

Working Instructions

- mechanical -



Xperia™ Z3

D6603,D6616,D6643,D6653,D6646

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

1 Exterior Views

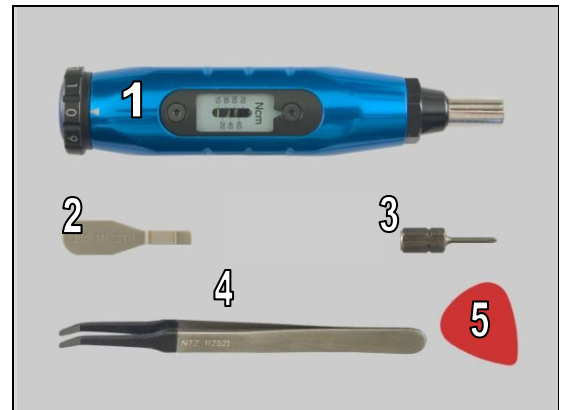
1.1 D6603, D6616, D6643, D6653, D6646



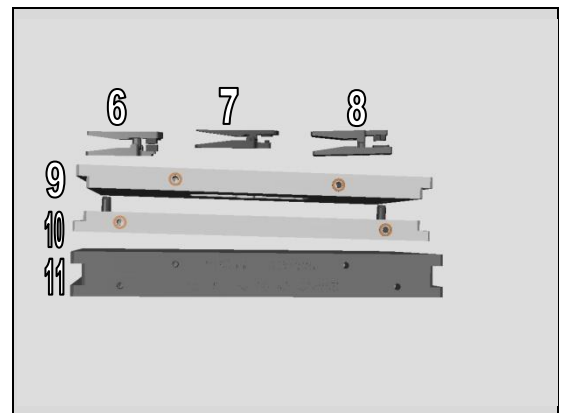
2 Tools

SPECIAL TOOLS

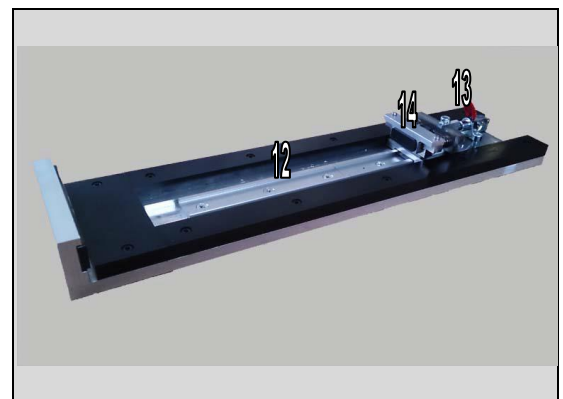
1. Torque Screwdriver
2. Front Opening Tool
3. Bits (JCIS No 0)
4. Flex Film Assembly Tool
5. Guitar Pick



6. Audio Jack Press
7. Press Tool Loudspeaker
8. Speaker FPC Press
9. Rear Panel Press Top Inlay
10. Bottom Press Inlay
11. Rear Panel Adhesive alignment fixture



12. Side Panel press
13. Side Panel Press Head
14. Charge connector press pad

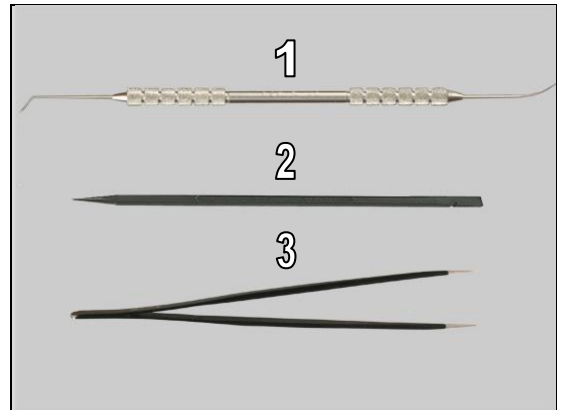


For part no's on the tools above, refer to the 'Tools Catalogue/Matrix'.

Tools

STANDARD TOOLS

1. Dentist Hook
2. Nylon Pointer
3. Tweezers



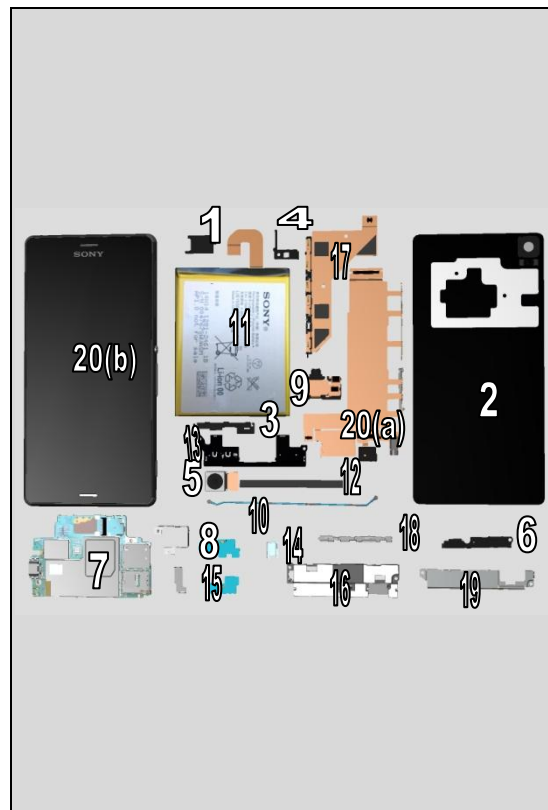
4. Suction Cup



3 Disassembly

The disassembly is done in the following order:

1. Sim Tray
2. Rear Panel
3. Sub Antenna
4. Holder Main Camera
5. Main Camera
6. Antenna BT + WLAN
7. Main PBA
8. Shield Main Camera
9. Audio Jack
10. RF cable
11. Embedded Battery
12. Cushion Battery
13. Main Antenna
14. Holder Vibrator
15. Plate Speaker
16. Holder Speaker sub assembly
17. Charge FPC
18. Holder key volume
19. Plate Holder Speaker
20. Relay FPC (a) + Front Assy (b)

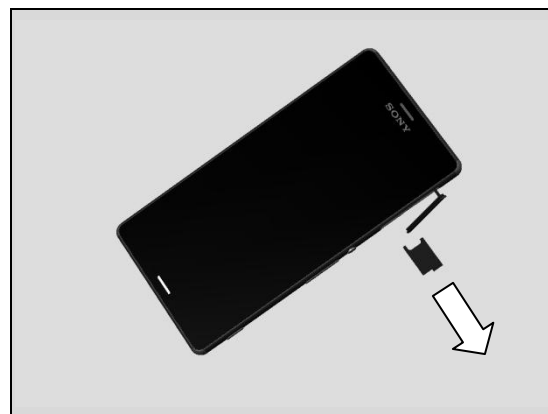


3.1 Sim Tray

Open the Cap SD



Remove the Sim Tray with fingers



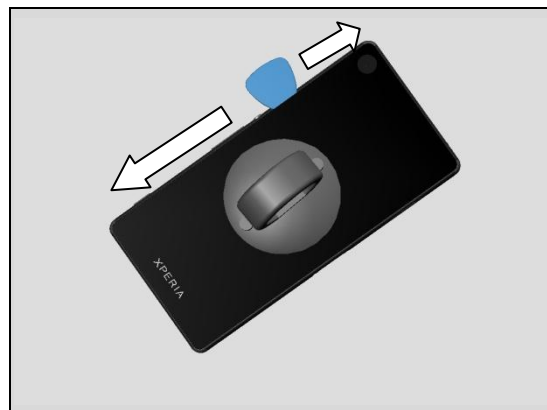
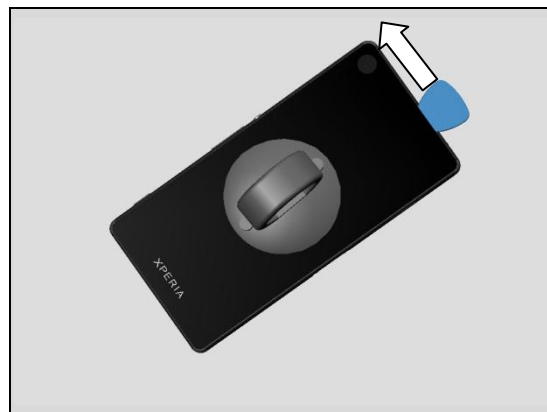
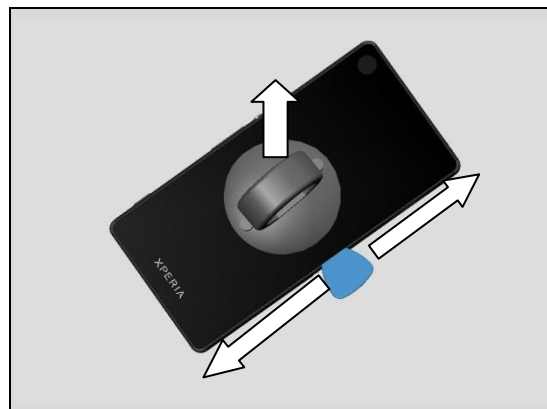
Disassembly

Close the Cap SD

3.2 Rear Panel

Use Suction cup to get space for inserting the Guitar Pick. Gently slide the Guitar Pick along to release all sides of the Rear Panel.

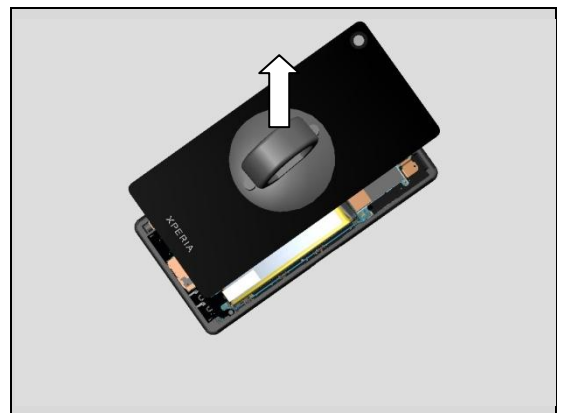
Note! Start in the middle of the right long side!



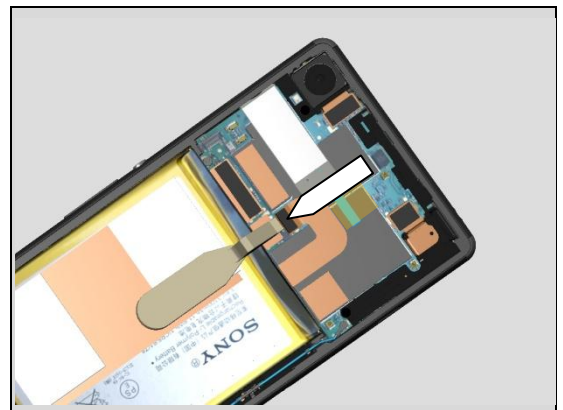
Disassembly

Remove the Rear Panel by using the Suction cup.

Note! Be careful when removing the Rear Panel due to the adhesive between Embedded Battery and Rear Panel.

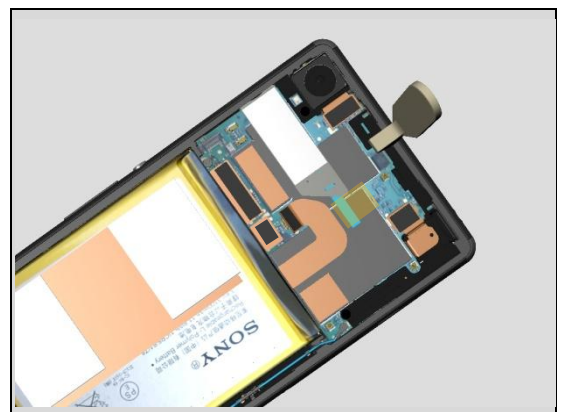


Use a Front Opening Tool to disconnect the BtB connector.



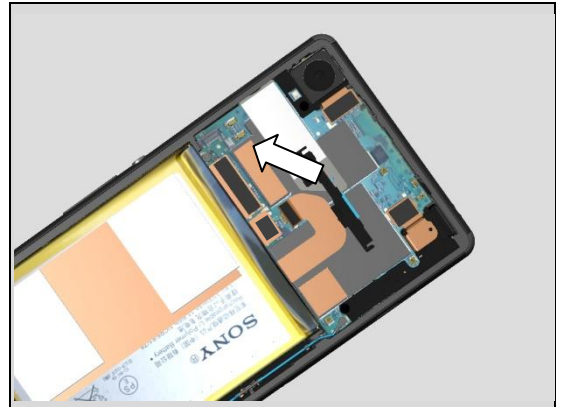
3.3 Sub Antenna

Remove the Sub Antenna by using a Front Opening Tool.



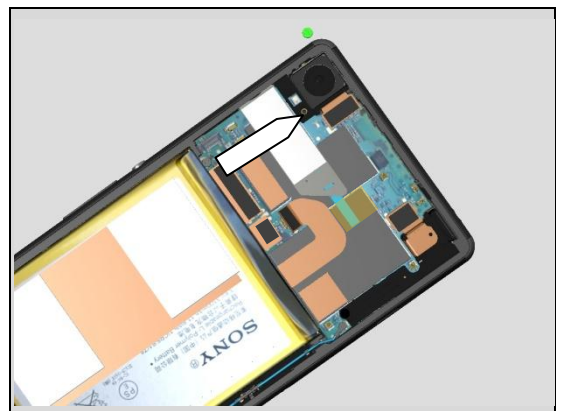
Disassembly

Remove the Sub Antenna.

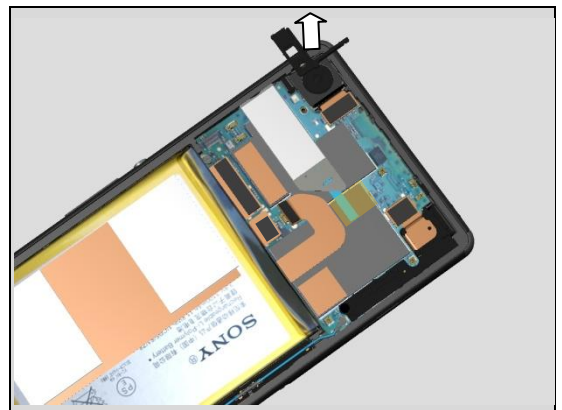


3.4 Holder Main Camera

Remove the Screw Other Len:2.6 Diam:1.4 by using a screwdriver with Bits (JCIS No 0).

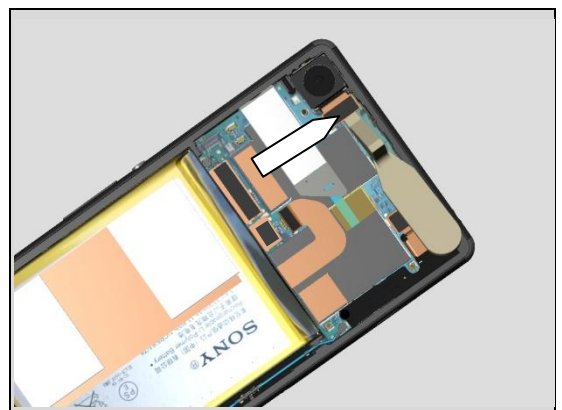


Remove Holder Main Camera



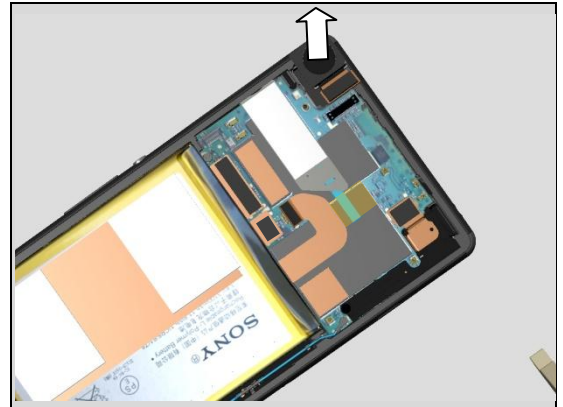
3.5 Main Camera

Use a Front Opening Tool to disconnect the BtB connector.



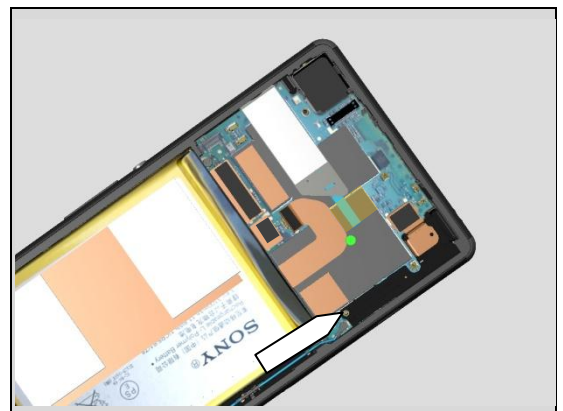
Disassembly

Remove the Camera. Be careful not to damage it.

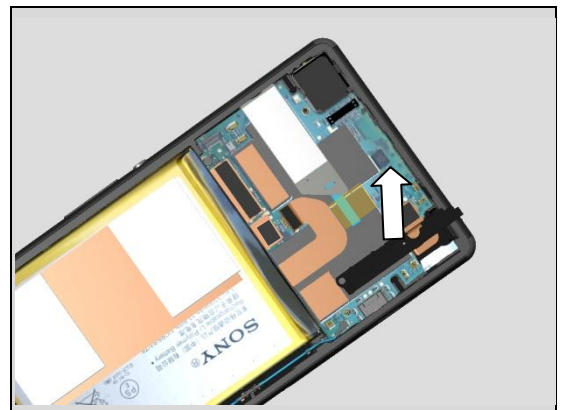


3.6 Antenna BT + WLAN

Remove the Screw Other Len:2.6 Diam:1.4 by using a screwdriver with Bits (JCIS No 0).

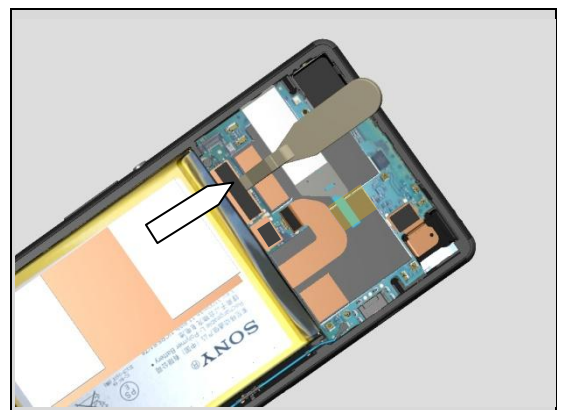


Remove the Antenna BT + WLAN with fingers.



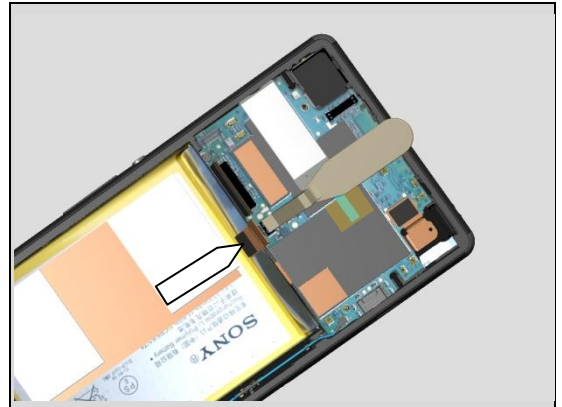
3.7 Main PBA

Use a Front Opening Tool to disconnect the BtB connector for Relay FPC.

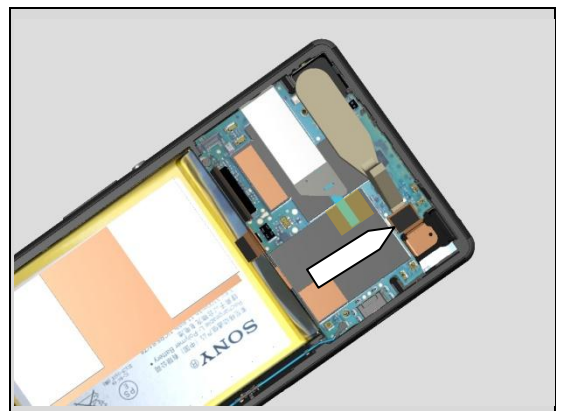


Disassembly

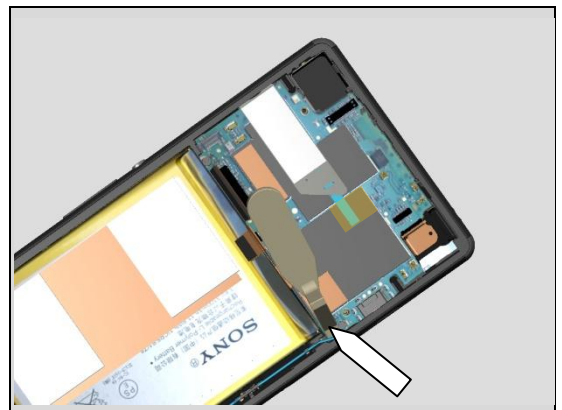
Use a Front Opening Tool to disconnect the BtB connector for Charger FPC.



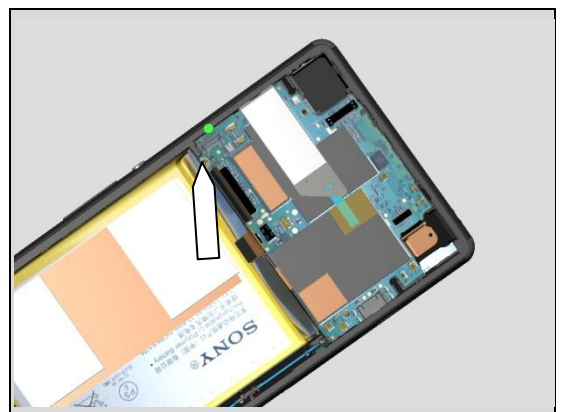
Use a Front Opening Tool to disconnect the BtB connector for Audio Jack.



Use a Front Opening Tool to disconnect the RF cable connector.

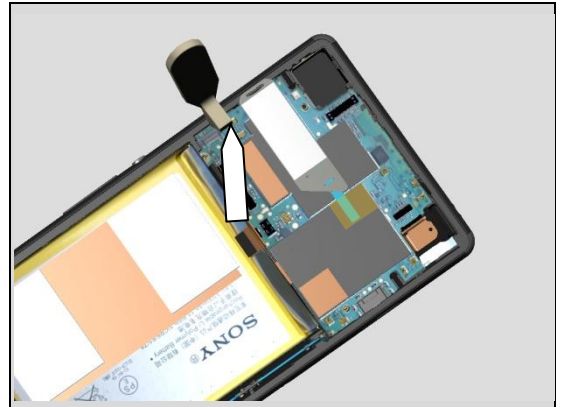


Remove the Screw Other Len:2.6 Diam:1.4 by using a screwdriver with Bits (JCIS No 0).

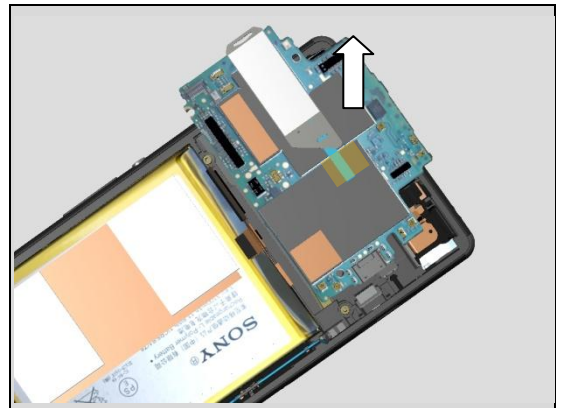


Disassembly

Insert the Front Opening Tool to release the Main PBA.

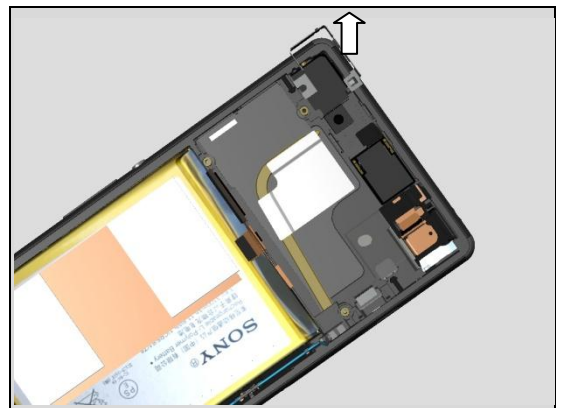


Remove the Main PBA



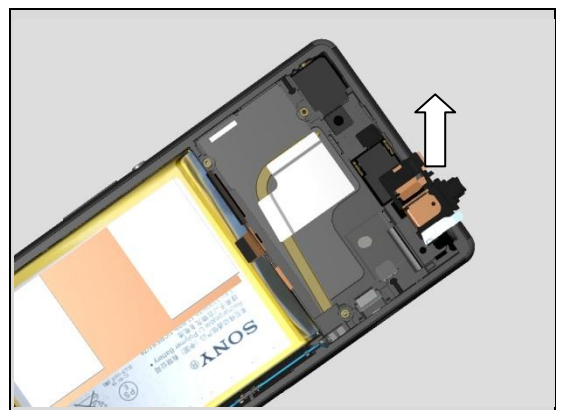
3.8 Shield Main Camera

Remove Shield Main Camera with a pair of tweezers.



3.9 Audio Jack

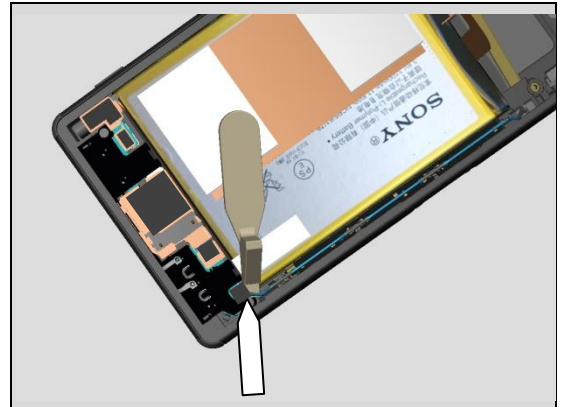
Remove the Audio Jack with fingers.



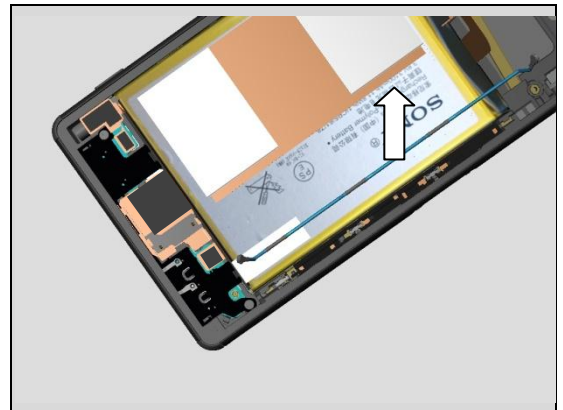
Disassembly

3.10 RF cable

Use a Front Opening Tool to disconnect the RF cable connector.

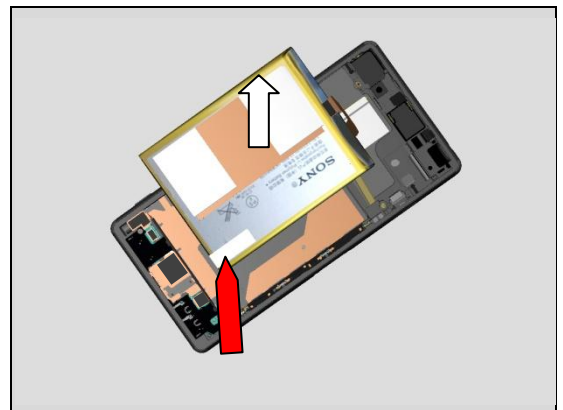


Remove the RF cable with fingers



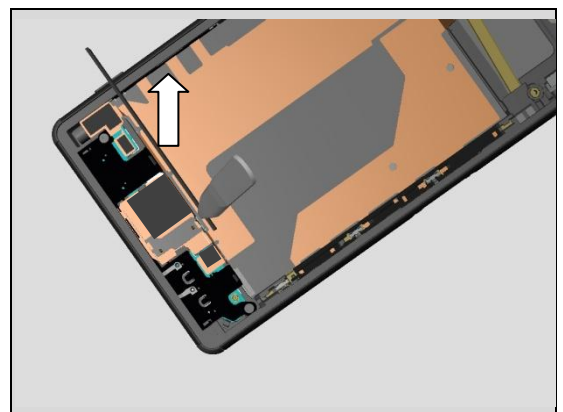
3.11 Embedded Battery

Remove the Embedded Battery by pull the tab (red arrow) with fingers



3.12 Cushion Battery

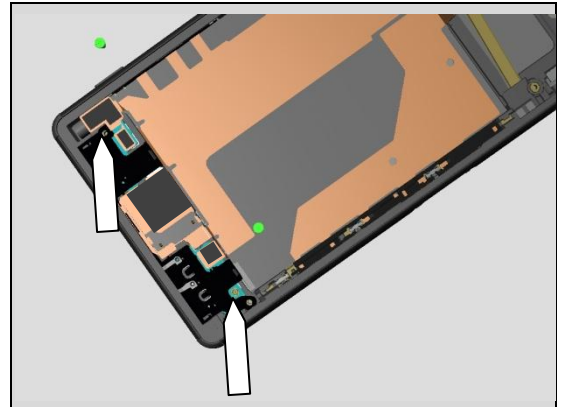
Remove the Cushion Battery using a Front Opening Tool and fingers.



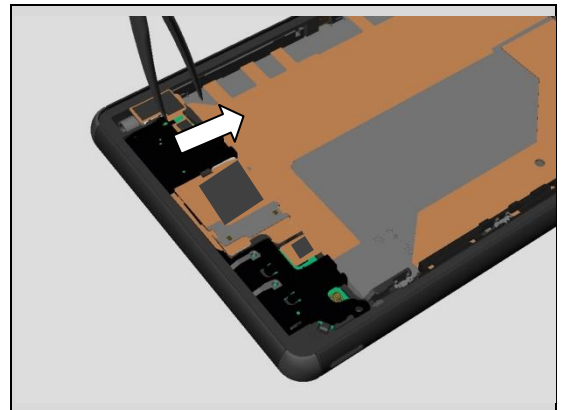
Disassembly

3.13 Main Antenna

Remove the two Screw Other Len:4.0 Diam:1.4 by using a screwdriver with Bits (JCIS No 0).



Insert the Flex Film Assembly Tool to release left side of Main Antenna



Insert the Flex Film Assembly Tool to release right side of Main Antenna



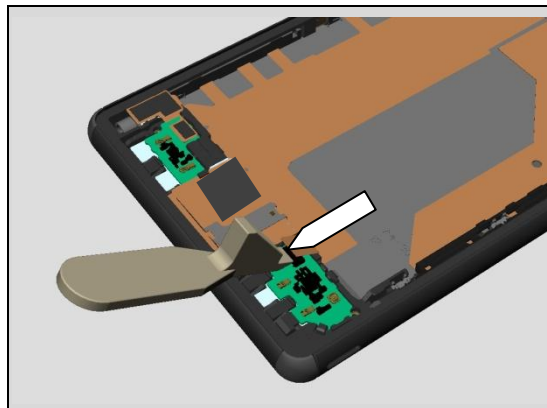
Remove Main Antenna with fingers



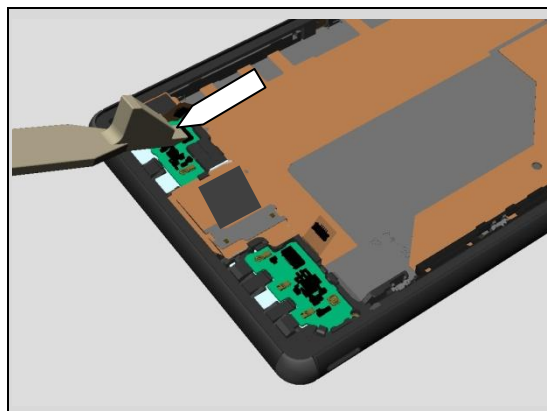
Disassembly

3.14 Holder Vibrator

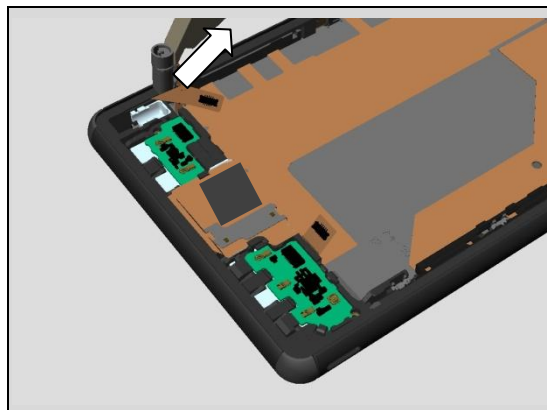
Use a Front Opening Tool to disconnect the BtB connector.



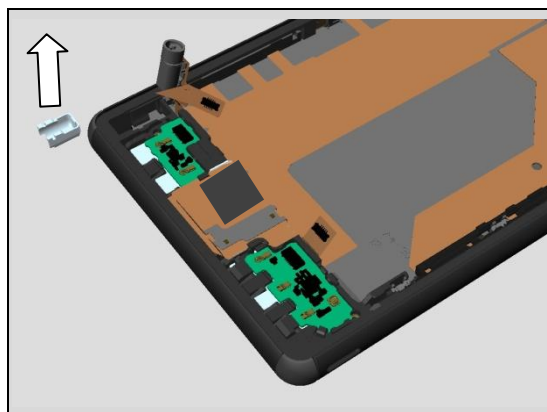
Use a Front Opening Tool to disconnect the BtB connector.



Lift the Vibrator



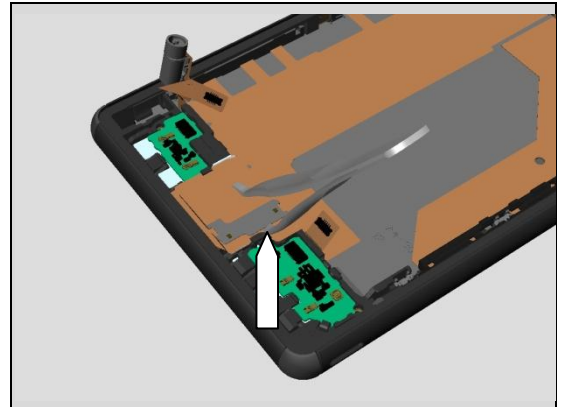
Remove the Holder Vibrator with a pair of tweezers.



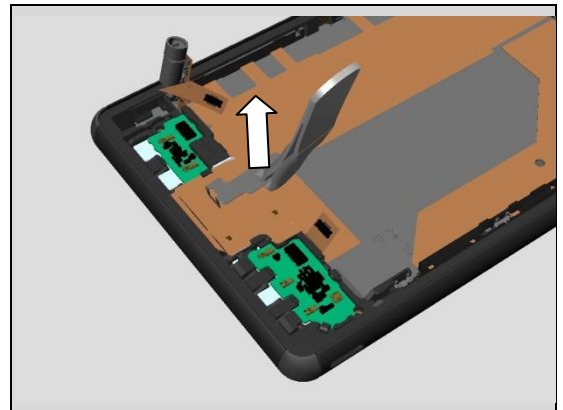
Disassembly

3.15 Plate Speaker

Detach the Plate Speaker with Flex Film Assembly Tool.

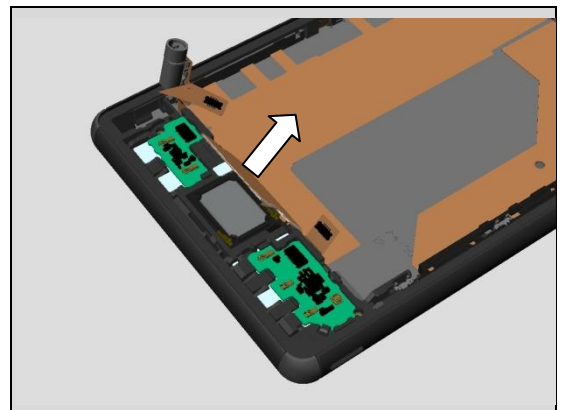


Remove the Plate Speaker with Flex Film Assembly Tool.



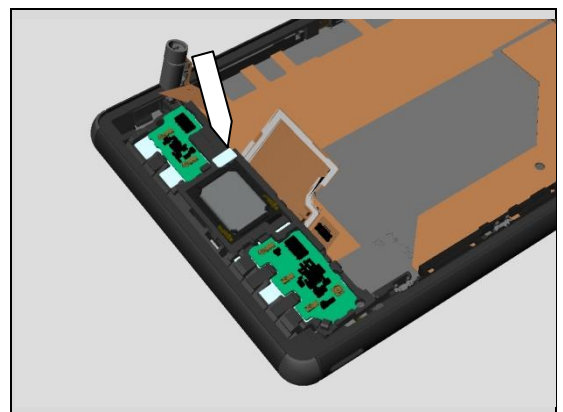
3.16 Holder Speaker sub assembly

Lift up the Relay FPC over Holder Speaker sub assembly with a Flex Film Assembly Tool



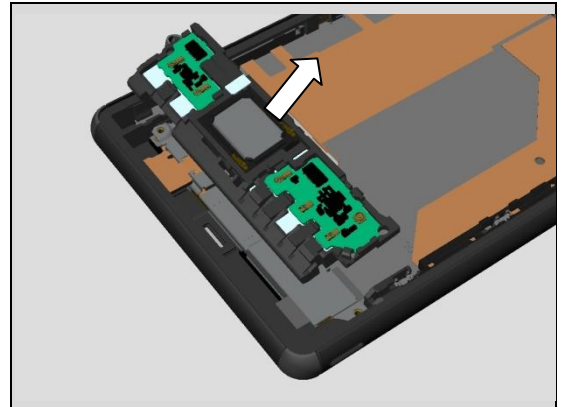
Unsnap the Holder Speaker sub assembly with fingers

Note see 4.76 MComp Sheet Spekaer BV G if you lift the tape indicated by arrow.



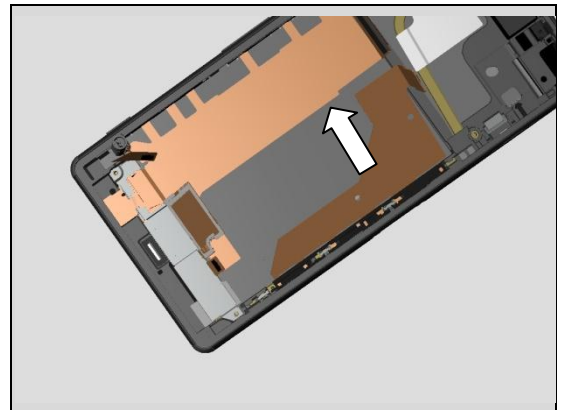
Disassembly

Remove it.

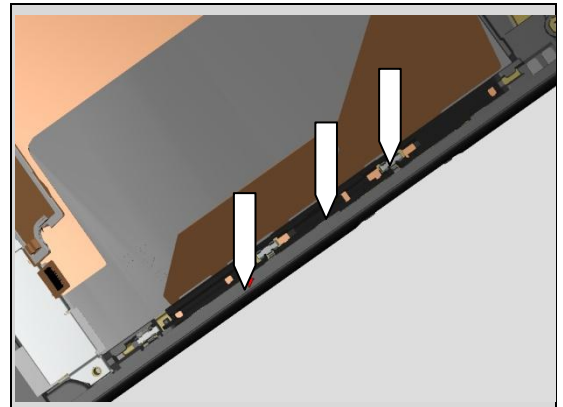


3.17 Charge FPC

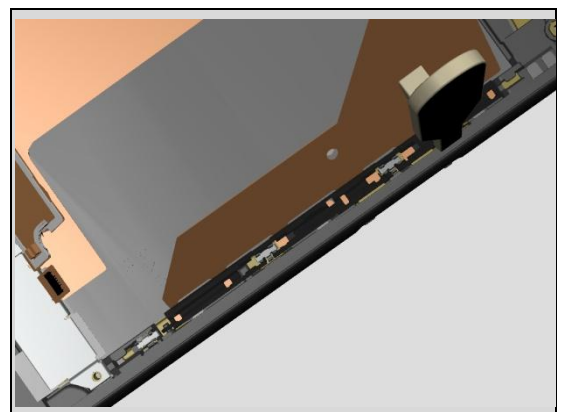
Detach the adhesive under the Charge FPC



Charge FPC has three hooks

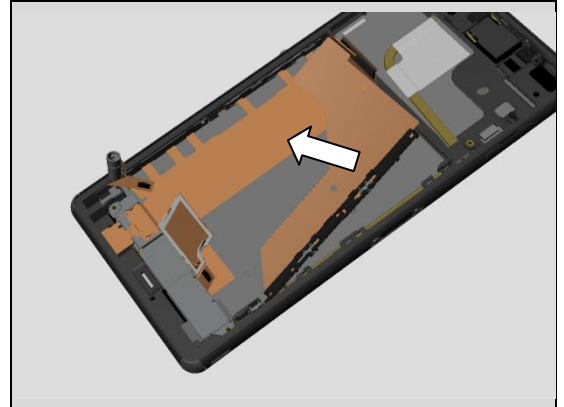


Detach the Charge FPC from Front Assy using Front Opening Tool

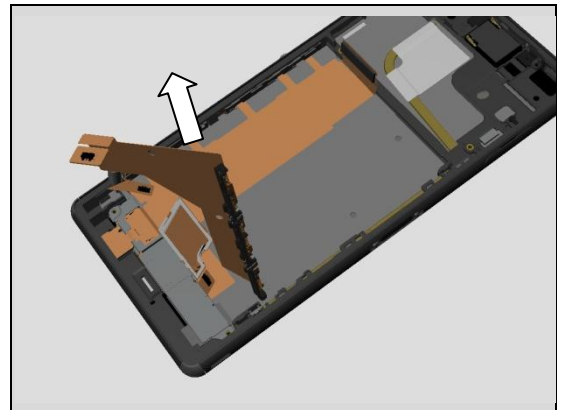


Disassembly

Lift up the Charge FPC

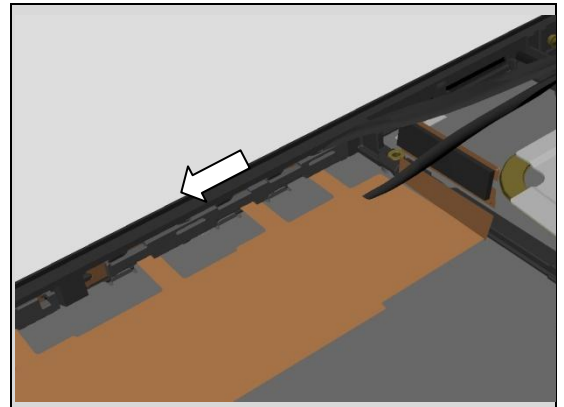


Remove the Charge FPC

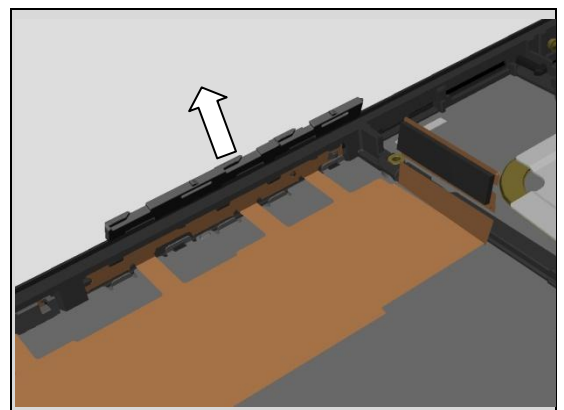


3.18 Holder key volume

Detach the Holder key volume to the left using a Flex Film Assembly Tool

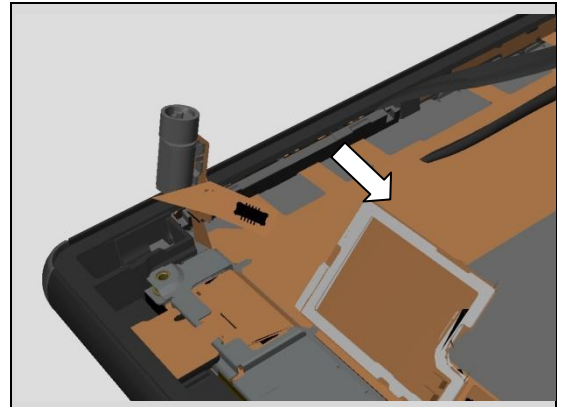


Remove the Holder key volume



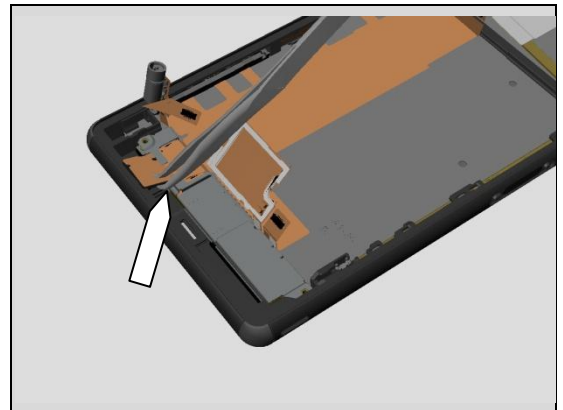
Disassembly

Unsnap the Holder camera key of Relay FPC

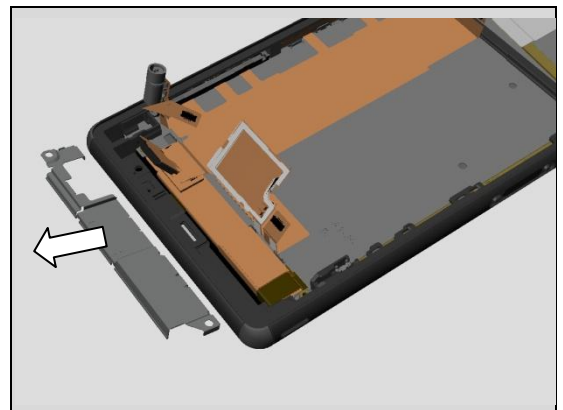


3.19 Plate holder speaker

Detach the Holder Mic sub assembly of Relay FPC from Front Assy with a Flex Film Assembly Tool.

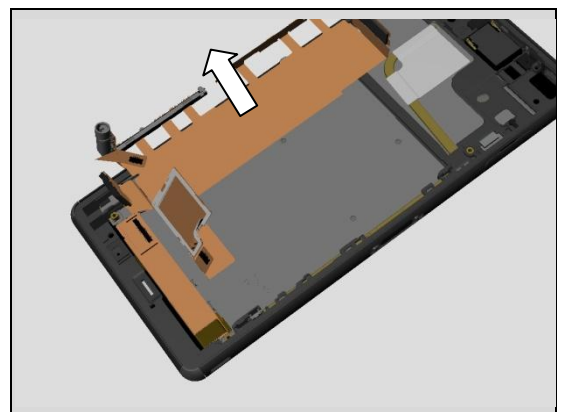


Remove the Plate holder speaker using a pair of tweezers.



3.20 Relay FPC + Front Assy

Detach the adhesive under Relay FPC and remove it



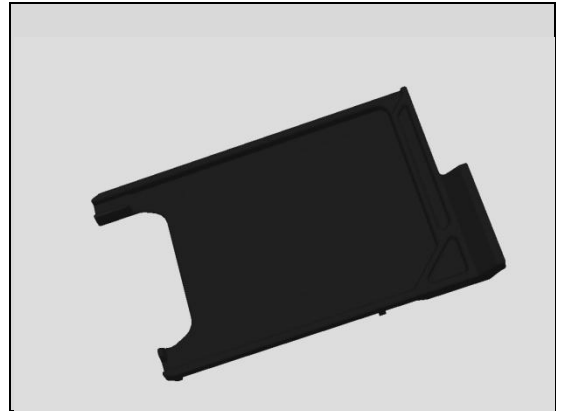
4 Replacement

4.1 Sim Tray

Follow the 3.1 Disassembly instructions!

Prepare the new Sim Tray.

Follow the 5.20 Reassembly instructions!



4.2 Rear Panel

Follow the 3.2 Disassembly instructions!

Prepare the new Rear Panel.

Follow the 4.27 Installation instructions!

Follow the 5.19 Reassembly instructions!



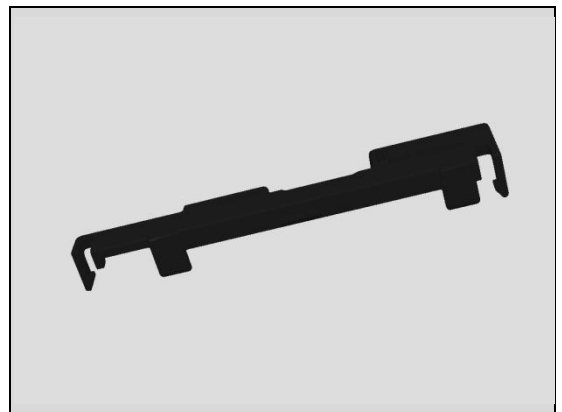
4.3 Sub Antenna

Follow the 3.2 – 3.3 Disassembly instructions!

Prepare the new Sub Antenna.

Follow the 4.63, 4.67 Installation instructions!

Follow the 5.18-5.19 Reassembly instructions!



4.4 Holder Main Camera

Follow the 3.2 and 3.6 Disassembly instructions!

Prepare the new Holder Main Camera.

Follow the 5.17 and 5.19 Reassembly instructions!



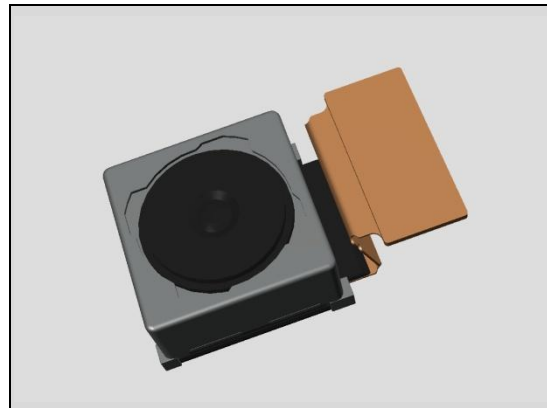
Replacement

4.5 Main Camera

Follow the 3.2 and 3.4-3.5 Disassembly instructions!

Prepare the new Main Camera.

Follow the 5.16-17 and 5.19 Reassembly instructions!



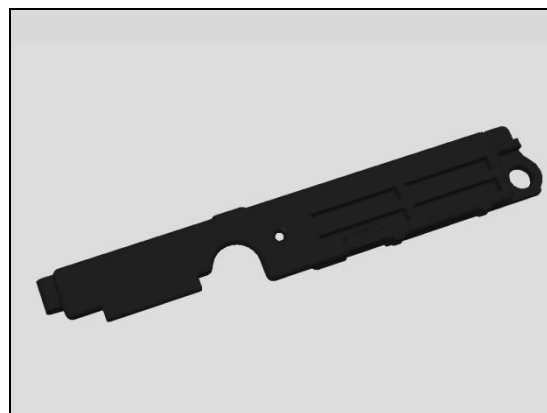
4.6 Antenna BT + WLAN

Follow the 3.2 and 3.6 Disassembly instructions!

Prepare the new Antenna BT + WLAN.

Follow the 4.53 Installation instructions!

Follow the 5.15 and 5.19 Reassembly instructions!



4.7 Main PBA

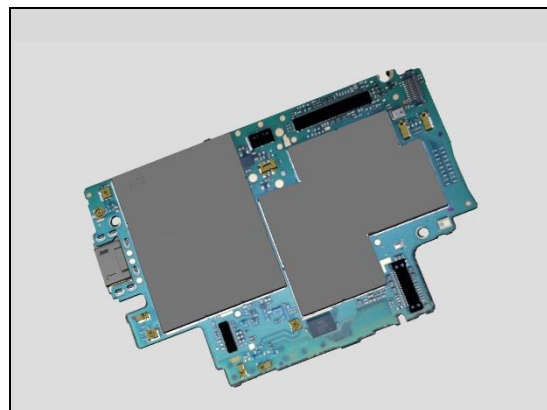
Follow the 3.1 – 3.7 Disassembly instructions!

Follow the 4.68 Removal instructions!

Prepare the new Main PBA.

Follow the 4.68 Installation instructions!

Follow the 5.14 – 5.20 Reassembly instructions!



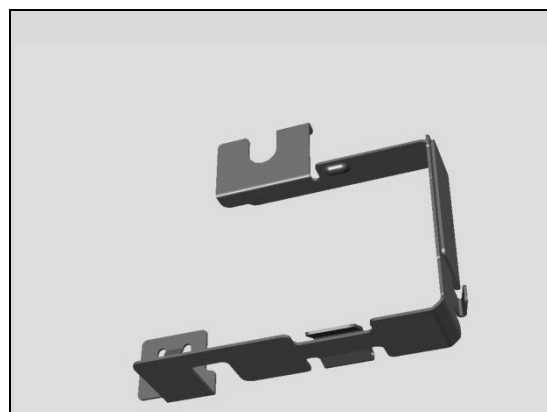
4.8 Shield Main Camera

Follow the 3.1 – 3.8 Disassembly instructions!

Prepare the new Shield Main Camera.

Follow the 4.45 Installation instructions!

Follow the 5.13 – 5.20 Reassembly instructions!



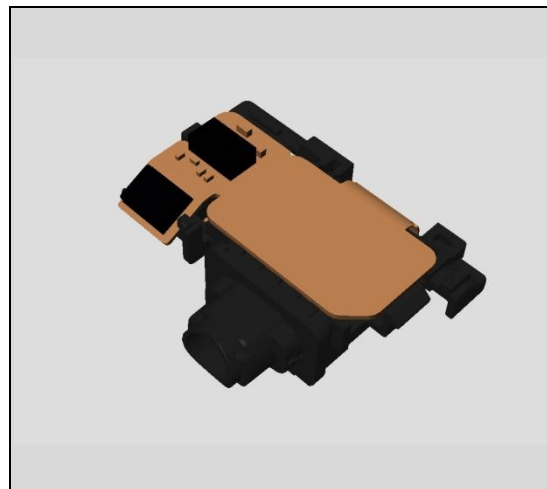
Replacement

4.9 Audio Jack

Follow the 3.1 – 3.7 and 3.9 Disassembly instructions!

Prepare the new Audio Jack.

Follow 5.12 and 5.14 – 5.20 Reassembly instructions!

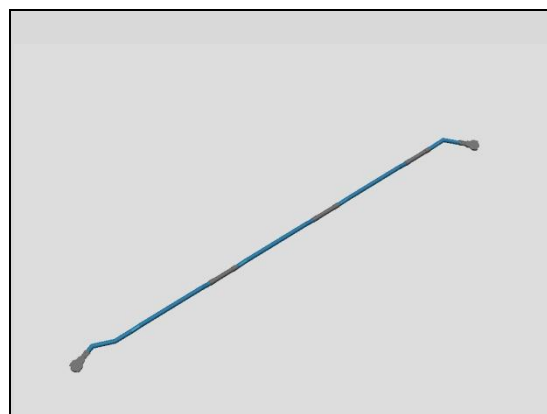


4.10 RF cable

Follow the 3.2 and 3.10 Disassembly instructions!

Prepare the new RF cable.

Follow the 5.11 and 5.19 Reassembly instructions!



4.11 Embedded Battery

Follow the 3.2 and 3.11 Disassembly instructions!

Prepare the new Embedded Battery.

Follow the 4.37 Installation instructions!

Follow the 5.10 and 5.19 Reassembly instructions!

Visual Inspection of the Battery.



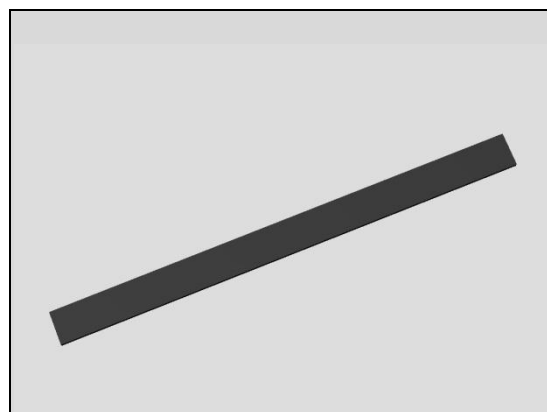
4.12 Cushion Battery

Follow the 3.2 and 3.11-3.12 Disassembly instructions!

Prepare the new Cushion Battery.

Follow the 5.9-5.10 and 5.19 Reassembly instructions!

Scrap! Not to be reused!



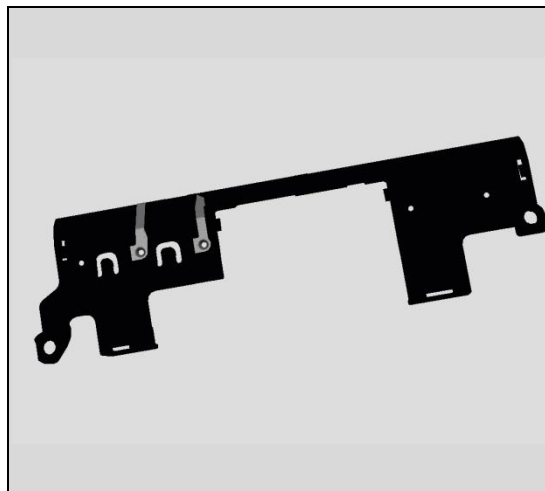
Replacement

4.13 Main Antenna

Follow the 3.2 and 3.11-3.13 Disassembly instructions!

Prepare the new Main Antenna.

Follow the 5.8-5.10 and 5.19 Reassembly instructions!

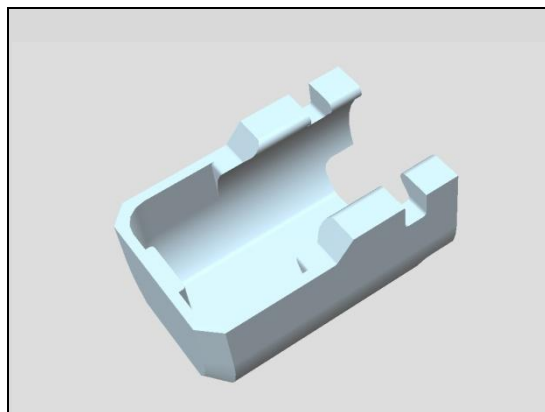


4.14 Holder Vibrator

Follow the 3.2 and 3.11-3.13 Disassembly instructions!

Prepare the new Holder Vibrator.

Follow the 5.7-5.10 and 5.19 Reassembly instructions!

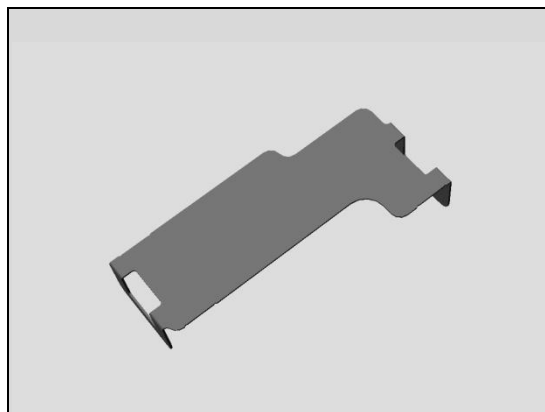


4.15 Plate Speaker

Follow the 3.2 and 3.11-3.14 Disassembly instructions!

Prepare the new Plate Speaker.

Follow the 5.8-5.10 and 5.19 Reassembly instructions!



4.16 Holder Speaker sub assembly

Follow the 3.2 and 3.11-3.14 Disassembly instructions!

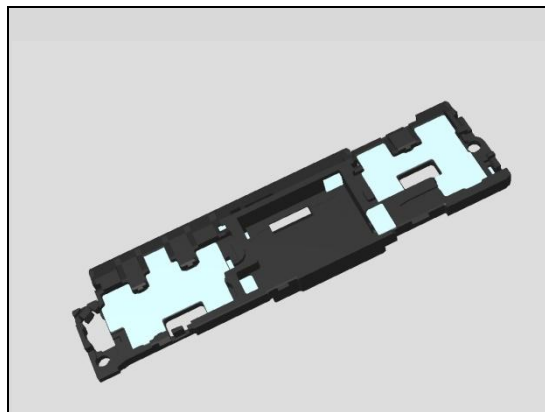
Follow the 4.69, 4.70, 4.55 Removal instructions!

Prepare the new Holder Speaker sub assembly

Follow the 4.30, 4.31, 4.55, 4.26, 4.69, 4.70

Installation instructions!

Follow the 5.8-5.10 and 5.19 Reassembly instructions!



Replacement

4.17 Charge FPC

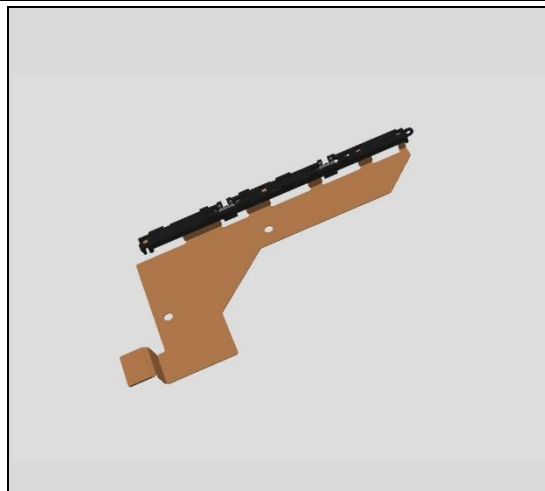
Follow the 3.2, 3.10-3.12 and 3.17 Disassembly instructions!

Prepare the new Charge FPC.

Follow the 4.37 Installation instructions!

Follow the 5.4, 5.9-5.11 and 5.19 Reassembly instructions!

Visual Inspection of the Charge FPC.

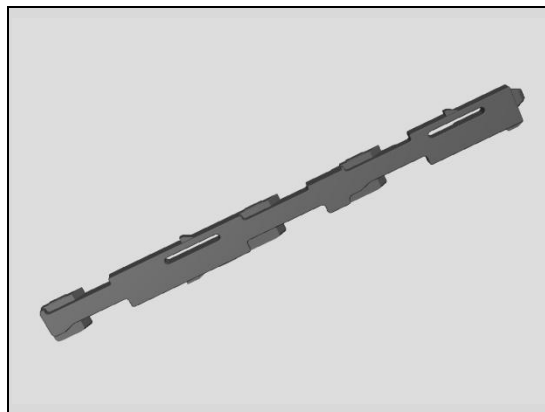


4.18 Holder key volume

Follow the 3.11-3.12 and 3.17 Disassembly instructions!

Prepare the new Holder key volume.

Follow the 4.79, 4.80 and 5.9-5.10 and 5.19 Reassembly instructions!

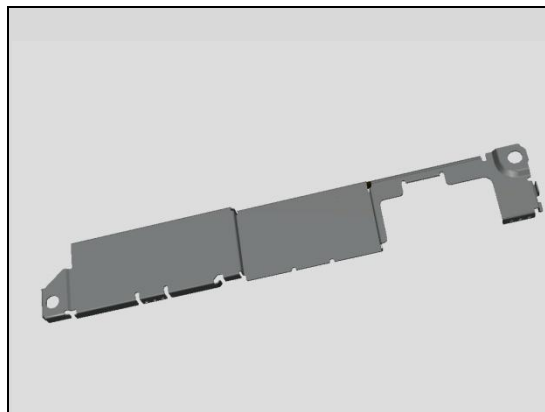


4.19 Plate holder speaker

Follow the 3.2, 3.11-3.16 and 3.19 Disassembly instructions!

Prepare the new Plate holder speaker.

Follow the 5.2, 5.5-5.10 and 5.8 Reassembly instructions!



4.20 Relay FPC

Follow the 3.2, 3.11-3.16 and 3.19 -3.20 Disassembly instructions!

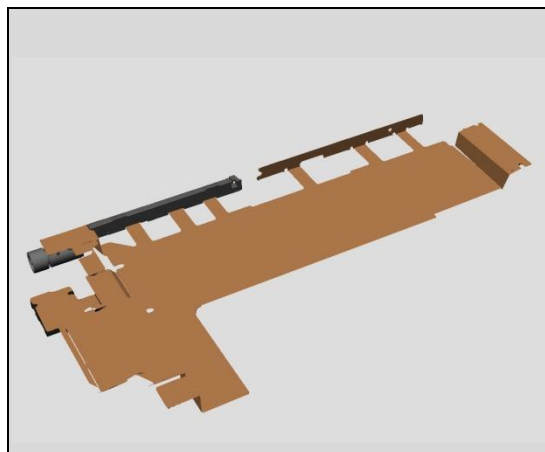
Follow the 4.28, 4.29 Removal instructions!

Prepare the new Relay FPC.

Follow the 4.28, 4.29, 4.37, 4.41, 4.43, 4.44, 4.48 Installation instructions!

Follow the 5.1-5.2, 5.5-5.10 and 5.8 Reassembly instructions!

Visual Inspection of the Relay FPC.



Replacement

4.21 Front Assy

Follow the 3.1 – 3.20 Disassembly instructions!

Follow the 4.49, 4.54 Removal instructions!

Prepare the new Front Assy.

Follow the 4.54, 4.65, 4.66 Installation instructions!

Follow the 5.1 – 5.20 Reassembly instructions!



Replacement

4.22 Adhesive Battery Front

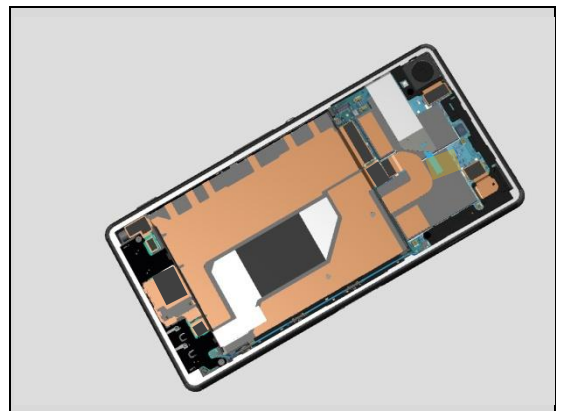
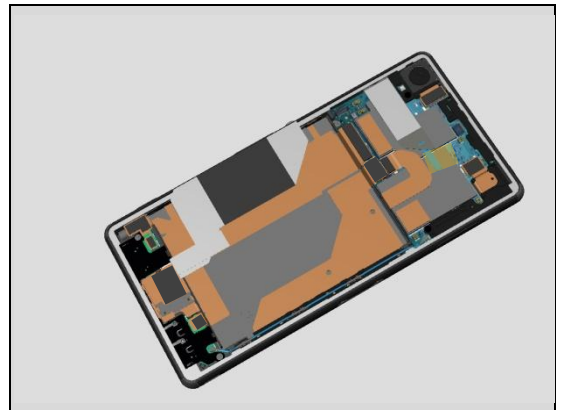
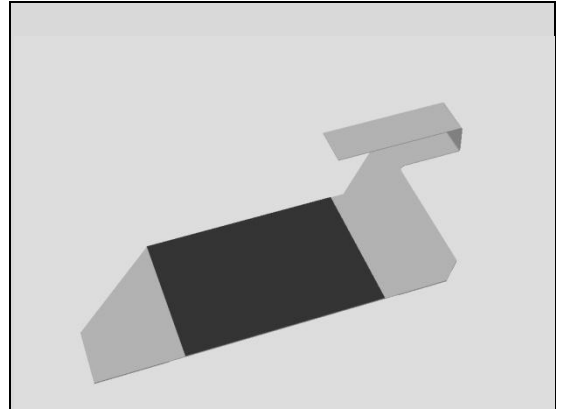
Follow the 3.2 and 3.11 Disassembly instructions!
Carry out the Removal as described below.
Prepare the new Adhesive Battery Front.
Carry out the Installation as described below.
Follow the 5.10 and 5.19 Reassembly instructions!

REMOVAL

Remove the Adhesive Battery Front with fingers.
Scrap! Not to be reused!

INSTALLATION

Attach the Adhesive Battery Front with fingers.



Replacement:

4.23 Adhesive Battery Rear

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive Battery Rear.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

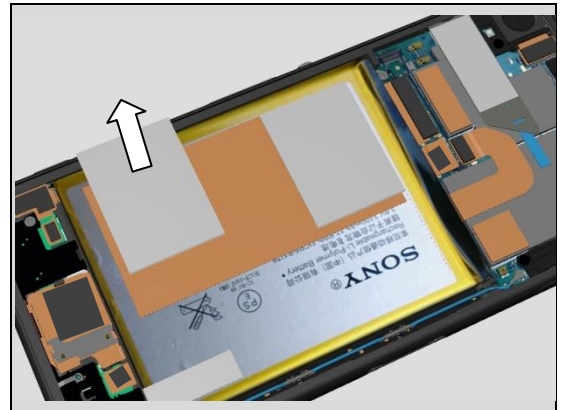
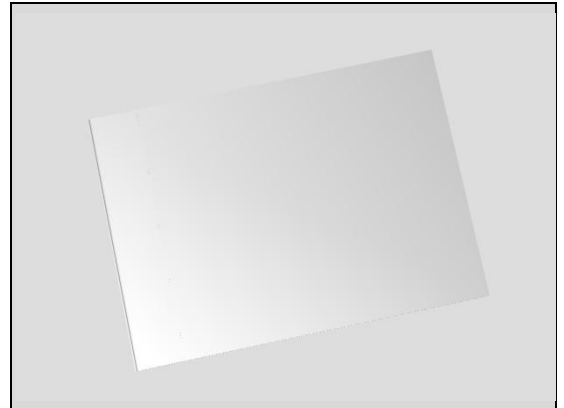
REMOVAL

Detach to remove the Adhesive Battery Rear with the Flex Film Assembly Tool

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive Battery Rear on the Embedded Battery using a Flex Film Assembly Tool.



Replacement

4.24 Adhesive Battery Rear 2

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive Battery Rear 2.

Carry out the Installation as described below.

Follow the 5.2 Reassembly instructions!

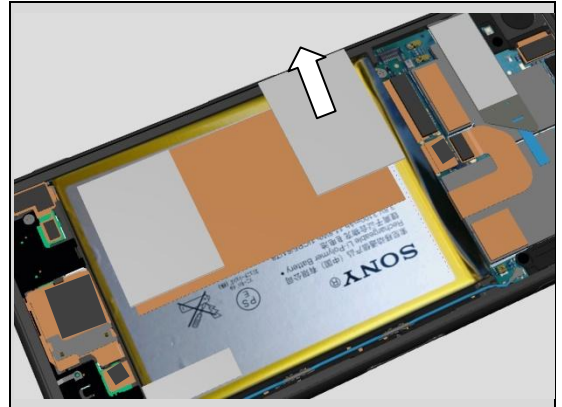
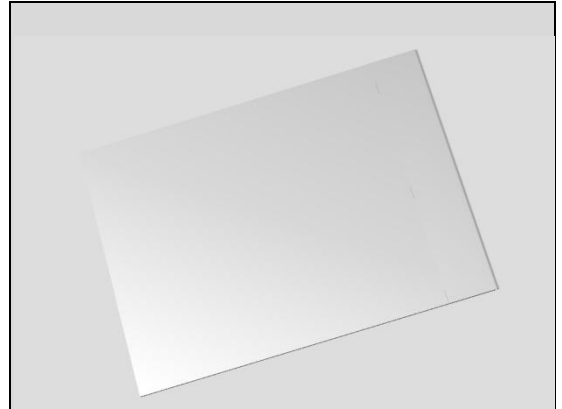
REMOVAL

Detach to remove the Adhesive Battery Rear 2 with the Flex Film Assembly Tool

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive Battery Rear2 on the Embedded Battery using a Flex Film Assembly Tool.



Replacement

4.25 Adhesive Charger FPC

Follow the 3.2, 3.10-3.12 and 3.17 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive Charger FPC.

Carry out the Installation as described below.

Follow the 5.4, 5.9-5.11 and 5.19 Reassembly instructions!

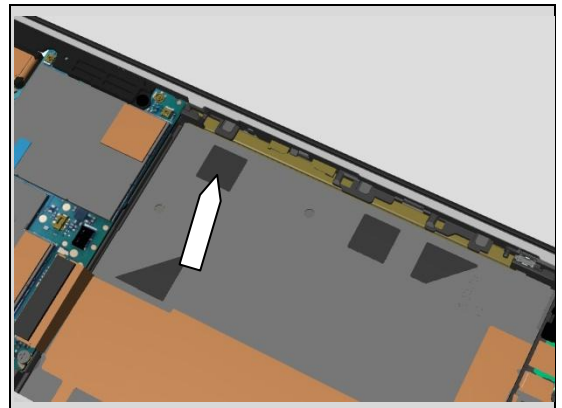
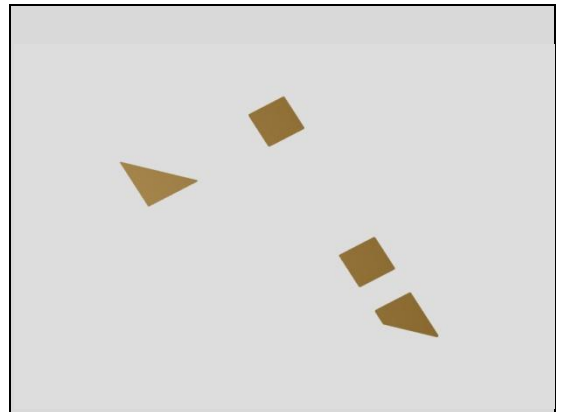
REMOVAL

Detach to remove the Adhesive Charger FPC with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive Charger FPC on the Front Assy using fingers



Replacement

4.26 Adhesive FPC Speaker

Follow the 3.2, 3.11 and 3.15 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive FPC Speaker.

Carry out the Installation as described below.

Follow the 5.6, 5.10 and 5.19 Reassembly instructions!

REMOVAL

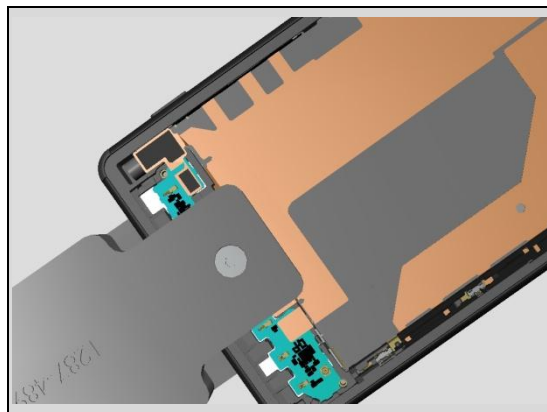
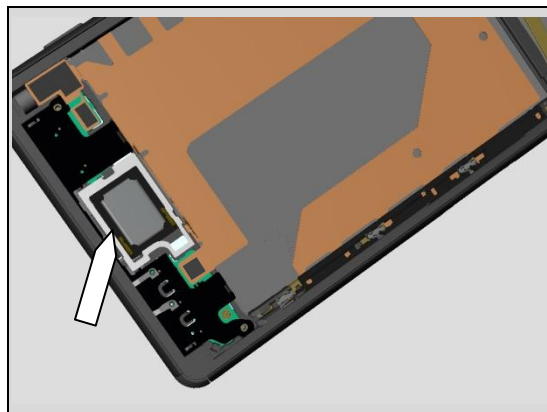
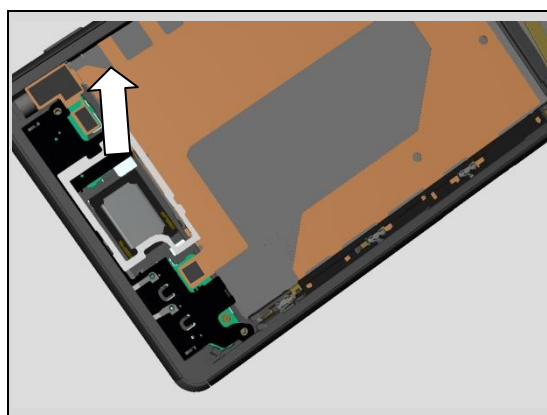
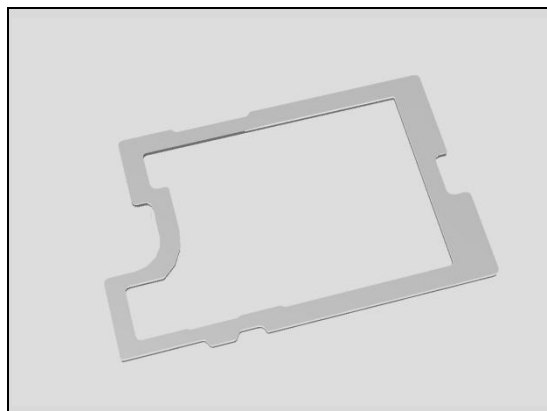
Detach to remove the Adhesive FPC Speaker with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive FPC Speaker on the Holder Speaker sub assembly using a pair of tweezers.

Fold down the Relay FPC on the Holder Speaker sub assembly and press with Speaker FPC Press under five seconds



Replacement

4.27 Adhesive Rear Panel

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive Rear Panel.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

REMOVAL

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

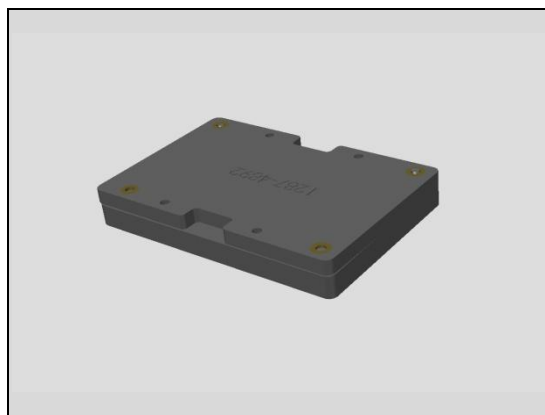
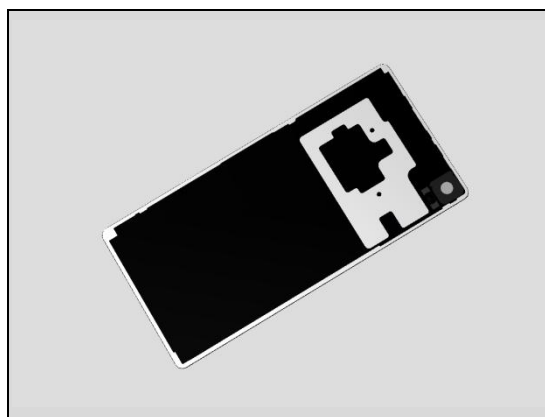
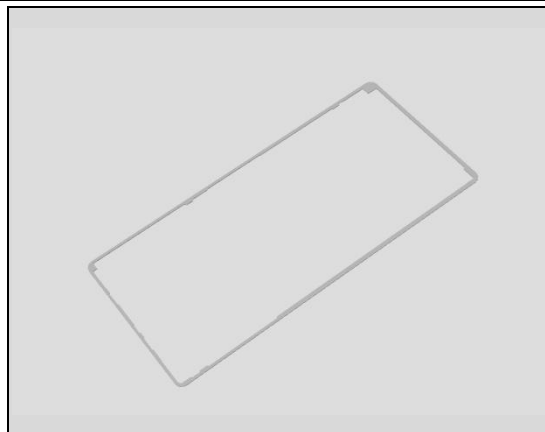
Clean the edges of the Rear Panel carefully with alcohol before the new Adhesive Rear Panel is mounted. This action is done to secure the water resistant of the unit.

Scrap! Not to be reused!

INSTALLATION

Place the new Adhesive Rear Panel in the Rear Panel adhesive alignment fixture and the Rear Panel in a correct position.

Press to secure the attachment.



Replacement

4.28 Adhesive Relay FPC A

Follow the 3.2, 3.11-3.16 and 3.18-3.20 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive Relay FPC A.

Carry out the Installation as described below.

Follow the 5.1-5.3, 5.5-5.10 and 5.19 Reassembly instructions!

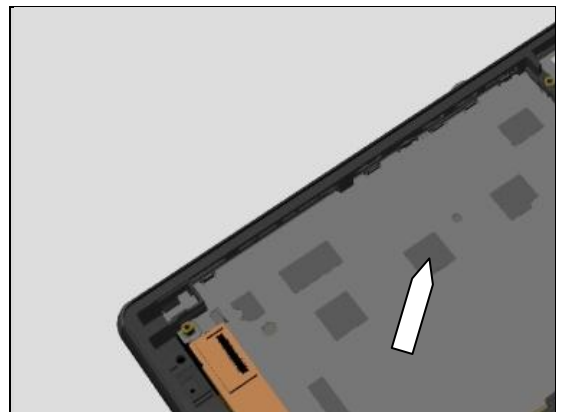
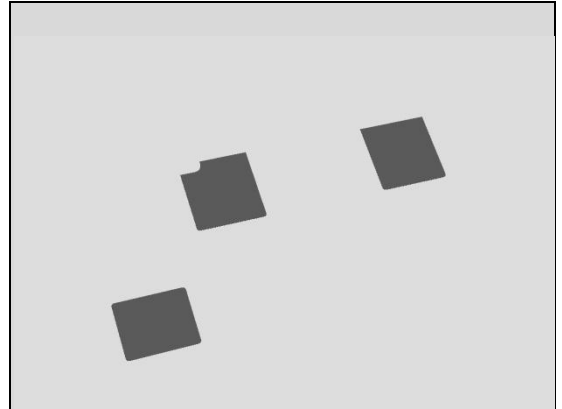
REMOVAL

Detach to remove the Adhesive Relay FPC A with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive Relay FPC A on the Front Assy using fingers



Replacement

4.29 Adhesive Relay FPC B

Follow the 3.2, 3.11-3.16 and 3.18-3.20 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive Relay FPC B.

Carry out the Installation as described below.

Follow the 5.1-5.3, 5.5-5.10 and 5.19 Reassembly instructions!

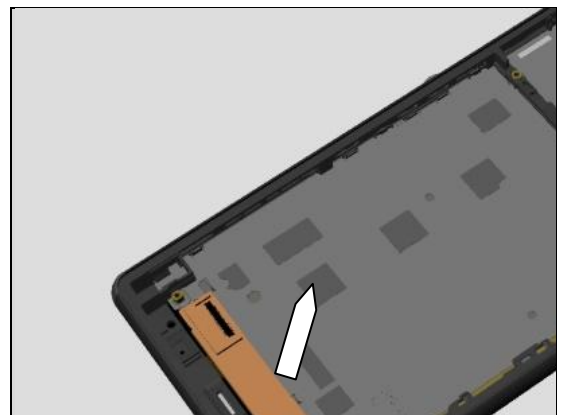
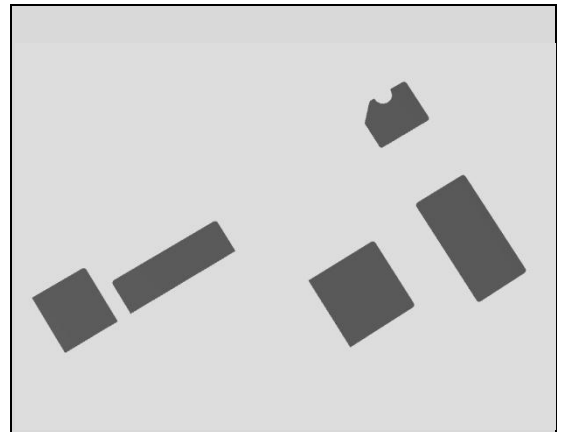
REMOVAL

Detach to remove the Adhesive Relay FPC B with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive Relay FPC B on the Front Assy using fingers



Replacement

4.30 Adhesive WP Audio Jack

Follow the 3.1 – 3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive WP Audio Jack.

Carry out the Installation as described below.

Follow the 5.14 – 5.20 Reassembly instructions!

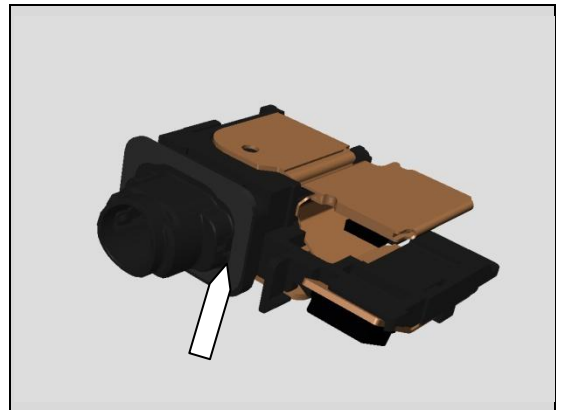
REMOVAL

Detach to remove the Adhesive WP Audio Jack with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive WP Audio Jack the Audio Jack using a Flex Film Assembly Tool.



Replacement

4.31 Adhesive WP holder speaker

Follow the 3.2 and 3.11-3.16 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive WP holder speaker.

Carry out the Installation as described below.

Follow the 5.5-5.10 and 5.19 Reassembly instructions!

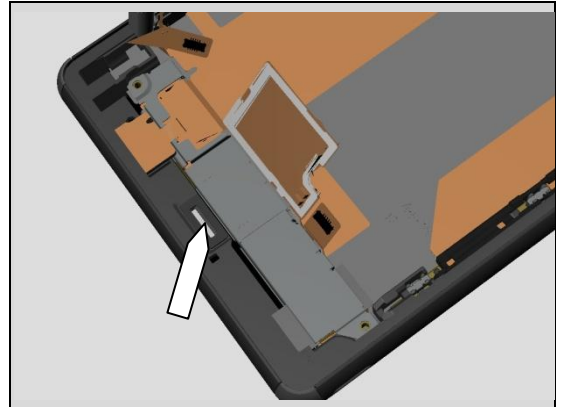
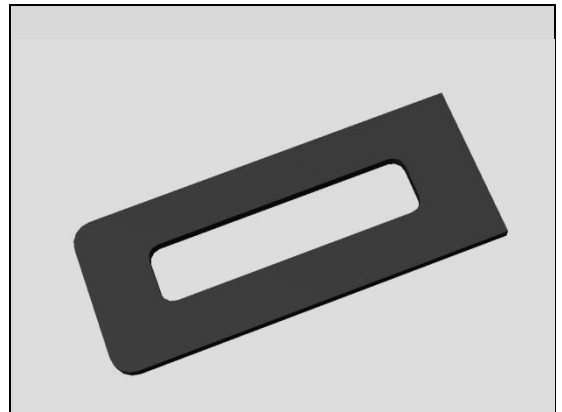
REMOVAL

Detach to remove the Adhesive WP holder speaker with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive WP holder speaker on the Front Assy using a Flex Film Assembly Tool.



Replacement

4.32 Adhesive WP Speaker

Follow the 3.2, 3.11 and 3.15 Disassembly instructions!

Follow the 4.26, 4.55 Removal instructions!

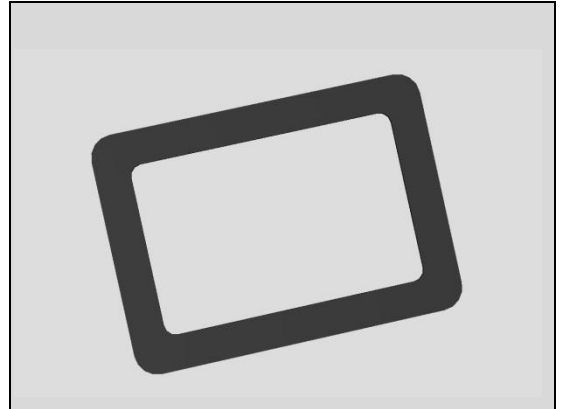
Carry out the Removal as described below.

Prepare the new Adhesive WP Speaker.

Carry out the Installation as described below.

Follow the 4.55, 4.26 Installation instructions!

Follow the 5.6, 5.10 and 5.19 Reassembly instructions!



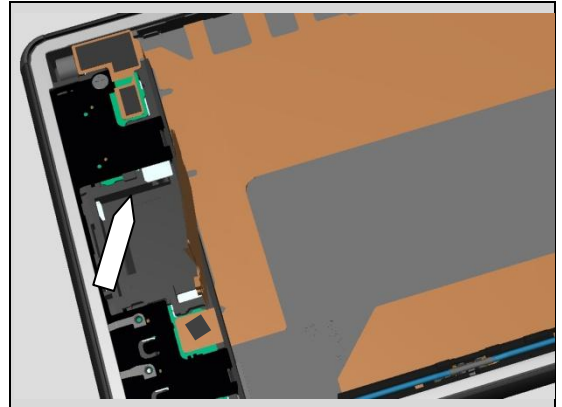
REMOVAL

Detach to remove the Adhesive WP Speaker with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive WP Speaker on the Holder Speaker sub assembly using a Flex Film Assembly Tool.



Replacement:

4.33 Cap SD

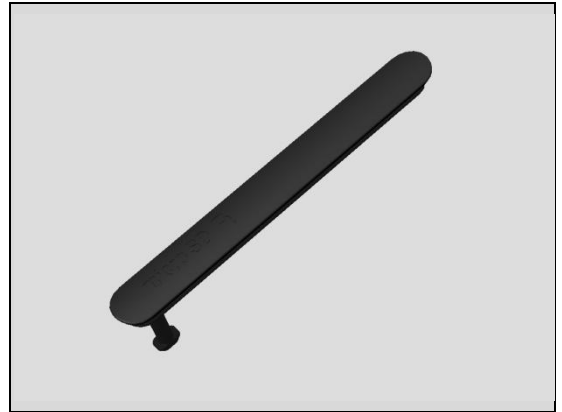
Carry out the Removal as described below.
Prepare the new Cap SD.
Carry out the Installation as described below.

REMOVAL

Detach to remove the Cap SD with fingers

INSTALLATION

Place a new Cap SD with fingers and a pair of tweezers



Replacement

4.34 Cap USB

Carry out the Removal as described below.

Prepare the new Cap USB.

Carry out the Installation as described below.

REMOVAL

Detach to remove the Cap USB with fingers

INSTALLATION

Place a new Cap USB with fingers and a pair of tweezers



Replacement:

4.35 Core Unit Label

Carry out the Removal as described below.

Prepare the new Core Unit Label.

Carry out the Installation as described below.

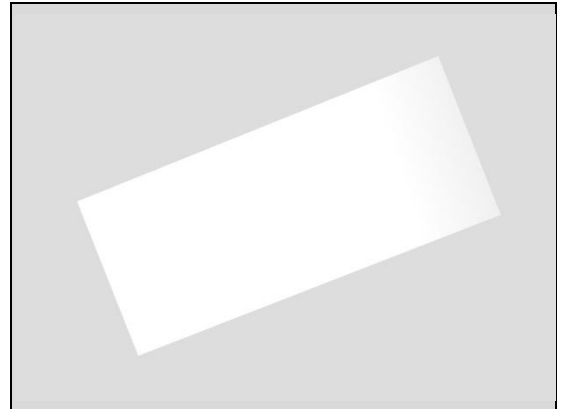
REMOVAL

Open Cap SD and pull out the Label Plate. Then remove the Core Unit Label with a Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Attach new Core Unit Label with fingers and close Cap SD.



Replacement:

4.36 Cushion Audio Jack FPC BtB

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Audio Jack FPC BtB.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

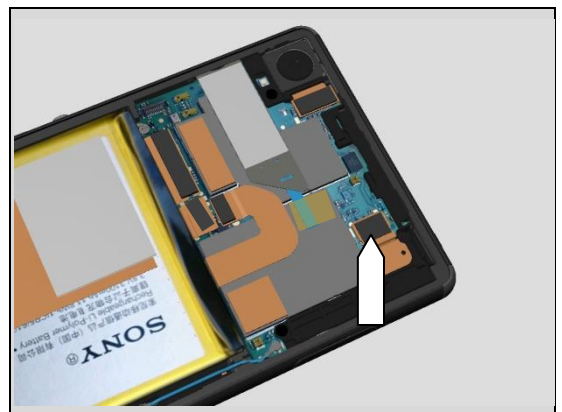
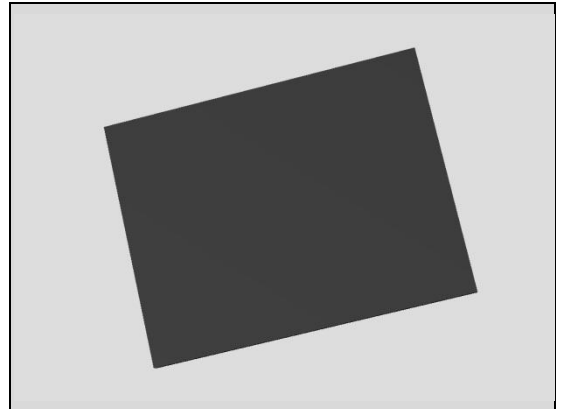
REMOVAL

Detach to remove the Cushion Audio Jack FPC BtB with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Audio Jack FPC BtB on the Audio Jack FPC using a Flex Film Assembly Tool.



Replacement:

4.37 Cushion Battery FPC BtB

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Battery FPC BtB.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

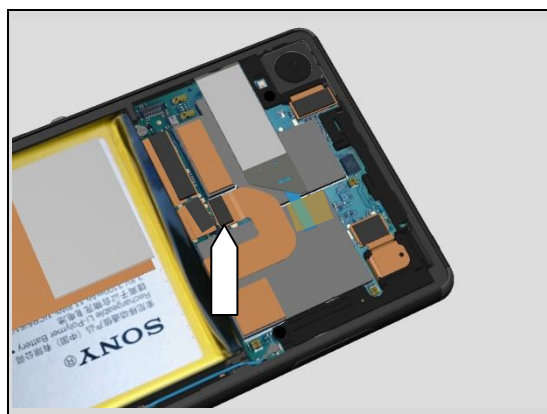
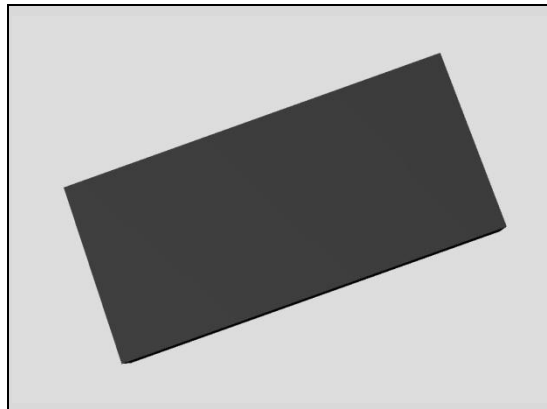
REMOVAL

Detach to remove the Cushion Battery FPC BtB with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Battery FPC BtB on the Embedded Battery FPC using a Flex Film Assembly Tool.



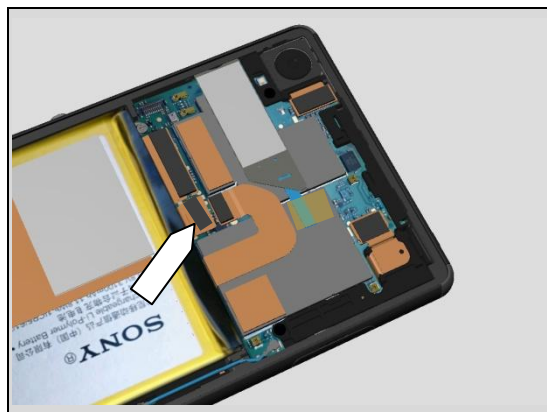
REMOVAL

Detach to remove the Cushion Battery FPC BtB with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Battery FPC BtB on the Charge FPC BtB using a Flex Film Assembly Tool.



Replacement

4.38 Cushion Camera BtB

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Camera BtB.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

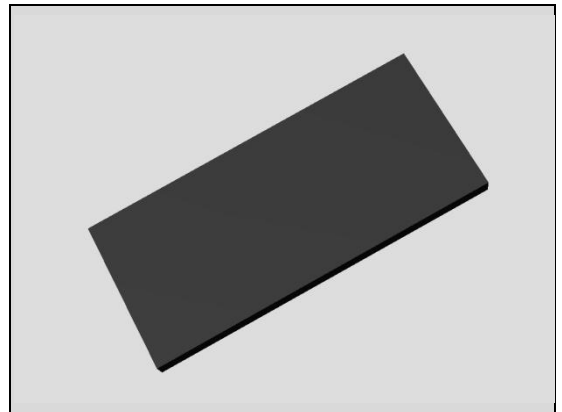
REMOVAL

Detach to remove the Cushion Camera BtB with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Camera BtB on the Main Camera FPC using a Flex Film Assembly Tool.



Replacement:

4.39 Cushion Chat Camera

Follow the 3.1-3.8 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Chat Camera.

Carry out the Installation as described below.

Follow the 5.13-5.20 Reassembly instructions!

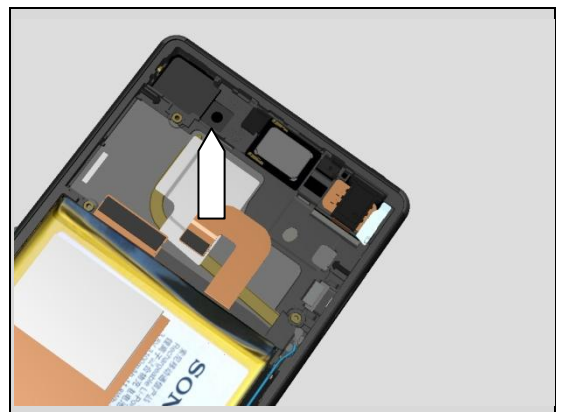
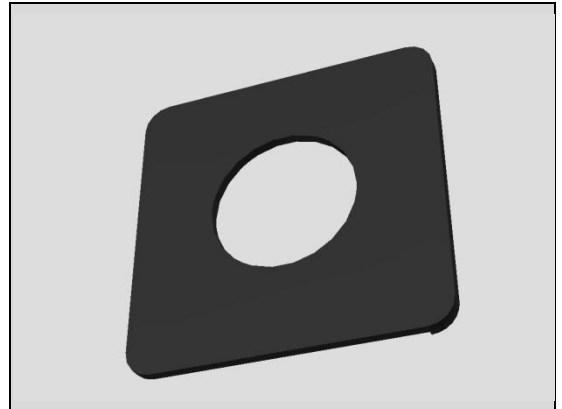
REMOVAL

Detach to remove the Cushion Chat Camera with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Chat Camera on the Front Assy using a Flex Film Assembly Tool.



Replacement

4.40 Cushion Rear Panel

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Rear Panel.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

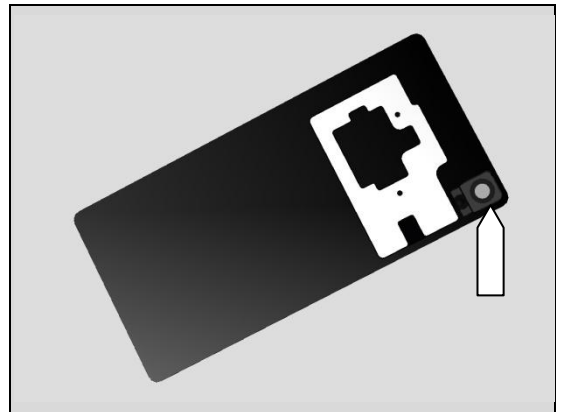
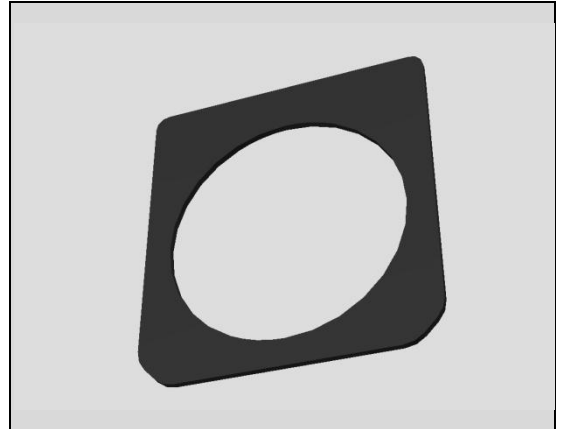
REMOVAL

Detach to remove the Cushion Rear Panel with a dentist hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Rear Panel on the Rear Panel using a Flex Film Assembly Tool.



Replacement:

4.41 Cushion Relay FPC bottom BtB

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Relay FPC bottom BtB.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

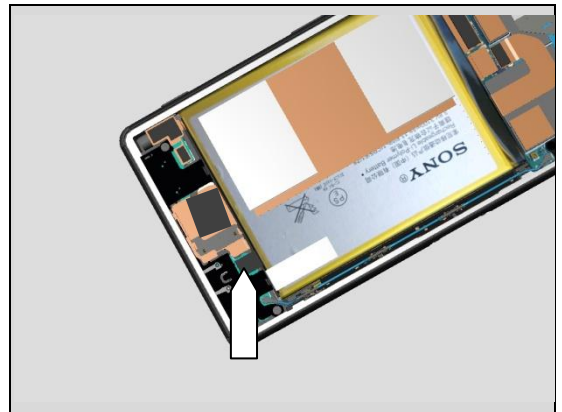
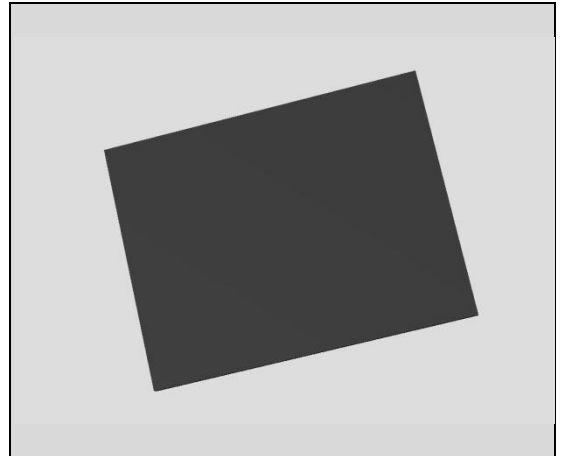
REMOVAL

Detach to remove the Cushion Relay FPC bottom BtB with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Relay FPC bottom BtB on the Relay FPC using a Flex Film Assembly Tool.



Replacement:

4.42 Cushion Relay FPC BtB

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Relay FPC BtB.

Carry out the Installation as described below.

Follow the 4.19 Reassembly instructions!

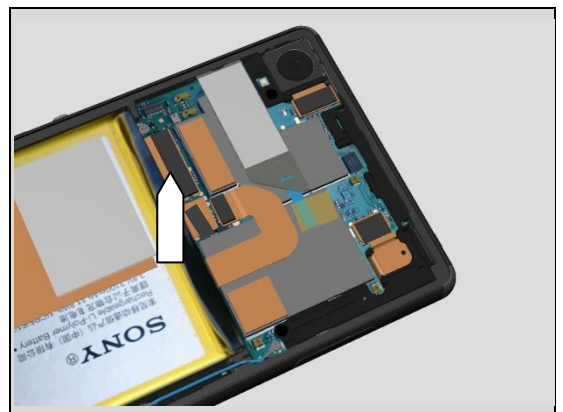
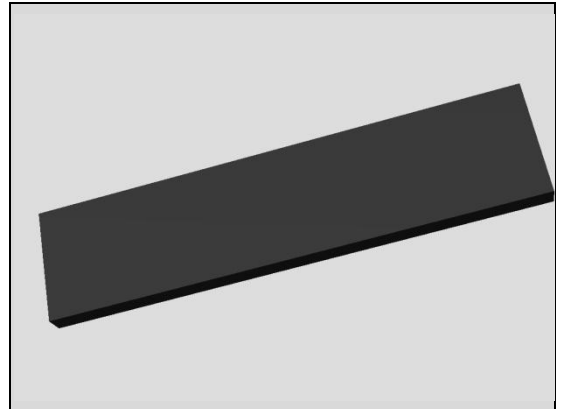
REMOVAL

Detach to remove the Cushion Relay FPC BtB with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Relay FPC BtB on the Relay FPC using a Flex Film Assembly Tool.



Replacement:

4.43 Cushion Speaker

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Speaker.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

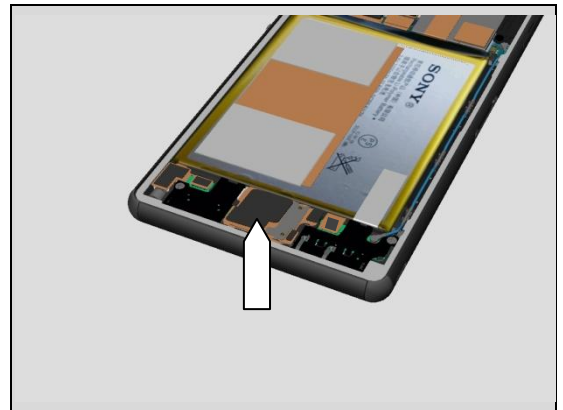
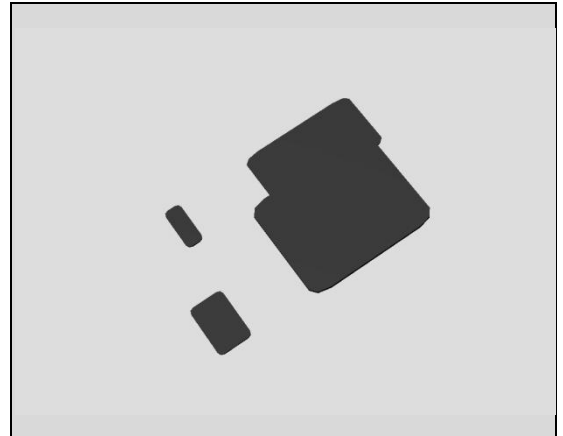
REMOVAL

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

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Speaker on the Relay FPC using a Flex Film Assembly Tool.



Replacement:

4.44 Cushion Vibrator

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cushion Vibrator.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

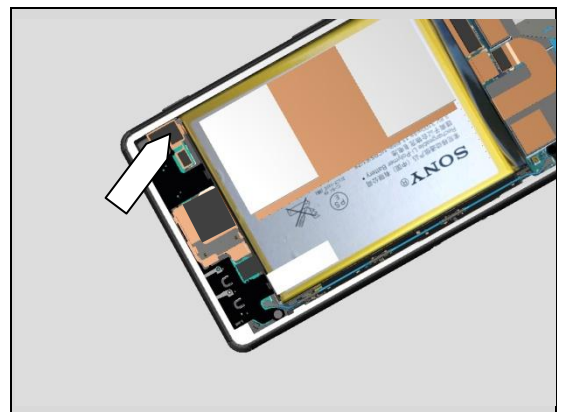
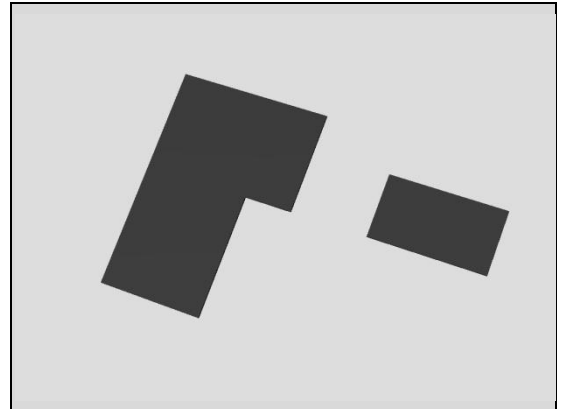
REMOVAL

Detach to remove the Cushion Vibrator with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Cushion Vibrator on the Relay FPC using a Flex Film Assembly Tool.



Replacement:

4.45 Gasket conductive USB

Follow the 3.1 – 3.8 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Gasket conductive USB.

Carry out the Installation as described below.

Follow the 5.13 – 5.20 Reassembly instructions!

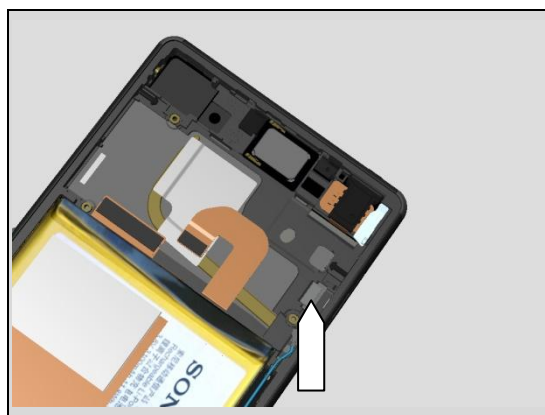
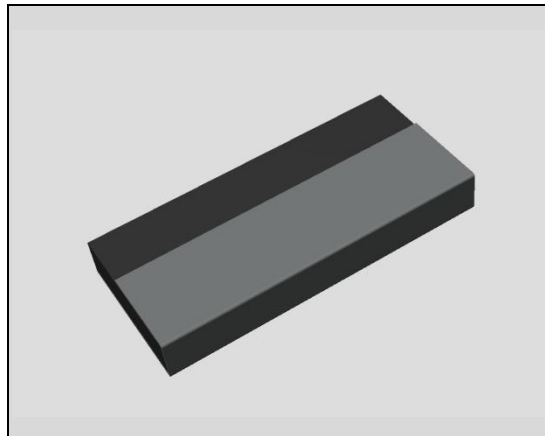
REMOVAL

Detach to remove the Gasket conductive USB with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Gasket conductive USB on the Front Assy using a pair of tweezers.



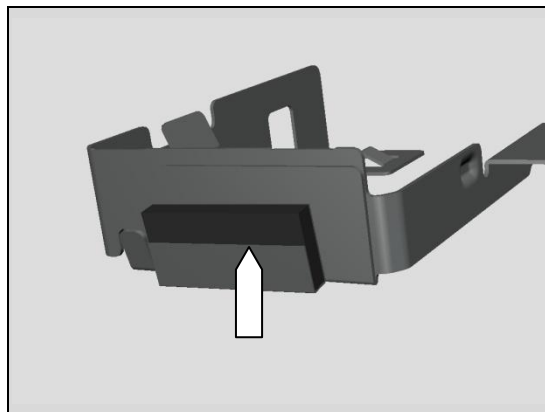
REMOVAL

Detach to remove the Gasket conductive USB with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Gasket conductive USB on the Shield Main Camera using a pair of tweezers.



Replacement

4.46 Gore Sheet(1st mic)

Follow the 3.2 and 3.11-3.16 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Gore Sheet(1st mic).

Carry out the Installation as described below.

Follow the 5.5-5.10 and 5.19 Reassembly instructions!

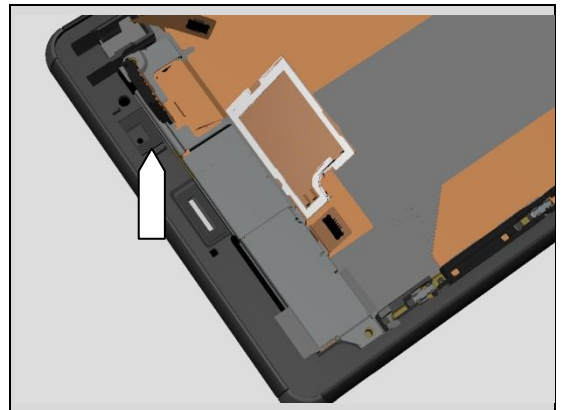
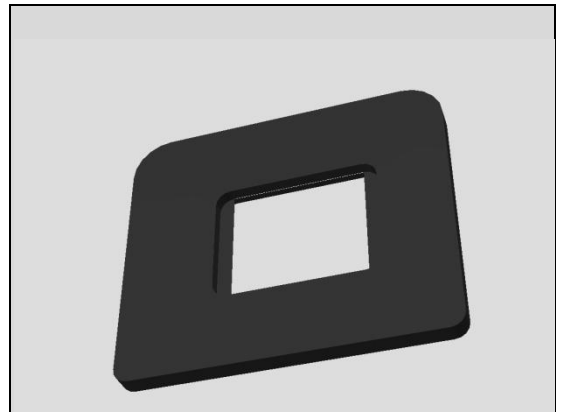
REMOVAL

Detach to remove the Gore Sheet(1st mic) with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Gore Sheet(1st mic) on the Front Assy using a pair of tweezers.



Replacement

4.47 Grill Receiver

Follow the 3.1 – 3.7 Disassembly instructions!

Follow the 4.54 Removal instructions!

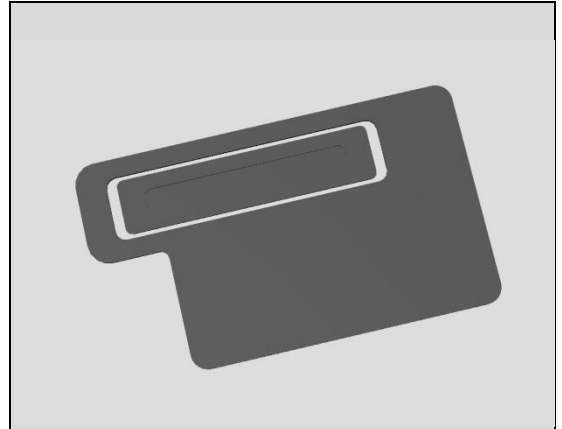
Carry out the Removal as described below.

Prepare the new Grill Receiver.

Carry out the Installation as described below.

Follow the 4.54 Installation instructions!

Follow the 5.14 – 5.20 Reassembly instructions!



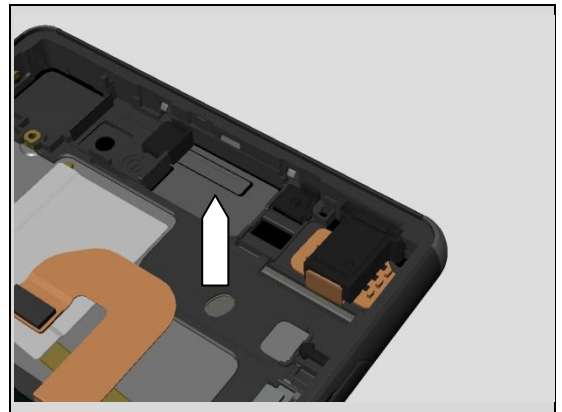
REMOVAL

Detach to remove the Grill Receiver with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Grill Receiver on the Front Assy using a Flex Film Assembly Tool.



Replacement

4.48 Holder Mic sub assembly

Follow the 3.2 and 3.11-3.16 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Holder Mic sub assembly.

Carry out the Installation as described below.

Follow the 5.5-5.10 and 3.2 Reassembly instructions!

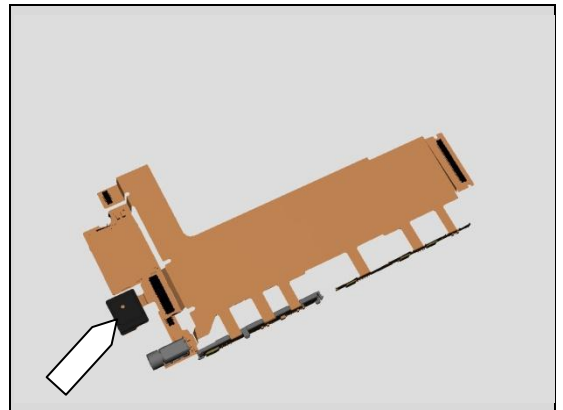


REMOVAL

Remove Holder Mic sub assembly with a Flex Film Assembly Tool.

INSTALLATION

Place a new Holder Mic sub assembly on the Relay FPC using a Flex Film Assembly Tool.



Replacement:

4.49 Holder Receiver sub assembly

Follow the 3.1 – 3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Holder Receiver sub assembly.

Carry out the Installation as described below.

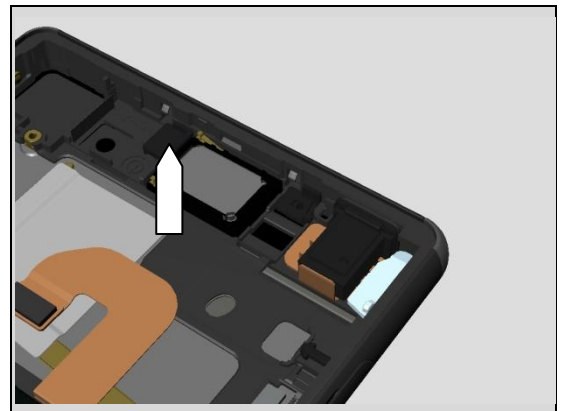
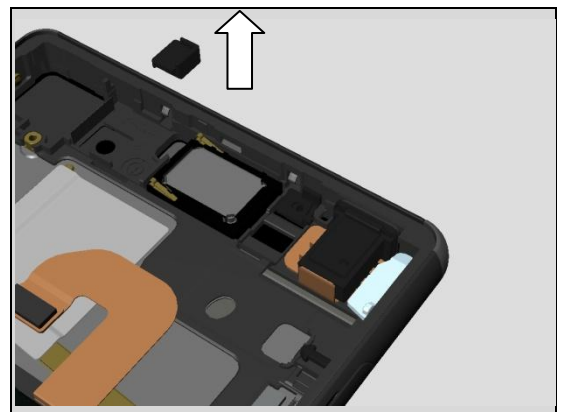
Follow the 5.14 – 5.20 Reassembly instructions!

REMOVAL

Remove Holder Receiver sub assembly with a pair of tweezers.

INSTALLATION

Place a new Holder Receiver sub assembly on the Front Assy using a pair of tweezers.



Replacement:

4.50 Label Plate

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Label Plate.

Carry out the Installation as described below.

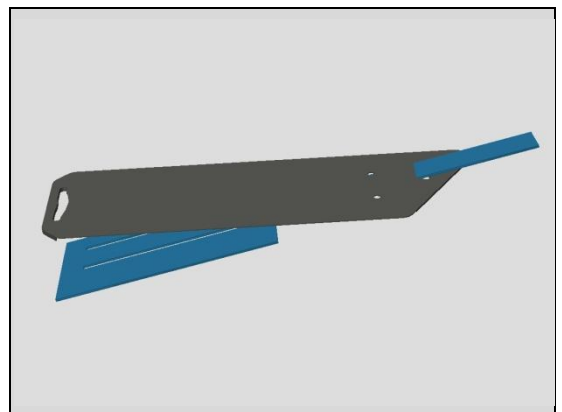
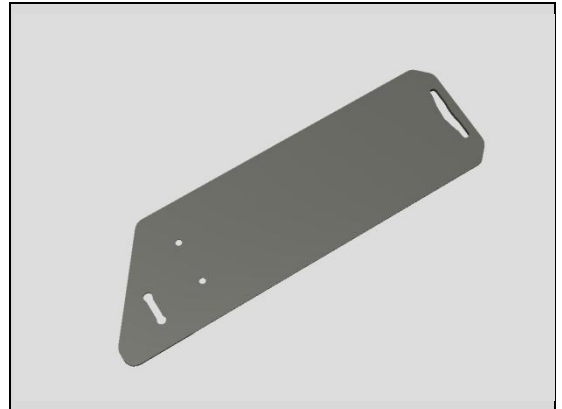
Follow the 5.19 Reassembly instructions!

REMOVAL

Remove Label Plate with a Flex Film AssemblyTool.

INSTALLATION

Place a new Label Plate on the Label Plate Guide using fingers.



Replacement:

4.51 Label Plate Guide

Follow the 3.2 Disassembly instructions!

Follow the 4.50 and 4.51 Removal instructions!

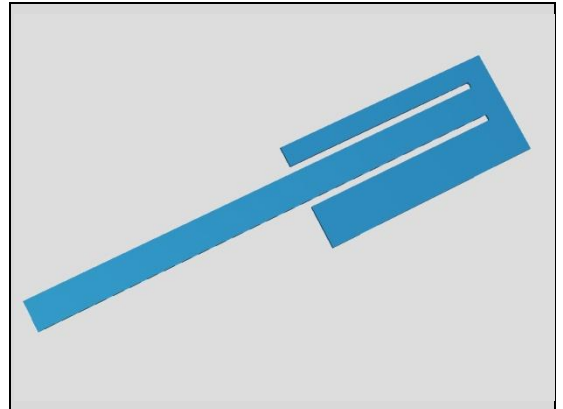
Carry out the Removal as described below.

Prepare the new Label Plate Guide.

Carry out the Installation as described below.

Follow the 4.50 and 4.51 Installation instructions!

Follow the 5.19 Reassembly instructions!

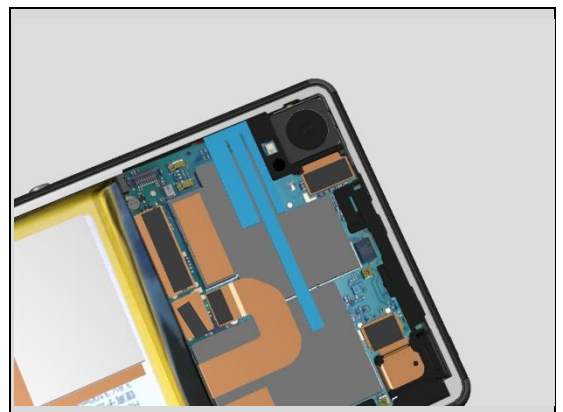


REMOVAL

Remove Label Plate Guide with a Flex Film AssemblyTool.

INSTALLATION

Place a new Label Plate Guide on the Main PBA using fingers.



Replacement:

4.52 Lightguide 3 LED

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

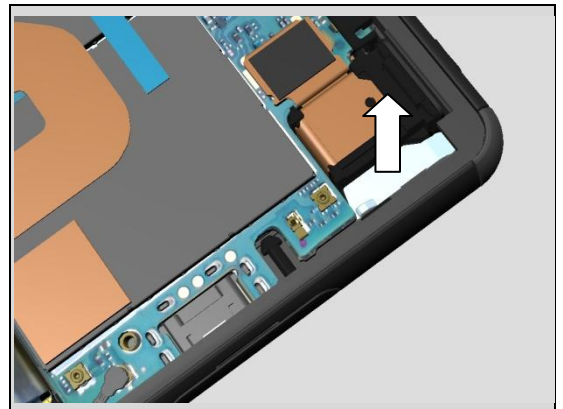
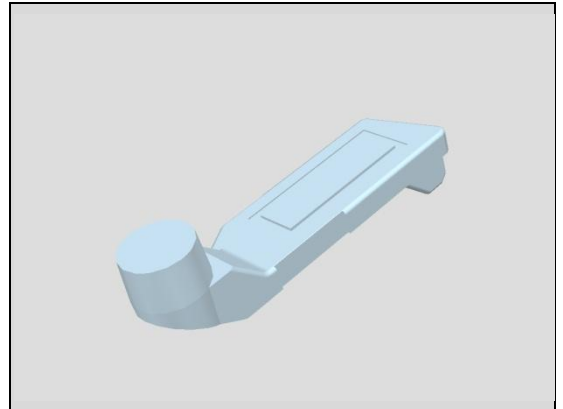
Prepare the new Lightguide 3 LED.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

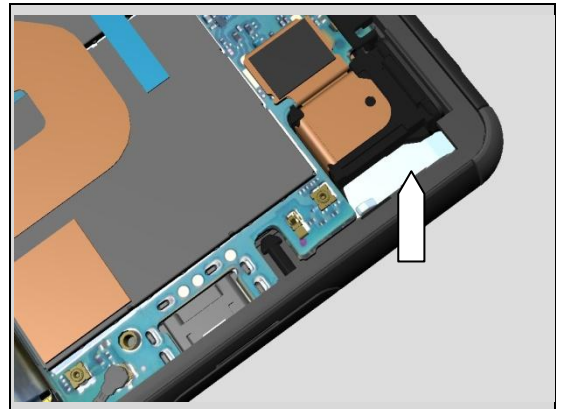
REMOVAL

Remove the Lightguide 3 LED with a pair of tweezers.



INSTALLATION

Place a new Lightguide 3 LED on the Audio Jack with a pair of tweezers.



Replacement:

4.53 Liquid Indicator

Follow the 3.2 and 3.6 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Liquid Indicator.

Carry out the Installation as described below.

Follow the 5.15 and 5.19 Reassembly instructions!

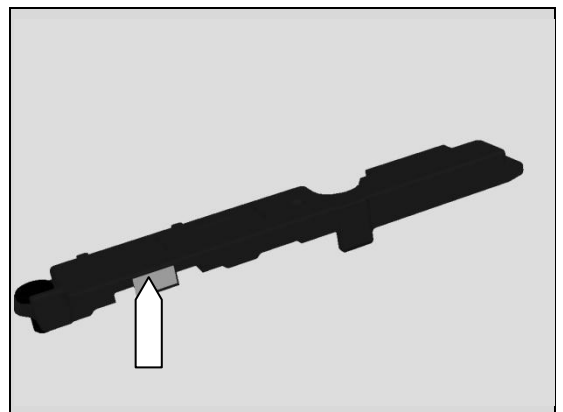
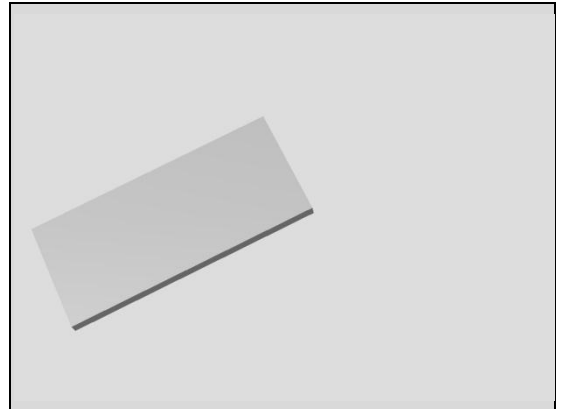
REMOVAL

Detach to remove the Liquid Indicator with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Liquid Indicator on the Antenna BT + WLAN using a pair of tweezers.



Replacement:

4.54 Loudspeaker

Follow the 3.2, 3.11 and 3.15 Disassembly instructions!

Follow the 4.26, 4.32 Removal instructions!

Carry out the Removal as described below.

Prepare the new Loudspeaker.

Carry out the Installation as described below.

Follow the 4.32, 4.26 Installation instructions!

Follow the 5.6, 5.10 and 5.19 Reassembly instructions!

REMOVAL

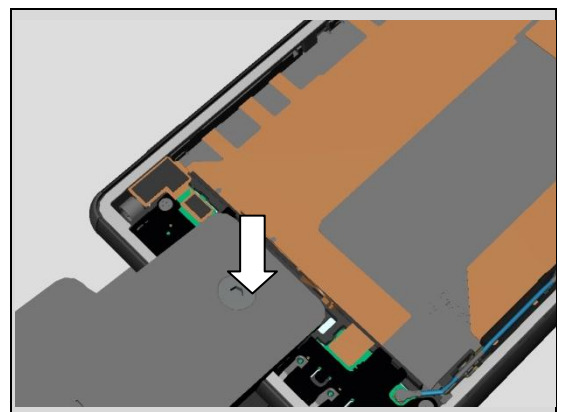
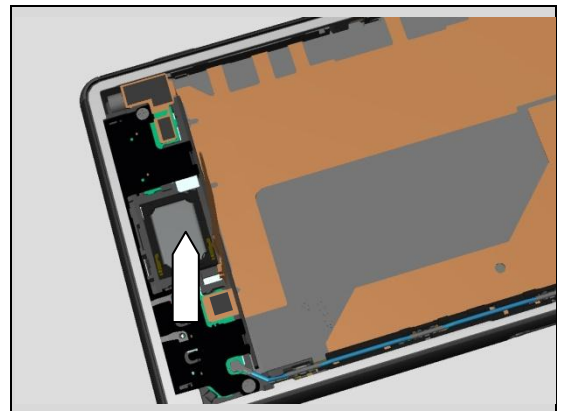
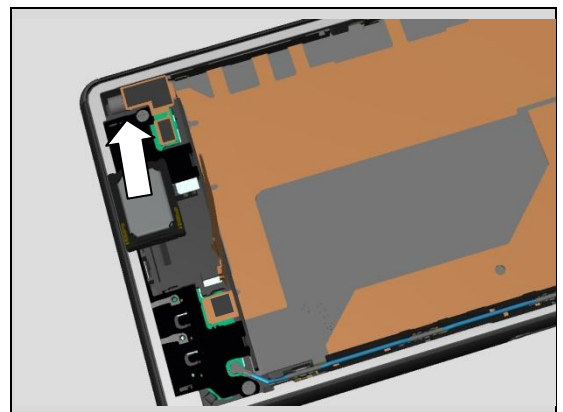
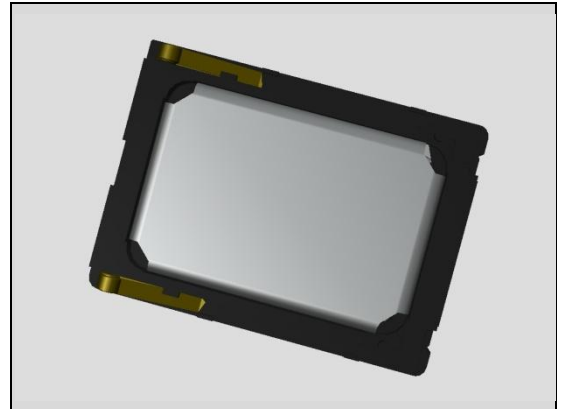
Detach to remove the Loudspeaker B with the Front Opening Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Loudspeaker B on the Front Assy using fingers.

Use Press Tool Loudspeaker and press for 10s.



Replacement:

4.55 Loudspeaker B

Follow the 3.1 – 3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Loudspeaker B.

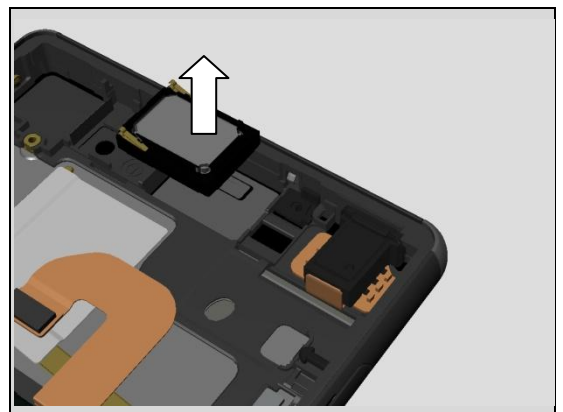
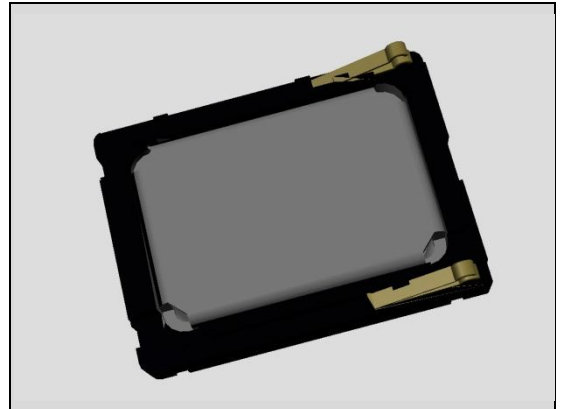
Carry out the Installation as described below.

Follow the 5.14 – 5.20 Reassembly instructions!

REMOVAL

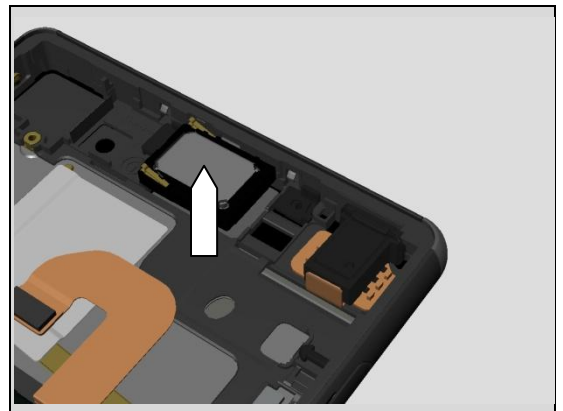
Detach to remove the Loudspeaker with the Front Opening Tool.

Scrap! Not to be reused!

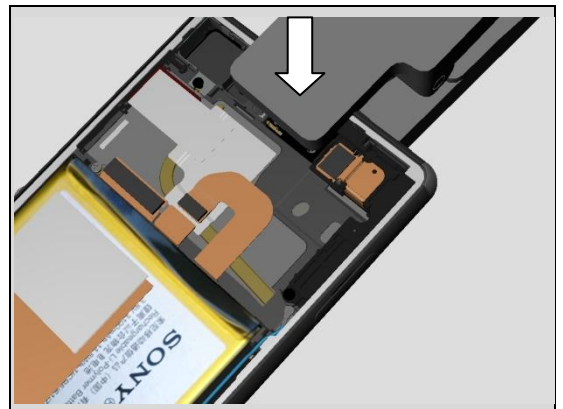


INSTALLATION

Place a new Loudspeaker on the Front Assy using Flex Film Assembly Tool.



Use Press Tool Loudspeaker and press for 10s.



Replacement:

4.56 Magnetic connector

Follow the 3.2, 3.10-3.12 and 3.17 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Magnetic connector.

Carry out the Installation as described below.

Follow the 5.4, 5.9-5.11 – 5.19 Reassembly instructions!

REMOVAL

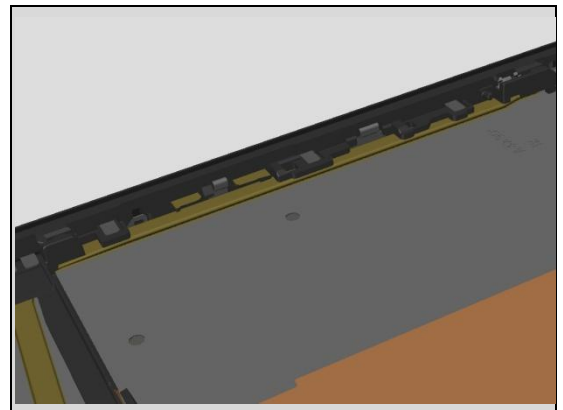
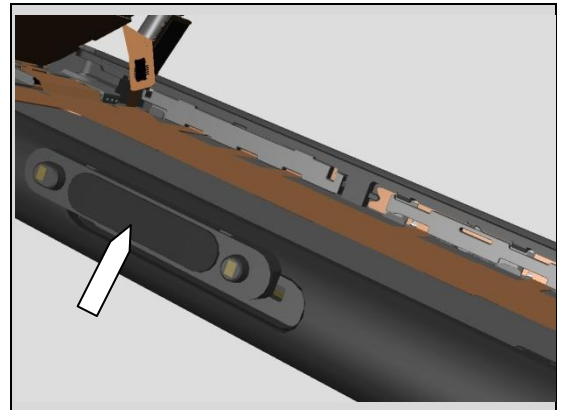
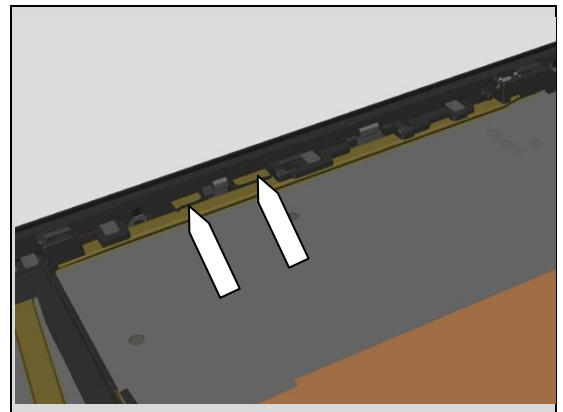
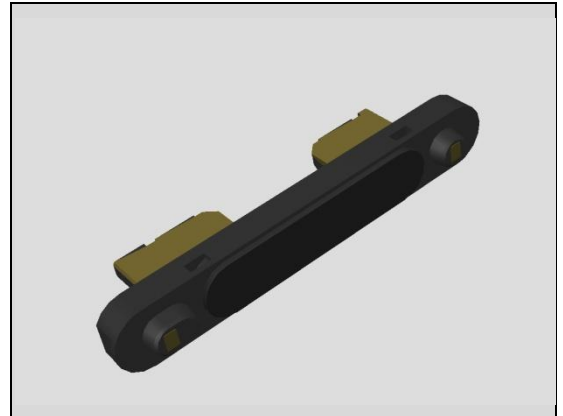
Push the two pads of *Magnetic charger connector* by using Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Mount a new Magnetic charger connector by fingers.

Then use Side Panel press, Side Panel Press Head and Charge connector press pad with the force of 60N for five seconds. According to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.57 Sheet ACO L

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet ACO L.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

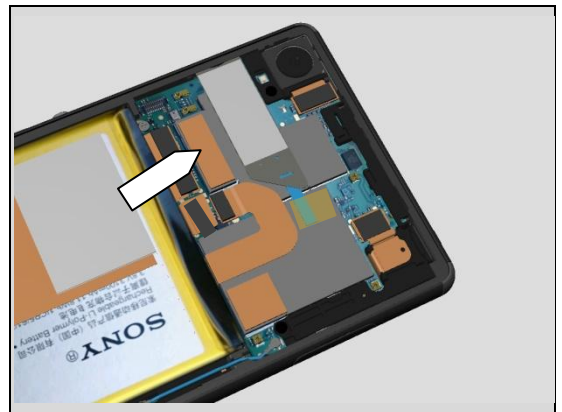
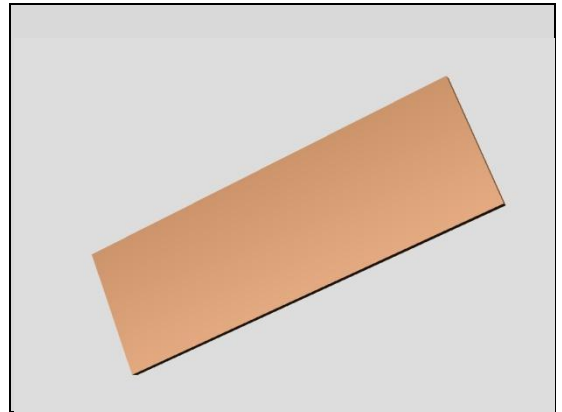
REMOVAL

Detach to remove the Sheet ACO L with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet ACO L on the Main PBA using a Flex Film Assembly Tool.



Replacement

4.58 Sheet ACO R

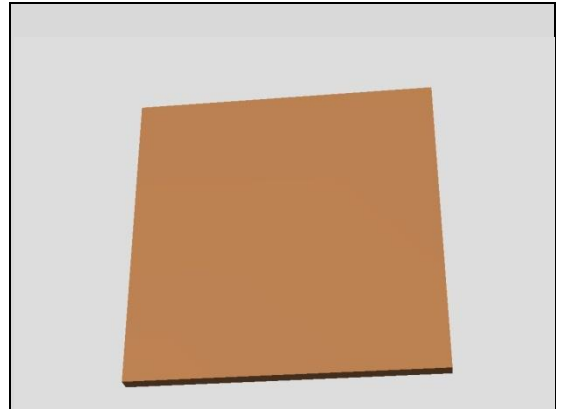
Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet ACO R.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!



R REMOVAL

Detach to remove the Sheet ACO R with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet ACO R on the Main PBA using a Flex Film Assembly Tool.



Replacement

4.59 Sheet Battery Rear

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet Battery Rear.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

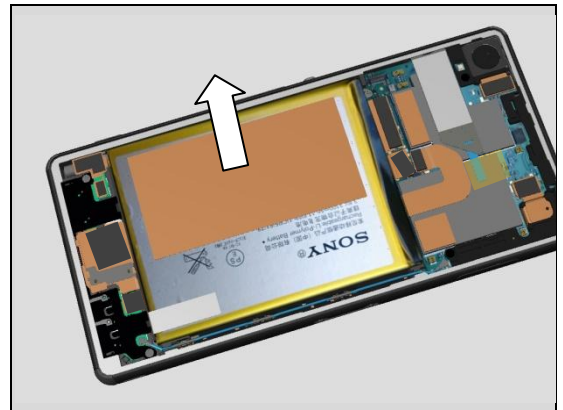
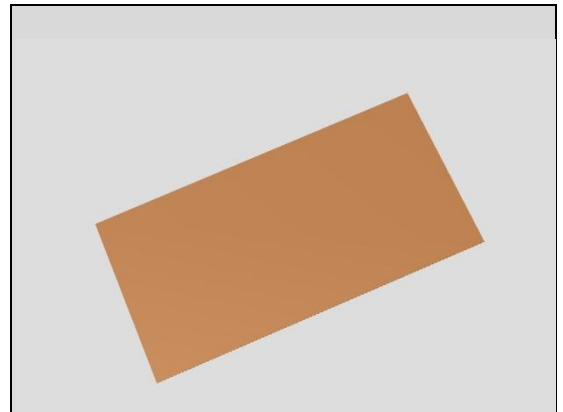
REMOVAL

Detach to remove the Sheet Battery Rear with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet Battery Rear on the Embedded Battery using a Flex Film Assembly Tool.



Replacement

4.60 Sheet Chat Camera

Follow the 3.1-3.7 Disassembly instructions!

Follow the 4.68 Removal instructions!

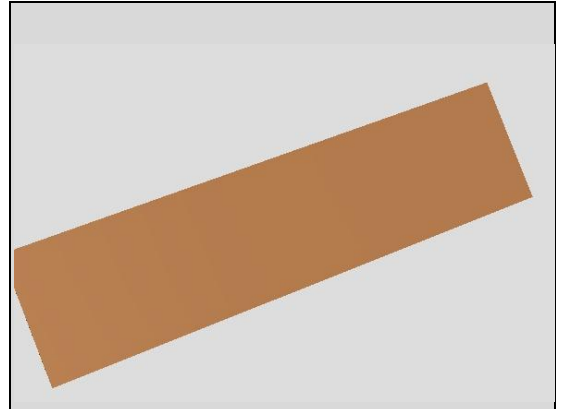
Carry out the Removal as described below.

Prepare the new Sheet Chat Camera.

Carry out the Installation as described below.

Follow the 4.68 Installation instructions!

Follow the 5.14-5.19 Reassembly instructions!



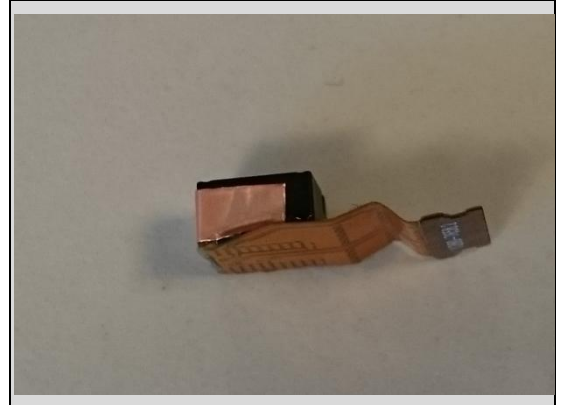
REMOVAL

Detach to remove the Sheet Chat Camera with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet Chat Camera on the Sub Camera using a Flex Film Assembly Tool.



Replacement

4.61 Sheet copper display BtB

Follow the 3.2 and 3.11-3.16 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet copper display BtB.

Carry out the Installation as described below.

Follow the 5.5-5.10 and 5.19 Reassembly instructions!

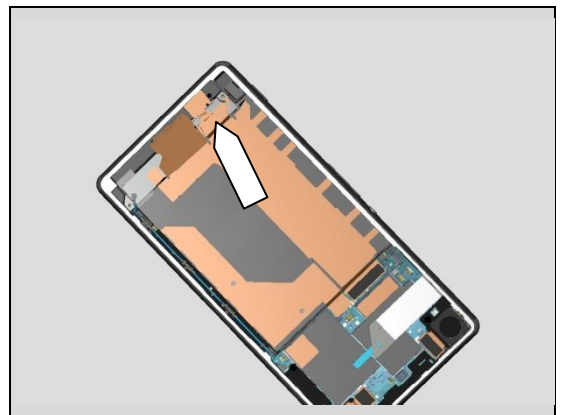
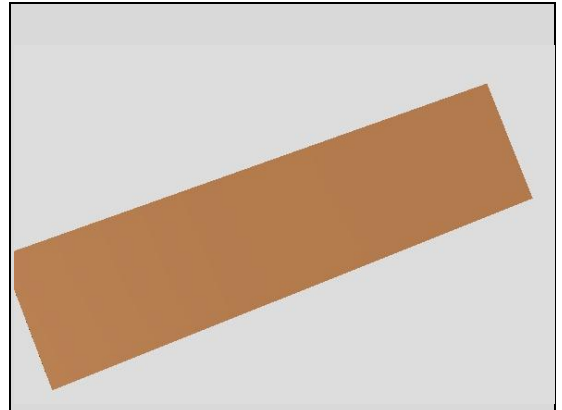
REMOVAL

Detach to remove the Sheet copper display BtB with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet copper display BtB on the Relay FPC using a Flex Film Assembly Tool.



Replacement

4.62 Sheet Relay FPC

Follow the 3.2, 3.11-3.16 and 3.19 -3.20 Disassembly instructions!

Follow the 4.28, 4. 29 Removal instructions!

Carry out the Removal as described below.

Prepare the new Sheet Relay FPC.

Carry out the Installation as described below.

Follow the 4.28, 4. 29 Installation instructions!

Follow the 5.1-5.2, 5.5-5.10 and 5.8 Reassembly instructions!

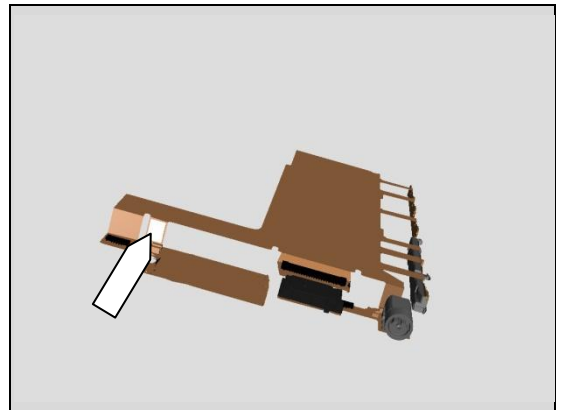
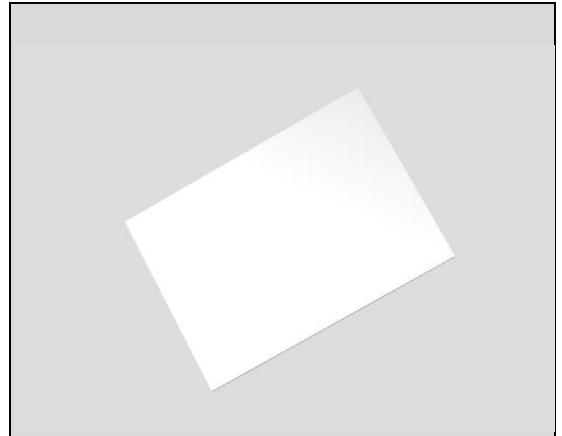
REMOVAL

Detach to remove the Sheet Relay FPC with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet Relay FPC on the Relay FPC using a Flex Film Assembly Tool.



Replacement

4.63 Sheet Sub Antenna

Follow the 3.2 -3.3 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet Sub Antenna.

Carry out the Installation as described below.

Follow the 5.18 – 5.19 Reassembly instructions!

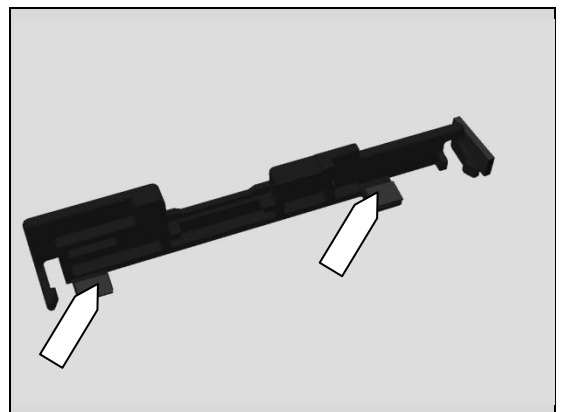
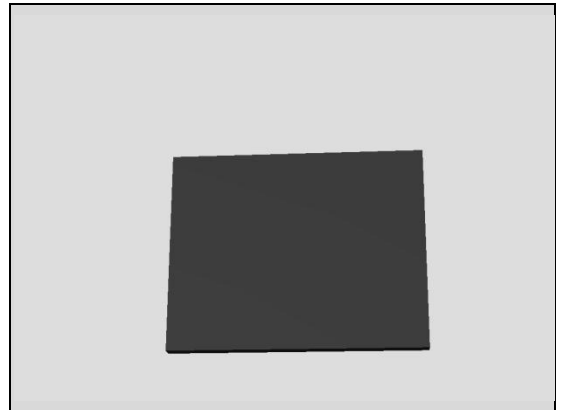
REMOVAL

Detach to remove the Sheet Sub Antenna with a Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet Sub Antenna on the Sub Antenna using a pair of tweezers.



Replacement

4.64 Sheet Sub PBA A

Follow the 3.2 – 3.11 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet Sub PBA A.

Carry out the Installation as described below.

Follow the 5.10 – 5.19 Reassembly instructions!

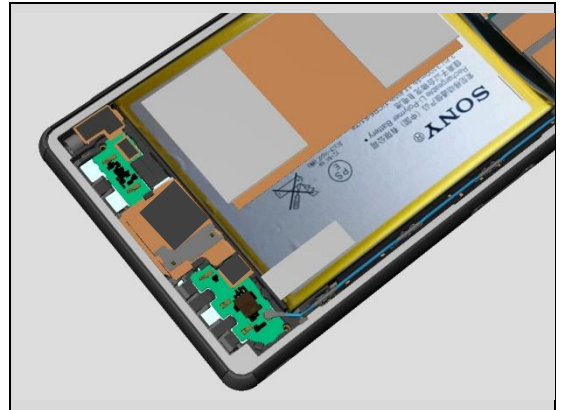
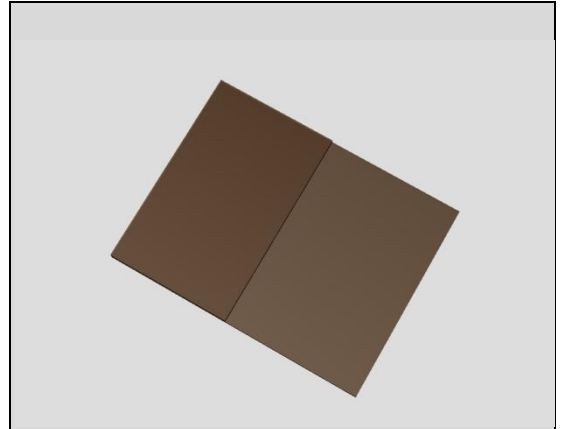
REMOVAL

Detach to remove the Sheet Sub PBA A with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet Sub PBA A on the Sub PBA-A using a Flex Film Assembly Tool.



Replacement

4.65 Sheet thermal MSM

Follow the 3.1 – 3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet thermal MSM.

Carry out the Installation as described below.

Follow the 5.14 – 5.20 Reassembly instructions!

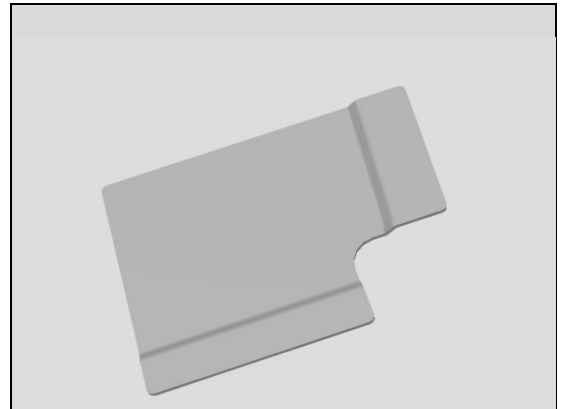
REMOVAL

Detach to remove the Sheet thermal MSM with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet thermal MSM on the Front Assy using a Flex Film Assembly Tool.



Replacement

4.66 Sheet touch FPC CN

Follow the 3.2, 3.11-3.16 and 3.19 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sheet touch FPC CN.

Carry out the Installation as described below.

Follow the 5.2, 5.5-10 and 5.19 Reassembly instructions!

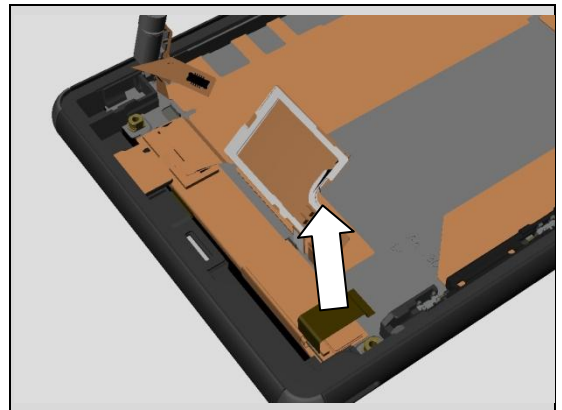
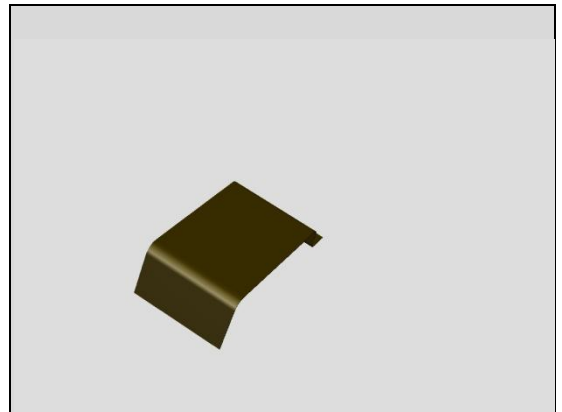
REMOVAL

Detach to remove the Sheet touch FPC CN with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place a new Sheet touch FPC CN on the Front Assy using a Flex Film Assembly Tool.



Replacement

4.67 Spacer Sub Antenna

Follow the 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Spacer Sub Antenna.

Carry out the Installation as described below.

Follow the 5.19 Reassembly instructions!

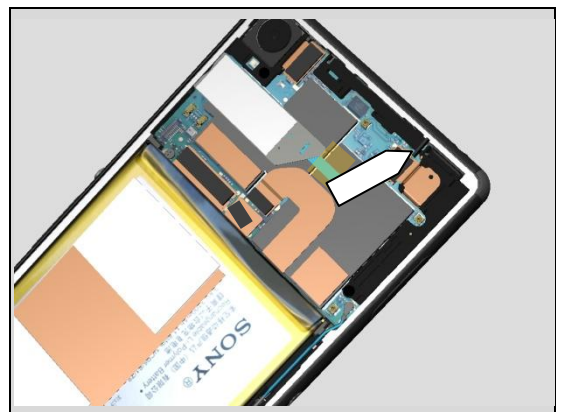
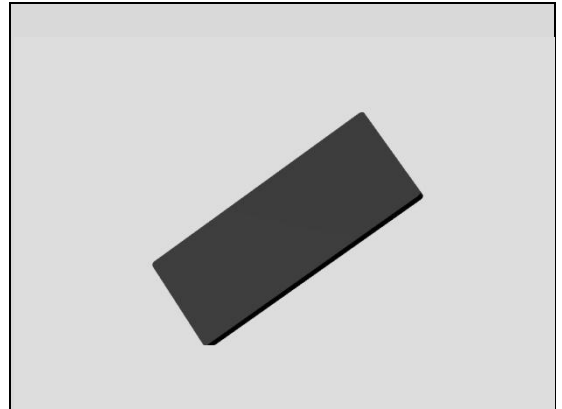
REMOVAL

Detach to remove the Spacer Sub Antenna a pair of tweezers.

Scrap! Not to be reused!

INSTALLATION

Place a new Spacer Sub Antenna on the Sub Antenna using a pair of tweezers.



Replacement

4.68 Sub Camera

Follow the 3.1 – 3.7 Disassembly instructions!

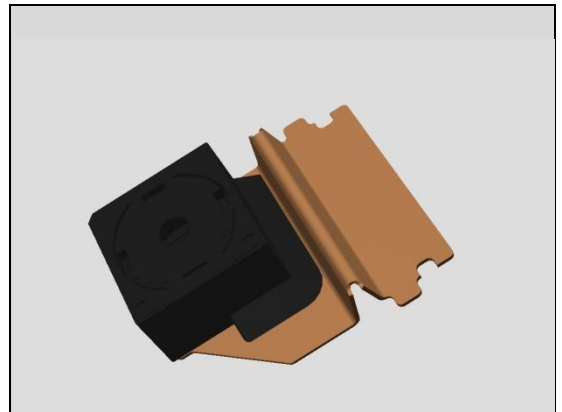
Carry out the Removal as described below.

Prepare the new Sub Camera.

Carry out the Installation as described below.

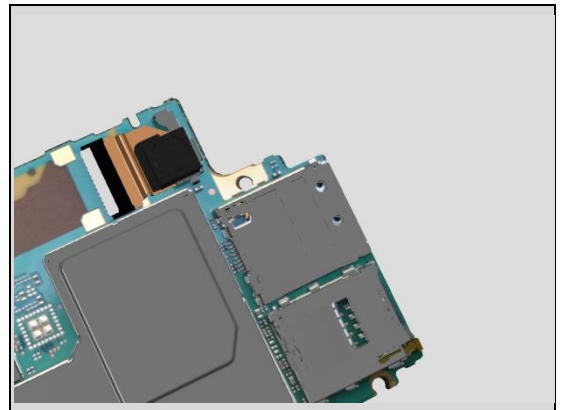
Follow the 4.60 Installation instructions!

Follow the 5.14 – 5.20 Reassembly instructions!

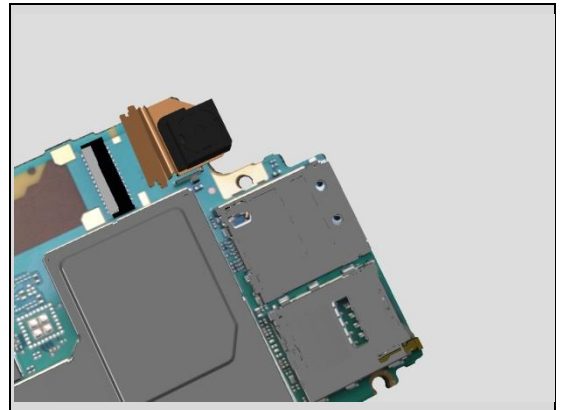


REMOVAL

Open the Zif contact with a Nylon pointer.

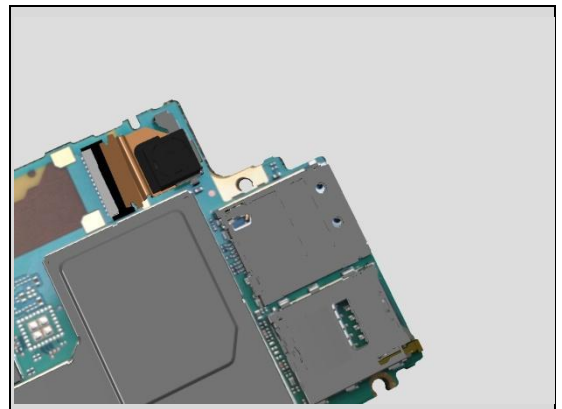


Use the Flex Film Assembly Tool to loosen the Sub Camera flex then use fingers to remove the Sub Camera.



INSTALLATION

Use the Flex Film Assembly Tool and attach the flex to Zif contact. Then use fingers for position the new Sub Camera in the cavity.



Replacemen

4.69 Sub PBA-A

Follow the 3.2 and 3.10-3.13 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sub PBA-A.

Carry out the Installation as described below.

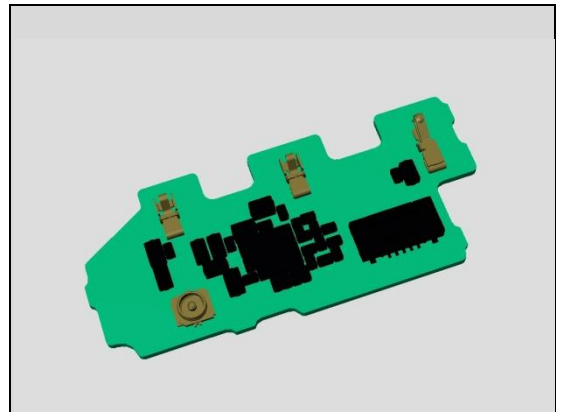
Follow the 5.8-5.11 – 5.19 Reassembly instructions!

REMOVAL

Remove the Sub PBA-A with Front Opening Tool.

INSTALLATION

Attach the Sub PBA-A with fingers



Replacement

4.70 Sub PBA-B

Follow the 3.2 and 3.10-3.13 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Sub PBA-B.

Carry out the Installation as described below.

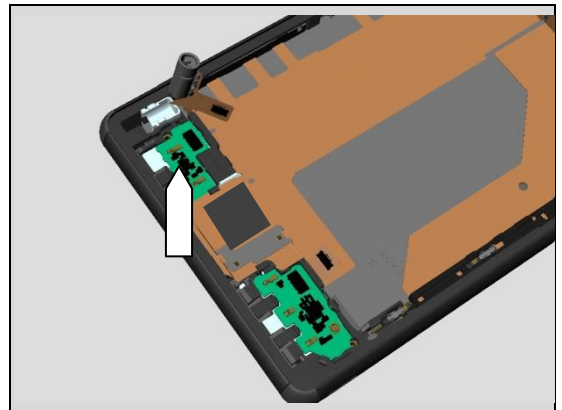
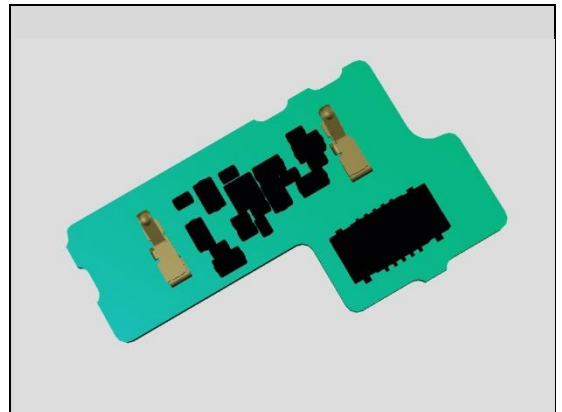
Follow the 5.8-5.11 – 5.19 Reassembly instructions!

REMOVAL

Remove the Sub PBA-B with Front Opening Tool.

INSTALLATION

Attach the Sub PBA-B with fingers



Replacement

4.71 Water Indicator

Follow the 3.1-3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Water Indicator.

Carry out the Installation as described below.

Follow the 5.14-5.20 Reassembly instructions!

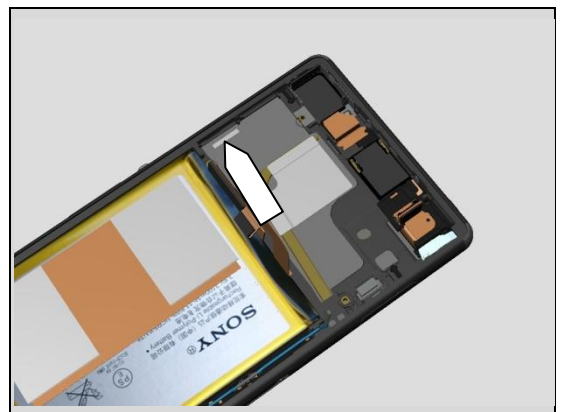
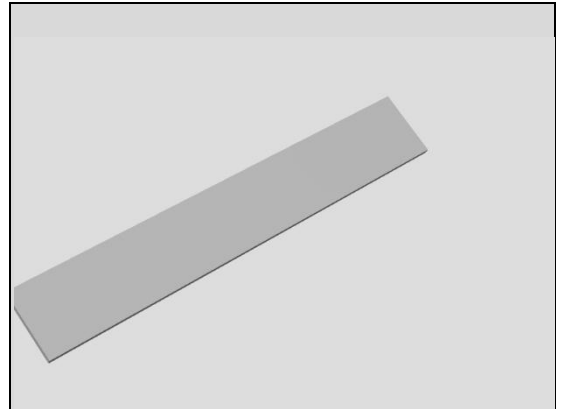
REMOVAL

Detach to remove the Water Indicator with a Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

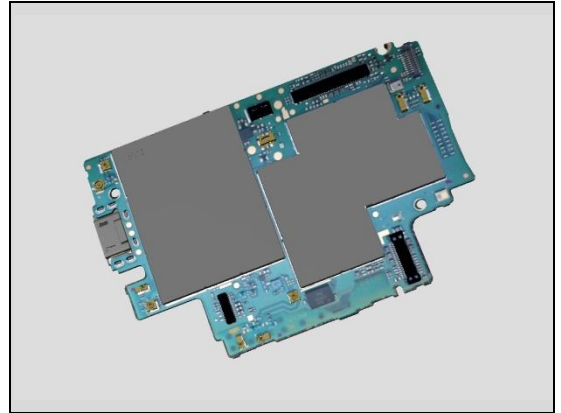
Place a new Water Indicator on the Front Assy using a pair of tweezers.



Replacement

4.72 Board Swap - Replacement

Follow the 3.1 – 3.7 Disassembly instructions!
Follow the 4.68 Removal instructions!
Replace the Swap Board.
Reuse the Main Camera and the Camera Chat.
Follow the 4.68 Installation instructions!
Follow the 5.14 – 5.20 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

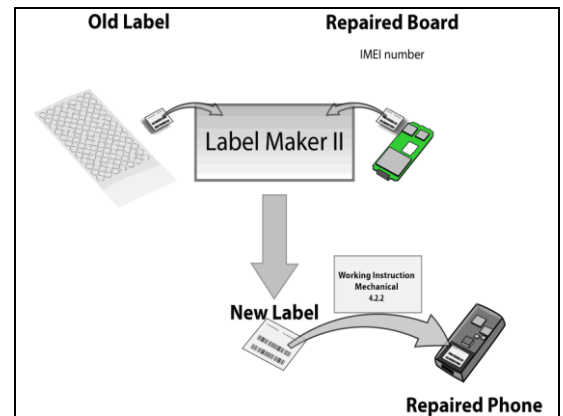
Accelerometer
Gyroscope
Noise cancelling

Replacement

4.73 Board Swap – Change Label

CHANGE LABEL

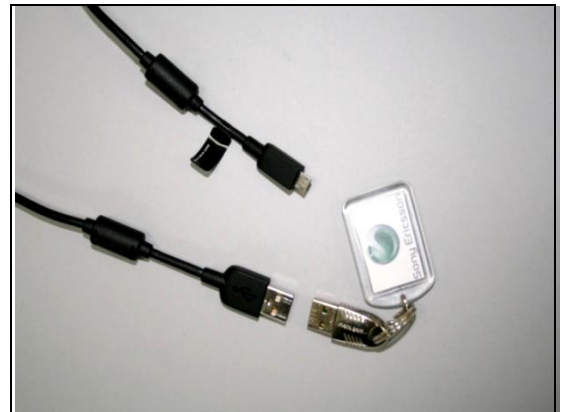
Follow the instructions in the Generic Repair Manual –
Build swap for change of label.



4.74 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

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



Replacement

4.75 Sheet FPC Battery

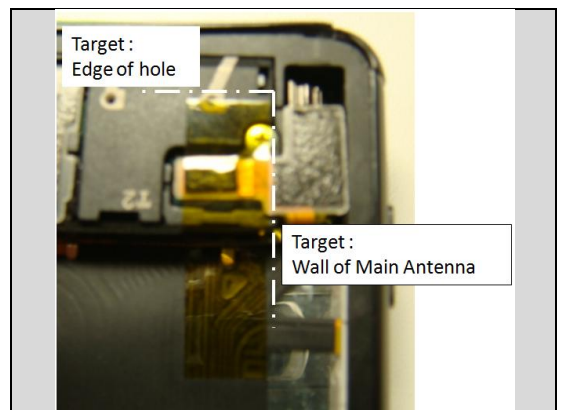
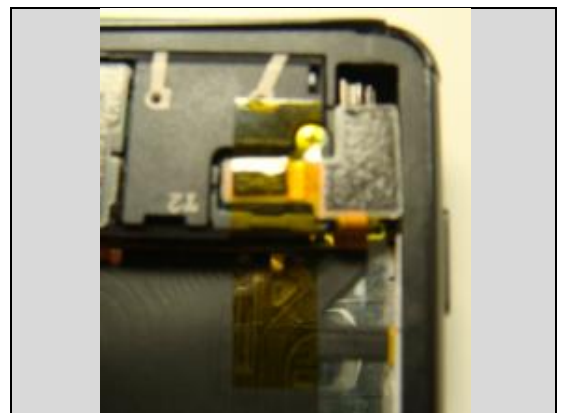
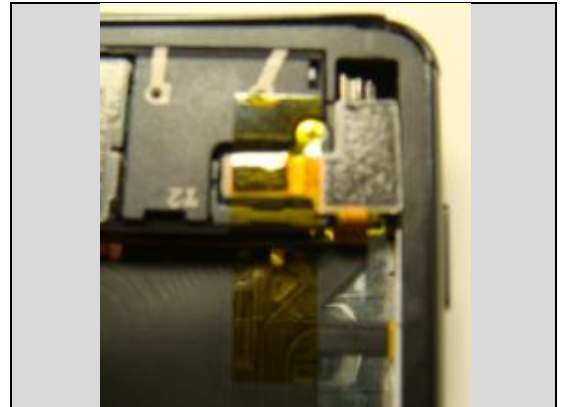
Follow the 3.1 – 3.11 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Sheet FPC battery.
 Carry out the Installation as described below.
Follow the 5.10 – 5.20 Reassembly instructions!

REMOVAL

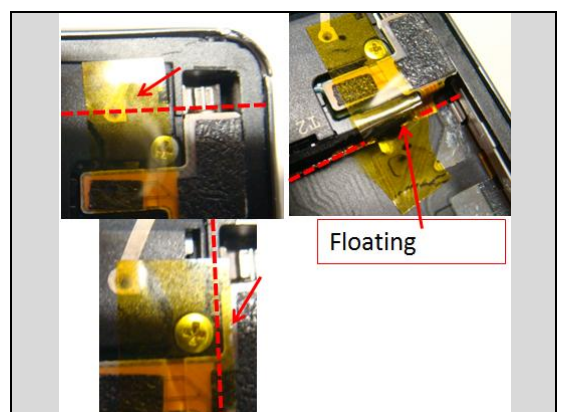
Remove with flex film assembly tool

INSTALLATION

Place a new Sheet FPC battery using a Flex Film Assembly Tool.



Examples of not allowed placements:



Replacement

4.76 MComp Sheet Spekaer BV G

Follow the 3.1 – 3.16 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new MComp Sheet Spekaer BV G.

Carry out the Installation as described below.

Follow the 5.5 – 5.20 Reassembly instructions!

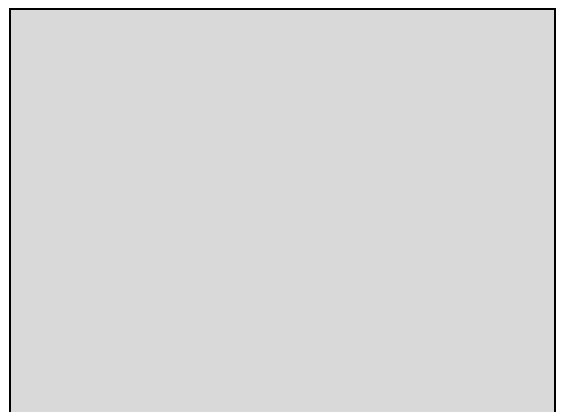
REMOVAL

Remove with flex film assembly tool



INSTALLATION

Place a new MComp Sheet Spekaer BV G using a Flex Film Assembly Tool.



Replacement

4.77 Sheet Sub PBA

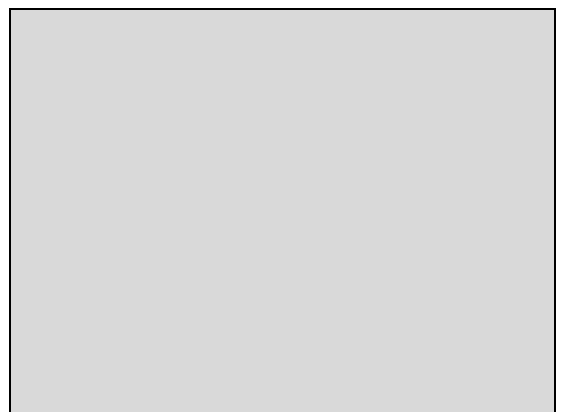
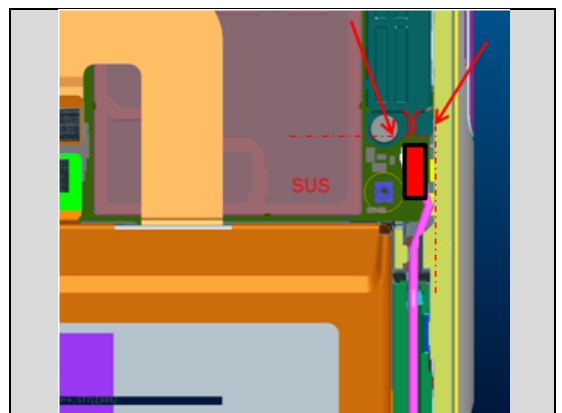
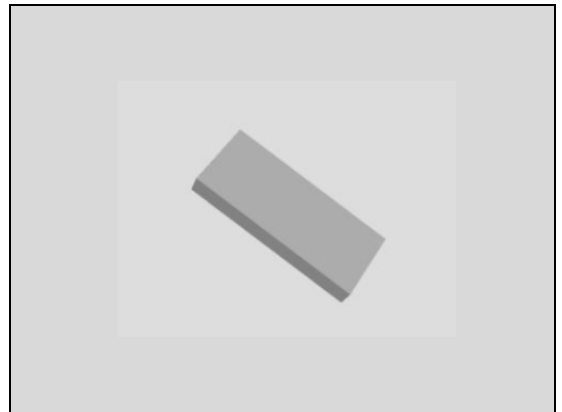
Follow the 3.1 – 3.10 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the Sheet Sub PBA.
 Carry out the Installation as described below.
Follow the 5.11 – 5.20 Reassembly instructions!

REMOVAL

Remove with flex film assembly tool

INSTALLATION

Place a new Sheet Sub PBA so it covers RF connector using a Flex Film Assembly Tool.
 Don't overlap to WLAN Antenna and Cover Main



Replacement

4.78 Spacer Charge FPC

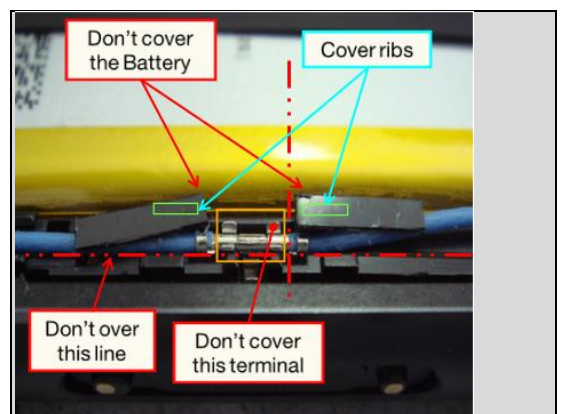
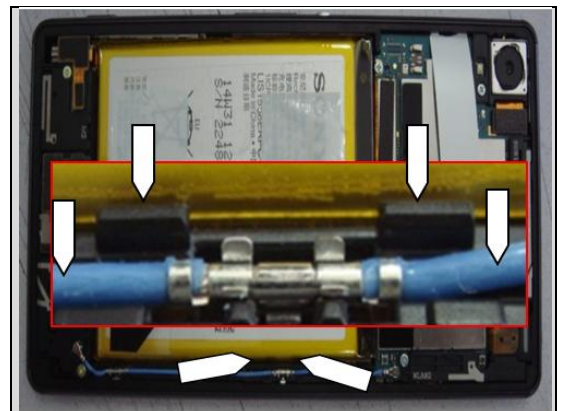
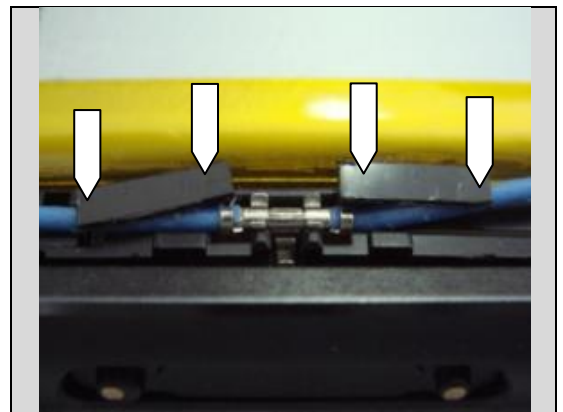
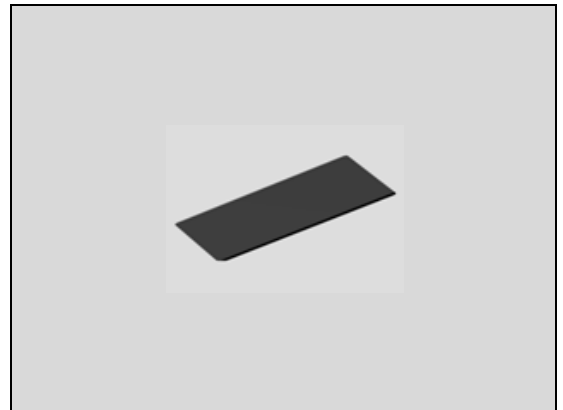
Follow the 3.1 – 3.10 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the Spacer Charge FPC.
 Carry out the Installation as described below.
Follow the 5.11 – 5.20 Reassembly instructions!

REMOVAL

Remove with flex film assembly tool

INSTALLATION

Place a new Spacer Charge FPC so it covers the 2 ribs and attach to the RF cable using a Flex Film Assembly Tool.



Replacement

4.79 Sheet Key Power B

Follow the 3.1 – 3.18 Disassembly instructions!

Carry out the Removal as described below.

Prepare the Sheet Key Power B.

Carry out the Installation as described below.

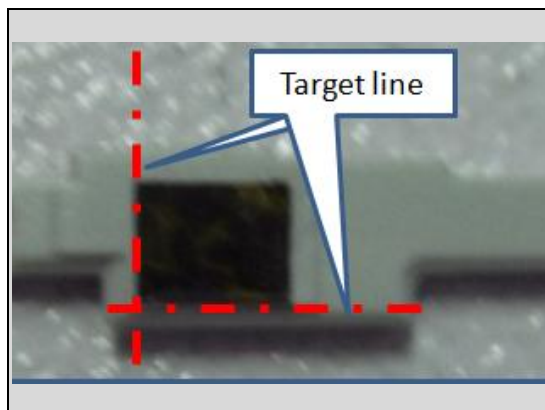
Follow the 5.4 – 5.20 Reassembly instructions!

REMOVAL

Remove with flex film assembly tool

INSTALLATION

Place a new the Sheet Key Power B using a Flex Film Assembly Tool.



4.80 Sheet Key Volume B

Follow the 3.1 – 3.10 Disassembly instructions!

Carry out the Removal as described below.

Prepare the Sheet Key Volume B.

Carry out the Installation as described below.

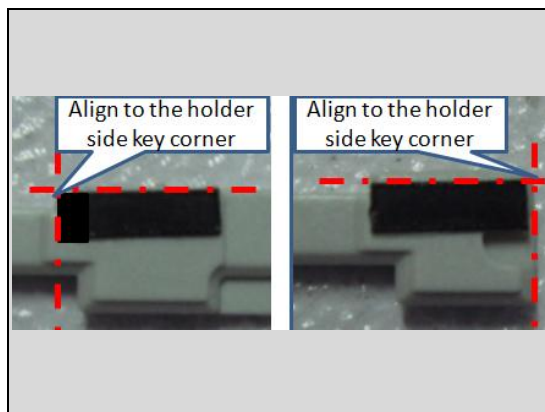
Follow the 5.11 – 5.20 Reassembly instructions!

REMOVAL

Remove with flex film assembly tool

INSTALLATION

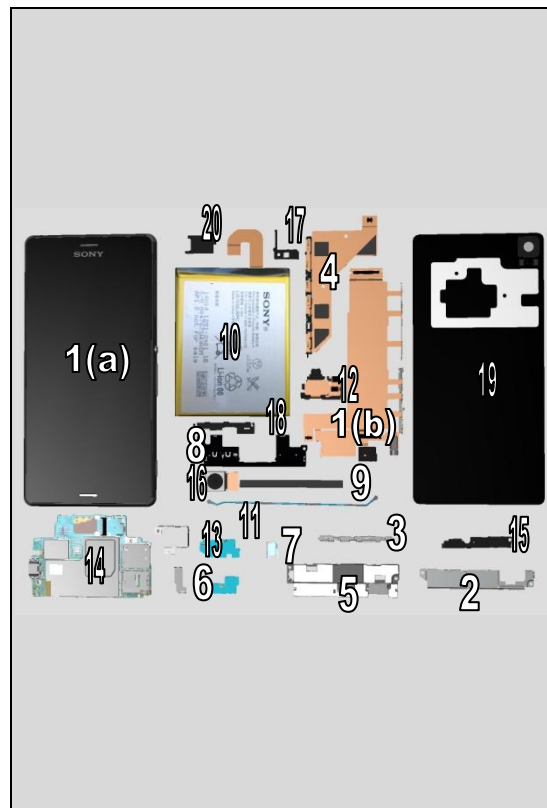
Place a new the Sheet Key Volume B using a Flex Film Assembly Tool.



5 Reassembly

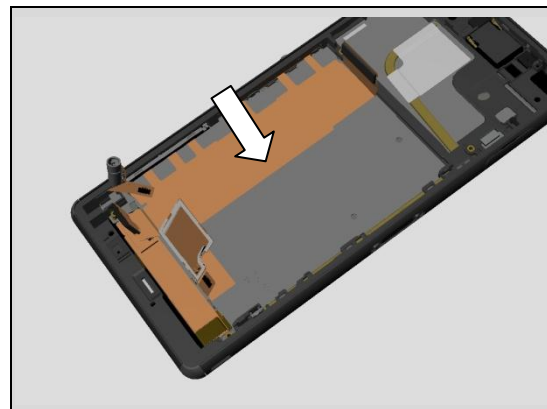
The disassembly is done in the following order:

1. Front Assy (a) + Relay FPC (b)
2. Plate Holder Speaker
3. Holder key volume
4. Charge FPC
5. Holder Speaker sub assembly
6. Plate Speaker
7. Holder Vibrator
8. Main Antenna
9. Cushion Battery
10. Embedded Battery
11. RF cable
12. Audio Jack
13. Shield Main Camera
14. Main PBA
15. Antenna BT + WLAN
16. Main Camera
17. Holder Main Camera
18. Sub Antenna
19. Rear Panel
20. Sim Tray



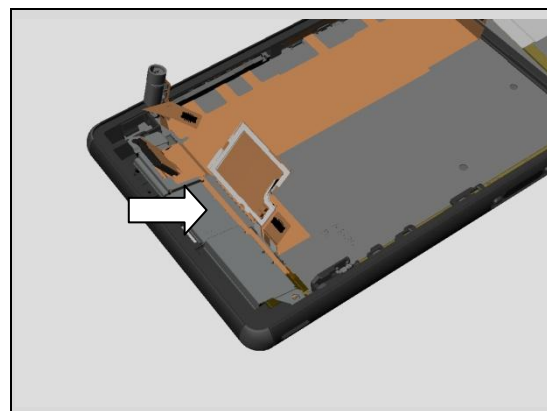
5.1 Front assy & Relay FPC

Place the Relay FPC on the Front Assy with fingers



5.2 Plate Holder Speaker

Place the Plate Holder Speaker to Front Assy



Use fingers to secure the position of Plate Holder Speaker and 1st mic then press with fingers for ten seconds.

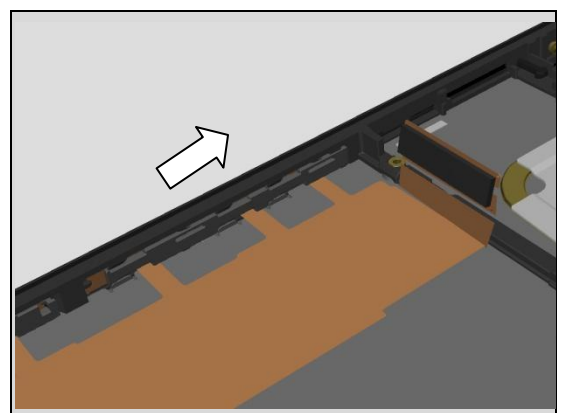
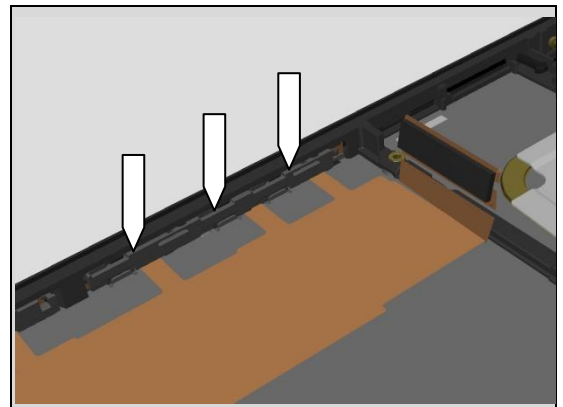
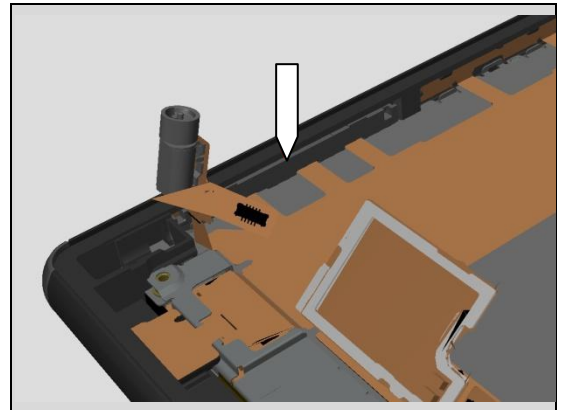
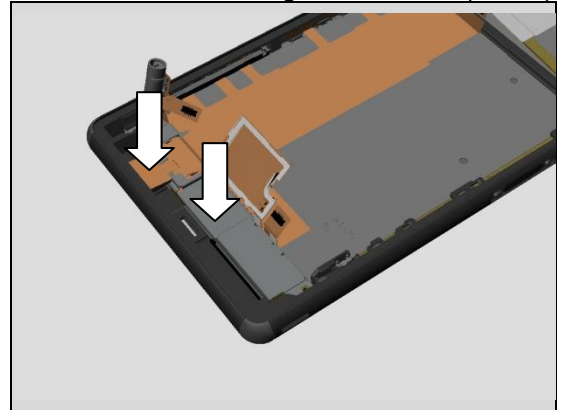
5.3 Holder key volume

Position the holder on Relay FPC to the Front Assy

Place the Holder key volume to the Front Assy

Use fingers to secure the position by move the Holder key volume to the right

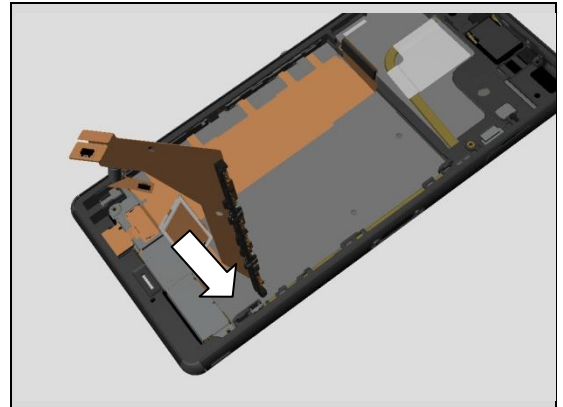
Working Instructions (mech)



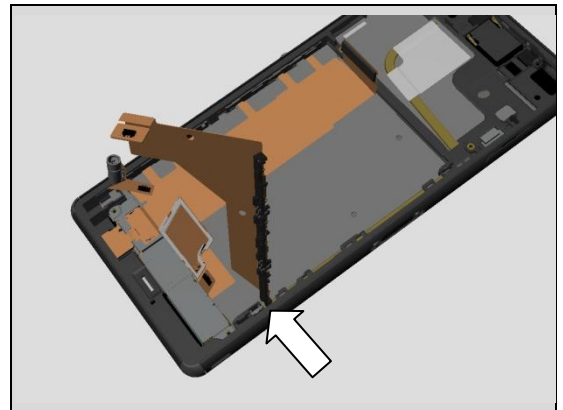
Reassembly

5.4 Charge FPC

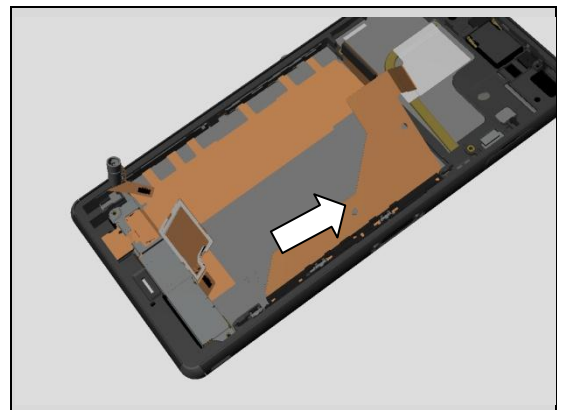
Place the Charge FPC to Front Assy



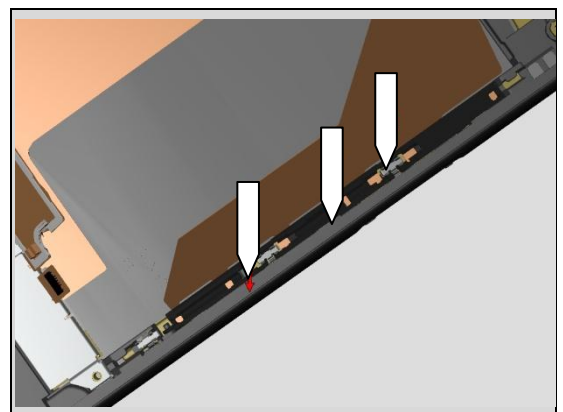
Position the Charge FPC to the pin on the Front Assy



Position the Charge FPC to the adhesive on the Front Assy

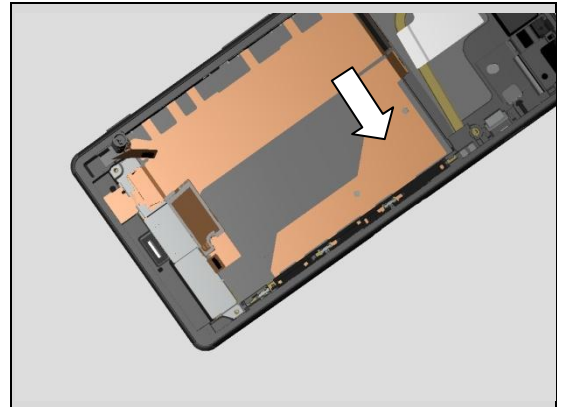


Secure the three hooks to the Front Assy



Reassembly

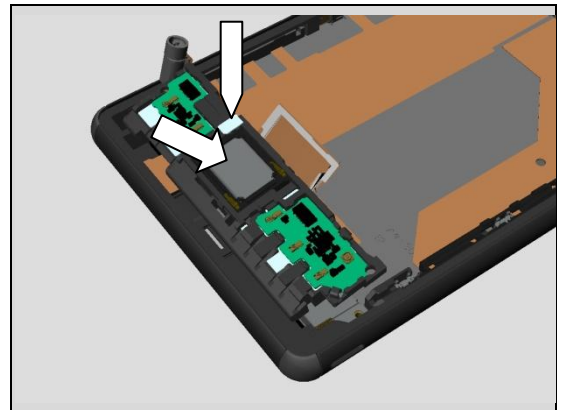
Attach the Charge FPC to the adhesive on Front Assy



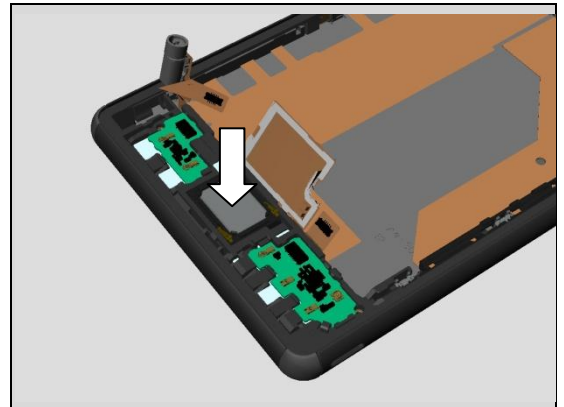
5.5 Holder Speaker sub assembly

Place the Holder Speaker sub assembly into the cavity

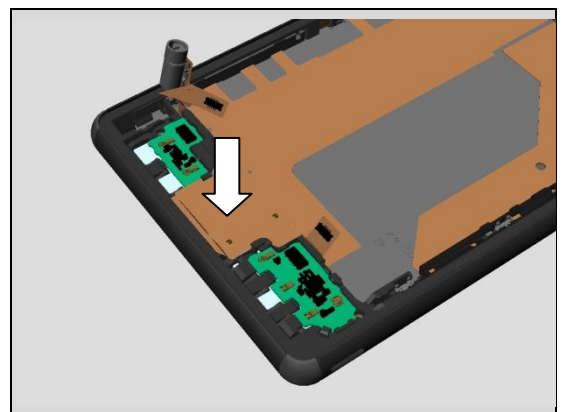
Note secure that the tape indicated by arrow is still there, if not see 4.76 MComp Sheet Spekaer BV G.



Use fingers to secure the position of Holder Speaker sub assembly

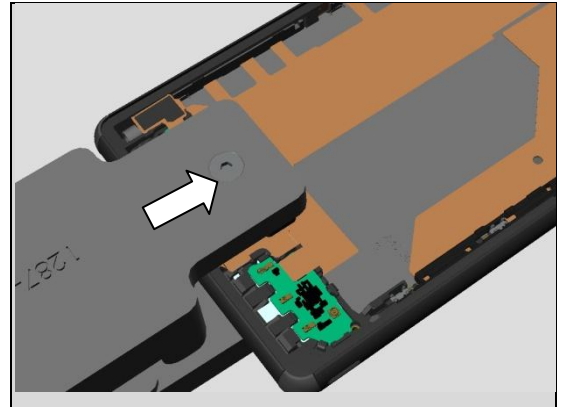


Fold down the Relay FPC over Holder Speaker sub assembly

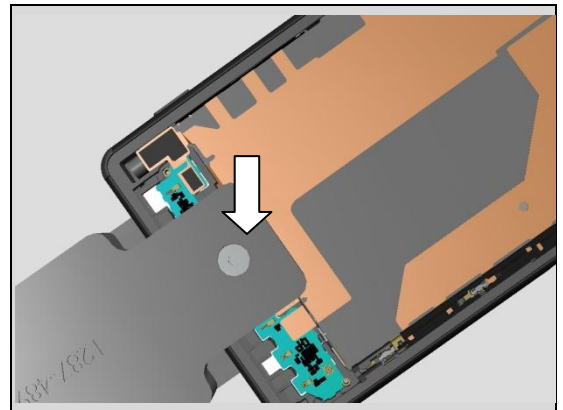


Reassembly

Use Speaker FPC Press to secure attachment

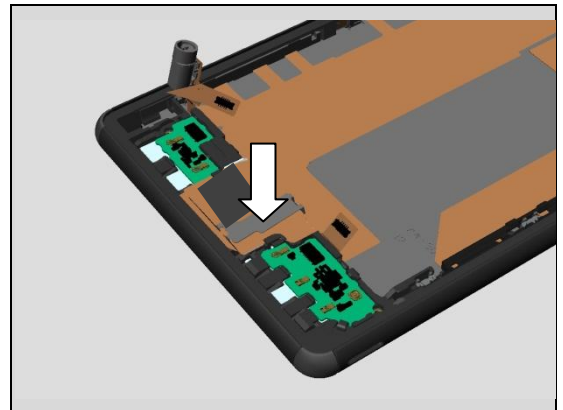


For five seconds



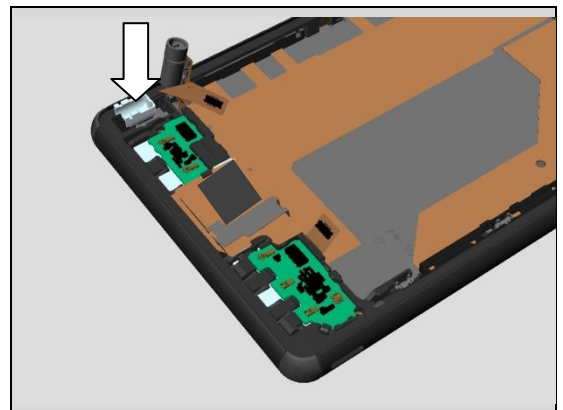
5.6 Plate Speaker

Place the Plate Speaker to the Relay FPC and position it



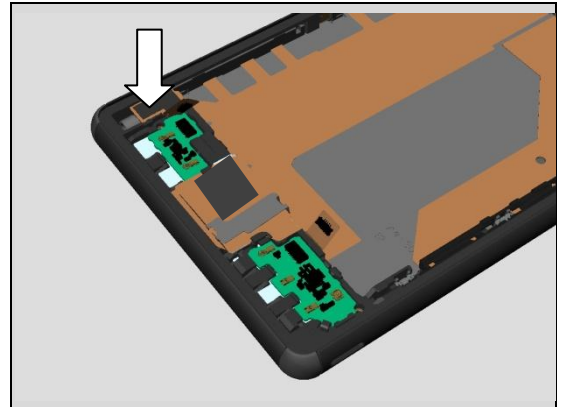
5.7 Holder Vibrator

Place the Holder Vibrator into the cavity on Front Assy

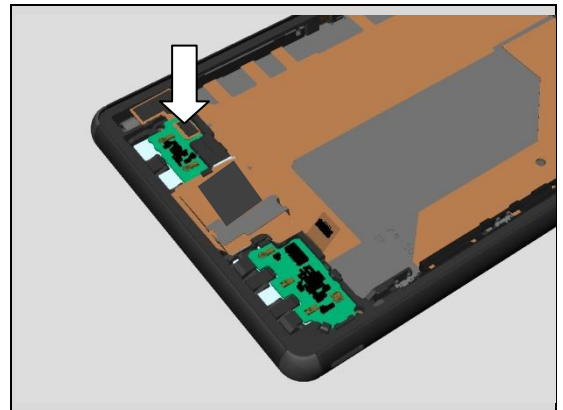


Reassembly

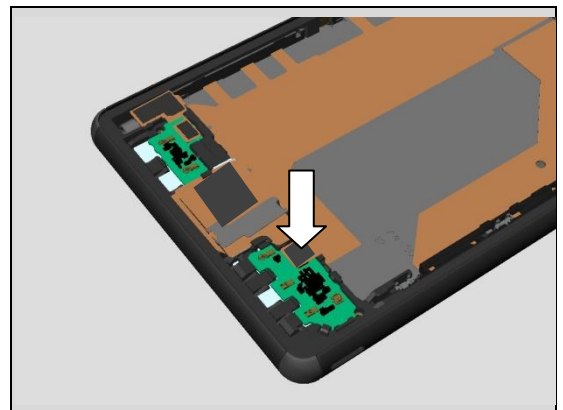
Fold down the vibrator into the Holder Vibrator



Position the BtB connector on Sub PBA-B

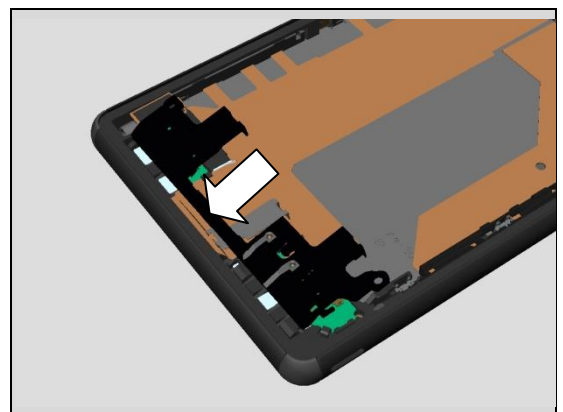


Position the BtB connector on Sub PBA-A



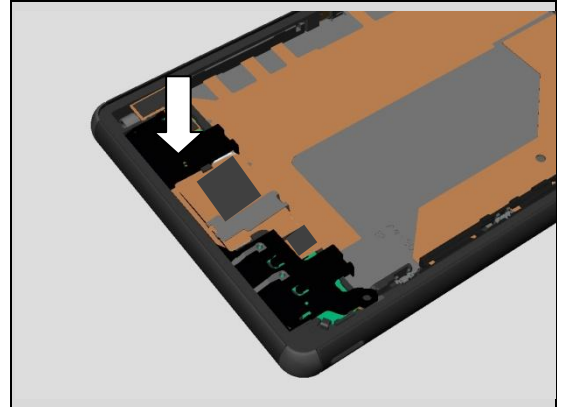
5.8 Main Antenna

Position the Main Antenna to the Holder Speaker sub assembly

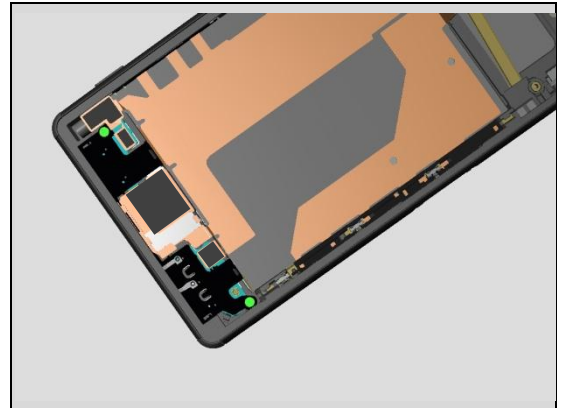


Reassembly

Use fingers to secure the position of the Main Antenna

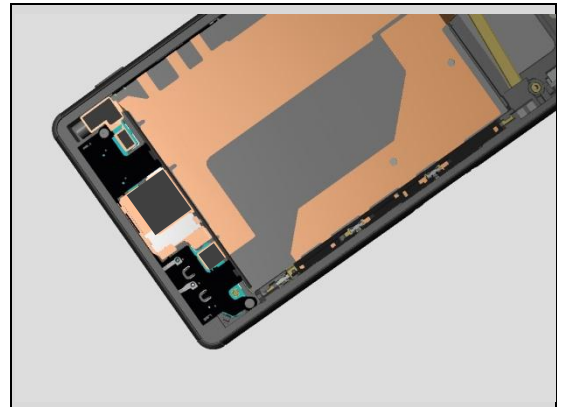


Apply 10 Ncm torque when tightening the Screw Other
Len:4.0 Diam:1.4 with Bits (JCIS No 0)



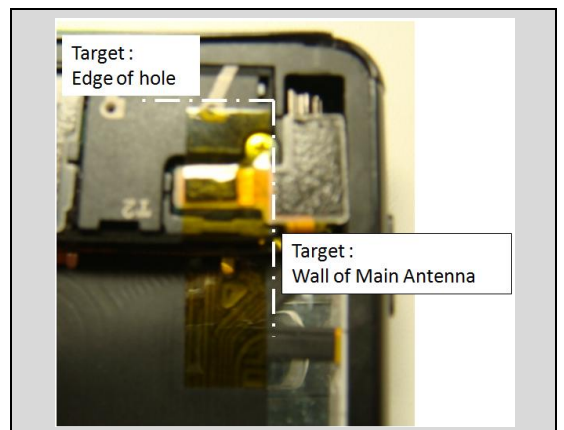
5.9 Cushion Battery

Place the Cushion Battery with a pair of tweezers



Sheet FPC battery

Place a new Sheet FPC battery using a Flex Film Assembly Tool.



Reassembly

5.10 Embedded Battery

Follow the 4.22 removal and installation instruction to replace a new Adhesive Battery Front

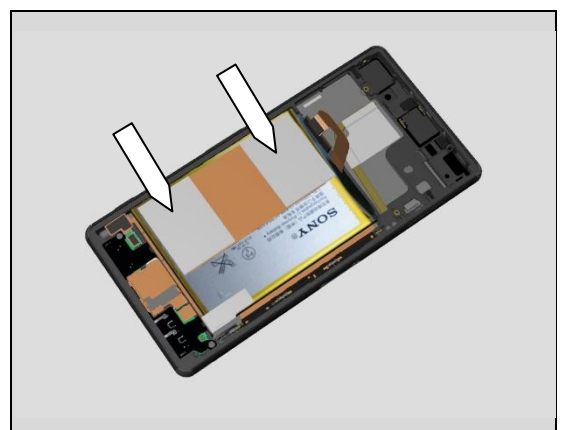
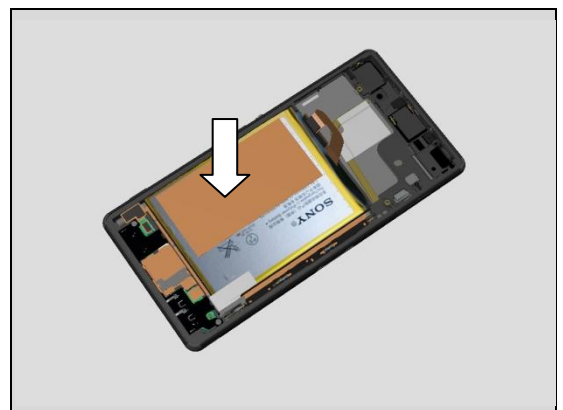
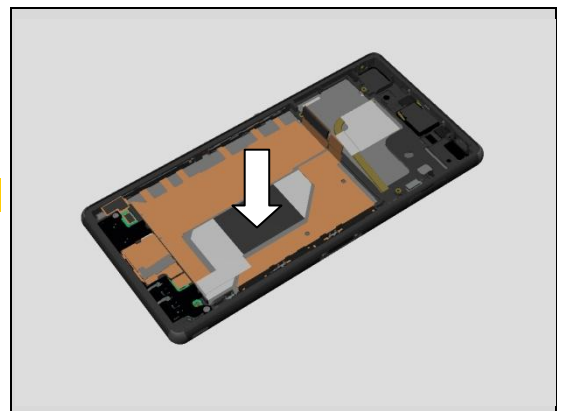
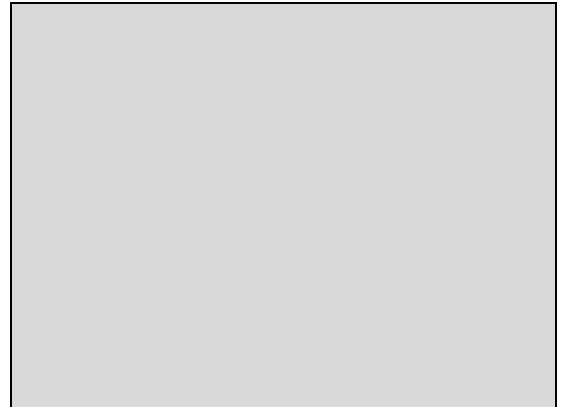
Note: Visible inspection of the Embedded Battery.

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

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

Place the Embedded Battery into the cavity

Follow the 4.23-24 removal and installation instruction to replace a new Adhesive Battery Rear and Adhesive Battery Rear 2

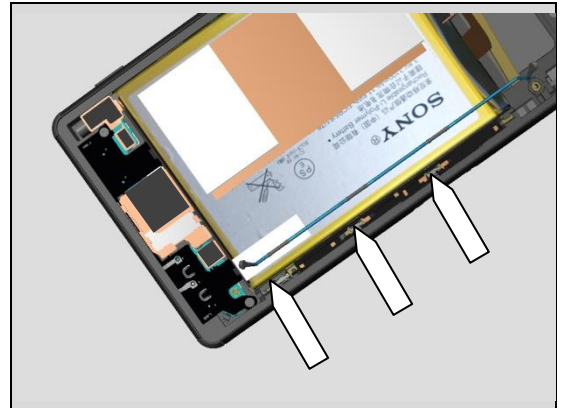


Reassembly

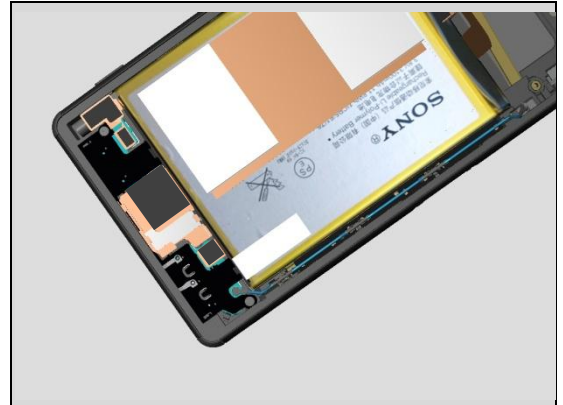
5.11 RF cable

Place the RF cable to the Charge FPC

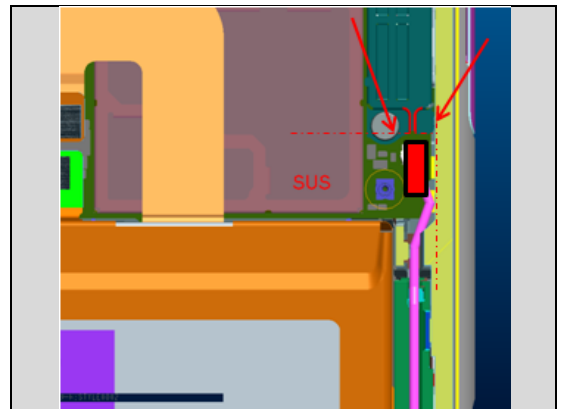
Note! Important that the silver parts of the RF cable A is placed in the three sockets.



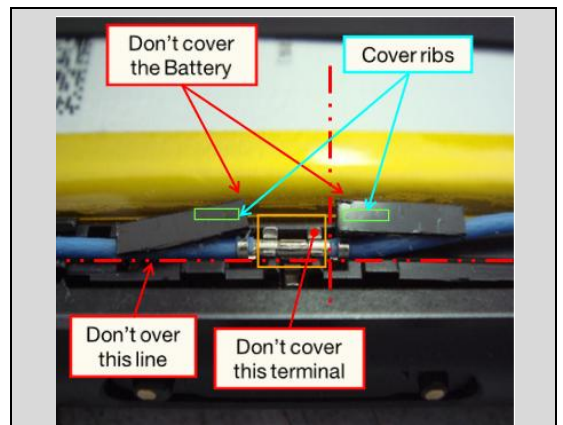
Use fingers to secure the connector of the RF cable to Sub PBA-A



Place a new Sheet Sub PBA so it covers RF connector using a Flex Film Assembly Tool.
Don't overlap to WLAN Antenna and Cover Main



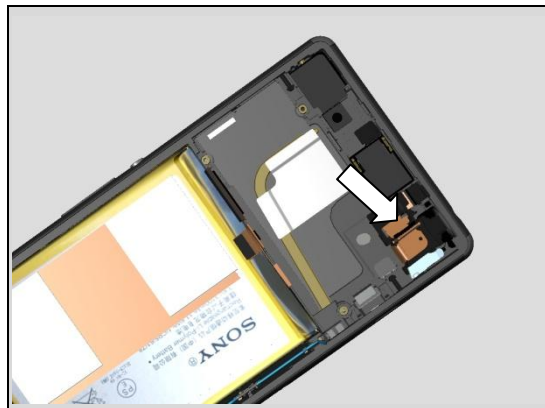
Place a new Spacer Charge FPC so it covers the 2 ribs and attach to the RF cable using a Flex Film Assembly Tool.
See 4.78 and Spacer Charge Pad for further information.



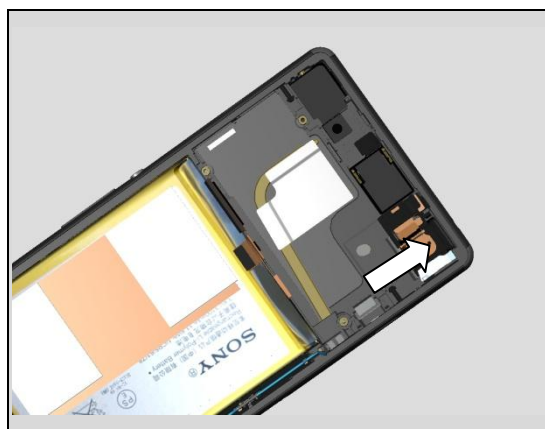
Reassembly

5.12 Audio Jack

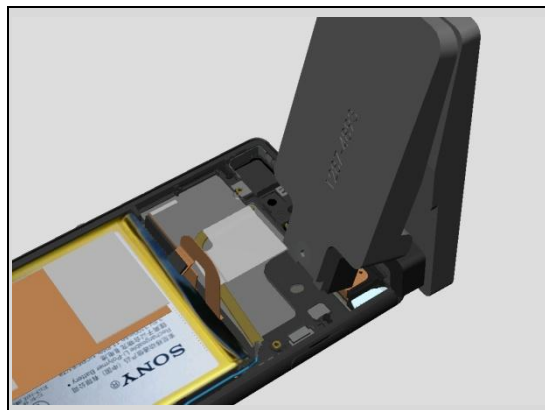
Place the Audio Jack to the Front Assy



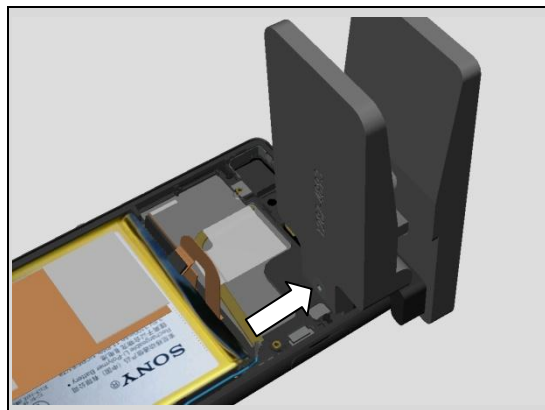
Use finger to secure the position of the Audio Jack



Use Audio Jack Press

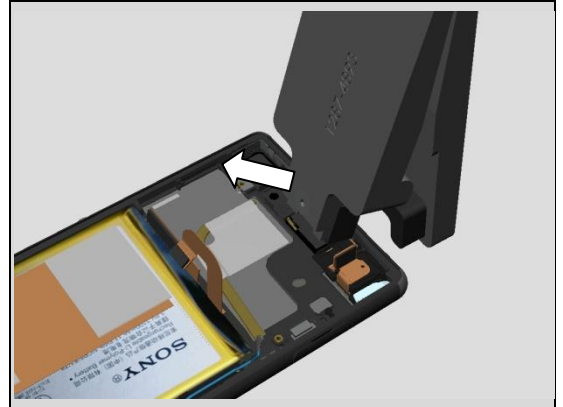


Press for 10s.



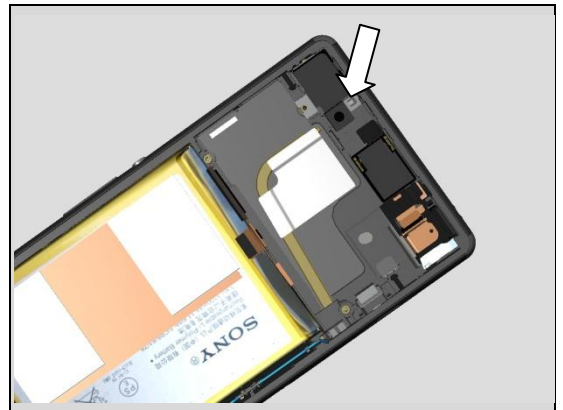
Reassembly

Remove the Audio Jack Press



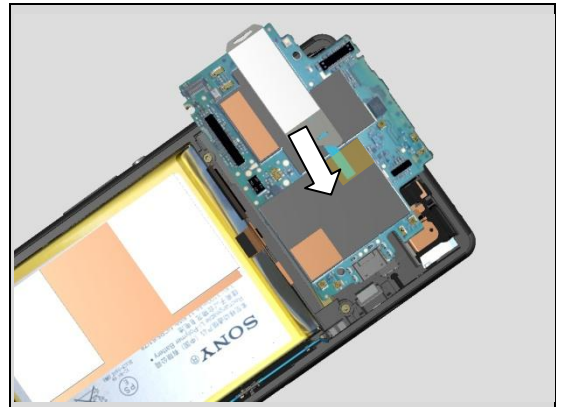
5.13 Shield Main Camera

Place the Shield Main Camera into the cavity

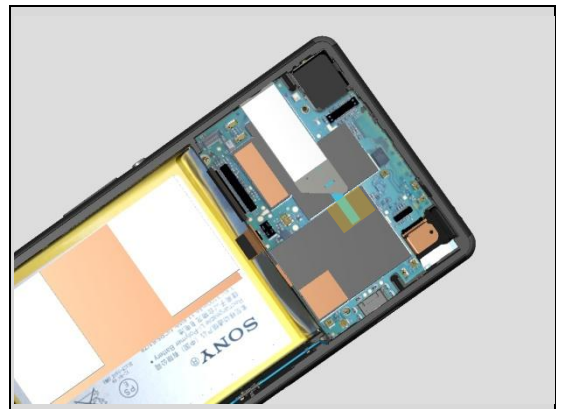


5.14 Main PBA

Place the Main PBA into the cavity

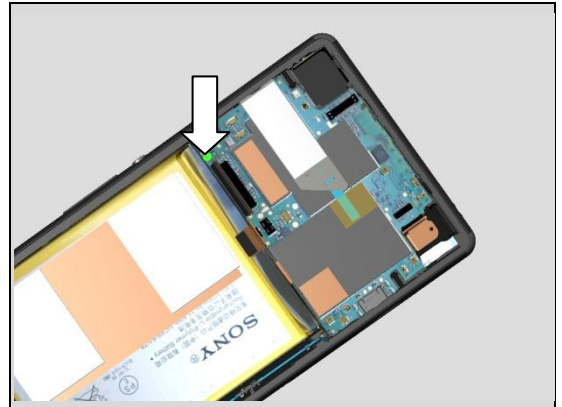


Use the fingers to secure the Main PBA on the Front Assy

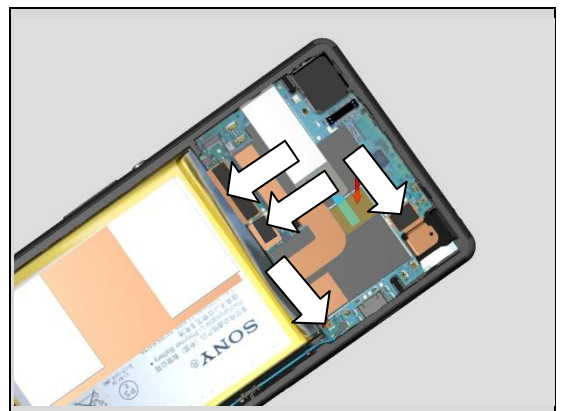


Reassembly

Apply 12 Ncm torque when tightening the Screw Other
Len:2.6 Diam:1.4 with Bits (JCIS No 0)

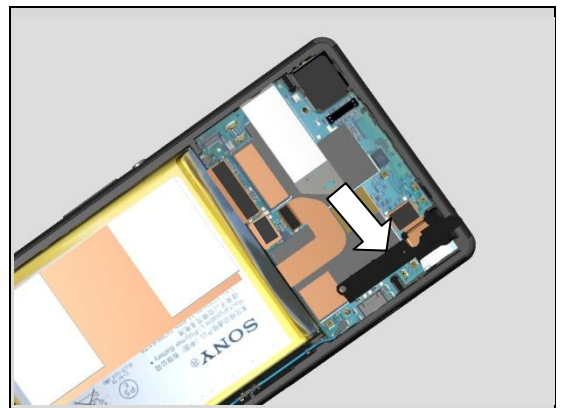


Attach the BtB connectors and the connector for RF cable to the Main PBA

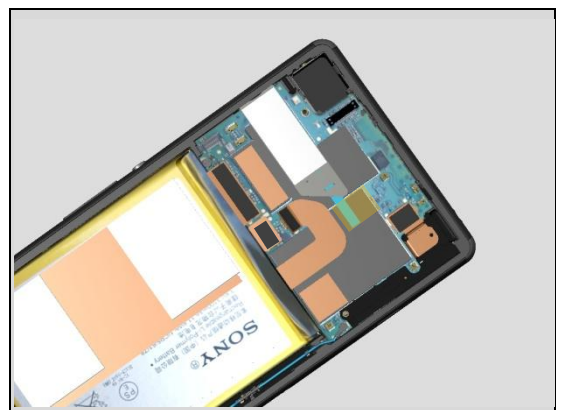


5.15 Antenna BT + WLAN

Place the Antenna BT + WLAN on the Main PBA

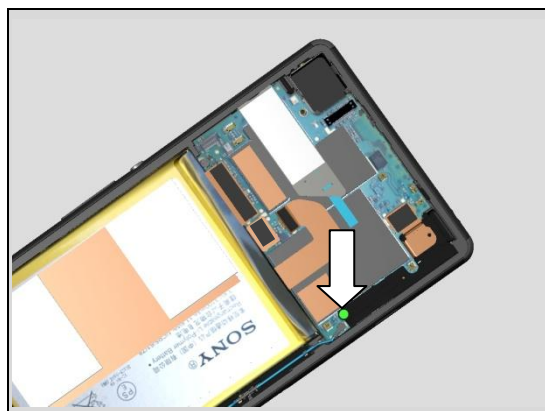


Use fingers to secure the position of the Antenna BT + WLAN



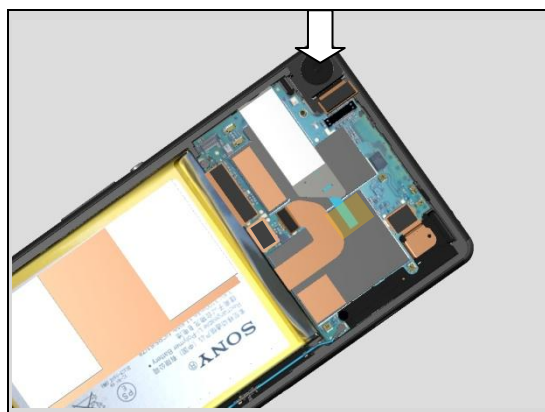
Reassembly

Apply 10 Ncm torque when tightening the Screw Other
Len:2.6 Diam:1.4 with Bits (JCIS No 0)

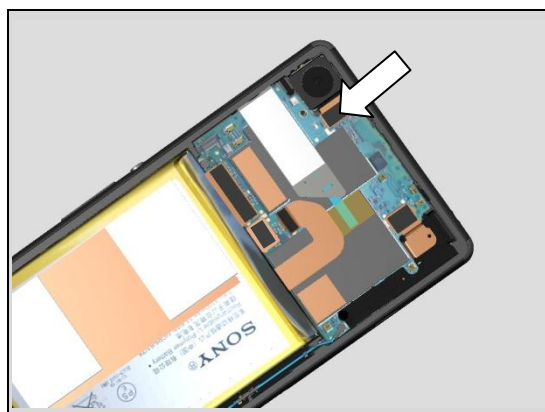


5.16 Main Camera

Place the Main Camera into the cavity

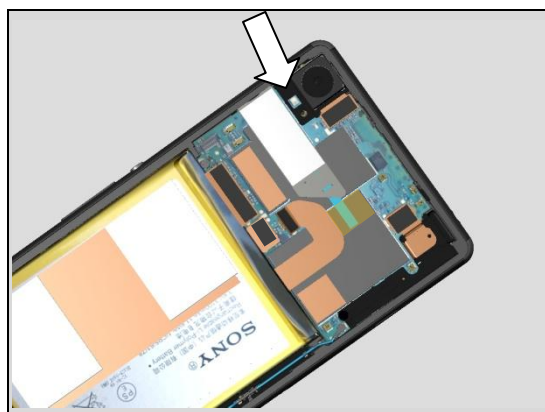


Attach the BtB connector of Main Camera to Main PBA



5.17 Holder Main Camera

Place the Holder Main Camera on the Main Camera

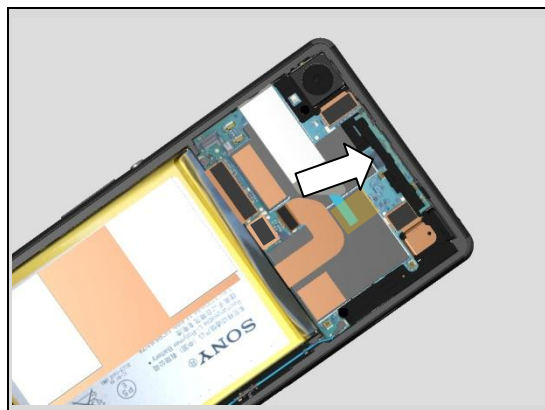
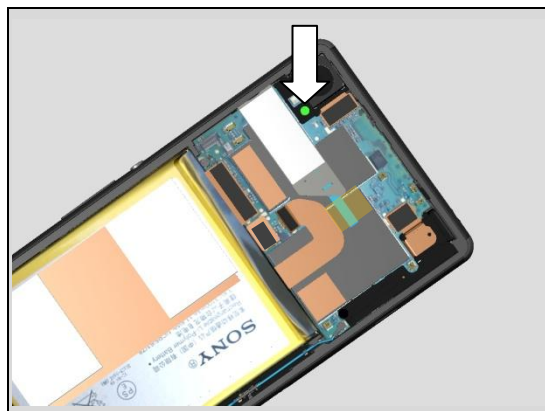


Reassembly

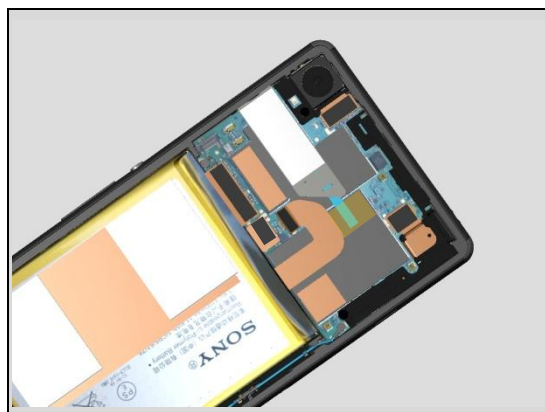
Apply 12 Ncm torque when tightening the Screw Other
Len:2.6 Diam:1.4 with Bits (JCIS No 0)

5.18 Sub Antenna

Place the Sub Antenna on the Main PBA

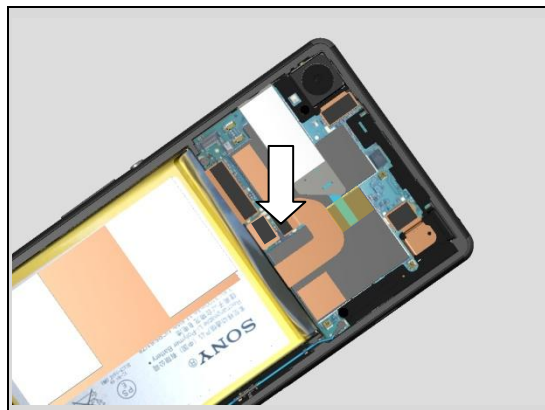


Use fingers to secure the position of the Sub Antenna



5.19 Rear Panel

Press with fingers to secure the contact of Embedded
Battery



Reassembly

Follow the 4.26 removal and installation instruction to replace a new Adhesive Rear Panel

Use Isopropyl Alcohol - 99 % for clean around the edges of Front Assy before assembly Rear Panel

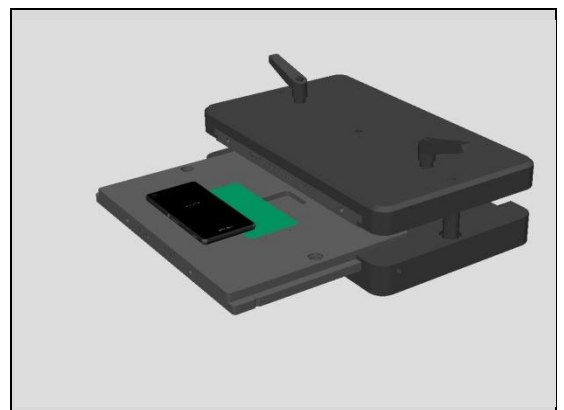
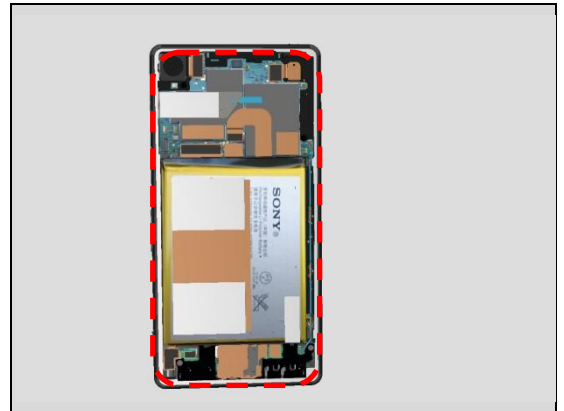
Place the Rear Panel on the Front Assy

Make sure of an good alignment so the Rear Panel is centered

Upper inlay = Rear Panel Press Top Inlay

Lower inlay = Bottom Press Inlay

Place the phone in the Bottom Press Inlay and follow the instruction in 1003-9107 Tool Catalogue – mechanical and document Toothed Rack Press Instruction for use.



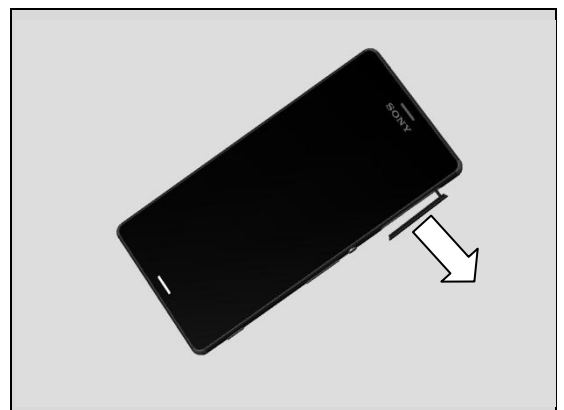
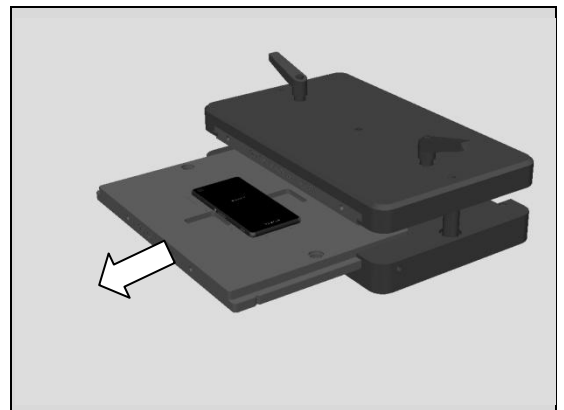
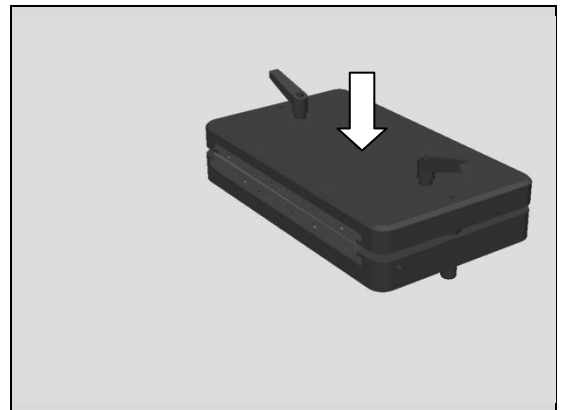
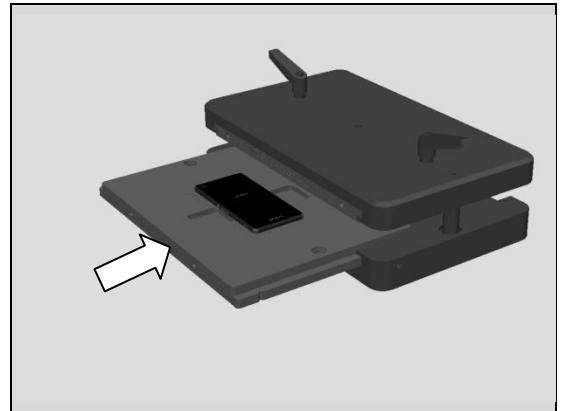
Reassembly

Press with 494 ± 60 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.

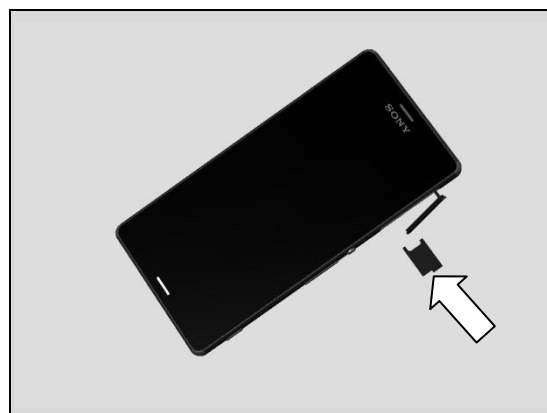
5.20 Sim Tray

Open Cap SD

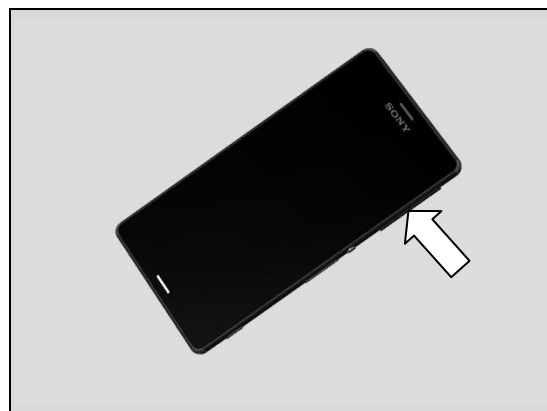


Reassembly

Insert the Sim Tray.



Close Cap SD



6 Revision History

Rev.	Date	Changes / Comments
1	2014-09-12	Initial release
2	2014-09-22	Added D6616
3	2014-10-17	Updated Removal and Installation instruction under Replacement chapter
4	2014-10-29	Updated in chapters 4.54 and 4.55
5	2015-02-19	4.75, 5.9 Sheet FPC battery, 4.76, 3.16 MComp Sheet Spekaer BV G updated, 4.77, 5.11 Sheet Sub PBA, 4,78, 5.11 Spacer charge pad, 4,79, 4,80 and 4.18 updated.
6	2015-09-16	Added D6646