



Sony Ericsson

# Working Instructions

## - mechanical -



*Xperia™ active*

*ST17i, ST17a*



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

**Very important**

**It is mandatory to verify that the unit is water resistant before the unit is returned to the customer  
Please see 1249-2430: ST17 Test Instruction**



# 1 Exterior Views

## 1.1 ST17i, ST17a



## 2 Tools

### SPECIAL TOOLS

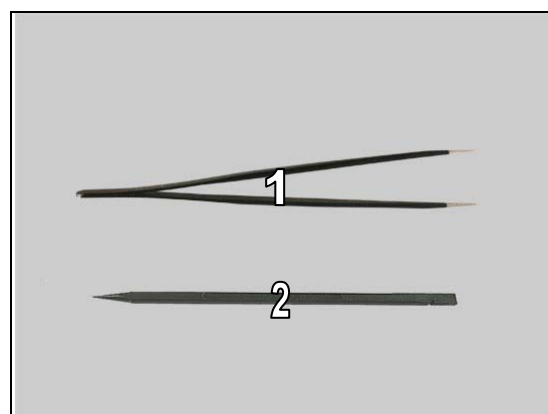
1. Guitar Pick
2. Flex Film Assembly Tool
3. Front Opening Tool
4. Torque Screwdriver
5. Bits(T5)



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

### STANDARD TOOLS

1. Tweezers
2. Nylon Pointer





## 3 Disassembly

The disassembly is done in the following order:

1. Cover Back
2. Cover Battery
3. Inner Frame
4. Main PBA
5. LCD Support
6. Cover Front



### 3.1 Cover Back

Open the Cap USB.



Open the Cap Audio.



Insert a finger into the nail grip and lift up the Cover Back.



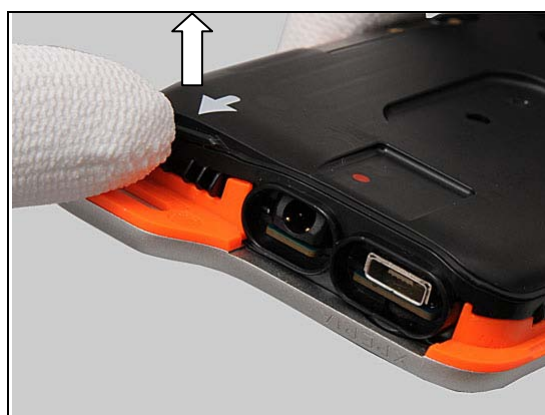
## Disassembly

Remove the Cover Back.



### 3.2 Cover Battery

Open the Cover Battery with a finger by the nail grip.



Remove the Cover Battery.



Lift up the Battery.





## Disassembly

Remove the Battery.



### 3.3 Inner Frame

Remove the Screw with a screwdriver with Bits (T5).



Remove the four Screws with a screwdriver with Bits (T5).



Release the Inner Frame with the Front Opening Tool.







## Disassembly

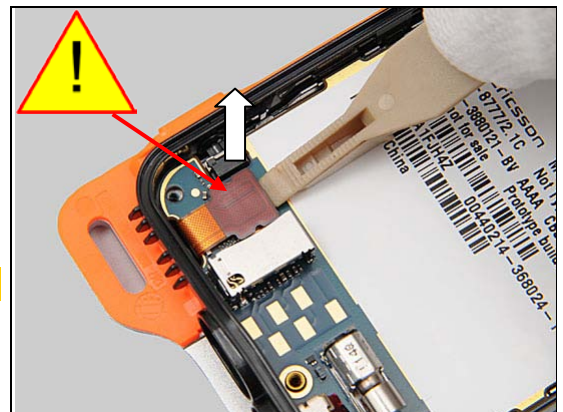
Remove the Inner Frame.



### 3.4 Main PBA

Release the BtB connector with the Front Opening Tool.

**Be careful not to damage the BtB connector!**



Insert the Guitar Pick to lift up the Main PBA.



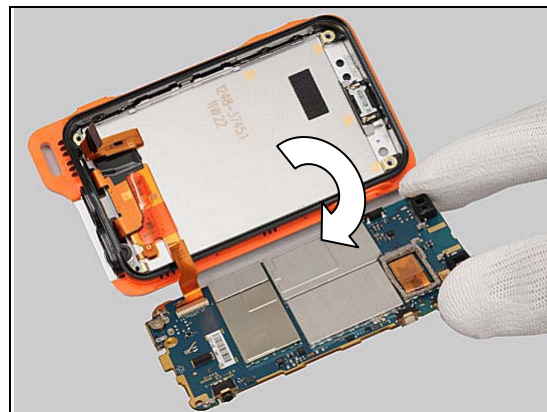
Lift up the top of the Main PBA gently.

**Do not stretch the flex films!**

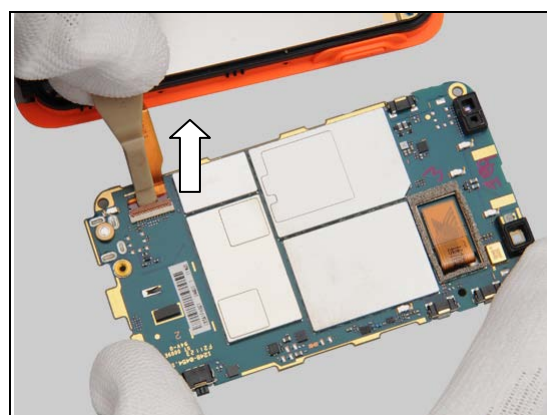


## Disassembly

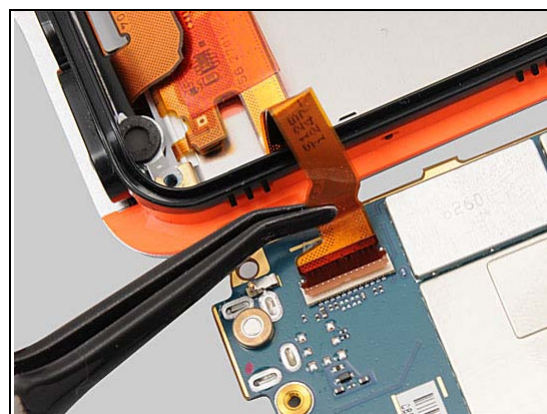
Turn over the Main PBA.



Open the ZIF connector with the Front Opening Tool.



Release the flex film with the Flex Film Assembly Tool.



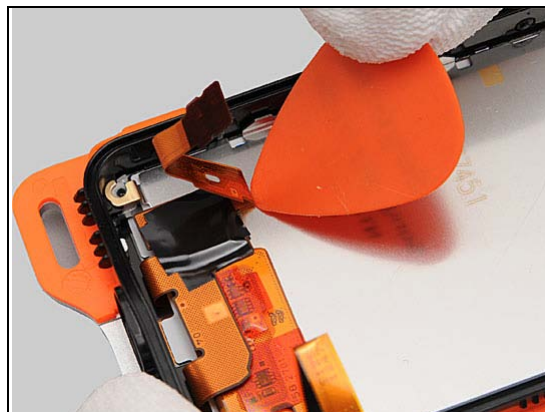
Separate the Main PBA from the front unit.



## Disassembly

### 3.5 LCD Support & Cover Front

Release the flex films with the Guitar Pick gently.



Insert the Guitar Pick to release the Support LCD.



Lift up and remove the Support LCD.



Separate the LCD Support and the Cover Front.





## 4 Replacement

### 4.1 Cover Back

*Follow the 3.1 Disassembly instructions.*

Prepare a new Cover Back.

*Follow the 5.5 Reassembly instructions.*



### 4.2 Cover Battery

*Follow the 3.1 – 3.2 Disassembly instructions.*

Prepare a new Cover Battery.

*Follow the 5.4 – 5.5 Reassembly instructions.*



### 4.3 Inner Frame

*Follow the 3.1 – 3.3 Disassembly instructions.*

Prepare a new Inner Frame.

*Follow the 5.3 – 5.5 Reassembly instructions.*

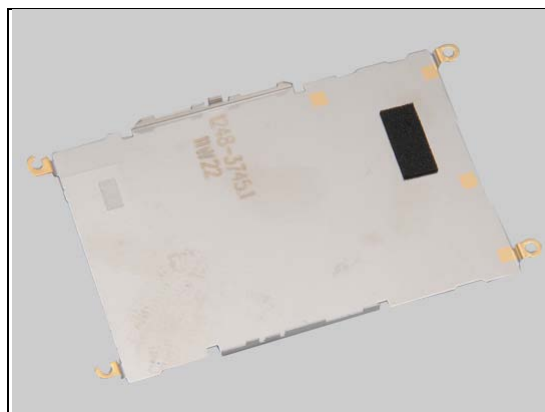


### 4.4 LCD Support

*Follow the 3.1 – 3.5 Disassembly instructions.*

Prepare a new LCD Support.

*Follow the 5.1 – 5.5 Reassembly instructions.*



## Replacement

### 4.5 Cover Front

*Follow the 3.1 – 3.5 Disassembly instructions.*

Prepare the new Cover Front.

*Follow the 5.1 – 5.5 Reassembly instructions.*

***Touch panel calibration has to be performed for all replaced units; 1257-2706 Trouble Shooting Application – mechanical.***

***Do not touch the front's touch screen, when you start up the phone the first time after a touch calibration, until the Sony Ericsson / Sony logo shows in the display!***





## Replacement

### 4.6 Adhesive 3 x 6

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Adhesive 3 x 6.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

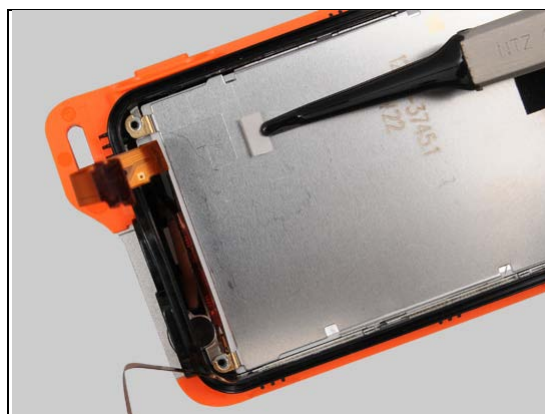
Remove the old Adhesive 3 x 6.

**Replace the Adhesive 3 x 6 every time the flex films have been released from the Support LCD!**



#### INSTALLATION

Mount a new Adhesive 3 x 6 in the correct position.



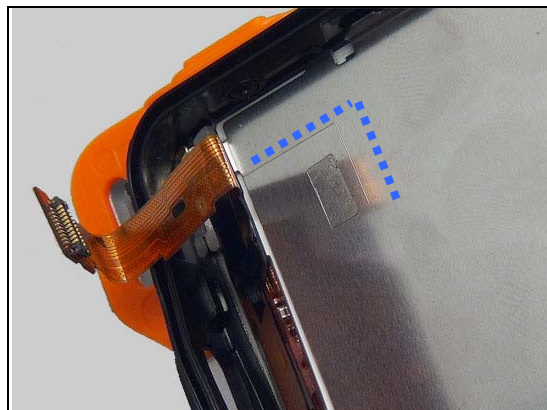
Press to secure its attachment.





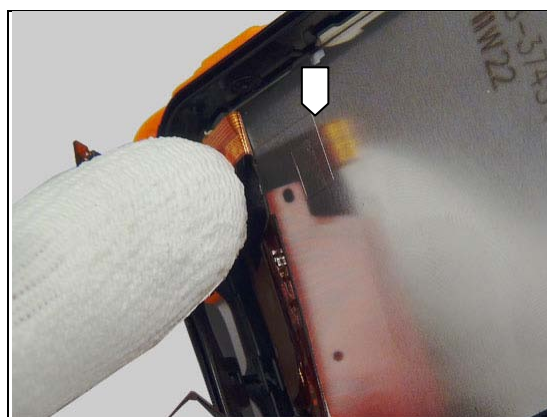
## Replacement: Adhesive 3 x 6

Align the flex films to the mark at the LCD Support.



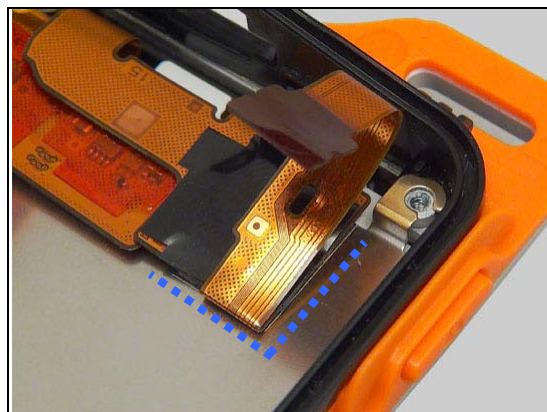
Press to secure the correct position of the flex films.

**Be careful not to damage the electrical components on the flex films.**



Correctly mounted flex films.

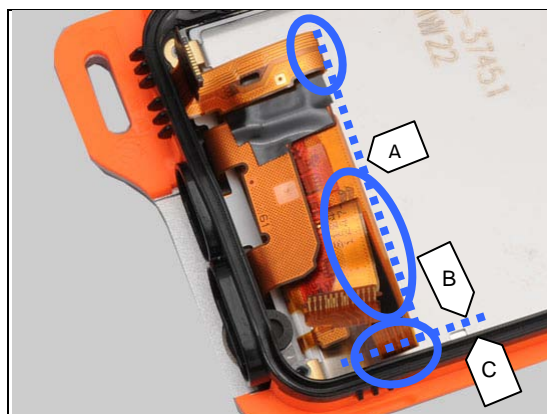
Pre-bend the flex film directly after the stiffener.



Pre-bend both the flex films before the main PBA is reassembled.

**Note: Important: Make sure both top flexes bent are aligned along the flex beneath according the dotted line (A) and also that the right top flex is bent according dotted line (B) 1-2 mm from the front's right edge (C)!**

**This is important to make sure the bent flex films are not squeezed between LCD support and shielding cans!**





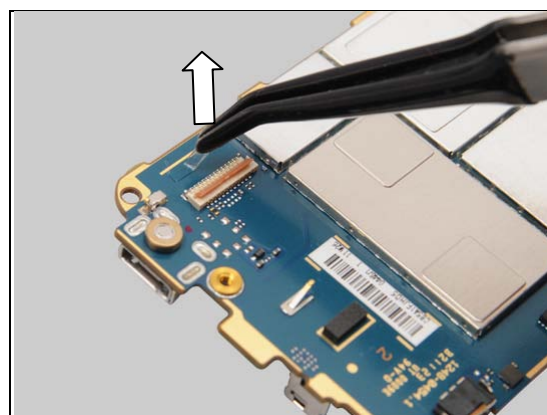
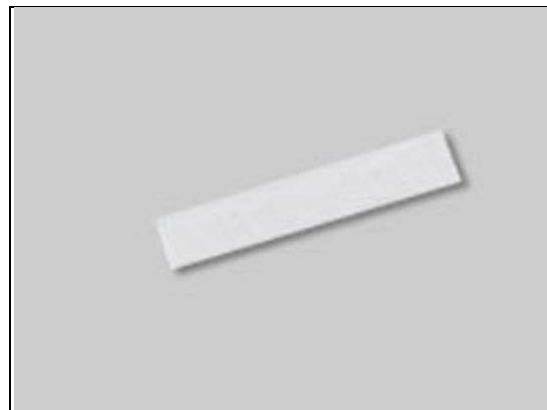
## Replacement

### 4.7 Adhesive 7,8 x 1,4

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Adhesive 7,8 x 1,4.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

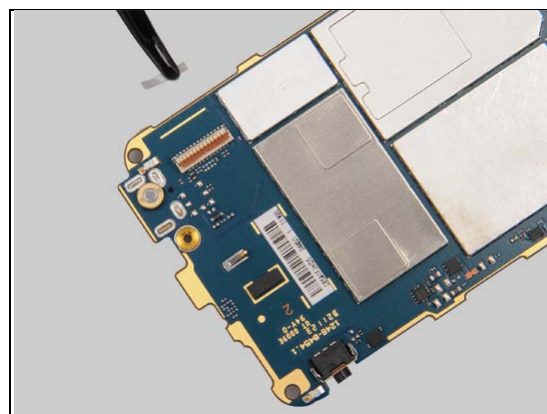
#### REMOVAL

Remove the old Adhesive 7,8 x 1,4.

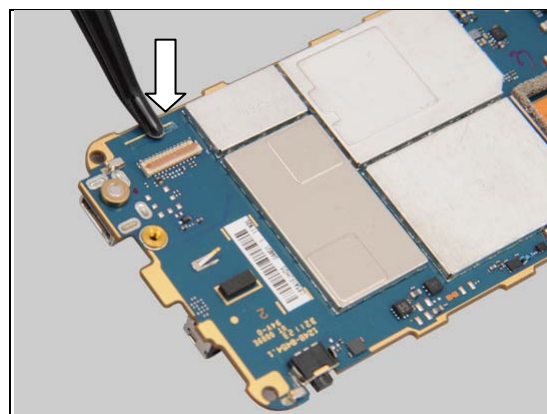


#### INSTALLATION

Mount a new Adhesive 7,8 x 1,4.



Press to secure its attachment.



## Replacement

### 4.8 Adhesive Irregular

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Adhesive Irregular.  
Carry out the Installation as described below.  
Follow the 4.6 Removal instructions.  
Follow the 4.6 Installation instructions.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

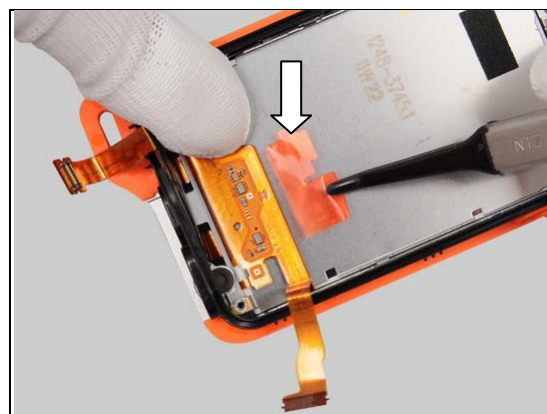
Release the flex films gently with the Guitar Pick.

Detach the Adhesive Irregular.

**Be careful not to damage the electrical components on the flex film.**

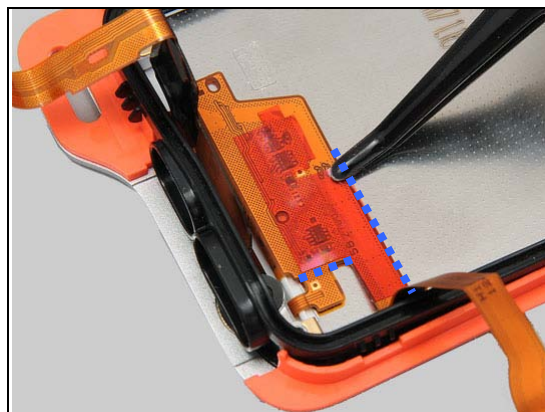
#### INSTALLATION

Mount gently a new Adhesive Irregular.



## Replacement: Adhesive Irregular

The Adhesive Irregular shall be aligned against two sides.



Press to secure its attachment.





## Replacement

### 4.9 Foil Adhesive for front flex

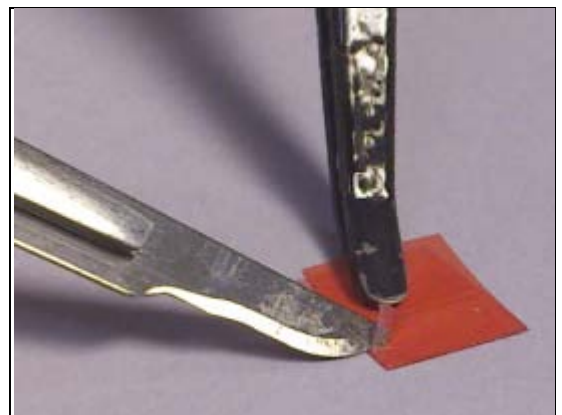
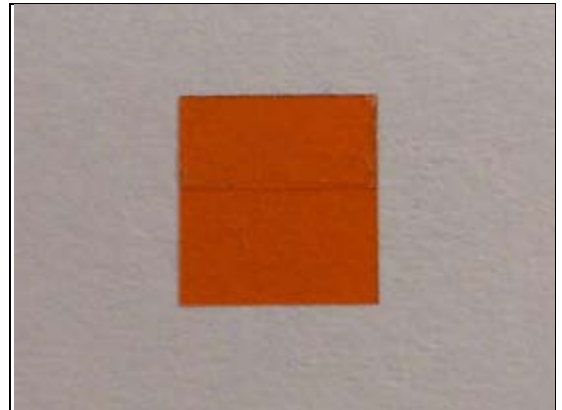
*The foil with double sided adhesive is securing the flex position during assembly. Only add if there is poor or missing adhesive.*

*Follow the 3.1 – 3.4 Disassembly instructions.*

*Prepare the new Foil Adhesive for front flex.*

*Carry out the Installation as described below.*

*Follow the 5.2 – 5.5 Reassembly instructions.*



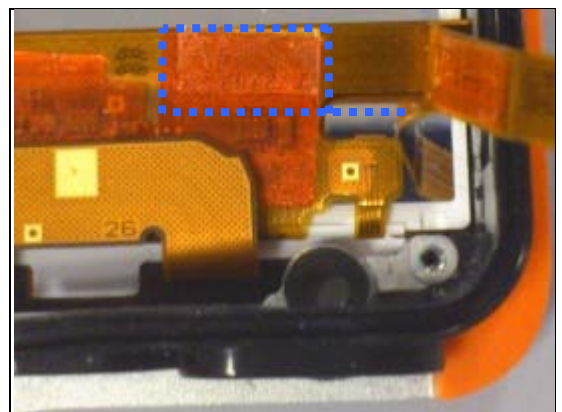
#### INSTALLATION

Remove the Foil Adhesive for front flex from protection foil.

Mount a new Foil Adhesive for front flex on top of the Adhesive Irregular.



Place it inside the blue dotted lines so the top flex will align on top of it later when assembled.



## Replacement

### 4.10 Audio Jack

*Follow the 3.1 – 3.3 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Audio Jack.  
Carry out the Installation as described below.  
Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

Disassembly the Audio Jack with the Nylon Pointer.



#### INSTALLATION

Assembly a new Audio Jack.



Press to secure its position.

**Be careful not to damage the pins of the Audio Jack!**





## Replacement

### 4.11 Camera 5 MPixel

*Follow the 3.1 – 3.4 Disassembly instructions.*

*Follow the 4.40 Removal instructions.*

*Carry out the Removal as described below.*

*Prepare the new Camera 5 MPixel.*

*Follow the 4.25 Installation instructions.*

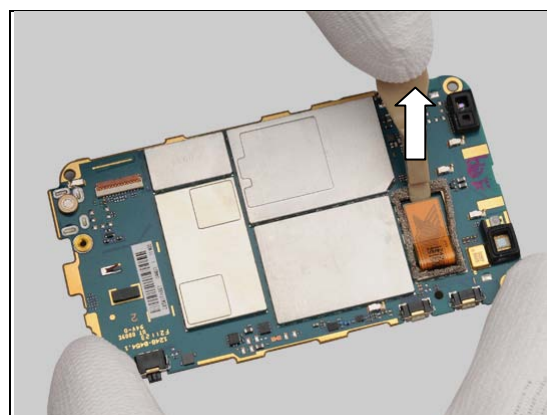
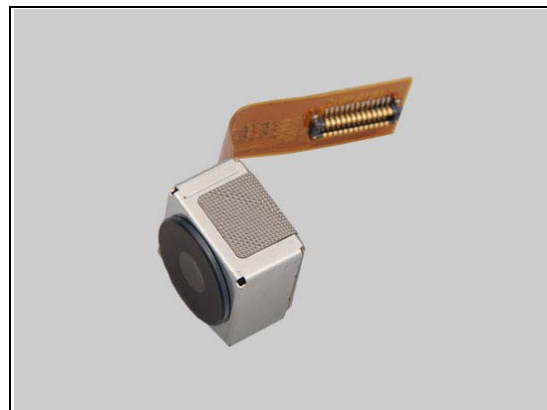
*Carry out the Installation as described below.*

*Follow the 4.40 Installation instructions.*

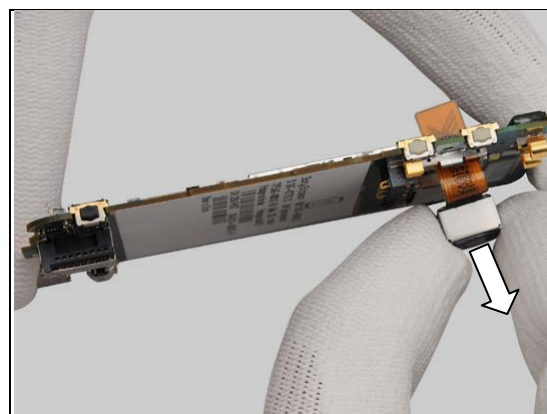
*Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

Unsnap the BtB connector.



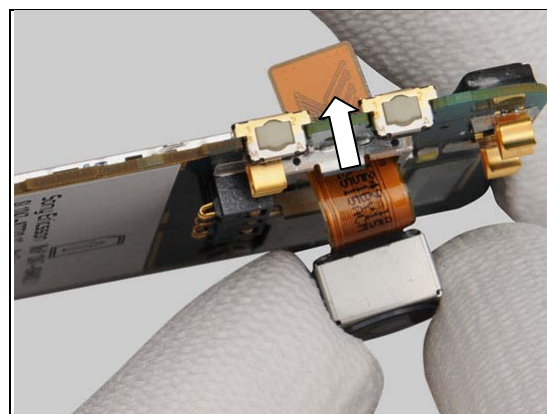
Remove the Camera 5 MPixel.



#### INSTALLATION

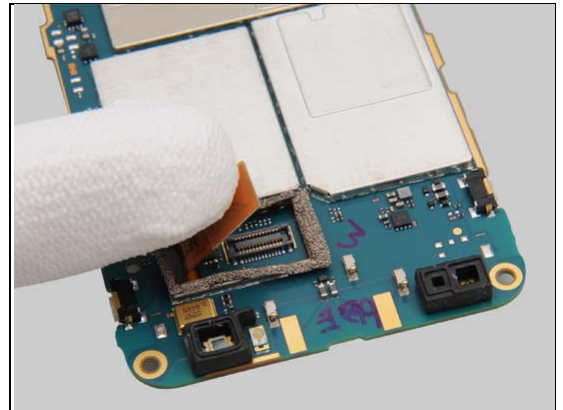
Mount the new Camera 5 MPixel into the Main PBA.

**Check that the Foil Grounding Camera is correct mounted, cornerwise!**



## Replacement: Camera 5 MPixel

Connect the BtB connector.





## Replacement

### 4.12 Cap Audio

*Follow the 3.1 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Cap Audio.  
Carry out the Installation as described below.  
Follow the 5.5 Reassembly instructions.*

#### REMOVAL

Release the “tail” of the Cap Audio.

Remove the Cap Audio.

#### INSTALLATION

Insert the “tail” of Cap Audio *into the cavity*.



## Replacement: Cap Audio

Fasten the “tail” to the hook.



## Replacement

### 4.13 Cap USB

*Follow the 3.1 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Cap USB.  
Carry out the Installation as described below.  
Follow the 5.5 Reassembly instructions.*

#### REMOVAL

Release the “tail” of the Cap USB.

Remove the Cap USB.

#### INSTALLATION

Insert the “tail” of Cap USB into the cavity.



## Replacement: Cap USB

Fasten the “tail” to the hook.



## Replacement

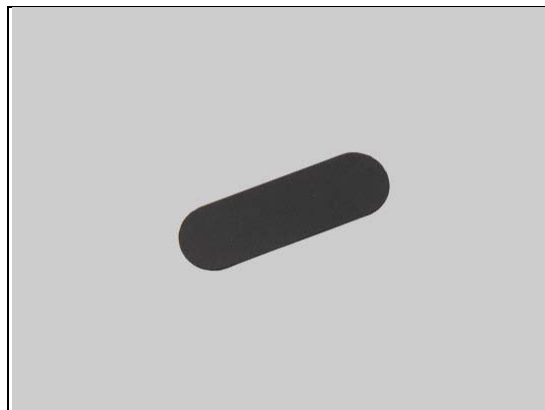
### 4.14 Co-Brand

*Follow the 3.1 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Co-Brand.  
Carry out the Installation as described below.  
Follow the 5.5 Reassembly instructions.*

#### REMOVAL

Remove the old Co-Brand.

**Be careful not to damage the Battery Cover.  
Scrap! Do not reuse the Co-brand.**



#### INSTALLATION

Mount the new Co-Brand.

**There are special Battery Covers aimed for Co-brands.**



Press to secure its attachment.



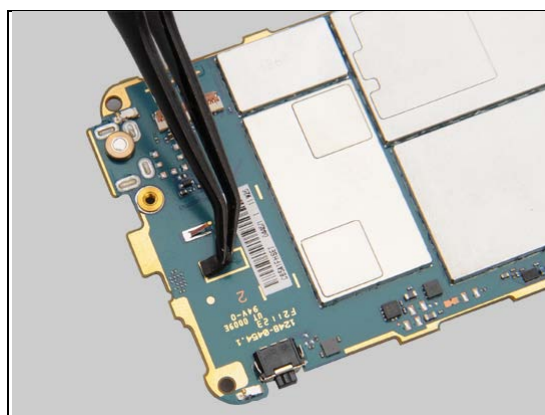
## Replacement

### 4.15 Cushion 5 x 2

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Cushion 5 x 2.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

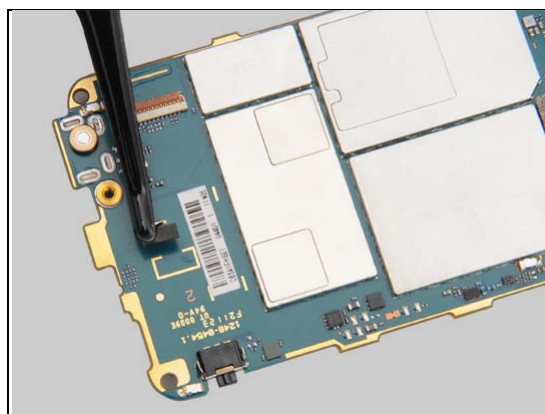
#### REMOVAL

Remove the old Cushion 5 x 2.

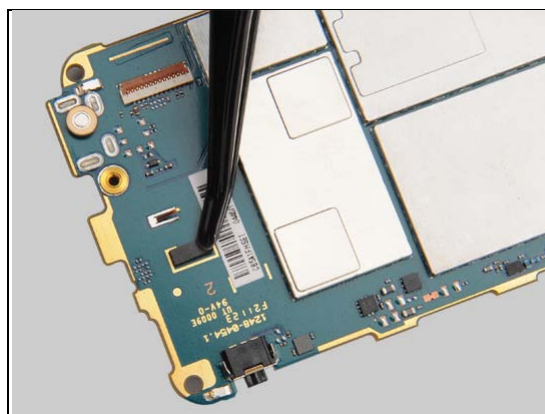


#### INSTALLATION

Mount a new Cushion 5 x 2.



Press to secure its attachment.



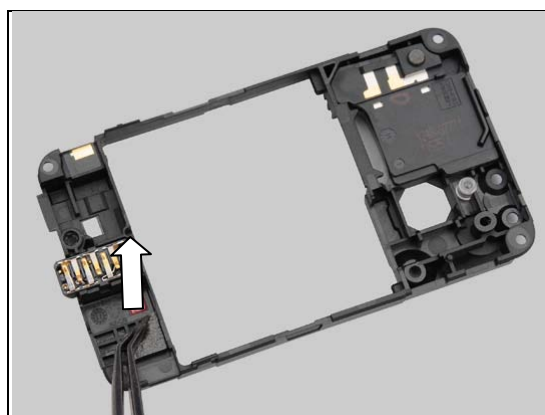
## Replacement

### 4.16 Cushion 7 x 7

*Follow the 3.1 – 3.3 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Cushion 7 x 7.  
Carry out the Installation as described below.  
Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

Remove the old Cushion 7 x 7.



#### INSTALLATION

Mount a new Cushion 7 x 7.



Press to secure its attachment.





## Replacement

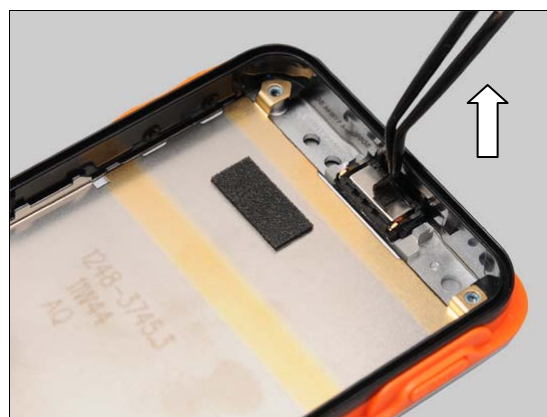
### 4.17 Cushion Earspeaker

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Cushion Earspeaker.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Cushion Earspeaker.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new Cushion Earspeaker.



Press seconds to secure its attachment.



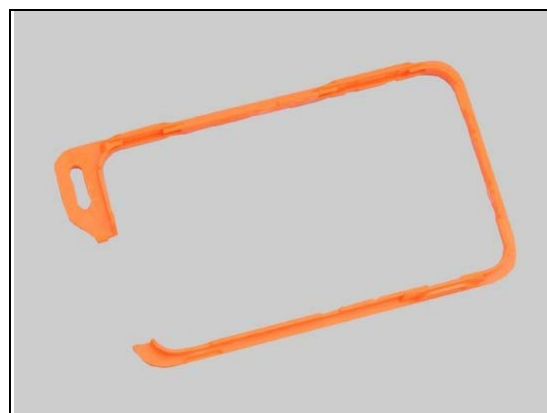
## Replacement

### 4.18 Deco Belt

*Follow the 3.1 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Deco Belt.  
Carry out the Installation as described below.  
Follow the 5.5 Reassembly instructions*

#### REMOVAL

Release the Deco Belt with the Front Opening Tool.



Unloose the Deco Belt around the unit.



Remove the Deco Belt and eliminate carefully the remains of the adhesive.

**Scrap! Do not reuse the Deco Belt.**

**All remains of the old adhesive should be removed before the new Deco Belt is assembled!**



## Replacement: Deco Belt

### INSTALLATION

**Secure the position of the Gasket Camera Key Sealing and three Gasket Key Sealing before the new Deco Belt is assembled.**

**Note! The Gasket Camera Key Sealing and three Gasket Key Sealings are parts that seal the unit.**



Align the new Deco Belt against the two tags.



Mount the Deco Belt carefully along the sides, particular around the keys.



Press to secure the Deco Belt and keys attachment.



## Replacement

### 4.19 Earspeaker, Adhesive Earspeaker & Cushion Earspeaker

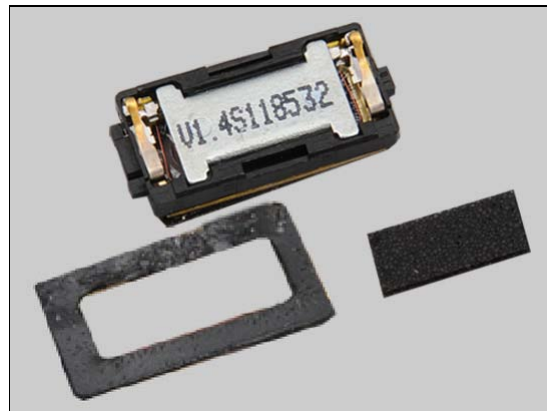
*Follow the 3.1 – 3.4 Disassembly instructions.*

*Carry out the Removal as described below.*

Prepare the new Earspeaker, Adhesive Earspeaker & Cushion Earspeaker.

*Carry out the Installation as described below.*

*Follow the 5.2 – 5.5 Reassembly instructions.*



#### REMOVAL

Remove the Earspeaker with a pair of Tweezers..

**Scrap the Earspeaker with the Cushion Earspeaker.**

**Remove any glue remains from gasket in the front!**



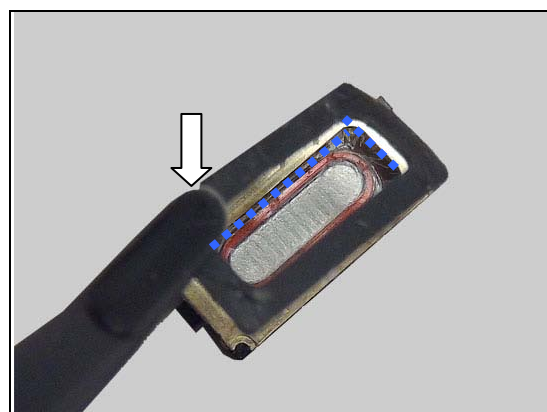
#### INSTALLATION

Mount a new Adhesive Earspeaker in the correct position on the Earspeaker.



Align the Adhesive Earspeaker with the inner metal edges; all four insides should be exactly aligned.

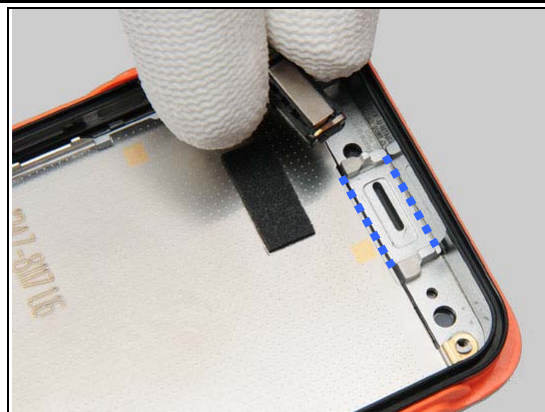
**Note! The Earspeaker and the Adhesive Earspeaker are parts that seal the unit! Assembly them carefully.**





## Replacement: Earspeaker, Adhesive Earspeaker & Cushion Earspeaker

Mount the Earspeaker with the new Adhesive in the correct position.



Align a new Cushion Earspeaker in the correct position on the Earspeaker.



Press to secure its attachment.



## Replacement

### 4.20 Foil Component Protection

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Foil Component Protection.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Foil Component Protection.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new Foil Component Protection. Align against the two sides as the blue lines shows.

**Be careful not to damage the electrical components on the flex films.**



Press carefully to secure its attachment.



## Replacement

### 4.21 Foil Grounding Camera

*Follow the 3.1 – 3.3 Disassembly instructions.*

*Follow the 4.40 Removal instructions.*

*Carry out the Removal as described below.*

*Prepare the new Foil Grounding Camera.*

*Carry out the Installation as described below.*

*Follow the 4.40 Installation instructions.*

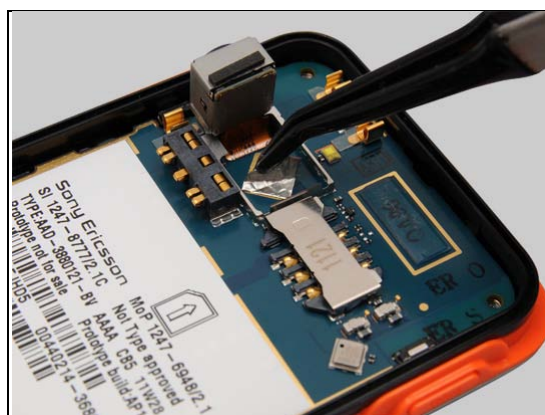
*Follow the 5.3 – 5.5 Reassembly instructions.*



#### REMOVAL

Remove the Foil Grounding Camera.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new Foil Grounding Camera in the correct position.

**The Foil Grounding Camera should be mounted cornerwise.**



Press to secure its attachment.





## Replacement

### 4.22 Gasket 14,1 x 6,4

*Follow the 3.1 – 3.4 Disassembly instructions.*

*Carry out the Removal as described below.*

*Prepare the new Gasket 14,1 x 6,4.*

*Carry out the Installation as described below.*

*Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

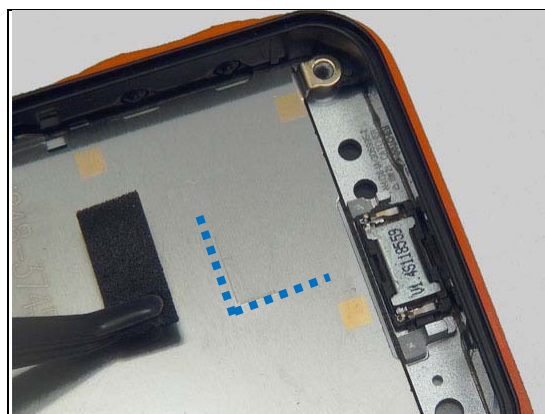
Remove the Gasket 14,1 x 6,4.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new Gasket 14,1 x 6,4. Align against the guide lines on the LCD support, marked blue in this picture.



Press to secure its attachment.



## Replacement

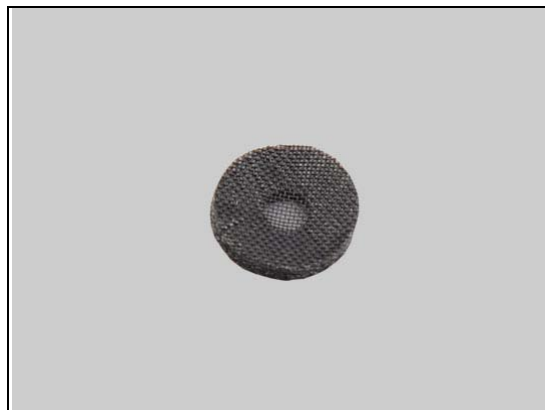
### 4.23 Gasket 2nd Mic for Battery Cover

*Follow the 3.1 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket 2nd Mic for Battery Cover.  
Carry out the Installation as described below.  
Follow the 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Gasket 2nd Mic for Battery Cover.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new Gasket 2nd Mic for Battery Cover.



Press to secure its attachment.



## Replacement

### 4.24 Gasket 2nd Mic for Inner Frame

*Follow the 3.1 – 3.3 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket 2nd Mic for Inner Frame.  
Carry out the Installation as described below.  
Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Gasket 2nd Mic for Inner Frame.

**Scrap! Not to be reused!**

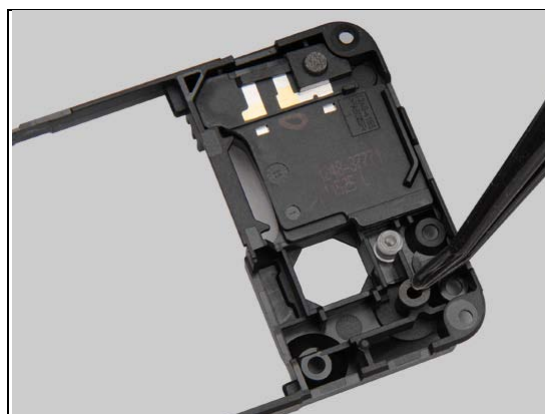


#### INSTALLATION

Mount a new Gasket 2nd Mic for Inner Frame.



Press to secure its attachment.



## Replacement

### 4.25 Gasket Mic With Membrane

*Follow the 3.1 – 3.3 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket Mic with Membrane.  
Carry out the Installation as described below.  
Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

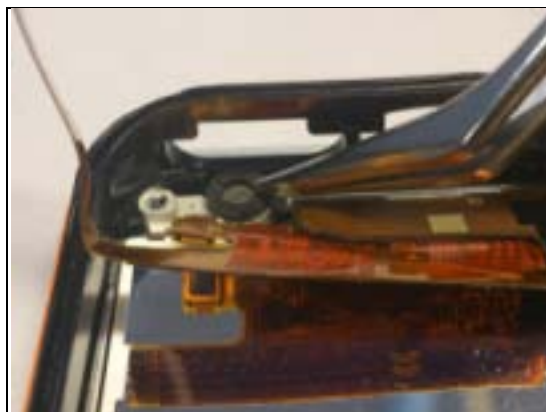
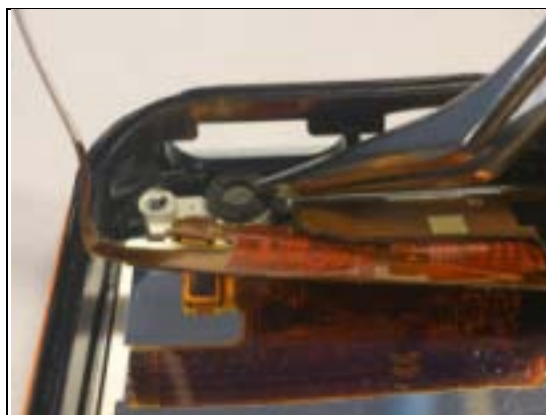
Remove the Gasket Mic With Membrane from Cover Front.

**Scrap! Not to be reused!**

Remove glue remains with Orangewood stick or Nylon pointer.

#### INSTALLATION

Mount a new Gasket Mic With Membrane on Cover Front.





## Replacement

### 4.26 Gasket 7,3 x 1,5

*Follow the 3.1 – 3.3 Disassembly instructions.*

*Follow the 4.40 Removal instructions.*

*Carry out the Removal as described below.*

*Prepare the new Gasket 7,3 x 1,5.*

*Carry out the Installation as described below.*

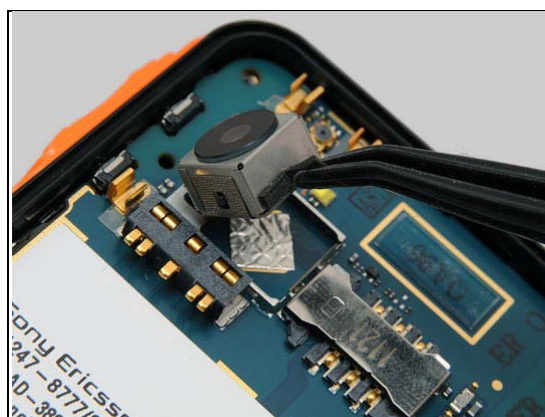
*Follow the 4.40 Installation instructions.*

*Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

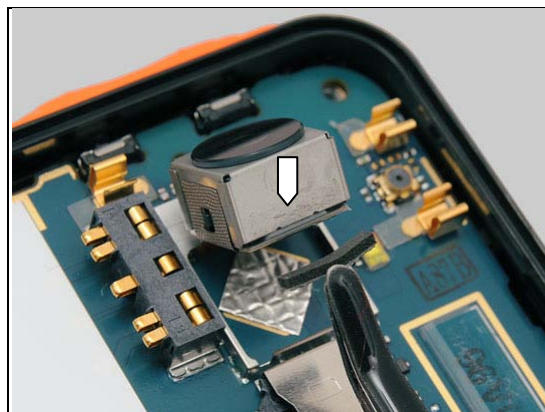
Remove the Gasket 7,3 x 1,5.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new Gasket 7,3 x 1,5.



Press to secure its attachment.



## Replacement

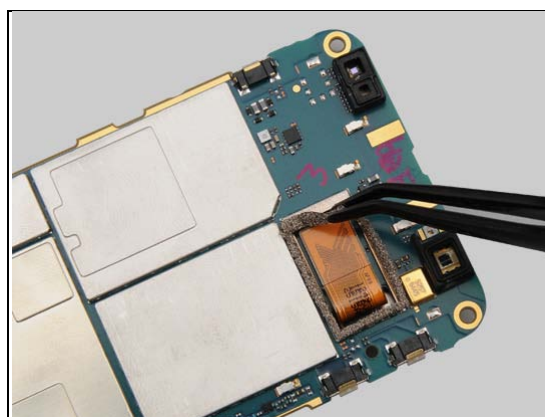
### 4.27 Gasket Conductive 19 x 10

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket Conductive 19 x 10.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

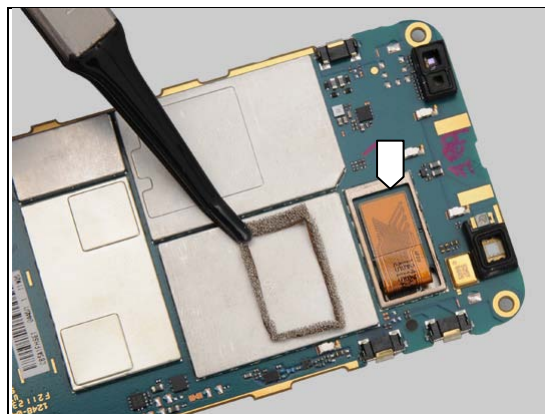
Remove the Gasket Conductive 19 x 10.

**Scrap! Not to be reused!**

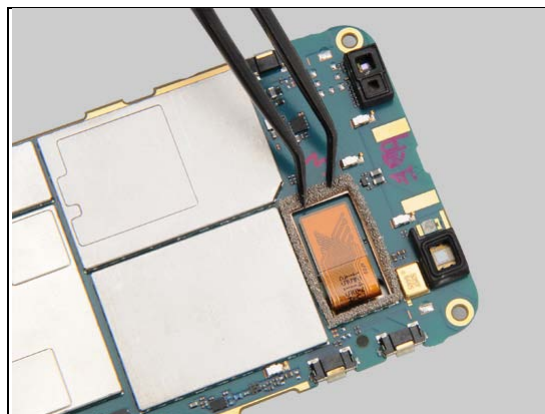


#### INSTALLATION

Mount a new Gasket Conductive 19 x 10.



Press to secure its attachment.





## Replacement

### 4.28 Gasket Key Sealing

Follow the 3.1 Disassembly instructions.  
 Follow the 4.18 and 4.33 or 4.34 Removal instructions.  
 Carry out the Removal as described below.  
 Prepare the new Gasket Key Sealing.  
 Carry out the Installation as described below.  
 Follow the 4.18 and 4.33 or 4.34 Installation instructions.  
 Follow the 5.5 Reassembly instructions.

#### REMOVAL

There are three Gasket Key Sealings.

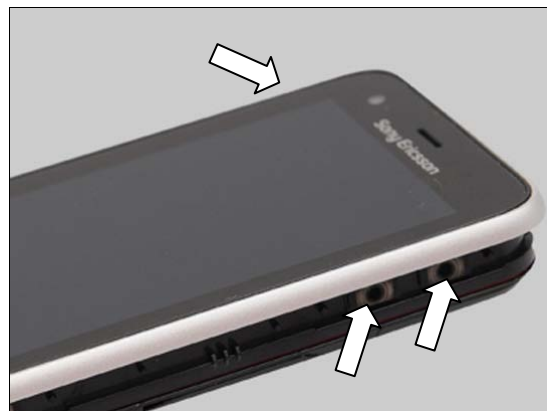
Remove the Gasket Key Sealing.

#### INSTALLATION

Mount the Gasket Key Sealing.

**Secure the correct position of the Gasket Key Sealings carefully.**

**Note! The three Gasket Key Sealings are parts that seal the unit.**



## Replacement: Gasket Key Sealing

Press to secure its attachment.



## Replacement

### 4.29 Gasket Camera Key Sealing

*Follow the 3.1 Disassembly instructions.  
Follow the 4.18 and 4.32 Removal instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket Camera Key Sealing.  
Carry out the Installation as described below.  
Follow the 4.18 and 4.32 Installation instructions.  
Follow the 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Gasket Camera Key Sealing.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new Gasket Camera Key Sealing.



Press seconds to secure its attachment.



## Replacement

### 4.30 Gasket Proxy

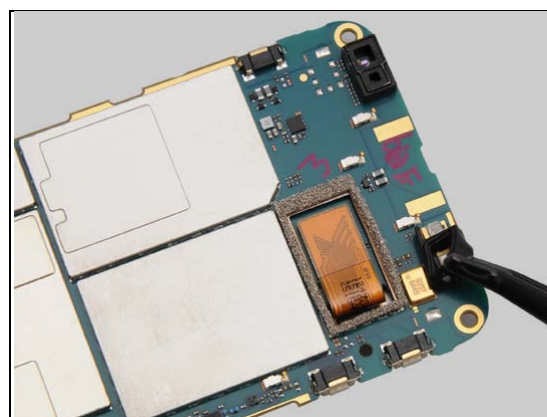
*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket Proxy.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Gasket Proxy.

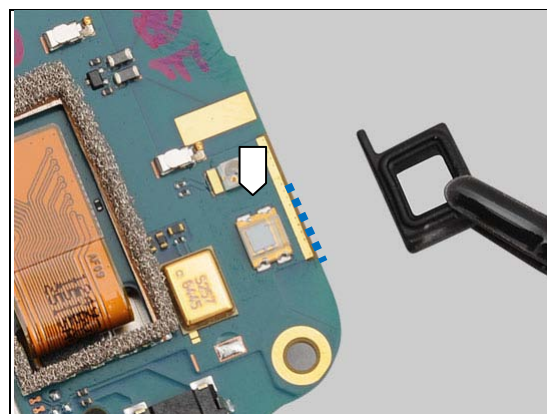
***All remains of the old adhesive should be removed  
before the new Gasket Proxy is assembled!***

***Scrap! Not to be reused!***

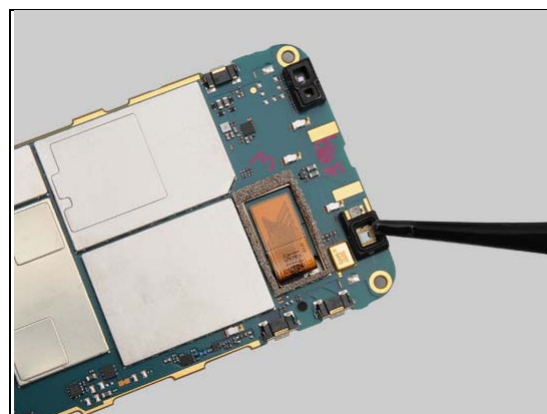


#### INSTALLATION

Align the new Gasket Proxy to the edge of the PBA.



Press to secure its attachment.



## Replacement

### 4.31 Gasket RGB

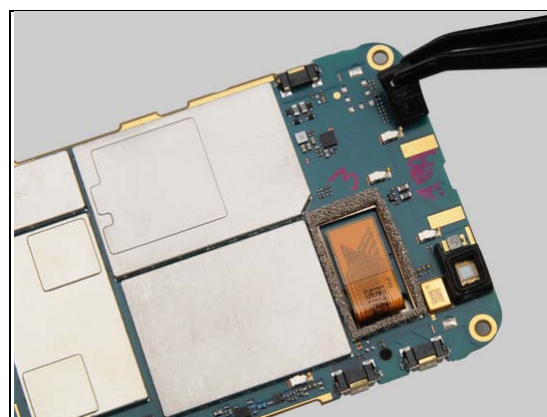
*Follow the 3.1 – 3.4. Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket RGB.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Gasket RGB.

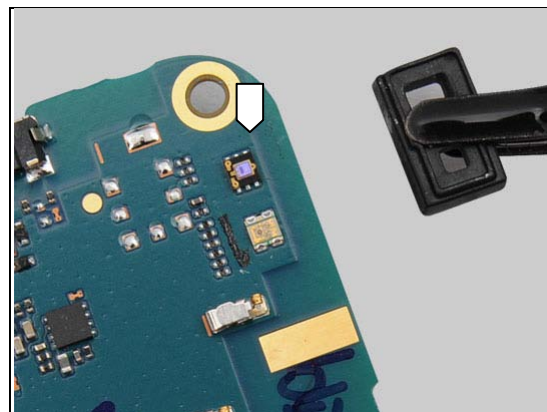
***All remains of the old adhesive should be removed  
before the new Gasket RGB is assembled!***

***Scrap! Not to be reused!***

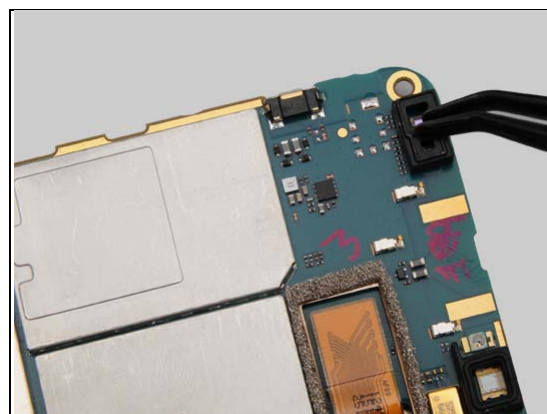


#### INSTALLATION

Mount the new Gasket RGB carefully in the correct position.



Press to secure its attachment.





## Replacement

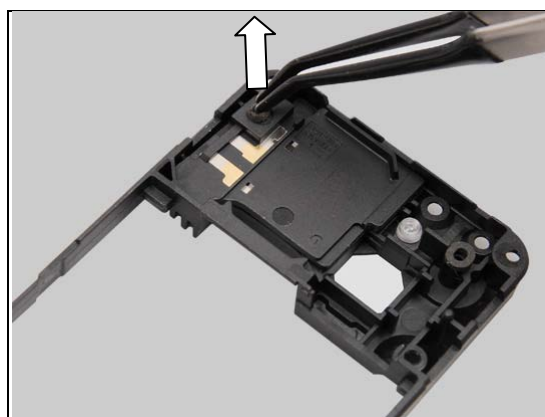
### 4.32 Gasket US-welding

*Follow the 3.1—3.3 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Gasket US-welding.  
Carry out the Installation as described below.  
Follow the 5.3—5.5 Reassembly instructions.*

#### REMOVAL

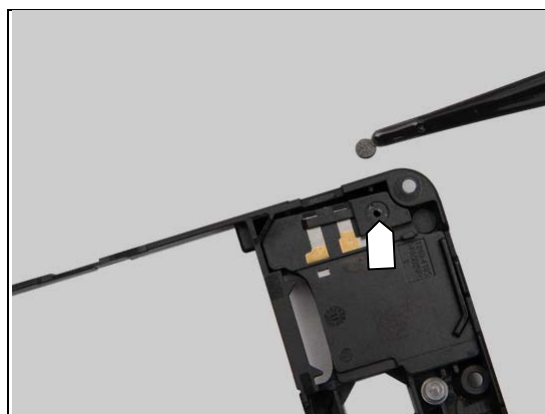
Remove the Gasket US-welding.

**Scrap! Not to be reused!**

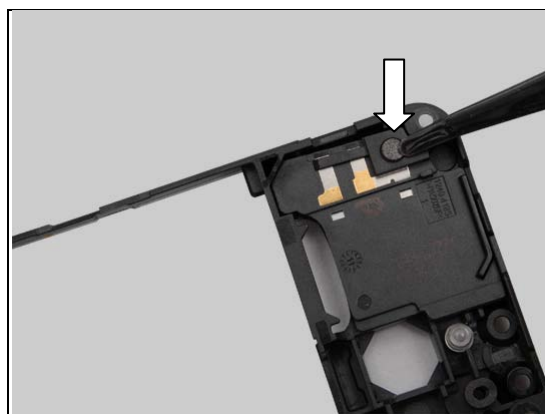


#### INSTALLATION

Mount the new Gasket US-welding.



Press to secure its attachment.





## Replacement

### 4.33 Key Camera

*Follow the 3.1 Disassembly instructions.*

*Follow the 4.18 Removal instructions.*

Carry out the Removal as described below.

**Units produced before 11W46:**

**Follow the 4.28 Removal and Installation instructions, replace the Gasket Camera Key Sealing.**

Prepare the new Key Camera.

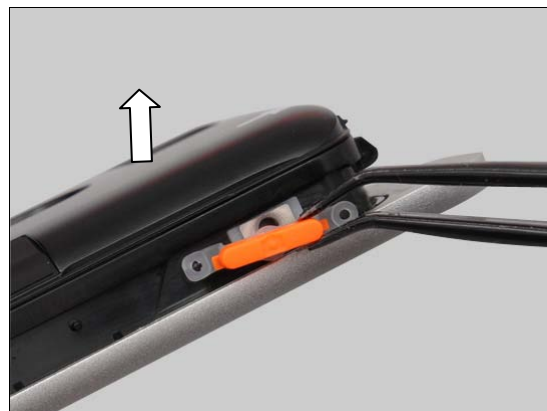
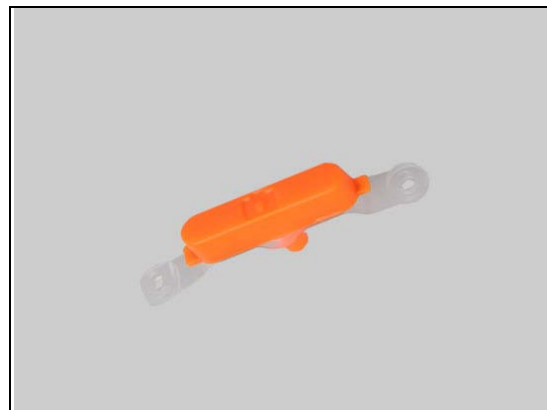
Carry out the Installation as described below.

*Follow the 4.18 Installation instructions.*

*Follow the 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Key Camera.



#### INSTALLATION

Loosen and remount the Gasket Camera Key Sealing to check if the Gasket Camera Key sealing is damaged or dirty. Replace it if it is damaged.

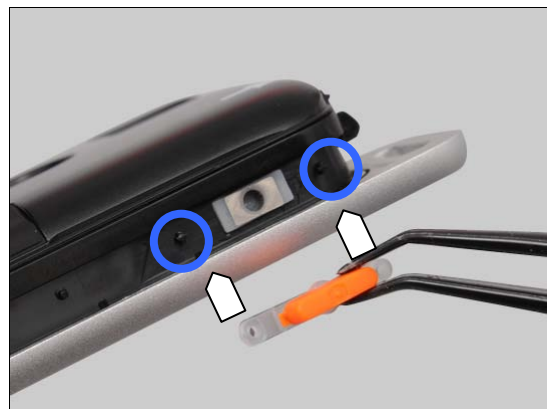
**Secure the correct position of the Gasket Camera Key Sealing carefully.**

**For units produced before 11W46, secure that PET film for camera switch is present! (4.36 PET film for camera switch)**



Mount the Key Camera.

**Note the button's direction. One round end and one squared end.**



## Replacement: Key Camera

The correct direction of the key.



Press both ends to secure its attachment.



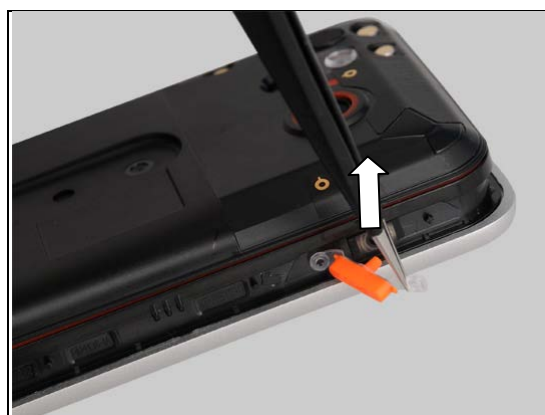
## Replacement

### 4.34 Key On/Off

Follow the 3.1 Disassembly instructions.  
 Follow the 4.18 Removal instructions.  
 Carry out the Removal as described below.  
 Prepare the new Key On/Off.  
 Carry out the Installation as described below.  
 Follow the 4.18 Installation instructions.  
 Follow the 5.5 Reassembly instructions.

#### REMOVAL

Remove the Key On/Off.



#### INSTALLATION

Loosen and remount the Gasket Key Sealing to check if the Gasket Key sealing is damaged or dirty. Replace it if it is damaged.

**Secure the correct position of the Gasket Key Sealing carefully.**



Mount the Key On/Off. Press both ends to secure its attachment.

**Note the button's direction. One round end and one squared end.**



## Replacement

### 4.35 Key Volume

Follow the 3.1 Disassembly instructions.  
 Follow the 4.18 Removal instructions.  
 Carry out the Removal as described below.  
 Prepare the new Key Volume.  
 Carry out the Installation as described below.  
 Follow the 4.18 Installation instructions.  
 Follow the 5.5 Reassembly instructions.

#### REMOVAL

Remove the Key Volume.



#### INSTALLATION

Loosen and remount the Gasket Key Sealing to check if the Gasket Key sealing is damaged or dirty. Replace it if it is damaged.

**Secure the correct position of the Gasket Key Sealing carefully.**



Mount the Key Volume. Press both ends to secure its attachment.

**Note the button's direction. One round end and one squared end.**



## Replacement

### 4.36 Label Mobile Phone

*Follow the 3.1—3.2 Disassembly instructions.*

*Carry out the Removal as described below.*

*Prepare the new Label Mobile Phone.*

*Carry out the Installation as described below.*

*Follow the 5.4—5.5 Reassembly instructions.*

#### REMOVAL

Read the old Label Mobile Phone and write the information into the 'LabelMake' program before removal.

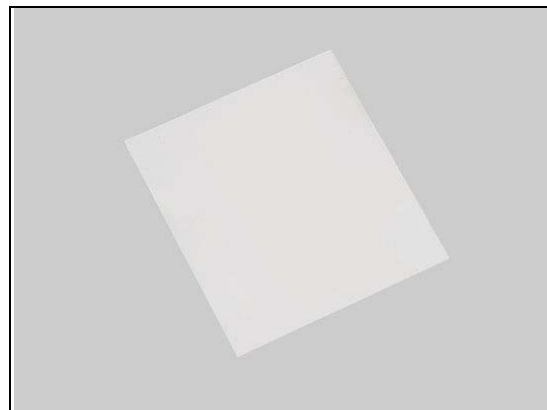
Carefully remove the Label.

#### INSTALLATION

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

Press along the surface to make Label securely attached.

**One label only is allowed!**





## Replacement

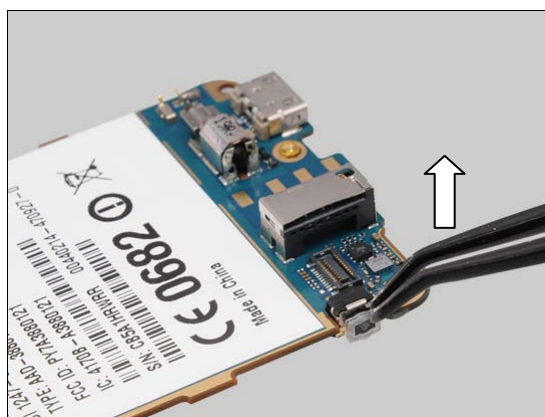
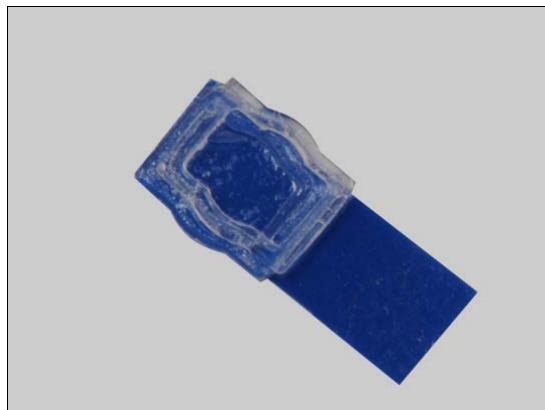
### 4.37 PET-film for Camera Switch

Follow the 3.1 – 3.4 Disassembly instructions.  
 Carry out the Removal as described below.  
 Prepare the new PET-film for Camera Switch.  
 Carry out the Installation as described below.  
 Follow the 5.2 – 5.5 Reassembly instructions.

#### REMOVAL

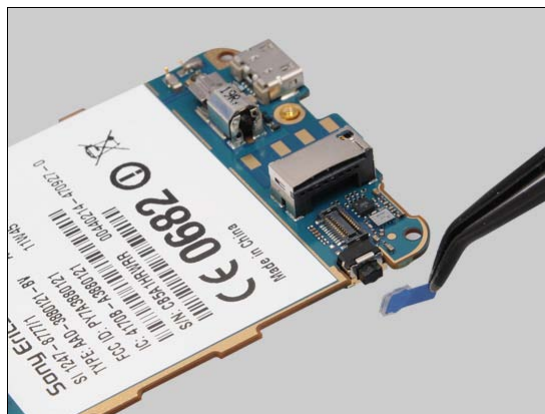
Remove the PET-film for Camera Switch.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount a new PET-film for Camera Switch.



Press 8 seconds to secure its attachment.



## Replacement

Peel of the protective film.





## Replacement

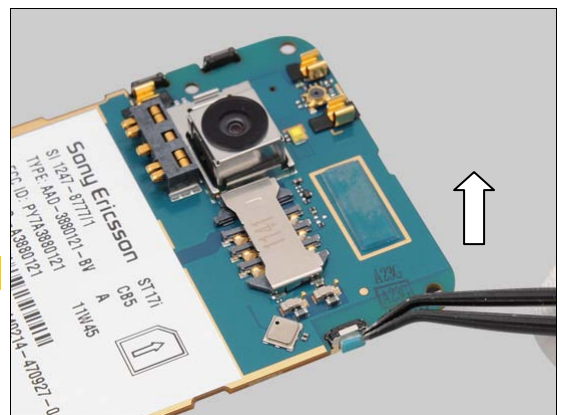
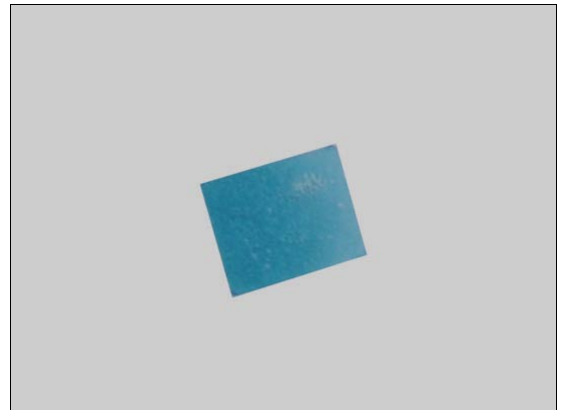
### 4.38 Sheet for On/Off Switch

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Sheet for On/Off Switch.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

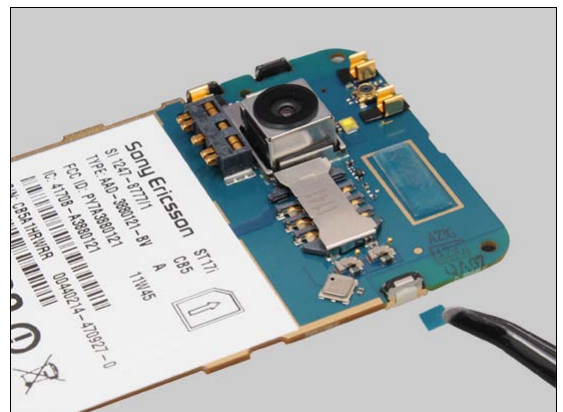
Remove the Sheet for On/Off Switch.

**Scrap! Not to be reused!**

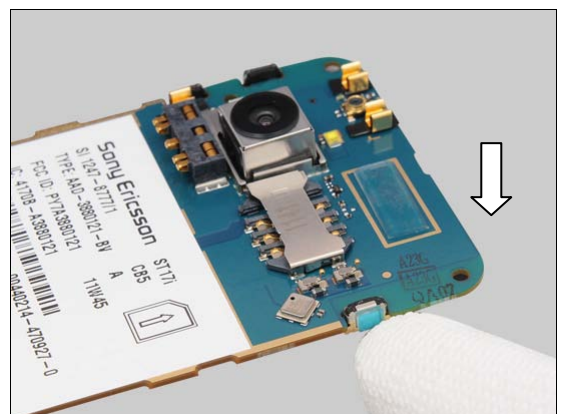


#### INSTALLATION

Mount a new Sheet for On/Off Switch.



Press 8 seconds to secure its attachment.



## Replacement

### 4.39 Shield Can Lid ABB

*Follow the 3.1 – 3.4 Disassembly instructions.*

*Carry out the Removal as described below.*

*Prepare the Shield Can Lid ABB.*

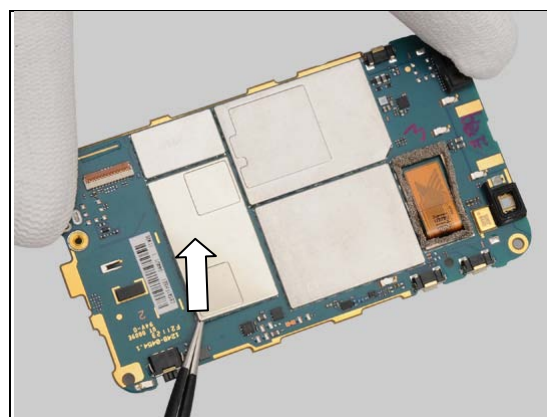
*Carry out the Installation as described below.*

*Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

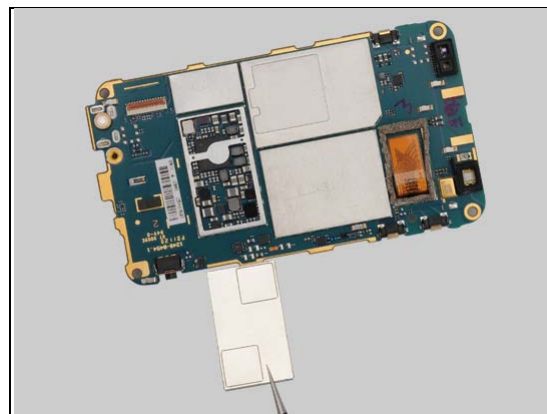
Unsnap the corners of the Shield Can Lid ABB with a pair of Tweezers and remove it.

**Scrap the Shield Can Lid, it shall not be reused.**



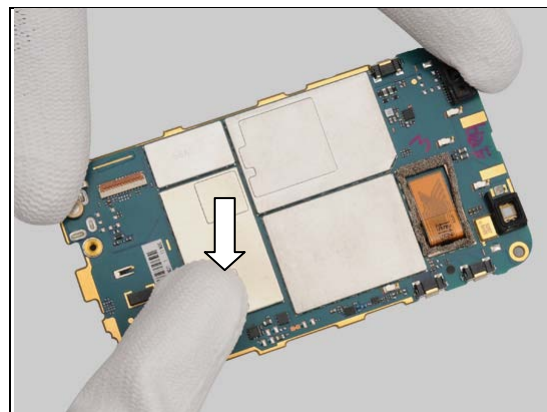
#### INSTALLATION

Mount a new Shield Can Lid ABB.



Press to snap it.

**Press only on the edges of the Shield Can Lid.  
Not in the middle of the Shield Can Lid.**



## Replacement

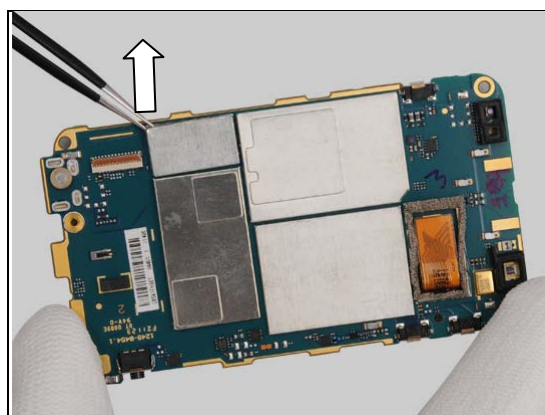
### 4.40 Shield Can Lid BT/WLAN

Follow the 3.1 – 3.4 Disassembly instructions.  
 Carry out the Removal as described below.  
 Prepare the Shield Can Lid BT/WLAN.  
 Carry out the Installation as described below.  
 Follow the 5.2 – 5.5 Reassembly instructions.

#### REMOVAL

Unsnap the corners of the Shield Can Lid BT/WLAN with a pair of Tweezers and remove it.

**Scrap the Shield Can Lid, it shall not be reused.**

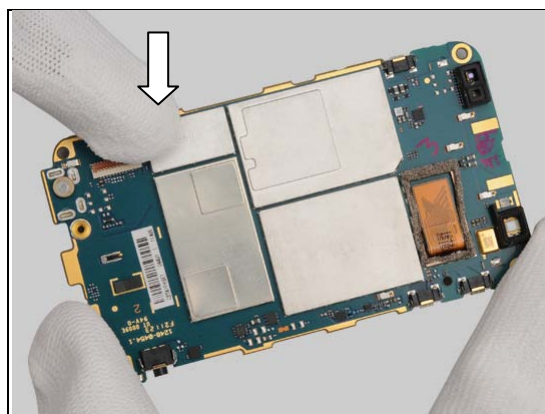
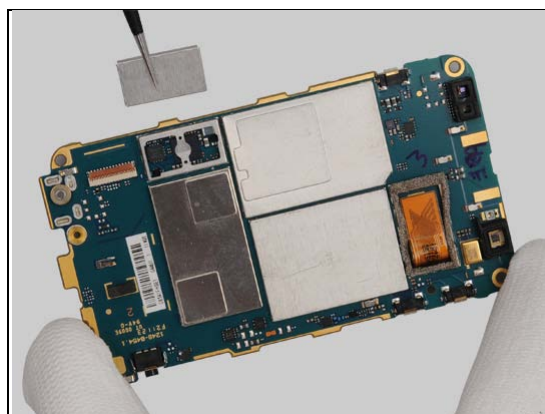


#### INSTALLATION

Mount a new Shield Can Lid BT/WLAN.

Press to snap it.

**Press only on the edges of the Shield Can Lid.  
 Not in the middle of the Shield Can Lid.**





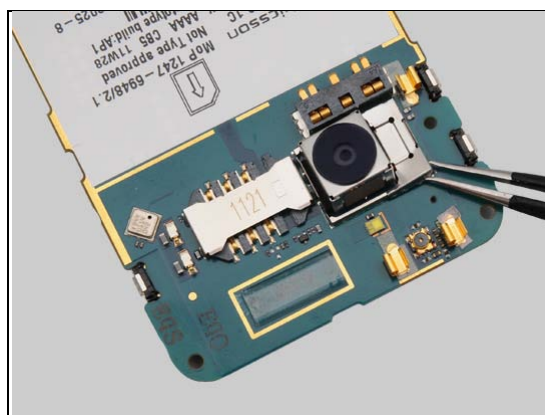
## Replacement

### 4.41 Shield Can Lid Camera

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Shield Can Lid Camera.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

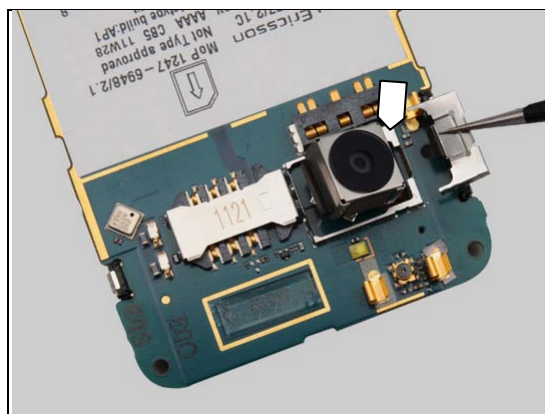
#### REMOVAL

Lift up to remove the Shield Can Lid Camera.

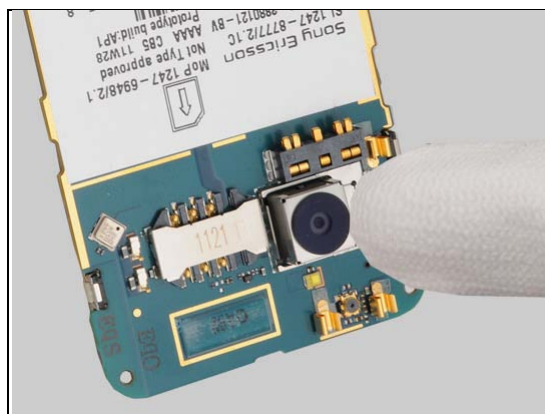


#### INSTALLATION

Mount the Shield Can Lid Camera.



Press to snap it.



## Replacement

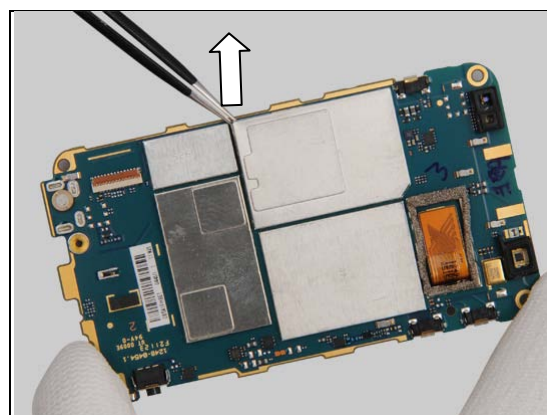
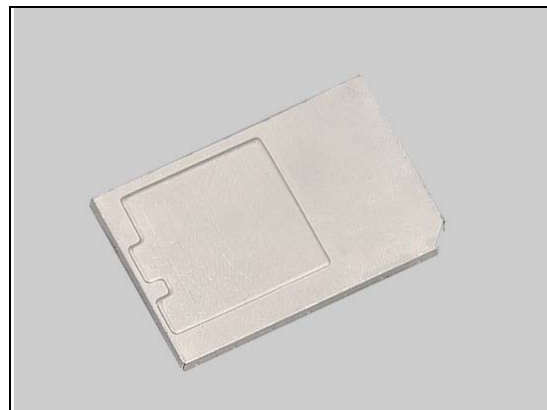
### 4.42 Shield Can Lid DBB

*Follow the 3.1 – 3.4 Disassembly instructions.  
Carry out the Removal as described below.  
Prepare the new Shield Can Lid DBB.  
Carry out the Installation as described below.  
Follow the 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

Unsnap the corners of the Shield Can Lid DBB with a pair of Tweezers and remove it.

**Scrap the Shield Can Lid, it shall not be reused.**

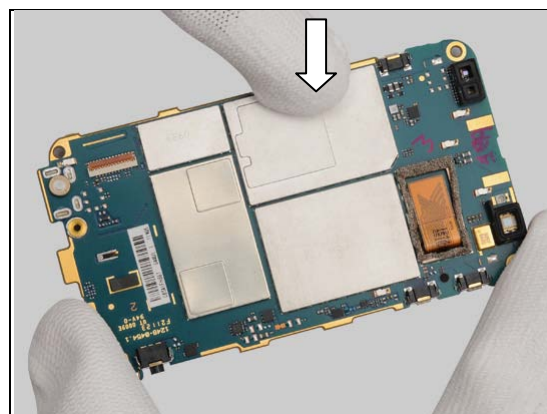
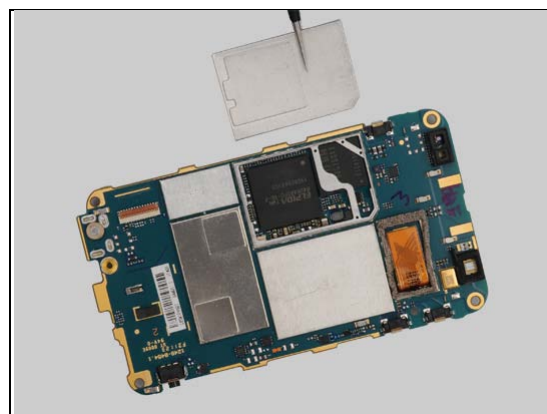


#### INSTALLATION

Mount a new Shield Can Lid DBB.

Press to snap it.

**Press only on the edges of the Shield Can Lid.  
Not in the middle of the Shield Can Lid.**





## Replacement

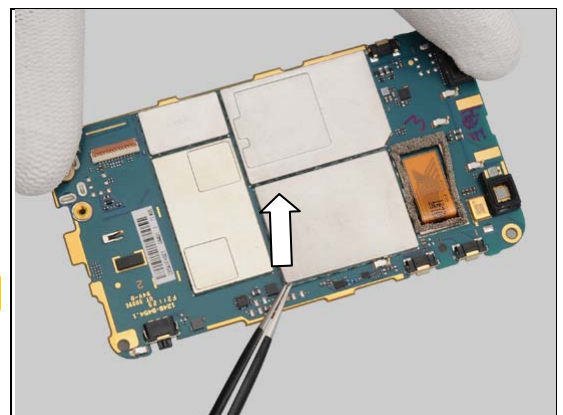
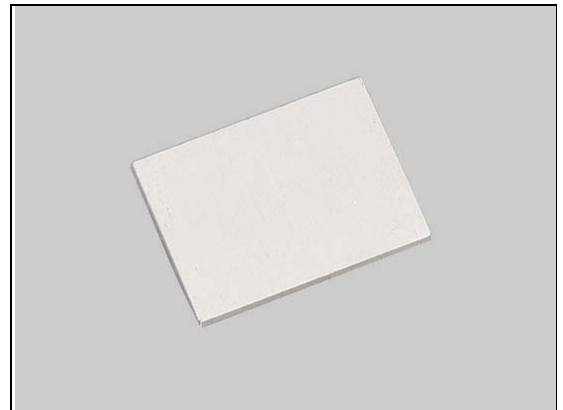
### 4.43 Shield Can Lid RF

*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 5.2 – 5.5 Reassembly instructions.*

#### REMOVAL

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

**Scrap the Shield Can Lid, it shall not be reused.**

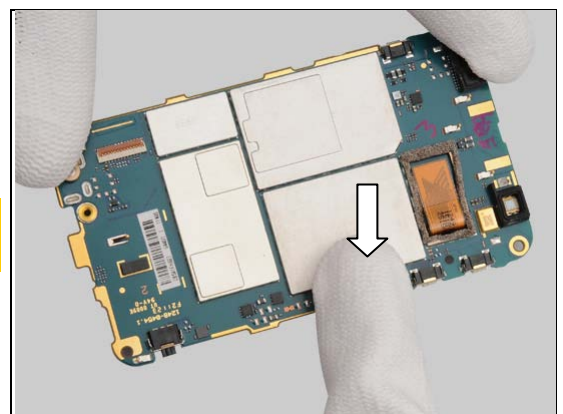
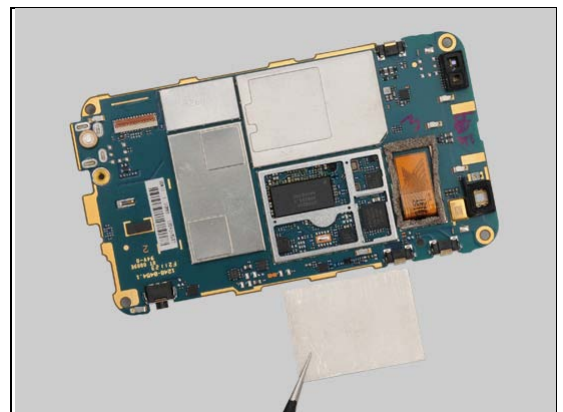


#### INSTALLATION

Mount a new Shield Can Lid RF.

Press to snap it.

**Press only on the edges of the Shield Can Lid.  
Not in the middle of the Shield Can Lid.**



## Replacement

### 4.44 Spacer for SIM card

Follow the 3.1 – 3.3 Disassembly instructions.  
 Carry out the Removal as described below.  
 Prepare the new Spacer for SIM card.  
 Carry out the Installation as described below.  
 Follow the 5.3 – 5.5 Reassembly instructions.

#### REMOVAL

Remove the Spacer for SIM card.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount the Spacer for SIM card.



Press to secure its attachment.





## Replacement

### 4.45 Tape Isolation 4,0 x 1,8

*Follow the 3.1 – 3.3 Disassembly instructions.*

*Carry out the Removal as described below.*

*Prepare the new Tape Isolation 4,0 x 1,8.*

*Carry out the Installation as described below.*

*Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

Remove the Tape Isolation 4,0 x 1,8.

**Scrap! Not to be reused!**

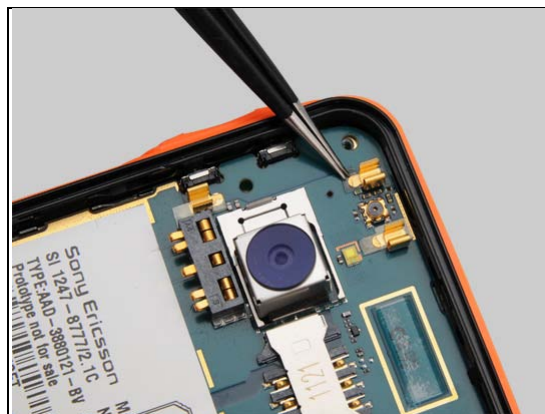


#### INSTALLATION

Mount the new Tape Isolation 4,0 x 1,8.



Press to secure its attachment.







## Replacement

### 4.46 Tape Isolation 4,1 x 2,8

*Follow the 3.1 – 3.3 Disassembly instructions.*

*Carry out the Removal as described below.*

*Prepare the new Tape Isolation 4,1 x 2,8.*

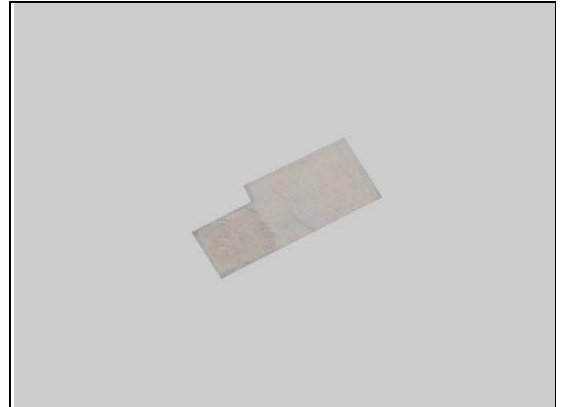
*Carry out the Installation as described below.*

*Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

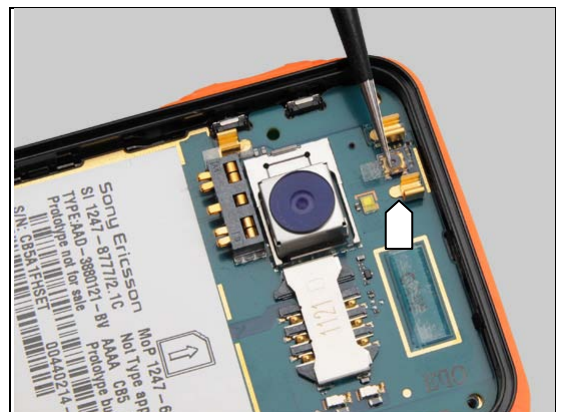
There are two Tape Isolation 4,1 x 2,8 in each unit .  
Remove the Tape Isolation 4,1 x 2,8.

**Scrap! Not to be reused!**



#### INSTALLATION

Mount the new Tape Isolation 4,1 x 2,8.



Press to secure its attachment.



## Replacement

### 4.47 Water Indicator

#### INSPECTION

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

*Follow the 3.1 – 3.3 Disassembly instructions.*

*Carry out the Removal as described below.*

Prepare the new Water Indicator.

*Carry out the Installation as described below.*

*Follow the 5.3 – 5.5 Reassembly instructions.*

#### REMOVAL

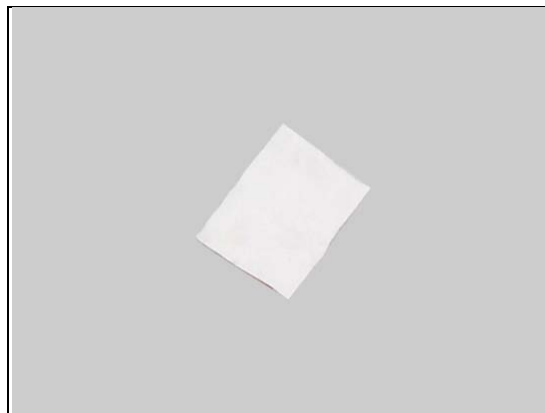
Remove the Water Indicator.

**Scrap! Not to be reused!**

#### INSTALLATION

Mount a new Water Indicator.

Press to secure its attachment.



## Replacement

### 4.48 Water Indicator 3x3

#### INSPECTION

Check whether the Water Indicator 3x3 has been activated (reddish color).

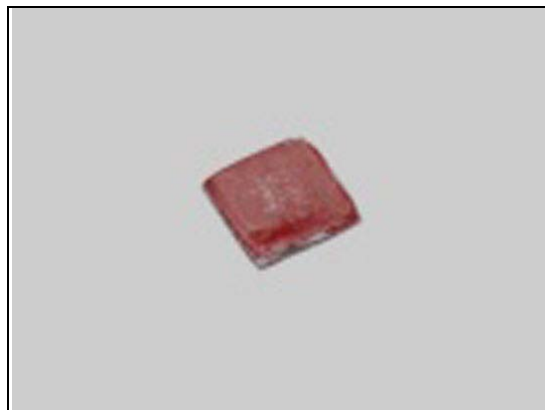
*Follow the 3.1 – 3.3 Disassembly instructions.*

*Carry out the Removal as described below.*

Prepare the new Water Indicator 3x3.

*Carry out the Installation as described below.*

*Follow the 5.3 – 5.5 Reassembly instructions.*



#### REMOVAL

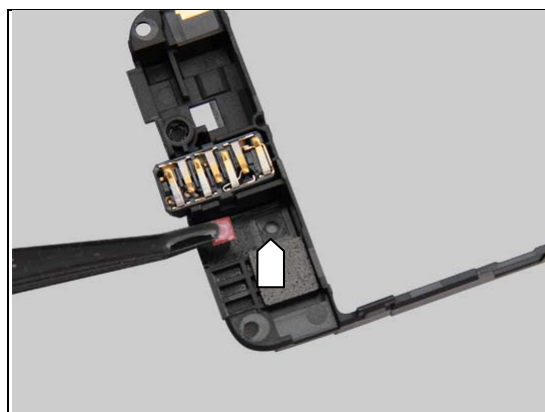
Remove the Water Indicator 3x3.

**Scrap! Not to be reused!**

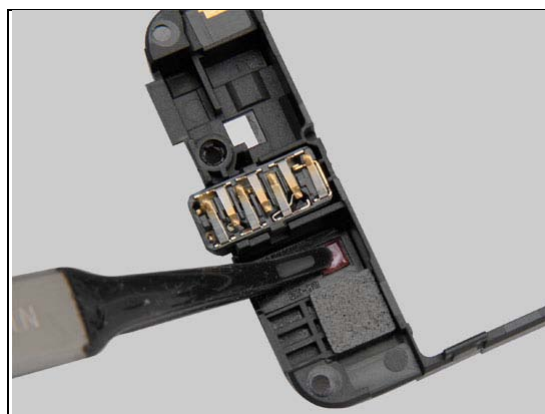


#### INSTALLATION

Mount a new Water Indicator 3x3.



Press to secure its attachment.



## Replacement

### 4.49 Board Swap - Replacement

*Follow the 3.1 – 3.4 Disassembly instructions.*

*Follow the 4.11 Removal instructions.*

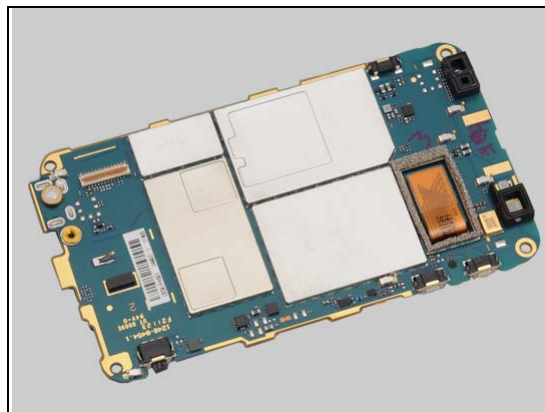
Replace the Swap Board.

*Reuse the Camera 5 MPixel.*

*Follow the 4.7, 4.11, 4.15, 4.21, 4.26, 4.29, 4.30, 4.36, 4.37, 4.43, 4.44 and 4.45, Installation instructions.*

*Follow the 5.2 – 5.5 Reassembly instructions.*

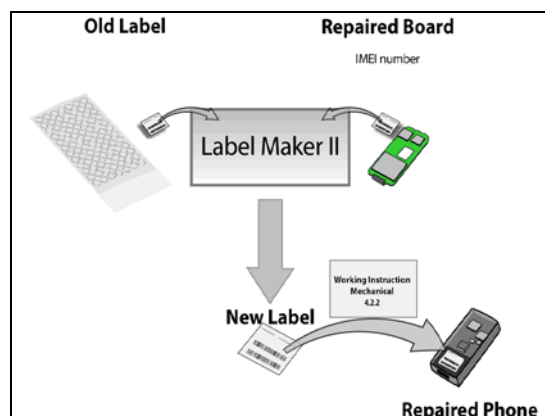
Startup the unit to initialize settings, before performing Customize Phone in Emma



### 4.50 Board Swap – Change Label

#### CHANGE LABEL

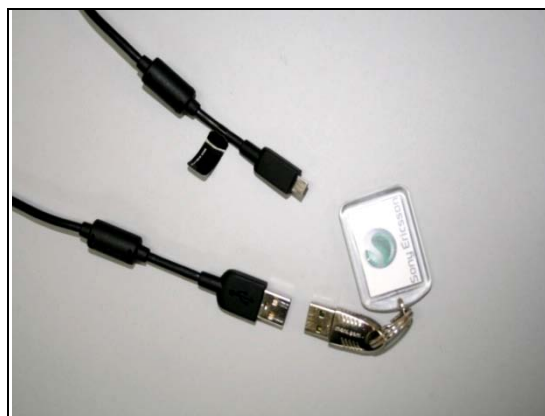
*Follow the instructions in the Generic Repair Manual – Build swap for change of label.*



### 4.51 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

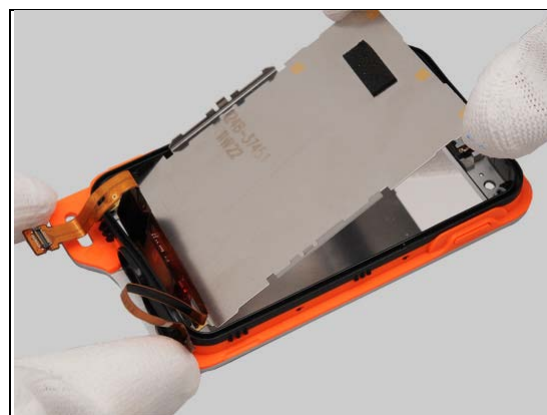
The disassembly is done in the following order:

1. Cover Front
2. LCD Support
3. Main PBA
4. Inner Frame
5. Cover Battery
6. Cover Back



### 5.1 Cover Front & LCD Support

Place the LCD Support into the Cover Front.



Press to snap the side hooks.



Remove the old Adhesive 3 x 6.

#### **Note!**

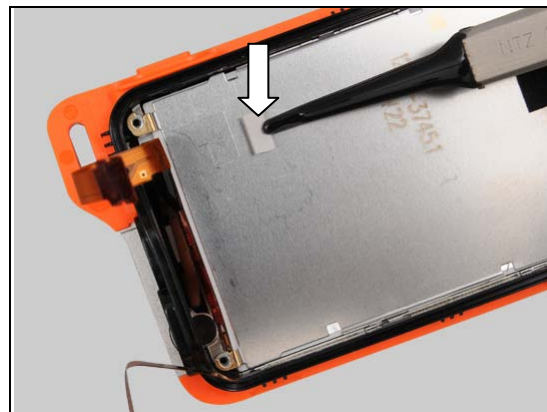
**To secure the location of the flex films, shall the Adhesive 3 x 6 been replaced with a new Adhesive every time the flex films have been released from the Support LCD.**





## Reassembly

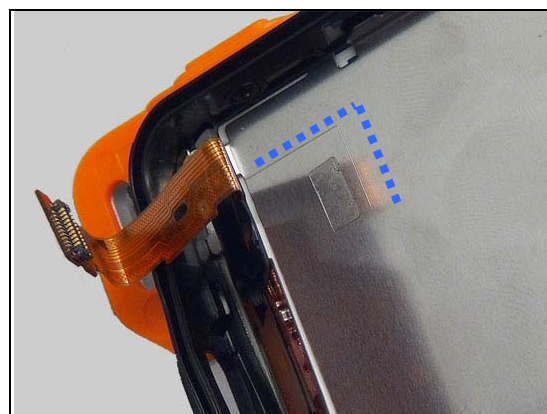
Mount a **new** Adhesive 3 x 6 on the LCD Support.



Press to secure the attachment.

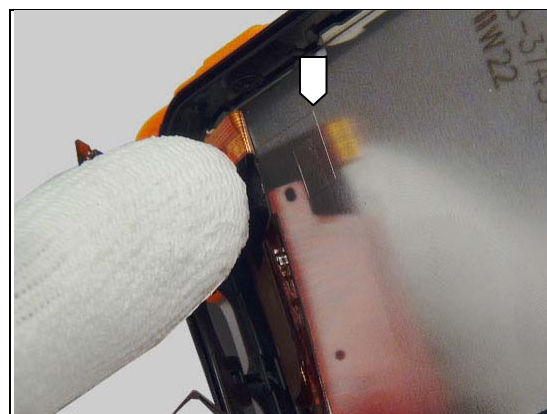


Align the flex films to the mark at the LCD Support.



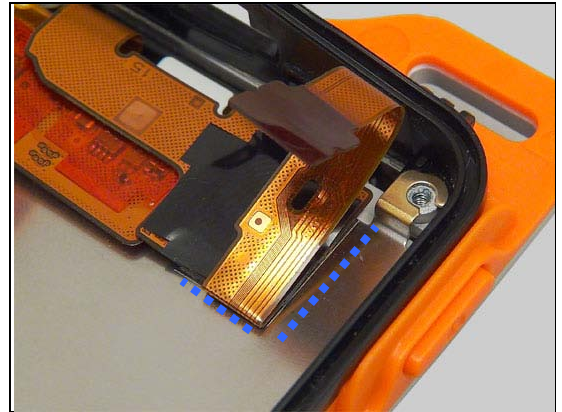
Press to secure the correct position of the flex films.

**Be careful not to damage the electrical components on the flex films.**



## Reassembly

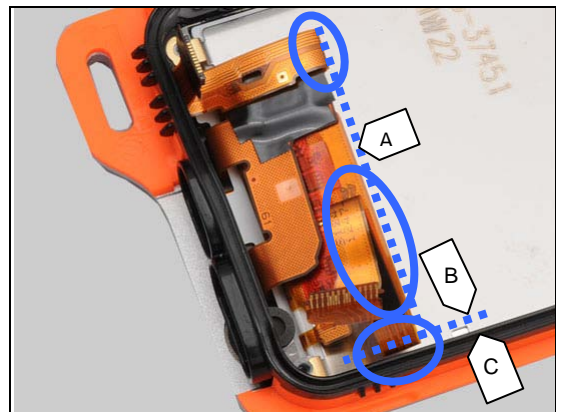
Correctly mounted flex films.  
Pre-bend the flex film directly after the stiffener.



Pre-bend both the flex films before the main PBA is reassembled.

**Note: Important: Make sure both top flexes bent are aligned along the flex beneath according the dotted line (A) and also that the right top flex is bent according dotted line (B) 1-2 mm from the front's right edge (C)!**

**This is important to make sure the bent flex films are not squeezed between LCD support and shielding cans!**

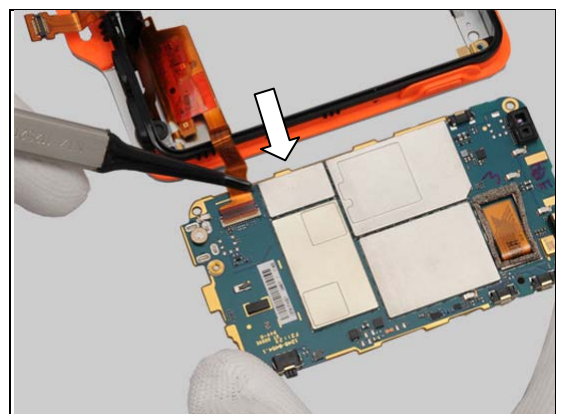


## 5.2 Main PBA

Place the Main PBA next to the front unit.



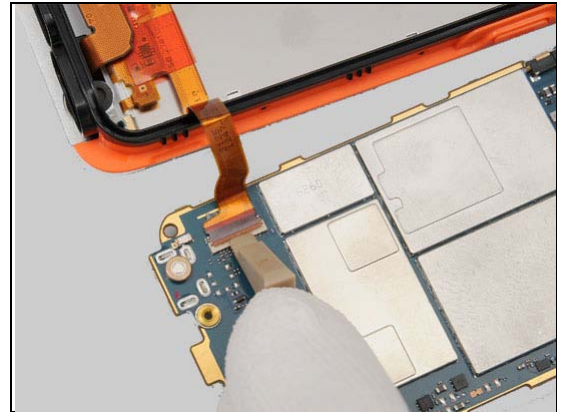
. Connect the ZIF connector.



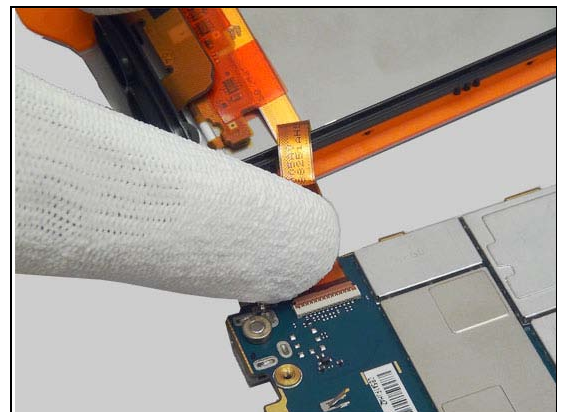


## Reassembly

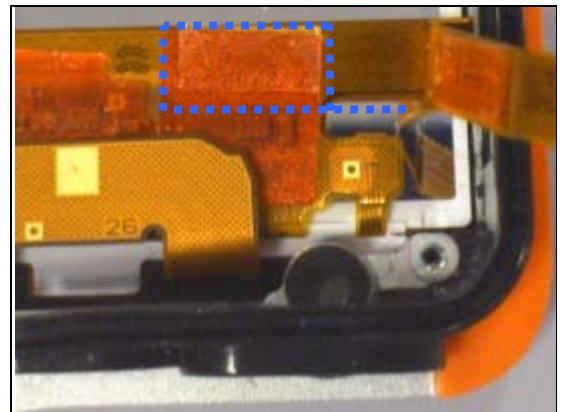
Close the ZIF connector with the Front Opening Tool



Press to attach the flex film to the Adhesive 7,8 x 1,4.

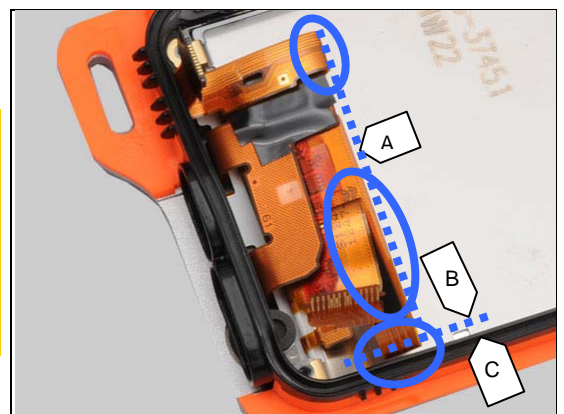


Secure there is adhesive on Adhesive Irregular (See Foil Adhesive for front flex if the adhesive is poor or missing)



**Note: Important: Make sure both top flexes bent are aligned along the flex beneath according the dotted line (A) and also that the right top flex is bent according dotted line (B) 1-2 mm from the front's right edge (C)!**

**This is important to make sure the bent flex films are not squeezed between LCD support and shielding cans!**



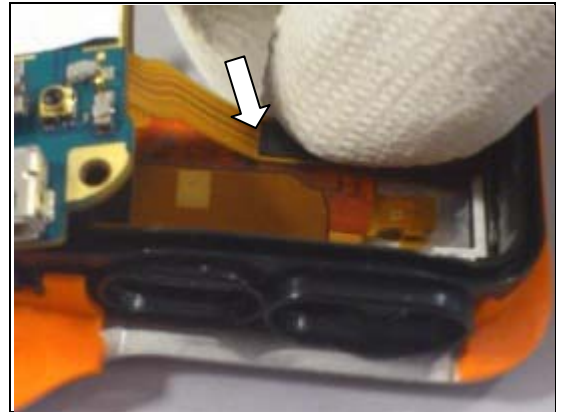




## Reassembly

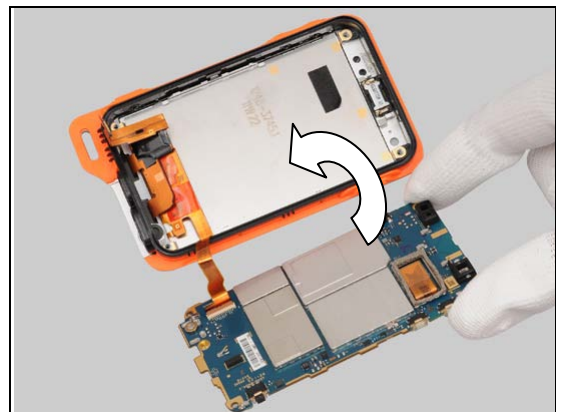
Secure the top right flex in the adhesive on Adhesive Irregular, make sure it follow the top edge of the flex beneath it.

***This is important to make sure the bent flex film don't move during assembly and is squeezed between LCD support and shielding cans!***



Turn over to place the Main PBA into the front unit.

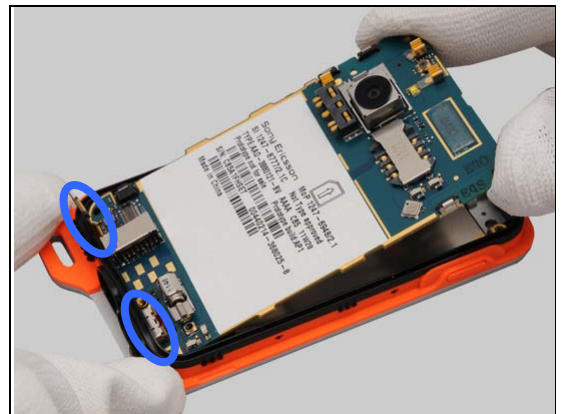
***Secure the position of the flex films!***



Shove the Main PBA into the front unit.

***Make sure that the BtB connector is above the Main PBA.***

***Secure the position of the Micro USB connector.***



## Reassembly

Press to snap the hooks.

**Listen to the click sound.**



Reconnect the BtB connector.



### 5.3 Inner Frame

Place the Inner Frame on the unit.



Press to secure its position.





## Reassembly

Apply  $18 \pm 1$  Ncm torque when tightening the four  
Screw Torx Len:5.2 Diam:3.0 with Bits (T5).



Apply  $18 \pm 1$  Ncm torque when tightening the  
Screw Torx Len:3.4 Diam:3.0 with Bits (T5).



### 5.4 Cover Battery

Reinstall the Battery.



Press the Battery in place with a finger.



## Reassembly

Make sure that the red sealings of the Cover Battery aren't dirty or damaged before it is assembled.



Place the Cover Battery in the correct position.



### Note!

**Reassembly the Cover Battery with great care. The Cover Battery is one of the parts that seal the unit. The red gasket shall not be visible when the unit is correctly assembled.**



Press around the unit until the red gasket is not visible.



## Reassembly

Press the opposite side until the red stripe disappears.



Press the top side until the red stripe disappears.



Press the bottom side until the red stripe disappears.



Press around the Loudspeaker to secure that the unit is water resistant.



## Reassembly

### 5.5 Cover Back

Make sure that the red gaskets of the Cap Audio and Cap USB aren't dirty, misaligned or damaged before the Cover Back is assembled.

Place the Cover Back in the correct position.

Press to snap the hooks.

***Snap the Cap Audio and the Cap USB closely to secure that the unit is water resistant.***





## 6 Revision History

Rev.	Date	Changes / Comments
1	2011-Sept-26	Initial release
2	2011-Sept-30	General adjustment to improve the quality.
3	2011-Nov-02	Added note on page 3 about the WRT
4	2011-Nov-25	Added a note regarding the Touch panel calibration note.
5	2011-Dec-14	Added instruction for Camera Key, Gasket Key sealing, Gasket Camera Key Sealing, PET-film Camera Switch, Sheet for On/Off Switch, Cushion Earspeaker and earspeaker shall not be reused.
6	2012-Feb-02	Important clarification on how to bend the fronts flexes on page 15 and 68.
7	2012-April-11	Tape to fix the front flex during assembly added to page 19 and 70-71.
8	2012-July-12	Board SWAP – replacement and Front updated
9	2012-Aug-31	Correct the mistakes in the cross references.
10	2012-Sept-04	No changes, due to system failure.
11	2012-Nov-06	Gasket Mic with Membrane added