

Working Instructions

- mechanical -



Xperia XZ1

G8341, G8342 (Dual SIM), G8343

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General Notes

For general information about mechanical repair related issues, refer to 000154064: Generic Repair Manual - mechanical (in RE4250: Repair - Mechanical - Repair instructions).

Always firstly disconnect the Battery FPC BtoB connector to cut off power supply when the Plate Display is disassembled.

Always finally connect the Battery FPC BtoB connector before the Plate Display is reassembled.

After repairing/reassembling the unit, calibration by CS-Everest, and flashing software Customize by Emma is required.

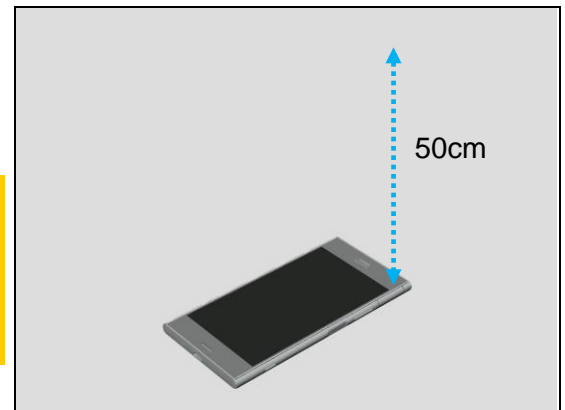
Calibration tool "CS-Everest 1309-7255" is available at Repair Information (in RE4251: Repair - Mechanical - Tools and Equipment (including Repair Software)).

When perform calibration, put the unit on a stable place, facing up, and no objects within 50cm.

Note!

Remove the protection film if sensor window is covered by it.

The sensor window shouldn't be covered by any materials for proximity sensor calibration.



Flashing Customize or Refurbish in Emma must be performed when replace Loudspeaker and/or Speaker Box.

Aged Battery Reset in EMMA must be performed when Battery is replaced (installed brand new Battery) in order to delete battery log data.

Camera (both Main Camera and Front Camera) is sensitive for the dust.

Don't touch the lens area of the camera during repairing.

1 Exterior Views

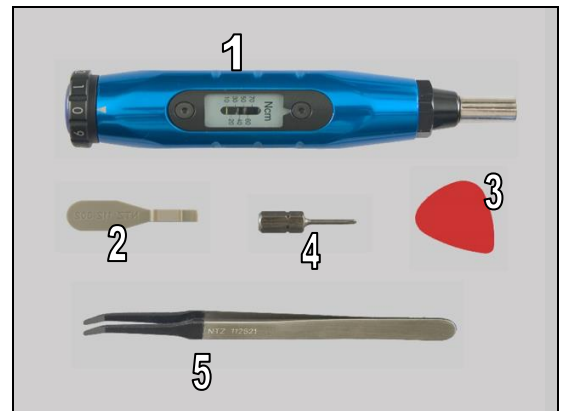
G8341, G8342, G8343



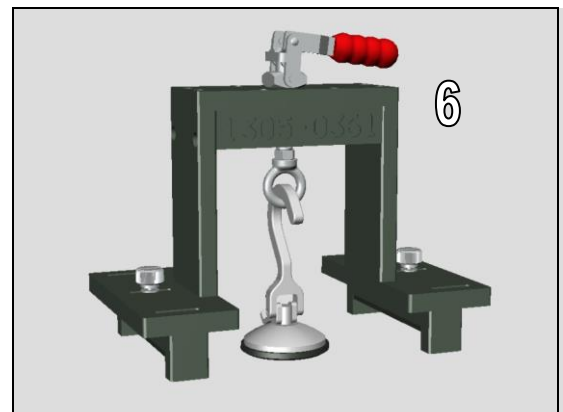
2 Tools

SPECIAL TOOLS

1. Torque Screwdriver 2-30Ncm (1233-2284)
2. Front Opening Tool (NTZ 112 302/2)
3. Guitar Pick (NTZ 112 590)
4. Bits (JCIS No 0) (NTZ 112 1052)
5. Flex Film Assembly Tool (NTZ 112 521)



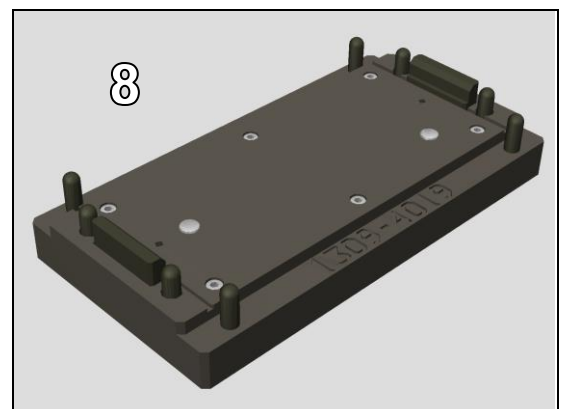
6. Panel Disassembly Tool (1305-0361)
(Including Vacuum Cup for Tool 1305-7901.)



7. Vacuum Cup for Tool (1305-7901)
(Maintenance parts for Panel Disassembly Tool 1305-0361.)

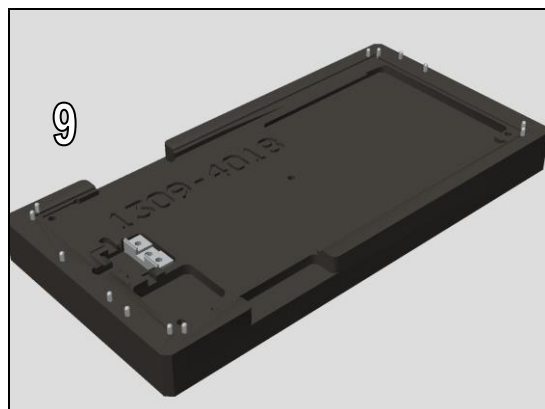


8. Window Panel Adhesive Fixture (1309-4019)



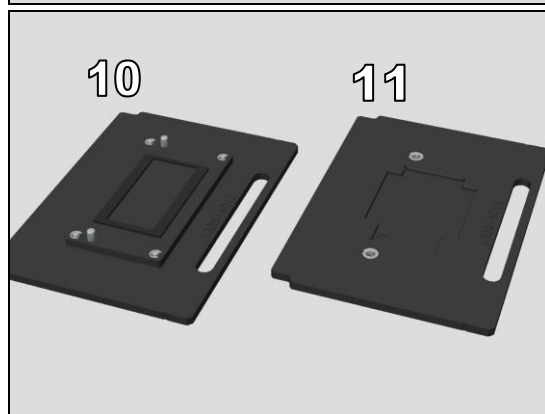
Tools

9. Adhesive Position Pin Fixture (1309-4018)



10. Panel Press Top Inlay (1309-4017)

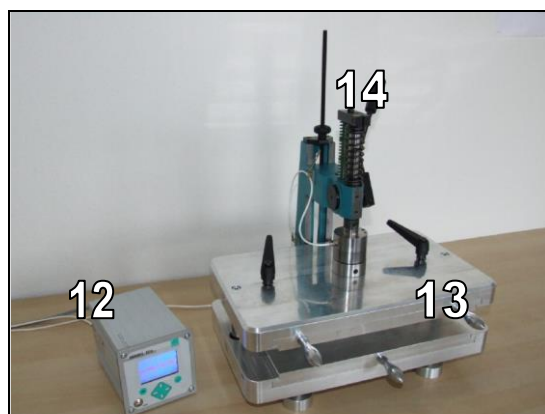
11. Bottom Press Inlay (1309-4016)



12. Load cell measurement kit (1274-3895)

13. Generic Fixture for Presstool (1273-4413)

14. Toothed Rack Press (1281-2676)

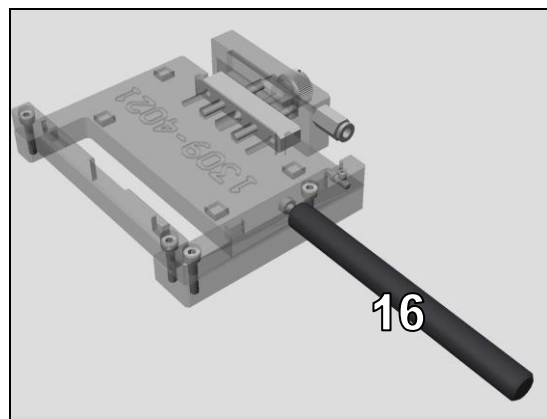


15. Media Cable TypeC Cable (Black) (1302-1935)

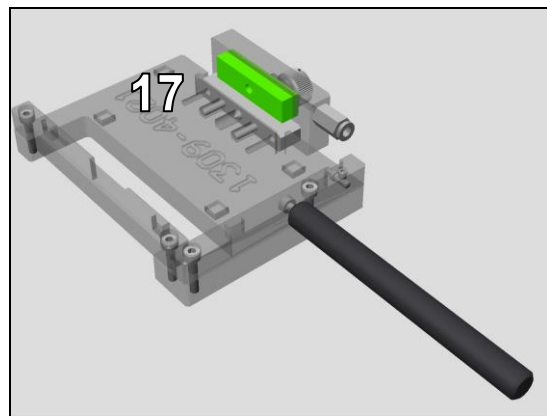


Tools

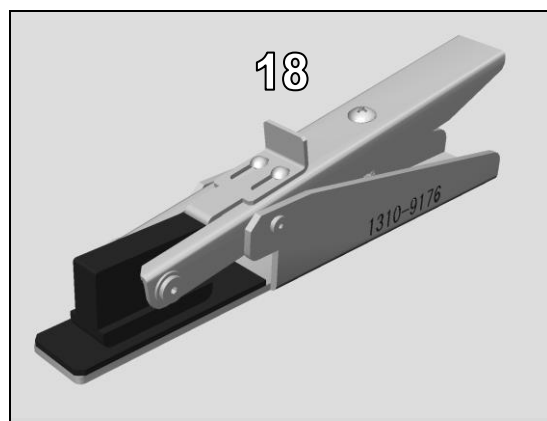
16. WRT Fixture (1309-4021)
(Includes Silicon Suction Cup (1309-4022))



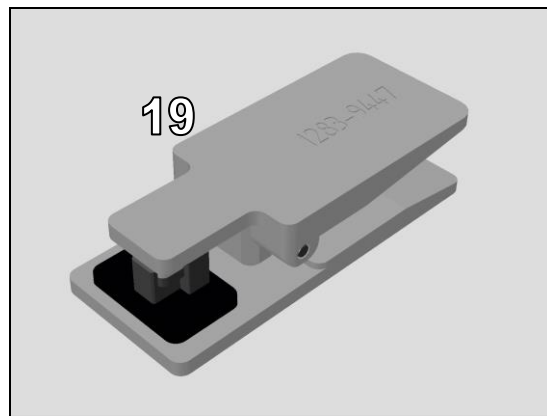
17. Silicon Suction Cup (1309-4022)
(Maintenance parts for WRT Fixture 1309-4021.)



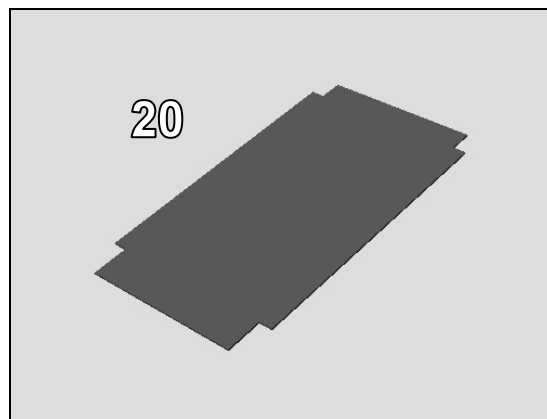
18. Press Clamp (1310-9176)
(For pressing Battery)



19. Earspeaker/Loudspeaker Top Press Tool (1283-9447)
(For pressing Loudspeaker)



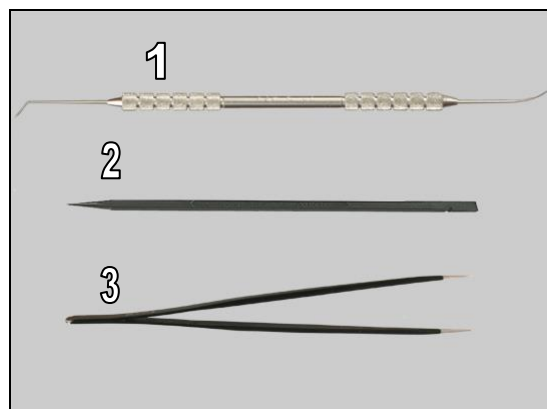
20. Disassembly Sheet (1295-5578)



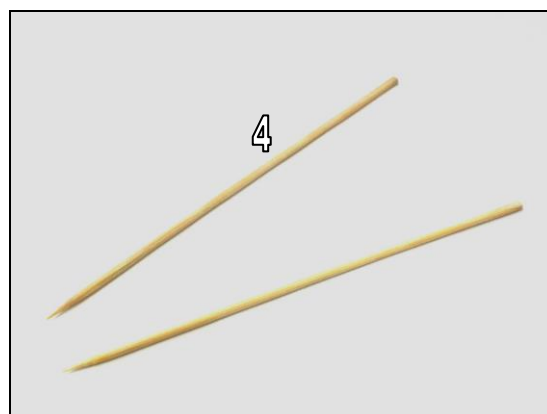
Tools

STANDARD TOOLS

1. Dentist Hook
2. Nylon Pointer
3. Tweezers



4. Bamboo Skewer



5. Screwdriver PH0 x 100



6. Tweezers (Curved Tip)



Refer to the 1003-9107 Tools Catalogue for detail of standard tools (RE4251).

3 Mandatory Replacement Parts List

The Mandatory Replacement Parts List is embedded.
Click the icon to open the file.



Targeted replacement parts are listed

Mandatory replacement part	Num	Cap Tray	Display	Speaker Top	Speaker Bottom	Antenna Main	PBA Main	Main Camera	Front Camera	Antenna Sub	PBA Sub	Audio Jack	Antenna NFC	Battery	FPC USB	FPC Key	Key Volume	Key Camera	FP Sensor	Cover M	Refurbish
Cover Main RoW Black	1310-1																				
Cover Main RoW Silver	1310-1																				
Cover Main RoW Rose	1310-1																				
Cover Main RoW Blue	1310-1																				
Cover Main India Black (For India Market)	1309-0																				
Sheet Battery Side	1309-0																				
Sheet WR Test	1307-2																				
Adhesive WR Test	1307-2																				
Antenna NFC	1307-2																				
Sheet RF Conductive NFC	1309-0																				
FP Sensor Assy Black (For Black color)	1309-0																				
FP Sensor Assy Silver (For Silver, Pink, Blue)	1309-0																				
Key Volume Black	1307-2																				
Key Volume Silver	1307-2																				
Key Volume Rose	1307-2																				
Key Volume Blue	1307-2																				
Key Camera Black	1307-2																				
Key Camera Silver	1307-2																				
Key Camera Rose	1307-2																				
Key Camera Blue	1307-2																				
FPC Key	1306-9																				
Adhesive RF Conductive Key FPC	1307-2																				
Adhesive VIB	1309-0																				
Screw M1.2x2.5	1301-0																				
FPC JK	1306-9																				
Adhesive WP Audio Jack	1306-9																				
Sheet Spacer Audio Jack	1311-2																				
FPC USB	1306-9																				
Gasket RF Conductive USB FPC	1310-7																				
Adhesive RF Conductive USB FPC Sub	1307-2																				
Sheet FPC USB	1311-2																				
Adhesive RF Conductive GND USB	1311-2																				
Battery	1307-0																				
Adhesive Battery	1307-2																				
Sheet Slider Label MoP A (For G8341)	1310-7																				
Sheet Slider Label MoP DS (For G8342)	1310-7																				
Sheet Slider Label MoP B (For G8343)	1310-7																				
PBA Main	1307-2																				
Gasket RF Conductive Audio Jack	1307-2																				
PICTIVE Main Camera	1301-0																				
Sheet RF Conductive GND Camera	1311-0																				
Sheet Spacer Main Camera BSB	1307-2																				
Cushion BioB Cam	1311-2																				

Number in the cells indicates parts
require replacing for target part.

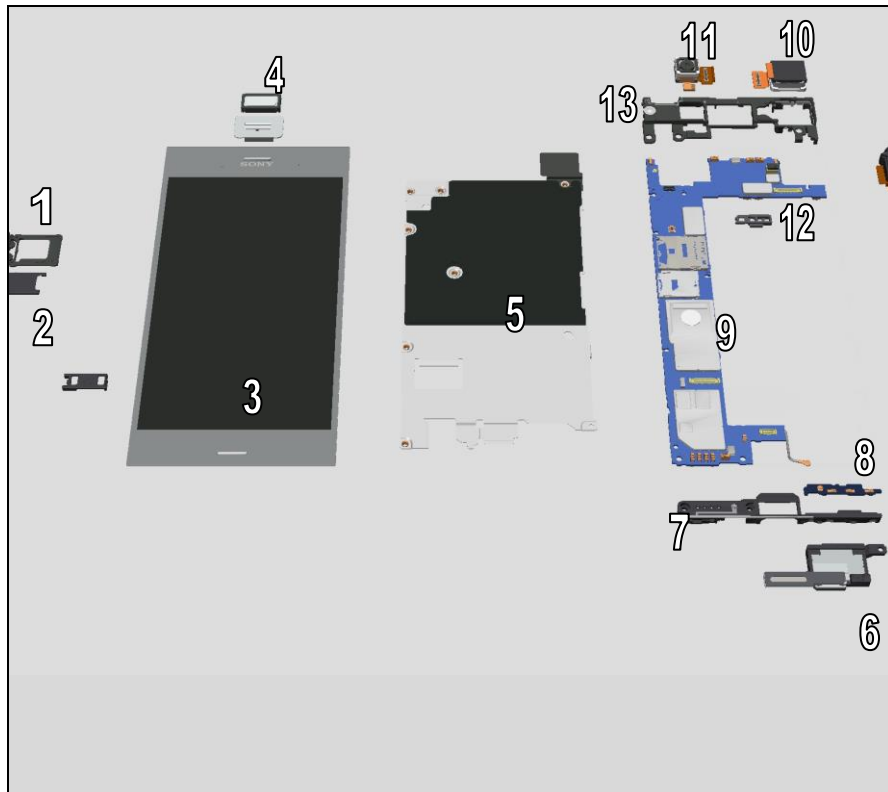
Mandatory replacement parts for refurbishment.

Parts that is required to replace in addition to
target replacement parts.

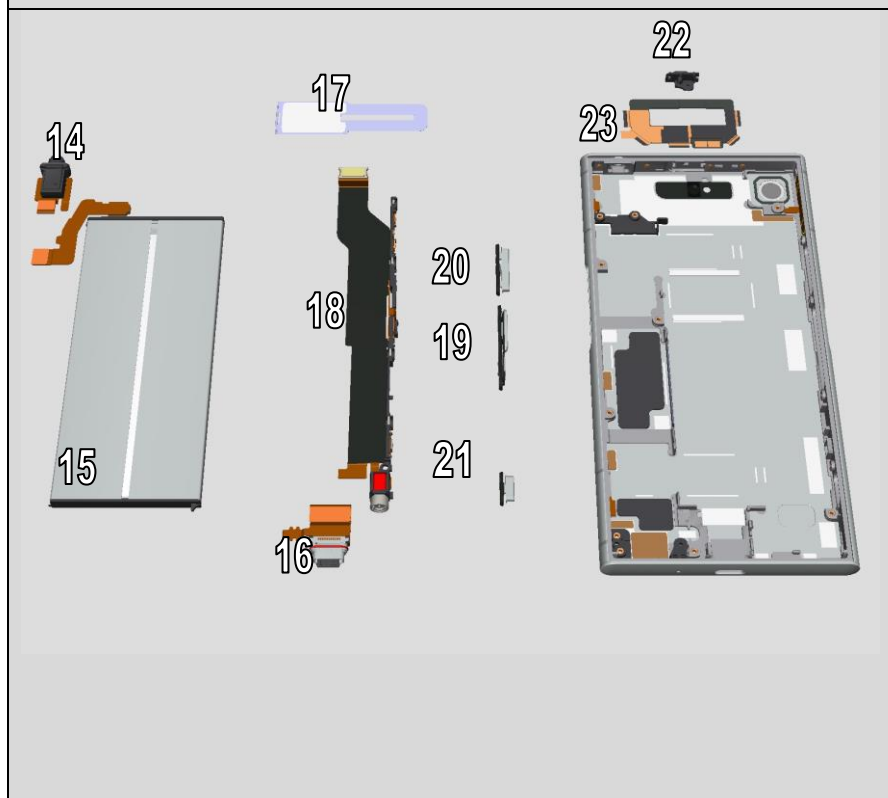
4 Disassembly

The disassembly is done in the following order:

- 1 Cap Tray
- 2 Tray Nano SIM
- 3 Display
- 4 Loudspeaker
- 5 Plate Display
- 6 Speaker Box
- 7 Holder Ant Main
- 8 PBA Sub
- 9 PBA Main
- 10 Main Camera
- 11 Front Camera
- 12 Holder Sensor
- 13 Holder Ant Sub

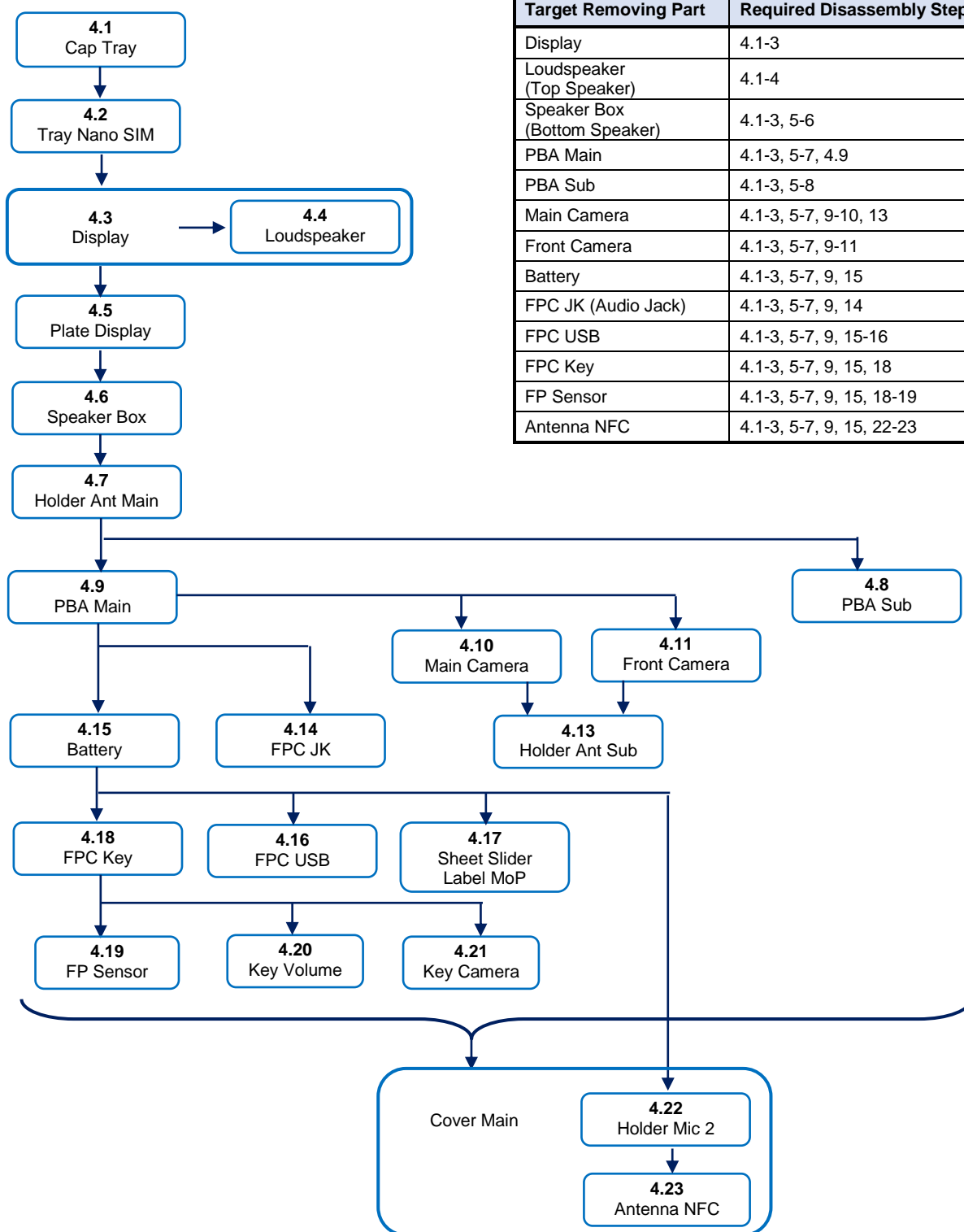


- 14 FPC JK
- 15 Battery
- 16 FPC USB
- 17 Sheet Slider Label MoP
- 18 FPC Key
- 19 FP Sensor
- 20 Key Volume
- 21 Key Camera
- 22 Holder Mic 2
- 23 Antenna NFC



Disassembly

Quick Reference for Disassembling

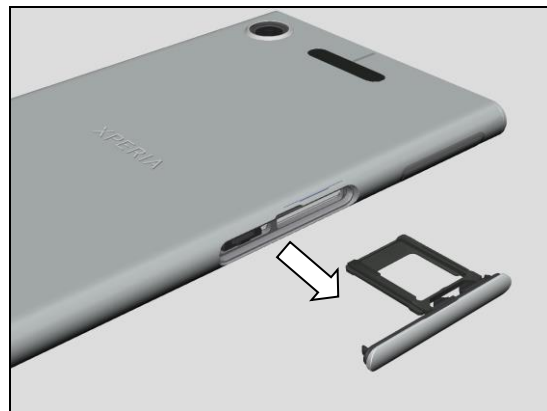


Required Disassembly Steps by Part

Target Removing Part	Required Disassembly Steps
Display	4.1-3
Loudspeaker (Top Speaker)	4.1-4
Speaker Box (Bottom Speaker)	4.1-3, 5-6
PBA Main	4.1-3, 5-7, 4.9
PBA Sub	4.1-3, 5-8
Main Camera	4.1-3, 5-7, 9-10, 13
Front Camera	4.1-3, 5-7, 9-11
Battery	4.1-3, 5-7, 9, 15
FPC JK (Audio Jack)	4.1-3, 5-7, 9, 14
FPC USB	4.1-3, 5-7, 9, 15-16
FPC Key	4.1-3, 5-7, 9, 15, 18
FP Sensor	4.1-3, 5-7, 9, 15, 18-19
Antenna NFC	4.1-3, 5-7, 9, 15, 22-23

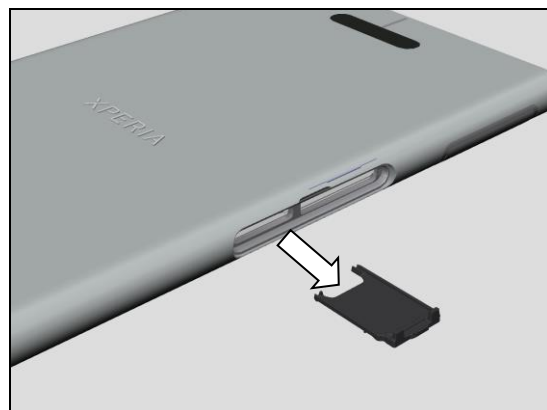
4.1 Cap Tray

Remove the Cap Tray.



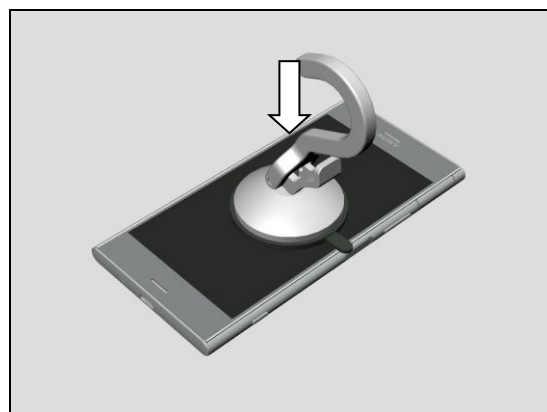
4.2 Tray Nano SIM

Remove the Tray Nano SIM.

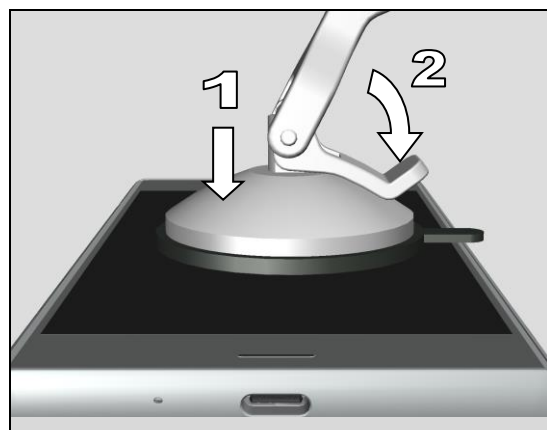


4.3 Display

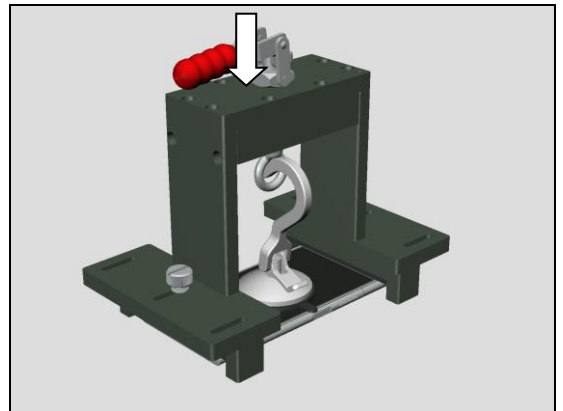
Place the Vacuum Cup for Tool on the center of the Display.



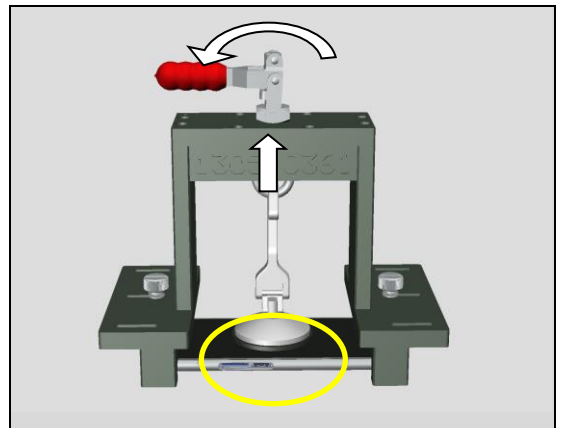
Push the cup and lock it by the flap.



Place the Panel Disassembly Tool over the unit.

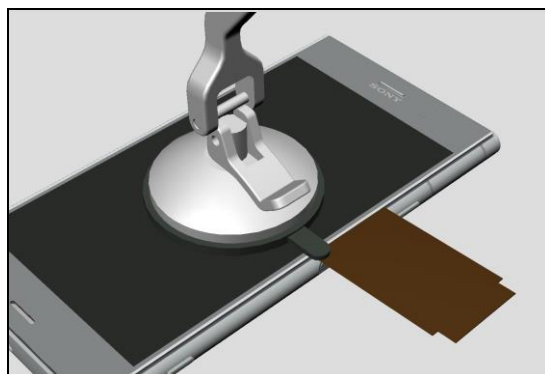
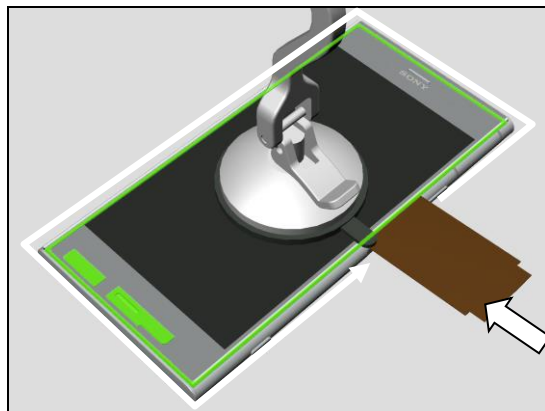


Pull the lever and wait as the Display begins to open.



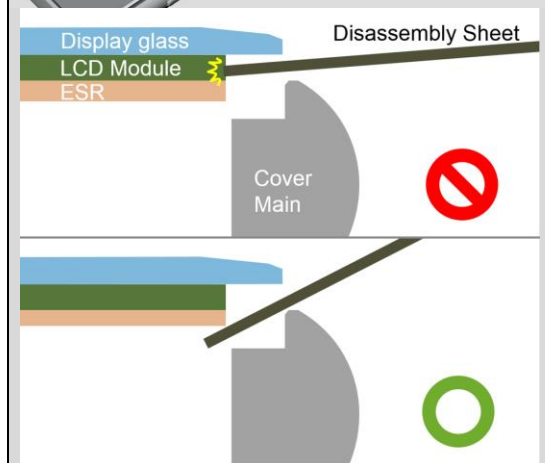
Disassembly

Insert the Disassembly Sheet and slide to cut the Adhesive WR Display, Adhesive Window Display Bottom and Net WR Speaker Bottom by following the notes.



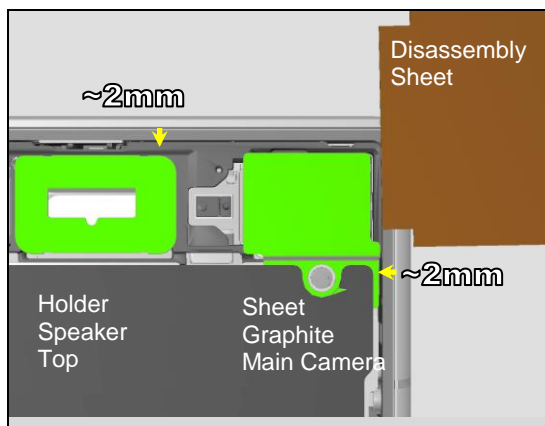
NOTE1 INSERT AND RIGHT/LEFT AREA

Do not hit the LCD module or ESR (Enhanced Specular Reflector) on the flip side of the Display when inserting and sliding the Disassembly Sheet.



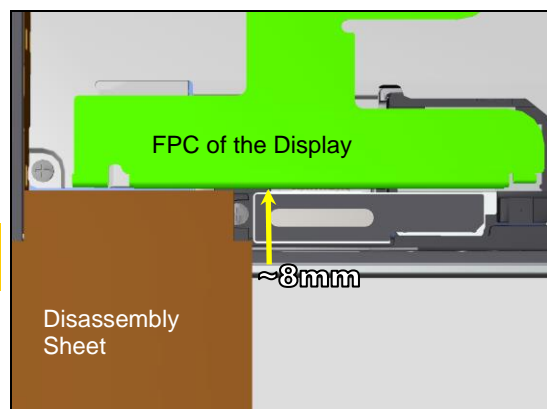
NOTE2 TOP AREA

Do not insert the Disassembly Sheet more than 2mm not to damage the Sheet Graphite Main Camera and Holder Speaker Top.

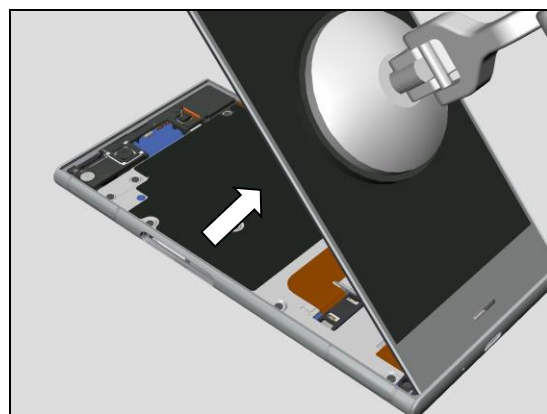


NOTE3 BOTTOM AREA

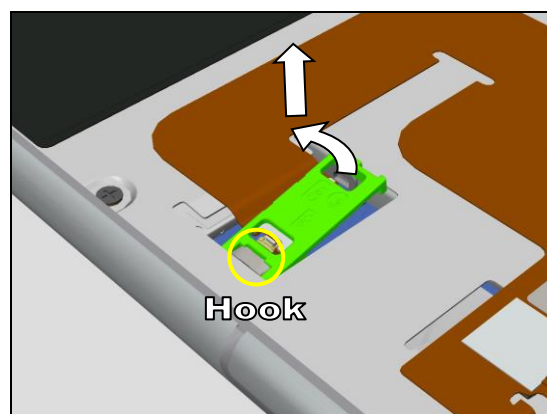
Do not insert the Disassembly Sheet more than 8mm not to damage the FPC of the Display.



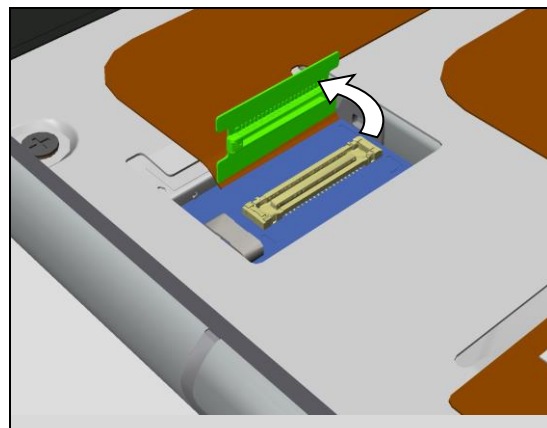
Carefully open the Display.



Remove the Holder LCD BtoB.



Disconnect the BtoB connector of the Display.

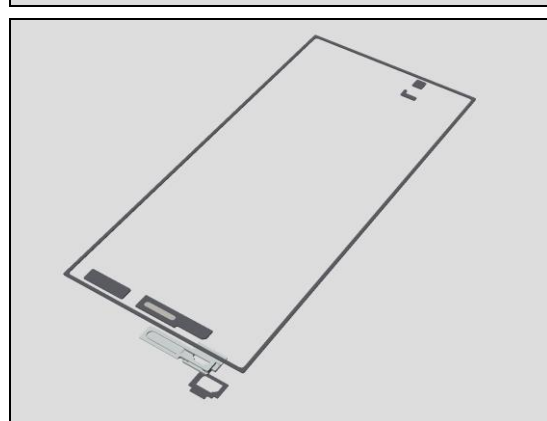
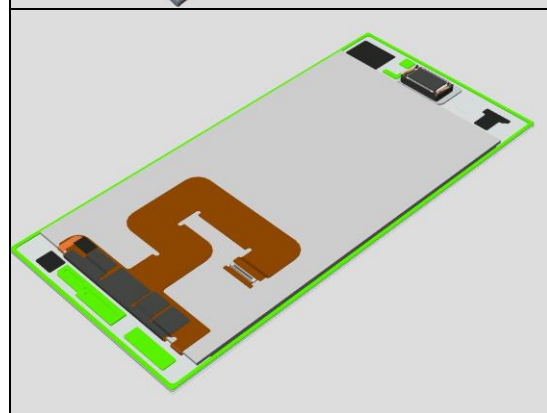
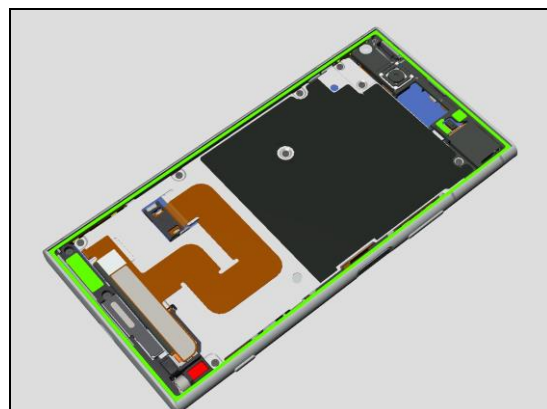


Disassembly

Remove all residues of the adhesives on the Display and Cover Main (Green Highlighted Area) with the Bamboo Skewer.

Do not use Isopropyl Alcohol for Cover Main cleaning.

Scrap! Do not reuse Holder Speaker Bottom, Net WR Speaker WR Speaker Bottom, Adhesive WR Speaker Box, Adhesive WR Display, Adhesive Window Display Bottom and Adhesive Window Display Top.



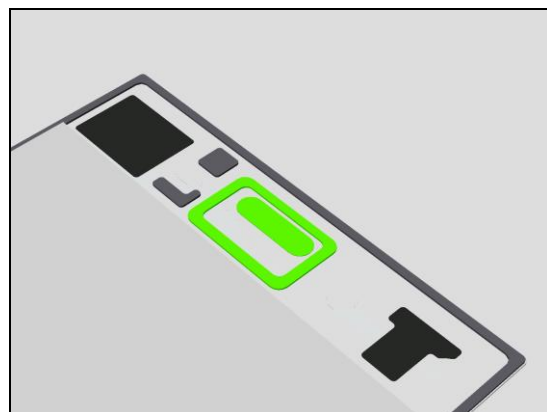
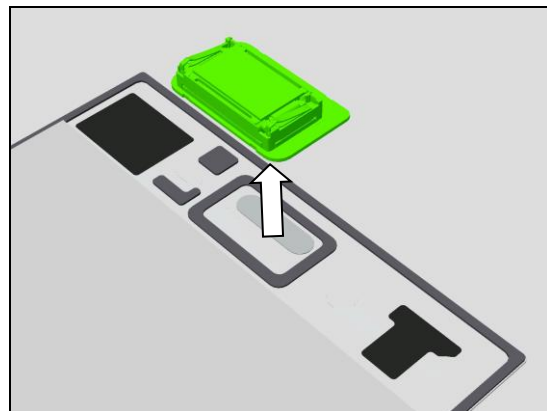
4.4 Loudspeaker

Remove the Loudspeaker along with the Holder Speaker Top.

This chapter can be skipped except for Loudspeaker replacement.

Remove the Net Speaker Top and Adhesive WR Holder Speaker Top from the Display with the Bamboo Skewer.

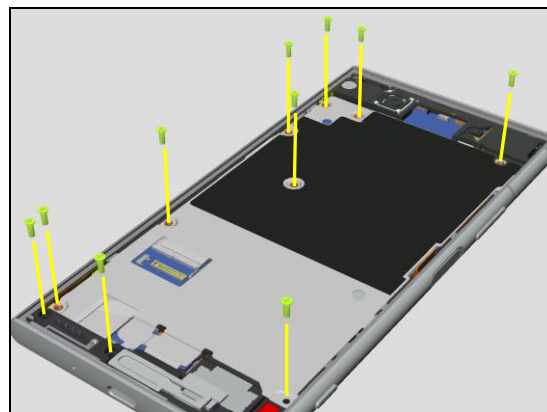
Scrap! Do not reuse Loudspeaker, Holder Speaker Top, Net Speaker Top, Cushion Speaker, Adhesive WR Holder Speaker Top and Adhesive WR Speaker Bottom.



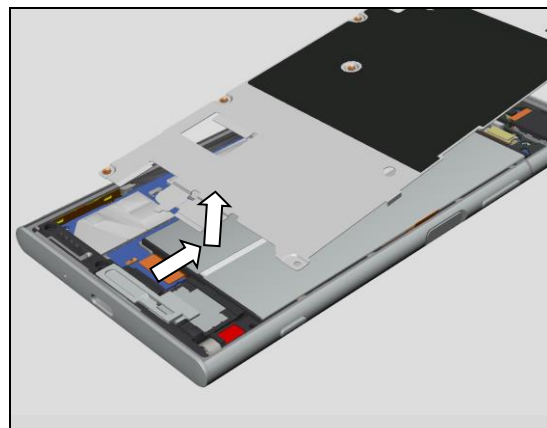
4.5 Plate Display

Remove the 10 pcs of Screw M1.4x3.8. (JCIS No 0)

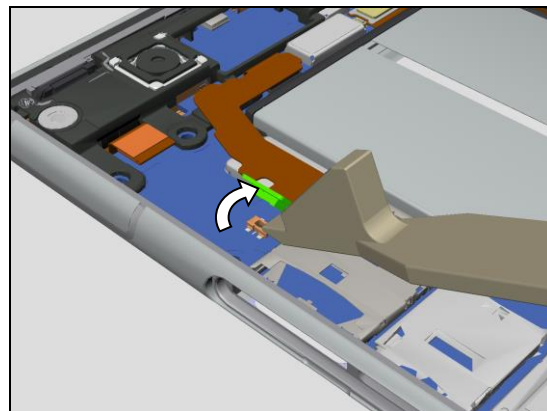
Scrap! Do not reuse the screws.



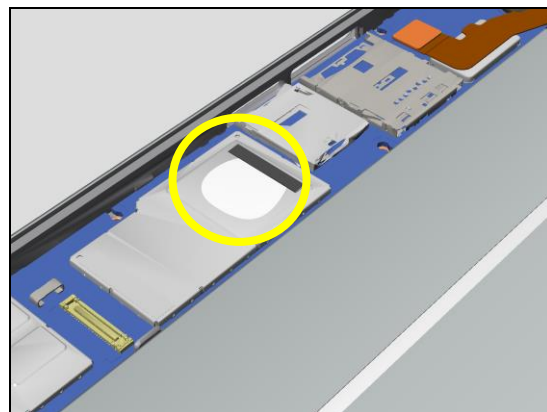
Remove the Plate Display.



Disconnect the BtoB connector of Battery with the Front Opening Tool.

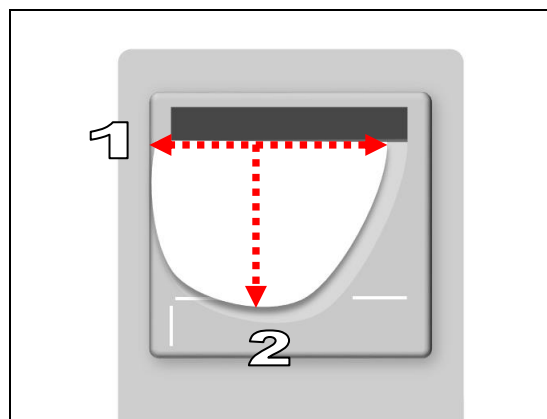


Check the condition of the Thermal Gap Filler on the PBA Main.

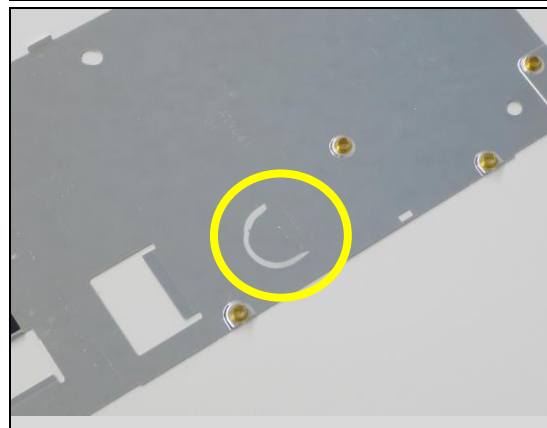


If it does not meet the shown condition, do not reuse the Thermal Gap Filler. Remove and clean it.

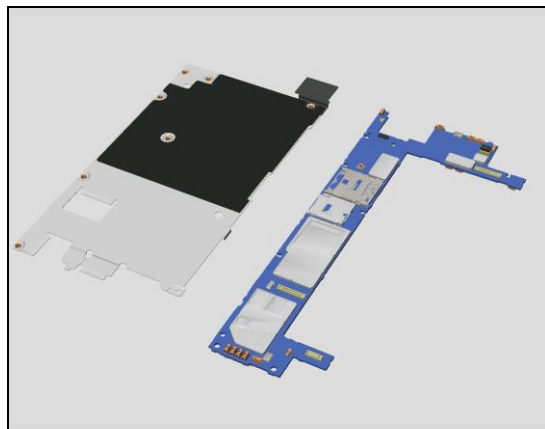
- 1 Top edge: The material remains more than 10.5mm.
- 2 Bottom edge: The material remains more than 8.5mm.



Clean all residue of Thermal Gap Filler on the Plate Display side.

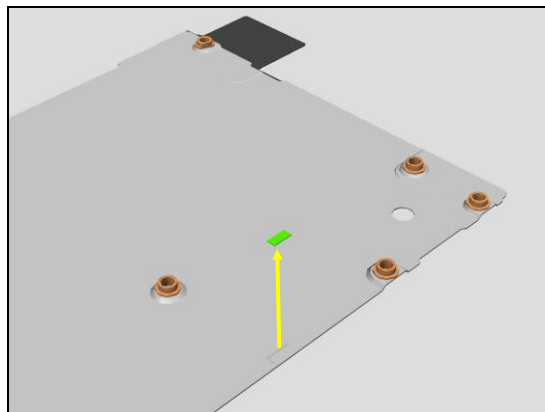


Scrap! Do not reuse the Thermal Gap Filler when replacing the Plate Display or PBA Main.



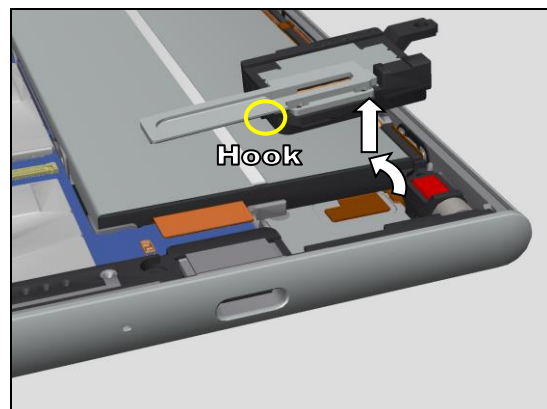
In case of replacing the Liquid indicator, remove the Liquid indicator.

Scrap! Do not reuse Liquid indicator.

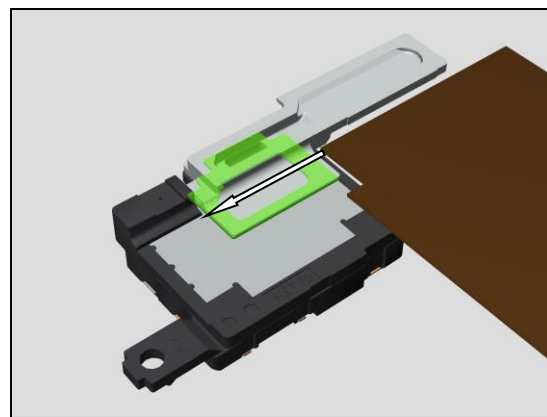


4.6 Speaker Box

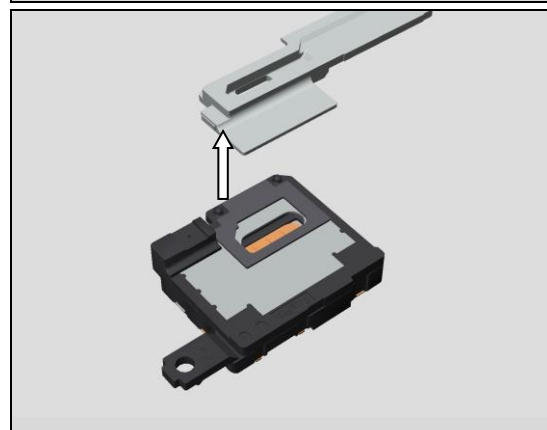
Remove the Speaker Box along with the Holder Speaker Bottom.



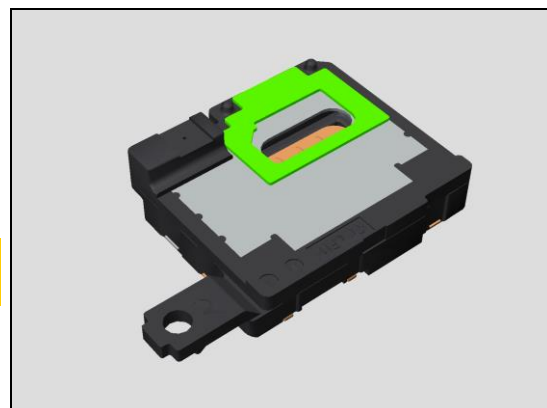
Insert the Disassembly Sheet and slide it to cut the Adhesive WR Speaker Box.



Remove the Holder Speaker from the Speaker Box.



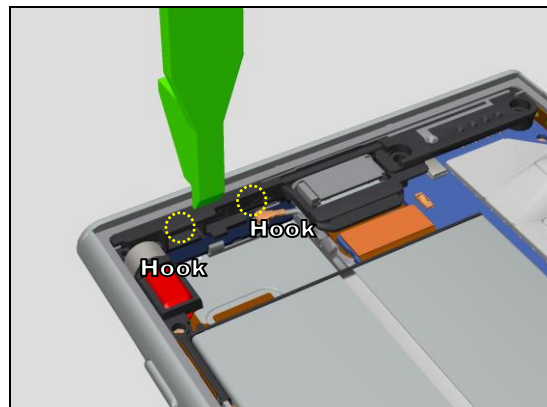
Remove the Adhesive WR Speaker Box from the Speaker Box with the Bamboo Skewer



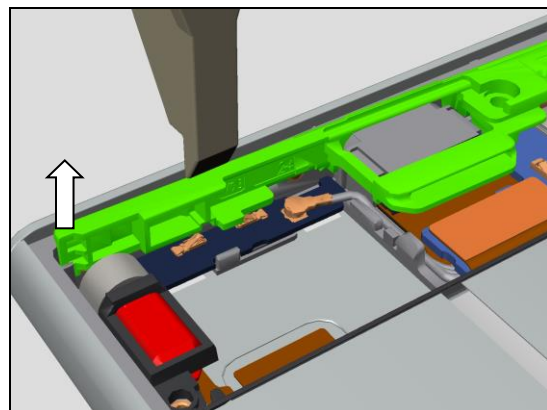
Scrap! Do not reuse Holder Speaker, Net WR Speaker Bottom and Adhesive WR Speaker Box.

4.7 Holder Ant Main

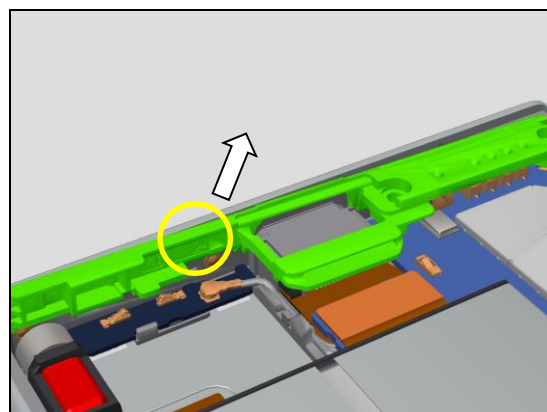
Insert the Front Opening Tool between the Holder Ant Main and the Cover Main to unhook.



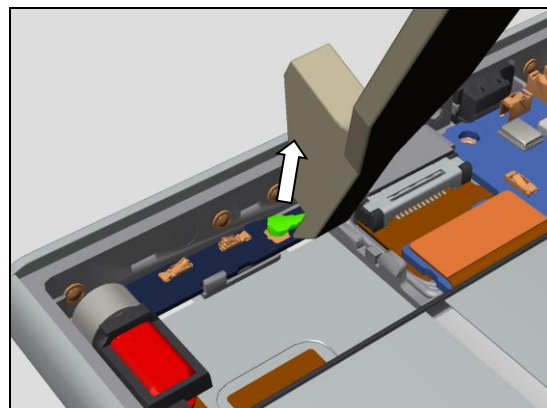
Slightly lift up.



Pick the circled area and slowly lift up the whole Holder Ant Main.



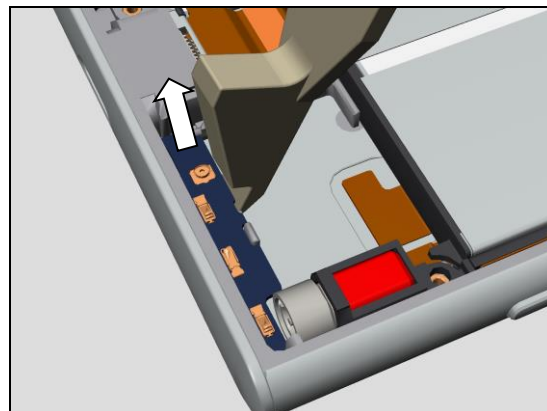
Disconnect the RF Cable with the Front Opening Tool.



4.8 PBA Sub

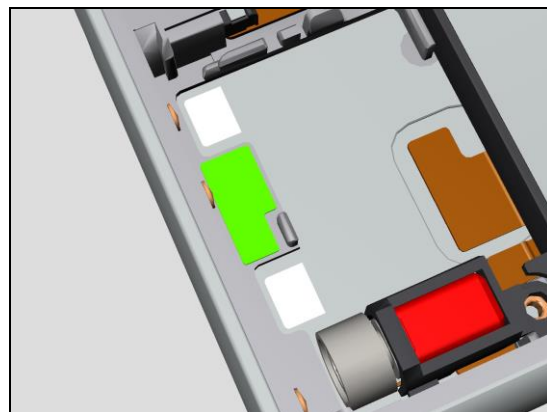
Remove the PBA Sub with the Front Opening Tool.

This chapter can be skipped except for PBA Sub replacement.



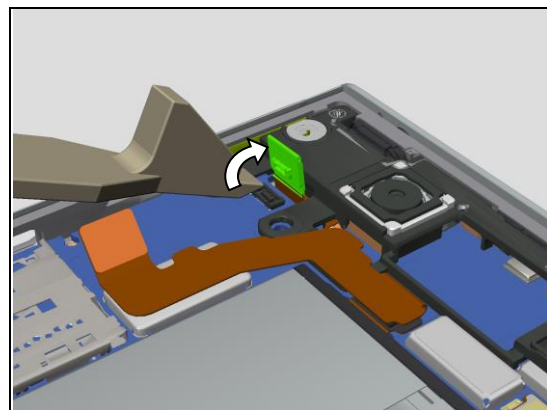
Remove the Adhesive Sub PBA from the Cover Main with the Bamboo Skewer.

Scrap! Do not reuse Adhesive Sub PBA.

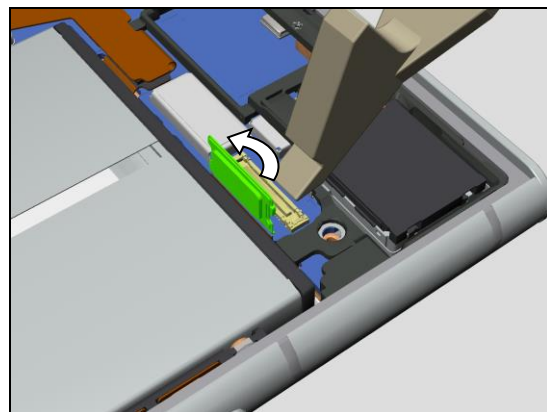


4.9 PBA Main

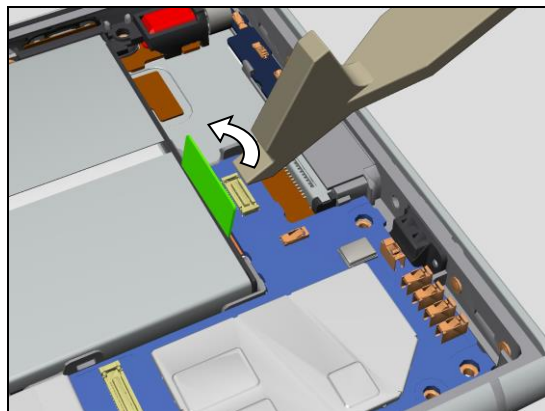
Disconnect the BtoB connector of FPC JK.



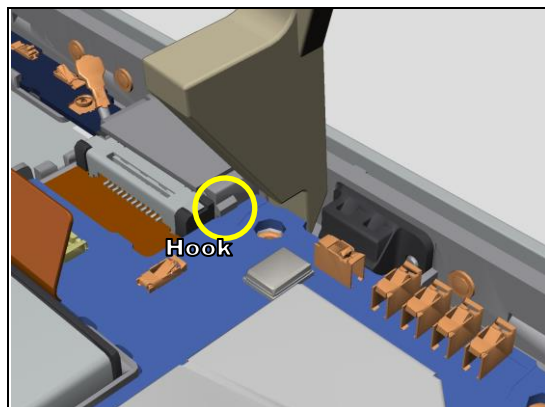
Disconnect the BtoB connector of FPC Key.



Disconnect the BtoB connector of FPC USB.



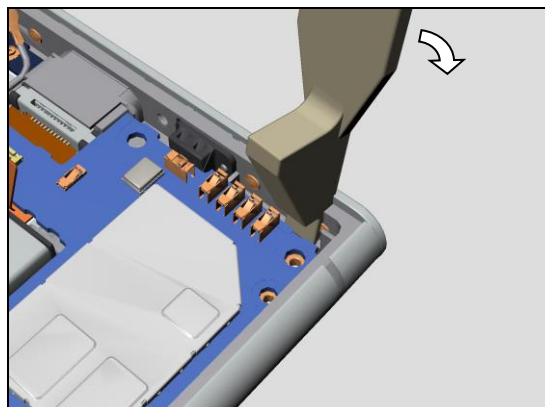
Insert the Front Opening Tool into the cavity between the PBA Main and Cover Main near the USB connector.



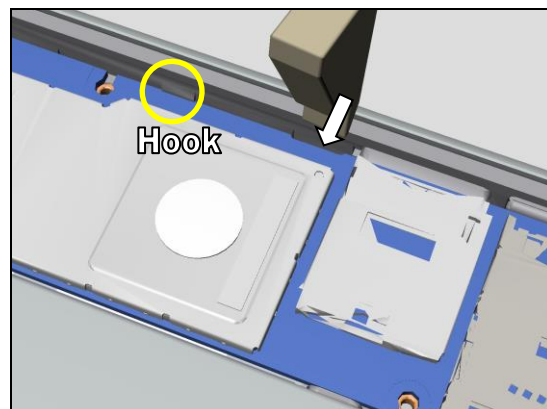
Tilt the Front Opening Tool to unhook the PBA Main.



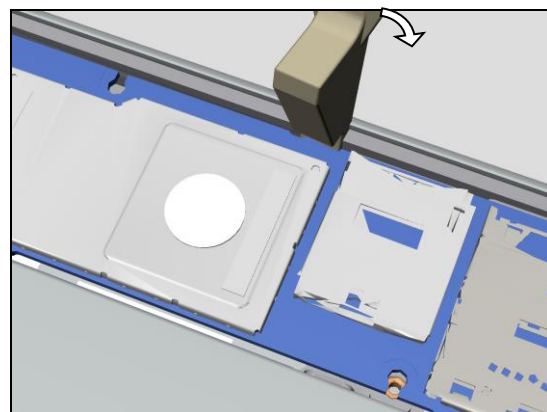
Do the same way at around the shown area.
Pinch the PBA to secure the unhooked state.



Insert the Front Opening Tool into the cavity between the PBA Main and Cover Main near the SIM connector.

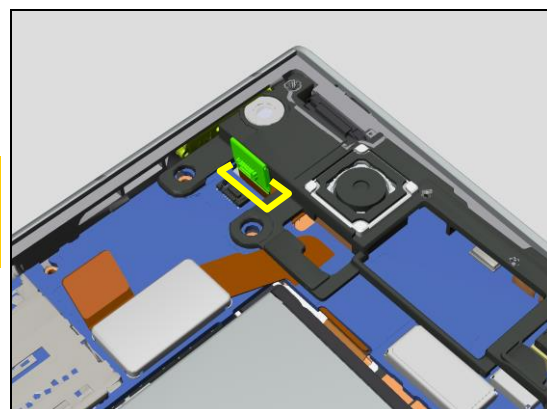


Tilt the Front Opening Tool to unhook the PBA Main.

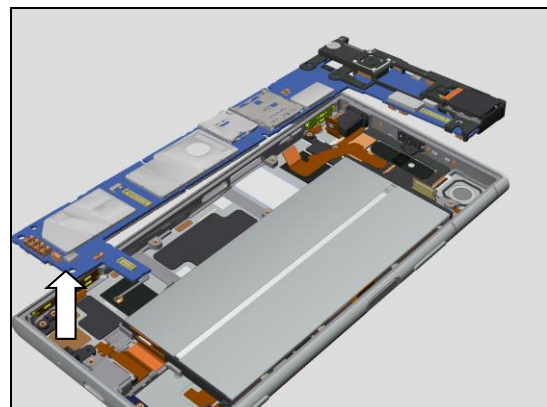


Note!

Make sure to let the BtoB connector of FPC JK through the slit of the PBA Main and Holder Ant Sub.

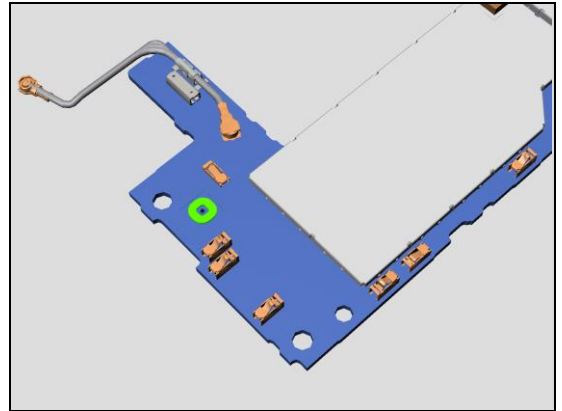


Lift up the PBA Main along with the Holder Ant Sub.

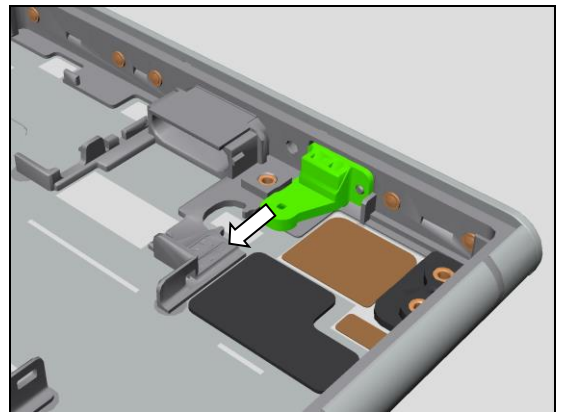


Disassembly

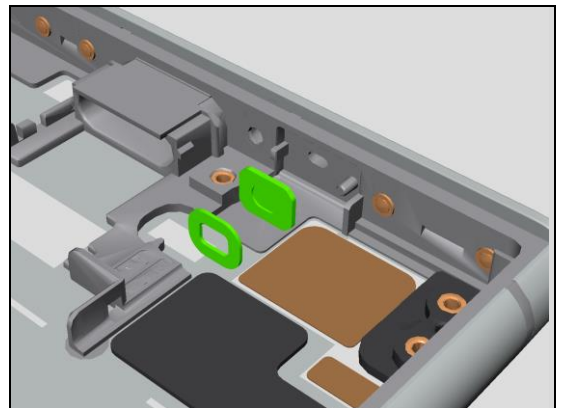
Remove the Adhesive Mic1 from the PBA Main with the Bamboo Skewer.



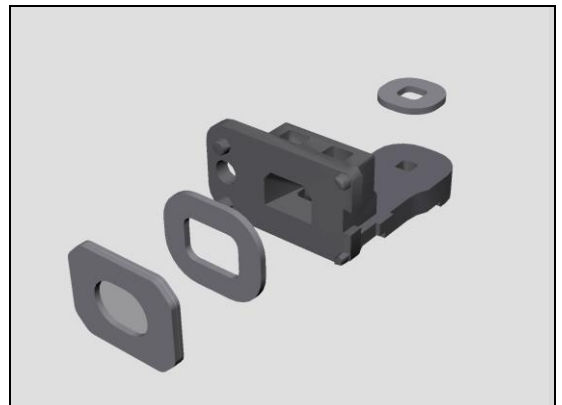
Remove the Holder Mic 1.



Remove the Adhesive Mic 1 and Sheet WR Mic with the Bamboo Skewer.



Scrap! Do not reuse Holder Mic 1, Adhesive Mic 1, Sheet WR Mic and Adhesive Mic 1 PBA when the PBA Main is removed.



4.10 Main Camera

Remove the Cushion BtoB Cam.

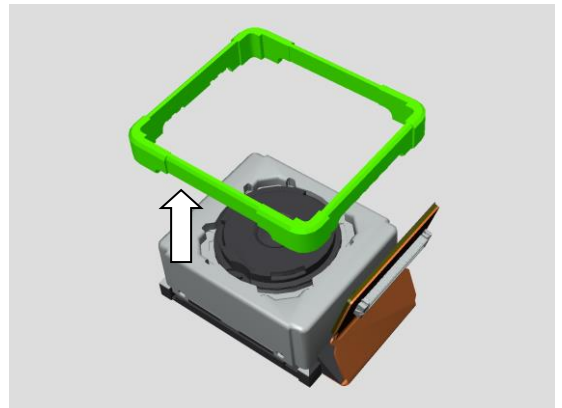
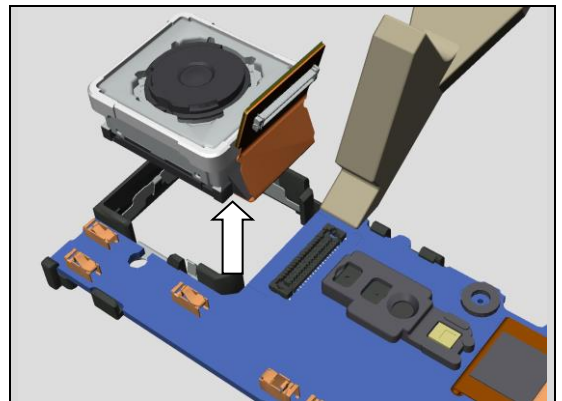
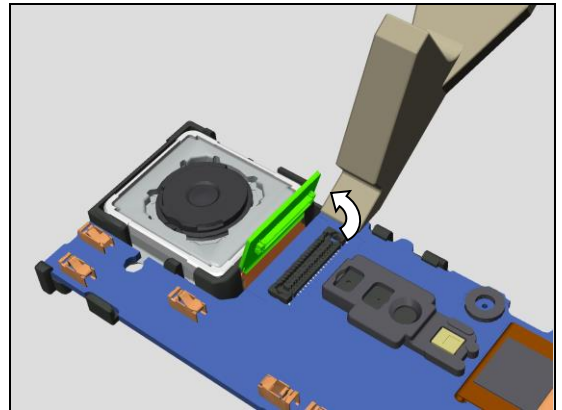
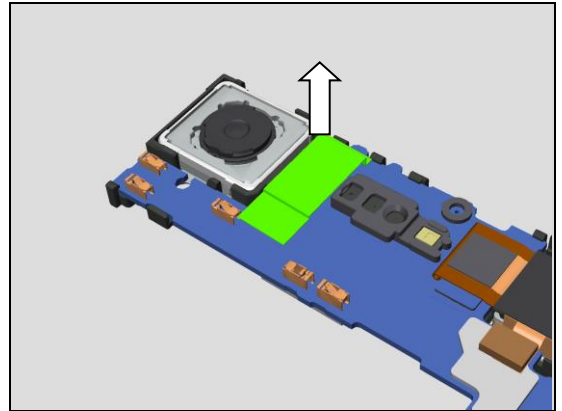
This chapter can be skipped except for Main Camera, PBA Main, and Holder Ant Sub replacement.

Scrap! Do not reuse Cushion BtoB Cam.

Disconnect the BtoB connector of Main Camera.

Remove the Main Camera.

Remove the Holder Main Camera.



4.11 Front Camera

Remove the Sheet RF Conductive Sub Camera.

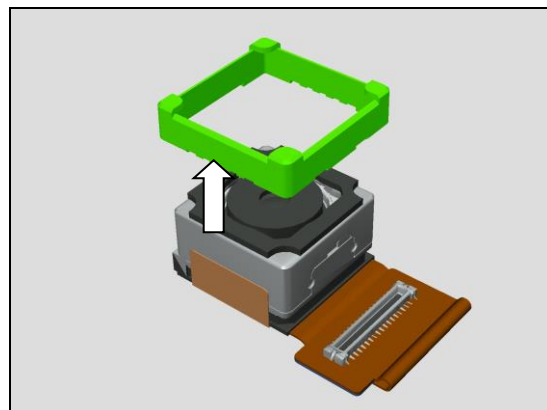
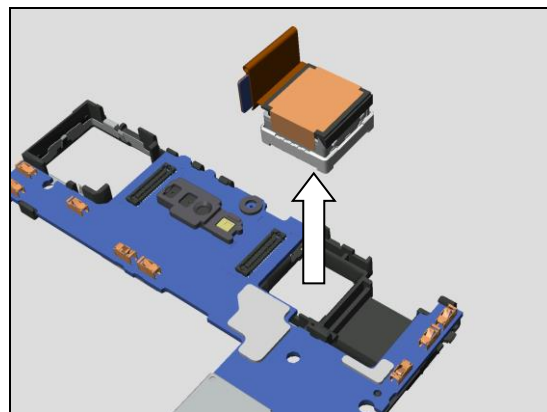
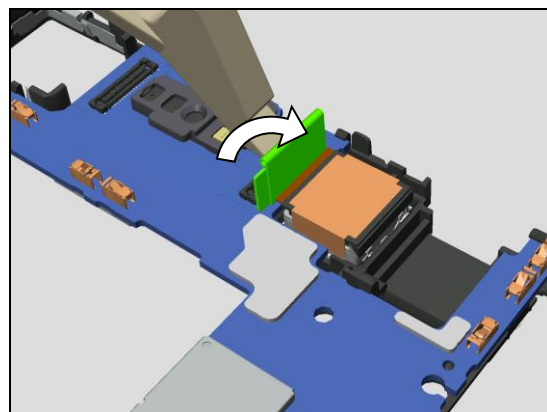
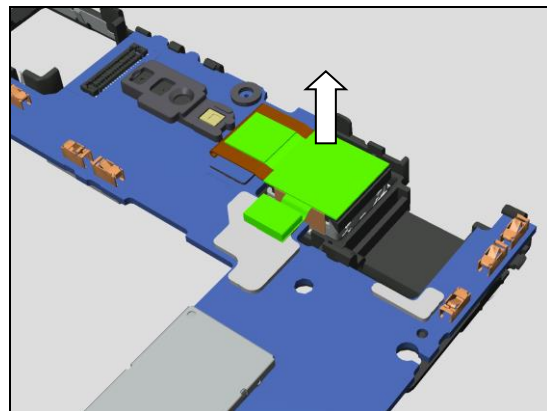
This chapter can be skipped except for Front Camera, Main Camera, PBA Main, and Holder Ant Sub replacement.

Scrap! Do not reuse the Sheet RF Conductive Sub Camera and Gasket RF Conductive Front Camera.

Disconnect the BtoB connector of Front Camera.

Remove the Front Camera.

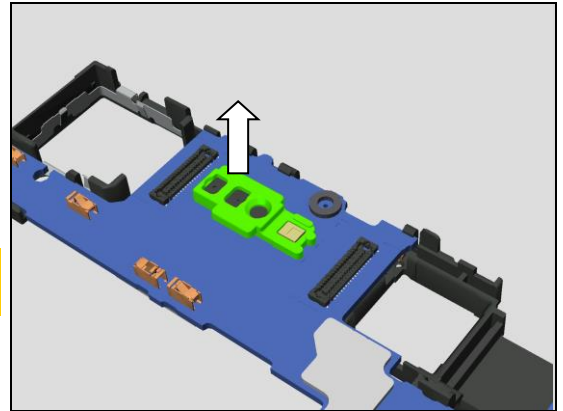
Remove the Holder Front Camera.



4.12 Holder Sensor

Remove the Holder Sensor.

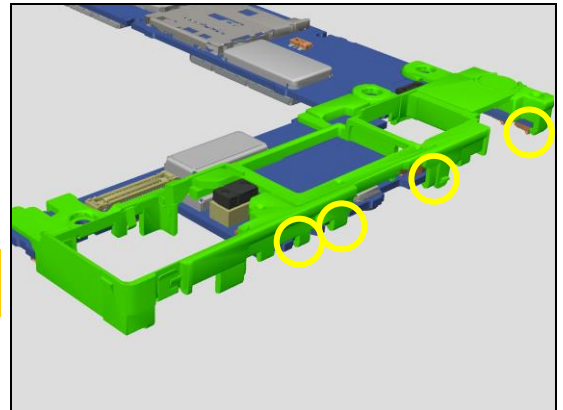
This chapter can be skipped except for PBA Main replacement.



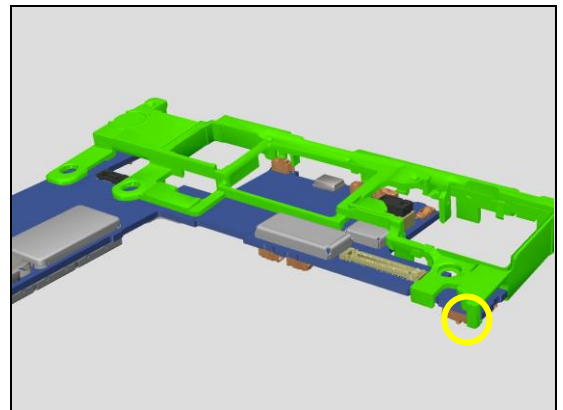
4.13 Holder Ant Sub

Unhook the circled area.

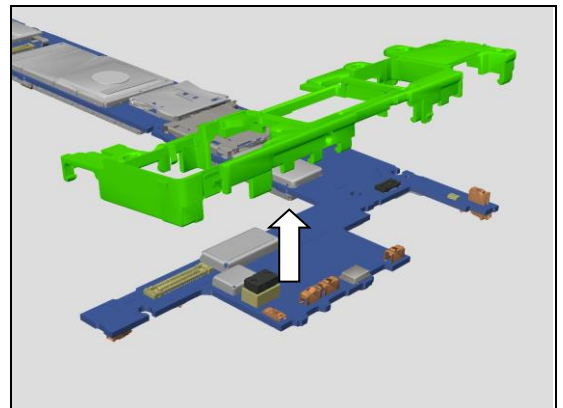
This chapter can be skipped except for Main Camera, Holder Ant Sub and PBA Main Replacement.



Unhook the circled area.



Remove the Holder Ant Sub.



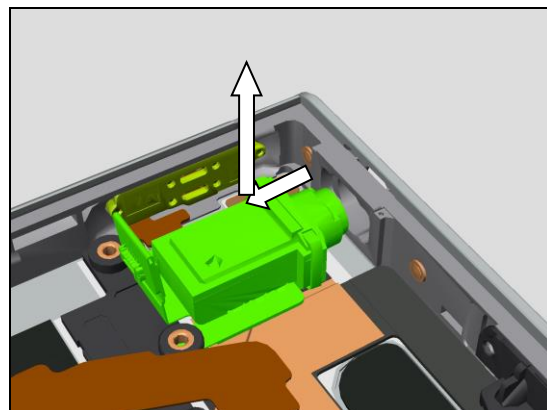
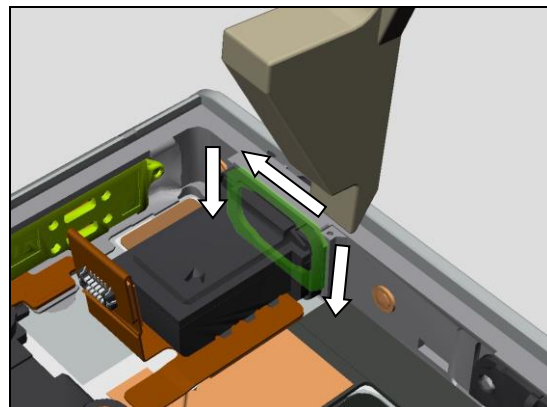
4.14 FPC JK

Insert the Front Opening Tool to cut the Adhesive WP Audio Jack.

This chapter can be skipped except for FPC JK and Antenna NFC replacement.

Remove the FPC JK.

Scrap! Do not reuse Adhesive WP Audio Jack.

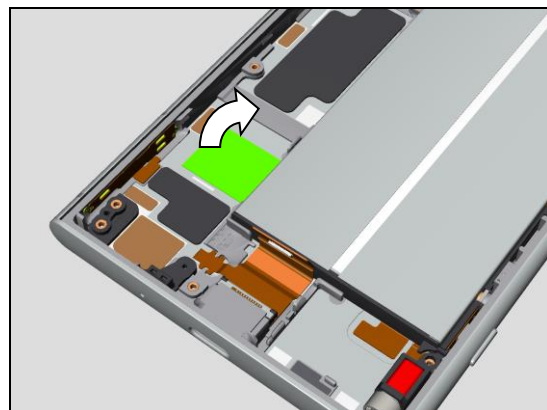


4.15 Battery

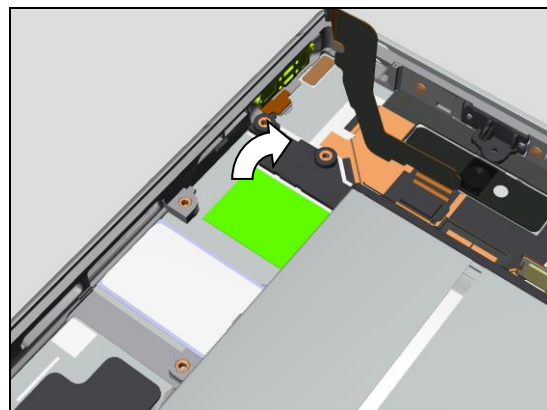
Pinch the tab of Adhesive Battery at the bottom side.

Carefully pull the Adhesive Battery as horizontally as possible.

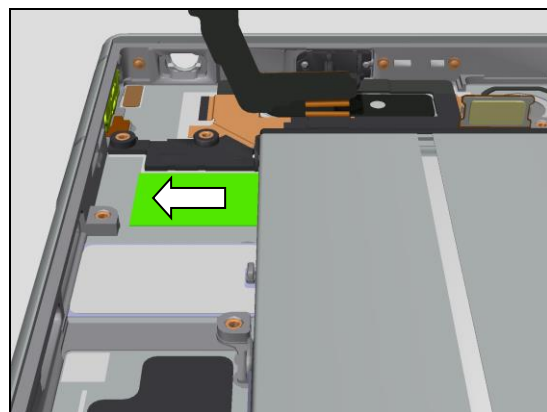
Scrap! Do not reuse Adhesive Battery.



Pinch the tab of Adhesive Battery at the top side.

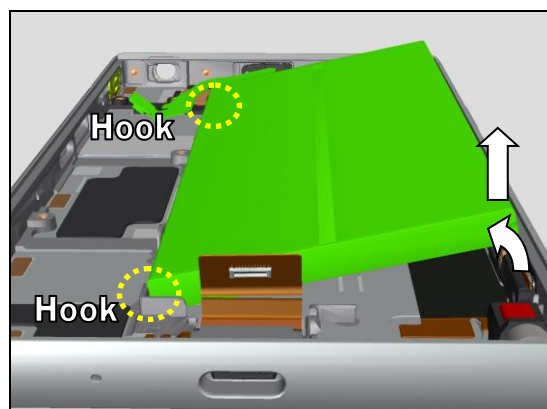


Carefully pull the Adhesive Battery as horizontally as possible.

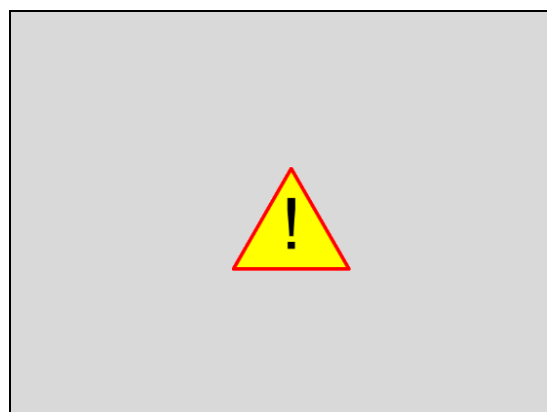


Scrap! Do not reuse Adhesive Battery.

Remove the Battery.



Follow 6. Battery Reuse Instruction



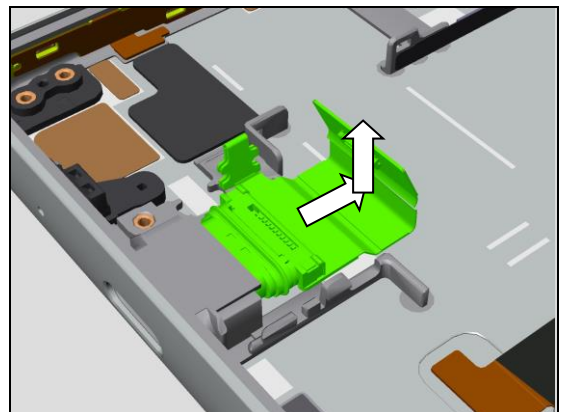
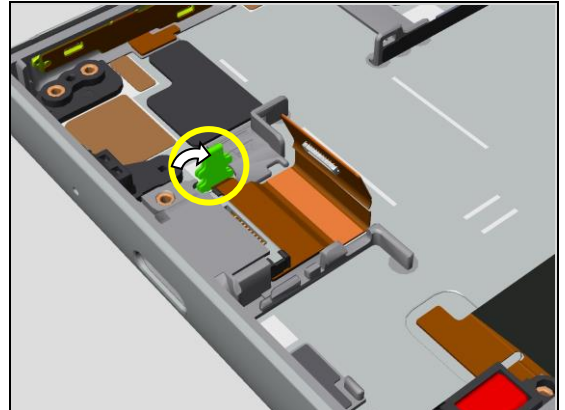
4.16 FPC USB

Remove the tab of the FPC USB.

This chapter can be skipped except for FPC USB replacement.

Remove the FPC USB.

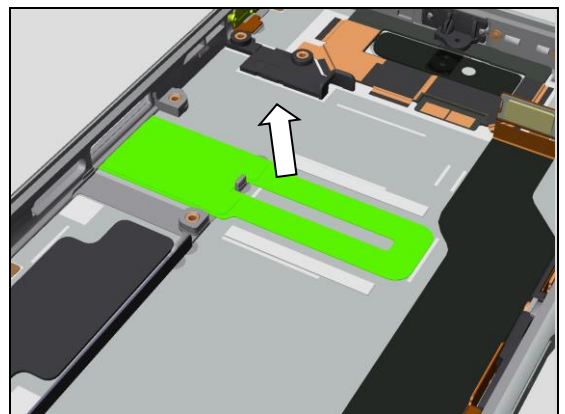
Scrap! Do not reuse Adhesive RF Conductive FPC USB Sub, Adhesive RF Conductive GND USB and Gasket RF Conductive USB FPC.



4.17 Sheet Slider Label MoP

Remove the Sheet Slider Label MoP.

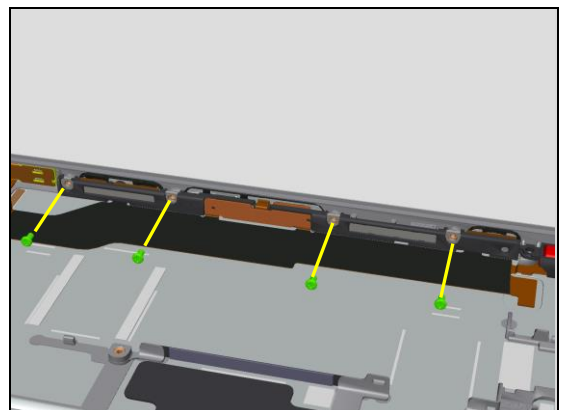
This chapter can be skipped except for PBA Main replacement.



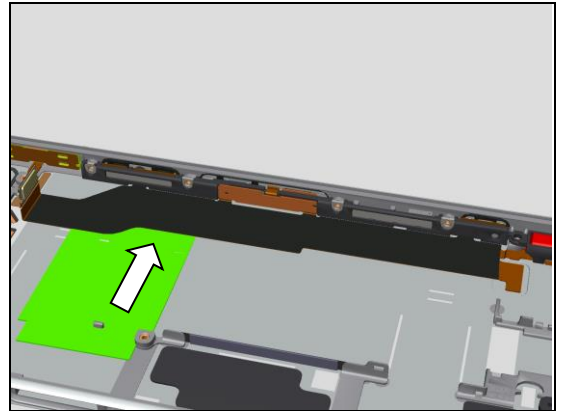
4.18 FPC Key

Remove the 4 pcs of Screw M1.2x2.1 with Screwdriver PH0 x 100.

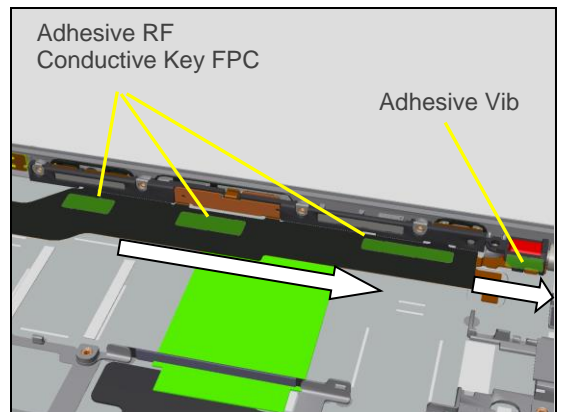
Scrap! Do not reuse the screws.



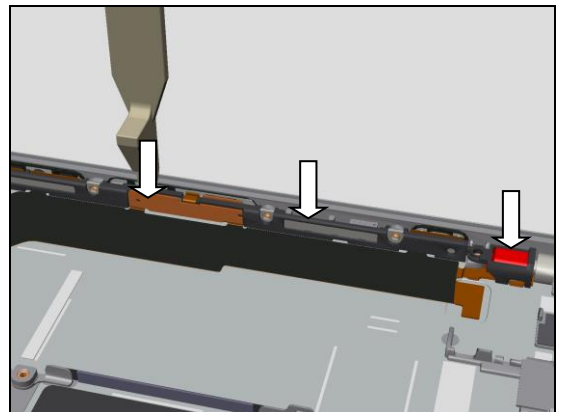
Insert the Disassembly Sheet underneath the FPC Key.



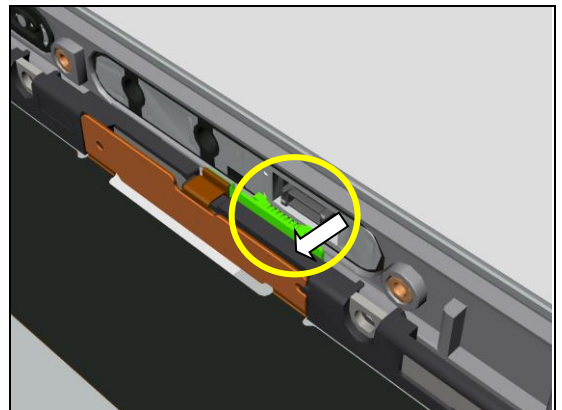
Slide the Disassembly Sheet to cut the adhesives (Adhesive RF Conductive Key FPC and Adhesive Vib).



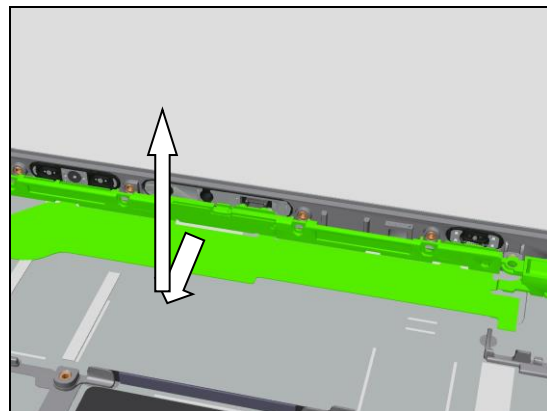
Insert the Front Opening Tool to detach the FPC Key from the Cover Main.



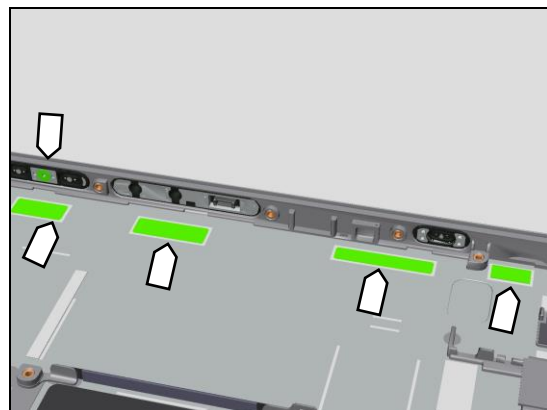
Disconnect the BtoB connector to FP Sensor.



Remove the FPC Key.

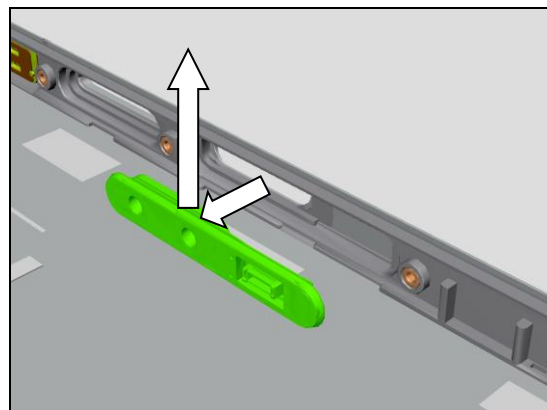


Scrap! Do not reuse Adhesive RF Conductive Key FPC, Adhesive Vib and Adhesive WR Test.



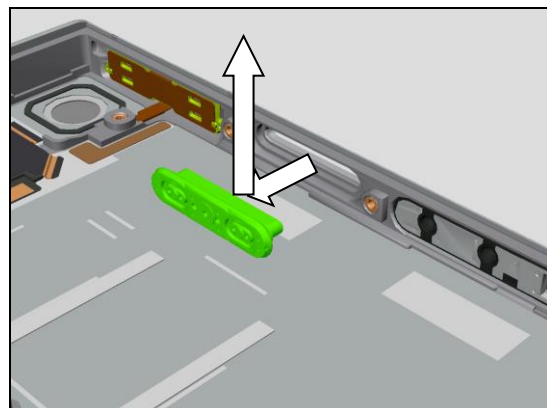
4.19 FP Sensor

Push from the outside to remove the FP Sensor.



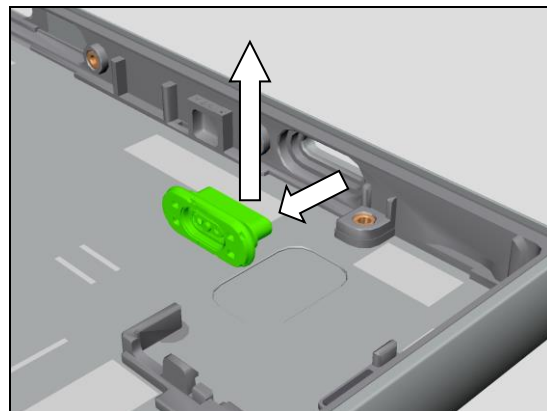
4.20 Key Volume

Push from the outside to remove the Key Volume and Gasket WR Key Volume.



4.21 Key Camera

Push from the outside to remove the Key Camera and Gasket WR Key Camera.

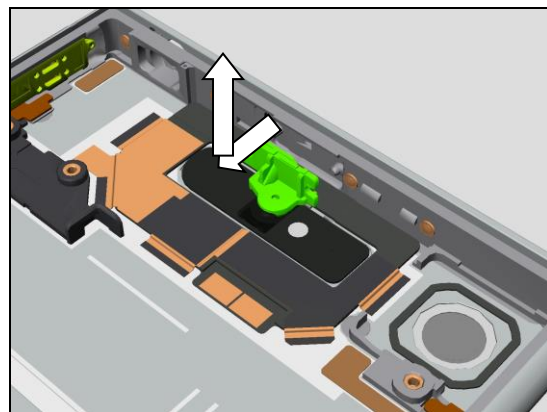


4.22 Holder Mic 2

Remove the Holder Mic 2.

This chapter can be skipped except for Antenna NFC replacement.

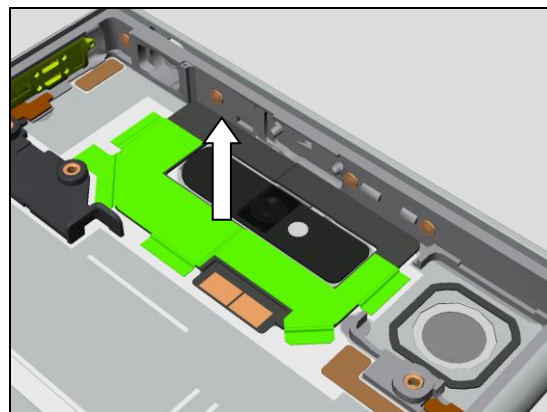
Scrap! Do not reuse Holder Mic 2, Adhesive Mic 2 and Sheet WR Mic.



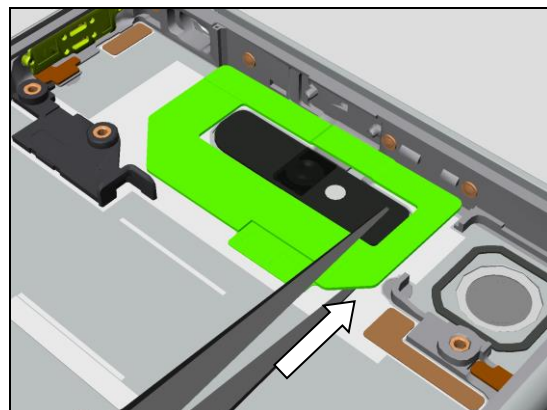
4.23 Antenna NFC

Remove the Sheet RF Conductive NFC.

This chapter can be skipped except for Antenna NFC replacement.

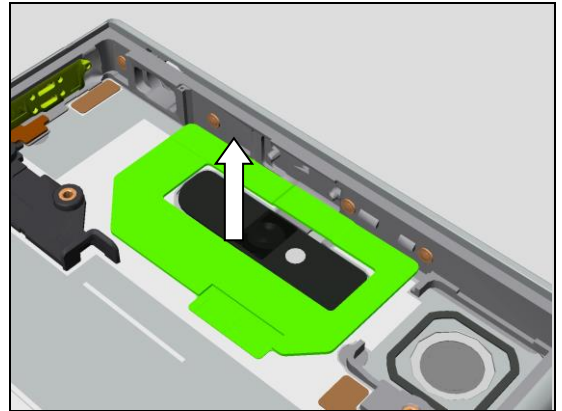


Insert the Tweezers beneath the Antenna NFC.



Remove the Antenna NFC.

Scrap! Do not reuse Antenna NFC and Sheet RF Conductive NFC.



Clean all adhesive residue.

Make sure feeling no adhesive.
The persistence of color is acceptable.

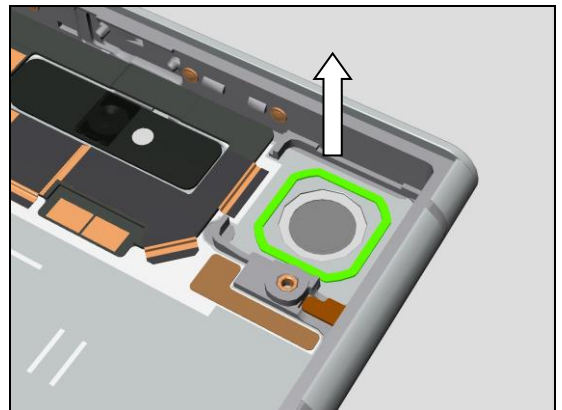


4.24 Cushion Camera

Remove the Cushion Camera with the Bamboo Skewer.

This chapter can be skipped except for Cushion Camera replacement.

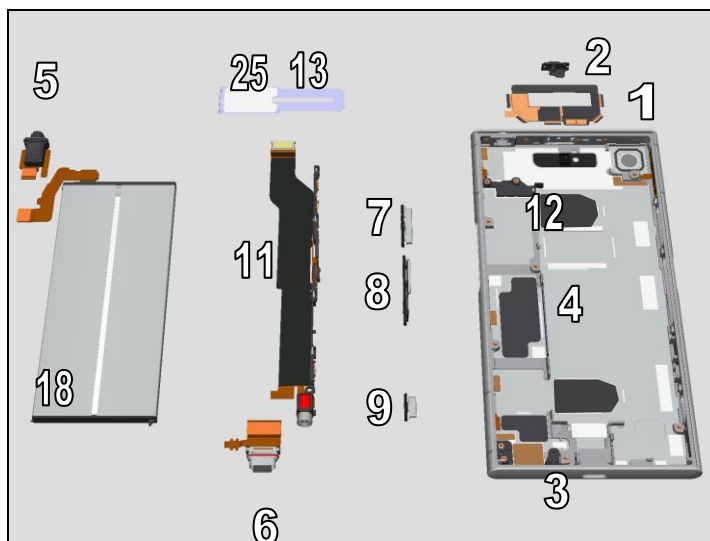
Scrap! Do not reuse Cushion Camera.



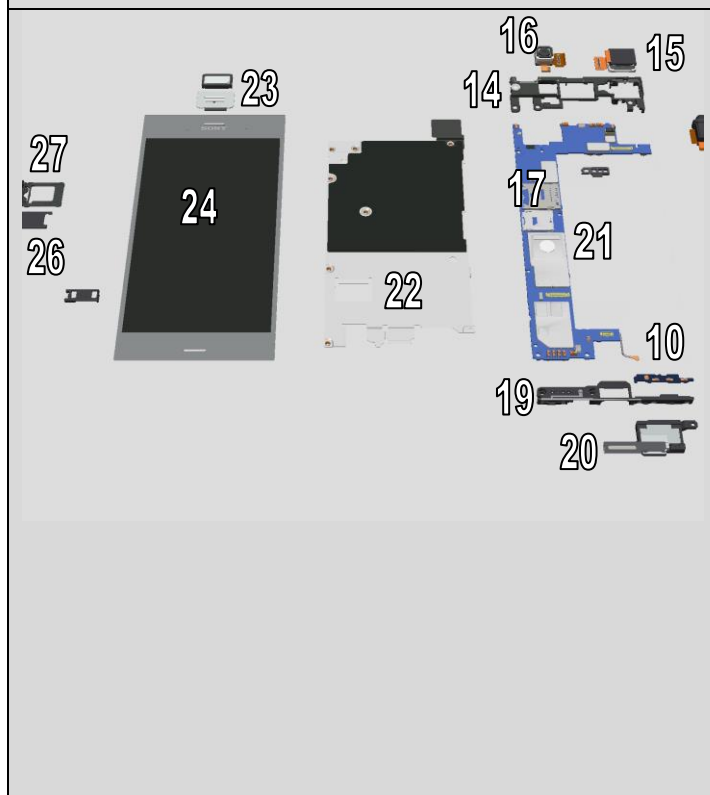
5 Reassembly

The reassembly is done in the following order:

- 1 Antenna NFC
- 2 Holder Mic 2
- 3 Holder Mic 1
- 4 Sheet Battery Side
- 5 FPC JK
- 6 FPC USB
- 7 Key Volume
- 8 FP Sensor
- 9 Key Camera
- 10 Sub PBA
- 11 FPC Key
- 12 Adhesive Battery
- 13 Sheet Slider Label MoP

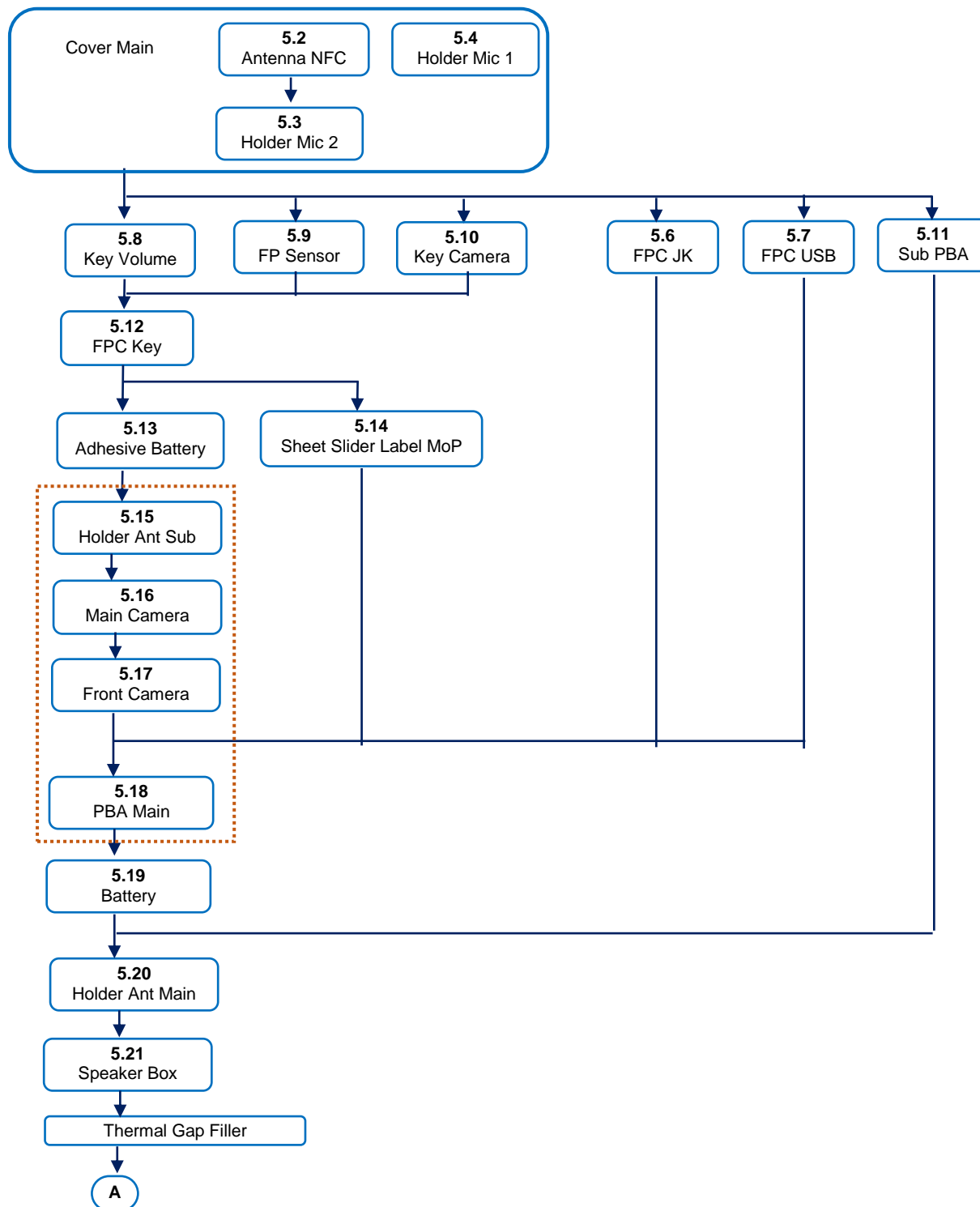


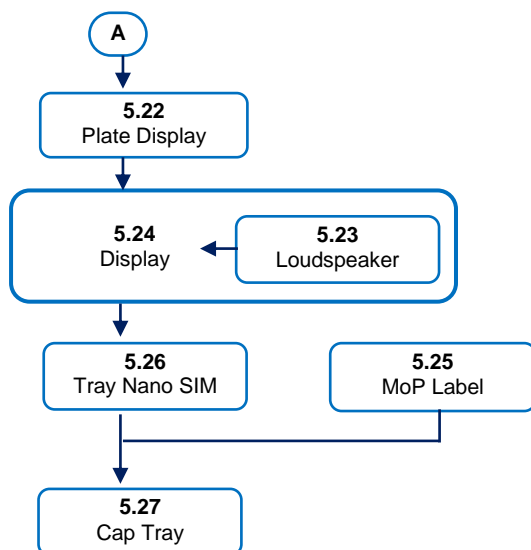
- 14 Holder Ant Sub
- 15 Main Camera
- 16 Front Camera
- 17 PBA Main
- 18 Battery
- 19 Holder Ant Main
- 20 Speaker Box
- 21 Thermal Gap Filler
- 22 Plate Display
- 23 Loudspeaker
- 24 Display
- 25 MoP Label
- 26 Tray Nano SIM
- 27 Cap Tray



Reassembly

Quick Reference for Reassembling





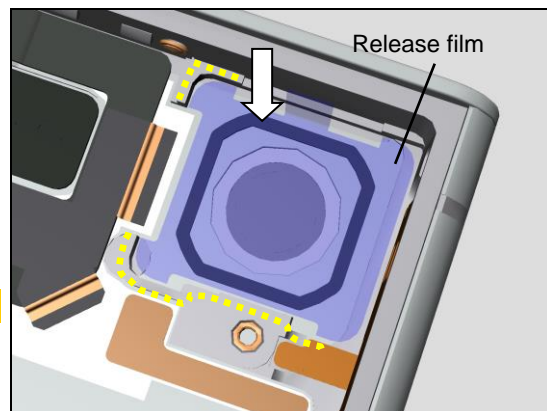
Required Reassembly Steps by Replaced Part

Replaced Part	Required Assembling Steps
Display	5.24, 26-27
Loudspeaker (Top Speaker)	5.23-24, 26-27
Speaker Box (Bottom Speaker)	5.21-22, 24, 26-27
PBA Main	5.4, 15-18, 20-22, 24-27
PBA Sub	5.11, 20-22, 24, 26-27
Main Camera	5.4, 15-18, 20-22, 24, 26-27
Front Camera	5.4, 17-18, 20-22, 24, 26-27
Battery	5.4, 13, 18-22, 24, 26-27
FPC JK (Audio Jack)	5.4, 6, 18, 20-22, 24, 26-27
FPC USB	5.4, 7, 13, 18-22, 24, 26-27
FPC Key	5.4, 12-13, 18-22, 24, 26-27
FP Sensor	5.4, 9, 12-13, 18-22, 24, 26-27
Antenna NFC	5.2-4, 13, 18-22, 24, 26-27

5.1 Cushion Camera

Fit the outline of the release film into the cavity of the Cover Main to paste the Cushion Camera.

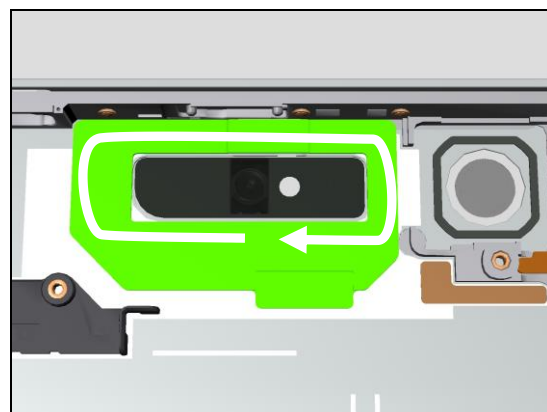
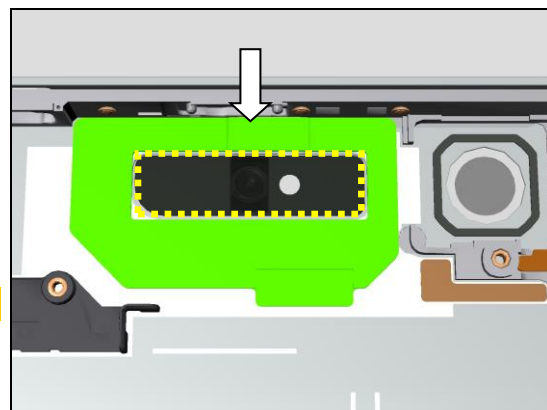
Do not cover the camera lens.



5.2 Antenna NFC

Paste the Antenna NFC around the sensor window of the Cover Main.

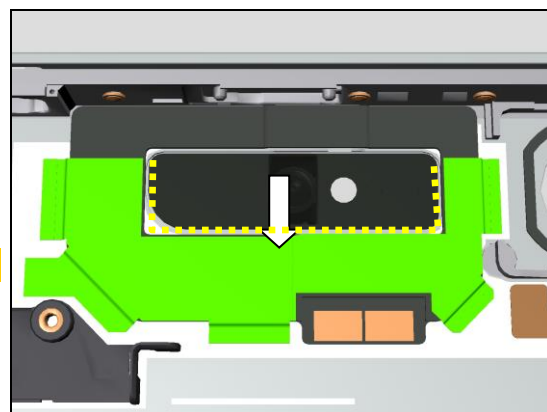
Do not step on the sensor window.



Press the Antenna NFC with a finger.

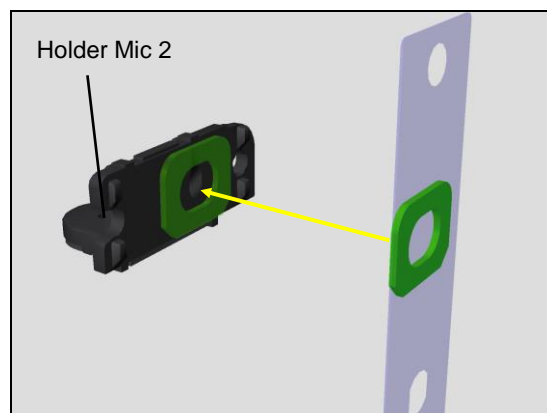
Paste the Sheet RF Conductive NFC on the Antenna NFC and Cover Main.

Do not step on the sensor window.

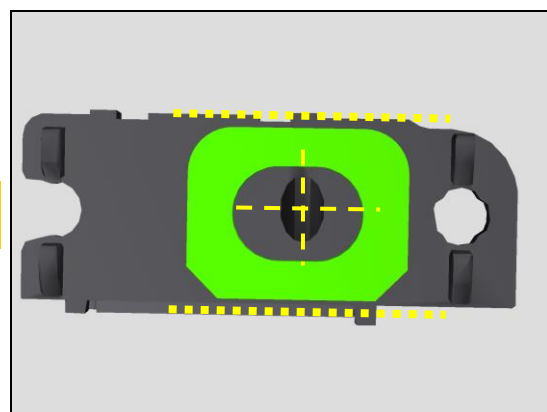


5.3 Holder Mic 2

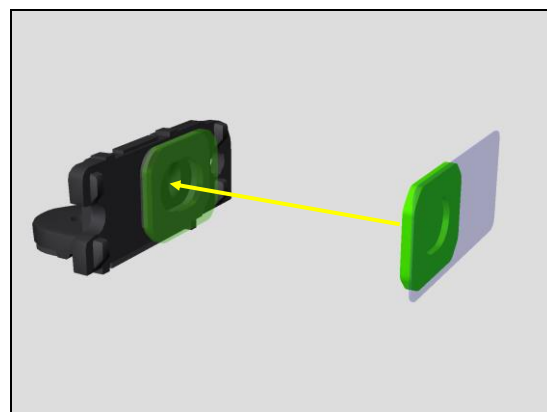
Paste the Adhesive Mic 2 on the Holder Mic 2.



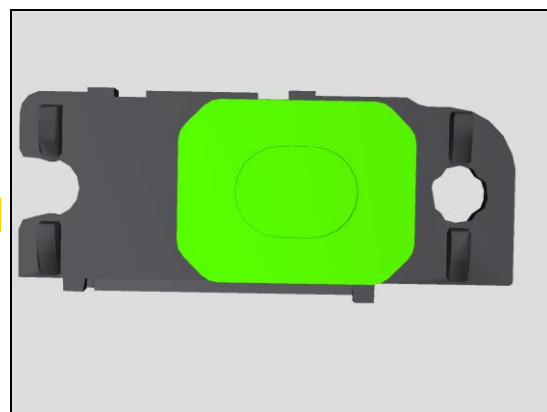
Paste at the center of the mic hole and within the outline of Holder Mic 2.



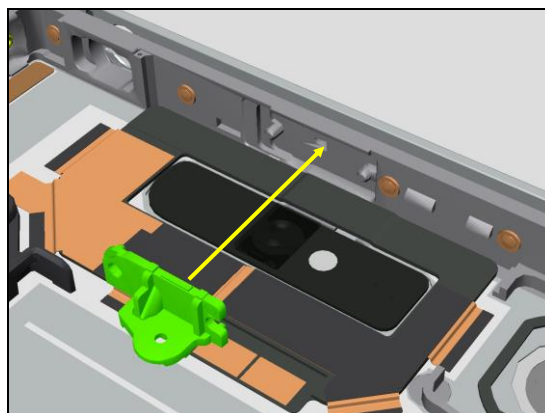
Paste the Sheet WR Mic on the Adhesive Mic 2.



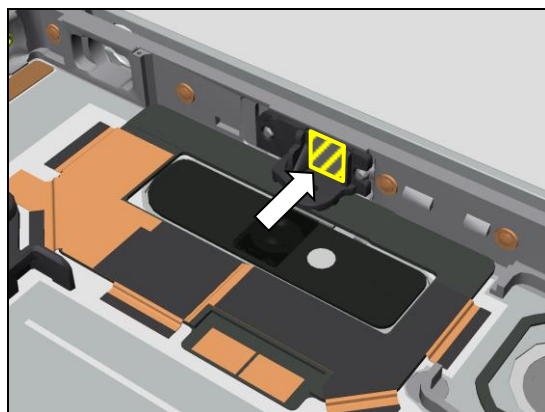
Paste exactly on the Adhesive Mic 2.



Paste the Holder Mic 2 on the Cover Main.

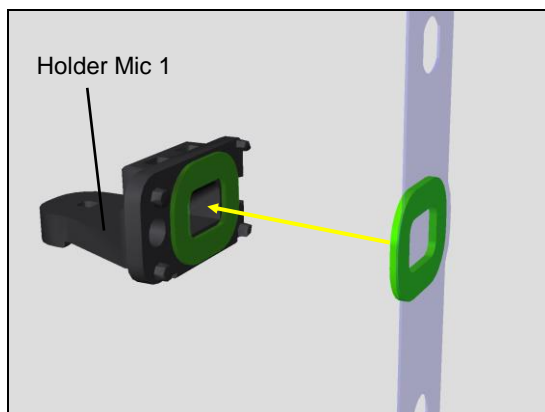


Press the hatched area for 5 sec.

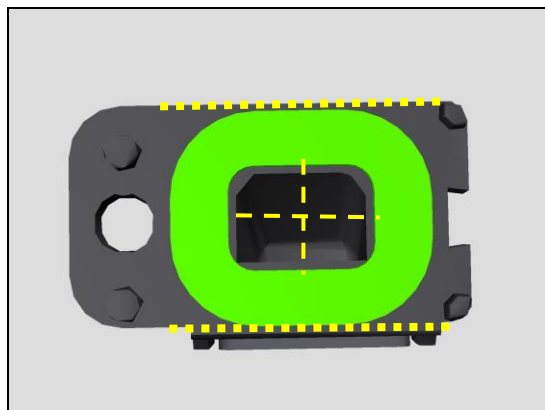


5.4 Holder Mic 1

Paste the Adhesive Mic 1 on the Holder Mic 1.

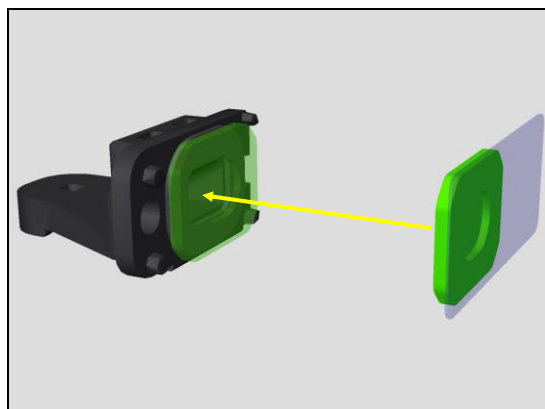


Paste at the center of the mic hole and within the outline of Holder Mic 1.



Reassembly

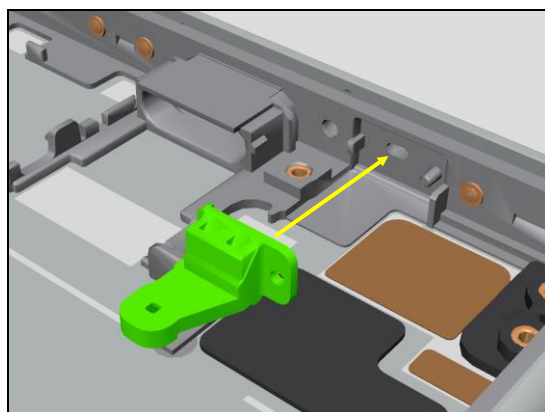
Paste the Sheet WR Mic on the Adhesive Mic 1.



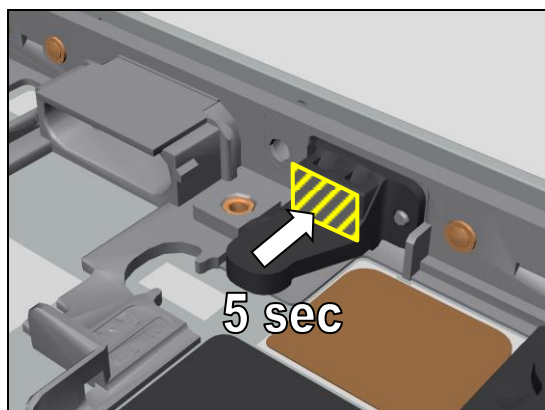
Paste exactly on the Adhesive Mic 1.



Paste the Holder Mic 1 on the Cover Main.

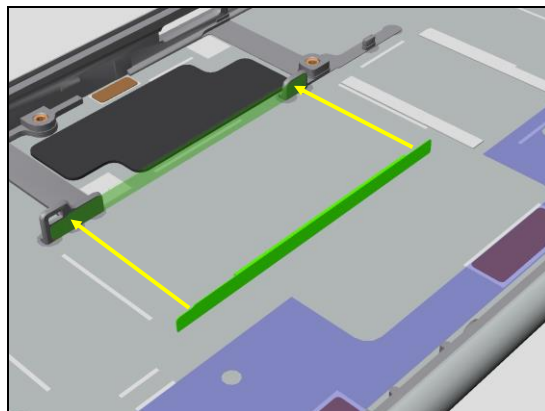


Press the hatched area for 5 sec.



5.5 Sheet Battery Side

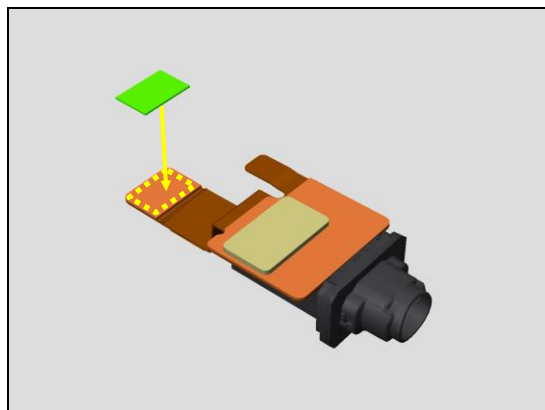
Paste the Sheet Battery Side on the Cover Main.



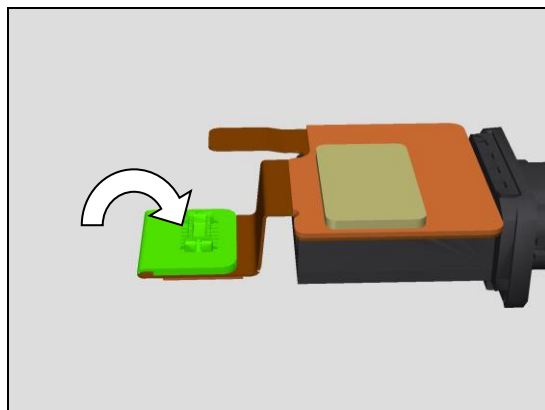
5.6 FPC JK

Paste the Sheet Spacer Audio Jack on the FPC JK.

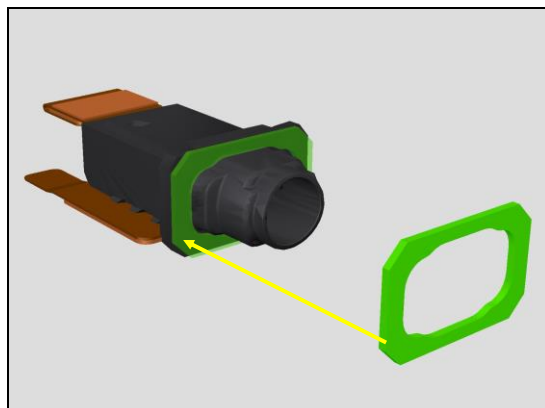
Paste within the FPC JK outline (yellow dotted box).



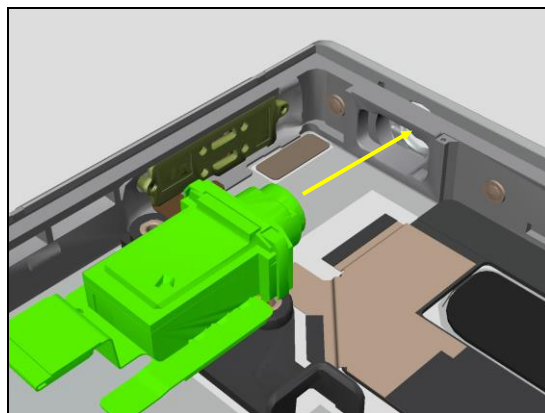
Fold the BtoB connector end of the FPC JK.



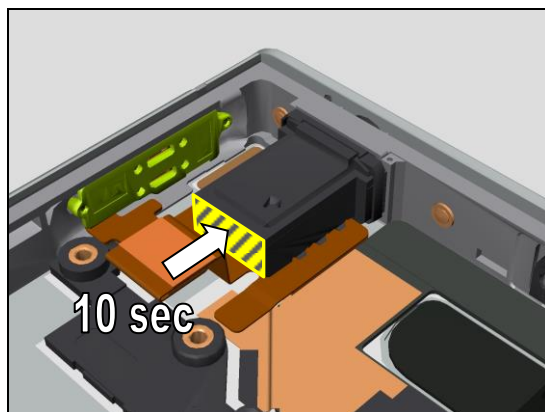
Paste the Adhesive WP Audio Jack on the FPC JK.



Paste the FPC JK on the Cover Main.

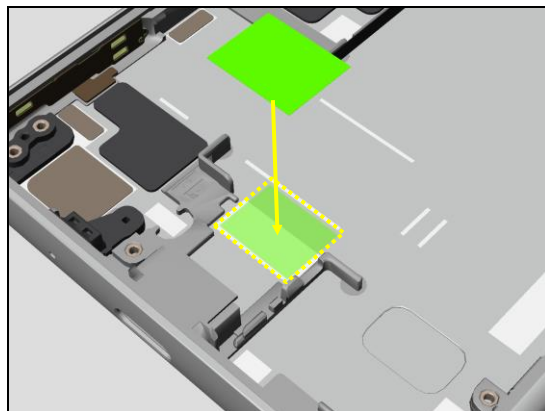


Press the hatched area with a finger for 10 sec.

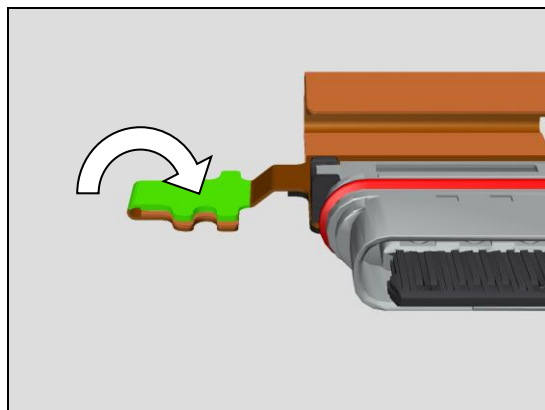


5.7 FPC USB

Paste the Adhesive RF Conductive GND USB.

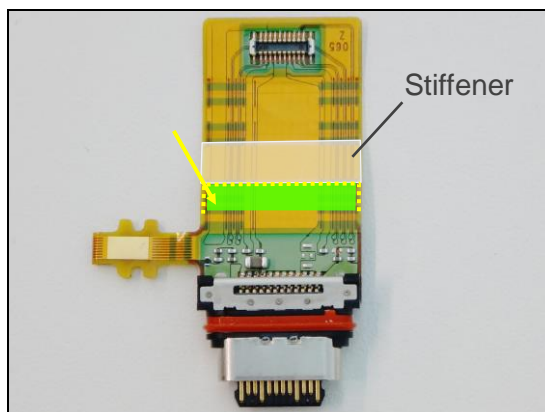


When using a brand new FPC USB, fold and paste the small FPC tab.

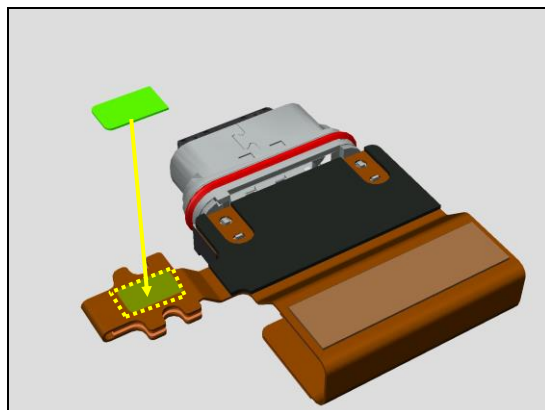


When using a brand new FPC USB, paste the Sheet FPC USB on the FPC.

Align with the FPC stiffener and paste at the center of the FPC.

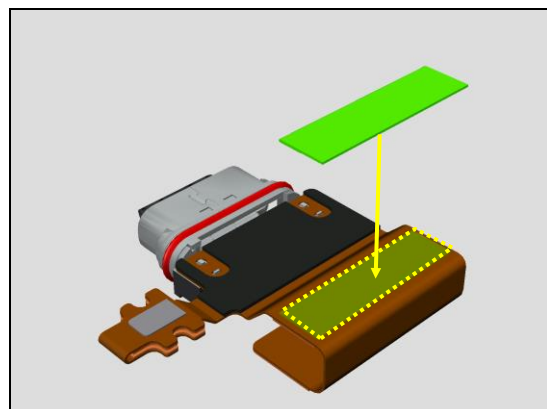


When reusing the FPC USB, paste the Adhesive RF Conductive FPC USB Sub on the metal contact area of the FPC USB.



Reassembly

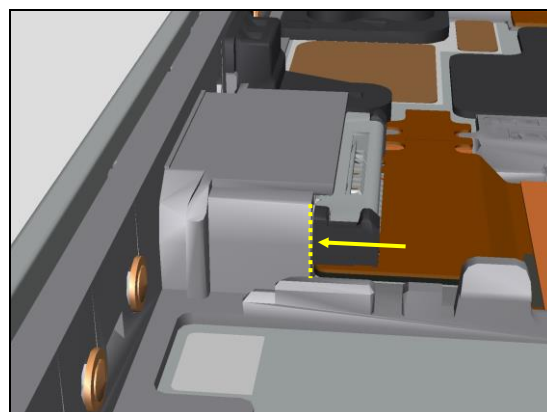
When reusing the FPC USB, paste the Gasket RF Conductive USB FPC on the metal contact area of the FPC USB.



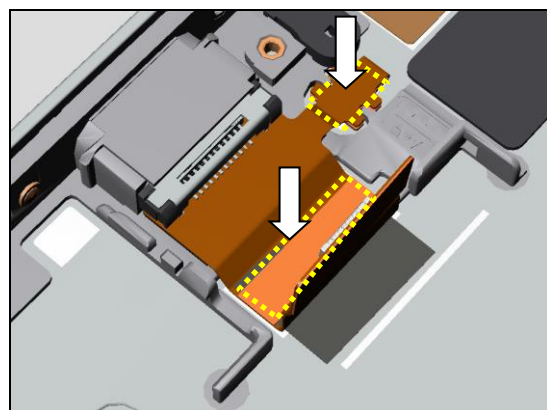
Attach the FPC USB on the Cover Main.



Make sure the FPC USB is inserted until the end.

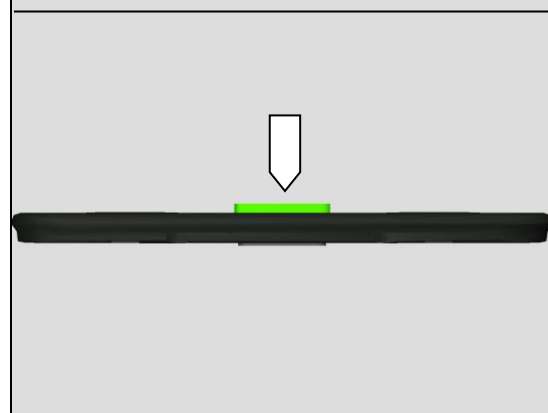
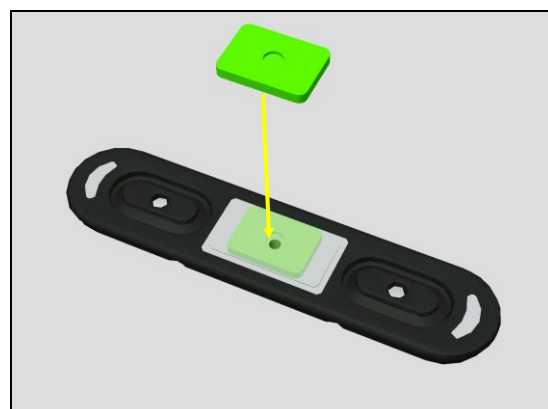


Press the adhesive areas with a finger.



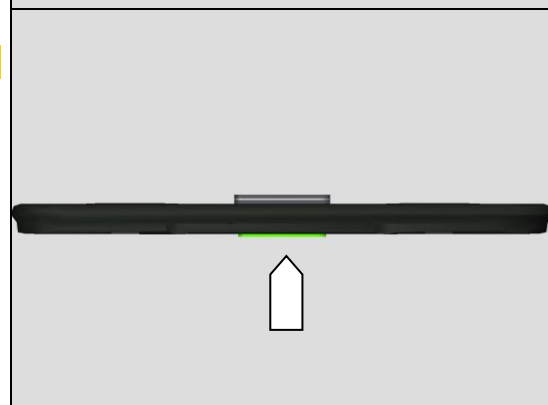
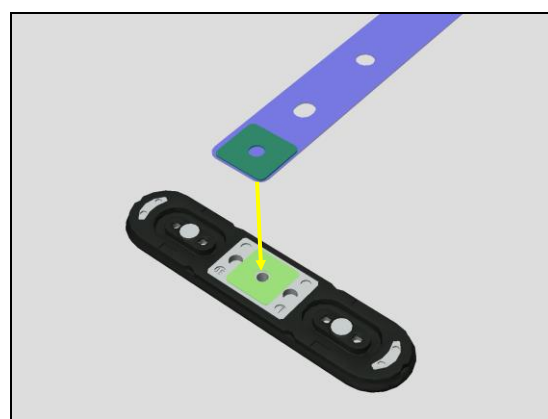
5.8 Key Volume

Paste the Sheet WR Test on the Gasket WR Key Volume.

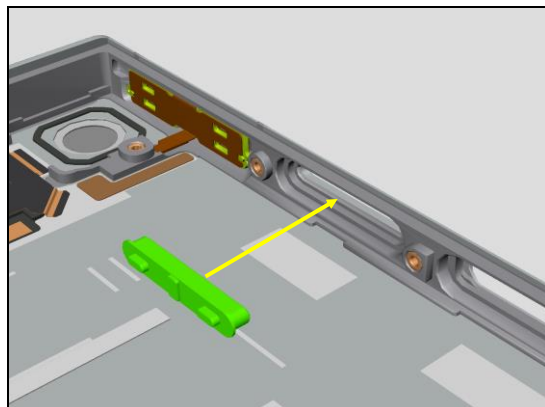


Paste the Adhesive WR Test on the Gasket WR Key Volume.

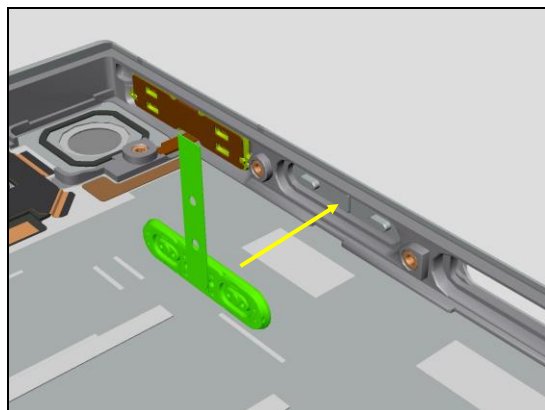
Keep the release film until the FPC Key is assembled.



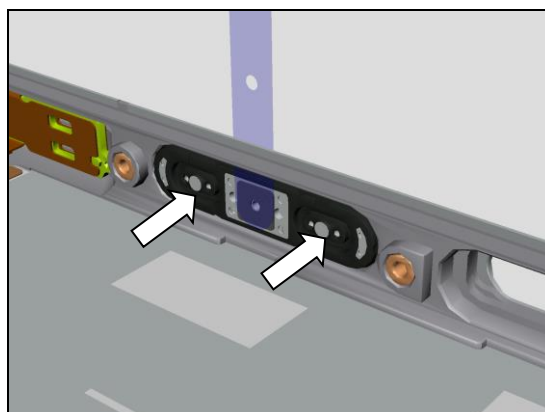
Attach the Key Volume on the Cover Main.



Attach the Gasket WR Key Volume on the Key Volume and Cover Main.

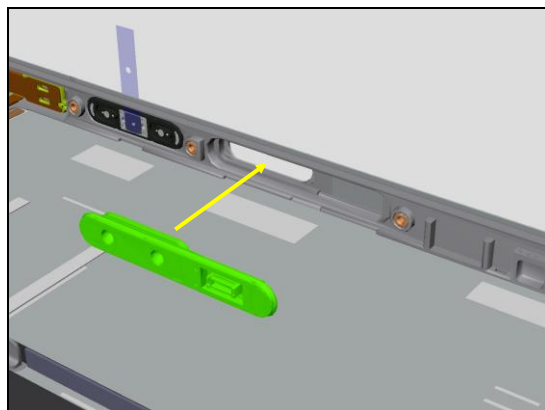


Press with a finger.

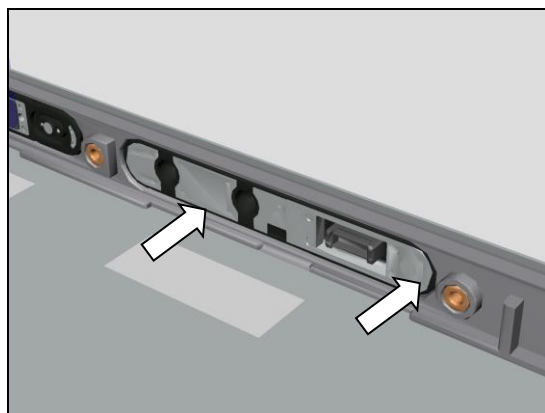


5.9 FP Sensor

Attach the FP Sensor on the Cover Main.

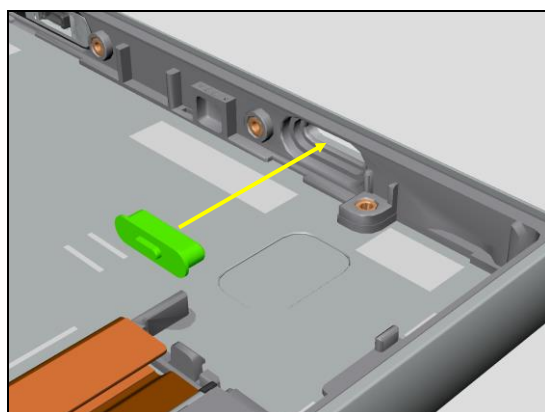


Press with a finger.

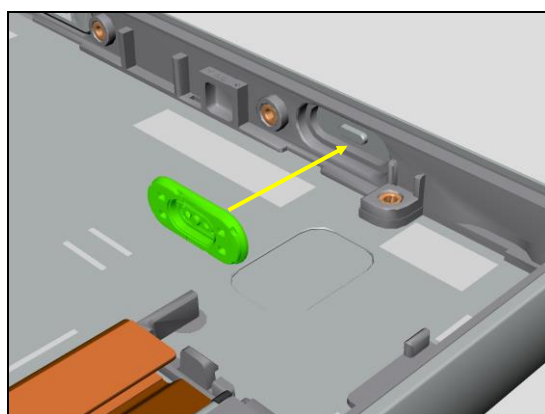


5.10 Key Camera

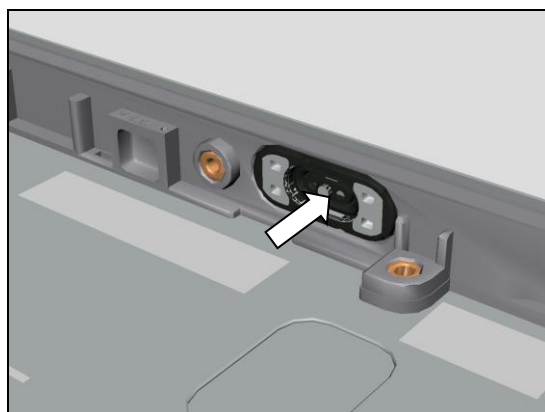
Attach the Key Camera on the Cover Main.



Attach the Gasket WR Key Camera on the Key Camera and Cover Main.

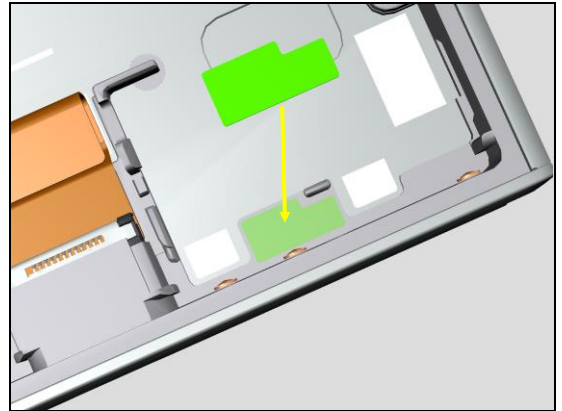


Press with a finger.

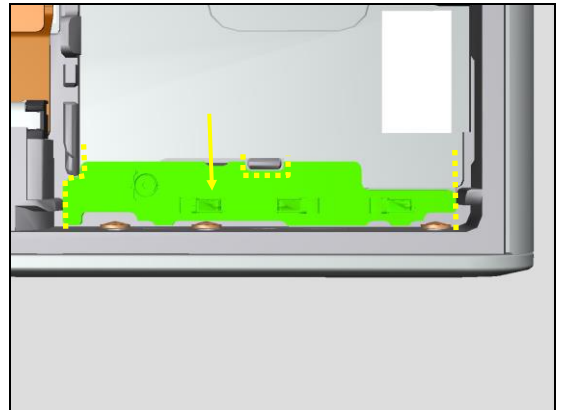


5.11 Sub PBA

Paste the Adhesive Sub PBA on the Cover Main.

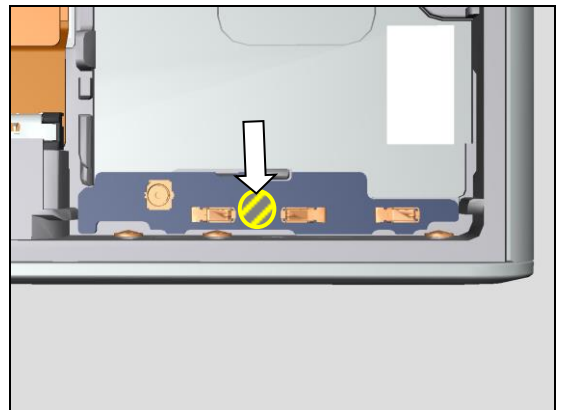


Paste the Sub PBA on the Cover Main.



Press the yellow area with the Nylon pointer.

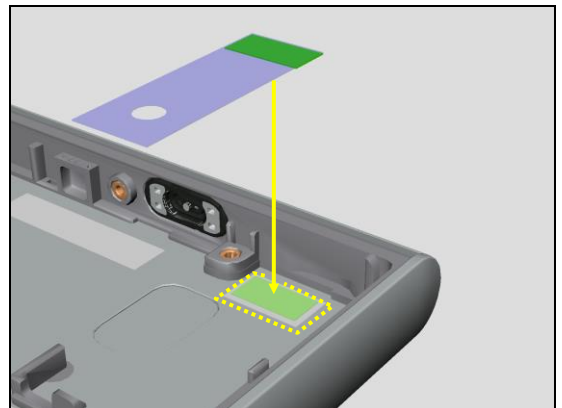
Do not damage the onboard components.



5.12 FPC Key

Paste the Adhesive Vib within the metal area of the Cover Main.

Keep the release film until the FPC Key is assembled.



Reassembly

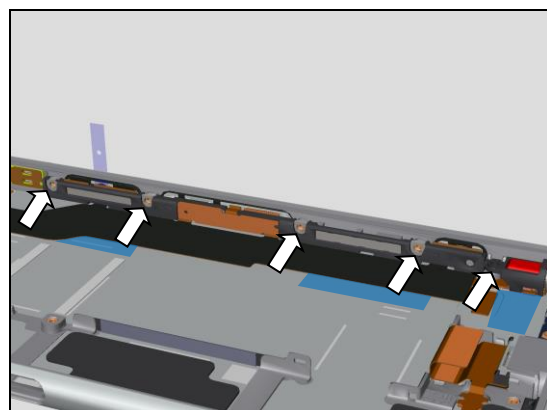
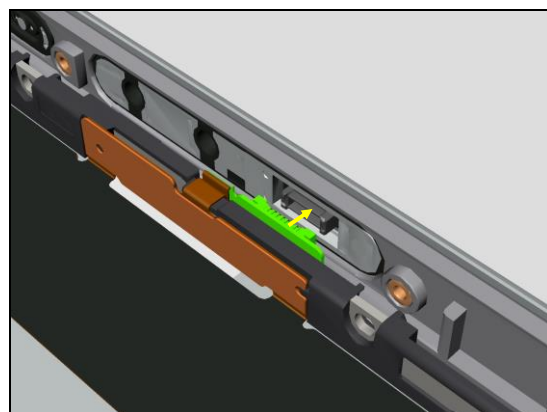
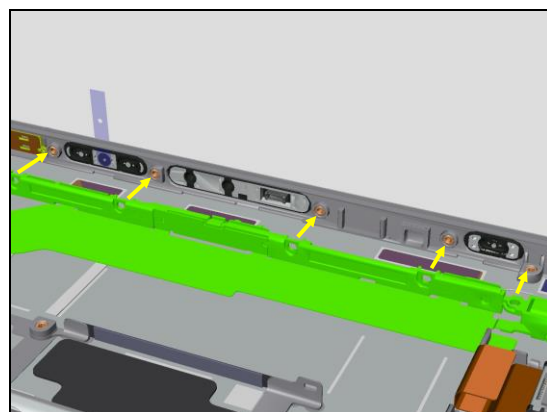
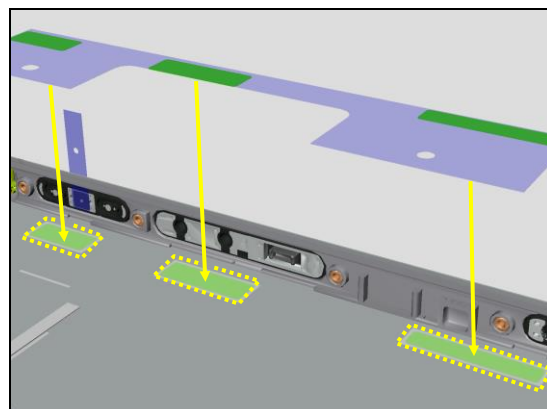
When reusing the FPC Key or Cover Main, paste the Adhesive RF Conductive Key FPC within the metal areas of the Cover Main.

Keep the release film until the FPC Key is assembled.

Put the FPC Key close to the Cover Main.

Connect the BtoB connector of the FPC Key to the FP Sensor.

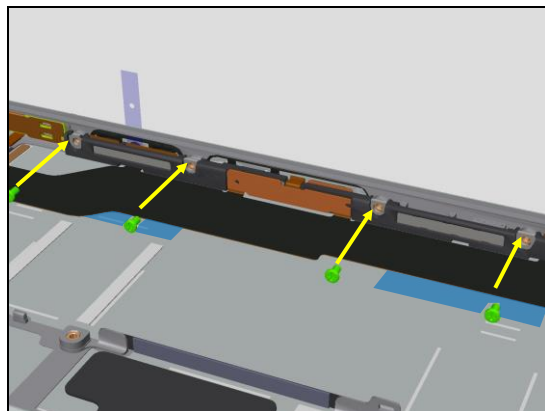
Attach the FPC Key by the hooks.



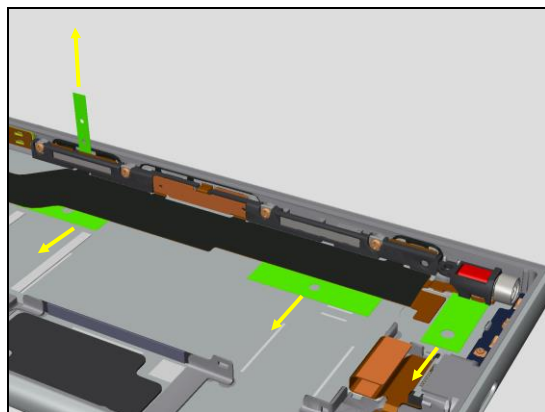
Reassembly

Tighten the 4 pcs of Screw M1.2x2.1 with Screwdriver PH0 x 100.

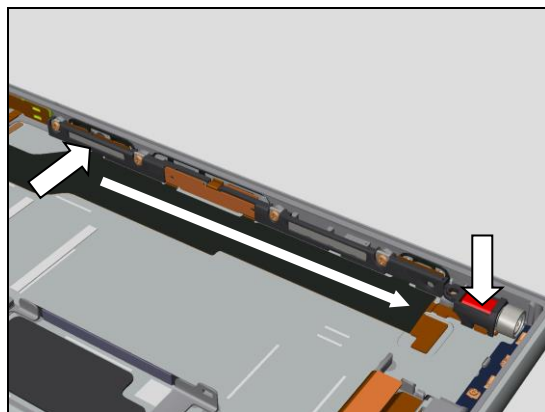
Torque : 8 Ncm



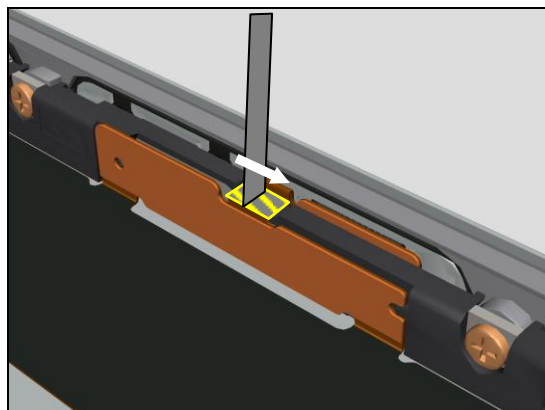
Remove the release films of Adhesive Vib and Adhesive RF Conductive Key FPC.



Press the adhesive areas with a finger.



Press the yellow hatched FPC area by sliding the Nylon pointer flat end.

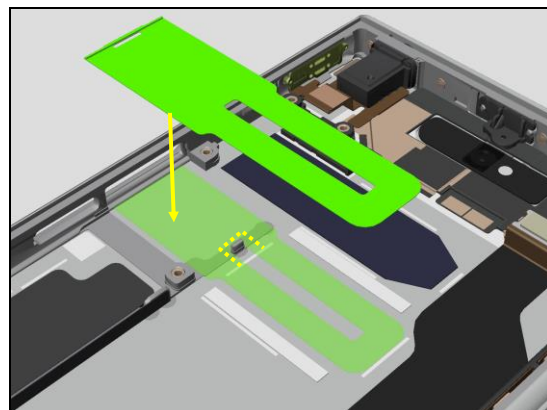
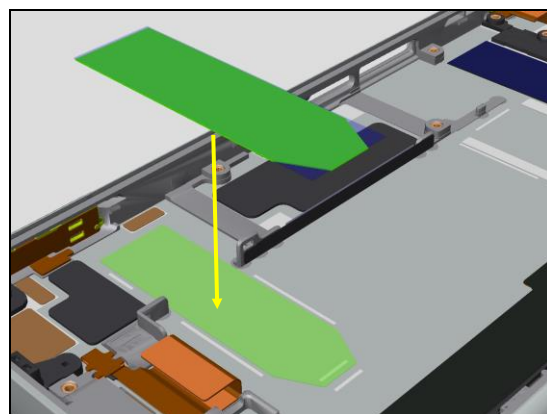
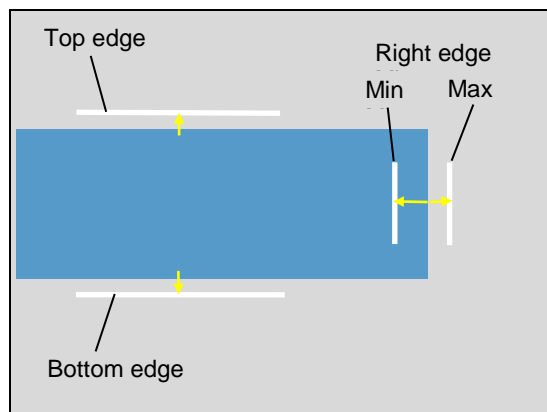
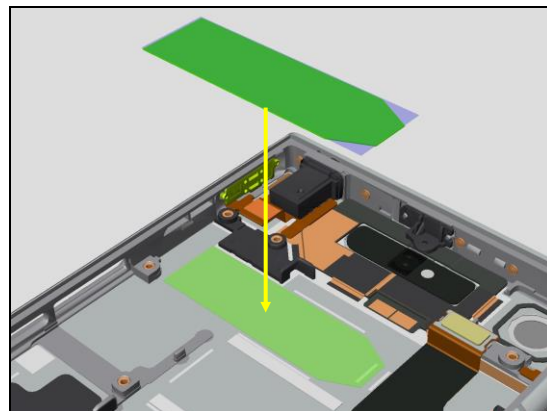


5.13 Adhesive Battery

Paste the Adhesive Battery on the top side of Cover Main.

Paste within the guide lines on the Cover Main.

Paste another Adhesive Battery on the bottom side of Cover Main in the same way.

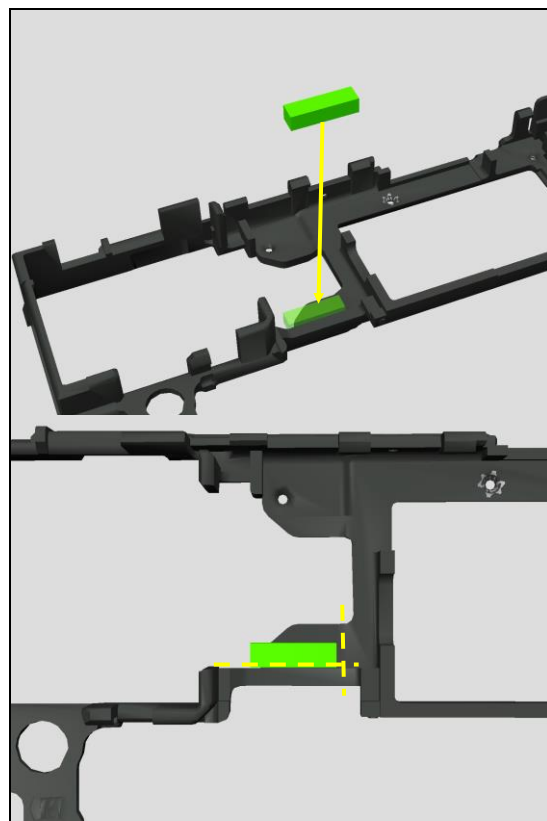


5.14 Sheet Slider Label MoP

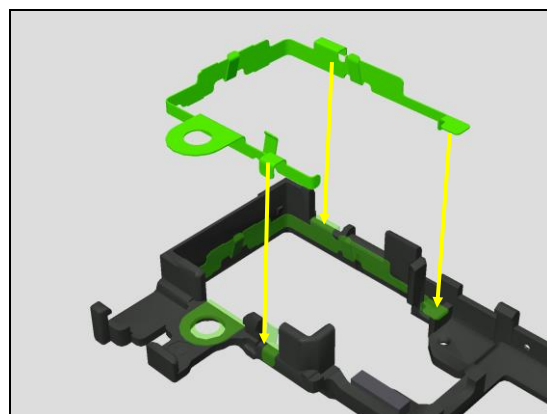
Attach the Sheet Slider Label MoP.

5.15 Holder Ant Sub

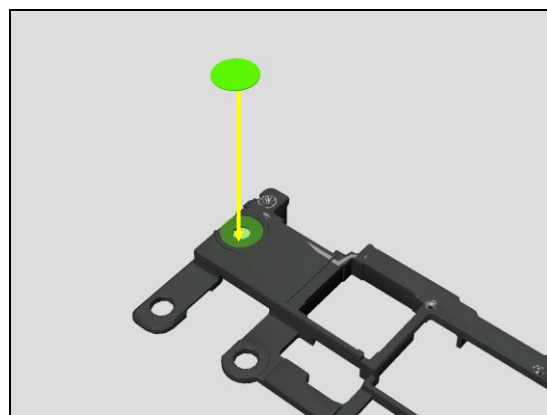
Paste the Cushion Shade Proximity Sensor on the Holder Ant Sub.



Attach the Shield Main Camera on the Holder Ant Sub.



Paste the Sheet Lightguide 3LED on the Holder Ant Sub.



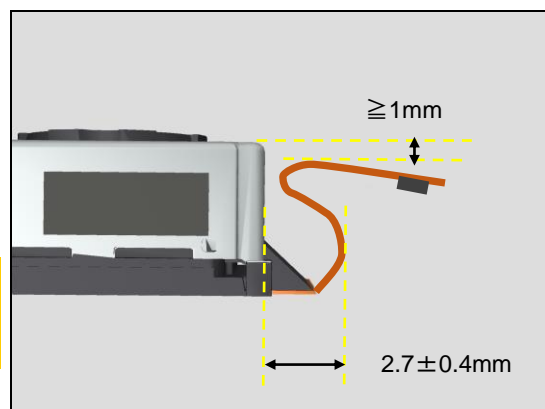
5.16 Main Camera

5.16.1 FPC inspection

Make sure the FPC condition in idle state complies with the shown criteria.

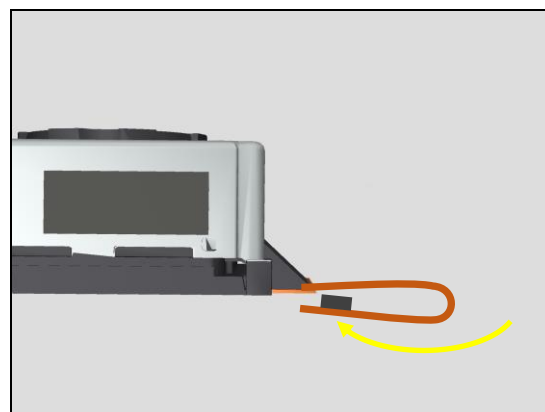
If it does not meet the criteria or when using a brand new Main Camera, go to 5.16.2.

If it meets the criteria, skip 5.16.2 and go to 5.16.3.



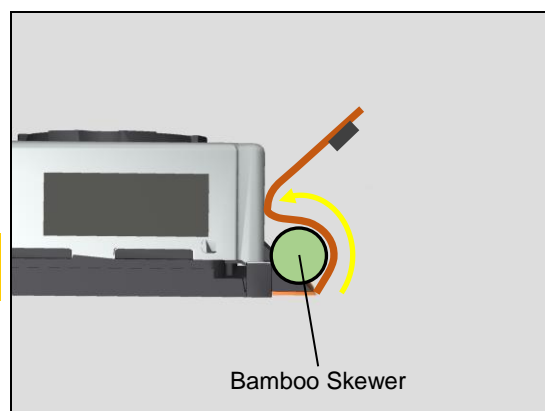
5.16.2 FPC pre bending

Fold the BtoB connector end of the Main Camera with a finger.

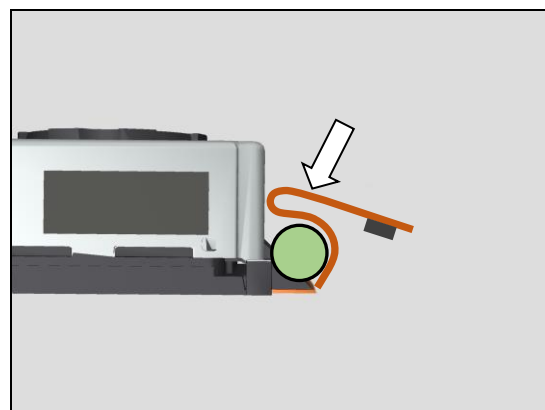


Place the Bamboo Skewer on the FPC of Main Camera and fold the FPC along the Bamboo Skewer.

Do not lift the Bamboo Skewer off the FPC during operation.



Press the FPC with a finger.



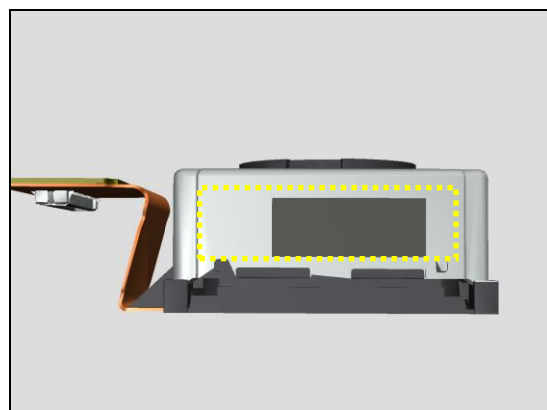
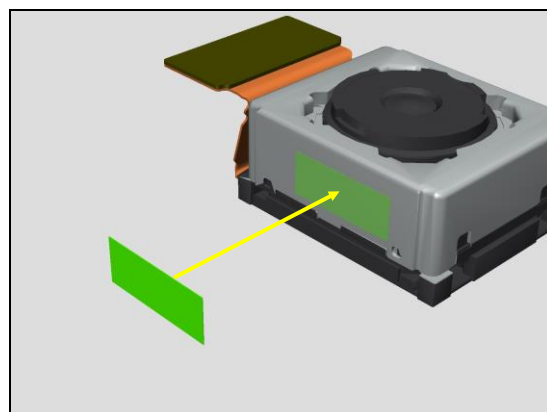
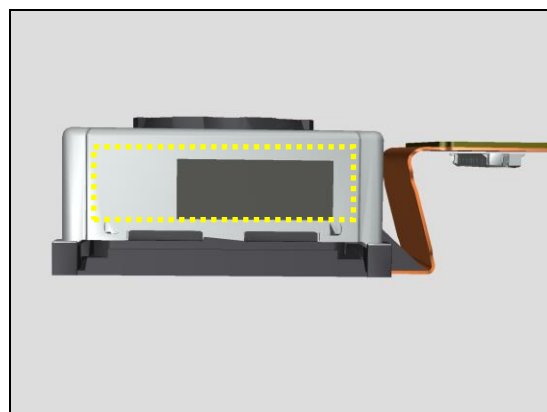
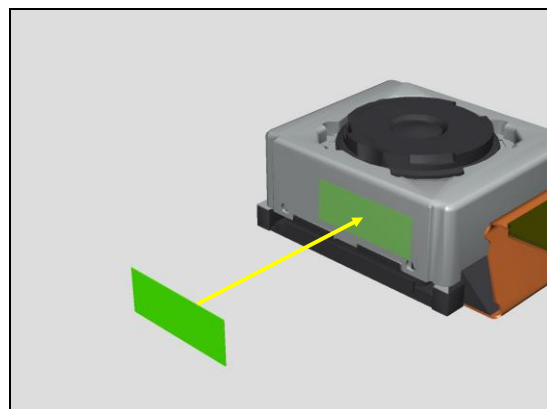
5.16.3 Assemble Main Camera

Paste the Sheet RF Conductive GND Camera on the Main Camera.

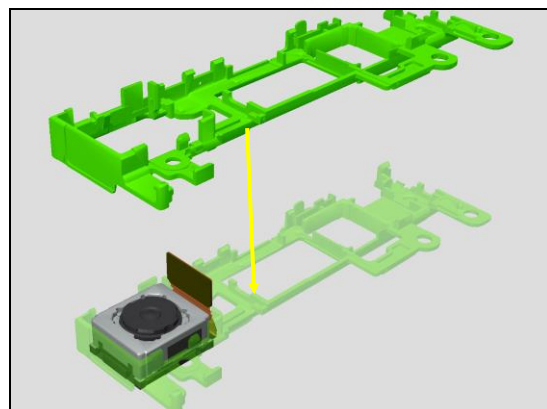
Paste within the yellow dotted box.

Paste another Sheet RF Conductive GND Camera on the other side of Main Camera.

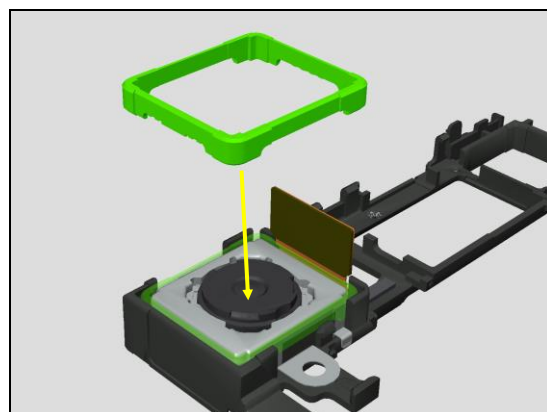
Paste within the yellow dotted box.



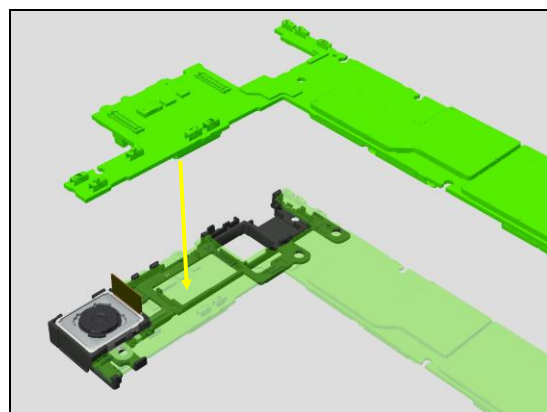
Attach the Holder Ant Sub on the Camera Main.



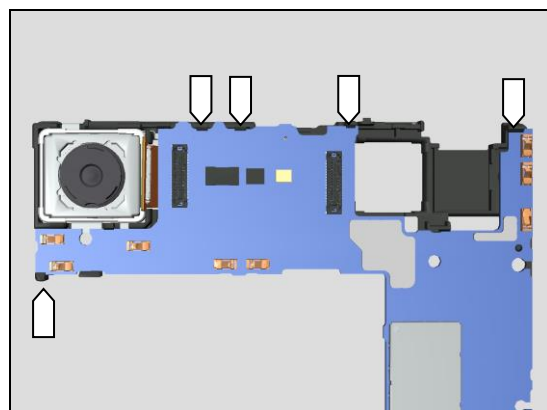
Attach the Holder Main Camera on the Camera Main.



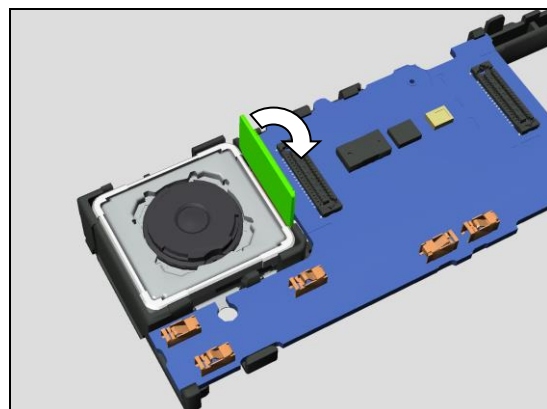
Put the PBA Main on the Holder Ant Sub.



Attach by the hooks.

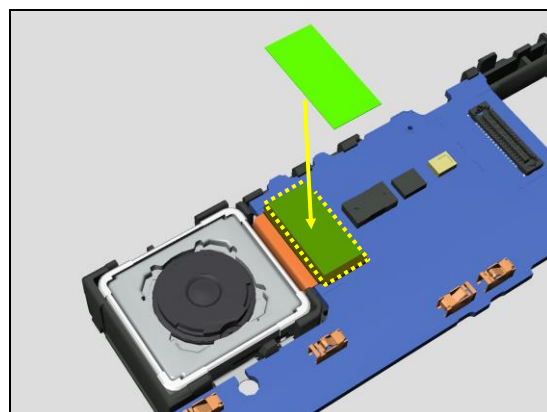


Connect the BtoB connector of the Main Camera.

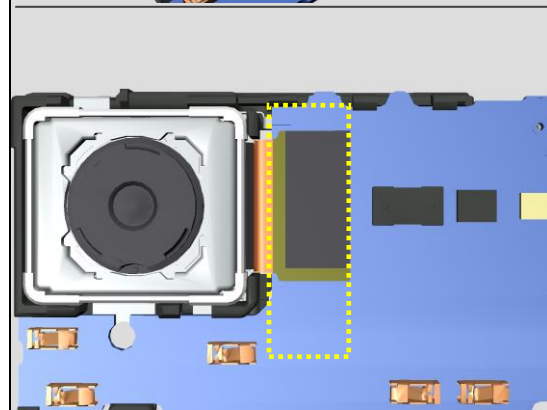
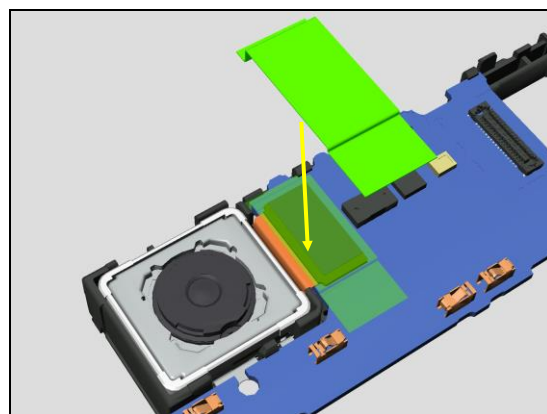


Paste the Sheet Spacer Main Camera BtoB on the BtoB connector of the Main Camera.

Paste within the BtoB stiffener outline (yellow dotted box).

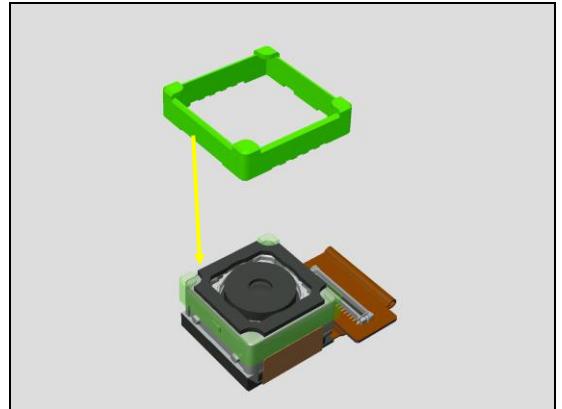


Paste the Cushion BtoB Cam to hold the BtoB connector and PBA Main.

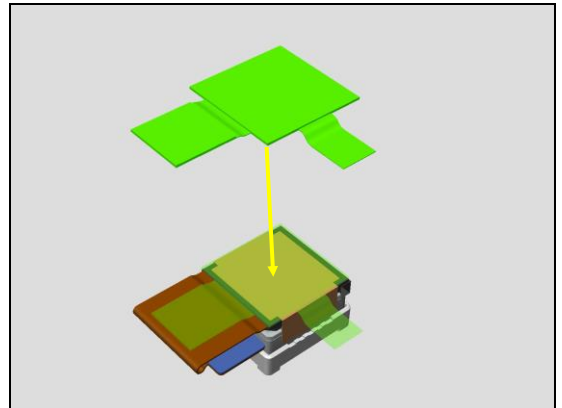


5.17 Front Camera

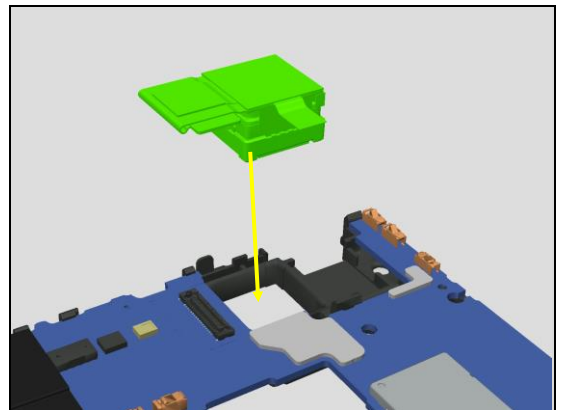
Attach the Holder Front Camera on the Front Camera.



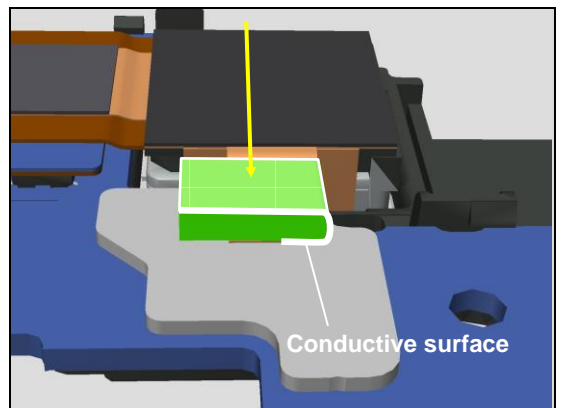
Paste the Sheet RF Conductive Front Camera on the Front Camera.



Attach the Front Camera on the PBA Main.
Connect the BtoB connector.



Paste the Gasket RF Conductive Front Camera across the
Sheet RF Conductive Front Camera and PBA Main.



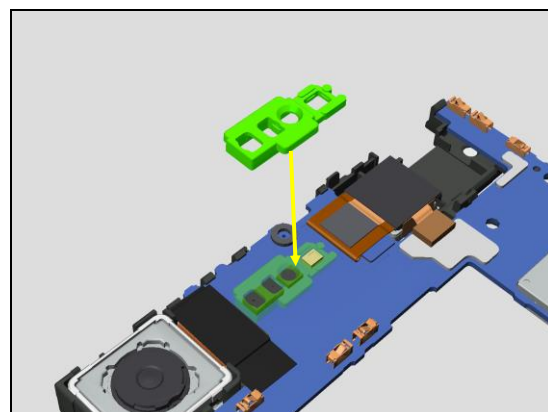
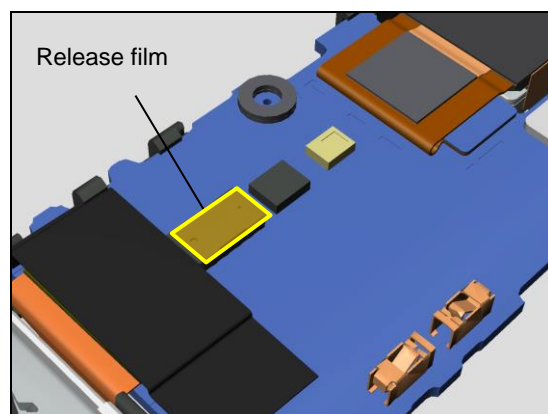
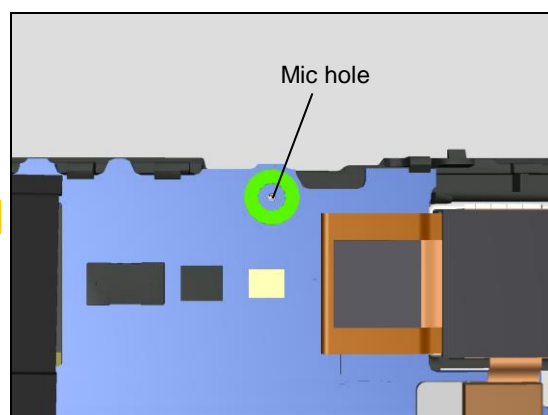
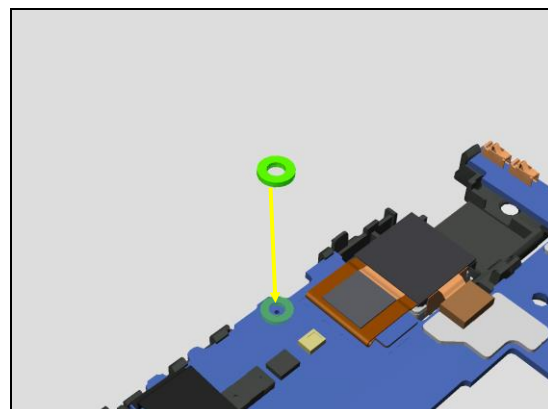
5.18 PBA Main

Paste the Cushion Mic 2 PBA on the PBA Main.

Paste at the center of the mic hole on the board.

When using a brand new PBA Main, remove the release film on the ToF sensor.

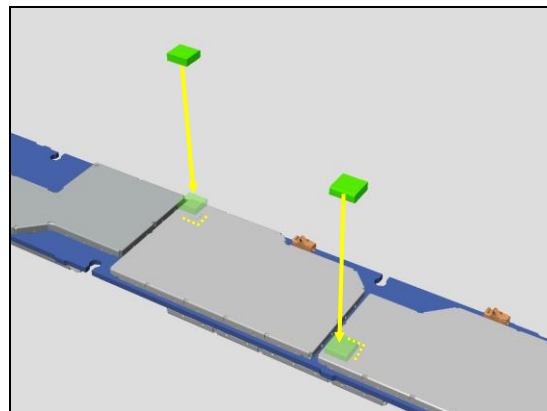
Attach the Holder Sensor on the PBA Main.



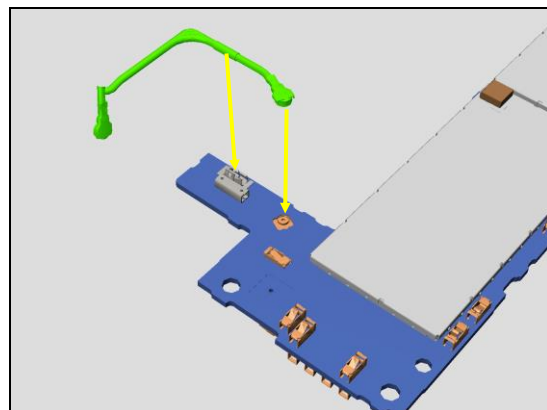
Reassembly

Paste 2 pcs of the Gasket RF Conductive Audio Jack on the shield lids.

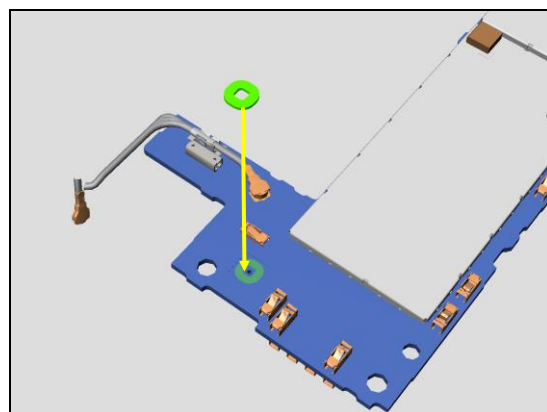
Paste within the guide lines on the shield lids.



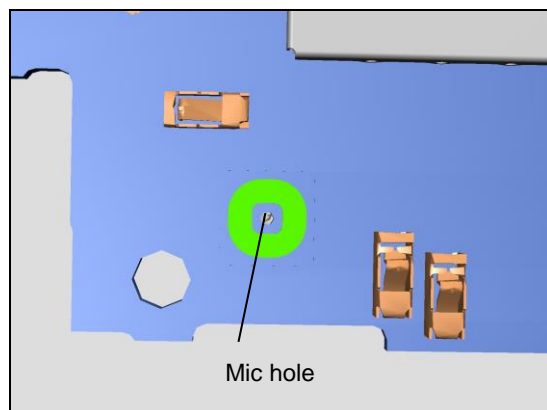
Connect the RF Cable connector and attach on the hook.



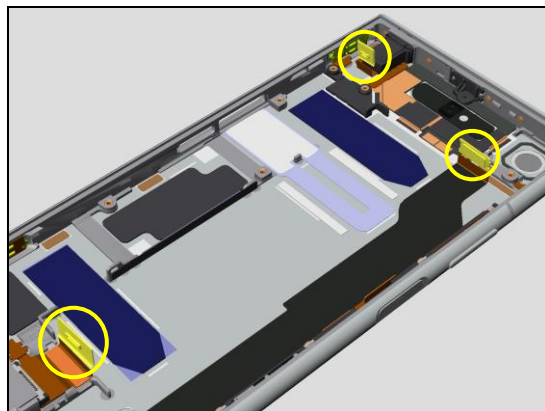
Paste the Adhesive Mic 1 PBA on the PBA Main.



Paste at the center of the mic hole on the board.



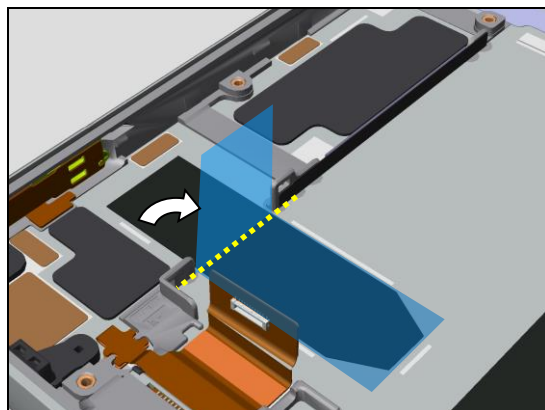
Put the three BtoB connectors up.



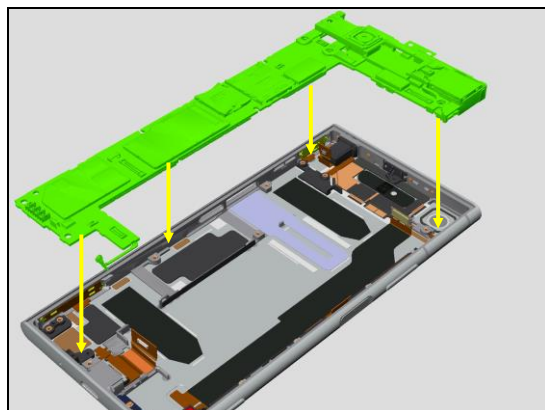
Fold the release film of the Adhesive Battery at the top side.



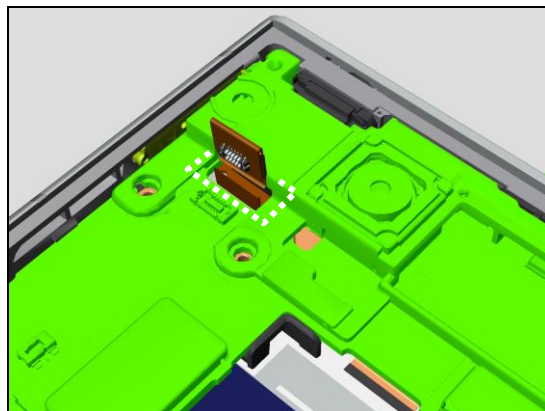
Fold the release film of the Adhesive Battery at the bottom side



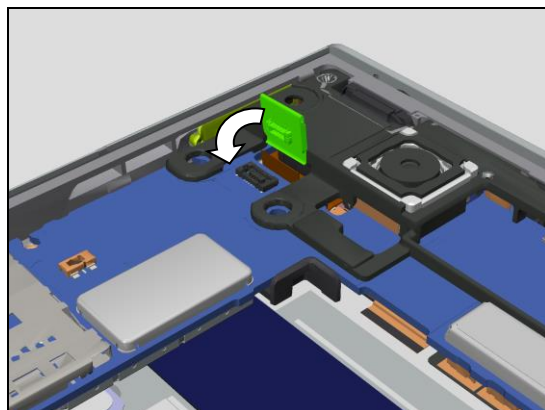
Put the PBA Main on the Cover Main and attach by the hooks.



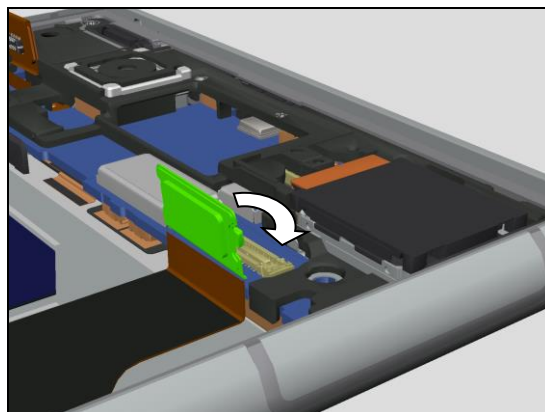
Let the BtoB connector of FPC JK through the slit.



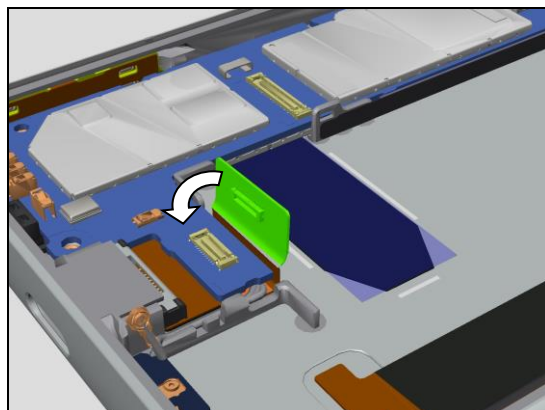
Connect the BtoB connector of the FPC JK.



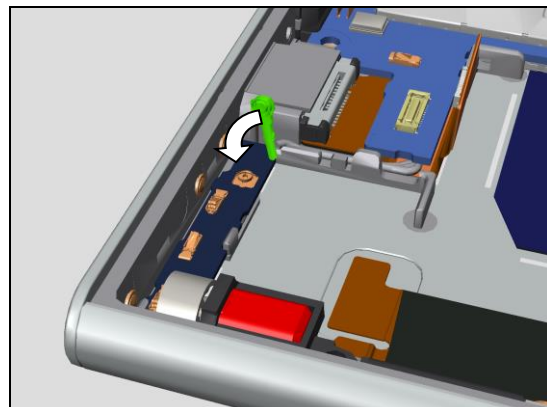
Connect the BtoB connector of the FPC Key.



Connect the BtoB connector of the FPC USB

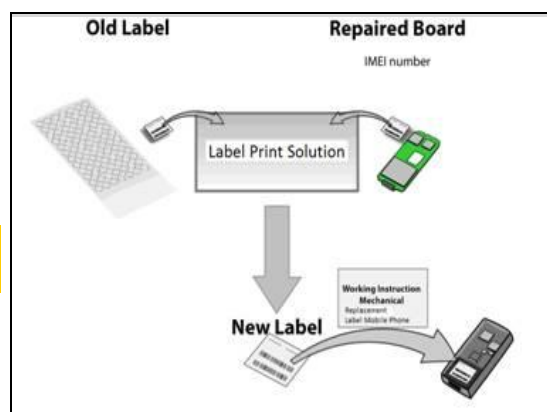


Connect the RF Cable connector.



When replacing PBA Main, replace the MoP Label.

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



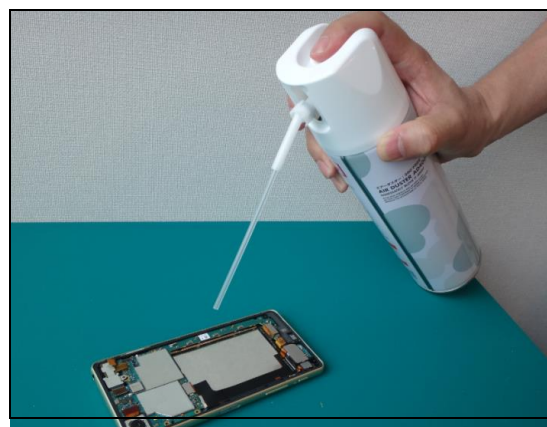
5.19 Battery

Note!

Clean the battery compartment by pressure air using air duster spray can or ionized air blower.

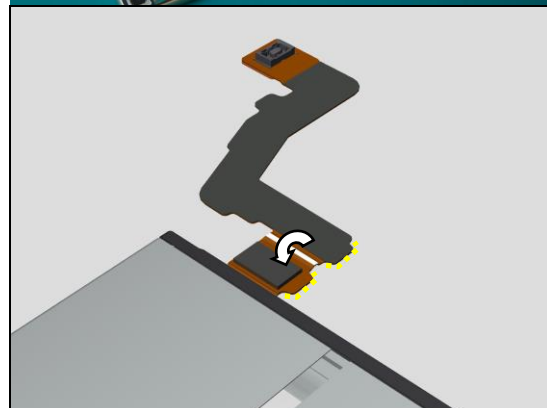
Make sure no foreign materials on the battery compartment of the unit.

Any foreign materials put into between battery and unit will be the cause of battery damages.



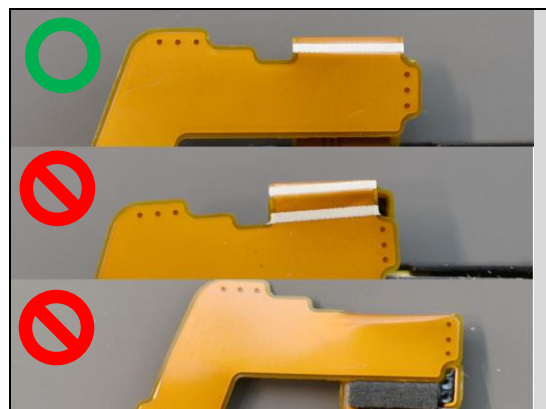
When using a brand new Battery, fold the FPC at the white line.

Align two tabs.

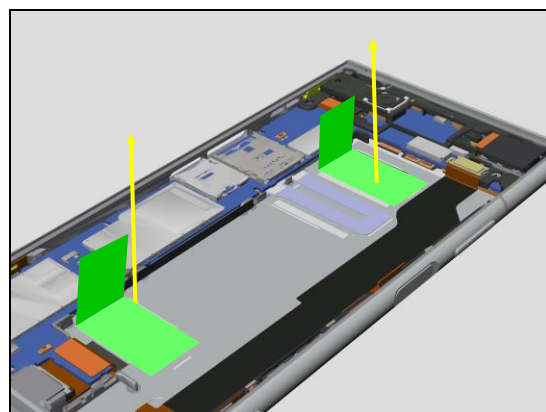


Reassembly

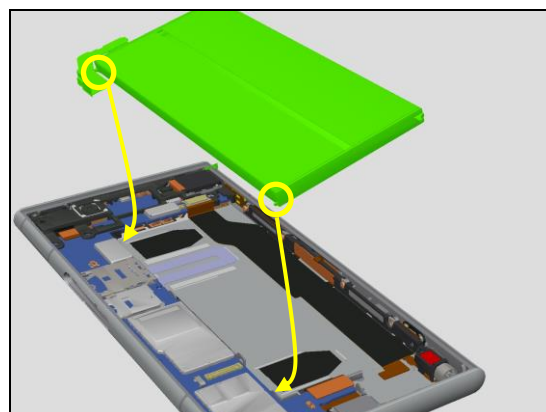
After folding, make sure only single white line is visible in top view.



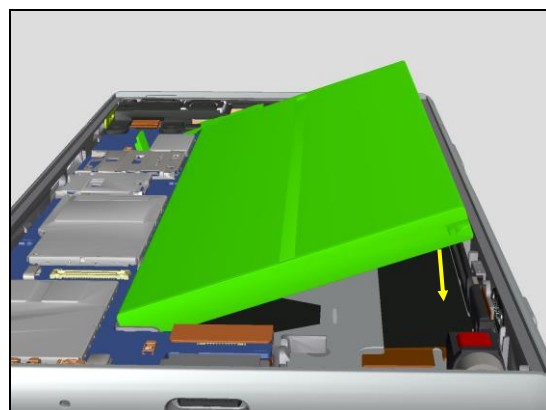
Remove the release films of the Adhesive Battery.



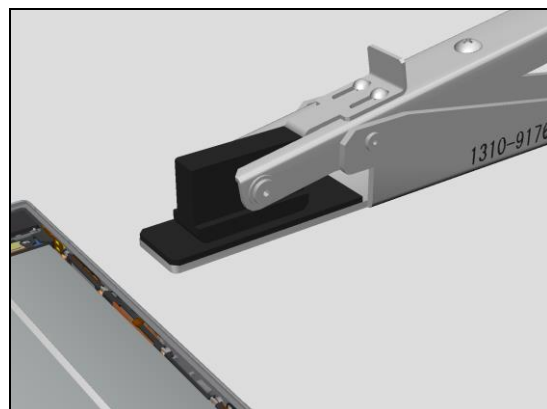
Attach the Battery on the Cover Main.



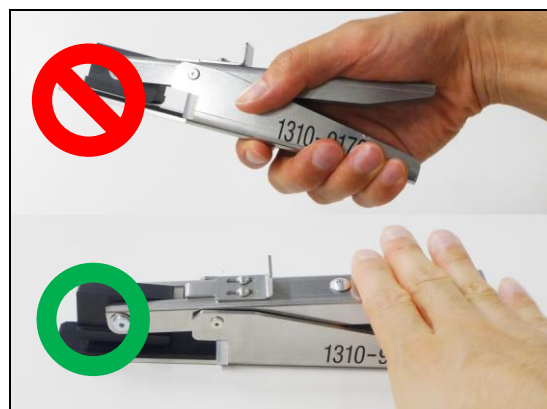
Paste the Battery on the Adhesive Battery.



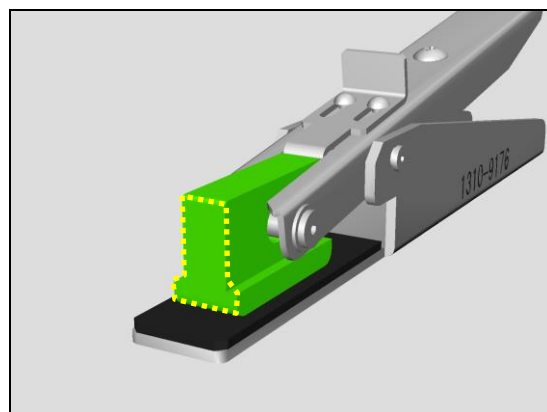
Set the Press Cramp on a workbench.



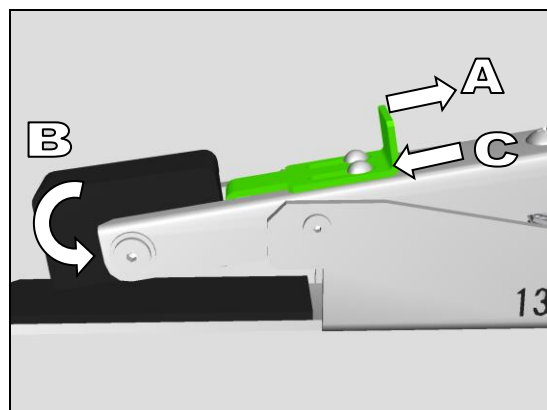
Do not grip the Press Cramp.



Make sure the press head is wide bottom angle.

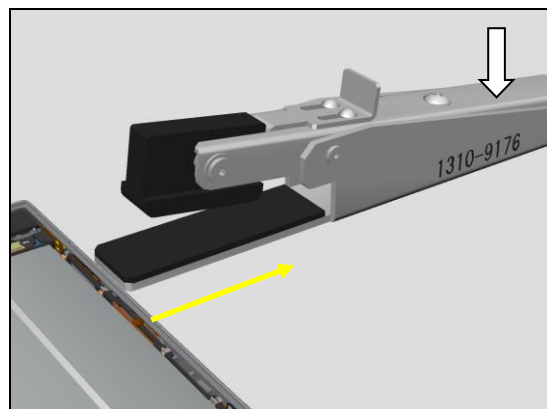


If it's the other way around, (A)slide the lever to unlock and
(B)turn the press head.
(C)Slide the lever to lock the press head.



Reassembly

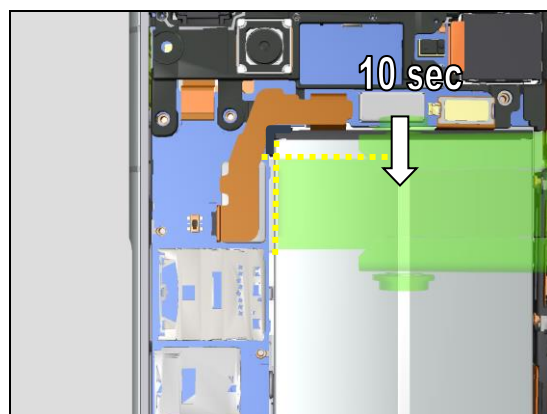
Open the press head to insert the unit.



Align the press head with the yellow dotted lines and press for 10 sec.

Top side: The bottom end of “└”-shape battery fence.

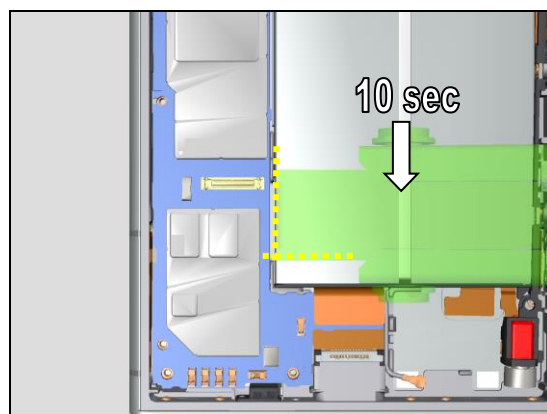
Left side: The left edge of the Battery.



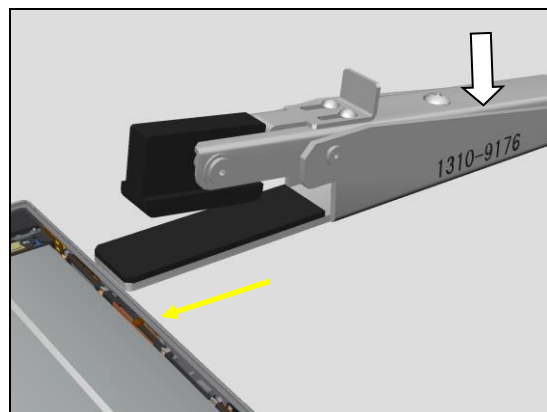
Align the press head with the yellow dotted lines and press for 10 sec.

Bottom side: The top end of “└”-shape battery fence.

Left side: The left edge of the Battery.



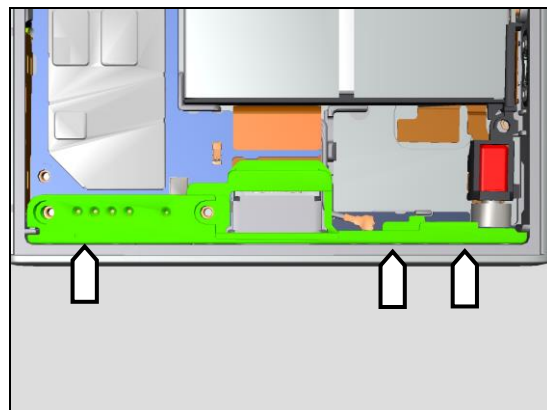
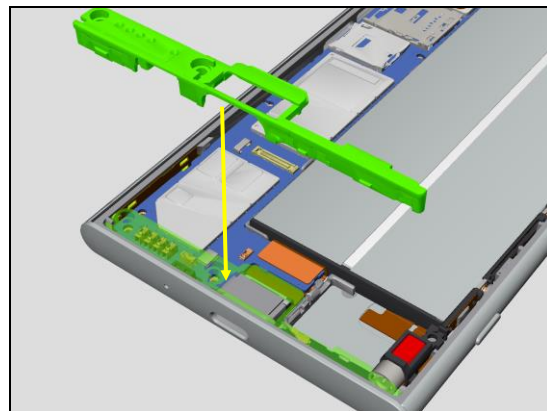
Open the press head to release the unit.



5.20 Holder Ant Main

Put the Holder Ant Main on the Cover Main.

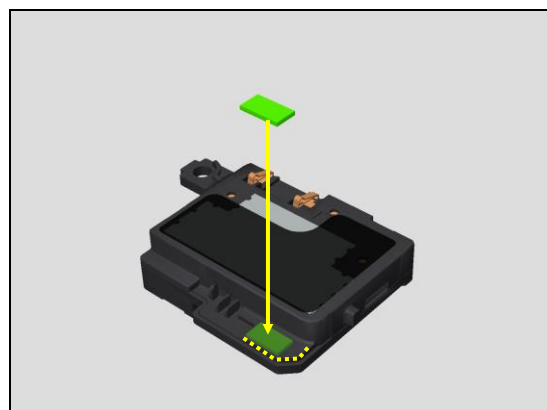
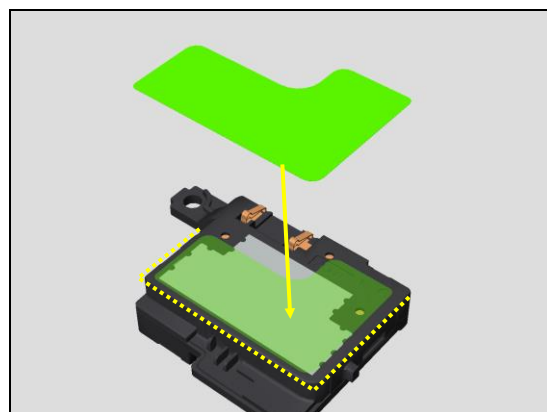
Attach the holder Ant Main by the hooks.



5.21 Speaker Box

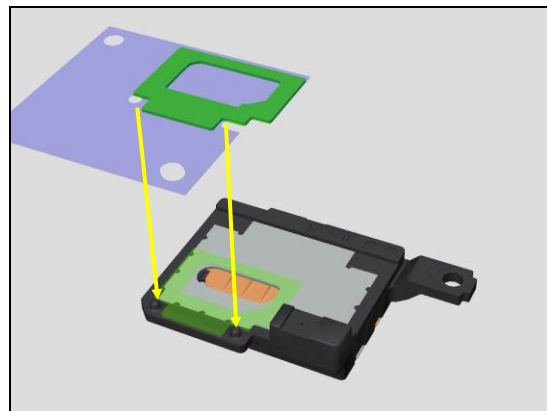
Paste the Sheet Insulative Speaker Box on the Speaker Box.

Paste within the outline of the Speaker Box.

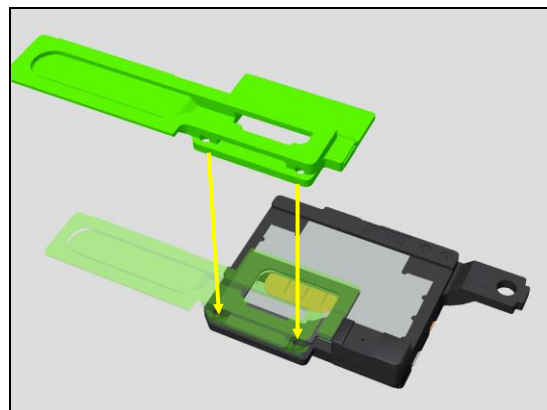


Paste the Cushion Speaker Box on the Speaker Box.

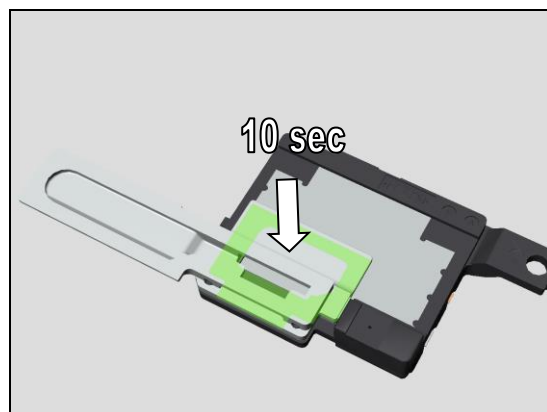
Paste the Adhesive WR Speaker Box on the Speaker Box.



Paste the Holder Speaker Bottom on the Adhesive WR Speaker Box.

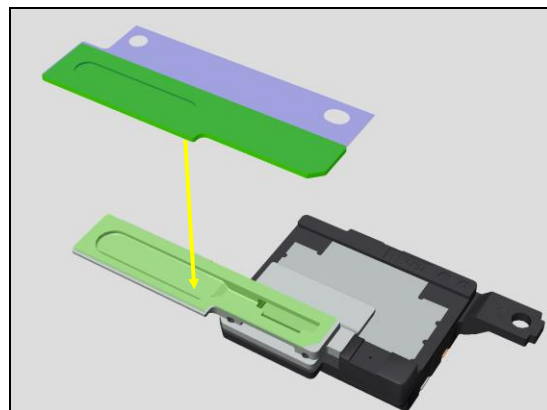


Press the Adhesive WR Speaker Box area with a finger for 10 sec.



Paste the Net WR Speaker Bottom on the Holder Speaker Bottom.

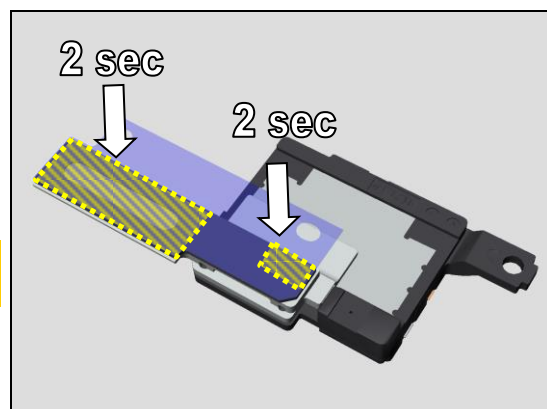
Paste within the outline of the Holder Speaker Bottom.



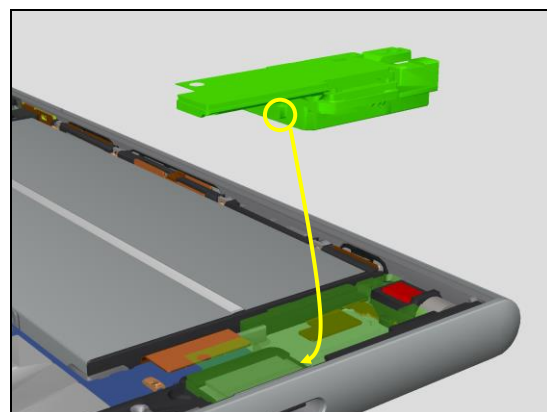
Reassembly

Gently press the yellow hatched areas with a finger for 2 sec.

Keep the release film until the Holder LCD BtoB is assembled.



Attach the Speaker Box on the Cover Main.

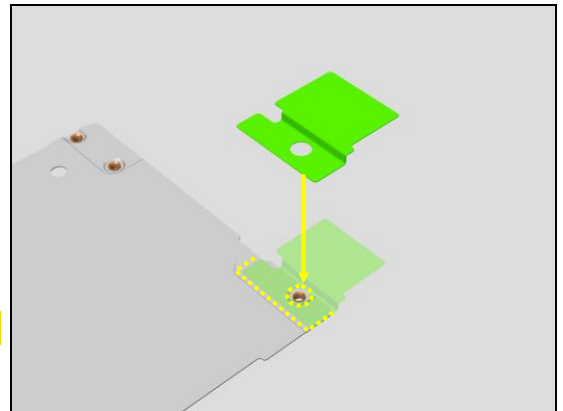


5.22 Plate Display

5.22.1 Paste sheets

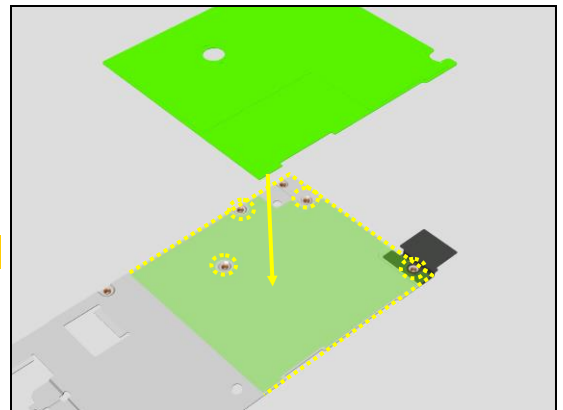
Paste the Sheet Graphite Main Camera on the Plate Display.

Do not cover the screw hole.



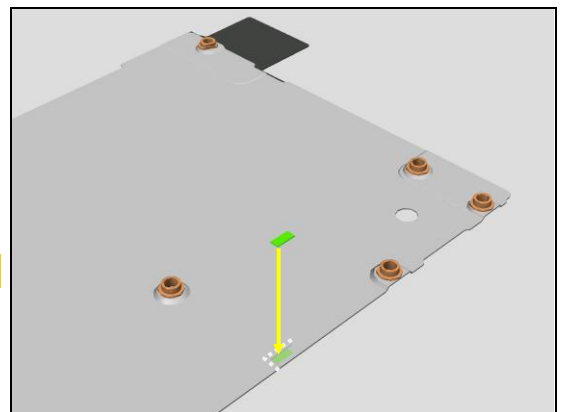
Paste the Sheet Graphite Plate Display on the Plate Display.

Do not cover the screw holes.



In case of replacing the Liquid indicator, paste the Liquid indicator.

Align with the guideline engraved on the Plate Display.



5.22.2 Apply the Thermal Gap Filler

Thermal Gap Filler needs to be reapplied when replacing PBA Main or Plate Display.

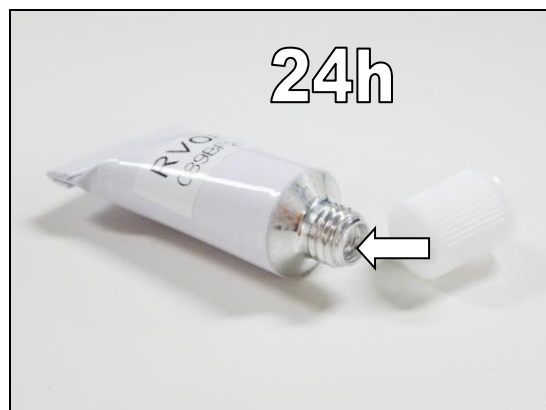
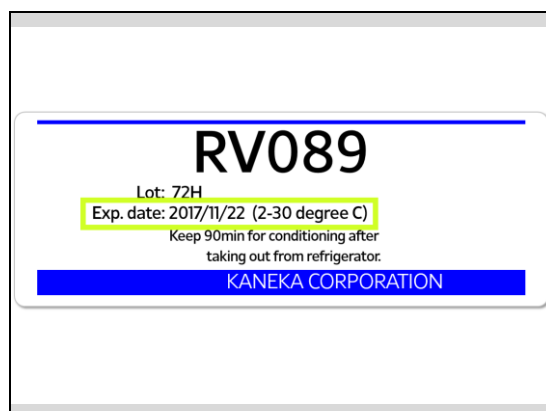
Open the embedded Thermal Gap Filler instruction in attachment, and make sure to go through it prior to use!



Confirm the expiration date that is printed on the package label.

Open the tube with cap head

**Material will start to set once it is exposed to air.
Scrap! Thermal Gap Filler Tube cannot be used in 24h after opening.**

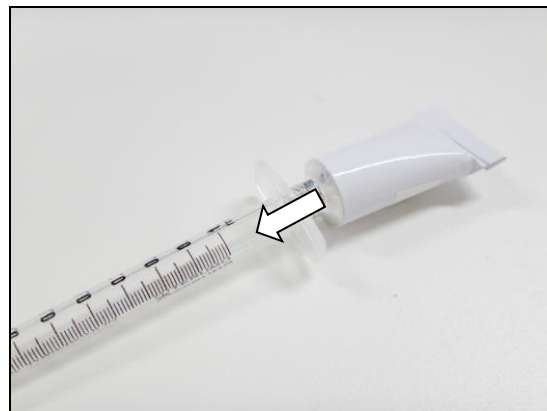


Reassembly

Fill the contents of the tube in to the syringe from the end of the syringe.

Once filled in the syringe, must use within 1 hour.

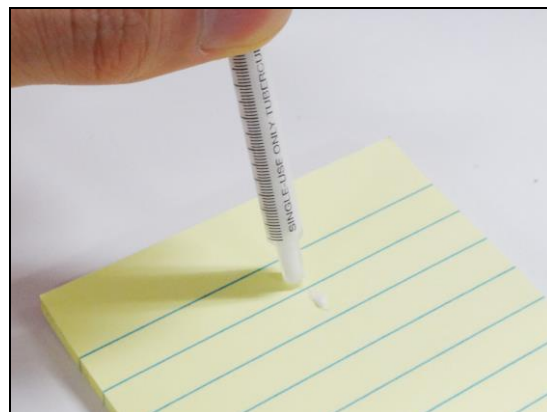
Scrap! Thermal Gap Filler Syringe cannot be used 1hour after filling.



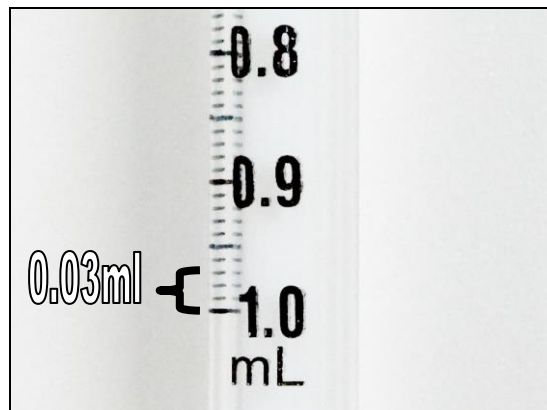
Make sure the contents reach up to the tip of the syringe and a small amount of the contents flows out as air is released.



Wipe off the tip before using.

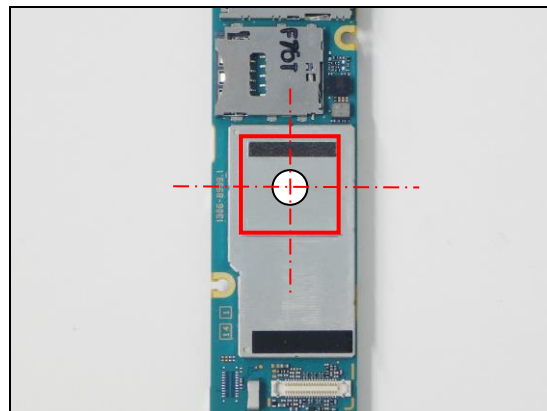


Applying volume for one unit is 0.03 ml.

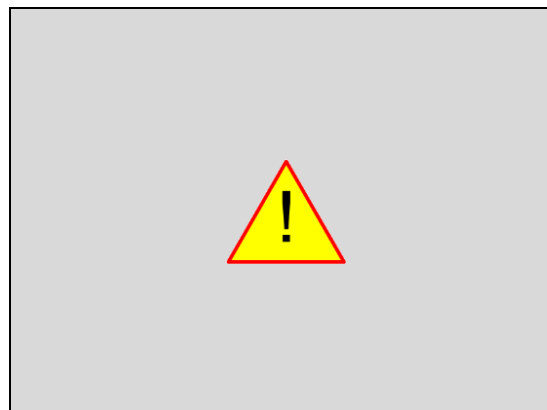


Reassembly

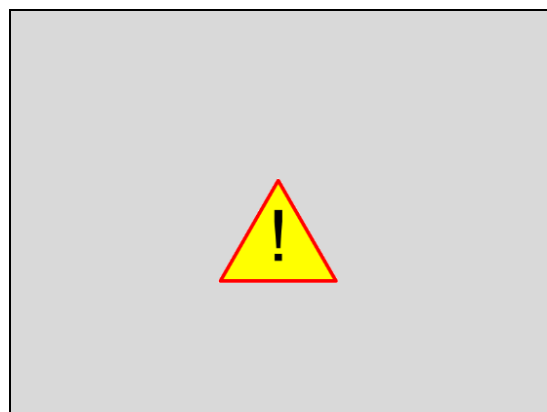
Carefully apply the Thermal Gap Filler on the PBA shield lid (at the center of the red square area) as shown in the picture.



Installing of the Plate Display must be done immediately after applied Thermal Gap Filler (within 5 minutes).

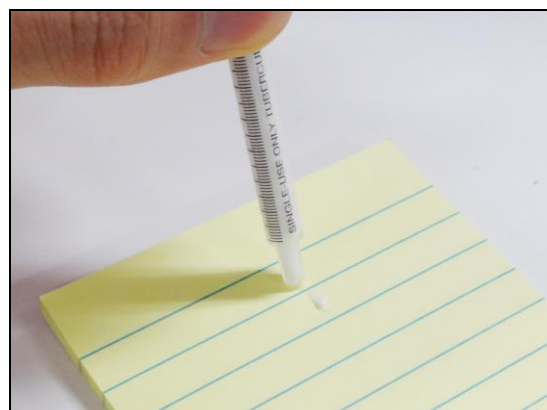


Note! If the position or amount is not correct, wipe it off with a cotton swab, and apply another fresh Thermal Gap Filler.



Wipe off the tip of the syringe until next repair.

Scrap! Don't refill the Thermal Gap Filler to the used syringe.

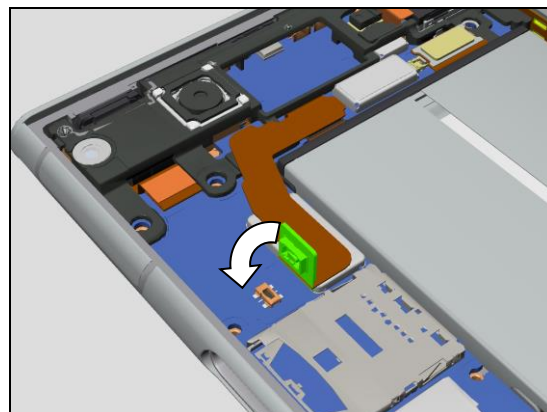


Next time you use, let a small amount of contents flow out and wipe off the tip again.

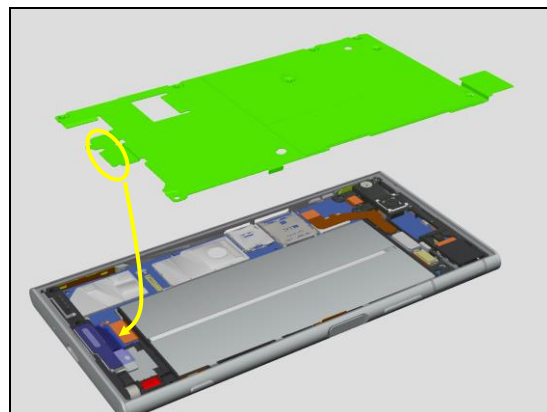


5.22.3 Assemble Plate Display

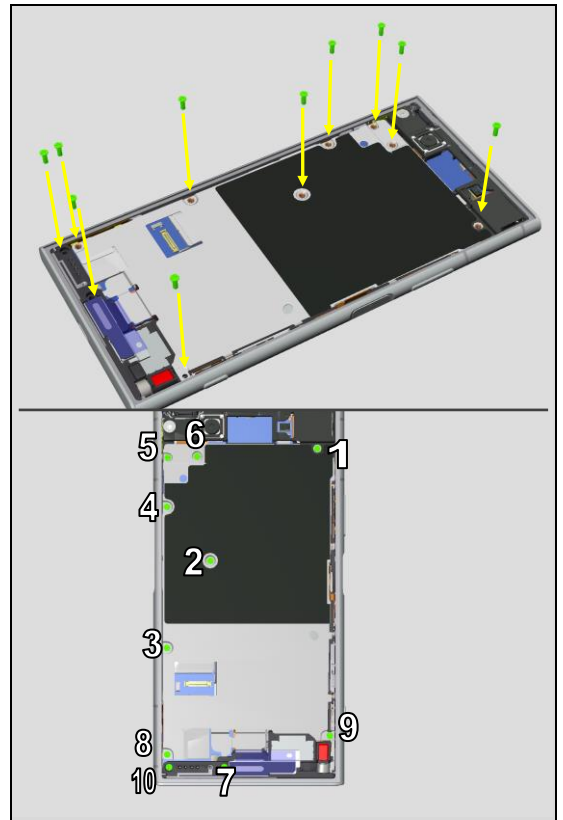
Connect the BtoB connector of the Battery.



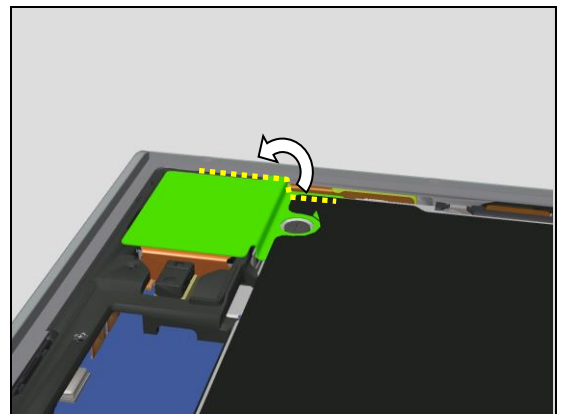
Attach the Plate Display.



Tighten the Screw M1.4x3.8 in the shown order.
Torque : 11 Ncm

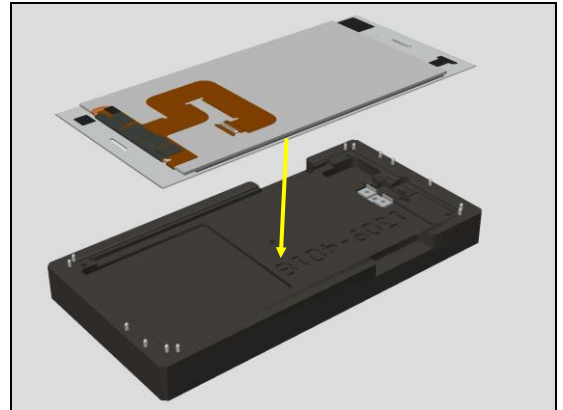


Fold the Sheet Graphite Main Camera along the Main Camera body.

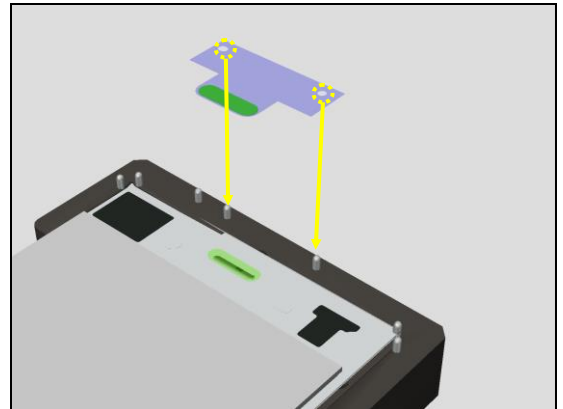


5.23 Loudspeaker

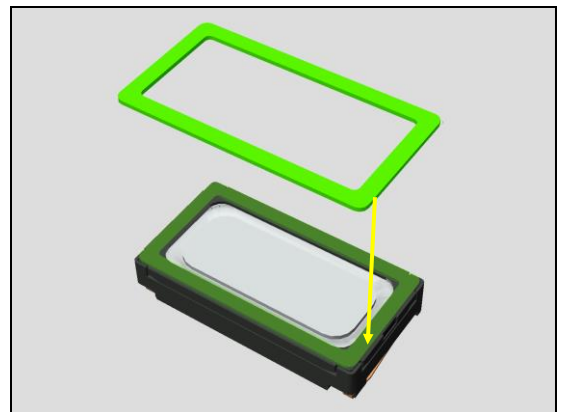
Place the Display on the Adhesive Position Pin Fixture.



Paste the Net Speaker Top on the Display by using the alignment pins.

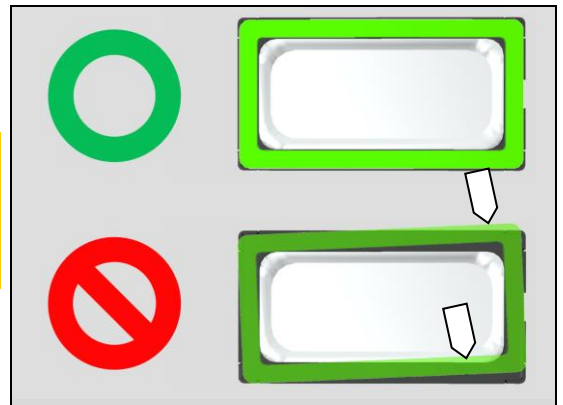


Paste the Adhesive WR Speaker Bottom on the Loudspeaker.



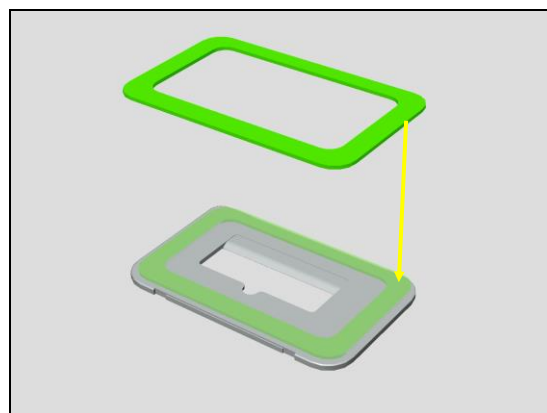
Paste exactly on the rim of the Loudspeaker.

Exceeding the outline or pasting on the membrane area is not allowed.

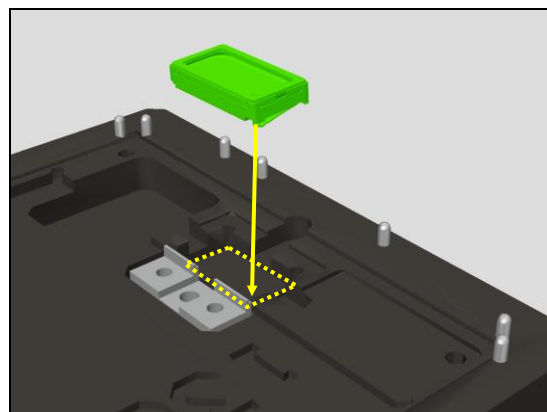


Paste the Adhesive WR Holder Speaker Top on the Holder Speaker Top.

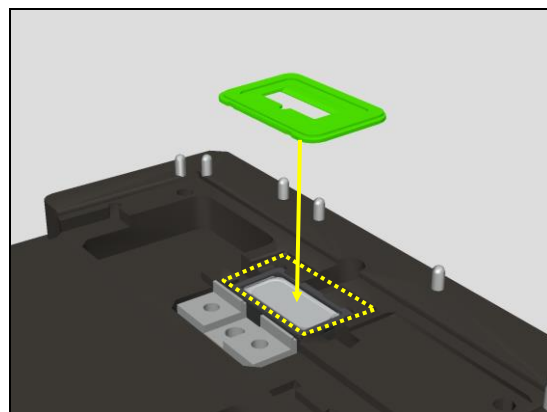
Paste within the outline of the Holder Speaker Top.



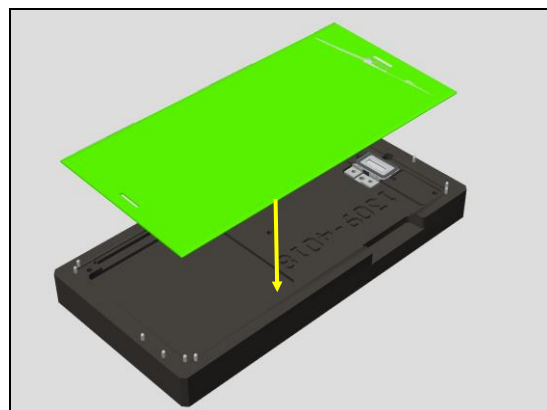
Place the Loudspeaker on the cavity.



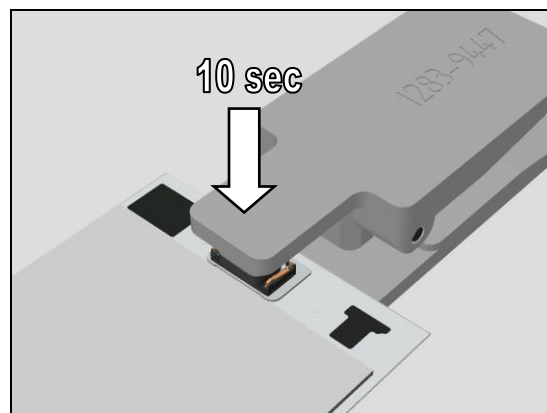
Paste the Holder Speaker Top on the Loudspeaker.



Paste the Display on the Holder Speaker Top.

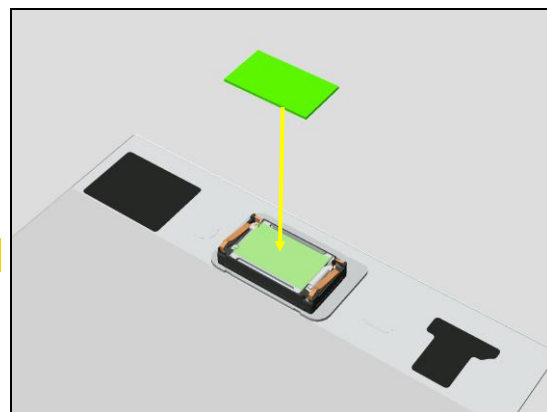


Press the Speaker with the Earspeaker/Loudspeaker Top Press Tool for 10 sec.



Paste the Cushion Speaker on the Loudspeaker.

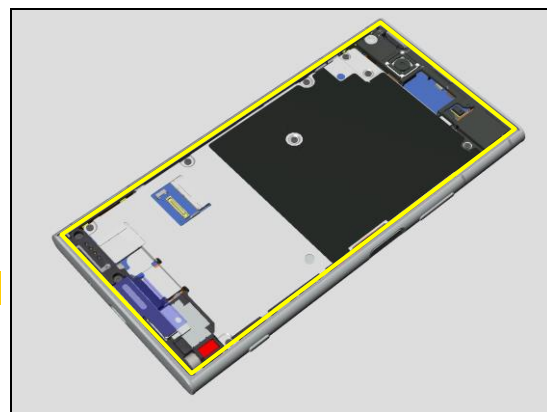
Paste within the metal area.



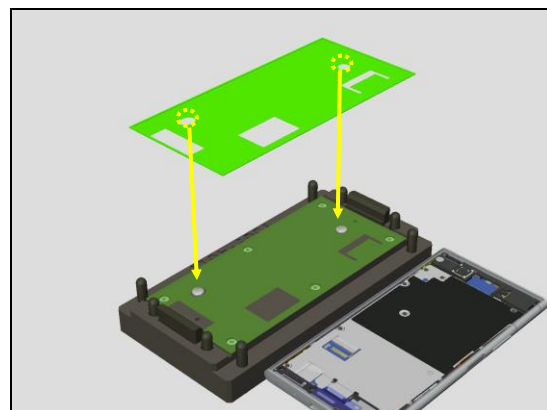
5.24 Display

Wipe the rim of the Cover Main clean.

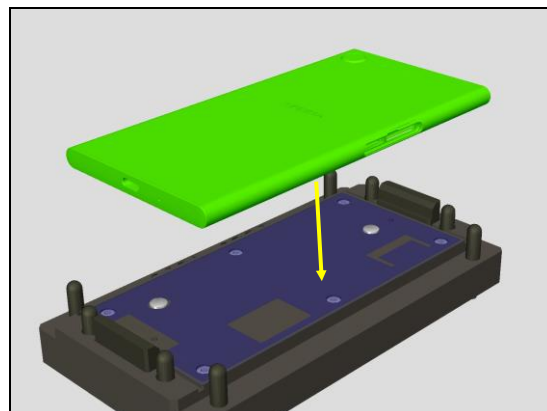
Do not use Isopropyl Alcohol for cleaning.



Place the Adhesive WR Display on the Window Panel Adhesive Fixture.

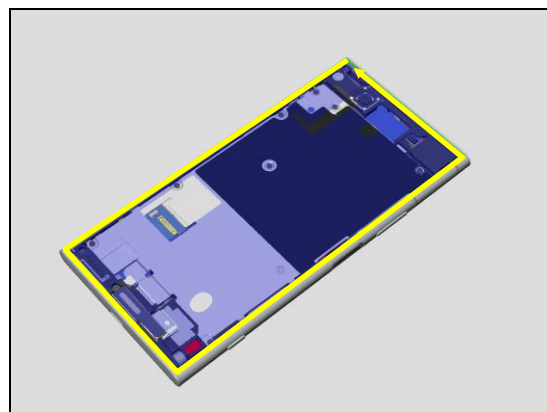


Paste the Cover Main on the Adhesive WR Display.

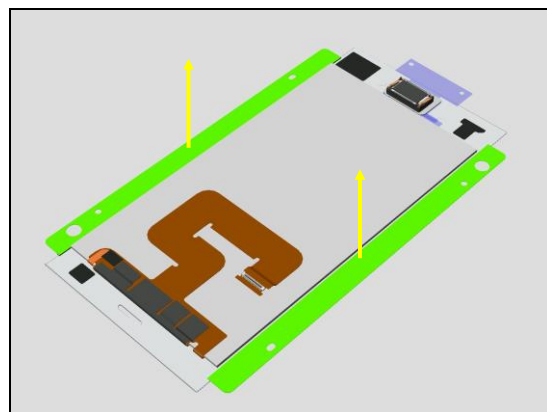


Press the adhesive area with a finger.

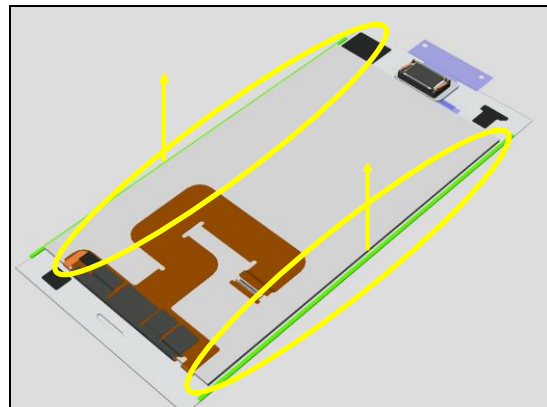
Keep the release film until the Holder LCD BtoB is assembled.



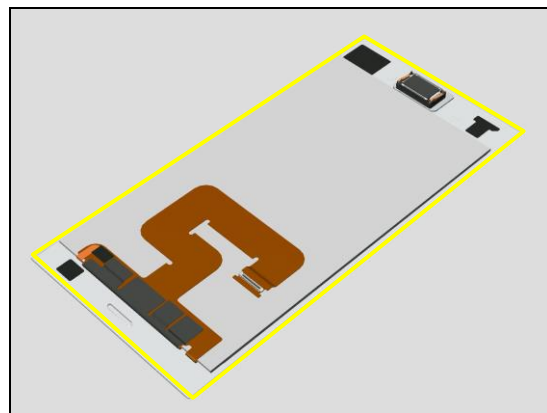
Remove two release films on the both edges of the Display.



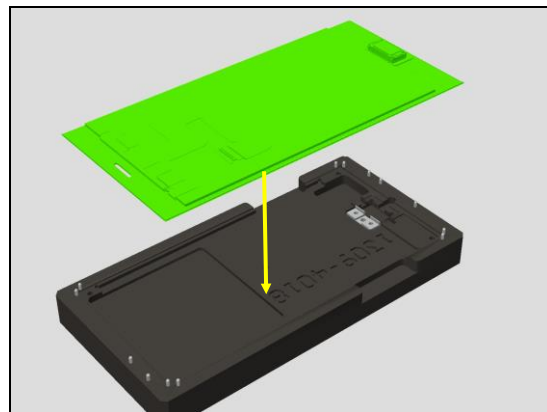
Remove the adhesive cushions with the Bamboo Skewer.



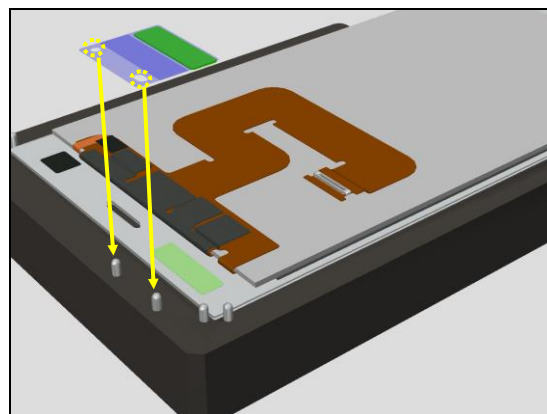
Wipe the rim of the Display clean.



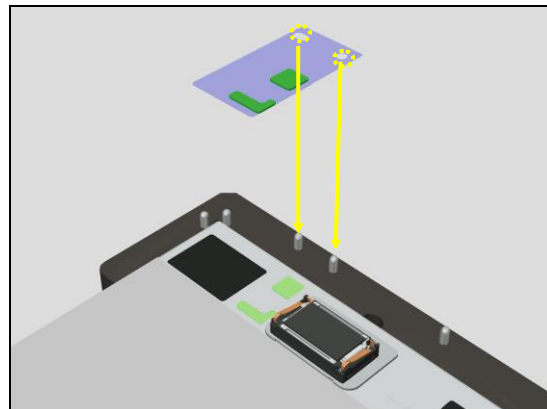
Place the Display on the Adhesive Position Pin Fixture.



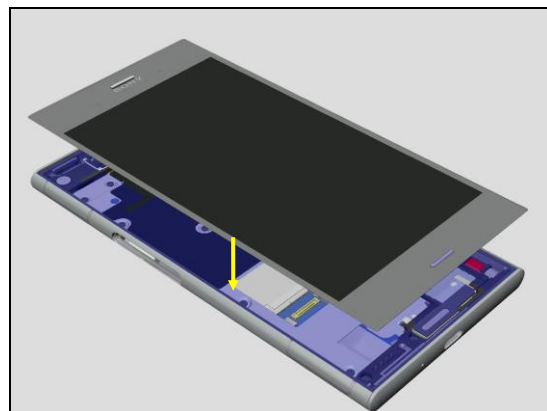
Paste the Adhesive Window Display Bottom by using the alignment pins.



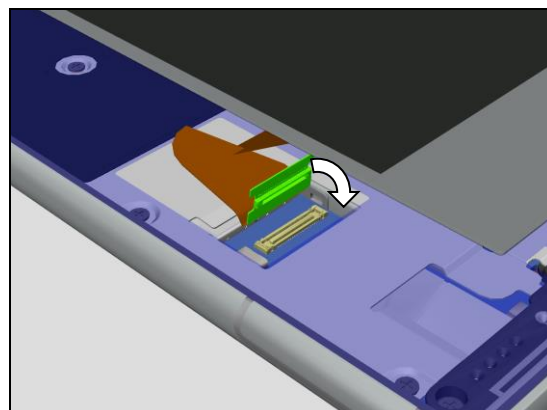
Paste the Adhesive Window Display Top by using the alignment pins.



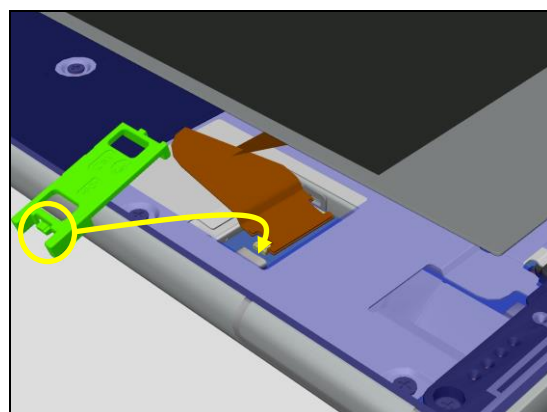
Put the Display close to the Cover Main.



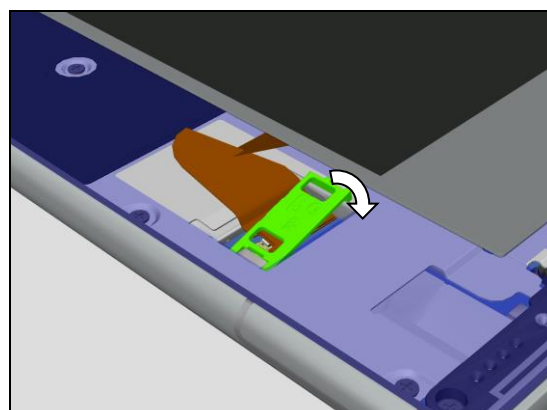
Connect the BtoB connector of Display.



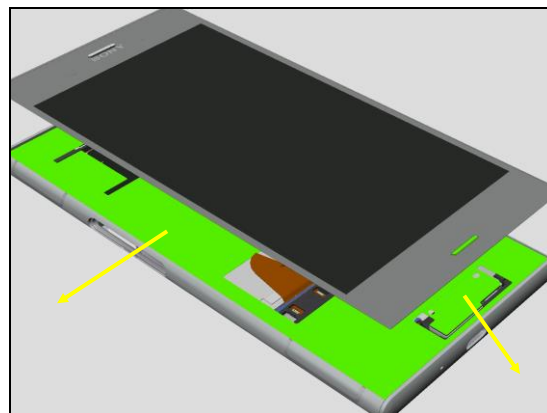
Put the Holder LCD BtoB on the PBA Main.



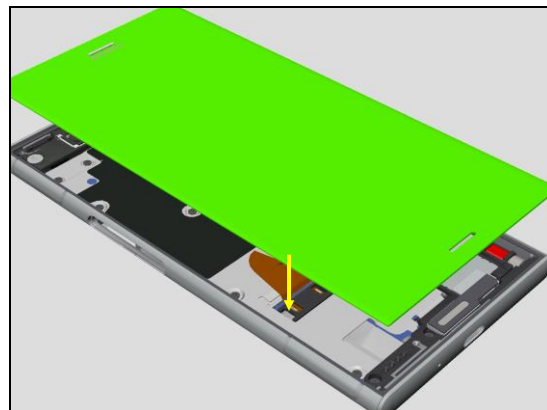
Attach the Holder LCD BtoB by hook.



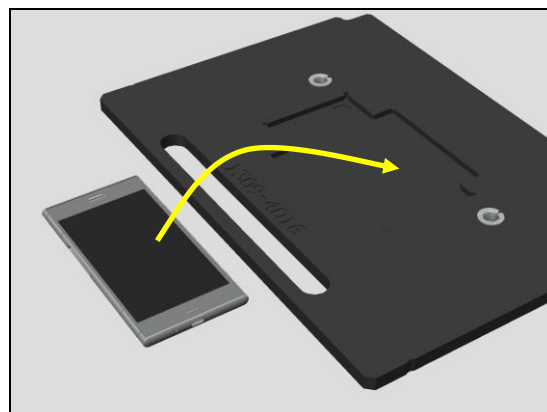
Rip and remove the release film of the Adhesive WR Display.
Remove the release film of the Net WR Speaker Bottom.



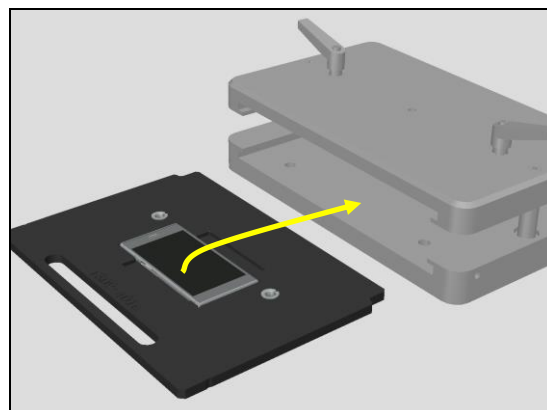
Paste the Display.



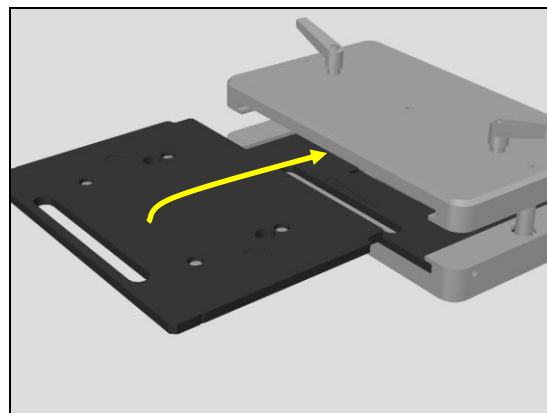
Place the unit on the Bottom Press Inlay.



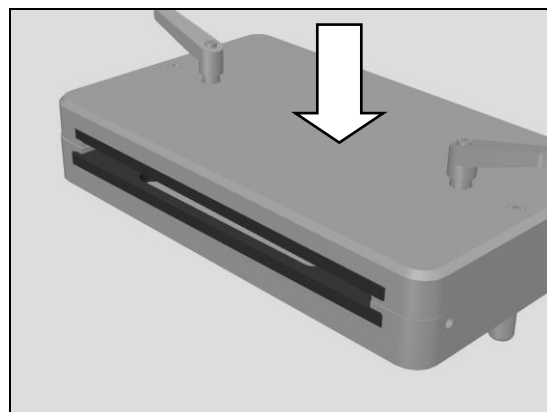
Insert the Bottom Press Inlay into the Toothed Rack Press.



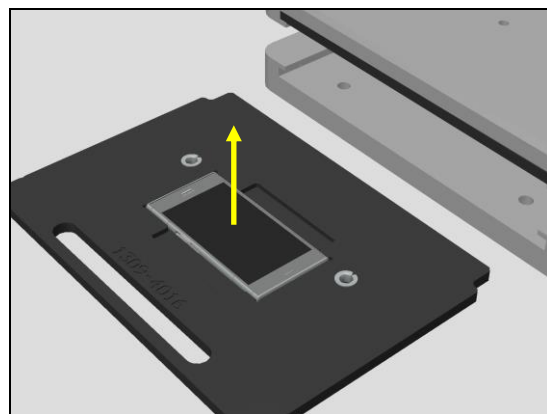
Insert the Panel Press Top Inlay into the Toothed Rack Press.



Press the unit twice.
1st press: 650 N, 15 sec
2nd press: 450 N, 15 sec

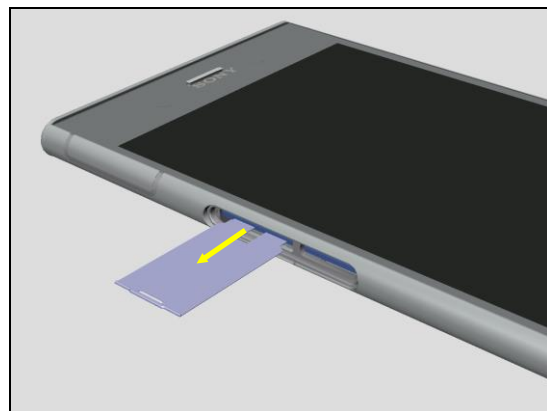


Take out the unit.

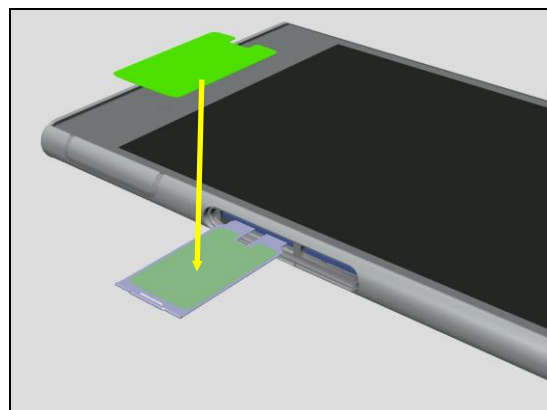


5.25 MoP Label

Pull out the Sheet Slider Label MoP.



Paste the printed MoP Label on the Sheet Slider Label MoP.
Insert the Sheet Slider Label MoP into the unit.



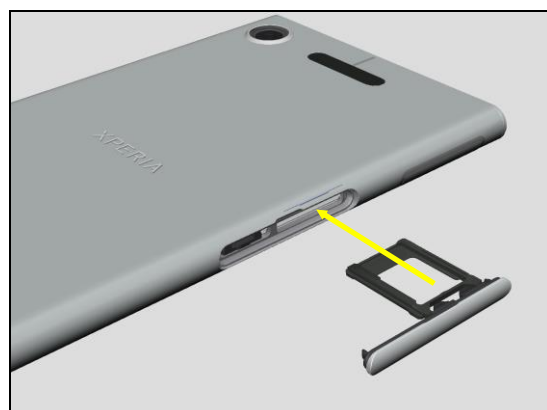
5.26 Tray Nano SIM

Insert Tray Nano SIM into the unit.



5.27 Cap Tray

Insert the Cap Tray into the unit.

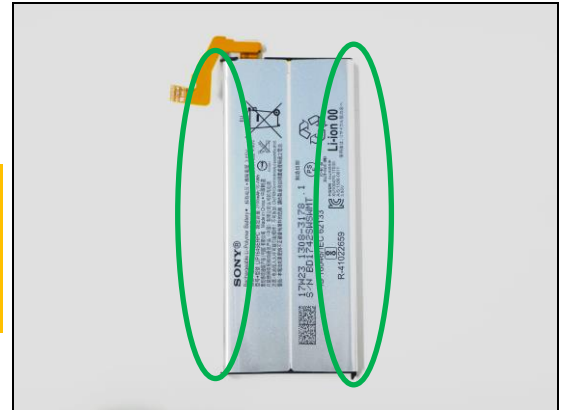


6 Battery Reuse Instruction

**If you intend to reuse the Battery, carefully follow the Battery Reuse Instruction.
If it is failed, don't reuse the Battery, and scrap it.**

6.1 Battery Handling Notices

1. Don't damage the Battery foil with sharp objects.
2. Don't twist or deform the Battery.
3. If the Battery is dropped, don't reuse, and scrap.
4. Hold the Battery at the frame edges of the Battery (green circled portion).



6.2 Dot Mark Check

Check if the Battery (which has been removed from the unit) has blue/red or black/red dots marking.

Do not reuse, if the Battery has two (2) red dots marking, and scrap it.

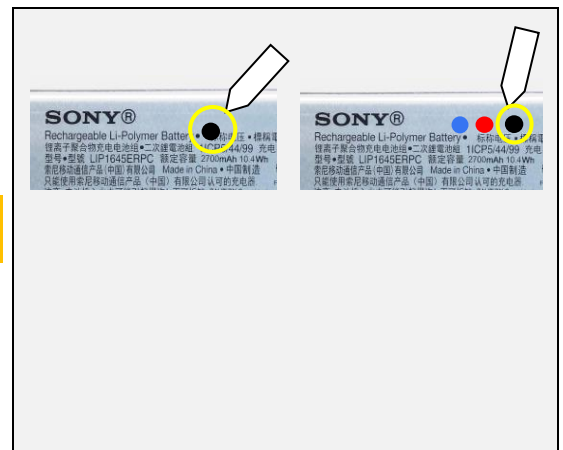
Blue and black dot indicates Battery had been removed from the unit, and red dot indicates Battery had been reinstalled (reused).

Scrap! If the battery has two (2) red dots marking, it can't be reused for third times.



6.3 Dot Marking 1

If no dot marking on the Battery, put black dot marking with permanent pen.



Battery Reuse Instruction

6.4 Appearance Check

Check if any damages on the battery such as Winkle, Bubble, Dent, Floating up the AL sheet, Twist, and/ or Line.

If it is out of below specification, do not reuse, and scrap the battery.

Item of Damage	Limit of size	Limit of quantity
Winkle	Length $\leq 5\text{mm}$	1 wrinkle per Al sheet
Mark	No mark is allowed.	
Bubble	Diameter $\leq \Phi 2\text{mm}$	3 bubble per Al sheet
Dent	Diameter $\leq \Phi 2\text{mm}$	3 dents per surface
Scratch	Scratch is allowed as far as printed characters are visible.	
Lift up Al Sheet	No lifting up of the Al sheet is allowed.	
Twist	Twist line is allowed.	
Line	No line is allowed.	

Definition of Damages and Sample Pictures

Wrinkle:

A slight line or fold on label or tape of the battery.



Mark:

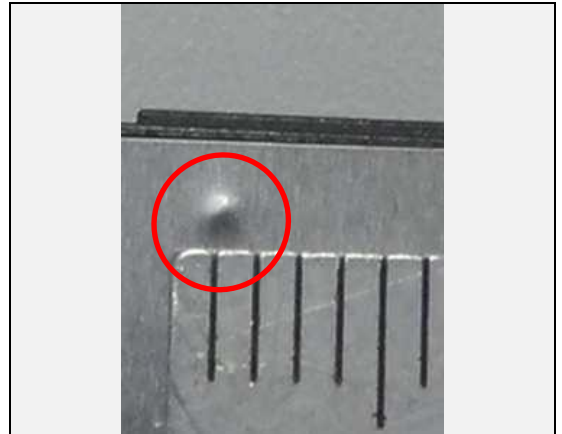
Surface is bulged as lined by foreign material is located between Al sheet and battery cell housing.



Battery Reuse Instruction

Bubble:

Surface is bulged as pointed by foreign material is located between Al sheet and battery cell housing.



Dent:

It is caused that is stuck by sharp pointed objects.



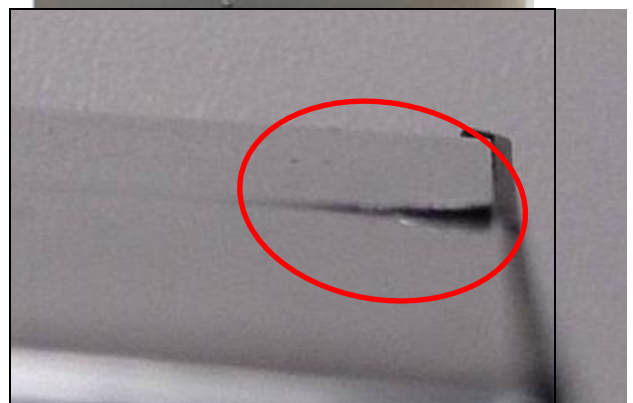
Scratch:

It is caused that scratched by sharp edge/pointed objects.



Lift up Al Sheet:

The edge of Al sheet is lifted caused by improper handling.



Battery Reuse Instruction

Twist:

Twisting line locates at the corner of battery pack that is created during Al sheet wrapping.



Line:

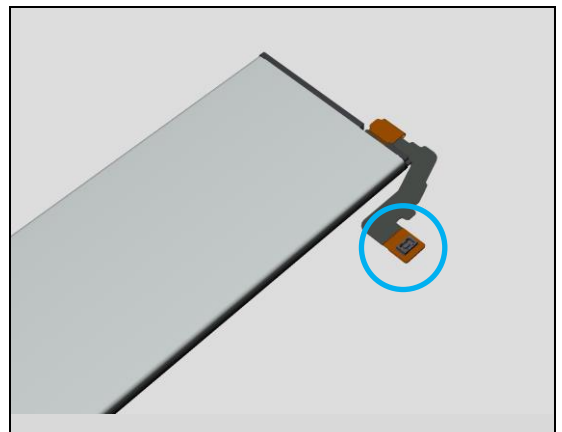
A slight line located at the border of battery cell and frame.



6.5 BtoB Connector Check

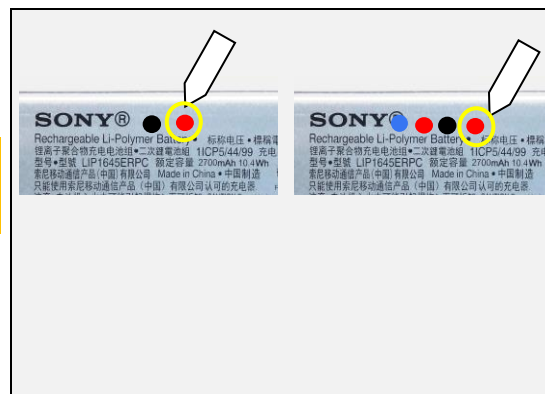
Check if BtoB connector has damages.

If any damages on the BtoB connector, do not reuse, and scrap the battery.

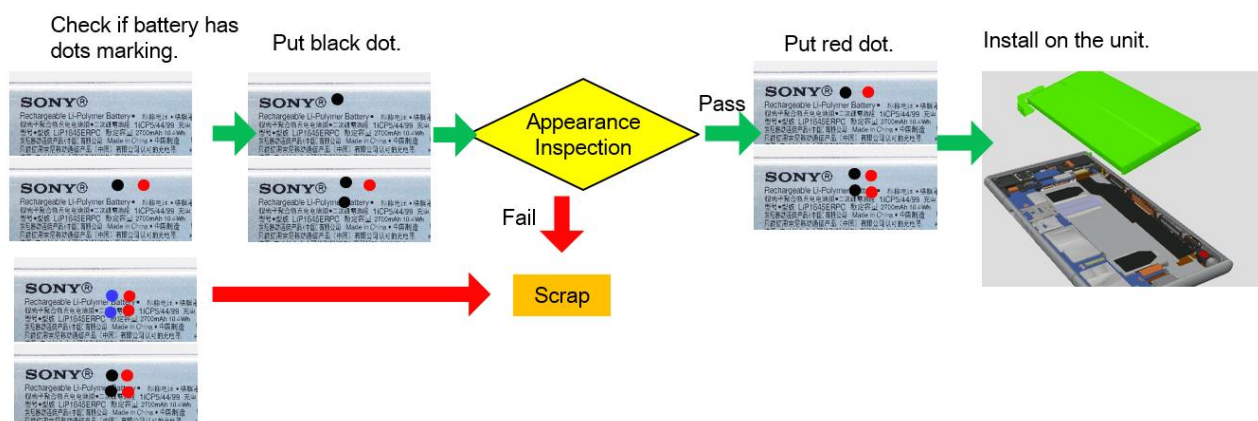


6.6 Dot Marking 2

If no failure has been detected by above appearance check, put the red dot marking on the Battery with permanent pen for reinstalling (reuse).



Overall procedure for Battery Reusing



7 Revision History

Rev.	Date	Changes / Comments
1	2017-08-25	Initial release
2	2017-09-01	Update cover image. Add marketing name. Ease the reuse condition of Thermal Gap Filler in 4.5.
3	2017-09-19	Update descriptions in 5.24. Update Mandatory Replacement Parts List Fix typos (Mic1 => Mic 1, Mic2 => Mic 2).
4	2017-10-11	Update descriptions in 5.22.2 (Expiry date definition) Update the screw order in 5.22.3 (Exchange 7 and 9)
5	2017-10-19	Update important notice about Adhesive WR Speaker Bottom positioning in 5.23. (Frame 4)