

Working Instructions

- mechanical -



Xperia™ Z5
E6603, E6653

Xperia™ Z5 Dual
E6633, E6683

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For general information about mechanical repair related issues, refer to

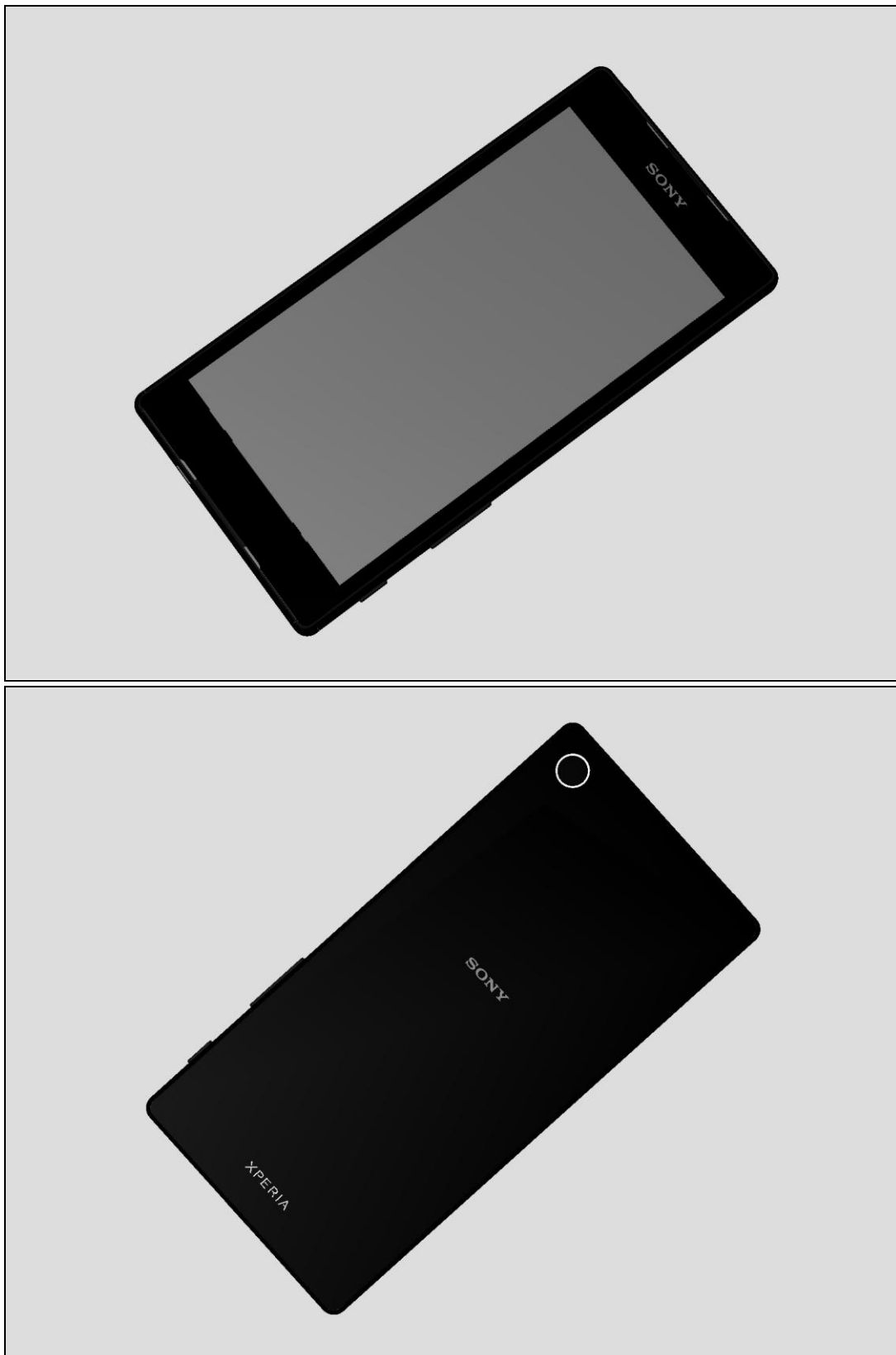
1220-1333: Generic Repair Manual - mechanical

Always firstly disconnect the Battery FPC BtB connector to cut off power supply when the Panel Rear is disassembled.

If there are no special indications of 'E6633' or 'E6683', E6633 and E6683 share the same repair method as common sections

1 Exterior Views

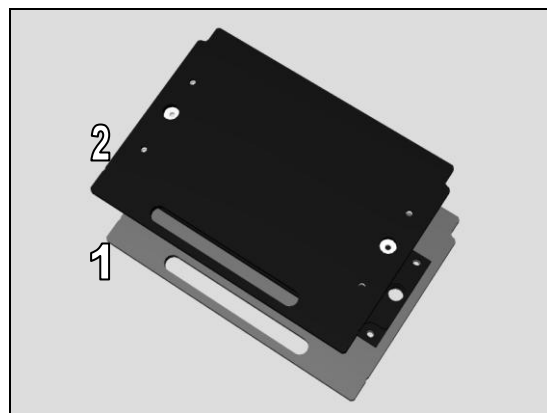
1.1 E6603/E6653/E6633/E6683



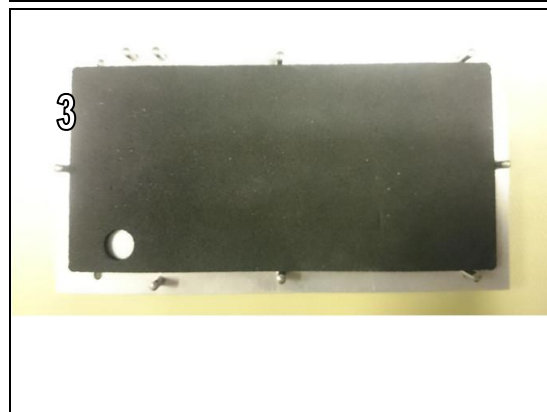
2 Tools

SPECIAL TOOLS

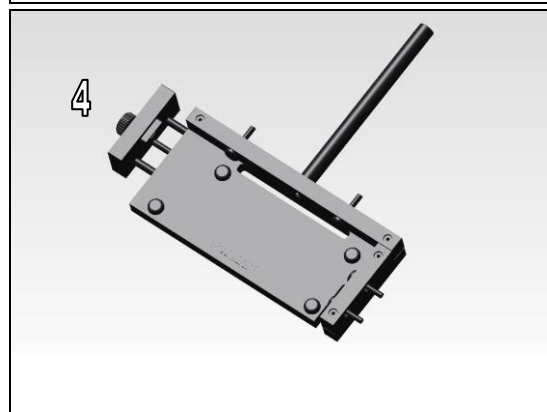
1. Bottom Press Inlay 1297-5969
2. Rear Panel Press Top Inlay 1297-5970



3. Rear Panel Adhesive Alignment Fixture 1297-5971



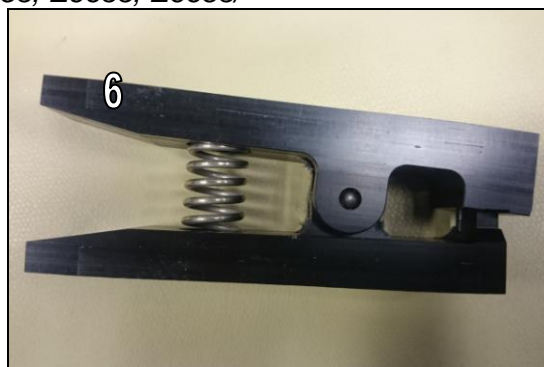
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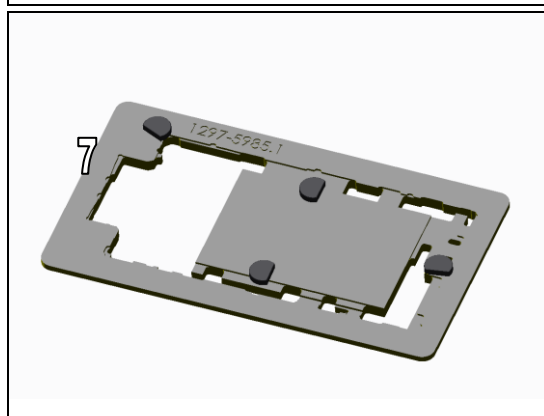
5. FPC Jack Module Press 1297-5984



6. Gasket WR SPK Press 1298-1228



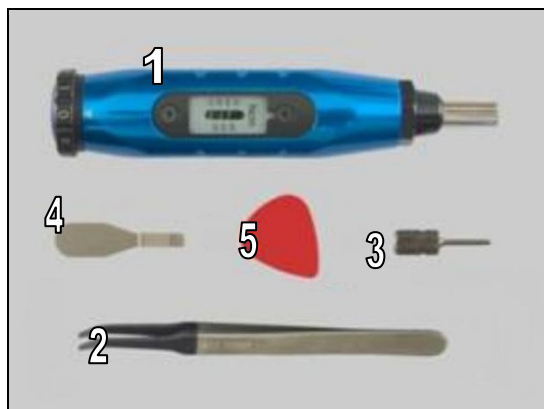
7. Soldering Fixture 1297-5985



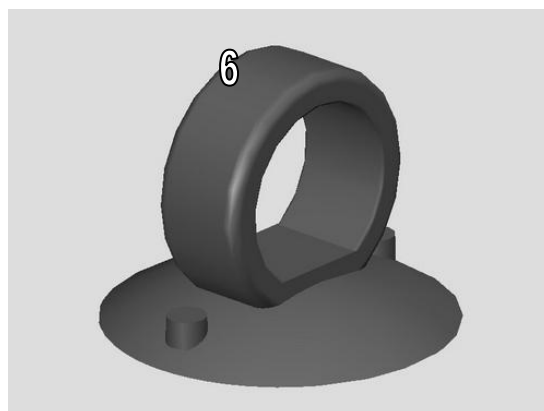
For part no's on the tools above, refer to the 'Tools Catalogue/Matrix'!

STANDARD TOOLS

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



6. Suction cup

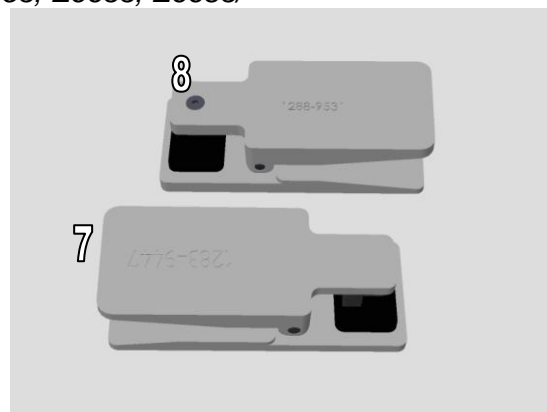


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- 7. Earspeaker/Loudspeaker Top Press Tool (1283-9447) for upper speaker
- 8. Press Tool Ear Speaker (1288-9531) for lower speaker

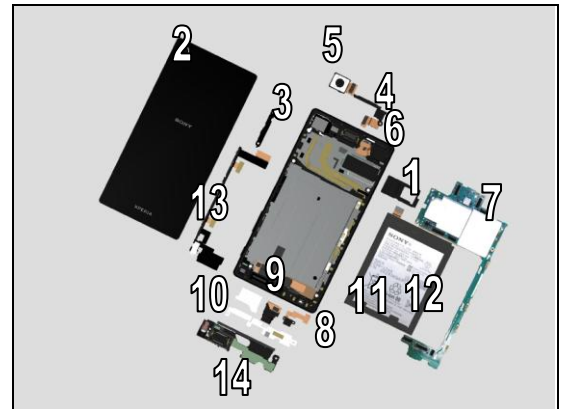
Note! Due to limitation of order system, names of above tools come from the naming in the past model. Please be careful.



3 Disassembly

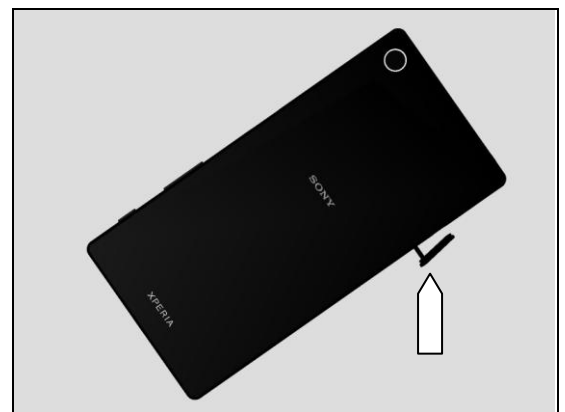
The disassembly is done in the following order:

1. Tray Combo
2. Panel Rear
3. Holder PBA
4. Antenna Cell Sub
5. Camera Main
6. Camera Sub
7. Main PBA
8. FPC 1st Mic
9. FPC USB
10. Shield FPC LCD
11. Adhesive Battery
12. Battery Embedded
13. FPC Key
14. Antenna Cell Main

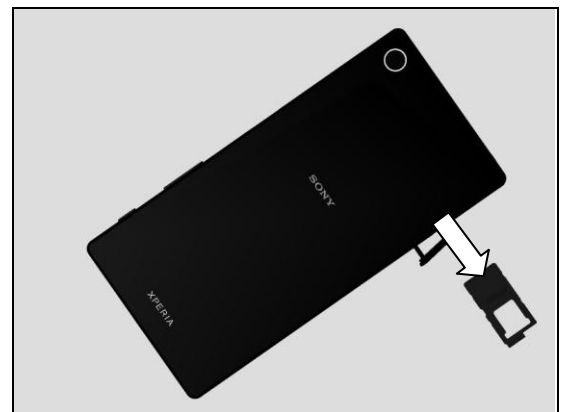


3.1 Tray Combo

Open the Cap.

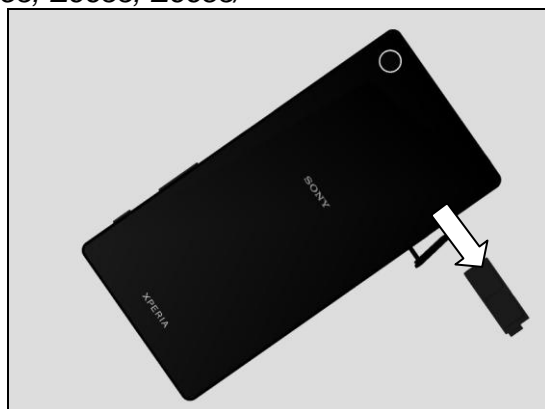


Remove the Tray Combo.
(For E6603, E6653)



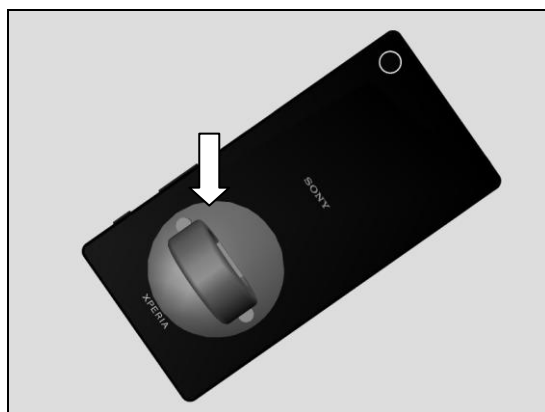
(For E6633, E6683)

Close the Cap.

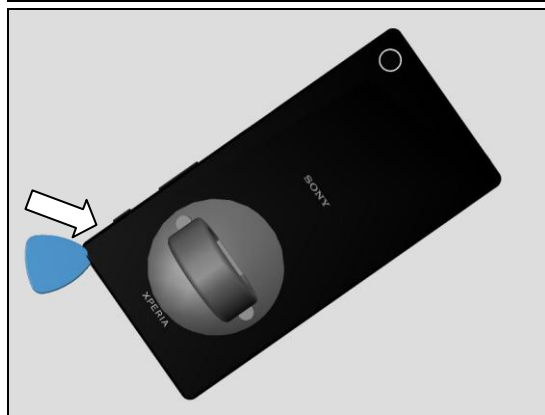


3.2 Panel Rear

Put the suction cup on the Panel Rear and pull up.



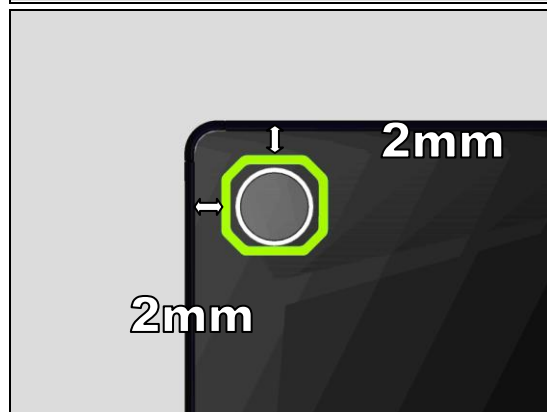
Insert the Guitar Pick.



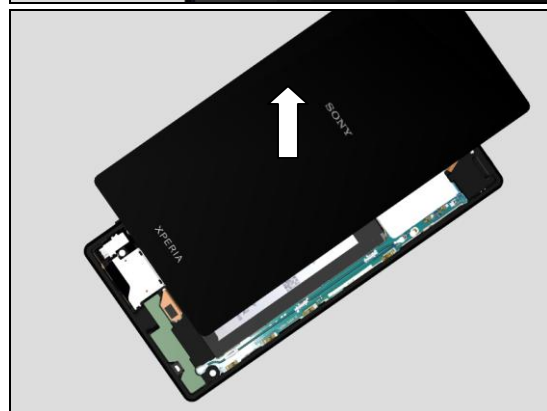
Gently slide the Guitar Pick along the rim.



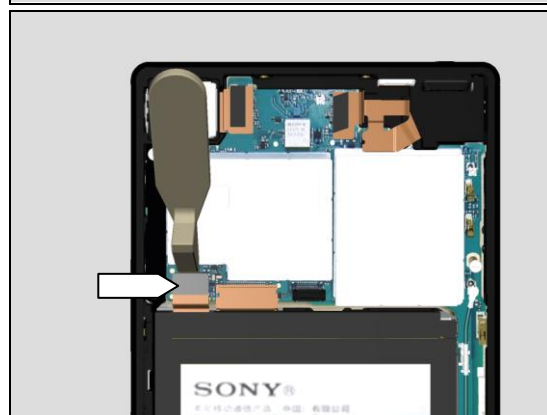
Pay special attention at the upper side not to damage the Cushion Main Camera. Do not insert the Guitar Pick more than 2mm.



Remove the Panel Rear.

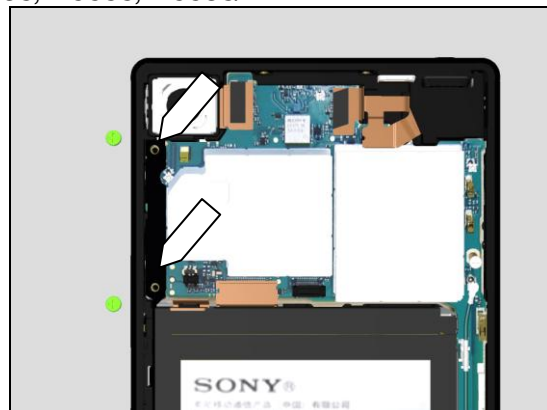


Disconnect the Battery Embedded connector right after disassembling the Panel Rear.

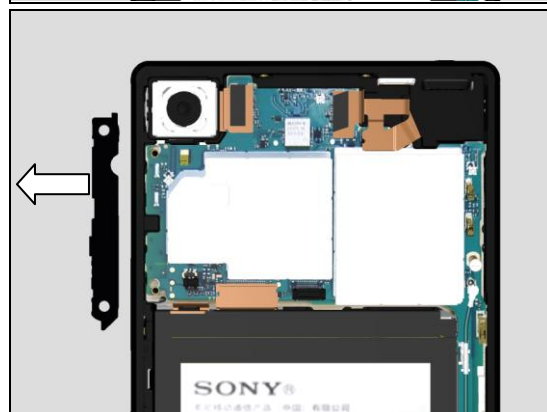


3.3 Holder PBA

Remove the two screws on the Holder PBA.

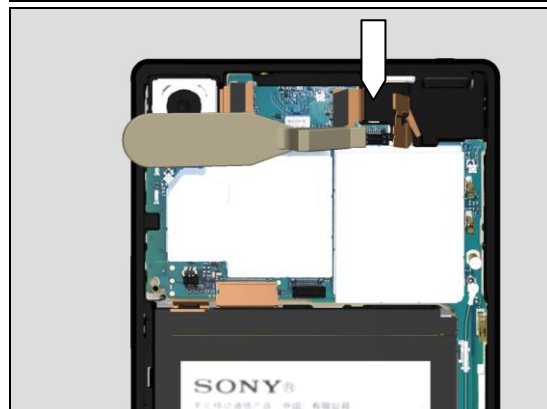


Remove the Holder PBA.

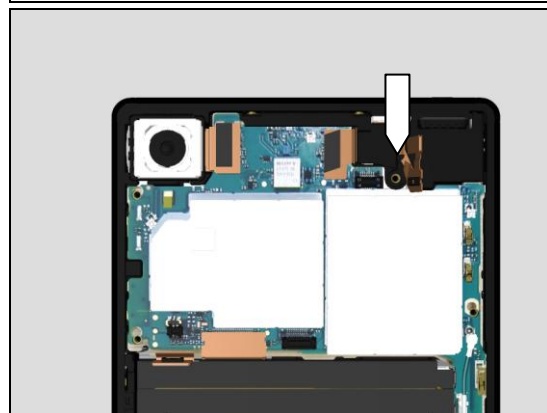


3.4 Antenna Cell Sub

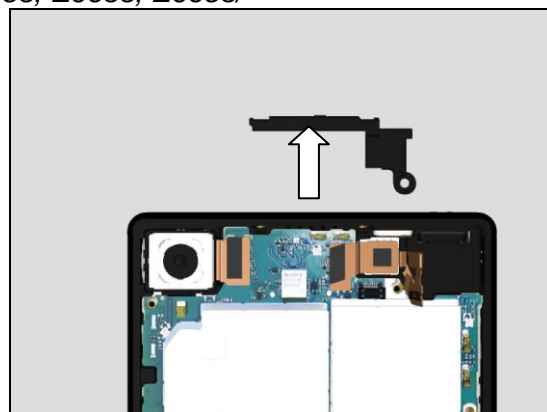
Disconnect the FPC Top connector.



Remove the screw on the Antenna Cell Sub.

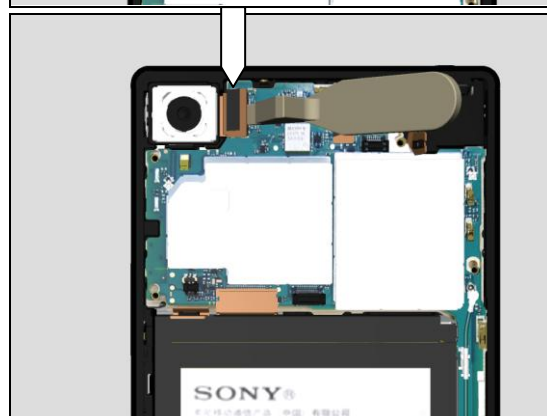


Remove the Antenna Cell Sub

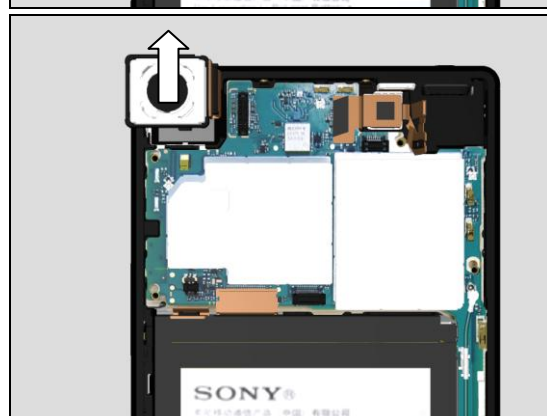


3.5 Camera Main

Disconnect the Camera Main Connector.

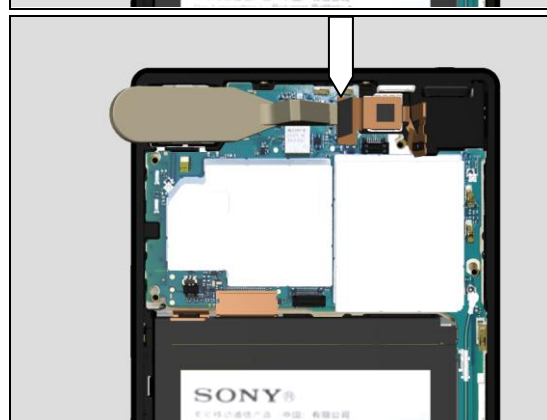


Remove the Camera Main.



3.6 Camera Sub

Disconnect the Camera Sub Connector.

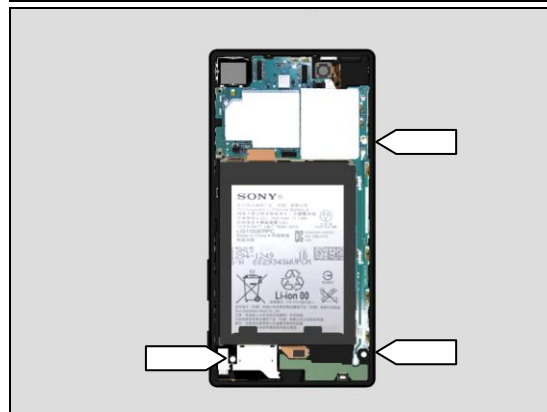


Remove the Camera Sub.



3.7 Man PBA

Remove the remaining screws on the Main PBA.



E6633, E6683 have one less screw on the PBA.



Disconnect the FPC Key connector.

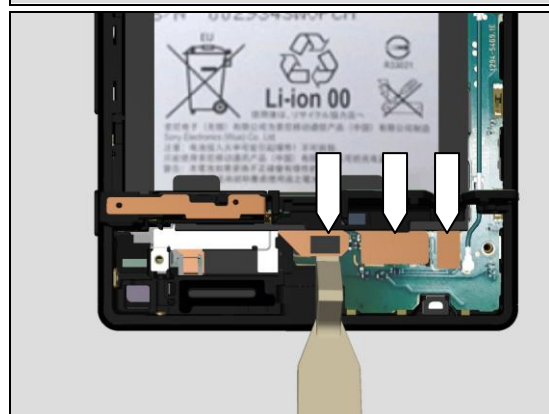


Gently open the Antenna Cell Main with the Top FPC up to the right angle.

Note! Do not break the FPC Key!



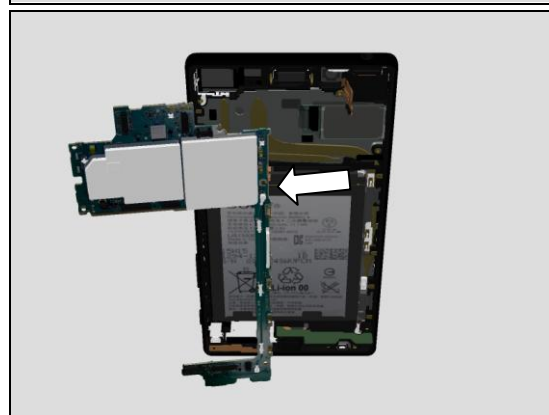
Disconnect three connectors at the bottom.



Pull up the left side of the Main PBA.

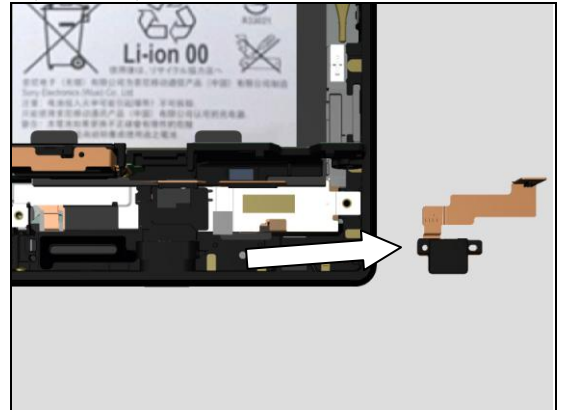


Remove the Main PBA.



3.8 FPC 1st Mic

Remove the FPC 1st Mic.

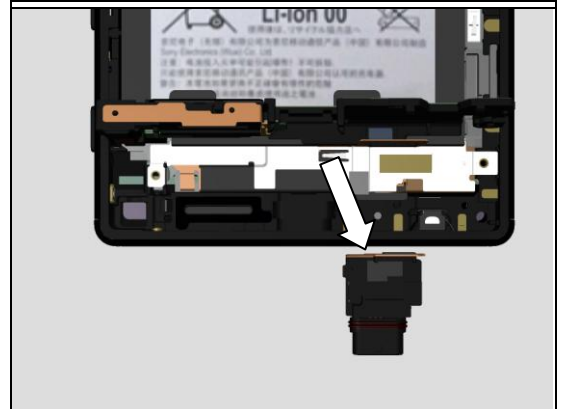


3.9 FPC USB

Slide upwards the FPC USB.

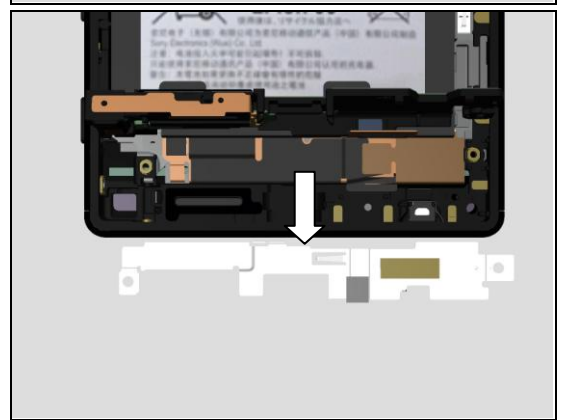


Remove the FPC USB.



3.10 Shield FPC LCD

Remove the Shield FPC LCD.

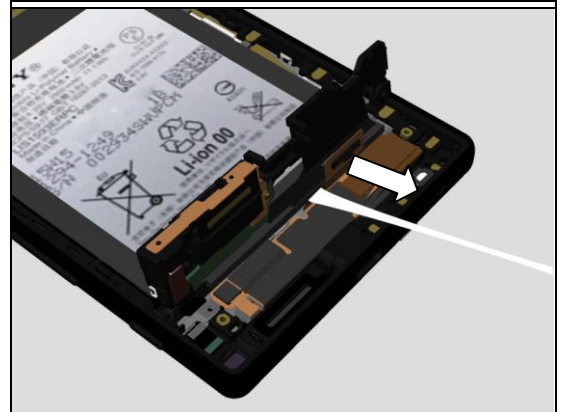
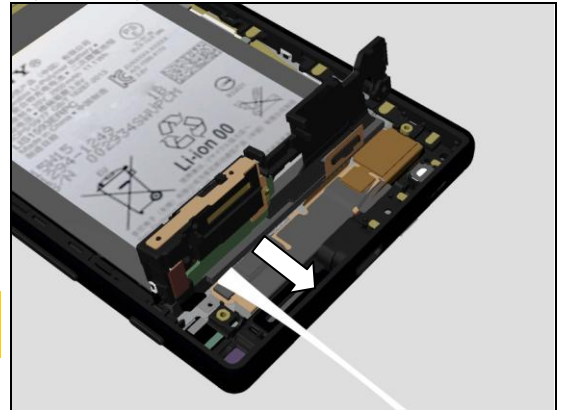


3.11 Adhesive Battery

Pinch the Adhesive Battery tab.
Slowly pull out the Adhesive Battery to planar direction.

Do not twist the tab. Do not make the adhesive touch any of other components.

Remaining tab as well.



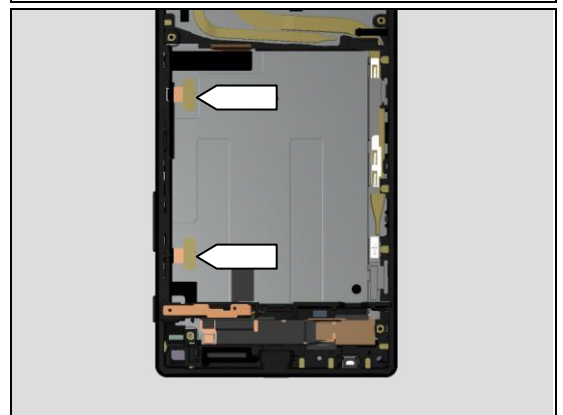
3.12 Battery Embedded

Remove the Battery Embedded.

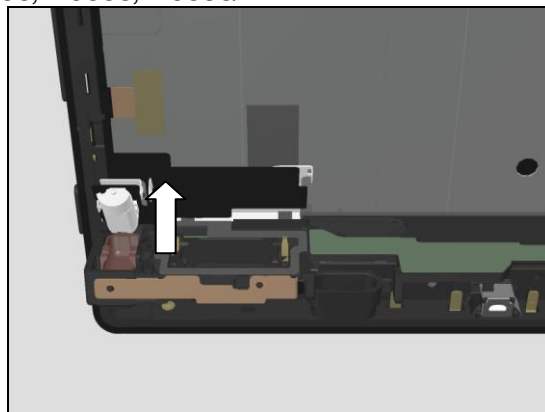


3.13 FPC Key

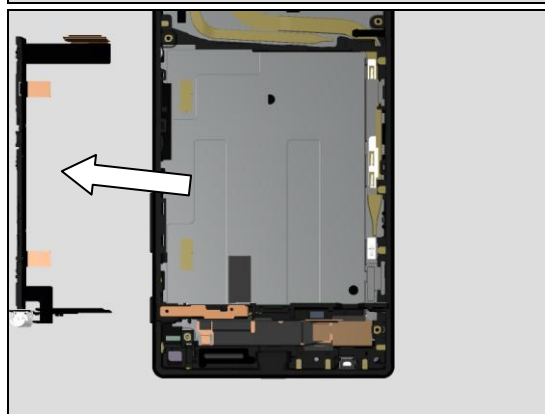
Remove the Sheet Conductive FPC Relay.



Remove the Plate Speaker and FPC area on the Speaker.

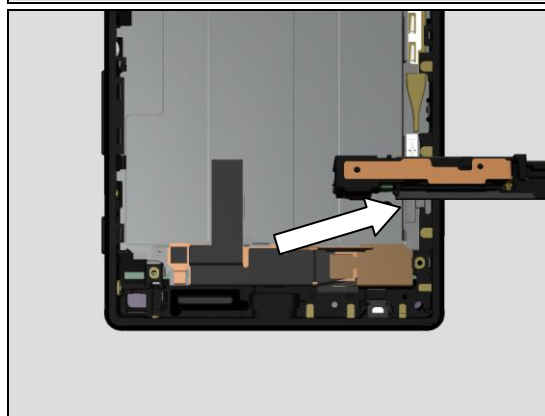


Remove the FPC Key.



3.14 Antenna Cell Main

Remove the Antenna Cell Main.



4 Replacement

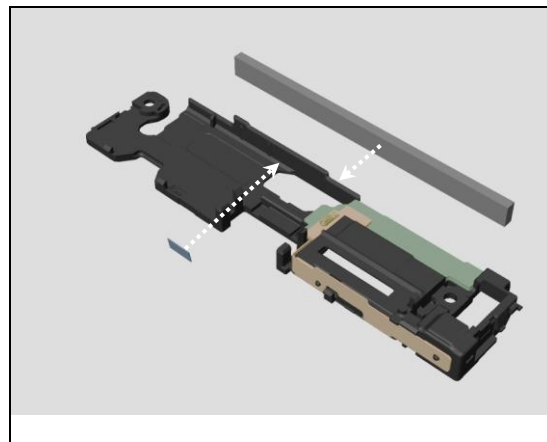
4.1 Antenna Cell Main & Sheet Holder Speaker & Cushion Battery Bottom

Follow the 3.1 – 3.14 Disassembly instructions!

Prepare the new Antenna Cell Main & Sheet Holder Speaker & Cushion Battery Bottom.

Follow the 5.5, 13 – 30 Reassembly instructions!

Scrap! Sheet Holder Speaker & Cushion Battery Bottom cannot be reused!



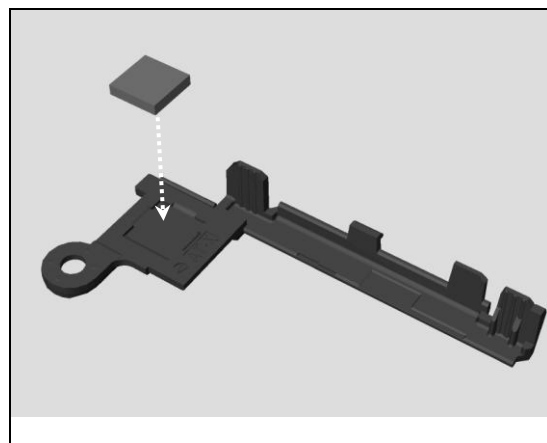
4.2 Antenna Cell Sub & Gasket Conductive Sub Camera

Follow the 3.1 – 3.2, 3.4 Disassembly instructions!

Prepare the new Antenna Cell Sub and Gasket Conductive Sub Camera.

Follow the 5.16, 29 - 30 Reassembly instructions!

Scrap! Gasket Conductive Sub Camera cannot be reused!



4.3 Antenna WiFi Sub

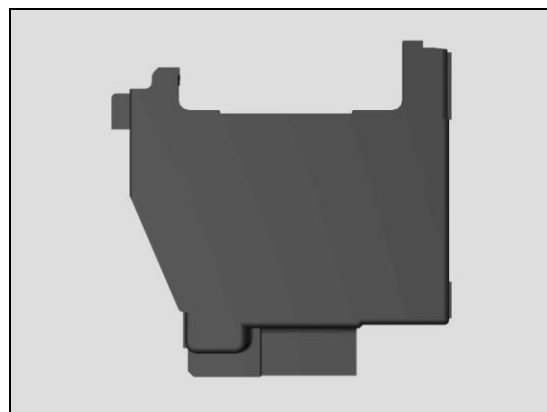
Follow the 3.1 – 3.7 Disassembly instructions!

Prepare the new Antenna WiFi Sub.

Follow the Removal instructions!

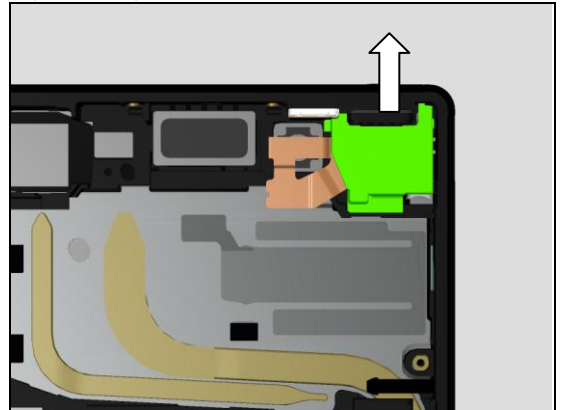
Follow the Installation instructions!

Follow the 5.13 – 16, 23, 29 -30 Reassembly instructions!



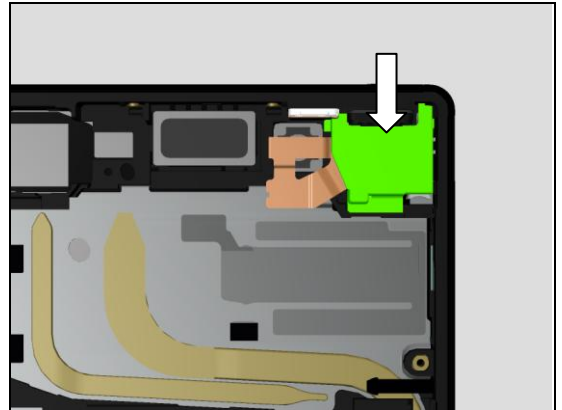
REMOVAL

Remove the Antenna WiFi Sub.



INSTALLATION

Place the new Antenna WiFi Sub on the FPC Top.



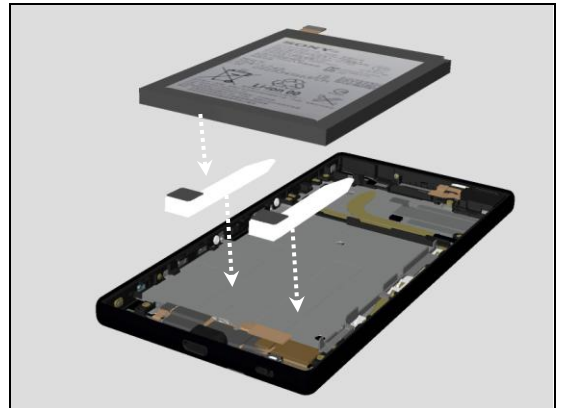
4.4 Battery Embedded & Adhesive Battery

Follow the 3.1 – 3.7, 11-12 Disassembly instructions!

Prepare the new Battery Embedded & Adhesive Battery.

Follow the 5.13 – 16, 23, 25 – 26, 29 - 30 Reassembly instructions!

Scrap! Adhesive Battery cannot be reused!



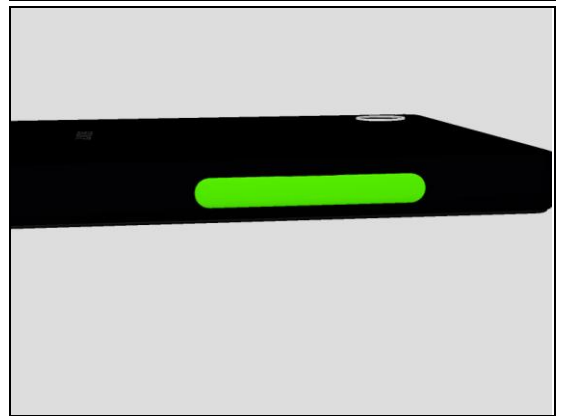
4.5 Cap

Prepare the new Cap.

Remove the Cap.

Insert the new Cap in the cavity.

Scrap! Caps cannot be reused!



4.6 Cushion Main Camera

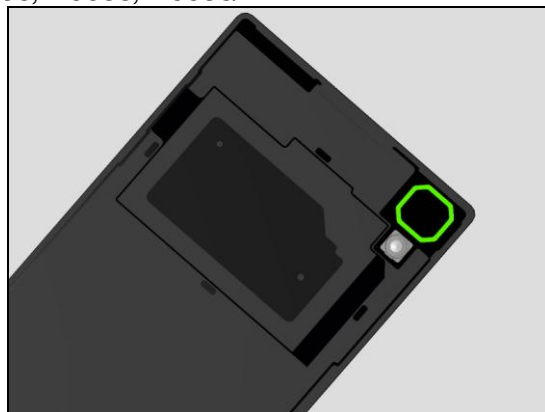
Follow the 3.1 - 2 Disassembly instructions!

Prepare the new Cushion Main Camera.

Remove the old Cushion Main Camera.

Follow the 5.29 - 30 Reassembly instructions!

Scrap! Cushion Main Camera cannot be reused!



4.7 Antenna NFC

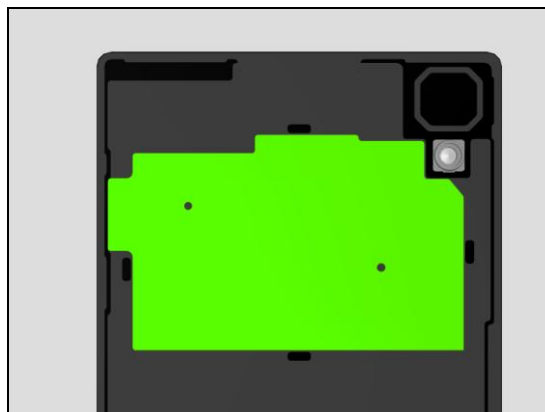
Follow the 3.1 - 2 Disassembly instructions!

Prepare the new Antenna NFC.

Remove the old Antenna NFC.

Follow the 5.29 - 30 Reassembly instructions!

Scrap! Antenna NFC cannot be reused!



4.8 Camera Main & Holder Main Camera & Cushion BtoB A

Follow the 3.1 - 2, 5 Disassembly instructions!

Prepare the new Camera Main & Holder Main Camera & Cushion BtoB A.

Follow the 5.23, 27, 29 - 30 Reassembly instructions!

Scrap! Cushion BtoB A cannot be reused!



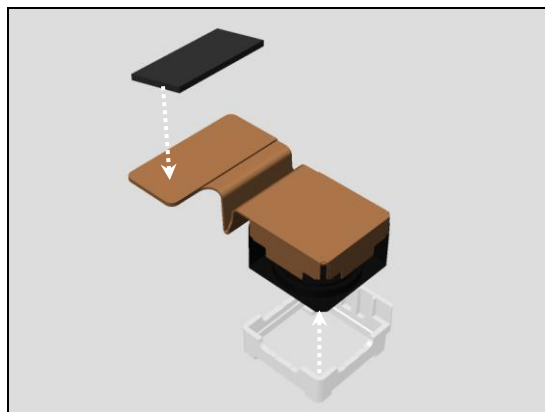
4.9 Camera Sub & Holder Sub Camera & Cushion BtoB B

Follow the 3.1 - 2, 4, 6 Disassembly instructions!

Prepare the new Camera Sub & Holder Sub Camera & Cushion BtoB B.

Follow the 5.15 - 16, 27, 29 - 30 Reassembly instructions!

Scrap! Cushion BtoB B cannot be reused!



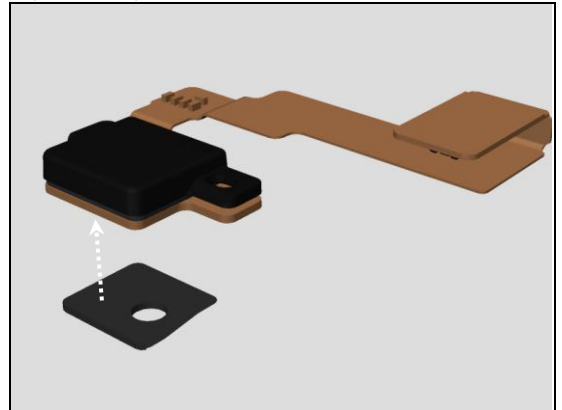
4.10 FPC 1st Mic & Adhesive FPC 1st Mic

Follow the 3.1 – 8 Disassembly instructions!

Prepare the FPC 1st Mic.

Follow the 5.9, 13 – 16, 23, 29 - 30 Reassembly instructions!

Scrap! Adhesive FPC 1st Mic cannot be reused!



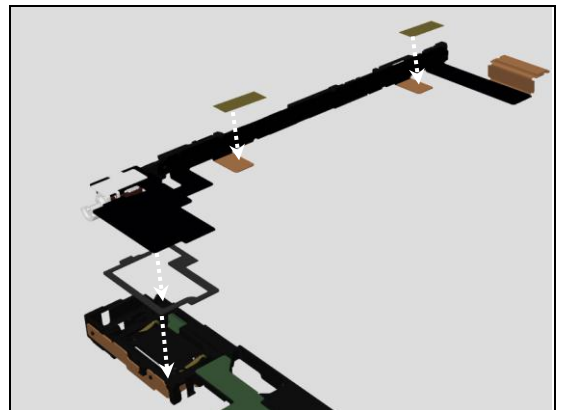
4.11 FPC Key & Adhesive FPC Speaker & Plate Speaker & Sheet Conductive FPC Relay

Follow the 3.1 – 13 Disassembly instructions!

Prepare the new FPC Key & Adhesive FPC Speaker & Plate Speaker & Sheet Conductive FPC Relay.

Follow the 5.8 - 9, 13 – 17, 19 - 23, 26, 29 - 30 Reassembly instructions!

Scrap! Adhesive FPC Speaker & Plate Speaker & Sheet Conductive FPC Relay cannot be reused!



4.12 FPC Top & Adhesive Audio Jack & Adhesive Holder 2nd Mic & Cushion Shade Audio Jack & Holder 2nd Mic & Sheet Holder 2nd Mic & Sheet Shade Audio Jack 2

Follow the 3.1 – 7 Disassembly instructions!

Prepare new parts of above items.

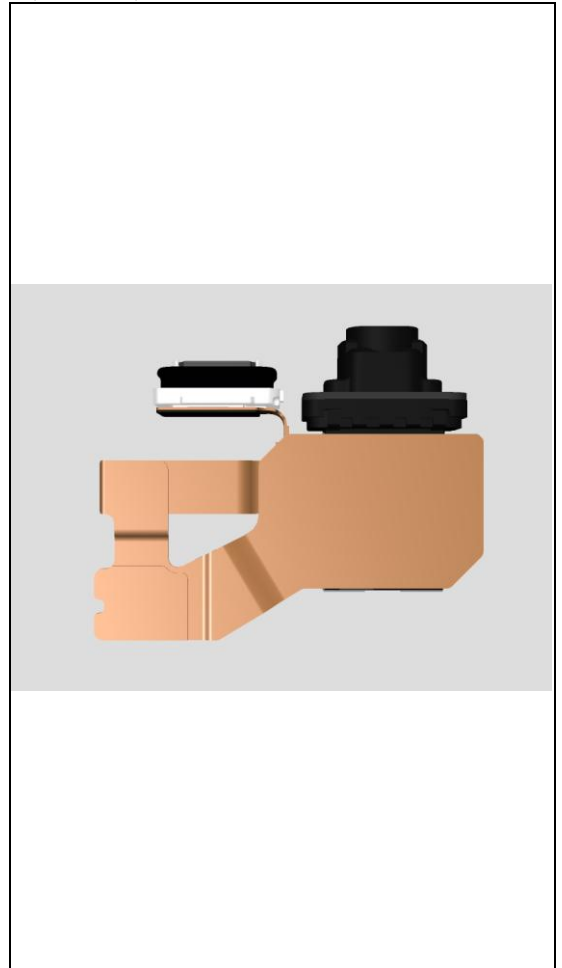
Follow the Removal instructions!

Follow the Installation instructions!

Follow the 5.13 – 16, 23, 29 -30 Reassembly instructions!

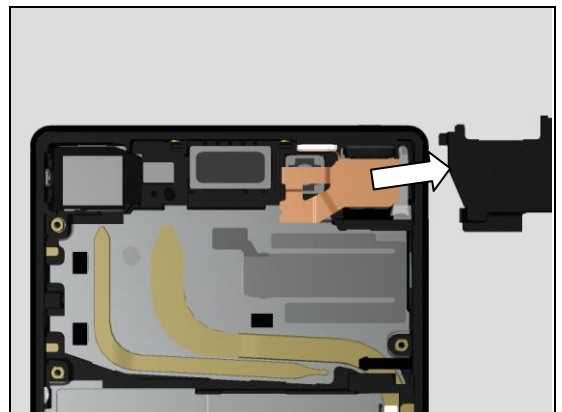
**Scrap! Adhesive Audio Jack & Adhesive Holder 2nd Mic
& Cushion Shade Audio Jack & Sheet Holder 2nd Mic &
Sheet Shade Audio Jack 2 cannot be reused!**

**Important! Noise Cancelling flashing must be performed
after replacing the FPC Top; 1289-2983 Trouble
Shooting Application – mechanical.**

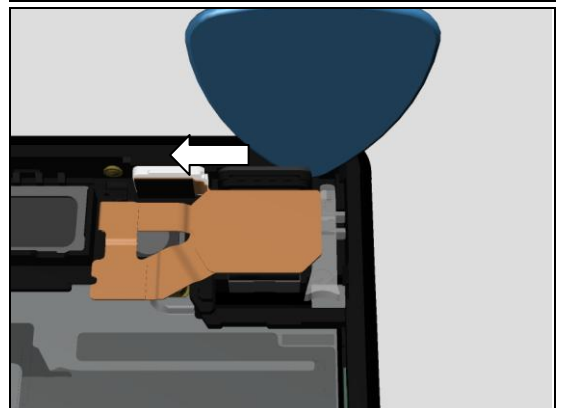


REMOVAL

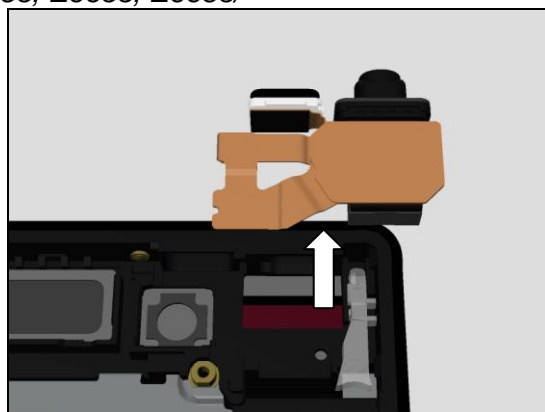
Remove the Antenna WiFi Sub.



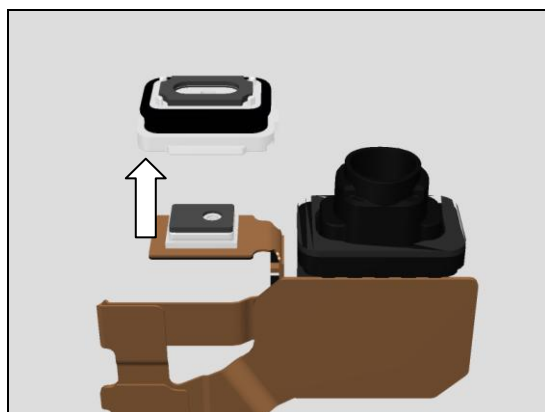
Insert and slide the Guitar Pick between the Audio Jack and the Front Assy frame.



Remove the FPC Top.



Remove the Holder 2nd Mic.

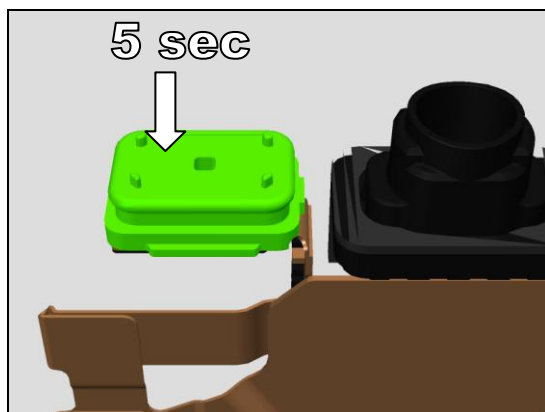


INSTALLATION

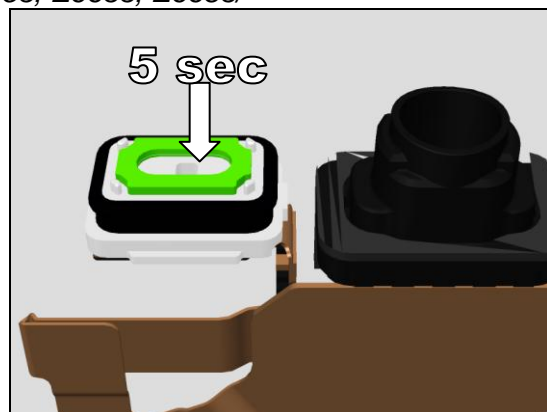
Attach the Adhesive Holder 2nd Mic.



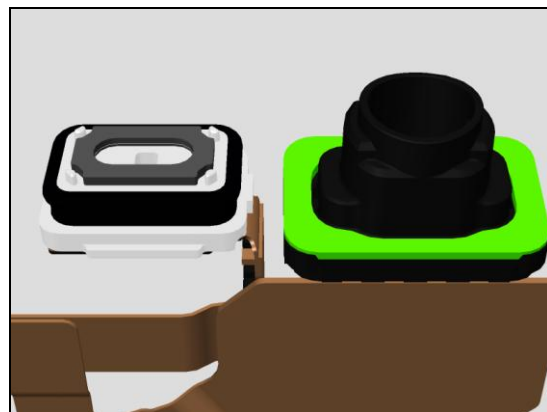
Attach the Holder 2nd Mic.
Press with a finger for 5 sec.



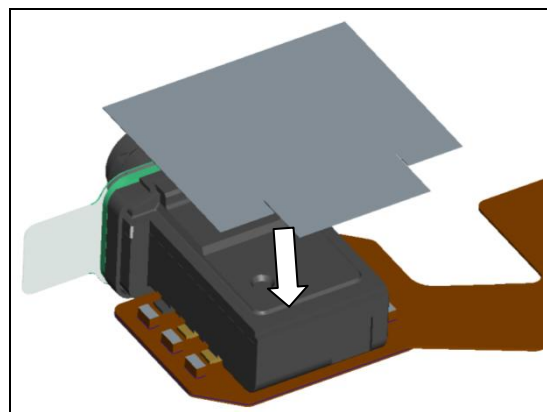
Attach the Sheet Holder 2nd Mic.
Gently press with a finger for 5 sec.
Inspect the sheet condition.



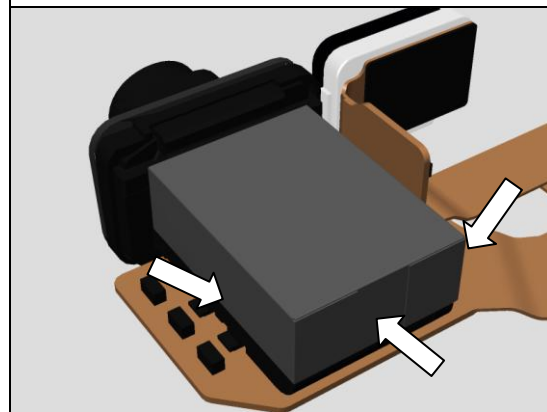
Attach the Adhesive Audio Jack.



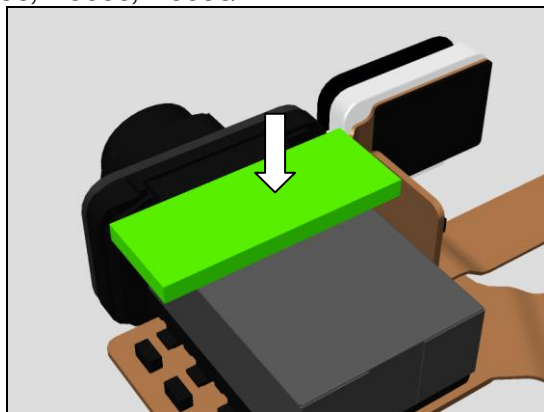
Attach the Sheet Shade Audio Jack 2.



Fold the Sheet Shade Audio Jack 2 along the surface.



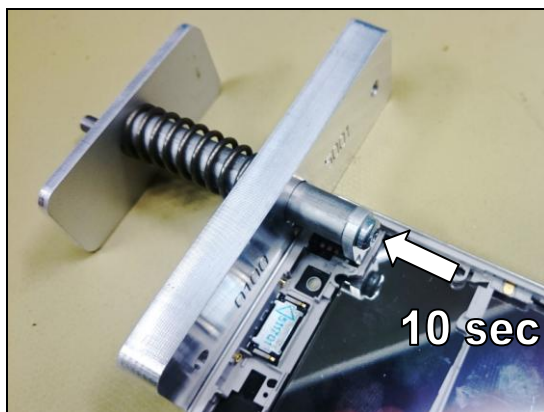
Attach the Cushion Shade Audio Jack.



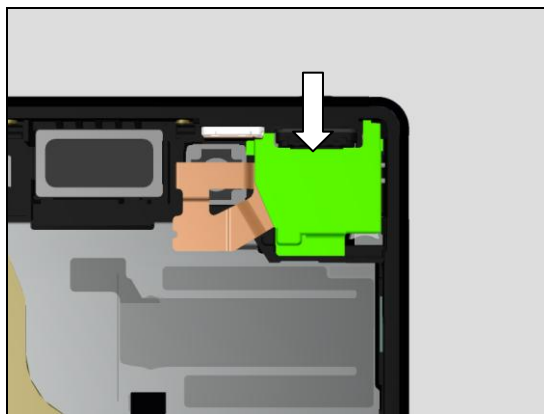
Insert the FPC Top in the cavity.



Press with FPC Jack Module Press for 10 sec.



Place the Antenna WiFi Sub.



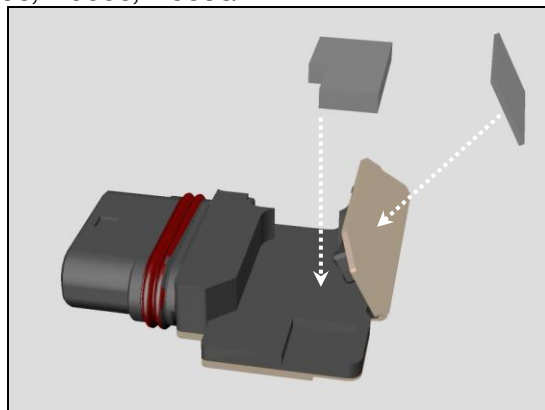
4.13 FPC USB & Cushion BtoB C & Sheet Spacer USB

Follow the 3.1 – 7, 9 Disassembly instructions!

Prepare the new FPC USB & Cushion BtoB C & Sheet Spacer USB.

Follow the 5.8, 13 – 16, 23, 27, 29 - 30 Reassembly instructions!

Scrap! Cushion BtoB C & Sheet Spacer USB cannot be reused!



4.14 Front Assy

Follow the 3.1 – 14 Disassembly instructions!

Prepare the new Front Assy

Follow the 5.1 – 9, 13 – 23, 25 – 26, 29 – 30 Reassembly instructions!

Note! Thermal Gap Filler must be re-applied!



4.15 Gasket Conductive Relay-U

Follow the 3.1 – 14 Disassembly instructions!

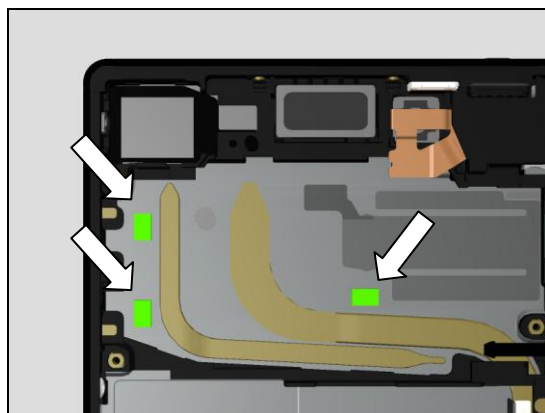
Prepare the new Gasket Conductive Relay-U.

Remove the old Gasket Conductive Relay-U.

Attach the new Gasket Conductive Relay-U.

Follow the 5.5, 8 – 9, 13 – 16, 23, 29 – 30 Reassembly instructions!

Scrap! Gasket Conductive Relay-U cannot be reused!



4.16 Gasket Speaker Bottom

Follow the 3.1 – 2 Disassembly instructions!

Prepare the new Gasket Speaker Bottom.

Follow the Removal instructions!

Follow the 5.3, 29 – 30 Reassembly instructions!

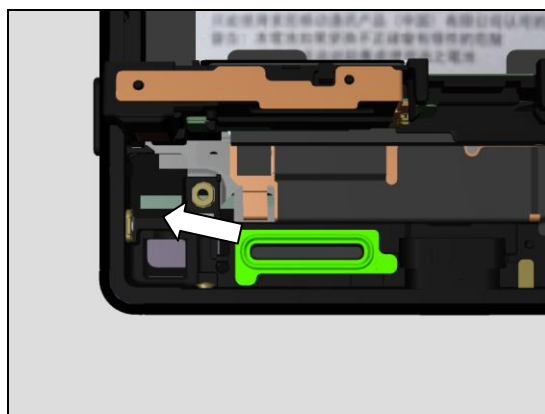
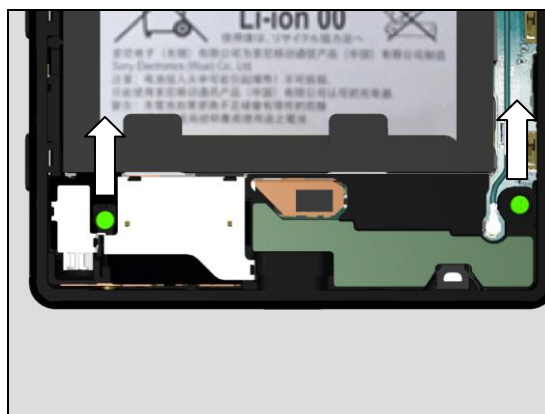
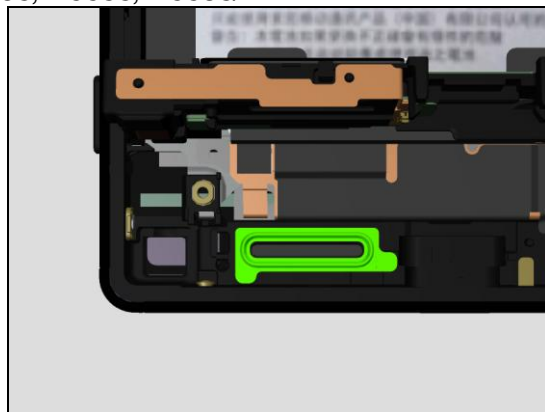
Scrap! Gasket Speaker Bottom cannot be reused!

REMOVAL

Remove the two screws on the Antenna Cell Main.

Turn up the Antenna Cell Main.

Remove the old Gasket Speaker Bottom.



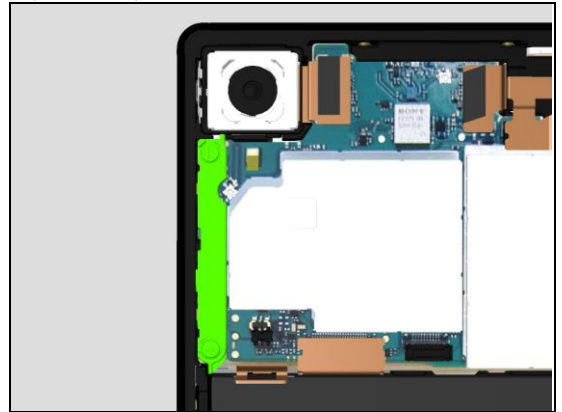
4.17 Holder PBA

Follow the 3.1 – 2 Disassembly instructions!

Prepare the new Holder PBA.

Remove the two screws and the holder PBA.

Follow the 5.14, 29 – 30 Reassembly instructions!

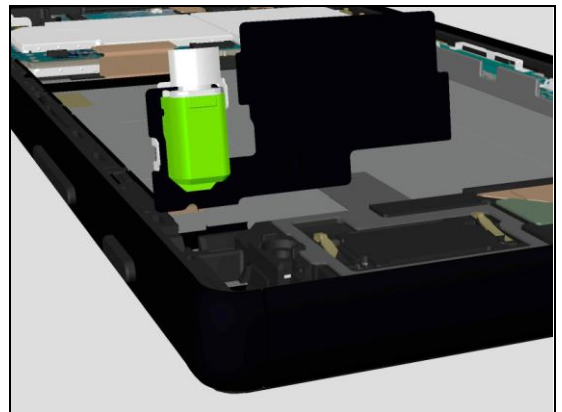


4.18 Holder Vib

Follow the 3.1 – 13 Disassembly instructions!

Prepare the new Holder Vib.

Follow the 5.8 - 9, 13 – 17, 19 - 23, 26, 29 - 30 Reassembly instructions!

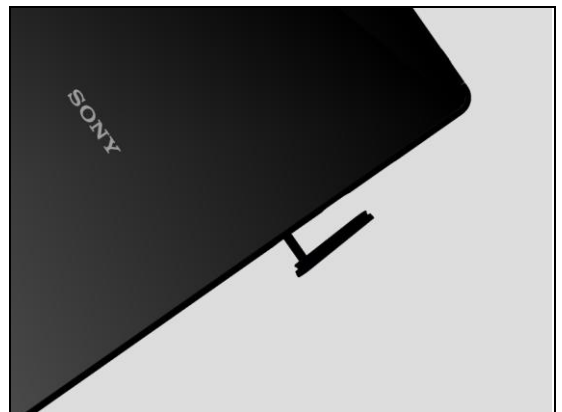


4.19 Label MoP

Prepare the new Label MoP printed.

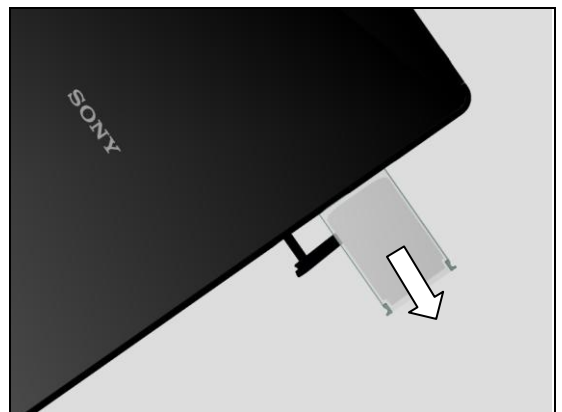
Open the Cap.

Scrap! Label MoP cannot be reused!



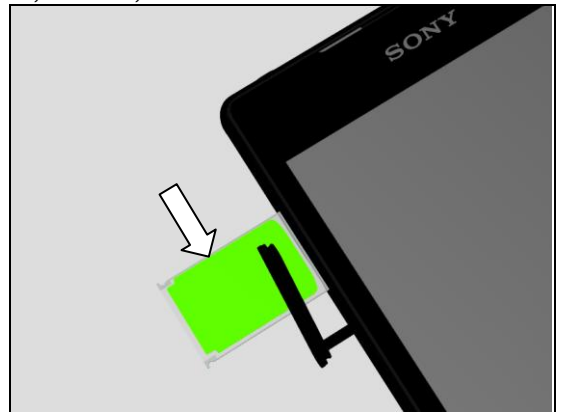
Pull out the Sheet Slider MoP.

Remove the old Label MoP



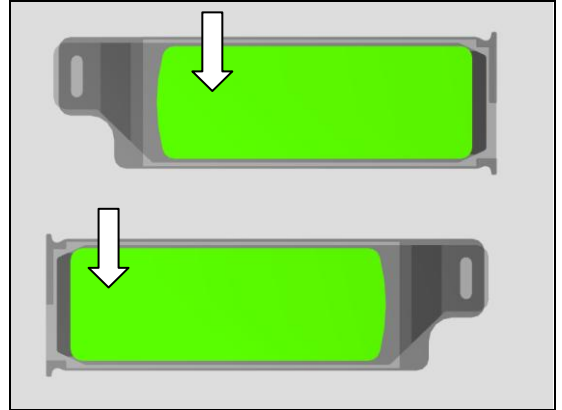
(For E6603, E6653)

Attach the new Label MoP.

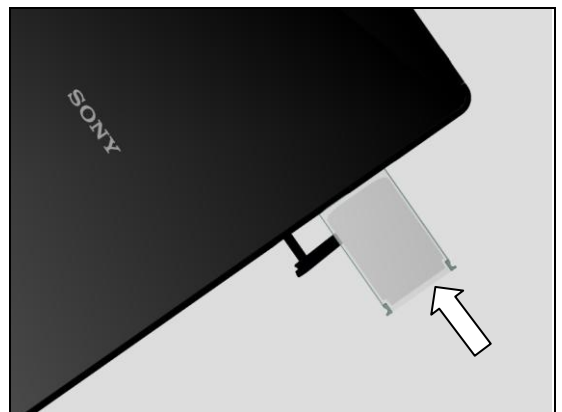


(For E6633, E6683)

Attach the new Label MoP.



Insert the Sheet Slider MoP.



Close the Cap.



4.20 Light Guide 3LED / Light Guide 3LED Transparent

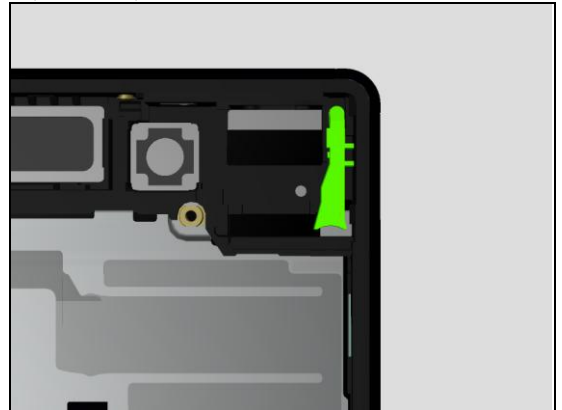
Follow the 3.1 – 7 Disassembly instructions!

Prepare the new Light Guide 3LED.

Remove the old Light Guide 3LED.

Follow the 4.12 Installation instructions!

Follow the 5.13 – 16, 23, 29 -30 Reassembly instructions!



4.21 Loudspeaker & Adhesive Ear Speaker & Cushion ACO

Follow the 3.1 – 7 Disassembly instructions!

Prepare the new Loudspeaker & Adhesive Ear Speaker & Cushion ACO.

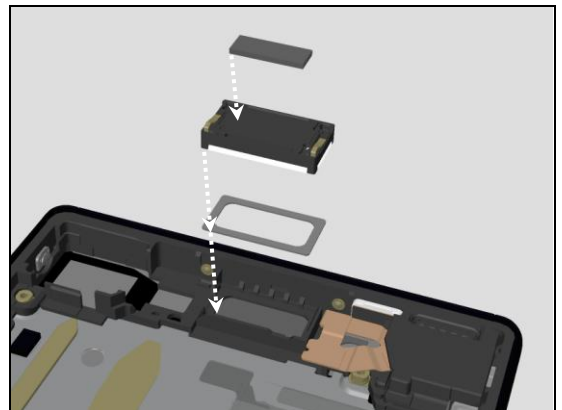
Follow the Removal instructions!

Follow the Installation instructions!

Follow the 5.6, 13 – 16, 23, 29 -30 Reassembly instructions!

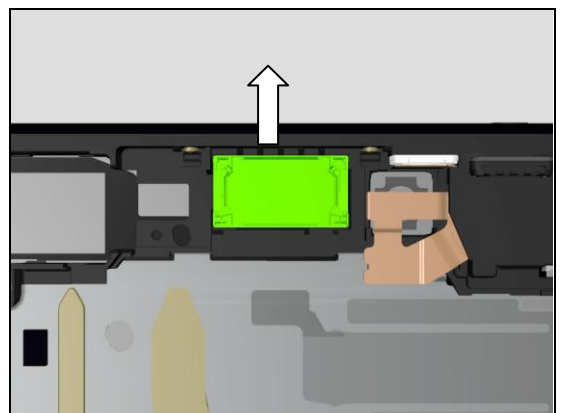
Scrap! Loudspeaker & Adhesive Ear Speaker & Cushion ACO cannot be reused!

Important! After replacing the Loudspeaker, flash the phone by Customize or Refurbish or SUCE (not SU) in EMMA.



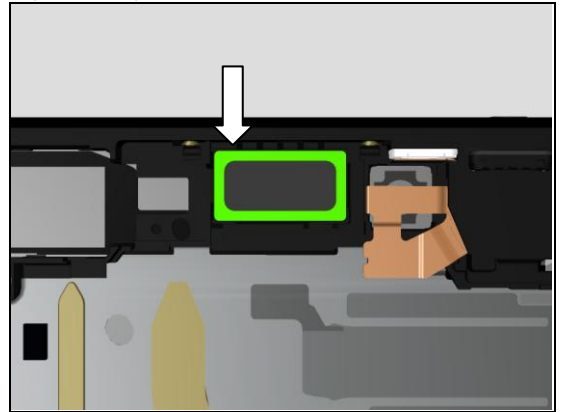
REMOVAL

Remove the old Loudspeaker.



INSTALLATION

Attach the new Adhesive Ear Speaker.



4.22 Panel Rear

Follow the 3.1 - 2 Disassembly instructions!

Prepare the new Panel Rear.

Follow the 5.28, 30 Reassembly instructions!



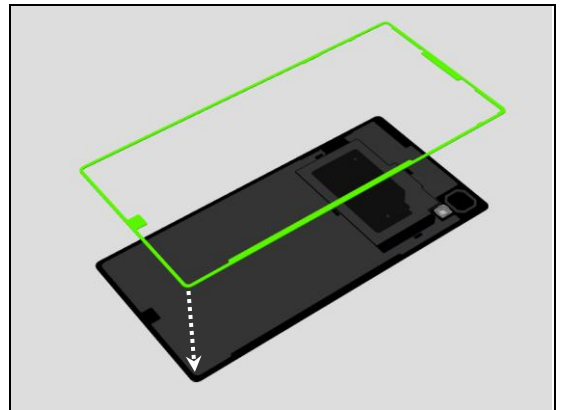
4.23 Adhesive Panel Rear

Follow the 3.1- 2 Disassembly instructions!

Prepare the new Adhesive Panel Rear.

Follow the 5.29 -30 Reassembly instructions!

Scrap! Adhesive Panel Rear cannot be reused!



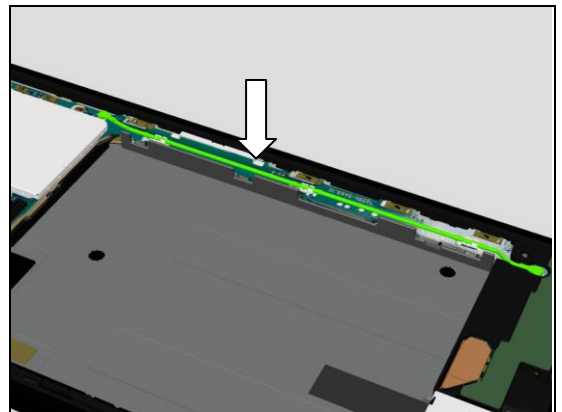
4.24 RF Coax Cable

Follow the 3.1- 2 Disassembly instructions!

Prepare the new RF Coax Cable.

Remove the old RF Coax Cable.

Follow the 5.24, 29 -30 Reassembly instructions!



4.25 Sheet Conductive LCD FPC A

Follow the 3.1- 12 Disassembly instructions!

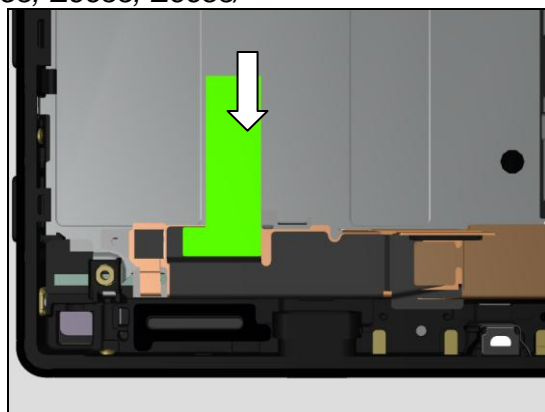
Prepare the new Sheet Conductive LCD FPC A.

Remove the old Sheet Conductive LCD FPC A.

Follow the 5.4 – 5, 8 – 9, 13 – 16, 23, 26, 29 -30

Reassembly instructions!

Scrap! Sheet Conductive LCD FPC A cannot be reused!



4.26 Sheet Guide MoP

Follow the 3.1- 7 Disassembly instructions!

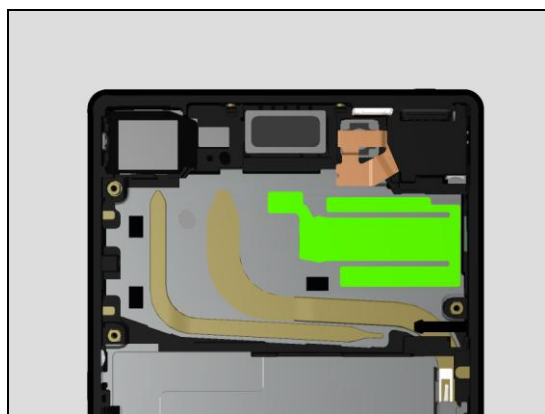
Prepare the new Sheet Guide MoP.

Remove the old Sheet Guide MoP.

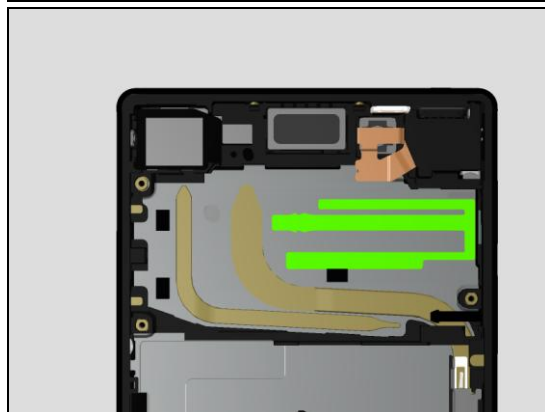
Follow the 5.2, 13 – 16, 23, 29 -30 Reassembly instructions!

Scrap! Sheet Guide MoP cannot be reused!

(For E6603, E6653)



(For E6633, E6683)



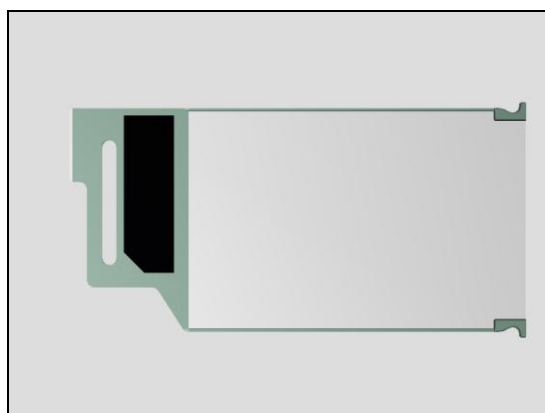
4.27 Sheet Slider MoP

Follow the 3.1- 7 Disassembly instructions!

Prepare the new Sheet Slider MoP.

Follow the Removal instructions!

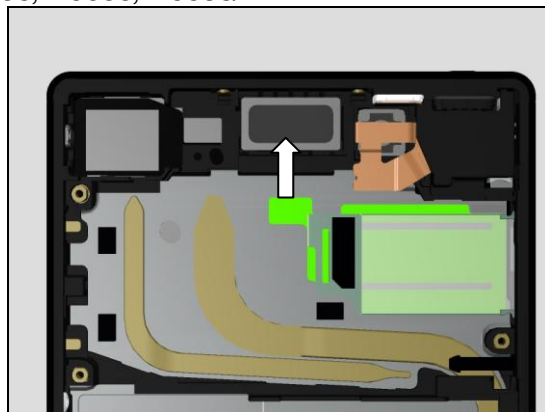
Follow the 5.2, 13 – 16, 23, 29 -30 Reassembly instructions!



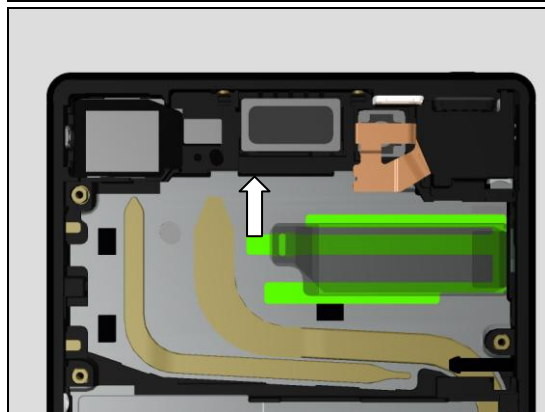
REMOVAL

Peel off the adhesive area of the Sheet Guide MoP.

(For E6603, E6653)

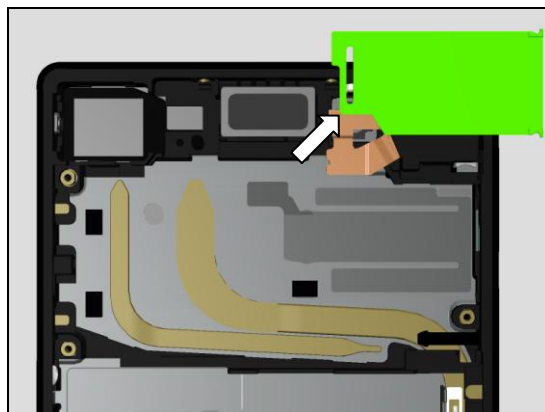


(For E6633, E6683)

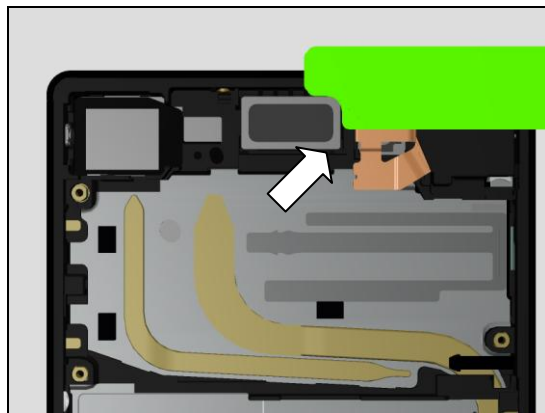


Remove the old Sheet Slider MoP.

(For E6603, E6653)



(For E6633, E6683)



4.28 Sheet WR Test

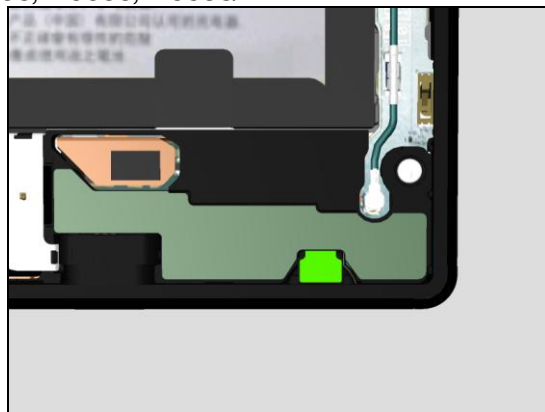
Follow the 3.1- 2 Disassembly instructions!

Prepare the new Sheet WR Test.

Remove the old Sheet WR Test.

Attach the new Sheet WR Test.

Scrap! Sheet WR Test cannot be reused!



4.29 Sheet ZIF LCD.

Follow the 3.1- 10 Disassembly instructions!

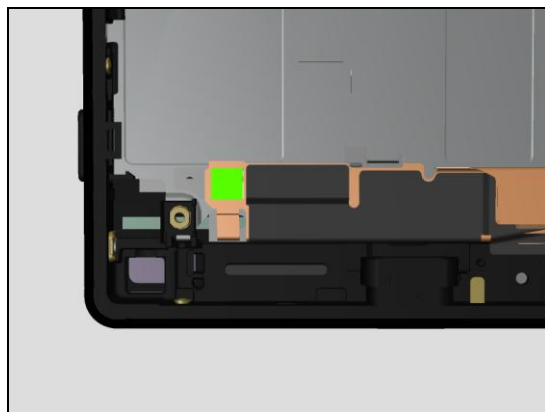
Prepare the new Sheet ZIF LCD.

Remove the old Sheet ZIF LCD.

Attach the new Sheet ZIF LCD.

Follow the 5.5, 8 – 9, 13 – 16, 23, 29 -30 Reassembly instructions!

Scrap! Sheet ZIF LCD cannot be reused!



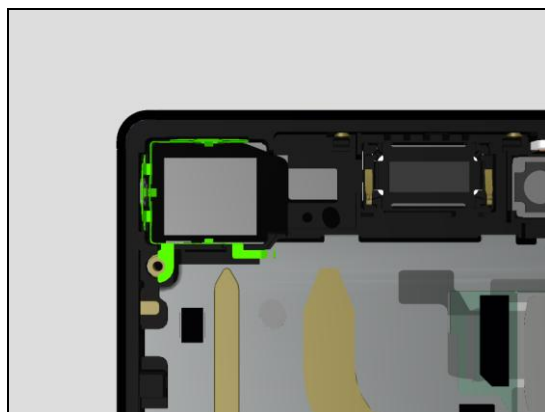
4.30 Shield Camera

Follow the 3.1- 7 Disassembly instructions!

Prepare the new Shield Camera.

Remove the old Shield Camera.

Follow the 5.7, 13 – 16, 23, 29 -30 Reassembly instructions!



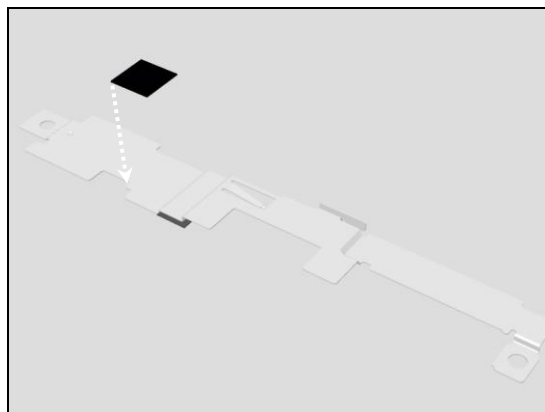
4.31 Shield FPC LCD & Sheet BtoB Touch

Follow the 3.1- 10 Disassembly instructions!

Prepare the new Shield FPC LCD.

Follow the 5.5, 8 – 9, 13 – 16, 23, 29 -30 Reassembly instructions!

Scrap! Sheet BtoB Touch cannot be reused!



4.32 Spacer Panel Right

Follow the 3.1- 10 Disassembly instructions!

Follow the Removal instructions!

Prepare the new Spacer Panel Right.

Follow the Installation instructions!

Follow the 5.5, 7 – 9, 13 – 16, 23, 29 -30 Reassembly instructions!

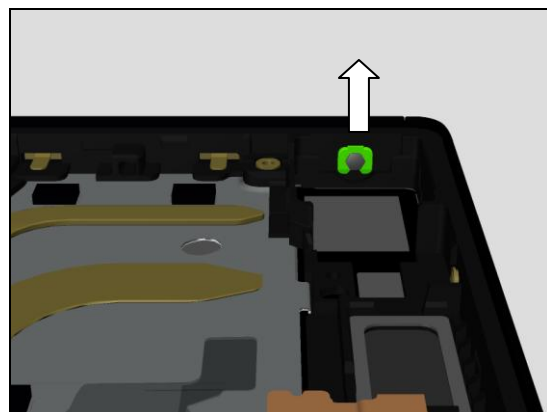
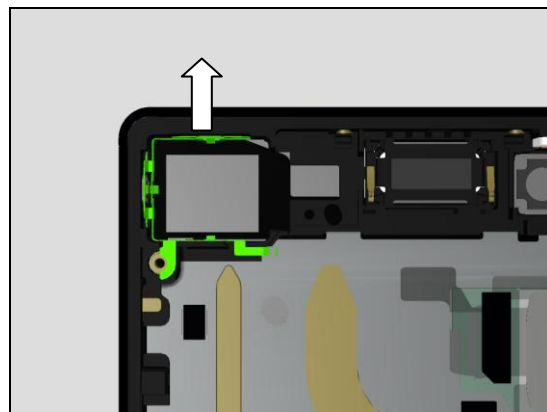
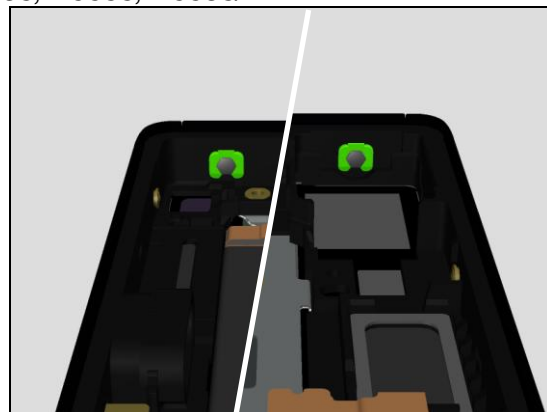
Scrap! Spacer Panel Right cannot be reused!

REMOVAL

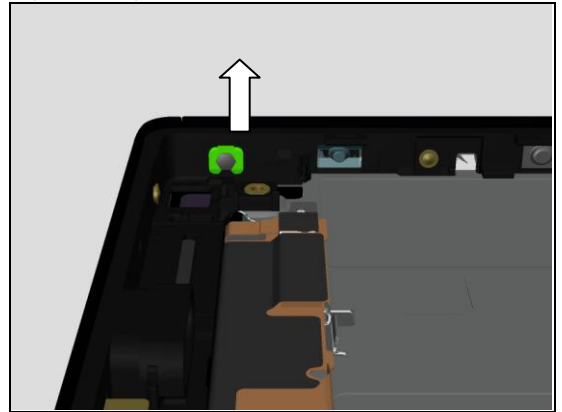
Remove the Shield Camera.

Remove the Spacer Panel Right (Upper).

Turn up the Antenna Cell Main.

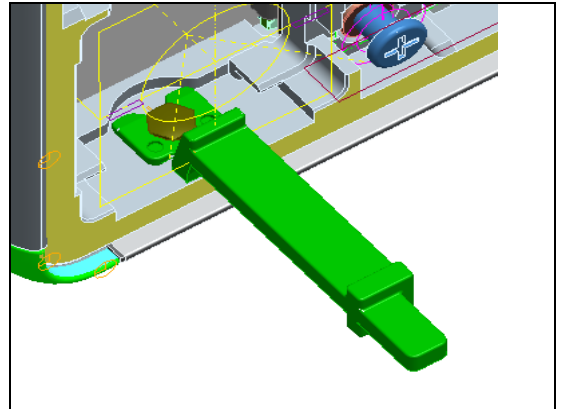


Remove the Spacer Panel Right (Lower).

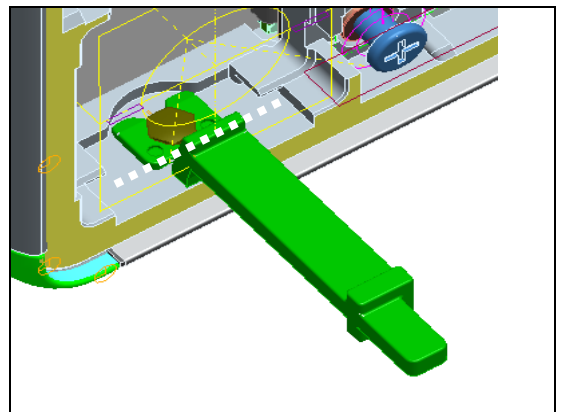


INSTALLATION

Clamp the metal contact with the Spacer Panel Right.



Cut the extra area of the Spacer Panel Right.



4.33 Thermal Gap Filler

Follow the 3.1 – 7 Disassembly instructions!

Prepare the new Thermal Gap Filler Tube & Thermal Gap Filler Syringe.

Remove the Thermal Gap Filler.

Follow the 5.12 – 16, 23, 29 -30 Reassembly instructions!

Scrap! Thermal Gap Filler cannot be reused in case of Front Assy replacement or Main PBA replacement!

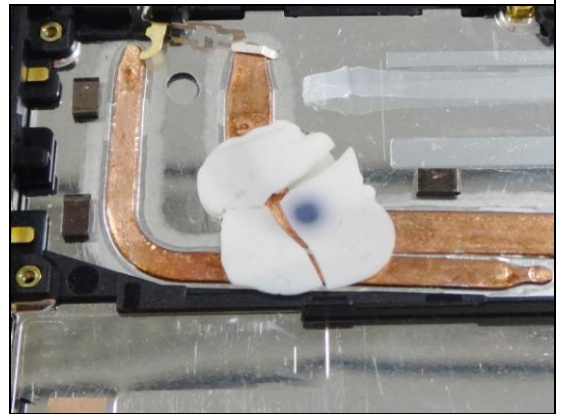


In case of reuse, make sure that Thermal Gap Filler is left on the Front Assy side.

Thermal Gap Filler left on the PBA side cannot be reused!



Broken Thermal Gap Filler cannot be reused!



4.34 Top Speaker & Adhesive Speaker Bottom

Follow the 3.1 – 14 Disassembly instructions!

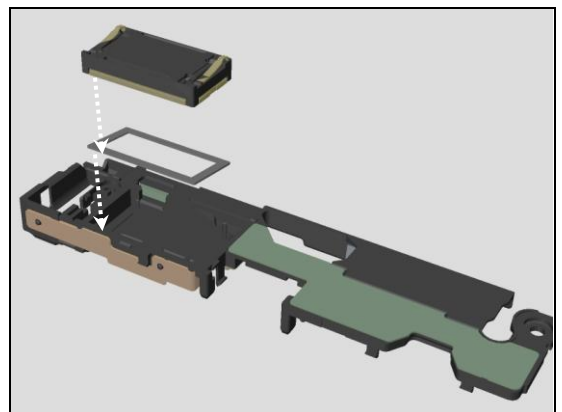
Prepare the new Top Speaker & Adhesive Speaker Bottom.

Follow the 5.8 - 9, 13 – 23, 26, 29 - 30 Reassembly instructions!

Scrap! Top Speaker & Adhesive Speaker Bottom cannot be reused!

Note! Part name comes from the naming in the past model. This part is for lower speaker in this model.

Important! After replacing the Top Speaker, flash the phone by Customize or Refurbish or SUCE (not SU) in EMMA.

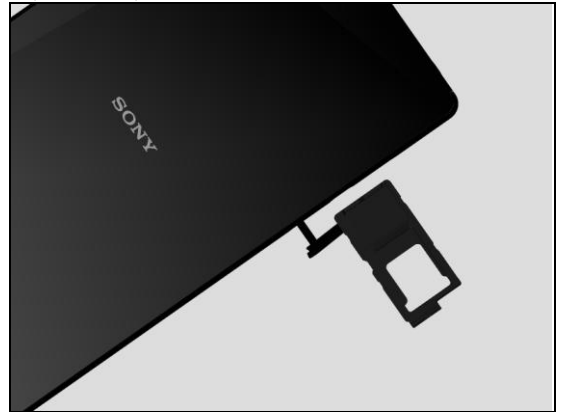


4.35 Tray Combo

Prepare the new Tray Combo.

Open the Cap.

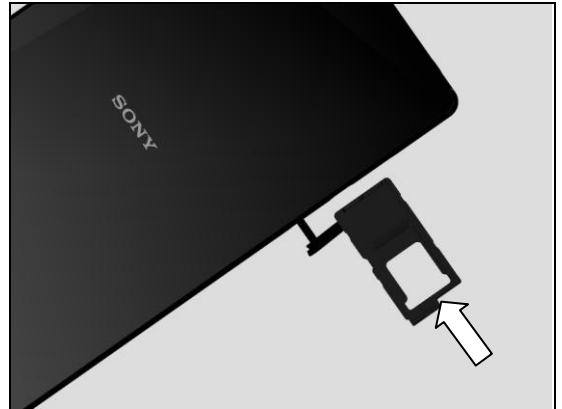
Remove the old Tray Combo.



Insert the new Tray Combo.

Close the Cap

(For E6603, E6653)



(For E6633, E6683)



4.36 Water indicator

Follow the 3.1 – 14 Disassembly instructions!

Prepare the new Water indicator.

Remove the old Water indicator.

Attach the new Water indicator.

Follow the 5.5, 8 – 9, 13 – 16, 23, 29 – 30 Reassembly instructions!

Scrap! Water indicator cannot be reused!

(For E6603, E6653)



(For E6633, E6683)

4.37 Main PBA & Cushion TGF Lower/Upper/D & Sheet Protection MoP Label – Board Swap Replacement

Follow the 3.1 – 7 Disassembly instructions!

Prepare the Exchange PBA & Cushion TGF Lower/Upper/D & Sheet Protection MoP Label.

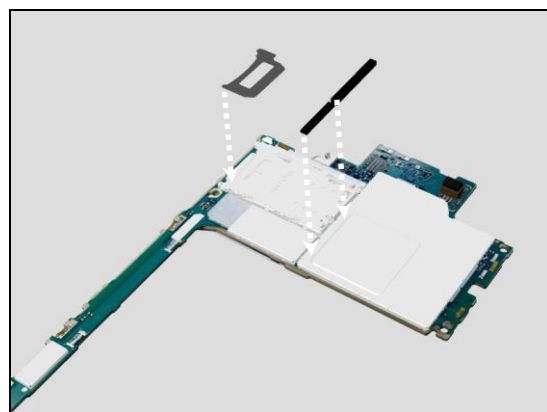
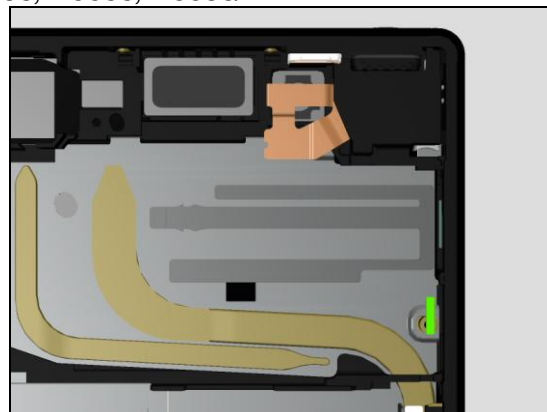
Follow the 5.10 – 16, 23, 29 -30 Reassembly instructions!

Scrap! Cushion TGF Lower/Upper/D & Sheet Protection MoP Label cannot be reused!

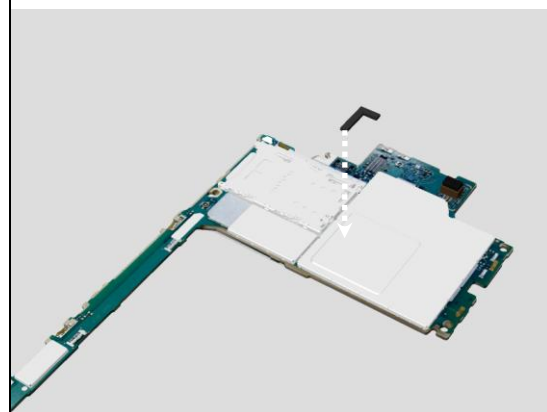
Note! Thermal Gap Filler must be re-applied!

Sheet Protection MoP Label is only for E6603, E6653.

Proximity, Noise Cancelling, Gyroscope and Accelerometer Calibration and Color ID Flashing must be performed for all replaced units; 1289-2983 Trouble Shooting Application – mechanical.



(For E6603, E6653)

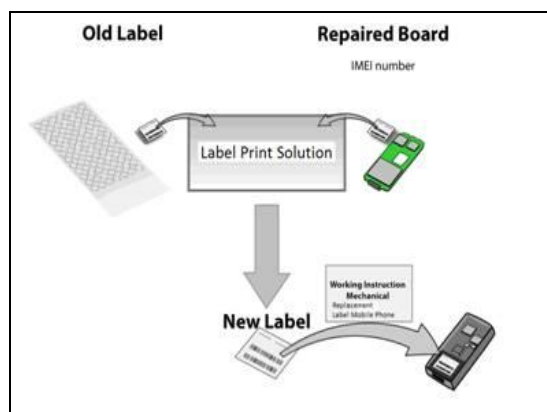


(For E6633, E6683)

4.38 Board Swap – Change Label

CHANGE LABEL

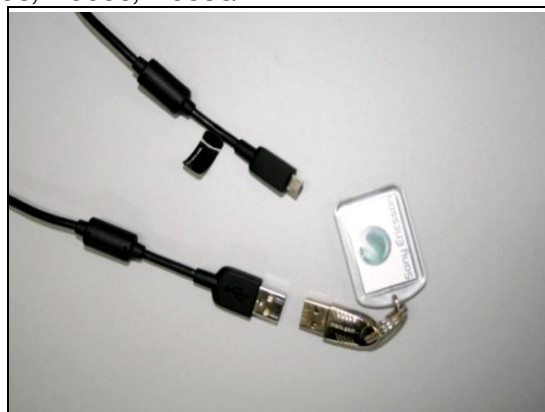
Follow the instructions in the Generic Repair Manual – Build swap for change of label.



4.39 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

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



5 Reassembly

The reassembly is done in the following order:

1. Front Assy
2. Sheet Slider MoP
3. Gasket Speaker Bottom
4. Sheet Conductive LCD FPC A
5. Sheet BtoB Touch & Shield FPC LCD
6. Loudspeaker & Cushion ACO
7. Shield Camera
8. Sheet Spacer USB & FPC USB
9. FPC 1st Mic
10. Sheet Protection MoP Label
11. Sheet TGF Upper & Lower / Sheet TGF D
12. Thermal Gap Filler
13. Main PBA
14. Holder PBA
15. Holder Sub Camera & Camera Sub
16. Gasket Conductive Sub Camera & Antenna Cell Sub
17. FPC Key & Sheet Conductive FPC Relay
18. Sheet Holder Speaker & Adhesive Speaker Bottom & Top Speaker
19. Adhesive FPC Speaker
20. Antenna Cell Main
21. Holder Vib
22. FPC Key 2 & Plate Speaker
23. Camera Main & Holder Main Camera
24. RF Coax Cable
25. Cushion Battery
26. Adhesive Battery & Battery Embedded
27. Cushion BtoB A & B & C
28. Antenna NFC
29. Adhesive Panel Rear
30. Panel Rear

5.1 Front Assy

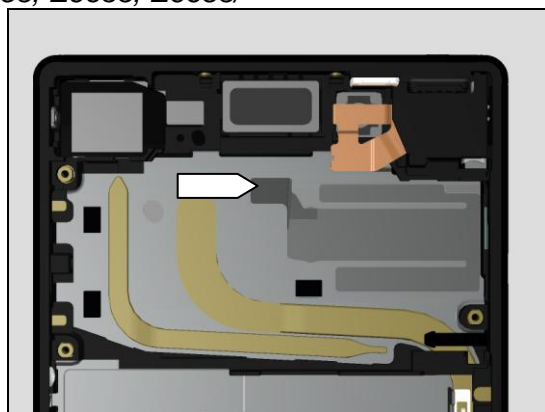
Prepare the new Front Assy.



5.2 Sheet Slider MoP

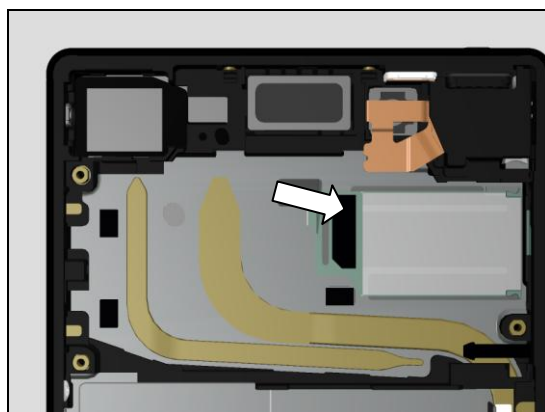
(For E6603, E6653)

Open the adhesive area of the Sheet Guide MoP



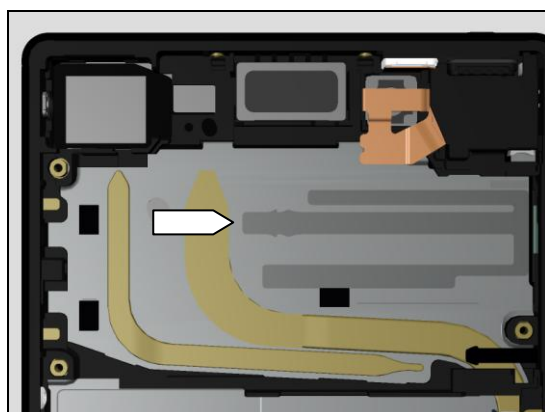
Insert the Sheet Slider MoP.

Close the Sheet Guide MoP.



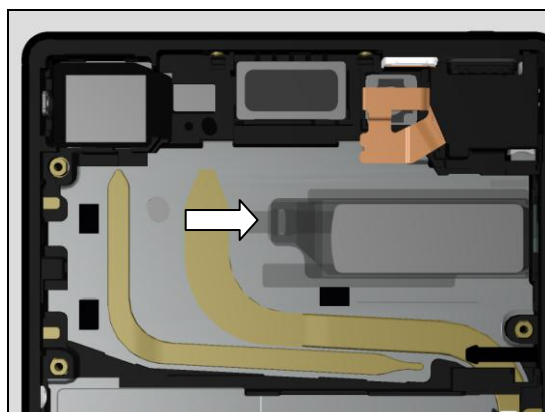
(For E6633, E6683)

Open the adhesive area of the Sheet Guide MoP D.



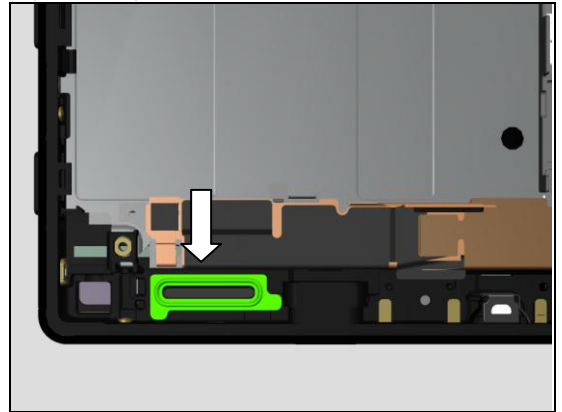
Insert the Sheet Slider MoP.

Close the Sheet Guide MoP D.

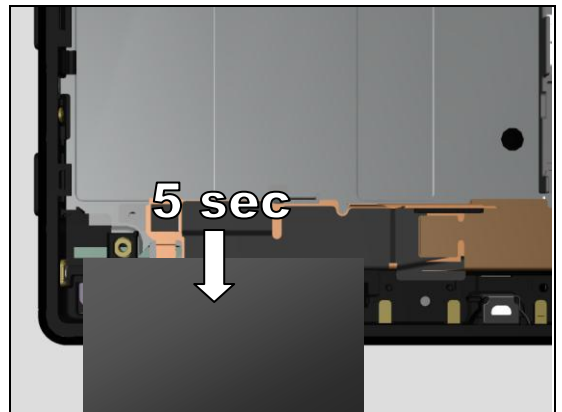


5.3 Gasket Speaker Bottom

Attach the new Gasket Speaker Bottom.

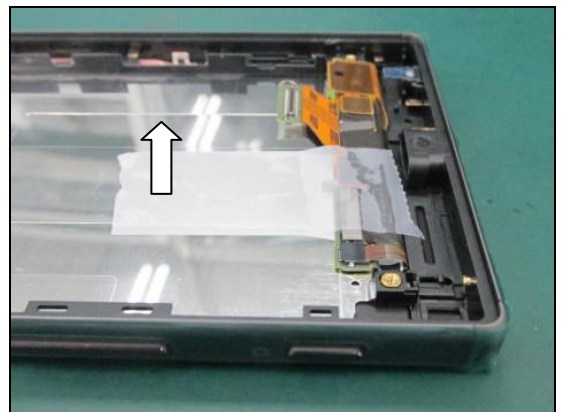


Press by Gasket WR SPK press for 5 sec.

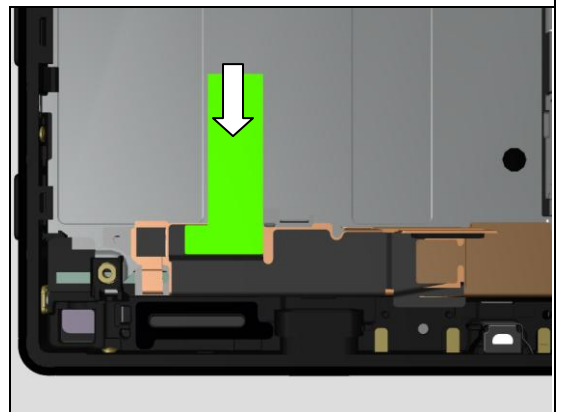


5.4 Sheet Conductive LCD FPC A

Remove the protection tape on the new Front Assy.

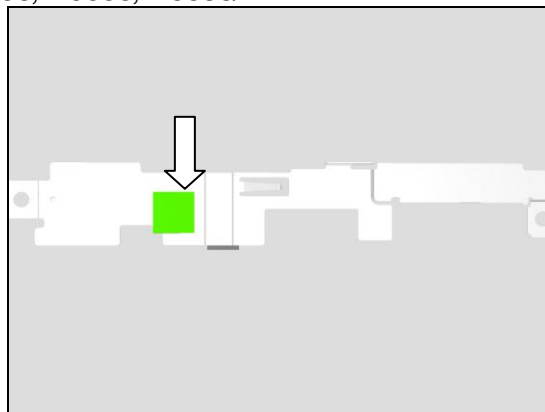


Attach the new Sheet Conductive LCD FPC A on the metal plate area and FPC conductive area.

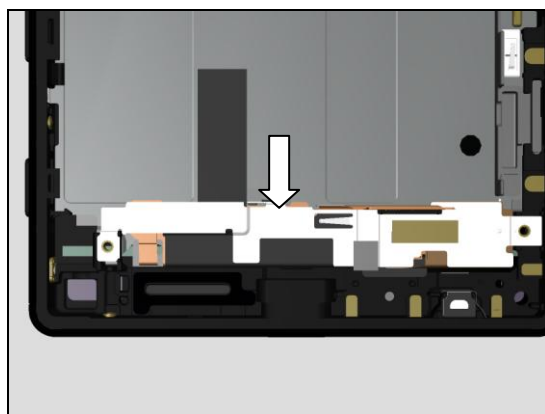


5.5 Sheet BtoB Touch & Shield FPC LCD

Attach the new Sheet BtoB Touch on the Shield FPC LCD.

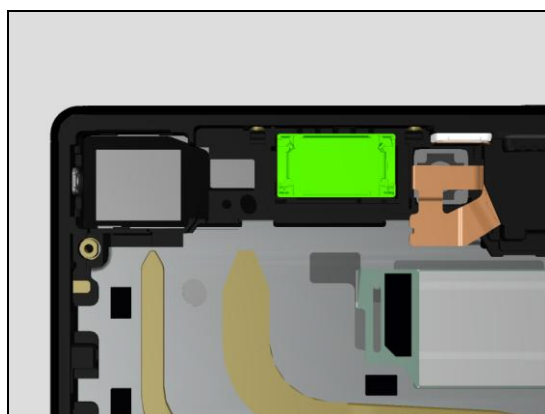


Place the Shield FPC LCD.

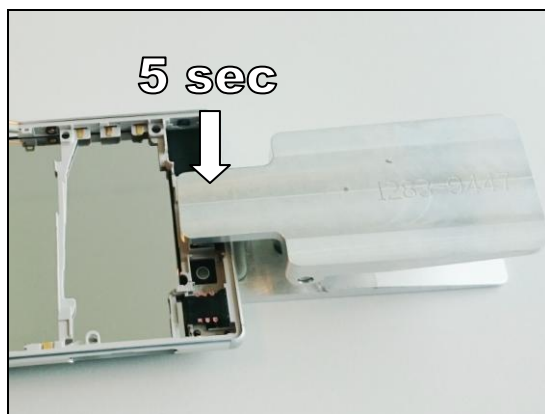


5.6 Loudspeaker & Cushion ACO

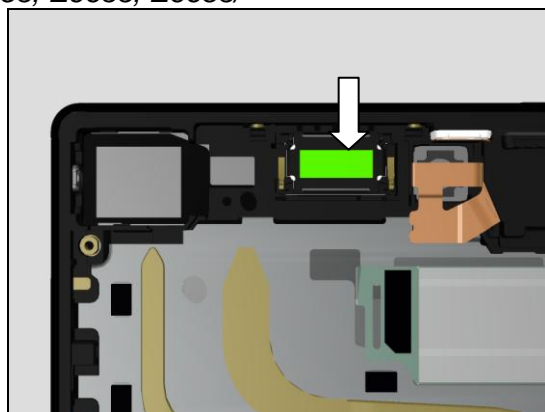
Place the new Loudspeaker on the adhesive.



Press by Earspeaker/Loudspeaker Top Press Tool for 5 sec.

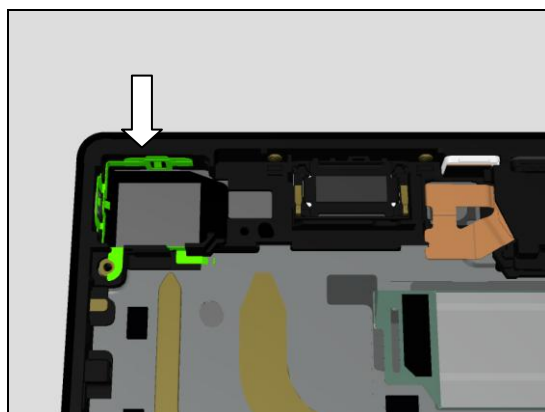


Attach the new Cushion ACO on the Loudspeaker.



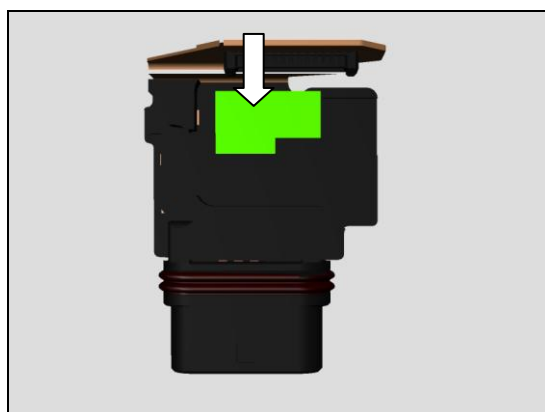
5.7 Shield Camera

Place the Shield Camera in the cavity.

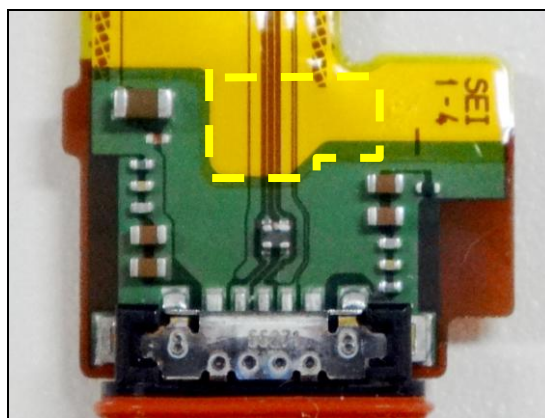


5.8 Sheet Spacer USB & FPC USB

Attach the new Sheet Spacer USB on the FPC USB.



Target position is shown by the dotted line in the picture.

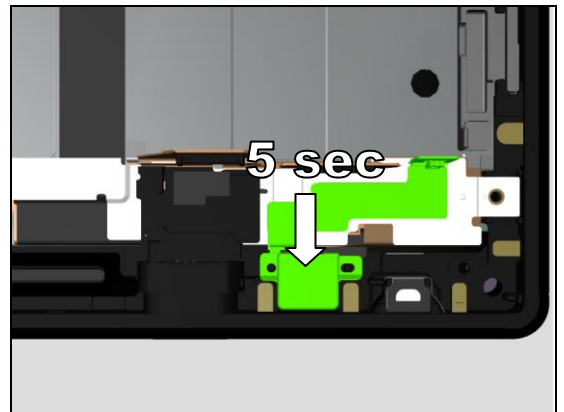


Insert the FPC USB in the cavity.



5.9 FPC 1st Mic

Attach the FPC 1st Mic on the Front Assy. Firmly press black plastic area by a finger for 5 sec.



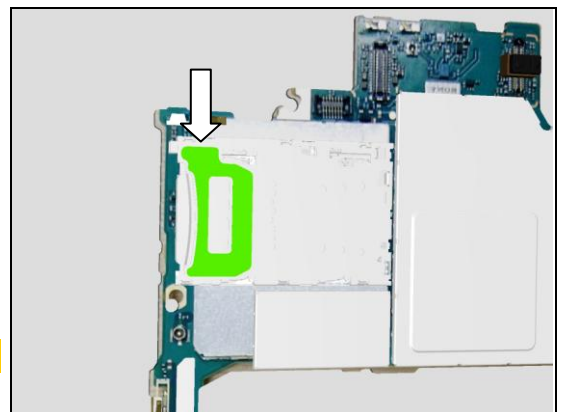
Press FPC area on the gold conductive film of the Shield FPC LCD.



5.10 Sheet Protection MoP Label

Attach the new Sheet Protection MoP Label on the combo connector of the Main PBA.

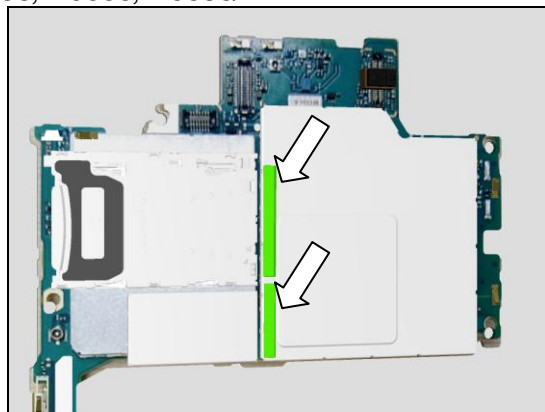
Only for E6603, E6653!



5.11 Sheet TGF Upper & Lower / Sheet TGF D

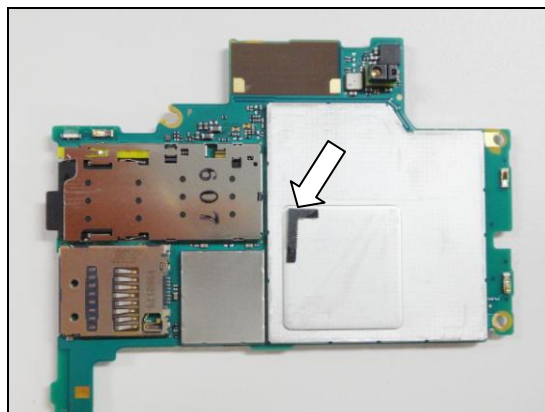
(For E6603, E6653)

Attach the new Sheet TGF Upper & Lower on the Main PBA as shown in the picture.



(For E6633, E6683)

Attach the new Sheet TGF D on the Main PBA as shown in the picture.

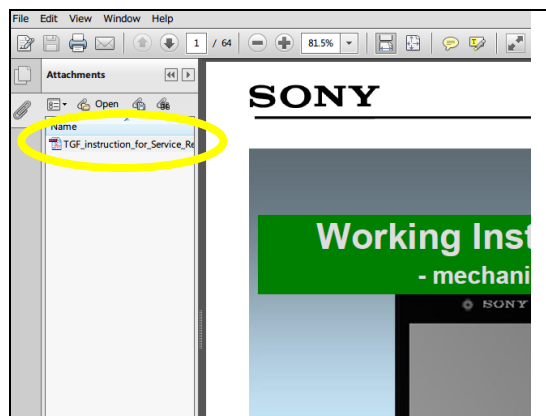


5.12 Thermal Gap Filler

Prepare the new Thermal Gap Filler Syringe and Thermal Gap Filler Tube.



Open the embedded Thermal Gap Filler instruction in Attachments and make sure to go through it prior to use!



SONY

Working Instruction Repair Instruction Mechanical/E6603, E6653, E6633, E6683/

Confirm the expiration date that is stamped at the Thermal Gap Filler Tube end.

Expiration date is 6 month after manufacturing.

X: Manufacturing Year (201X)

Y: Manufacturing Month (1,2,,,9, A, B, C)

Z: Manufacturing Date (1,2,,,9, A, B,,,V)

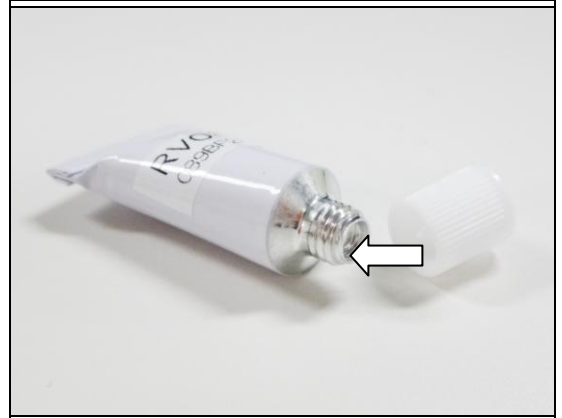
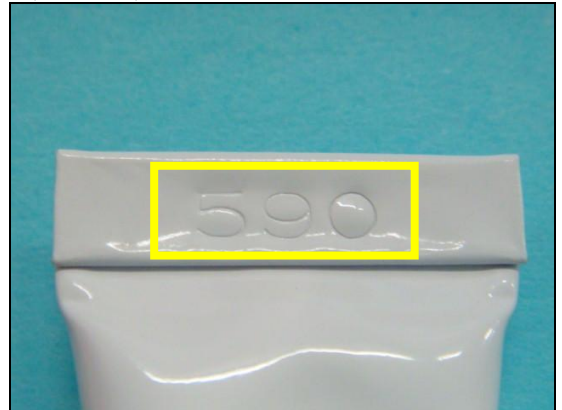
Ex) Lot.59O = Manufacturing date is September 24th , 2015.

Material will start to set once it is exposed to air.

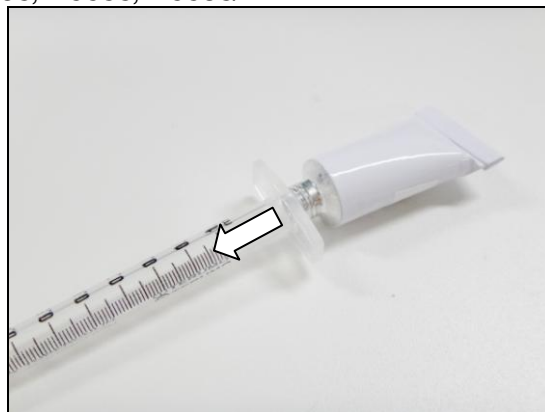
Scrap! Thermal Gap Filler Tube cannot be used 24h after first opening.

Scrap! Thermal Gap Filler Syringe cannot be used 1h after filling.

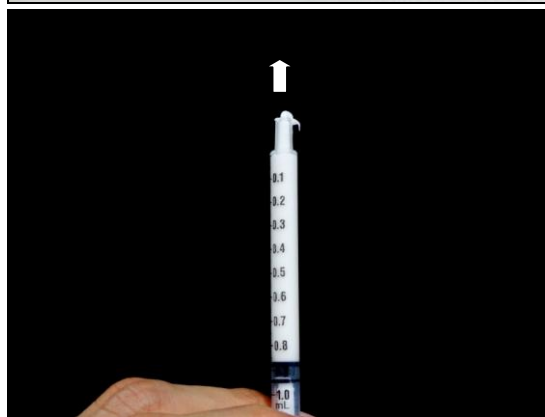
Open the tube with the cap head.



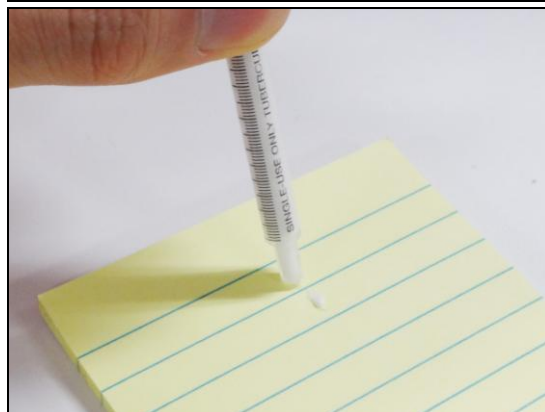
Inject contents of the tube from the end of the syringe.



Make sure the contents reach up to the tip of the syringe and a small amount of the contents flows out as air is released.

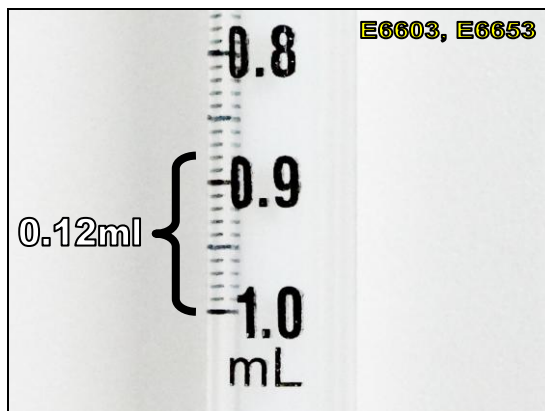


Wipe off the tip before using.

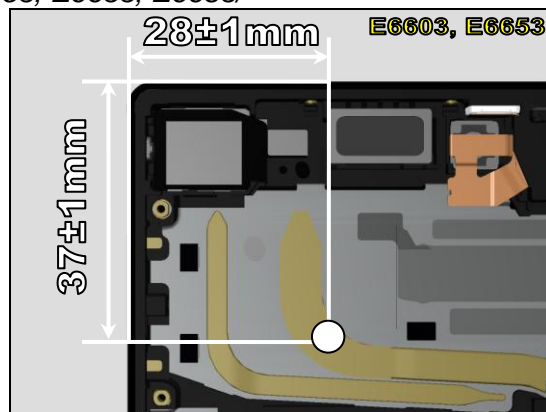


(For E6603, E6653)

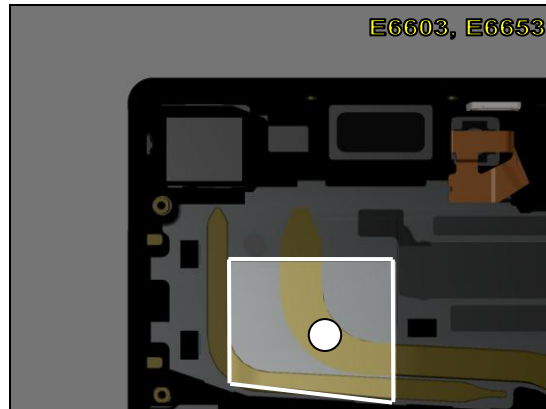
Volume for one unit is 0.12 ml at one point.



Carefully apply the Thermal Gap Filler on the shown point.



Thermal Gap Filler must not cross the shaded area.

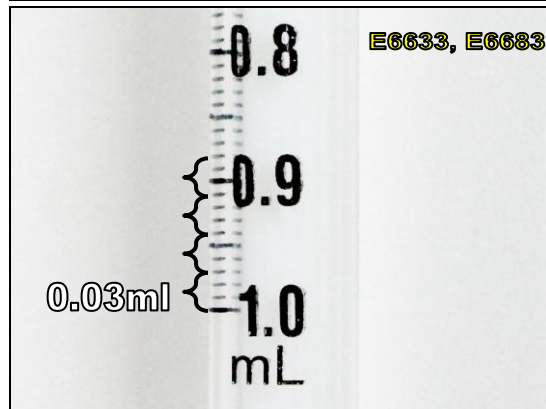


<Sample picture>

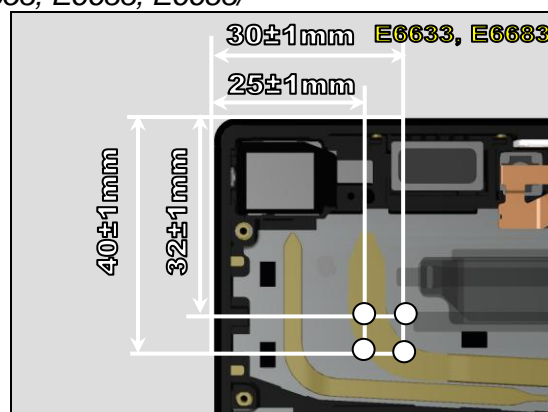


(For E6633, E6683)

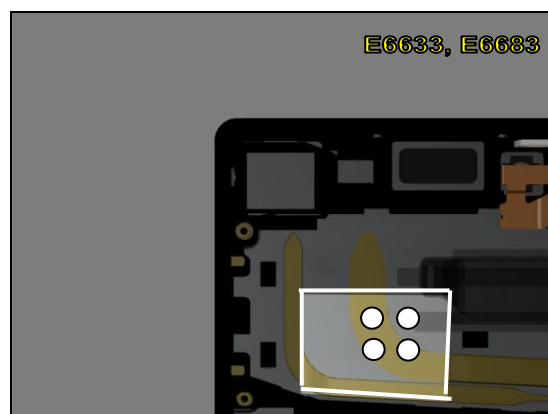
Volume for one unit is 0.12 ml. 0.03 ml at each of four point.



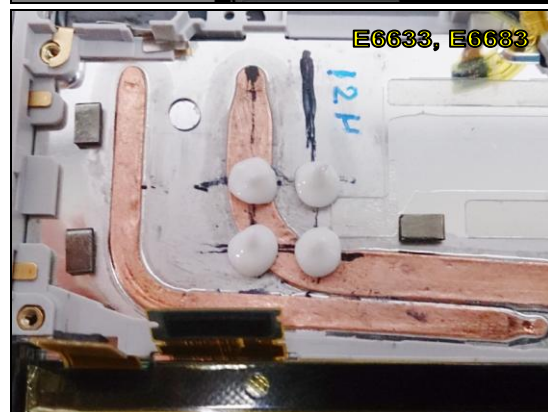
Carefully apply the Thermal Gap Filler on the shown point.



Thermal Gap Filler must not cross the shaded area.

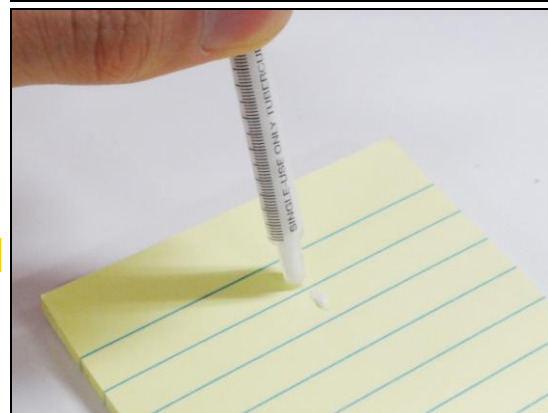


<Sample picture>



Wipe off the tip of the syringe until next repair.

Scrap! Do not refill the same syringe.



Next time you use, let a small amount of contents flow out and wipe off the tip again.

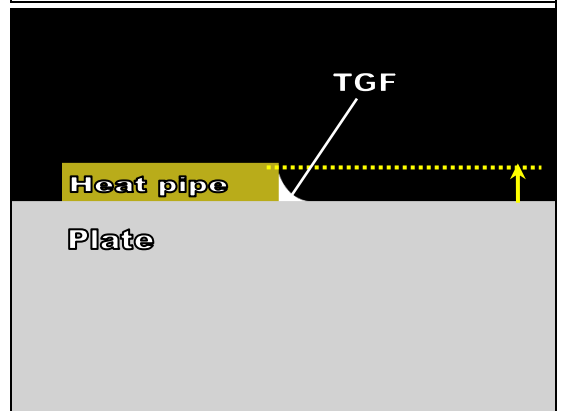
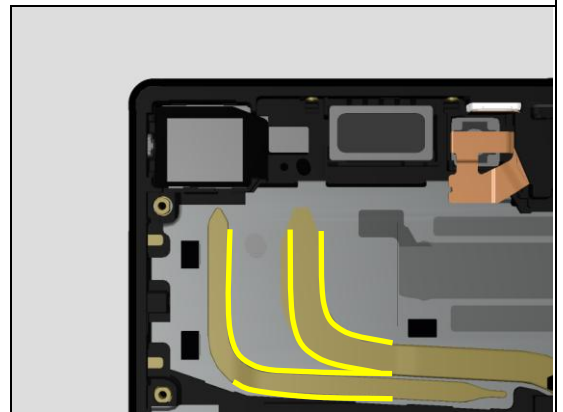
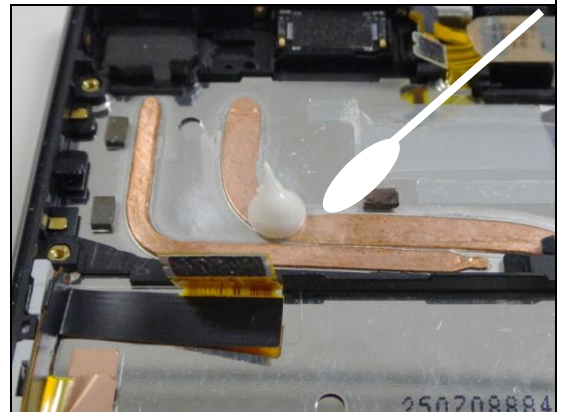
REWORK

If the position or amount is not correct, wipe it off with a cotton swab. pply the new Thermal Gap Filler.

Do inspection before applying Thermal Gap Filler.

Thermal Gap Filler is only allowed to be left at yellow ditch up to 1mm width.

Do not let Thermal Gap Filler exceed the height of heat pipe.



5.13 Main PBA

Insert the Main PBA with around 30 degrees of an angle.

Main PBA assembling must be done immediately (within 5 minutes after Thermal Gap Filler applying).

(For E6603, E6653)

Tighten one screw on the right side of the PBA.

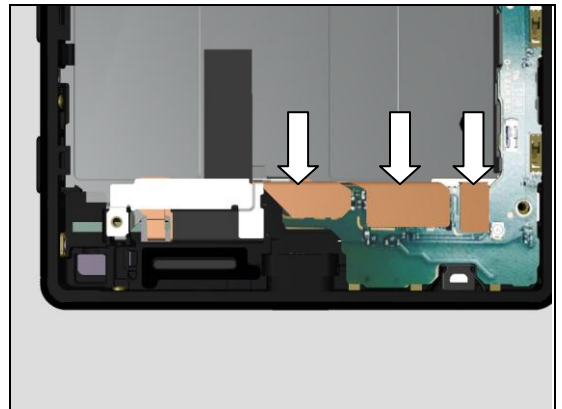
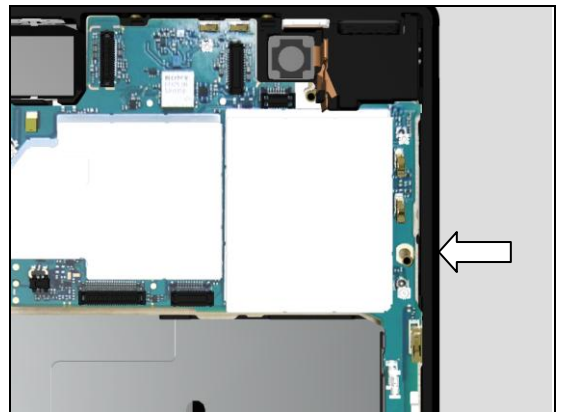
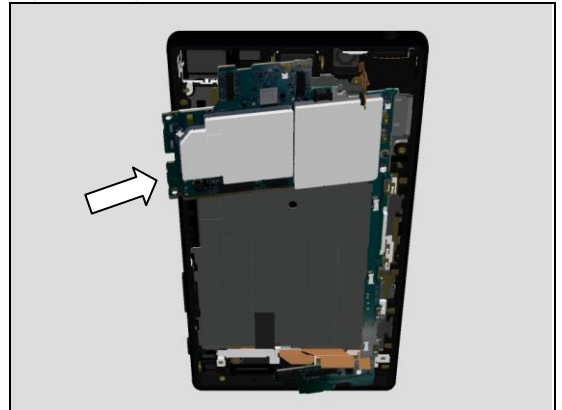
Len:2.6 Diam:1.4

Torque:13±1.3Ncm

(For E6633, E6683)

No screw here.

Connect three connectors (for USB, for LCD, for 1st Mic).



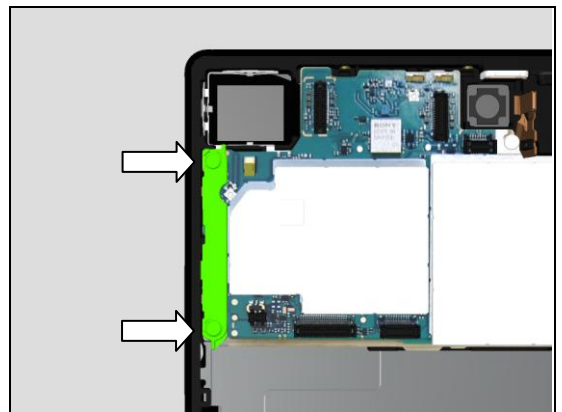
5.14 Holder PBA

Place the Holder PBA.

Tighten two screws.

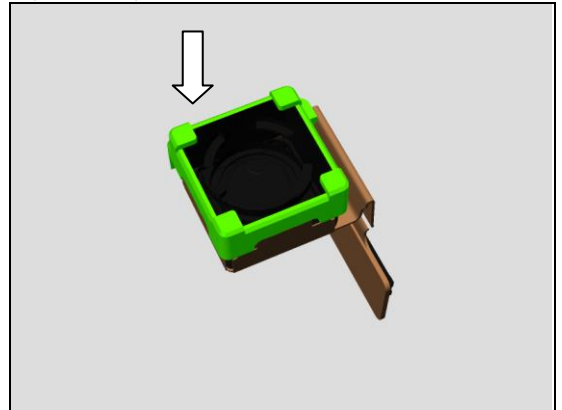
Len:2.6 Diam:1.4

Torque:13±1.3Ncm

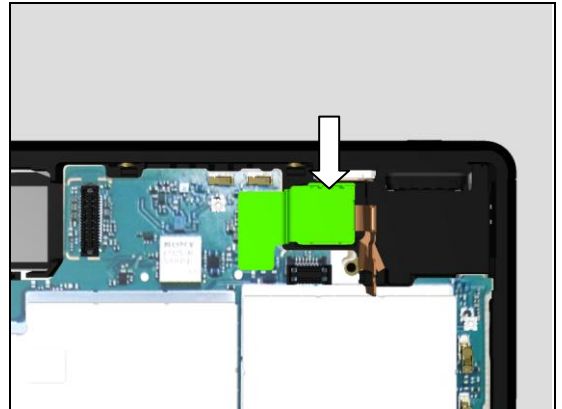


5.15 Holder Sub Camera & Camera Sub

Attach the Holder Sub Camera on the Camera Sub.

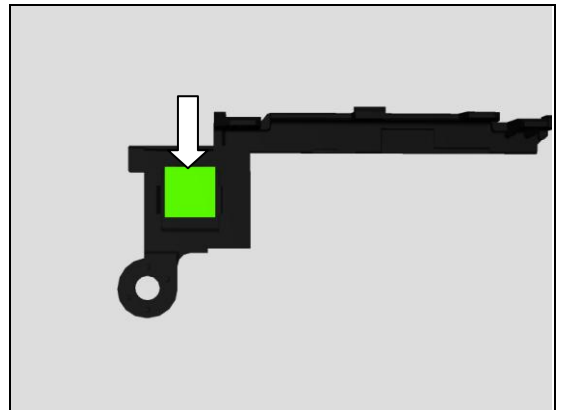


Place the Camera Sub on the cavity.
Connect the Camera Sub connector.

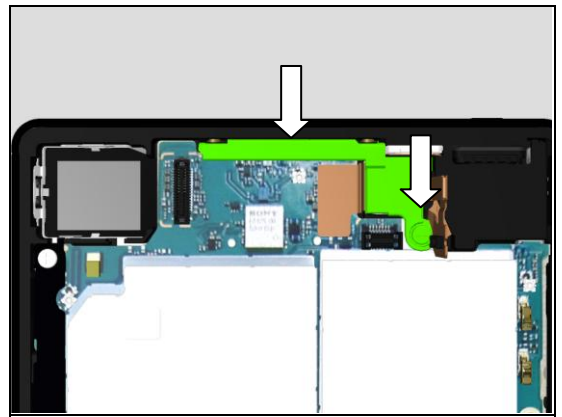


5.16 Gasket Conductive Sub Camera & Antenna Cell Sub

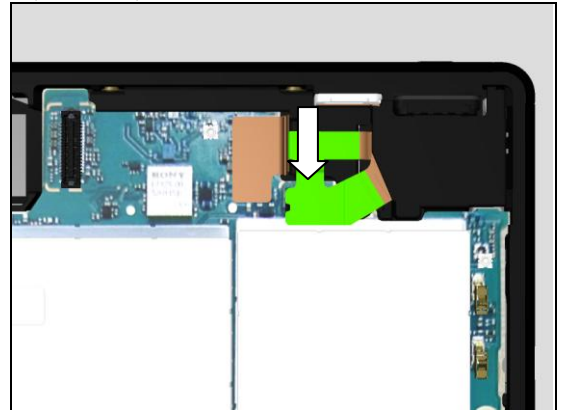
Attach the new Gasket Conductive Sub Camera on the Antenna Cell Sub.



Place the Antenna Cell Sub on the Main PBA.
Tighten the screw.
Len:2.6 Diam:1.4
Torque:13±1.3Ncm

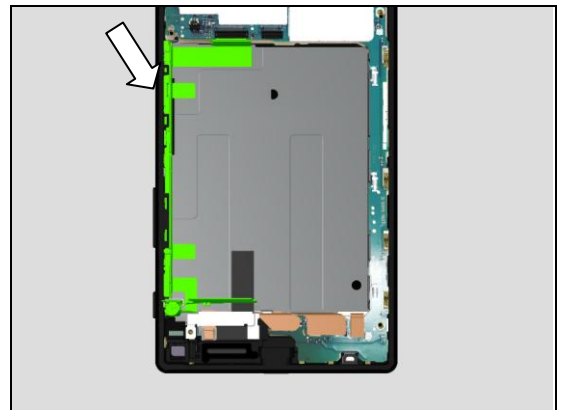


Connect the FPC Top connector.

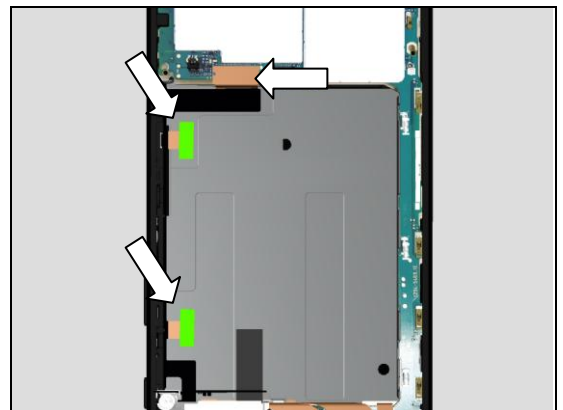


5.17 FPC Key & Sheet Conductive FPC Relay

Place the new FPC Key.



Attach the new Sheet Conductive FPC Relays.
Connect the FPC Key Connector.

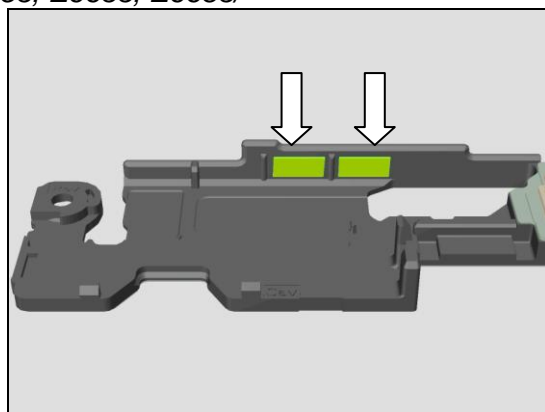


New version of FPC does not have the tabs. In that case pasting the Sheet Conductive FPC Relay is not required.

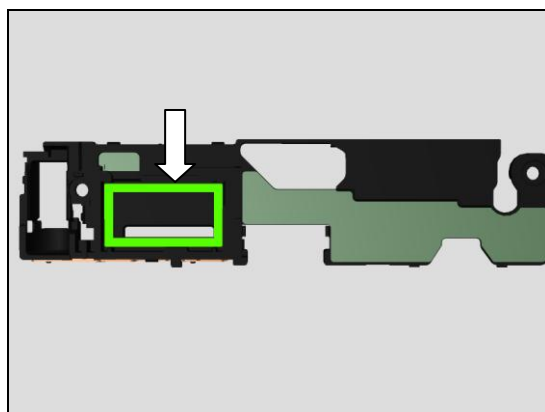


5.18 Sheet Holder Speaker & Adhesive Speaker Bottom & Top Speaker

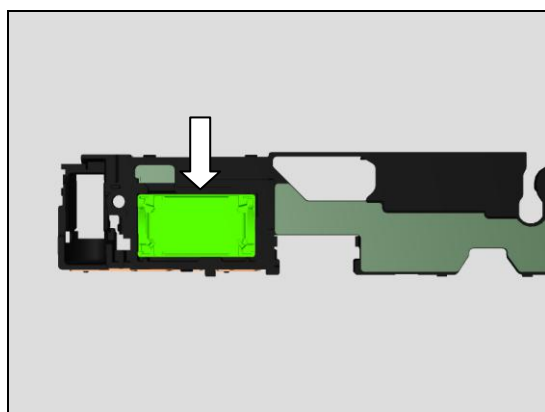
Attach the new Sheet Holder Speaker on the Antenna Cell Main.



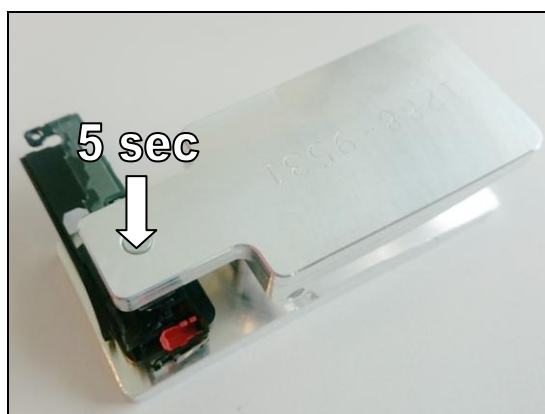
Attach the new Adhesive Speaker on the Antenna Cell Main.



Attach the Top Speaker on the Antenna Cell Main.

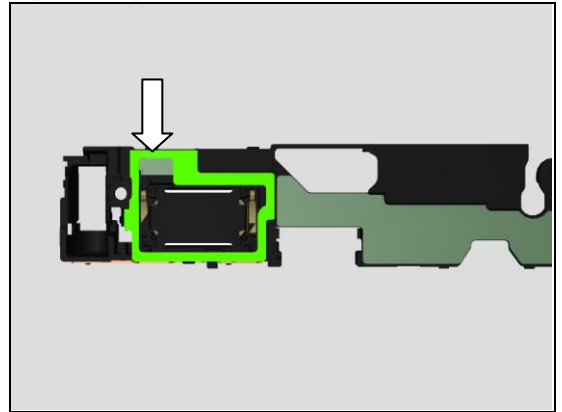


Press with Press Tool Ear Speaker for 5 sec.



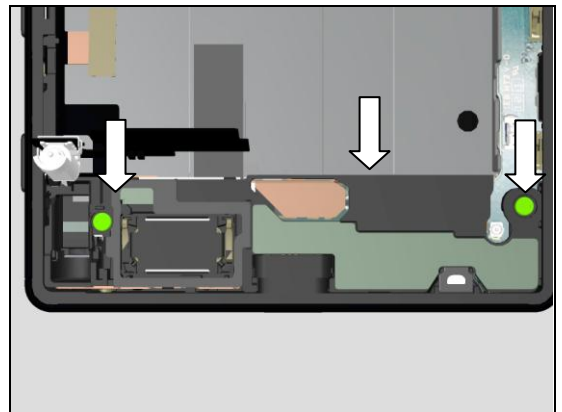
5.19 Adhesive FPC Speaker

Attach the Adhesive FPC Speaker on the Antenna Cell Main.



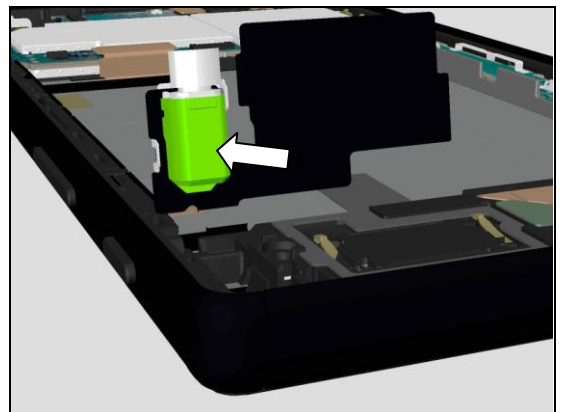
5.20 Antenna Cell Main

Place the Antenna Cell Main on the Front Assy.
Tighten two screws.
Len:2.6 Diam:1.4
Torque:13±1.3Ncm



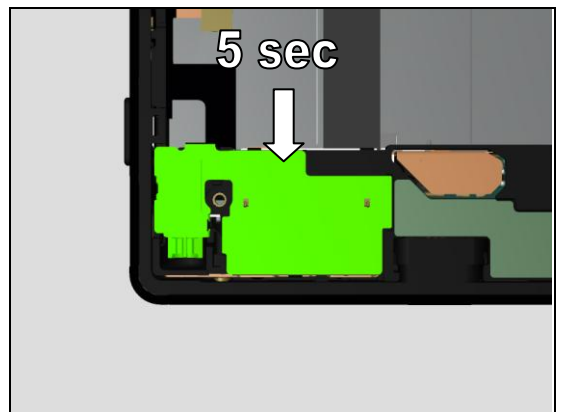
5.21 Holder Vib

Place the Holder Vib on the vibrator.

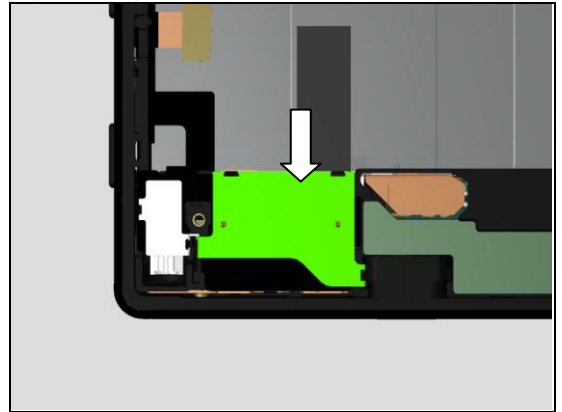


5.22 FPC Key 2 & Plate Speaker

Place FPC Key on the Adhesive FPC Speaker.
Firmly press with a finger for 5 sec.

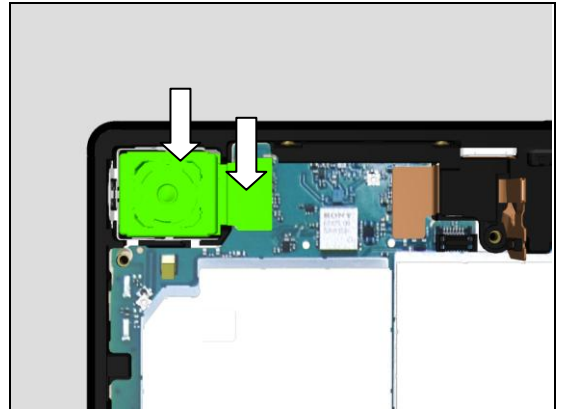


Attach the Plate Speaker on the FPC Key.

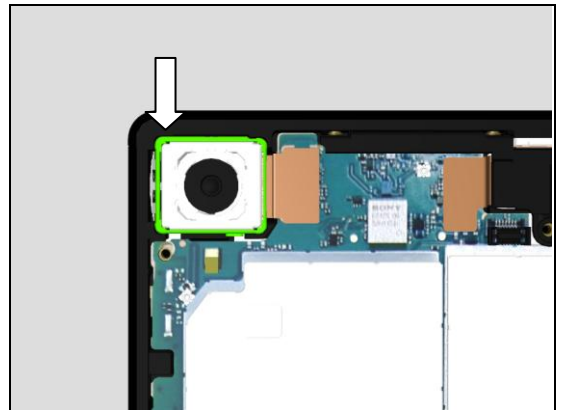


5.23 Camera Main & Holder Main Camera

Place the Camera Main.
Connect the Camera Main connector.

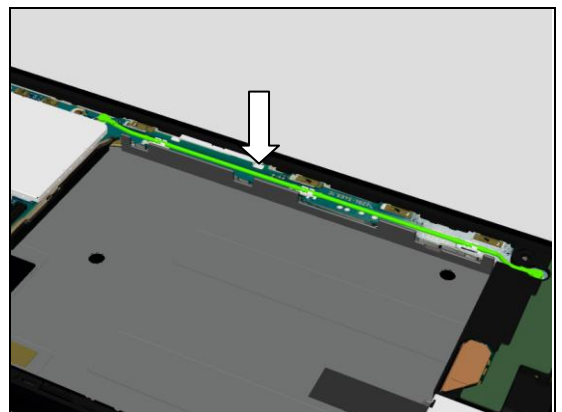


Place the Holder Main Camera on the Camera Main.



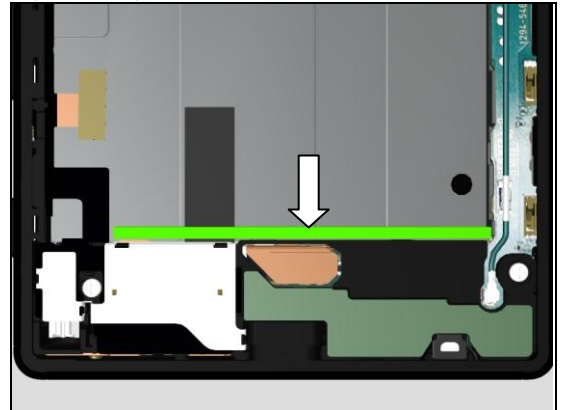
5.24 RF Coax Cable

Attach the RF Coax Cable on the Main PBA.



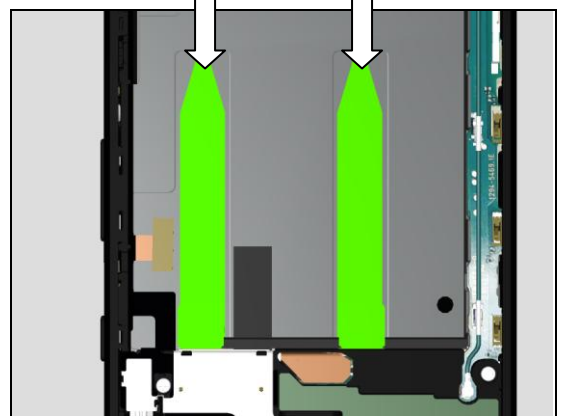
5.25 Cushion Battery

Attach the Cushion Battery on the Antenna Cell Main.



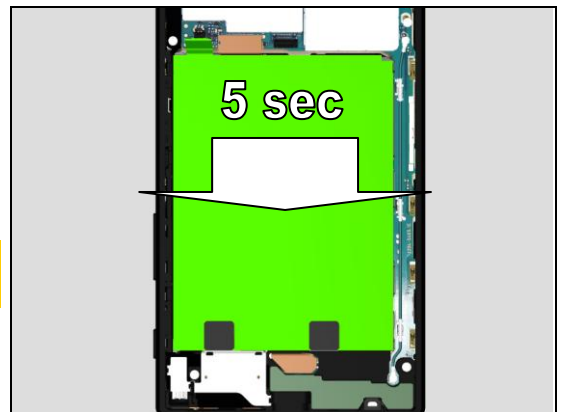
5.26 Adhesive Battery & Battery Embedded

Attach the Adhesive Battery along the guide line.



Attach the Battery Embedded.
Press with a hand evenly for 5 sec.

Make sure the pull tabs peek between the Cushion Battery and the Battery Embedded.

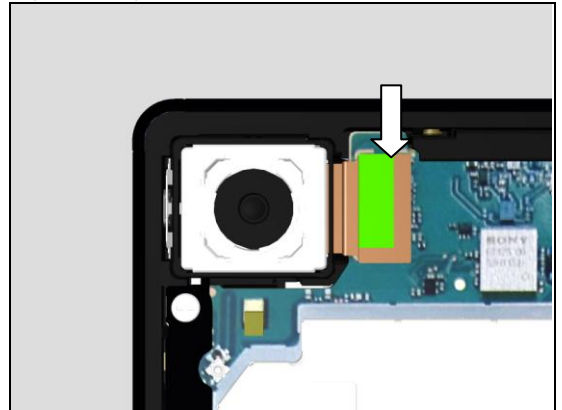


Connect the Battery connector.



5.27 Cushion BtoB A & B & C

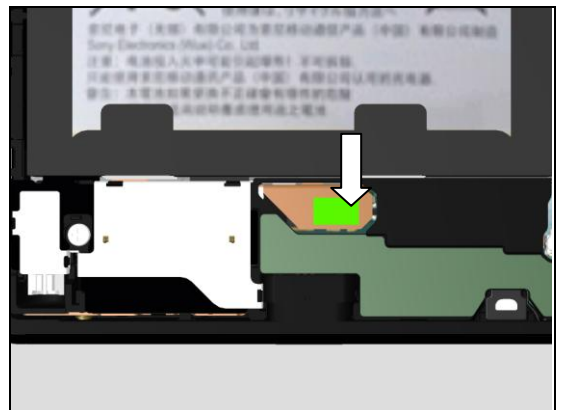
Attach the new Cushion BtoB A.



Attach the new Cushion BtoB B.



Attach the new Cushion BtoB C.



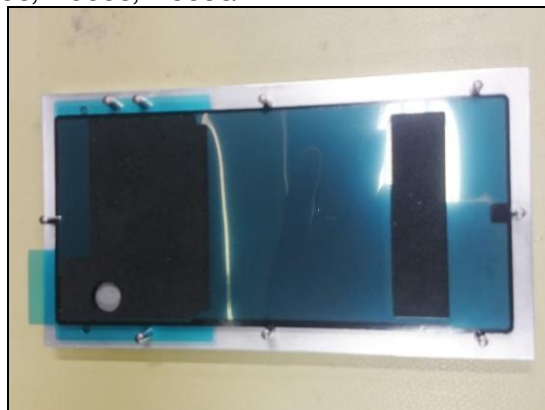
5.28 Antenna NFC

Attach the new Antenna NFC on the Panel Rear.
Press with a hand evenly for 5 sec.



5.29 Adhesive Panel Rear

Place the Adhesive Panel Rear on the Rear Panel Adhesive Alignment Fixture.

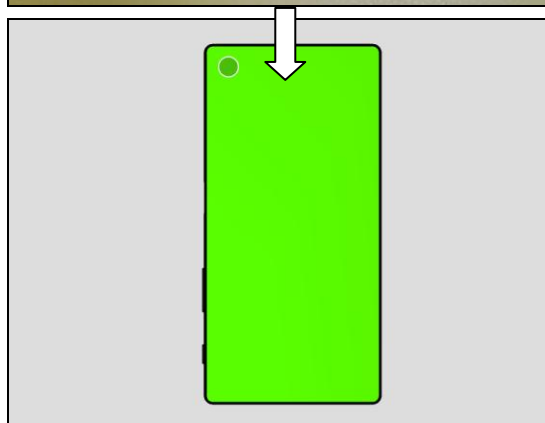


Attach the Adhesive Panel Rear.



5.30 Panel Rear

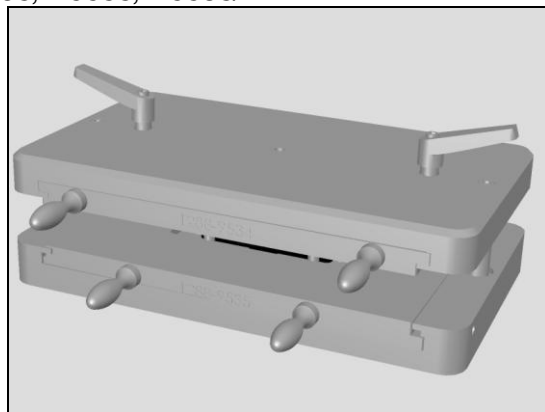
Attach the Panel Rear on the phone unit.



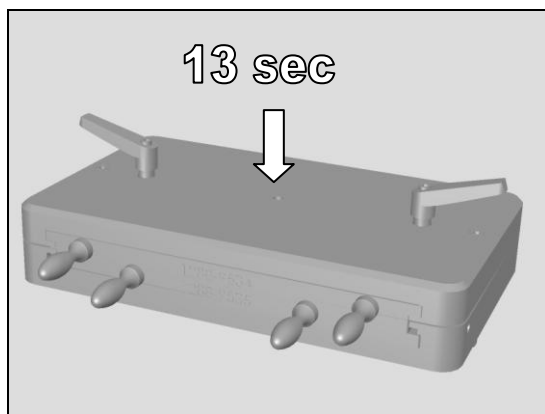
Place the phone unit on the Bottom Press Inlay.



Insert the Bottom Press Inlay and the Rear Panel Press Top Inlay in the Generic fixture for Press tool.



Press with the Bottom Press Inlay and the Rear Panel Press Top Inlay for 13 sec with $512\text{N} \pm 50$.



6 Revision History

Rev.	Date	Changes / Comments
1	2015-Sep-18	Initial release
2	2015-Sep-25	Add "Important!" description in 4.12, 21 and 34.
3	2015-Sep-30	Embedded Thermal Gap Filler instruction file in 5.12.
4	2015-Oct-23	Add Screw specification in 5.13, 14, 16, and 20. Update Panel Rear press duration (10 to 13) in 5.30.
5	2015-Nov-17	Update Thermal Gap Filler tube picture in 5.12. Update TGF instruction (embedded).
6	2016-May-6	Add description about new version of FPC Key in 5.17.