



# Working Instruction, Mechanical

Applicable for F305

## CONTENTS

<b>1</b>	<b>Introduction .....</b>	<b>3</b>
1.1	Equipment.....	4
1.2	General Cautions.....	5
1.3	Adhesives.....	5
<b>2</b>	<b>Disassembly .....</b>	<b>6</b>
2.1	Overview.....	7
2.1.1	Battery Cover and Battery.....	8
2.1.2	Style Upper Cover and Upper Front Cover Assembly ..	9
2.1.3	LCD TFT 2.0 .....	11
2.1.4	Upper Rear Cover .....	13
2.1.5	Hinge Assembly .....	14
2.1.6	Lower Front Cover .....	15
2.1.7	PCBA and Lower Rear Cover .....	17
<b>3</b>	<b>Replacements.....</b>	<b>18</b>
3.1	Style Upper Cover Assembly .....	19
3.2	Upper Front Cover Assembly.....	19
3.3	LCD TFT 2.0.....	19
3.4	Upper Rear Cover .....	19
3.5	Hinge Assembly.....	19
3.6	Lower Front Cover.....	19
3.7	Lower Rear Cover.....	19
3.8	RF Cap .....	20
3.9	KRH Label .....	21
3.10	Cushion .....	22
3.11	Water Intrusion Indicator.....	23
3.12	A Key .....	26
3.13	B Key .....	27
3.14	Navi Keypad .....	28
3.15	Keyboard PBA Assembly .....	29
3.16	Decoration Sheet .....	31
3.17	Insulation Tape .....	32
3.18	Conductive Gasket for H-H FPC .....	33
3.19	Protection Foil for Connector .....	34
3.20	H-H FPC .....	35
3.21	Protection Foil for Test Point .....	36



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3.22	Camera Key.....	37
3.23	Volume Key.....	38
3.24	M2 Cover .....	39
3.25	Keypad.....	40
3.26	Main Key Dome Assembly.....	41
3.27	Camera Module.....	42
3.28	BB Shield Can Lid .....	44
3.29	Space Cover.....	45
3.30	BT Antenna and Speaker Assembly.....	46
3.31	Main Antenna and Speaker Assembly .....	47
3.32	Vibrator.....	48
3.33	Double Side Receiver Adhesive.....	49
4	Reassembly .....	50
4.1	Overview.....	51
4.1.1	PCBA and Lower Rear Cover .....	52
4.1.2	Lower Front Cover .....	53
4.1.3	Hinge Assembly .....	54
4.1.4	Upper Rear Cover .....	56
4.1.5	LCD TFT 2.0 .....	57
4.1.6	Upper Front Cover Assembly and Style Upper Cover .....	59
4.1.7	Battery and Battery Cover.....	61
5	Country of Origin Barcodes for Brazil/VIVO Labels .....	62
6	Revision History.....	62

# 1 Introduction

**Front**



**Back**



## 1.1 Equipment

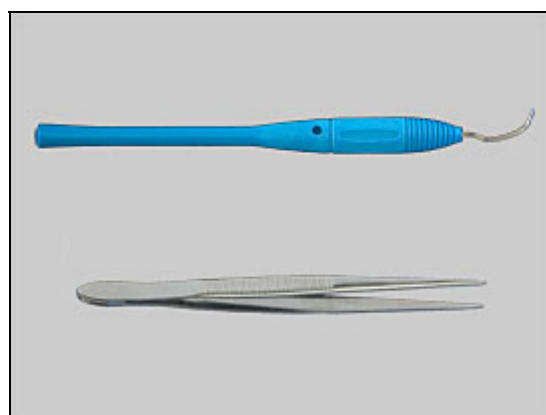
### Special Tools

- NTZ 112 459 Torque screwdriver (or equivalent)
- NTZ 112 1052 Bits(JCIS No 0)
- SXA 109 3563 Bits/Torx 4
- NTZ 112 302/2 Front opening tool
- NTZ 112 1067 MEGA Pixel Camera Tool
- NTZ 112 590 Guitar Pick #Plectrum#
- NTZ 112 521 Flex film assembly tool



### Standard Tools

- Dentist hook
- ESD tweezers



### Label Equipment

The following special equipment is required when replacing or installing a new label:

- Hot air flow repair station
- Zebra printer



### Other Equipment

- ESD wrist bands with cable
- ESD gloves
- Isopropyl alcohol
- Ionized air gun or blower





## 1.2 General Cautions

The following cautions are considered to be generic for all phone models and will not be repeated in the Disassembly, Replacements and Reassembly sections:

**TURN OFF THE PHONE AND REMOVE THE SIM CARD BEFORE STARTING THE DISASSEMBLY!**

**KEEP ALL CONTACT SURFACES CLEAN!**

**BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, OPENING TOOLS, GUITAR PICK ETC. TO AVOID SCRATCHES OR DAMAGES TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!**

**BE CAREFUL NOT TO DAMAGE ANY CONTACT SPRINGS!**

**REMEMBER TO REMOVE THE PROTECTION FOILS ON NEW PARTS SUCH AS THE LCD!**

**NEVER TOUCH THE DISPLAY GLASS!**

**USE AIR BLOW EQUIPMENT TO KEEP THE FRONT WINDOW AND DISPLAY MODULE DUST FREE!**

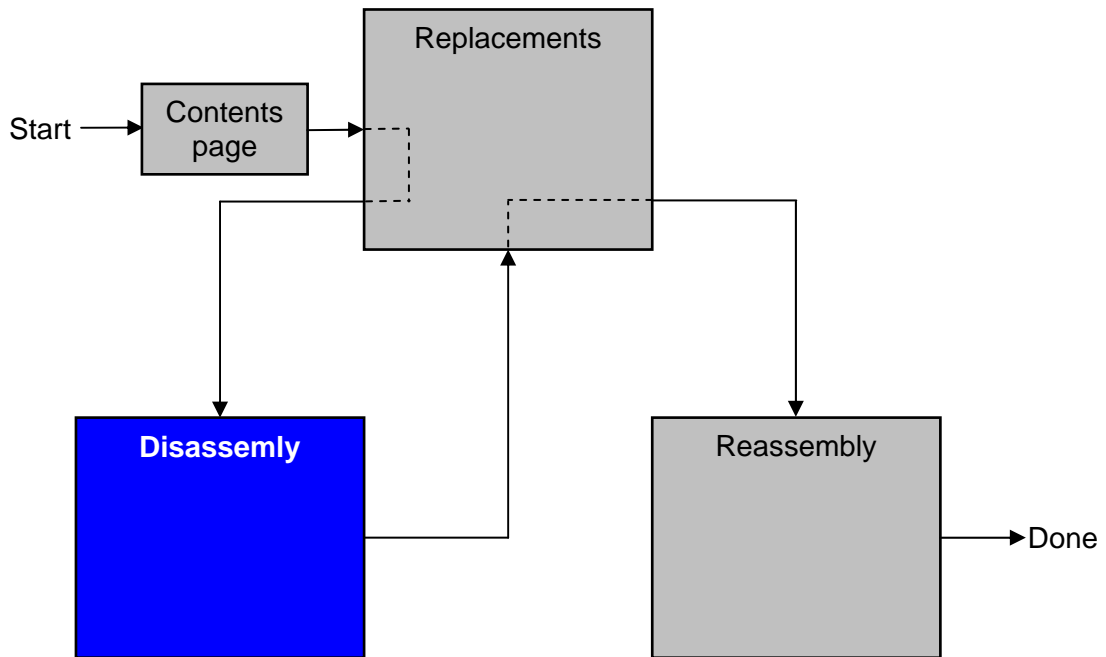
## 1.3 Adhesives

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



## 2 Disassembly

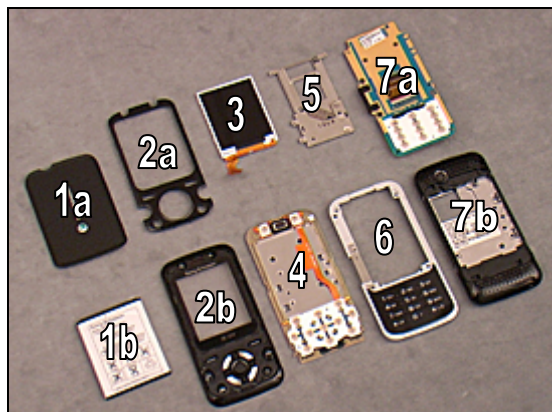
When you are going to replace a part being listed in *Replacements*, the instruction of that section usually begins by directing you to this *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before returning to *Replacements* for the actual replacement.



## 2.1 Overview

Disassemble the phone in the following sequence:

1. Battery Cover (a) and Battery (b)
2. Style Upper Cover (a) and  
Upper Front Cover Assembly (b)
3. LCD TFT 2.0
4. Upper Rear Cover
5. Hinge Assembly
6. Lower Front Cover
7. PCBA (a) and Lower Rear Cover (b)



### 2.1.1 Battery Cover and Battery

Unsnap the hook (1) and (2) of the *Battery Cover* using fingers.



Remove the *Battery Cover*.



Insert finger as shown in the picture.



Raise and remove the *Battery*.





## 2.1.2 Style Upper Cover and Upper Front Cover Assembly

Unsnap the *Style Upper Cover* from the bottom side using fingers.



Remove the *Style Upper Cover*.



Remove these six *Screws* as shown in the picture using JCIS No.0 Screw Bit.



Slide the phone in open position.  
Locate the five snap hooks around the *Upper Front Cover Assembly* that have to be unlatched as shown in the picture.





Turn the phone over.

Insert a guitar pick and slide it along top side to unsnap the snap hooks as shown in the picture.

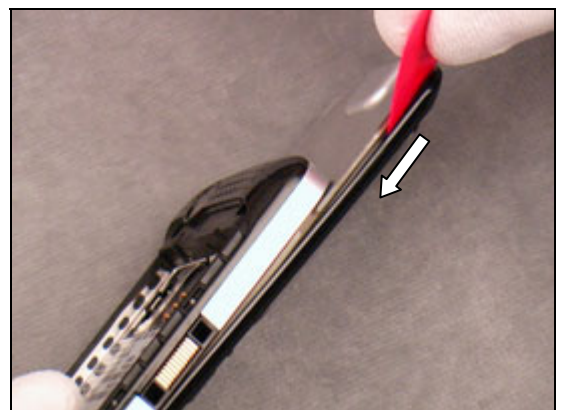
**NOTE: IF NECESSARY, SLIDE BACK AND FORTH UNTIL ALL HOOKS ARE UNLATCHED!**



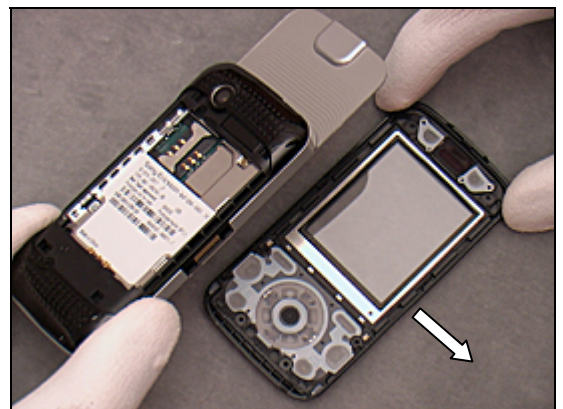
Continue to slide it on this side.



Continue on the opposite side.



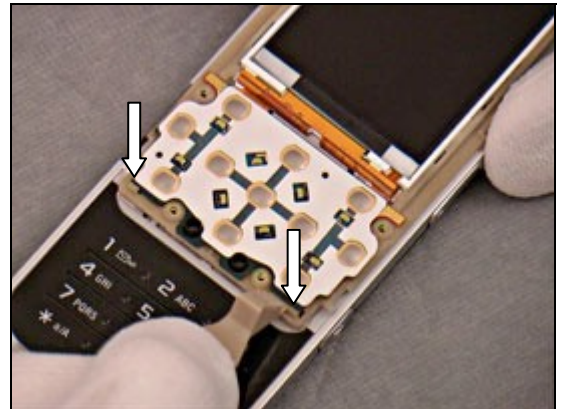
Remove the *Upper Front Cover Assembly with Navi Keypad and A Key, B Key*.



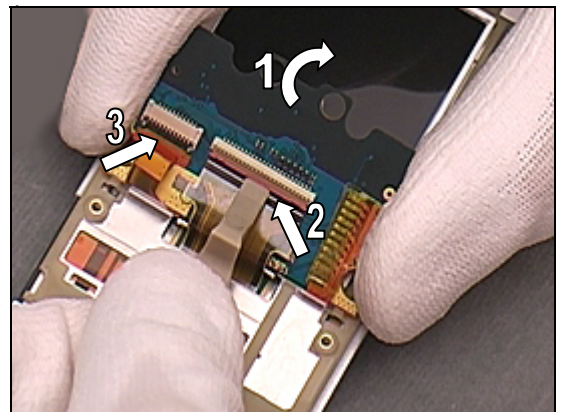


### 2.1.3 LCD TFT 2.0

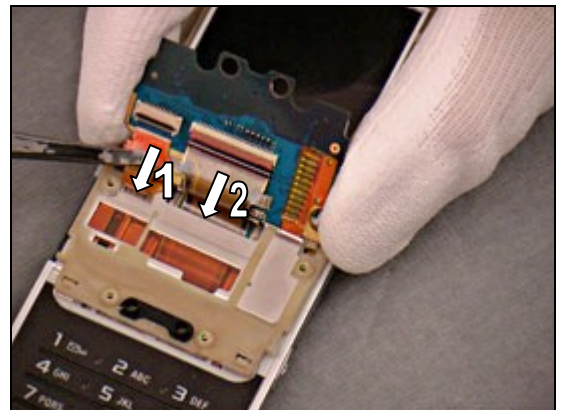
Unsnap the two hooks using a front opening tool as shown in the picture.



Fold the *Keyboard PBA* (1) open and unlock the *H-H FPC Connector* (2) and the *LCD Connector* (3) using a front opening tool.



Carefully release the *LCD FPC* (1) and *H-H FPC* (2) using the flex film assembly tool.

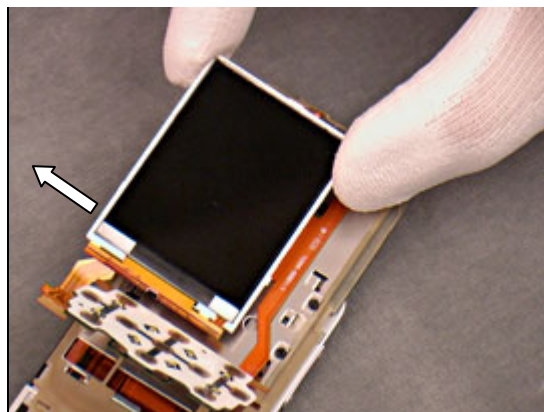


Unsnap the *LCD* using the front opening tool.



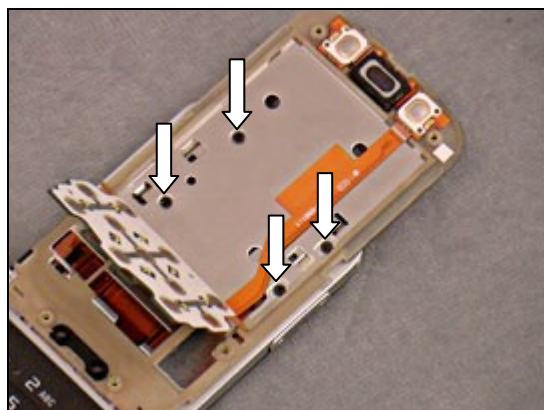
Remove the *LCD*.

**NOTE: BE CAREFUL NOT TO DAMAGE THE LCD FPC DURING THE OPERATION.**



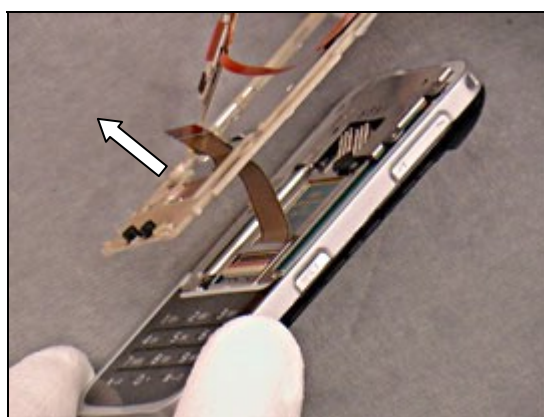
## 2.1.4 Upper Rear Cover

Remove these four Screws using JCIS No.0 Screw Bit.



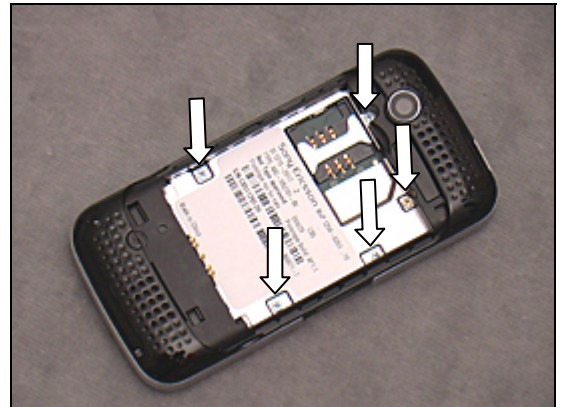
Remove the *Upper Rear Cover* from the phone.

**NOTE: BE CAREFUL NOT TO DAMAGE THE H-H FPC DURING THE OPERATION.**



## 2.1.5 Hinge Assembly

Remove these five Screws using JCIS No.0 Screw Bit.

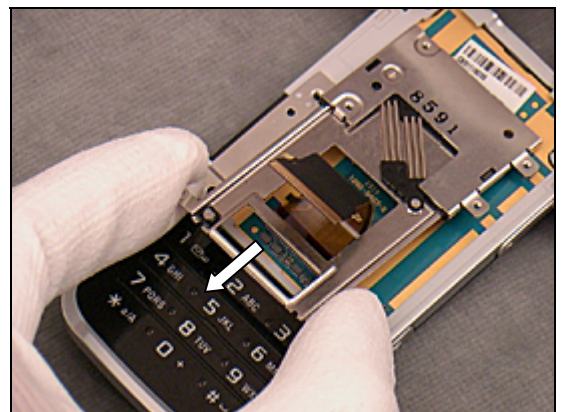


Unsnap the *Hinge Assembly* using the front opening tool as shown in the picture.



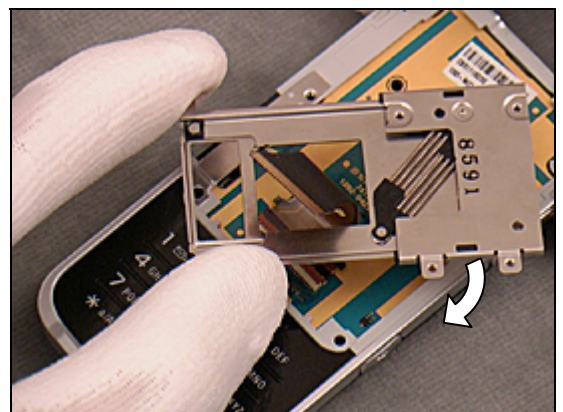
Remove the *Hinge Assembly* by the arrow.

**NOTE: MAKE SURE THE HINGE ASSEMBLY IS IN THE OPEN POSITION.**



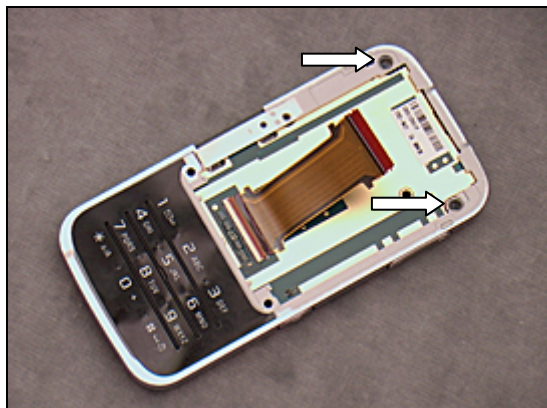
Rotate the *Hinge Assembly* horizontally to slide out as shown in the picture.

**NOTE: BE CAREFUL NOT TO DAMAGE THE H-H FPC DURING THE OPERATION.**

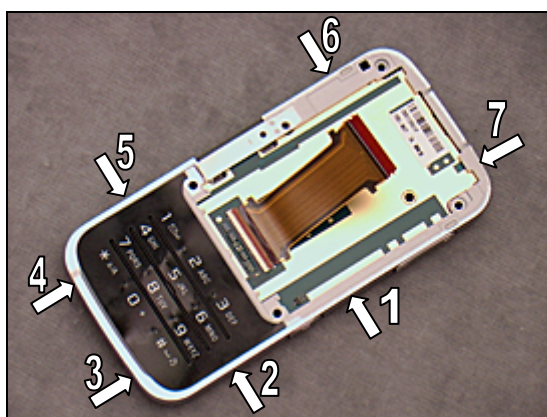


## 2.1.6 Lower Front Cover

Remove the two Screws using torx bit no. 4.

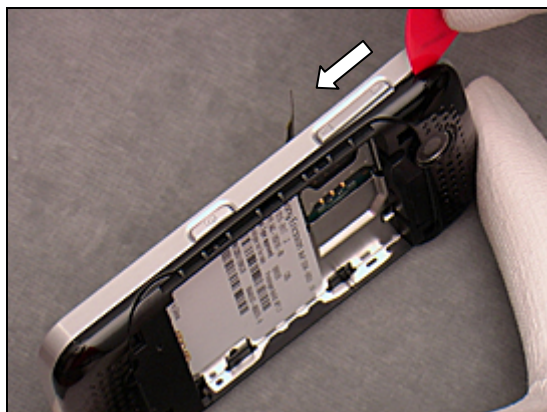


Locate the seven snap hooks around the lower unit that have to be unlatched as shown in the picture.



Insert a guitar pick as shown in the picture and slide it along this side.

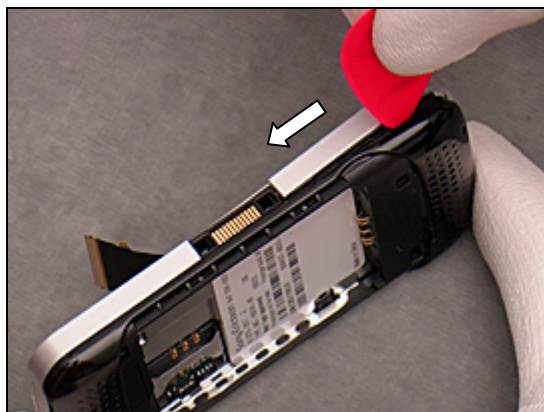
**NOTE: IF NECESSARY, SLIDE BACK AND FORTH UNTIL ALL HOOKS ARE UNLATCHED!**



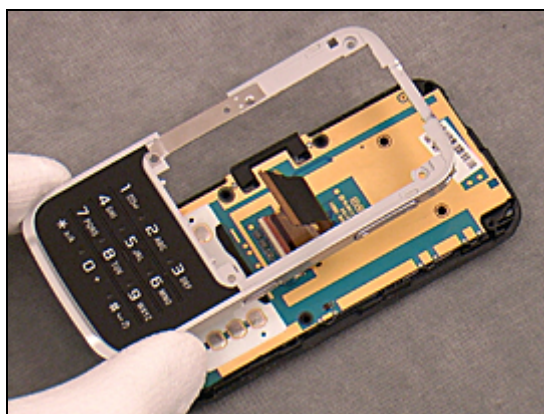
Continue to slide it on the bottom side.



Continue to slide it on the opposite side.



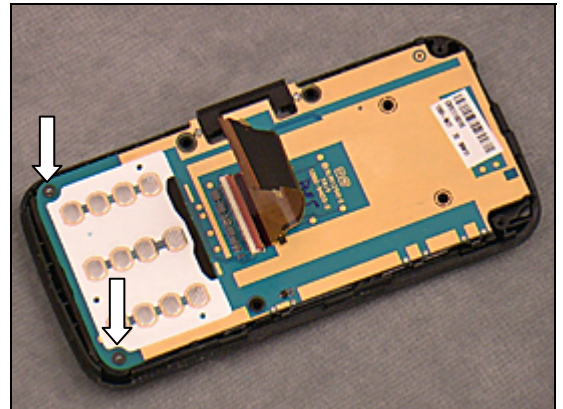
Remove the *Lower Front Cover Assembly*.



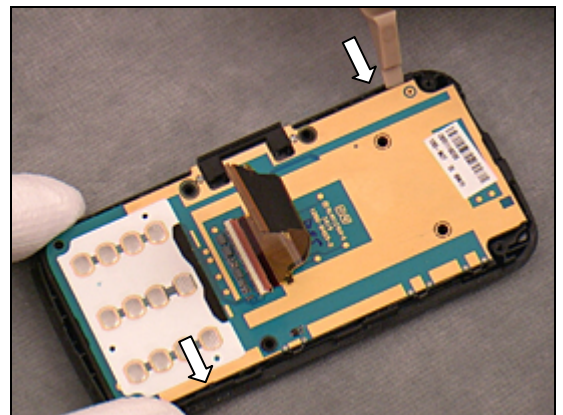


## 2.1.7 PCBA and Lower Rear Cover

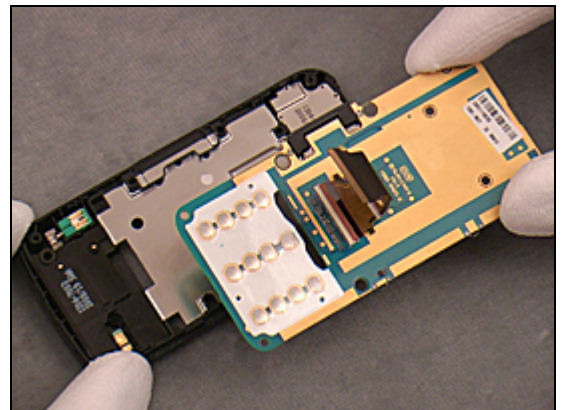
Remove the two Screws using torx bit no. 4.



Unsnap the two snap hooks using the front opening tool as shown in the picture.



Separate the PCBA and the Lower Rear Cover.





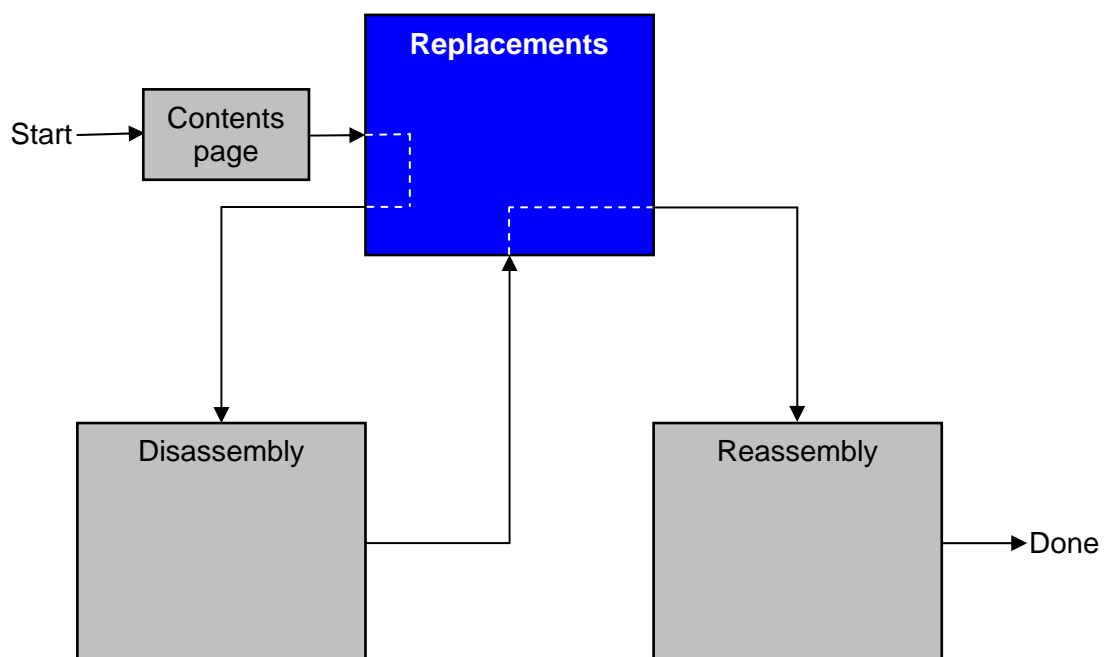
### 3 Replacements

Search for the part to be replaced on the Contents page and go to that instruction to be found in this *Replacements* section.

The instruction usually begins by directing you to the *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before the actual replacement.

Go back to this *Replacements* section and carry out the instruction.

The instruction usually ends by directing you to the *Reassembly* section with a specification of the instructions you have to carry out in order to reassemble the phone.





### **3.1 Style Upper Cover Assembly**

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

Prepare the new *Style Upper Cover Assembly*.

*Follow the 4.1.6 – 4.1.7 Reassembly instructions!*

### **3.2 Upper Front Cover Assembly**

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

Prepare the new *Upper Front Cover Assembly*.

*Follow the 4.1.6 – 4.1.7 Reassembly instructions!*

### **3.3 LCD TFT 2.0**

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Prepare the new *LCD TFT 2.0*.

*Follow the 4.1.5 – 4.1.7 Reassembly instructions!*

### **3.4 Upper Rear Cover**

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

Prepare the new *Upper Rear Cover*.

*Follow the 4.1.4 – 4.1.7 Reassembly instructions!*

### **3.5 Hinge Assembly**

*Follow the 2.1.1 – 2.1.5 Disassembly instructions!*

Prepare the new *Hinge Assembly*.

*Follow the 4.1.3 – 4.1.7 Reassembly instructions!*

### **3.6 Lower Front Cover**

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

Prepare the new *Lower Font Cover*.

*Follow the 4.1.2 – 4.1.7 Reassembly instructions!*

### **3.7 Lower Rear Cover**

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Prepare the new *Lower Rear Cover*.

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*

## 3.8 RF Cap

### Removal

*Follow the 2.1.1 Disassembly instruction!*

Remove the *RF Cap* using a dentist hook.



### Installation

Place the *RF Cap* into position using the tweezers.



Press down to secure the *RF Cap* in position using the tweezers.

*Follow the 4.1.7 Reassembly instruction!*





### 3.9 KRH Label

*Follow the 2.1.1 Disassembly instruction!*

- Read the old label and/or write the information into the "Label make" program before removal
- Note the position of the label before removal
- Heat up the label by using hot air, if needed
- Carefully remove the label without causing scratches
- If there still are residues, clean the surface with isopropyl alcohol

- Check that the proper label format is loaded in the Zebra printer
- Write a new label by using the program "Label make" and check that the printing is OK
- Take the new label and place it onto the frame as in the adjacent picture

**ONE LABEL ONLY IS ALLOWED!**

*Follow the 4.1.7 Reassembly instruction!*

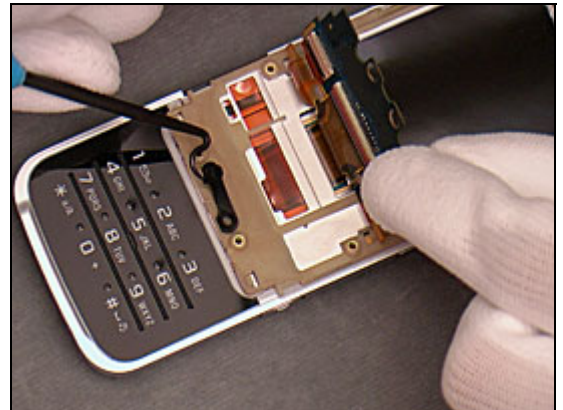


## 3.10 Cushion

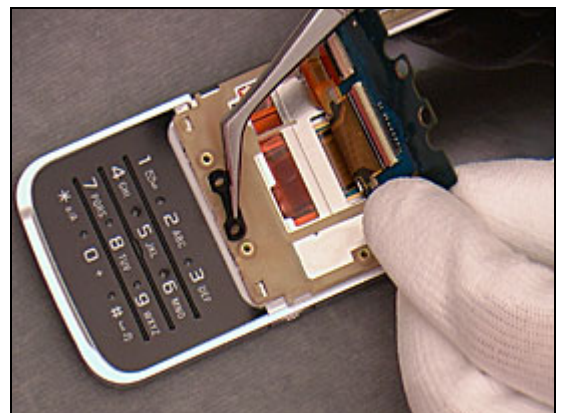
### Removal

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

Loosen the *Cushion* using a dentist hook.



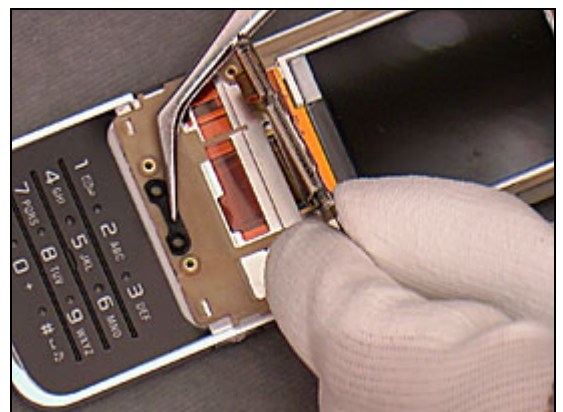
Remove the *Cushion* using the tweezers.



### Installation

Place a new *Cushion* into position and press to secure the attachment using the tweezers.

*Follow the 4.1.6 – 4.1.7 Reassembly instructions!*



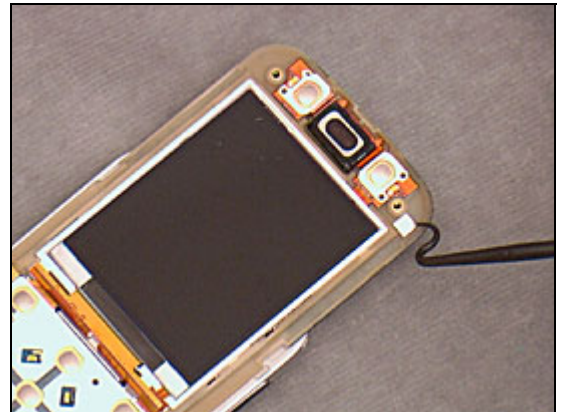


## 3.11 Water Intrusion Indicator

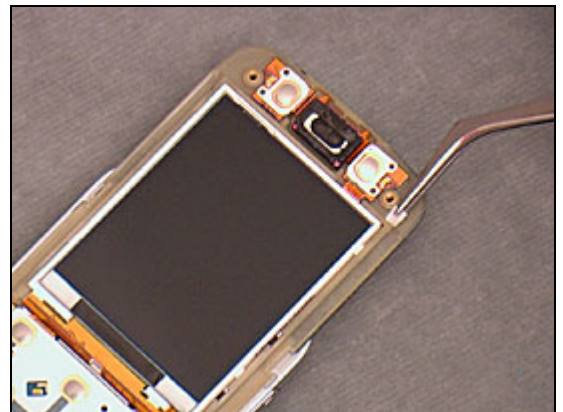
### Removal

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

Loosen the *Water Intrusion Indicator* using a dentist hook.



Remove the *Water Intrusion Indicator* using the tweezers.

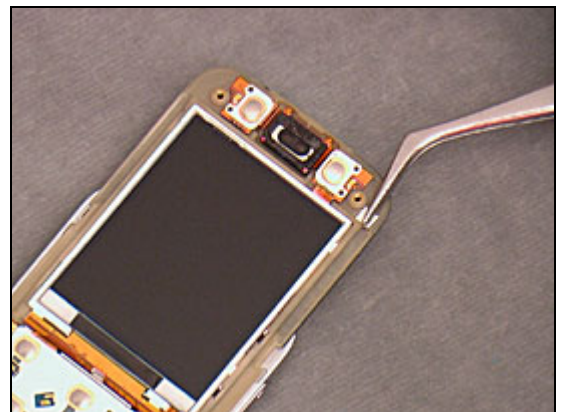


### Installation

**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

Attach the new *Water Intrusion Indicator* in place and press to secure the attachment using the tweezers.

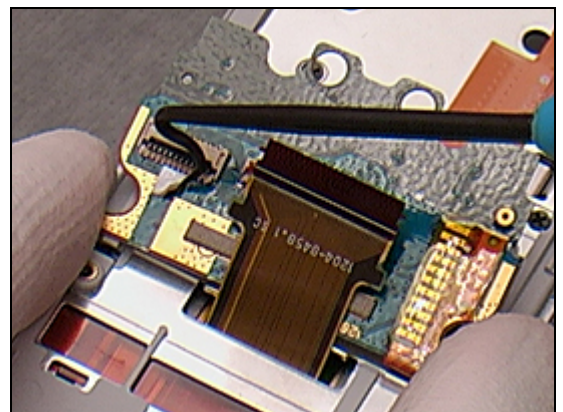
*Follow the 4.1.6 – 4.1.7 Reassembly instructions!*



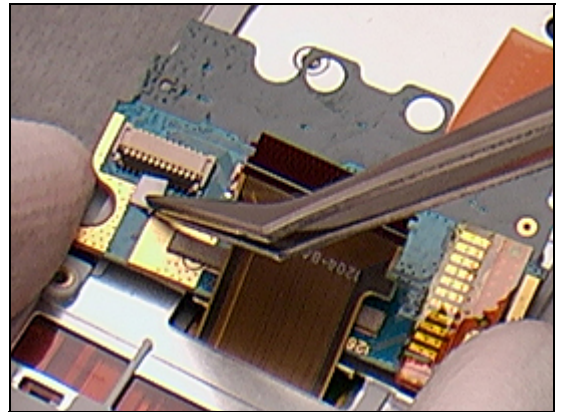
### Removal

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Loosen the *Water Intrusion Indicator* using a dentist hook.



Remove the *Water Intrusion Indicator* using the tweezers.

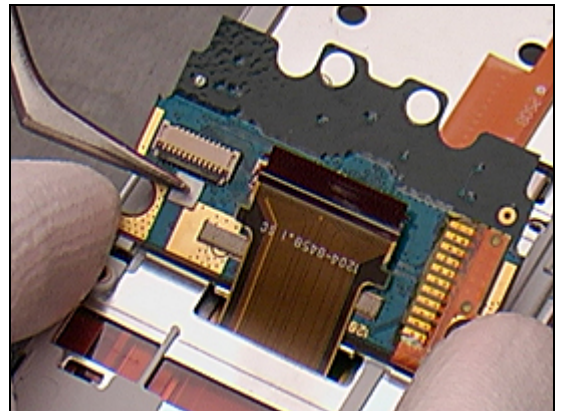


## Installation

**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

Attach the new *Water Intrusion Indicator* in place and press to secure the attachment using the tweezers.

*Follow the 4.1.5 – 4.1.7 Reassembly instructions!*



## Removal

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Loosen the *Water Intrusion Indicator* using a dentist hook



Remove the *Water Intrusion Indicator* using the tweezers.



## Installation

**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

Attach the new *Water Intrusion Indicator* in place and press to secure the attachment using the tweezers.

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*



## 3.12 A Key

### Removal

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

Remove the A Key using the tweezers.



### Installation

Position the A Key into place and press to secure it in position using the tweezers.

*Follow the 4.1.6 – 4.1.7 Reassembly instructions!*



### 3.13 B Key

#### Removal

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

Remove the *B* Key using the tweezers



#### Installation

Position the *B* Key into place and press to secure it in position using the tweezers.

*Follow the 4.1.6 – 4.1.7 Reassembly instructions!*

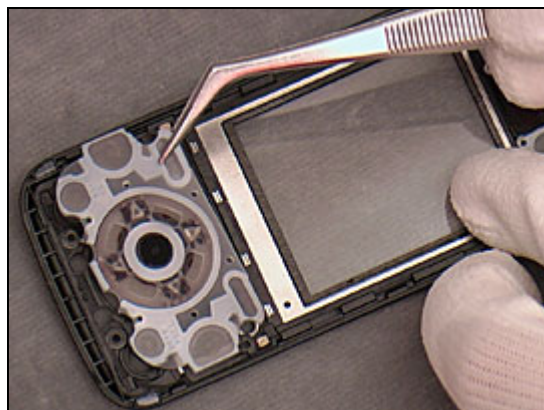


## 3.14 Navi Keypad

### Removal

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

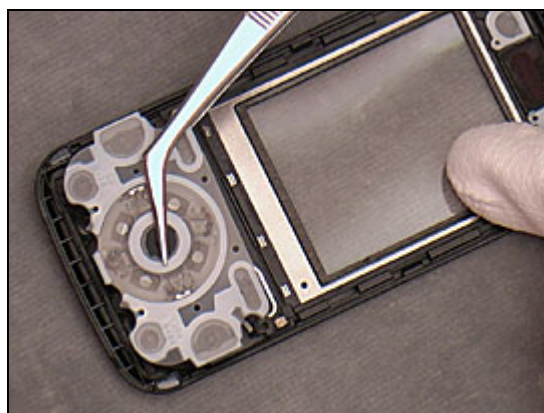
Remove the *Navi Keypad* using the tweezers.



### Installation

Position the *Navi Keypad* into place and press to secure it in position using the tweezers.

*Follow the 4.1.6 – 4.1.7 Reassembly instructions!*

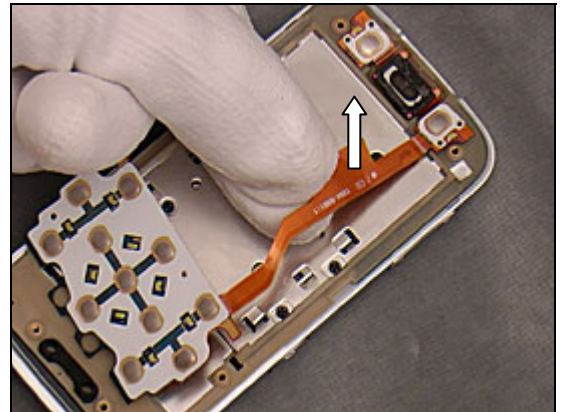


## 3.15 Keyboard PBA Assembly

### Removal

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

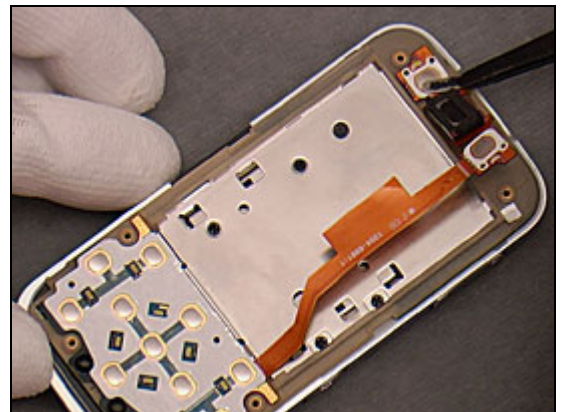
Peel off the *Keyboard PBA Assembly* using fingers.



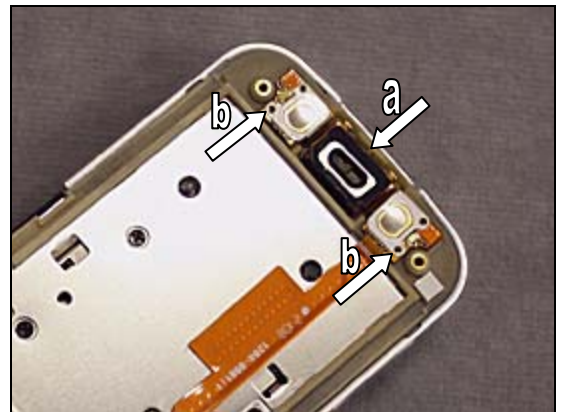
### Installation

**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

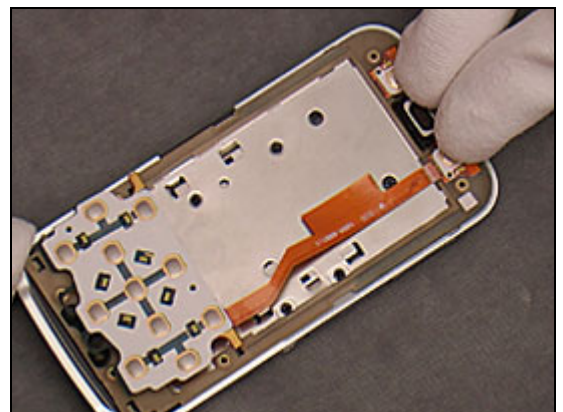
Attach a new *Keyboard PBA Assembly* in place using the flex film assembly tool.



Check the alignment (a) and (b) as shown by the arrows.

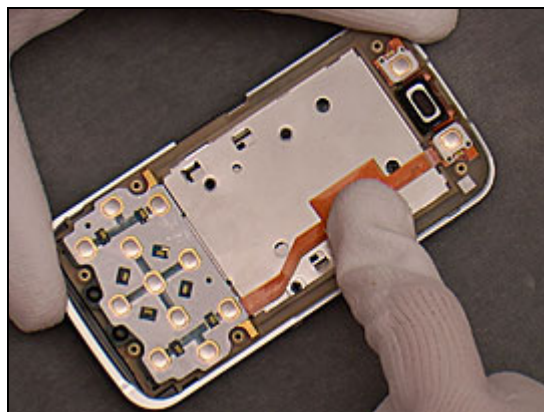


Press the *Keyboard PBA Assembly* to secure the attachment using fingers as shown in the picture.



Press the *Keyboard PBA Assembly* to secure the attachment using fingers as shown in the picture.

*Follow the 4.1.5 – 4.1.7 Reassembly instructions!*



## 3.16 Decoration Sheet

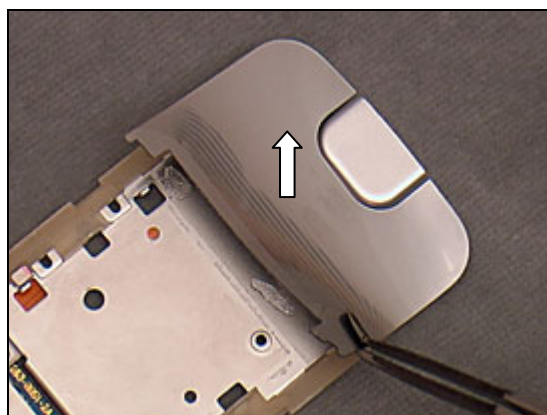
### Removal

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

Loosen the *Decoration Sheet* using a dentist hook.



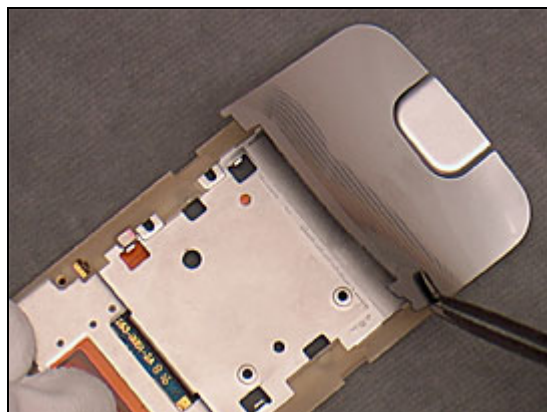
Peel off the *Decoration Sheet* using the flex film assembly tool.



### Installation

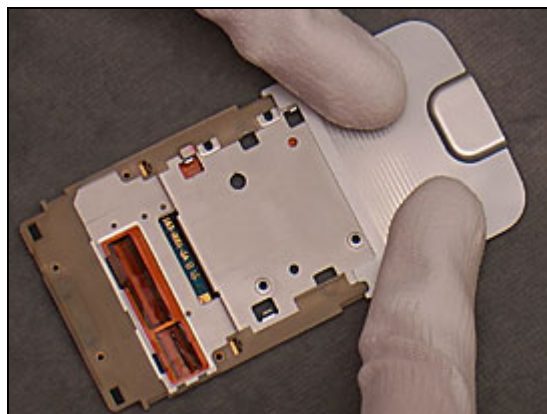
**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

Place a new *Decoration Sheet* in place using the flex film assembly tool.



Press the *Decoration Sheet* around using fingers to secure the attachment.

*Follow the 4.1.4 – 4.1.7 Reassembly instructions!*

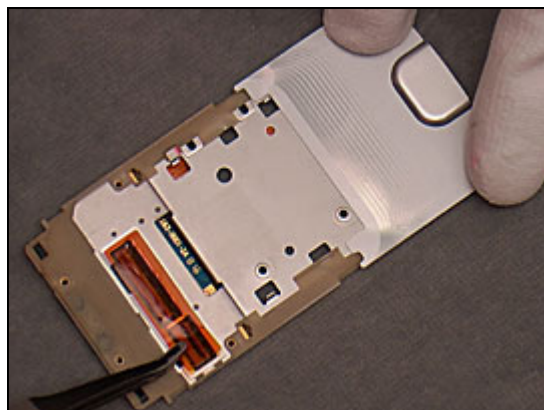


## 3.17 Insulation Tape

### Removal

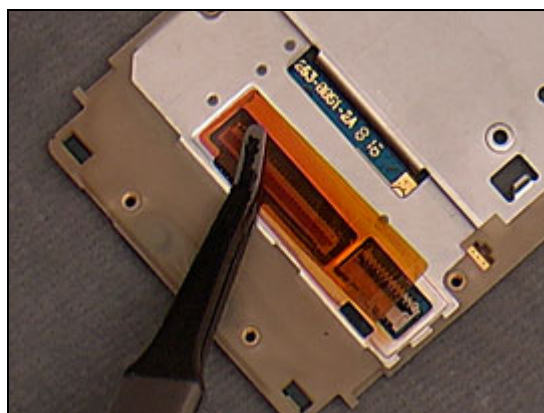
*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

Peel off the *Insulation Tape* using the flex film assembly tool.



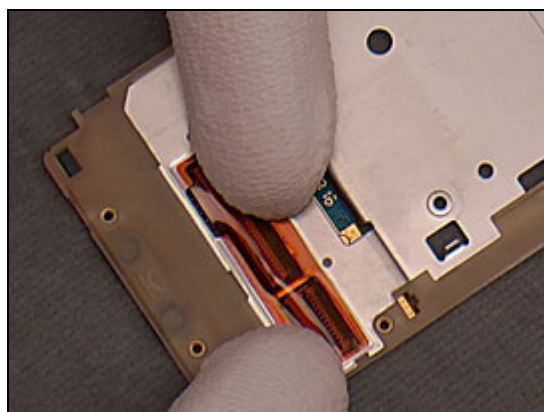
### Installation

Place a new *Insulation Tape* in position.



Press on the *Insulation Tape* to secure the attachment.

*Follow the 4.1.4 – 4.1.7 Reassembly instructions!*



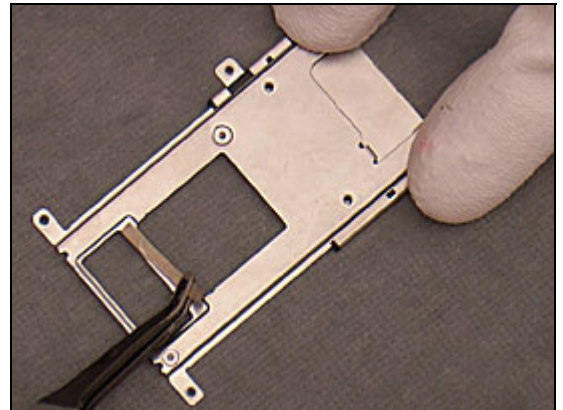


### 3.18 Conductive Gasket for H-H FPC

#### Removal

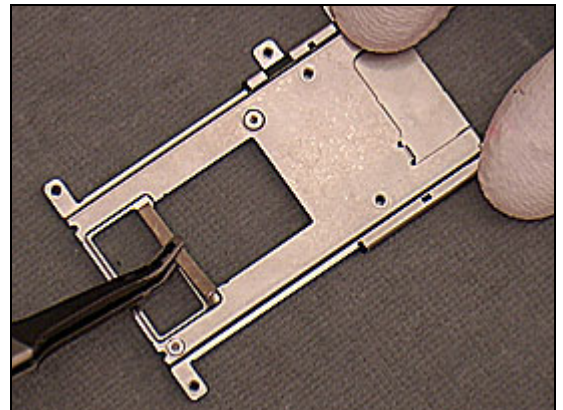
*Follow the 2.1.1 – 2.1.5 Disassembly instructions!*

Loosen and remove the *Conductive Gasket for H-H FPC* using the flex film assembly tool.



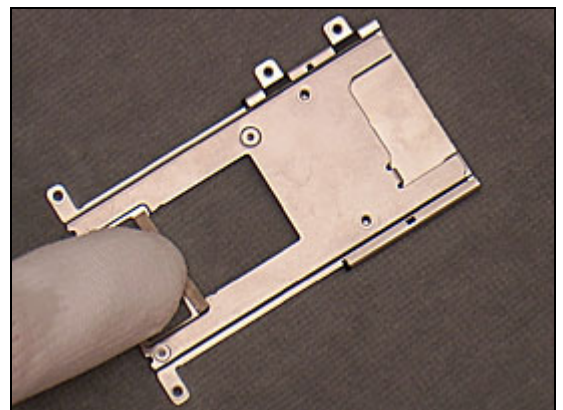
#### Installation

Position a new *Conductive Gasket for H-H FPC* in place using the flex film assembly tool.



Press to secure the attachment.

*Follow the 4.1.3 – 4.1.7 Reassembly instructions!*





### 3.19 Protection Foil for Connector

#### Removal

Follow the 2.1.1 – 2.1.5 Disassembly instructions!

Loosen the *Protection Foil* using the flex film assembly tool.

**NOTE: BE CAREFUL NOT TO DAMAGE THE H-H FPC DURING THE OPERATION.**

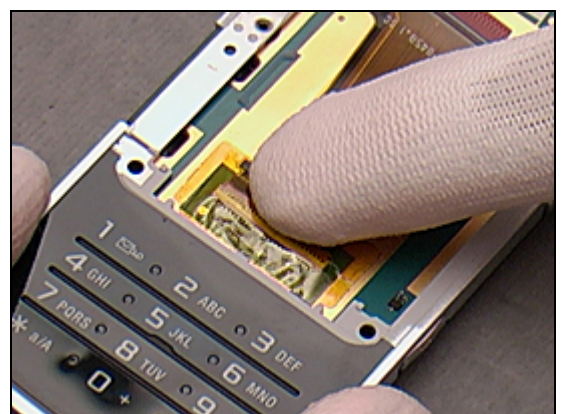
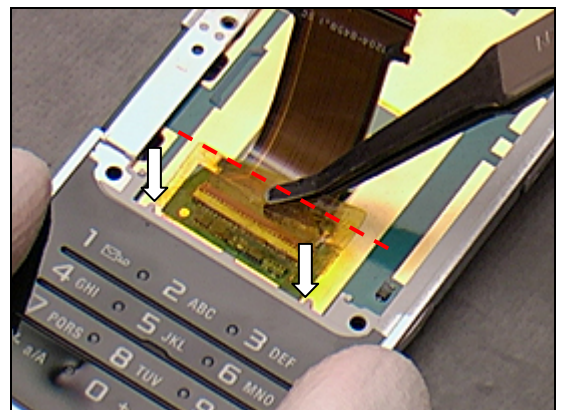
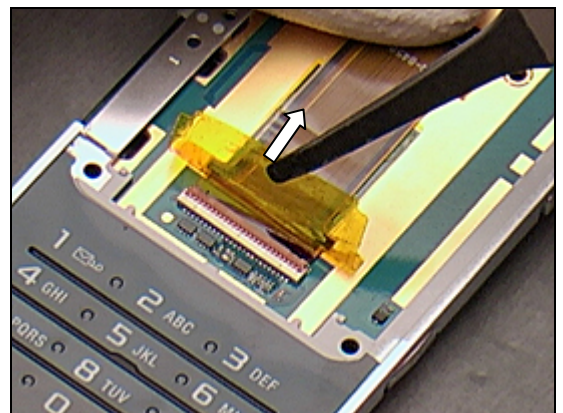
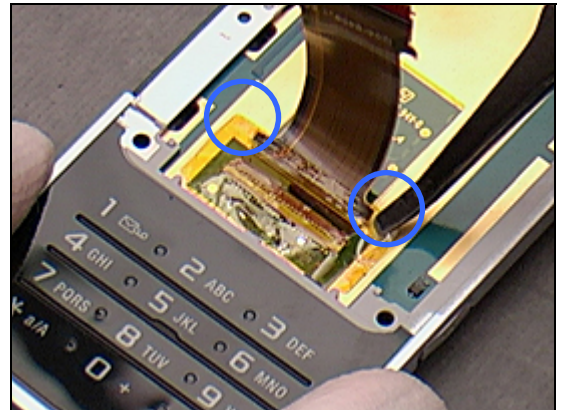
Carefully peel off the *Protection Foil* by the arrow using the flex film assembly tool.

#### Installation

Check the alignment as shown by the arrows and place the *Protection Foil* in position by the guiding line.

Press to secure the attachment.

Follow the 4.1.3 – 4.1.7 Reassembly instructions!



## 3.20 H-H FPC

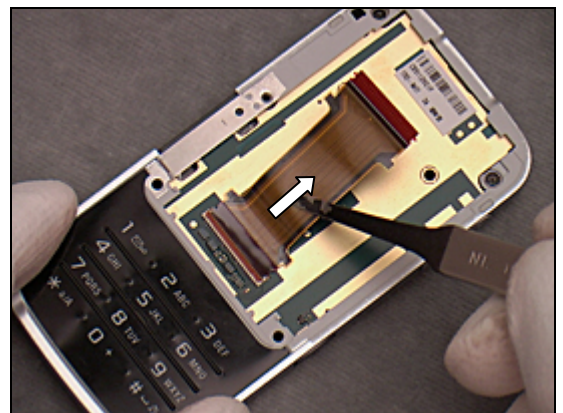
### Removal

*Follow the 2.1.1 – 2.1.5 Disassembly instructions!  
Follow the 3.20 Removal instructions!*

Unlock the *H-H PFC* connector using the front opening tool.



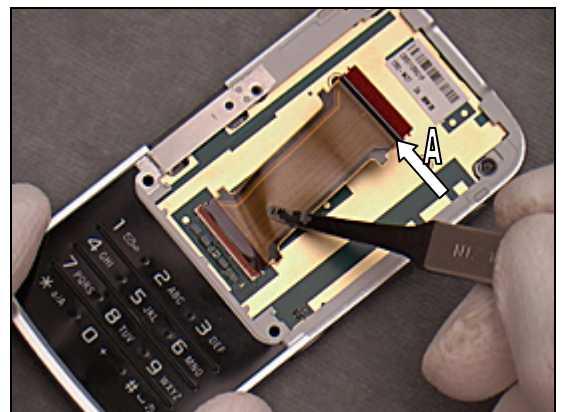
Remove the *H-H FPC* using the flex film assembly tool.



### Installation

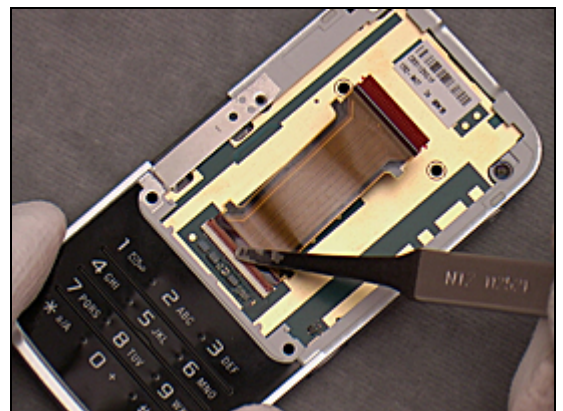
**NOTE: IDENTIFY THE LOCATION MARKER (A) AS SHOWN BY THE ARROW.**

Connect the end without the location marker to the connector on the *PCBA* using a flex film assembly tool as shown in the picture.



Lock the connector by turning and pressing the locking bar using the flex film assembly tool.

*Follow the 3.20 Installation instructions!  
Follow the 4.1.3 – 4.1.7 Reassembly instructions!*



## 3.21 Protection Foil for Test Point

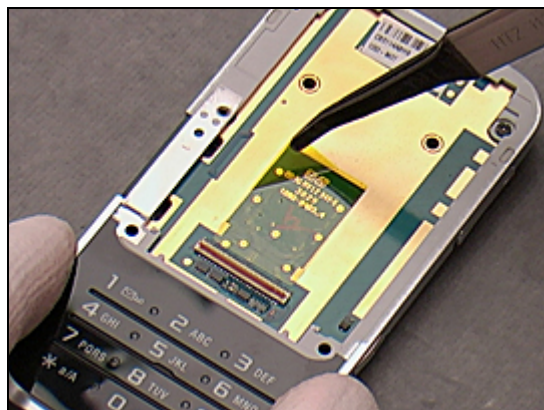
### Removal

*Follow the 2.1.1 – 2.1.5 Disassembly instructions!*

*Follow the 3.20 Removal instructions!*

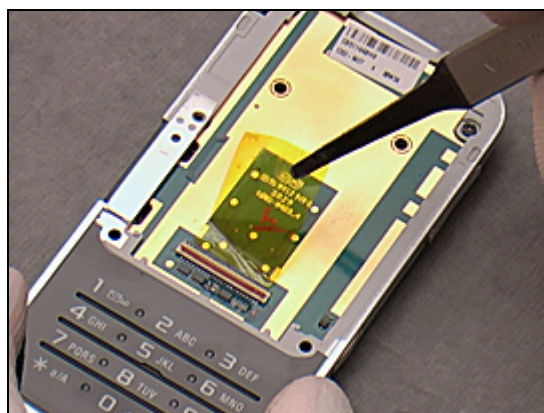
*Follow the 3.21 Removal instructions!*

Peel off the *Protection Foil* using the flex film assembly tool.



### Installation

Place a new *Protection Foil* in position as shown in the picture.

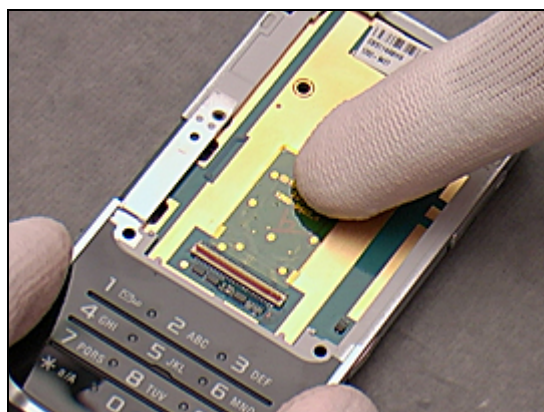


Press to secure the attachment.

*Follow the 3.21 Installation instructions!*

*Follow the 3.20 Installation instructions!*

*Follow the 4.1.3 – 4.1.7 Reassembly instructions!*

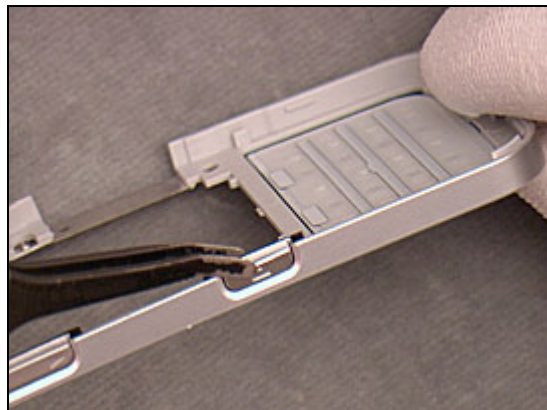


## 3.22 Camera Key

### Removal

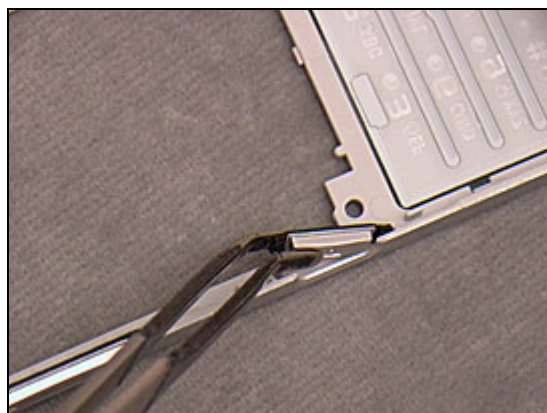
*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

Remove the *Camera Key* using the flex film assembly tool.



### Installation

Position a new *Camera Key* in place using the flex film assembly tool.



Press to secure the *Camera Key* using the flex film assembly tool.

*Follow the 4.1.2 – 4.1.7 Reassembly instructions!*



## 3.23 Volume Key

### Removal

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

Remove the *Volume Key* using the flex film assembly tool.



### Installation

Position the *Volume Key* in place using the flex film assembly tool.



Press to secure the *Volume Key* in place using the flex film assembly tool.

*Follow the 4.1.2 – 4.1.7 Reassembly instructions!*



## 3.24 M2 Cover

### Removal

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

Remove the *M2 Cover* using the flex film assembly tool.



### Installation

Position a new *M2 Cover* in place using the flex film assembly tool.



Press to secure the *M2 Cover* using a flex film assembly tool.

*Follow the 4.1.2 – 4.1.7 Reassembly instructions!*

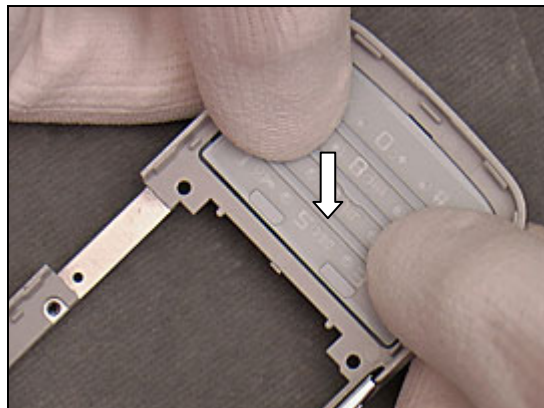


## 3.25 Keypad

### Removal

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

Loosen the *Keypad* by pressing from back using fingers.



Remove the *Keypad* using a flex film assembly tool.



### Installation

**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

Place a new *Keypad* into position using the flex film assembly tool.



Press around the *Keypad* to secure the attachment using fingers.

*Follow the 4.1.2 – 4.1.7 Reassembly instructions!*

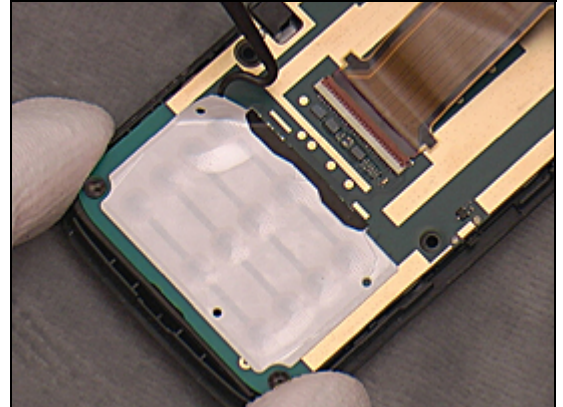


## 3.26 Main Key Dome Assembly

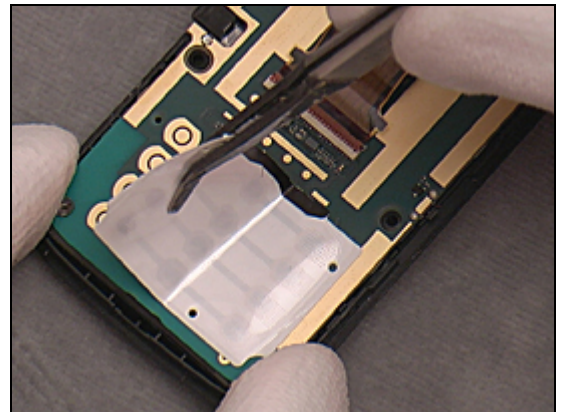
### Removal

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

Loosen the *Main Key Dome Assembly* using a dentist hook.



Peel off the *Main Key Dome Assembly* using a flex film assembly tool.

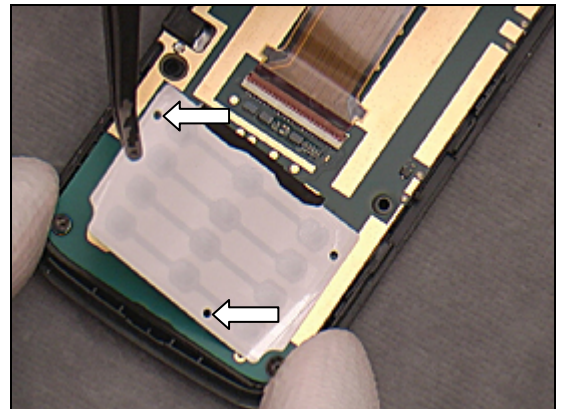


### Installation

**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

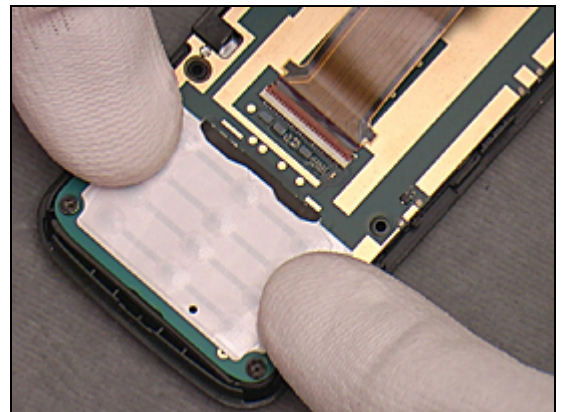
Attach a new *Main Key Dome Assembly* to the *PCBA* using a flex film assembly tool.

**NOTE: MAKE SURE THAT THE TWO HOLES ON THE MAIN KEY DOME ASSEMBLY CORRESPOND TO THE TWO GUIDING HOLES ON THE PCBA.**



Press around the *Main Key Dome Assembly* to secure its attachment.

*Follow the 4.1.2 – 4.1.7 Reassembly instructions!*



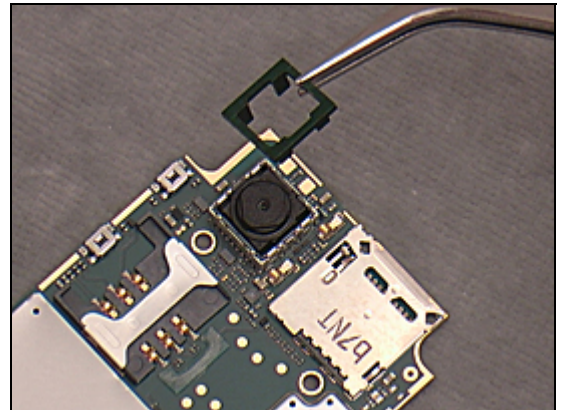


## 3.27 Camera Module

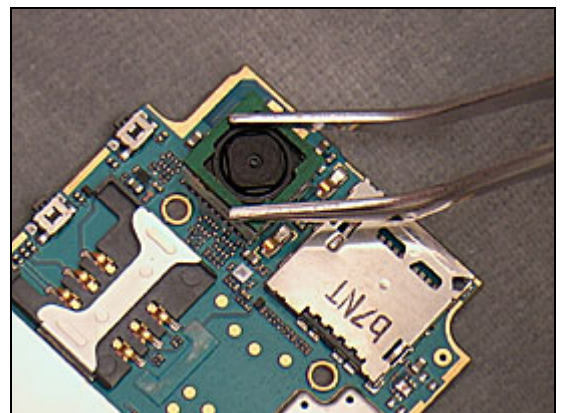
### Removal

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

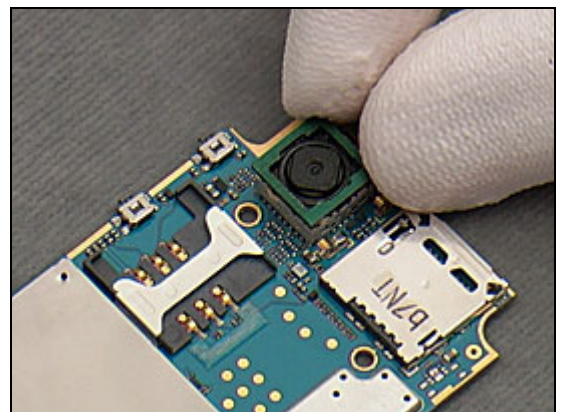
Place the camera removal tool onto socket using the tweezers as shown in the picture.



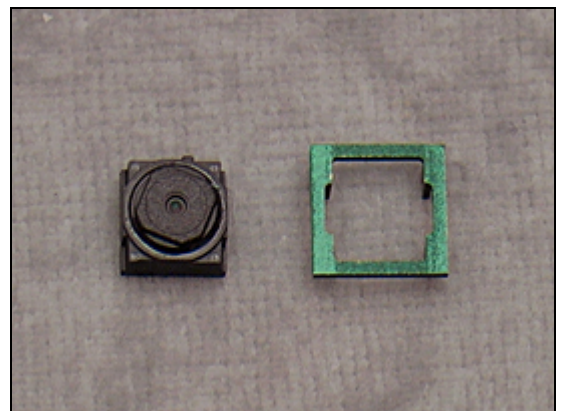
Press down the camera removal tool to the bottom of the camera socket.



Remove the *Camera Module* by lifting straight up.



The *Camera Module* and the camera removal tool separated.

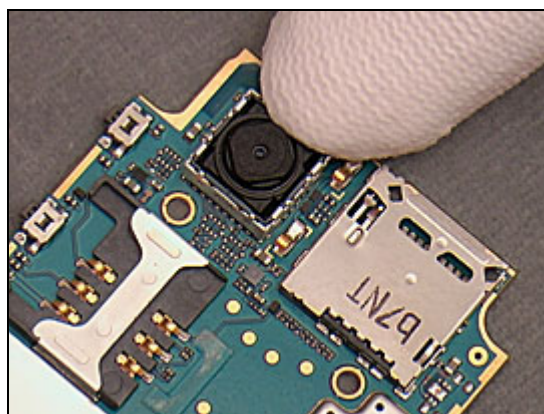
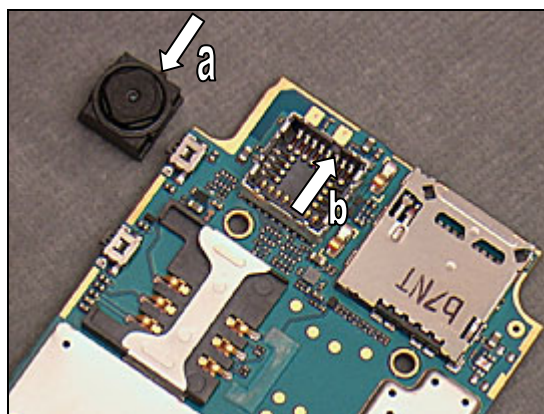


## Installation

Make sure the orientation of the camera and socket: camera pin (a) into socket slot (b) when installing the *Camera Module*.

Place the *Camera Module* into socket and press down on each edge to secure its position.

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*

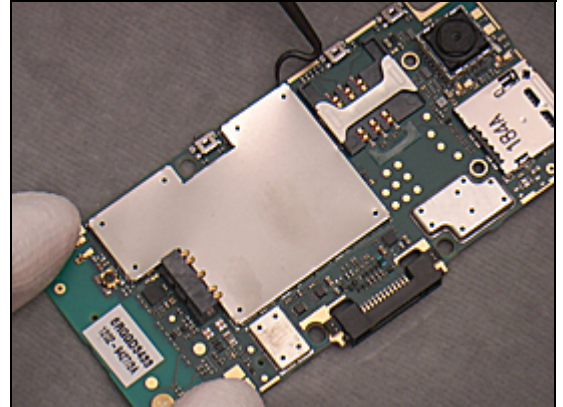


## 3.28 BB Shield Can Lid

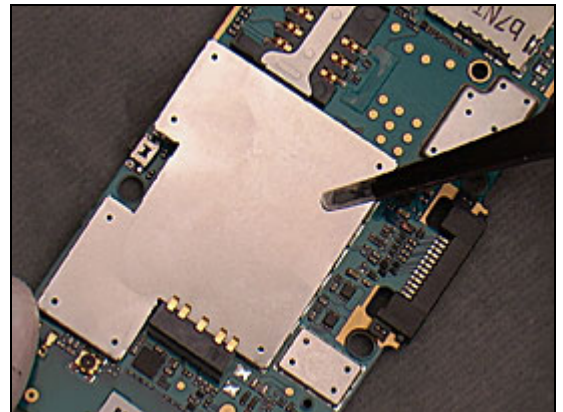
### Removal

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Loosen each corner of the *BB Shield Can Lid* using the dentist hook.

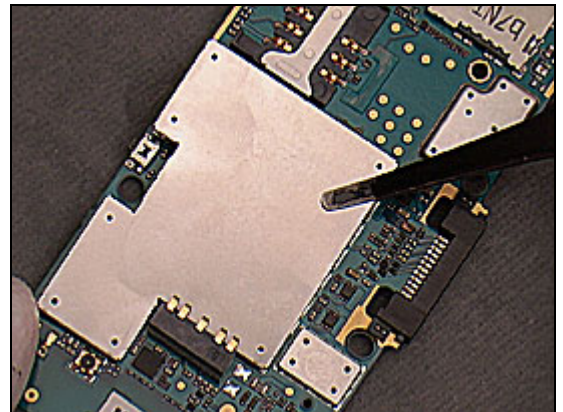


Remove the *BB Shield Can Lid* using the flex film assembly tool.



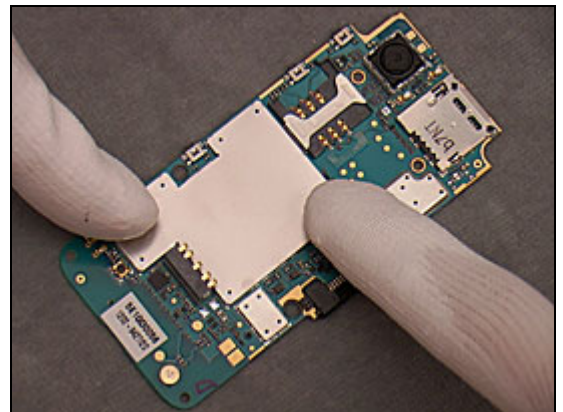
### Installation

Position a new *BB Shield Can Lid* in place using the flex film assembly tool.



Press down on each corner of the *BB Shield Can Lid* to secure the snap hooks

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*

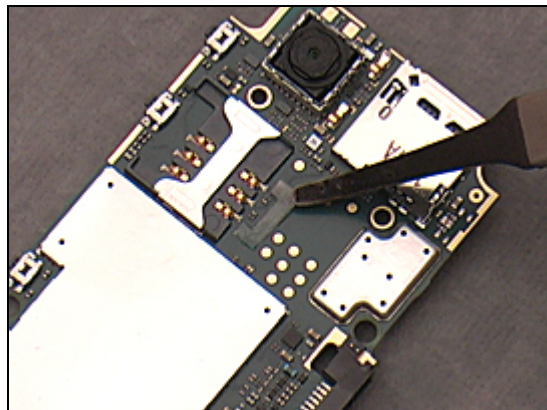


## 3.29 Space Cover

### Removal

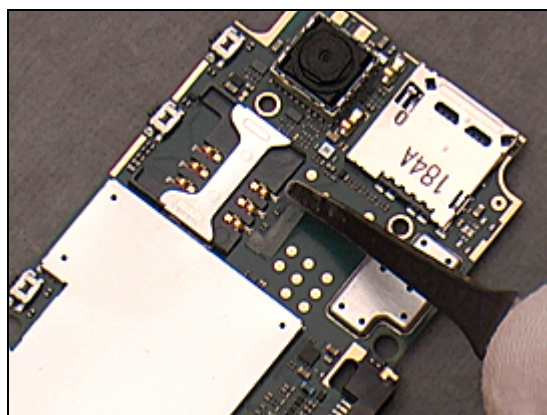
*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Loosen and remove the *Space Cover* using the flex film assembly tool.



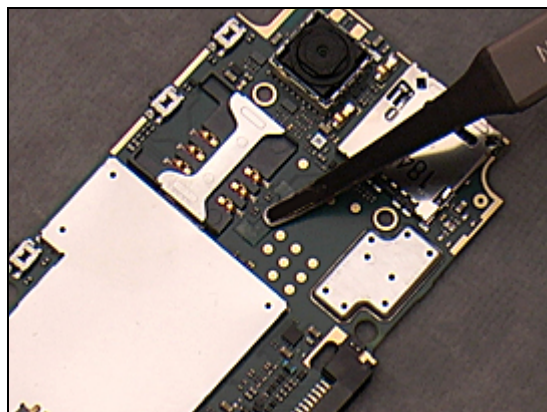
### Installation

Position a new *Space Cover* in place using the flex film assembly tool.



Press to secure the attachment.

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*



### 3.30 BT Antenna and Speaker Assembly

#### Removal

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Unsnap the *BT Antenna and Speaker Assembly* using the front opening tool.



Remove the *BT Antenna and Speaker Assembly* using fingers.



#### Installation

Position a new *BT Antenna and Speaker Assembly* in place using fingers.



Press down the *BT Antenna and Speaker Assembly* to secure the snap hooks.

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*



### 3.31 Main Antenna and Speaker Assembly

#### Removal

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Unsnap the *Main Antenna and Speaker Assembly* using the front opening tool.

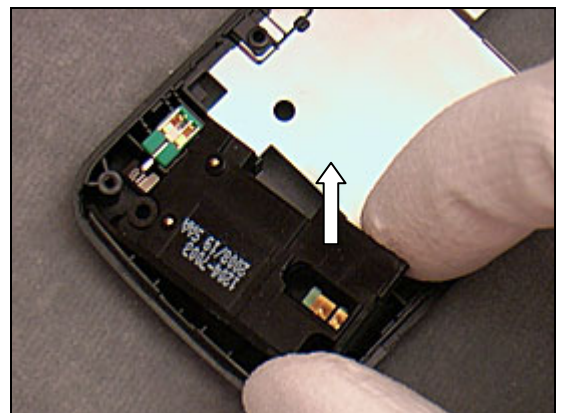
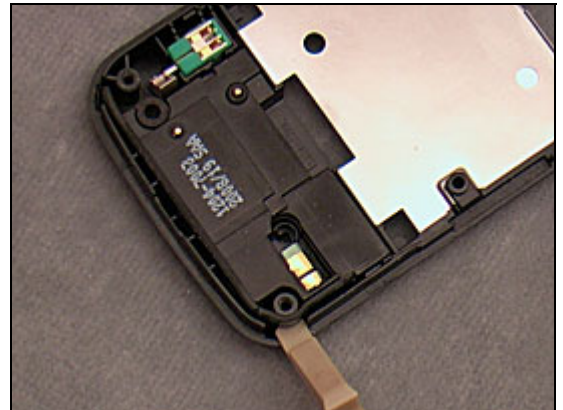
Remove the *Main Antenna and Speaker Assembly* using fingers.

#### Installation

Position a new *Main Antenna and Speaker Assembly* in place.

Press down the *Main Antenna and Speaker Assembly* to secure the snap hook.

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*

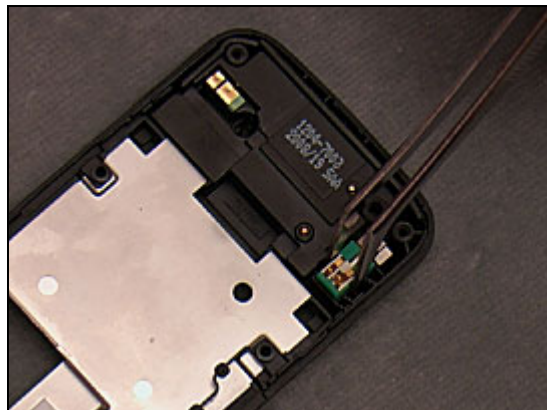


## 3.32 Vibrator

### Removal

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Remove the *Vibrator* using the tweezers.



### Installation

Place a new *Vibrator* in position and press it to the bottom of its cavity using the tweezers.

*Follow the 4.1.1 – 4.1.7 Reassembly instructions!*

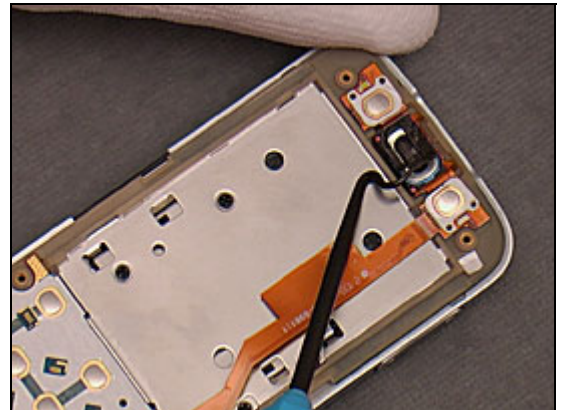


### 3.33 Double Side Receiver Adhesive

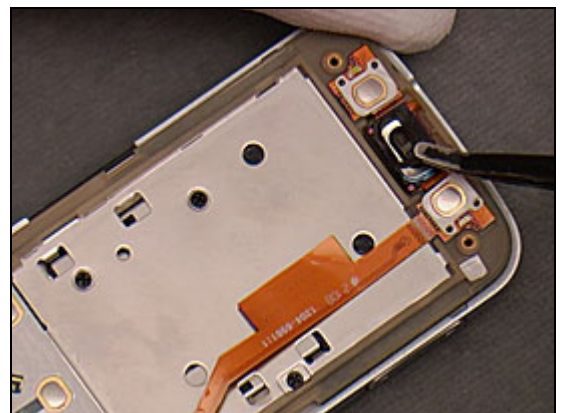
#### Removal

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Loosen the *Double Side Receiver Adhesive* using a dentist hook.



Peel off the *Double Side Receiver Adhesive* using the flex film assembly tool.



#### Installation

**NOTE: IF NECESSARY, FIRST CLEAN THE SURFACE WITH ISOPROPYL ALCOHOL.**

Position a new *Double Side Receiver Adhesive* in place using the flex film assembly tool.



Press the *Double Side Receiver Adhesive* using fingers to secure the attachment.

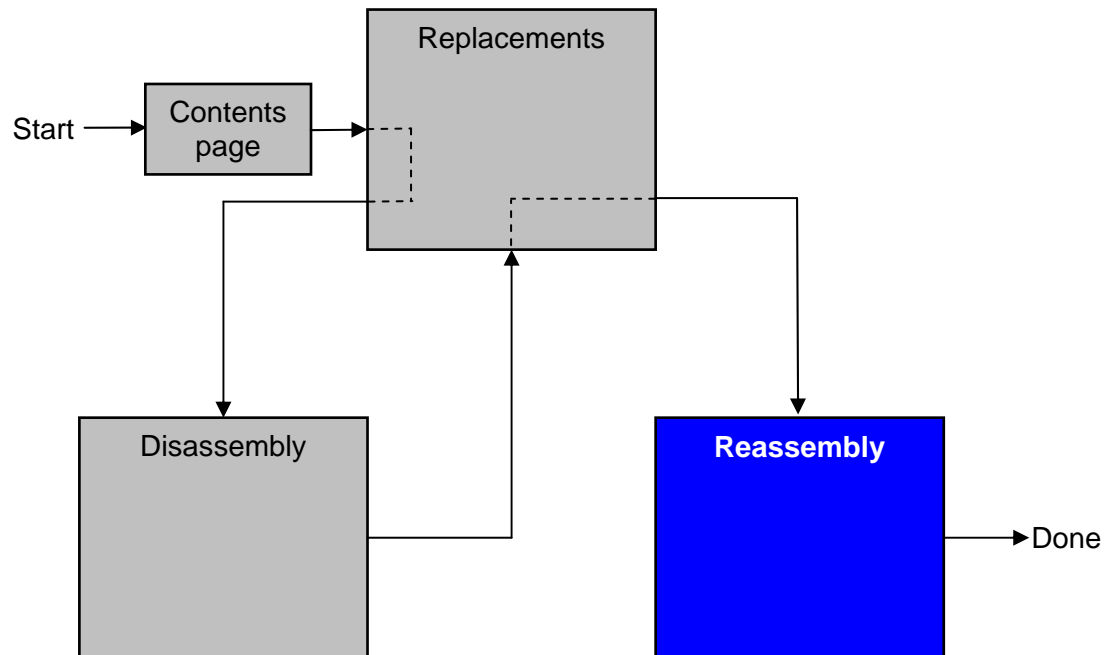
*Follow the 4.1.5 – 4.1.7 Reassembly instructions!*





## 4 Reassembly

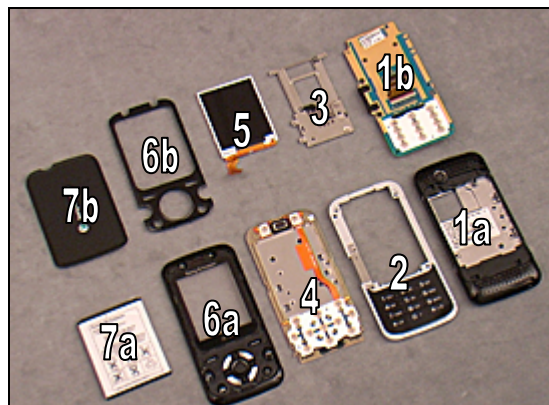
After replacing a part being listed in Replacements, the instruction of that section usually ends by directing you to this Reassembly section with a specification of the instructions you have to carry out in order to reassemble the phone.



## 4.1 Overview

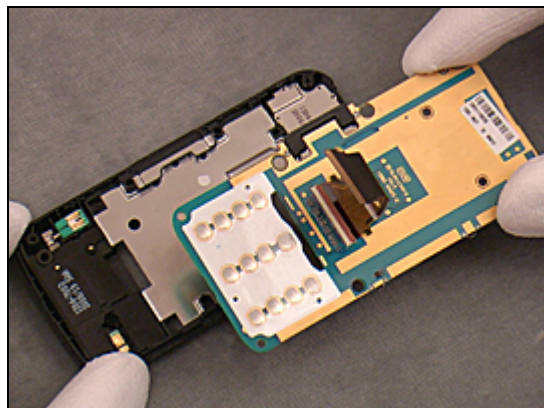
Reassemble the phone in the following sequence:

1. Lower Rear Cover (a) and PCBA (b)
2. Lower Front Cover
3. Hinge Assembly
4. Upper Rear Cover
5. LCD TFT 2.0
6. Upper Front Cover Assembly (a) and  
Style Upper Cover (b)
7. Battery (a) and Battery Cover (b)



### 4.1.1 PCBA and Lower Rear Cover

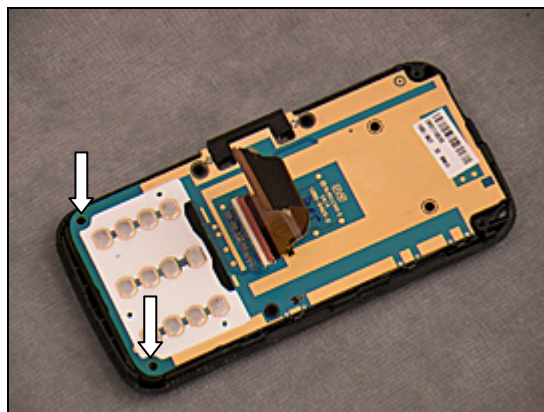
Place the *PCBA* onto the *Lower Rear Cover*.



Press to snap it using fingers.



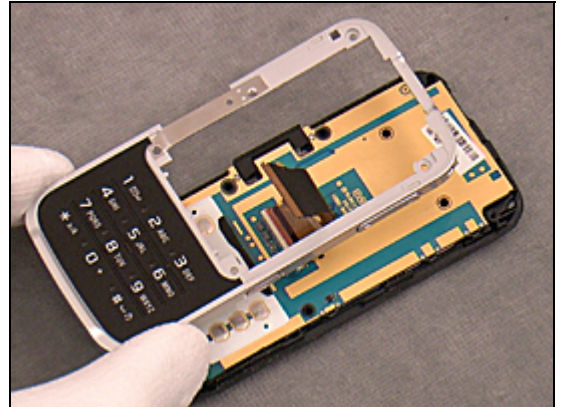
Tighten these two *Screws* (M1.7x5) using torx bit no. 4 to a torque of 17 Ncm.



## 4.1.2 Lower Front Cover

**NOTE: MAKE SURE ALL THE SIDE KEYS ARE IN POSTION.**

Place the *Lower Front Cover* onto the *Lower Rear Cover*.



Press to snap it until the two covers are jointed without any gaps.



Tighten the two Screws (M1.7x5) using torx bit no. 4 to a torque of 17 Ncm.



### 4.1.3 Hinge Assembly

**NOTE: MAKE SURE THE HINGE ASSEMBLY IS IN ITS OPEN POSITION.**

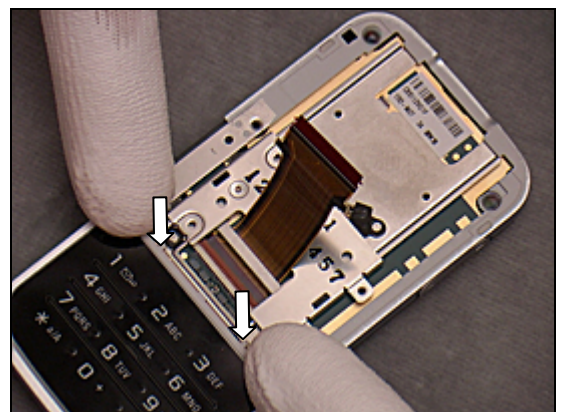
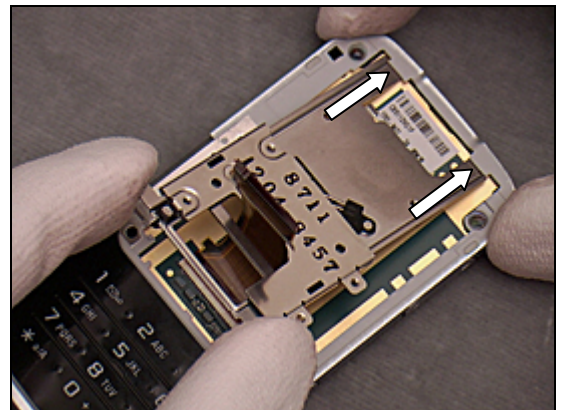
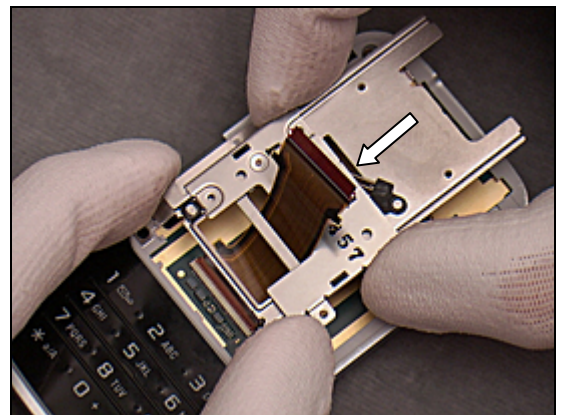
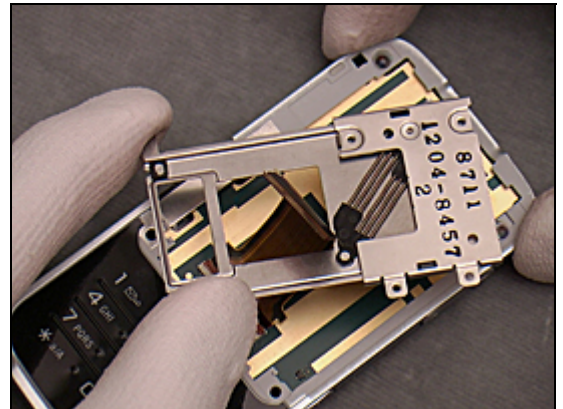
Carefully thread the *H-H FPC* into the *Hinge Assembly* as shown in the picture.

**NOTE: BE CAREFUL NOT TO DAMAGE THE H-H FPC DURING THE OPERATION.**

Carefully slide the *Hinge Assembly* to its close position as shown in the picture.

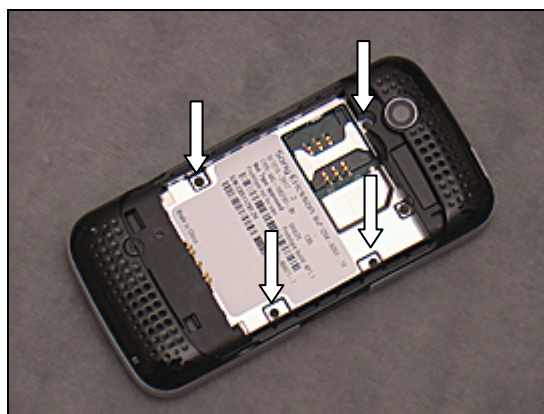
Hold the *Hinge Assembly* and insert the two tabs into the slots on the top of the *Lower Front Cover* as shown in the picture.

Check the alignment as shown by the arrows and press the *Hinge Assembly* to snap it in position.



Turn the phone over.

Tighten these four Screws (M1.4x3.5) using the JCIS No.0 Screw Bit to a torque of 10 Ncm.



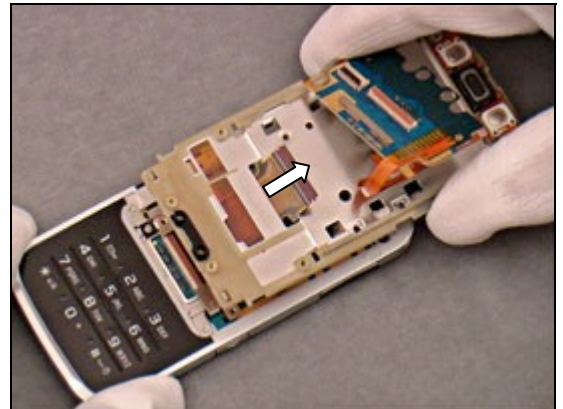
Tighten the Screw (M1.4x2.8) using the JCIS No.0 Screw Bit to a torque of 10 Ncm.



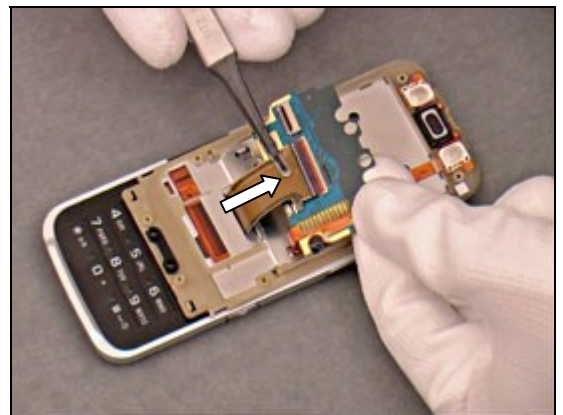


#### 4.1.4 Upper Rear Cover

Carefully thread the *H-H FPC* into the *Upper Rear Cover*.



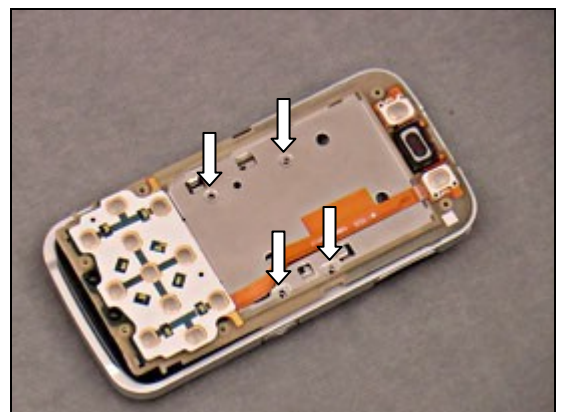
Connect the *H-H FPC* to the connector on the back of the *Keyboard PBA Assembly* using the flex film assembly tool.



Lock the connector by turning and pressing the locking bar using the flex film assembly tool.

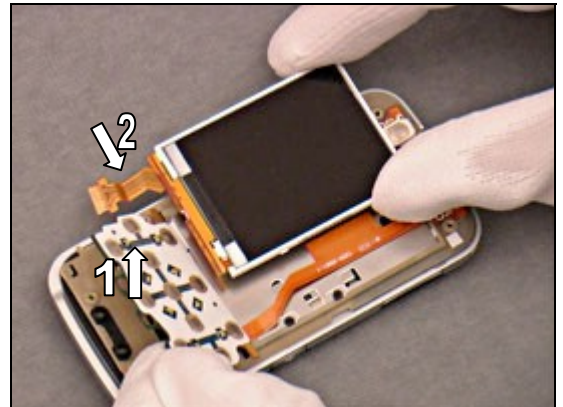


Check the alignment and tighten the four *Screws* (M1.4x1.5) using a JCIS No.0 Screw Bit to a torque of 10 Ncm.



#### 4.1.5 LCD TFT 2.0

Lift up the *Keypad PBA Assembly* (1) and carefully move the *LCD TFT 2.0* to slide the *LCD FPC* into the slot (2) as shown in the picture.

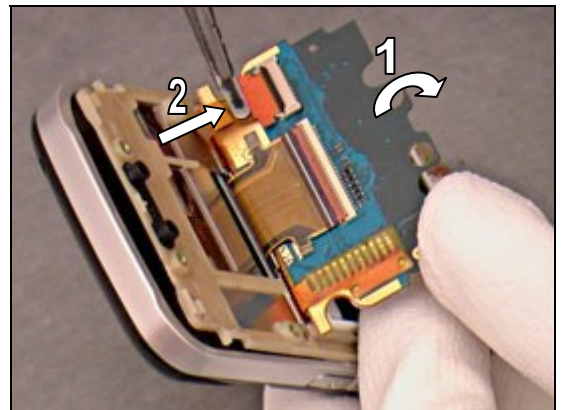


Place the *LCD TFT 2.0* into the *Upper Rear Cover* and press to snap it in position.

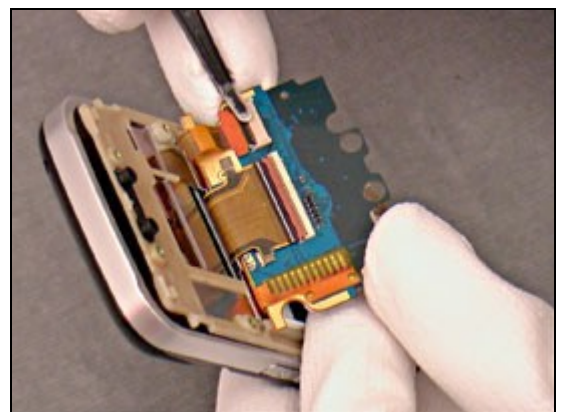


Carefully fold the *Keyboard PBA Assembly* (1) open and connect the *LCD FPC* (2) to the connector using the flex film assembly tool.

**NOTE: INSERT THE FPC TO THE BOTTOM OF THE CONNECTOR.**



Lock the connector by turning and pressing the locking bar using the flex film assembly tool.



Press the *Keyboard PBA Assembly* to snap it in position.



#### 4.1.6 Upper Front Cover Assembly and Style Upper Cover

**NOTE: MAKE SURE THE A KEY, B KEY AND NAVI KEYPAD ARE IN POSITION.**

Place the phone onto the *Upper Front Cover Assembly*.



Press around all sides of the *Lower Rear Cover* to snap the hooks.



Turn the phone over.  
Press around all sides of the *Upper Front Cover* until the two covers are joined without any gaps.



Tighten the six *Screws (M1.4x2.0)* using the JCIS No.0 Screw Bit to a torque of 10 Ncm.



Hold the bottom of the *Style Upper Cover* and insert the tabs into the slots on the top of the *Upper Front Cover*.



Press the *Style Upper Cover* to snap the remaining sides of the *Style Upper Cover* until the two covers are joined without any gaps.



### 4.1.7 Battery and Battery Cover

Place the *Battery* into its cavity.



Press it into position using fingers.



Insert the *Battery Cover*.



Press to secure the *Battery Cover*.



## 5 Country of Origin Barcodes for Brazil/VIVO Labels

Below is a link to a list of countries of origin. If you are printing a Brazil or VIVO label, scan the barcode corresponding to the correct country of origin for the “Fabricado” field.



## 6 Revision History

Rev.	Date	Changes / Comments
1	2008-10-10	1 <sup>st</sup> release of the document
2	2008-12-12	Update process
3	2008-12-31	Add 3.33
4	2009-01-20	Add the 5th chapter