



Working Instruction, Mechanical

Applicable for K810 and K818

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1 Introduction

1.1 K810



1.2 Equipment

SPECIAL TOOLS

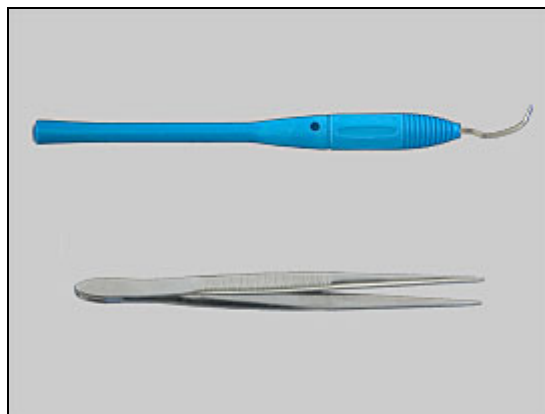
- NTZ 122 459 Torque screwdriver (or equivalent)
- NTZ 122 288 Torx bit no. 6
- NTZ 112 1052 JCIS bit
- NTZ 112 302/2 Front opening tool
- NTZ 122 521 Flex film assembly tool
- LSY 901 55 VGA Camera Removal Tool
- NTZ 112 590 Guitar pick



STANDARD TOOLS

Standard tools have to be locally purchased

- Dentist hook
- ESD tweezers



LABEL EQUIPMENT

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

- Hot air flow solder station
- Zebra printer connected to computer



OTHER EQUIPMENT

- ESD-wristband
- ESD-gloves
- Isopropyl alcohol
- Air blower



1.3 General cautions

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

- **TURN OFF THE PHONE AND REMOVE THE SIM CARD AND THE MEMORY CARD BEFORE STARTING THE DISASSEMBLY!**
- **KEEP ALL CONTACT SURFACES CLEAN!**
- **BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, OPENING TOOLS, GUITAR PICK ETC. TO AVOID SCRATCHES OR DAMAGES TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!**
- **BE CAREFUL NOT TO DAMAGE ANY CONTACT SPRINGS!**
- **REMEMBER TO REMOVE THE PROTECTION FOILS ON NEW PARTS SUCH AS THE LCD!**
- **NEVER TOUCH THE DISPLAY GLASS!**
- **USE AIR BLOW EQUIPMENT TO KEEP THE FRONT WINDOW AND DISPLAY MODULE DUST FREE!**

1.4 Discharge Camera Flash before Disassembly

Before performing any disassembly, discharge the camera flash by performing the following steps.

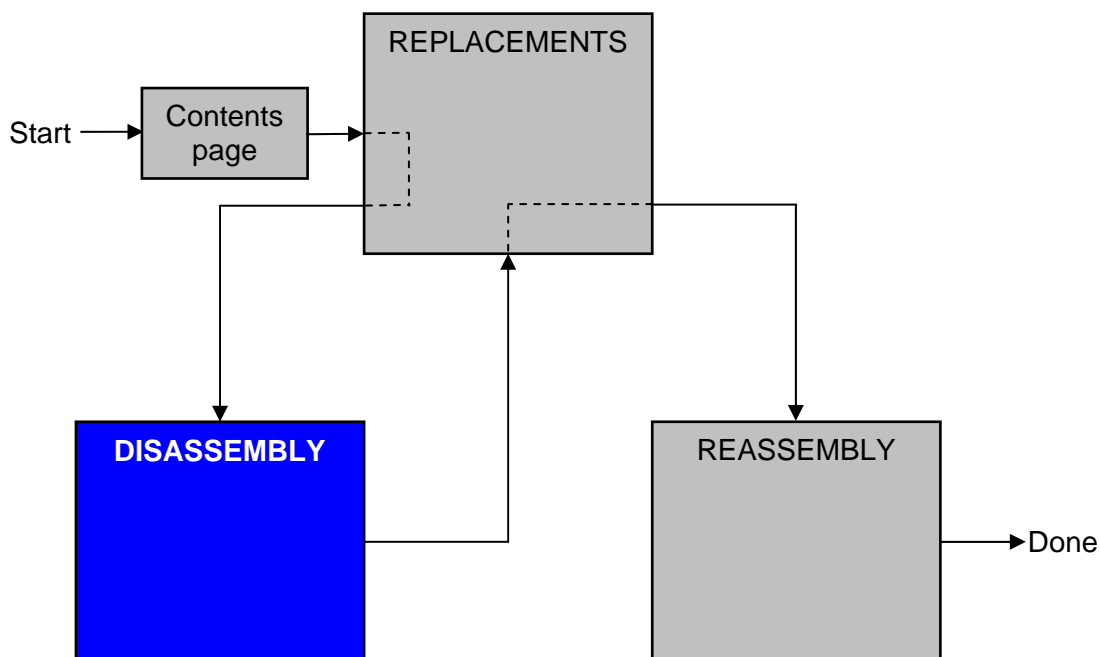
- 1) Close the lens cover
- 2) Install a battery
- 3) Power the phone on and go to the Service Test Menu
- 4) Select the "Discharge Flash" option
- 5) Wait several seconds until the strobe light flashes
- 6) Power the phone down

If it is not possible to access the Service Test Menu, leave the unit without battery for 30 minutes and the camera flash will be discharged.

NOTE! The phone may still contain residual voltage that can discharge through skin contact, but it is not enough to cause injury. This discharge may be avoided by wearing rubber glover.

2 Disassembly

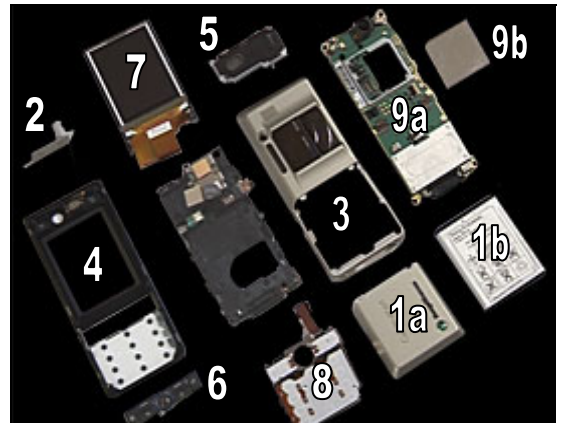
When you are going to replace a part being listed in *Replacements*, the instruction of that section usually begins by directing you to this *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before returning to *Replacements*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



2.1 Overview

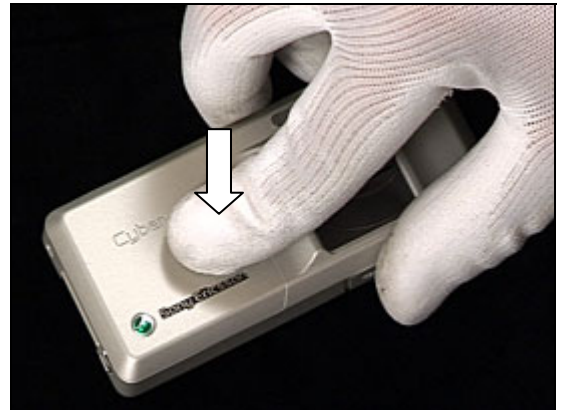
The disassembly is done in the following order:

1. Battery Lid Assembly (a) & Battery (b)
2. MS Cover
3. Antenna Cover Assembly
4. Front
5. Antenna/Speaker Box Assembly
6. Function Keyboard Assy
7. LCD
8. Key Foil Complete
9. PCB (a) & Shield Can Lid, Camera Assy (b)



2.1.1 Battery Lid Assembly & Battery

Release the Battery Cover.



Slide the battery cover from the phone.



Remove the Battery Cover.



Grab the Battery and pull it up.



Battery Lid Assembly & Battery *continued*

Remove the Battery.

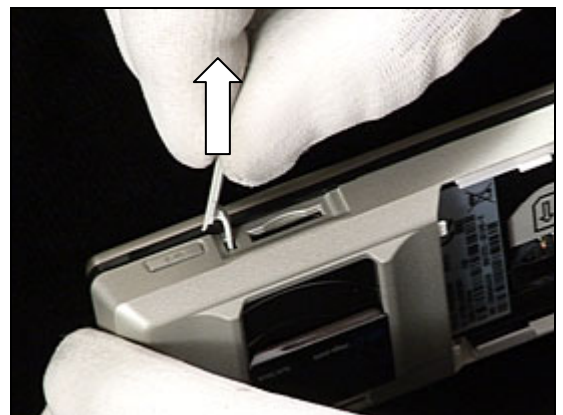
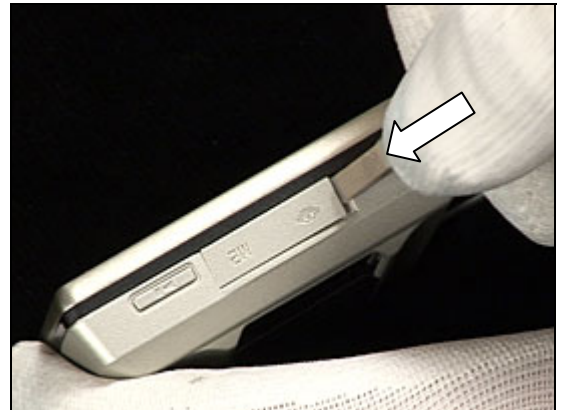


2.1.2 MS Cover

Use a front opening tool to open MS Cover

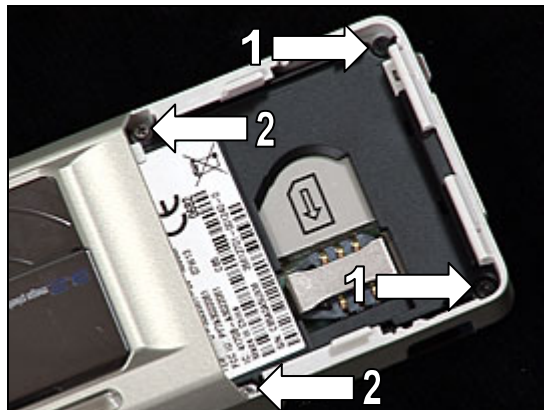
DO NOT FORGOTT TO REMOVE THE MEMORY CARD!

Remove the MS Cover by pulling out the tab that connects the cover to the phone.

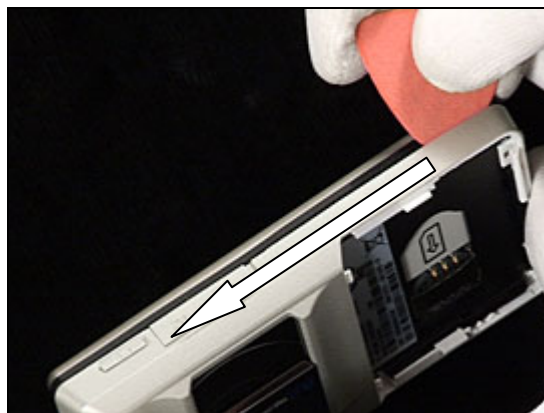


2.1.3 Antenna Cover Assembly

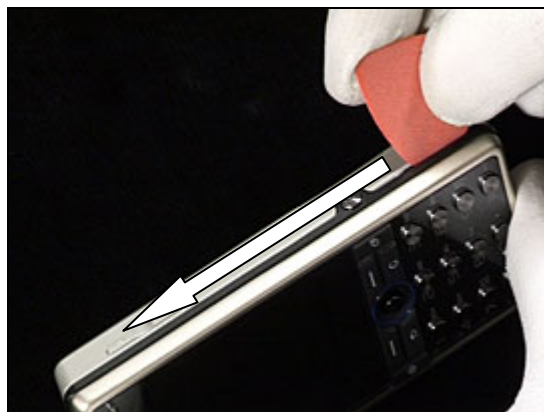
Use Torx bit no 6 to remove the two screws numbered 1.
Use JCIS to remove the two screws numbered 2.



Use a guitar pick and slide upwards and downwards to release the Front from the Antenna Cover Assembly.



Start on the opposite side and do the same thing.

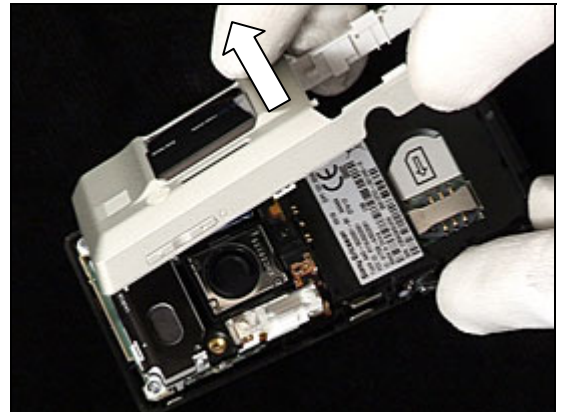


Use your fingers and wiggle the Antenna Cover Assembly upwards to release it from the Front.



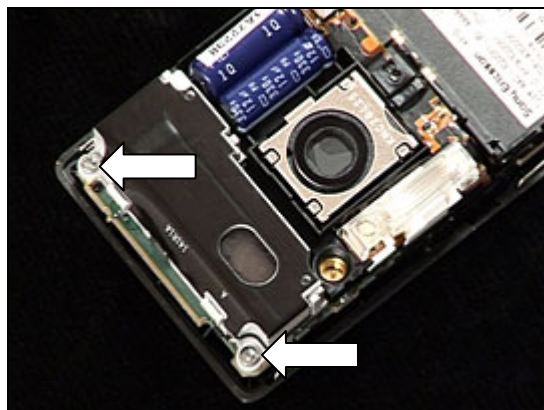
Antenna Cover Assembly *continued*

Remove the Antenna Cover Assembly.



2.1.4 Front Unit

Use Torx bit no 6 to remove the two screws.



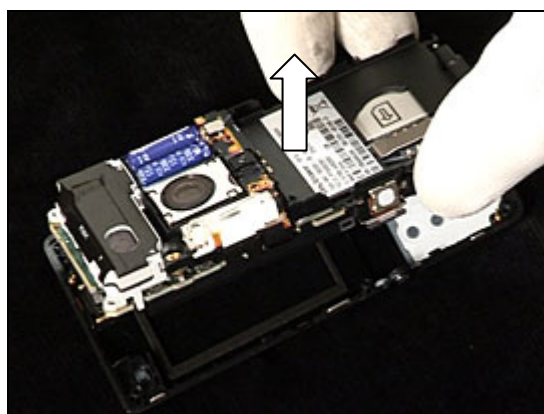
Use the front opening tool to bend and make the Front to start to become loose.



Start on the opposite side and do the same thing.

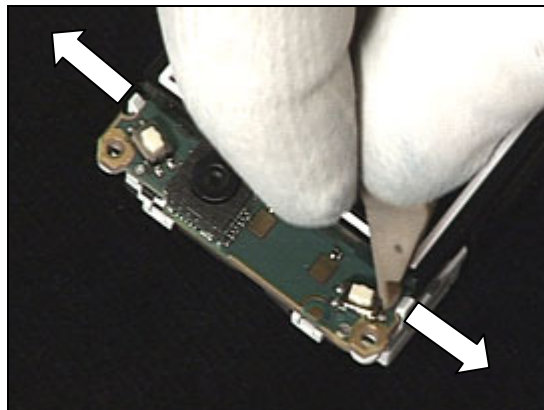


Gently remove the Core Unit from the Front.

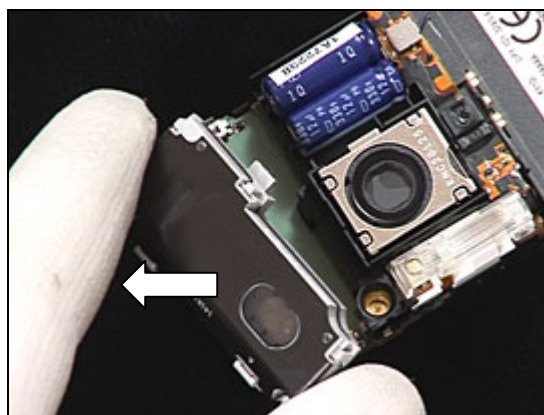


2.1.5 Antenna/Speaker Box Assembly

Use the front opening tool to release the two latches indicated from the edge of the PBA.

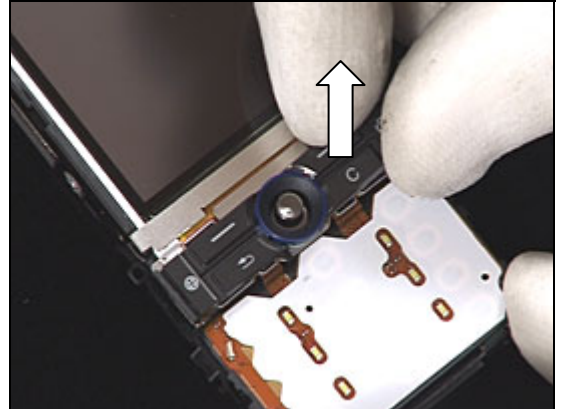


Remove the Antenna/Speaker Box Assembly



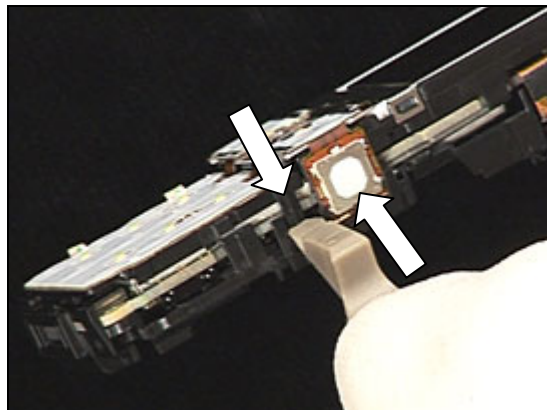
2.1.6 Function Keyboard Assembly

Remove the Function Keyboard Assembly with your fingers.

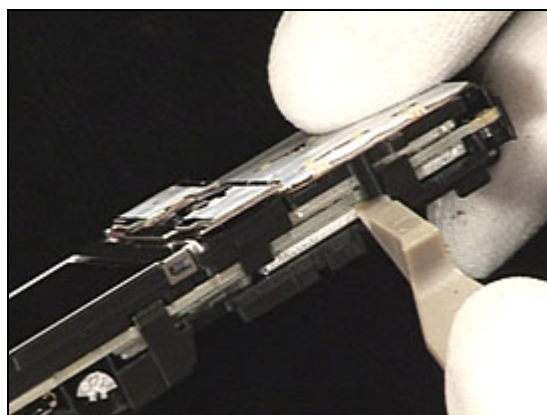


2.1.7 Key Foil Complete/LCD release

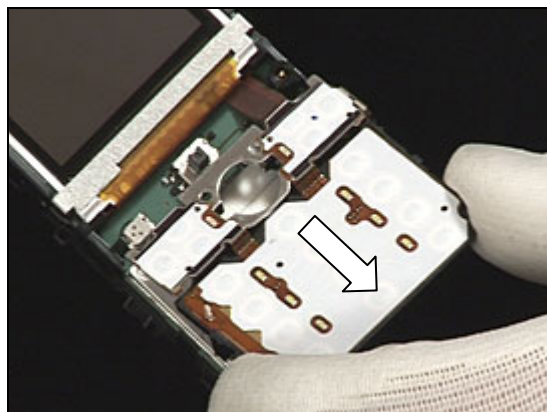
Use the front opening tool to release the two latches indicated.



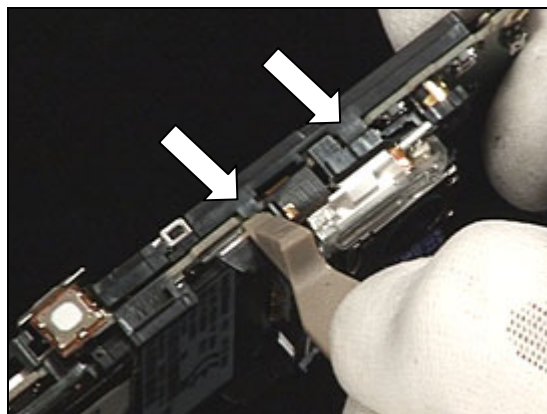
Do the same thing on the opposite side.



Position the Key Foil Complete over the system connector. Be careful not to pull on the Key Foil flex film.

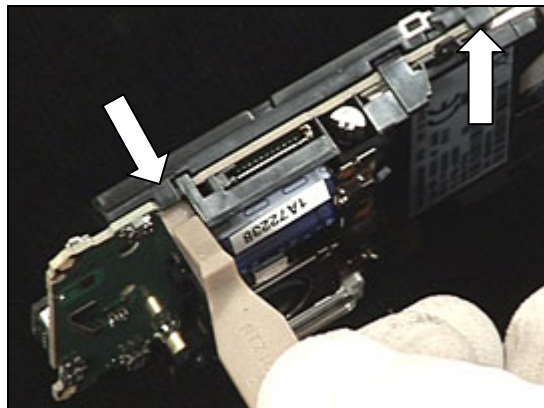


Use the front opening tool to release the two latches indicated on the LCD holder.

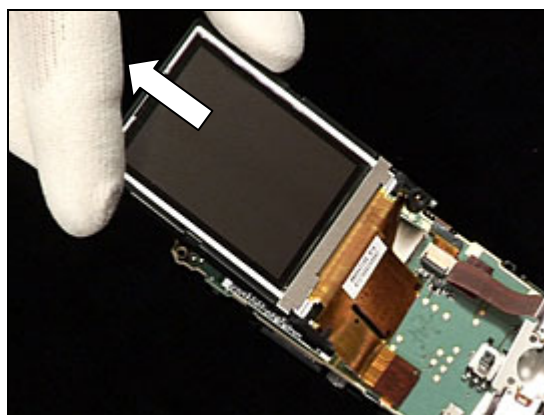


Key Foil & LCD release *continued*

Do the same thing on the opposite side.

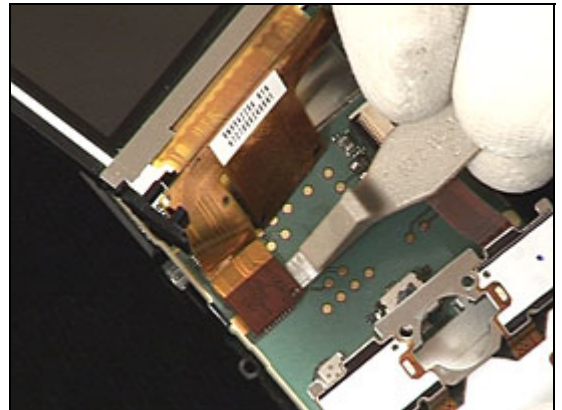


Position the LCD over the end of the phone.
Be careful not to pull on the LCD flex film.

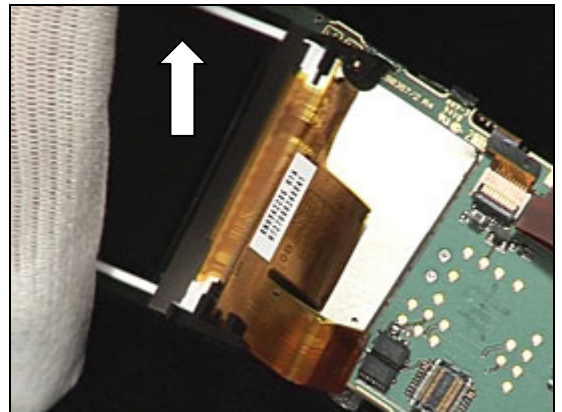


2.1.8 LCD

Use a front opening tool and pull it upwards to disconnect the LCD from the BtB connector.

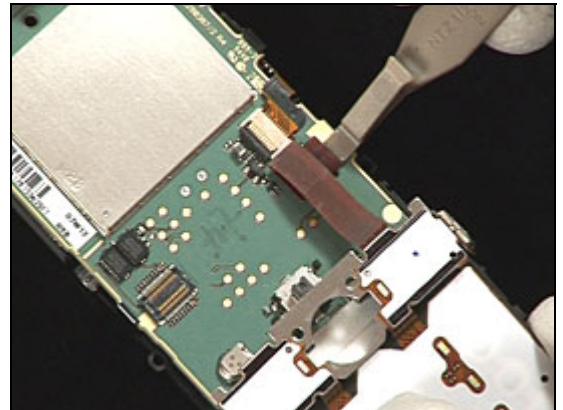


Remove the LCD from the PBA.

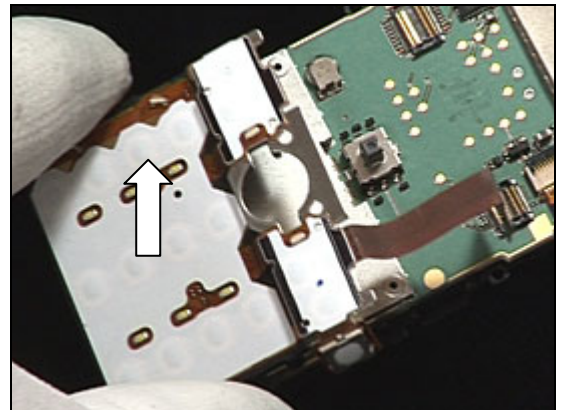


2.1.9 Key Foil Complete

Use a front opening tool and pull it upwards to disconnect the Key Foil Complete from the BtB connector.

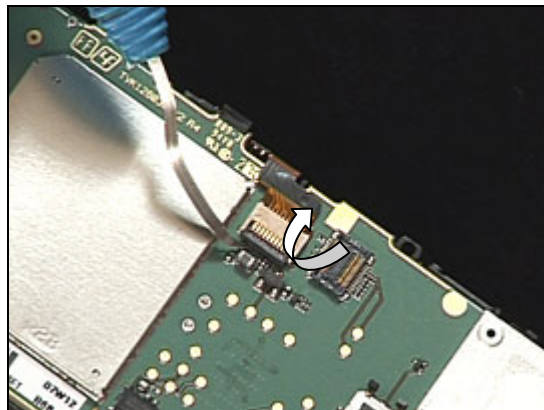


Remove the Key Foil Complete from the PBA.

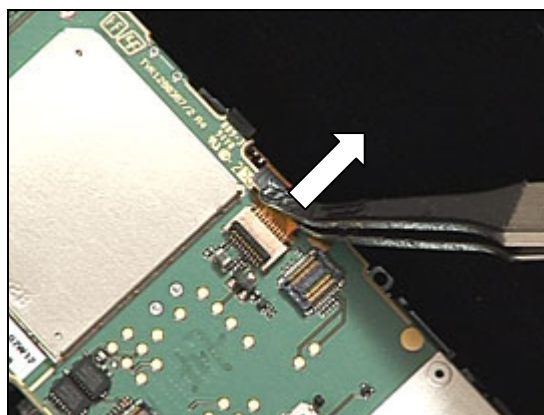


2.1.10 PCB & Shield Can Lid, Camera Assy

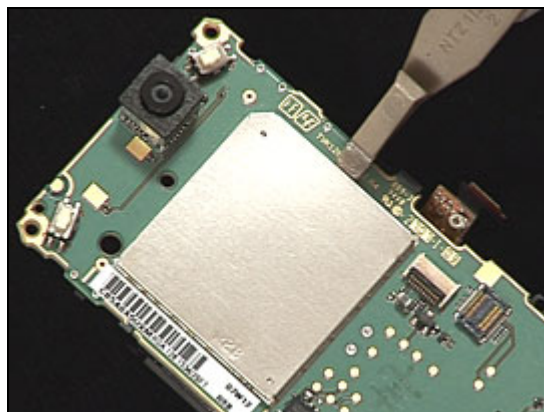
Rotate the black retaining bar of the connector toward the flex film.



Use a flex film assembly tool and pull the flex film from the connector.

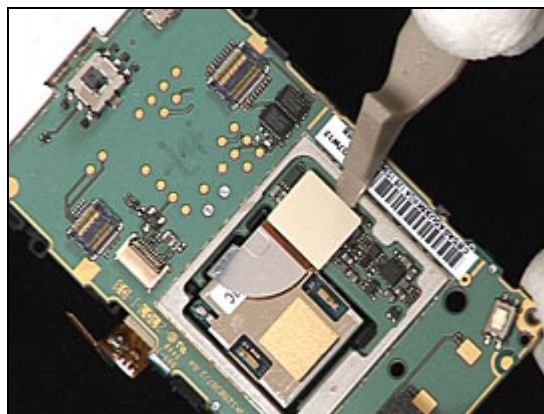


Use the front opening tool to remove the Shield Can, Camera Assembly.



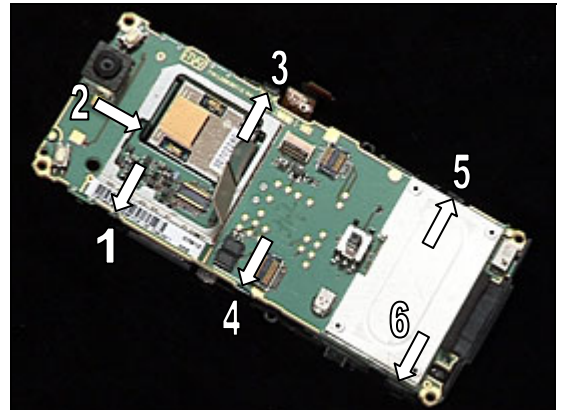
Be VERY careful when removing the Camera BtB connector or it might brake!

Use a front opening tool to disconnect the Camera from the BtB connector.

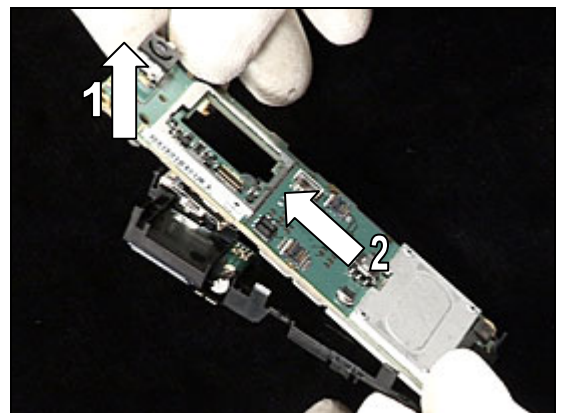


PCB with Shield Can Lid, Camera Assy *continued*

Use a front opening tool to release the six latches in the order shown from the edge of the PBA.



First lift up the PBA.
Second pull the PBA out of the Frame assy.



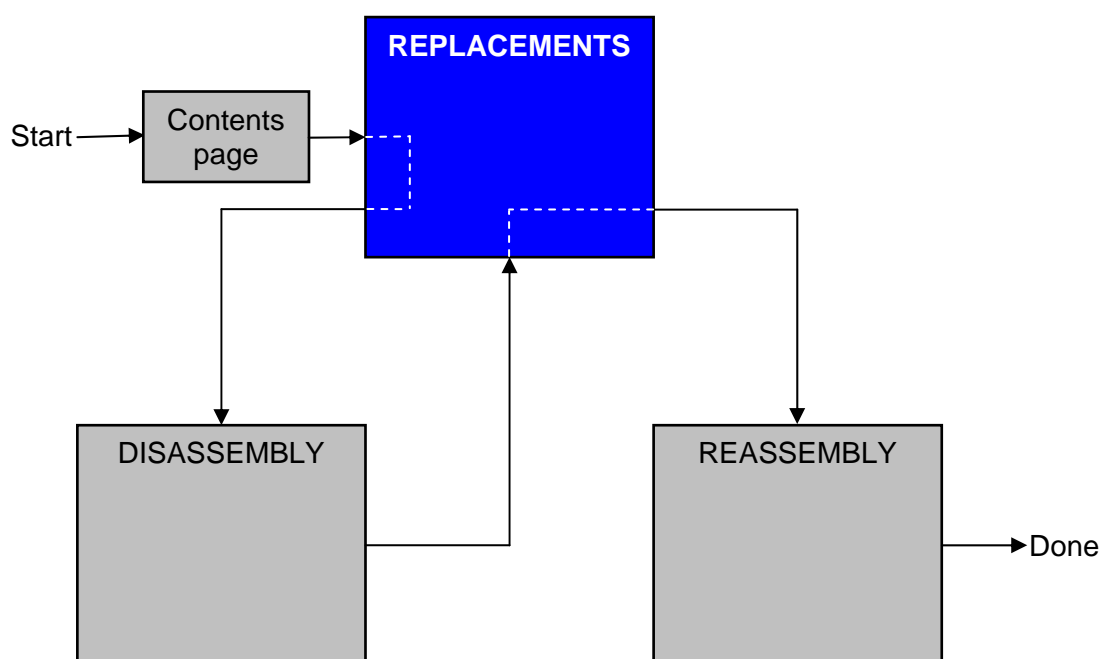
3 Replacements

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

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

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

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



3.1 Battery Lid Assembly

Follow the 2.1.1 Disassembly instructions!

Prepare the new Battery Lid Assembly.

Follow the 4.1.10 Reassembly instructions!

3.2 MS Cover

Follow the 2.1.2 Disassembly instructions!

Prepare the new MS Cover.

Follow the 4.1.9 Reassembly instructions!

3.3 Antenna Cover Assembly

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

Prepare the new Antenna Cover Assembly.

Follow the 4.1.8 – 4.1.10 Reassembly instructions!

3.4 Antenna/Speaker Box Assembly

Follow the 2.1.1 – 2.1.5 Disassembly instructions!

Prepare the new Antenna/Speaker Box Assembly.

Follow the 4.1.6 – 4.1.10 Reassembly instructions!

3.5 Function Keyboard Assy

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

Prepare the new Function Keyboard Assy.

Follow the 4.1.5 – 4.1.10 Reassembly instructions!

3.6 Key Foil Complete

Follow the 2.1.1 – 2.1.9 Disassembly instructions!

Prepare the new Key Foil Complete.

Follow the 4.1.2 – 4.1.10 Reassembly instructions!

3.7 Shield Can Lid, Camera Assy

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

Prepare the new Shield Can Lid, Camera Assy.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!

3.8 Frame Assembly

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

Remove the Camera as described in 3.12

Remove the Vibrator as described in 3.13

Remove the Xenon Flash as described in 3.19

Prepare the new Frame Assembly.

Install the old Camera as described in 3.12

Install the old Vibrator as described in 3.13

Install the old Xenon Flash as described in 3.19

Install a new KRH Label as described in 3.33

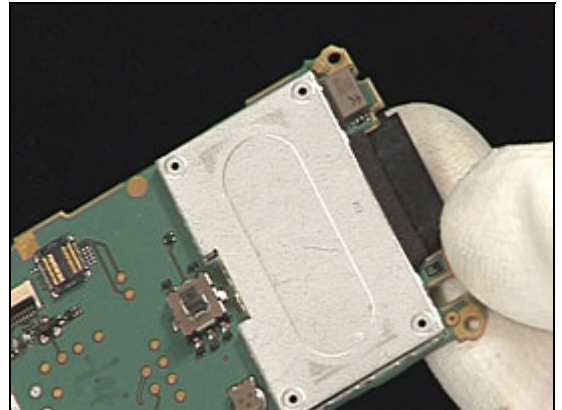
Follow the 4.1.1 – 4.1.10 Reassembly instructions!

3.9 System Connector

REMOVAL

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

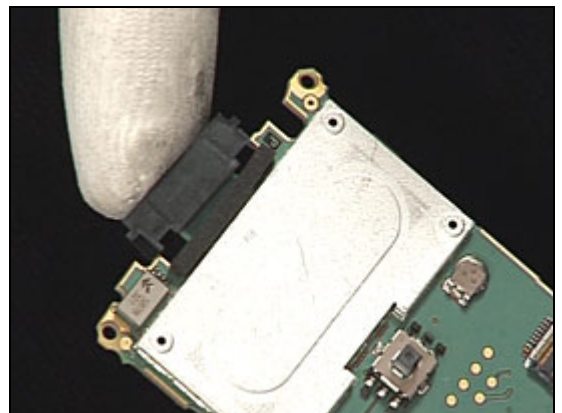
Use your fingers to remove the System Connector.



INSTALLATION

Use your fingers to position the System Connector.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!



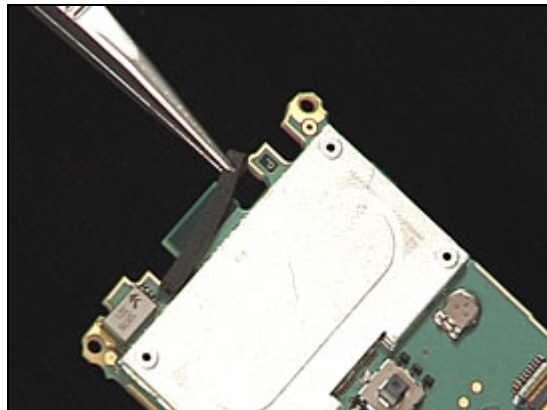
3.10 Dust Gasket for System Connector

REMOVAL

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

Follow the 3.8 Removal instructions!

Use tweezers to remove the Dust Gasket, System Connector.

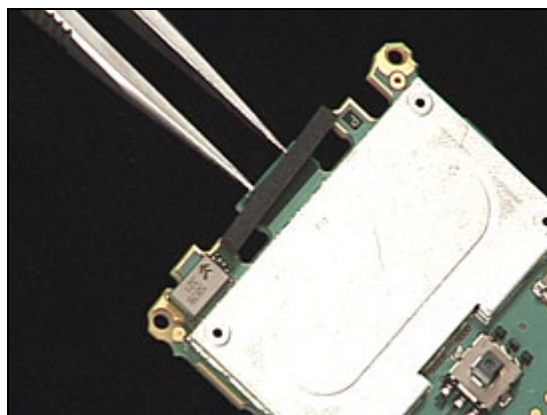


INSTALLATION

Use tweezers to position the Dust Gasket, System Connector.

Follow the 3.8 Installation instructions!

Follow the 4.1.1 – 4.1.10 Reassembly instructions!

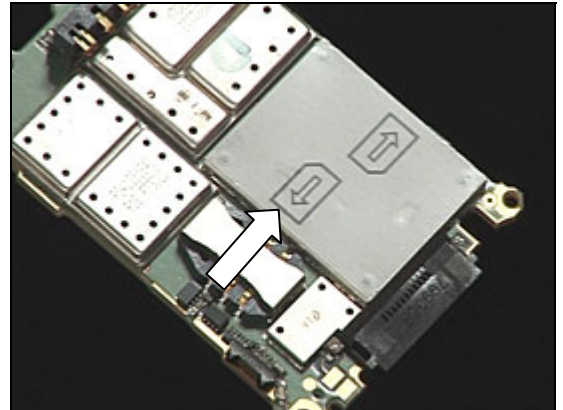


3.11 Insulation Label

REMOVAL

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

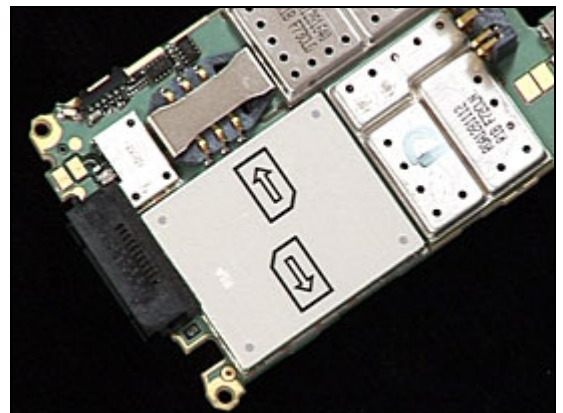
Use tweezers to remove the Insulation label.



INSTALLATION

Use tweezers to position the Insulation label.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!

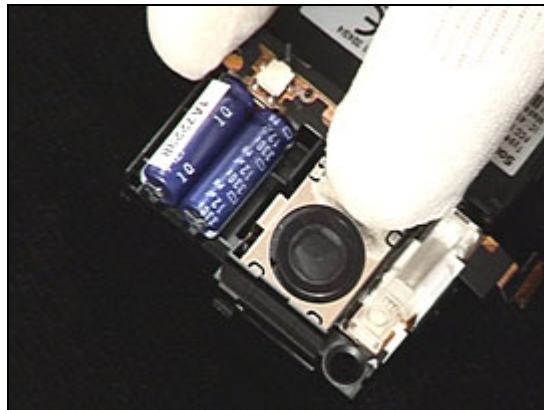


3.12 Camera

REMOVAL

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

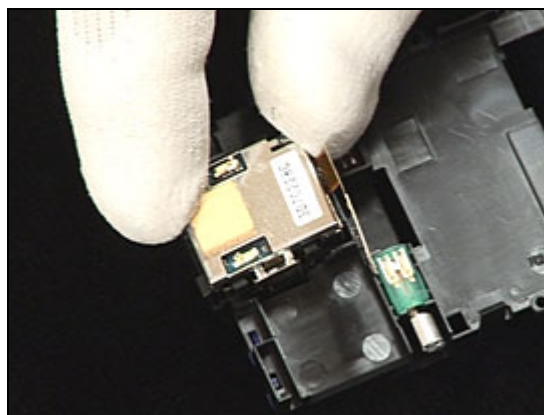
Push on the lens side of the camera so that the Camera falls out of its cavity in the Frame assy.



INSTALLATION

Use your fingers to position the Camera.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!

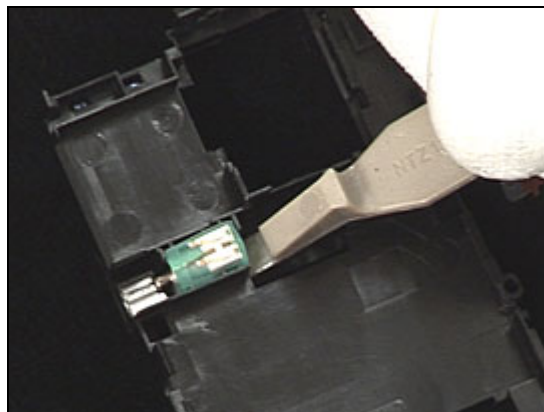


3.13 Vibrator

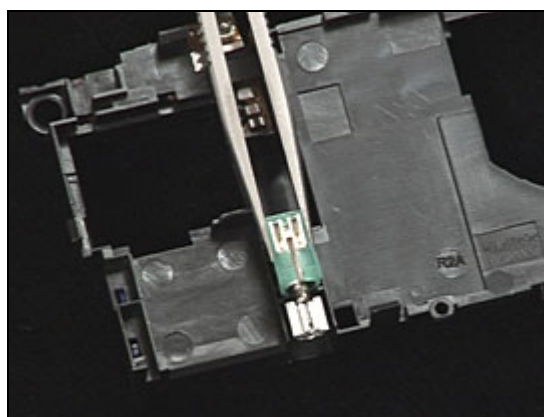
REMOVAL

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

Use a front opening tool to lift up the Vibrator.



Use tweezers to remove the Vibrator

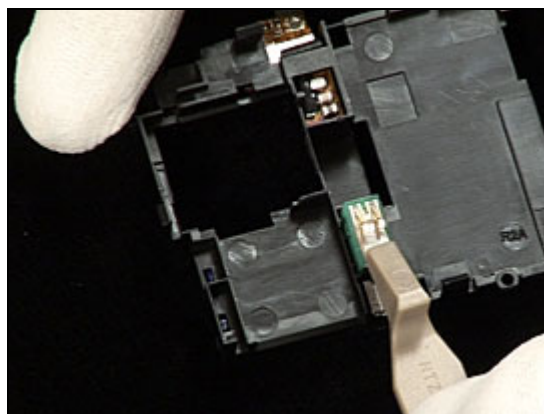


INSTALLATION

DO NOT TOUCH THE VIBRATOR SPRINGS!

Use a front opening tool to press the Vibrator into its cavity.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!

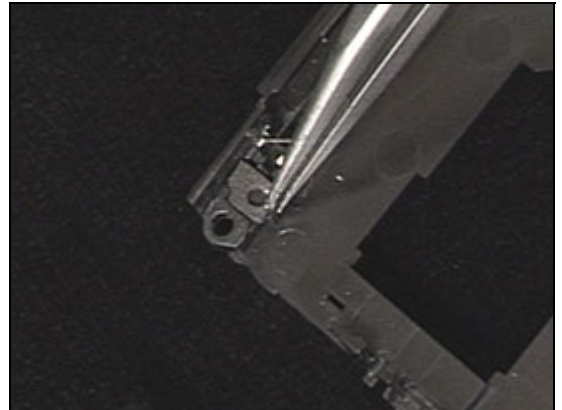


3.14 Microphone Gasket

REMOVAL

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

Use tweezers to remove the Microphone Gasket.



INSTALLATION

Use tweezers to position the Microphone Gasket.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!

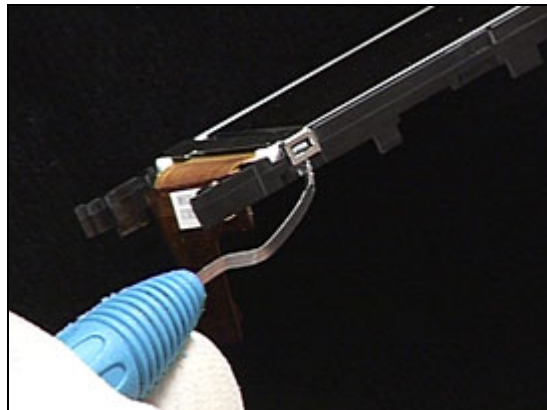


3.15 LCD, LCD Holder Assembly & ESD Protection sheet

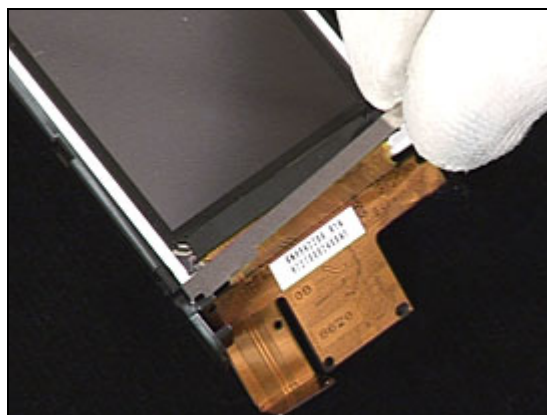
REMOVAL

Follow the 2.1.1 – 2.1.8 Disassembly instructions!

Use a dentist hook to unhook the ESD protection sheet.



Use your fingers to remove the ESD protection sheet.

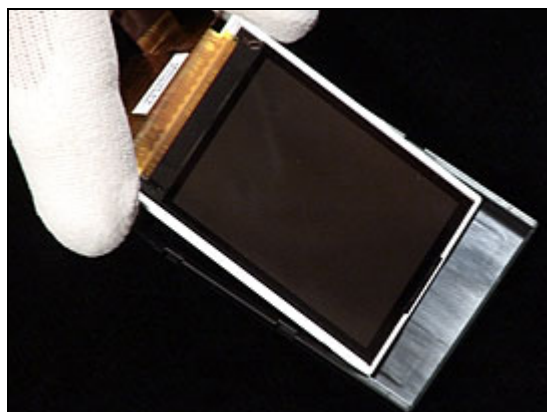


Use your fingers to remove the LCD from the LCD holder assembly.



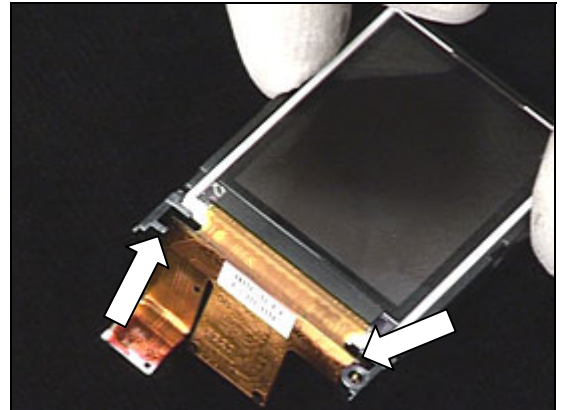
INSTALLATION

Use your fingers to position the LCD in the LCD holder assembly



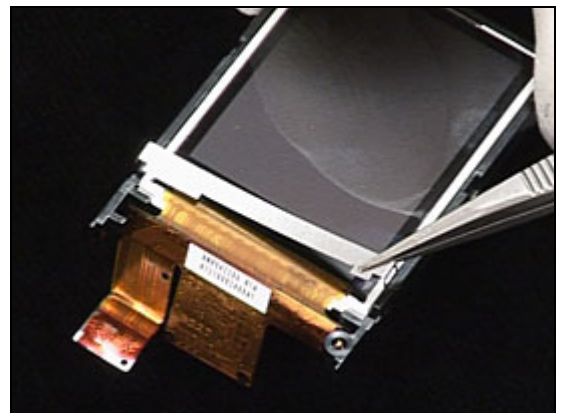
LCD, LCD Holder & ESD Protection sheet *continued*

Position the LCD flex film behind the two portions of the LCD holder as shown.



Use tweezers to position the ESD Protection sheet.

Follow the 4.1.3 – 4.1.10 Reassembly instructions!

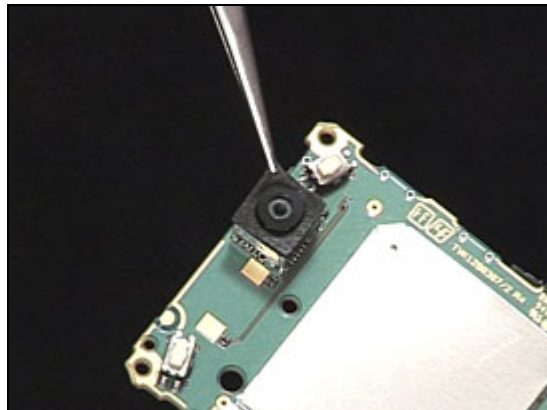


3.16 VGA Socket Gasket – **K810 Only**

REMOVAL

Follow the 2.1.1 – 2.1.8 Disassembly instructions!

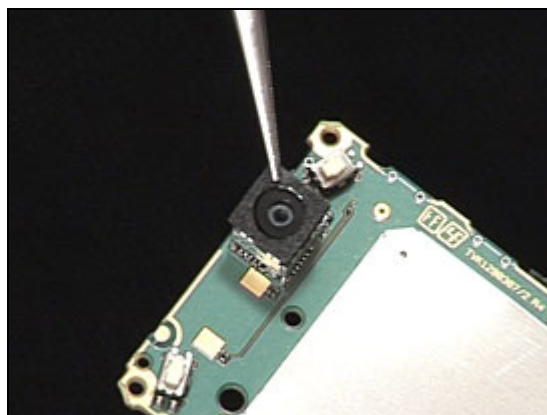
Use tweezers to remove the VGA Socket Gasket



INSTALLATION

Use tweezers to position the VGA Socket Gasket.

Follow the 4.1.3 – 4.1.10 Reassembly instructions!

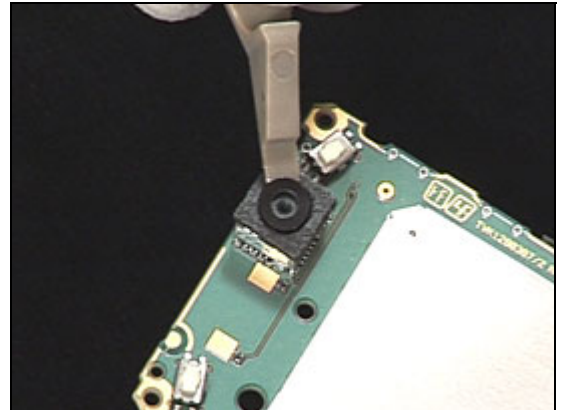


3.17 VGA Camera Window – **K810 Only**

REMOVAL

Follow the 2.1.1 – 2.1.8 Disassembly instructions!

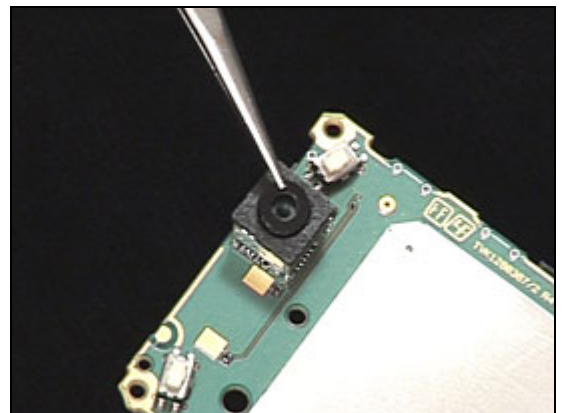
Use a front opening tool to remove the VGA Camera Window.



INSTALLATION

Use tweezers to position the VGA Camera Window

Follow the 4.1.3 – 4.1.10 Reassembly instructions!



3.18 VGA Camera – K810 Only

REMOVAL

Follow the 2.1.1 – 2.1.8 Disassembly instructions!
Follow the 3.16 – 3.17 Removal instructions!

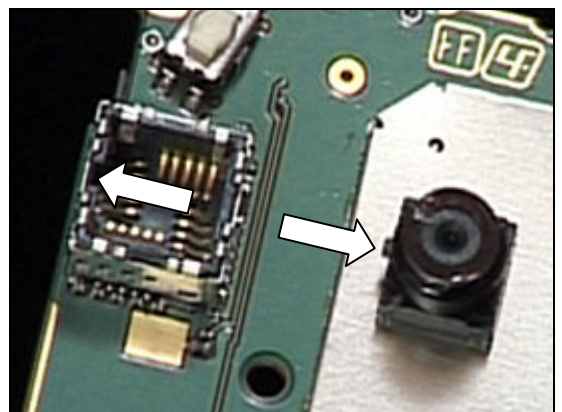
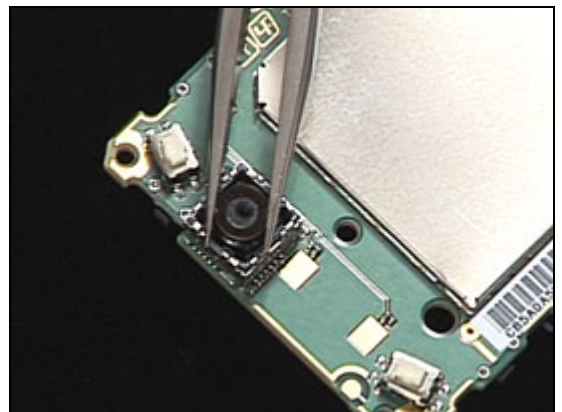
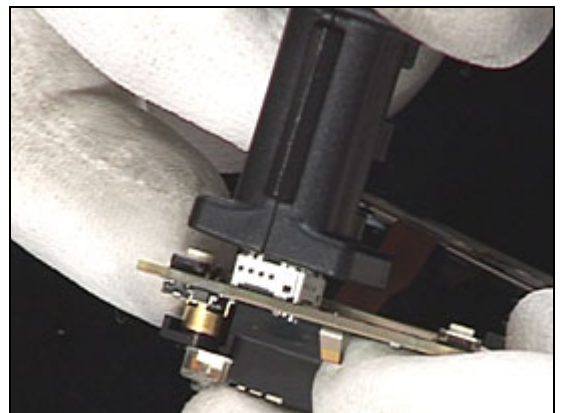
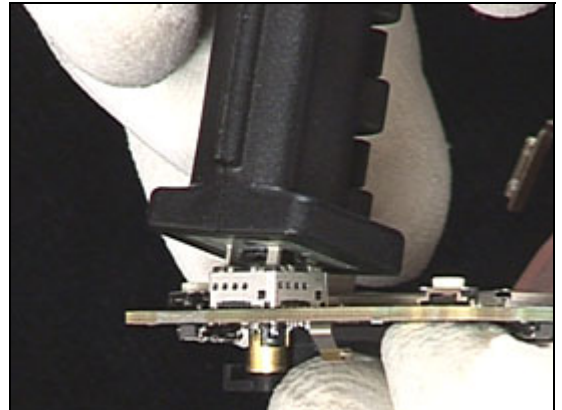
Use VGA camera removal tool to remove VGA Camera.

Push the VGA camera tool to bottom and wiggle the tool side to side before lifting the tool up.

Use tweezers to remove the VGA camera

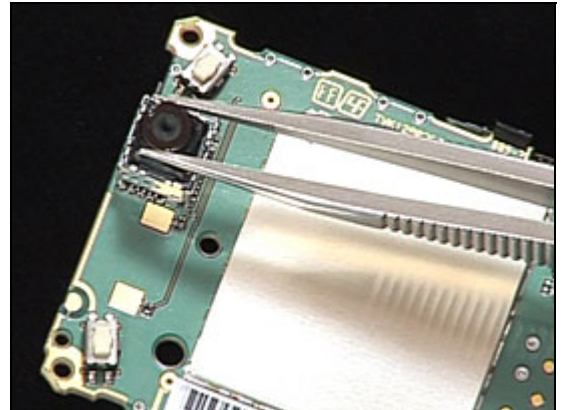
INSTALLATION

Notice the small slot in the socket and the small slot in the VGA camera.



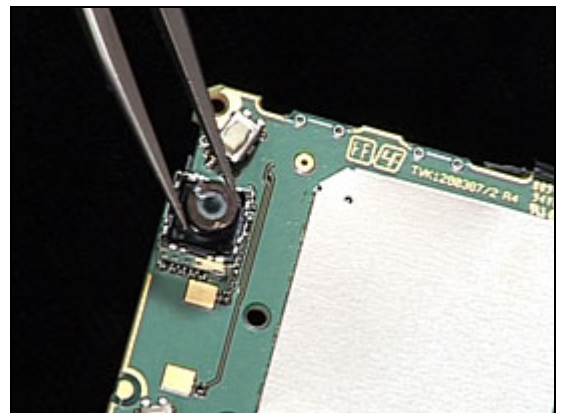
VGA Camera *continued*

Use tweezers to position the VGA camera



Press gently on the top of the *VGA camera* until it snaps into place.

Follow the 3.17 – 3.16 Removal instructions!
Follow the 4.1.3 – 4.1.10 Reassembly instructions!



3.19 Xenon Flash

REMOVAL

Follow the 2.1.1 – 2.1.5 Disassembly instructions!

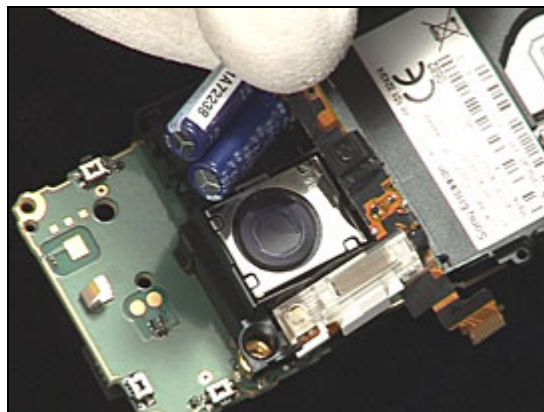
Use your finger to lift the end of both capacitors out of their cavity.



Use a front opening tool to detach the Xenon flash flex film from the Frame assembly.



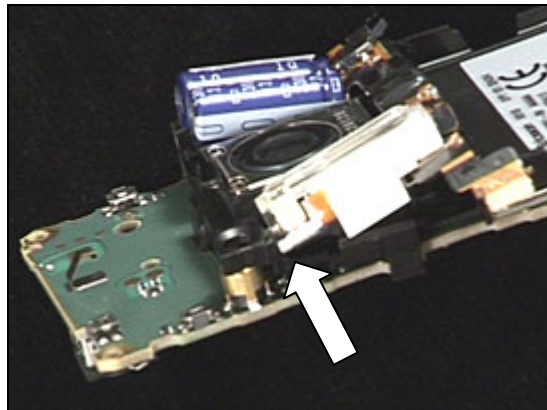
Use your fingers to remove the Xenon flash.



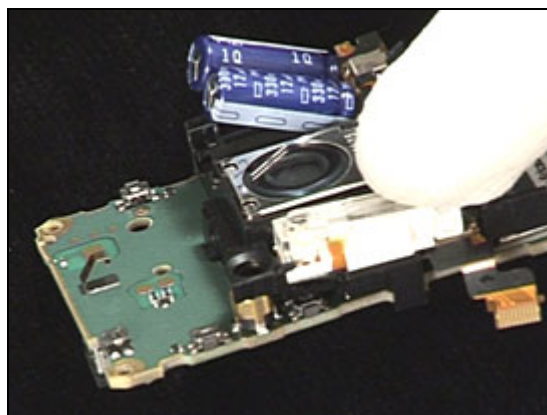
Xenon Flash *continued*

INSTALLATION

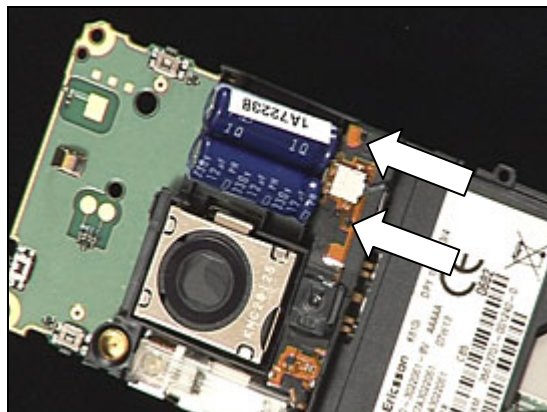
Obtain a new Xenon flash and orient it to its cavity in the Frame assy.



Verify that the Xenon flash goes under the placement peg.



Place the Xenon flash to the frame so that it fits the two guiding pins.



Use your fingers to snap the capacitors in their cavity in the frame assy.

Follow the 4.1.6 – 4.1.10 Reassembly instructions!

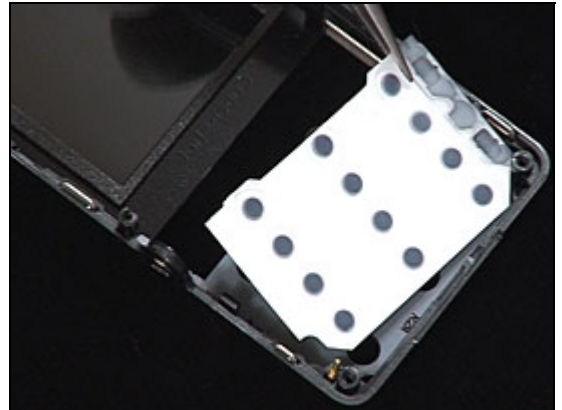


3.20 Numeric Keyboard

REMOVAL

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

Use tweezers to remove the Numeric keyboard.



INSTALLATION

Use tweezers to position the Numeric keyboard.

Follow the 4.1.7 – 4.1.10 Reassembly instructions!

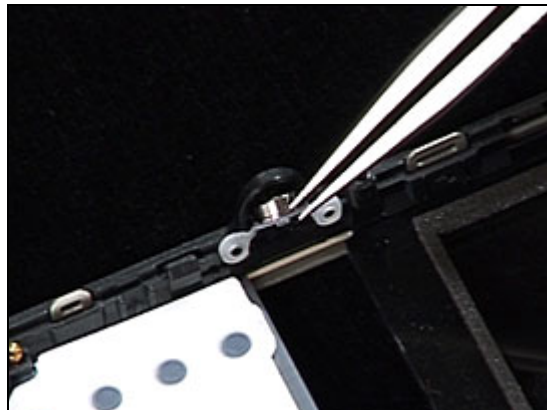


3.21 Camera Key

REMOVAL

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

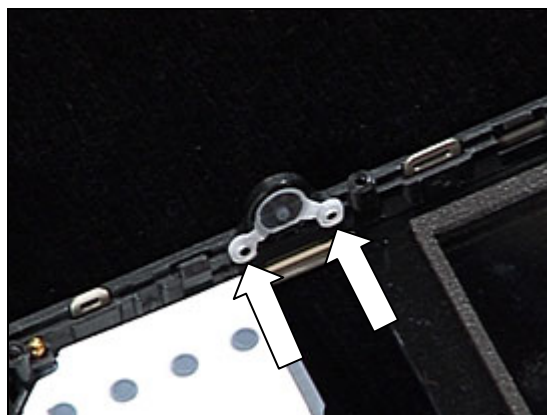
Use tweezers to remove the Camera key.



INSTALL

Use tweezers to position the Camera key. Use the two guiding pins.

Follow the 4.1.7 – 4.1.10 Reassembly instructions!

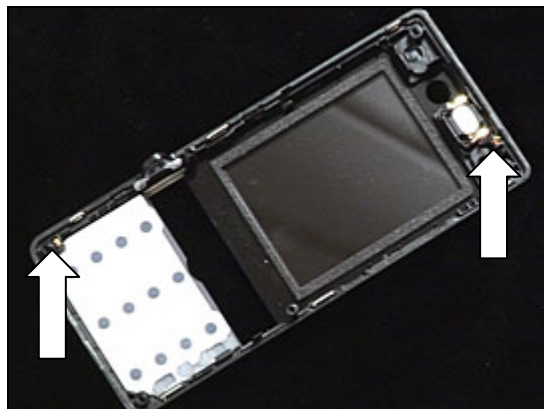


3.22 Ground Connectors

REMOVAL

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

There is two Ground Connectors.



Use tweezers to remove the Ground connector



INSTALLATION

Use tweezers to position the Ground connector

Follow the 4.1.7 – 4.1.10 Reassembly instructions!



3.23 Ear Speaker

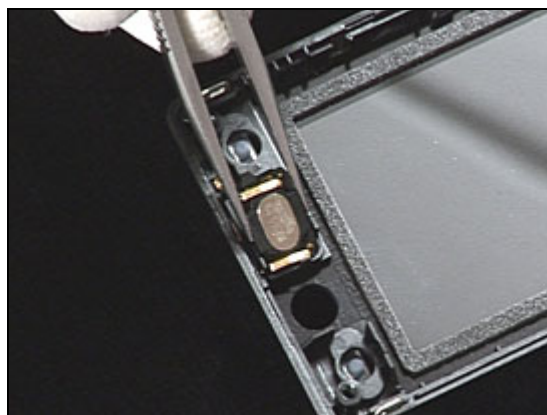
REMOVAL

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

Use a front opening tool to release the Ear speaker.

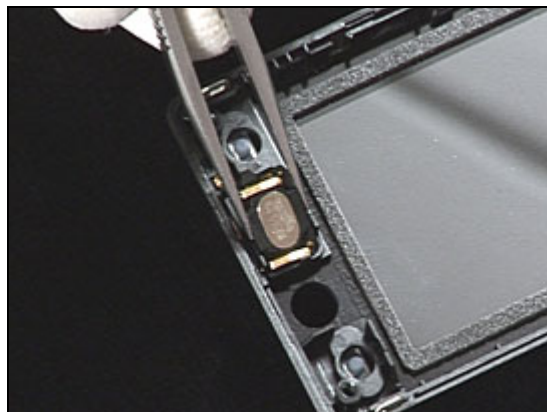


Use tweezers to remove the Ear speaker.



INSTALLATION

Use tweezers to position the Ear speaker.



DO NOT TOUCH THE EAR SPEAKER SPRINGS!

Use a front opening tool to press the Ear speaker into its cavity.

Follow the 4.1.7 – 4.1.10 Reassembly instructions!

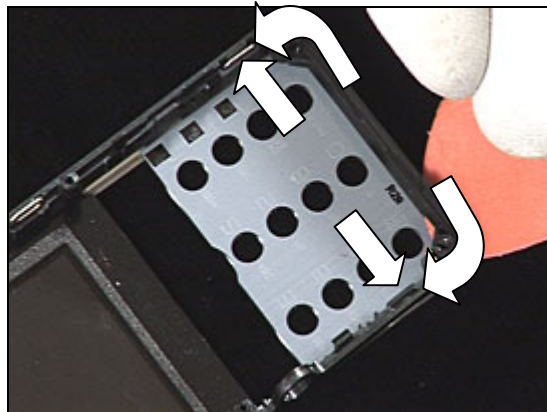


3.24 Front Assy

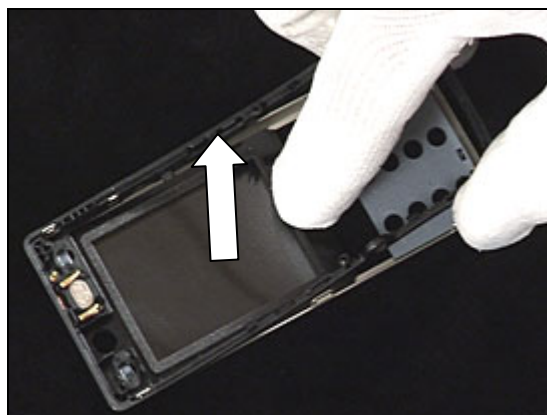
REMOVAL

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

Use a Guitar pick to unsnap the two first hooks.

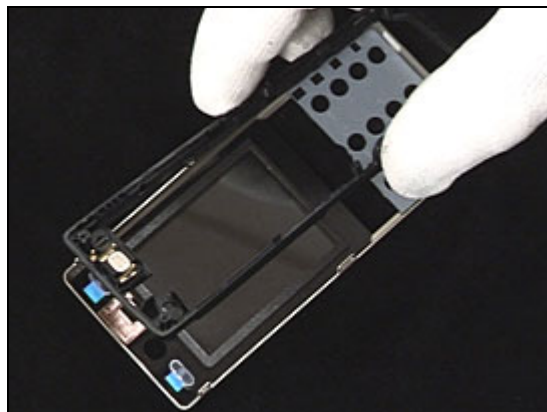


Use your fingers and pull the Front assy upwards to release it from the Front complete.



INSTALLATION

Put the Front assy over the Front complete.



Press down the Front assy with your fingers so that the six hooks snaps.

Follow the 4.1.7 – 4.1.10 Reassembly instructions!

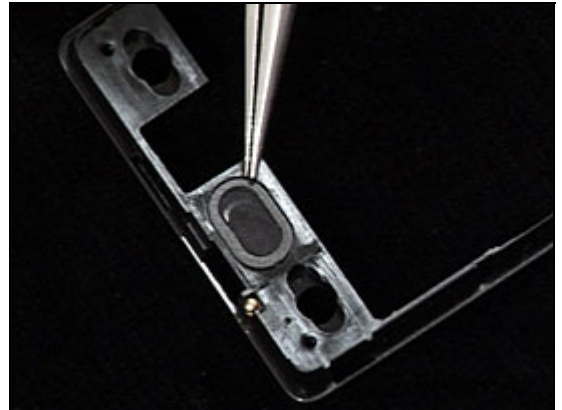


3.25 Ear Speaker Gasket

REMOVAL

Follow the 2.1.1 – 2.1.4 Disassembly instructions!
Follow the 3.24 Removal instructions!

Use tweezers to remove the Ear speaker gasket.



INSTALLATION

Use tweezers to position the Ear speaker gasket.

Follow the 3.24 Installation instructions!
Follow the 4.1.7 – 4.1.10 Reassembly instructions!

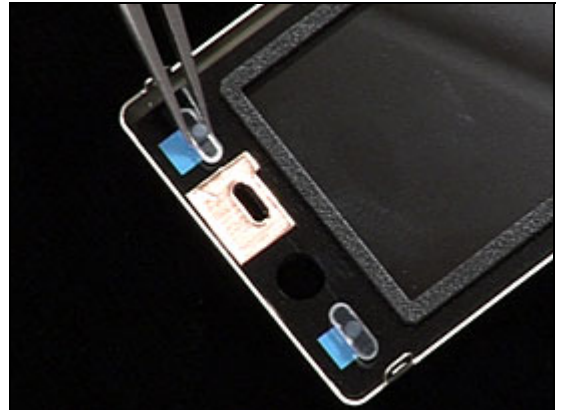


3.26 A/B Keys

REMOVAL

Follow the 2.1.1 – 2.1.4 Disassembly instructions!
Follow the 3.24 Removal instructions!

Use tweezers to remove the A/B keys.



INSTALLATION

Use tweezers to position the A/B keys.

Follow the 3.24 Installation instructions!
Follow the 4.1.7 – 4.1.10 Reassembly instructions!



3.27 Loudspeaker Gasket

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

Use tweezers to remove the Loudspeaker gasket.



INSTALLATION

Use tweezers to position the Loudspeaker gasket.

Follow the 4.1.8 – 4.1.10 Reassembly instructions!

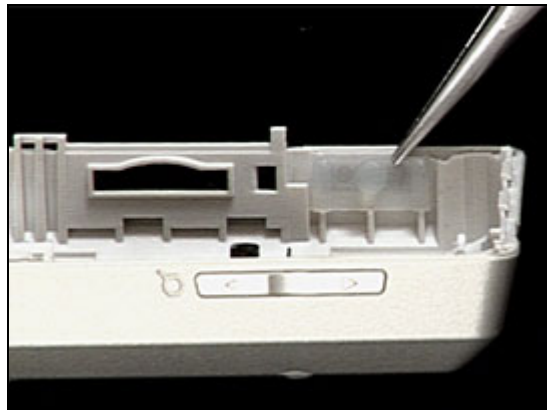


3.28 Music Player Key

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

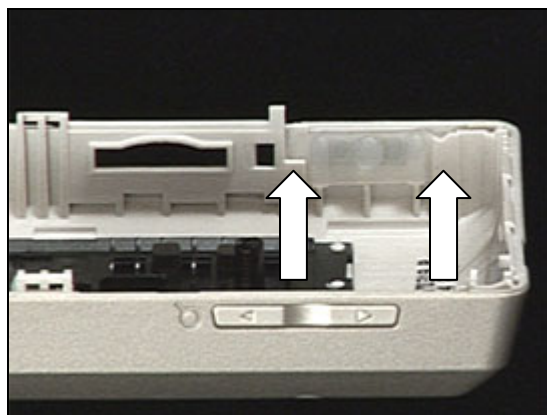
Use tweezers to remove the Music play key.



INSTALLATION

Use tweezers to position the Music player key. Use the two guiding.

Follow the 4.1.8 – 4.1.10 Reassembly instructions!



3.29 Volume Key

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

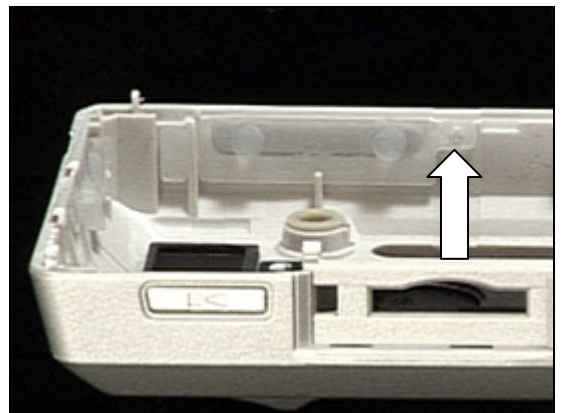
Use tweezers to remove the Volume key.



INSTALLATION

Use tweezers to position the Volume key. Use the guiding pin.

Follow the 4.1.8 – 4.1.10 Reassembly instructions!

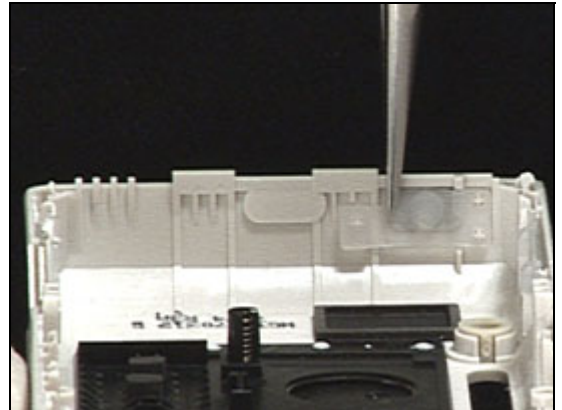


3.30 On/Off Key

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

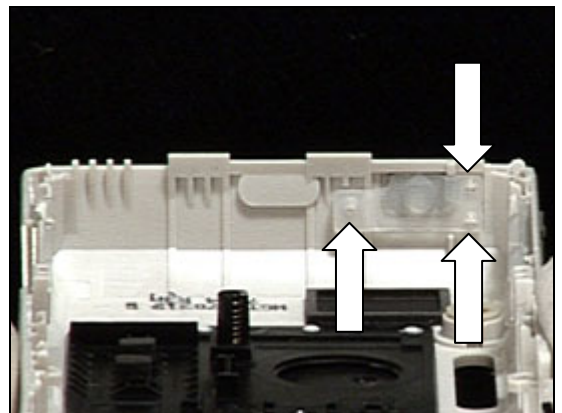
Use tweezers to remove the On/Off key.



INSTALLATION

Use tweezers to position the On/Off key. Use the three guiding pins.

Follow the 4.1.8 – 4.1.10 Reassembly instructions!

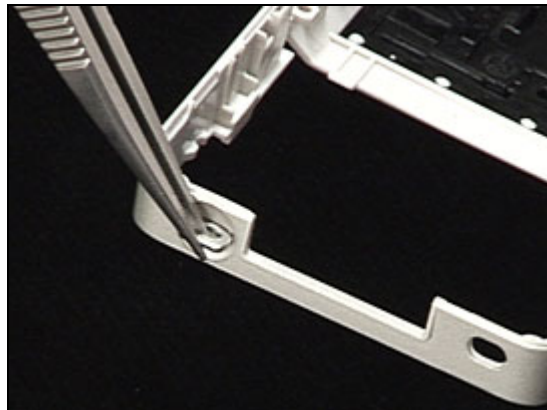


3.31 Handstrap Plate

REMOVAL

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

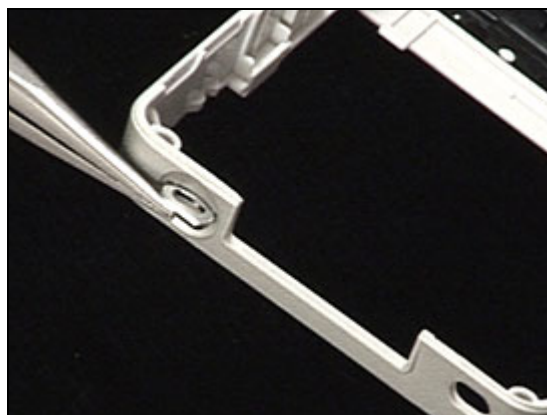
Use tweezers to remove the Handstrap plate.



INSTALLATION

Use tweezers to position the Handstrap plate.

Follow the 4.1.8 – 4.1.10 Reassembly instructions!



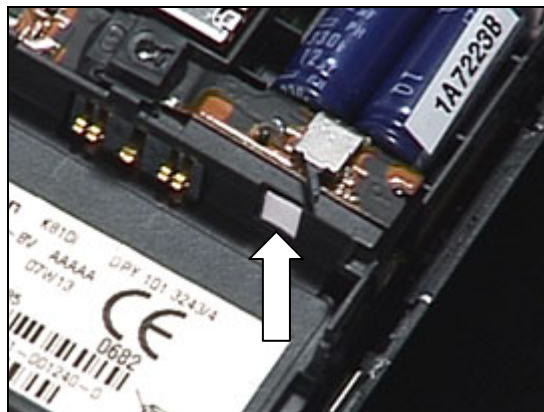
3.32 Liquid Indicator

INSPECTION

There is one Liquid Indicators located at the position of the arrow

To get access to and to inspect the indicators:

Follow 2.1.1 – 2.1.3 Disassembly instructions!



REMOVAL

Remove the activated Liquid Intrusion Indicator with the dentist hook and the tweezers.

INSTALLATION

Attach the new *liquid intrusion indicator* with the tweezers and the dentist hook.

Follow the 4.1.8 – 4.1.10 Reassembly instructions!

3.33 KRH Label

Follow the 2.1.1 – 2.1.3 Disassembly instructions!

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



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

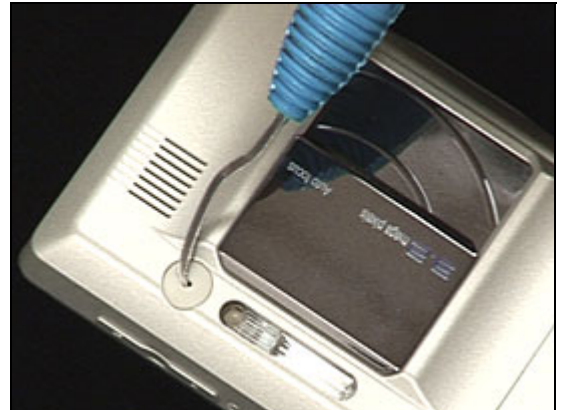
ONE LABEL ONLY IS ALLOWED!

Follow the 4.1.8 – 4.1.10 Reassembly instructions!

3.34 Plug (External Antenna)

REMOVAL

Use a dentist hook to remove the Plug (External antenna).



INSTALLATION

Use tweezers to position the Plug (External antenna).



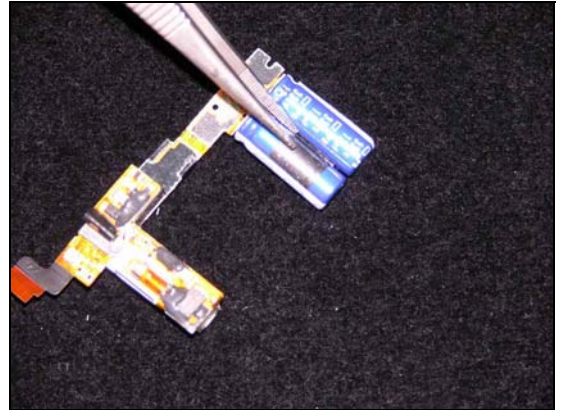
3.35 Tape (holder capacitor)

REMOVAL

Use a tweezers to remove the Tape (holder capacitor).

INSTALLATION

Use a tweezers to position the Tape (holder capacitor).



3.36 Board Swap – replace swap board

Follow the 2.1.1 to 2.1.10 Disassembly instructions!

Replace swap board

Follow the 4.1.1 to 4.1.10 Reassembly instructions!

3.37 Board Swap – Change Label

CHANGE LABEL

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

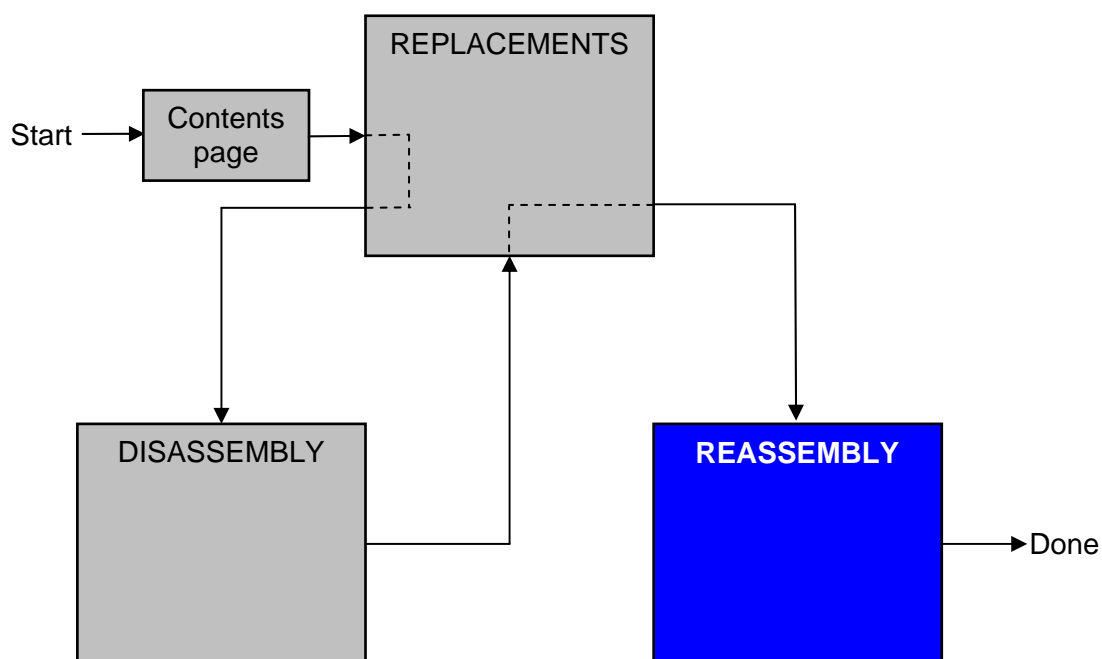
3.38 Board Swap – Customize Software

CUSTOMIZATION OF SOFTWARE

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

4 Reassembly

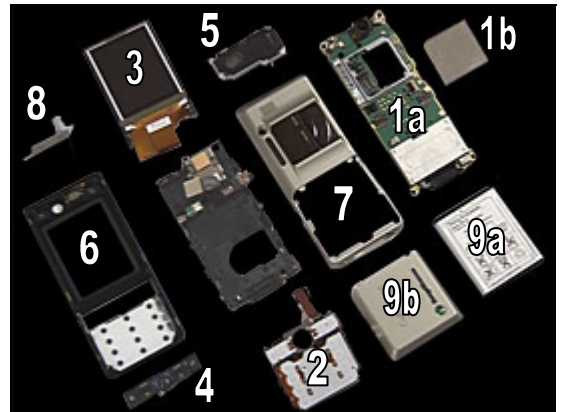
After replacing a part being listed in Replacements, the instruction of that section usually ends by directing you to this Reassembly section with a specification of the instructions you have to carry out in order to reassemble the phone.



4.1 Overview

The reassembly is done in the following order:

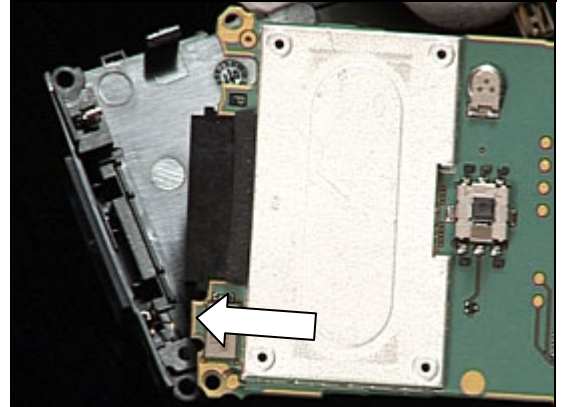
1. PCB (a) & Shield Can Lid, Camera Assy (b)
2. Key Foil Complete
3. LCD
4. Function Keyboard Assy
5. Antenna/Speaker Box Assembly
6. Front
7. Antenna Cover Assembly
8. MS Cover
9. Battery (a) & Battery Lid Assembly (b)



4.1.1 PCB & Shield Can Lid, Camera Assy

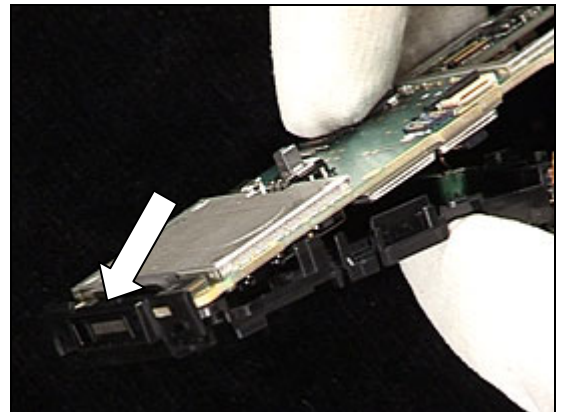
MAKE SURE THE BLUETOOTH ANTENNA'S CONTACT FINGERS ARE UNDER THE PBA!

Place the indicated tab portion of the PBA into the slot on the Frame assy.

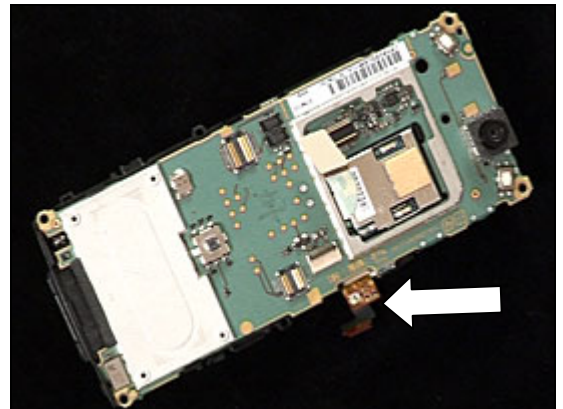


Rotate the PBA so that the system connector is put into the Frame assy.

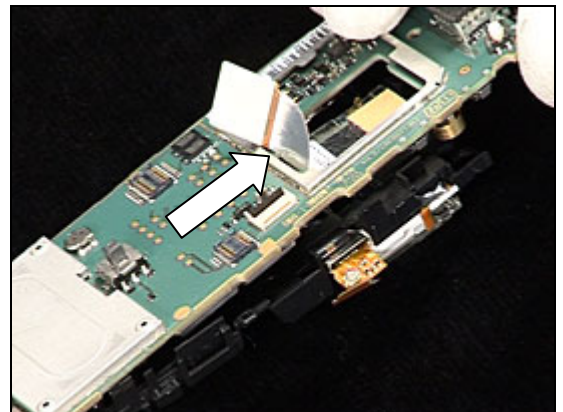
SECURE ONCE AGAIN SO THAT THE BLUETOOTH ANTENNA'S CONTACT FINGERS ARE UNDER THE PBA!



Make sure that the Xenon flash flex film is between the Frame assy and the PBA.

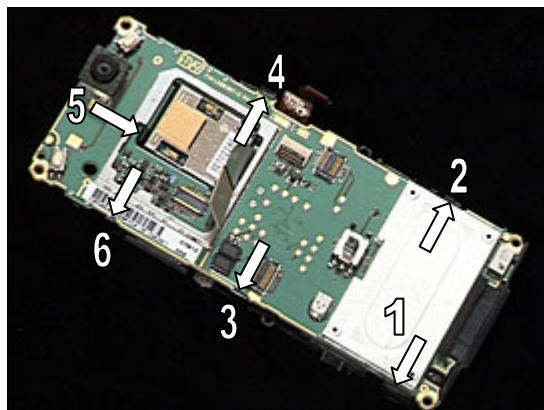


Put out the Camera flex film through the large hole.

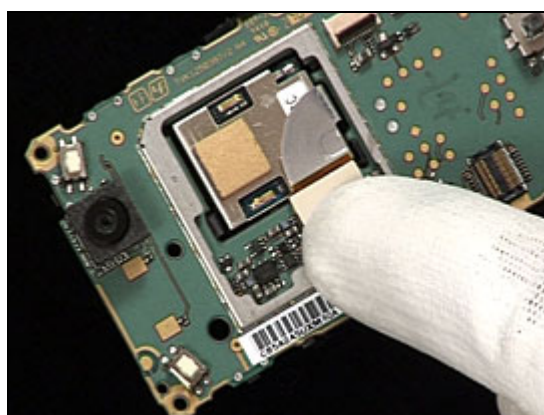


PCB & Shield Can Lid, Camera Assy *continued*

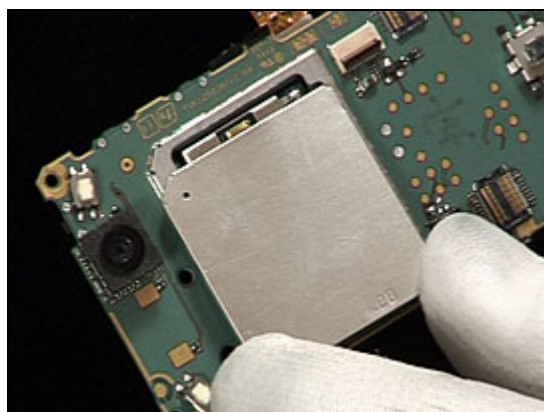
Snap the six latches in the order shown from the edge of the PBA.



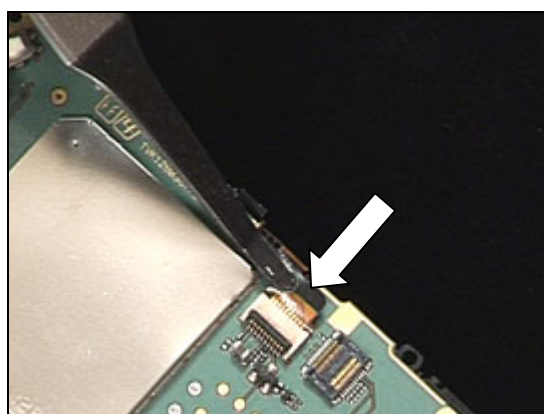
Plug the Camera connector to the connector on the PBA.



Use your fingers to install a new Shield can lid, camera assy.

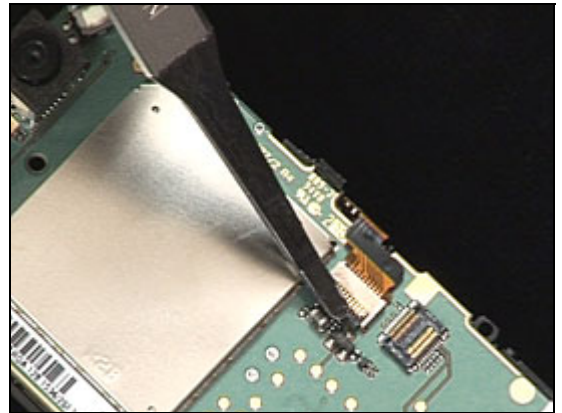


Use a flex film assembly tool and pull the flex film into the connector.



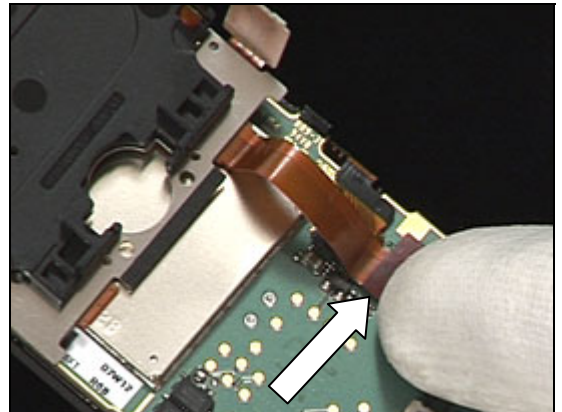
PCB & Shield Can Lid, Camera Assy *continued*

Rotate the black retaining bar of the connector away from the flex film.

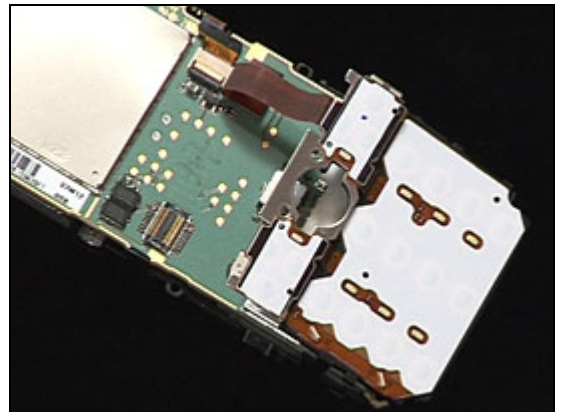


4.1.2 Key Foil Complete

Lay the Key foil complete upside down over the Shield can lid, camera assy. Plug the Key foil complete flex film to the BtB connector on the PBA with your fingers.

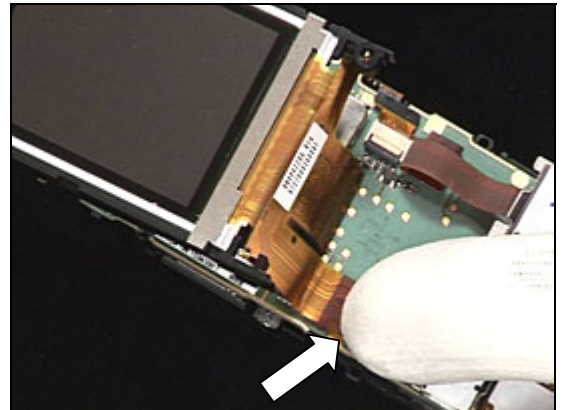


Rotate the Key foil complete and position it over the system connector.

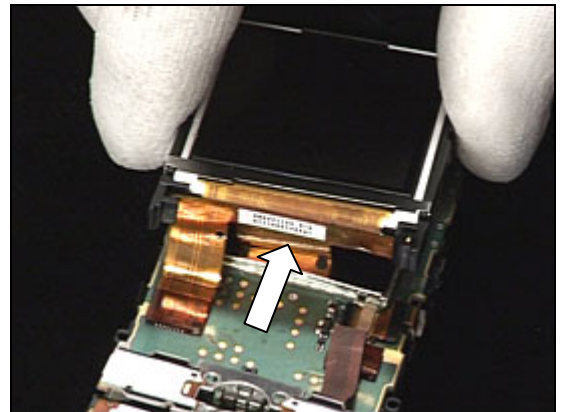


4.1.3 LCD

Plug the LCD flex film into the BtB connector on the PBA with your fingers.

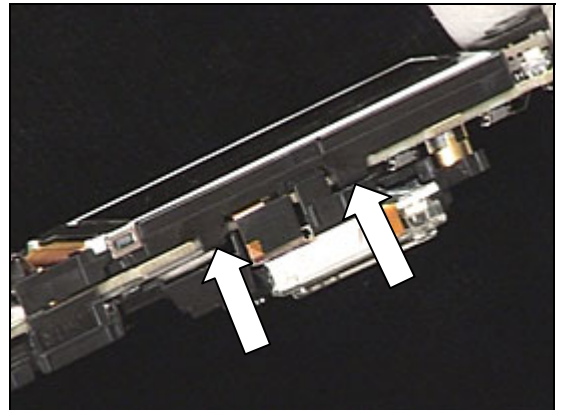


Rotate the LCD down onto the PBA so that the LCD flex film folds underneath the LCD.

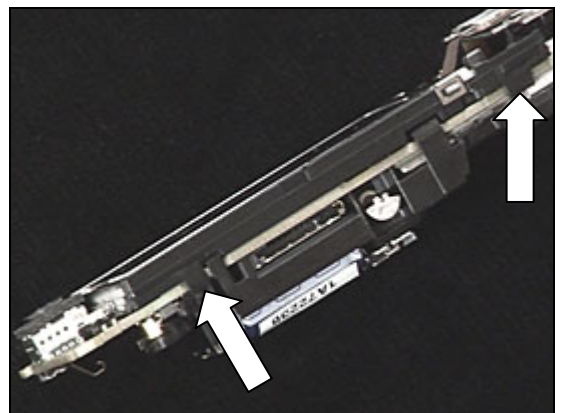


4.1.4 LCD/Key Foil Complete attachment

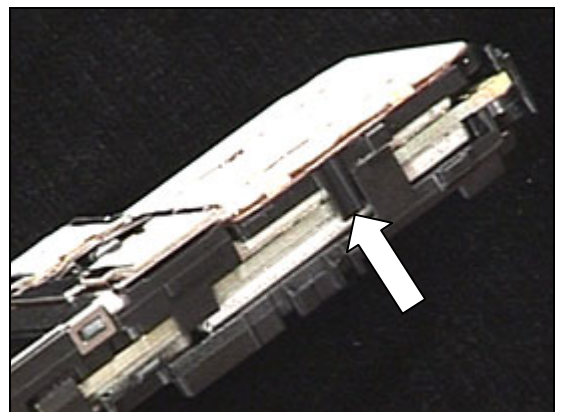
Snap the two latches of the LCD holder.



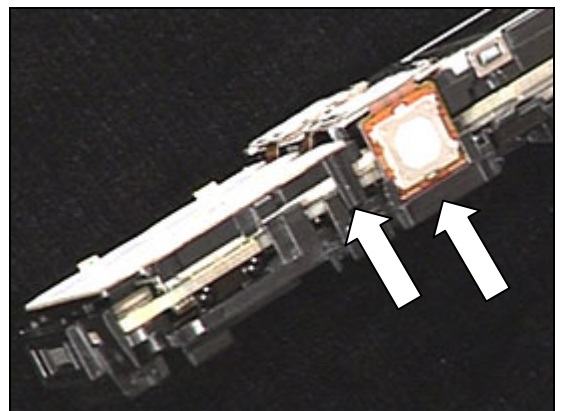
Do the same thing on the opposite side.



Snap the latch of the Key foil complete.

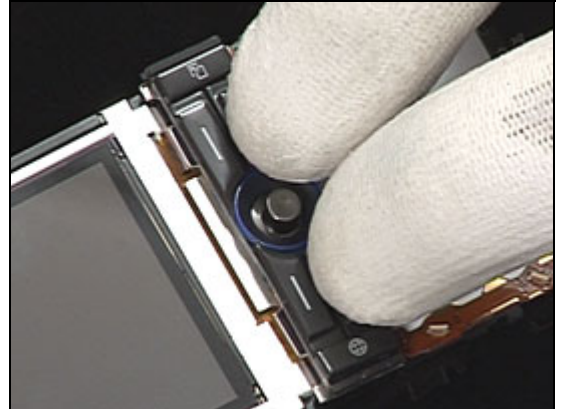


Do the same thing on the other side and slide the camera switch into its slot in the Frame assy.



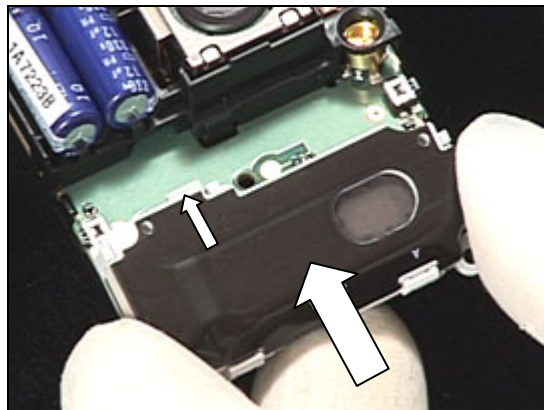
4.1.5 Function Keyboard Assy

Use your fingers to position the Function keyboard assy.

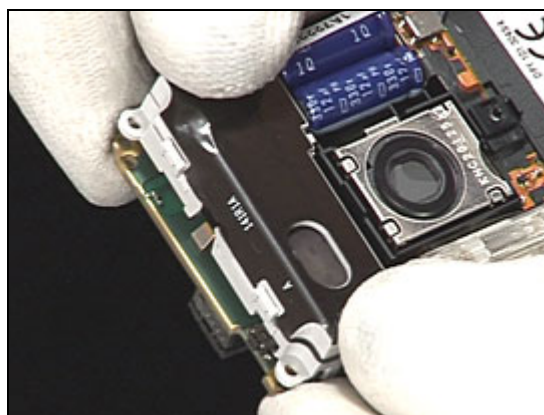


4.1.6 Antenna/Speaker Box Assembly

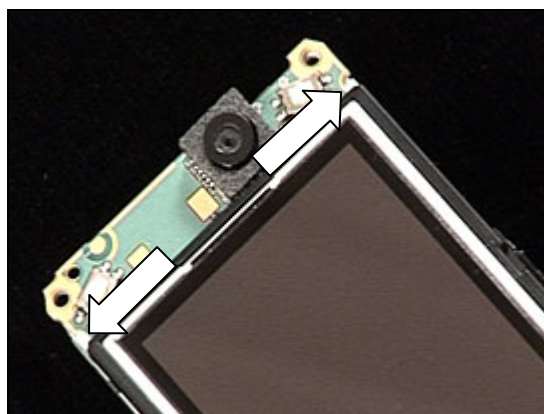
Insert the tab portion of the Antenna/Speaker box assembly in the slot under the capacitors.



Use your fingers to position the Antenna/Speaker box assembly and snap it on the PBA.



Visually inspect so that the hooks has snapped!



4.1.7 Front Unit

Insert the camera key side of the Core unit in the Front complete.



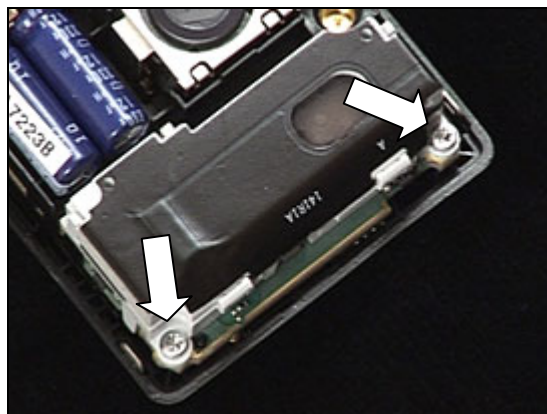
Rotate opposite side of the Core unit into the Front complete.



Snap the Core unit and the Front complete together with your fingers.



Install the two silver screws using torque screwdriver at 22 Ncm with a T6 bit.

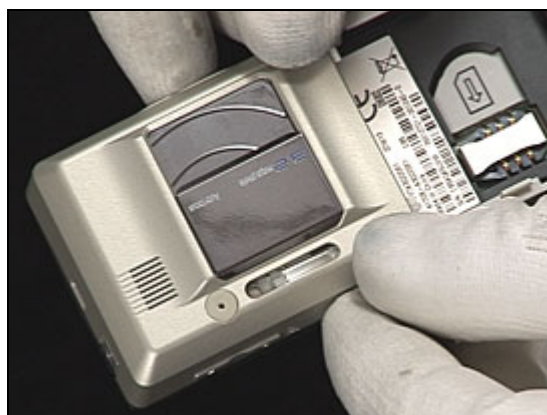


4.1.8 Antenna Cover Assembly

Use your fingers to position the top of the Antenna cover assembly on the Front unit.



Rotate the Antenna cover assembly down onto the phone.

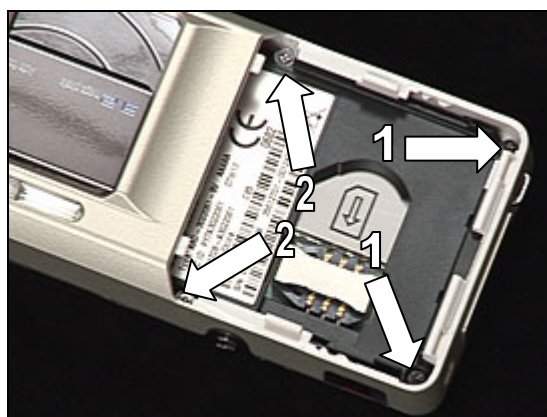


Use your fingers to snap the phone together.



Install the two black screws (numbered 1) with torque screwdriver at 22 Ncm with a T6 bit.

Install two screws (numbered 2) with torque screwdriver at 10 Ncm with a JCIS.

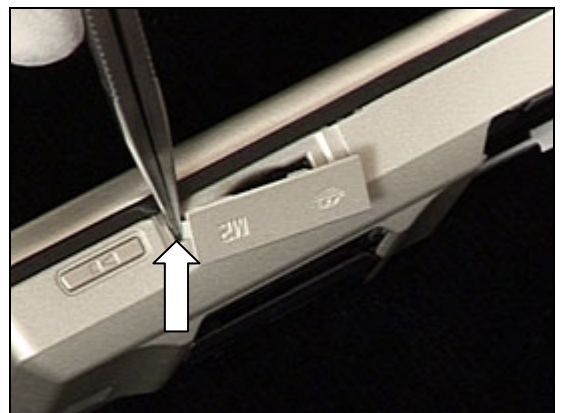


4.1.9 MS Cover

Use tweezers to position the MS cover.



Use tweezers to press the tab portion of the MS cover into the small hole in the memory stick cavity.



Use your fingers to snap the MS cover into the memory stick cavity.



4.1.10 Battery & Battery Lid Assembly

Insert the contact end of the battery into the cavity.



Press the battery down in the cavity.



Position the battery cover as shown.



Slide the battery cover into place. Make sure it snaps into place.



5 Revision history

Rev.	Date	Changes / Comments
A	2007-04-20	Initial release
B	2007-05-10	Added some information in Chapter 2.1.7
C	2007-05-15	Due to system problem. No changes made on content
D	2007-05-21	Added Tape (holder capacitor)
E	2007-06-19	Added support for K818
6	2010-01-29	Added Board swap instructions