



Sony Ericsson

Working Instructions

- mechanical -



*MK16i, MK16a,
Xperia™ Pro*



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**For general information about mechanical repair related issues, refer to
1220-1333: Generic Repair Manual - mechanical**



1 Exterior Views

1.1 MK16





Exterior Views

1.2 MK16



2 Tools

SPECIAL TOOLS

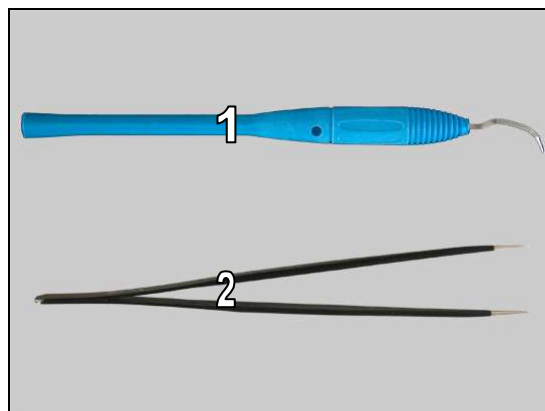
1. Torque Screwdriver
2. Flex Film Assembly Tool
3. Front Opening Tool
4. Bits(T5)
5. Bits(JCIS No 0)
6. Guitar Pick



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

STANDARD TOOLS

1. Dentist Hook
2. Tweezers (ESD-safe & non-metallic)

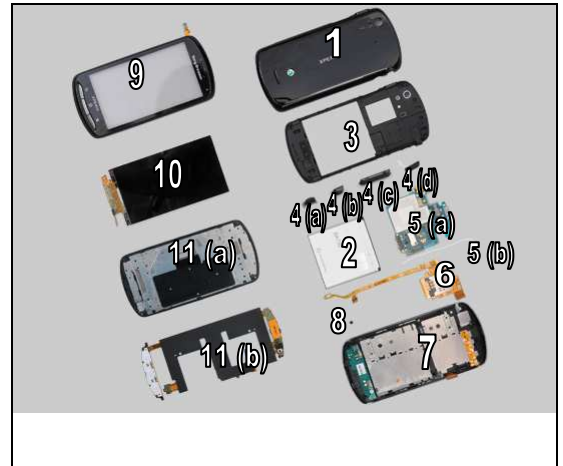




3 Disassembly

The disassembly is done in the following order:

1. Cover Battery
2. Battery
3. Cover Lower Rear
4. Key On/Off (a) & Key Camera (b) & Key Volume (c) & Cap HDMI (d)
5. Main PBA (a) & Cable RF (b)
6. SIM Flex PBA Assy
7. Cover Lower Front
8. Sheet Screw
9. Front Cover Assy
10. 3.7inch TFT LCD
11. Slider Sub Assembly (a) & Slider Flex FPC Assy (b)



3.1 Cover Battery

Release the hook of the Cover Battery from bottom side.



Lift up to release the Cover Battery from bottom side and remove it.



Lift up the Battery from its cavity by finger.





Disassembly

Remove the Battery.



3.2 Cover Lower Rear

Remove the four Screw Other Len:5.0 Diam:1.4 by a screwdriver with Bits (JCIS No 0).



Remove the four Screw Other Len:4.0 Diam:1.4 by a screwdriver with Bits (T5).



Insert guitar pick between Cover Lower Rear and Cover Lower Front from upper right corner and slide along right side.





Disassembly

Slide along bottom side.

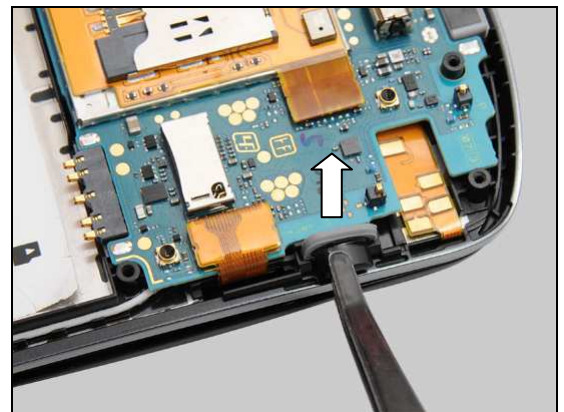


Remove the Cover Lower Rear.



3.3 Key On/Off & Key Camera & Key Volume

Remove the Key On/Off.

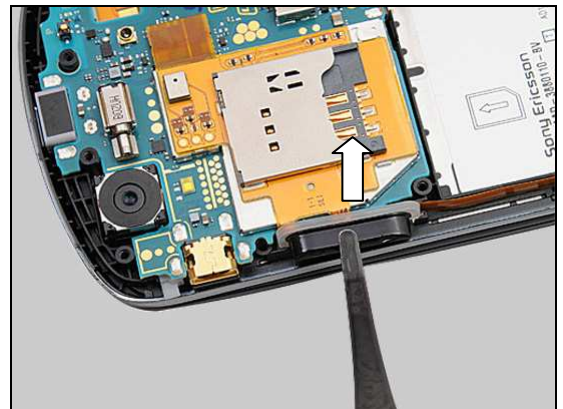


Remove the Key Camera.



Disassembly

Remove the Key Volume.

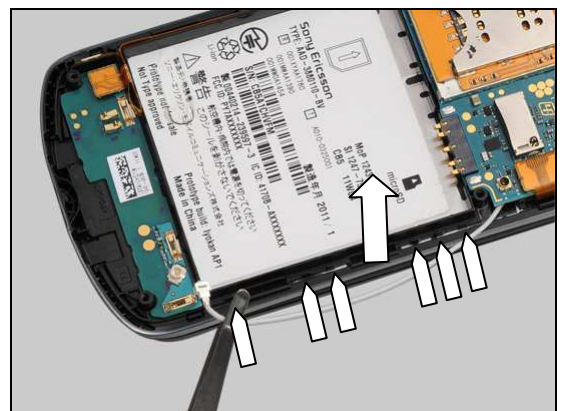


3.4 Main PBA & Cable RF

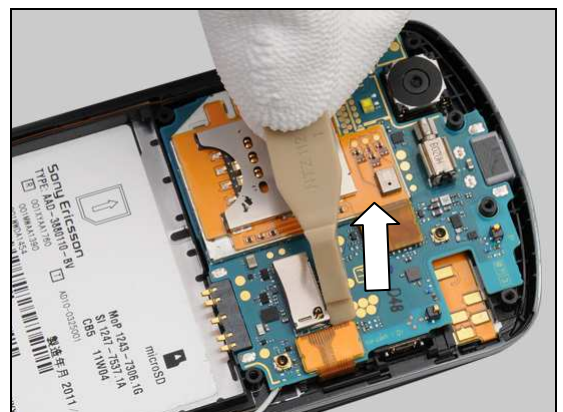
Unsnap the connector with Front Opening Tool.



Lift up the Cable RF at six fixing sockets.

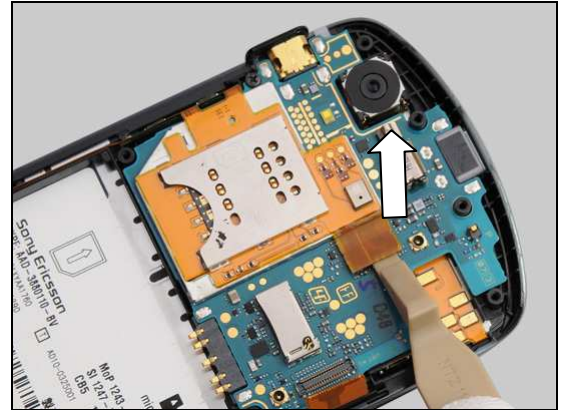


Unsnap the BtB connector with Front Opening Tool.



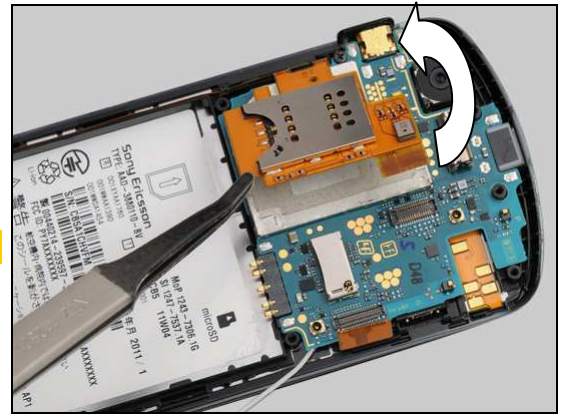
Disassembly

Unsnap the BtB connector with Front Opening Tool.

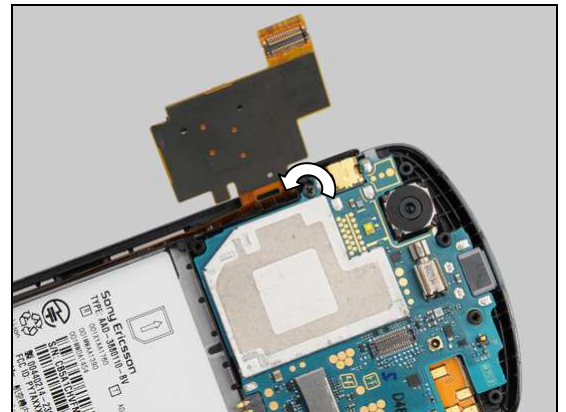


Lift up SIM Flex PBA Assy at lower right corner with Flex Film Assembly Tool.

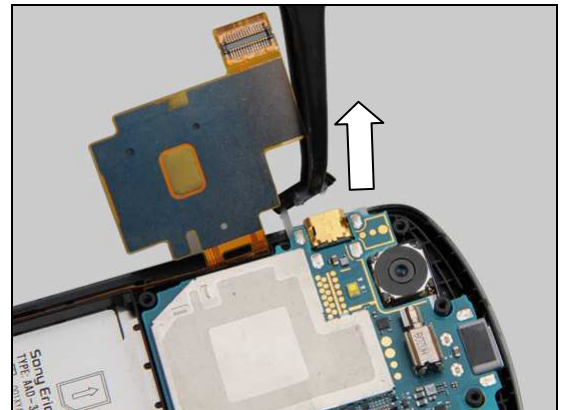
Note: Do not touch pins.



Remove the Screw Phillips Len:3.0 Diam:1.4 by a screwdriver with Bits (JCIS No 0).

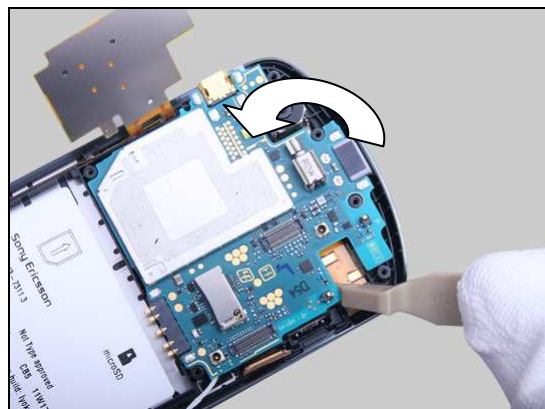


Remove the Cap HDMI.

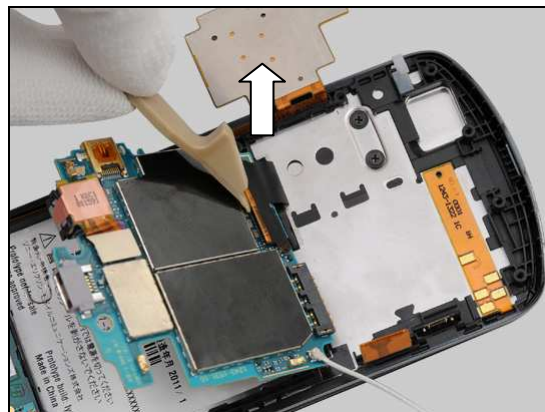


Disassembly

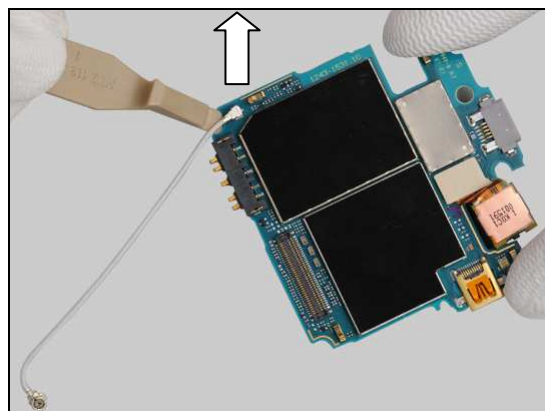
Insert Front Opening Tool from upper right corner and turn over Main PBA.



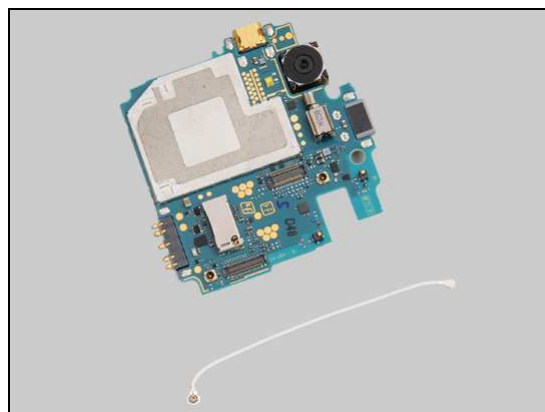
Unsnap the BtB connector with Front Opening Tool then remove the Main PBA.



Unsnap the other connector of Cable RF from Main PBA.



Separate Main PBA and Cable RF.



Disassembly

3.5 SIM Flex PBA Assy

Lift up the SIM Flex PBA Assy gently.



Unsnap the BtB connector with Front Opening Tool.

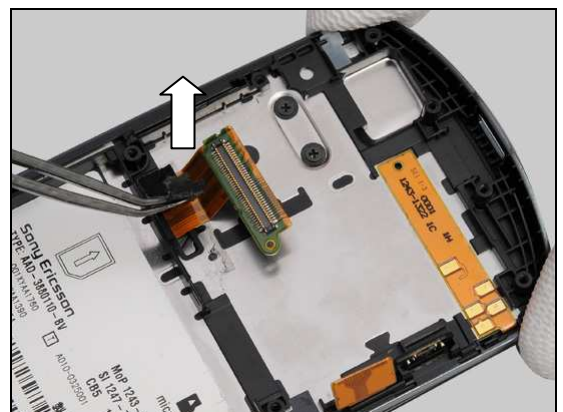


Lift up to remove the SIM Flex PBA Assy.



3.6 Cover Lower Front

Peel off MComp Sheet Slider LF with Flex Film Assembly Tool.



Disassembly

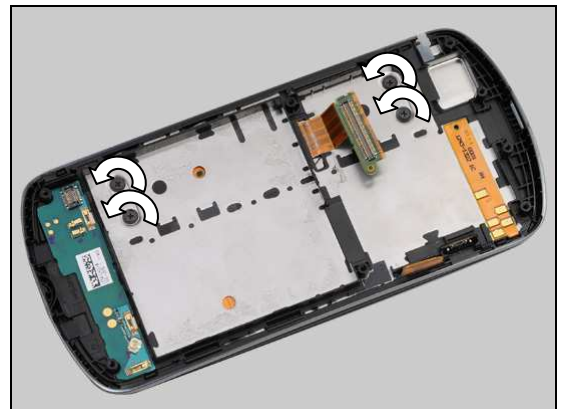
Copy old Core Unit Label information into the 'LabelMake' program.



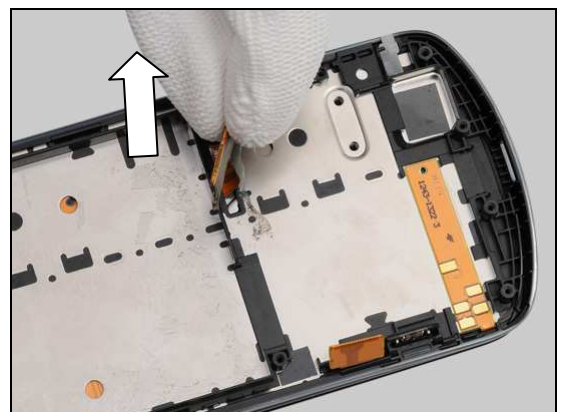
Carefully remove the Label with Flex Film Assembly Tool.



Remove the four Screw Len: 2.0 Diam: 1.4 by a screwdriver with Bits (JCIS No 0).



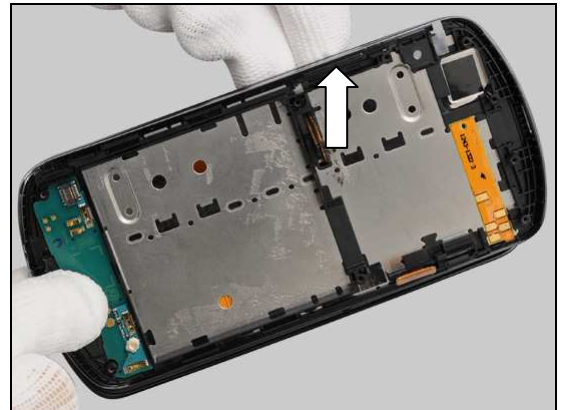
Detach the foil.





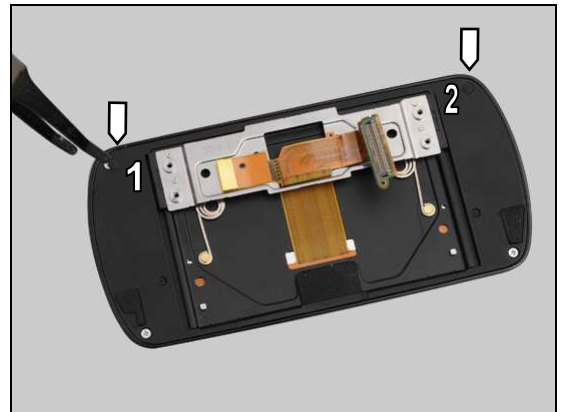
Disassembly

Separate Cover Lower Front from Slider Sub Assembly.

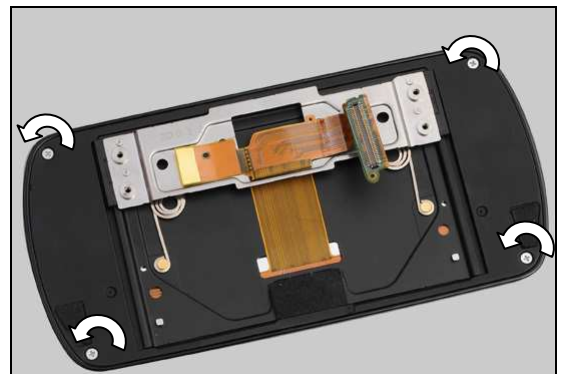


3.7 Sheet Screw

Lift to remove the Sheet Screw with Flex Film Assembly Tool.

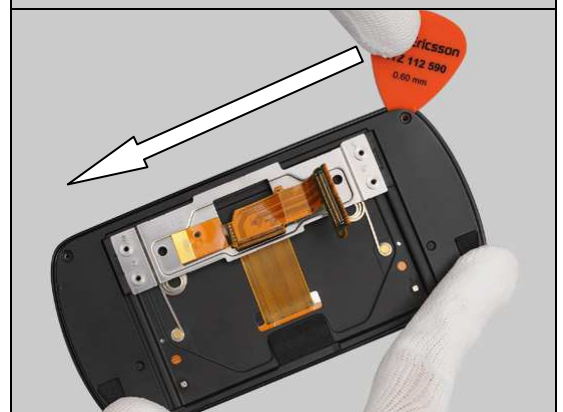


Remove the four Screw Phillips Len:2.5 Diam:1.4 M by a screwdriver with Bits (JCIS No 0).



3.8 Front Cover Assy

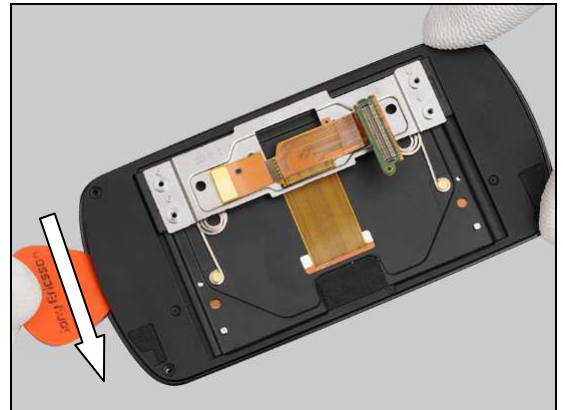
Insert Guitar pick from the upper left corner and slide along left side.





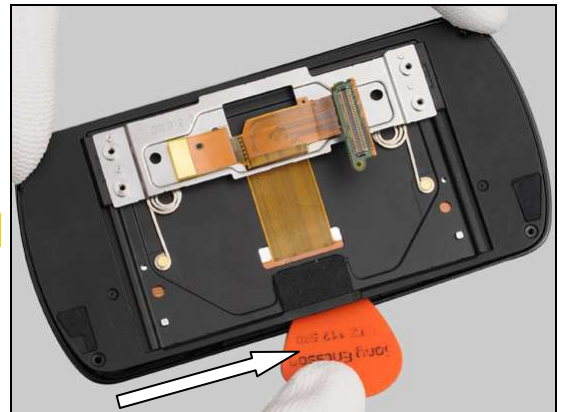
Disassembly

Slide along bottom side.



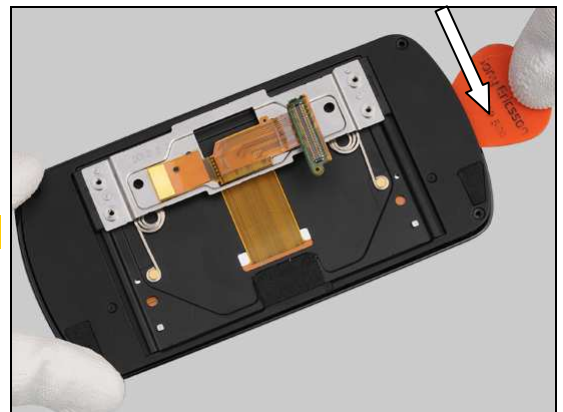
Slide along right side.

Slide gently! Just stop slide at middle of right side.



Slide along top side from left to right.

Slide gently! Just stop slide at middle of top side.



Turn over the Slider Sub Assembly gently, and carefully open the Front Cover Assy.





Disassembly

Unsnap the BtB connector with Front Opening Tool.



Separate Front Cover Assy and the Slider Sub Assembly.

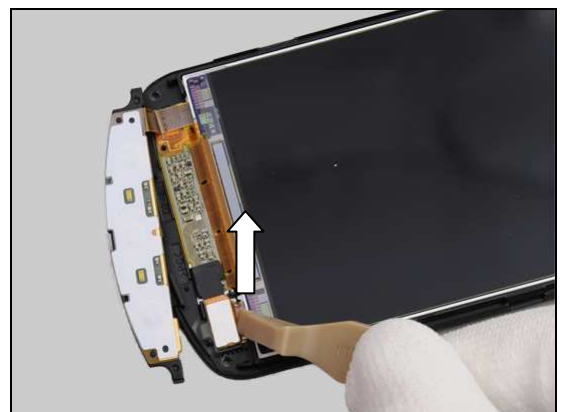


3.9 3.7inch TFT LCD

Release the hook with Front Opening Tool.

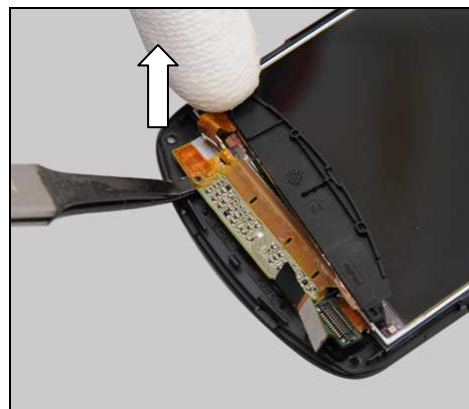


Unsnap the BtB connector with Front Opening Tool.

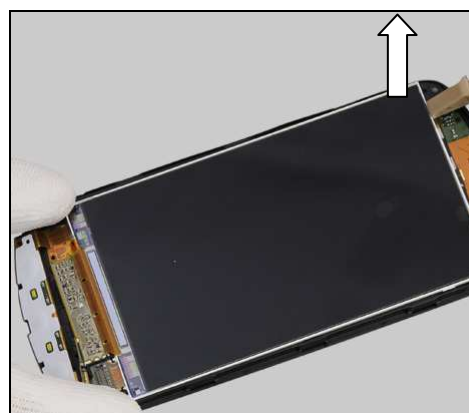


Disassembly

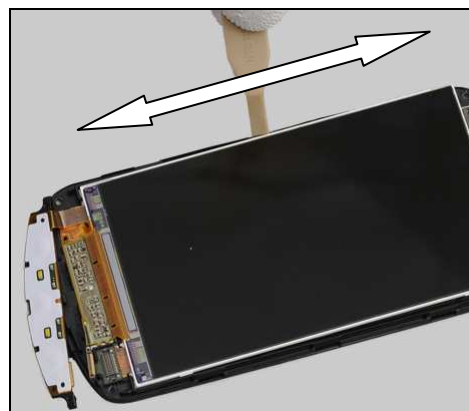
Detach the foil.



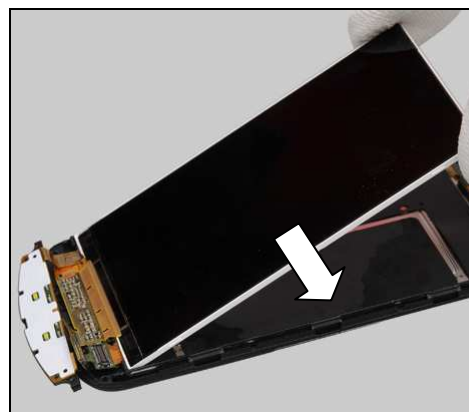
Insert Front Opening Tool to release the 3.7inch TFT LCD from upper left corner.



Slide along left side.



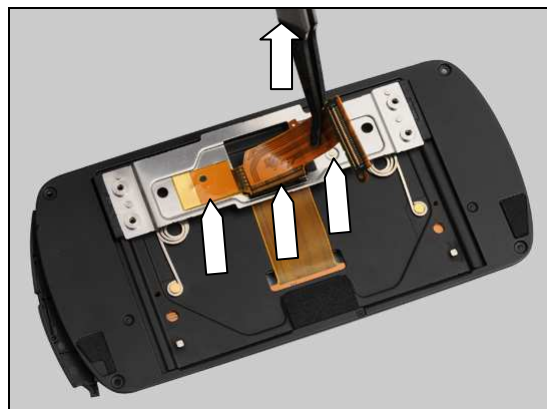
Lift up the 3.7inch TFT LCD and remove it gently.



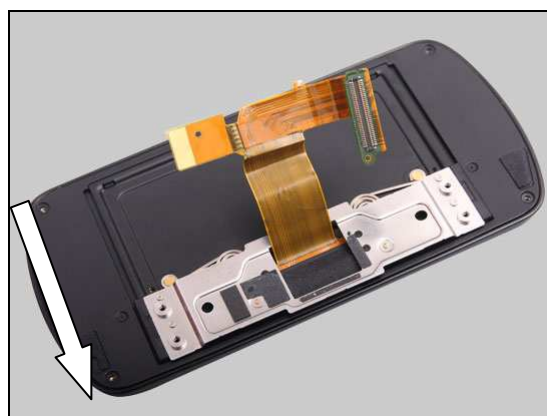
Disassembly

3.10 Slider Sub Assembly & Slider Flex FPC Assy

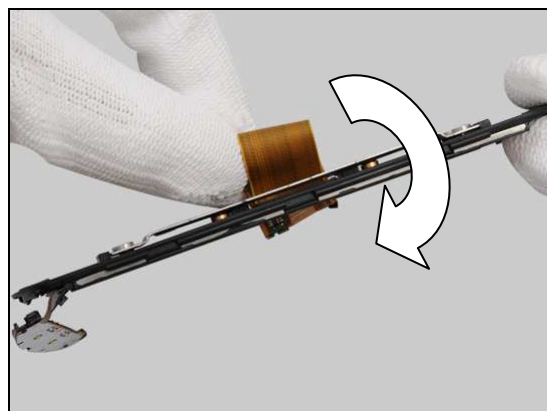
Detach the foil.



Slide the hinge to the other side.



Kink the FPC and move it through the slot with fingers.

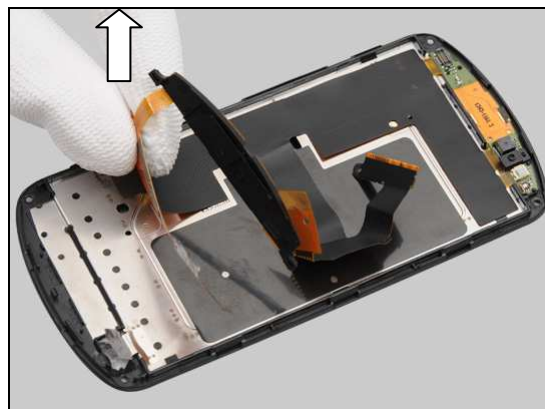


Pull out the FPC from the other side gently.

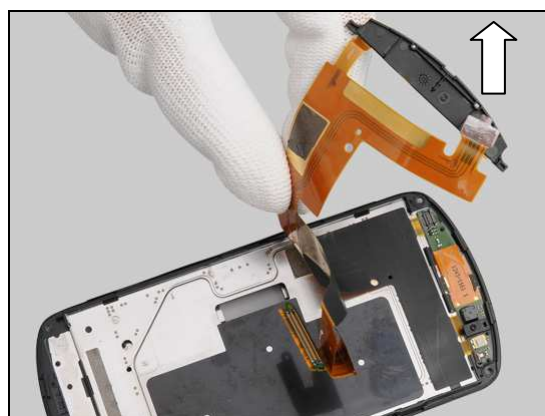


Disassembly

Peel off the Slider Flex FPC Assy gently from left side.



Peel off the Slider Flex FPC Assy gently.



Separate Slider Flex FPC Assy and Slider Sub Assembly.





4 Replacement

4.1 Cover Battery

Follow the 3.1 Disassembly instructions!

Prepare the new Cover Battery.

Follow the 5.10 Reassembly instructions!



4.2 Cover Lower Rear

Follow the 3.1 – 3.2 Disassembly instructions!

Follow the 4.13, 4.20, 4.23, 4.25 and 4.33 Removal instructions!

Prepare the new Cover Lower Rear.

Follow the 4.13, 4.20, 4.23, 4.25 and 4.33 Installation instructions!

Follow the 5.9 – 5.10 Reassembly instructions!



4.3 Key On/Off

Follow the 3.1 – 3.2 Disassembly instructions!

Follow the 3.3 Key On/Off Disassembly instructions!

Prepare the new Key On/Off.

Follow the 5.8 Key On/Off Reassembly instructions!

Follow the 5.9 – 5.10 Reassembly instructions!



4.4 Key Camera

Follow the 3.1 – 3.2 Disassembly instructions!

Follow the 3.3 Key Camera Disassembly instructions!

Prepare the new Key Camera.

Follow the 5.8 Key Camera Reassembly instructions!

Follow the 5.9 – 5.10 Reassembly instructions!



Replacement

4.5 Key Volume

Follow the 3.1 – 3.2 Disassembly instructions!

Follow the 3.3 Key Volume Disassembly instructions!

Prepare the new Key Volume.

Follow the 5.8 Key Volume Reassembly instructions!

Follow the 5.9 – 5.10 Reassembly instructions!

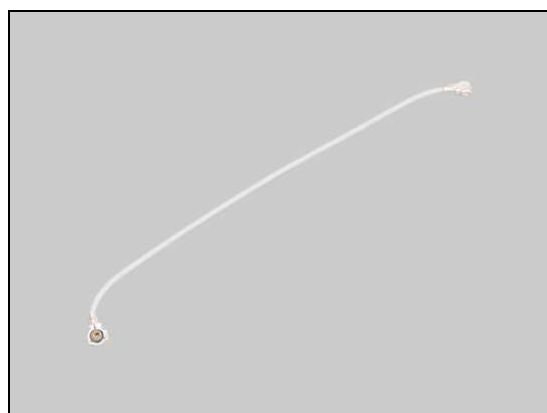


4.6 Cable RF

Follow the 3.1 – 3.4 Disassembly instructions!

Prepare the new Cable RF.

Follow the 5.7 – 5.10 Reassembly instructions!

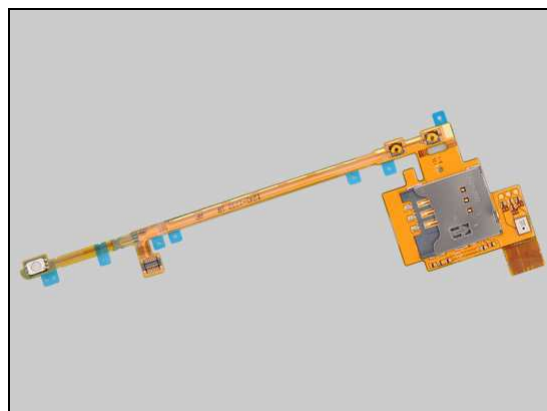


4.7 SIM Flex PBA Assy

Follow the 3.1 – 3.5 Disassembly instructions!

Prepare the new SIM Flex PBA Assy.

Follow the 5.6– 5.10 Reassembly instructions!



4.8 Front Cover Assy

Follow the 3.1 – 3.8 Disassembly instructions!

Follow the 4.17 and 4.18 Removal instructions!

Prepare the new Front Cover Assy.

Follow the 4.17 and 4.18 Installation instructions!

Follow the 5.3 – 5.10 Reassembly instructions!



Replacement

4.9 3.7inch TFT LCD

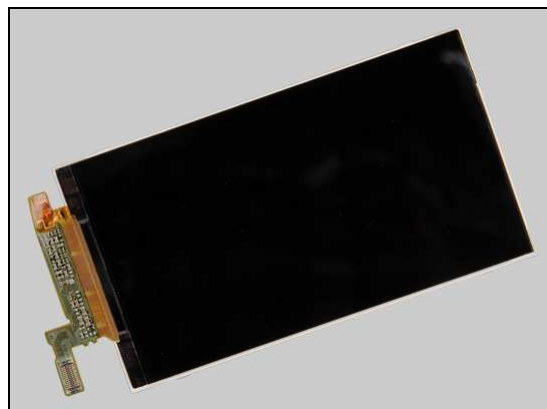
Follow the 3.1 – 3.9 Disassembly instructions!

Prepare the new 3.7inch TFT LCD.

Follow the 5.2 Reassembly instructions!

Follow the 4.9 Installation instructions!

Follow the 5.3– 5.10 Reassembly instructions!



4.10 Slider Sub Assembly

Follow the 3.1 – 3.10 Disassembly instructions!

Prepare the new Slider Sub Assembly.

Follow the 5.1 - 5.10 Reassembly instructions!

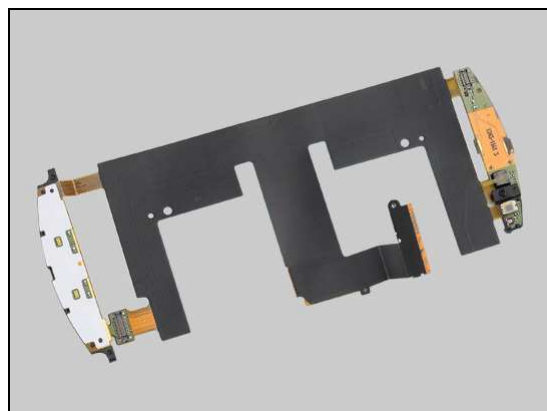


4.11 Slider Flex FPC Assy

Follow the 3.1 – 3.10 Disassembly instructions!

Prepare the new Slider Flex FPC Assy.

Follow the 5.1 – 5.10 Reassembly instructions!





Replacement

4.12 Cap HDMI

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

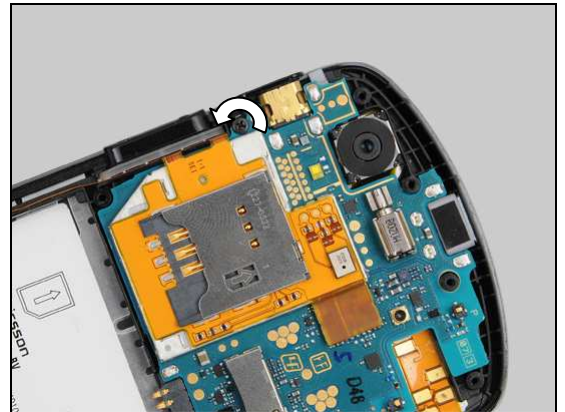
Prepare the new Cap HDMI.

Carry out the Installation as described below.

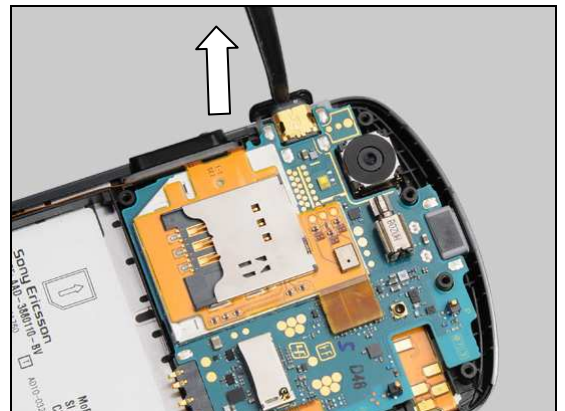
Follow the 5.9 – 5.10 Reassembly instructions!

REMOVAL

Remove the Screw Phillips Len:3.0 Diam:1.4 by a screwdriver with Bits (JCIS No 0).

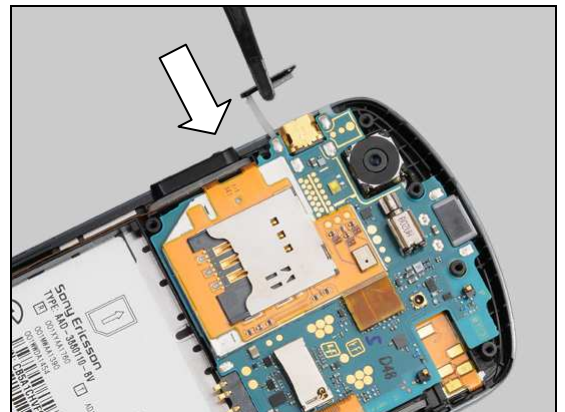


Remove the Cap HDMI.



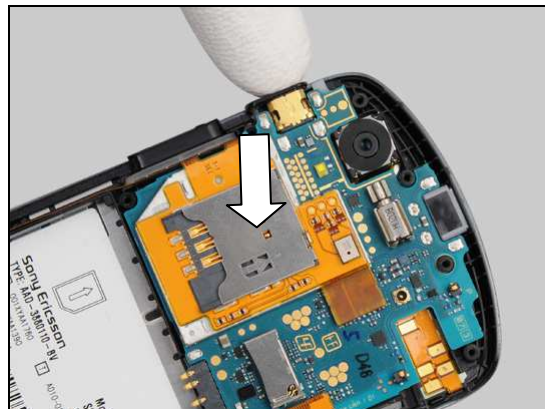
INSTALLATION

Insert the Cap HDMI into the hole.



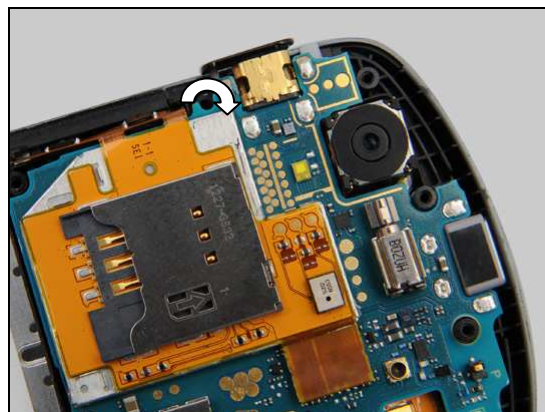
Replacement: Cap HDMI

Press to secure its position.



Apply 11 ± 1 Ncm torque when tightening the Screw Phillips
Len:3.0 Diam:1.4 with Bits (JCIS No 0).

Use new screw!





Replacement

4.13 Cap RF

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

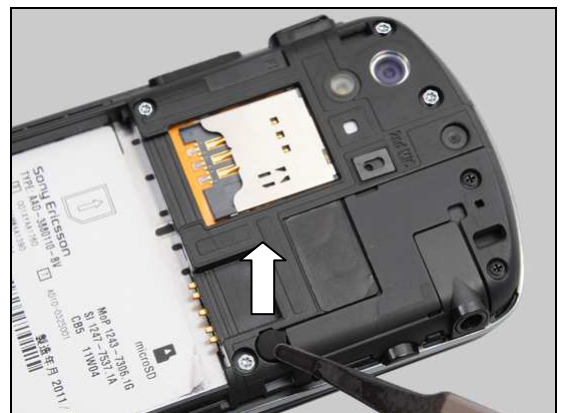
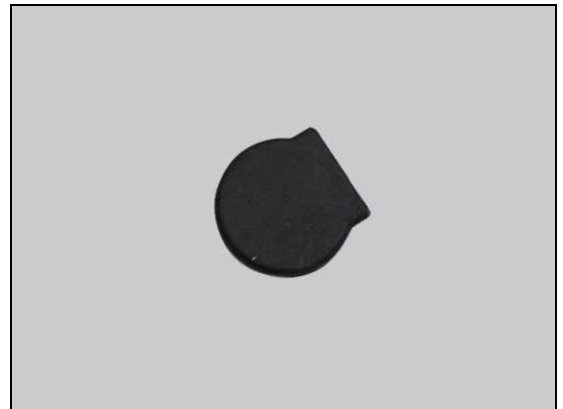
Prepare the new Cap RF.

Carry out the Installation as described below.

Follow the 5.10 Reassembly instructions!

REMOVAL

Lift up Cap RF with Flex Film Assembly Tool and remove it.

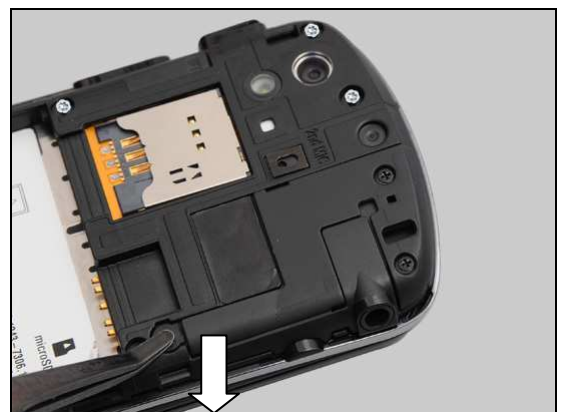


INSTALLATION

Prepare a new Cap RF in the correct position in the correct position.



Press to secure its position.





Replacement

4.14 Core Unit Phone Label

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Core Unit Phone Label.

Carry out the Installation as described below.

Follow the 5.10 Reassembly instructions!

REMOVAL

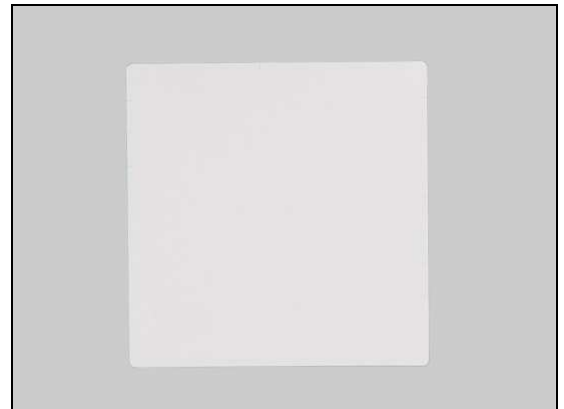
Copy old Core Unit Label information into the 'LabelMake' program.

Carefully remove the Label with Flex Film Assembly Tool.

INSTALLATION

Check that the correct label format is loaded in the Zebra printer and print a new Label by using the 'LabelMake' software.

One label only is allowed!



Replacement: Core Unit Phone Label

Press along the surface to make Label securely attached.





Replacement

4.15 Sub PBA

Follow the 3.1 – 3.6 Disassembly instructions!

Follow the 4.27 Removal instructions!

Carry out the Removal as described below.

Prepare the new Cover Lower Front.

Carry out the Installation as described below.

Follow the 4.27 Installation instructions!

Follow the 5.5 – 5.10 Reassembly instructions!

REMOVAL

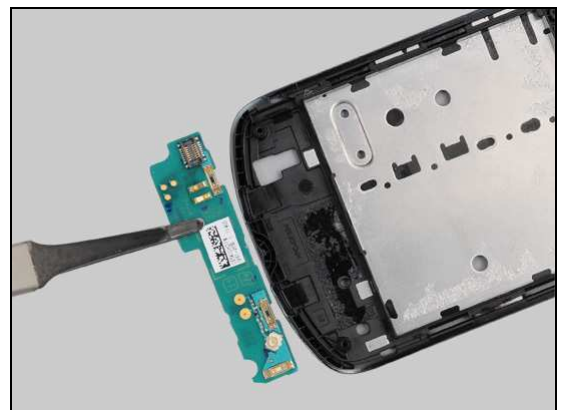
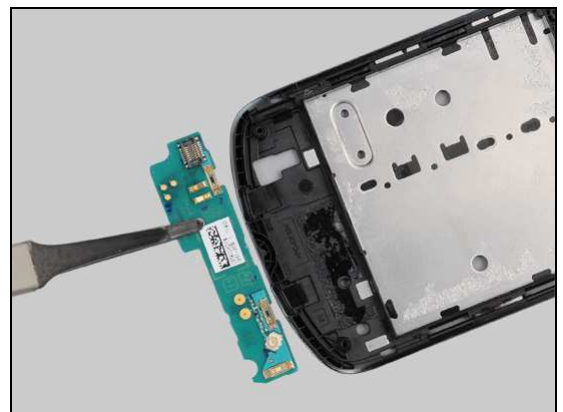
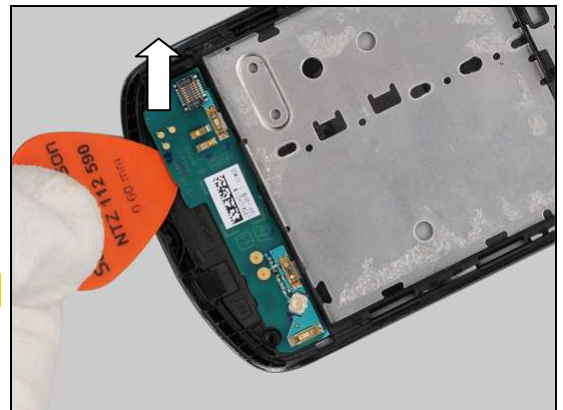
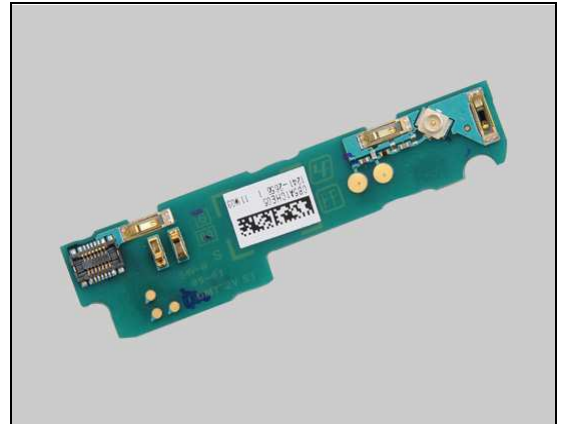
Insert a guitar pick underneath the sub PBA to detach the foil and Lift up the sub PBA.

Do not slide the guitar pick directly!

Remove the sub PBA.

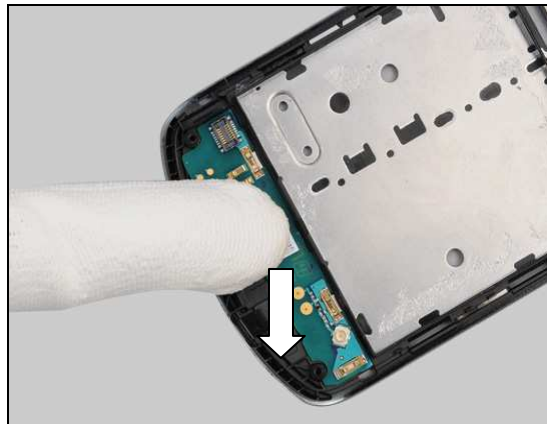
INSTALLATION

Prepare a new sub PBA in the correct position in the correct position.



Replacement: Cover Lower Front

Press to secure its attachment.



Replacement

4.16 Cover Panel Lower Front

Follow the 3.1 – 3.6 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cover Panel Lower Front.

Carry out the Installation as described below.

Follow the 5.5 – 5.10 Reassembly instructions!

REMOVAL

Insert the Guitar Pick to release the hooks and foil from upper right corner and slide along right side.



Slide along bottom side.



Slide along left side.

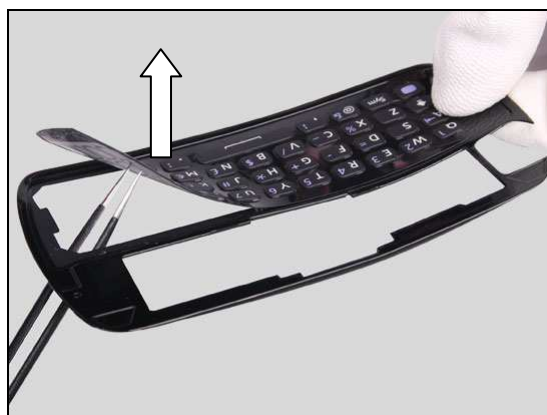


Replacement: Cover Panel Lower Front

Remove the Cover Panel Lower Front.



Push the Keyboard from inside to release the foil.



Peel off the Keyboard.



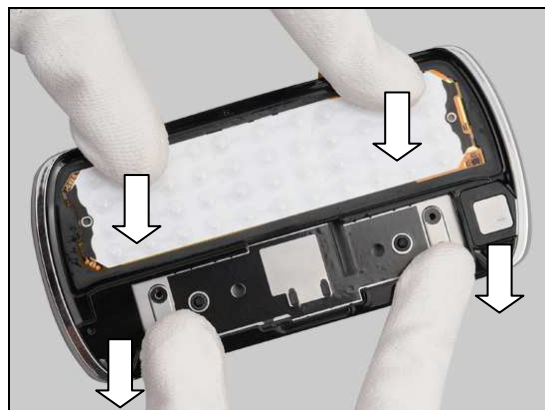
INSTALLATION

Place the Cover Panel Lower Front in the correct position.



Replacement: Cover Panel Lower Front

Press along surface to secure its attachment.



Place the Keyboard into position in the correct direction.



Press along surface to secure its attachment.





Replacement

4.17 Ear Speaker

Follow the 3.1 – 3.8 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Ear Speaker.

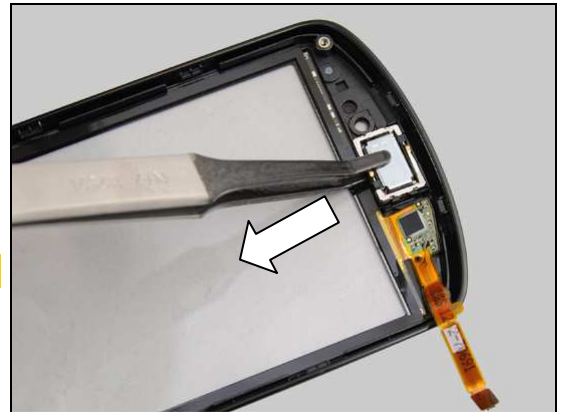
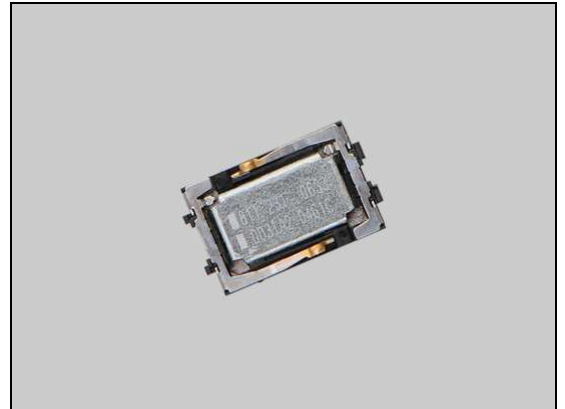
Carry out the Installation as described below.

Follow the 5.3 – 5.10 Reassembly instructions!

REMOVAL

Remove the Ear Speaker with Flex Film Assembly Tool.

Do not touch the pins!



INSTALLATION

Place the new Ear Speaker into the cavity.

Note the correct position of the Ear Speaker.

Note the correct direction of the Ear Speaker.



Press to secure its position and attachment.



Replacement

4.18 Key Upper

Follow the 3.1 – 3.8 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Key Upper.

Carry out the Installation as described below.

Follow the 5.3 – 5.10 Reassembly instructions!

REMOVAL

Push the Key Upper from outside.



Remove it with Flex Film Assembly Tool.



INSTALLATION

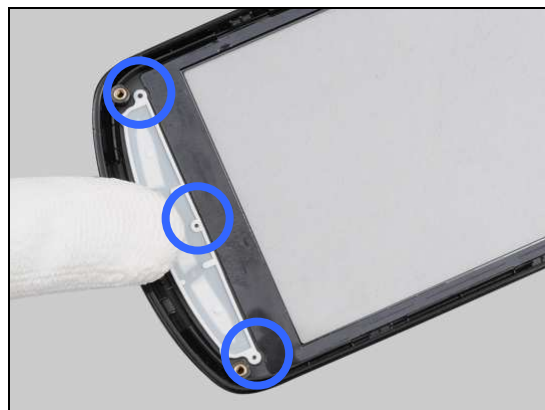
Place the new Key Upper in the correct position.



Replacement: Key Upper

Press to secure its position.

Align the Key Upper into the three guiding hole.





Replacement

4.19 Keyboard

Carry out the Removal as described below.

Prepare the new Keyboard.

Carry out the Installation as described below.

REMOVAL

Slide to open the phone.

Puncture hole at upper right corner on Keyboard with Dentist Hook.

Lift up the Keyboard and remove it.

Scrap! Not to be reused!



Replacement: Keyboard

INSTALLATION

Place the new Keyboard in the correct position.



Press to secure its position and attachment.





Replacement

4.20 Main Antenna

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Main Antenna.

Carry out the Installation as described below.

Follow the 4.24 Installation instructions!

Follow the 5.10 Reassembly instructions!

REMOVAL

Remove the two Screw Other Len:5.0 Diam:1.4 by a screwdriver with Bits (JCIS No 0).

Insert Front Opening Tool to lift up Main Antenna and remove it.

INSTALLATION

Place the Main Antenna in the correct position.



Replacement: Main Antenna

Press to secure its position.



Apply 14 ± 1 Ncm torque when tightening the two Screw
Other Len:5.0 Diam:1.4 with Bits (JCIS No 0).

Use new screws!





Replacement

4.21 Main Camera

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Main Camera.

Carry out the Installation as described below.

Follow the 5.7 – 5.10 Reassembly instructions!

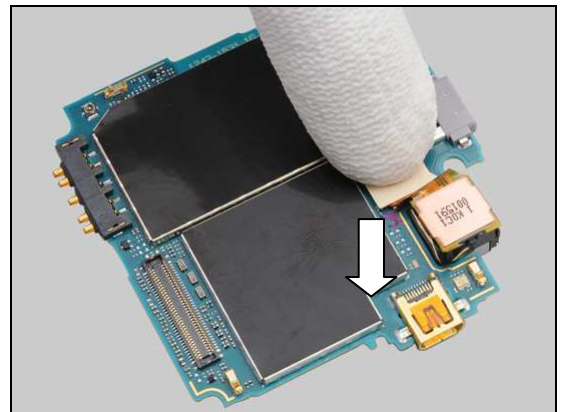
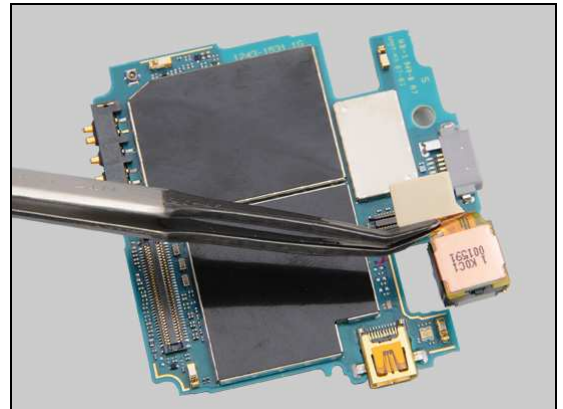
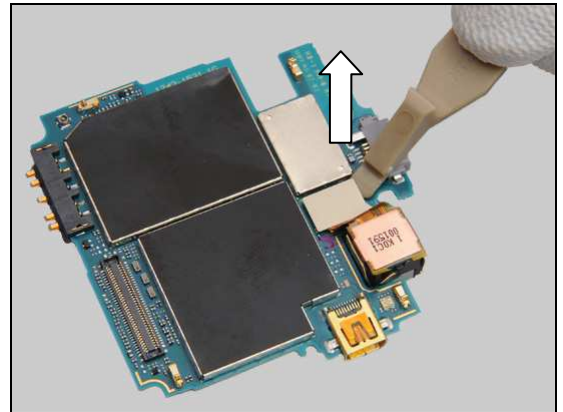
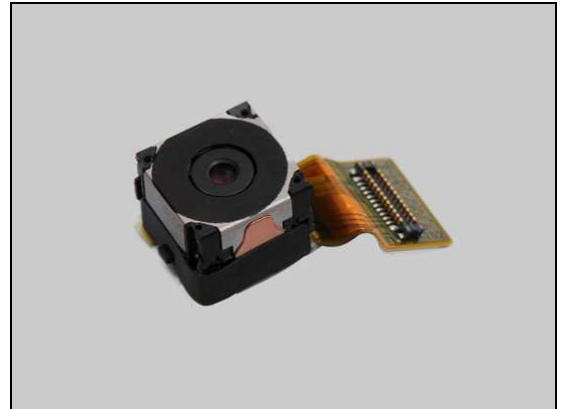
REMOVAL

Unsnap the BtB connector with Front Opening Tool and remove it.

INSTALLATION

Place the Camera into socket.

Snap the BtB connector with fingers to secure.



Replacement

4.22 MComp Sheet Slider LF

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below.

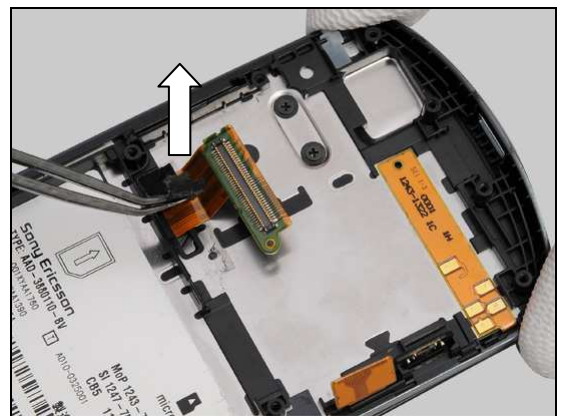
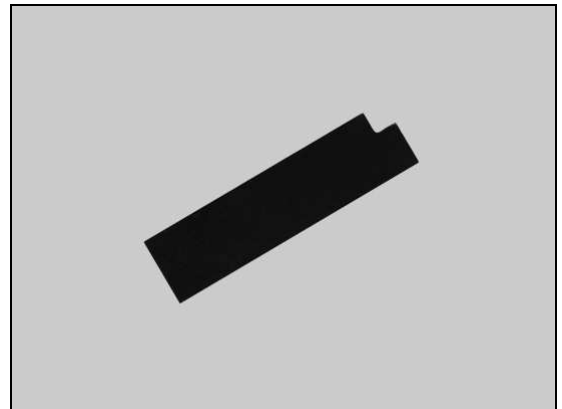
Prepare the new MComp Sheet Slider LF.

Carry out the Installation as described below.

Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

Peel off MComp Sheet Slider LF with Flex Film Assembly Tool.

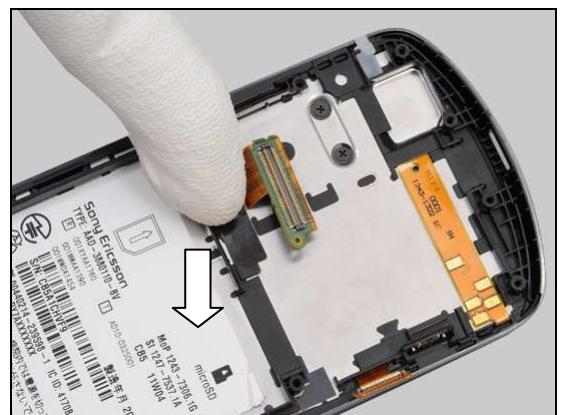


INSTALLATION

Place the new MComp Sheet Slider LF in the correct position.



Press to secure its attachment by fingers.





Replacement

4.23 MComp Sheet TP

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new MComp Sheet TP.

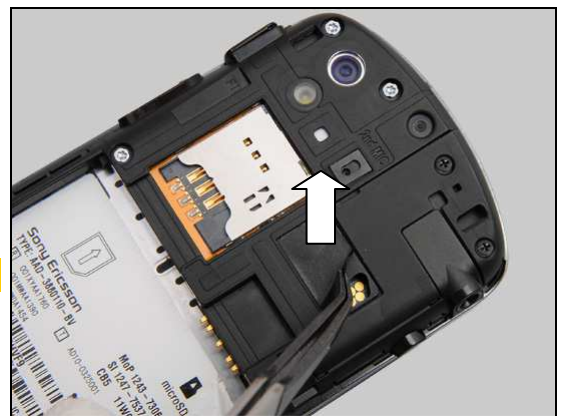
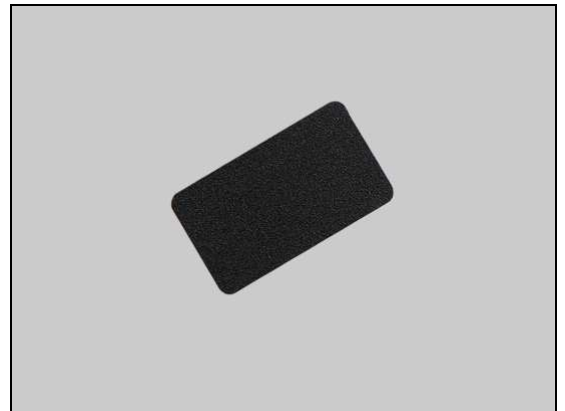
Carry out the Installation as described below.

Follow the 5.10 Reassembly instructions!

REMOVAL

Detach the MComp Sheet TP with Flex Film Assembly Tool.

Scrap! Not to be reused!

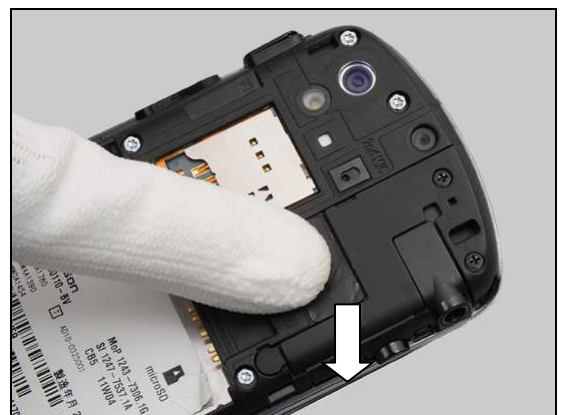


INSTALLATION

Place the new MComp Sheet TP in the correct position.



Press to secure its attachment.



Replacement

4.24 MComp Sheet USB

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new MComp Sheet USB.

Carry out the Installation as described below.

Follow the 5.10 Reassembly instructions!

REMOVAL

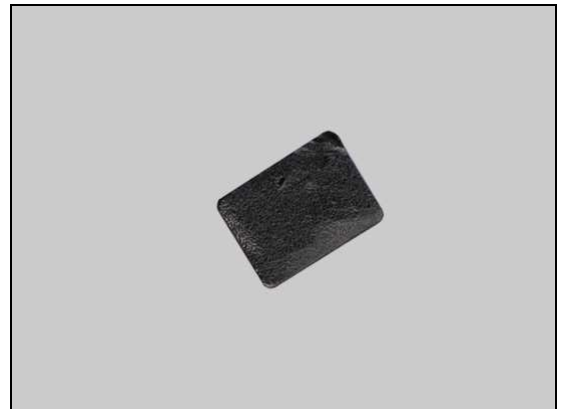
Detach the MComp Sheet USB with Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place the new MComp Sheet USB in the correct position.

Press to secure its attachment.





Replacement

4.25 Non-cellular Antenna

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Non-cellular Antenna.

Carry out the Installation as described below.

Follow the 5.10 Reassembly instructions!

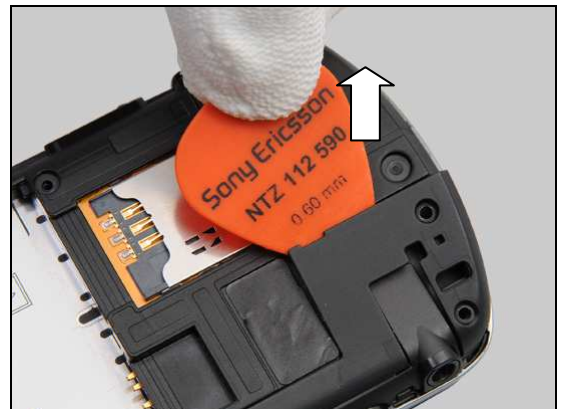
REMOVAL

Remove the two Screw Other Len:5.0 Diam:1.4 by a screwdriver with Bits (JCIS No 0).



REMOVAL

Release the hook and foil with Guitar Pick from upper right corner and remove it.



INSTALLATION

Place the new Non-cellular Antenna in the correct position.



Replacement: Non-cellular Antenna

Press to secure its position and attachment.



Apply 14 ± 1 Ncm torque when tightening the two Screw
Other Len:5.0 Diam:1.4 with Bits (JCIS No 0).

Use new screws!





Replacement

4.26 Proximity Sensor Tape

Follow the 3.1 - 3.8 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Proximity Sensor Tape.

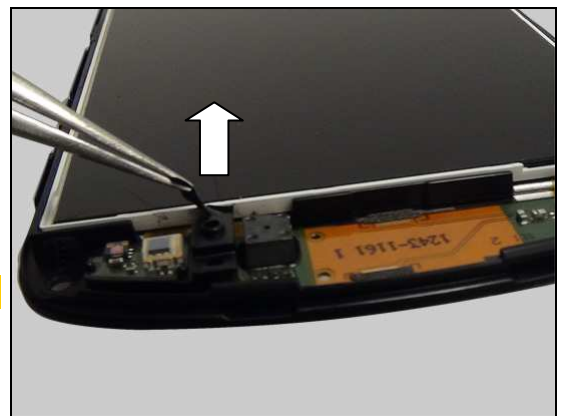
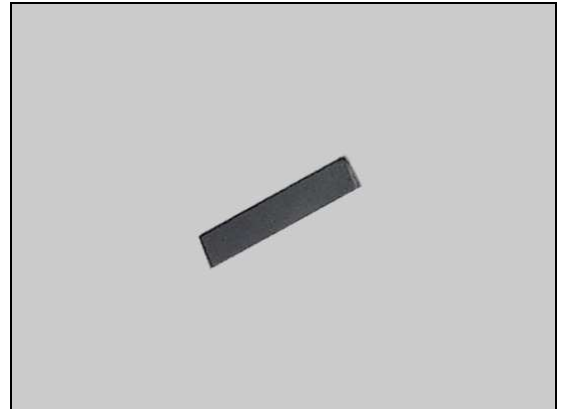
Carry out the Installation as described below.

Follow the 5.3 - 5.10 Reassembly instructions!

REMOVAL

Detach the Proximity Sensor Tape with Flex Film Assembly Tool.

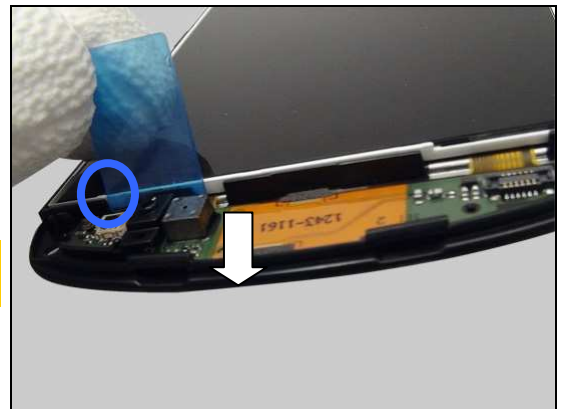
Scrap! Not to be reused!



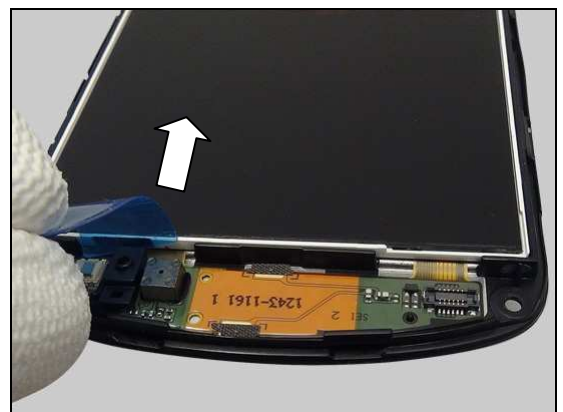
INSTALLATION

Insert Proximity Sensor Tape completely.

Note: Insert Proximity Sensor Tape align the tape as shown.



Bend separator to secure Proximity Sensor Tape attachment on white frame and remove the separator.



Replacement

4.27 Qwerty Key Flex PBA

Follow the 3.1 – 3.6 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Qwerty Key Flex PBA.

Carry out the Installation as described below.

Follow the 5.5 – 5.10 Reassembly instructions!

REMOVAL

Insert the Guitar Pick to release the hooks and foil from upper right corner and slide along right side.



Slide along bottom side.



Slide along left side.

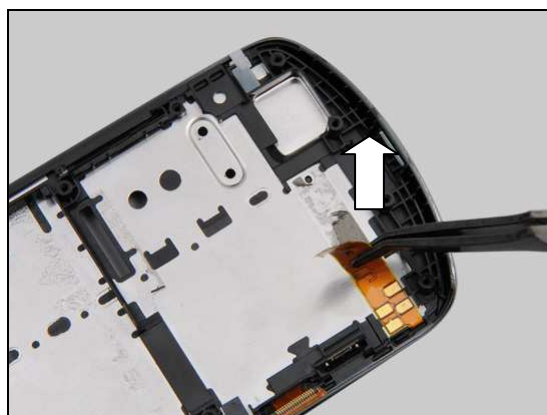


Replacement: Qwerty Key Flex PBA

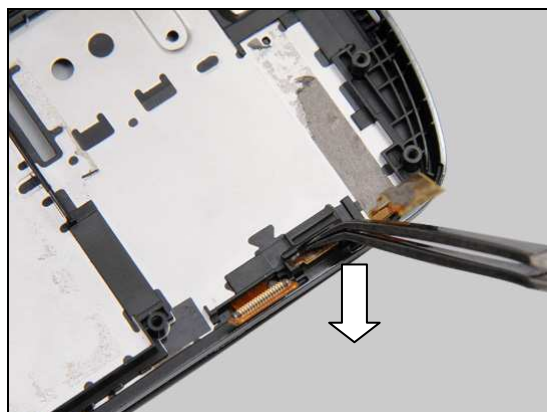
Remove the Cover Panel Lower Front.



Detach the FPC with Flex Film Assembly Tool.



Detach the key dome with Flex Film Assembly Tool.



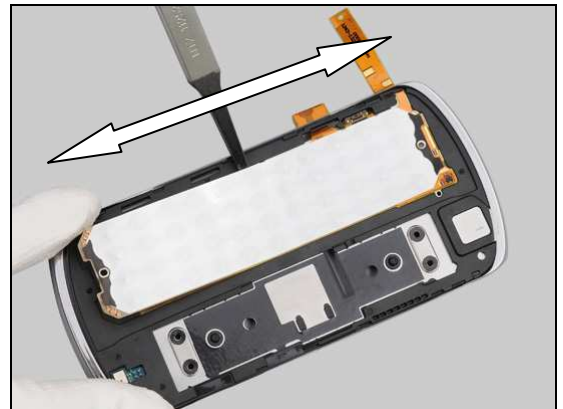
Detach the foil with Flex Film Assembly Tool from upper right and slide along right side.



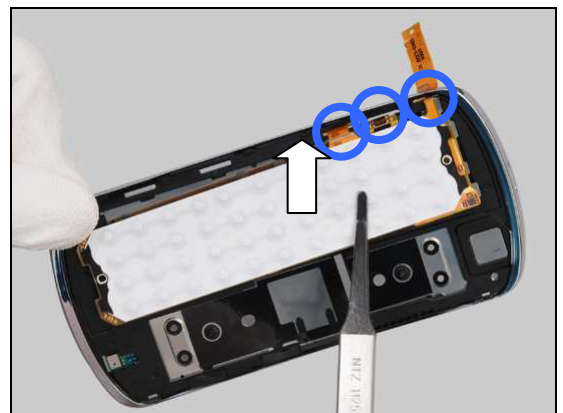


Replacement: Qwerty Key Flex PBA

Do the same for the other side.

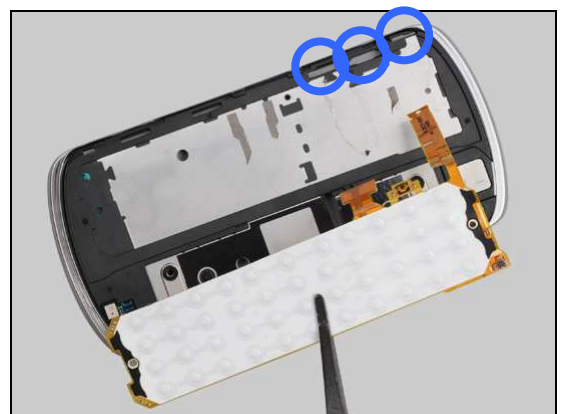


Lift up the Qwerty Key Flex PBA from the three slots.

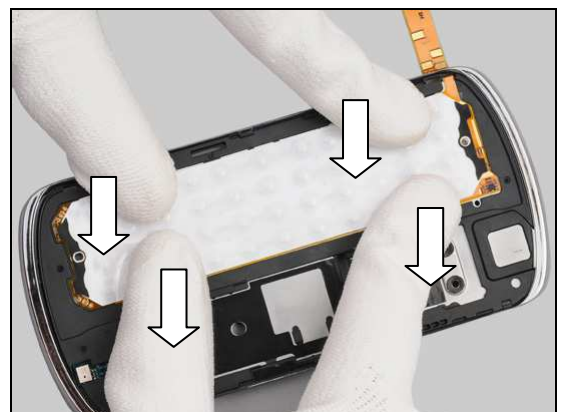


INSTALLATION

Place the new Qwerty Key Flex PBA in the correct position and thread it into the three alignment slots.

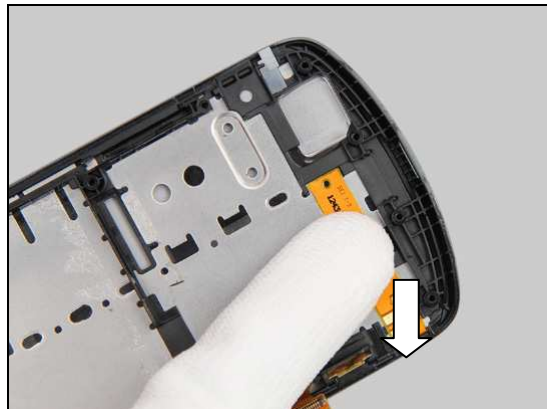


Press to secure its attachment.

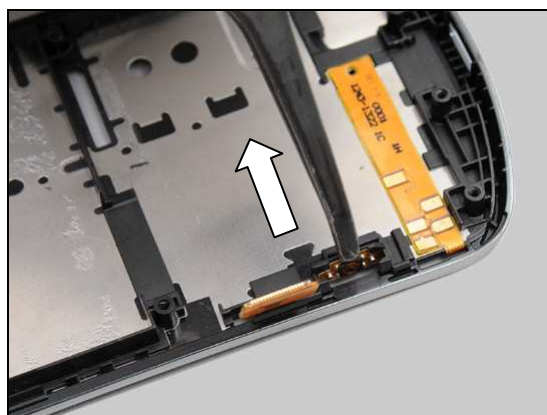


Replacement: Qwerty Key Flex PBA

Press to secure its attachment.



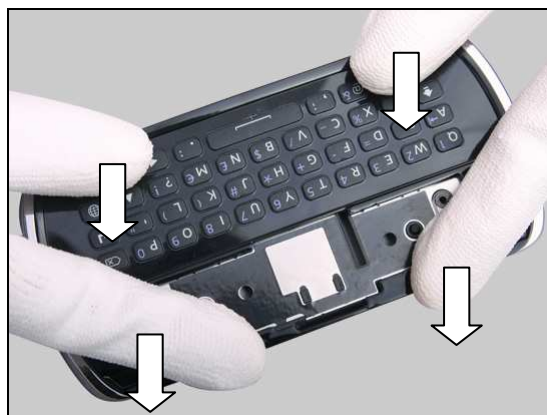
Press to secure its attachment with Flex Film Assembly Tool.



Place the Cover Panel Lower Front in the correct position.



Press along surface to secure its attachment.



Replacement

4.28 Sheet Screw

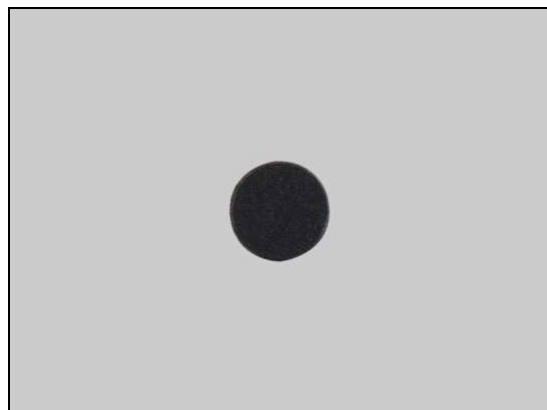
Carry out the Removal as described below.

Prepare the new Sheet Screw.

Carry out the Installation as described below.

REMOVAL

Slide to open the phone.



Detach Sheet Screw with Flex Film Assembly Tool.

Scrap! Not to be reused!



INSTALLATION

Place the new Sheet Screw in the correct position.



Replacement: Sheet Screw

Press to secure its attachment.





Replacement

4.29 Shield Can Lid MSM

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Shield Can Lid MSM.

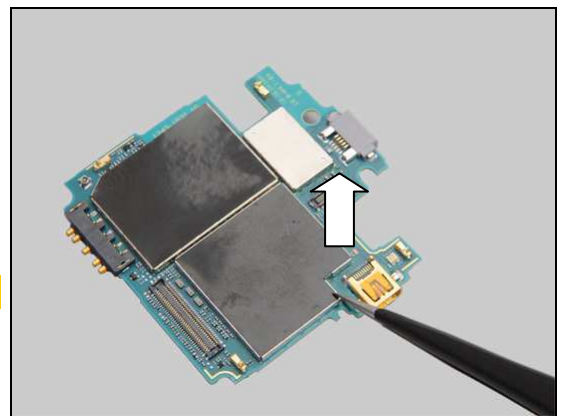
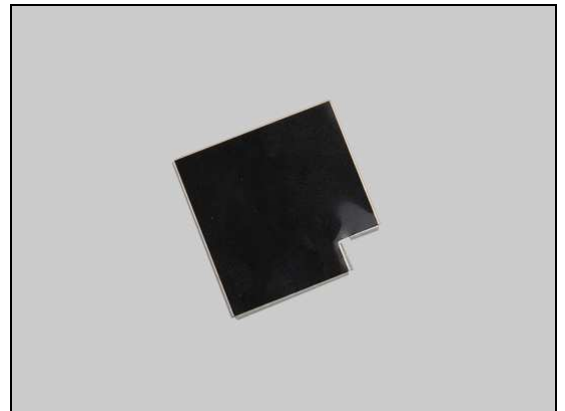
Carry out the Installation as described below.

Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

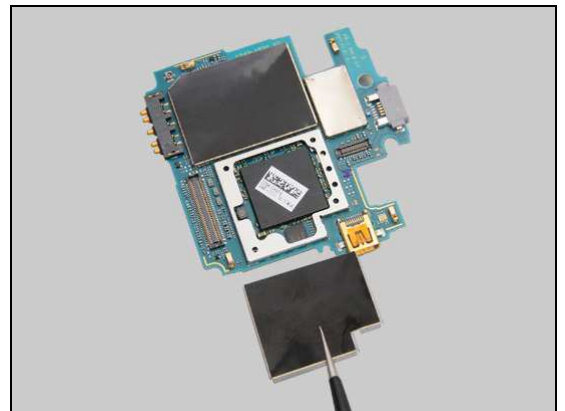
Unsnap the corners of the Shield Can Lid MSM with a pair of tweezers and remove it.

Scrap! Not to be reused!

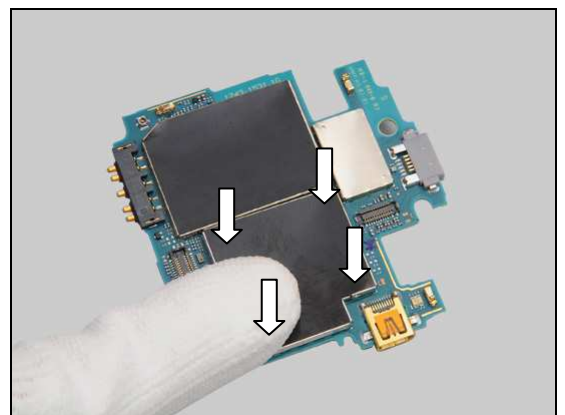


INSTALLATION

Place a new Shield Can Lid MSM into correct position.



Press to snap it into position.





Replacement

4.30 Shield Can Lid PMIC

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Shield Can Lid PMIC.

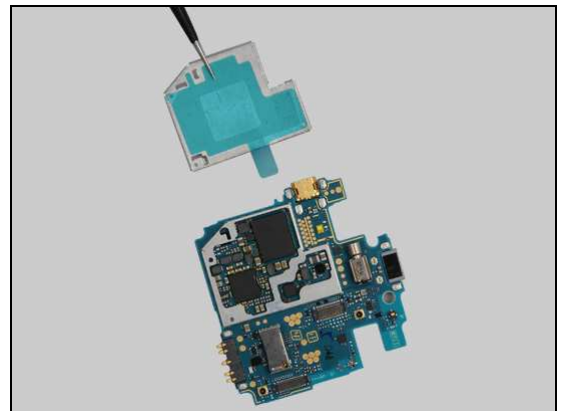
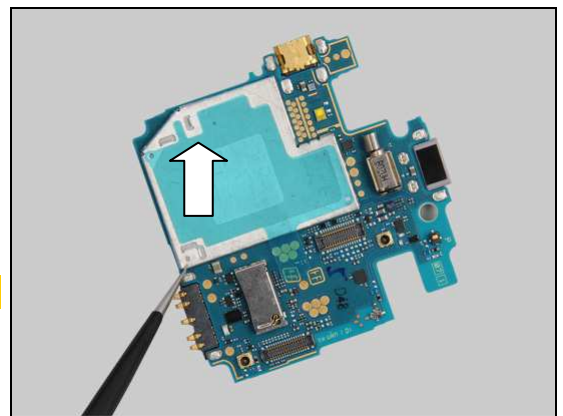
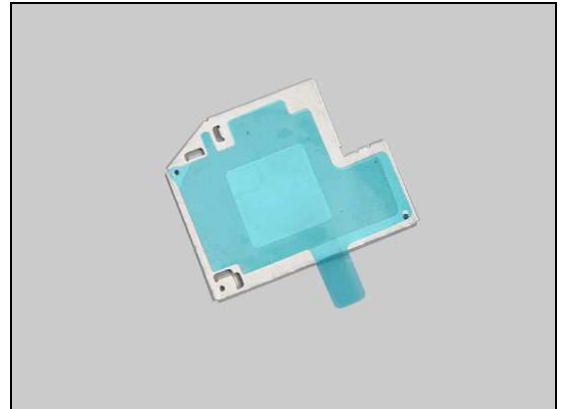
Carry out the Installation as described below.

Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

Unsnap the corners of the Shield Can Lid PMIC with a pair of tweezers and remove it.

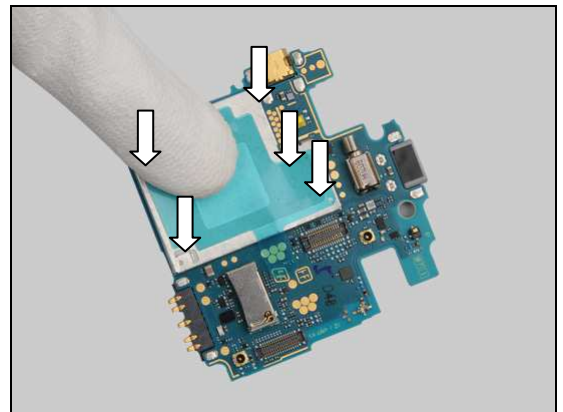
Scrap! Not to be reused!



INSTALLATION

Place a new Shield Can Lid PMIC into correct position.

Press to snap it into position.



Replacement

4.31 Shield Can Lid RF

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Shield Can Lid RF.

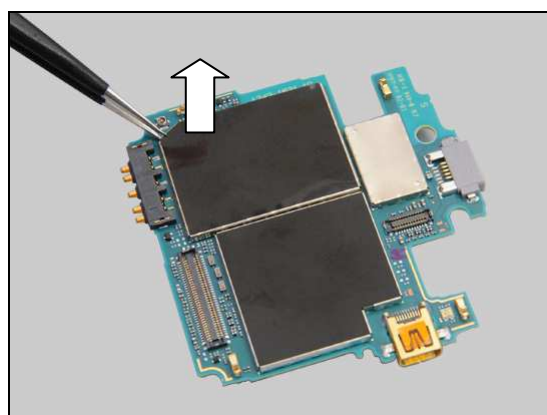
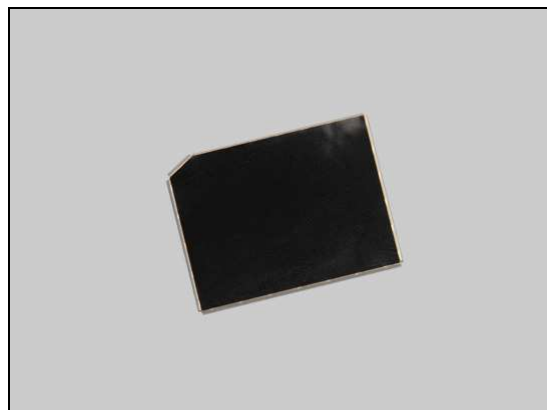
Carry out the Installation as described below.

Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

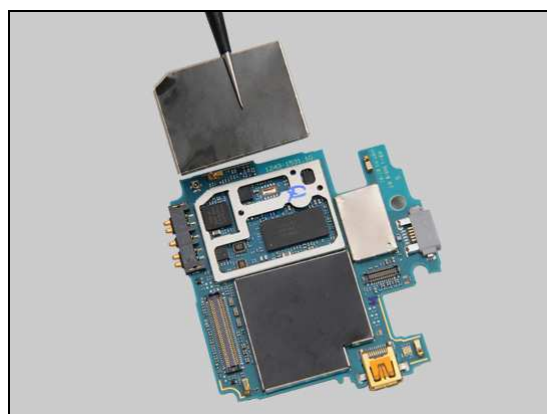
Unsnap the corners of the Shield Can Lid RF with a pair of tweezers and remove it.

Scrap! Not to be reused!

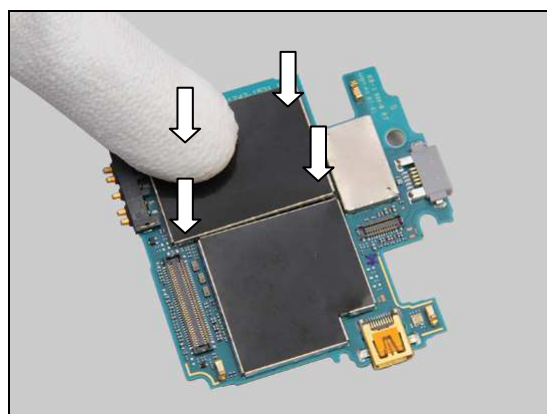


INSTALLATION

Place a new Shield Can Lid RF into correct position.



Press to snap it into position.



Replacement

4.32 Shield Can Lid WLAN

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Shield Can Lid WLAN.

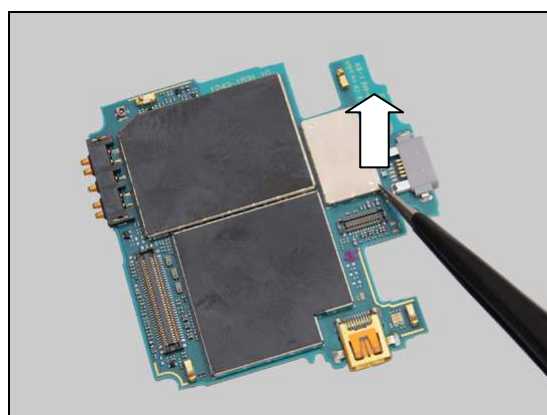
Carry out the Installation as described below.

Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

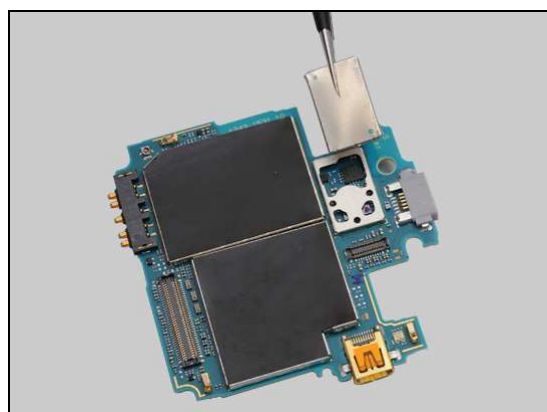
Unsnap the corners of the Shield Can Lid WLAN with a pair of tweezers and remove it.

Scrap! Not to be reused!

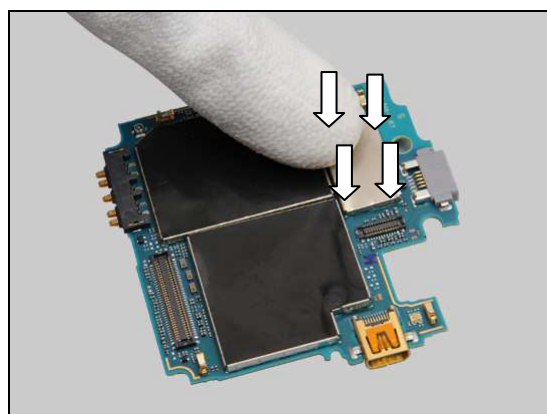


INSTALLATION

Place a new Shield Can Lid WLAN into correct position.



Press to snap it into position.



Replacement

4.33 Water Indicator

Check whether the Liquid Intrusion Indicator has been activated (reddish color).

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

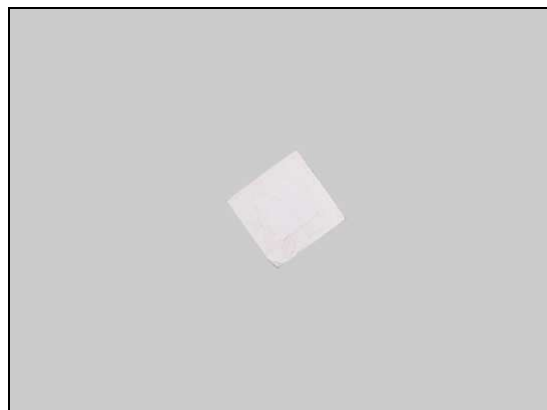
Prepare the new Water Indicator.

Carry out the Installation as described below.

Follow the 5.9 – 5.10 Reassembly instructions!

REMOVAL

Push the Water Indicator from outside to release the foil.



Remove the Water Indicator from inside.

Scrap! Not to be reused!



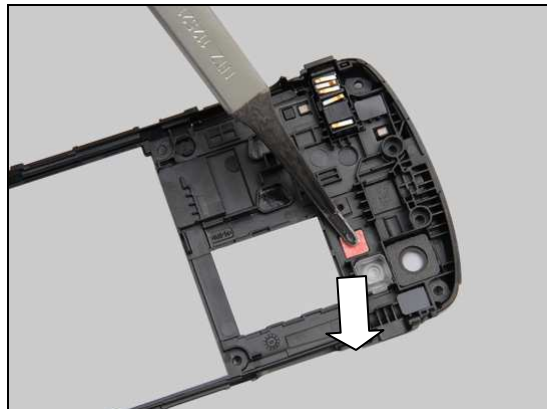
INSTALLATION

Place the new Water Indicator into correct position.



Replacement: Water Indicator

Press to secure its attachment.





Replacement

4.34 Board Swap - Replacement

Follow the 3.1 – 3.4 Disassembly instructions.

Follow the 4.7, Removal instruction.

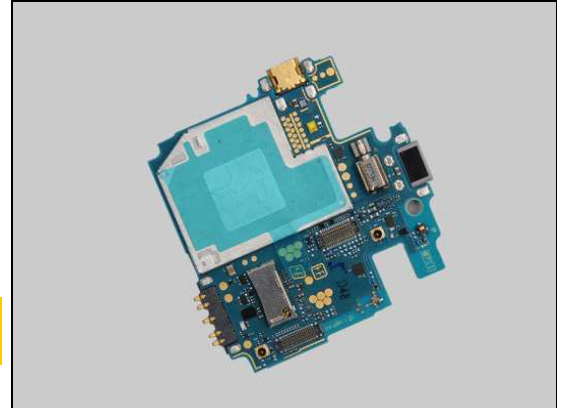
Replace the Swap Board.

Reuse Camera

Follow the 4.7, Installation instruction.

Follow the 5.6 – 5.10 Reassembly instructions.

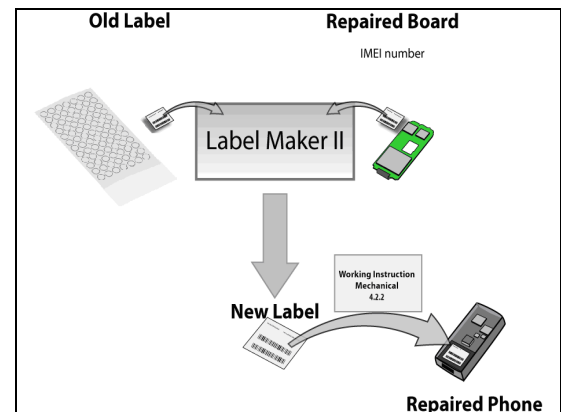
Startup the unit to initialize settings, before performing Customize Phone in Emma.



4.35 Board Swap – Change Label

CHANGE LABEL

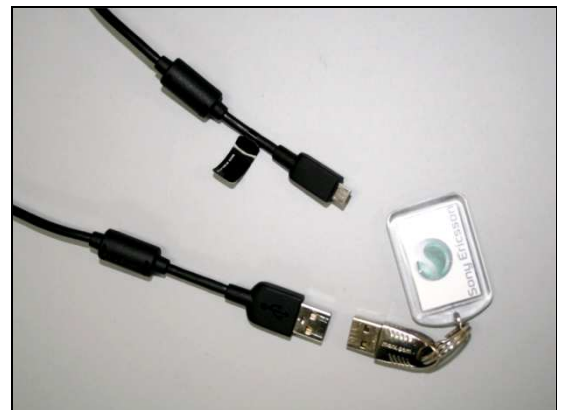
Follow the instructions in the Generic Repair Manual – Build swap for change of label.



4.36 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

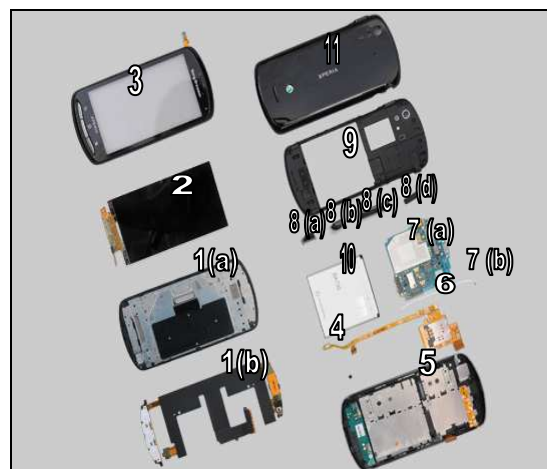
Follow the instructions in the Generic Repair Manual – Build swap for customization of the software.



5 Reassembly

The reassembly is done in the following order:

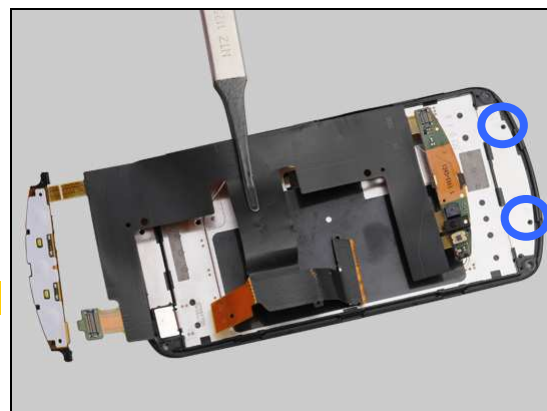
1. Slider Sub Assembly (a) & Slider Flex FPC Assy (b)
2. 3.7inch TFT LCD
3. Front Cover Assy
4. Sheet Screw
5. Cover Lower Front
6. SIM Flex PBA Assy
7. Main PBA (a) & Cable RF (b)
8. Key On/Off (a) & Key Camera (b) & Key Volume (c) & Cap HDMI (d)
9. Cover Lower Rear
10. Battery
11. Cover Battery



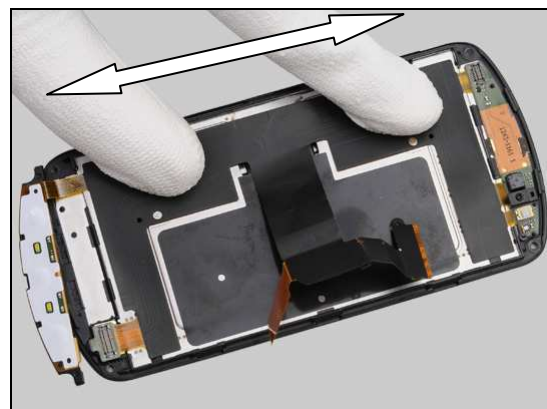
5.1 Slider Sub Assembly & Slider Flex FPC Assy

Place the Slider Flex FPC Assy into correct position.

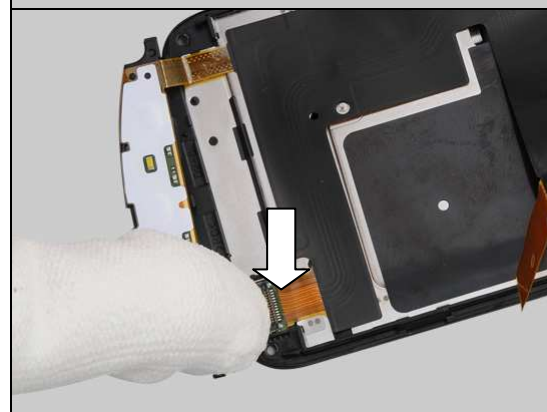
Note the two guiding holes at top!



Press along the surface to secure the FPC's position and attachment.



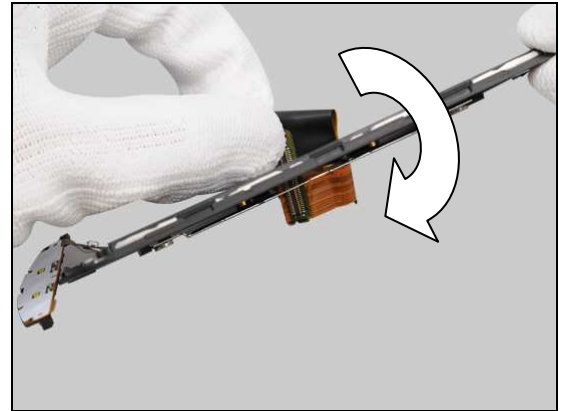
Press to secure the connector's position and attachment.



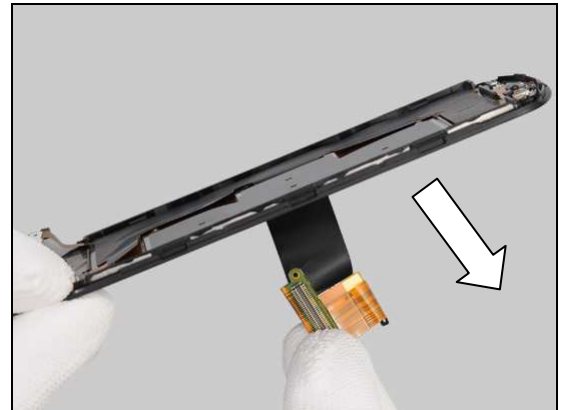


Reassembly

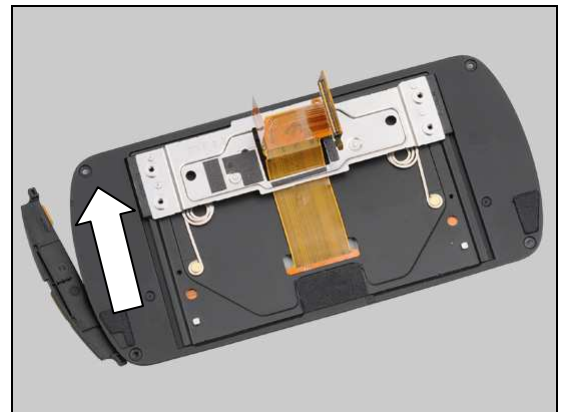
Kink the FPC and thread it into the slot gently.



Gently pull the FPC out from the other side gently.

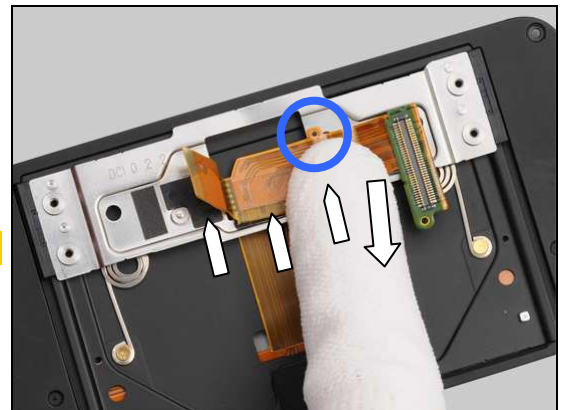


Slide the hinge to the other side.



Press to secure the FPC's attachment of three guiding positions.

Note the guiding hole to secure its position.





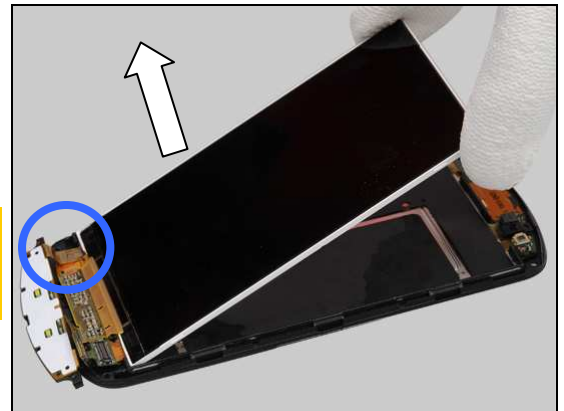
Reassembly

5.2 3.7inch TFT LCD

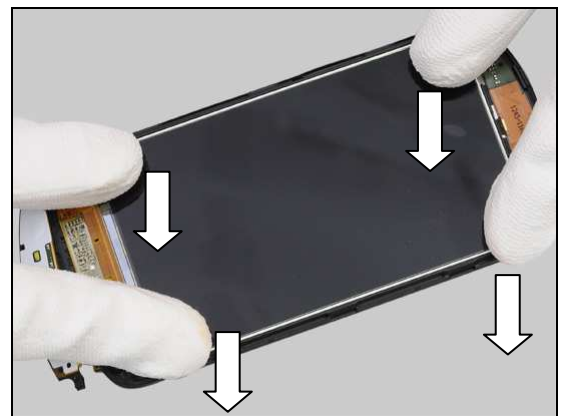
Place the Display onto Slider Sub Assembly.

Do not touch the front of Display.

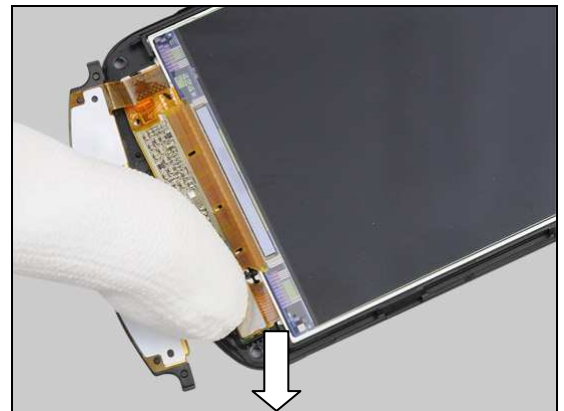
Place the LCD FPC under the FPC of Slider Flex FPC Assy.



Press the corners to secure its position.



Snap the BtB connector securing its connection.

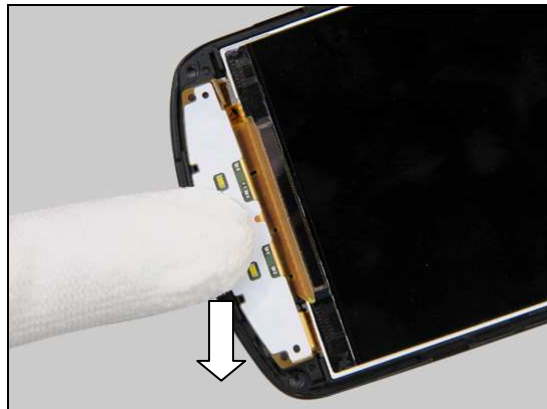


Insert the key dome into the cavity.



Reassembly

Press to snap it into position.



Check that no damage to Proximity Sensor Tape on white frame of LCD before continuing with assembly!



5.3 Front Cover Assy

Snap the BT connector securing its connection.



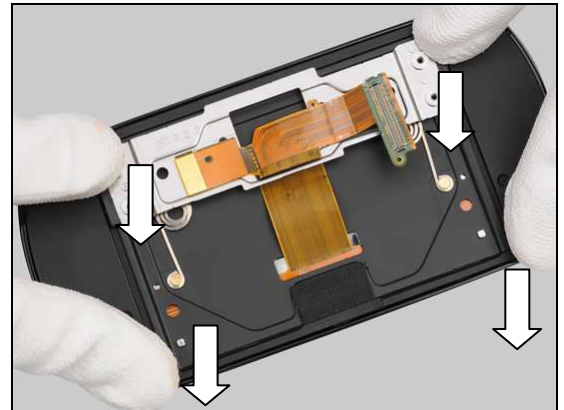
Place the Front Cover Assy into correct position.





Reassembly

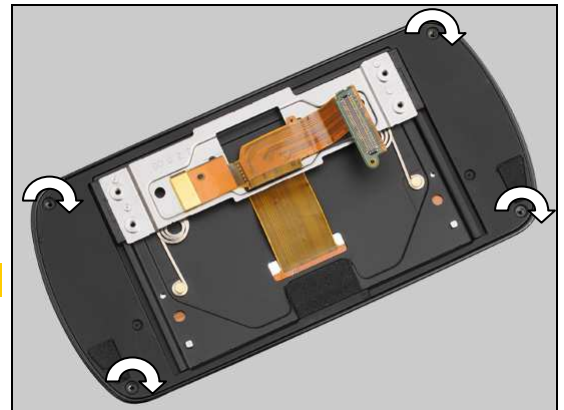
Press to snap the hooks.



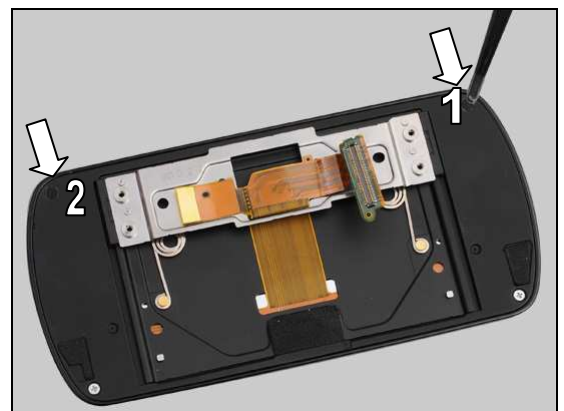
5.4 Sheet Screw

Apply 11 ± 1 Ncm torque when tightening the four Screw Phillips Len:2.5 Diam:1.4 M with Bits (JCIS No 0).

Use new screws!



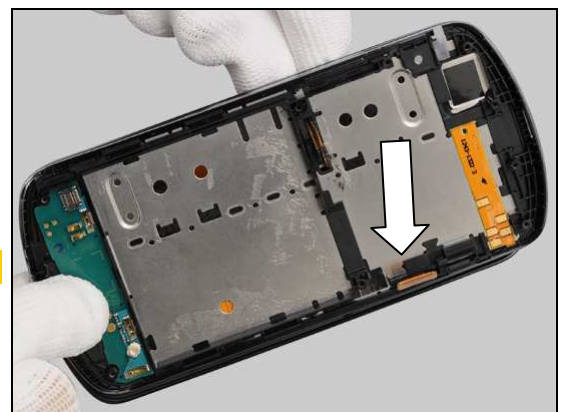
Attach the two Sheet Screws into correct position.



5.5 Cover Lower Front

Move the FPC through the slot gently.

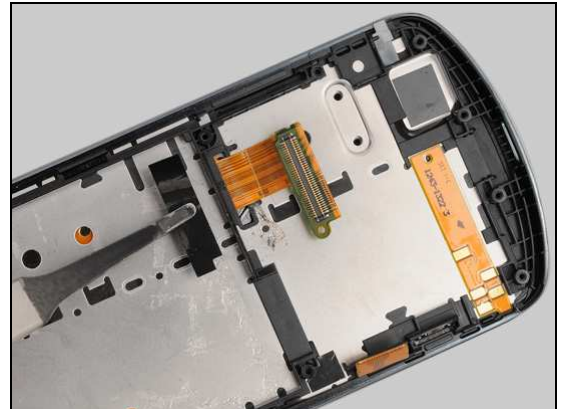
Make sure the correct position of four screw holes.



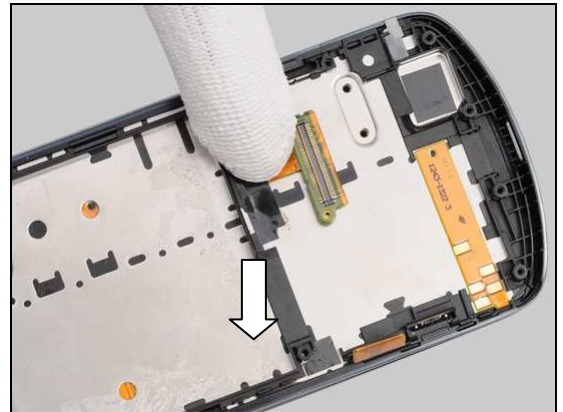


Reassembly

Place the new MComp Sheet Slider LF into correct position.

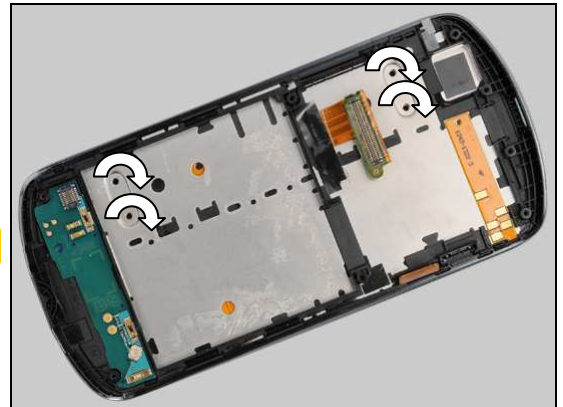


Press to secure its attachment.



Apply 11 ± 1 Ncm torque when tightening the four Screw
Len:2.0 Diam:1.4 with Bits (JCIS No 0).

Use new screws!



Check that the proper label format is loaded in the Zebra printer and print a new Label by using the 'LabelMake' software.

One label only is allowed!



Reassembly

Press along the surface to make sure Label securely attached.



5.6 SIM Flex PBA Assy

Insert the SIM Flex PBA Assy into the groove, and press along the slot to secure its position and attachment.



Snap the BtB connector securing its connection.



Insert the key dome into its socket.





Reassembly

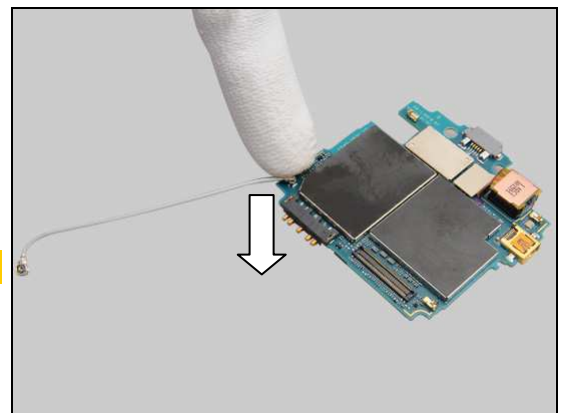
Press to secure its position.



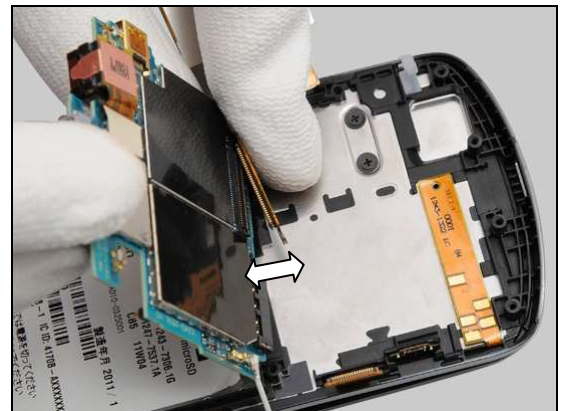
5.7 Main PBA & Cable RF

Connect the connector of Cable RF securing with fingers.

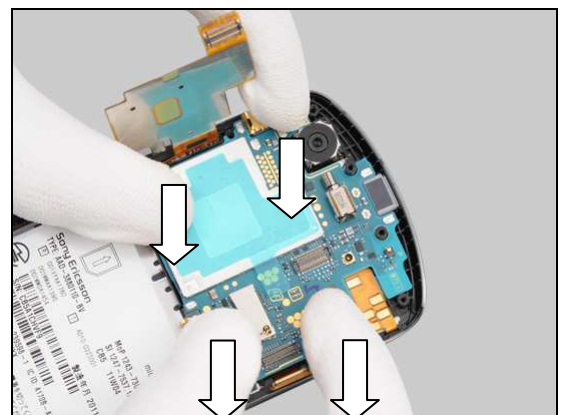
Listen for the click sound.



Snap the BtB connector securing its connection.



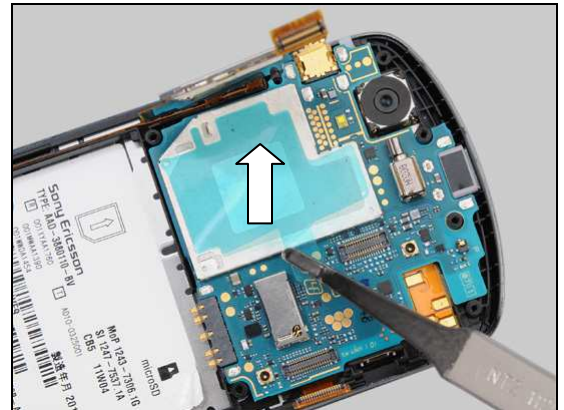
Press the Main PBA to snap into position.





Reassembly

Peel off the blue protection tape.

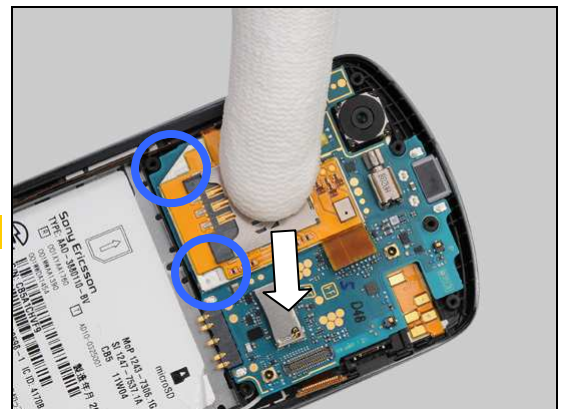


Turn over the SIM Flex PBA Assy.

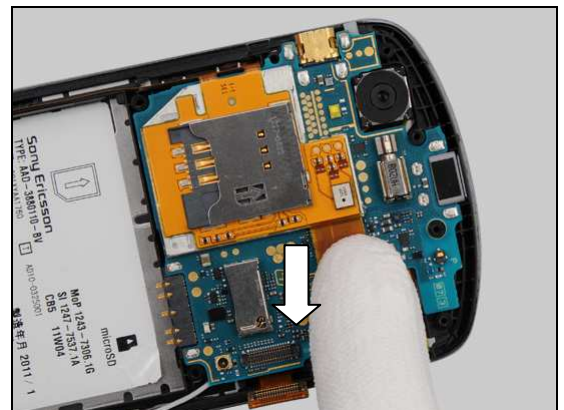


Press to secure its attachment.

Note the guiding position.



Snap the BtB connector securing its connection.



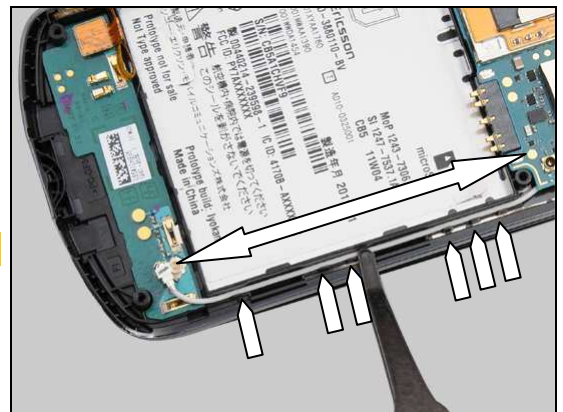
Reassembly

Snap the BtB connector securing its connection.



Place the Cable RF in the fixing sockets with Flex Film Assembly Tool.

Note: Gently secure the cable without causing damage.

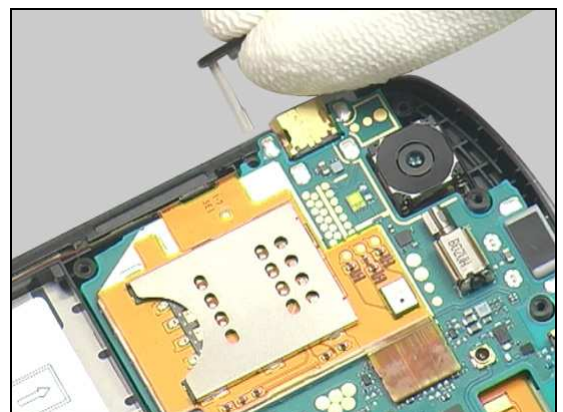


Connect the connector of Cable RF with fingers..

Listen for the click sound.



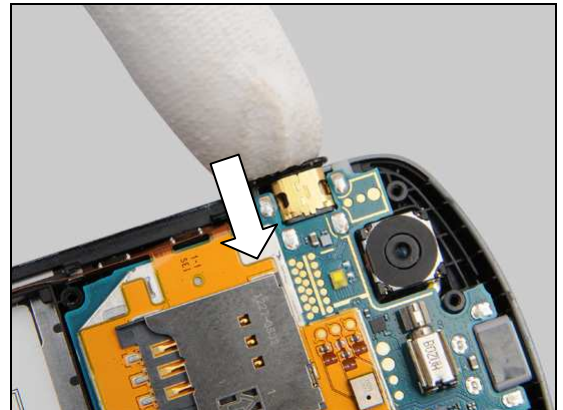
Place the Cap HDMI in the correct position and insert the Cap HDMI into the hole.





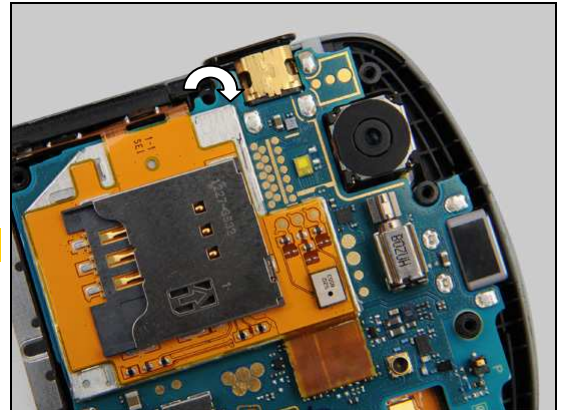
Reassembly

Press to secure its position.



Apply 11 ± 1 Ncm torque when tightening the Screw Phillips
Len:3.0 Diam:1.4 with Bits (JCIS No 0).

Use new screw!

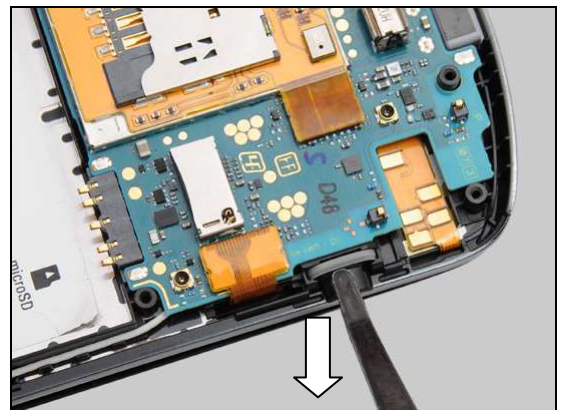


5.8 Key On/Off & Key Camera & Key Volume

Place the Key On/Off into correct position.



Press to secure its position.



Reassembly

Place the Key Camera into correct position.



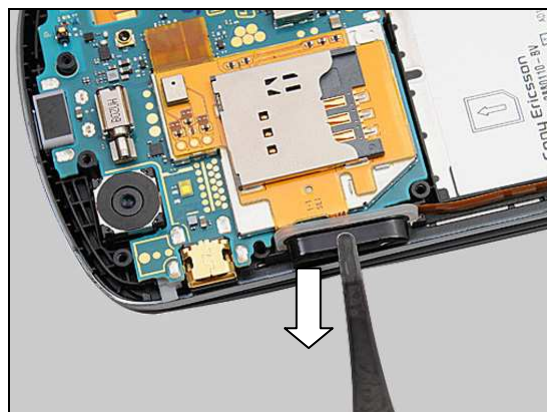
Press to secure its position.



Place the Key Volume into correct position.



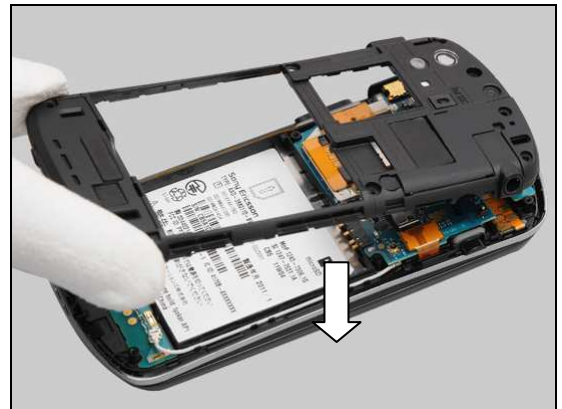
Press to secure its position.



Reassembly

5.9 Cover Lower Rear

Place the Cover Lower Rear into correct position.



Press the corner, the middle of Cover Lower Rear to snap it, securing the cover.



5.10 Cover Battery

Apply 14 ± 1 Ncm torque when tightening the four Screw
Other Len:4.0 Diam:1.4 with Bits (T5).

Use new screws!



Apply 14 ± 1 Ncm torque when tightening the four Screw
Other Len:5.0 Diam:1.4 with Bits (JCIS No 0).

Use new screws!



Reassembly

Place the Battery into correct position and press it into the cavity.



Place the Cover Battery into correct position.



Press to snap it.





6 Revision History

Rev.	Date	Changes / Comments
1	2011-Aug-3	Released
2	2011-Aug-11	Commercial Model update
3	2011-Sep-16	System Error (No Change)
4	2011-Sep-16	Chapters added 4.33, 4.34 & 4.35
5	2011-Sep-16	4.33 Picture updated
6	2011-Sep-16	4.33 Text Update
7	2011-Sep-16	Java System Error (No Change)
8	2011-Sep-16	Java System Error (No Change)
9	2011-Sep-29	Add new part - Proximity Sensor Tape
10	2011-Oct-11	Chapter 4.15 Updated
11	2011-Oct-18	Page 25, 40, 46, 65, 66, 71, 73 Grammar updated