

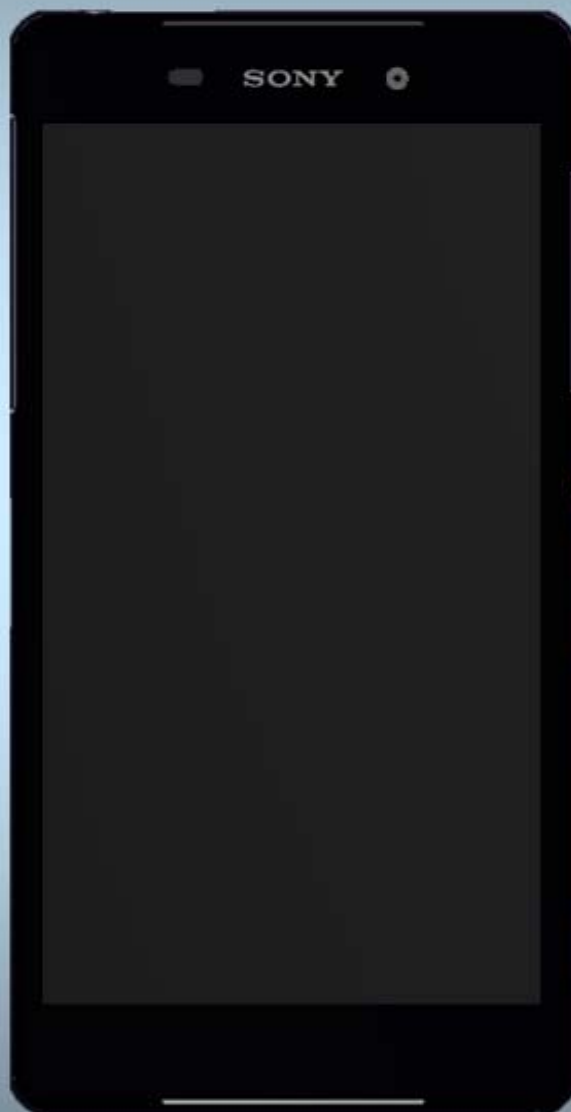
# SONY

make.believe

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## Working Instructions

- mechanical -



**Xperia™ Z2**

**D6502, D6503, D6543, L50w**

## CONTENTS

<b>1</b>	<b>Exterior Views.....</b>	<b>4</b>
1.1	D6502, D6503, D6543 & L50w .....	4
<b>2</b>	<b>Tools .....</b>	<b>5</b>
<b>3</b>	<b>Disassembly.....</b>	<b>6</b>
3.1	SIM Tray .....	6
3.2	Back Panel .....	6
3.3	Adhesive Battery .....	7
3.4	Sheet FPC Battery & Battery .....	8
3.5	Antenna WLAN .....	9
3.6	Main Camera.....	9
3.7	Sheet CU 17 x 4 .....	10
3.8	Front assy & Main PBA.....	10
<b>4</b>	<b>Replacement .....</b>	<b>12</b>
4.1	SIM Tray .....	12
4.2	Back Panel & Adhesive Panel Back.....	12
4.3	Adhesive Battery .....	12
4.4	Sheet FPC Battery .....	12
4.5	Battery.....	13
4.6	Antenna WLAN .....	13
4.7	Main Camera.....	13
4.8	Sheet CU 17 x 4 .....	13
4.9	Display Frame.....	14
4.10	Adhesive MIC Con.....	15
4.11	Cable RF Coax.....	17
4.12	Camera Chat.....	19
4.13	Cap SD .....	20
4.14	Cap USB.....	21
4.15	Core Unit Label.....	22
4.16	Cushion Relay FPC .....	23
4.17	Earspeaker (Top Speaker) & Adhesive Earspeaker .....	24
4.18	FPC Audio Jack & Adhesive Audio Jack.....	26
4.19	FPC CG .....	30
4.20	FPC Relay & Adhesive CU 25 x 6 - 3 pcs & Sheet CU 46 x 5 & Sheet CU 18 x 5.....	32
4.21	Holder 2nd Mic .....	38
4.22	Holder Camera Chat.....	39
4.23	Holder Loudspeaker & Adhesive Loudspeaker Lid & Adh Speaker Back & Adh VIB Conn & Adh with mesh 14 x 5.....	40
4.24	PBA Antenna .....	49

4.25	Plate Speaker.....	50
4.26	Ring Audio Jack.....	52
4.27	Sheet Battery Adhesive Top.....	53
4.28	Sheet LCD 18 x 7 .....	54
4.29	Sheet LCD 7 x 7 .....	54
4.30	Sheet Thermal Conductive .....	55
4.31	Shield Camera .....	56
4.32	Spacer 10 x 4 .....	57
4.33	Tray Core Unit Label .....	58
4.34	Water indicator I.....	59
4.35	Water indicator II .....	60
4.36	Vibrator & Adhesive VIB & Spacer 5 x 2.5.....	61
4.37	Cushion Cam .....	63
4.38	Sheet Guide Label.....	64
4.39	Sheet 5x10 .....	65
4.40	Spacer 8x5 .....	66
4.41	Sheet 1st MIC.....	67
4.42	Board Swap - Replacement .....	68
4.43	Board Swap – Change Label .....	69
4.44	Board Swap – Customize of Software .....	69
5	Reassembly.....	70
5.1	Front assy & Main PBA.....	70
5.2	Sheet CU 17 x 4 .....	71
5.3	Main Camera.....	72
5.4	Antenna WLAN .....	72
5.5	Battery & Sheet FPC Battery .....	73
5.6	Adhesive Battery.....	75
5.7	Back Panel with Adhesive Panel Back .....	75
5.8	SIM Tray .....	79
6	Revision History .....	80

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

## 1 Exterior Views

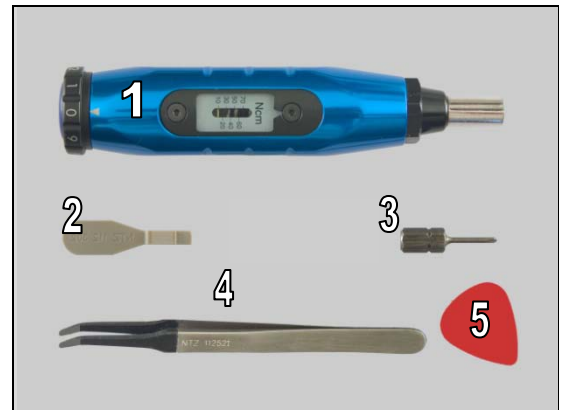
### 1.1 D6502, D6503, D6543 & L50w



## 2 Tools

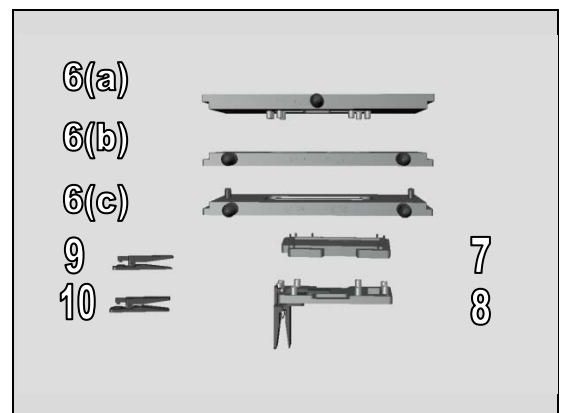
### SPECIAL TOOLS

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



- 6a & c. Top and Bottom Press
- 6b. Top press inlay no 2

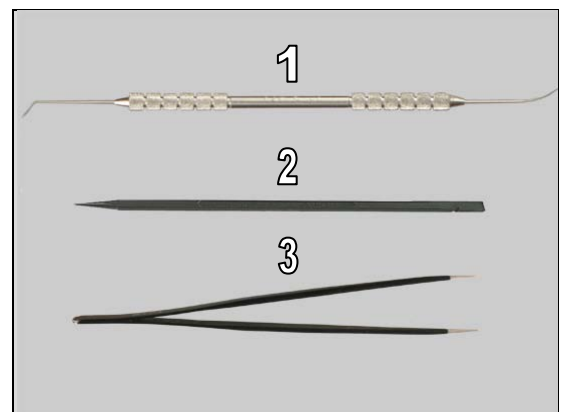
7. Rear Panel Adhesive Align Fixture
8. Audio Jack Press
9. Earspeaker/Loudspeaker Top
10. Speaker Holder Press



**For part no's on the tools above, refer to the 'Tools Catalogue/Matrix'.**

### STANDARD TOOLS

1. Dentist Hook
2. Nylon Pointer
3. Tweezers



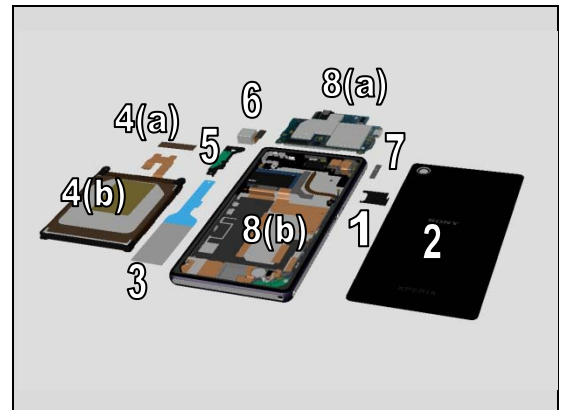
4. Suction Cup



## 3 Disassembly

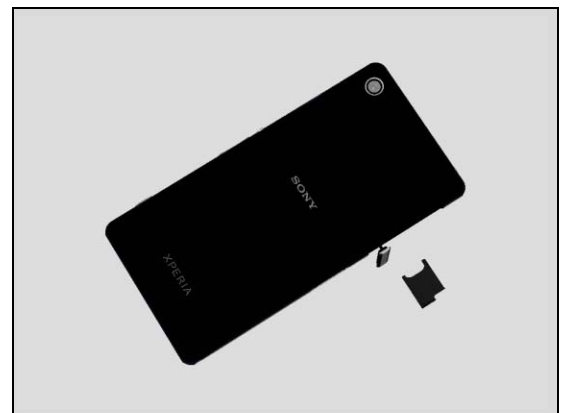
The disassembly is done in the following order:

1. SIM Tray
2. Back Panel
3. Adhesive Battery
4. Sheet FPC Battery (a) & Battery (b)
5. Antenna WLAN
6. Main Camera
7. Sheet CU 17 x 4
8. Front assy (a) & Main PBA (b)



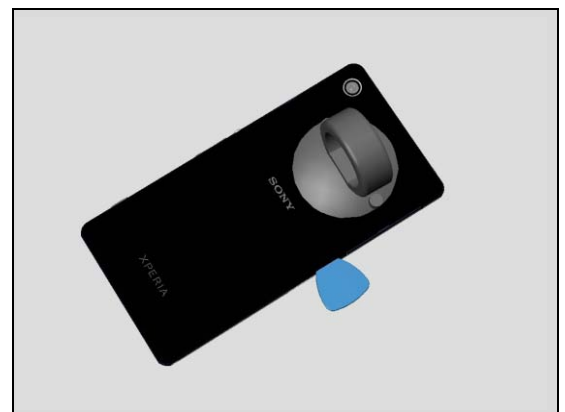
### 3.1 SIM Tray

Open the Cap USB and remove the SIM card and the SIM Tray.

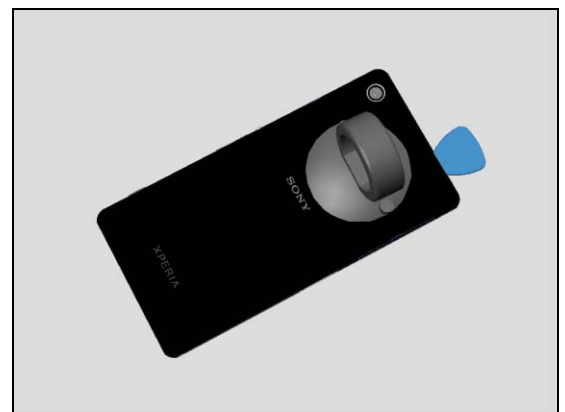


### 3.2 Back Panel

Attach the Suction cup, insert the Guitar Pick.

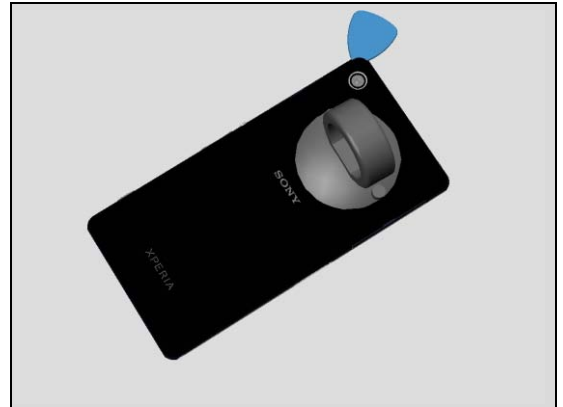


Slide along all sides.

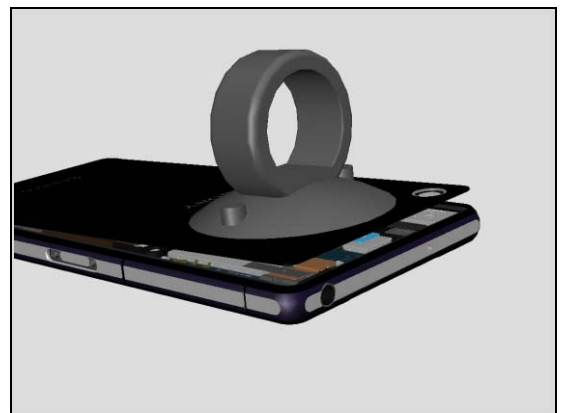


## Disassembly

Be careful not to damage the camera.

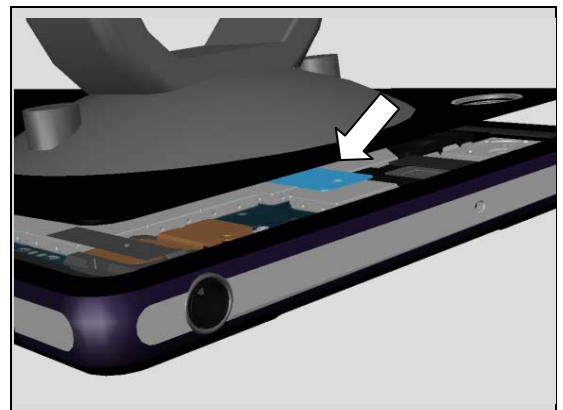


Lift up the upper part of the Back Panel slightly.



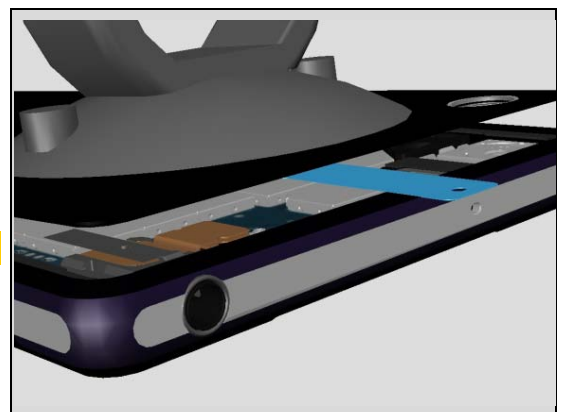
### 3.3 Adhesive Battery

Capture the Adhesive Battery tab.



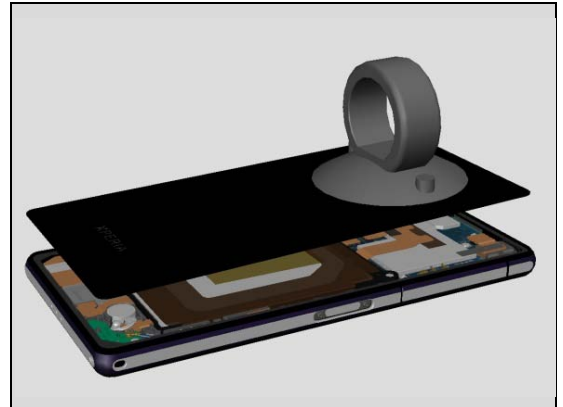
Pull the tab slowly in a horizontal direction until you removed the adhesive completely.

**Scrap! Not to be reused.**

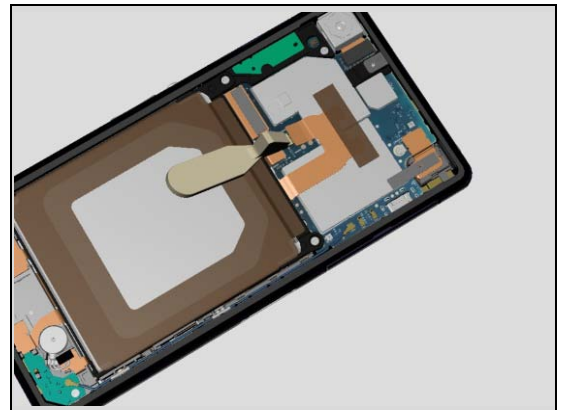


## Disassembly

Remove the back Panel.



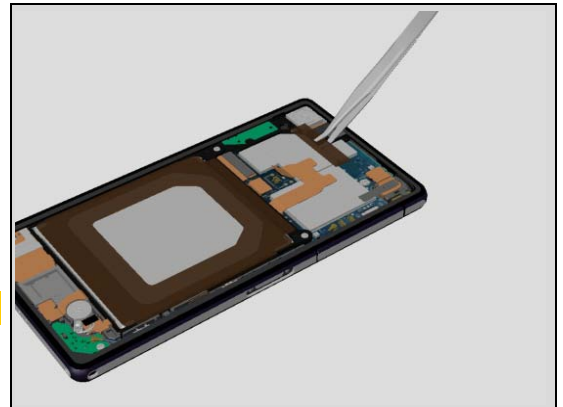
Unsnap the BtB connector of the Battery.



### 3.4 Sheet FPC Battery & Battery

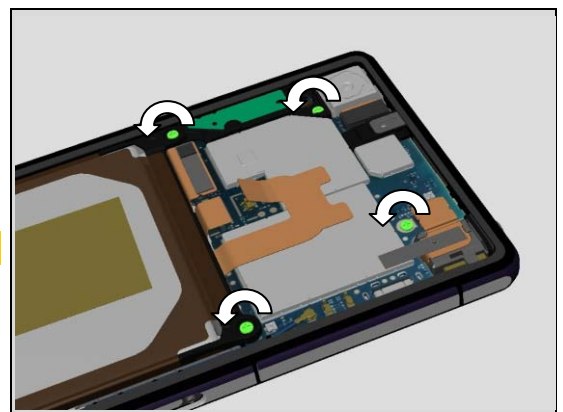
Remove the Sheet FPC Battery.

**Scrap! Not to be reused.**



Remove the four Screws by using a screwdriver with Bits (JCIS No 0).

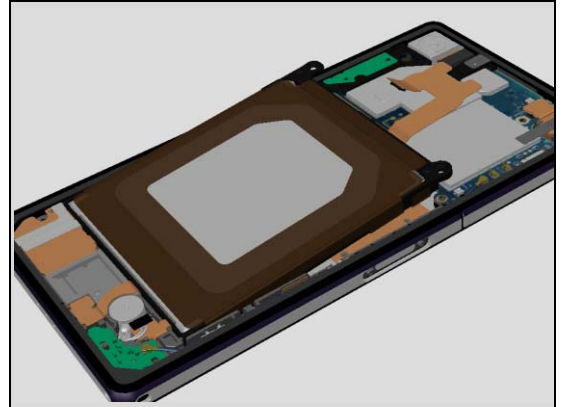
**Scrap! Not to be reused.**





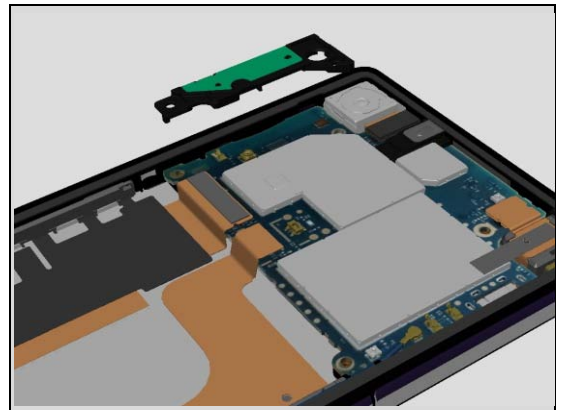
## Disassembly

Lift up the Battery in an angle and remove the Battery.



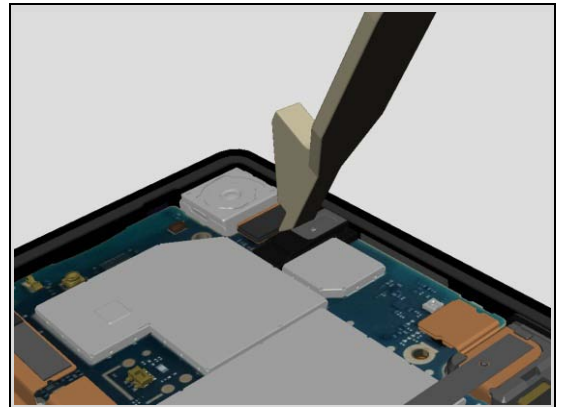
### 3.5 Antenna WLAN

Remove the Antenna WLAN.

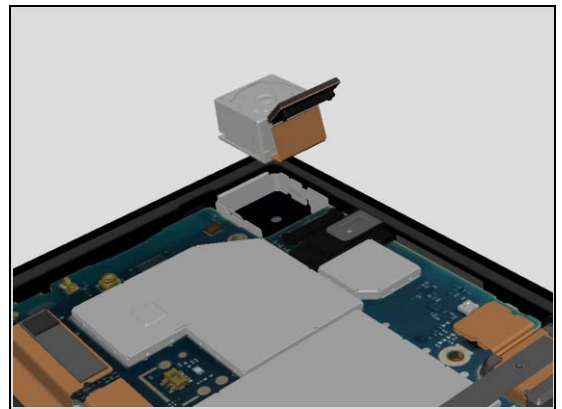


### 3.6 Main Camera

Unsnap the BtB connector of the Camera.



Remove the Camera. Be careful not to damage it.

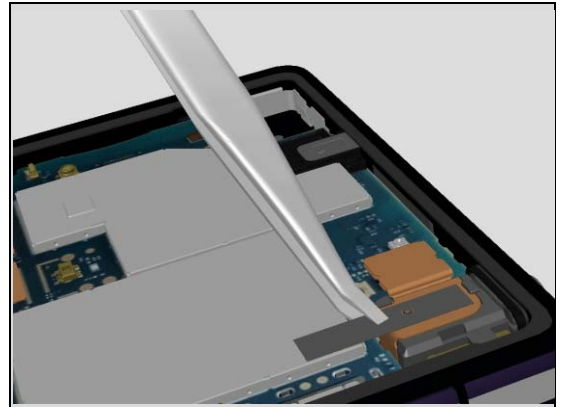


## Disassembly

### 3.7 Sheet CU 17 x 4

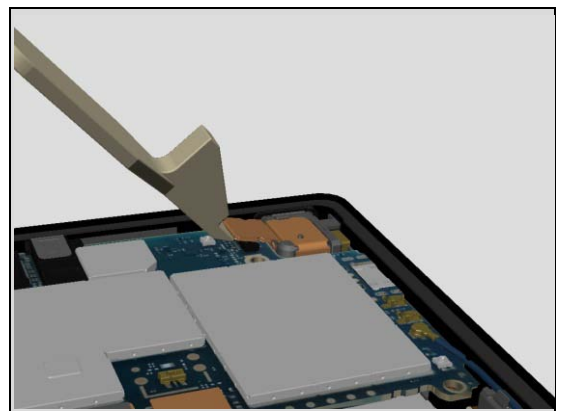
Remove the Sheet CU 17 x 4.

**Scrap! Not to be reused.**

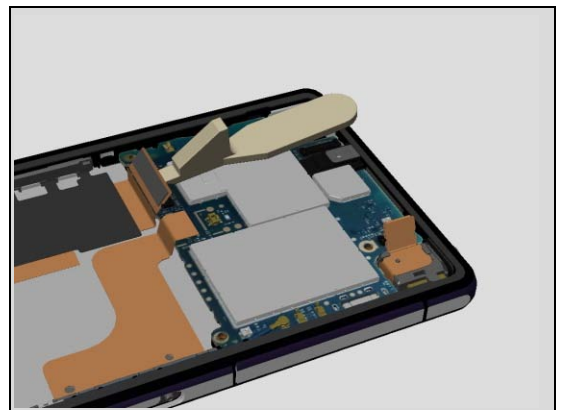


### 3.8 Front assy & Main PBA

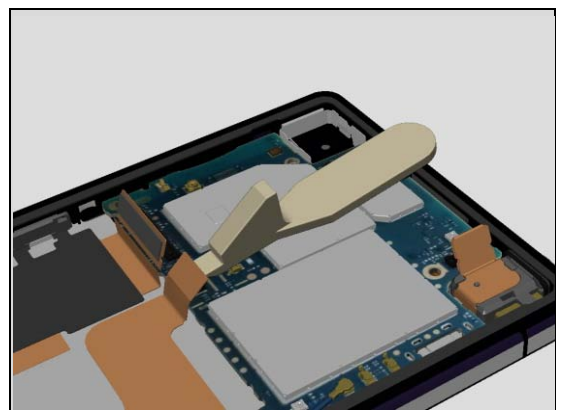
Unsnap the BtB connector of FPC Audio Jack.



Unsnap the BtB connector of FPC Relay.

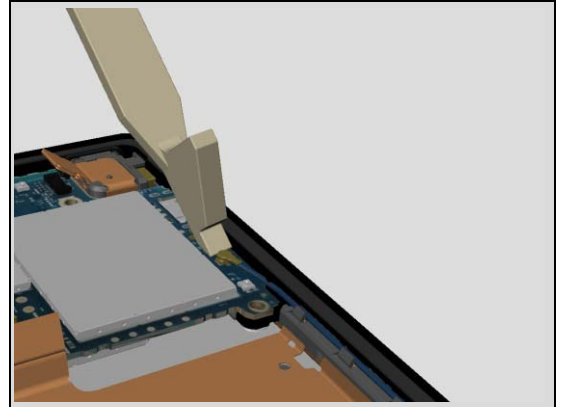


Unsnap the BtB connector of FPC CG.

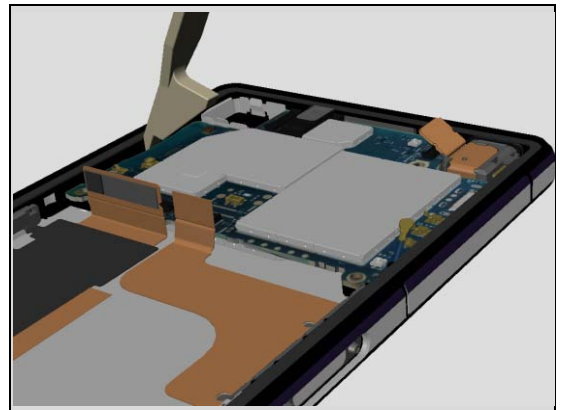


## Disassembly

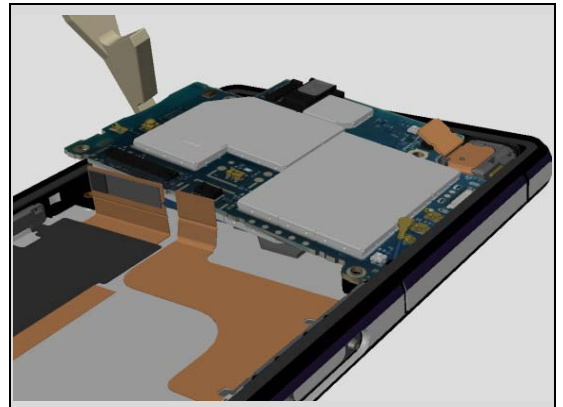
Unsnap the connector of Cable RF Coax.



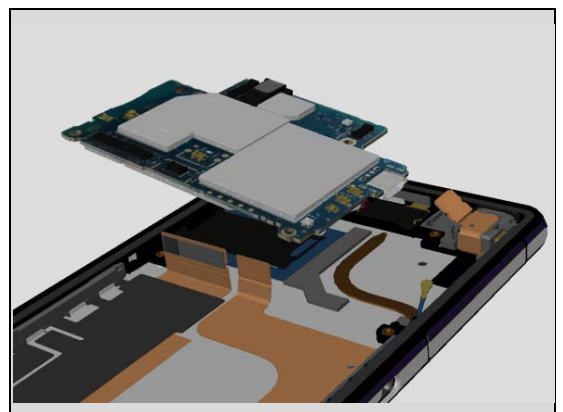
Insert the Front Opening Tool to release the Main PBA.



Lift the main PBA.



Separate the Main PBA from the Front assy.



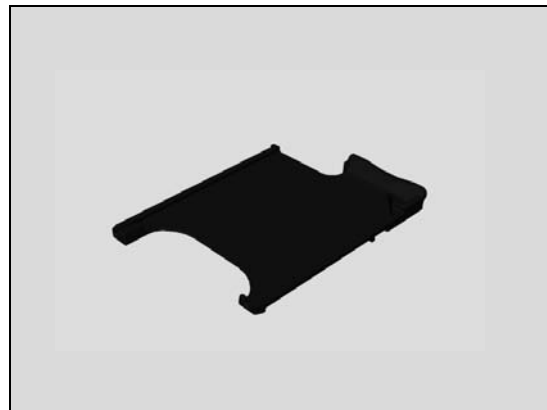
## 4 Replacement

### 4.1 SIM Tray

*Follow the 3.1 Disassembly instructions!*

Prepare the new SIM Tray.

*Follow the 5.8 Reassembly instructions!*



### 4.2 Back Panel & Adhesive Panel Back

*Follow the 3.1 – 3.2 Disassembly instructions!*

Prepare the new Back Panel with Adhesive Panel Back.

*Follow the 5.7 – 5.8 Reassembly instructions!*

**Scrap! Do not reuse the Adhesive Panel Back.**



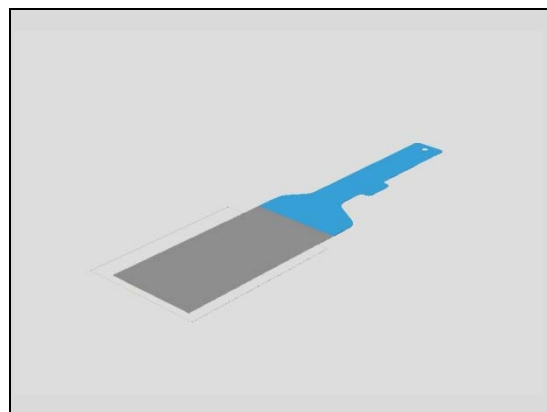
### 4.3 Adhesive Battery

*Follow the 3.1 – 3.3 Disassembly instructions!*

Prepare the new Adhesive Battery.

*Follow the 5.6 – 5.8 Reassembly instructions!*

**Scrap! Do not reuse the Adhesive Battery.**



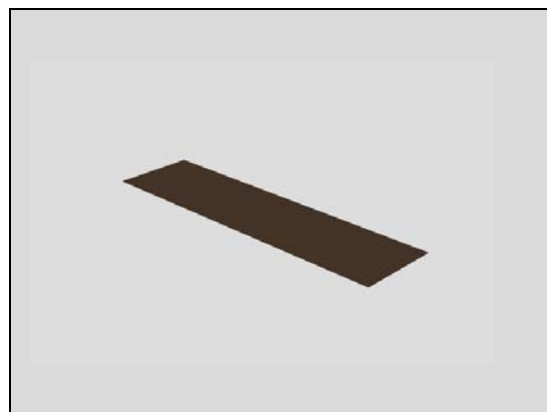
### 4.4 Sheet FPC Battery

*Follow the 3.1 – 3.4 Disassembly instructions!*

Prepare the new Sheet FPC Battery.

*Follow the 5.5 – 5.8 Reassembly instructions!*

**Scrap! Do not reuse the Sheet FPC Battery.**



## Replacement

### 4.5 Battery

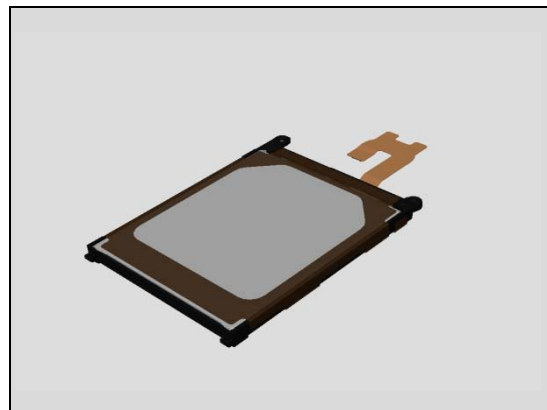
*Follow the 3.1 – 3.4 Disassembly instructions!*

*Prepare the new Sheet FPC Battery.*

*Follow the 4.27 Replacement instructions.*

*Follow the 5.5 – 5.8 Reassembly instructions!*

**Visual Inspection of the Battery.**

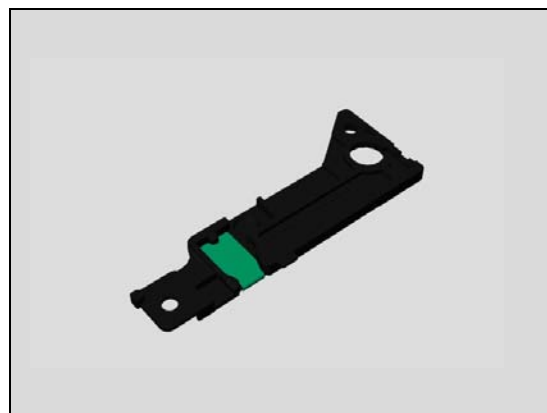


### 4.6 Antenna WLAN

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Prepare the new Antenna WLAN.*

*Follow the 5.4 – 5.8 Reassembly instructions!*

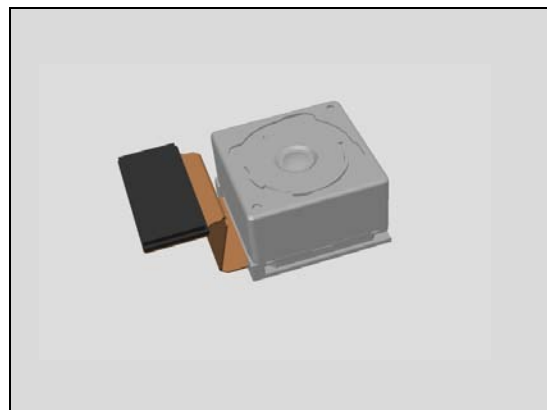


### 4.7 Main Camera

*Follow the 3.1 – 3.6 Disassembly instructions!*

*Prepare the new Main Camera.*

*Follow the 5.3 – 5.8 Reassembly instructions!*



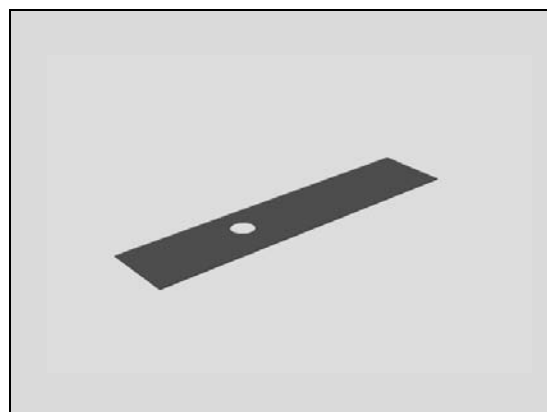
### 4.8 Sheet CU 17 x 4

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Prepare the new Sheet CU 17 x 4.*

*Follow the 5.2 – 5.8 Reassembly instructions!*

**Scrap! Do not reuse the Sheet CU 17 x 4.**



## Replacement

### 4.9 Display Frame

*Follow the 3.1 – 3.8 Disassembly instructions!*

*Follow the 4.11, 4.19, 4.20, 4.23, 4.30, 4.37, 4.39, 4.40 Removal instructions!*

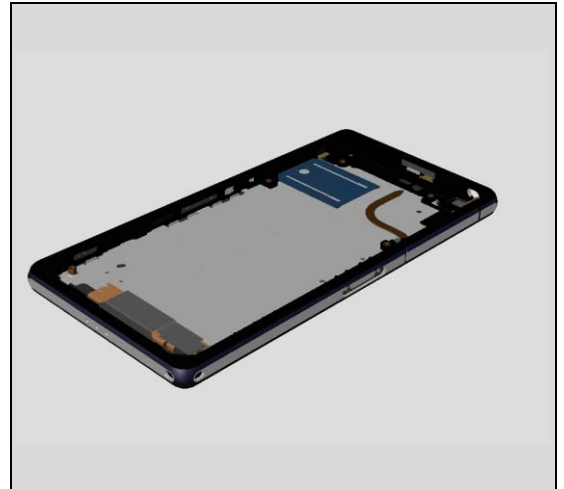
Carry out the Removal as described below.

Prepare the new Display Frame.

Carry out the Installation as described below.

*Follow the 4.39, 4.11, 4.19, 4.20, 4.23, 4.40, 4.30, 4.37 Installation instructions!*

*Follow the 5.1 – 5.8 Reassembly instructions!*



## Replacement

### 4.10 Adhesive MIC Con

*Follow the 3.1 – 3.3 Disassembly instructions!*

Carry out the Removal as described below.

Prepare the new Adhesive MIC Con.

Carry out the Installation as described below.

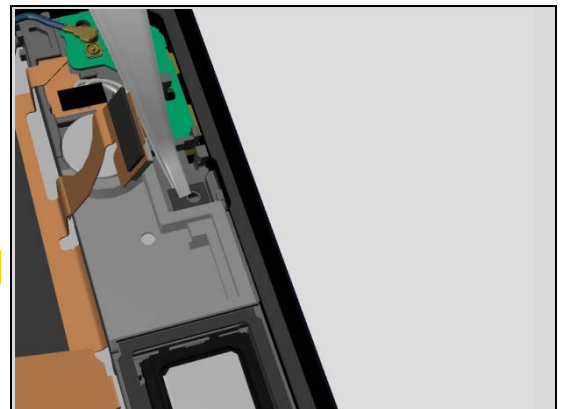
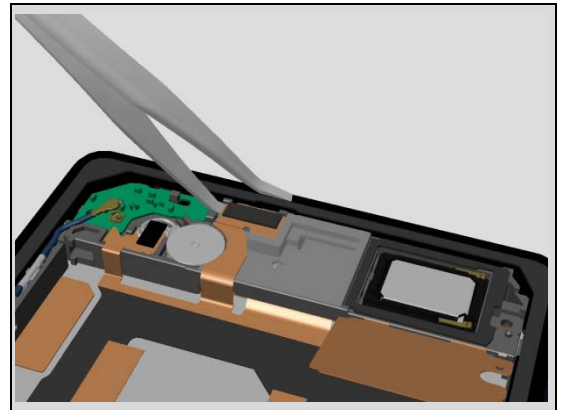
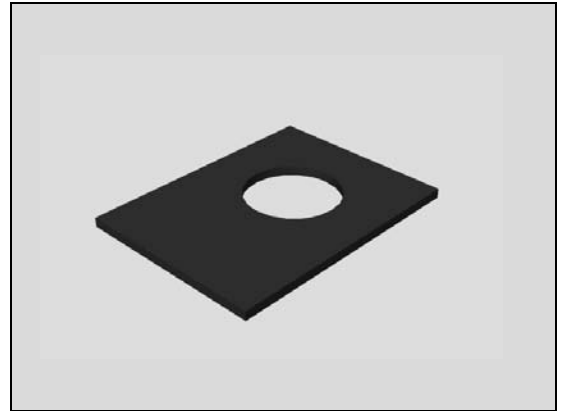
*Follow the 5.6 – 5.8 Reassembly instructions!*

#### REMOVAL

Lift the flex over the MIC with the Flex Film Assembly Tool.

Remove the Adhesive MIC Con. Remove all remains of the adhesive residue found on the Holder Loud speaker and the MIC.

**Scrap! Not to be reused!**

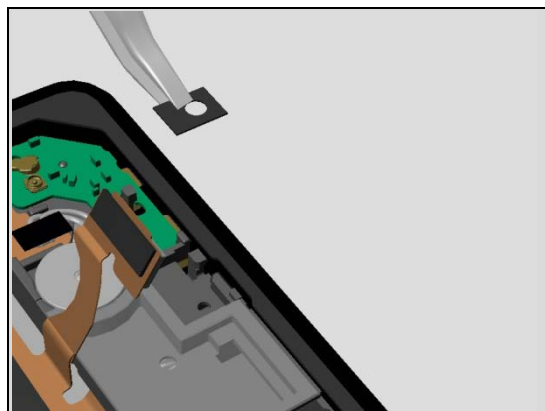




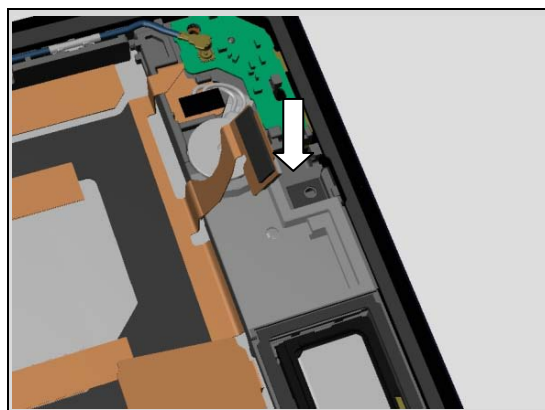
## Replacement:

### INSTALLATION

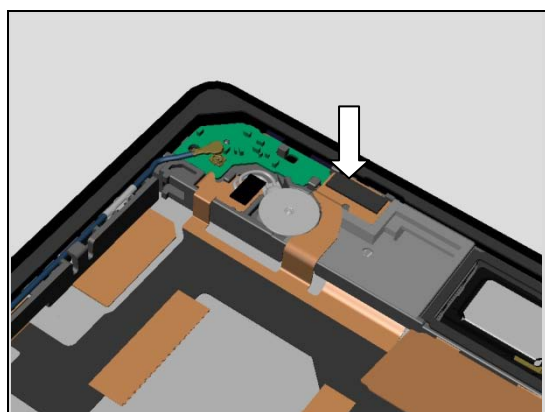
Place a new Adhesive MIC Con in the correct position.



Press gently.



Attach the flex and press to secure its attachment.





## Replacement

### 4.11 Cable RF Coax

*Follow the 3.1 – 3.3 Disassembly instructions!*

Carry out the Removal as described below.

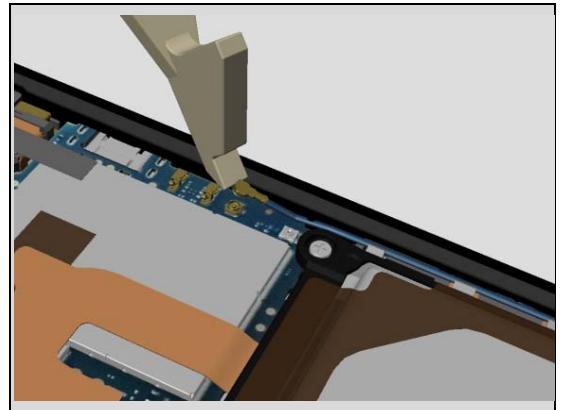
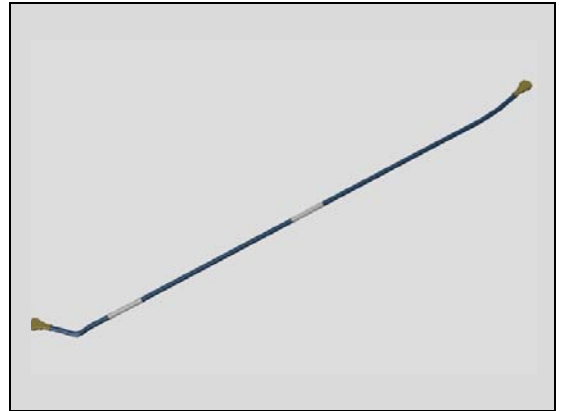
Prepare the new Cable RF Coax.

Carry out the Installation as described below.

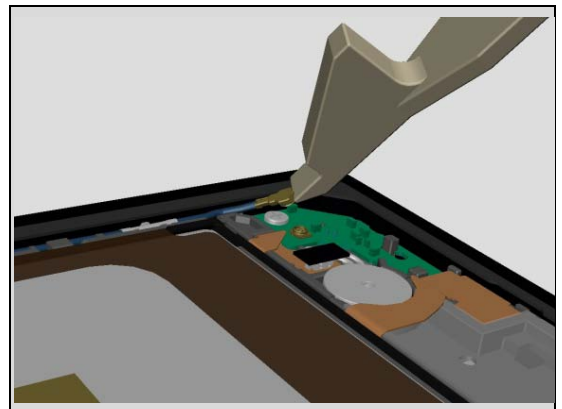
*Follow the 5.6 – 5.8 Reassembly instructions!*

#### REMOVAL

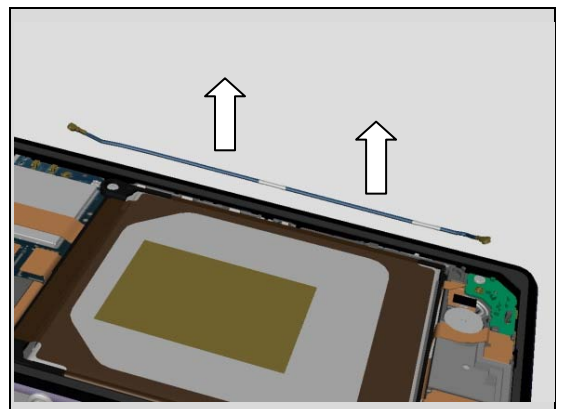
Disconnect the Cable RF Coax from the Main PBA.



Disconnect the Cable RF Coax from the PBA Antenna.



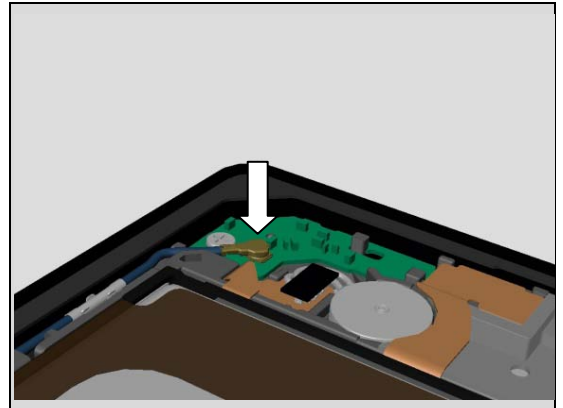
Unsnap and remove the Cable RF Coax.



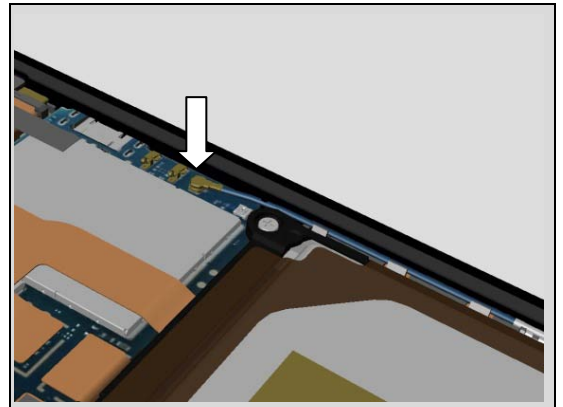
## Replacement:

### INSTALLATION

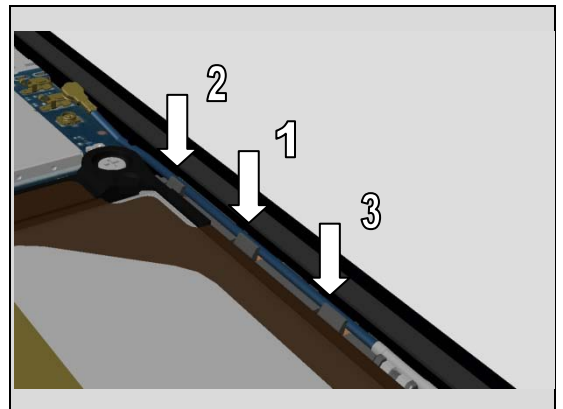
Connect the Cable RF Coax to the PBA Antenna.



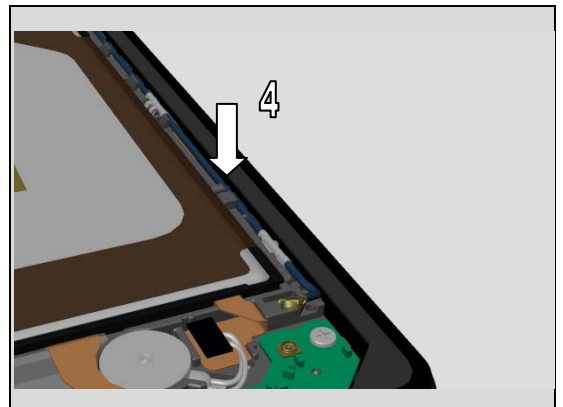
Connect the Cable RF Coax to the Main PBA.



Insert the Cable to the four hooks Nylon Pointer.



Visual check that the Cable is well fixed to the hooks. No parts of the Cable should be higher than the inner frame of the Display Frame.



## Replacement

### 4.12 Camera Chat

*Follow the 3.1 – 3.8 Disassembly instructions!*

*Follow the 4.22 Removal instructions!*

Carry out the Removal as described below.

Prepare the new Camera Chat.

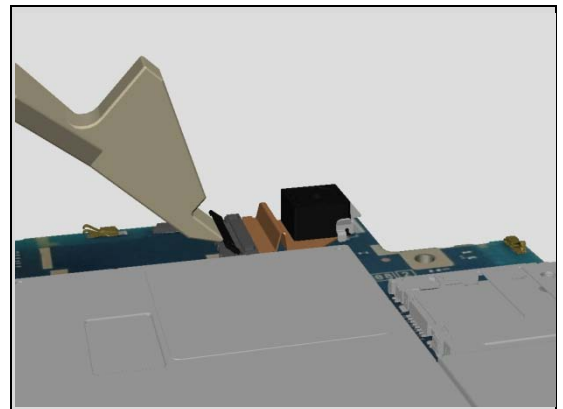
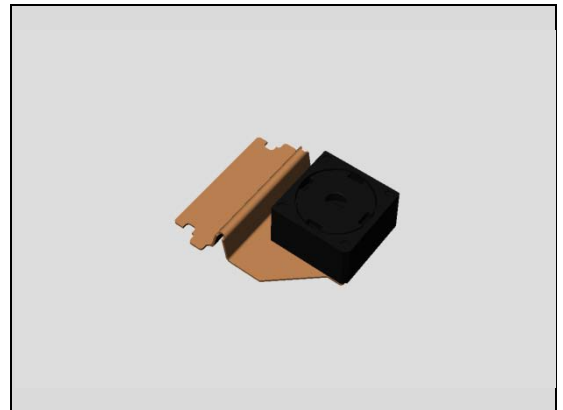
Carry out the Installation as described below.

*Follow the 4.22 Installation instructions!*

*Follow the 5.1 – 5.8 Reassembly instructions!*

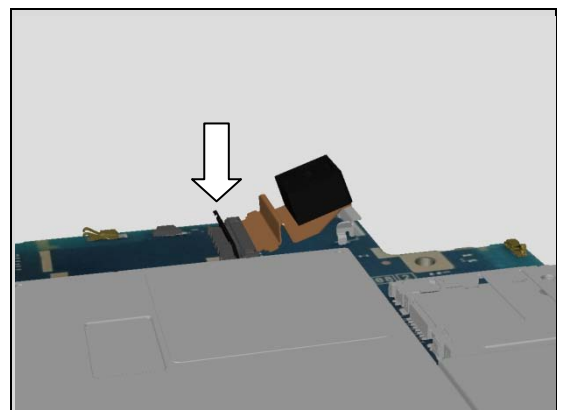
#### REMOVAL

Open the connector and remove the Camera Chat.

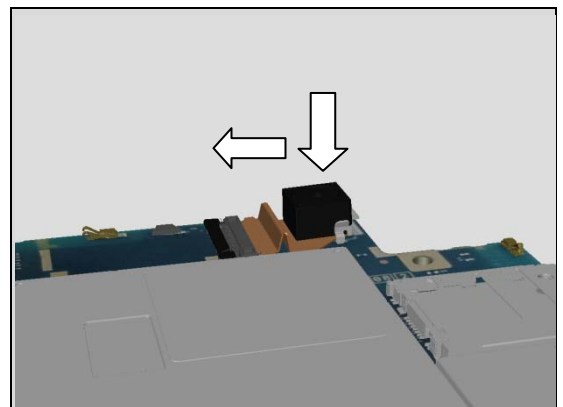


#### INSTALLATION

Insert the Camera flex into the ZIF connector. Align the two wings on the flex. Close the connector with your finger.



Push the Camera forward and down to secure the position in the shield fence. Do not touch the lens.



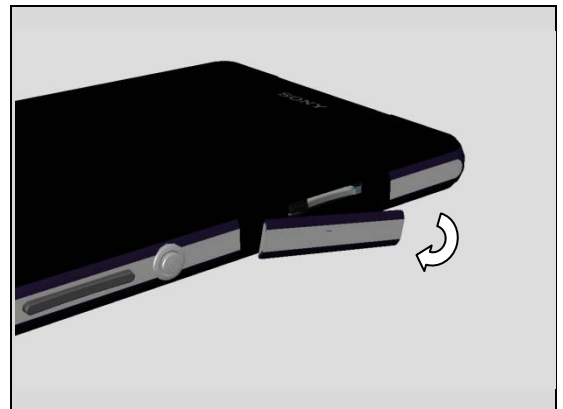
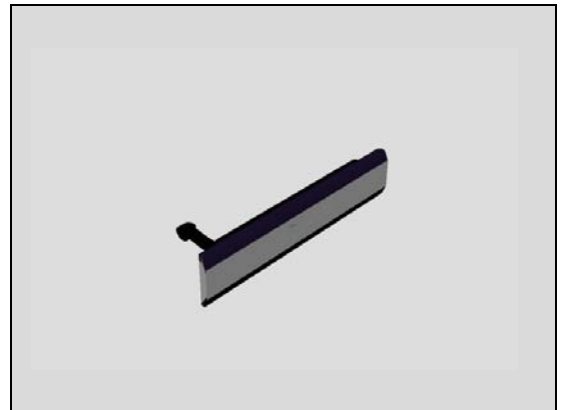
## Replacement

### 4.13 Cap SD

Carry out the Removal as described below.  
Prepare the new Cap SD.  
Carry out the Installation as described below.

#### REMOVAL

Turn the Cap SD and pull.  
The head of the plug is oval.

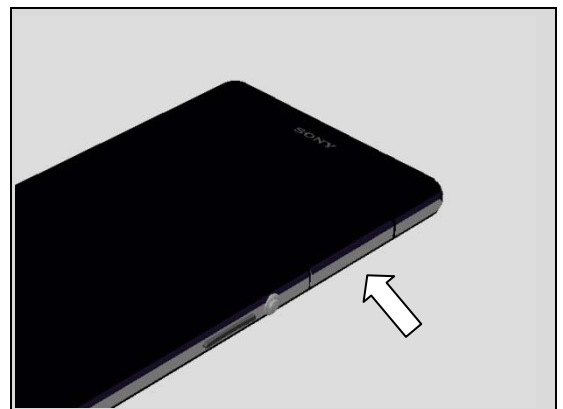


#### INSTALLATION

Place a new Cap SD in the correct position.



Press to secure its position.



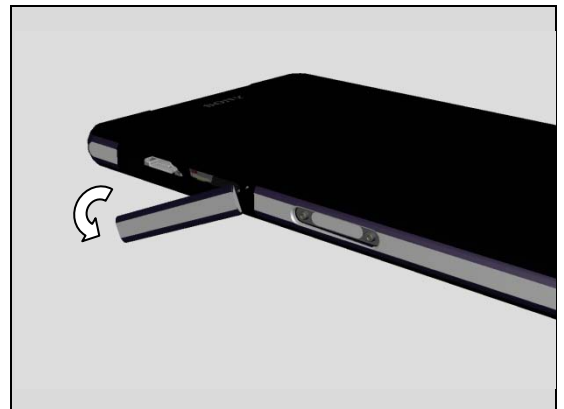
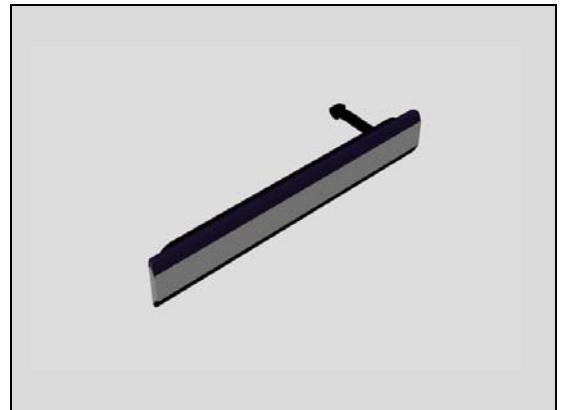
## Replacement

### 4.14 Cap USB

Carry out the Removal as described below.  
Prepare the new Cap USB.  
Carry out the Installation as described below.

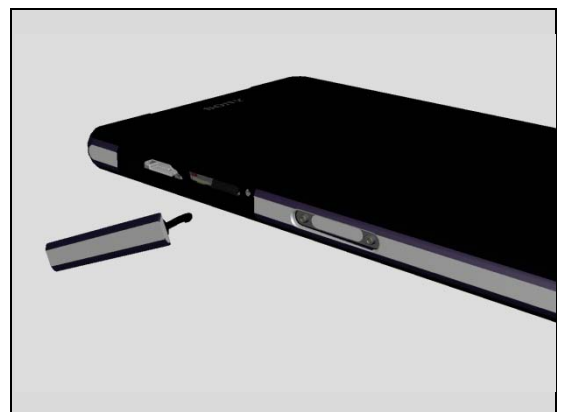
#### REMOVAL

Turn the Cap USB and pull.  
The head of the plug is oval.



#### INSTALLATION

Place a new Cap USB in the correct position.



Press to secure its position.



## Replacement

### 4.15 Core Unit Label

Carry out the Removal as described below.  
Prepare the new Core Unit Label.  
Carry out the Installation as described below.

#### REMOVAL

Read the old Core Unit Label and write the information into the "LabelPrint Solution" program.

Open the Cap SD and pull out the Label Tray.  
Remove the Core Unit Label.

**Scrap Core Unit Label, not to be reused.**

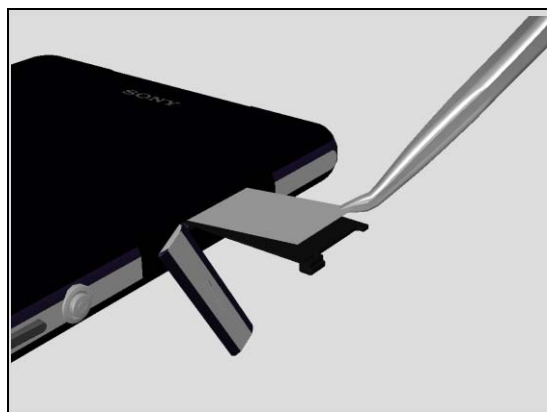
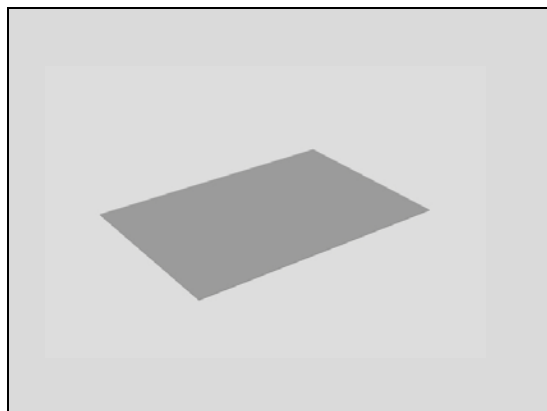
*Remove and clean any remaining adhesive residue found on Label Tray.*

#### INSTALLATION

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

Place and align a new Core Unit Label in the correct position. Press with a finger to secure the attachment.

**One label only is allowed.**



## Replacement

### 4.16 Cushion Relay FPC

*Follow the 3.1 – 3.3 Disassembly instructions!*

Carry out the Removal as described below.

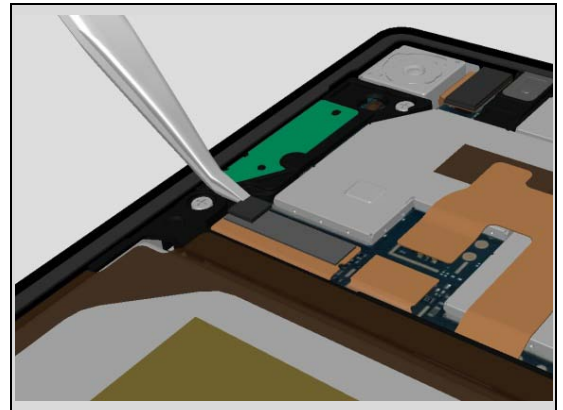
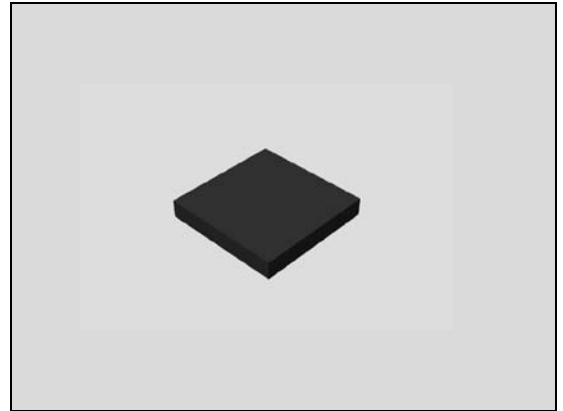
Prepare the new Cushion Relay FPC.

Carry out the Installation as described below.

*Follow the 5.6 – 5.8 Reassembly instructions!*

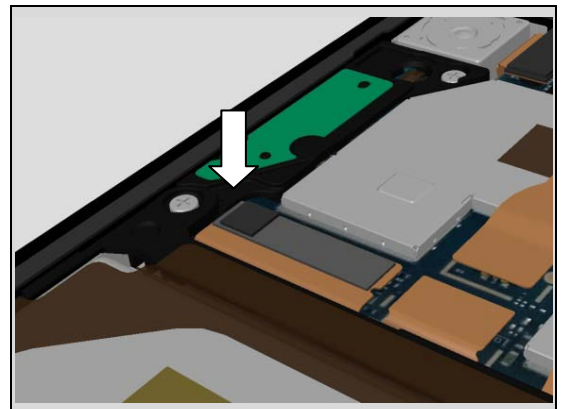
#### REMOVAL

Remove the Cushion Relay FPC.



#### INSTALLATION

Align by the top left corner of the Spacer on the BtB connector. Press gently with your finger to secure the attachment.



## Replacement

### 4.17 Earspeaker (Top Speaker) & Adhesive Earspeaker

*Follow the 3.1 – 3.8 Disassembly instructions!*

Carry out the Removal as described below.

Prepare the new Earspeaker with Adhesive.

Carry out the Installation as described below.

*Follow the 5.1 – 5.8 Reassembly instructions!*

#### REMOVAL

Remove the old Earspeaker.

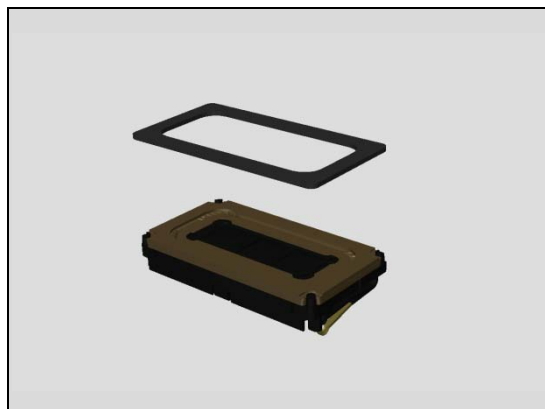
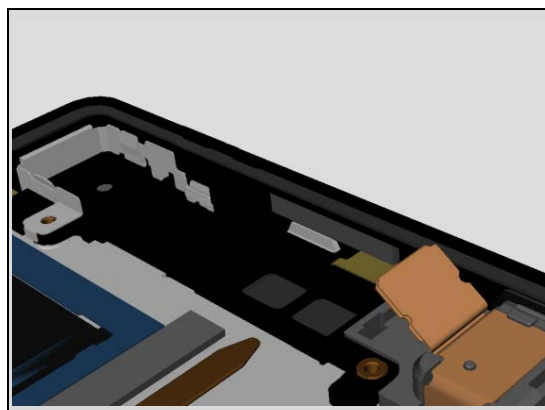
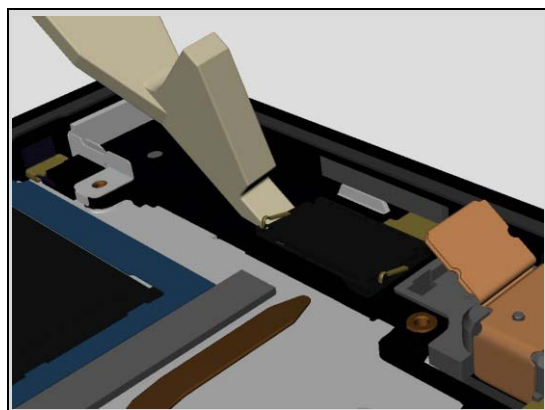
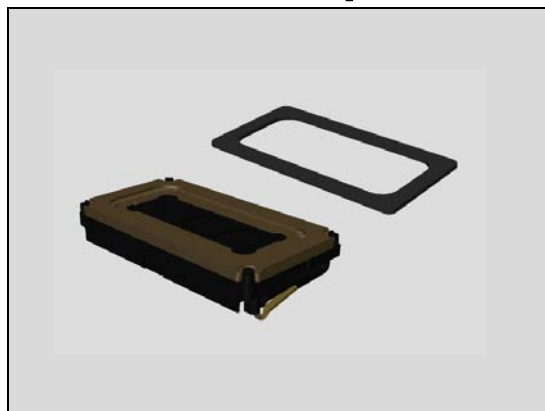
**Scrap! Not to be reused!**

Remove the old Adhesive and all remains of the Adhesive residue found in the cavity.

#### INSTALLATION

Clean the Earspeaker carefully before the new Adhesive Earspeaker is attached to secure the water resistant.

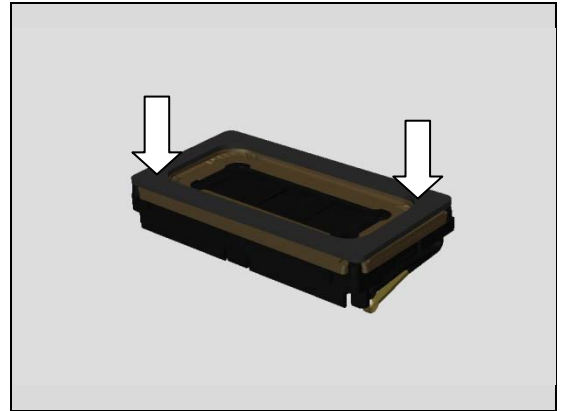
Align a new Adhesive Earspeaker on the Earspeaker without any wrinkles.



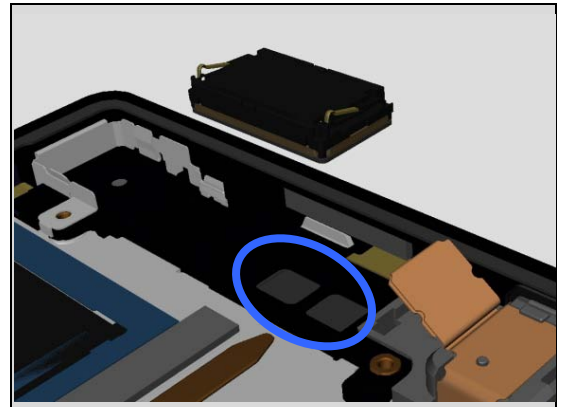


## Replacement:

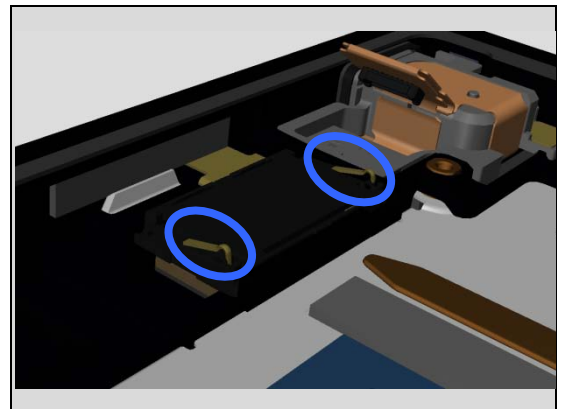
Press to secure its attachment of the Adhesive.



Clean the cavity carefully with alcohol before the new Earspeaker is mounted. This action is done to secure the water resistant of the unit.

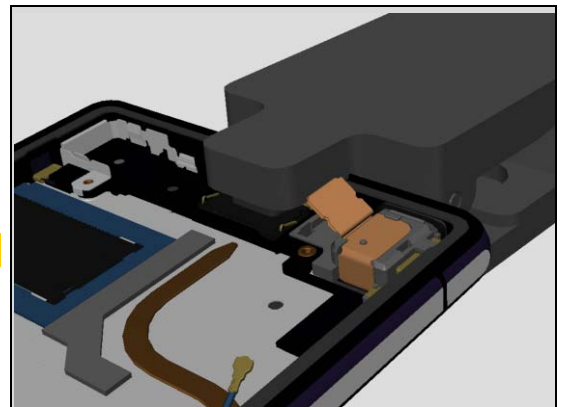


Place the new Earspeaker in a proper position as shown in the picture.



Press for 5 seconds with the Earspeaker/Loudspeaker Top to secure the attachment.

**Do not touch the pins of the Earspeaker!**



## Replacement

### 4.18 FPC Audio Jack & Adhesive Audio Jack

*Follow the 3.1 – 3.8 Disassembly instructions!*

Carry out the Removal as described below.

Prepare the new FPC Audio Jack with Adhesive.

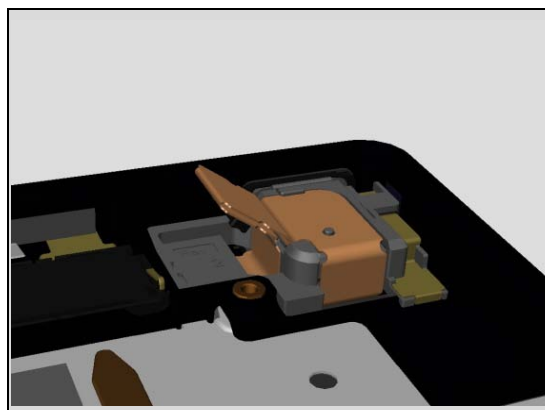
Carry out the Installation as described below.

*Follow the 5.1 – 5.8 Reassembly instructions!*

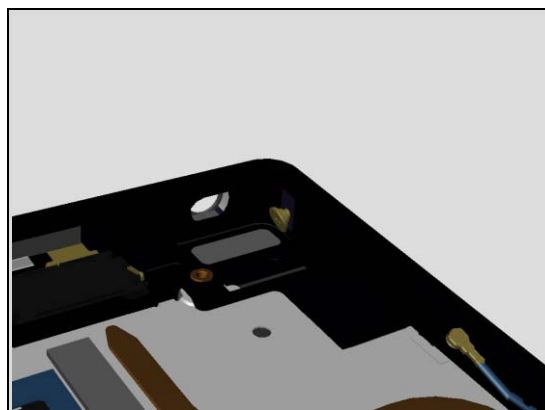


#### REMOVAL

Remove the FPC Audio Jack gently.

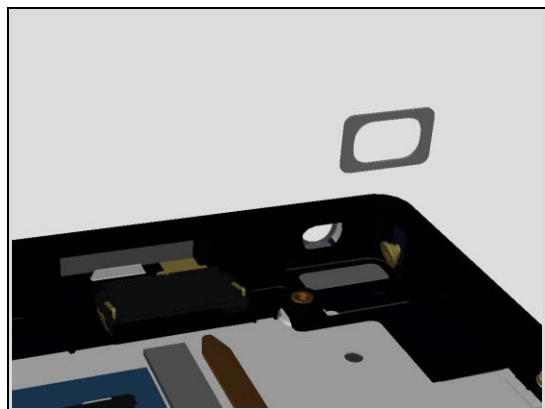


Remove the old Adhesive and all remains of the Adhesive residue found in the cavity.



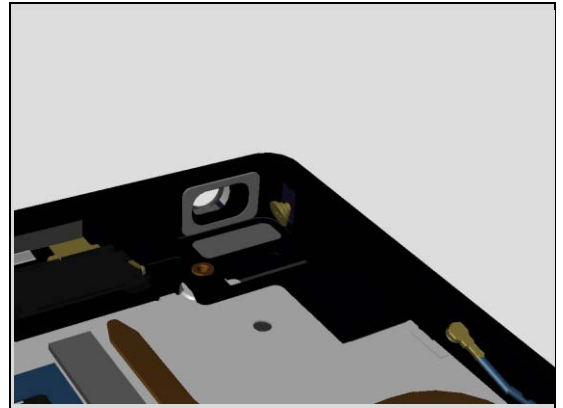
#### INSTALLATION

Clean the cavity carefully with alcohol (twice) before the new Adhesive Audio Jack is mounted. This action is done to secure the water resistant of the unit.

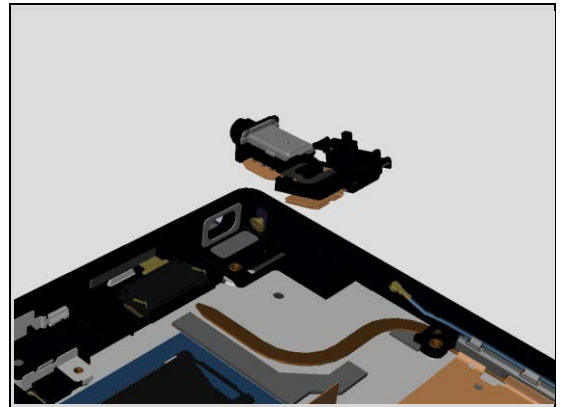


## Replacement:

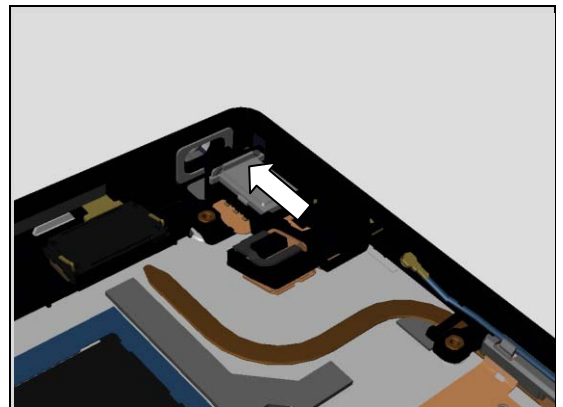
Align the Adhesive Audio Jack without any wrinkles.



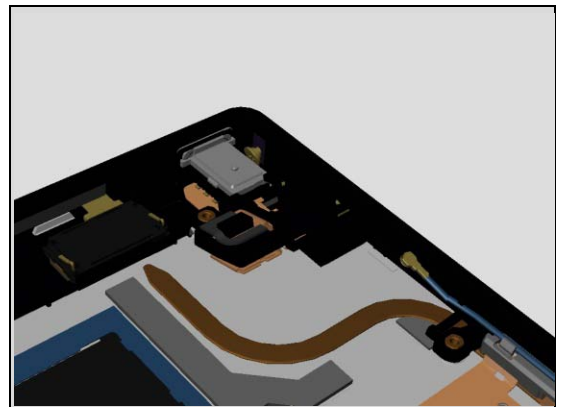
Prepare a new FPC Audio Jack.



Place the FPC Audio Jack and push gently forward ...

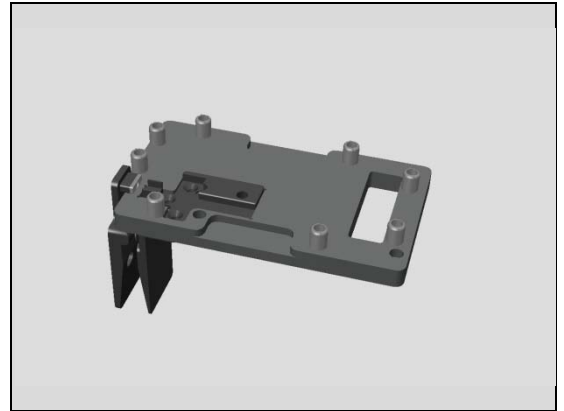


... to the correct position. Don't reverse the movement to avoid any malfunction of water resistant of the Adhesive.

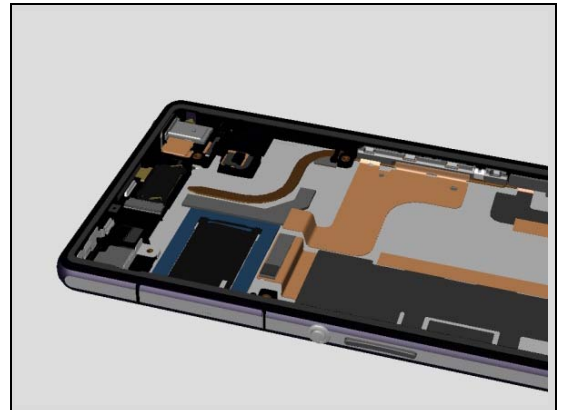


## Replacement:

Use the Audio Jack Press ...



... to secure the attachment of the FPC Audio Jack.



Place the unit in the fixture.

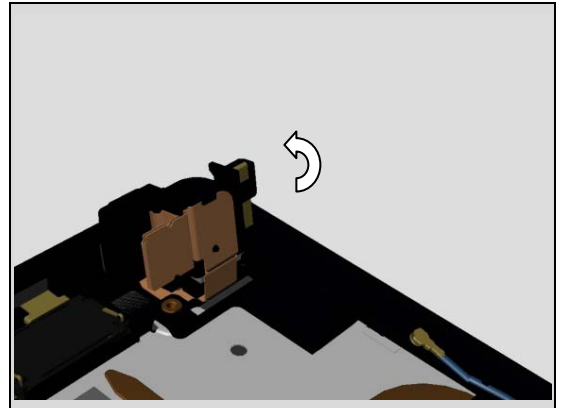


Press for ten seconds with the Audio Jack Press to secure the attachment.



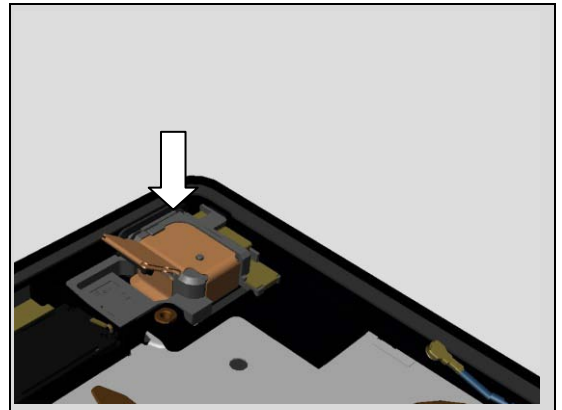
## Replacement:

Turn over the rear part of the FPC Audio Jack.



Align and press gently with your finger to secure the attachment.

Be careful with the BtB flex of the FPC Audio Jack, no twist or pull of this section. Check that the FPC Audio Jack isn't damaged and properly fixed.



## Replacement

### 4.19 FPC CG

*Follow the 3.1 – 3.4 Disassembly instructions!*

Carry out the Removal as described below.

Prepare the new FPC CG.

Carry out the Installation as described below.

*Follow the 5.5 – 5.8 Reassembly instructions!*

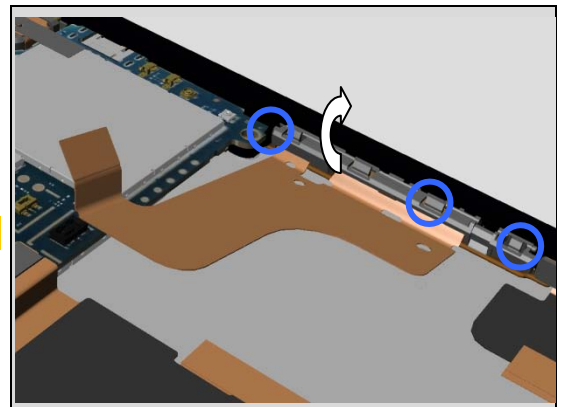
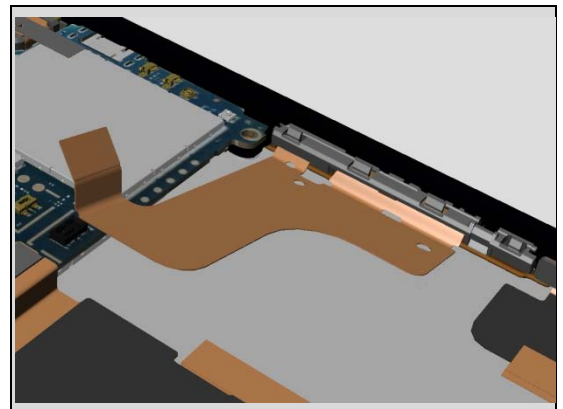
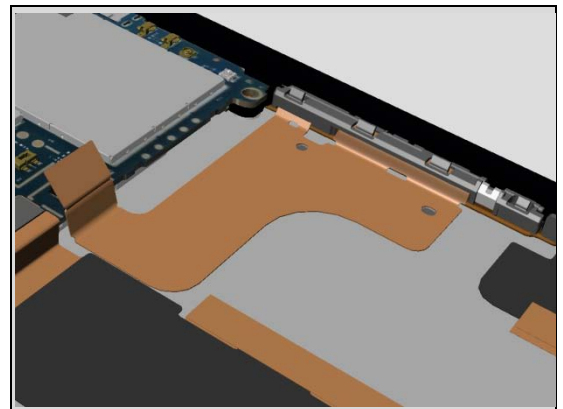
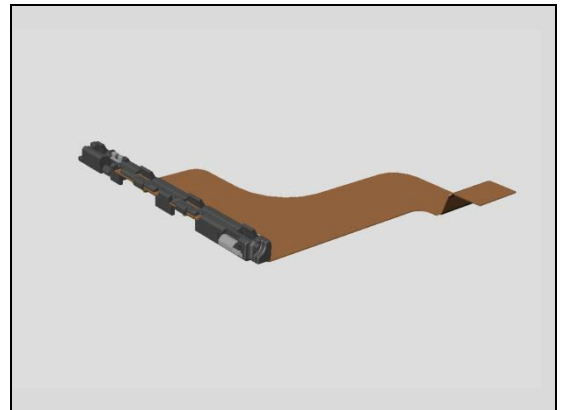
#### REMOVAL

Unsnap the BtB between FPC CG and Main PBA.

Lift the flex to release the adhesive.

Rotate to release the three hooks.

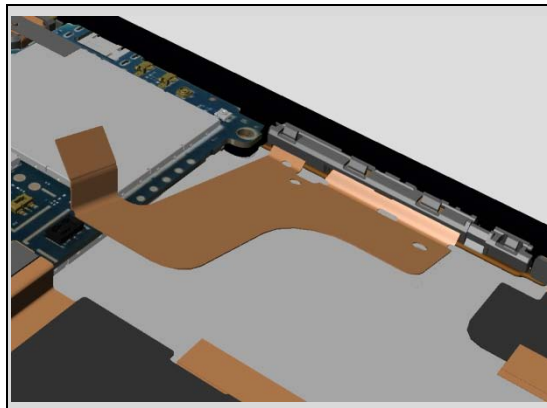
**Scrap! Not to be reused!**



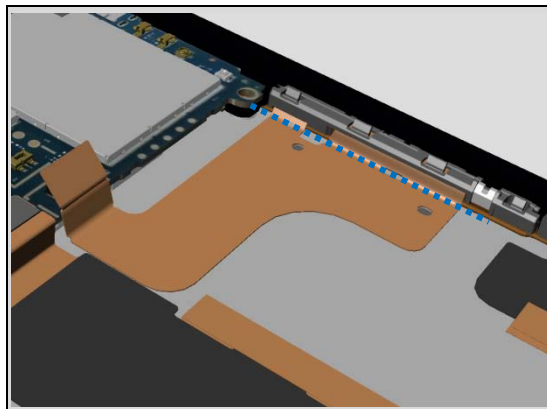
## Replacement:

### INSTALLATION

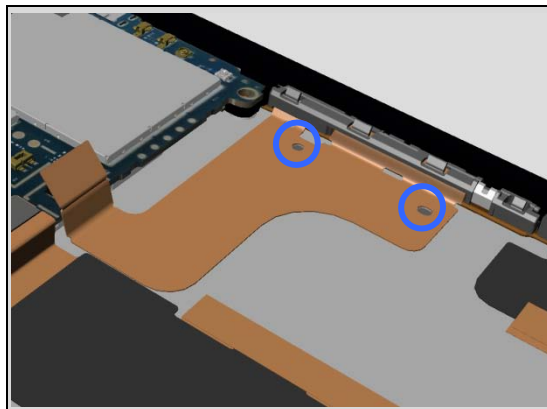
Align and insert the left end of the rib. Push the right end to fix the hooks.



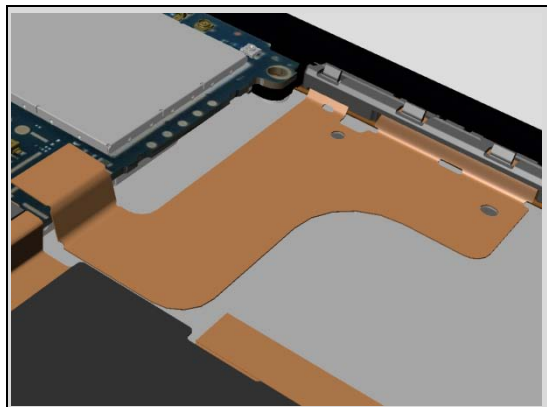
Align the flex. Secure the position and press to attach.



Check and confirm the guide holes.



Connect the BtB.





## Replacement

### 4.20 FPC Relay & Adhesive CU 25 x 6 - 3 pcs & Sheet CU 46 x 5 & Sheet CU 18 x 5

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Follow the 4.39, 4.16, 4.23 Removal instructions!*

Carry out the Removal as described below.

Prepare the new FPC Relay, Adhesives and Sheet.

Carry out the Installation as described below.

*Follow the 4.16, 4.23, 4.39 Installation instructions!*

*Follow the 5.5 – 5.8 Reassembly instructions!*

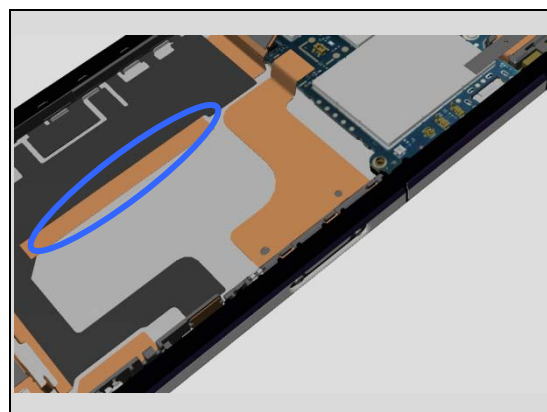
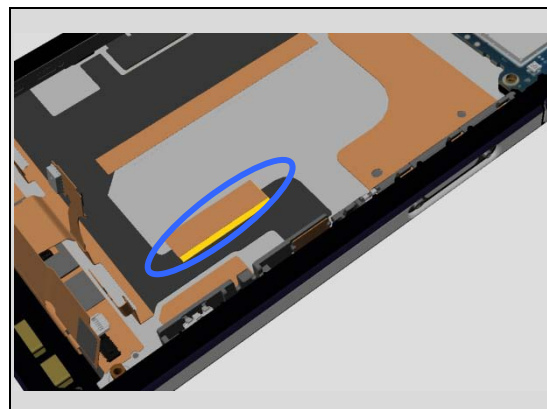
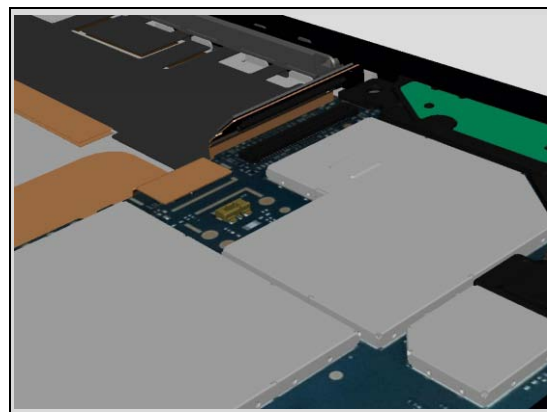
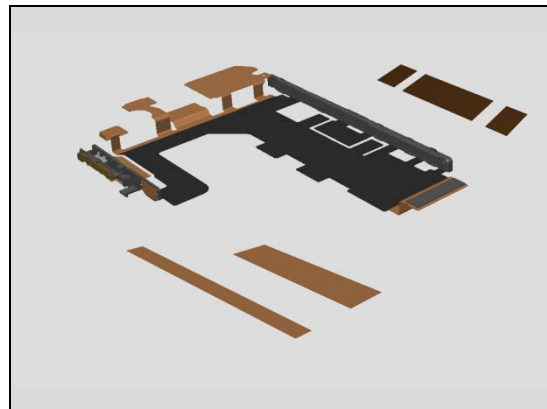
#### REMOVAL

Unsnap the BtB between the FPC Relay and the Main PBA.

Remove the Holder Loudspeaker according to 4.23

Remove the Sheet CU 18 x 5.

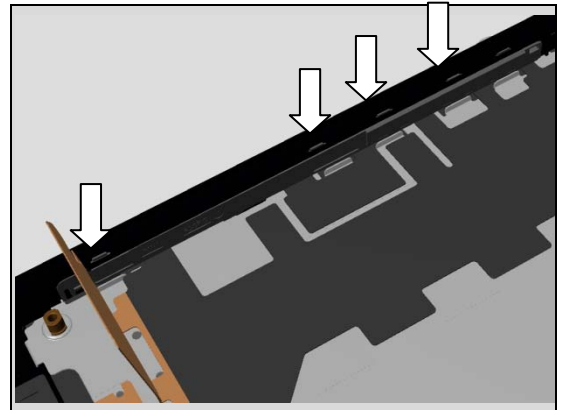
Remove the Sheet CU 46 x 5.



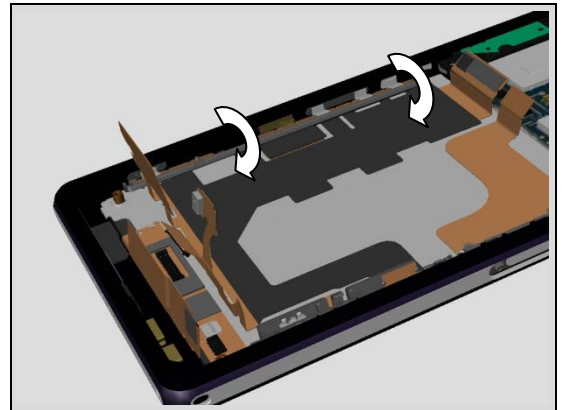


## Replacement:

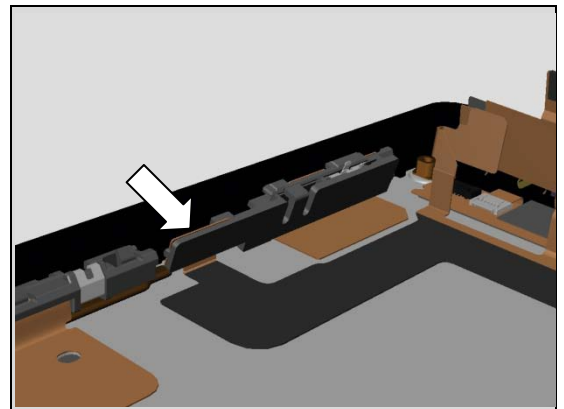
Release the five hooks of the key holder.



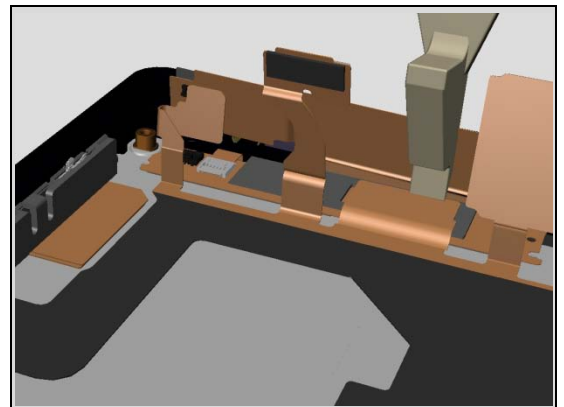
Rotate to release.



Release the holder on the opposite side.



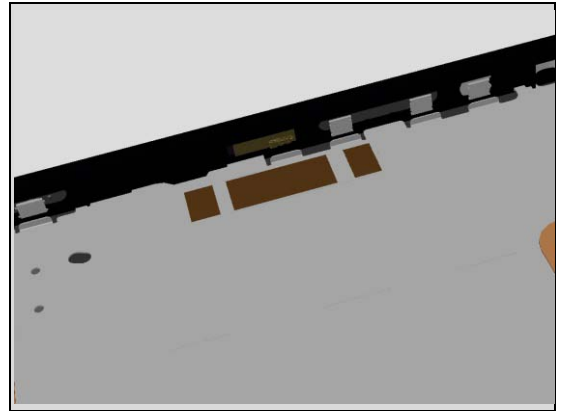
Unsnap the BtB connector to the front.  
Remove the FPC Relay.



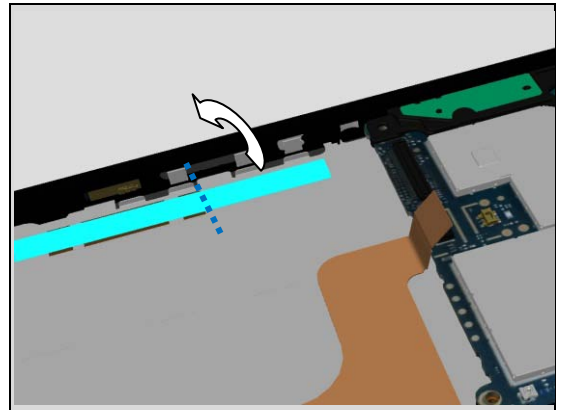
## Replacement:

### INSTALLATION

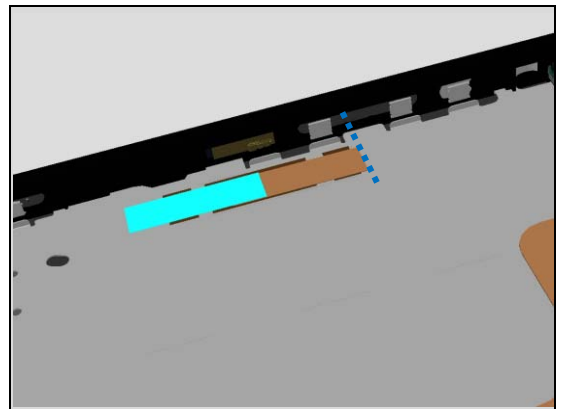
Remove the Adhesive CU 25 x 6 - 3 pcs and all remains of the Adhesive residue on the metal plate.



Align a new Adhesive CU 25 x 6 - 3 pcs.  
Bend the separator 180 degrees by the bending line.

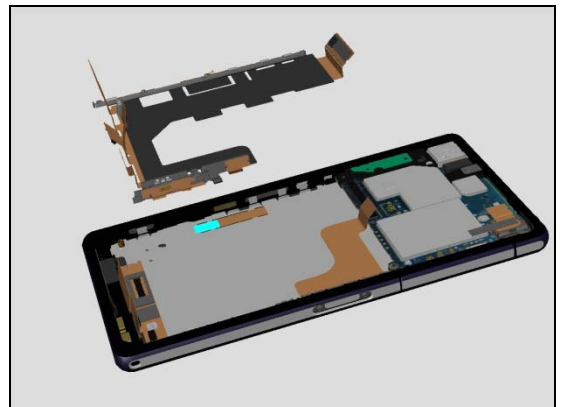


Let the separator be to later on.



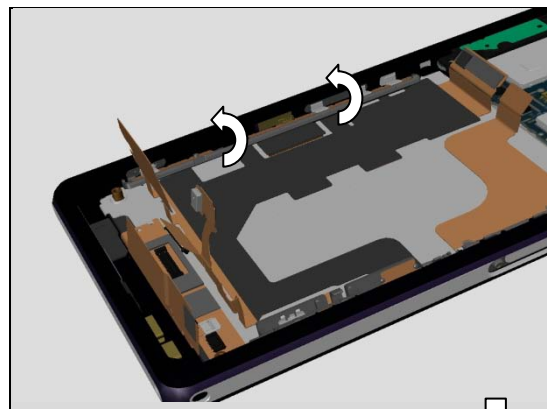
Prepare a FPC Relay.

**Do not reuse the FPC if it is damaged.**

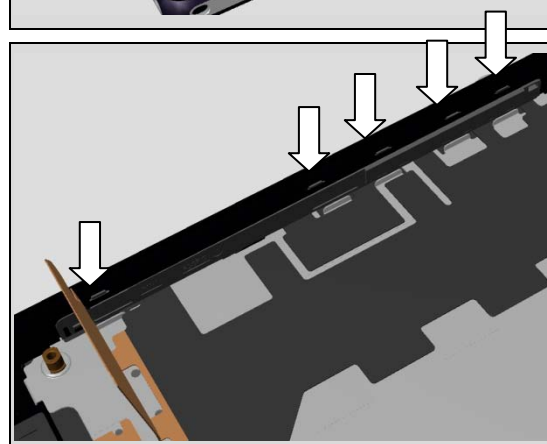


## Replacement:

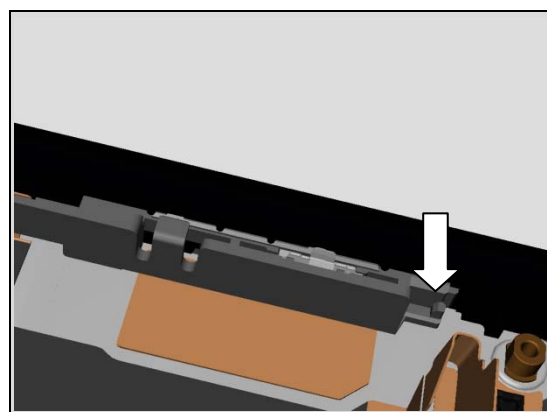
Assemble the key holder with a rotation. Insert the holder between the metal plate and the main cover.



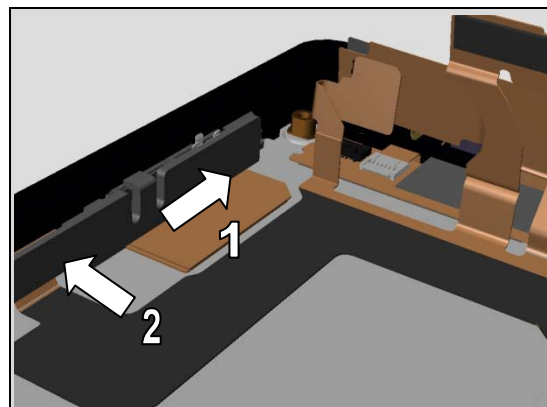
Secure the position of the five hooks.



Assembly the holder on the opposite side.  
Start with the hook in the bottom ..

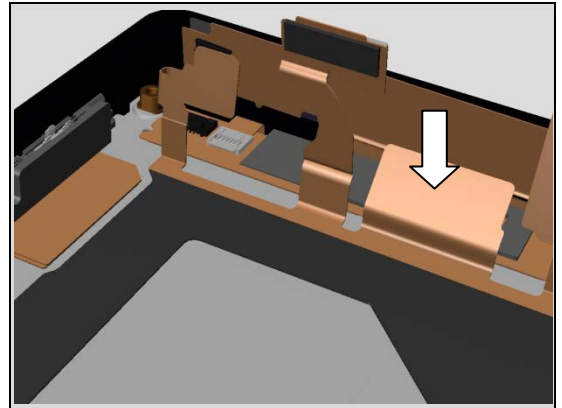


.. and press to lock the holder.

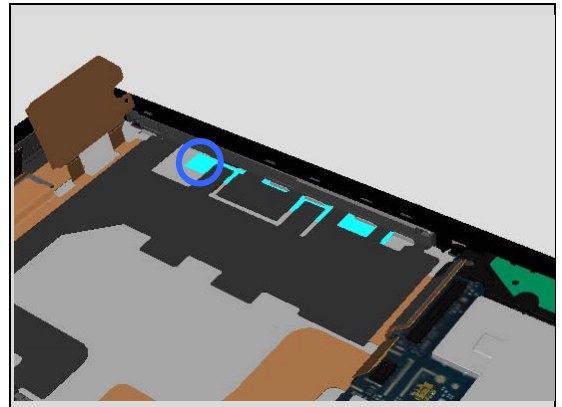


## Replacement:

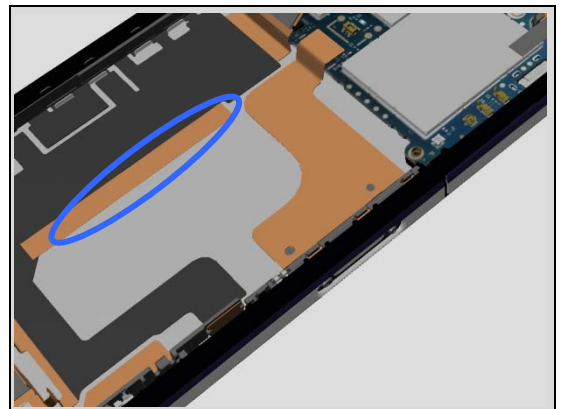
Connect the BtB connector between the FPC Relay and the front.



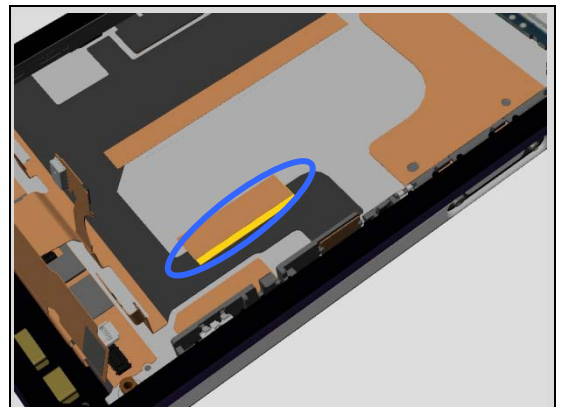
Remove the separator and press to secure the attachment.



Align and assemble the Sheet CU 46 x 5.  
Press with your finger to secure the attachment.

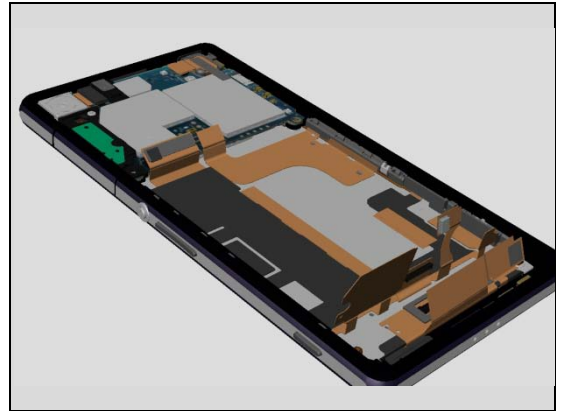


Align and assemble the Sheet CU 18 x 5.  
Press with your finger to secure the attachment.

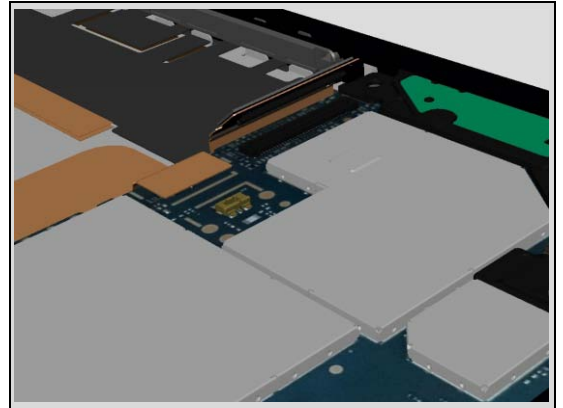


## Replacement:

Secure that the FPC Relay is properly attached..



Connect the BtB between the FPC Relay and the Main PBA.  
Replace the Holder Loudspeaker according to 4.23  
Assemble a new Cushion Relay FPC 4.16



## Replacement

### 4.21 Holder 2nd Mic

*Follow the 3.1 – 3.3 Disassembly instructions!*

Carry out the Removal as described below.

Prepare the new Holder 2nd Mic.

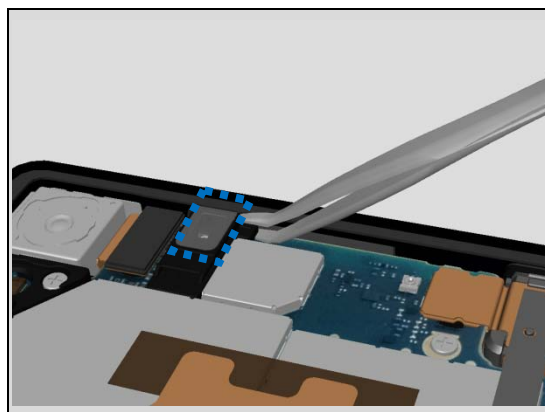
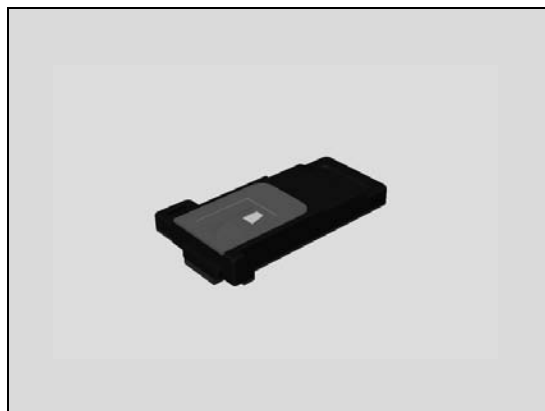
Carry out the Installation as described below.

*Follow the 5.6 – 5.8 Reassembly instructions!*

#### REMOVAL

Remove the Holder 2nd Mic gently.

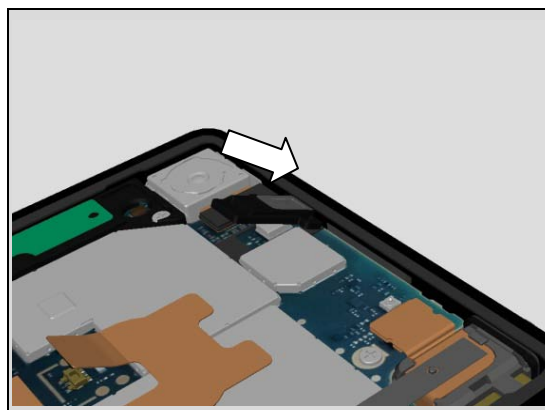
**Do not touch the acoustic cabinet (mark in blue).**



#### INSTALLATION

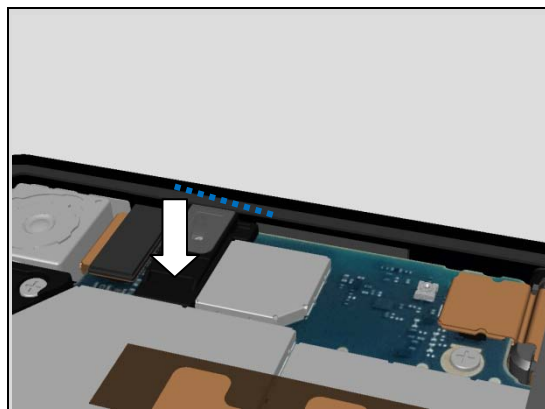
Align and insert the hook. Place the Holder 2nd Mic in an angle.

**Do not touch the acoustic cabinet!**



Press (not at the acoustic cabinet) to secure its attachment. Check that the Holder is well fixed.

**No gap (by the blue line in the picture), the guiding boss shouldn't be visible!**



## Replacement

### 4.22 Holder Camera Chat

*Follow the 3.1 – 3.8 Disassembly instructions!*

Carry out the Removal as described below.

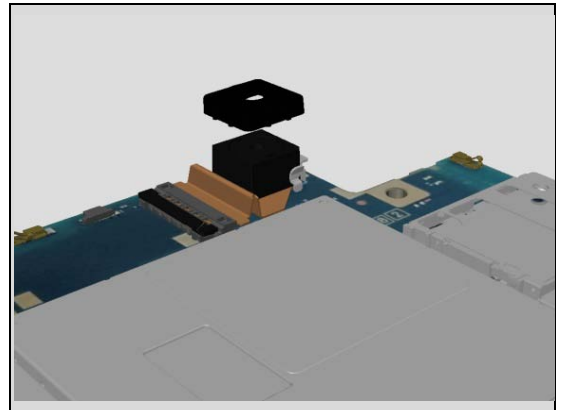
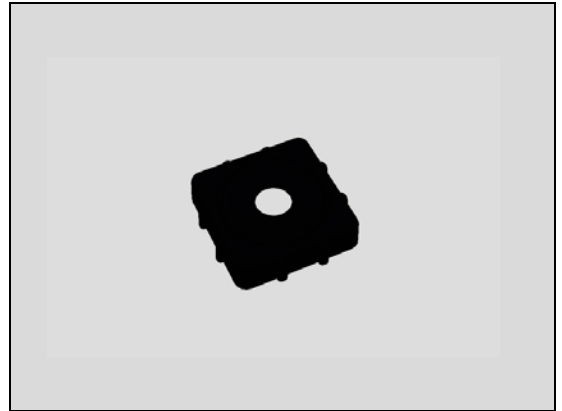
Prepare the new Holder Camera Chat.

Carry out the Installation as described below.

*Follow the 5.1 – 5.8 Reassembly instructions!*

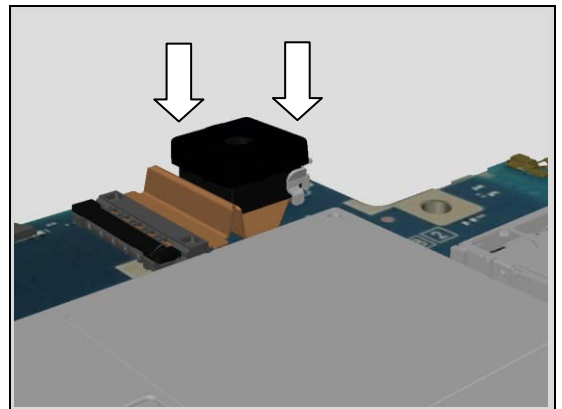
#### REMOVAL

Remove the Holder Camera Chat.



#### INSTALLATION

Mount a new Holder Camera Chat.





## Replacement

### 4.23 Holder Loudspeaker & Adhesive Loudspeaker Lid & Adh Speaker Back & Adh VIB Conn & Adh with mesh 14 x 5

*Follow the 3.1 – 3.4 Disassembly instructions!*  
*Follow the 4.40 and 4.25 Removal instructions!*  
 Carry out the Removal as described below.  
 Prepare the new Holder Loudspeaker & Adhesives.  
 Carry out the Installation as described below.  
*Follow the 4.25 and 4.40 Installation instructions!*  
*Follow the 5.5 – 5.8 Reassembly instructions!*

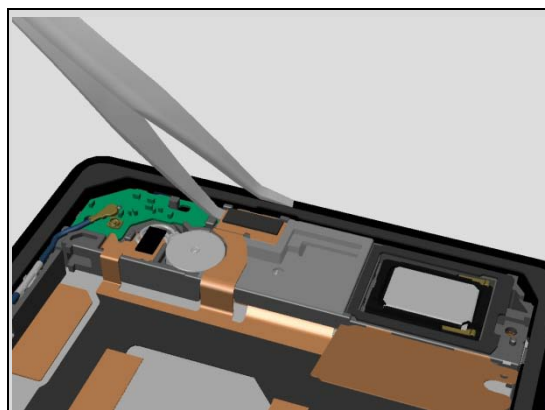
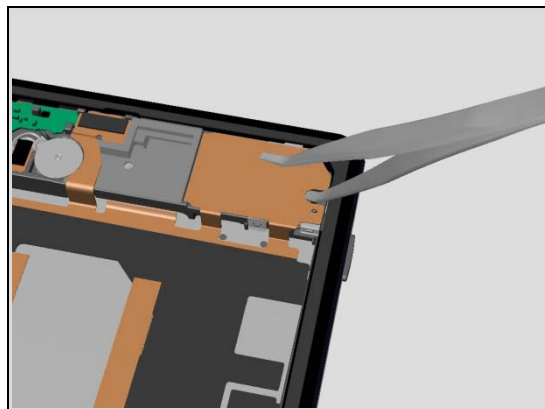
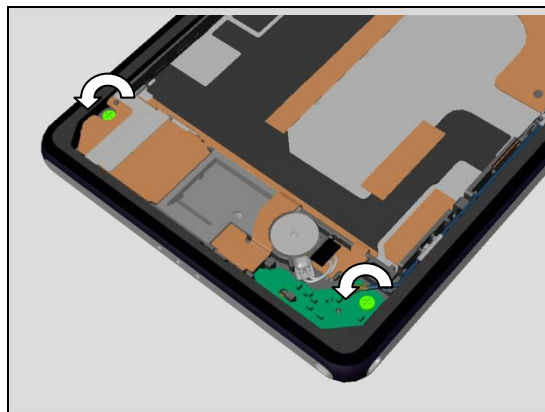
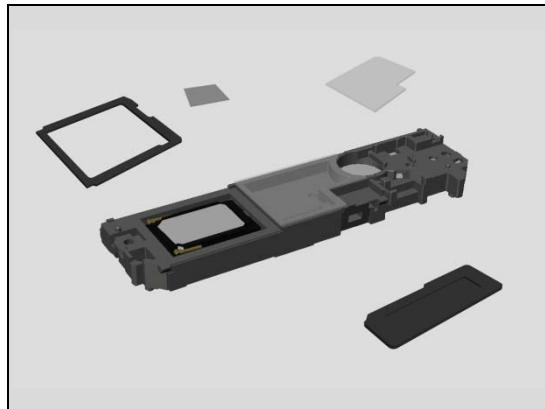
#### REMOVAL

Remove the four Screws by using a screwdriver with Bits (JCIS No 0).

**Scrap! Not to be reused.**

Release the flex lid over the Loudspeaker when the Plate Speaker has been removed, chapter 4.25

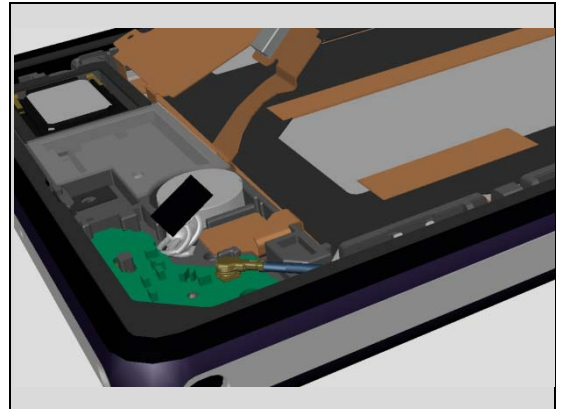
Release the flex over the MIC.





## Replacement:

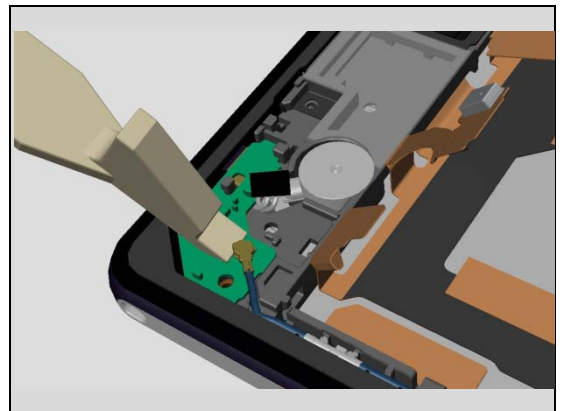
Unsnap the Connector for the Vibrator.



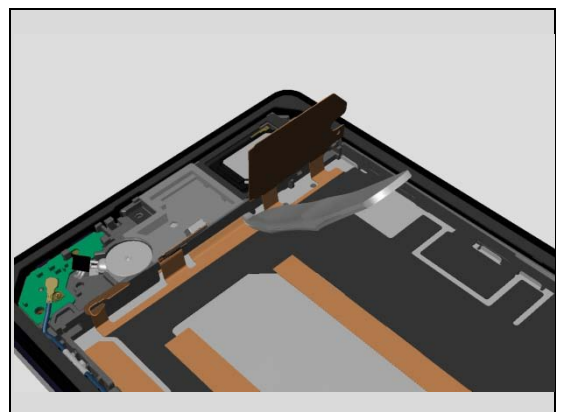
Release the flex with the Vibrator connector.



Unsnap the Cable RF Coax.

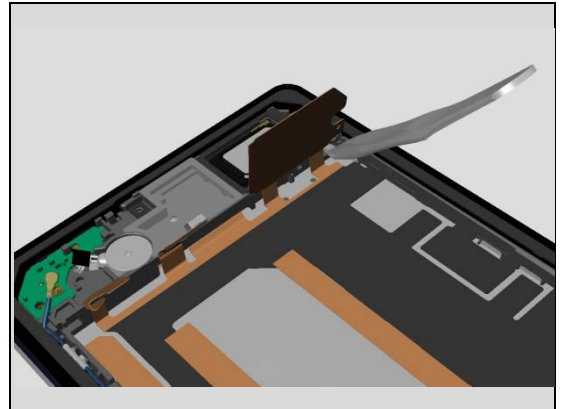


Release the Holder Loudspeaker in the middle ..

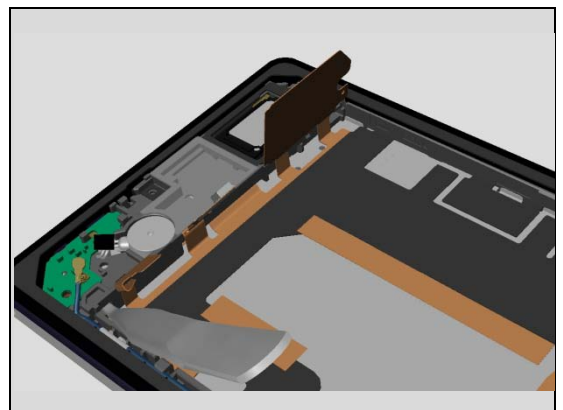


## Replacement:

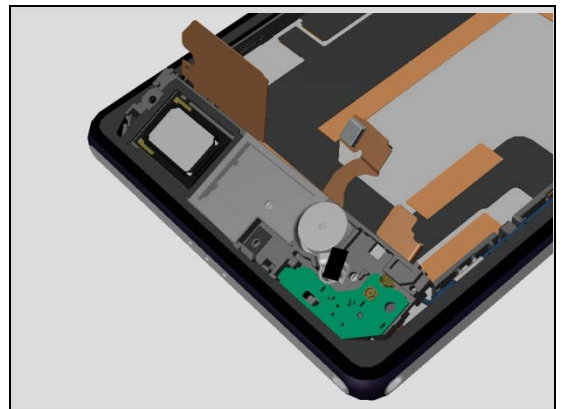
.. and at the right side ..



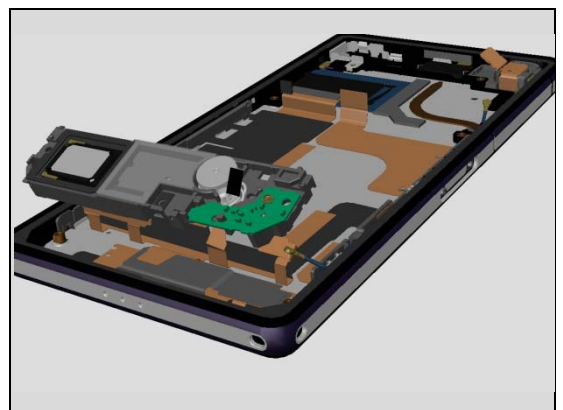
.. and in the left side.



Lift the Holder Loudspeaker in an angel ..

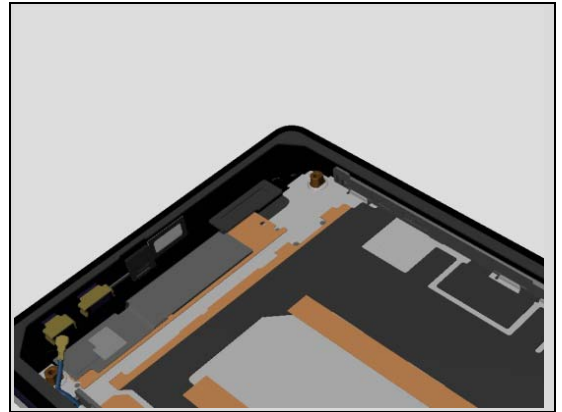


.. remove it.



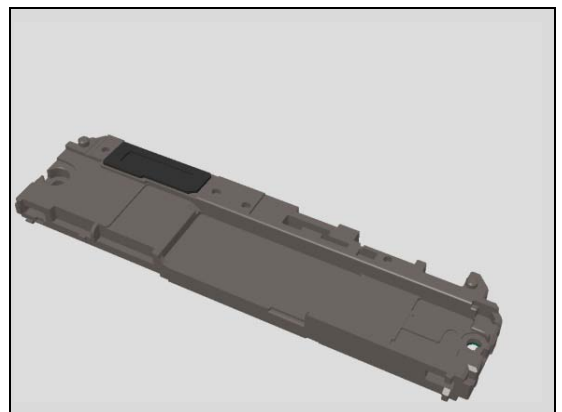
## Replacement:

Remove the old Adhesive with mesh 14 x 5 and all remains of the Adhesive residue found in the cavity.



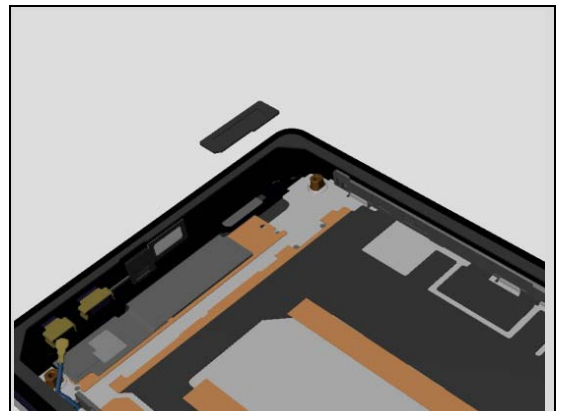
Remove the old Adhesive and all remains of the Adhesive residue found on the Holder Loud speaker.

Clean both surfaces carefully with alcohol before the new Adhesive is mounted. This action is done to secure the water resistant of the unit.

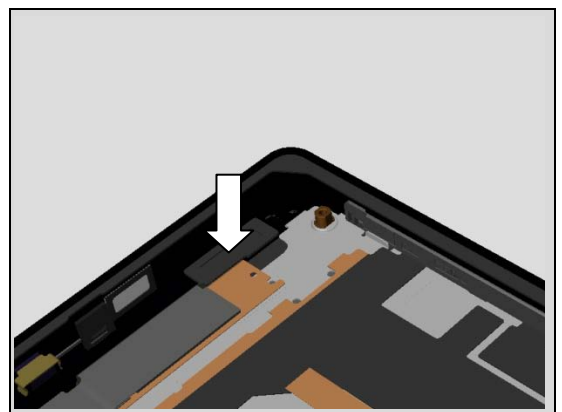


## INSTALLATION

Place a new Adhesive with mesh 14 x 5 in the correct position.

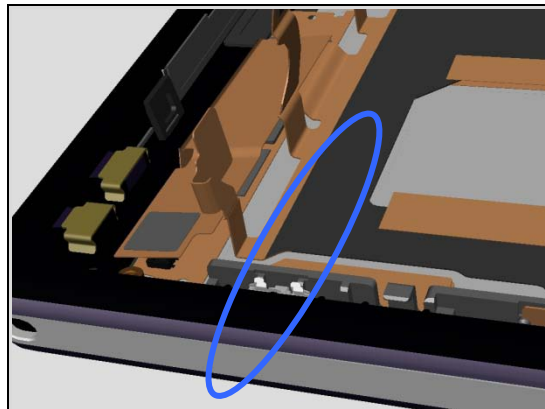


Press the Adhesive gently to secure the attachment.

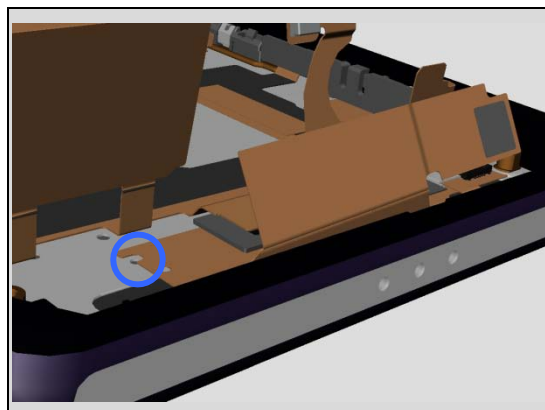


## Replacement:

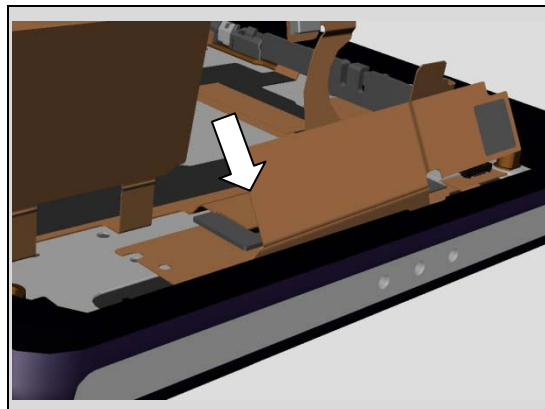
Make a visual inspection to secure no damage of the FPC Relay.



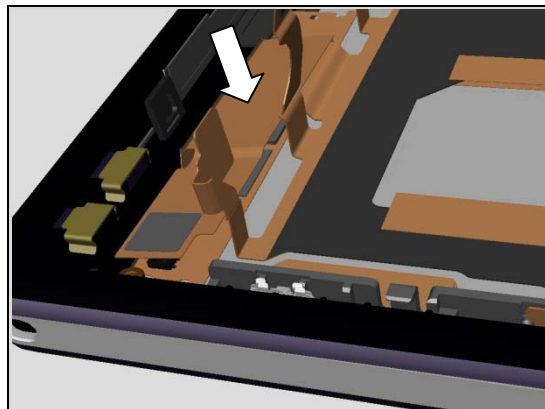
Secure the location of the front flex.



Secure that the FPC Relay BtB is correct connected.

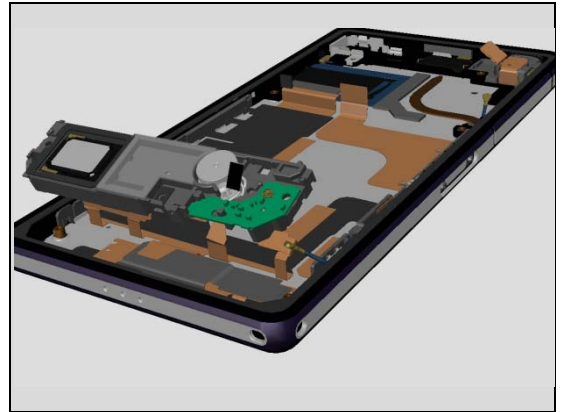


Lay down the second flex from the front.

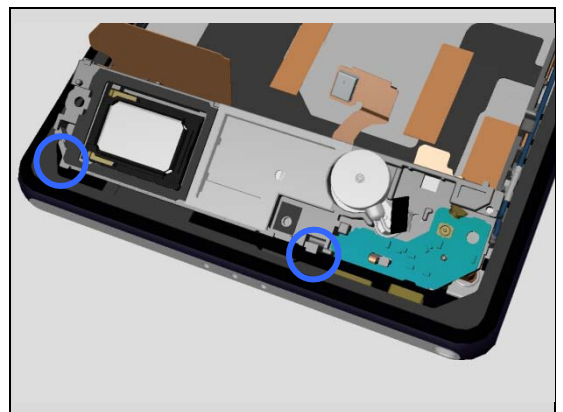


## Replacement:

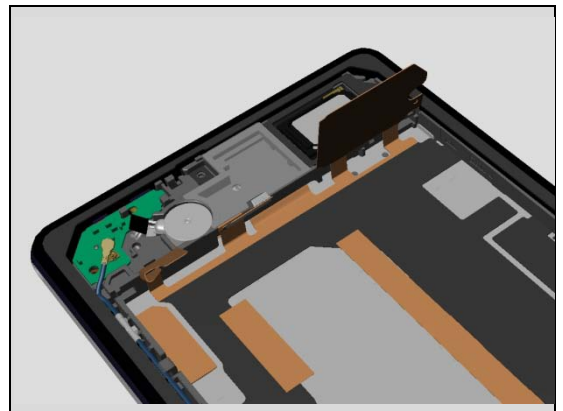
Insert the Holder Loudspeaker.



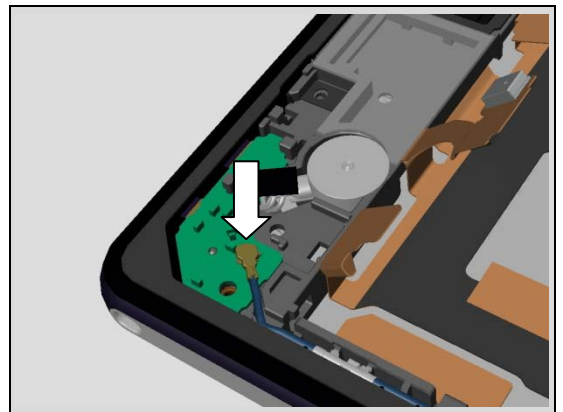
Align with the two hooks.



Press to secure its position.



Connect the Cable RF Coax to the PBA Antenna.

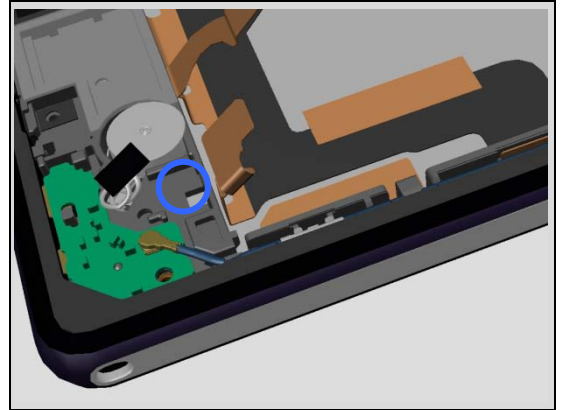




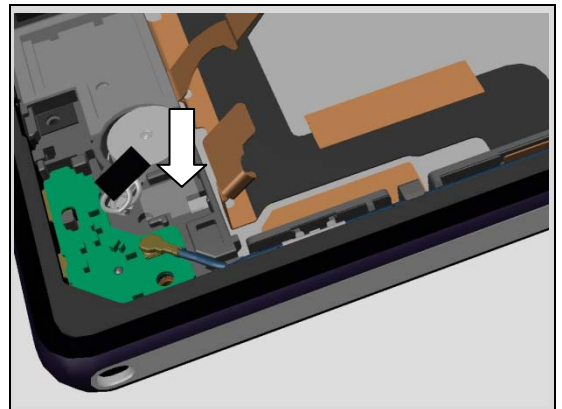
## Replacement:

Remove the Adhesive VIB Conn and all remains of the Adhesive residue both on the Loudspeaker and the flex.

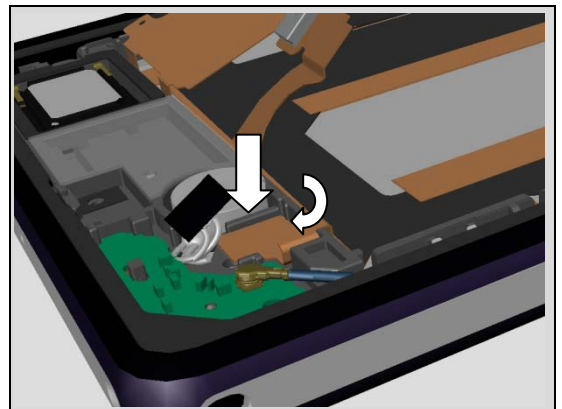
**Scrap! Not to be reused.**



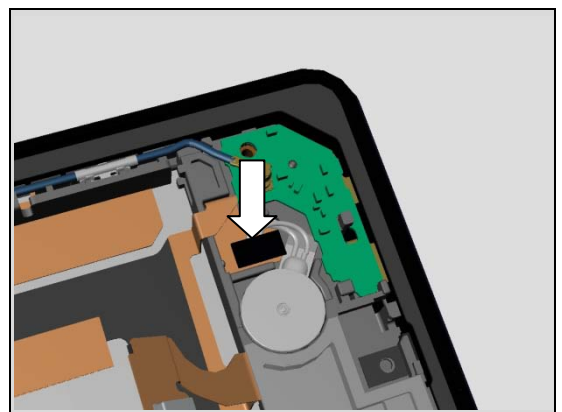
Align and mount a new Adhesive VIB Conn. Press gently to secure its attachment.



Turn around and twist the flex with the connector for the Vibrator. Press to secure its attachment.

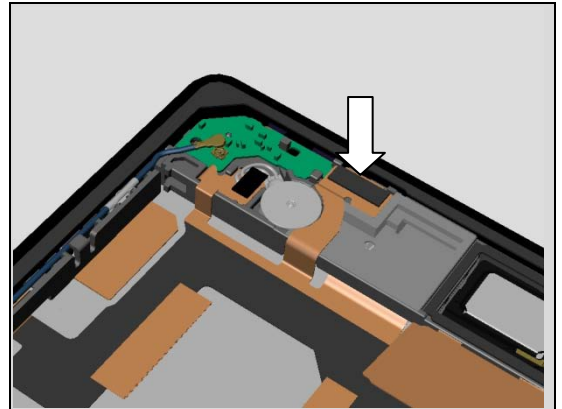


Connect the connector for the Vibrator. Press to secure its attachment.



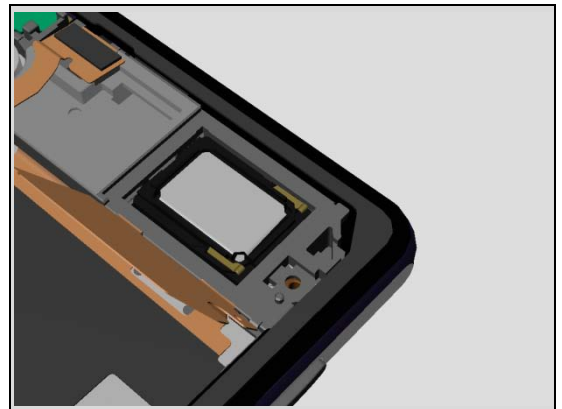
## Replacement:

Attach the flex over the MIC. Press to secure its attachment.

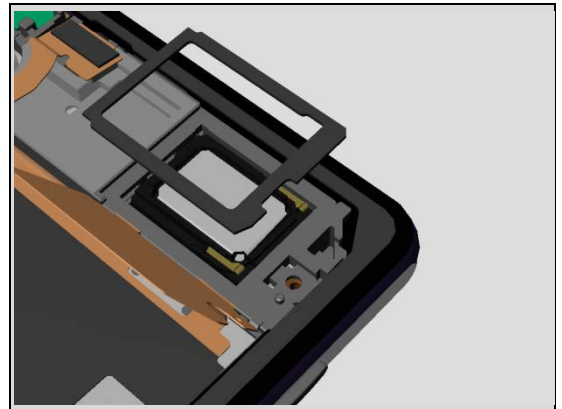


Remove the Adhesive Loudspeaker Lid and all remains of the Adhesive residue both on the Holder Loudspeaker and the flex lid.

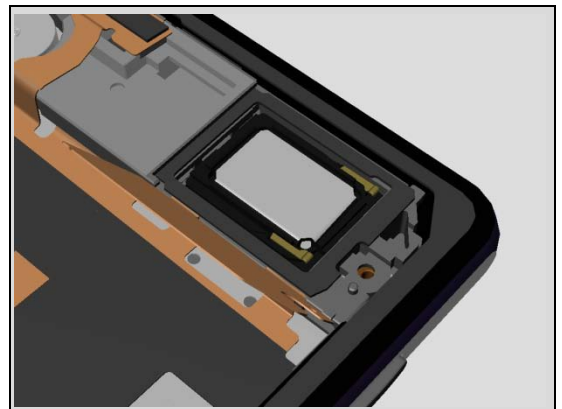
**Scrap! Not to be reused.**



Align a new Adhesive Loudspeaker Lid.



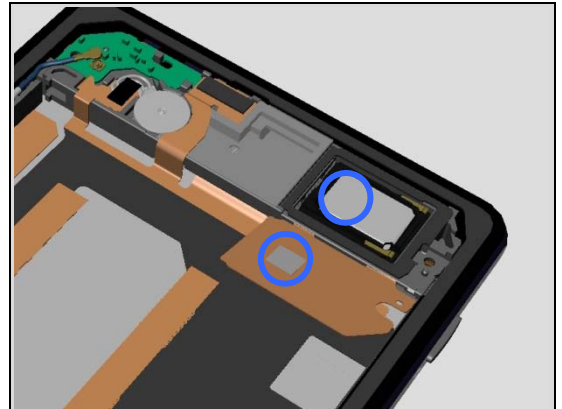
Press gently to secure its attachment and position.



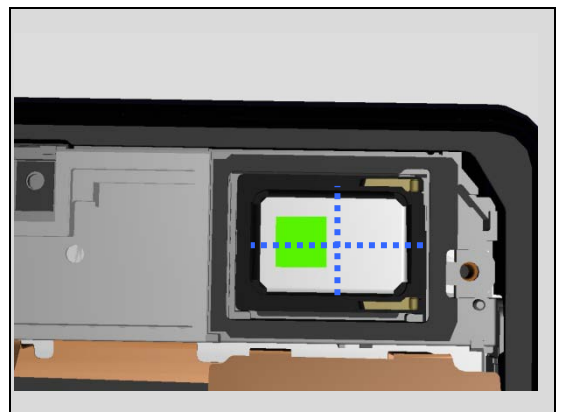
## Replacement:

Remove the Adhesive Speaker Back and all remains of the Adhesive residue both on the Loudspeaker and the flex lid.

**Scrap! Not to be reused.**

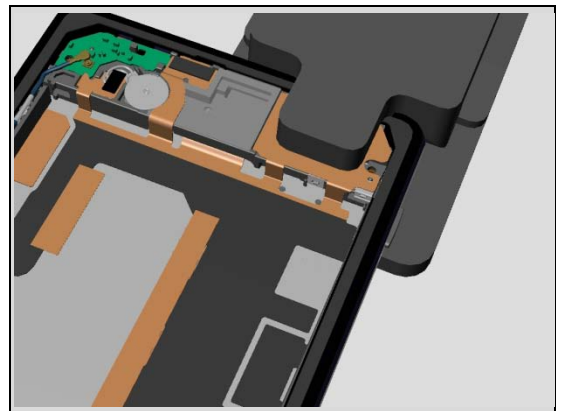


Align and mount a new Adhesive Speaker Back. Vertically on the left half and horizontally centered.



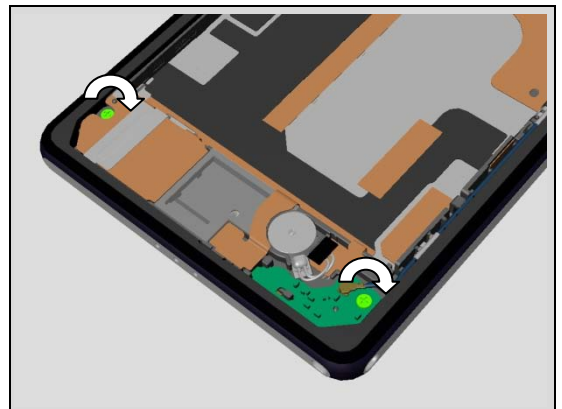
Close the flex lid. Press for 5 seconds with the Speaker Holder Press to secure the attachment.

**Do not touch the pins of the Speaker!**



Apply  $12 \pm 1$  Ncm torque when tightening the Screw Bits (JCIS No 0). Reinstall the Plate Speaker, chapter 4.25

**Take new Screws!**





## Replacement

### 4.24 PBA Antenna

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Follow the 4.23 Removal instructions!*

Carry out the Removal as described below.

Prepare the new PBA Antenna.

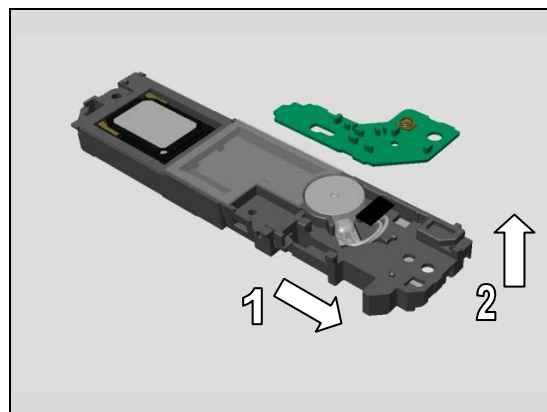
Carry out the Installation as described below.

*Follow the 4.23 Installation instructions!*

*Follow the 5.5 – 5.8 Reassembly instructions!*

#### REMOVAL

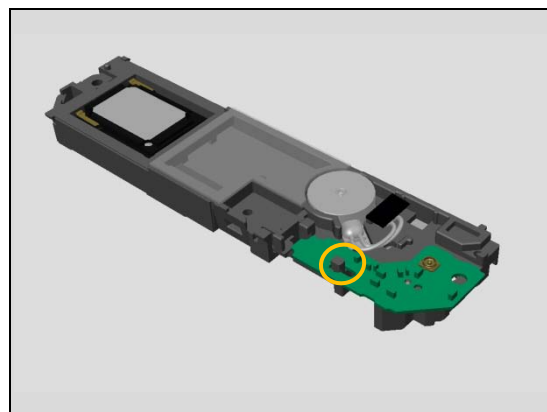
Push the PBA Antenna to the right and lift it.



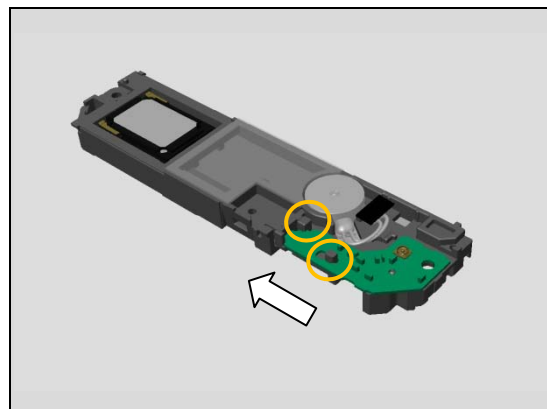
#### INSTALLATION

Place a new PBA Antenna in the correct position.

Align by the guide hole in the PBA Antenna and the rib on the Holder Loudspeaker.



Push the PBA Antenna leftwards and secure the position into the two hooks.



## Replacement

### 4.25 Plate Speaker

*Follow the 3.1 – 3.4 Disassembly instructions!*

Carry out the Removal as described below.

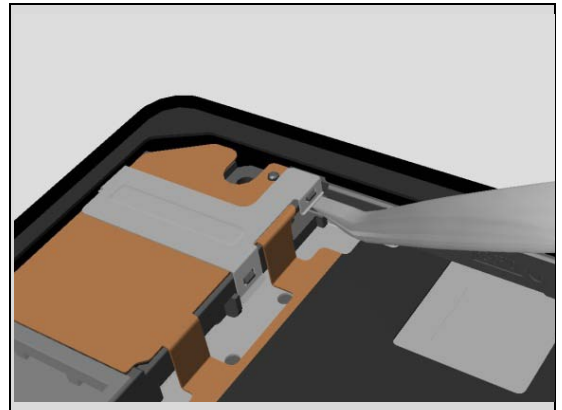
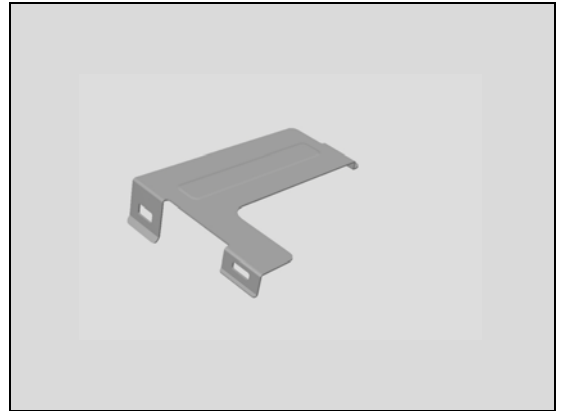
Prepare the new Plate Speaker.

Carry out the Installation as described below.

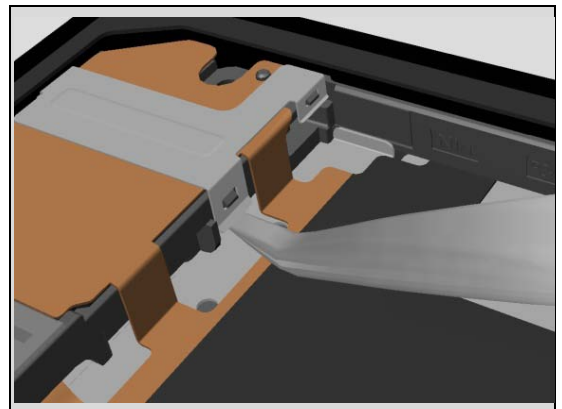
*Follow the 5.5 – 5.8 Reassembly instructions!*

#### REMOVAL

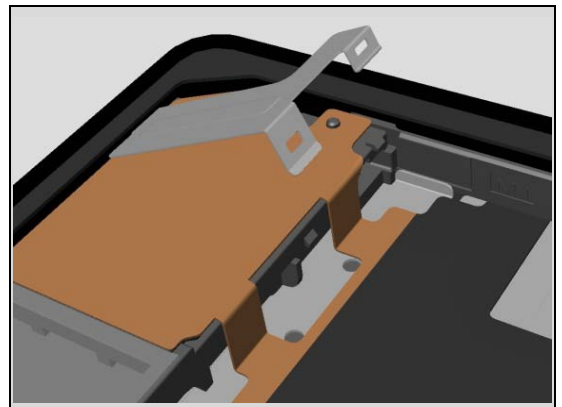
Release the first hook.



Release the second hook.



Lift the Plate Speaker in an angle and remove it.



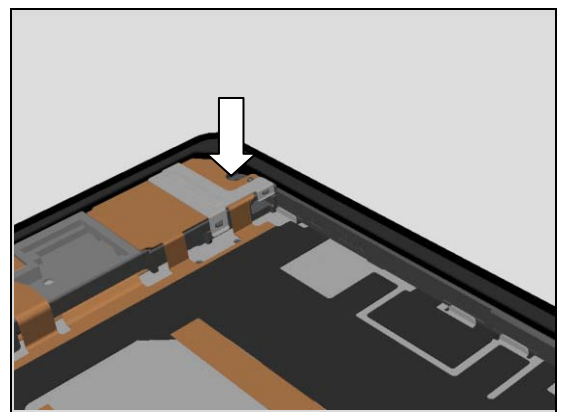
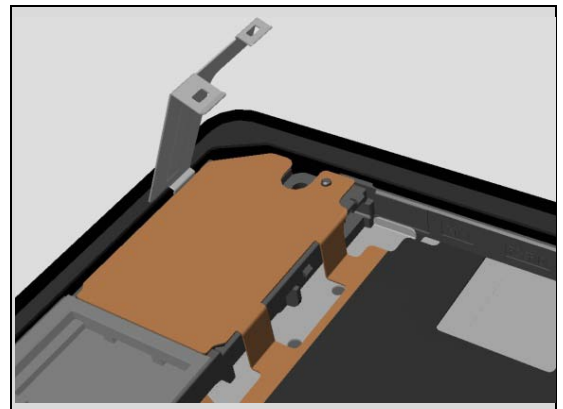
## Replacement:

### INSTALLATION

***Inspect that the Plate Speaker are flat.  
If not take a new one.***

Align and insert the hook of the Plate Speaker.

Press down with your finger and check that both hooks are proper attached.



## Replacement

### 4.26 Ring Audio Jack

*Follow the 3.1 – 3.8 Disassembly instructions!*

Carry out the Removal as described below.

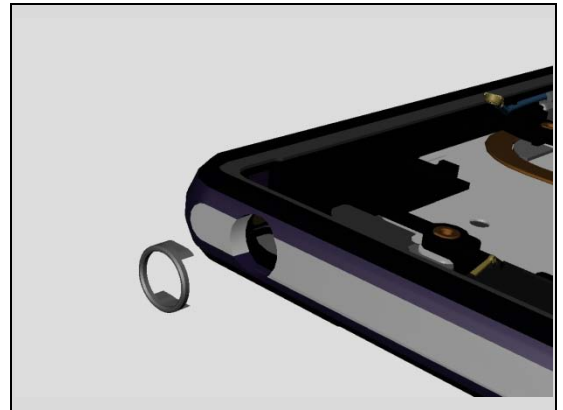
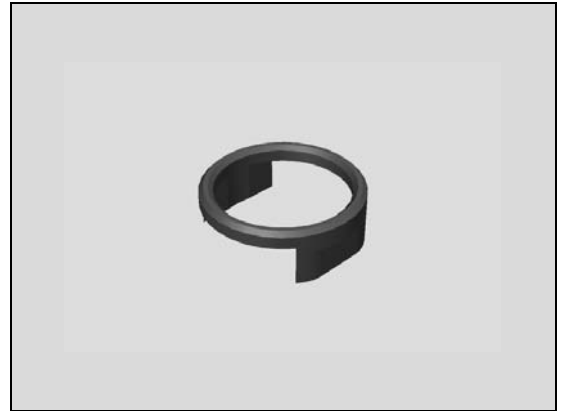
Prepare the new Ring Audio Jack.

Carry out the Installation as described below.

*Follow the 5.1 – 5.8 Reassembly instructions!*

#### REMOVAL

Remove the Ring Audio Jack gently with a Nylon Pointer.



#### INSTALLATION

Mount and press the new Ring Audio Jack with your finger.



## Replacement

### 4.27 Sheet Battery Adhesive Top

*Follow the 3.1 – 3.4 Disassembly instructions!*

Prepare the new Sheet Battery Adhesive Top.

Carry out the Installation as described below.

*Follow the 5.5 – 5.8 Reassembly instructions!*

*The Sheet Battery Adhesive Top shouldn't been removed since the Battery will then be imminent. In case of damage, replace the Battery.*

#### INSTALLATION

Prepare the new Sheet Battery Adhesive Top when a new Battery is used.

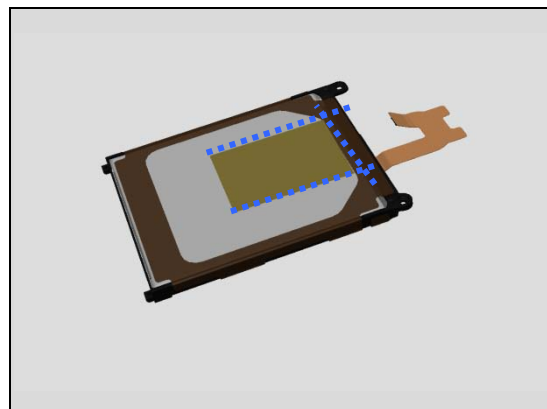
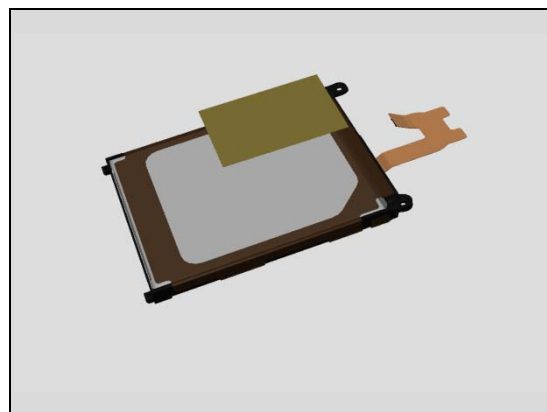
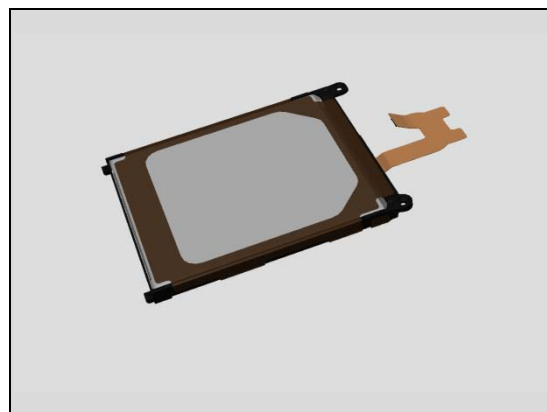
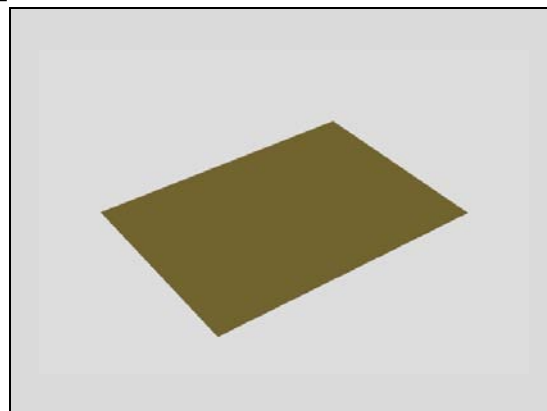
Align the Sheet horizontally in the center. It shouldn't cover the tape on the Battery.

**Scrap! Not to be reused!**

**Do not remove the Sheet Battery Adhesive Top from the Battery. If damaged, scrap it with the Battery.**

Press with a finger to secure the attachment.

Check and confirm that the Sheet Battery Adhesive Top is flat with no wrinkles.

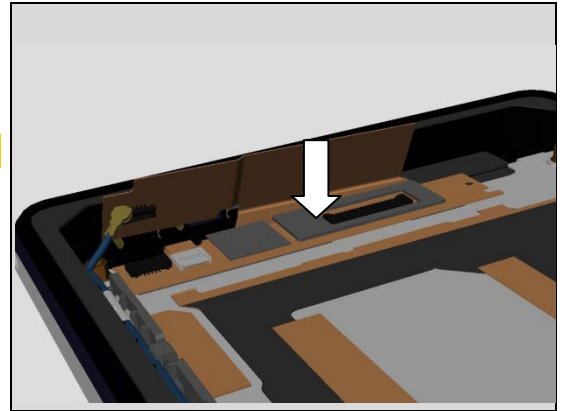


## Replacement

### 4.28 Sheet LCD 18 x 7

**Do not use!**

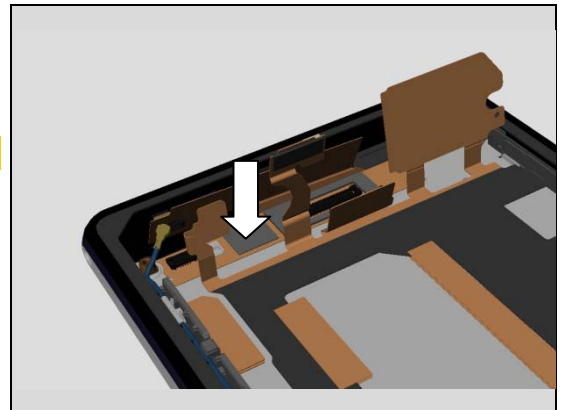
*Have been removed in later units and are not needed. Can be removed if needed on old units.*



### 4.29 Sheet LCD 7 x 7

**Do not use!**

*Have been removed in later units and are not needed. Can be removed if needed on old units.*



## Replacement

### 4.30 Sheet Thermal Conductive

*Follow the 3.1 – 3.8 Disassembly instructions!*

Carry out the Removal as described below.

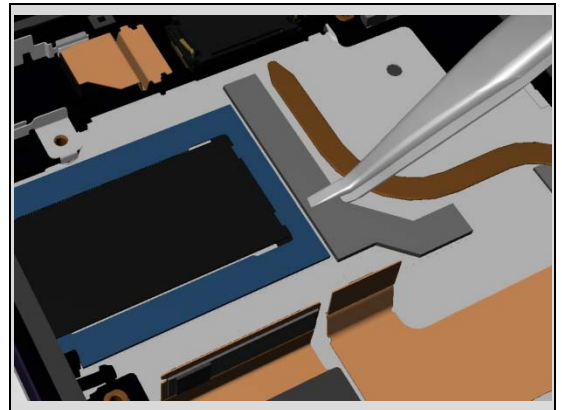
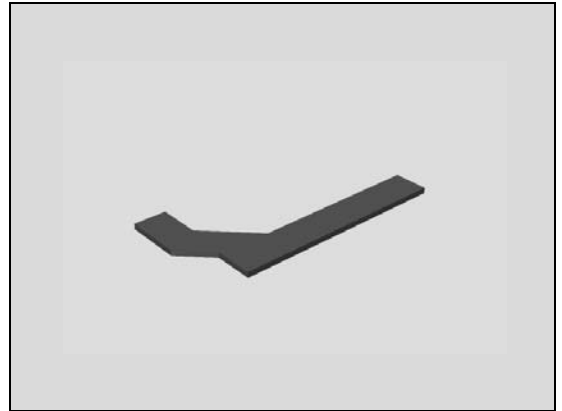
Prepare the new Sheet Thermal Conductive.

Carry out the Installation as described below.

*Follow the 5.1 – 5.8 Reassembly instructions!*

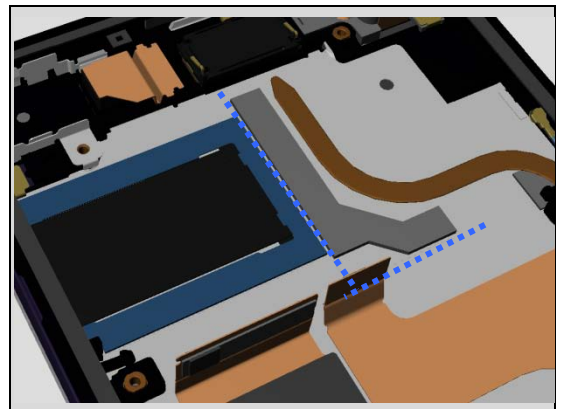
#### REMOVAL

Remove the Sheet Thermal Conductive.



#### INSTALLATION

Align with the marks in the frame and press.



## Replacement

### 4.31 Shield Camera

*Follow the 3.1 – 3.8 Disassembly instructions!*

Carry out the Removal as described below.

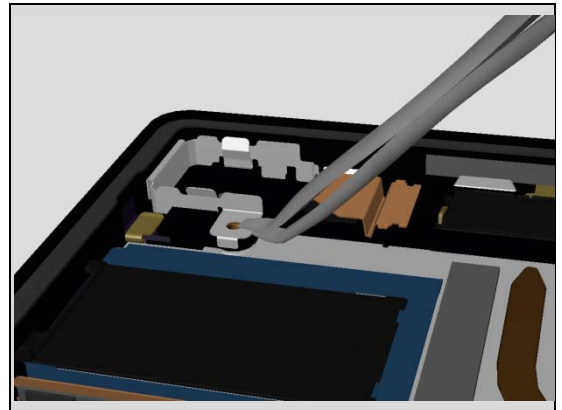
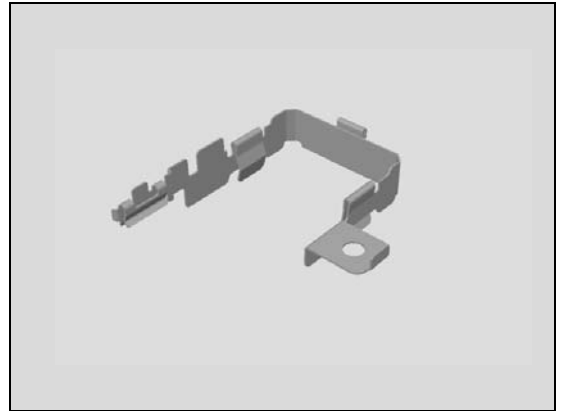
Prepare the new Shield Camera.

Carry out the Installation as described below.

*Follow the 5.1 – 5.8 Reassembly instructions!*

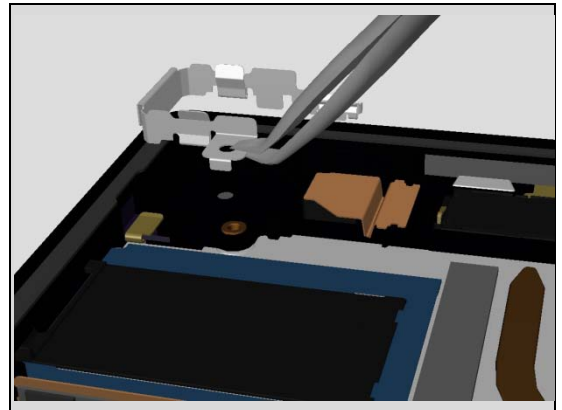
#### REMOVAL

Remove the Shield Camera.

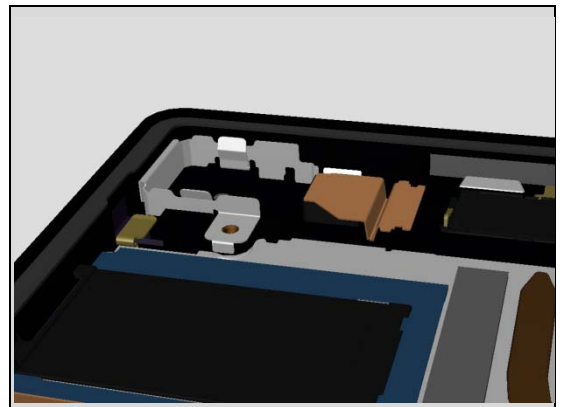


#### INSTALLATION

Take a new Shield Camera.



Press with your finger to secure the position.





## Replacement

### 4.32 Spacer 10 x 4

*Follow the 3.1 – 3.6 Disassembly instructions!*

Prepare the new Spacer 10 x 4.

Carry out the Installation as described below.

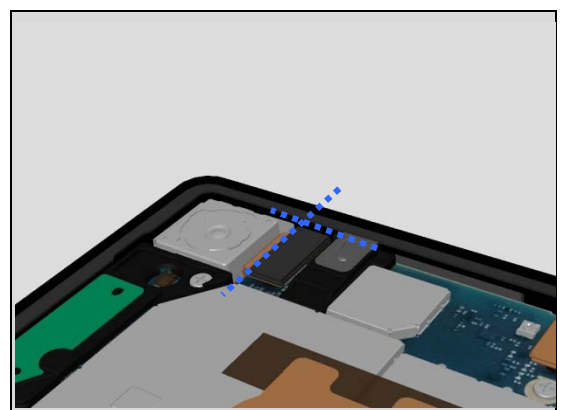
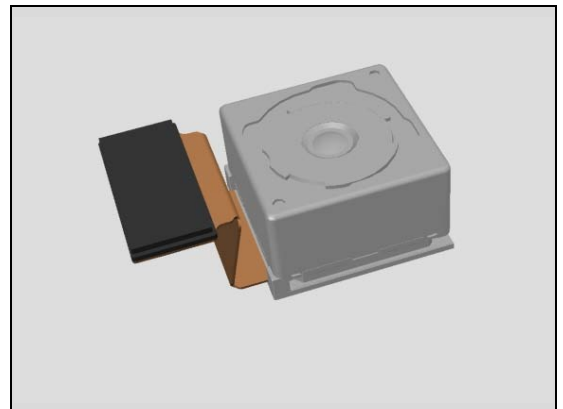
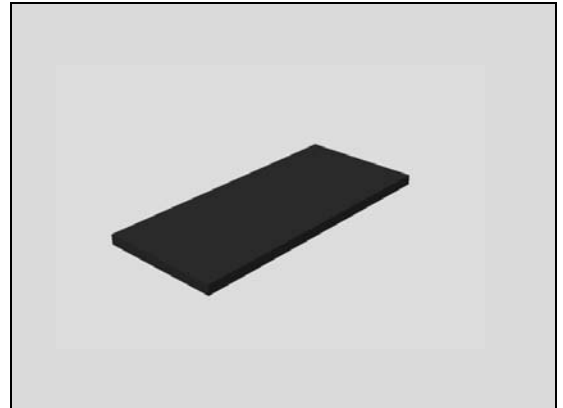
*Follow the 5.3 – 5.8 Reassembly instructions!*

*The Spacer 10 x 4 shouldn't been removed since the flex of the Main Cover will then be imminent.*

#### INSTALLATION

Prepare the new Spacer 10 x 4 when a new Main Camera is used. Place a new Spacer 10 x 4 in the correct position.

Align by the top left corner of the BtB connector. Press with your finger to secure the attachment.



## Replacement

### 4.33 Tray Core Unit Label

*Follow the 3.1 – 3.8 Disassembly instructions!*

*Follow the 4.15 Removal instructions!*

Carry out the Removal as described below.

Prepare the new Tray Core Unit Label.

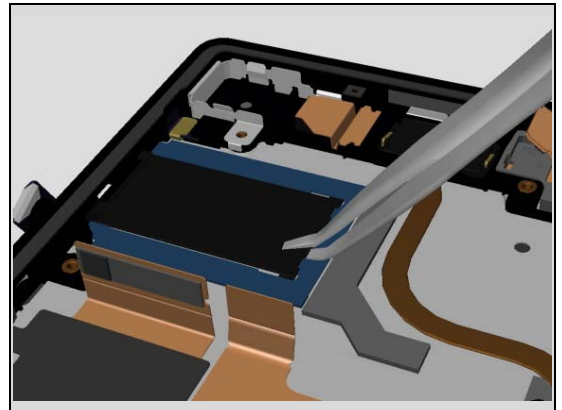
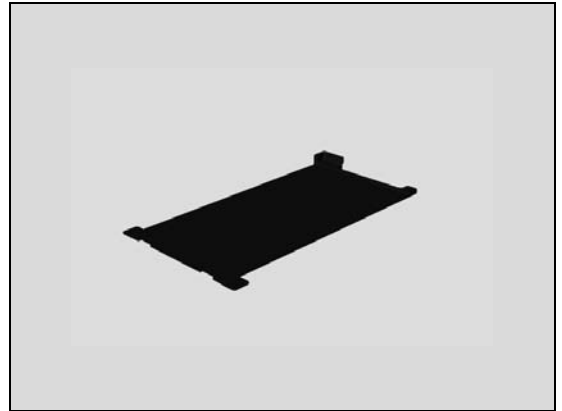
Carry out the Installation as described below.

*Follow the 4.15 Installation instructions!*

*Follow the 5.1 – 5.8 Reassembly instructions!*

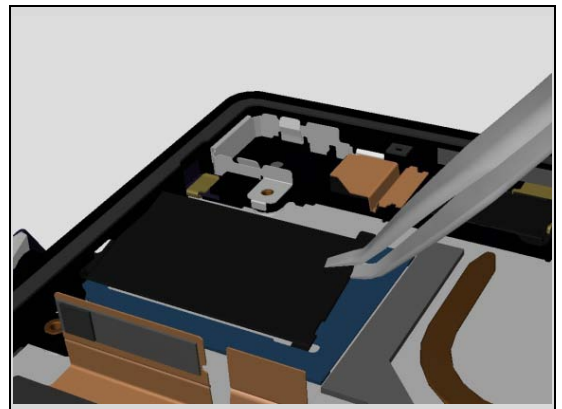
#### REMOVAL

Remove the Tray Core Unit Label.

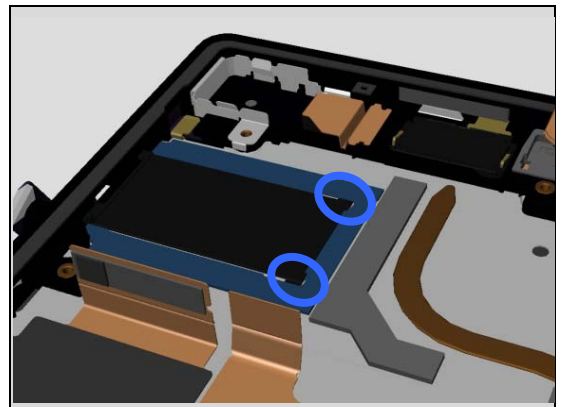


#### INSTALLATION

Insert the first wing of the Tray Core Unit Label under the Sheet Guide Label.



Bend in a n arc insert the second wing of the Tray. Check that both wings are under the Sheet.



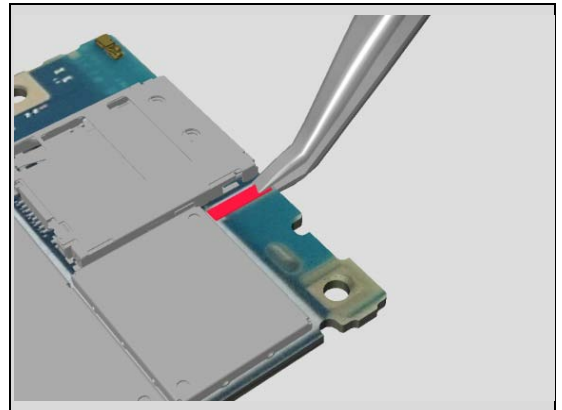
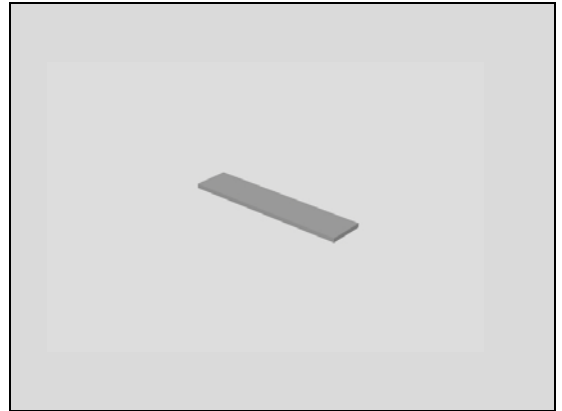
## Replacement

### 4.34 Water indicator I

*Follow the 3.1 – 3.8 Disassembly instructions!*  
Carry out the Removal as described below.  
Prepare the new Water indicator.  
Carry out the Installation as described below.  
*Follow the 5.1 – 5.8 Reassembly instructions!*

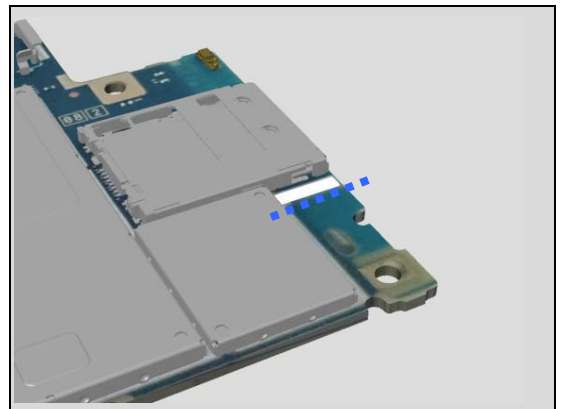
#### REMOVAL

Remove the Water indicator.



#### INSTALLATION

Align and press to attach a new Water indicator.



## Replacement

### 4.35 Water indicator II

*Follow the 3.1 – 3.8 Disassembly instructions!*

Carry out the Removal as described below.

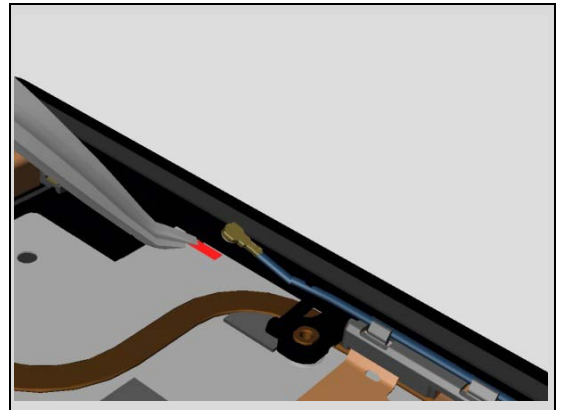
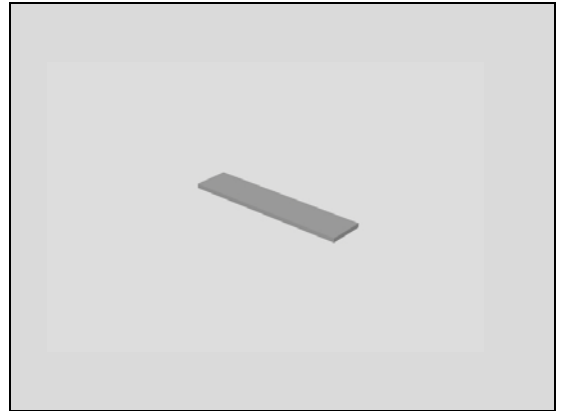
Prepare the new Water indicator.

Carry out the Installation as described below.

*Follow the 5.1 – 5.8 Reassembly instructions!*

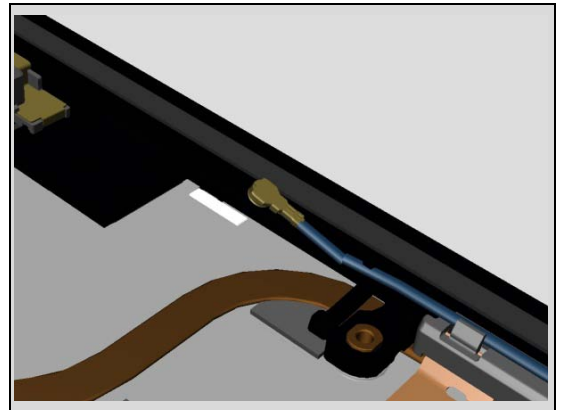
#### REMOVAL

Remove the Water indicator.



#### INSTALLATION

Align and press to attach a new Water indicator.



## Replacement

### 4.36 Vibrator & Adhesive VIB & Spacer 5 x 2.5

*Follow the 3.1 – 3.3 Disassembly instructions!*  
 Carry out the Removal as described below.  
 Prepare the new Vibrator, Adhesive and Spacer.  
 Carry out the Installation as described below.  
*Follow the 5.6 – 5.8 Reassembly instructions!*

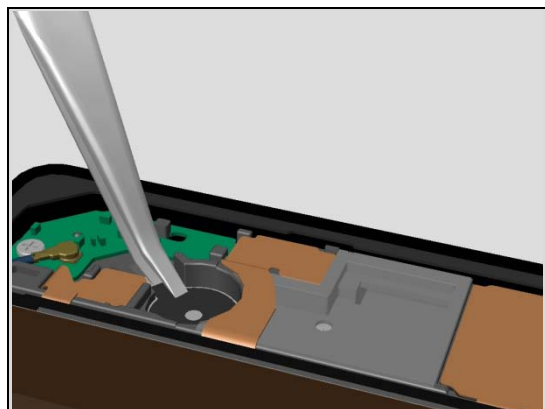
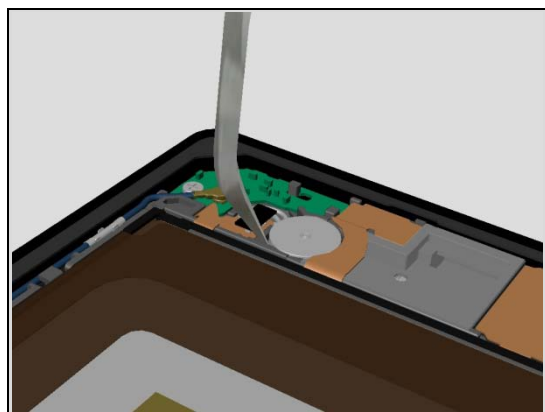
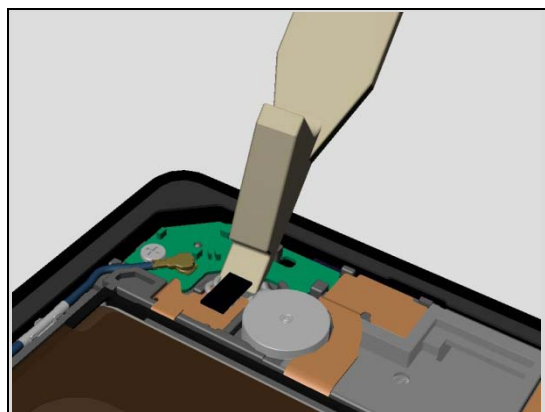
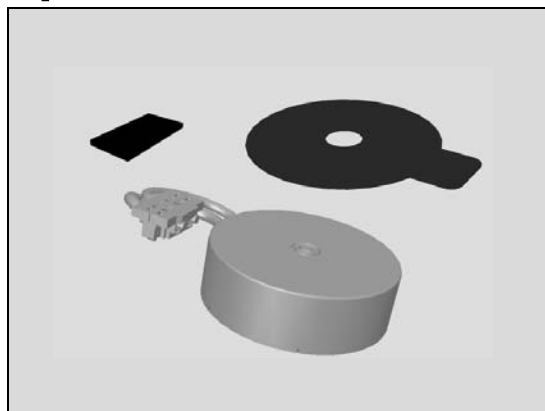
#### REMOVAL

Unsnap the connector for the Vibrator.

Release and remove the Vibrator.

Remove the Adhesive VIB. Remove all remains of the adhesive residue found on the Holder Loud speaker and the Vibrator.

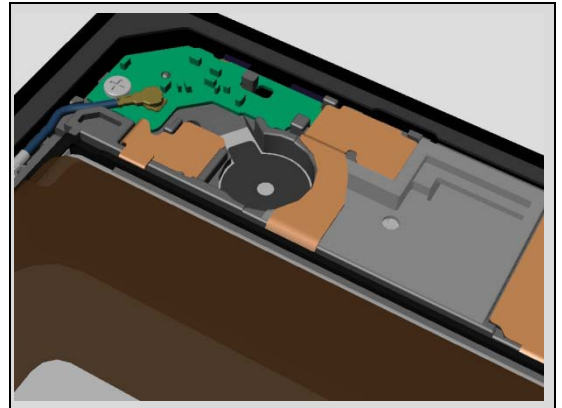
**Scrap! Not to be reused!**



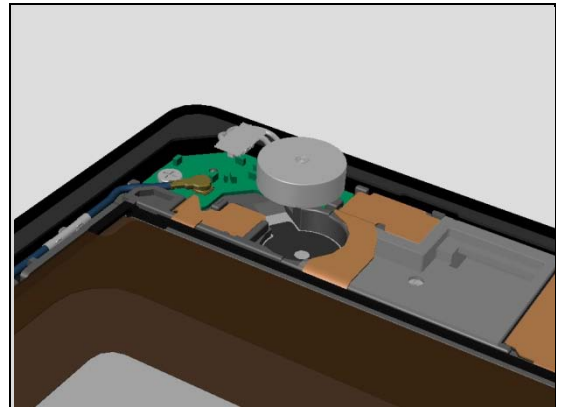
## Replacement:

### INSTALLATION

Place a new Adhesive VIB in the correct position.

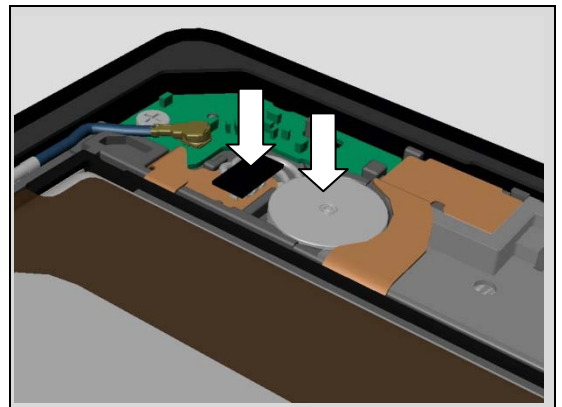


Place the Vibrator in the correct position.



Take a new Spacer 5 x 2.5 if the Vibrator isn't reused.  
Press on the Vibrator and the Spacer 5 x 2.5 to secure the attachment

**Scrap! The Spacer 5 x 2.5 should never be reused!**



## Replacement

### 4.37 Cushion Cam

Carry out the Removal as described below.  
Prepare the new Cushion Cam.  
Carry out the Installation as described below.

#### REMOVAL

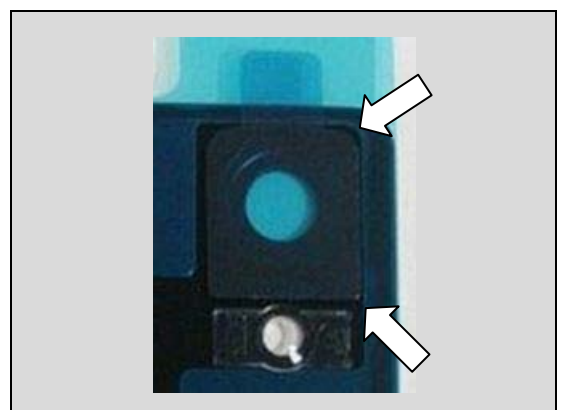
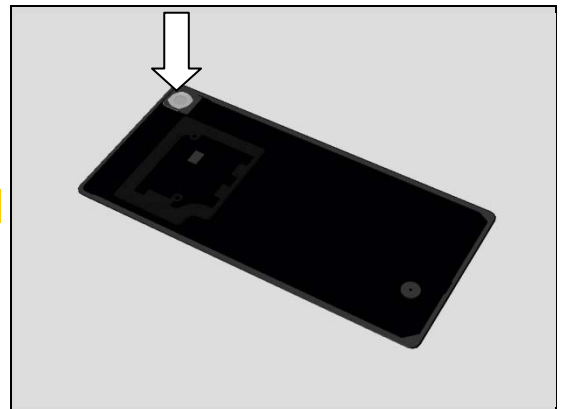
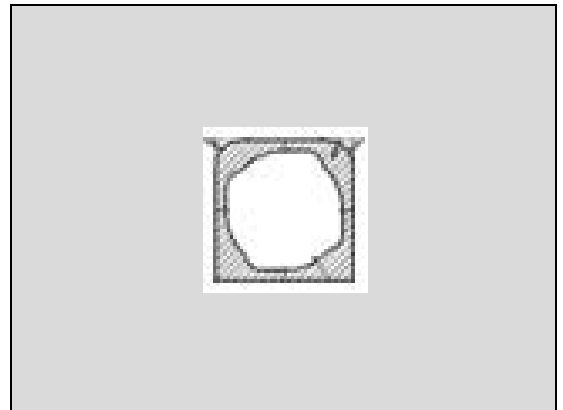
Remove old Cushion Cam from Back Panel

**Scrap! Not to be reused!**

Remove the old Adhesive and all remains of the Adhesive residue found on Back panel.

#### INSTALLATION

Align Cushion Cam's rounded edge along top and then align it along the right edge (blue dotted line).





## Replacement

### 4.38 Sheet Guide Label

*Follow the 3.1 – 3.4 Disassembly instructions!*

Carry out the Removal as described below.

Prepare the new Sheet Guide Label

Carry out the Installation as described below.

*Follow the 5.5 – 5.8 Reassembly instructions!*

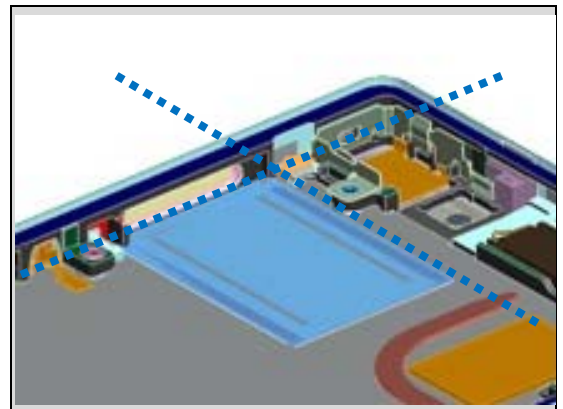
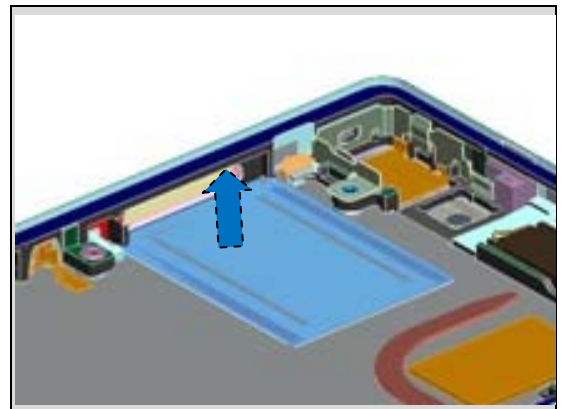
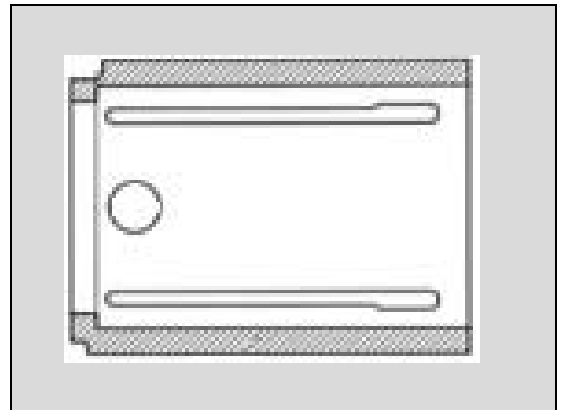
#### REMOVAL

Remove the Sheet Guide label

#### INSTALLATION

Align the sheet along the edge and the guiding line on the display frame (dotted lines)

Mount and press to secure the attachment of the Sheet.





## Replacement

### 4.39 Sheet 5x10

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Follow the 4.23 Removal instructions!*

Carry out the Removal as described below.

Prepare the new Sheet 5x10

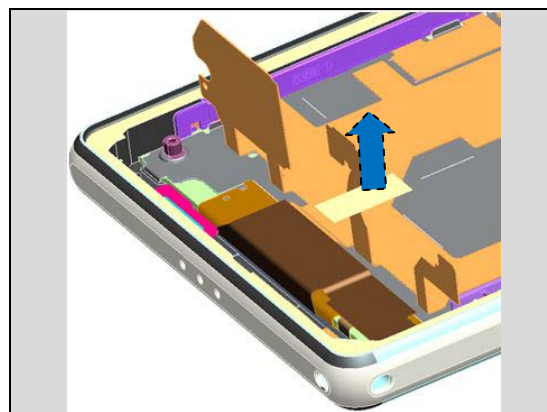
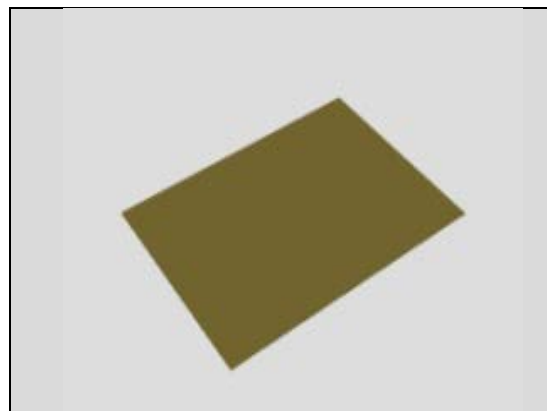
Carry out the Installation as described below.

*Follow the 4.23 Installation instructions!*

*Follow the 5.5 – 5.8 Reassembly instructions!*

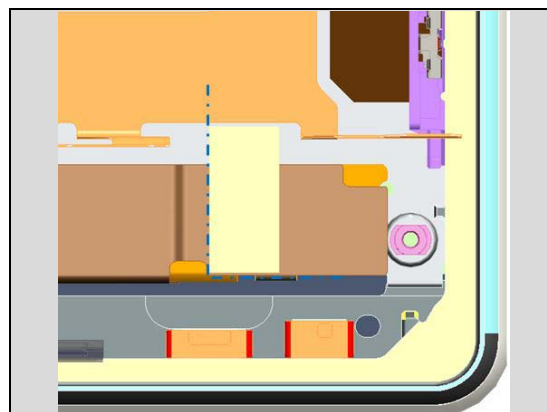
#### REMOVAL

Remove the Sheet 5x10



#### INSTALLATION

Align to attach Sheet 5x10 in the corner of Display Frame's FPC.



Secure that the sheet does not overlap FPC Relay (top circle).

Secure that the sheet is following the Display Frame's FPC edge (bottom circle).



## Replacement

### 4.40 Spacer 8x5

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Follow the 4.23 Removal instructions!*

Carry out the Removal as described below.

Prepare the new Spacer 8x5

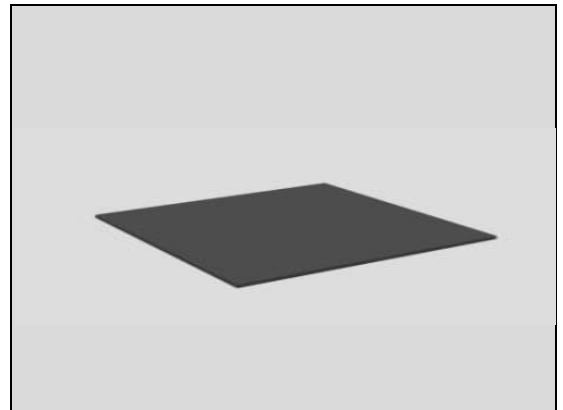
Carry out the Installation as described below.

*Follow the 4.23 Installation instructions!*

*Follow the 5.5 – 5.8 Reassembly instructions!*

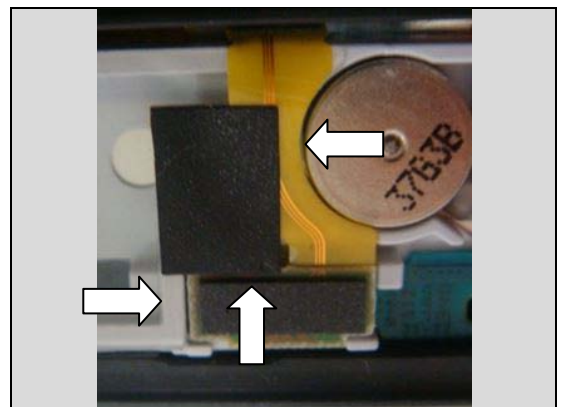
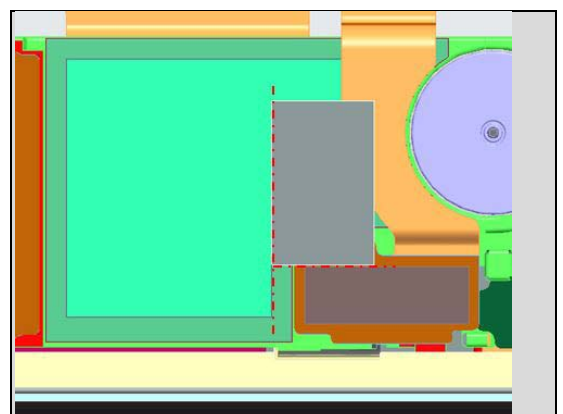
#### REMOVAL

Remove the Spacer 8x5



#### INSTALLATION

Align the spacer along the edge of FPC Relay's gasket and the Holder Loudspeaker wall for Loudspeaker. (dotted lines)  
Mount and press to secure the attachment of the spacer.



## Replacement

### 4.41 Sheet 1st MIC

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Follow the 4.23 Removal instructions!*

Carry out the Removal as described below.

Prepare the new Sheet 1st MIC

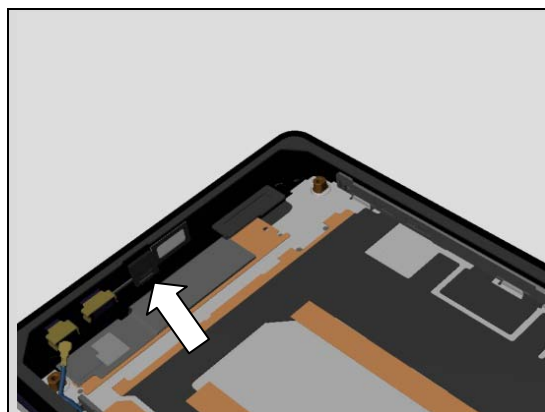
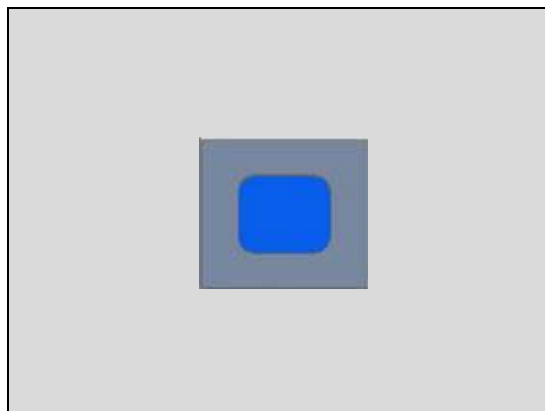
Carry out the Installation as described below.

*Follow the 4.23 Installation instructions!*

*Follow the 5.5 – 5.8 Reassembly instructions!*

#### REMOVAL

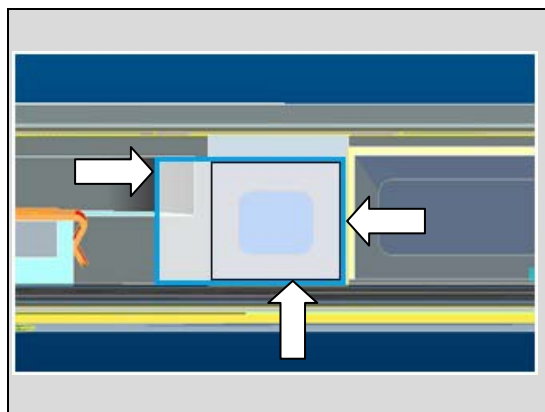
Remove the Sheet 1st MIC



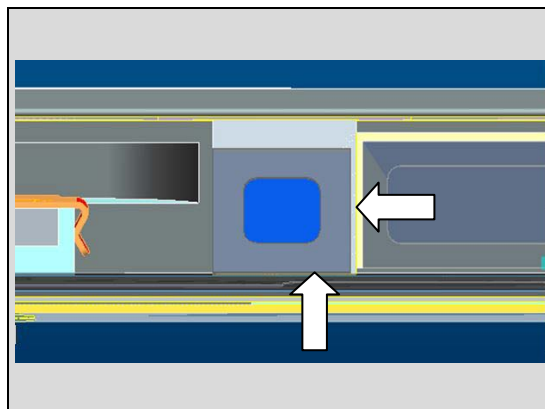
#### INSTALLATION

Secure that the protection tape direction is to the left.

Align the Sheet 1st MIC along the right and bottom edge



Secure the Sheet 1st MIC is aligned along the right and bottom edge.



## Replacement

### 4.42 Board Swap - Replacement

*Follow the 3.1 – 3.8 Disassembly instructions!*

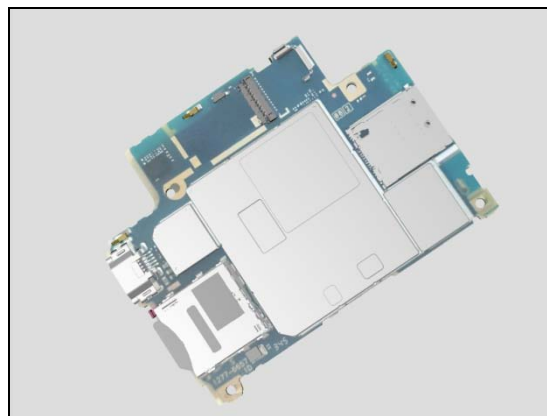
*Follow the 4.12 Removal instructions!*

Replace the Swap Board.

Reuse the Main Camera and the Camera Chat.

*Follow the 4.12, 4.21 Installation instructions!*

*Follow the 5.1 – 5.8 Reassembly instructions!*



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

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

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

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

Accelerometer

Gyroscope

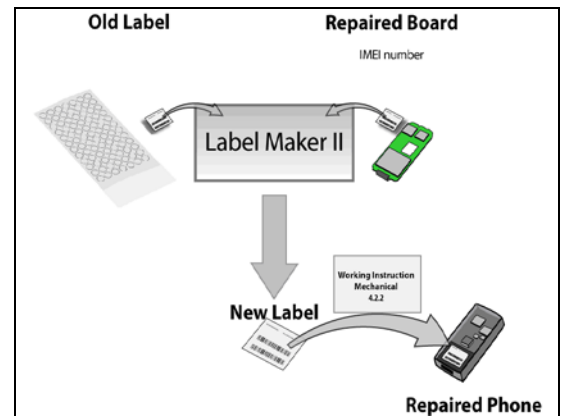
Noise cancelling

## Replacement

### 4.43 Board Swap – Change Label

#### CHANGE LABEL

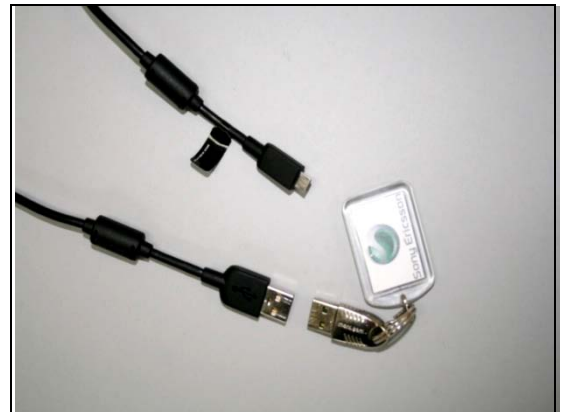
Follow the instructions in the Generic Repair Manual –  
Build swap for change of label.



### 4.44 Board Swap – Customize of Software

#### CUSTOMIZE OF SOFTWARE

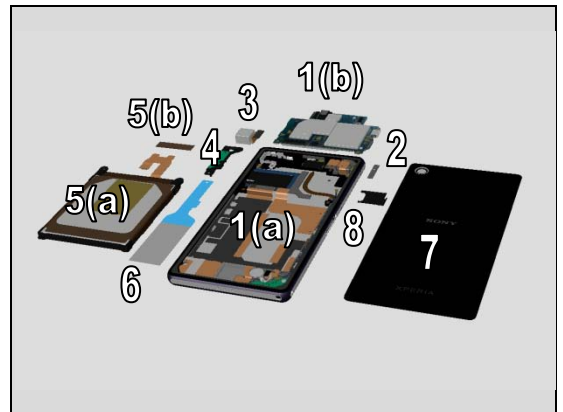
Follow the instructions in the Generic Repair Manual –  
Build swap for customization of the software.



## 5 Reassembly

The disassembly is done in the following order:

1. Front assy (a) & Main PBA (b)
2. Sheet CU 17 x 4
3. Main Camera
4. Antenna WLAN
5. Battery (a) & Sheet FPC Battery (b)
6. Adhesive Battery
7. Back Panel with Adhesive Panel Back
8. SIM Tray

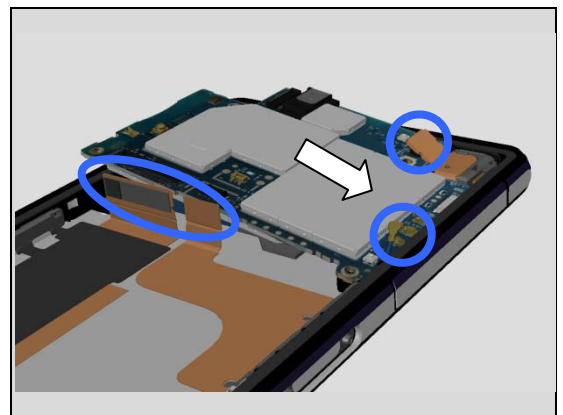


### 5.1 Front assy & Main PBA

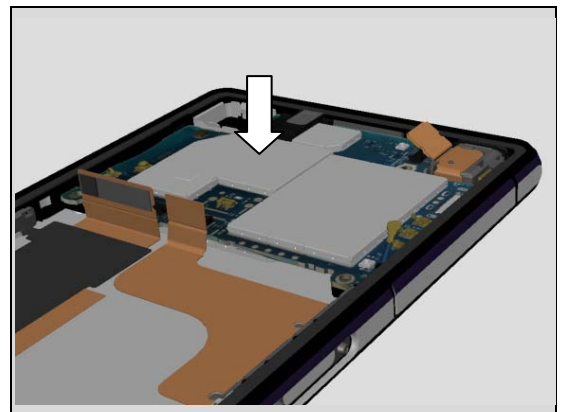
Insert the Main PBA into front assy.

Align with the USB connector.

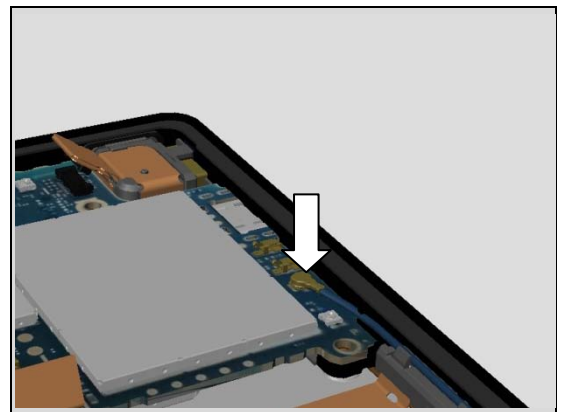
Be careful with the BtB flexes and the Cable RF Coax.



Press gently to secure the position.

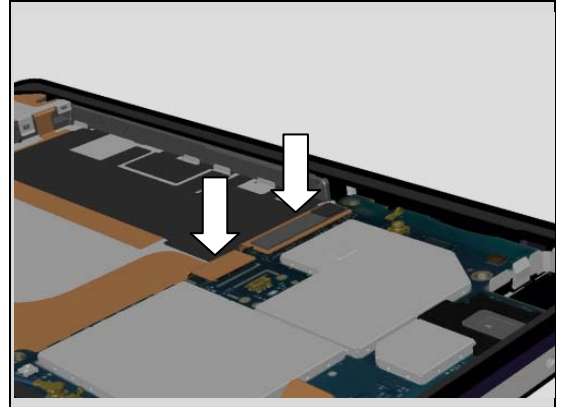


Connect the Cable RF Coax.

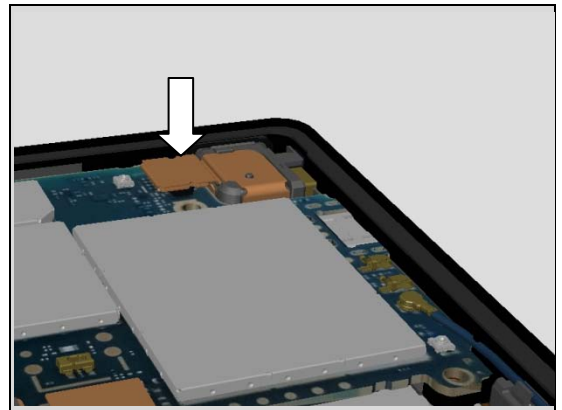


## Reassembly

Connect the BtB of the FPC CG and the FPC Relay.



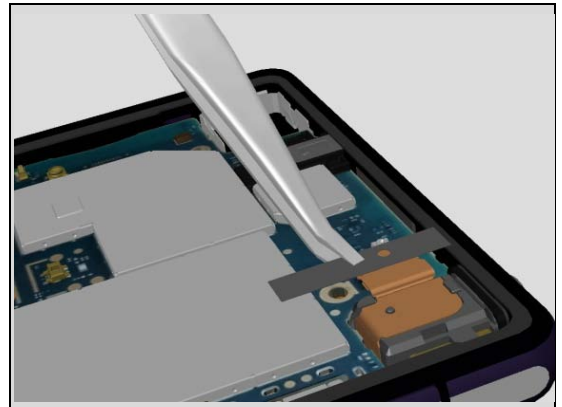
Connect the BtB of the FPC Audio Jack.



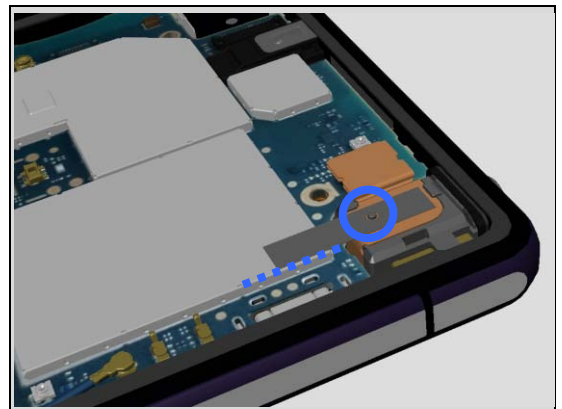
## 5.2 Sheet CU 17 x 4

Attach a new Sheet CU 17 x 4.

**Take a new Sheet!**



Align with the boss in the FPC Audio Jack and the edge of the shield lid.



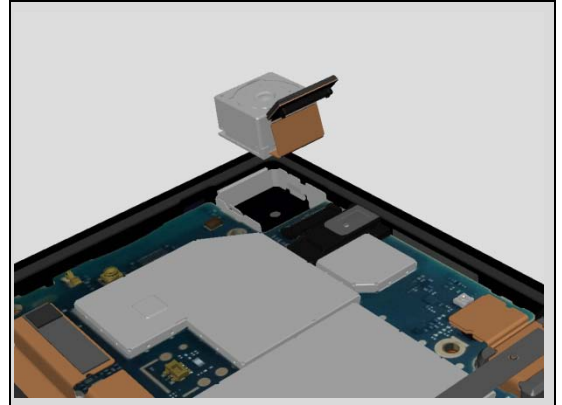


## Reassembly

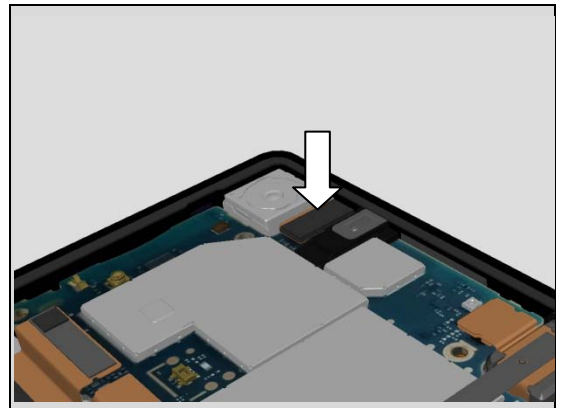
### 5.3 Main Camera

Place the Main Camera in the cavity.

**Note: Do not touch the lens.**

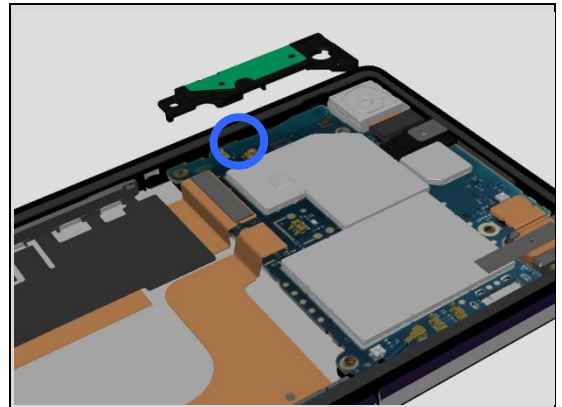


Connect the BtB of the Main Camera.

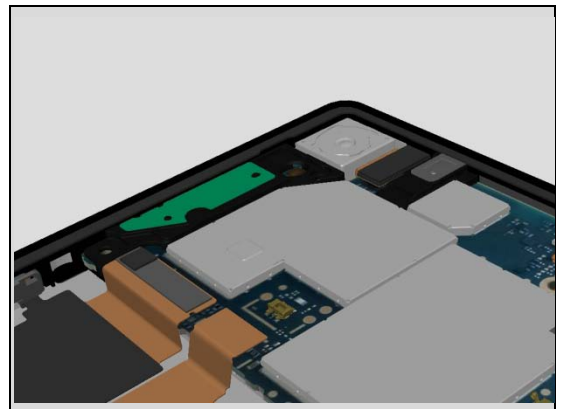


### 5.4 Antenna WLAN

Place the Antenna WLAN. Align with the hook in the frame.



Press gently with your finger.





## Reassembly

### 5.5 Battery & Sheet FPC Battery

**Note: Visible inspection of the Battery.**

*There is risk to damage the cell laminate (Pinhole, Bubbles or Wrinkles) when the Adhesive Battery is removed.*

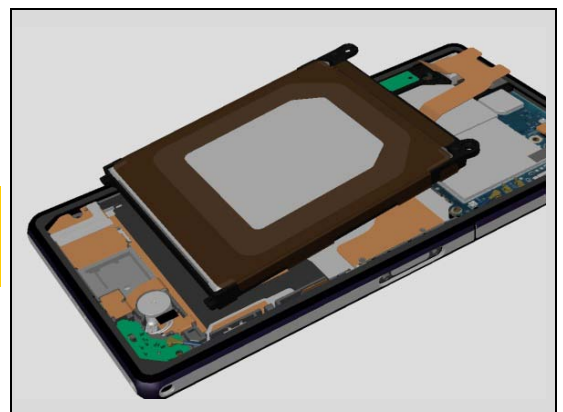
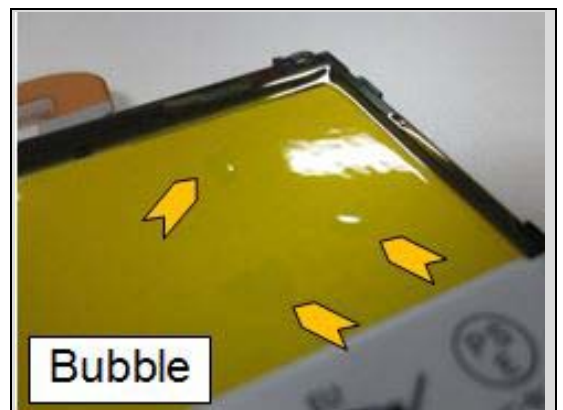
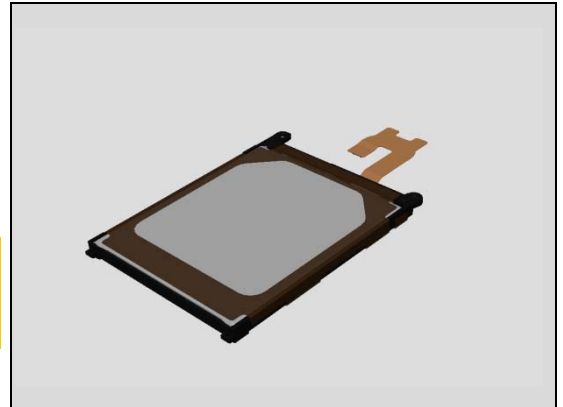
It is ok to reuse battery if the wrinkle is less than 5 mm.  
A swollen Battery should not be reused.

Battery with bubbles less than 3 mm in diameter can be reuse.

Do not twist or deform the battery in any way. A Battery that has been dropped to floor should not be reused.

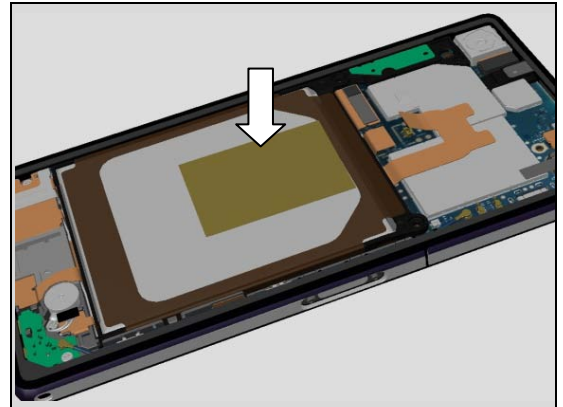
Mount the Battery in an angel.

**Note: If a new Battery is used please follow the replacement instruction for the Sheet Battery Adhesive Top 4.27**



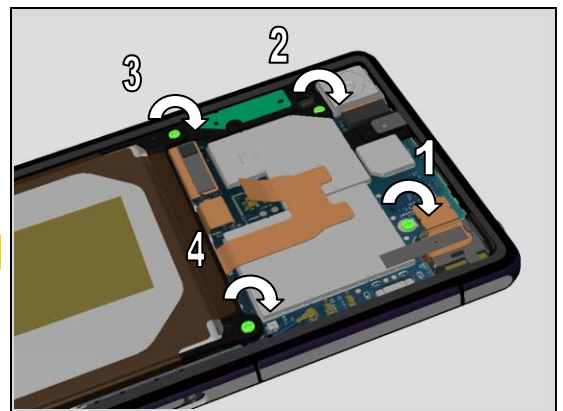
## Reassembly

Press gently with your finger on the Battery to secure the position.



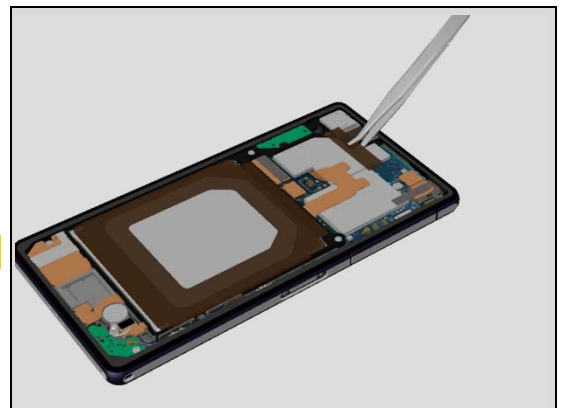
Apply  $12 \pm 1$  Ncm torque when tightening the Screw Bits (JCIS No 0).

**Take new Screws!**

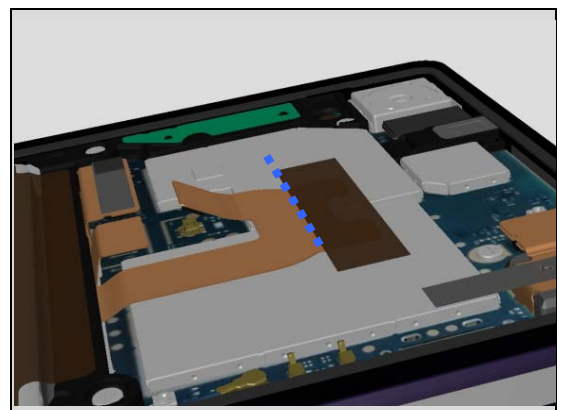


Attach a new Sheet FPC Battery.

**Take a new Sheet!**



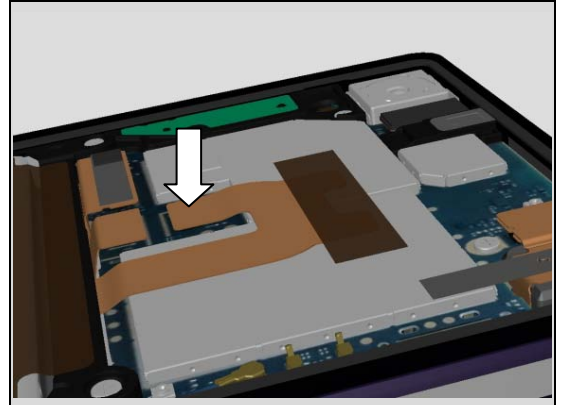
Align the Sheet as it covers the 'ears' of Battery flex.



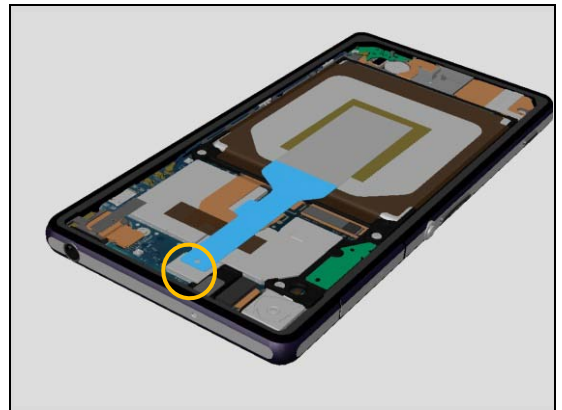
## Reassembly

### 5.6 Adhesive Battery

Connect the BtB of the Battery.



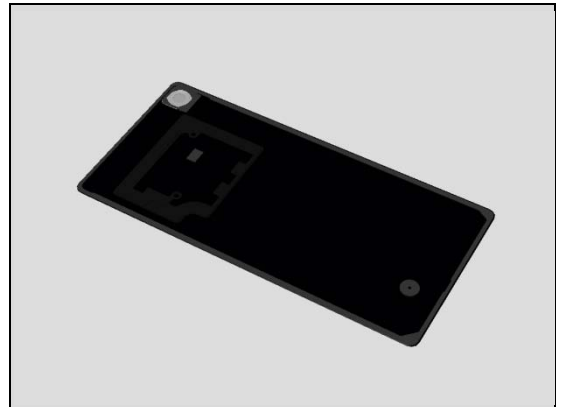
Align and attach the Adhesive Battery.



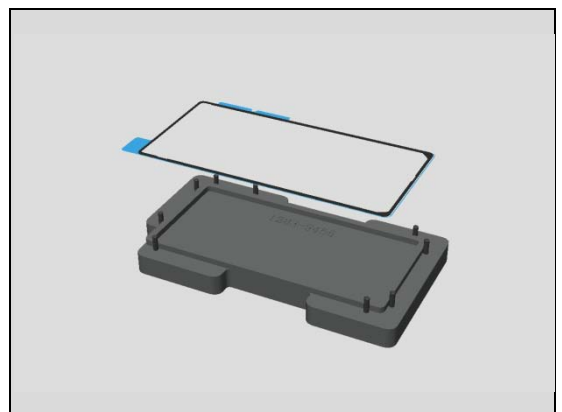
### 5.7 Back Panel with Adhesive Panel Back

Remove the old Adhesive Panel Back and all remains of the Adhesive residue.

Clean the edges of the Back Panel carefully with alcohol before the new Adhesive Panel Back is mounted. This action is done to secure the water resistant of the unit.

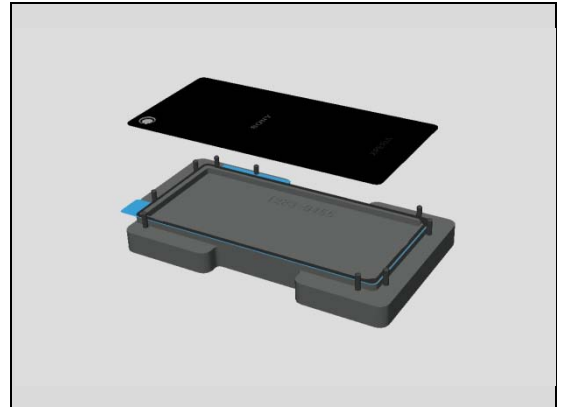


Place the new Adhesive in the Rear Panel Adhesive Align Fixture.

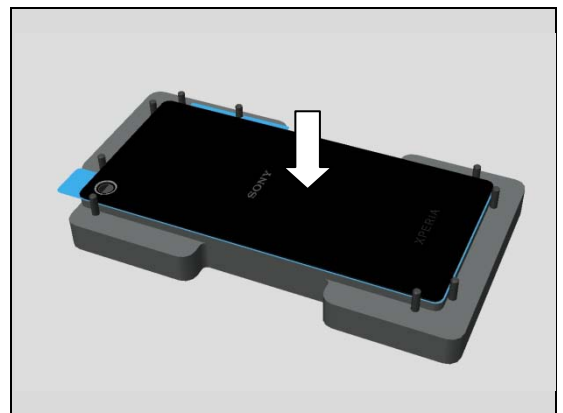


## Reassembly

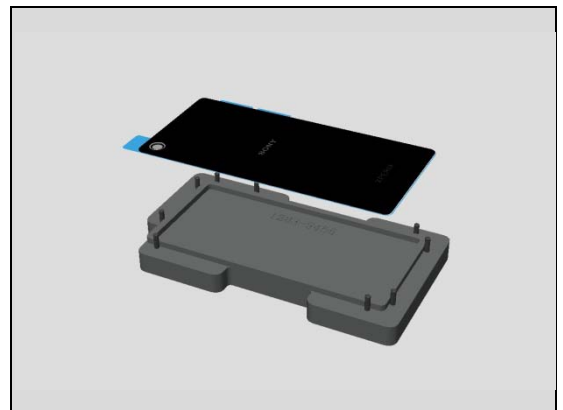
Place the Back Panel in a correct position.



Press to secure the attachment.



Lift up the Back Panel with the new Adhesive.



The Back Panel is ready to be assembled.

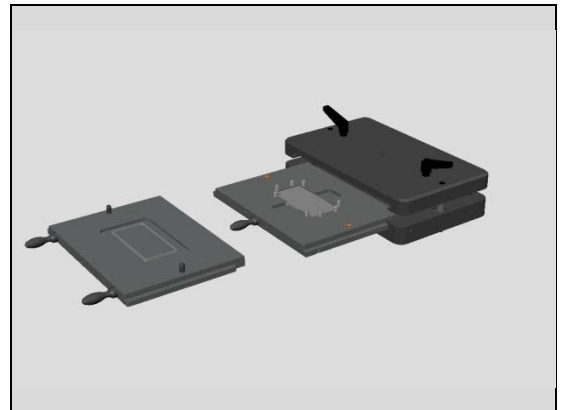


## Reassembly

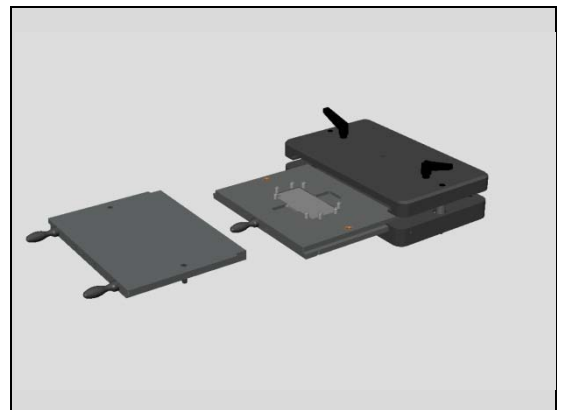
Insert the bottom press inlay.



Prepare top press inlay.



Turn around the top press inlay and insert it.



Secure that the top press is in correct position.



## Reassembly

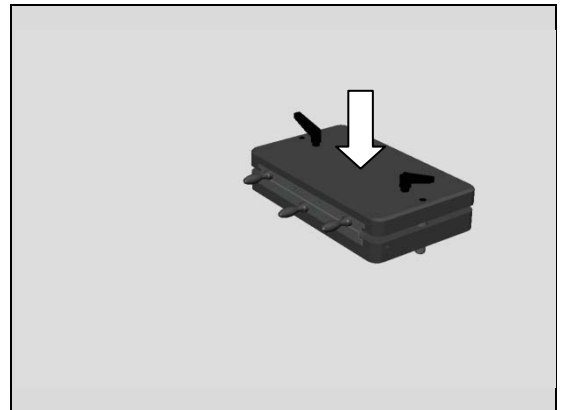
Place the unit with the back Panel upwards in the bottom inlay.

Follow the instruction in 1003 - 9107 Tool Catalogue - mechanical and document Toothed Rack Press Instruction.



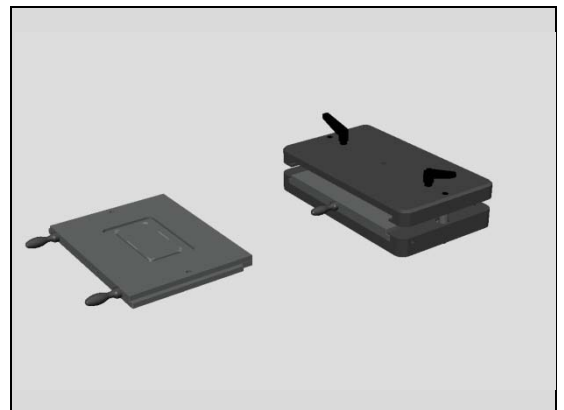
Insert the bottom press.

Press with  $494 \pm 50$  N for 20 seconds  
(the pressure value is adjusted for 600N because of the weight of the pressure fixture)

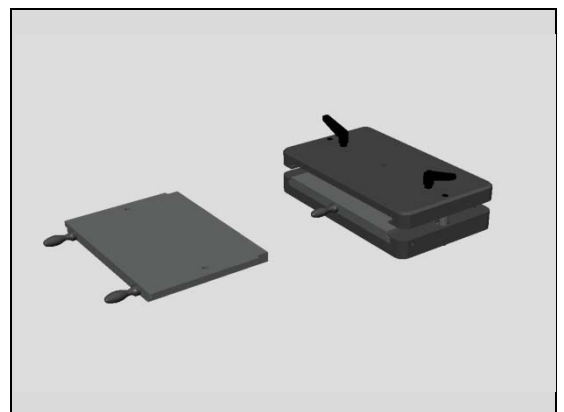


Replace the top press inlay with Top press inlay no 2.  
Inlay no 2 presses mainly at the edges and in corners.  
The Top press inlay no 2 is an improved solution for the 2<sup>nd</sup> press of the unit.

(Note: until Top press inlay no 2 is available in stock, June 2014, the top press inlay can be used temporarily for the 2<sup>nd</sup> press)

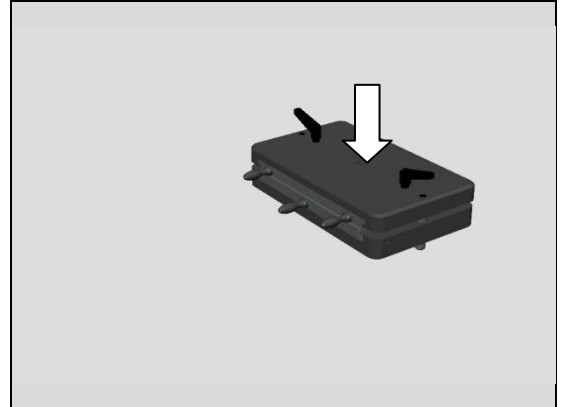


Turn around the top inlay no 2 and insert it.



## Reassembly

Press with  $494 \pm 50$  N for 10 seconds  
(the pressure value is adjusted for 600N because of the weight of the pressure fixture)

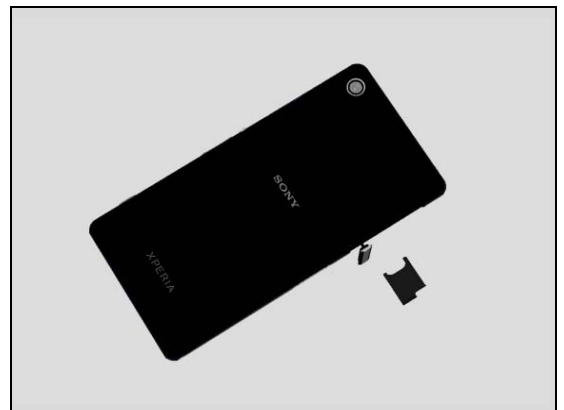


Remove the unit from the pressure fixture.

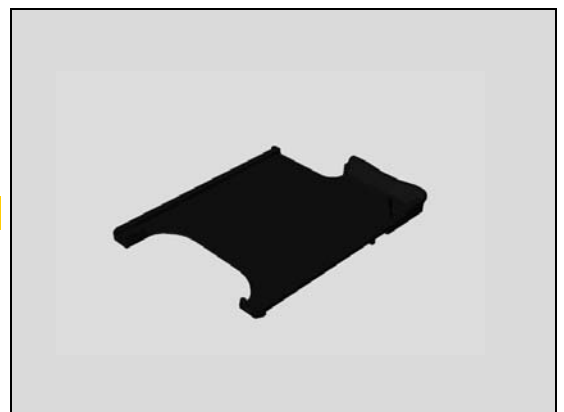


## 5.8 SIM Tray

Insert the SIM Tray.



**Secure the correct direction of the SIM Tray.**





## 6 Revision History

Rev.	Date	Changes / Comments
1	2014-March-20	Initial release
2	2014-April-02	Chapter 4 and 5 completely reworked.
3	2014-April-03	Due to system error.
4	2014-April-09	The "Board Swap – Replacement" has been updated. Added 4.20 & 4.23
5	2014-April-23	Pressure time changed to 20s in Reassembly, Top press inlay no 2. Have been added to Tools & Reassembly
6	2014-June-04	Cushion CAM, Sheet 5 x 10, Sheet Guide Label, Spacer 8 x 5 added, 4.09 Display Frame updated.
7	2014-July-02	Sheet 1st MIC added,
8	2014-July-30	Sheet LCD 18 x 7; 1280-4970 and Sheet LCD 7 x 7;1280-4972 removed!