

Working Instructions

- mechanical -



Xperia™ XZ1 Compact
G8441

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General Notes

For general information about mechanical repair related issues, refer to 1220-1333: Generic Repair Manual - mechanical - (under the RE4250: Repair - Mechanical - Repair instructions).

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

Always finally connect the Battery FPC BtB 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.

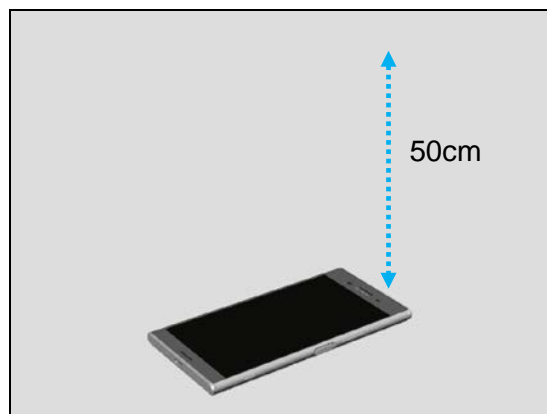
It is posted under the RE4251: Repair - Mechanical - Tools and Equipment (including Repair Software).

When perform calibration, put the unit on a stable place, facing up, and no any 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 Top Speaker and/or Bottom Speaker.

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

G8441



2 Tools

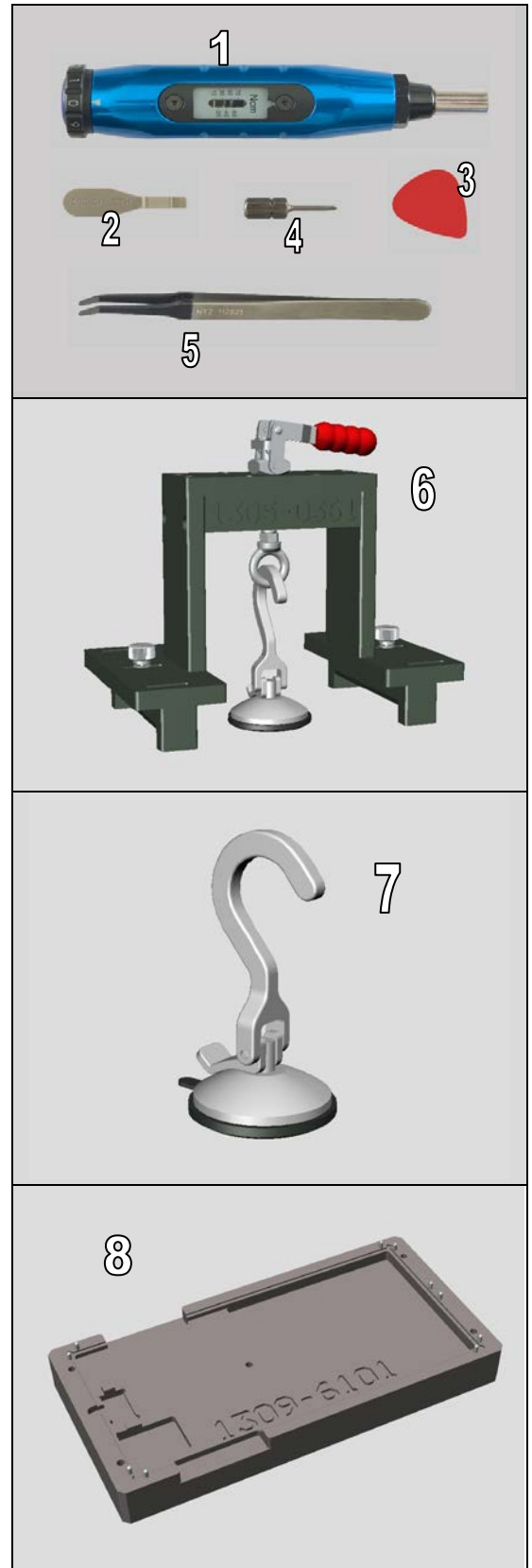
SPECIAL TOOLS

1. Torque Screwdriver 2-30Ncm (1233-2284)
2. Front Opening Tool (NTZ 112 302/2)
3. Guitar Pick (NTZ 112 590)
4. Bit (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.)

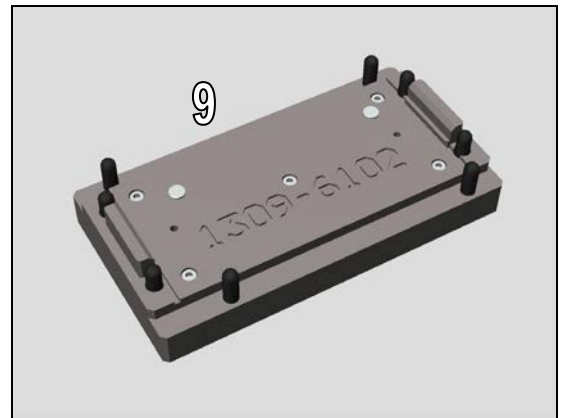
7. Vacuum Cup for Tool (1305-7901)
(Maintenance parts for Panel Disassembly Tool 1305-0361.)

8. Fixture Display Component (1309-6101)



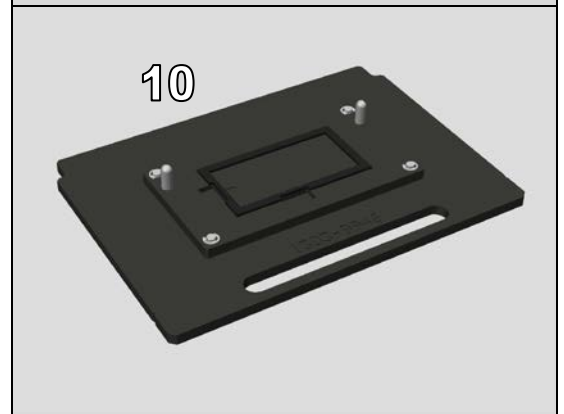
Tools

9. Fixture Display Adhesive (1309-6102)



10. Rear Cover Press Top Inlay (1303-9946)

(This tool name is not suitable for G8441 since this inlay is common with F5321.)



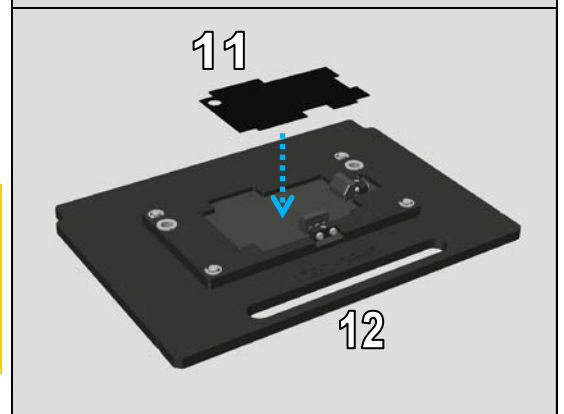
11. Sheet Bottom Press Inlay (1309-6098)

12. Bottom Press Inlay (1303-9945)

This Bottom Press Inlay is common with F5321.

Paste Sheet Bottom Press Inlay to Bottom Press Inlay for G8441.

Bottom Press Inlay after pasting Sheet Bottom Inlay can be used for F5321.



13. Load cell measurement kit (1274-3895)

14. Generic Fixture for Press tool (1273-4413)

15. Toothed Rack Press (1281-2676)



Tools

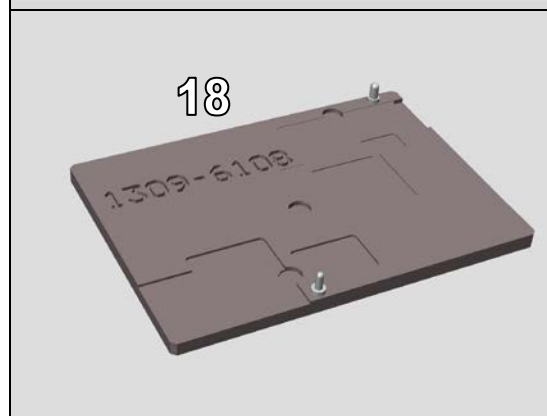
16. WRT Fixture 1309-6104
(Including Silicon Suction Cup 1309-6105.)



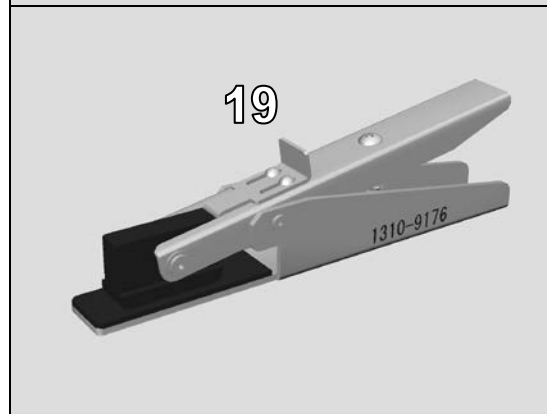
17. Silicon Suction Cup 1309-6105
(Maintenance parts for WRT Fixture 1309-6104.)



18. Fixture Battery Clamp (1309-6108)



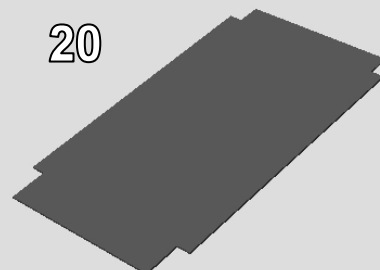
19. Press Clamp (1310-9176)



Tools

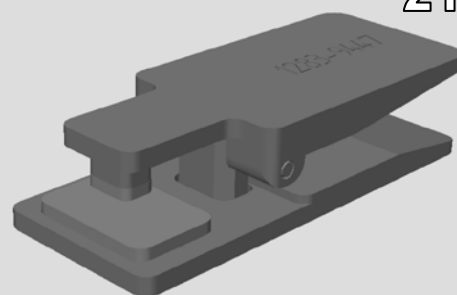
20. Disassembly Sheet (1295-5578)

20



21. Earspeaker/Loudspeaker Top Press Tool (1283-9447)

21



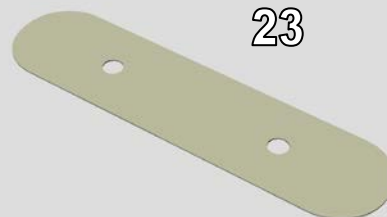
22. Media Cable TypeC Cable (Black) (1302-1935)

22



23. Flexible Disassembly tool

23



Tools

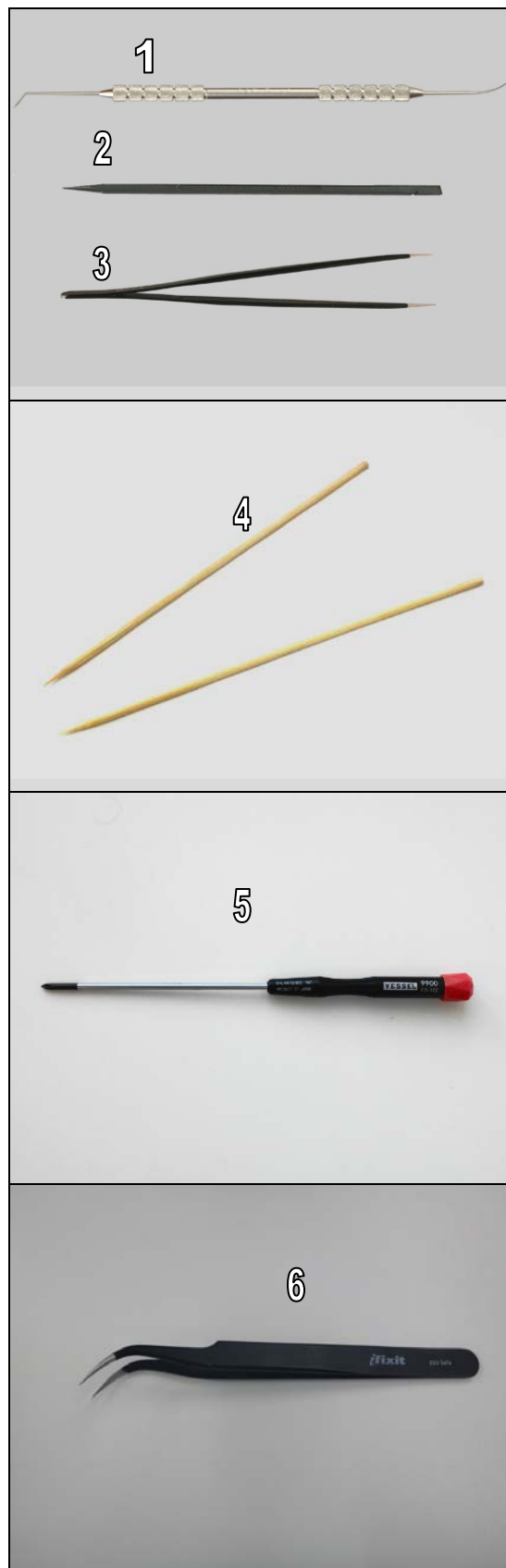
STANDARD TOOLS

1. Dentist Hook
2. Nylon Pointer
3. Tweezers

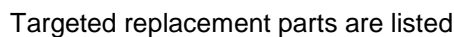
4. Bamboo Skewer

5. Screwdriver PH0 x 100

6. Tweezers (Curved Tip)



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

[illegible]

Mandatory replacement parts for refurbishment.

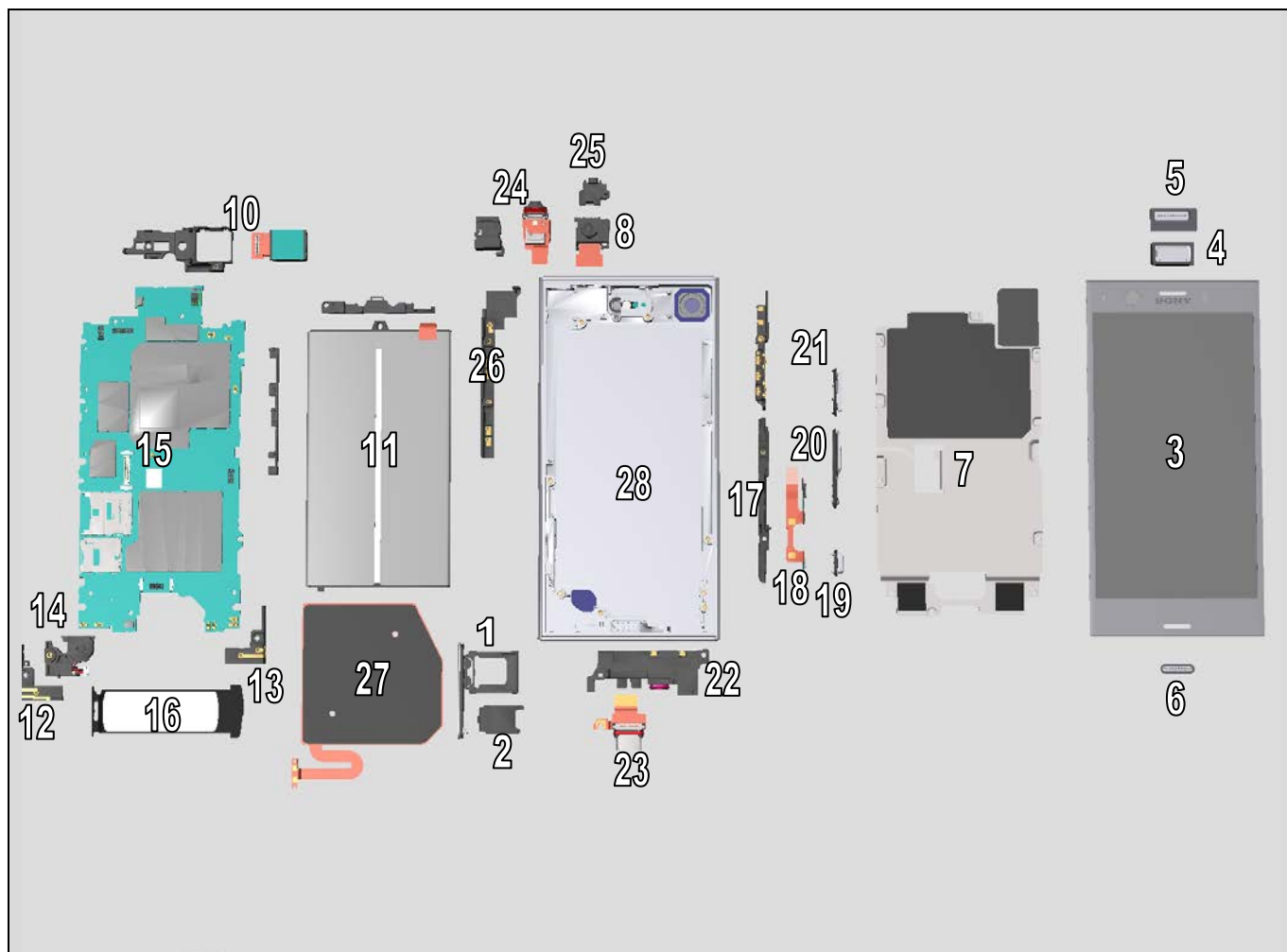
Parts that is required to replace in addition to target replacement parts.

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

4 Disassembly

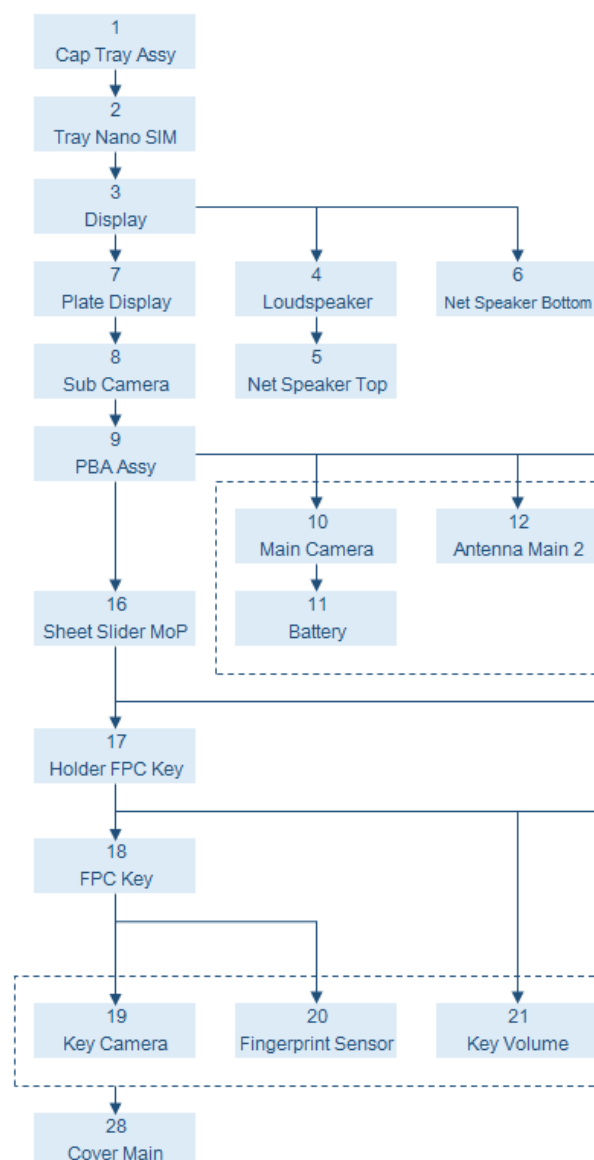
The disassembly is done in the following order:

1. Cap Tray Assy
2. Tray nano SIM
3. Display
4. Loudspeaker
5. Net Speaker Top
6. Net Speaker Bottom
7. Plate Display
8. Sub Camera
9. PBA Assy
10. Main Camera
11. Battery
12. Antenna Main 2
13. Antenna Main 1
14. Vibrator
15. PBA
16. Sheet Slider MoP
17. Holder FPC Key
18. FPC Key
19. Key Camera
20. Fingerprint Sensor
21. Key Volume
22. Speaker Box
23. FPC USB
24. FPC JK Module
25. Holder Mic 2nd
26. Antenna Combo LDS
27. Antenna NFC
28. Cover Main



Disassembly

Quick Reference for Disassembling



Replacement Target	Disassembly Procedure
1 Cap Tray Assy	1
2 Tray Nano SIM	1, 2
3 Display	1, 2, 3
4 Loudspeaker	1, 2, 3, 4
5 Net Speaker Top	1, 2, 3, 4, 5
6 Net Speaker Bottom	1, 2, 3, 6
7 Plate Display	1, 2, 3, 7
8 Sub Camera	1, 2, 3, 7, 8
9 PBA Assy	1, 2, 3, 7, 8, 9
10 Main Camera	1, 2, 3, 7, 8, 9, 10
11 Battery	1, 2, 3, 7, 8, 9, 10, 11
12 Antenna Main 2	1, 2, 3, 7, 8, 9, 12
13 Antenna Main 1	1, 2, 3, 7, 8, 9, 13
14 Vibrator	1, 2, 3, 7, 8, 9, 14
15 PBA	1, 2, 3, 7, 8, 9, 10, 11, 12, 13, 14, 15
16 Sheet Slider MoP	1, 2, 3, 7, 8, 9, 16
17 Holder FPC Key	1, 2, 3, 7, 8, 9, 16, 17
18 FPC Key	1, 2, 3, 7, 8, 9, 16, 17, 18
19 Key Camera	1, 2, 3, 7, 8, 9, 16, 17, 18, 19
20 Fingerprint Sensor	1, 2, 3, 7, 8, 9, 16, 17, 18, 20
21 Key Volume	1, 2, 3, 7, 8, 9, 16, 17, 21
22 Speaker Box	1, 2, 3, 7, 8, 9, 16, 17, 22
23 FPC USB	1, 2, 3, 7, 8, 9, 16, 17, 22, 23
24 FPC JK Module	1, 2, 3, 7, 8, 9, 16, 24
25 Holder Mic 2nd	1, 2, 3, 7, 8, 9, 16, 25
26 Antenna Combo LDS	1, 2, 3, 7, 8, 9, 16, 24, 25, 26
27 Antenna NFC	1, 2, 3, 7, 8, 9, 16, 27
28 Cover Main	1, 2, 3, 7, 8, 9, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28

Disassembly

4.1 Cap Tray Assy

Remove the Cap Tray Assy.

Note! Remove the Cap Tray Assy to keep rear side of the unit up. Otherwise, micro SD card will be fallen down.



4.2 Tray nano SIM

Remove the Tray nano SIM.

Note! Remove the Tray nano SIM to keep rear side of the unit up. Otherwise, SIM card will be fallen down.



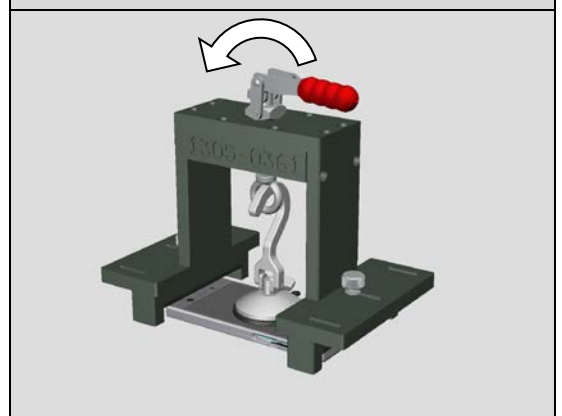
4.3 Display

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



Set the unit on the Panel Disassembly Tool as shown in the illustration.

And, turn the handle so that vacuum cup will pull up the Display.



Disassembly

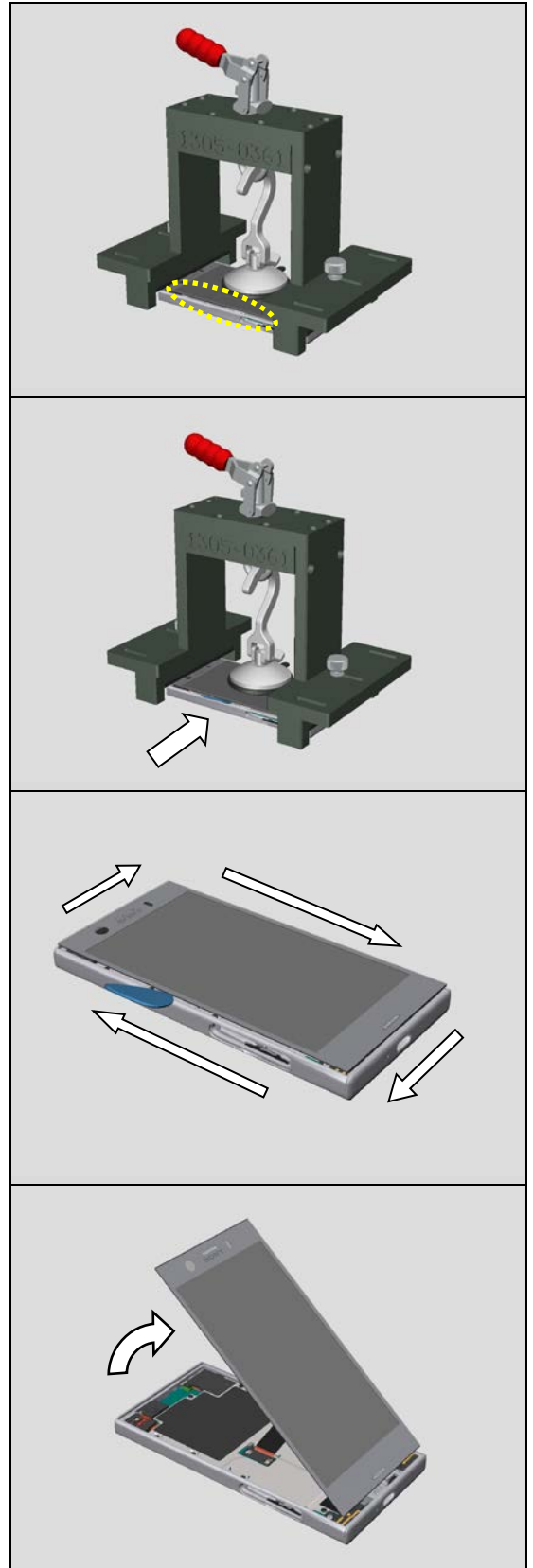
Wait about 60 seconds until Display will be lifted up from the unit.

Insert the Guitar Pick into the gap between Display and unit.
The illustration indicates to insert the Guitar Pick at the SIM/memory card slot side.

But, depends on the position of gap created, you can insert the Guitar Pick on the Power Key side.

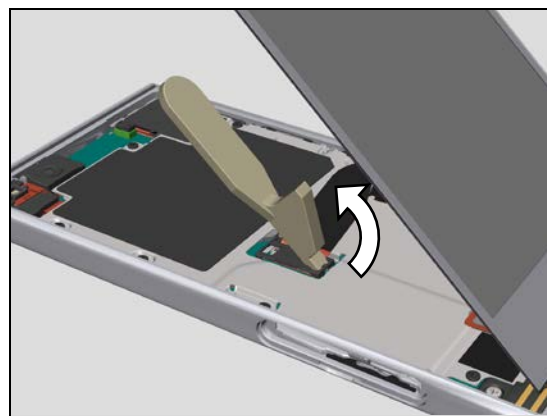
Remove the unit from the Panel Disassembly Tool.
Slide the Guitar Pick to cut the Adhesive WR Window Display.

Open the Display.

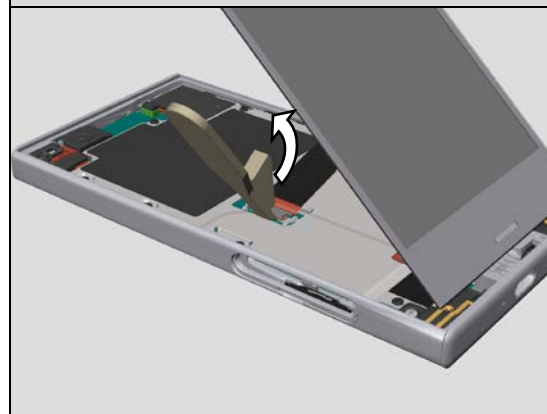


Disassembly

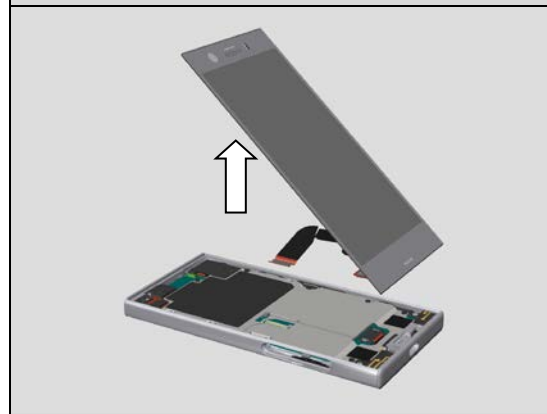
Remove the Holder LCD BtoB.



Disconnect the connector.



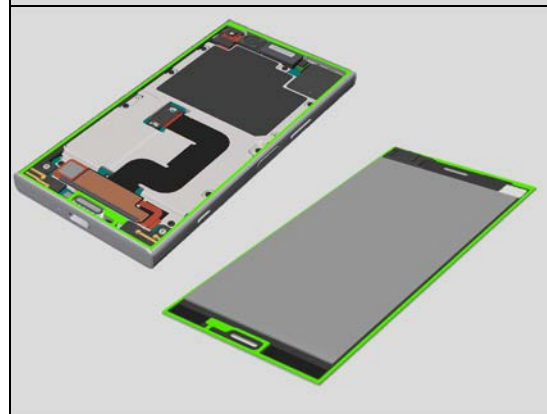
Remove the Display.



Remove the Adhesive WR Window Display to use Bamboo Skewer.

Rotate the Bamboo Skewer to take up the Adhesive WR Window Display.

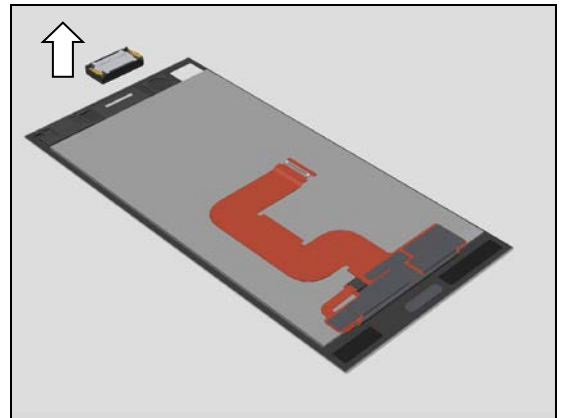
Note! Make sure to remove all residues of the Adhesive WR Panel Rear completely from both Panel Rear and unit (Green Highlighted Area).



4.4 Loudspeaker

Remove the Loudspeaker.

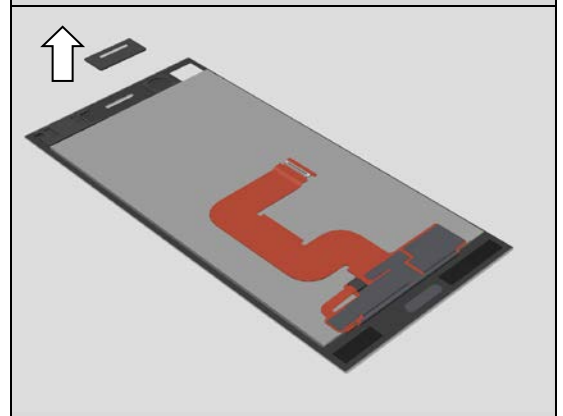
Scrap! Don't reuse the Loudspeaker!



4.5 Net Speaker Top

Remove the Net Speaker Top.

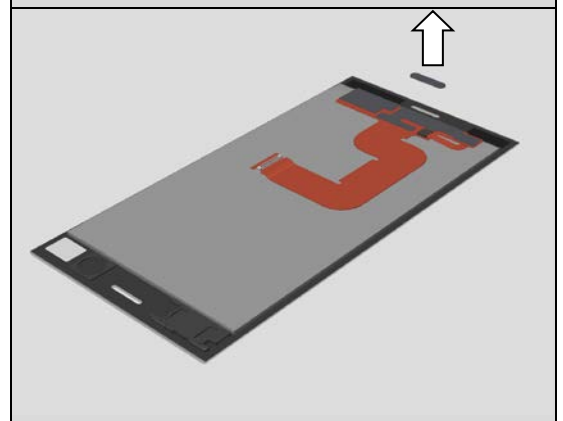
Scrap! Don't reuse the Net Speaker Top!



4.6 Net Speaker Bottom

Remove Net Speaker Bottom.

Scrap! Don't reuse the Net Speaker Bottom!



Disassembly

4.7 Plate Display

Remove the Screw 9 pieces of Screw M1.4*4.0 (Blue dotted circles) and a Screw M1.4 x3.8 (Yellow dotted circle) by using a screwdriver with Bit (JCIS No.0).

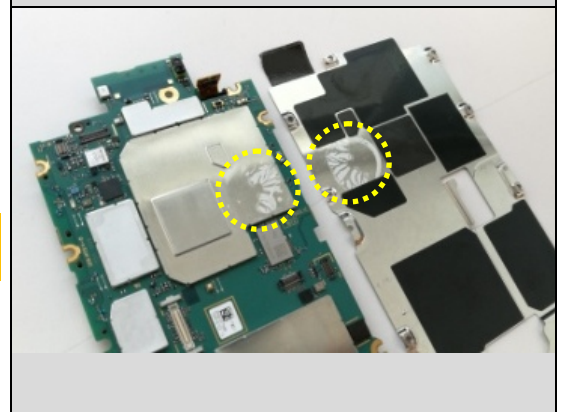
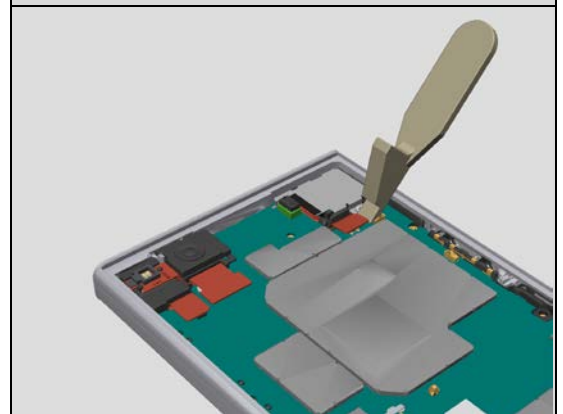
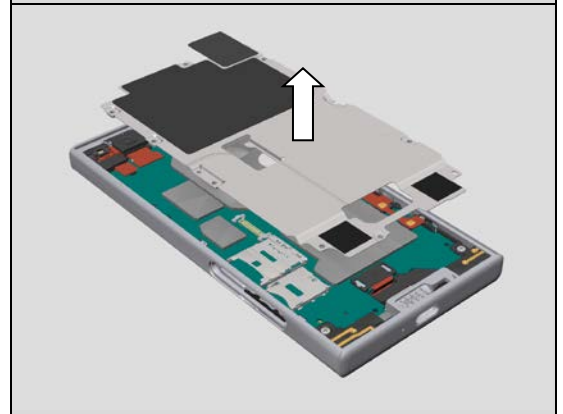
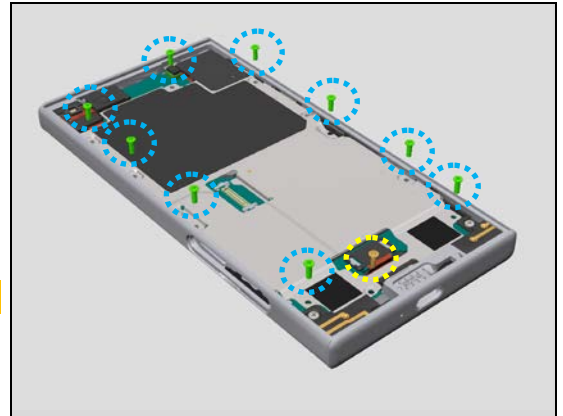
Scrap! Don't reuse the screw!

Remove the Plate Display.

Disconnect the Battery Connector.

Remove the Thermal Gap Filler on the Plate Display and PBA.

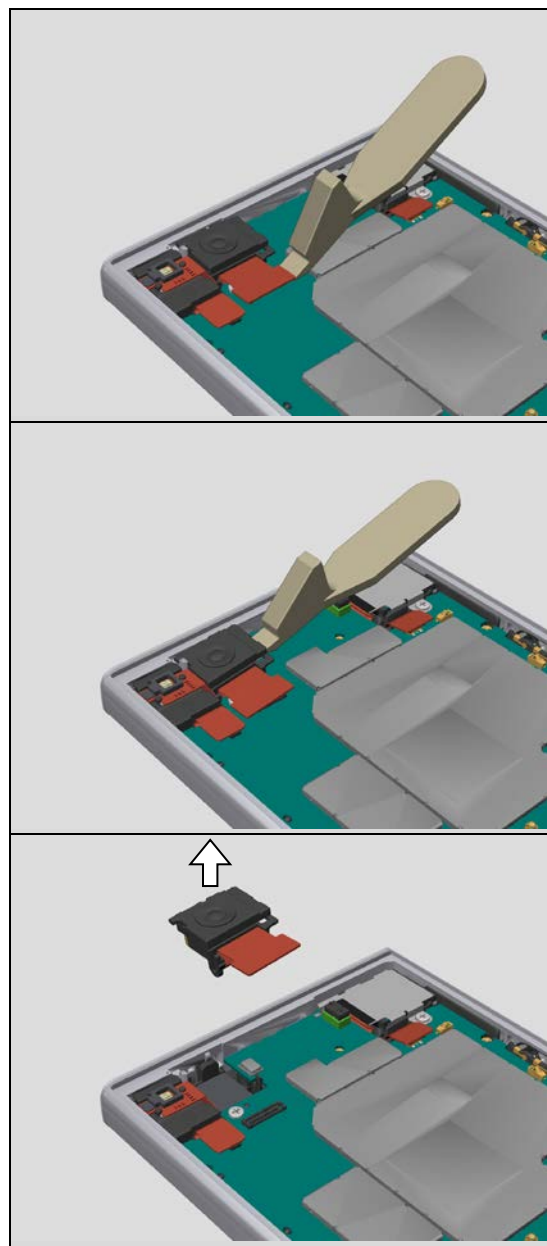
Note! Make sure to remove all residues of the Thermal Gap Filler on the either PBA or Plate Display.



4.8 Sub Camera

Disconnect the Sub Camera Connector.

Remove the Sub Camera.



4.9 PBA Assy

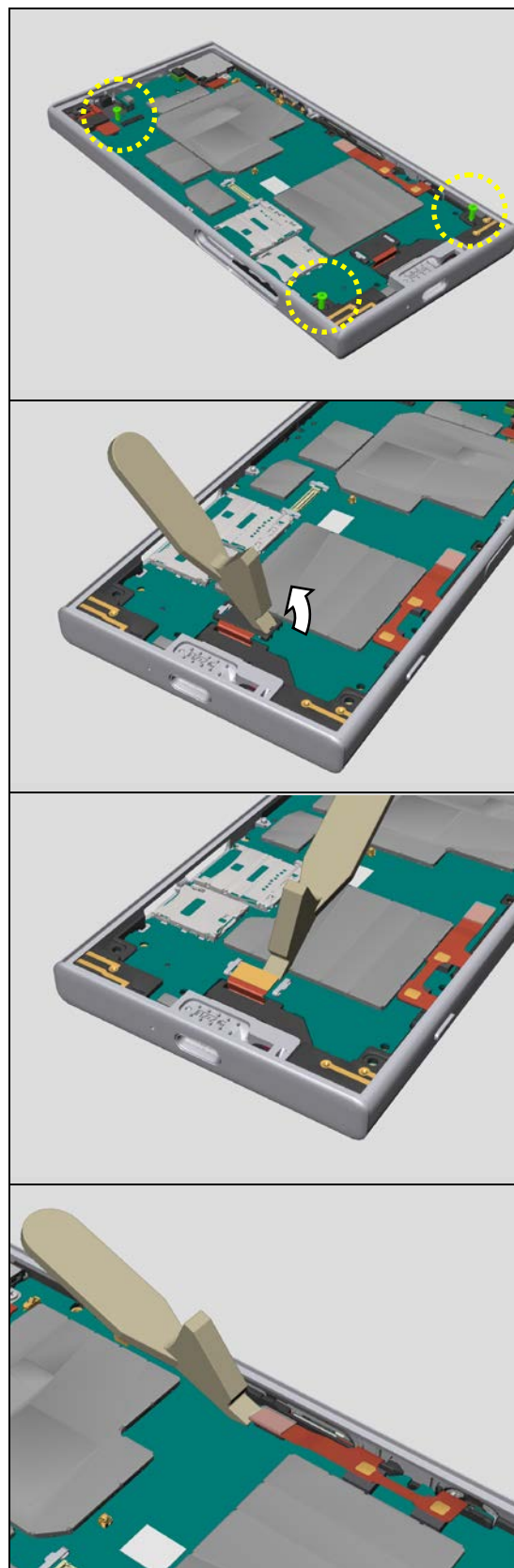
Remove the 3 pieces of Screw M1.4*3.4 by using a screwdriver with Bit (JCIS No.0).

Scrap! Do not reuse the screw!

Remove the Holder USB BtoB.

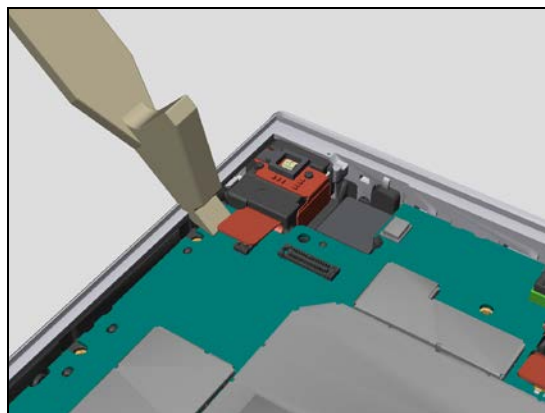
Disconnect the USB BtoB Connector.

Disconnect the Key Connector.

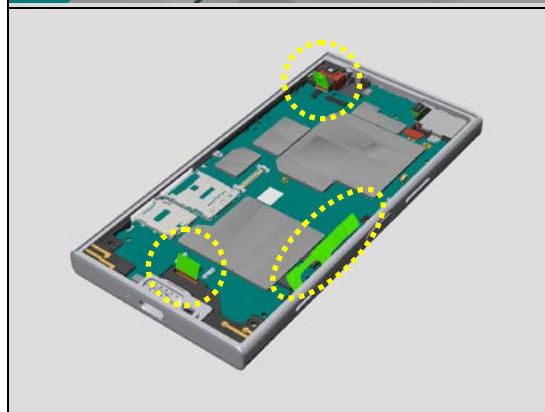


Disassembly

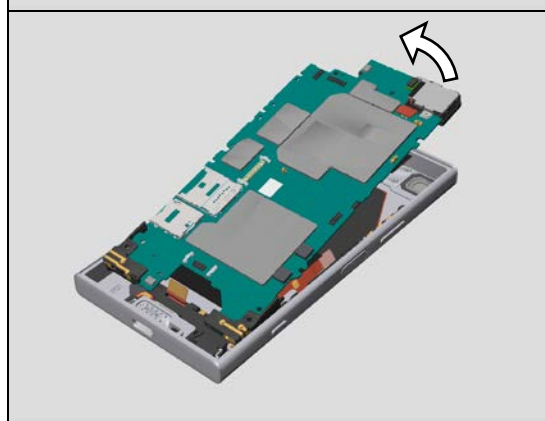
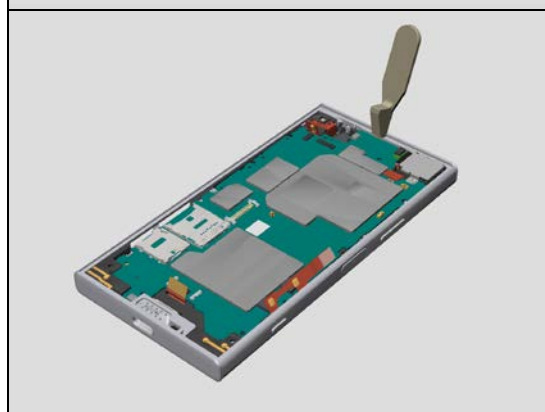
Disconnect the connector of the FPC JK Module.



Open the FPC of FPC USB, FPC Key and FPC JK Module.



Remove the PBA by using a Front Opening Tool from top side.



4.10 Main Camera

Remove a Screw M1.4*3.4 by using a screwdriver with Bit (JCIS No.0).

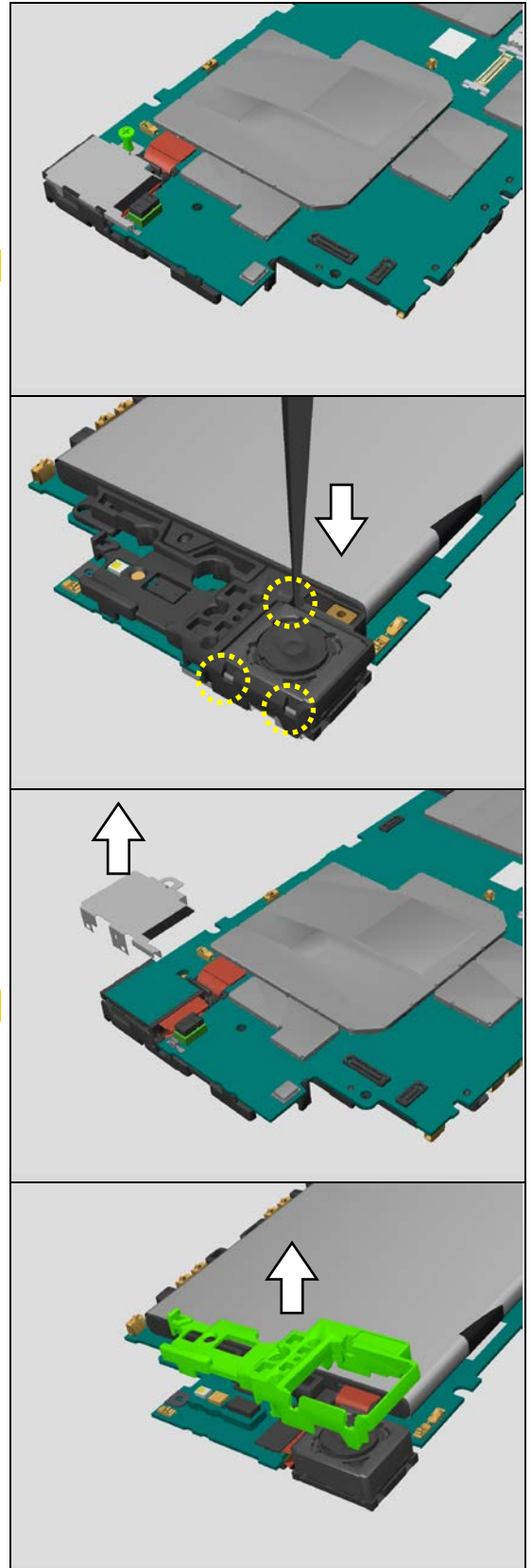
Scrap! Do not reuse the screw!

Unlock the 3 places of hook of the Shield Main Camera by using a tweezers.

Remove the Shield Main Camera.

Scrap! Do not reuse the Shield Main Camera!

Remove the Holder Top Rear.



4.11 Battery

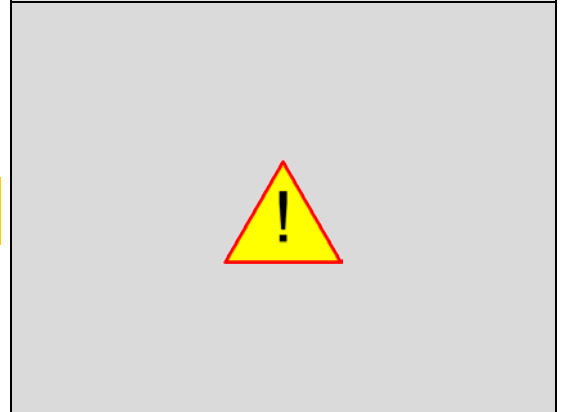
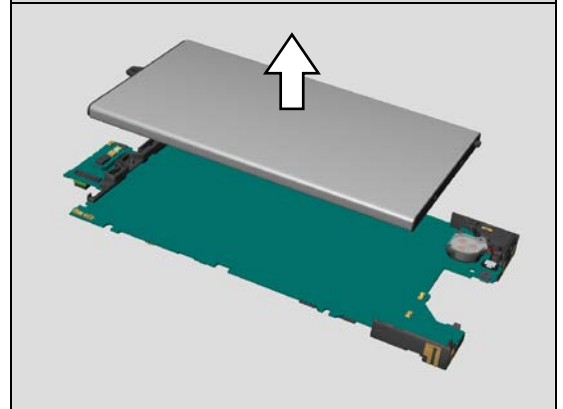
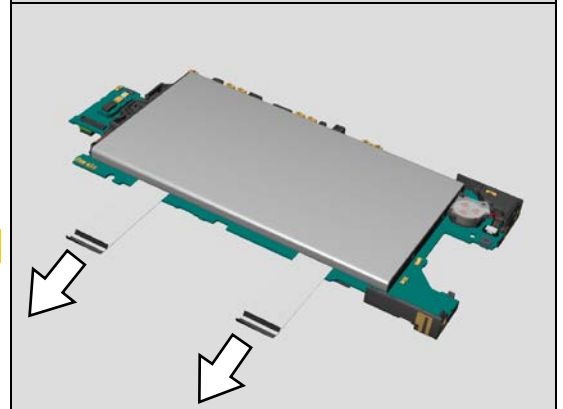
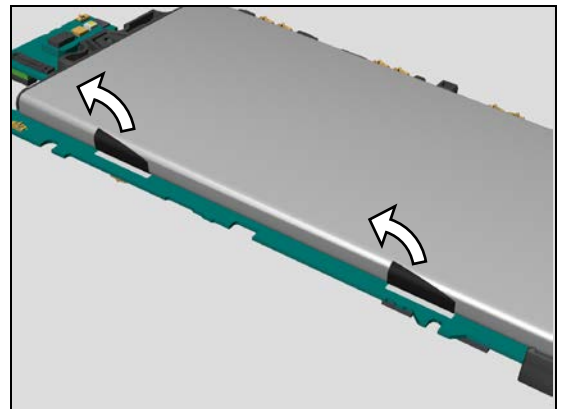
Pinch the 2 places of tab of Adhesive Battery.

Carefully pull the 2 places of Adhesive Battery as horizontally.

Scrap! Do not reuse the Adhesive Battery!

Remove the Battery.

Note! If you intend to reuse the Battery, follow the 6 Battery Reuse Instruction before reusing the Battery.



4.12 Antenna Main 2

Unlock the hook of the Antenna Main 2.

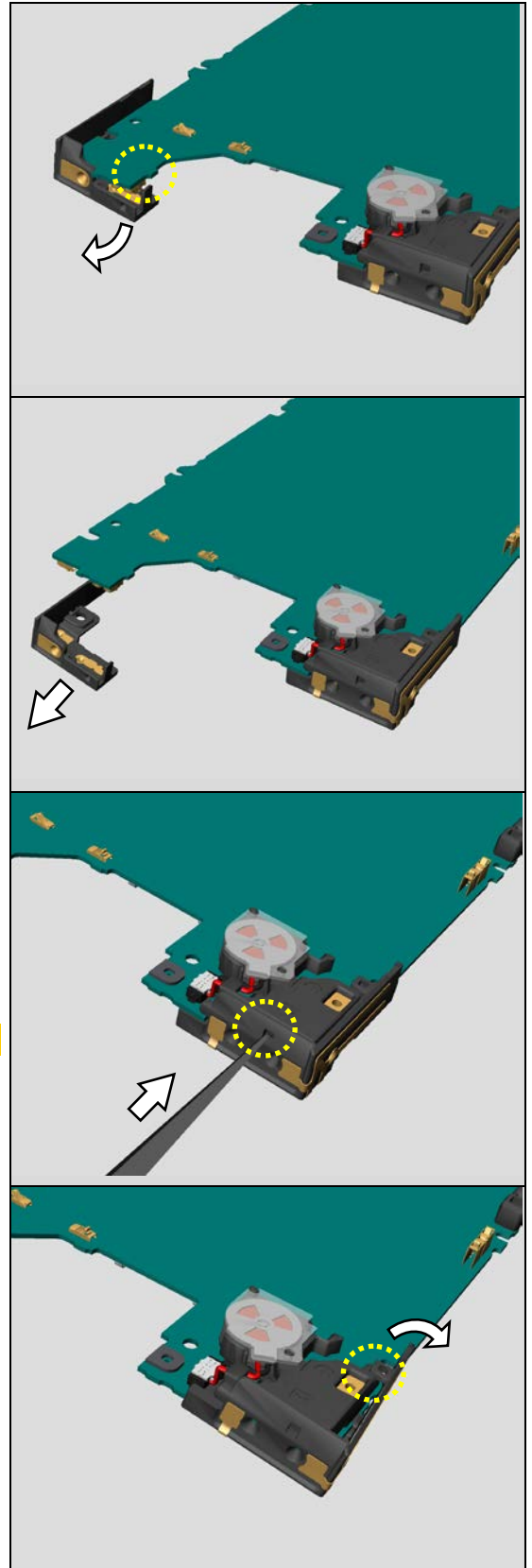
Remove the Antenna Main 2.

4.13 Antenna Main 1

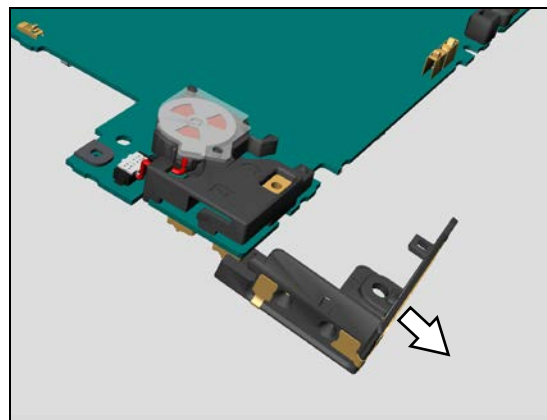
Unlock the hook of the Holder Vib by using tweezers.

Note! Do not push the hook strongly.

Unlock the hook of the Antenna Main 1.

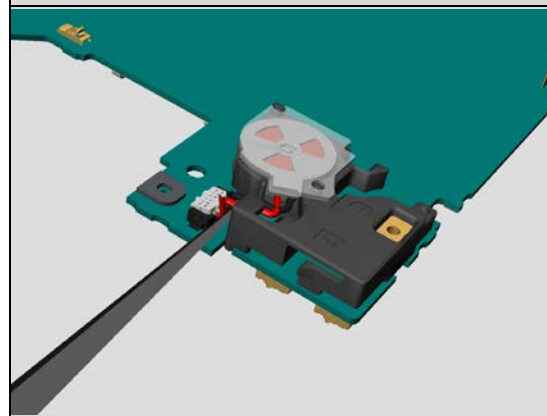


Remove the Antenna Main 1.



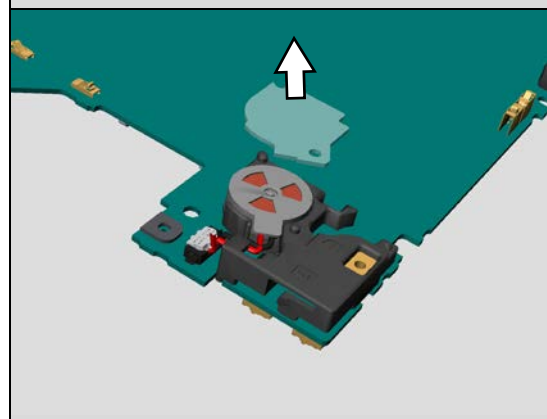
4.14 Vibrator

Disconnect the connector of the Vibrator.

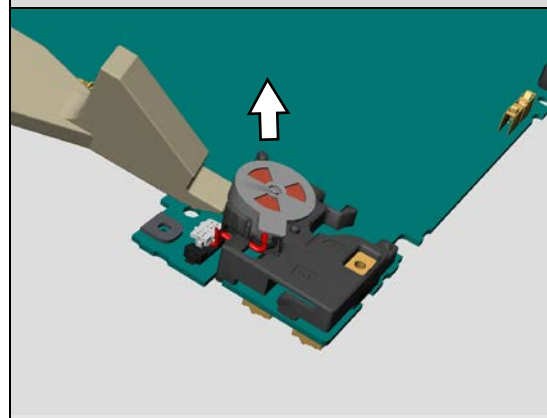


Remove the Sheet vib.

Scrap! Do not reuse the Sheet vib!



Remove the Vibrator.



Disassembly

4.15 PBA

Remove the Holder Vib.

Remove the Holder Battery Top and Holder Guide Left.

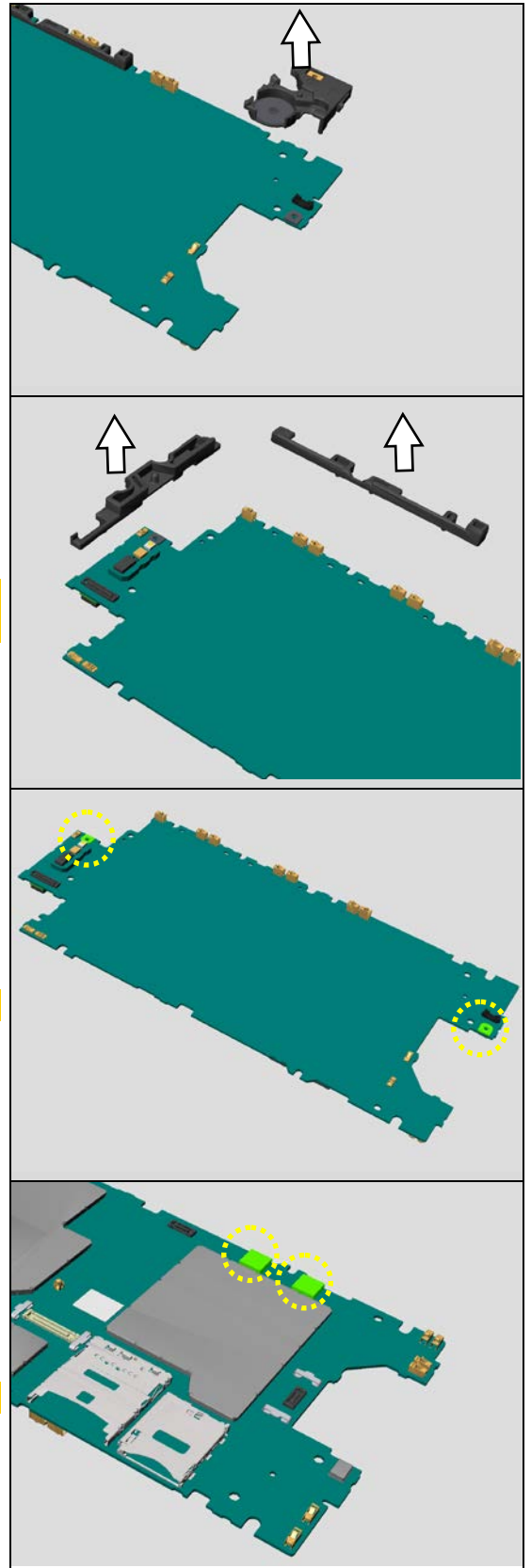
Scrap! Do not reuse the Holder Battery Top and Holder Guide Left!

Remove the 2 pieces of the Adhesive PWB Mic.

Scrap! Do not reuse the Adhesive PWB Mic!

Remove the 2 pieces of Cushion FPC Key.

Scrap! Do not reuse the Cushion FPC Key!

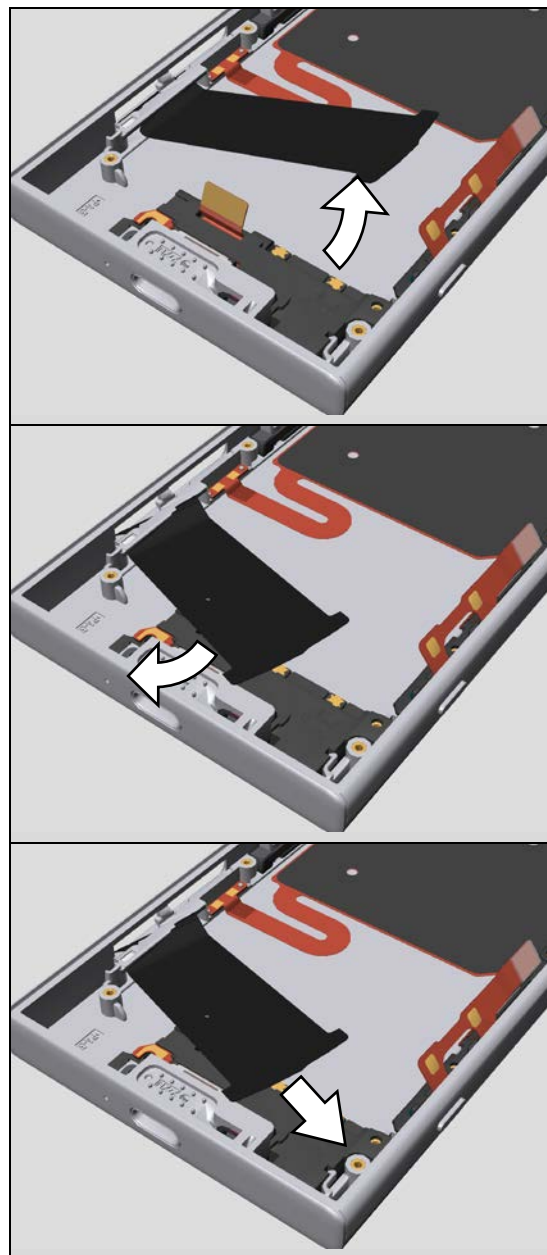


4.16 Sheet Slider MoP

Pinch the Sheet Slider MoP.

Rotate the Sheet Slider MoP as right figure.

Remove the Sheet Slider MoP.



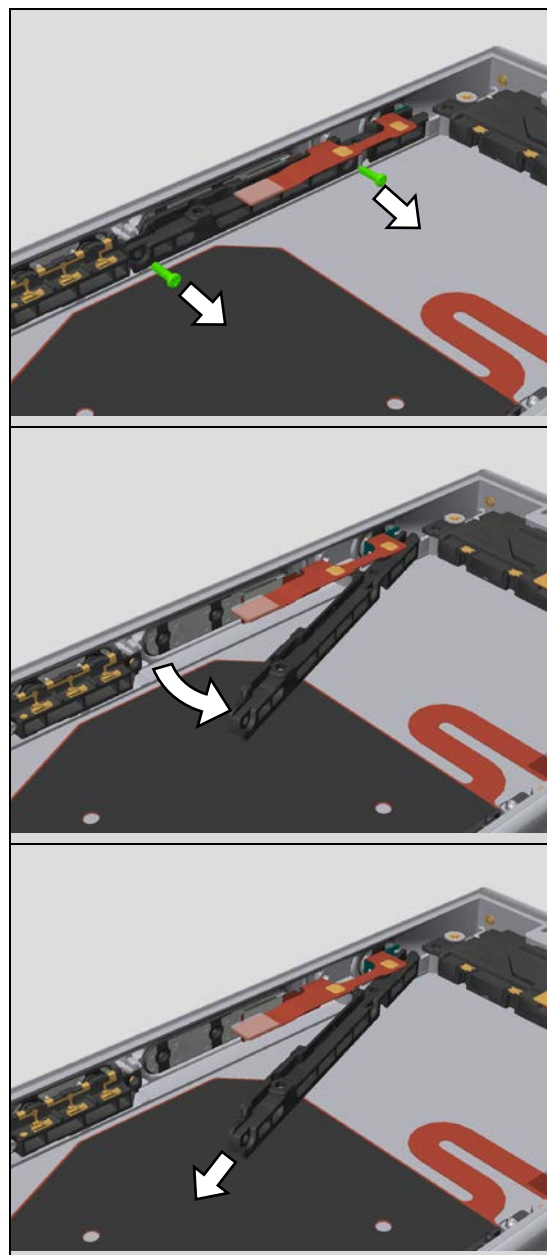
4.17 Holder FPC Key

Remove 2 places of the Screw M1.2*4.2.

Scrap! Do not reuse the screw!

Rotate the Holder FPC Key as right figure.

Remove the Holder FPC Key.



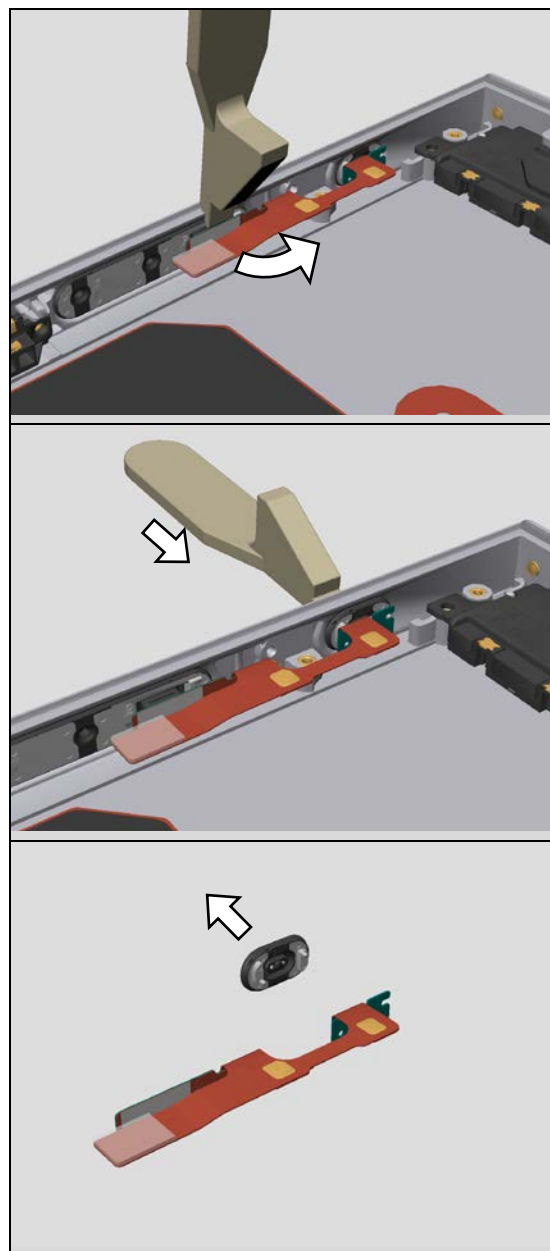
4.18 FPC Key

Disconnect a connector of the Fingerprint Sensor.

Push the Key Camera from key side by using Front Opening Tool.

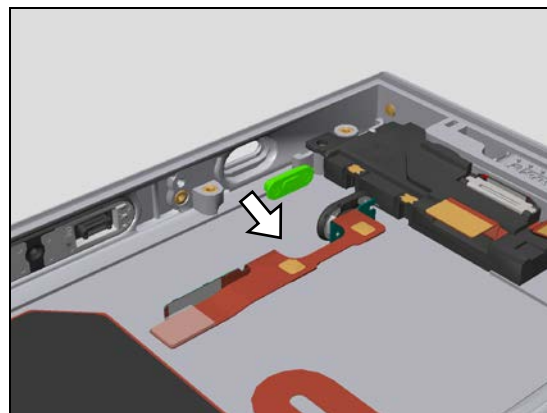
Remove the Gasket WR Camera when only replacement of the Gasket WR Camera or FPC Key.

Scrap! Do not reuse the Gasket WR Camera, when removing the Gasket WR Camera from FPC Key.



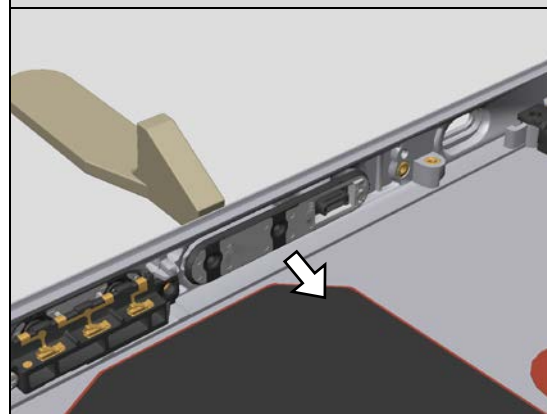
4.19 Key Camera

Remove the Key Camera.

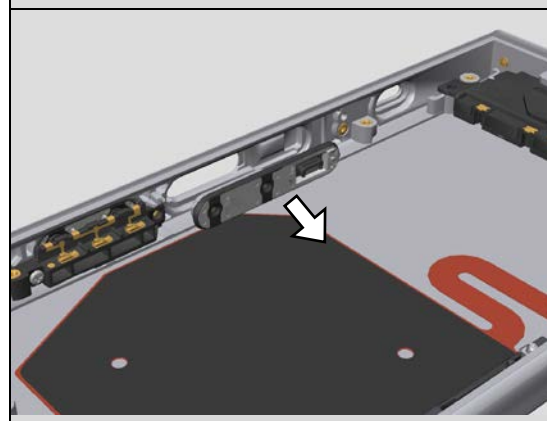


4.20 Fingerprint Sensor

Push the Fingerprint Sensor from key side by using Front Opening Tool.



Remove the Fingerprint Sensor.



4.21 Key Volume

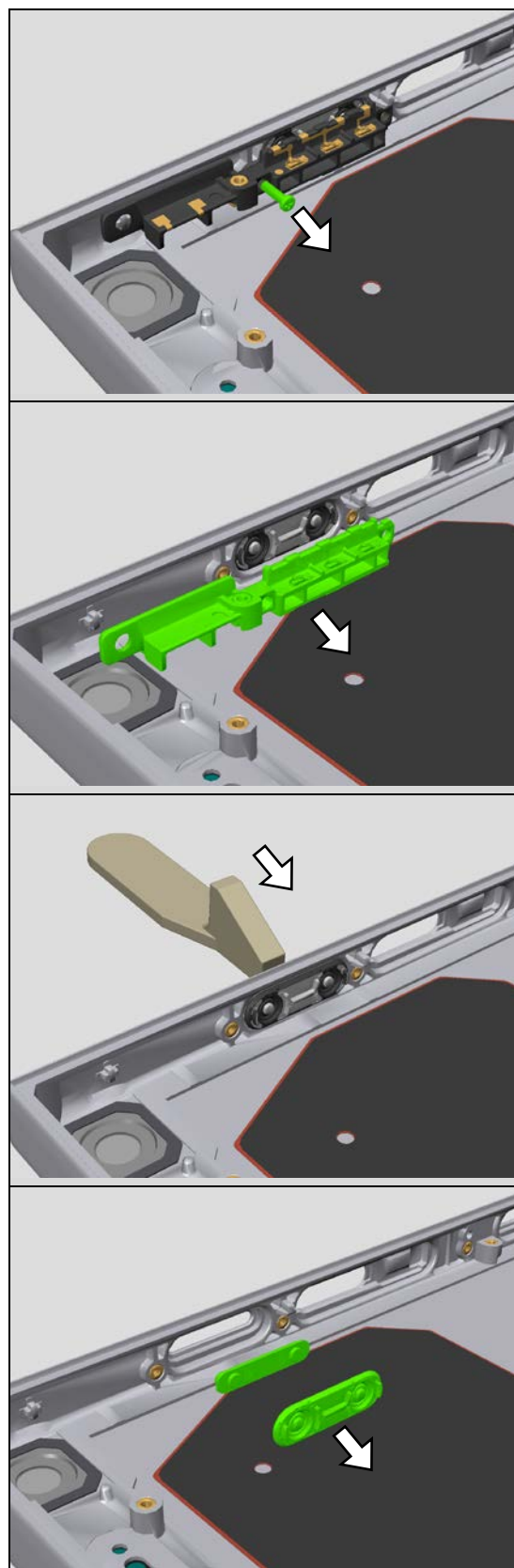
Remove the Screw M1.2*4.2.

Scrap! Do not reuse the screw!

Remove the Holder Key Volume.

Push the Key Volume from key side by using Front Opening Tool.

Remove the Gasket WR Volume and the Key Volume.



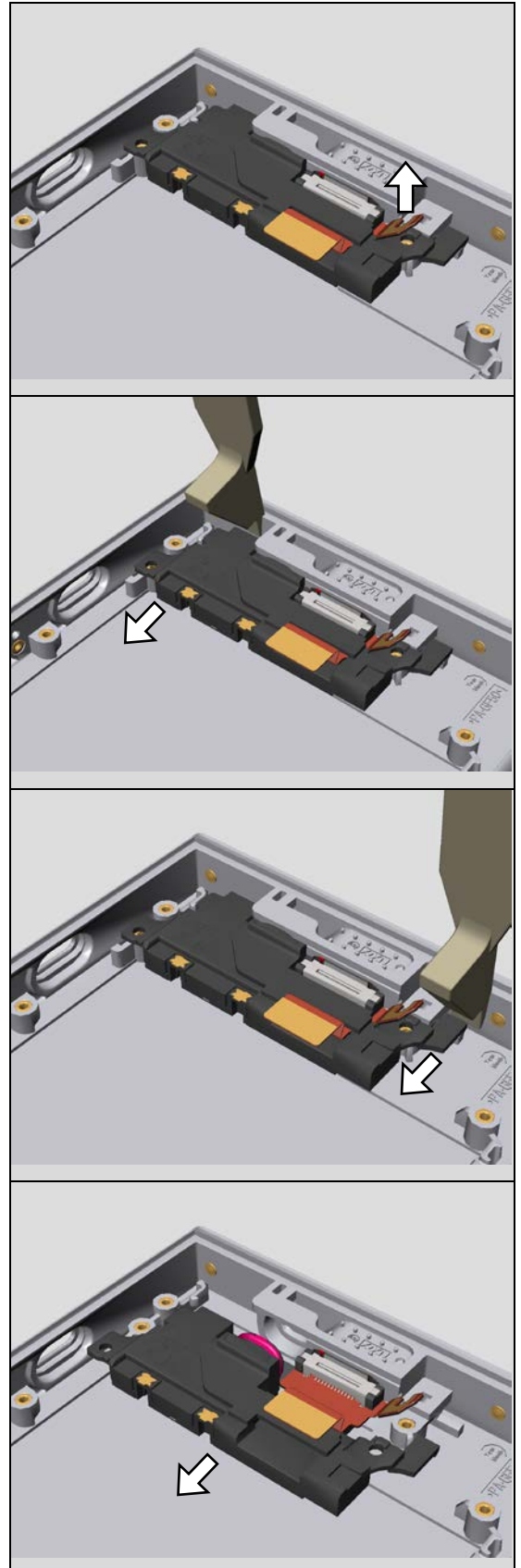
4.22 Speaker Box

Peel off the USB FPC from Speaker Box.

Move the Speaker Box by using Front Opening Tool as right figure.

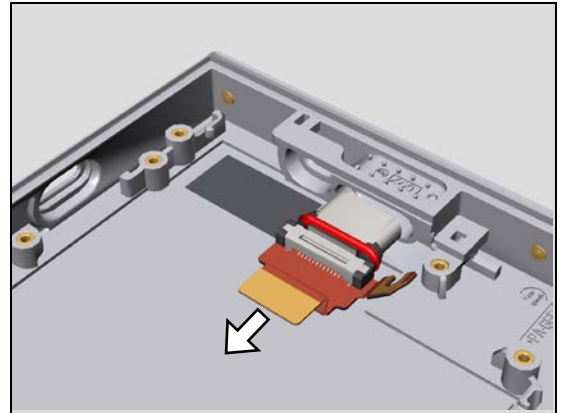
Move the Speaker Box by using Front Opening Tool as right figure.

Remove the Speaker Box.



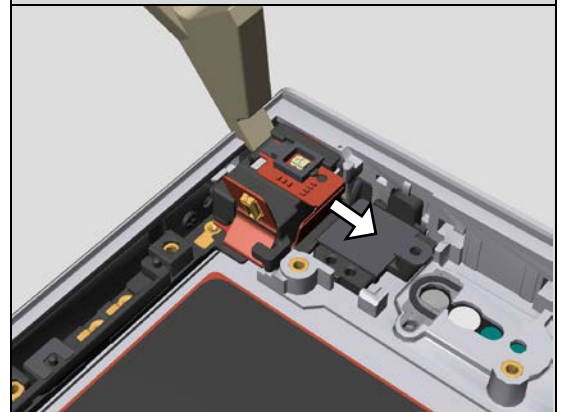
4.23 FPC USB

Remove the FPC USB.

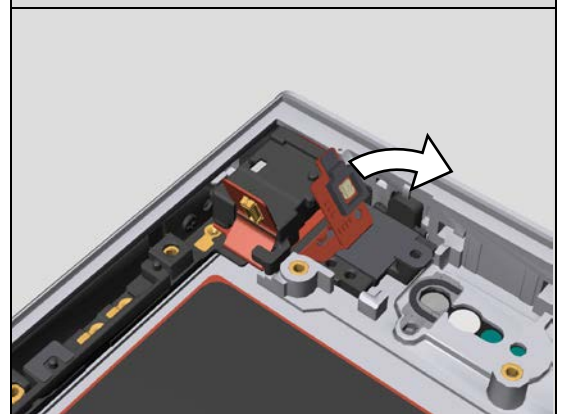


4.24 FPC JK Module

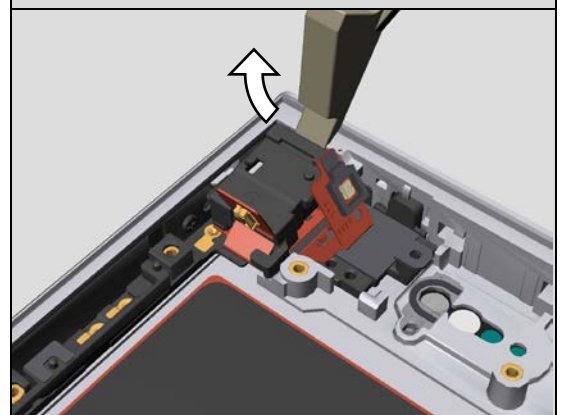
Move the FPC by using Front Opening Tool as right figure.



Rotate the FPC as right figure.

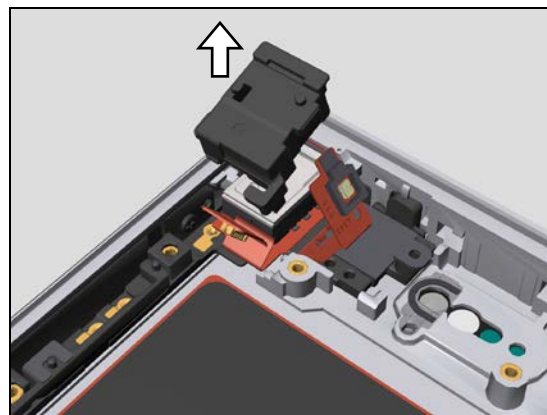


Lift up the Holder Audio Jack by using Front Opening Tool as right figure.

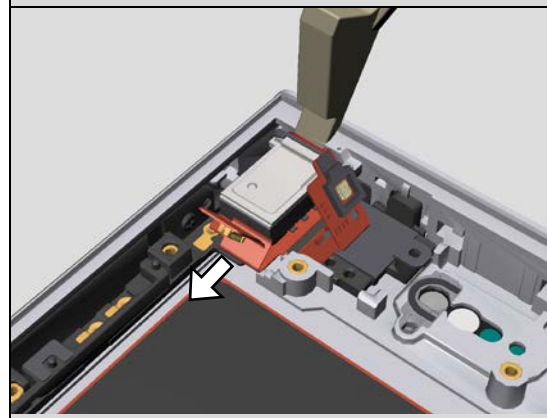


Disassembly

Remove the Holder Audio Jack.



Remove the FPC JK Module by using Front Opening Tool as right figure.



4.25 Holder Mic 2nd

Remove the Cushion Front Camera.

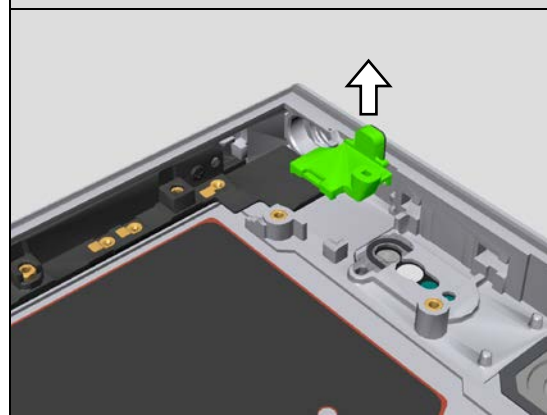
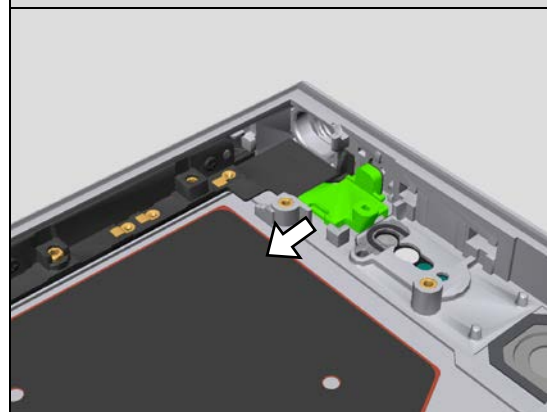
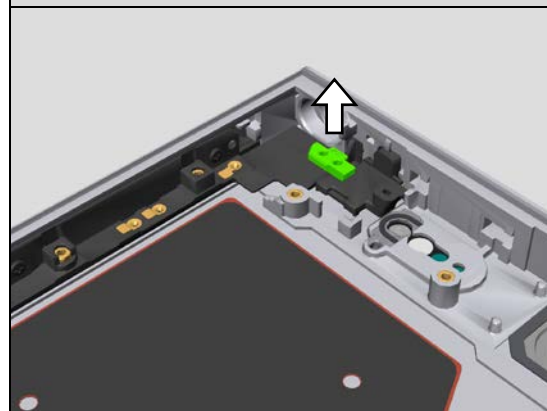
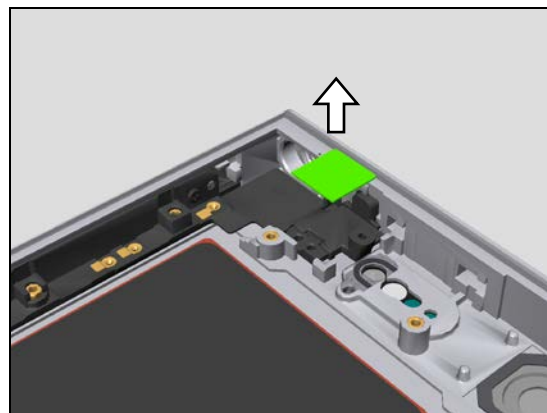
Scrap! Do not reuse the Cushion Front Camera!

Remove the Spacer holder 2nd Mic.

Scrap! Do not reuse the Spacer holder 2nd Mic!

Move the Holder Mic 2nd.

Remove the Holder Mic 2nd.



4.26 Antenna Combo LDS

Remove 2 places of the Screw M1.2x1.6.

Scrap! Do not reuse the screw!

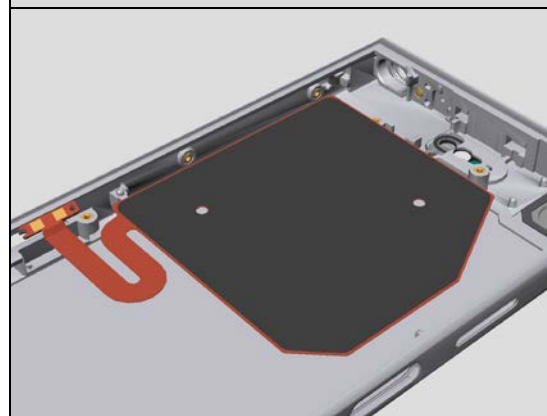
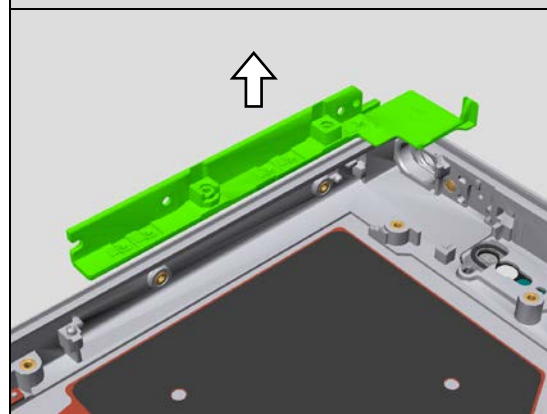
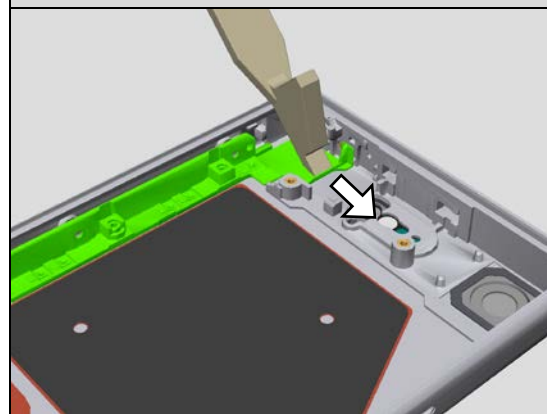
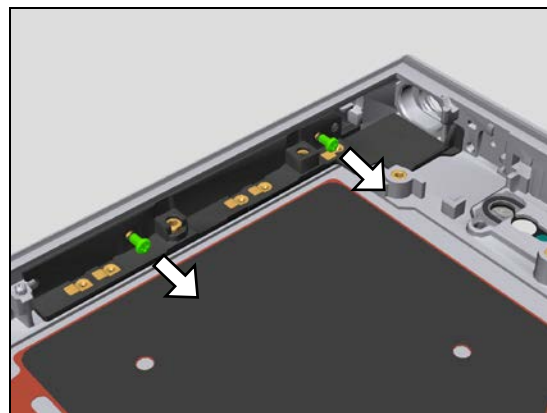
Move the Antenna Combo LDS by using Front Opening Tool as right figure.

Remove the Antenna Combo LDS.

4.27 Antenna NFC

Remove the Antenna NFC.

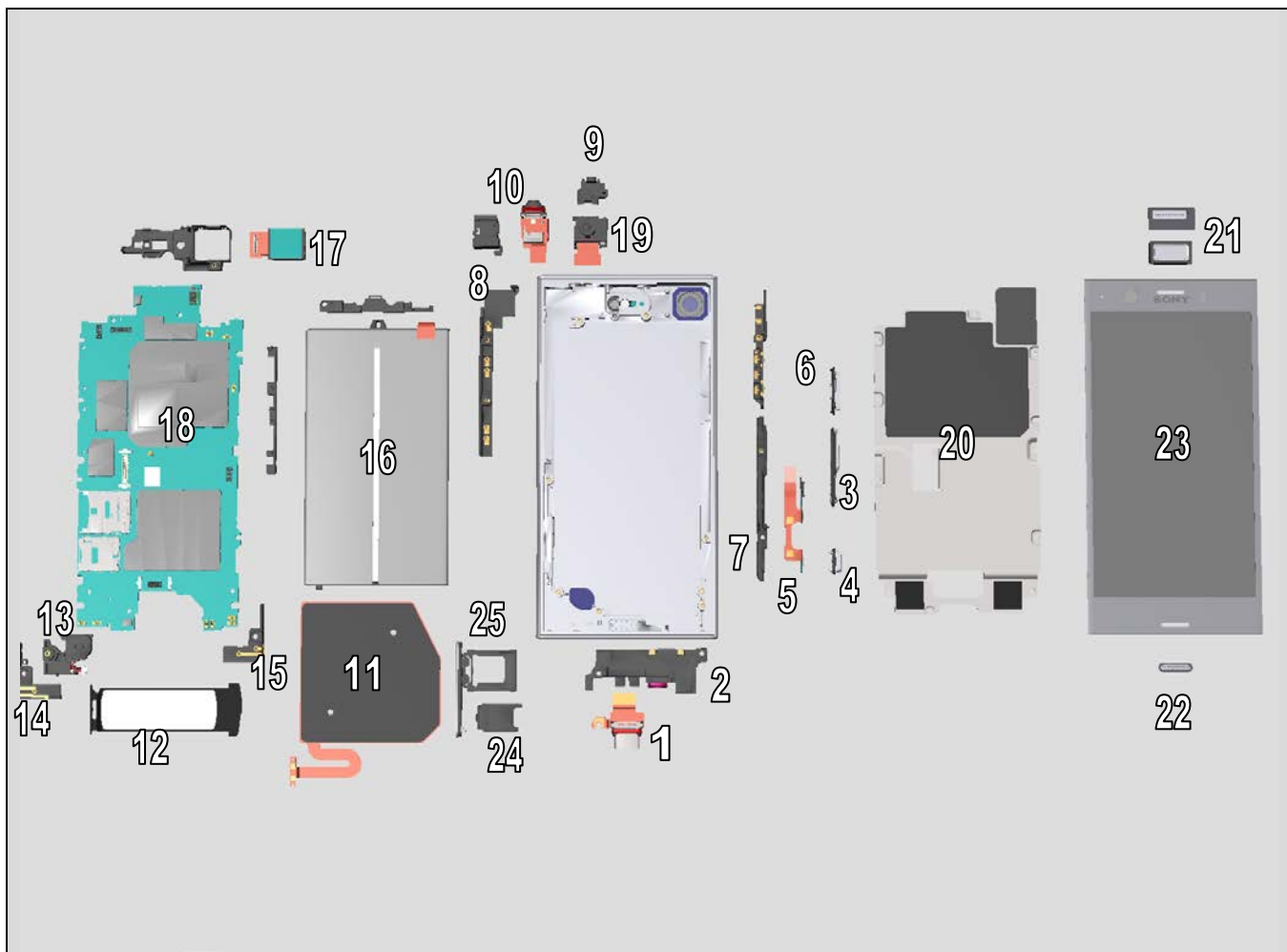
Scrap! Do not reuse the Antenna NFC!



5 Reassembly

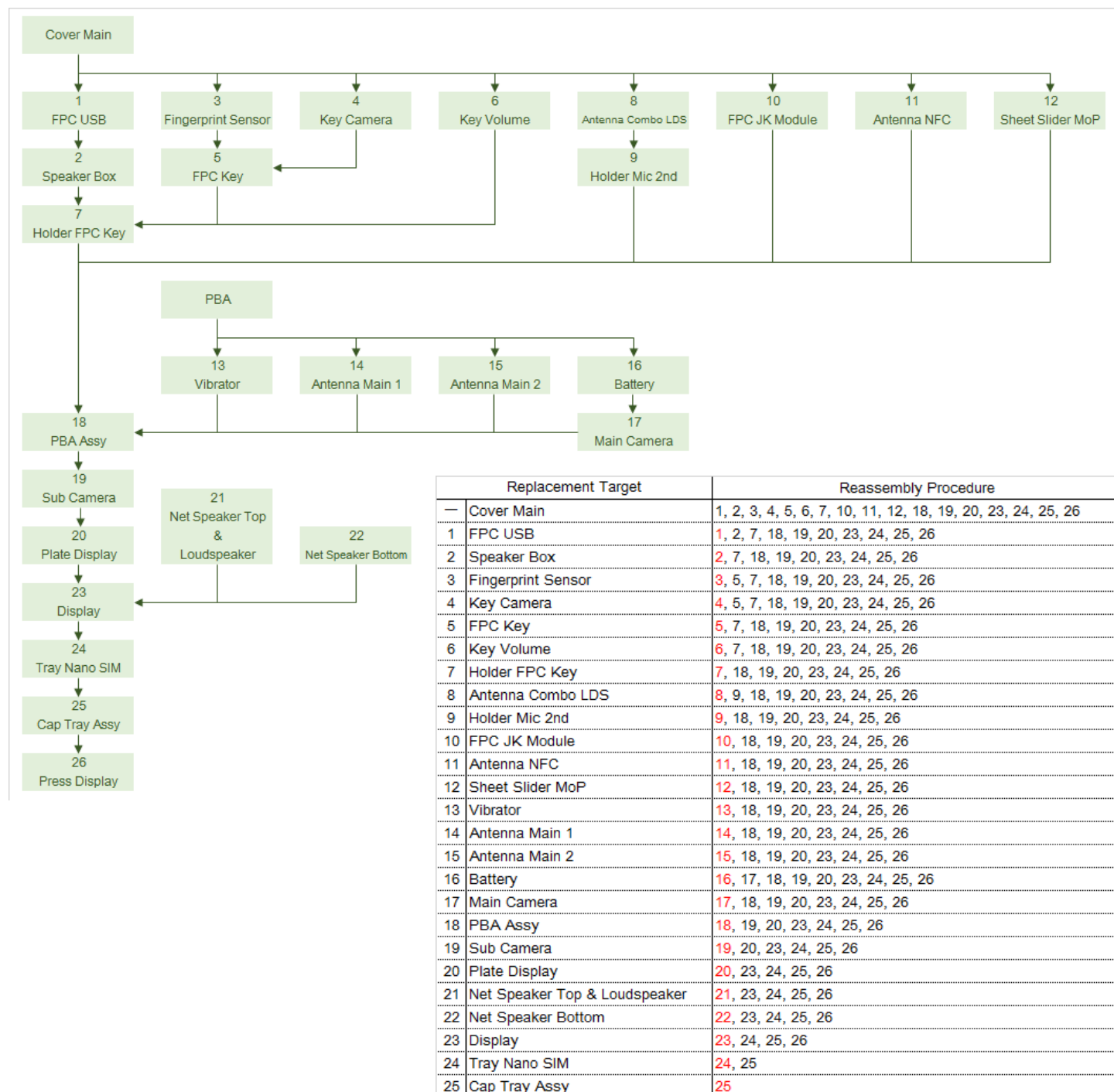
The reassembly is done in the following order:

1. FPC USB
2. Speaker Box
3. Fingerprint Sensor
4. Key Camera
5. FPC Key
6. Key Volume
7. Holder FPC Key
8. Antenna Combo LDS
9. Holder Mic 2nd
10. FPC JK Module
11. Antenna NFC
12. Sheet Slider MoP
13. Vibrator
14. Antenna Main 1
15. Antenna Main 2
16. Battery
17. Main Camera
18. PBA Assy
19. Sub Camera
20. Plate Display
21. Net Speaker Top & Loudspeaker
22. Net Speaker Bottom
23. Display
24. Tray nano SIM
25. Cap Tray Assy



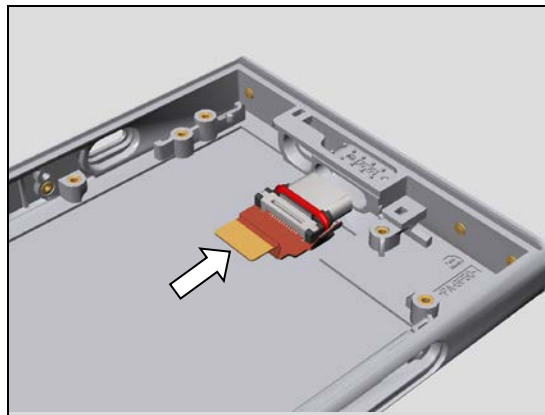
Reassembly

Quick Reference for Reassembling



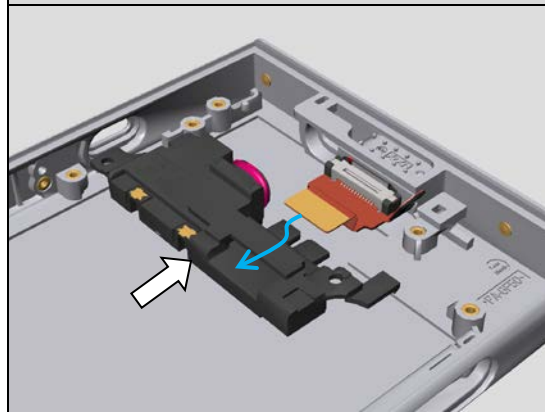
5.1 FPC USB

Install the FPC USB.

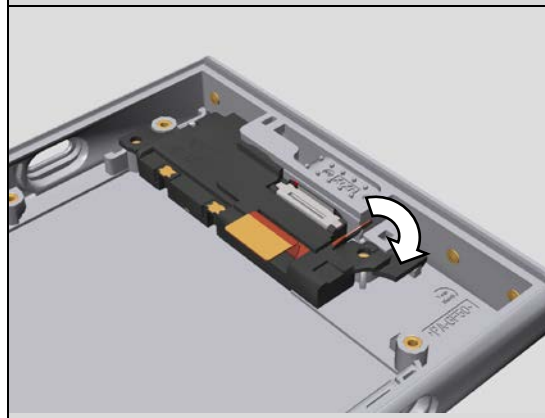


5.2 Speaker Box

Install the Speaker Box with inserting FPC to hole of Speaker Box as blue arrow.



Paste FPC to Speaker Box.



Reassembly

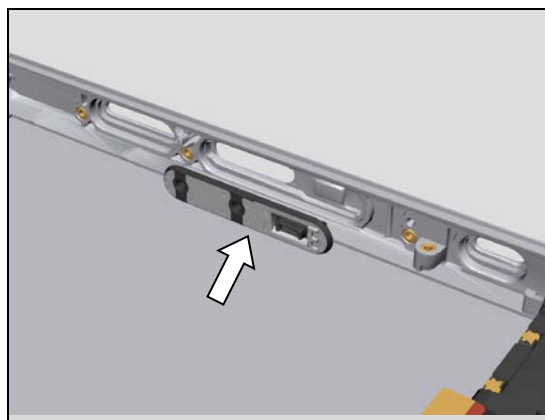
5.3 Fingerprint Sensor

Install the Fingerprint Sensor.

Note! Do not push Fingerprint Sensor from outside until assembly of Holder FPC Key.

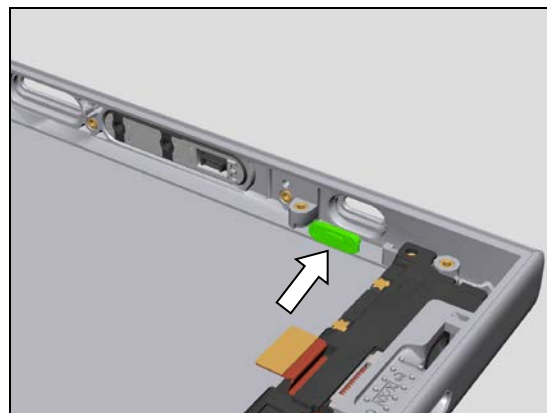
Note! Make sure the color matching of the phone and Fingerprint Sensor as below list.

Phone color	Fingerprint Sensor Color
Black	Black
White Silver	Silver
Horizon Blue	Silver
Twilight Pink	Silver



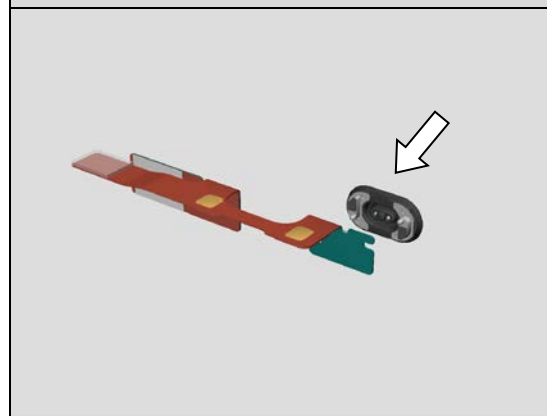
5.4 Key Camera

Install the Key Camera.



5.5 FPC Key

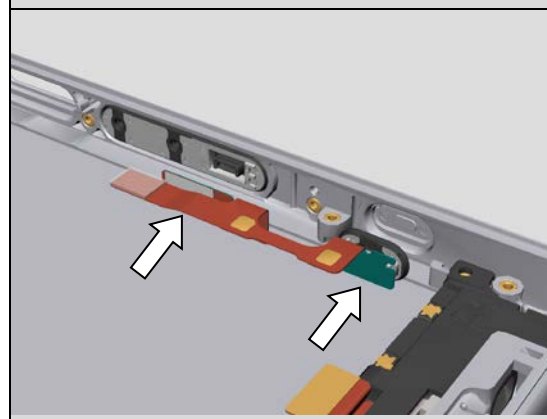
Paste Gasket WR Camera to FPC Key.



Install the Gasket WR Camera with FPC Key.

Then connect the Fingerprint Sensor BtoB.

Note! Do not push Fingerprint Sensor and Key Camera from outside until assembly of Holder FPC Key.



5.6 Key Volume

Install the Key Volume.

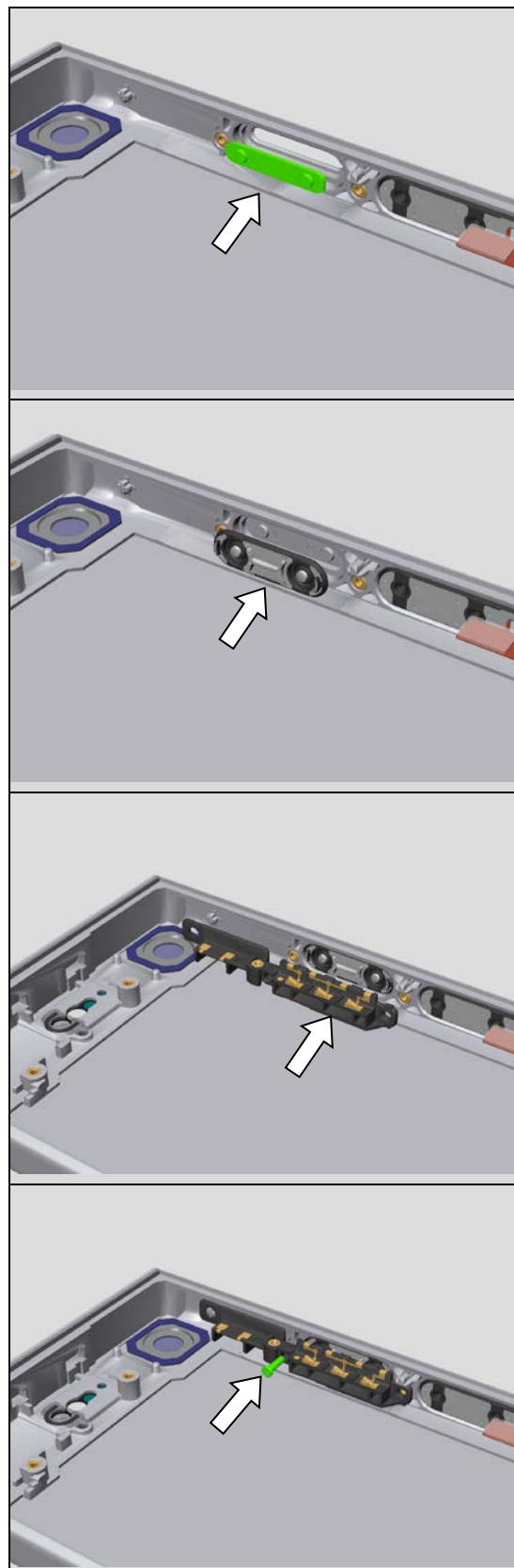
Install the Gasket WR Volume.

Note! Do not push the Key Volume from outside until assembly of the Holder Key Volume.

Install the Holder Key Volume.

Tighten a Screw M1.2*4.2 by using a screwdriver with Bit (JCIS No.0).

Torque: 8 ± 1 [Ncm]

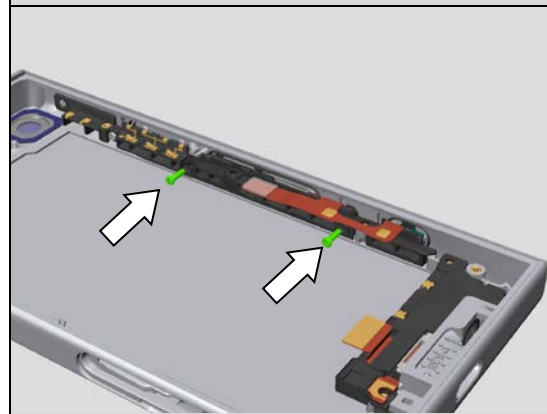
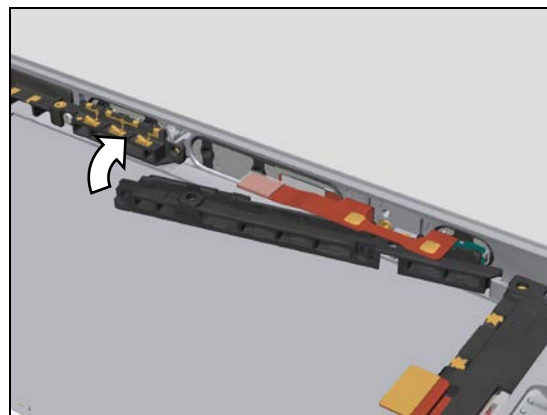


5.7 Holder FPC Key

Install the Holder FPC Key.

Tighten 2 places of the Screw M1.2*4.2 by using a screwdriver with Bit (JCIS No.0).

Torque: 10 ± 1 [Ncm]

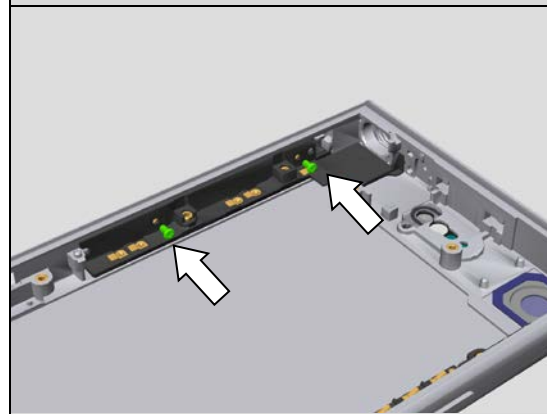
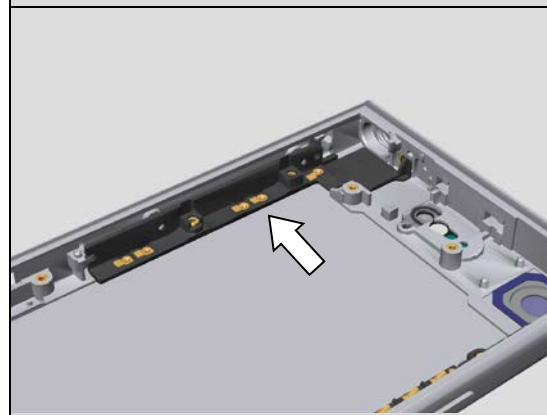


5.8 Antenna Combo LDS

Install the Antenna Combo LDS.

Tighten 2 places of the Screw M1.2x1.6 by using a screwdriver with Bit (JCIS No.0).

Torque: 8 ± 1 [Ncm]

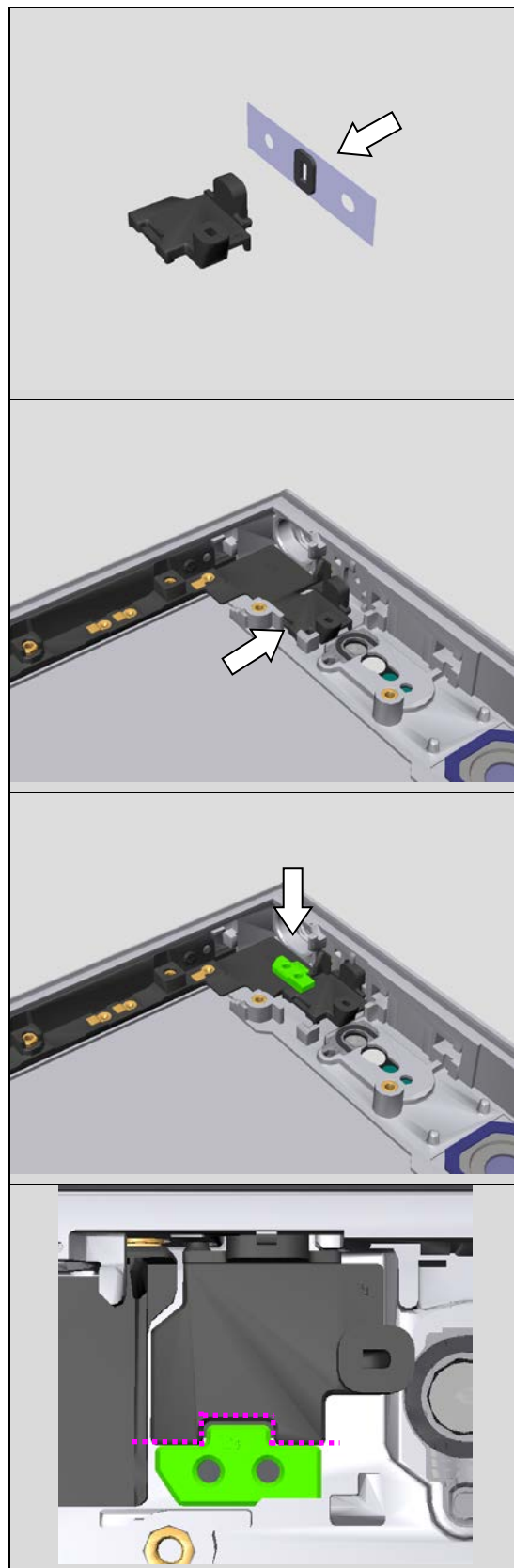


5.9 Holder Mic 2nd

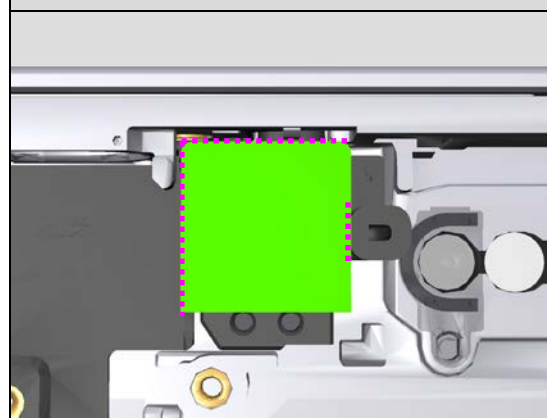
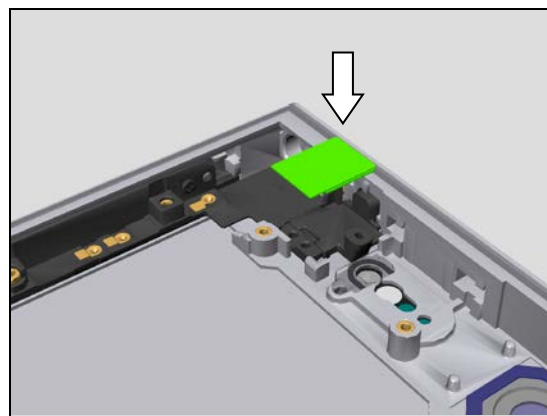
Paste the Adhesive Holder Mic 2nd to Holder Mic 2nd.

Install the Holder Mic 2nd to the Cover Main.

Paste the Spacer Holder 2nd Mic along red dotted line.

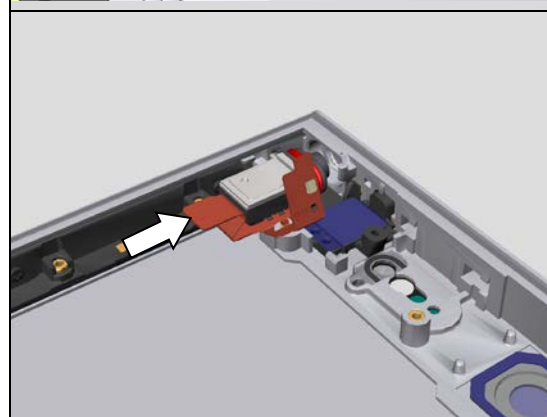


Paste the Cushion Front Camera along red dotted line as right figure.

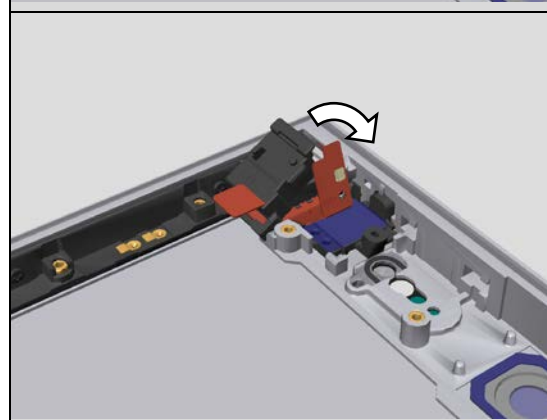


5.10 FPC JK Module

Install the FPC JK Module.

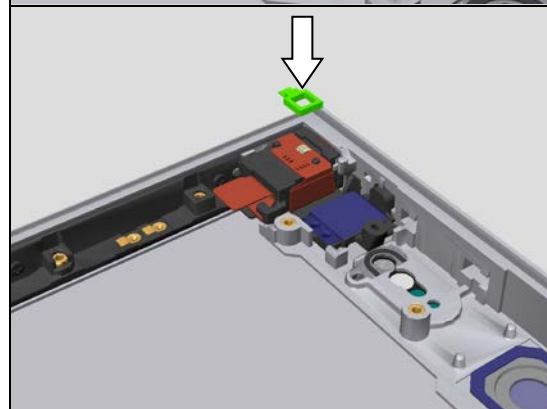
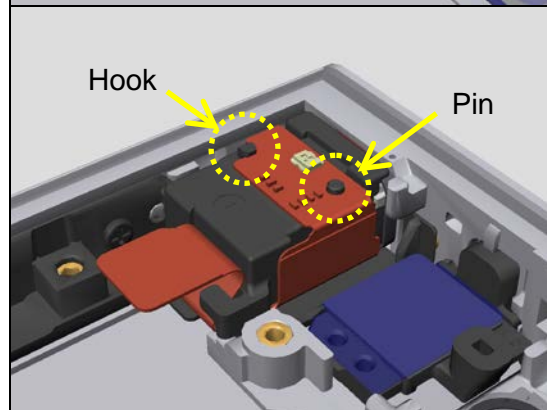
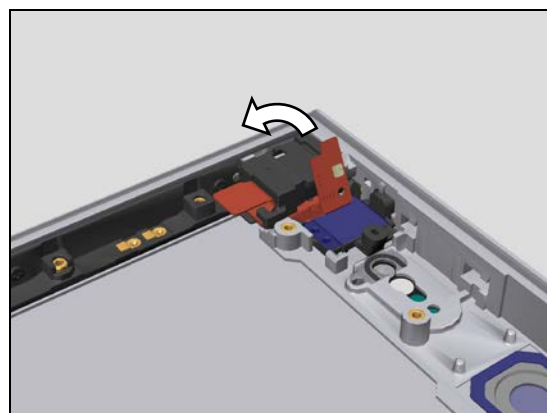


Install the Holder Audio Jack.

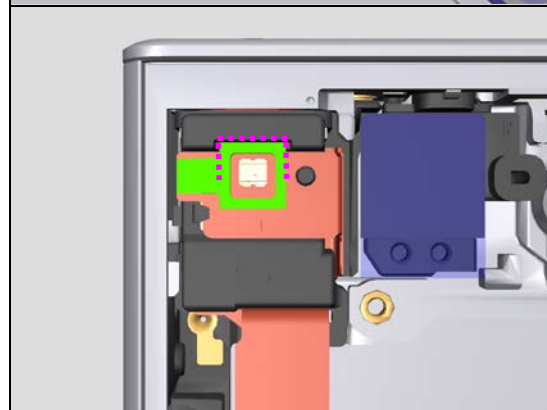


Reassembly

Install the FPC of the FPC JK Module to the Holder Audio Jack.



Paste the Cushion Shade LED to FPC along red dotted line as right figure.

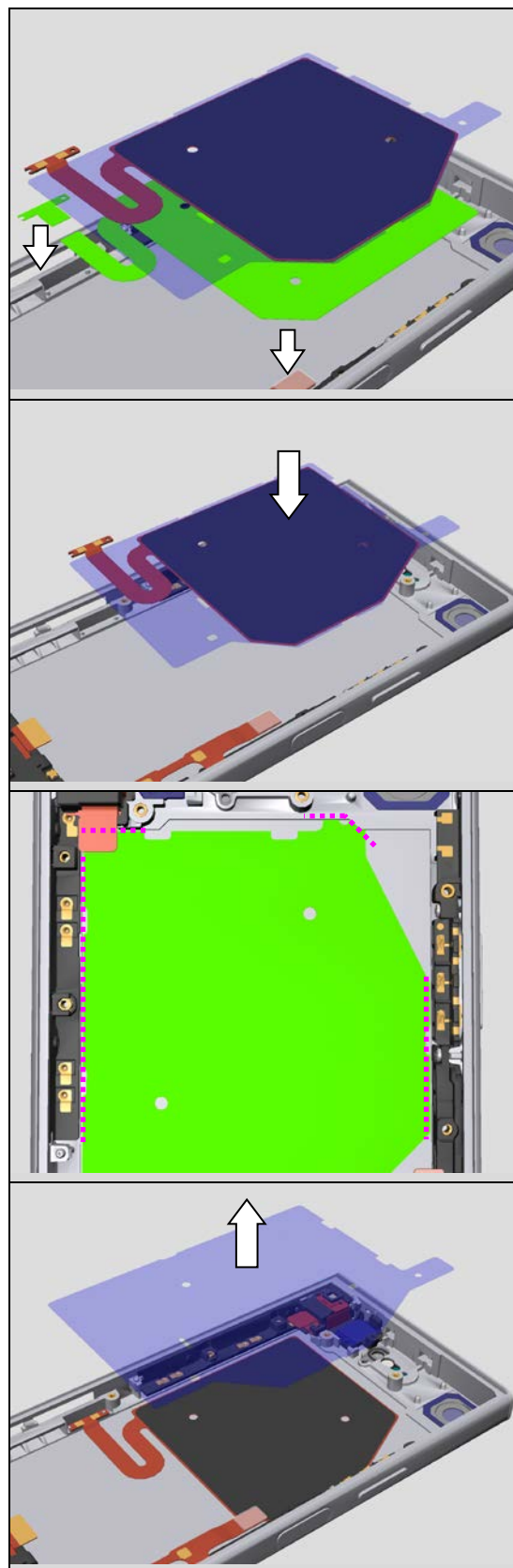


5.11 Antenna NFC

Remove release film of terminal and antenna area from Antenna NFC.

Paste the Antenna NFC along the release film of the Antenna NFC to red dotted line.

Remove the release film of the Antenna NFC.



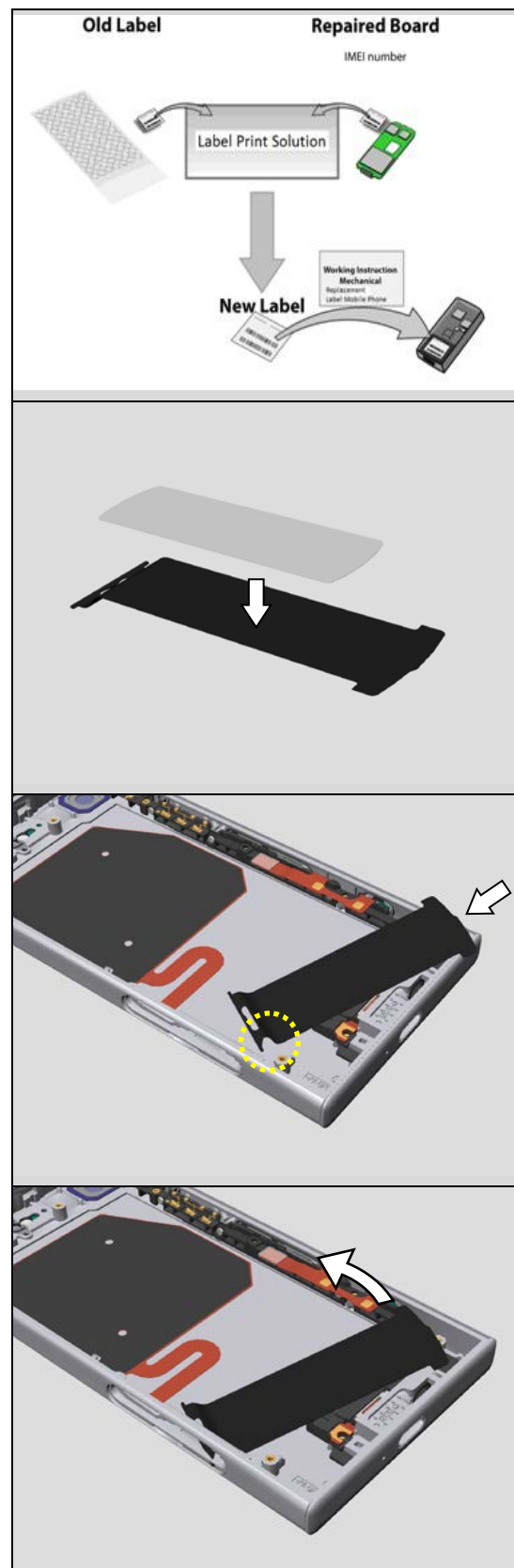
5.12 Sheet Slider MoP

When Label MoP is replaced, follow the instructions in the Generic Repair Manual – Build Swap for change of label.

Paste the printed Label MoP on the Sheet Slider MoP.

Insert the Sheet Slider MoP from concave of yellow circle.

Install the Sheet Slider MoP.



5.13 Vibrator

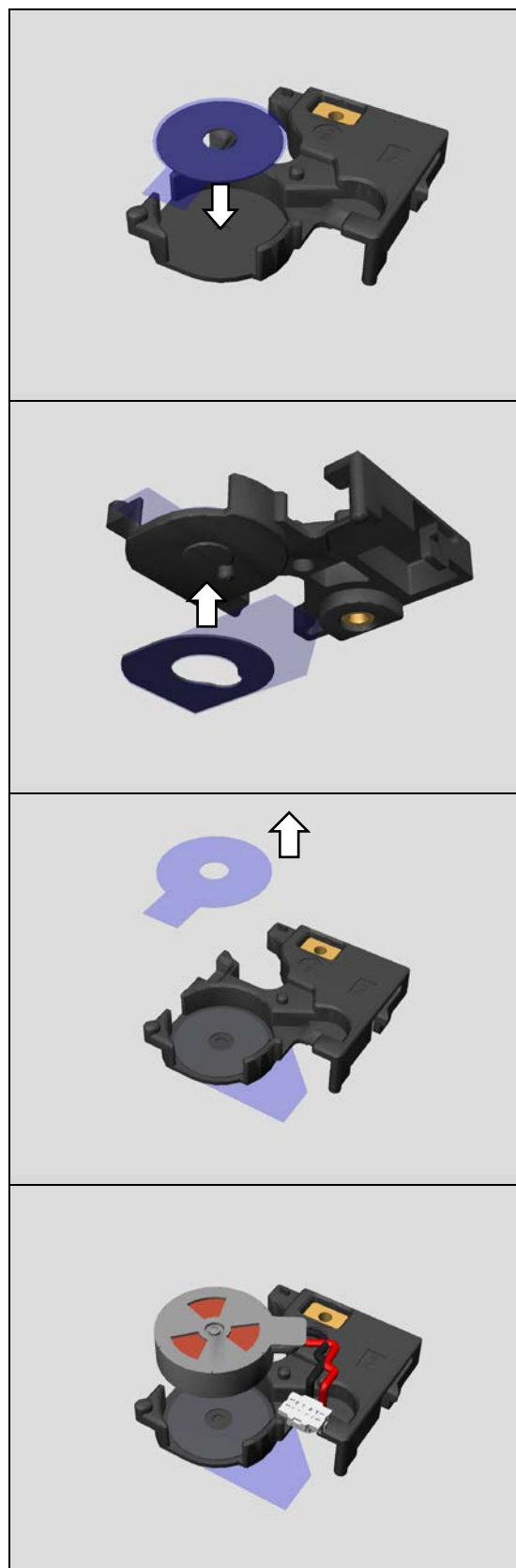
Paste the Adhesive Vib to Holder Vib.

Paste the Adhesive Holder Vib to back side of Holder Vib along the shape of Holder Vib.

Remove the release film of the Adhesive Vib.

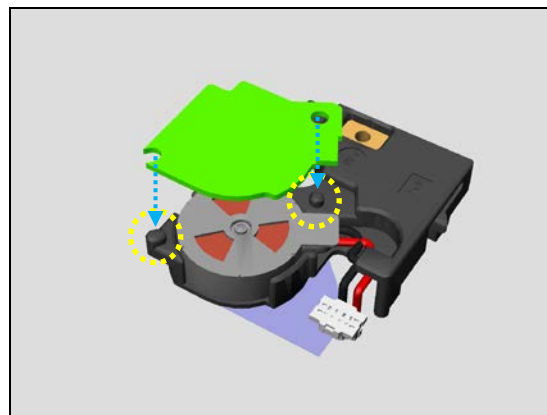
Paste the Vibrator.

Note! Cable must be hold in recess area of the Holder Vib.

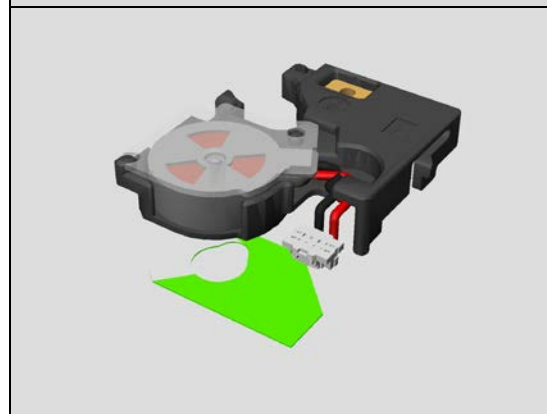


Reassembly

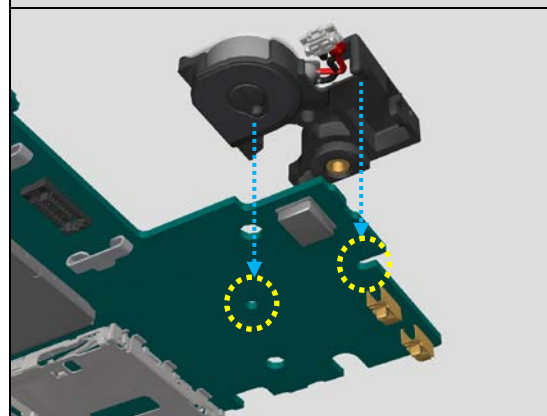
Paste the Sheet vib along hole of the Sheet vib to pins of the Holder Vib.



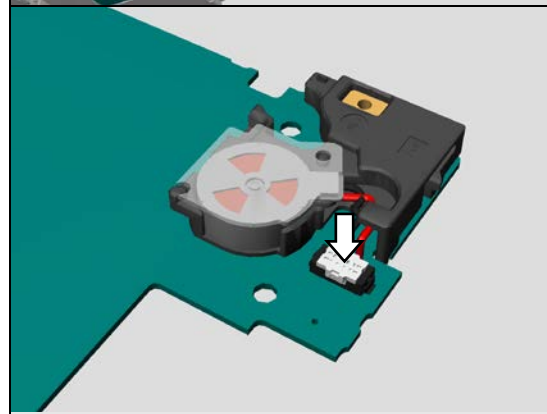
Remove the release film of the Adhesive Holder Vib.



Paste the Vibrator Assy to PBA along 2 pins of the Holder Vib to 2 holes of the PBA.



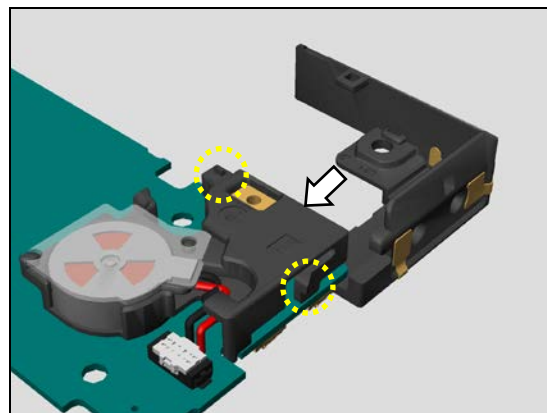
Connect the BtoB connector of the Vibrator.



5.14 Antenna Main 1

Install the Antenna Main 1.

Note! Confirm hold of the 2 hooks after installation.

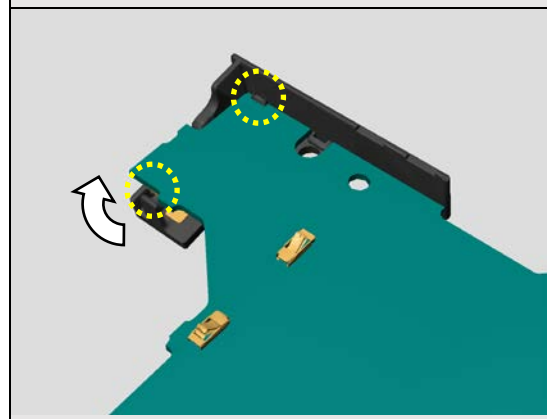
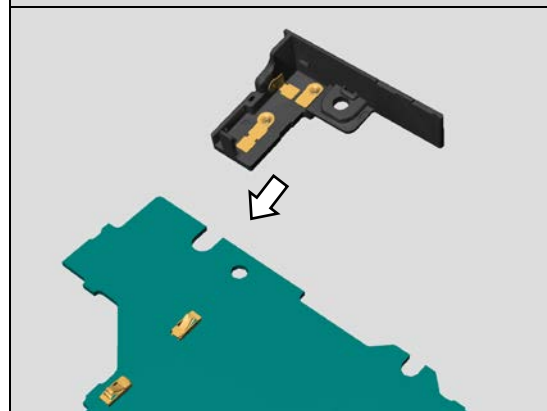


5.15 Antenna Main 2

Insert the Antenna Main 2 from direction as right figure.

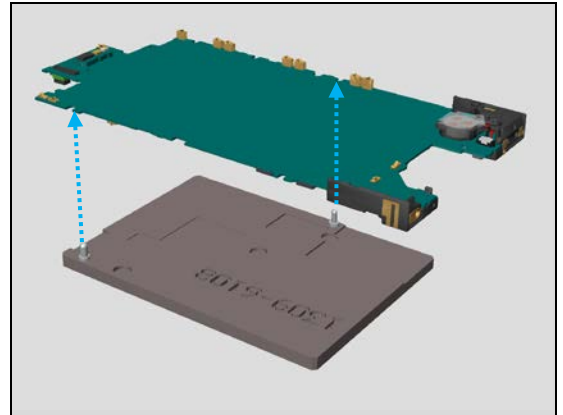
Install the Antenna Main 2 as right figure.

Note! Confirm hold of the 2 hooks after installation.

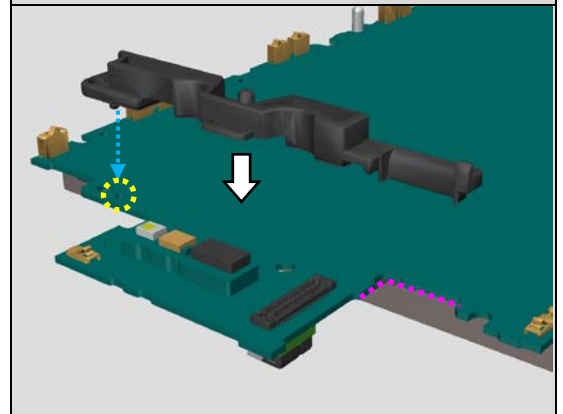


5.16 Battery

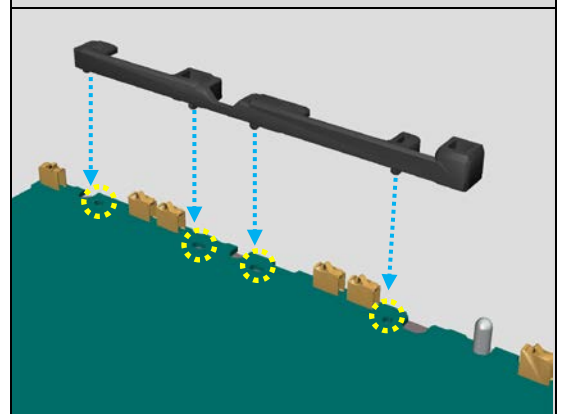
Set the Fixture Battery Clamp to PBA as right figure.



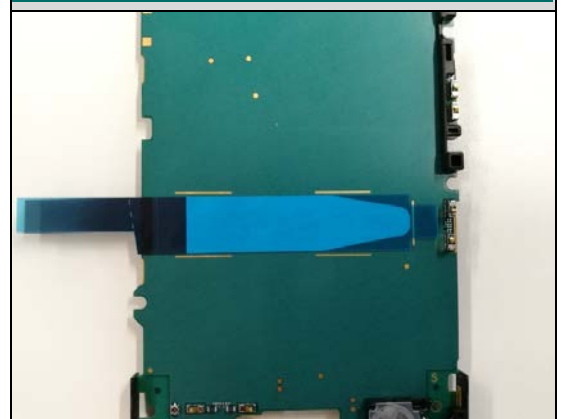
Paste the Holder Battery Top along a pin of the Holder Battery Top to a hole of the PBA as right figure.



Paste the Holder Guide Left along 4 pins of the Holder Guide Left to 4 holes of the PBA.

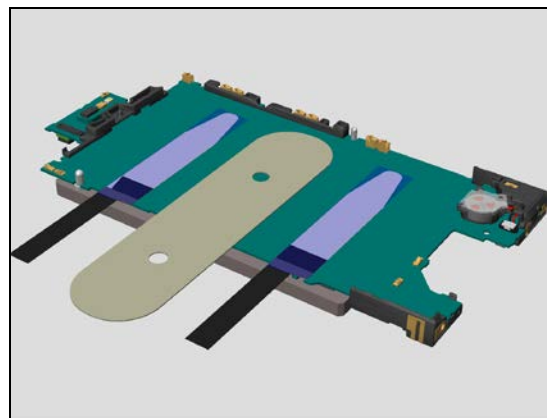


Paste 2 pieces of the Adhesive Battery along line on the PBA as right figure.

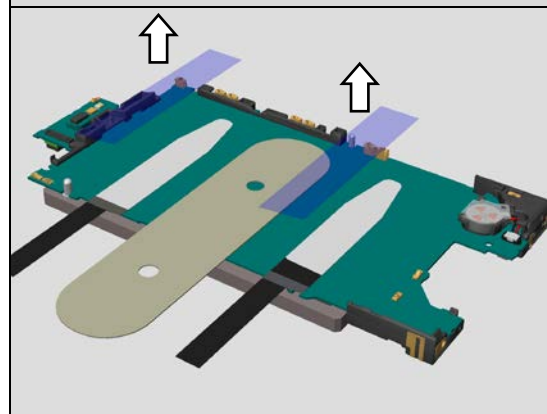


Reassembly

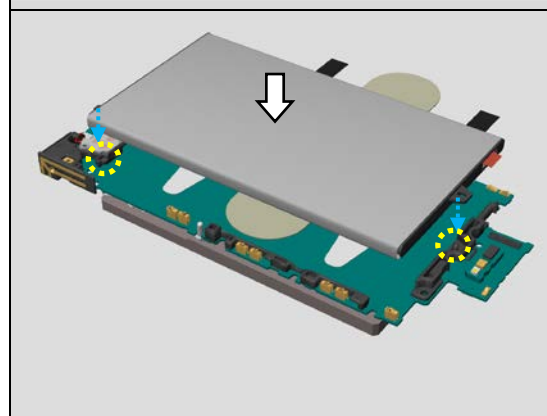
Put the Flexible Disassembly tool between 2 pieces of the Adhesive Battery.



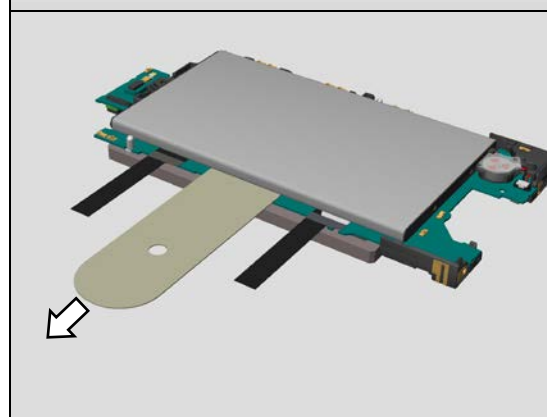
Remove the release film of the Adhesive Battery.



Put the Battery on the PBA along hole of the Battery to pin of the Holder Battery Top and convex of the Battery to concave of the Holder Vib as right figure.

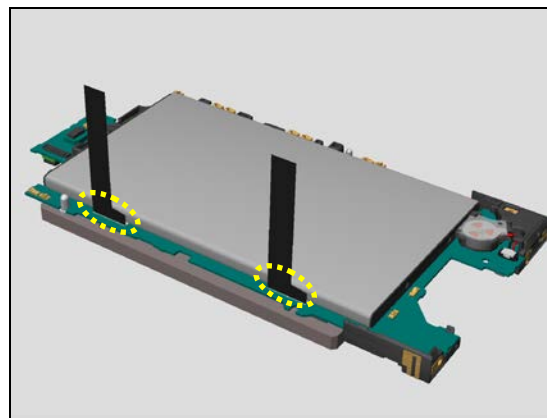


Remove the Flexible Disassembly tool.

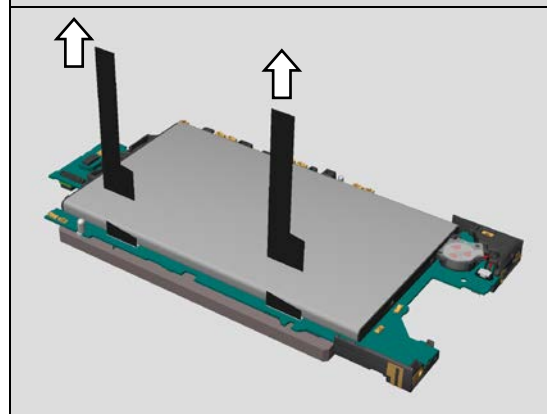


Reassembly

Paste the adhesive of yellow dotted circle to the Battery.



Remove the 2 pieces tab of the Adhesive Battery.



Set the Press Clamp on a workbench.

Note! Do not grip the Press Clamp.

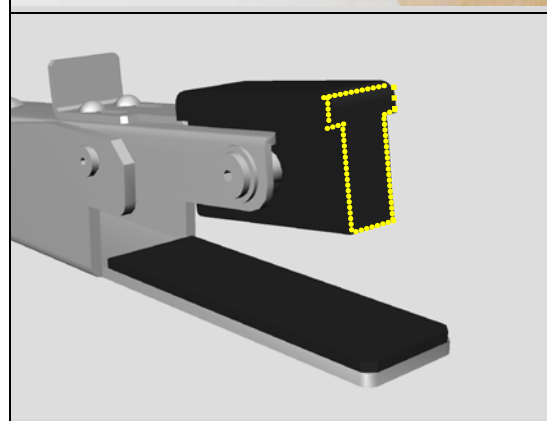


Make sure the Press Clamp head is narrow bottom angle.

for G8441



for G8341 / G8342 / G8343



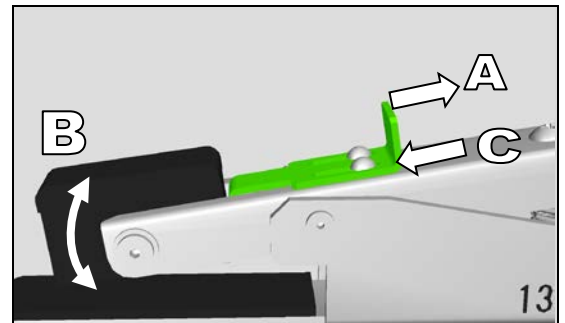
Reassembly

How to change the press head.

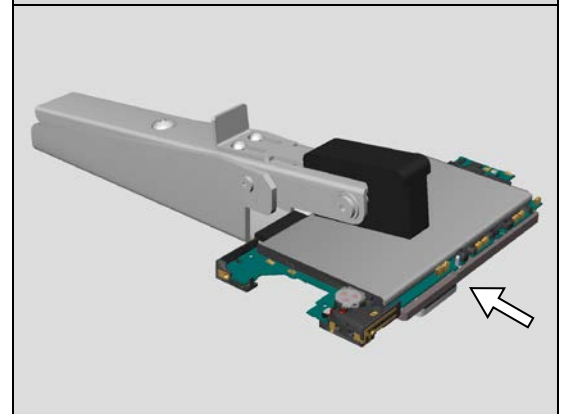
Slide the lever to unlock (A).

Turn the press head (B).

Slide the lever to lock (C).

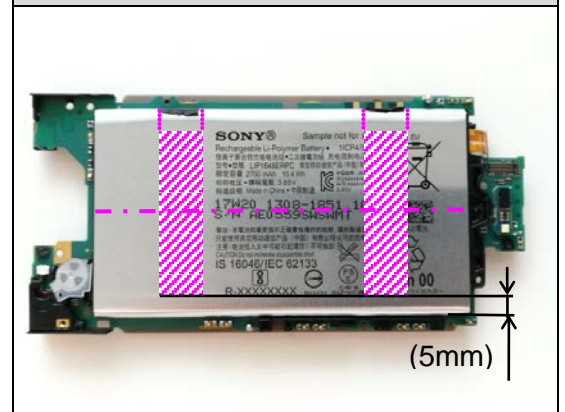
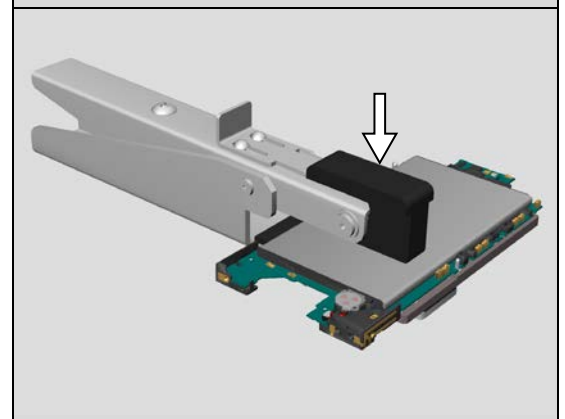


Open the press head to insert the unit.



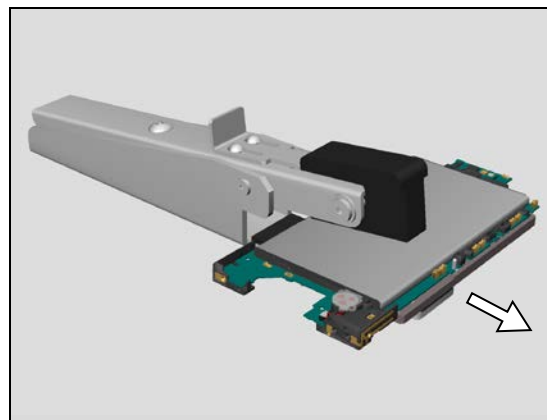
Press the Battery on 2 places of following position as right figure.

Press time : 5 sec



Reassembly

Open the press head to release the unit.

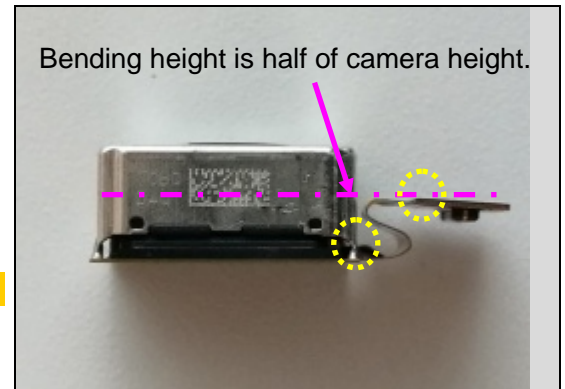


5.17 Main Camera

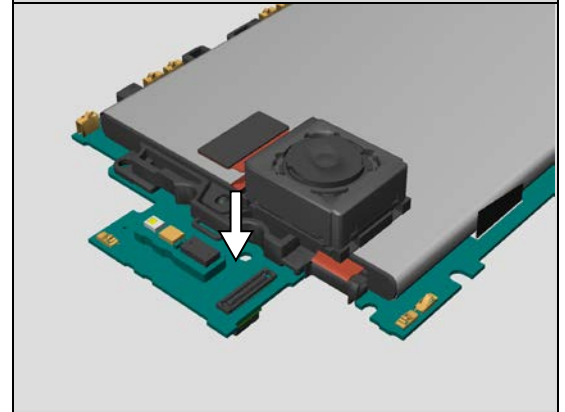
Pre-bend the FPC of the Main Camera.

Bending height is half of camera height as right figure.

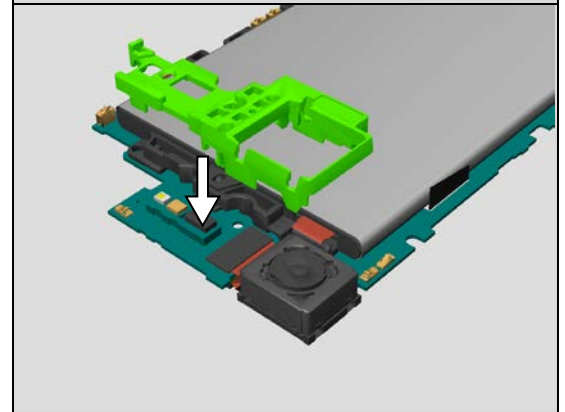
Note! Should not bend FPC of yellow circle area.



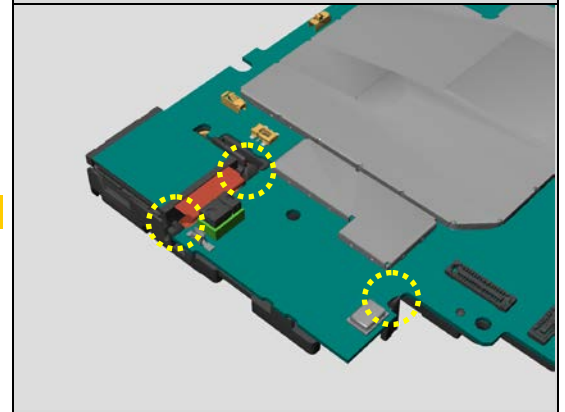
Connect the connector of the Main Camera to PBA.



Install the Holder Top Rear.



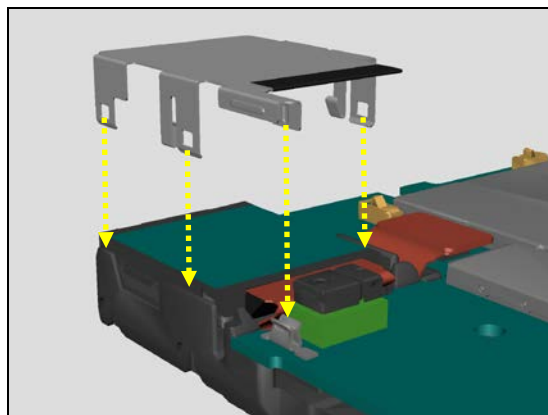
Note! 3 hooks must be fixed to PBA.



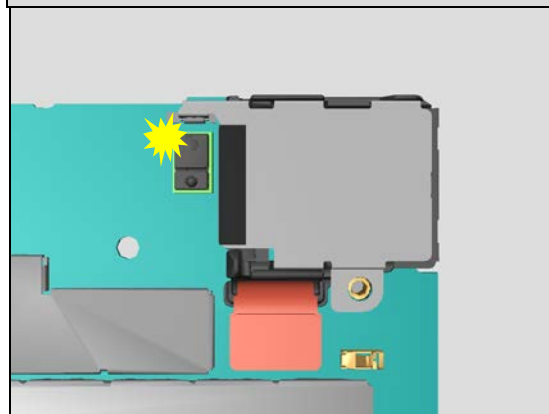
Reassembly

Install the Shield Main Camera.

Note! 4 hooks must be fixed to 3 slits of Holder Top Rear and a clip on the PBA.

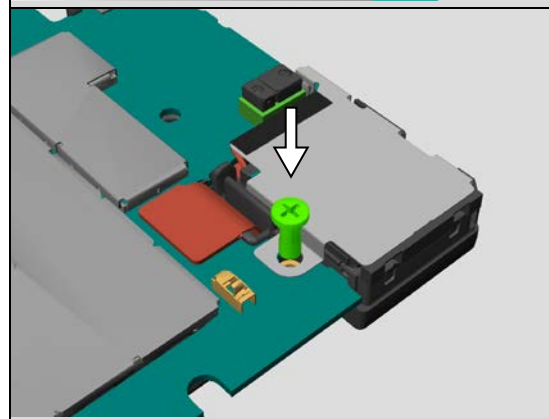


Note! When installing the Shield Main Camera, do not touch the sensor on the PBA.



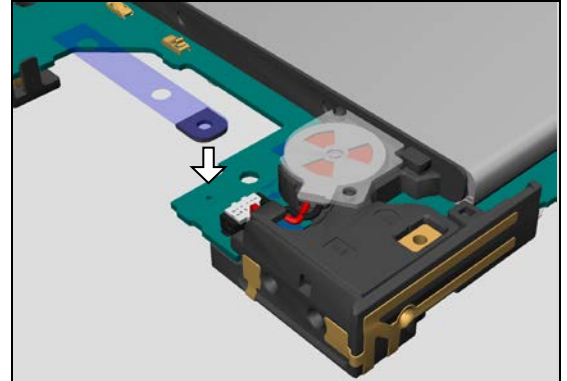
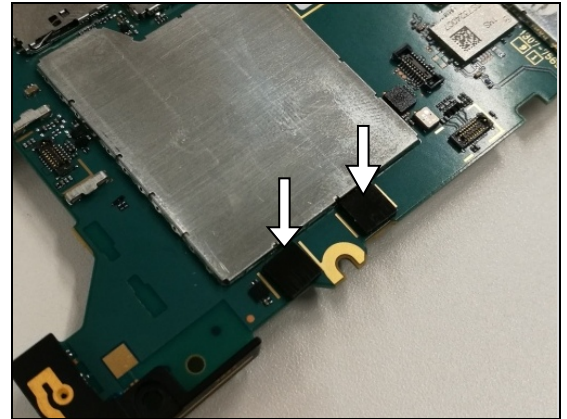
Tighten Screw M1.4x3.4 by using a screwdriver with Bit (JCIS No 0).

Torque : 8 Ncm

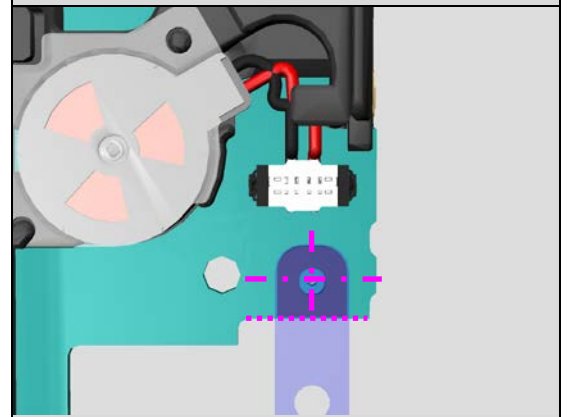


5.18 PBA Assy

Paste 2 pieces of the Cushion FPC Key along line on the PBA.



Paste the Adhesive PWB Mic along mic hole and red dotted line as right figure.



Note!

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

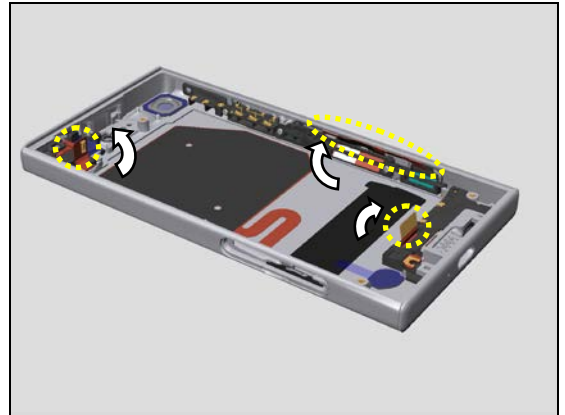
And, make sure to no foreign materials on the battery compartment of the unit.

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

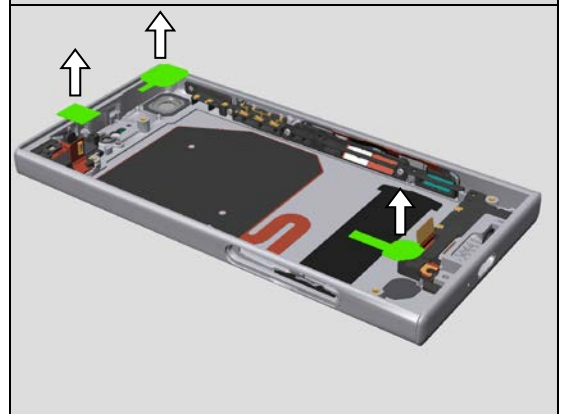


Reassembly

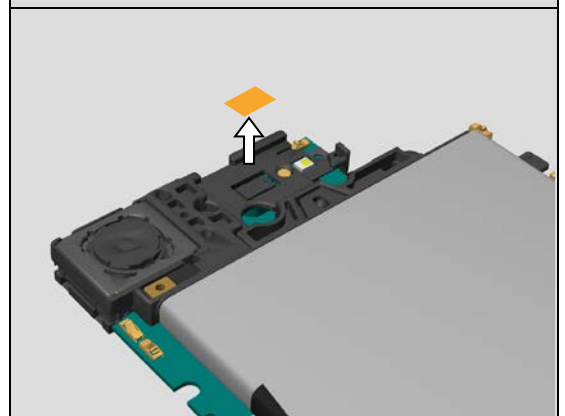
Open the FPC of FPC USB, FPC JK Module and FPC Key.



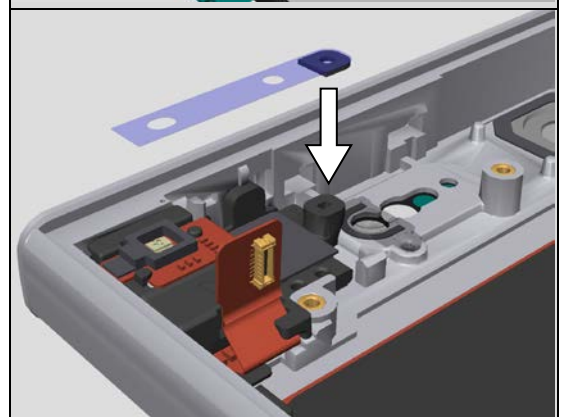
Remove the 3 pieces of the release film as right figure.



Remove the protection film of the ToF sensor.
If it is difficult to remove, paste tape on protection film.
Then remove protection film with tape.

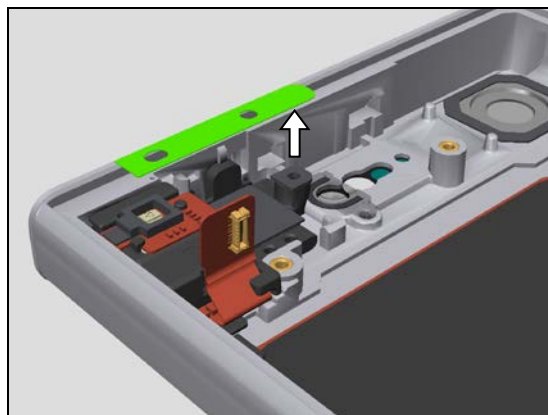


Paste the Adhesive PWB Mic to Holder Mic 2nd as direction of right figure.

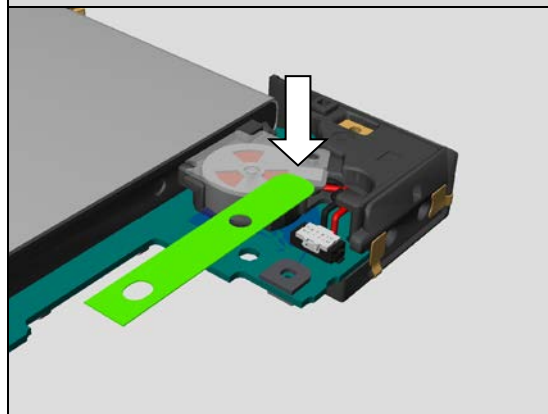


Reassembly

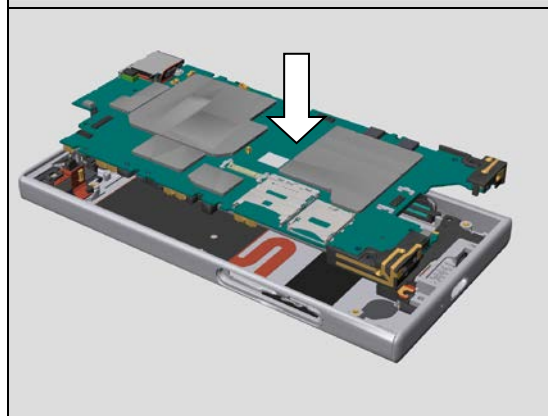
Remove the release film of the Adhesive PWB Mic.



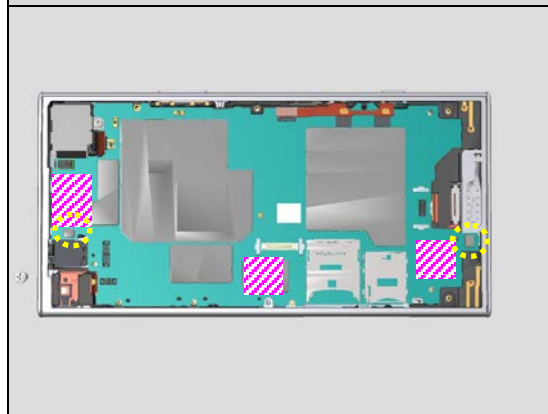
Remove the release film of the Adhesive PWB Mic.



Install the PBA Assy.



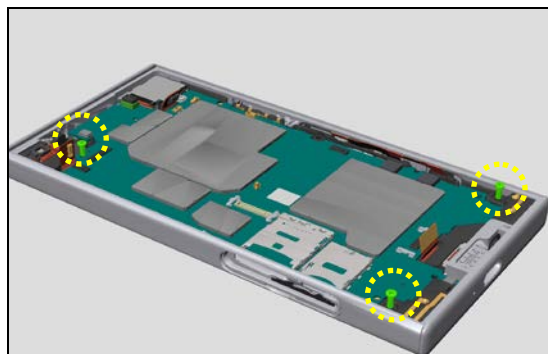
Press the 3 places hatched area of right figure and 2 places of the Mic (yellow circle).



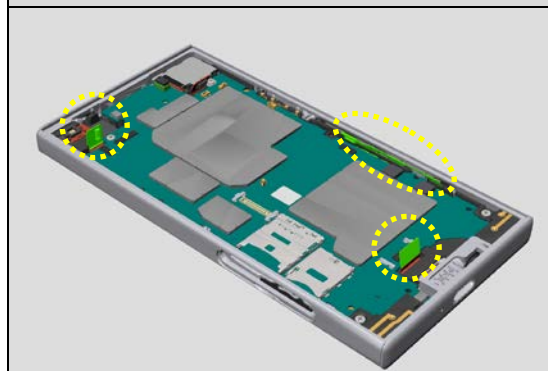
Reassembly

Tighten Screw M1.4x3.4 by using a screwdriver with Bit (JCIS No 0).

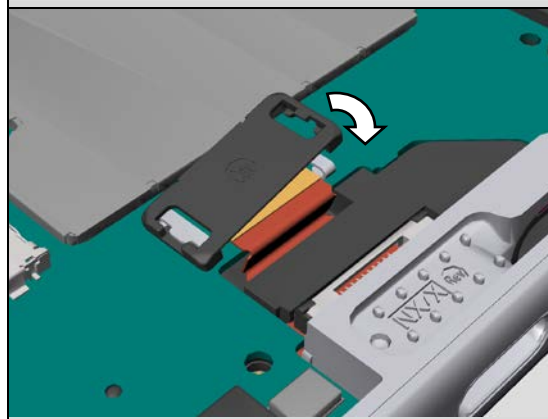
Torque : 8 Ncm



Connect the BtoB connector of the FPC JK Module, FPC Key and FPC USB.



Install the Holder USB BtoB.



5.19 Sub Camera

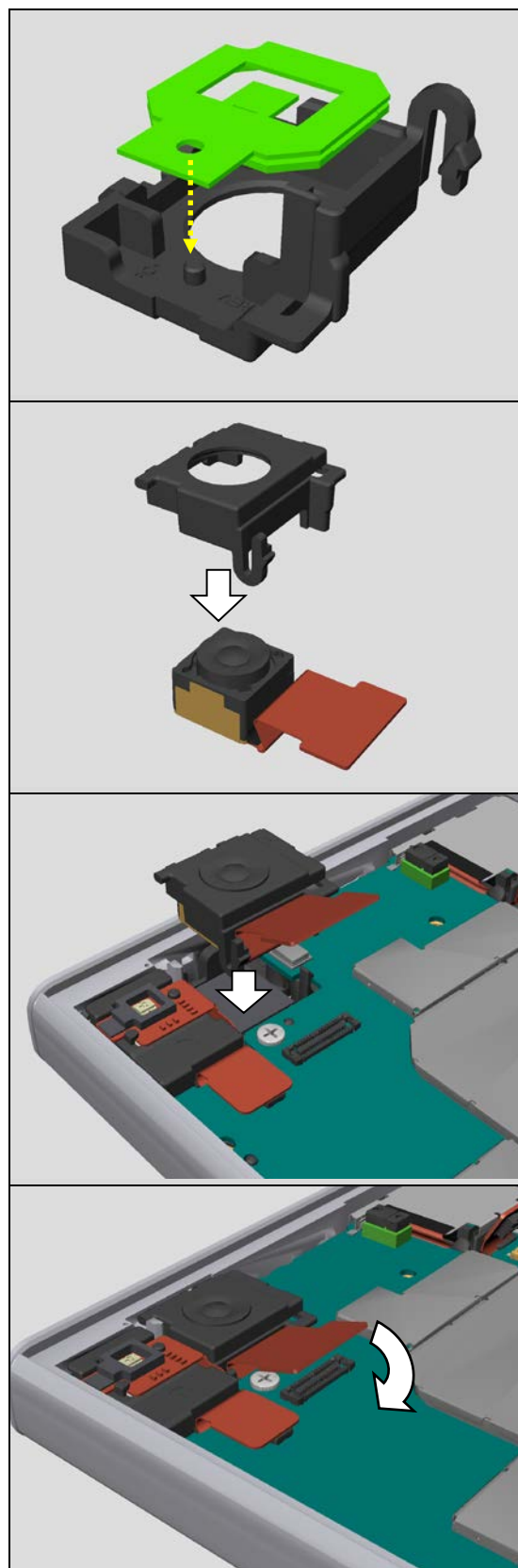
Paste the Cushion Front Camera Inner.

Then remove the release film of the Cushion Front Camera Inner.

Install the Holder Front Camera.

Install the Sub Camera with Holder Front Camera.

Connect a BtoB connector of the Sub Camera.



5.20 Plate Display

5.20.1 Paste graphite sheets

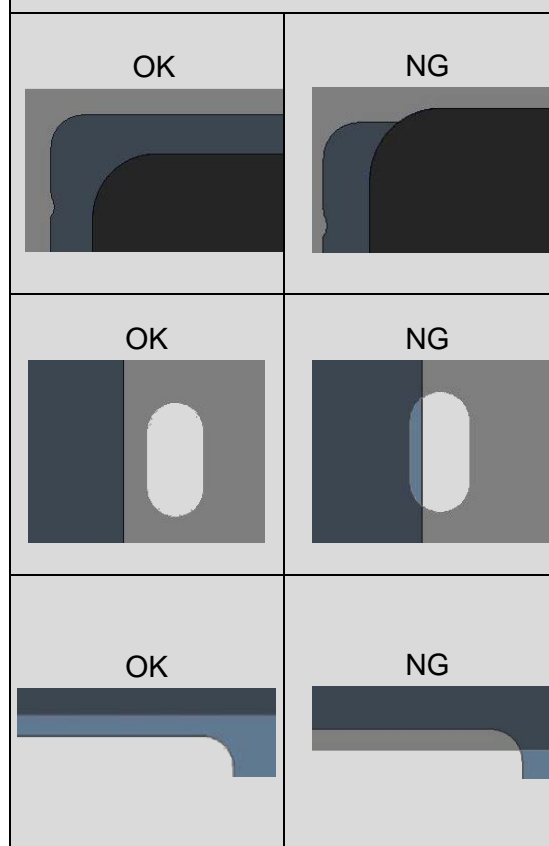
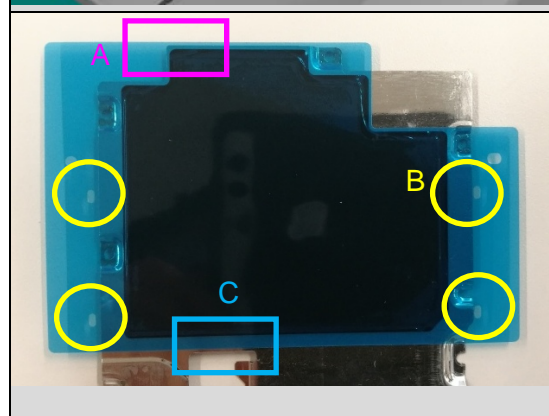
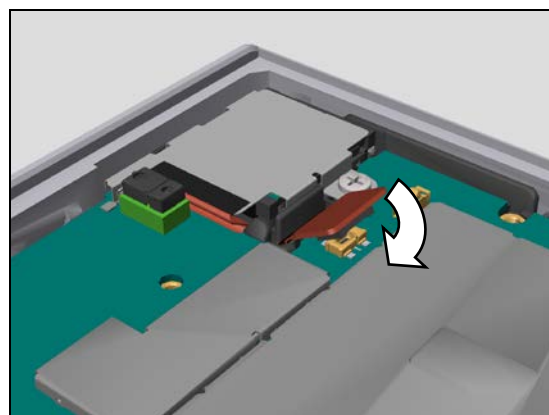
Connect a BtoB connector of the Main Camera.

Paste the Graphite Plate Display along following position.

A)
Graphite Plate Display shall not stick out from the outline of the Plate Display.

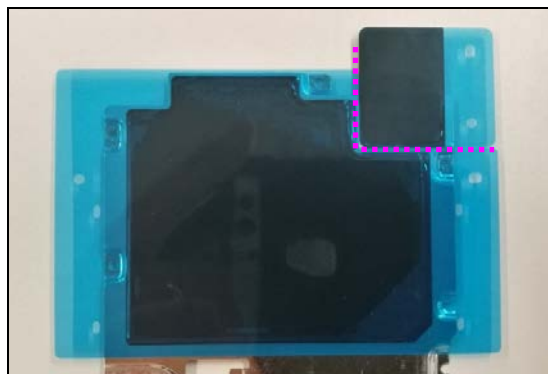
B)
4 holes must not overlap with the Plate Display.

C)
Release film must not be overlap from the outline of the Plate Display.

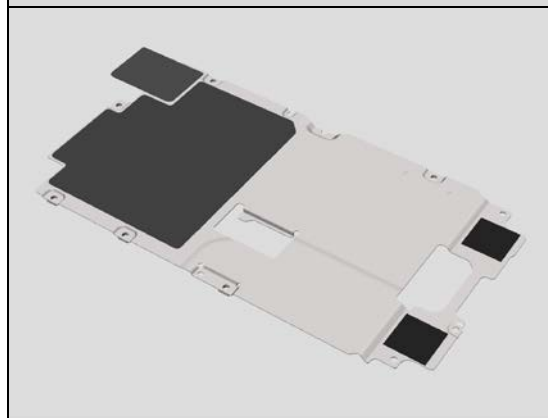


Reassembly

Paste the Graphite Camera along red dotted line as right figure.



Remove 2 pieces of the release film from the graphite sheet.



Reassembly

5.20.2 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 stamped at the Thermal Gap Filler Tube end.

Life is 6 month after manufacturing.

X: Manufacturing Year (201X)

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

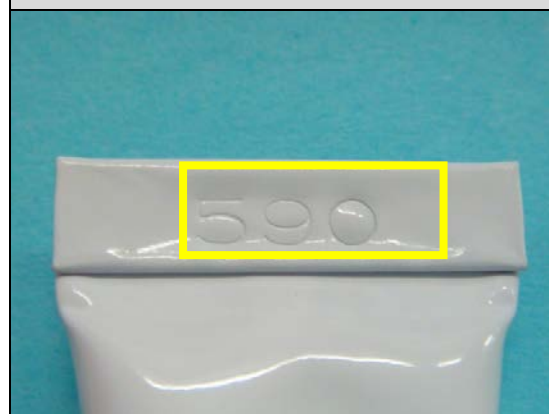
Z: Manufacturing Date (1,2,,,9, A, B,,,V)

Ex) Lot.590 = Manufacturing date is September 24th, 2015.

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.



24h



Reassembly

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

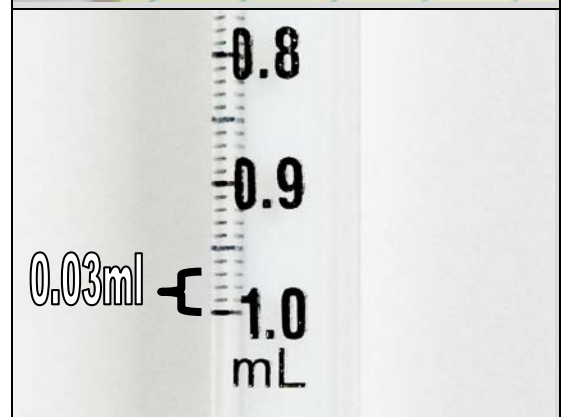
Once filled in the syringe, must use within 1 hour.

Scrap! Thermal Gap Filler Syringe cannot be used 1 hour 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 0.02 ml.



Reassembly

Carefully apply the Thermal Gap Filler on the PBA shield lid (at the center of the red circle area) as right figure.

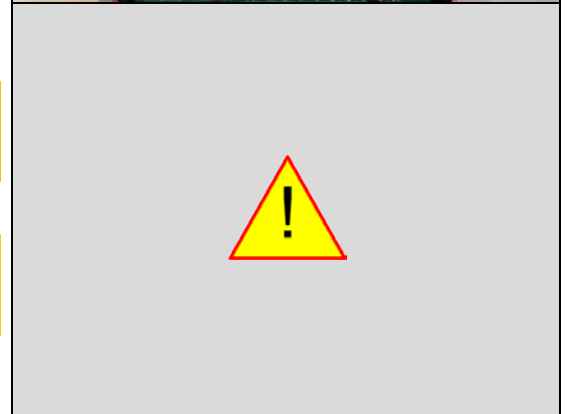
Note! Installing of the Plate Display must be done immediately after applied Thermal Gap Filler (within 5 minutes).

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.

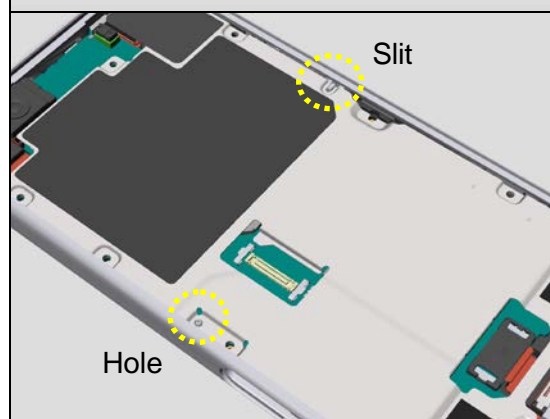
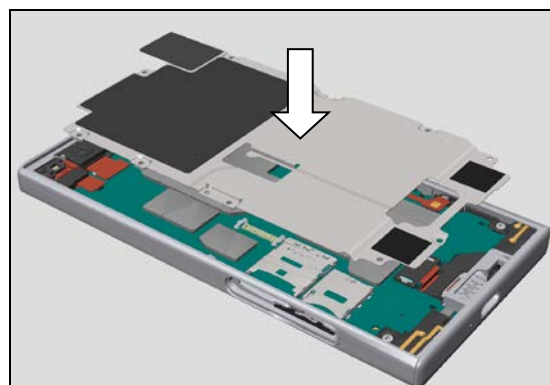
Next time you use, let a small amount of contents flow out and wipe off the tip again.



Reassembly

5.20.3 Assemble Plate Display

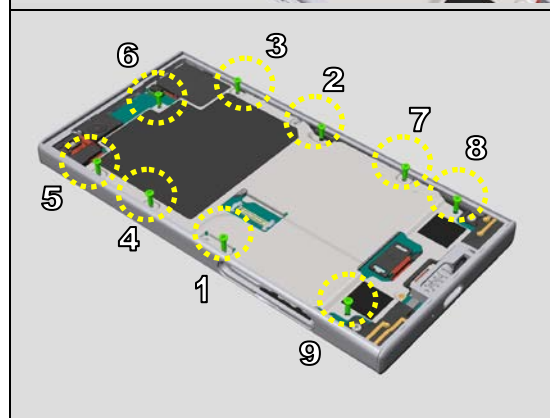
Put the Plate Display on the unit along positioning structure (hole and slit of the Plate Display) as following figure.



Tighten 9 pieces of the Screw M1.4x4.0 by using a screwdriver with Bit. (JCIS No 0).

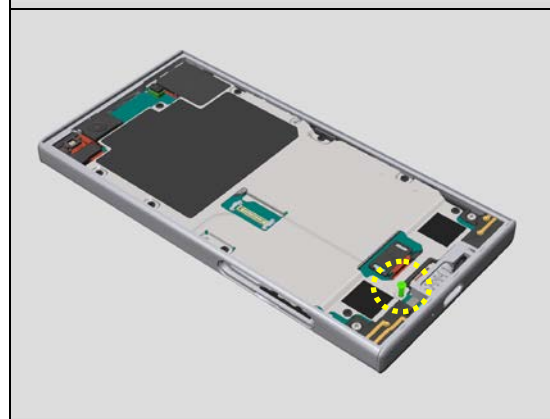
Torque : 8 Ncm

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



Tighten a Screw M1.4x3.8 by using a screwdriver with Bit. (JCIS No 0).

Torque : 10 Ncm



5.21 Net Speaker Top & Loudspeaker

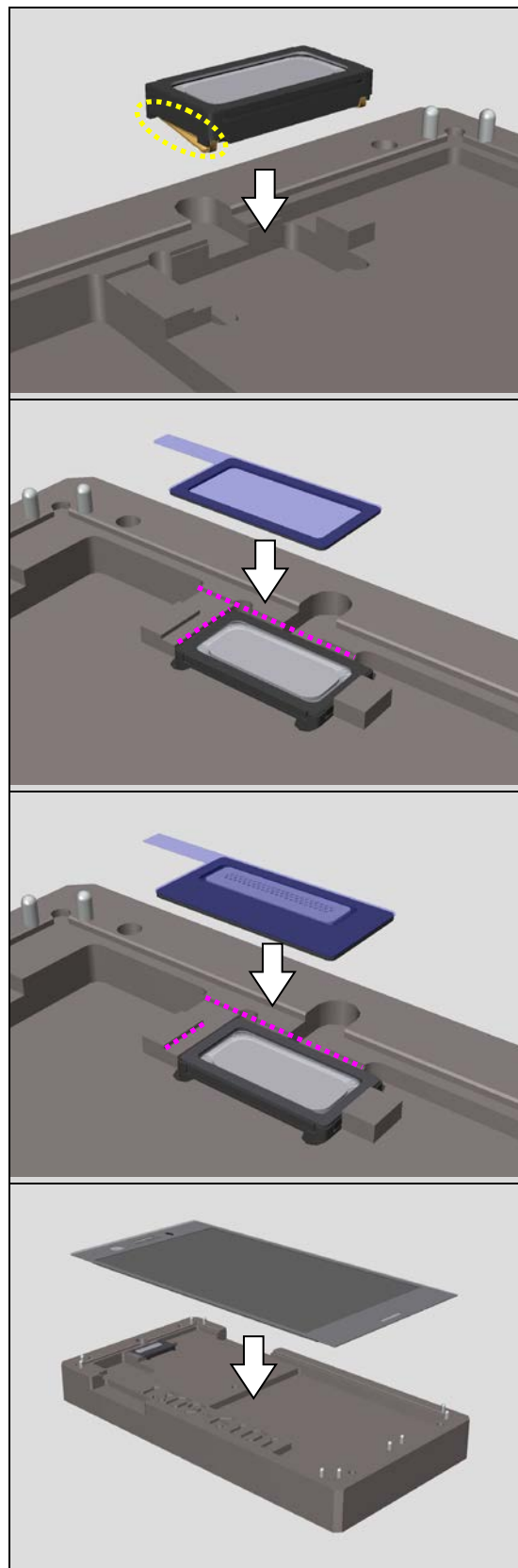
Set the Loudspeaker on the Fixture Display Component.

Note! Make sure direction of the Loudspeaker as yellow dotted circle.

Paste the Adhesive WR Receiver on the Loudspeaker along red dotted lines.

Paste the Net Speaker Top on the Adhesive WR Receiver along red dotted lines.

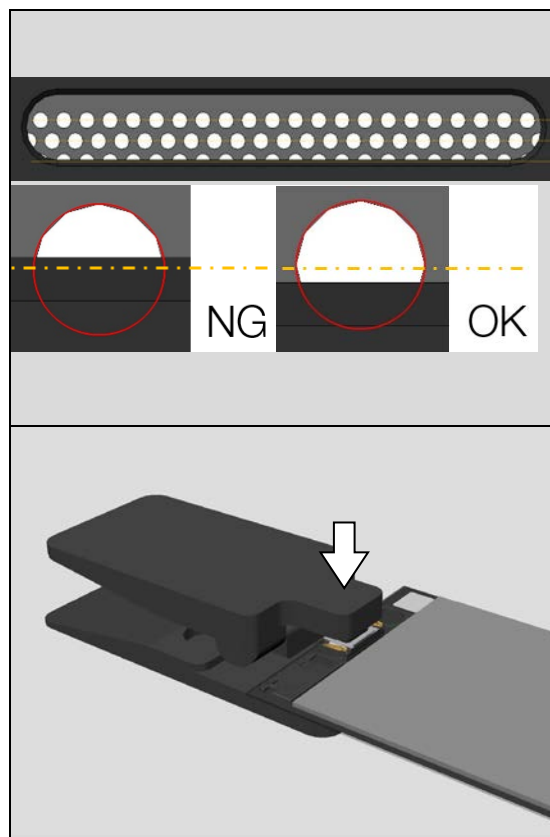
Put the Display on the Fixture Display Component.
Then paste the Adhesive WR Receiver to the Display.



Reassembly

Make sure the position of the Net Speaker Top as right figure.

If misalignment is found, replace the Net Speaker Top.



Press the Loudspeaker area by Earspeaker/Loudspeaker Top Press Tool.

Press Time : 5 sec

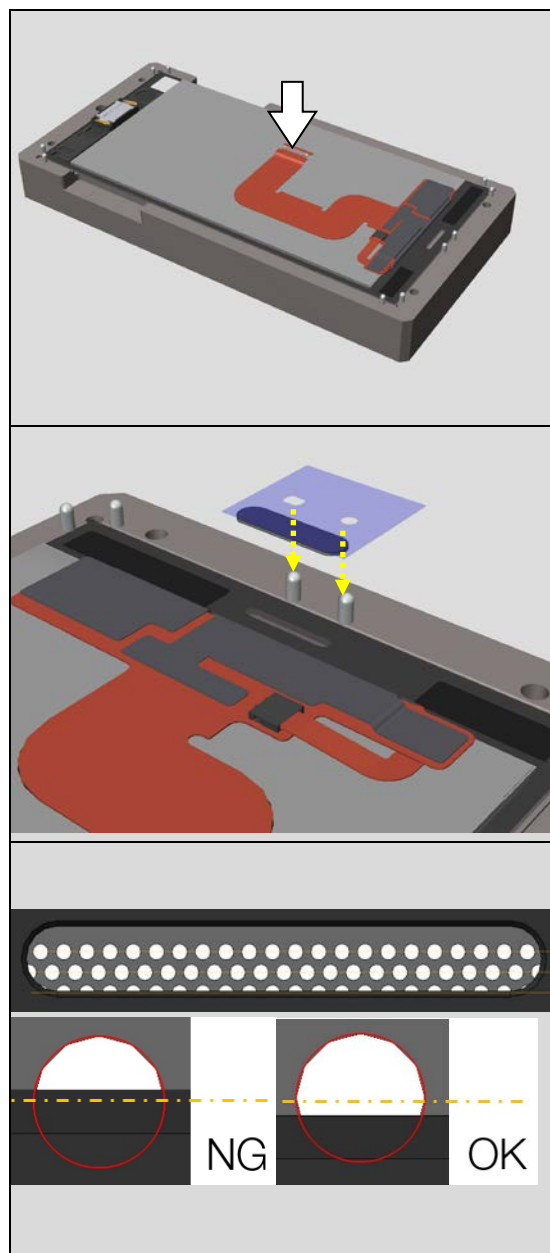
5.22 Net Speaker Bottom

Set the Display on the Fixture Display Component.

Paste the Net Speaker Top on the Fixture Display Component by hand along 2 pins of the Fixture Display Component.

Make sure the position of the Net Speaker Top as right figure.

If misalignment is found, replace the Net Speaker Top.



Reassembly

5.23 Display

Wipe the rim of the Cover Main clean.

Note! Do not use isopropyl alcohol for cleaning.

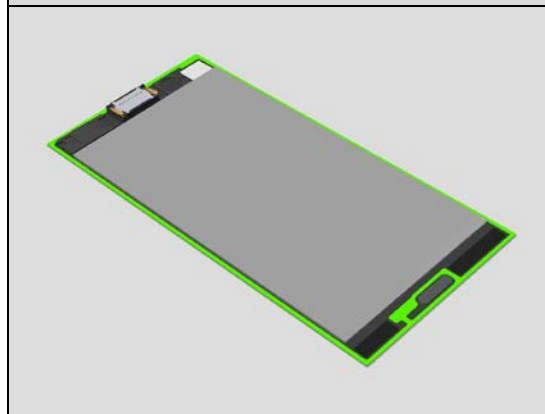
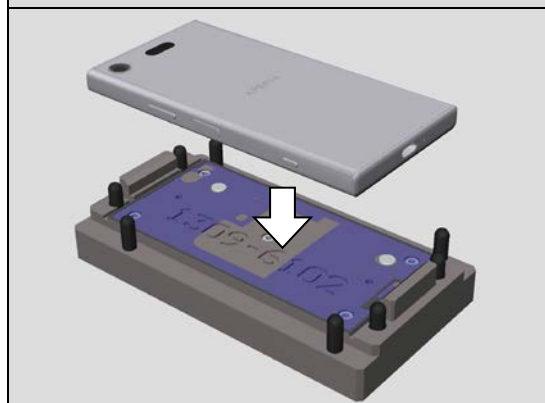
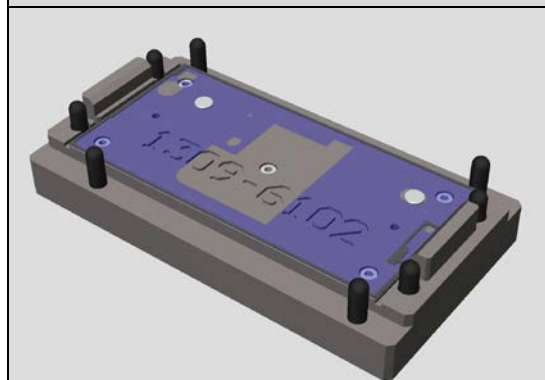
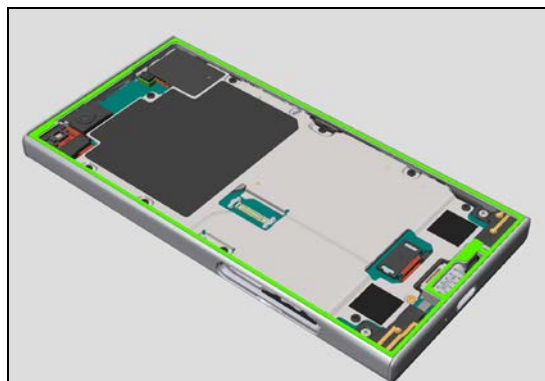
Set the Adhesive WR Window Display on the Fixture Display Adhesive.

Paste the Cover Main on the Adhesive WR Display.

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

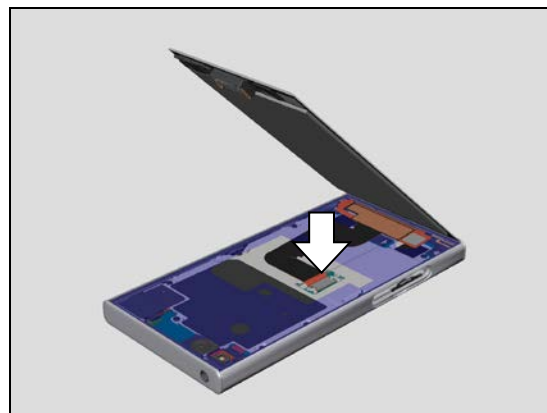
Wipe the rim of the Display clean.

Note! Do not use isopropyl alcohol for cleaning.

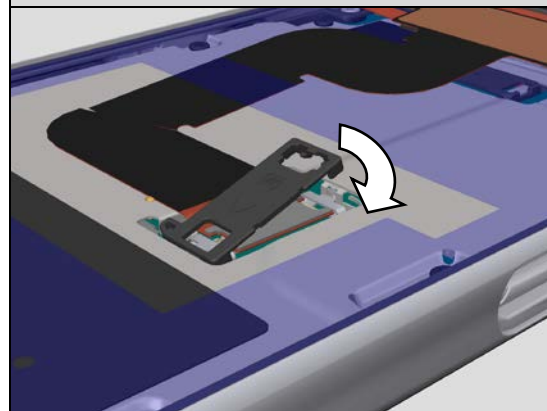


Reassembly

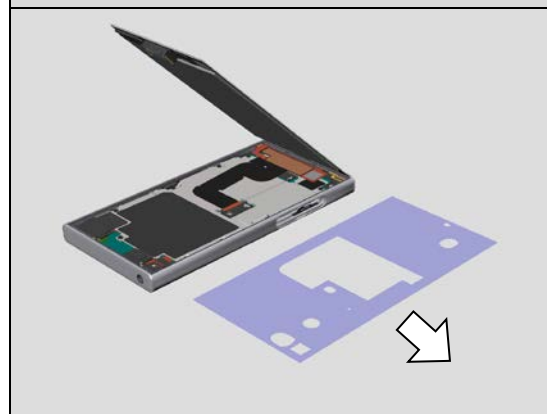
Connect the BtoB connector of the Display to the unit.



Install the Holder LCD BtoB as right figure.



Remove the release film of the Adhesive WR Window Display.



Paste the Display to the unit.



5.24 Tray nano SIM

Install the Tray nano SIM to the unit.

Note! Install the Tray nano SIM to keep rear side of the unit up. Otherwise, SIM card will be fallen down.



5.25 Cap Tray Assy

Install the Cap Tray Assy.

Note! Install the Cap Tray Assy to keep rear side of the unit up. Otherwise, micro SD card will be fallen down.



5.26 Press Display

Paste Sheet Bottom Press Inlay to Bottom Press Inlay.

This Bottom Press Inlay (before pasting Sheet Bottom Press Inlay) is common with F5321.

Bottom Press Inlay after pasting Sheet Bottom Inlay can be used for F5321 as usual.

Set the unit on the Bottom Press Inlay.

Note! Make sure assembled the Cap Tray Assy before setting.

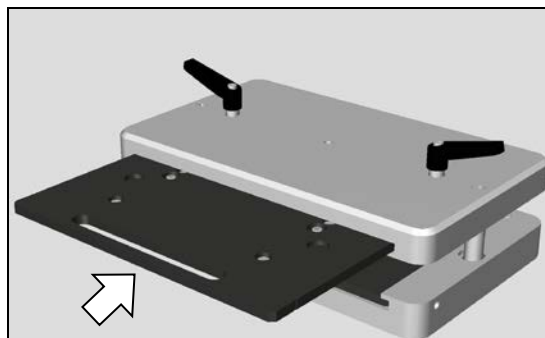
Note! Make sure direction of unit before pressing.

Insert the Bottom Press Inlay into the lower side of the Generic Fixture for Press tool.

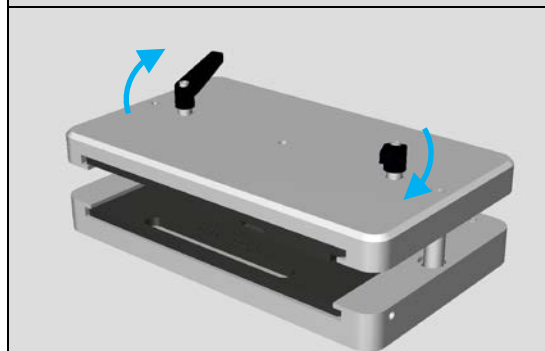


Reassembly

Insert the Rear Cover Press Top Inlay into the upper side of the Generic Fixture for Press tool.



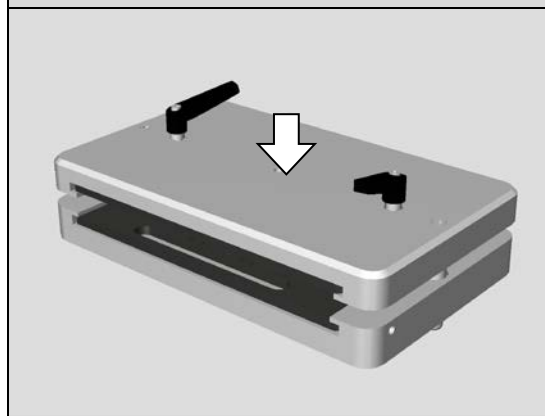
Fix the Rear Cover Press Top Inlay.



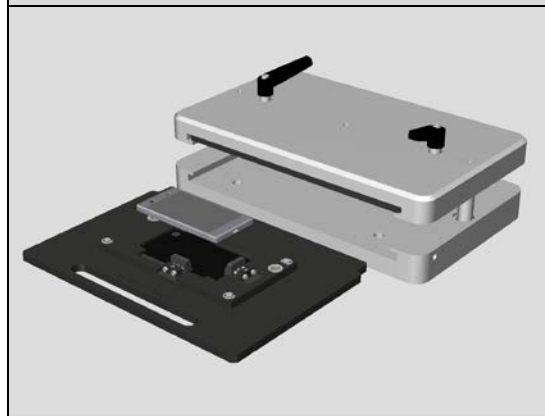
Press the unit twice.

1st press : 650N, 10 sec

2nd press : 500N, 10 sec



Take out the unit.

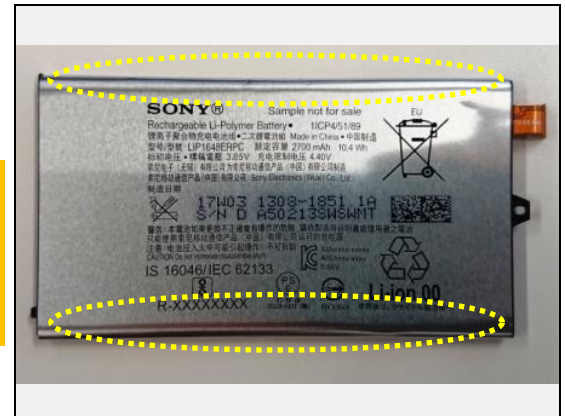


6 Battery Reuse Instruction

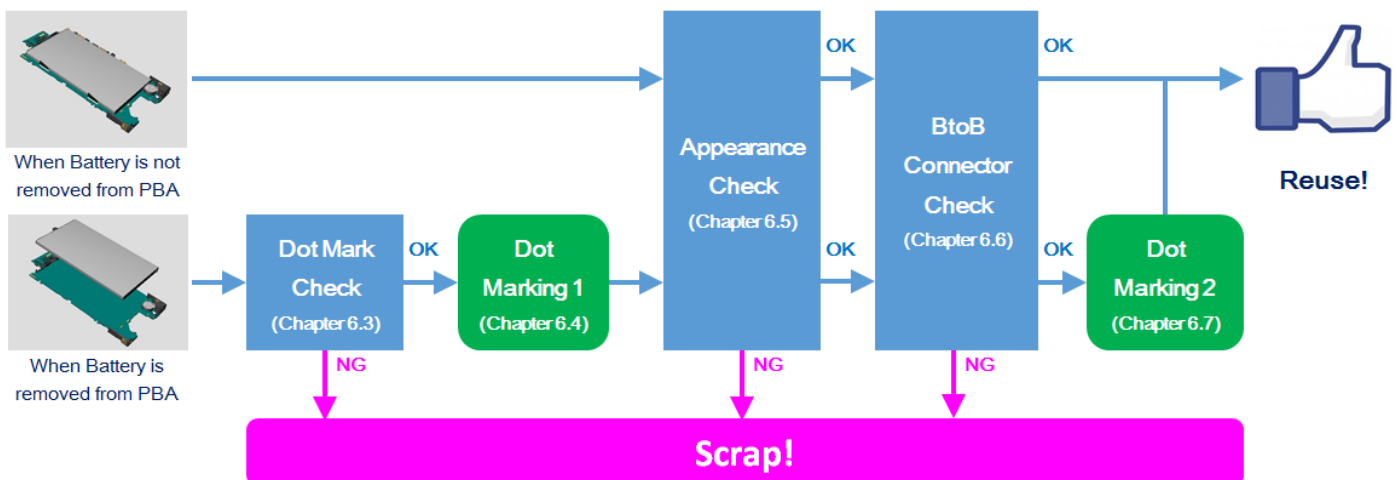
**If you intend to reuse the Battery, carefully follow the Battery Reuse Instruction.
If it is failed, don't reuse the Battery, and scrap it.**

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 Flow to Battery Reuse



Battery Reuse Instruction

6.3 Dot Mark Check

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

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

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

Can be reused



Can't be reused → Scrap



6.4 Dot Marking 1

Put the black dot mark with permanent pen after removing the Battery from the PBA.

When the battery is not removed from the PBA, black dot mark is not needed.



6.5 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 ≤ 5mm	1 wrinkle per Al sheet
Mark	No mark is allowed.	
Bubble	Diameter ≤ Φ2mm	3 bubble per Al sheet
Dent	Diameter ≤ Φ2mm	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.	

Battery Reuse Instruction

Definition of Damages and Sample Picture

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.



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.



Battery Reuse Instruction

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.



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.



Battery Reuse Instruction

6.6 BtoB Connector Check

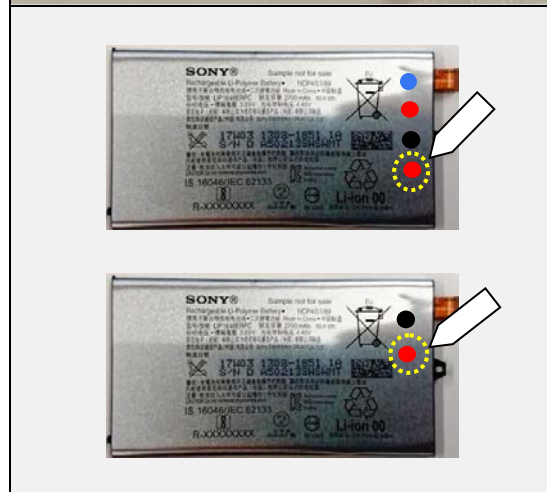
Check if BtoB connector has damages.

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



6.7 Dot Marking 2

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





Working Instruction Repair Instruction Mechanical/

7 Revision History

Rev.	Date	Changes / Comments
1	2017-Sep-15	Initial release