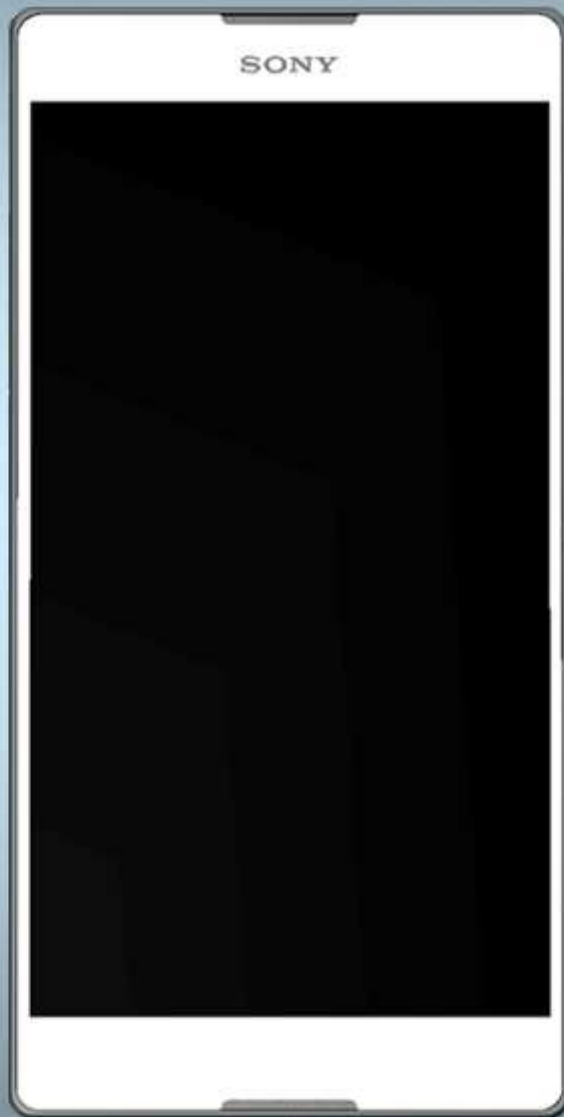


Working Instructions

- mechanical -



Xperia™ T2 Ultra Dual D5322, XM50h
Xperia™ T2 Ultra D5303, D5306, XM50t

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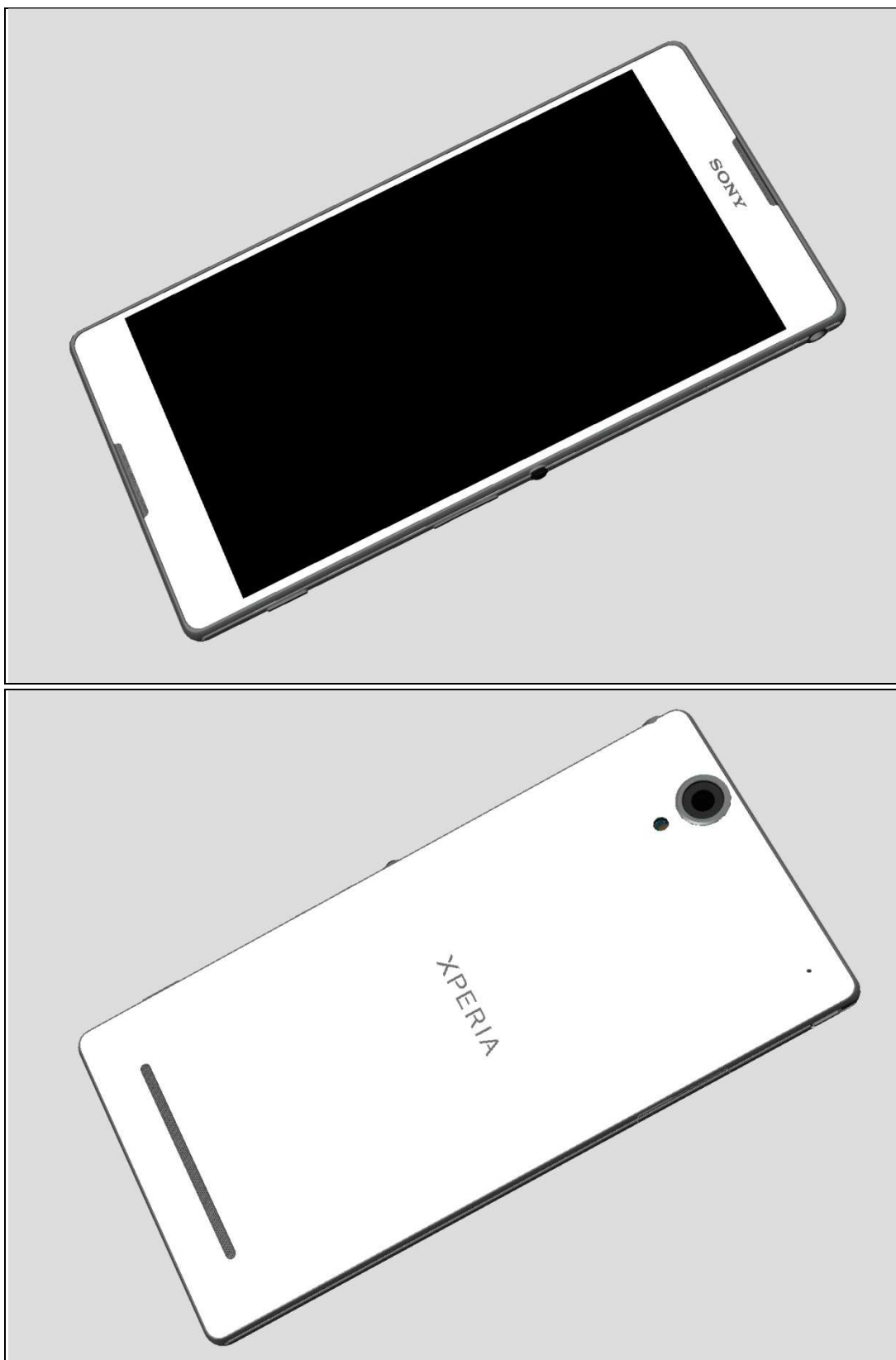
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**For general information about mechanical repair related issues, refer to
1220-1333: Generic Repair Manual - mechanical**

**Always firstly disconnect the Battery FPC BtB connector to cut off power supply when the
Antenna NFC Assy is disassembled.
Always finally connect the Battery FPC BtB connector before the Antenna NFC Assy is
reassembled.**

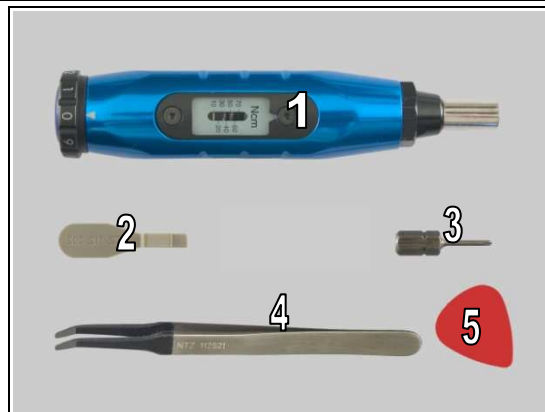
1 Exterior Views

1.1 D5322, XM50h, D5303, D5306, XM50t



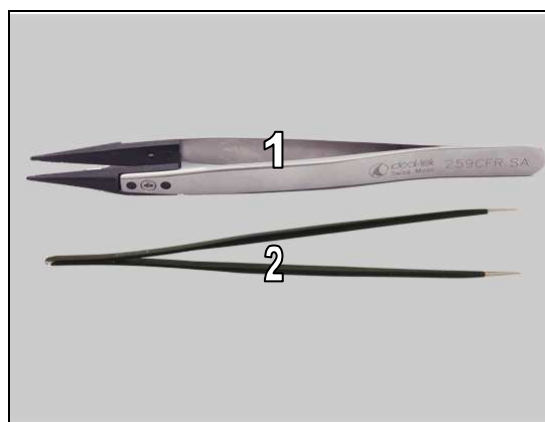
2 Tools

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



STANDARD TOOLS

1. Plastic Tweezers
2. Pointed-tip Tweezers



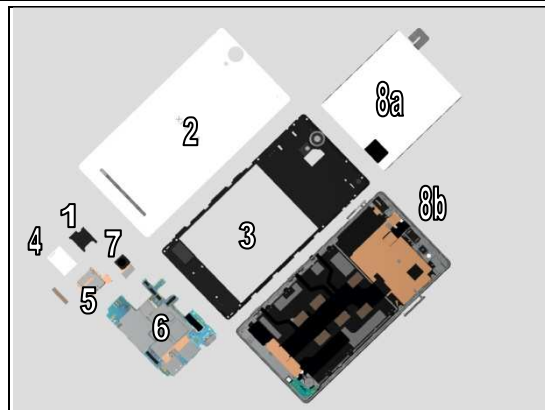
6. Suction cup



3 Disassembly

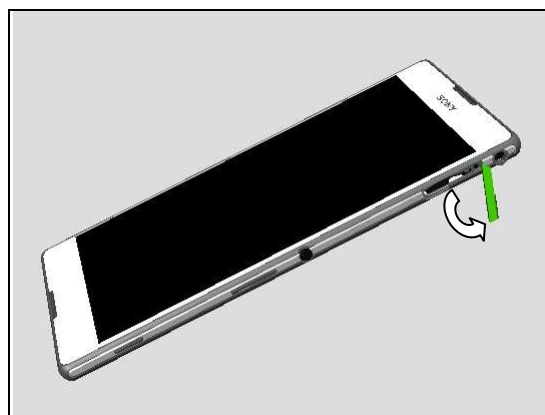
The disassembly is done in the following order:

1. SIM Tray
2. Battery Cover Assy
3. Rear Cover Assy
4. Label Tray
5. FPC SIM
6. Main PBA
7. Main Camera
8. Battery (a) & Display Assy (b)



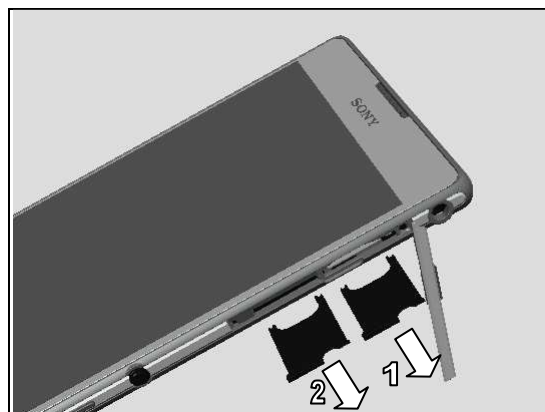
3.1 SIM Tray

Open the Cap SIM Single or Cap SIM Dual by fingers.



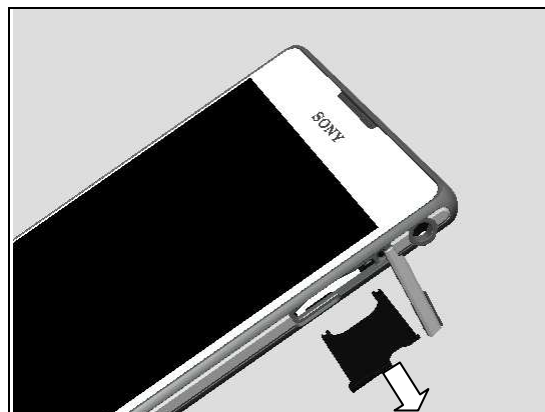
(For D5322, XM50h)

Remove two SIM Trays.



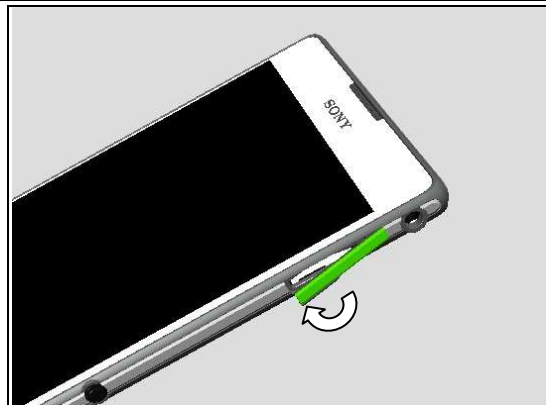
(For D5303, D5306, XM50t)

Remove SIM Tray.



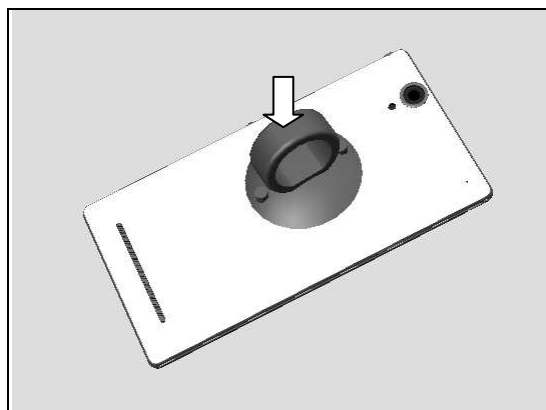
Disassembly

Close the Cap SIM Dual or Cap SIM Single.

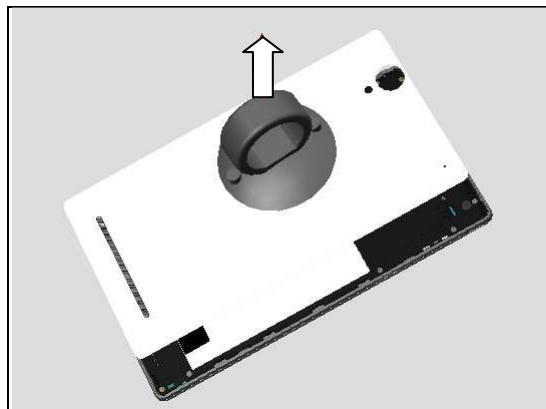


3.2 Battery Cover Assy

Attach the Suction Cup on the Battery Cover Assy as shown in picture.

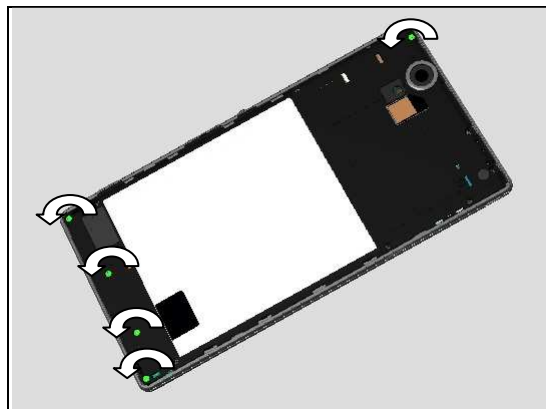


Pull upwards to release the hooks of Battery Cover Assy and remove the Battery Cover Assy.



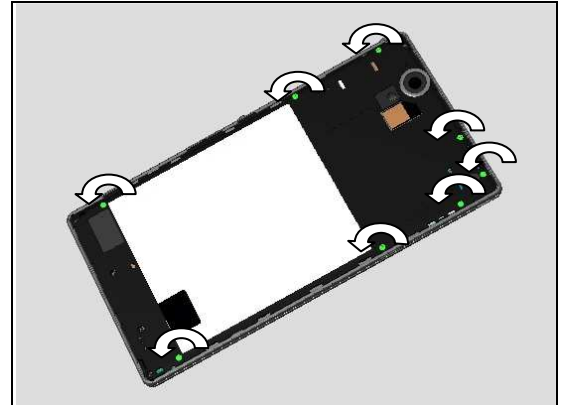
3.3 Rear Cover Assy

Remove the five Screws 1.4X3.5 (1262-1965) by using a screwdriver with Bits (JCIS No 0).



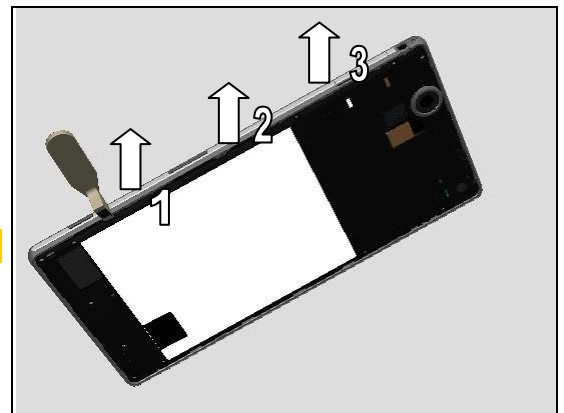
Disassembly

Remove the eight Screw Other Len:0.0 Diam:0.0 (1277-7492) by using a screwdriver with Bits (JCIS No 0).



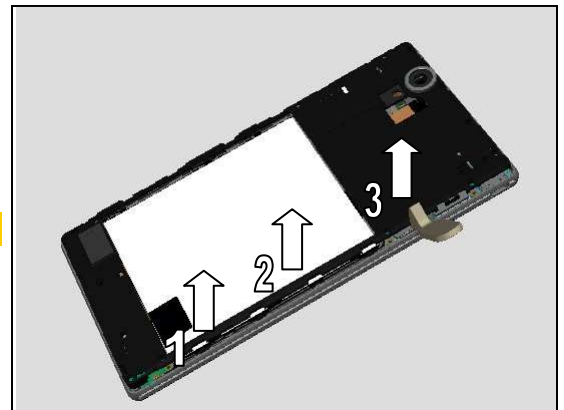
Insert the Front Opening Tool and pull upwards to release the left side following the sequence shown in picture.

Do not touch the battery!

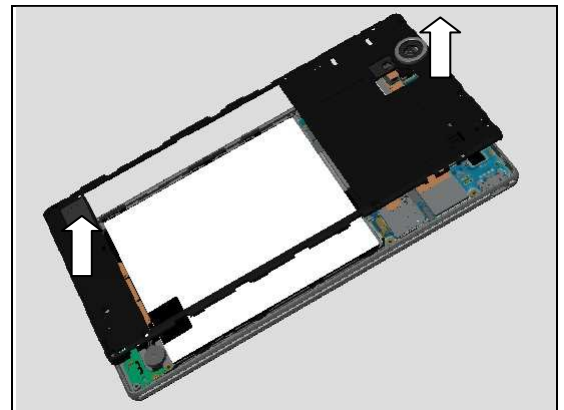


Do the same on the opposite side.

Do not touch the battery!

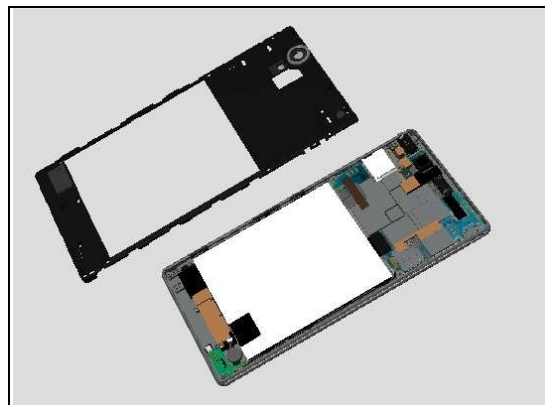


Lift gently to release the top and bottom side of Rear Cover Assy by fingers.



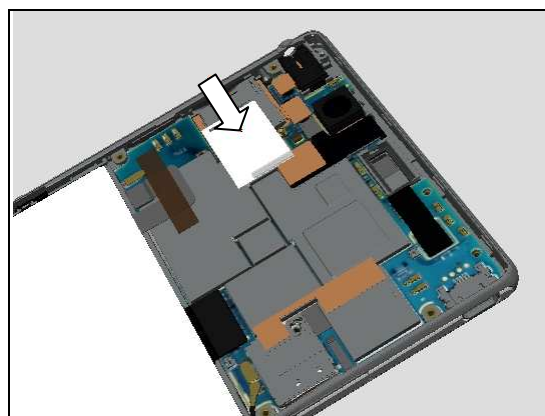
Disassembly

Remove the Rear Cover Assy.



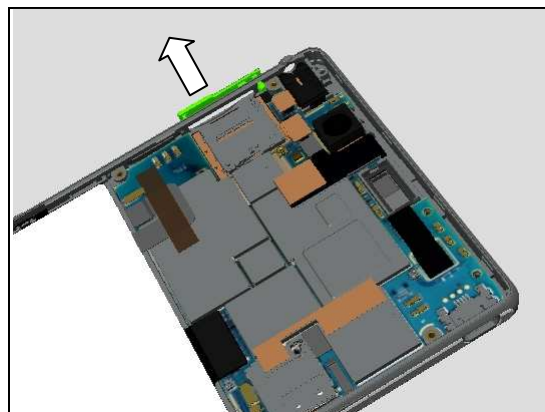
3.4 Label Tray

Remove the Label Tray as shown.



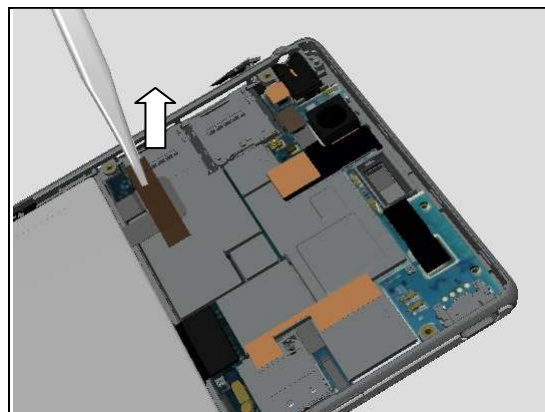
3.5 FPC SIM (Dual & Single)

Open the Cap SIM Dual or Cap SIM Single.



(Only for D5322 and XM50h.
Skip this step for D5303, D5306, XM50t)

Detach to remove the Adhesive Battery FPC by using the
Flex Film Assembly Tool.

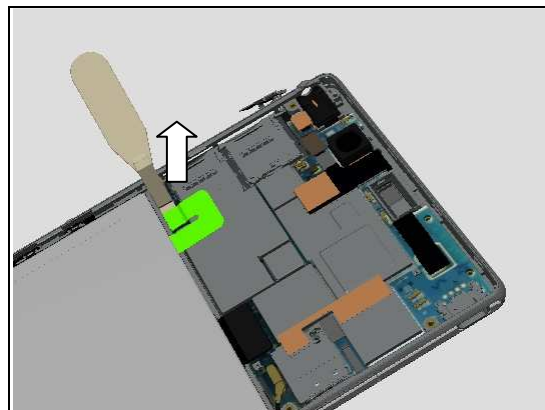


Disassembly

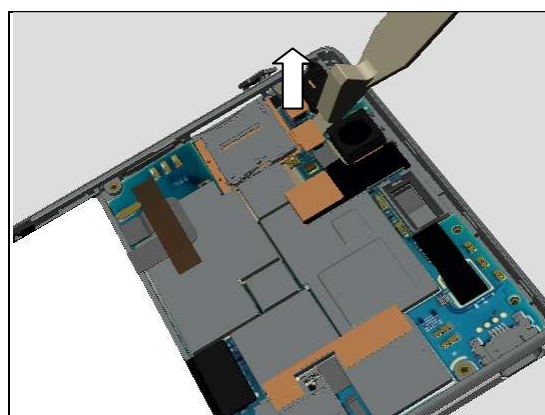
(Only for D5322 and XM50h.

Skip this step for D5303, D5306, XM50t)

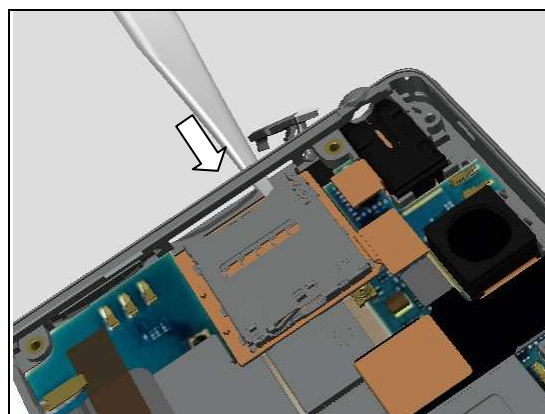
Disconnect BtB connector of Battery with the Front Opening Tool.



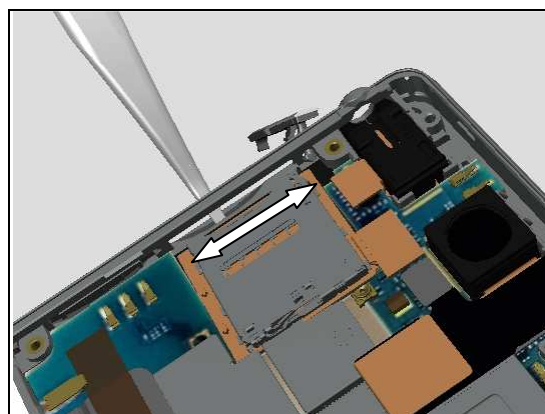
Disconnect the BtB connector of FPC SIM Single or FPC SIM Dual.



Insert the Flex Film Assembly Tool underneath the FPC SIM Single or FPC SIM Dual from SIM hole as shown **in picture**.



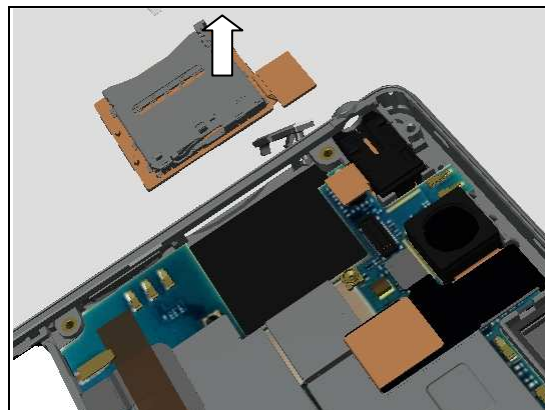
Slide along to detach the FPC SIM Single or FPC SIM Dual and pull upwards to release it.



Disassembly

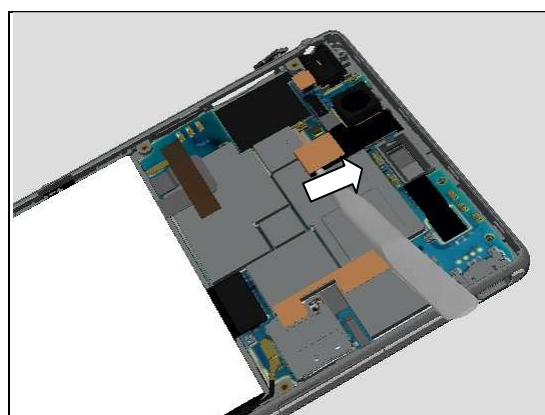
Remove FPC SIM Dual or FPC SIM Single.

Do not reuse!

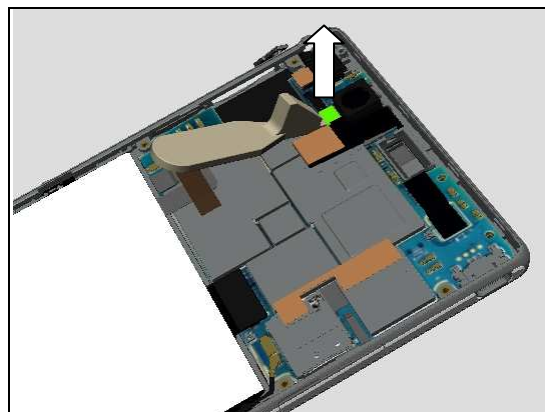


3.6 Main PBA

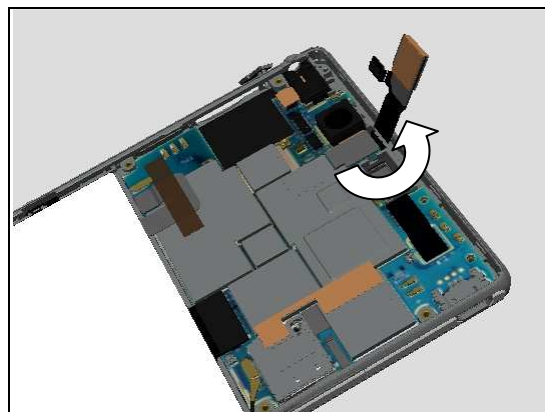
Insert the Flex Film Assembly Tool underneath the FPC Touch Panel and slide to release it from adhesive as shown.



Unsnap the BtB connector with Front Opening Tool.

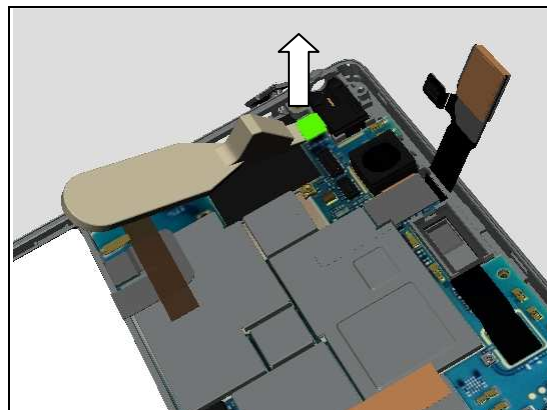


Turn the FPC over as shown.



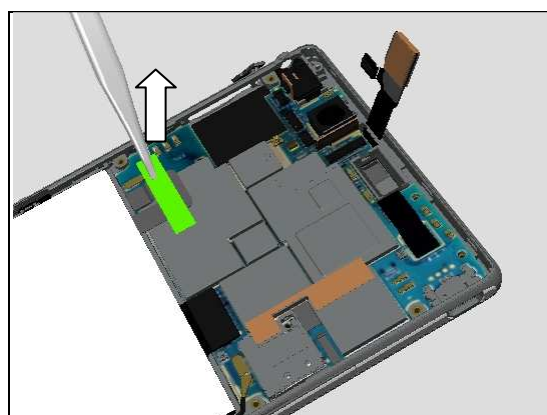
Disassembly

Disconnect BtB connector of FPC Audio Jack.



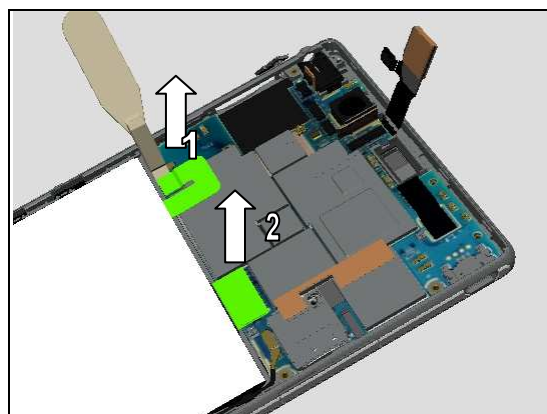
(Only for D5303, D5306, XM50t)
Skip this step for D5322 and XM50h)

Detach to remove the Adhesive Battery FPC by using the Flex Film Assembly Tool.

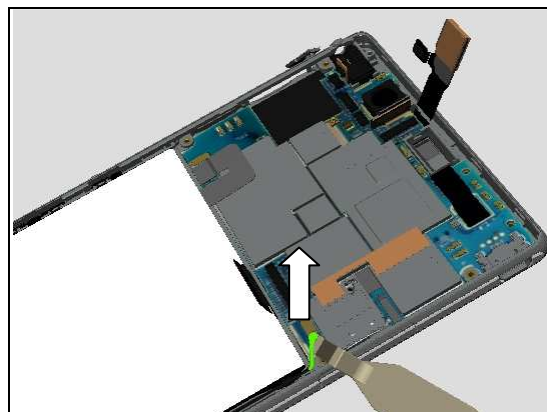


(Only for D5303, D5306, XM50t)
Skip this step for D5322 and XM50h)

Disconnect BtB connectors **following the** sequence shown in the picture.

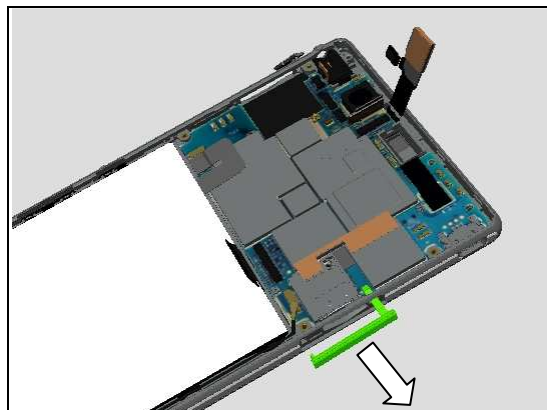


Disconnect the coax connector by using the Front Opening Tool.

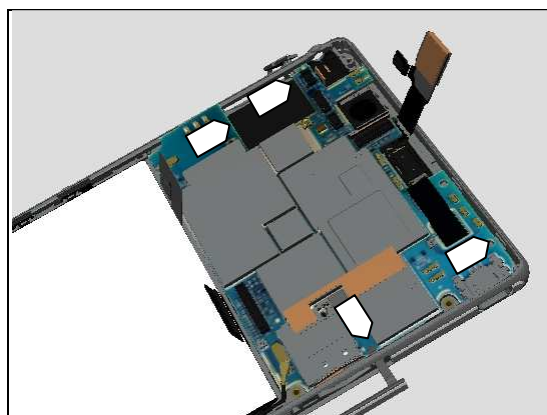


Disassembly

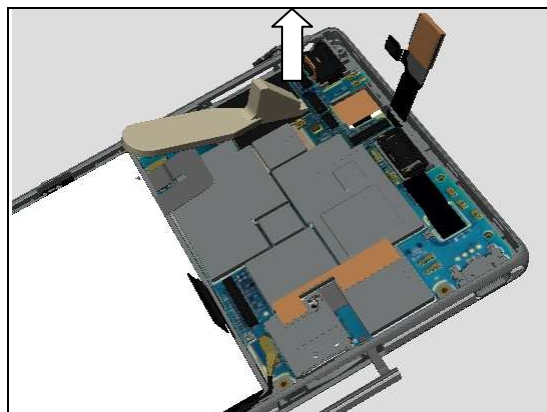
Open the Cap SD by fingers.



There are 4 snap hooks secure the Main PBA as shown in picture.

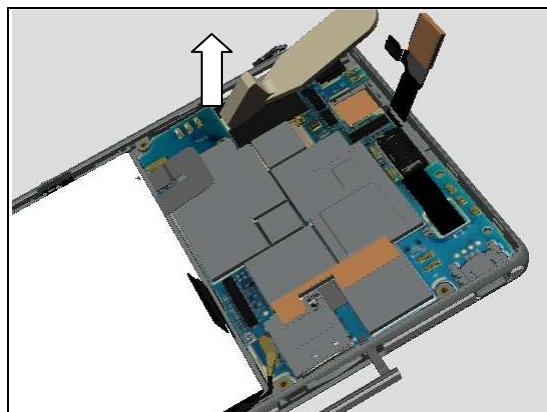


Insert the Front Opening Tool at position shown in picture, tilt to release the hook of Main PBA.



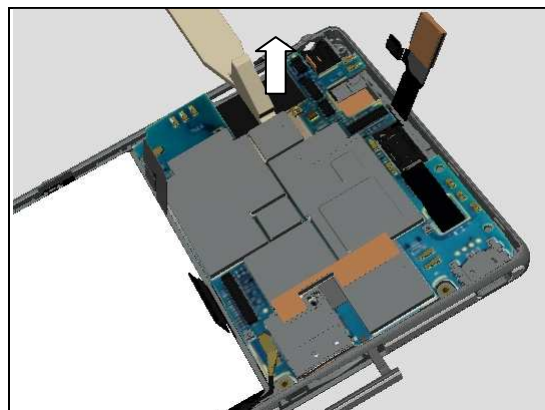
**(Only for D5303, D5306, XM50t
Skip this step for D5322 and XM50h)**

Do the same on another side as shown.



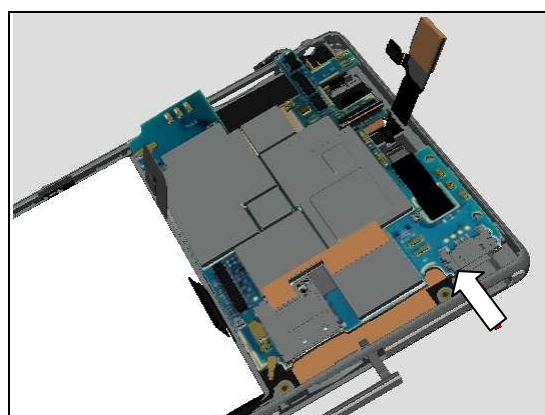
Disassembly

Insert the Front Opening Tool and tilt, this action will simultaneously raise the Main PBA.

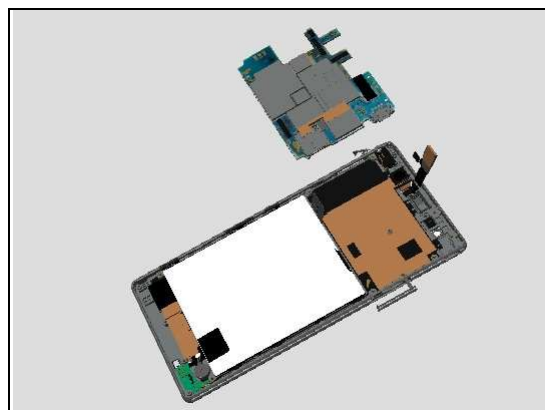


Remove the Main PBA from this side

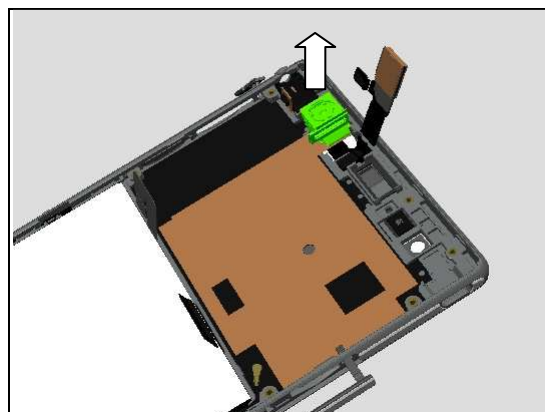
Make Sure the USB connector is protected!



Separate the Main PBA.



Remove the Main Camera.



Disassembly

3.7 Battery and Display Assy

Place the Front Cover Assy in a sealed ESD bag before placing it in the freezer, set to -20C, for 30 min.

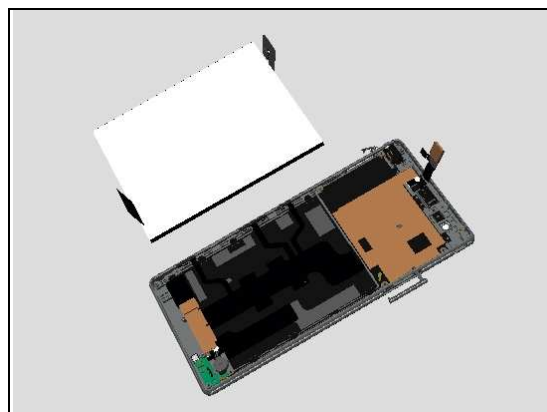
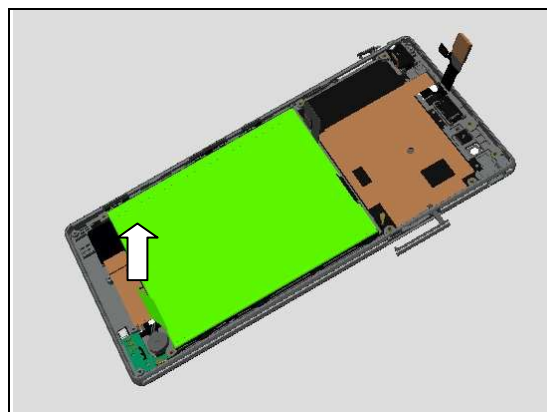
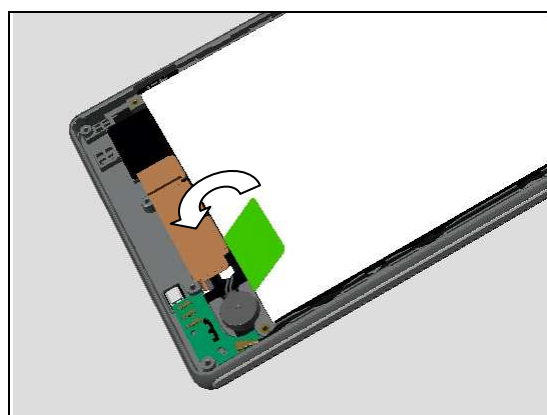
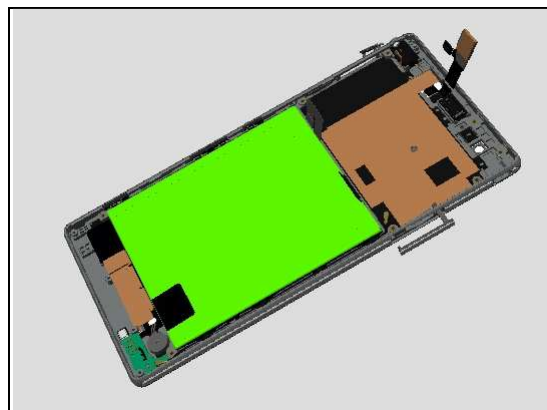
Turn the battery handle vertically.

Lift the handle to release the Battery from its adhesive underneath.

The removal action must be done immediately after freeze!

Separate the Battery.

Do not reuse!



4 Replacement

4.1 Battery Cover Assy

Follow the 3.2 Disassembly instructions!

Prepare a new Battery Cover Assy.

Follow the 5.6 Reassembly instructions!



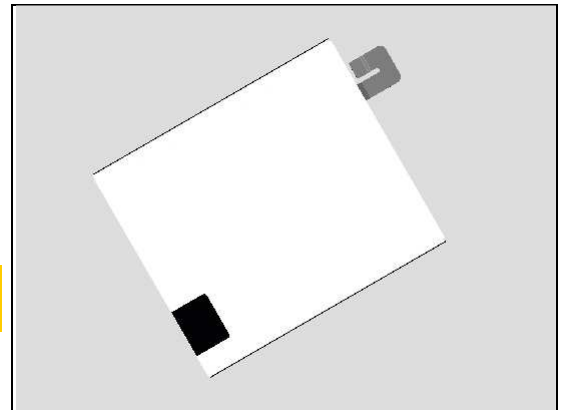
4.2 Battery

Follow the 3.1 – 3.3 & 3.7 Disassembly instructions!

Prepare the new Battery.

Follow the 5.1 & 5.5 – 5.7 Reassembly instructions!

Please refer to: Trouble Shooting Application 1257-2706 for applicable D53 calibrations!

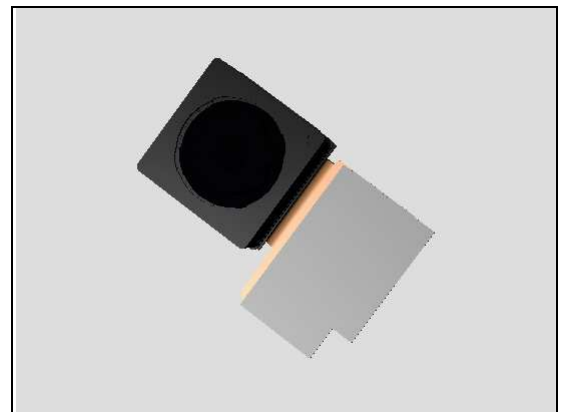


4.3 Camera 13 MPixel CMOS

Follow the 3.1 – 3.3, 3.6 Camera Removal part of Disassembly instructions!

Prepare the new Camera 13 MPixel CMOS.

Follow the 5.2 Camera Installation part, 5.5 – 5.7 Reassembly instructions!

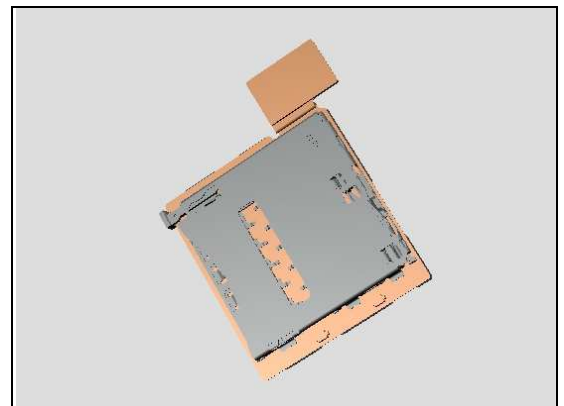


4.4 FPC SIM Dual/ FPC SIM Single

Follow the 3.1 – 3.5. Disassembly instructions!

Prepare the new FPC SIM **Dual or FPC SIM Single.**

Follow the 5.3 – 5.7 Reassembly instructions!



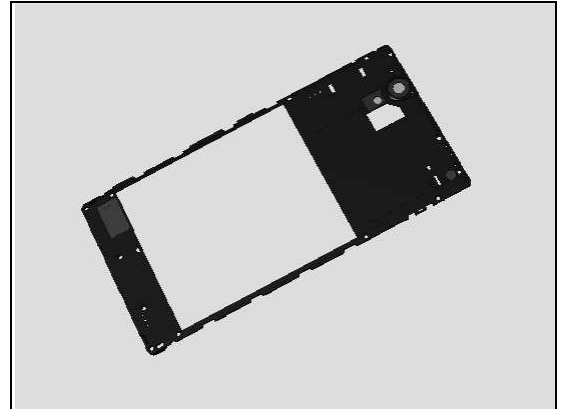
Replacement

4.5 Rear Cover Assy

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Rear Cover Assy.

Follow the 5.5 – 5.7 Reassembly instructions!

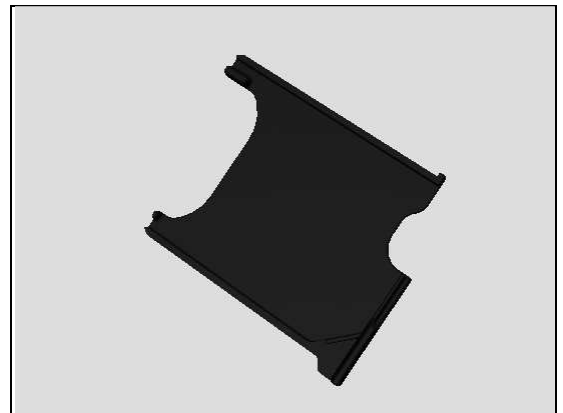


4.6 SIM Tray

Follow the 3.1 Disassembly instructions!

Prepare the new SIM Tray.

Follow the 5.7 Reassembly instructions!



Replacement

4.7 Adhesive Audio Jack & FPC Audio Jack

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Adhesive Audio Jack & FPC Audio Jack

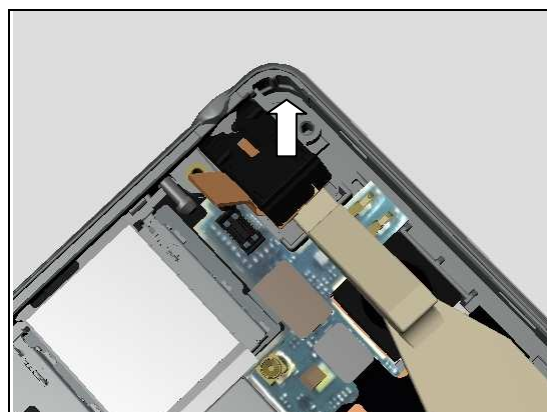
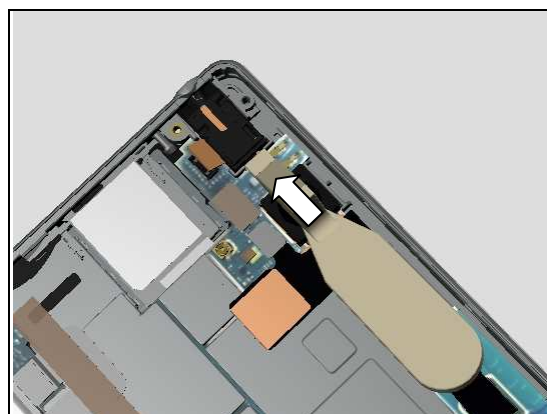
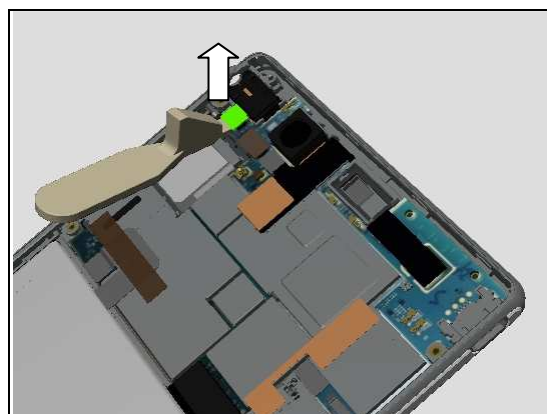
Follow the 5.5 – 5.7 Reassembly instructions!

REMOVAL

Disconnect the BtB connector by using the Front Opening Tool as shown.

Insert the Front Opening Tool underneath the FPC Audio Jack from the angle as shown.

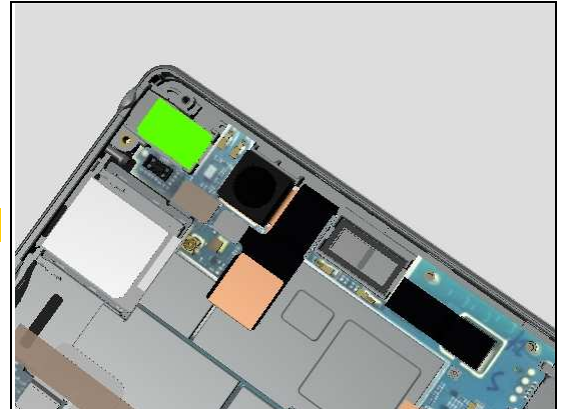
Pull upwards to release the FPC Audio Jack.



Replacement: Adhesive Audio Jack & FPC Audio Jack

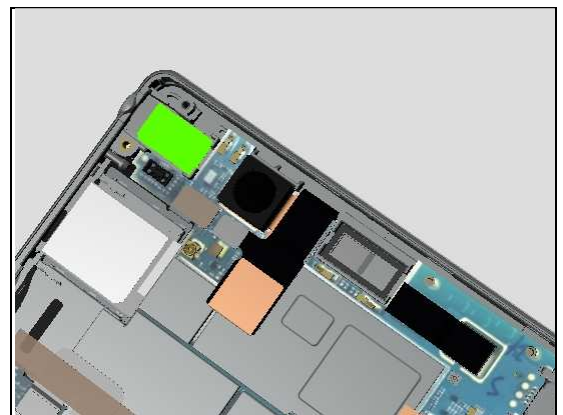
Remove the FPC Audio Jack.

Adhesive Audio Jack should be scrapped!

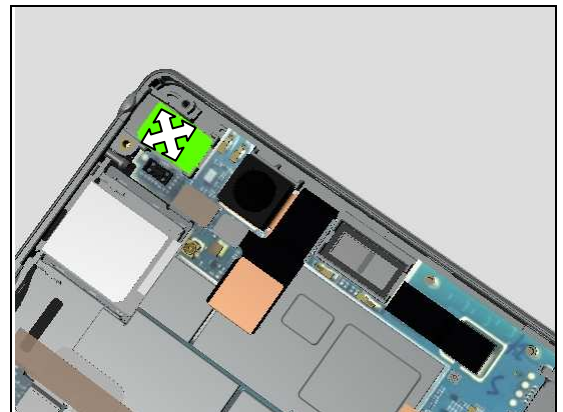


INSTALLATION

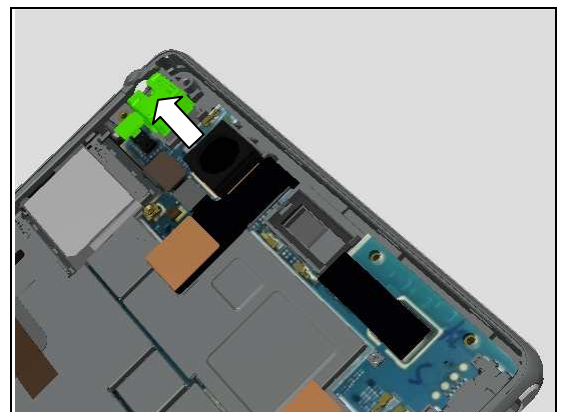
Prepare the new Adhesive Audio Jack in its proper position.



Attach the Adhesive Audio Jack into the cavity of Display Assy and press to secure its attachment.

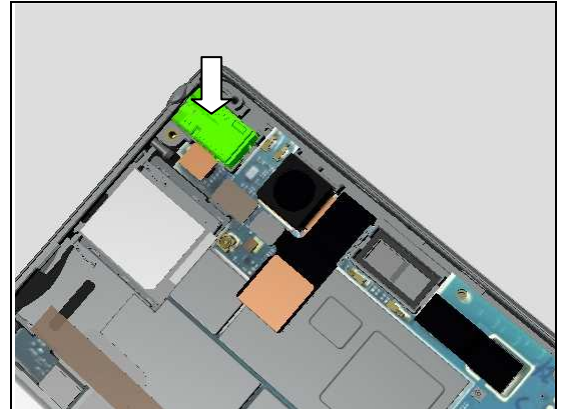


Insert the head of FPC Audio Jack into the Audio Jack hole.

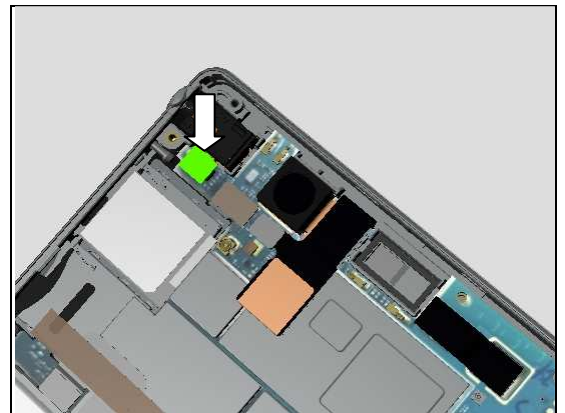


Replacement: Adhesive Audio Jack & FPC Audio Jack

Press to make it securely attached.



Connect the BtB connector by fingers.



Replacement

4.8 Adhesive Battery FPC

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Adhesive Battery FPC.

Follow the 5.5 – 5.7 Reassembly instructions!

REMOVAL

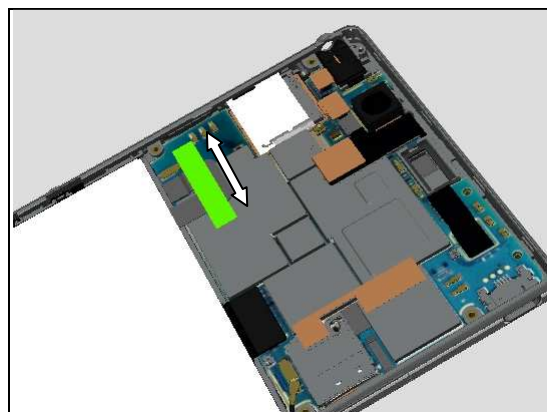
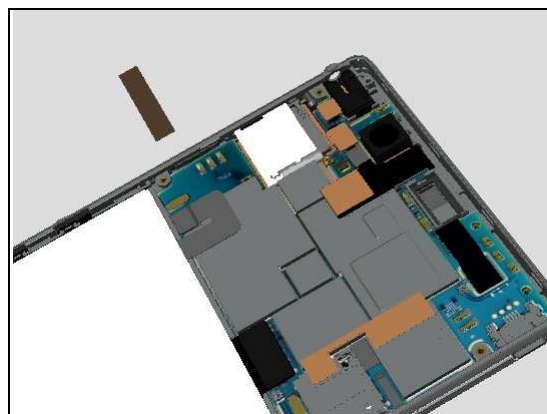
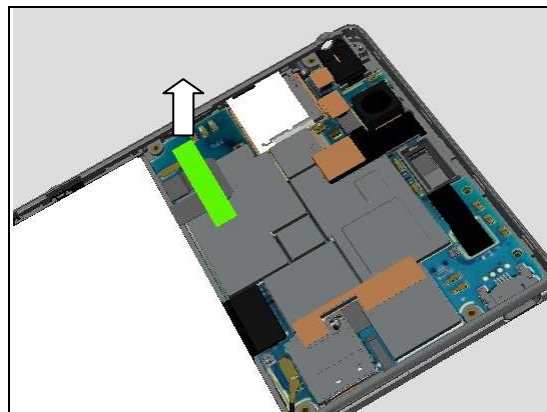
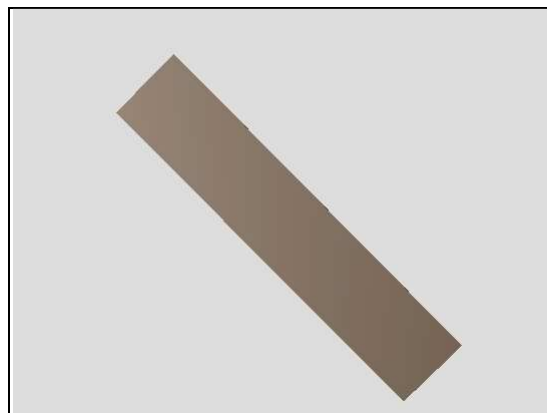
Detach to remove it gently from left side by using Flex Film Assembly Tool.

Do not reuse!

INSTALLATION

Place a new Adhesive Battery FPC and attach it onto Battery FPC.

Press along to make it attached firmly.



Replacement

4.9 Adhesive Relay FPC Single Side

Follow the 3.1 – 3.3 Disassembly instructions!
Prepare the new Adhesive Relay FPC Single Side.
Follow the 5.5 – 5.7 Reassembly instructions!

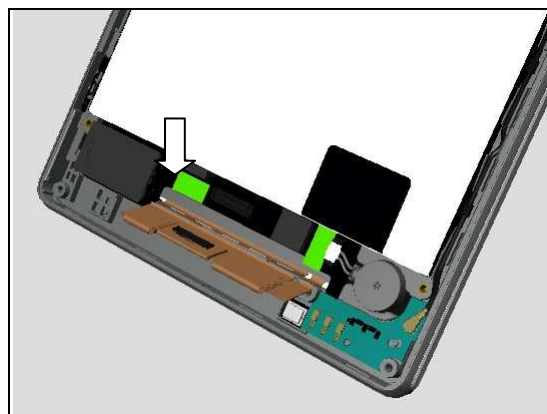
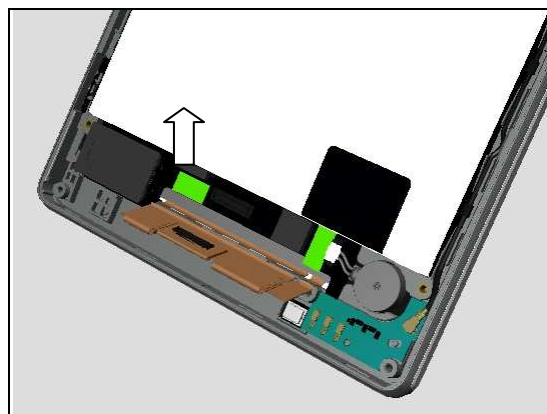
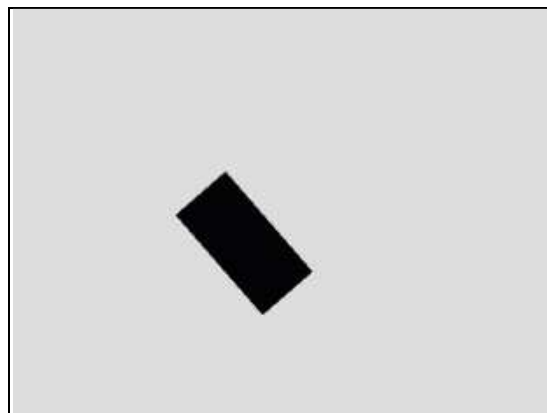
REMOVAL

Detach to remove each of them gently by using Flex Film Assembly Tool.

Do not reuse!

INSTALLATION

Place two pieces of new Adhesive Relay FPC Single Side and attach them onto the Relay FPC as shown.



Replacement

4.10 Adhesive Main Ant PBA & PBA Main Antenna

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Adhesive Main Ant PBA & PBA Main Antenna.

Follow the 5.5 – 5.7 Reassembly instructions!

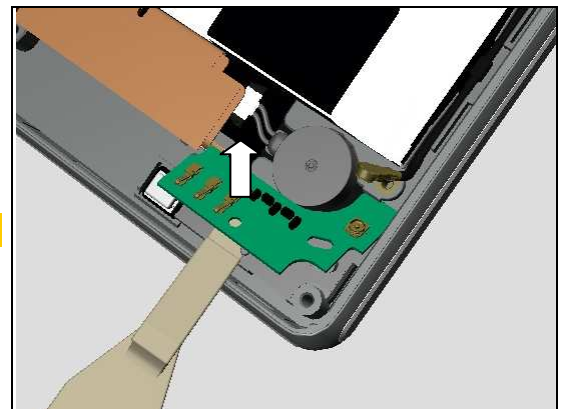
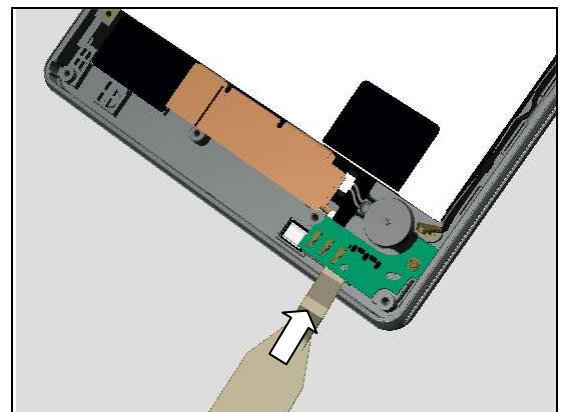
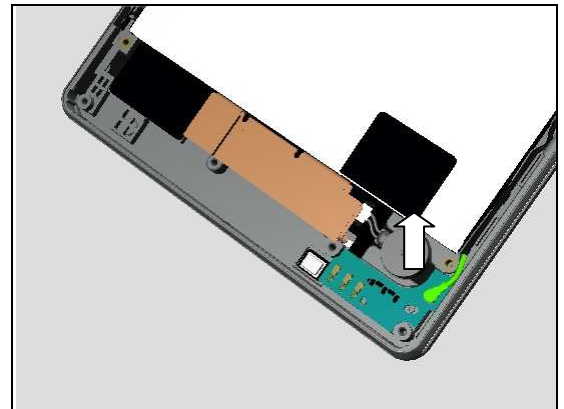
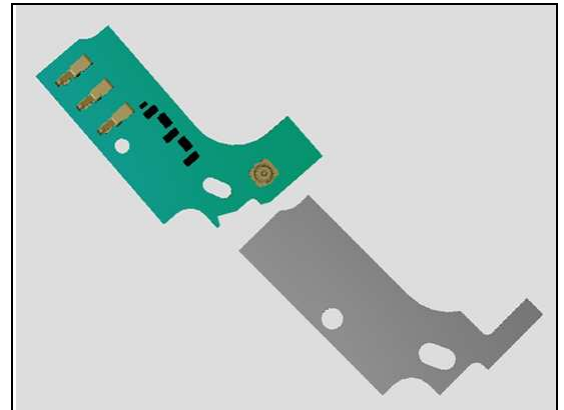
REMOVAL

Disconnect the coax connector of Cable antenna_cable from PBA Main Antenna.

Insert the Front Opening Tool as shown position.

Pull upwards to remove the PBA Main Antenna.

Adhesive Main Ant PBA should be scraped!



Replacement: Adhesive Main Ant PBA & PBA Main Antenna

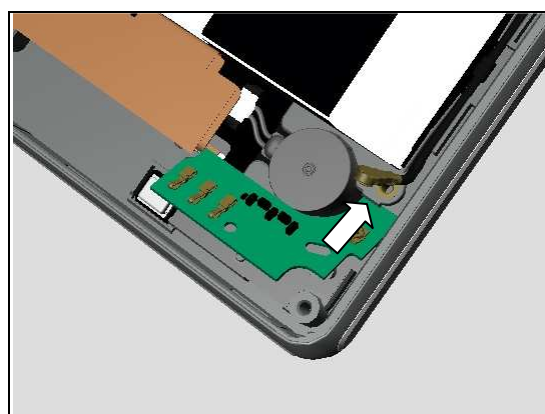
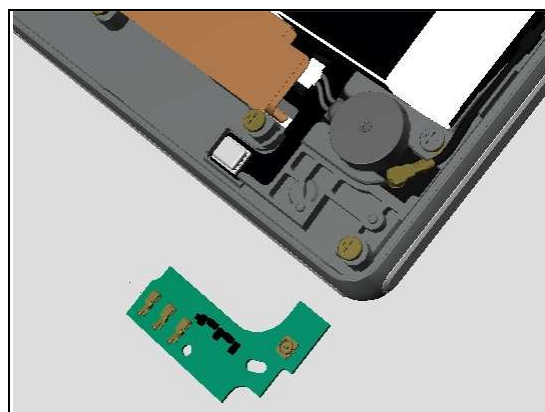
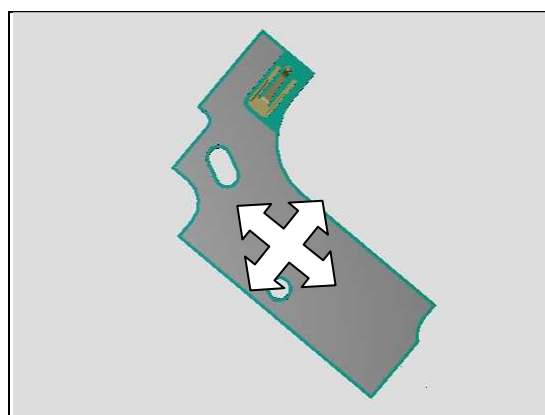
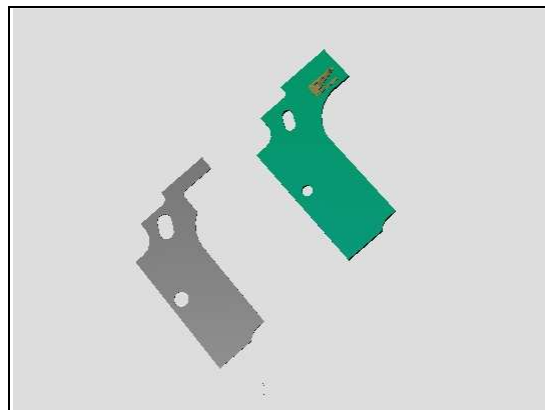
INSTALLATION

Prepare a new PBA Main Antenna and a new Adhesive Main Ant PBA in place.

Attach the Adhesive Main Ant PBA onto the back side of PBA Main Antenna according to its shape.

Prepare the PBA Main Antenna in place.

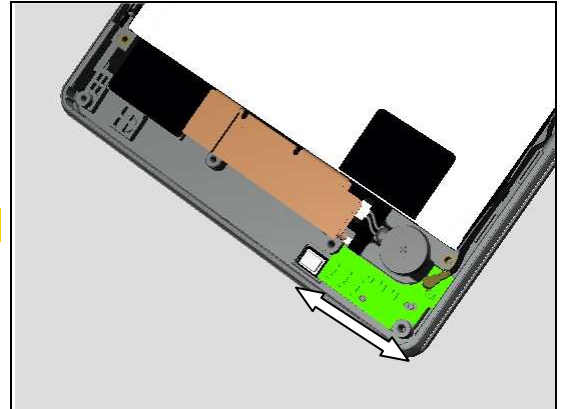
Insert the PBA Main Antenna by hook the top side firstly.



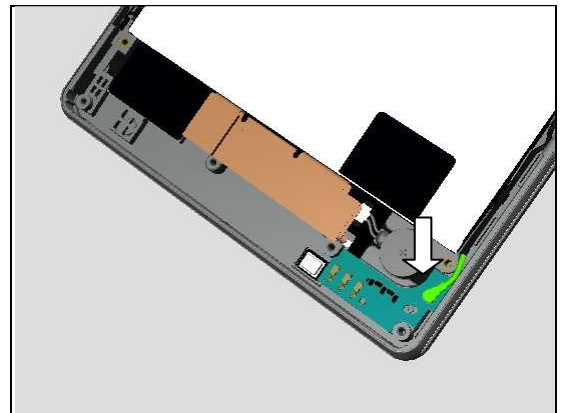
Replacement: Adhesive Main Ant PBA & PBA Main Antenna

Press along the PBA Main Antenna to snap it.

Do not touch the spring pins!



Connect the coax connector.



Replacement

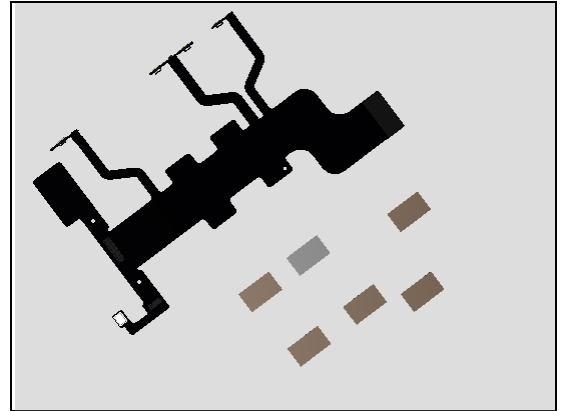
4.11 Adhesive Main FPC Single Side & FPC Relay

Follow the 3.1 – 3.3 & 3.7 Disassembly instructions!

Prepare the new Adhesive Main FPC Single Side & FPC Relay.

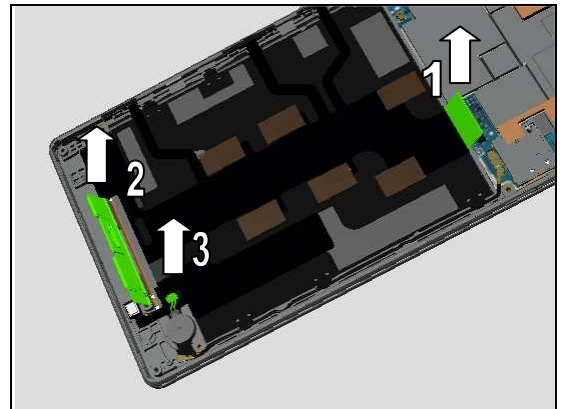
Follow the 4.9, 4.26, 4.27 Installation instructions!

Follow the 5.1 & 5.5 – 5.7 Reassembly instructions!

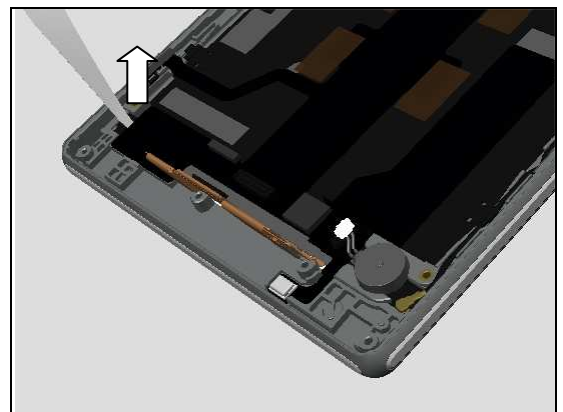


REMOVAL

Disconnect the two connectors of FPC Relay and Vibrator connector by using Front Opening Tool as shown.

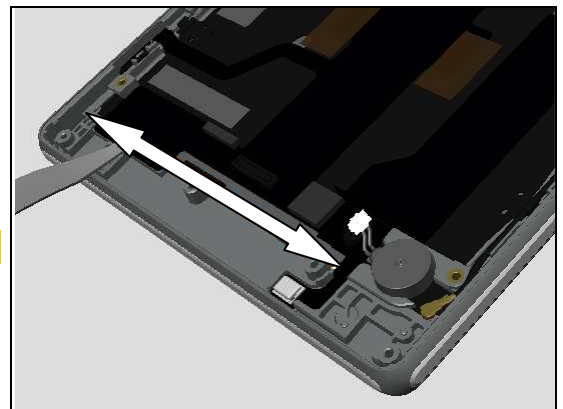


Insert the Flex Film Assembly Tool underneath the Loudspeaker Pad gently from corner as shown.



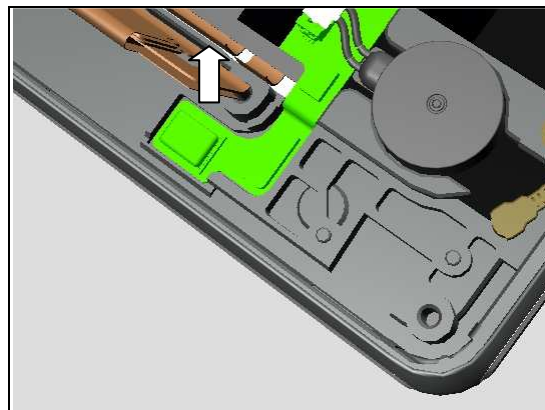
Slide along to release the bottom side of the FPC Relay gently.

Do not touch the contact pad of Loudspeaker!

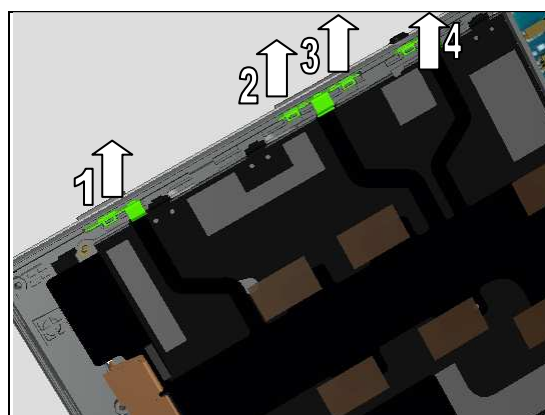


Replacement: Adhesive Main FPC Single Side & FPC Relay

Detach to release the Microphone area gently.

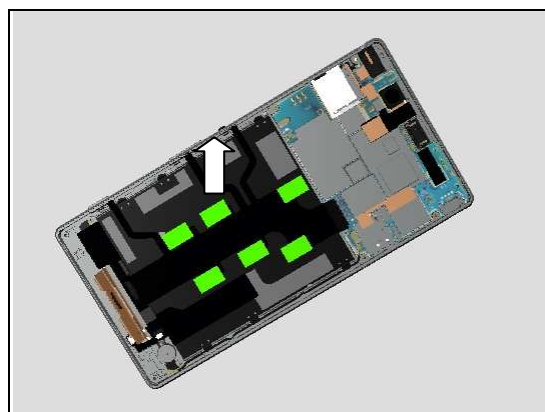


Unsnap the 4 hooks to release the side key FPCs following the sequence shown in picture.

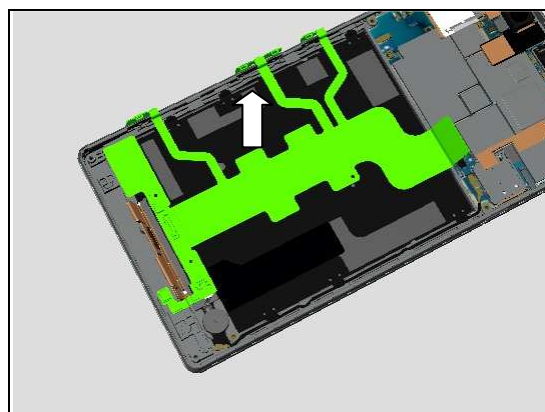


Detach to remove the Adhesive Main FPC Single Side by using Flex Film Assembly Tool.

Do not reuse!



Remove the FPC Relay.



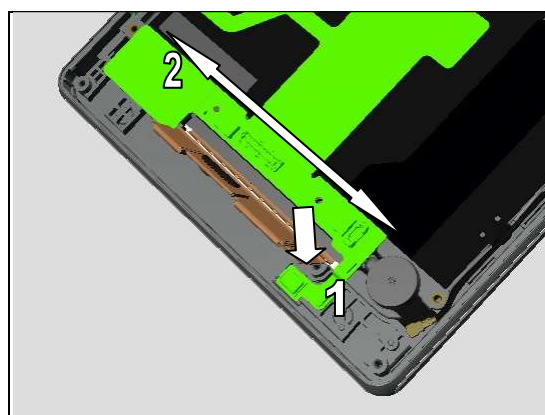
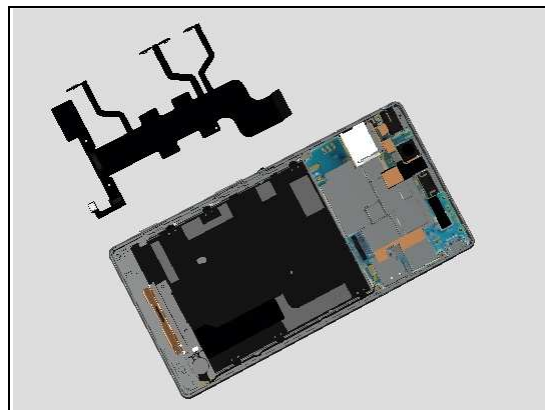
Replacement: Adhesive Main FPC Single Side & FPC Relay

INSTALLATION

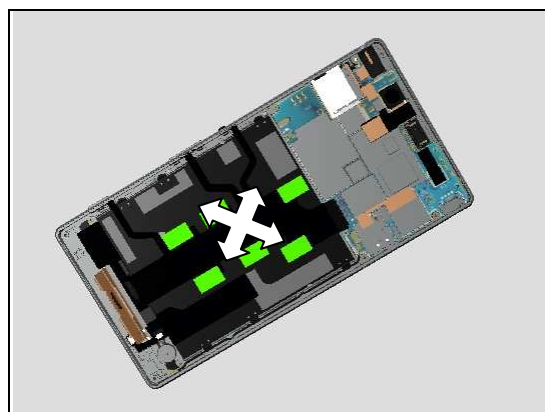
Prepare a new FPC Relay in place.

Attach the FPC Relay aligning to the guiding lines from the bottom side.

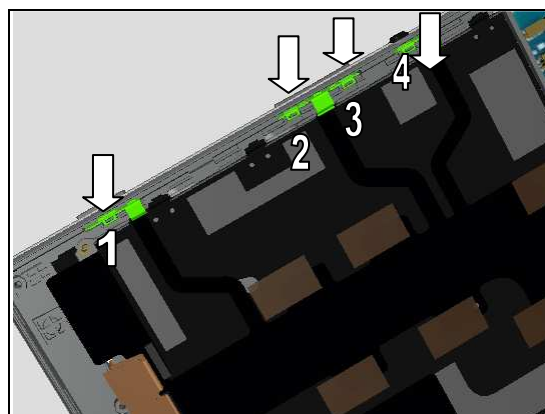
Make sure all the adhesive residue is removed before attachment!



Attach the new Adhesive Main FPC Single Side according to the guiding lines on the Display Assy.

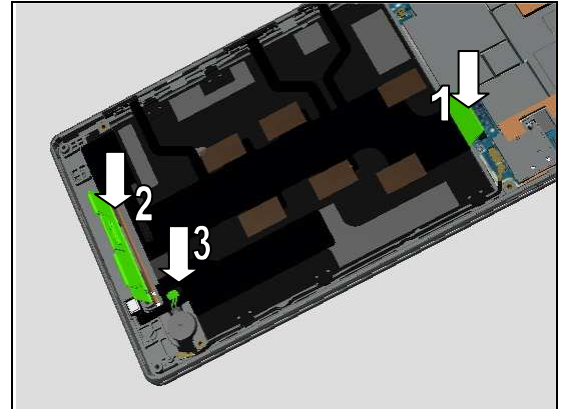


Press to snap the four hooks of side keys FPC with the Flex Film Assembly Tool as shown.



Replacement: Adhesive Main FPC Single Side & FPC Relay

Reconnect the two connectors of FPC Relay and Vibrator connector with fingers.



Replacement

4.12 Adhesive Sub Ant PBA & PBA 2nd Main Antenna XM50t (Only for XM50t)

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Adhesive Sub Ant PBA & PBA 2nd Main Antenna.

Follow the 5.5 – 5.7 Reassembly instructions!

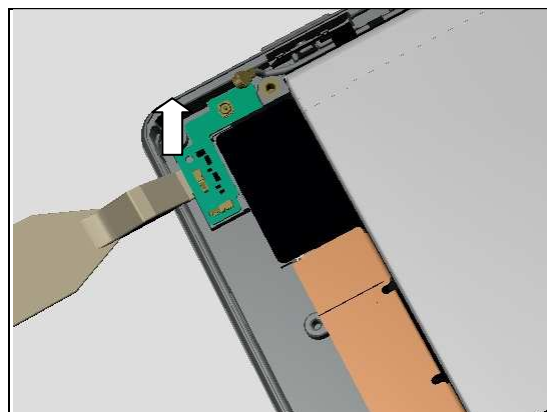
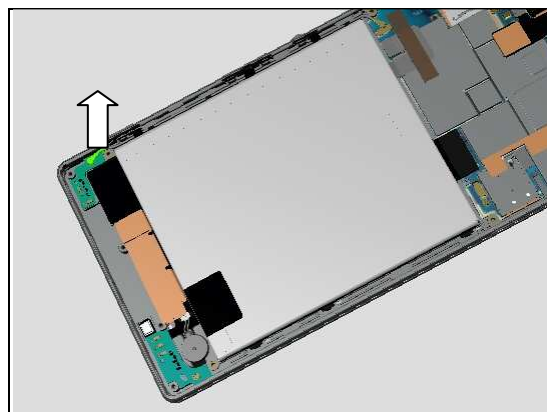
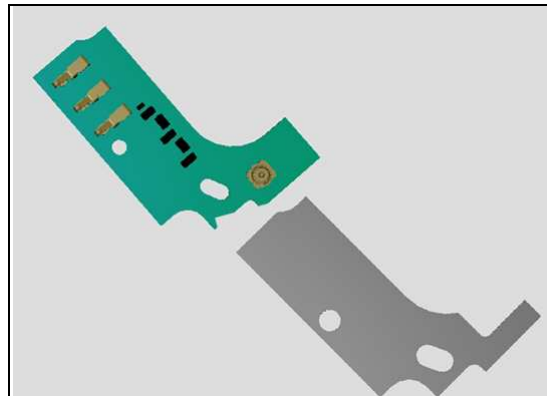
REMOVAL

Disconnect the coax connector of Cable antenna_cable from PBA 2nd Main Antenna.

Insert the Front Opening Tool as shown position.

Pull upwards to remove the PBA 2nd Main Antenna.

Adhesive Sub Ant PBA should be scraped!



Replacement: Adhesive Main Ant PBA & PBA Main Antenna

INSTALLATION

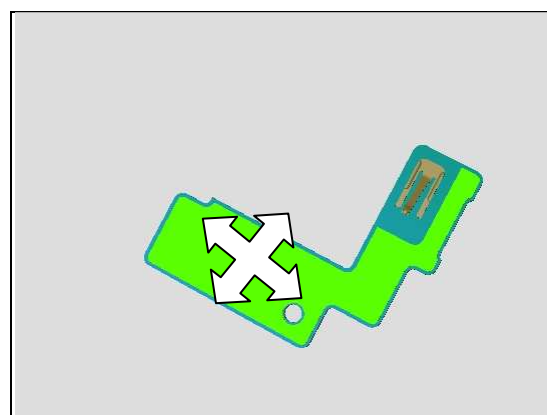
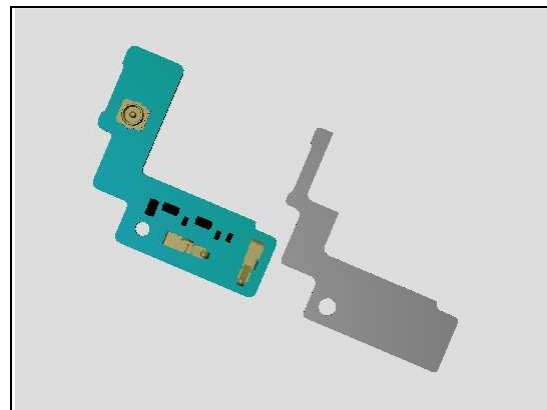
Prepare a new Adhesive Sub Ant PBA and a new PBA 2nd Main Antenna in place.

Attach the Adhesive Sub Ant PBA onto the back side of PBA 2nd Main Antenna according to its shape.

Insert the PBA 2nd Main Antenna by hook the top side firstly.

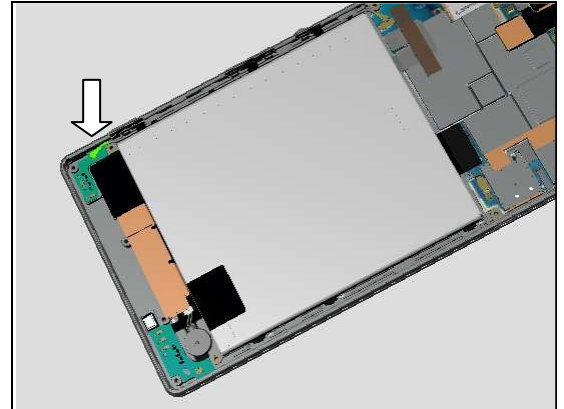
Press along the PBA 2nd Main Antenna to snap it.

Do not touch the spring pins!



Replacement: Adhesive Main Ant PBA & PBA Main Antenna

Connect the coax connector.



Replacement

4.13 Adhesive Vibrator & Vibrator

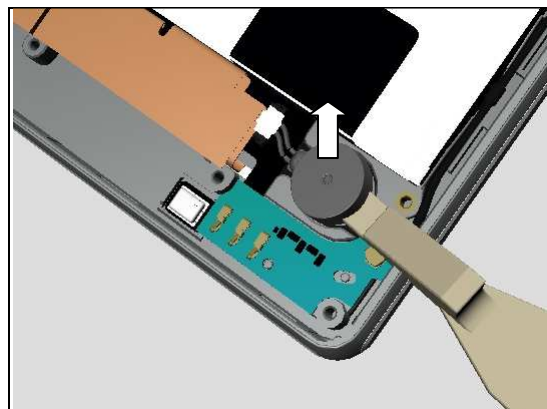
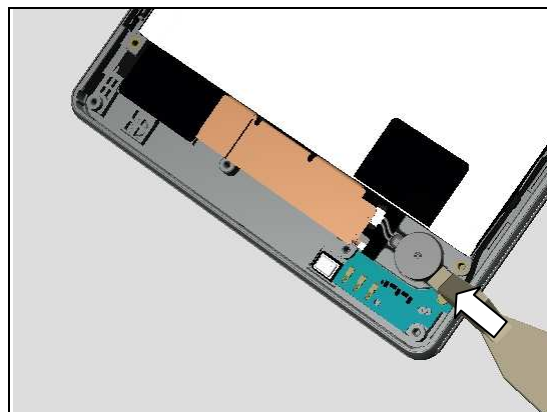
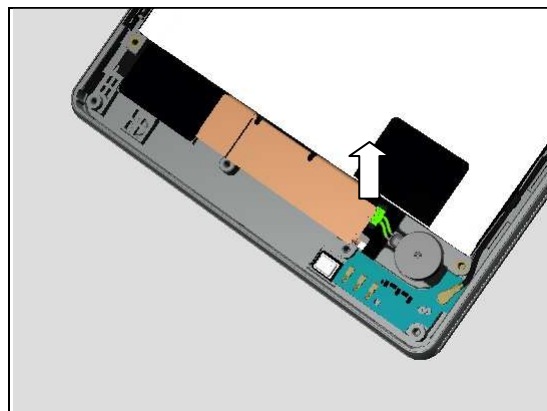
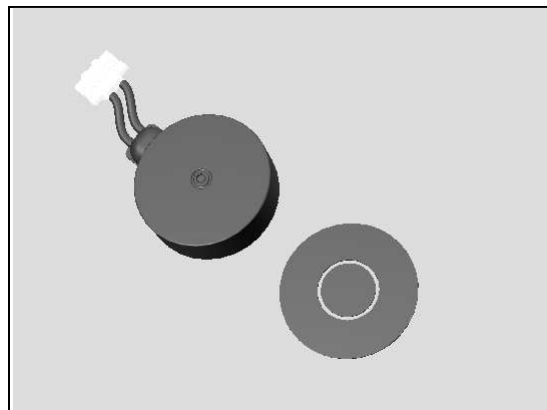
Follow the 3.1– 3.3 Disassembly instructions!
Prepare the new Adhesive Vibrator & Vibrator.
Follow the 5.5 – 5.7 Reassembly instructions!

REMOVAL

Disconnect the connector by using the Flex Film Assembly Tool as shown.

Insert the Front Opening Tool underneath the Vibrator from the angle as shown.

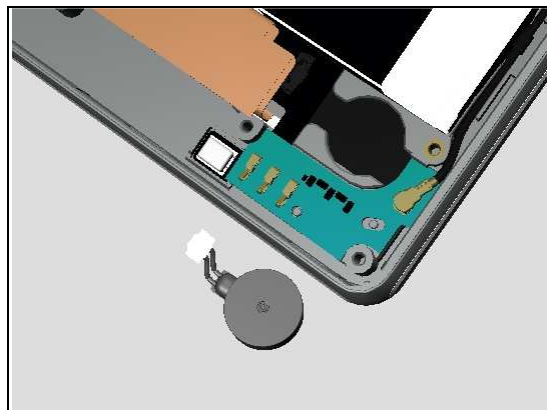
Pull upwards to release the Vibrator.



Replacement: Adhesive Vibrator & Vibrator

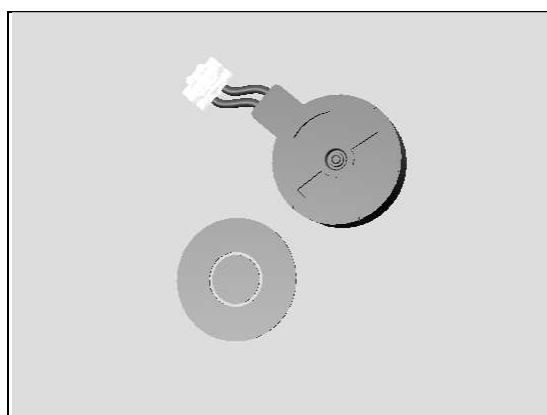
Remove the Vibrator.

Adhesive Vibrator should be scrapped!



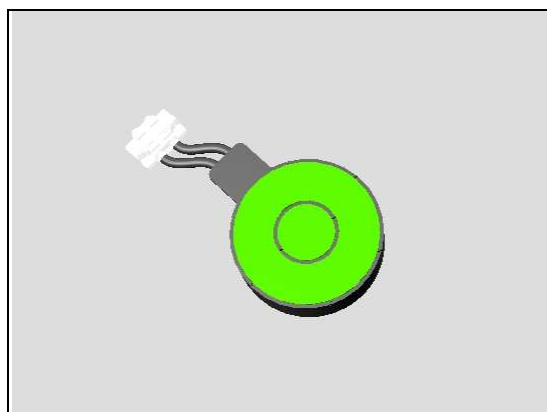
INSTALLATION

Prepare a new Adhesive Vibrator and a new Vibrator.

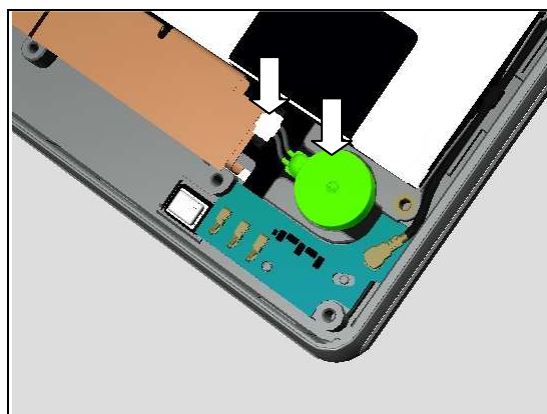


Attach the new Adhesive Vibrator on the bottom side of Vibrator as shown in picture.

Align Adhesive Vibrator by using shape of Vibrator!



1. Insert the Vibrator into the Cavity and press to make it securely attached.
2. Connect the Vibrator by pressing its connector from the top into the FPC Relay connector.



Replacement

4.14 Bracket Assy Block 2nd SIM (D5303, D5306, XM50t)

Follow the 3.1 – 3.6 Disassembly instructions!

Follow the 4.15 Removal instructions!

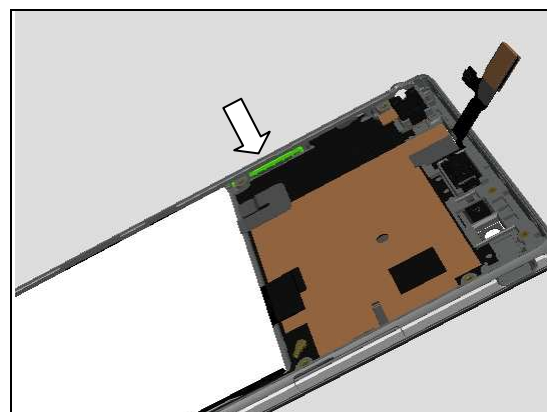
Prepare the new Bracket Assy Block 2nd SIM.

Follow the 4.15 Installation instructions!

Follow the 5.2 – 5.7 Reassembly instructions!

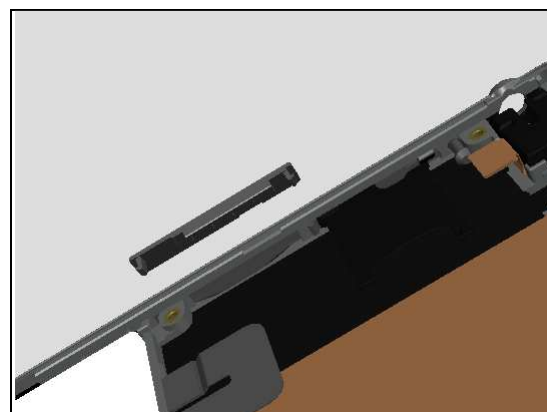
REMOVAL

Push from outside to remove it by tweezers as shown.

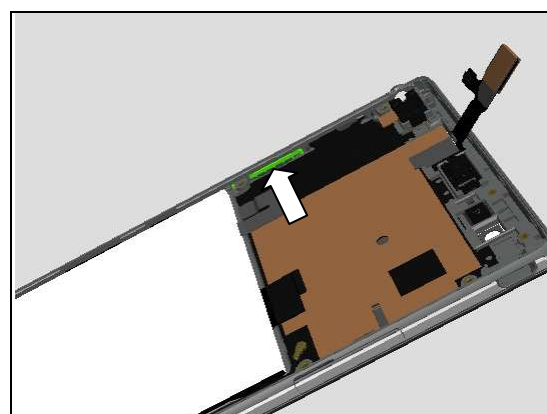


INSTALLATION

Prepare a new Bracket Assy Block 2nd SIM in place.



Insert it into the cavity and press a long to secure its position.



Replacement

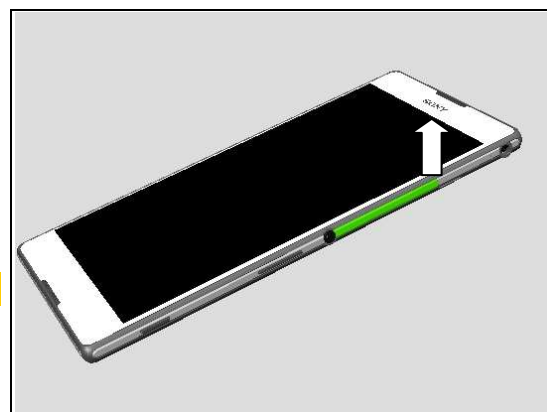
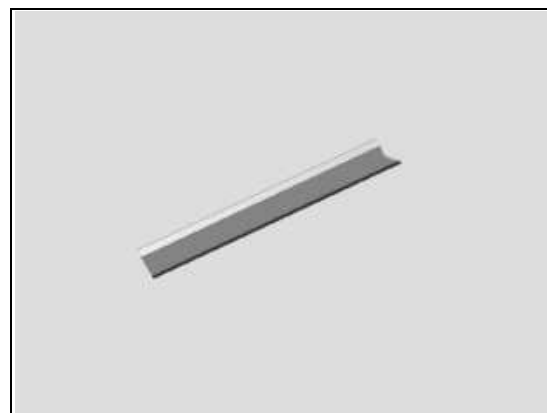
4.15 Bracket Assy Panel Right

Prepare the new Bracket Assy Panel Right.

REMOVAL

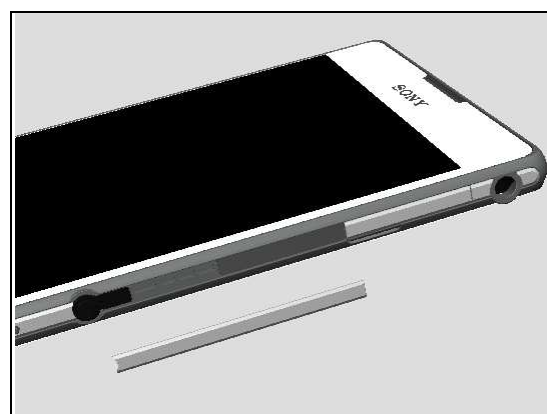
Detach to remove the Bracket Assy Panel Right with the Flex Film Assembly Tool.

Be careful not to scratch the Display Assy Frame!

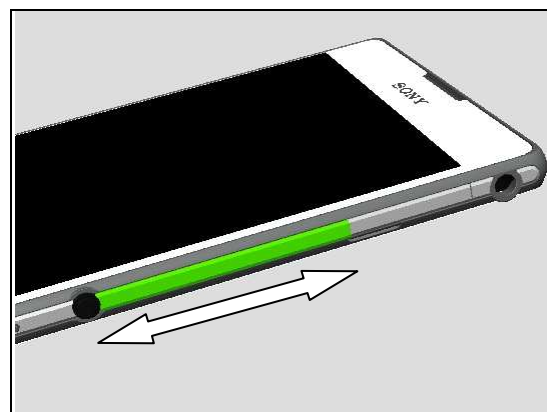


INSTALLATION

Place a new Bracket Assy Panel Right aligning to the cavity of Display Assy as shown.



Press along the side for 5 seconds to make it securely attached as shown in picture.



Replacement

4.16 Cable antenna_cable

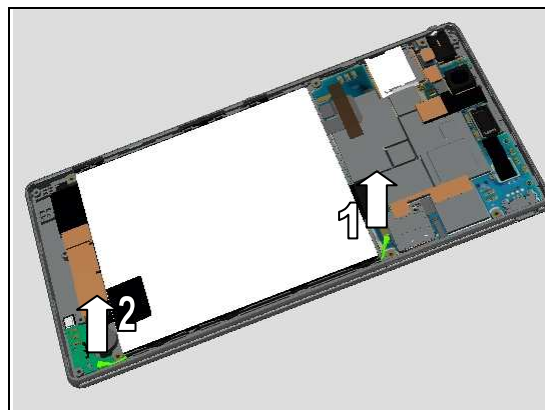
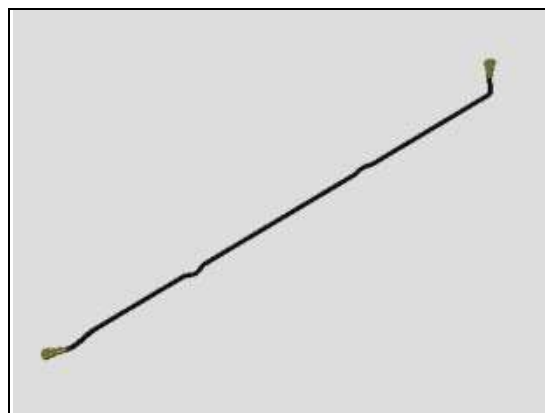
Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Cable antenna_cable.

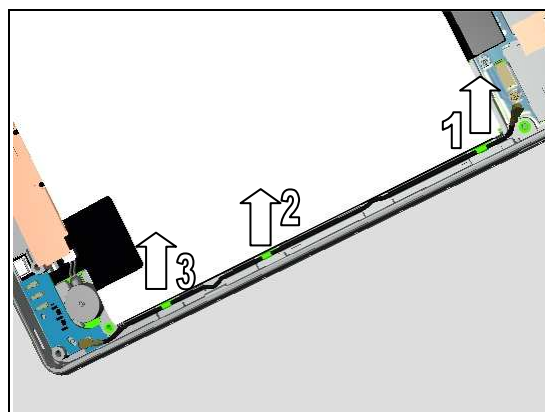
Follow the 5.5 – 5.7 Reassembly instructions!

REMOVAL

Disconnect both RF cable connectors as shown in picture.

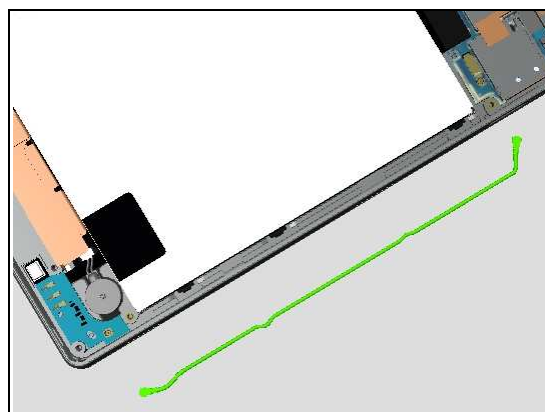


Pull it out from its three clips gently with fingers as shown in picture.



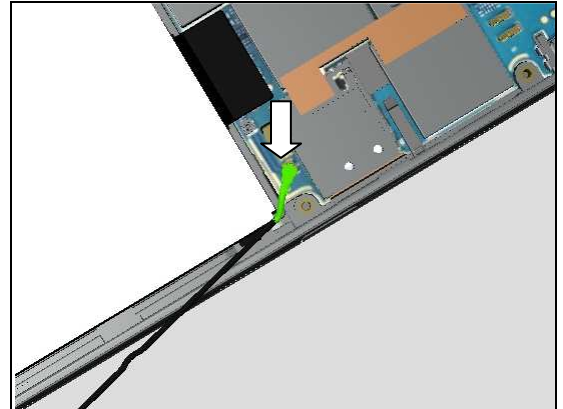
INSTALLATION

Place the Cable antenna_cable in place.

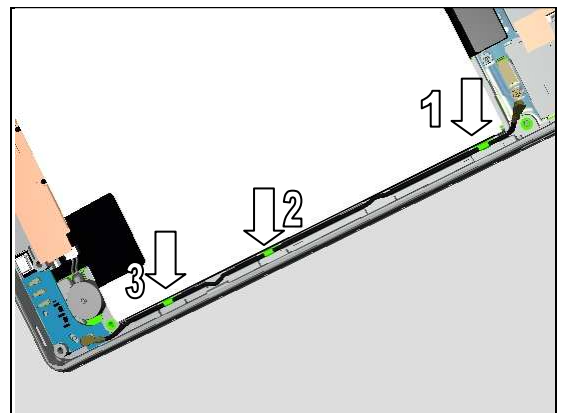


Replacement: Cable antenna_cable

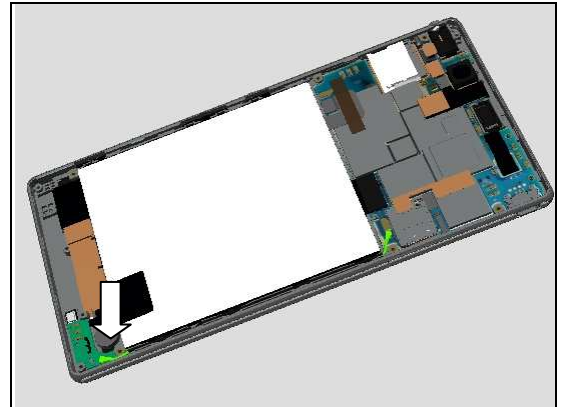
Connect the coax connector to the Main PBA as shown.



Press along the Cable antenna_cable into the cavity and insert the cable into three clips of Display Assy as shown in [picture](#).



Connect the coax connector to PBA Main Antenna side as shown.



Replacement

4.17 Camera Chat

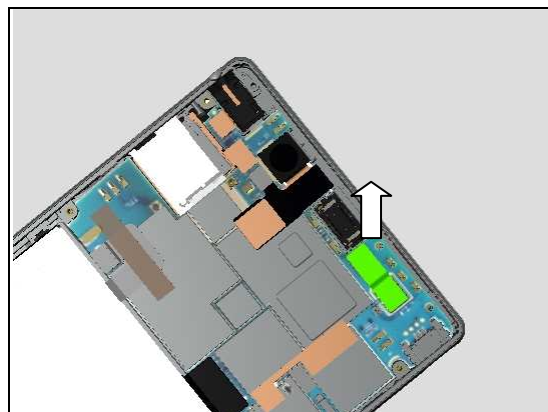
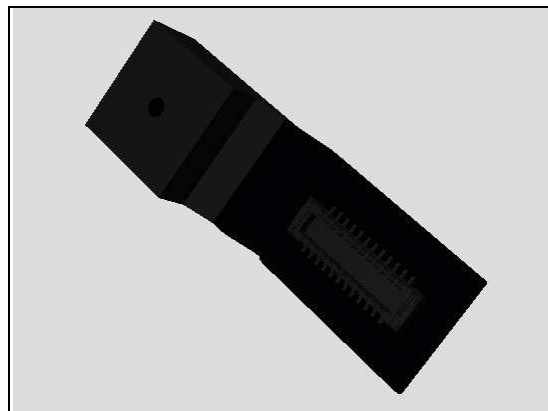
Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Camera Chat.

Follow the 5.5 – 5.7 Reassembly instructions!

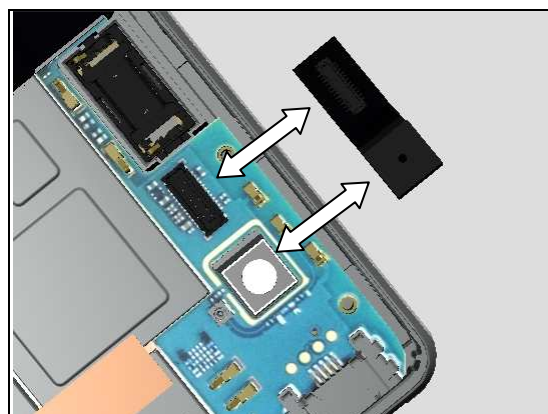
REMOVAL

1. Disconnect the BtB connector by Front Opening Tool.
2. Remove it gently.

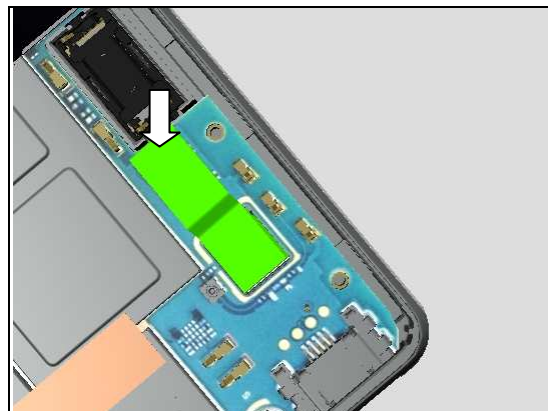


INSTALLATION

Prepare a new Camera Chat.



Snap to connect the BtB connector and make sure the camera head in its cavity.



Replacement

4.18 Camera Lens Adhesive & Window Camera

Follow the 3.1 – 3.2 Disassembly instructions!

Follow the 4.32 Removal instructions!

Prepare the new Camera Lens Adhesive & Window Camera.

Follow the 4.32 Installation instructions!

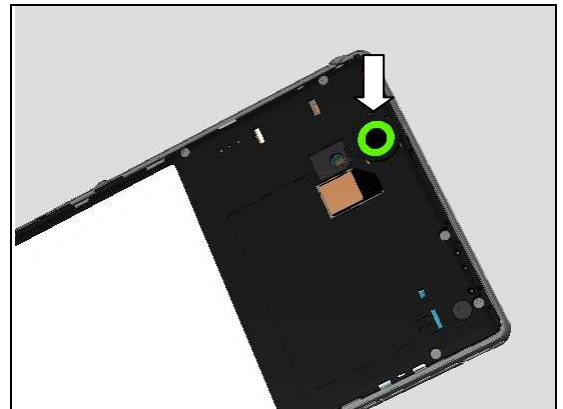
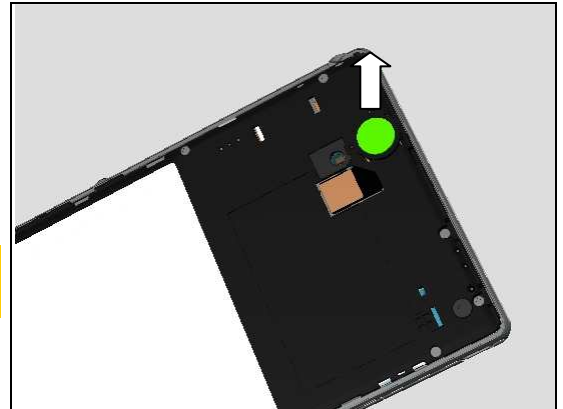
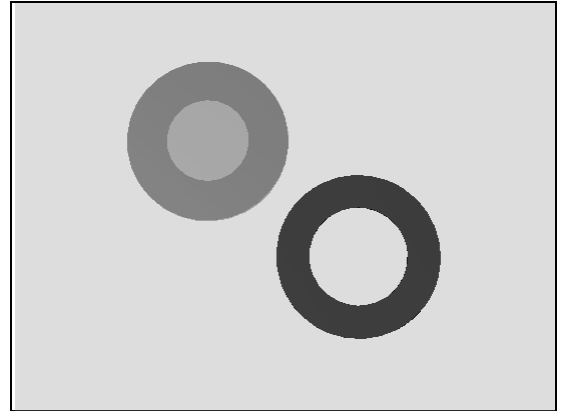
Follow the 5.6 – 5.7 Reassembly instructions!

REMOVAL

Detach to remove the Window Camera with the Flex Film Assembly Tool as shown.

Camera Lens Adhesive should be scrap!

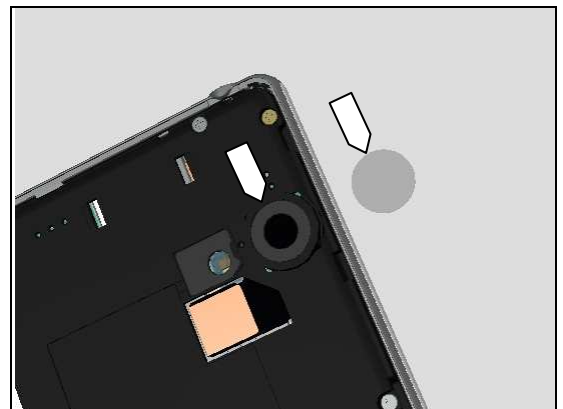
Make sure NO Flash Adhesive residue!



INSTALLATION

Prepare a new Camera Lens Adhesive and attach the Camera Lens Adhesive aligning to the cavity of Rear Cover Assy as shown.

Place the Window Camera into the cavity of Rear Cover Assy and press with fingers to make it securely attached.



Replacement

4.19 Cap SD

Prepare the new Cap SD.

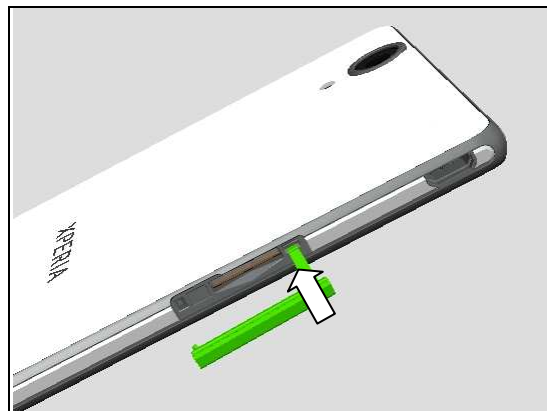
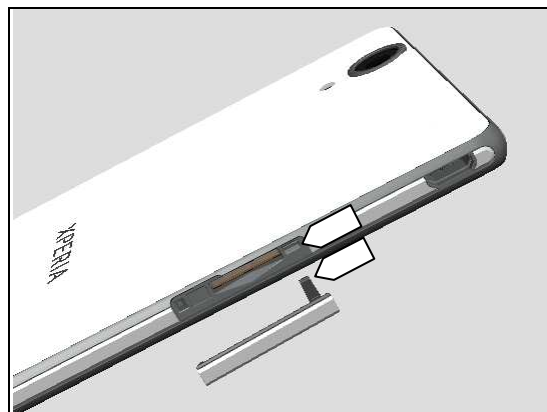
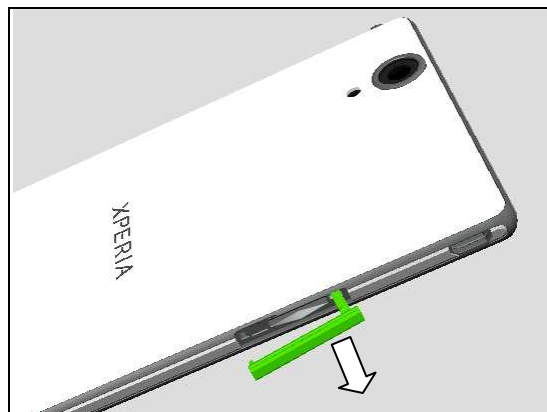
REMOVAL

Pull the head of the Cap SD to remove it with fingers.

INSTALLATION

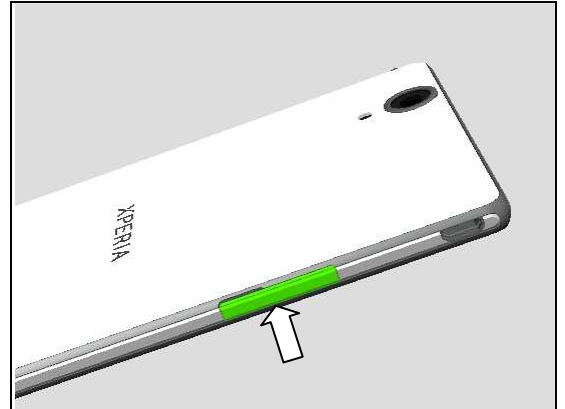
Place a new Cap SD in place.

Insert the head of Cap SD into the hole by tweezers.



Replacement: Cap SD

Press to snap the Cap SD.



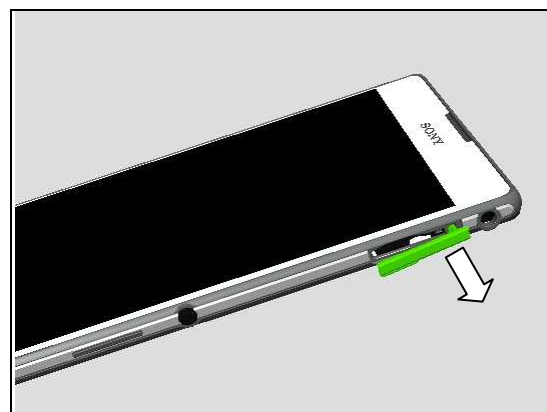
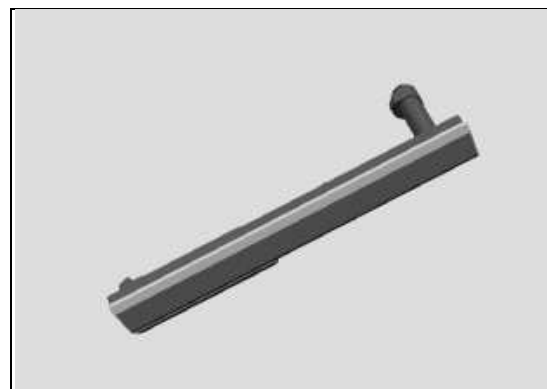
Replacement

4.20 Cap SIM Single (D5303, D5306, XM50t)/ Cap SIM Dual (D5322, XM50h)

Prepare the new Cap SIM Single or Cap SIM Dual.

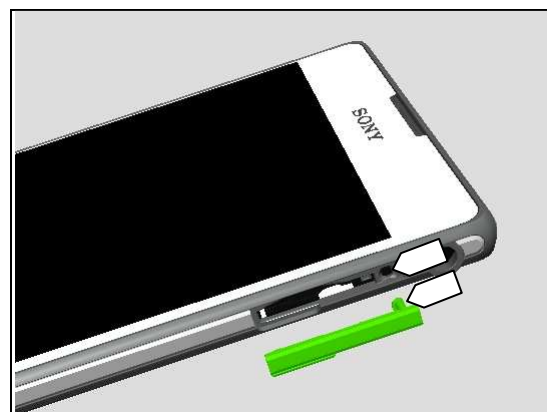
REMOVAL

Pull the head of the Cap SIM Single / Cap SIM Dual to remove it with fingers.

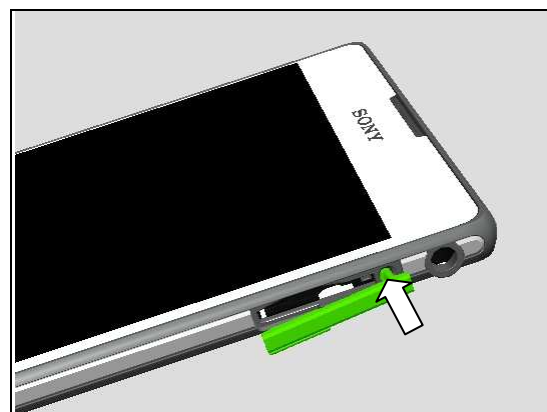


INSTALLATION

Place a new Cap SIM Single / Cap SIM Dual in place.

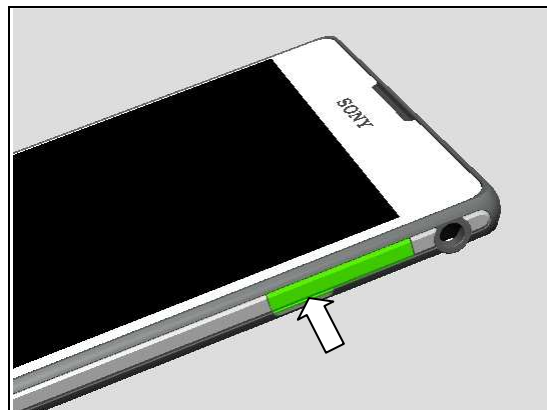


Insert the head of Cap SIM Single / Cap SIM Dual into the hole by tweezers.



Replacement: Cap SIM

Press to snap the Cap SIM Single / Cap SIM Dual.



Replacement

4.21 Display Assy

Follow the 3.1 – 3.7 Disassembly instructions!

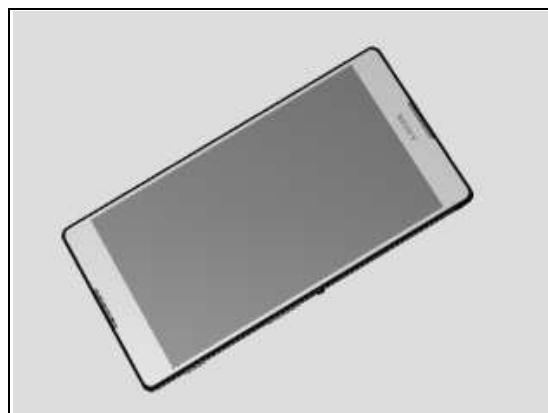
Follow the 4.7, 4.10, 4.11, 4.12, 4.13, 4.14 4.16, 4.22, Removal instructions!

Prepare the new Display Assy.

Follow the 4.7, 4.10, 4.11, 4.12, 4.13, 4.14 4.16, 4.22, Installation instructions!

Follow the 5.1 – 5.7 Reassembly instructions!

Note: Calibration required after replacing Touch Panel following Trouble Shooting Application 1257-2706!



Replacement

4.22 Earspeaker & Gasket Receiver

Follow the 3.1 – 3.3 Disassembly instructions!
Prepare the new Earspeaker & Gasket Receiver.
Follow the 5.5 – 5.7 Reassembly instructions!

REMOVAL

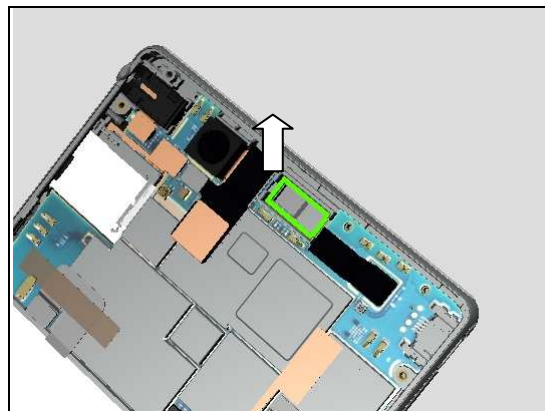
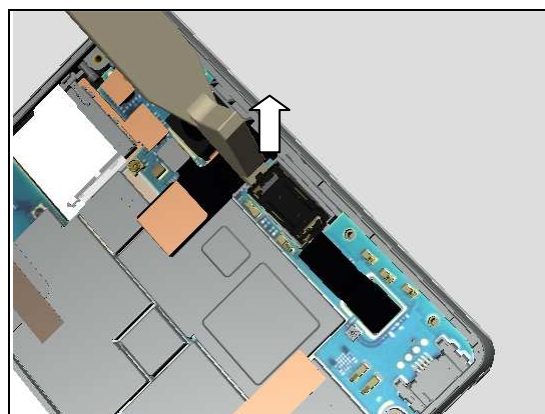
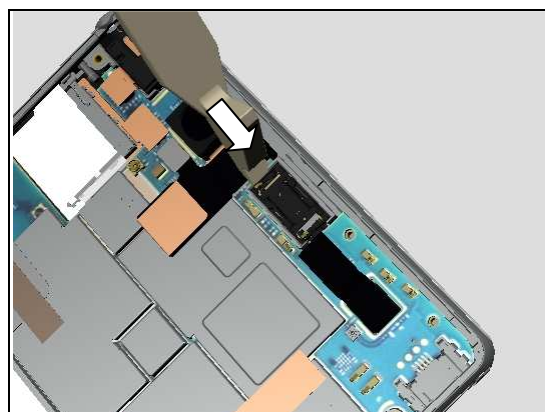
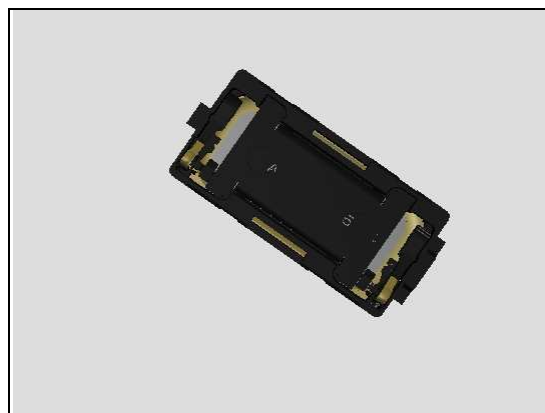
Insert the Front Opening Tool to unsnap the Earspeaker from the position as shown.

Pull upwards to release the Earspeaker.

Gasket Receiver should be scrapped!

Remove the Gasket Receiver.

Clean any remaining adhesive residue!



Replacement: Earspeaker & Gasket Receiver

INSTALLATION

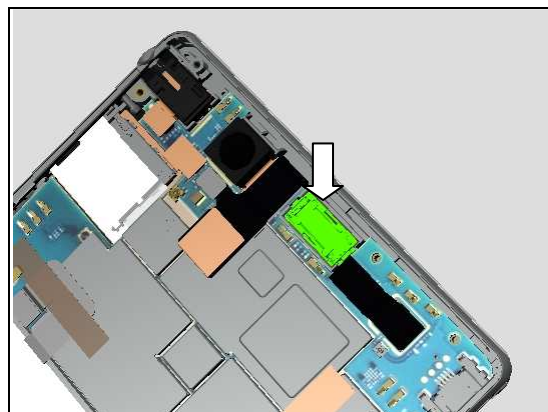
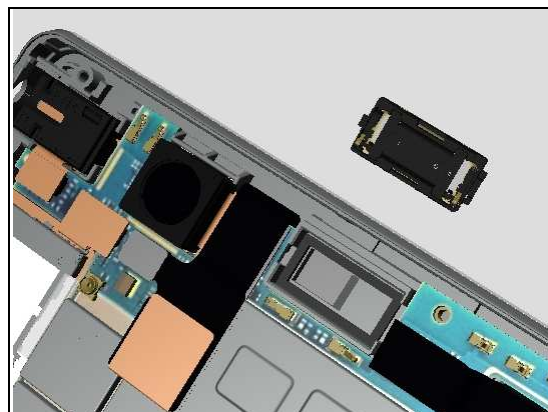
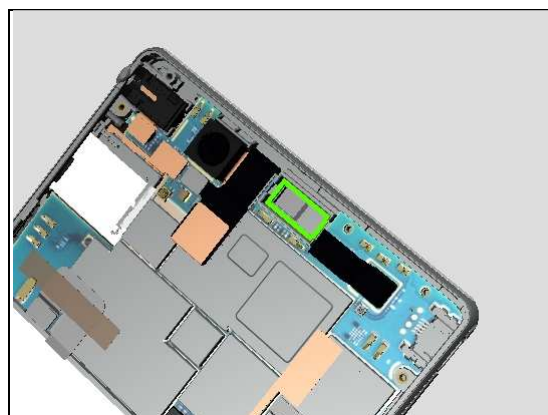
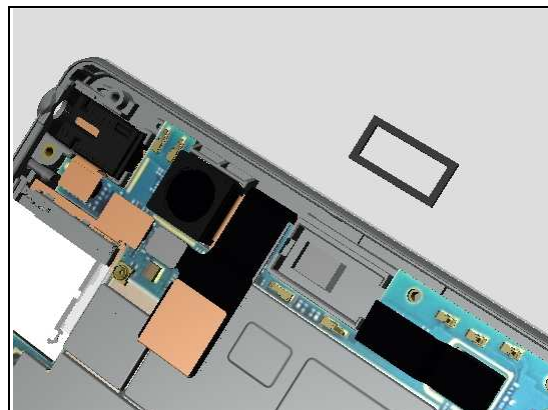
Prepare a new Gasket Receiver.

Place it into the cavity and press it securely.

Place the Earspeaker in its proper position

Press down it into the cavity with the flat end of the tweezers to make it securely attached.

Make sure the orientation direction is correct!



Replacement

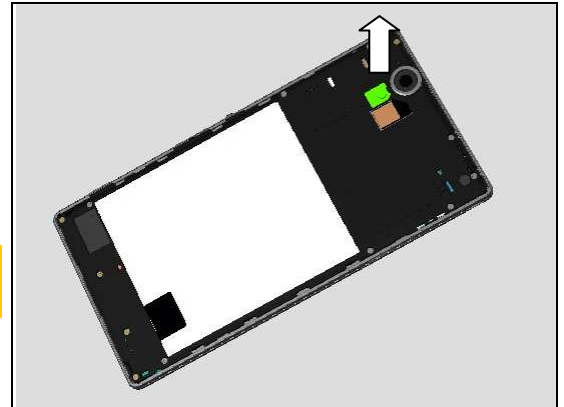
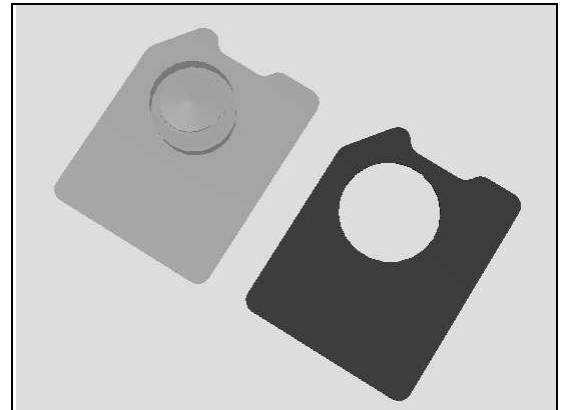
4.23 Flash Lens and Flash Lens Adhesive

Follow the 3.1 Disassembly instructions!
Prepare the new Flash Lens and Flash Lens Adhesive.
Follow the 5.7 Reassembly instructions!

REMOVAL

Detach to remove the Flash Lens with the Flex Film Assembly Tool as shown.

Flash Lens Adhesive should be scrap!
Clean any remaining adhesive residue!

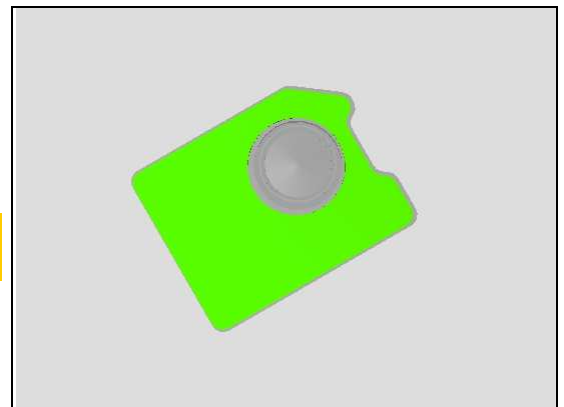
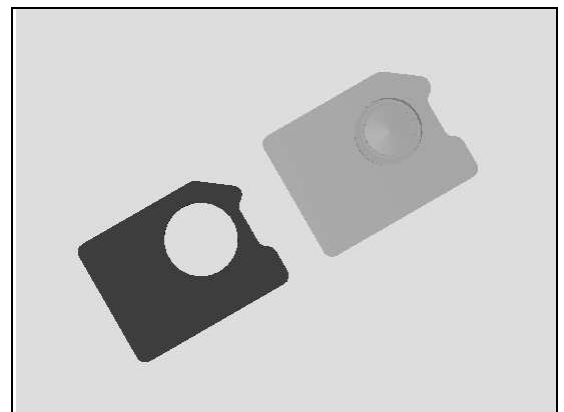


INSTALLATION

Prepare a new Flash Lens Adhesive and a new Flash Lens.

Attach the Flash Lens Adhesive onto the back side of Flash Lens.

Align Adhesive Flash Lens using inner pole of Flash Lens!



Replacement: Lens and Flash Lens Adhesive

Attach the Flash Lens on the Rear Cover and press with fingers to make it securely attached as shown.



Replacement

4.24 Label & Foil 0.0 mm CU label Tray

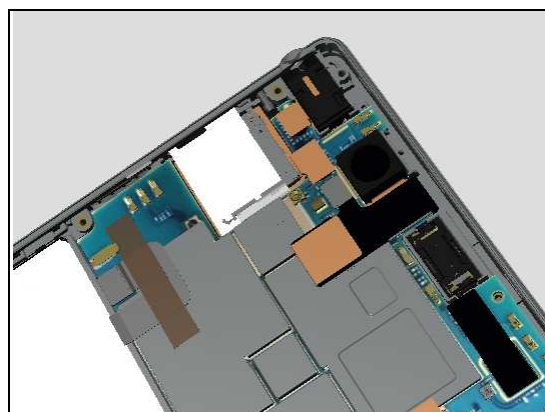
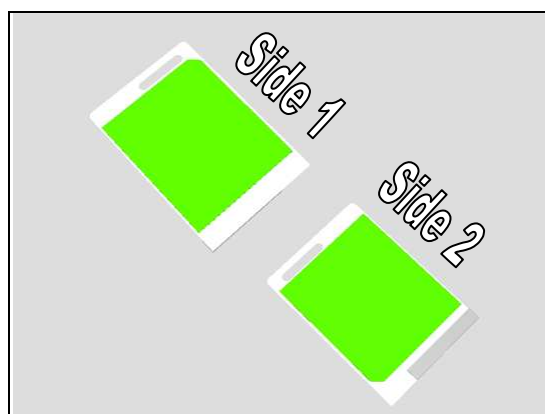
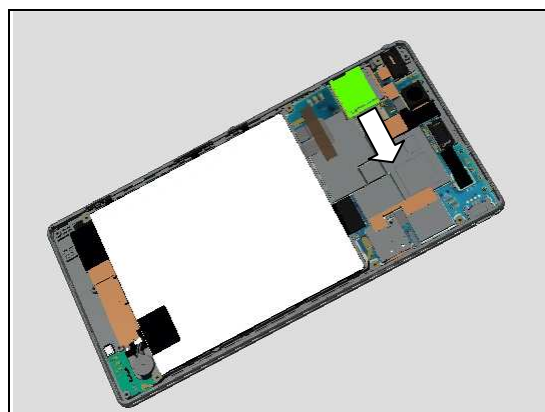
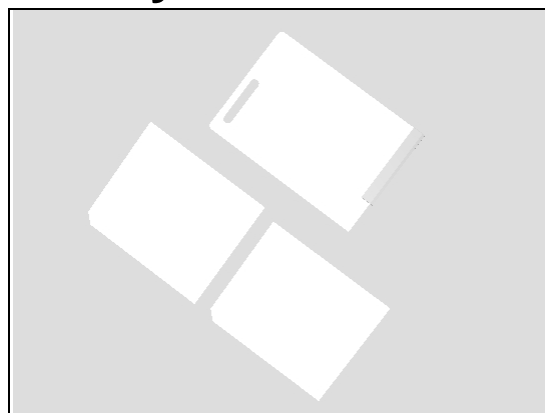
Follow the 3.1 – 3.3 Disassembly instructions!
Prepare the new Label & Foil 0.0 mm CU label Tray.
Follow the 5.5 – 5.7 Reassembly instructions!

Label and Foil 0.0 mm CU label Tray should be scraped after removal!

Read the information on both sides of the old Label and/or write the information into the 'Label Print Solution' program.

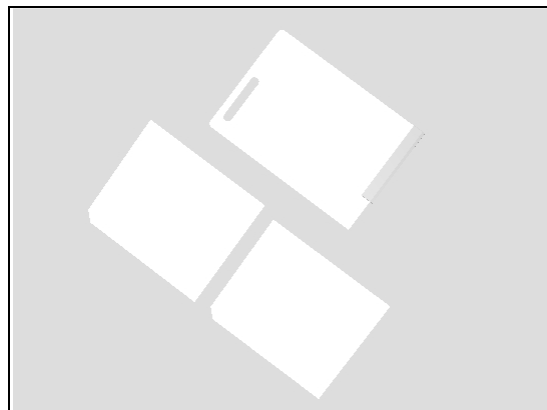
INSTALLATION

Check that the label format is properly loaded in the Zebra printer and write a new Label using the 'Label Print Solution' software.

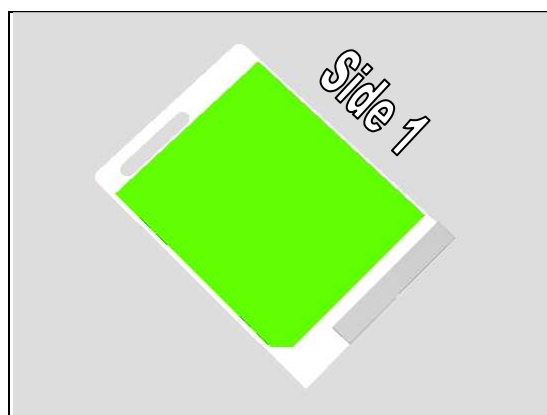


Replacement: Label & Foil 0.0 mm CU label Tray

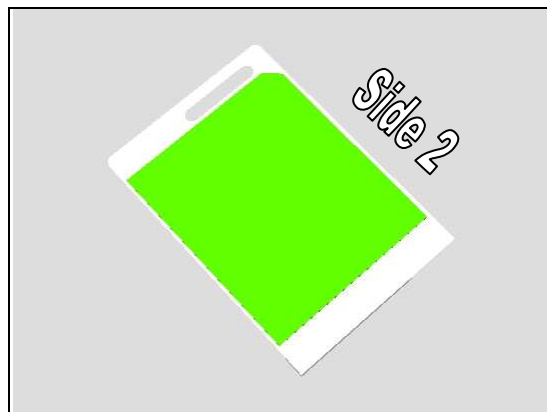
Prepare a new Foil 0.0 mm CU label Tray and Labels.



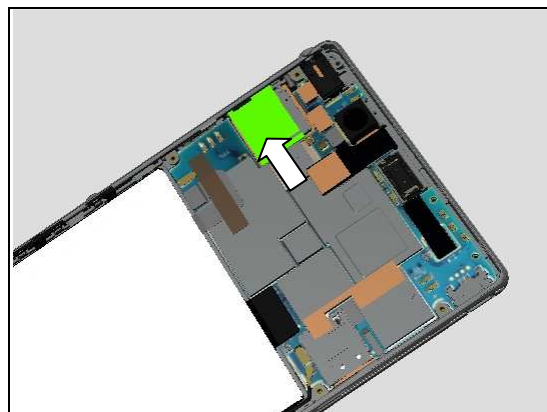
Attach the new Label Side 1 onto Foil 0.0 mm CU label Tray in proper position.



Do the same for the opposite side.



Insert the Label properly.



Replacement

4.25 Foil 0.0 mmBattery Right

Follow the 3.1 – 3.3 & 3.7 Disassembly instructions!

Prepare the new Foil 0.0 mmBattery Right.

Follow the 5.1 & 5.5 – 5.7 Reassembly instructions!

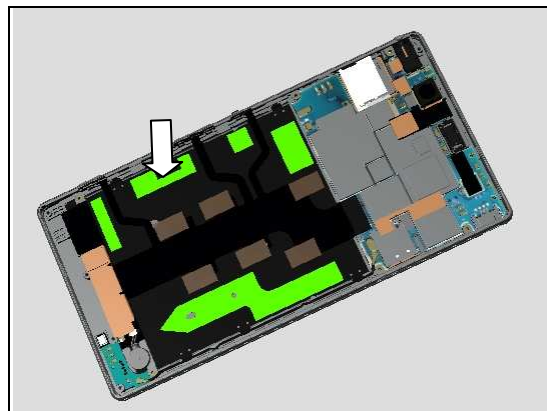
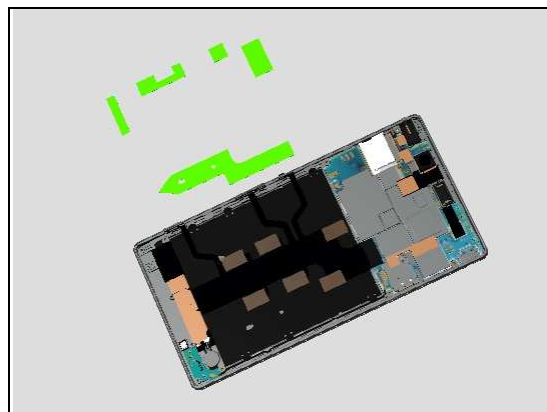
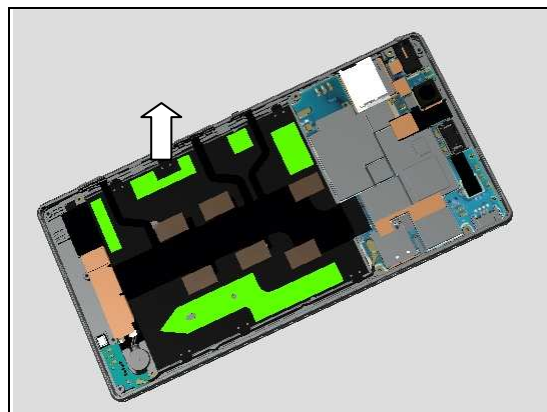
REMOVAL

Detach to remove the Foil 0.0 mmBattery Right, piece by piece until the no **adhesive** residue **remaining**.

INSTALLATION

Place a new Foil 0.0 mmBattery Right in place.

Attach it onto the Display Assy and press along to secure its attachment.



Replacement

4.26 Gasket Conductive Relay FPC Speaker Gasket

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Gasket Conductive Relay FPC Speaker Gasket.

Follow the 5.5 – 5.7 Reassembly instructions!

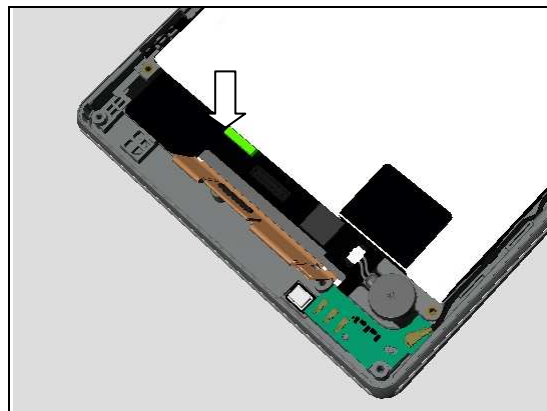
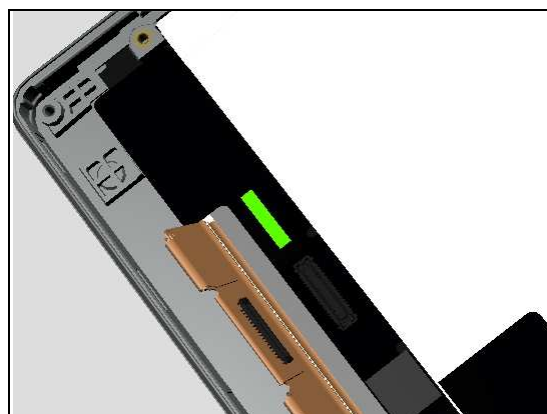
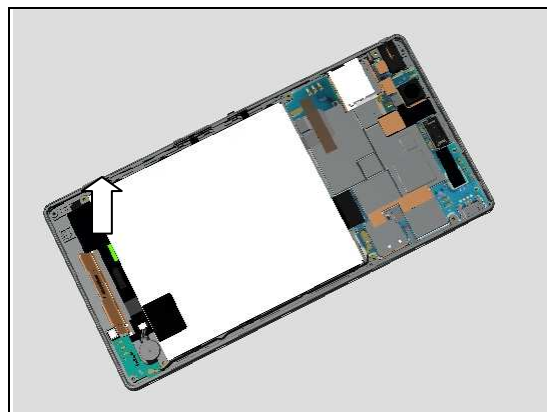
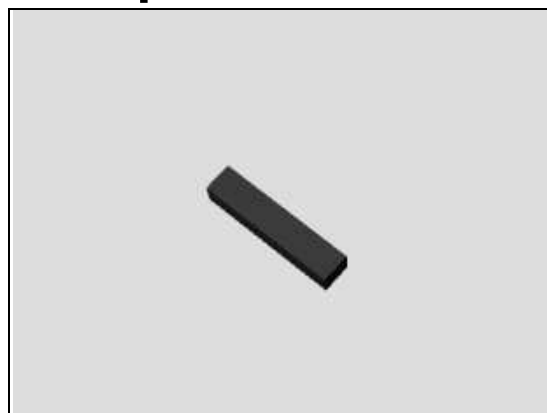
REMOVAL

Detach to remove the Gasket Conductive Relay FPC Speaker Gasket by using the Flex Film Assembly Tool as shown.

INSTALLATION

Attach the new Gasket Conductive Relay FPC Speaker Gasket on the FPC Relay aligning to the golden area as marked in the picture.

Press to make it securely attached.



Replacement

4.27 Gasket Conductive Relay FPC Vib Gasket

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Gasket Conductive Relay FPC Vib Gasket.

Follow the 5.5 – 5.7 Reassembly instructions!

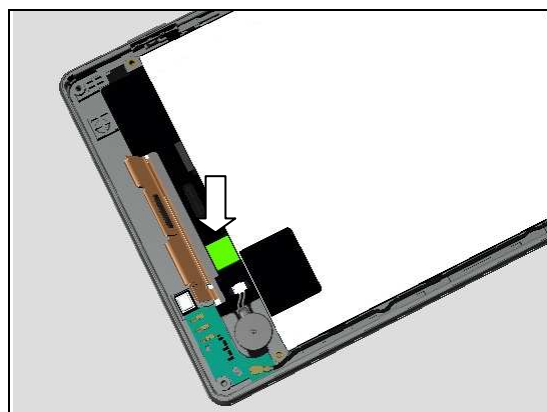
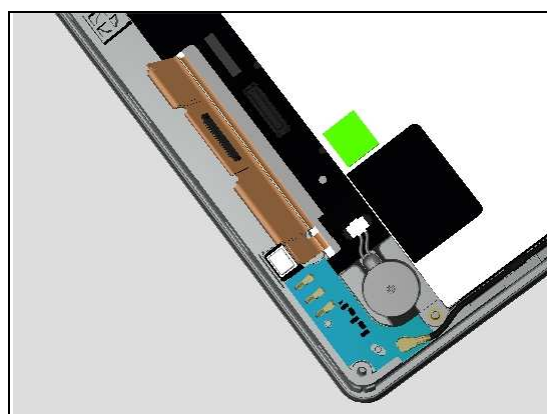
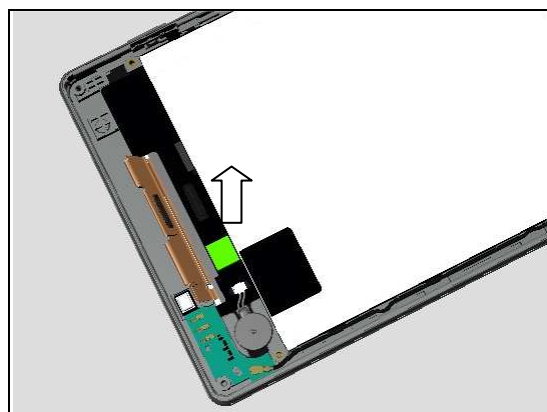
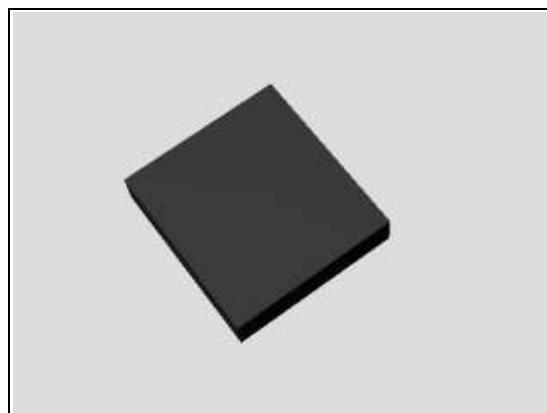
REMOVAL

Detach to remove it by using the Flex Film Assembly Tool as shown.

INSTALLATION

Attach the new Gasket Conductive Relay FPC Vib Gasket on the FPC Relay aligning to the golden area as marked in the picture.

Press to make it securely attached.



Replacement

4.28 Gasket Speaker & Loudspeaker

Follow the 3.1 – 3.3 Disassembly instructions!
Prepare the new Gasket Speaker & Loudspeaker.
Follow the 5.5 – 5.7 Reassembly instructions!

REMOVAL

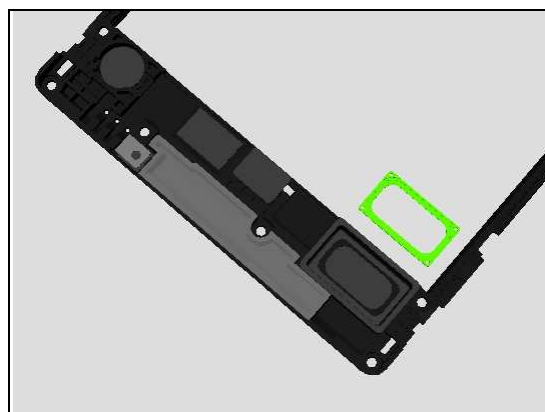
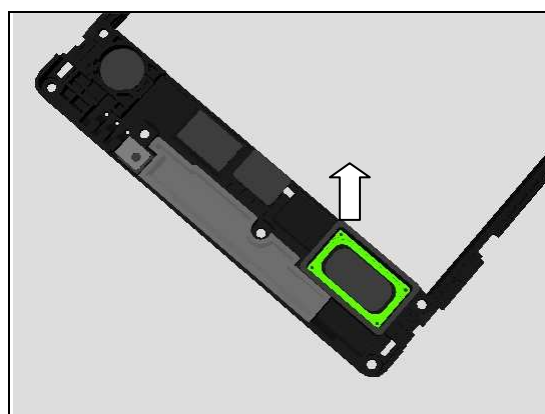
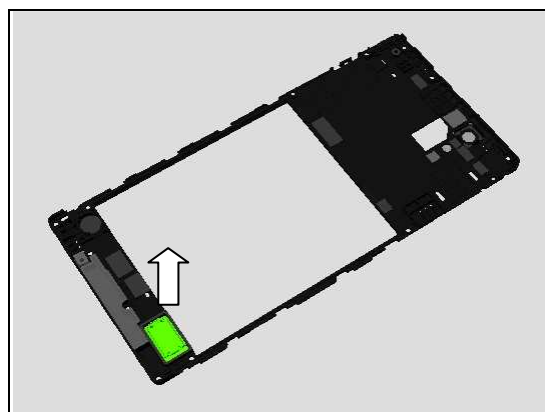
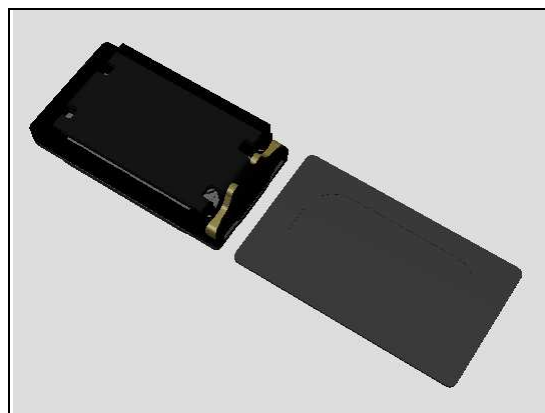
Insert the Front Opening Tool from right side and pull upwards to release the Loudspeaker.

Detach to remove the Gasket Speaker with Flex Film Assembly Tool.

Gasket Speaker should be scrap!
Clean any remaining adhesive residue!

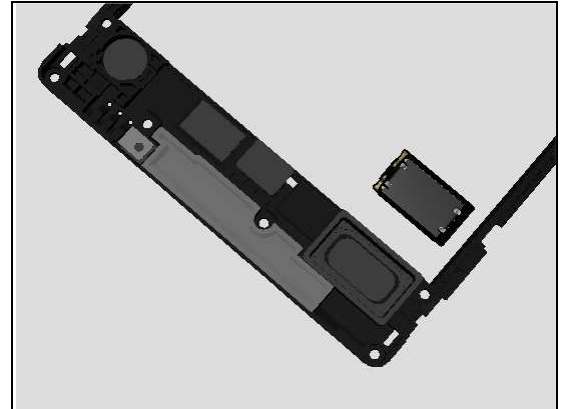
INSTALLATION

Attach the new Gasket Speaker into the cavity and press along to secure the attachment.



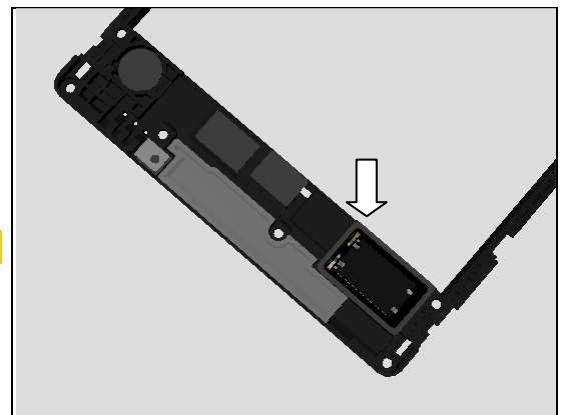
Replacement: Gasket Speaker & Loudspeaker.

Note the orientation of the Loudspeaker to be installed.



Place the Loudspeaker into the cavity and press the surface to secure its attachment.

Do not touch the pins!



Replacement

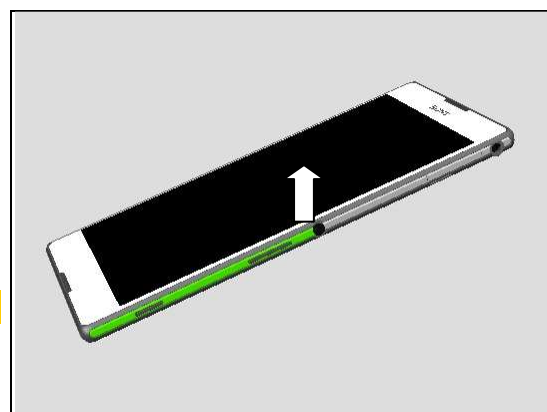
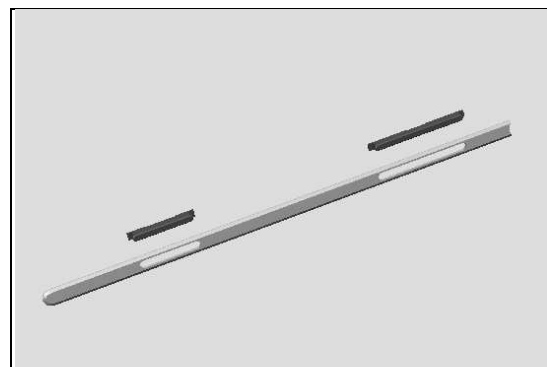
4.29 Key Camera & Key Volume & Bracket Assy Panel Key

Prepare the new Key Camera & Key Volume & Bracket Assy Panel Key.

REMOVAL

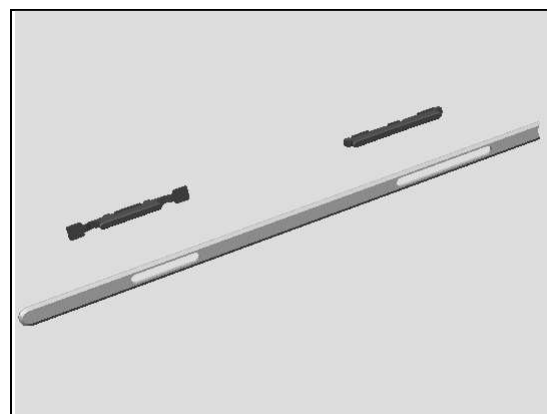
Detach to remove the Bracket Assy Panel Key with the Flex Film Assembly Tool and the Key Camera and the Key Volume will come off simultaneously.

Be careful not to scratch the Display Assy!

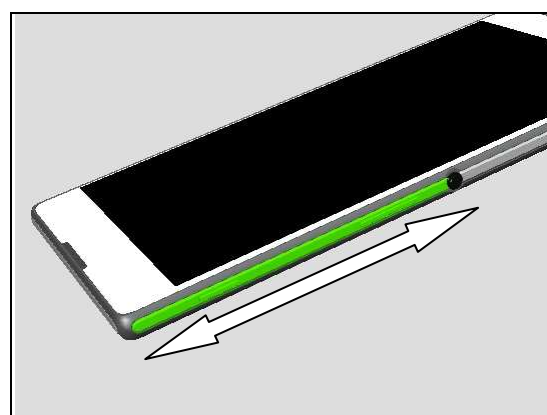


INSTALLATION

Prepare a new Bracket Assy Panel Key and insert the new Key Camera and the new Key Volume into the holes of the Bracket Assy Panel Key as shown.



Attach the Bracket Assy Panel Key onto the Display Assy **aligning** to the cavity and press along for 5 seconds to make it securely attached.



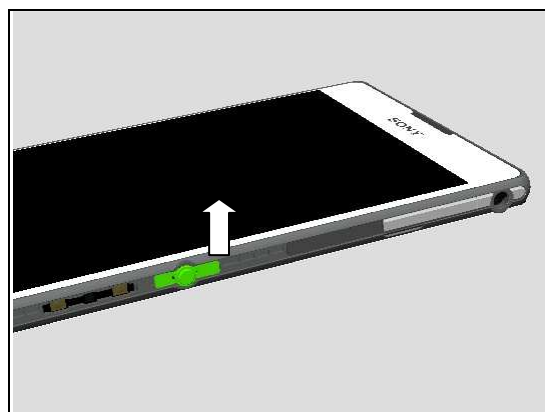
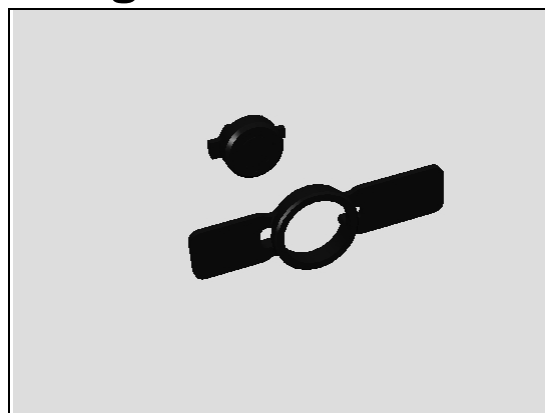
Replacement

4.30 Key On/Off & MComp Assy Ring Power

Follow the 4.15, 4.29 Removal instructions!
Prepare the new Key On/Off & MComp Assy Ring Power
Follow the 4.15, 4.29 Installation instructions!

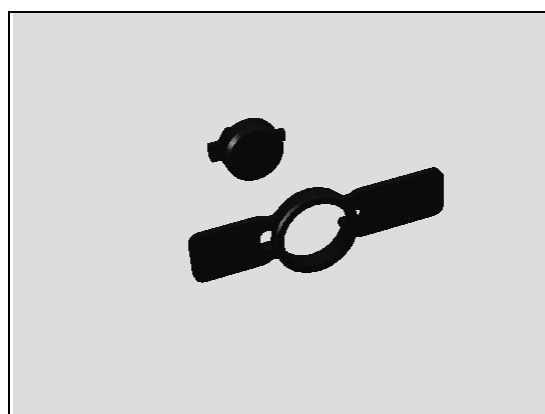
REMOVAL

Detach to remove the MComp Assy Ring Power and Key On/Off with the Flex Film Assembly Tool.

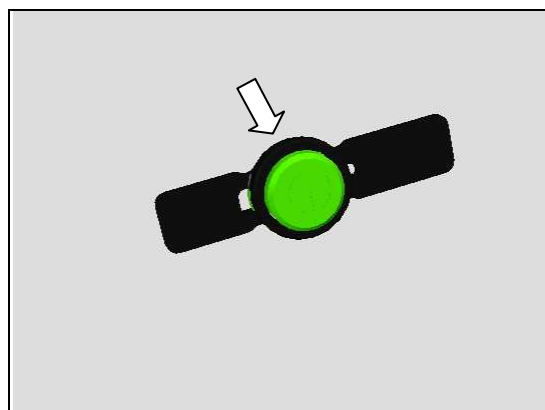


INSTALLATION

Prepare a new MComp Assy Ring Power and a new Key On/Off in place.

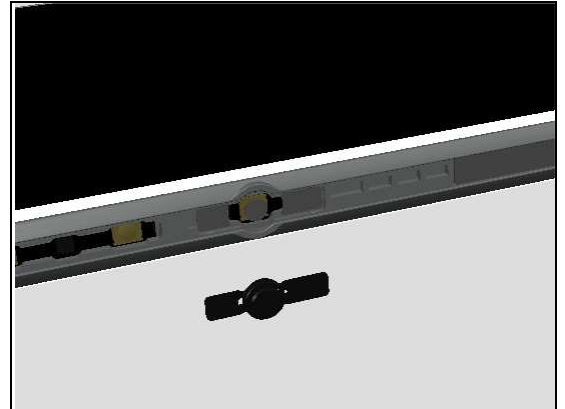


Insert the Key On/Off into the hole of MComp Assy Ring Power from back side as shown.

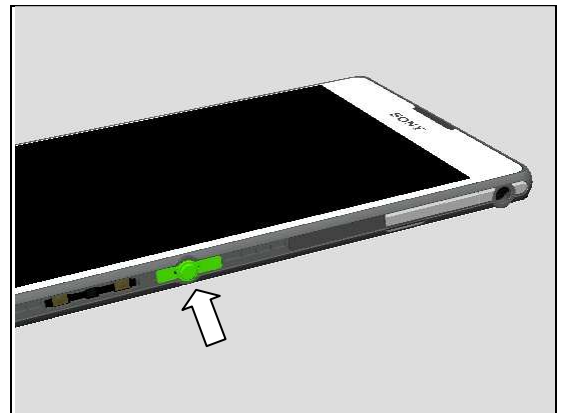


Replacement: Key On/Off & MComp Assy Ring Power

Attach the MComp Assy Ring Power into the cavity of the Display Assy as shown.



Press to secure its position.



Replacement

4.31 Speaker Mesh

Follow the 3.1 Disassembly instructions!

Prepare the new Speaker Mesh.

Follow the 5.7 Reassembly instructions!

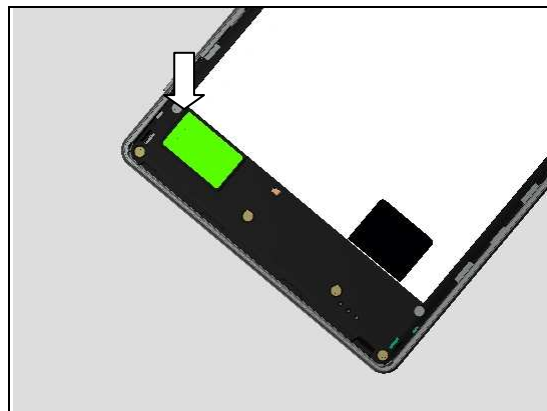
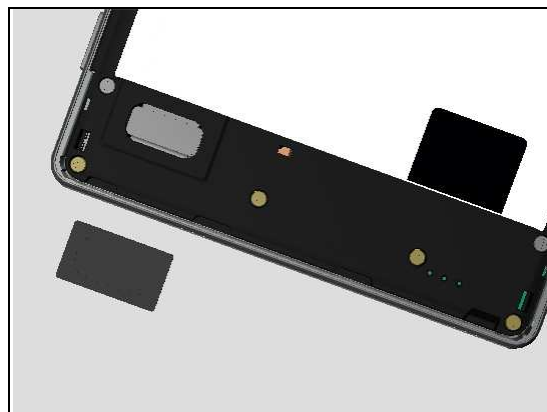
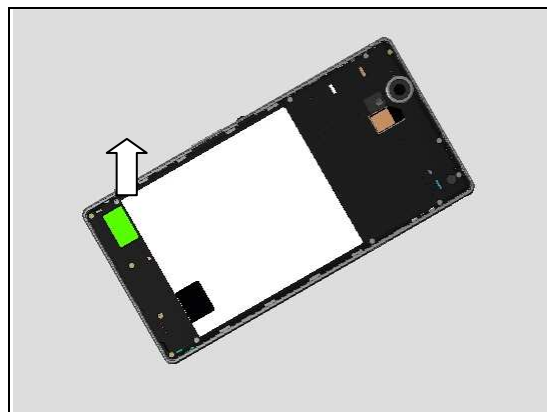
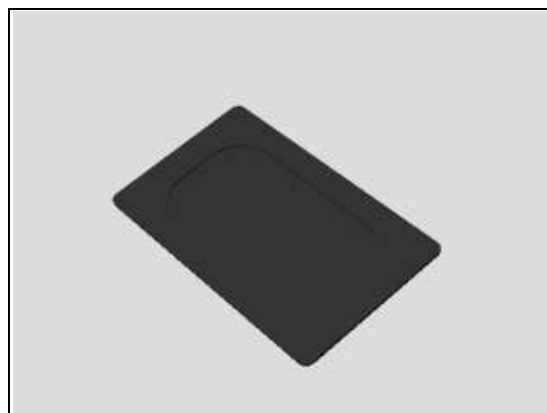
REMOVAL

Detach to remove it from the Rear Cover Assy by using a Flex Film Assembly Tool.

INSTALLATION

Prepare a new Speaker Mesh in place.

Place it according to the frame of Rear Cover Assy as shown and press it along to make it securely attached.



Replacement

4.32 Main Camera Ring & Main Camera Ring Adhesive

Follow the 3.1 Disassembly instructions!

Prepare the new Main Camera Ring & Main Camera Ring Adhesive.

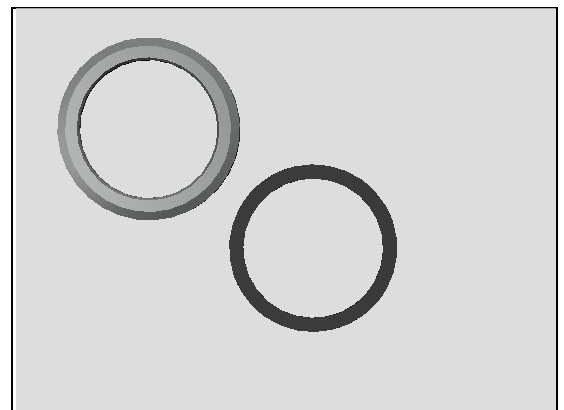
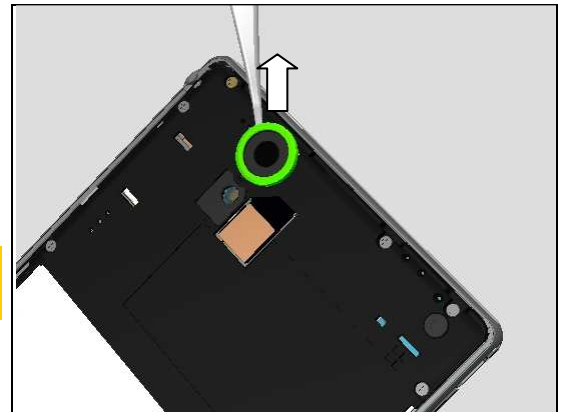
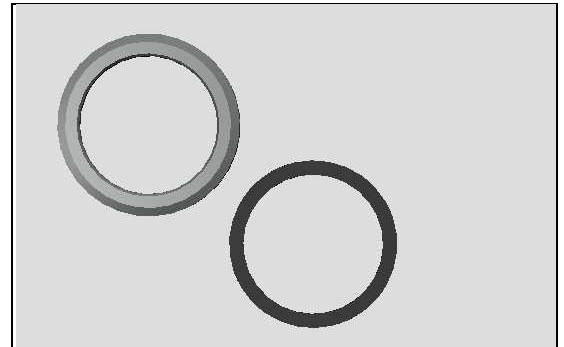
Follow the 5.7 Reassembly instructions!

REMOVAL

Detach to remove the Main Camera Ring with the Flex Film Assembly Tool as shown.

Main Camera Ring Adhesive should be scrap!

Clean any remaining adhesive residue!



INSTALLATION

Attach the Main Camera Ring Adhesive onto the back side of Main Camera Ring.

Place it to the frame of Rear Cover Assy in its proper position as shown and press it to make it securely attached.

Replacement

4.33 Board Swap – Replacement

Follow the 3.1-3.6 Disassembly instructions!

Follow the 4.17 Removal instructions!

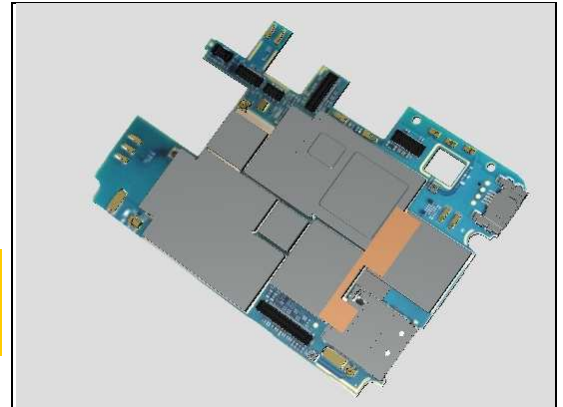
Prepare the Main PBA.

Follow the 4.17 Installation instructions!

Follow the 5.2-5.7 Reassembly instructions!

Reuse the Chat Camera.

Please refer to: Trouble Shooting Application 1257-2706 for applicable D53 calibrations!

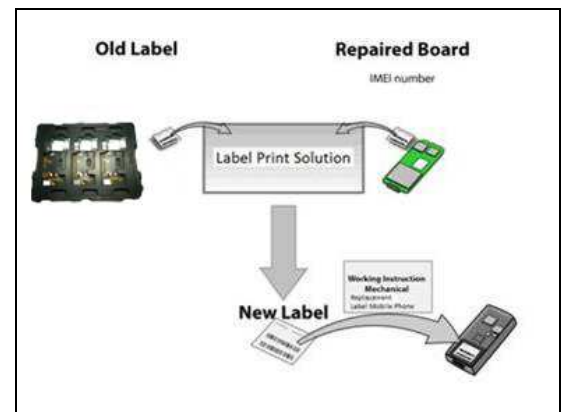


4.34 Board Swap – Change Label

CHANGE LABEL

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

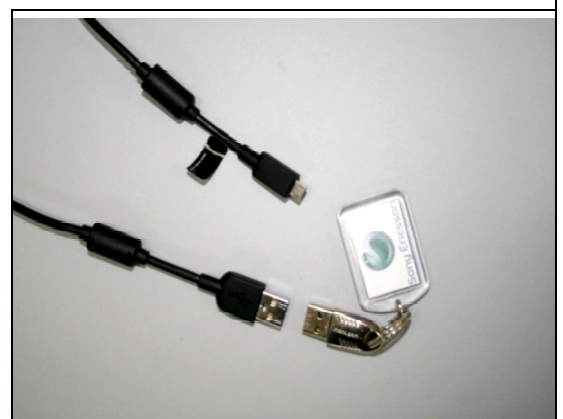
The Label Core unit need to paste on the shielding can of Main PBA Assy.



4.35 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

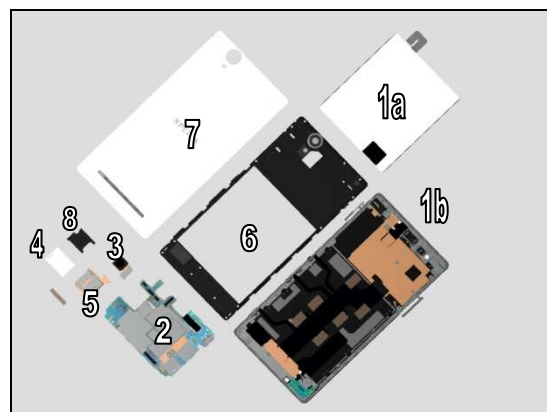
Follow the instructions in the Generic Repair Manual – Build swap for customization of the software.



5 Reassembly

The reassembly is done in the following order:

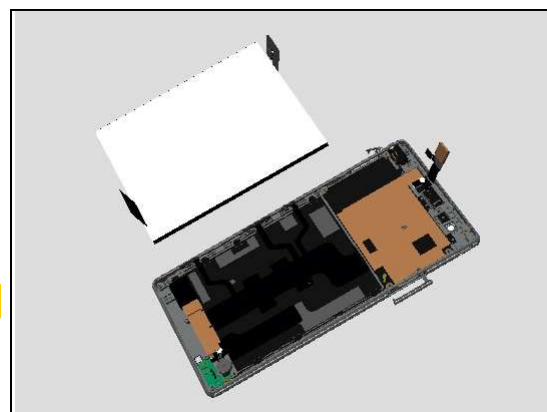
1. Battery & Display Assy
2. Main PBA
3. Main Camera
4. FPC SIM Dual
5. Label Tray
6. Rear Cover Assy
7. Battery Cover Assy
8. SIM Tray



5.1 Battery & Display Assy

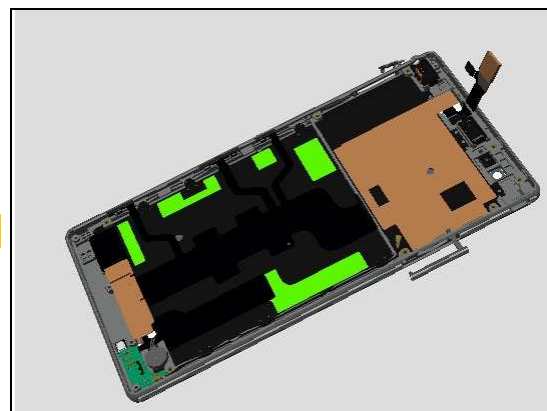
Prepare a new Battery and the Display Assy as shown in the picture.

Battery cannot be reused!

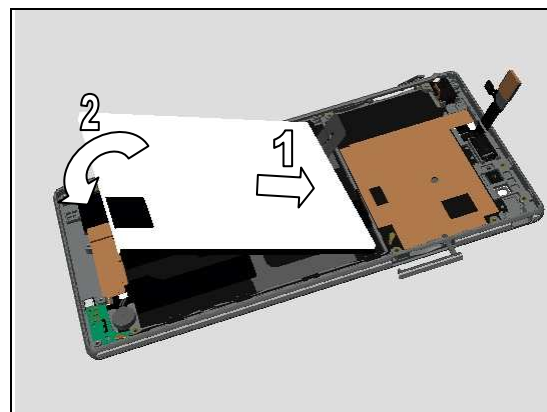


Replace the Foil 0.0 mm Battery Right with new one.

Do not reuse the Foil 0.0 mm Battery Right!

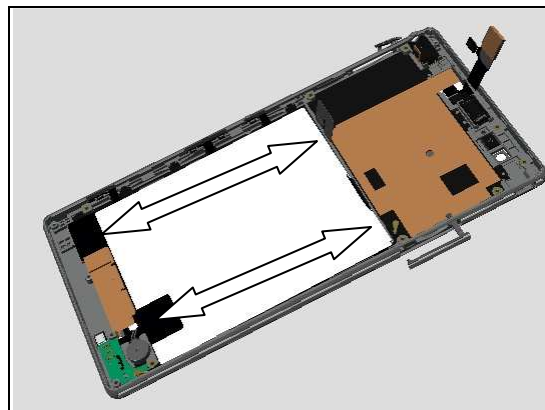


1. Insert the Battery into the cavity of Display Assy from the top side.
2. Turn the Battery over.



Reassembly

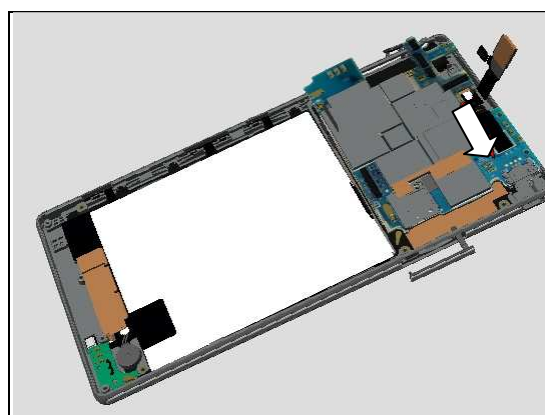
Press along the battery evenly to make it securely attached.



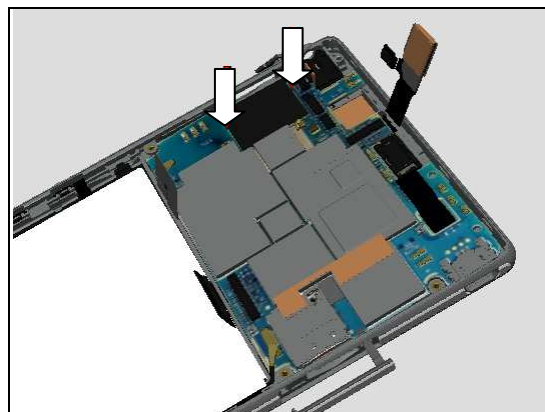
5.2 Main PBA

Place the Main PBA gently into the cavity of the Display Assy.

USB connector should be inserted firstly!

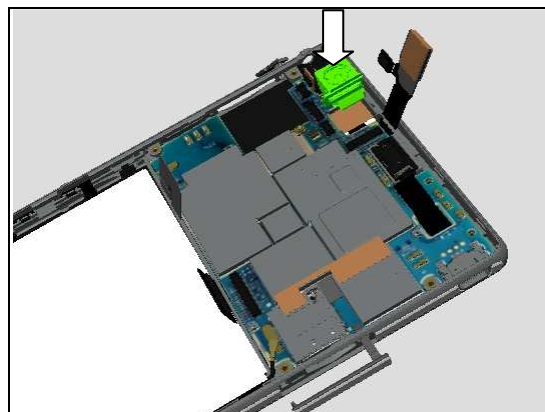


Press to snap the Main PBA as position shown.



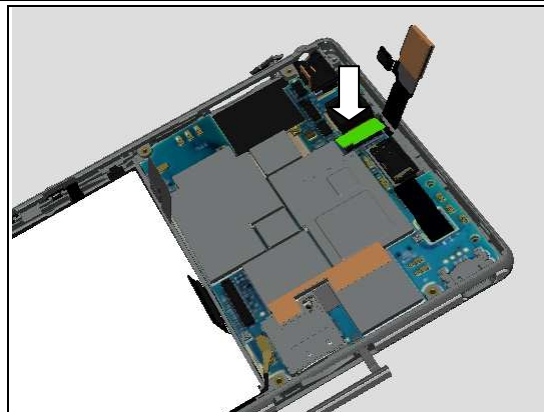
Place the Main Camera into the cavity as shown.

Do not touch the Camera Lens!

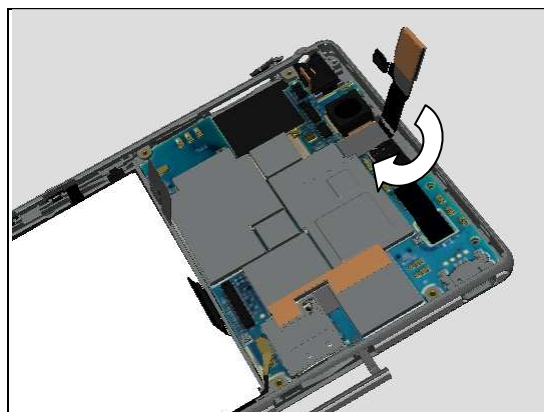


Reassembly

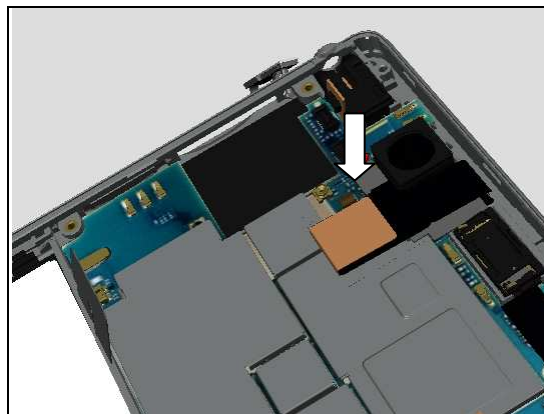
Press to connect the BtB connector of Main Camera.



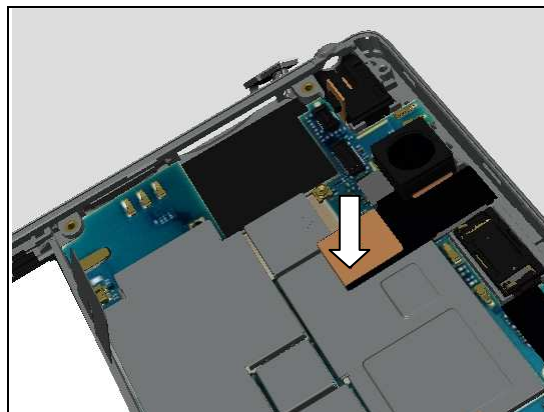
Turn the Touch Panel FPC back to horizontal position.



Press to snap the BtB connector as shown.

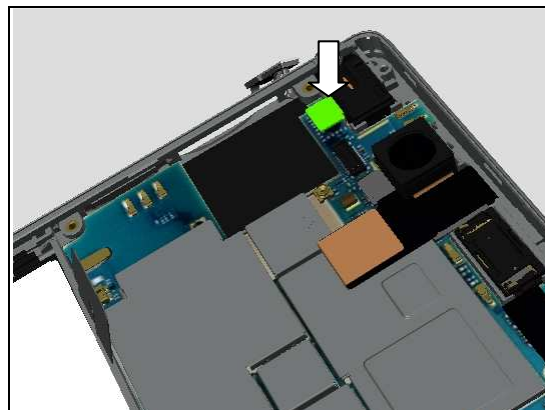


Press along the Touch Panel FPC to make it securely attached.



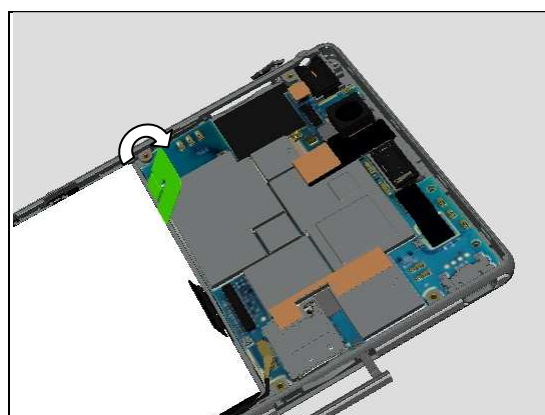
Reassembly

Press to connect the BtB connector of FPC Audio Jack.



(Only for D5303, D5306, XM50t)
Skip this step for D5322 and XM50h)

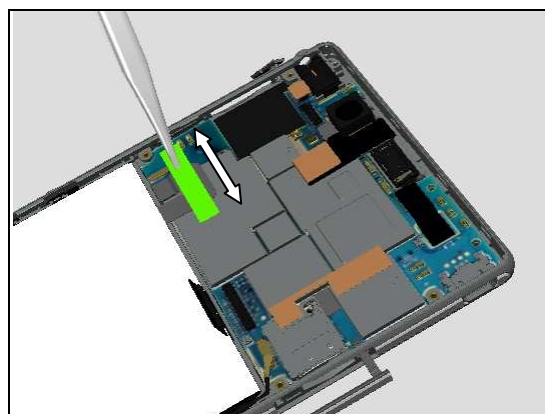
Turn the Battery FPC back to horizontal position and press to connect the BtB connector.



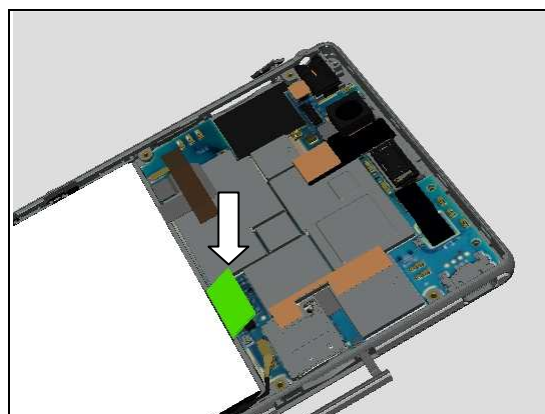
(Only for D5303, D5306, XM50t)
Skip this step for D5322 and XM50h)

Place a new Adhesive Battery FPC by Flex Film Assembly Tool and press along the Adhesive Battery FPC to make it securely attached

Do not reuse Adhesive Battery FPC!
Clean any remaining adhesive residue!

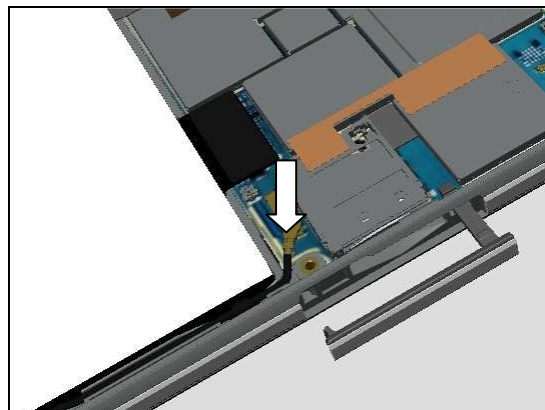


Turn the FPC Relay back to horizontal position and press to connect the BtB connector of FPC Relay.

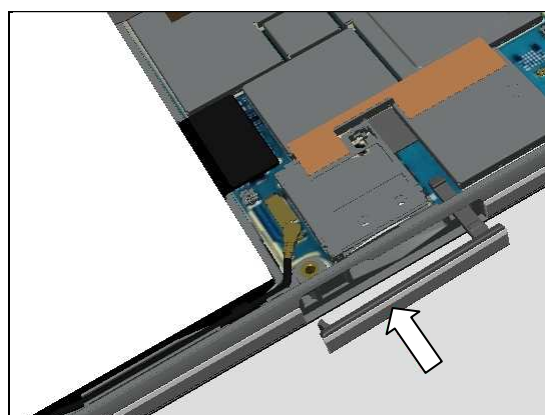


Reassembly

Press to connect the coax connector by fingers.



Press to snap the Cap SD.

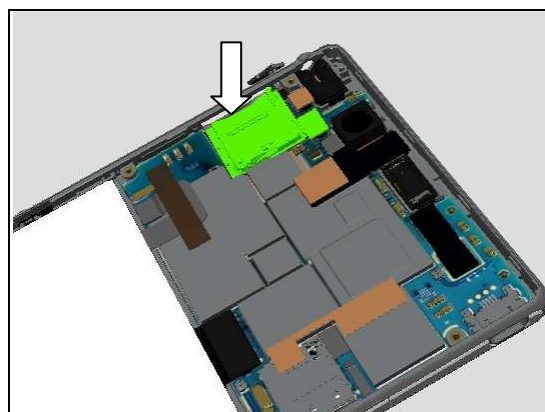
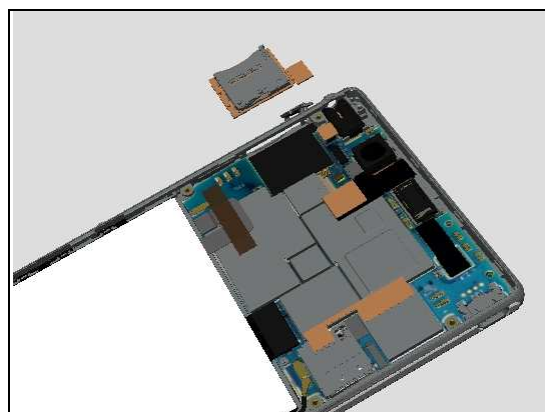


5.3 FPC SIM (Dual or Single)

Prepare a new FPC SIM Dual or FPC SIM Single in place.

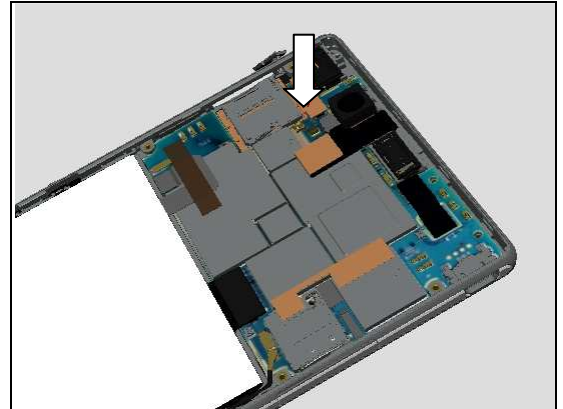
FPC SIM cannot be reused!

Put the FPC SIM Dual or FPC SIM Single into the cavity of Main PBA.

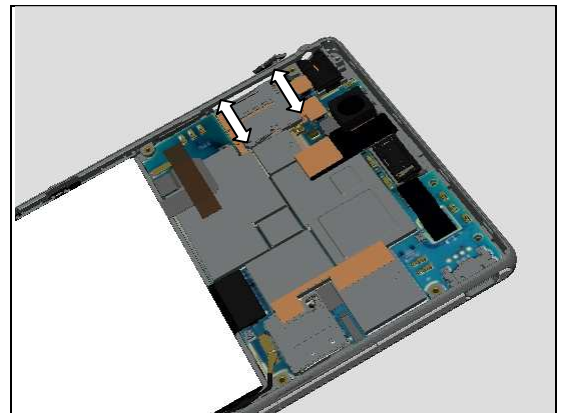


Reassembly

Press to connect the BtB connector.

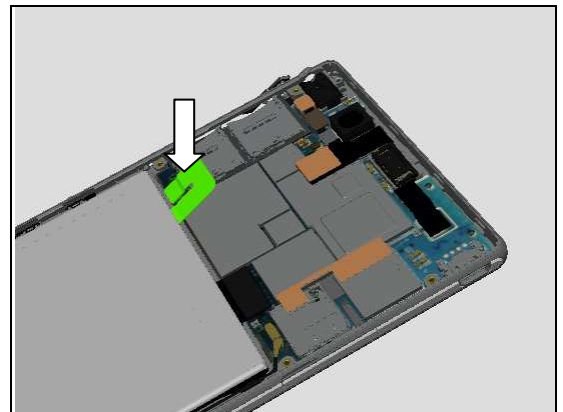


Press along the FPC SIM Single or FPC SIM Dual to make sure it's securely attached.



(Only for D5303, D5306, XM50t)
Skip this step for D5322 and XM50h)

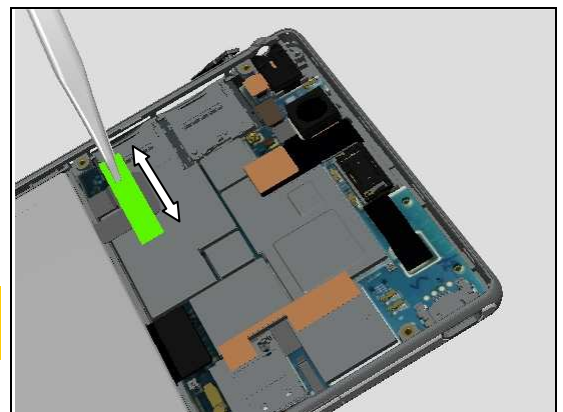
Turn the Battery FPC back to horizontal position and press to connect the BtB connector.



(Only for D5322 and XM50h)
Skip this step for D5303, D5306, XM50t)

Place a new Adhesive Battery FPC by Flex Film Assembly Tool and press along the Adhesive Battery FPC to make it securely attached.

Do not reuse Adhesive Battery FPC!
Clean any remaining adhesive residue!



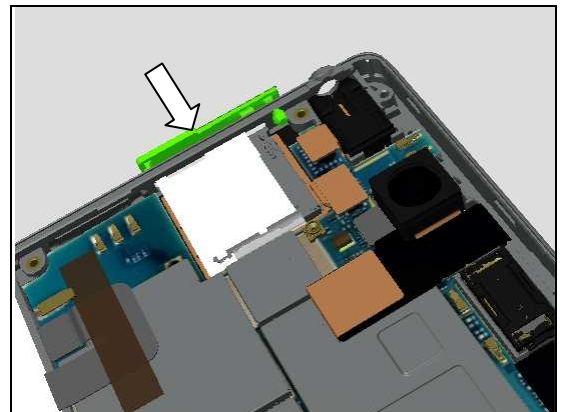
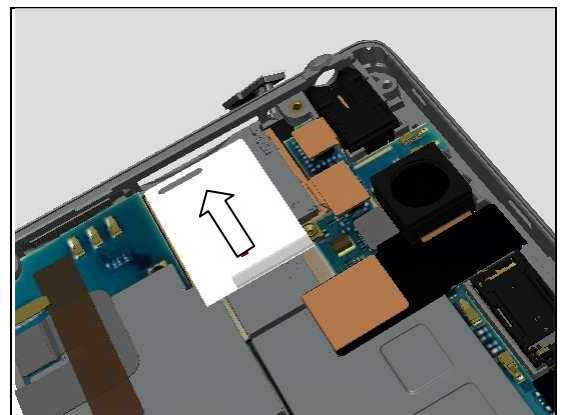
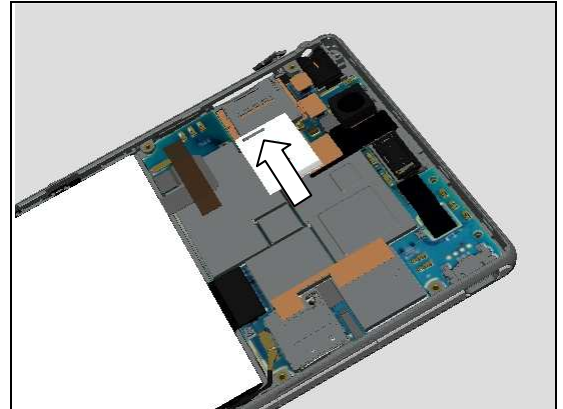
Reassembly

5.4 Label Tray

Prepare a new Label.

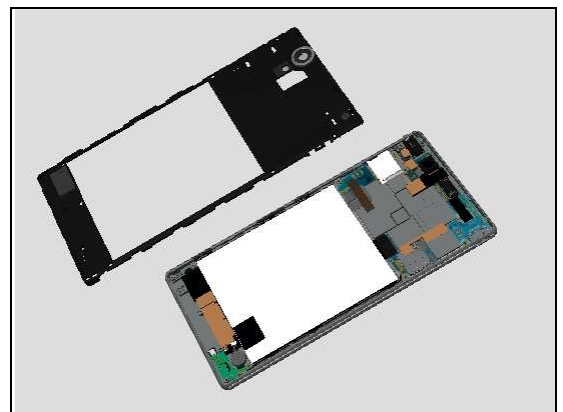
Insert the Label Tray properly.

Close the Cap SIM Dual or Cap SIM Single.



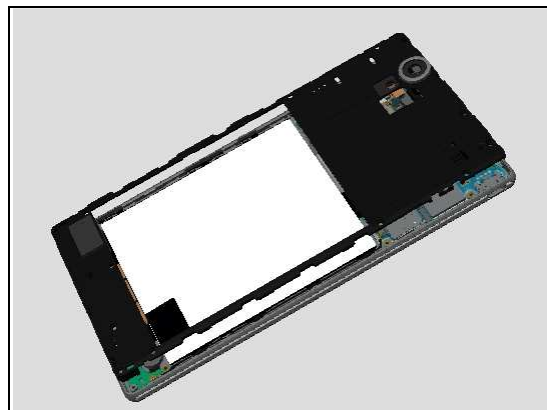
5.5 Rear Cover Assy

Prepare the Rear Cover Assy.

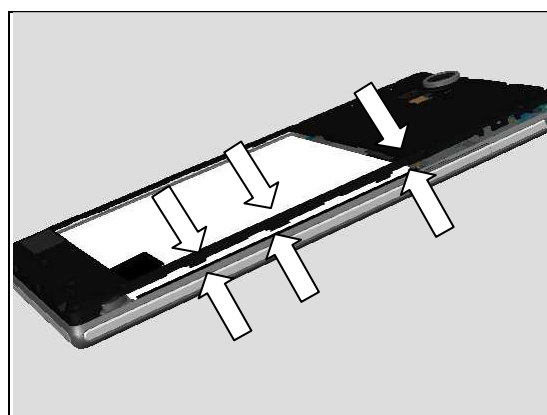


Reassembly

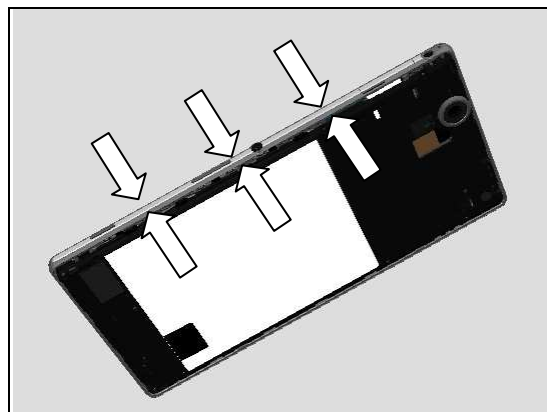
Place the Rear Cover Assy onto the Display Assy.



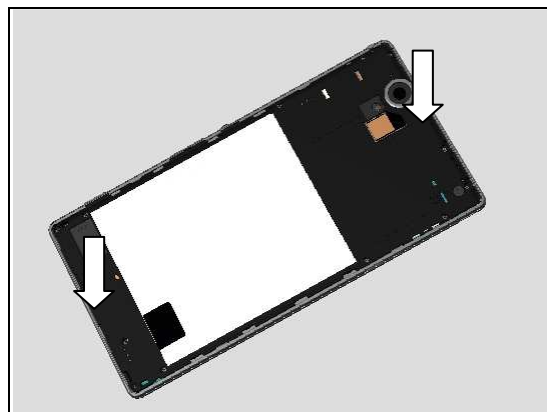
Press to snap this side of the Rear Cover Assy to the Unit.



Do the same for the opposite side.

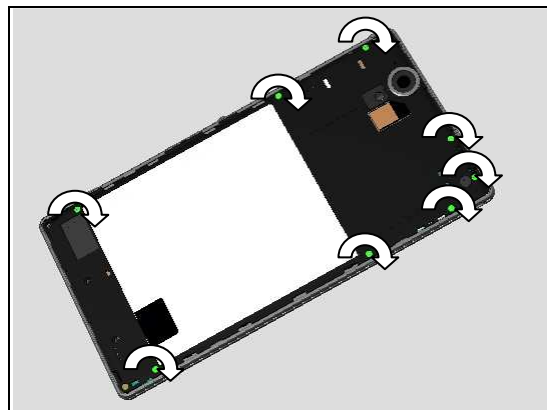


Press along the edge of top side and bottom side to make sure it's snapped properly.

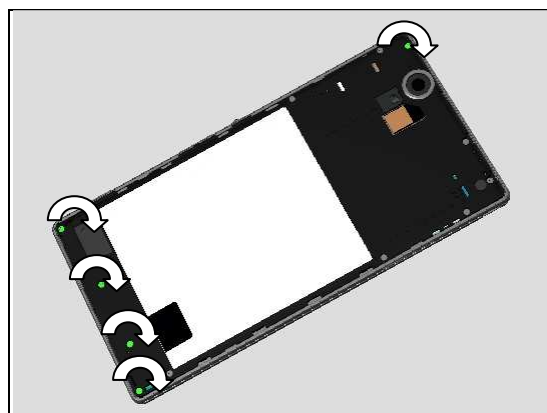


Reassembly

Apply 8 Ncm torque when tightening the Screw Other
Len:0.0 Diam:0.0 with Bits (JCIS No 0).



Apply 10 Ncm torque when tightening the Screw 1.4X3.5
with Bits (JCIS No 0).

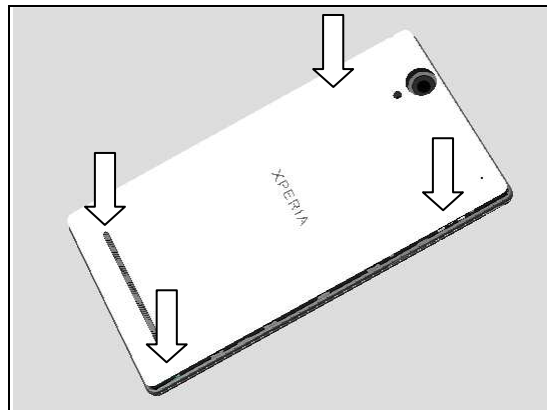


5.6 Battery Cover Assy

Prepare the Battery Cover Assy at its proper position as shown.



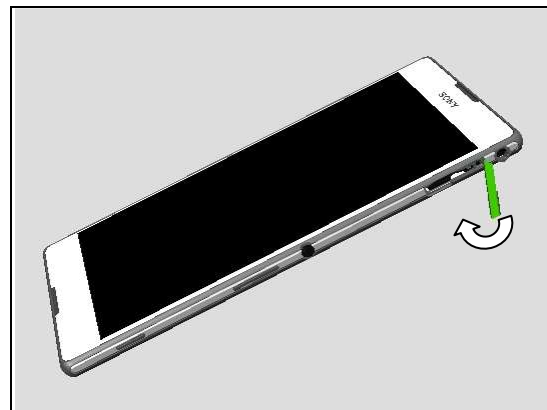
Press the four sides to snap the Battery Cover Assy.



Reassembly

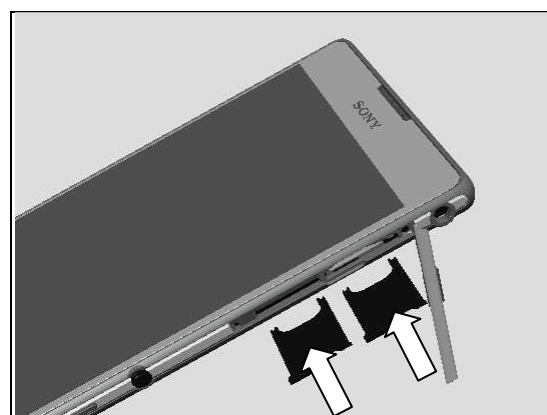
5.7 SIM Tray

Open Cap SIM Single or Cap SIM Dual as shown in picture.



(For D5322, XM50h)

Insert two SIM Trays with fingers as shown in picture.

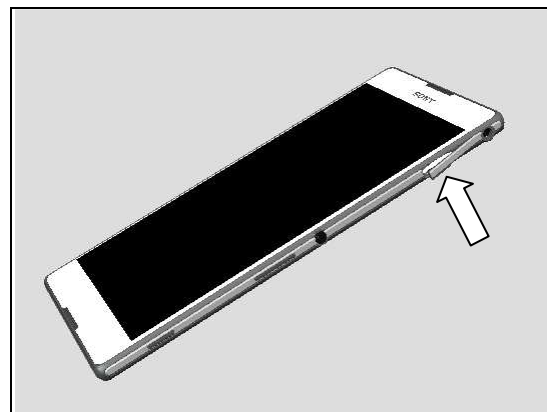


(For D5303, D5306, XM50t)

Insert SIM Tray with fingers as shown in picture.



Close Cap SIM Single or Cap SIM Dual.



6 Revision History

Rev.	Date	Changes/Comments
1	2014-Mar-07	Initial release