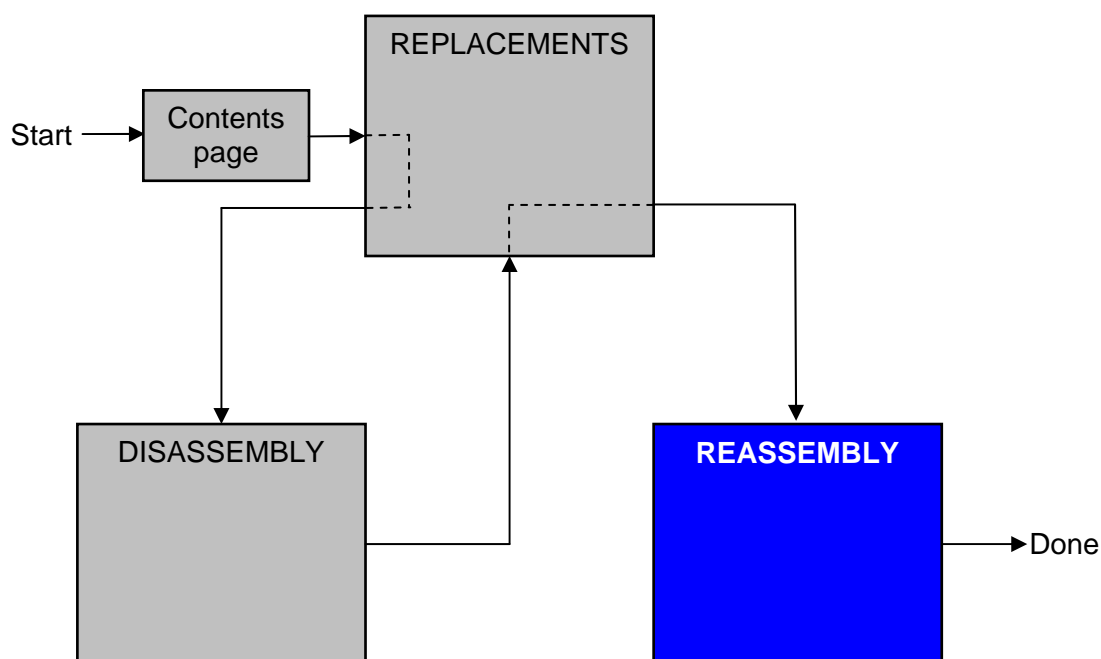
ONE LABEL ONLY IS ALLOWED!

Follow the 4.1.7 Reassembly instructions!



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 Overview

The disassembly is done in the following sequence:

1. Lower Inner Cover (a) and Upper Inner Cover (b)
2. Flex Assembly
3. Upper Frame Assembly
4. Style-up Cover
5. PCBA
6. Lower Frame Assembly
7. Battery (a) and Battery Cover (b)

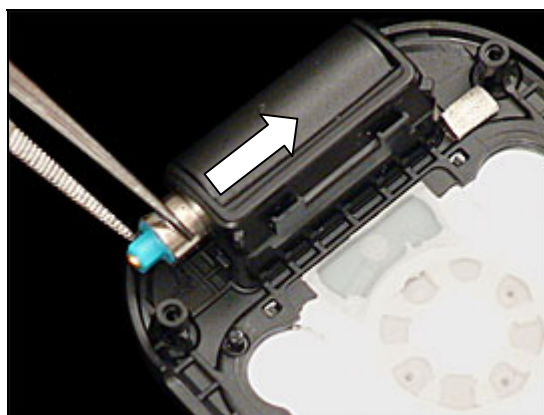


4.1.1 Upper Inner Cover and Lower Inner Cover

Use your fingers to reinstall the Upper Inner Cover and Lower Inner Cover in a 90 degree angle

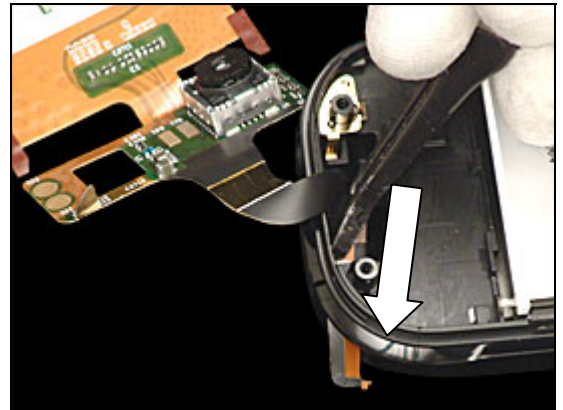


1. Fold the phone together
2. Use tweezers to push the Main Hinge into the hinge hole. Lower Frame Assembly



4.1.2 Flex Assembly

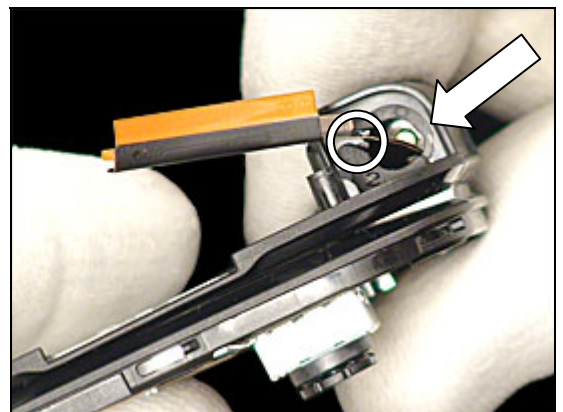
Use tweezers to press the Flex Assembly through the hinge hole. Use your fingers to carefully pull out the Flex film from the other side



Note the position of the Dummy Hinge before installation



Use your fingers to press the Dummy Hinge into place
MAKE SURE THAT THE FLEX FILM IS POSITIONED CORRECTLY IN THE HINGE HOLE!

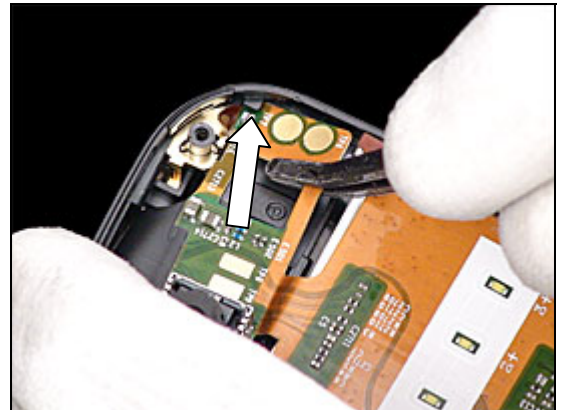


Insert Flex Assembly into two snaps close to the Camera



Flex Assembly *continued*

Use tweezers to align the Flex Assembly under the hook close to the Hinge Spring Connector



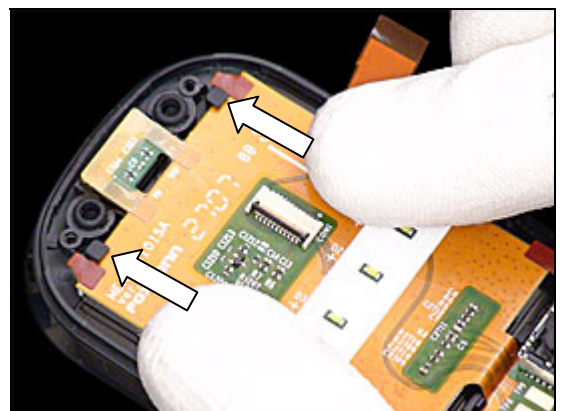
Use tweezers to snap the Flex Assembly under the middle hook



Note the mounted Flex Assembly under the hook

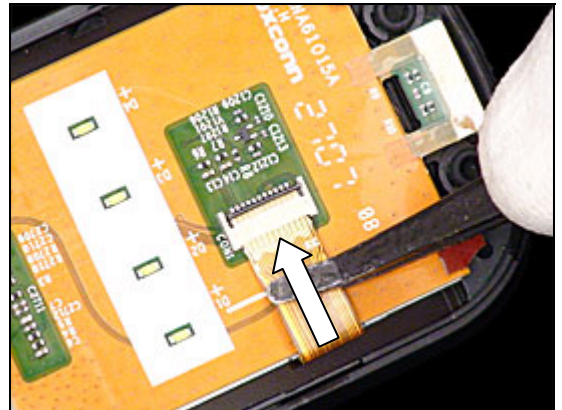


Push the Flex Assembly under the two hooks on the upper front

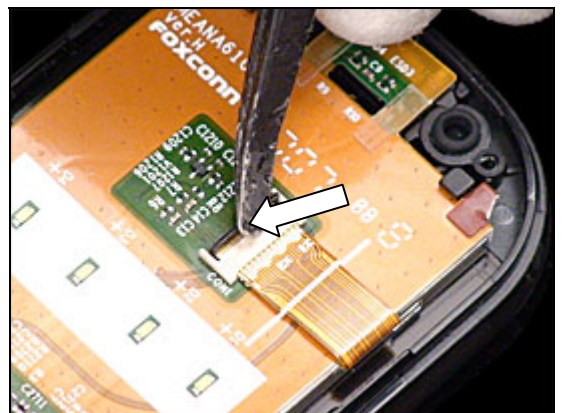


Flex Assembly *continued*

Use the Flex film assembly tool to insert the flex film into the ZIF Connector



Use tweezers to lock the ZIF Connector



Note the locked connector.



4.1.3 Upper Frame Assembly

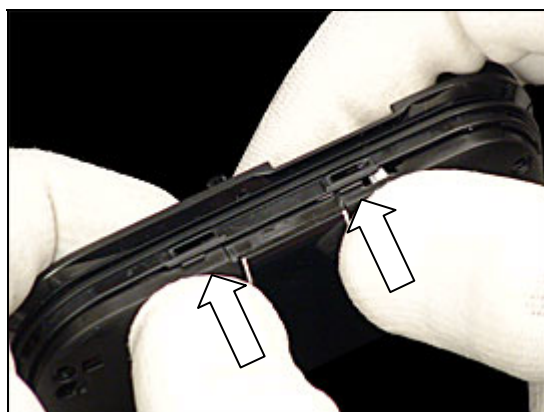
Align the Upper Frame Assembly on the Upper Inner Cover



Use your fingers to snap the Upper Frame Assembly to the two hooks on the right side



Use your fingers to snap the Upper Frame Assembly to the two hooks on the left side



Note the mounted Upper Frame Assembly



Upper Frame Assembly *continued*

Use Torx no. 5 to tighten the four screws in correct sequence

Note: Screw torque : 10 ± 0.5 Ncm



4.1.4 Style-Up Cover

Place the Style-Up Cover under the snaps on the top side



Use your fingers to press on both sides of the Style-Up Cover

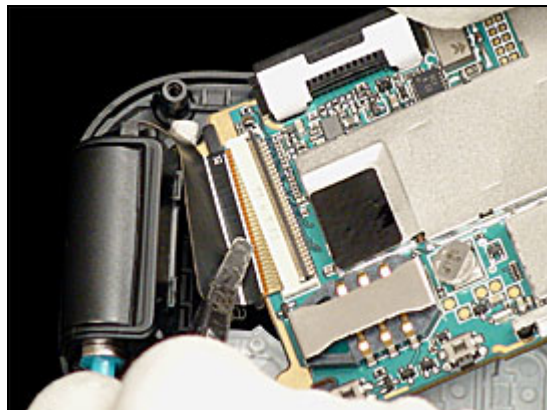


Use your fingers to snap the lower side on the Style-Up Cover

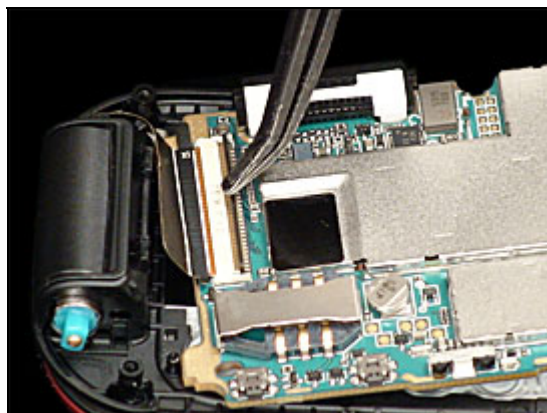


4.1.5 PCBA

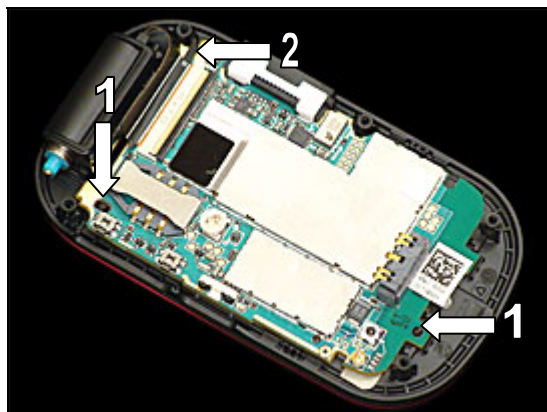
Use a Flex film assembly tool to insert the Flex Assembly into the ZIF connector



Use tweezers to lock the ZIF Connector



1. Align the PCBA with the locating pins of the Lower Inner Cover
2. Press down the conductive flange of the Flex Assemble on PCBA grounding pad

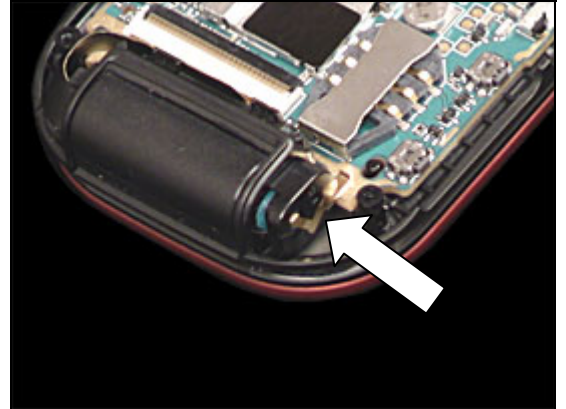


Note the position of the Rotation Lock before installation



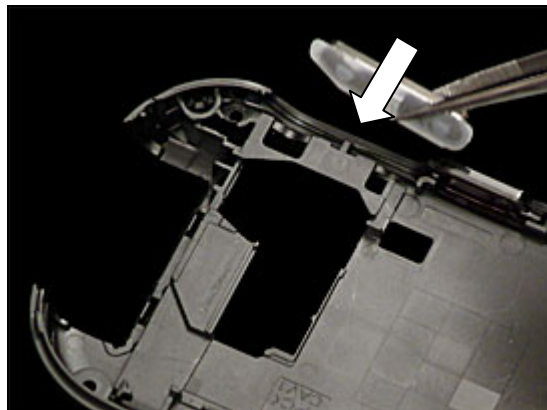
PCBA continued

Place rotation lock on the head of the Main Hinge
Push guide pin of rotation lock into Lower Inner Cover



4.1.6 Lower Frame Assembly

Insert the Volume Key into the cavity with a pair of tweezers



Place the Lower Frame Assembly under the snaps on the top side

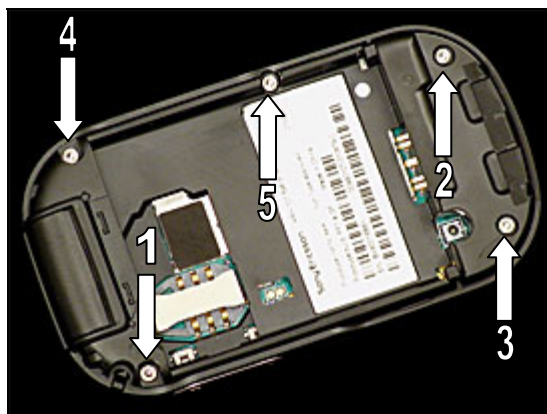


Use your fingers to press on both sides of the Lower Frame Assembly



Use Torx no. 5 to tighten the five screws in correct sequence

Note: Screw torque : 10 ± 0.5 Ncm



4.1.7 Battery and Battery Cover

Place the Battery into the battery cavity



Use your fingers to press down the Battery



Place the Battery Cover under the snaps on the top side



Use your fingers to press down the Battery Cover on both sides



PCBA *continued*

Lock the Battery Cover latch



5 Revision history

Rev.	Date	Changes / Comments
A	2007-10-09	1 st release
2	2007-12-20	Due to system error