

Working Instructions

- mechanical -



ST27i, ST27a

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make.believe

Working Instructions (mech)

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6 Revision History 57

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

1 Exterior Views

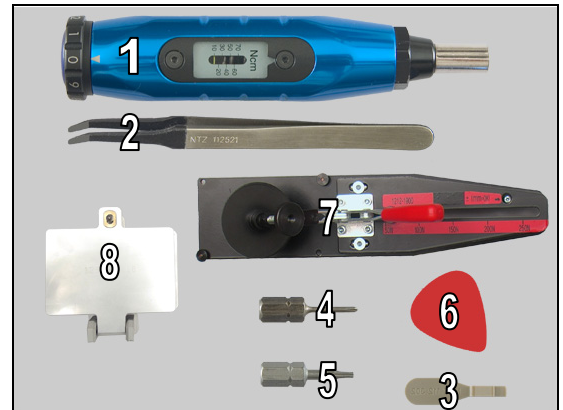
1.1 ST27i, ST27a



2 Tools

SPECIAL TOOLS

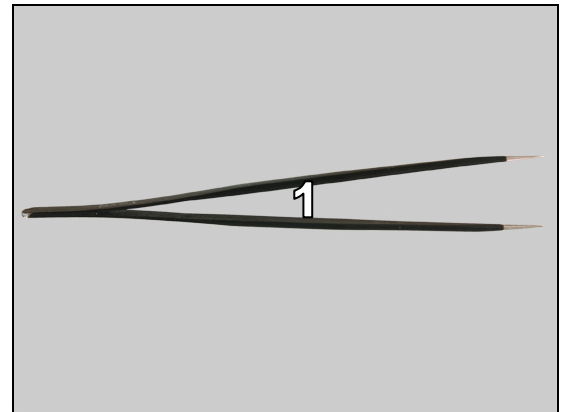
1. Torque Screwdriver
2. Flex Film Assembly Tool
3. Front Opening Tool
4. Bits(JCIS No 0)
5. Bits(T6)
6. Guitar Pick
7. Pressure Tool
8. Pressure Fixture



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

STANDARD TOOLS

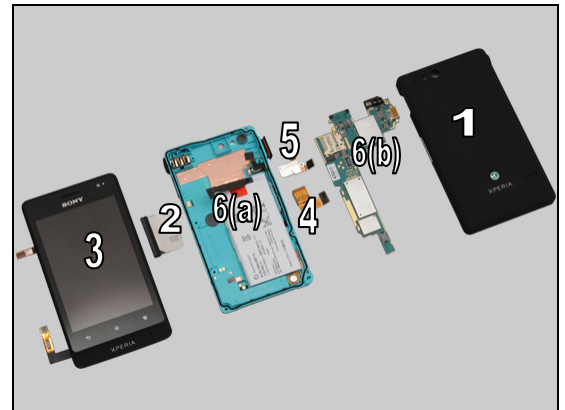
1. Tweezers (ESD-safe & non-metallic)



3 Disassembly

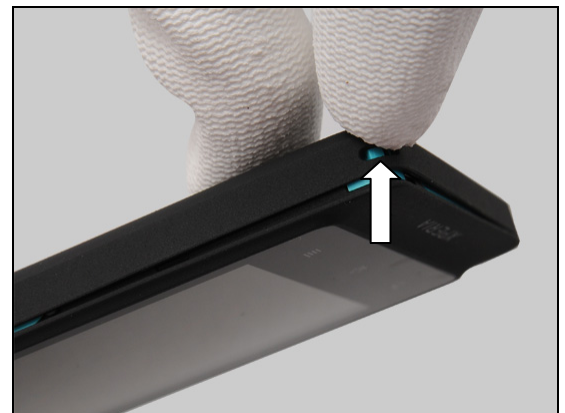
The disassembly is done in the following order:

1. Battery Cover Assy
2. SIM Drawer
3. Cover Front Housing Display Assy
4. Main Camera
5. Audio Jack FPC
6. Back Housing Assy (a) & Main PBA (b)

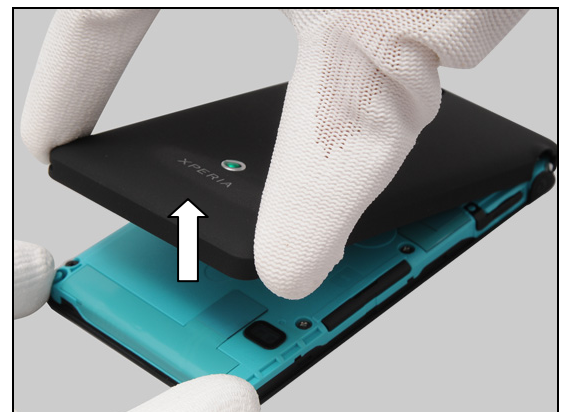


3.1 Battery Cover Assy

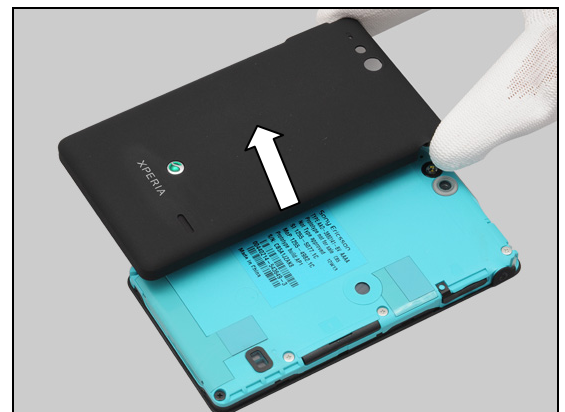
Lift up the Battery Cover Assy by gripping the hole with a finger.



Release the hook at bottom side.



Remove the Battery Cover Assy.



Disassembly

3.2 SIM Drawer

Pull out the SIM Drawer with fingers.



3.3 Cover Front Housing Display Assy

Remove the Screw Other Len:0.0 Diam:1.4 water proof by using a screwdriver with Bits (JCIS No 0).

Scrap! Not to be reused!

Press the phone tightly during all screws disassembly until the phone is turned over!



Remove the Screw Other Len:4.2 Diam:1.7 selftap by using a screwdriver with Bits (JCIS No 0).

Scrap! Not to be reused!

Press the phone tightly during all screws disassembly until the phone is turned over!



Remove the Screw Other Len:3.5 Diam:1.7 selftap by using a screwdriver with Bits (T6).

Scrap! Not to be reused!

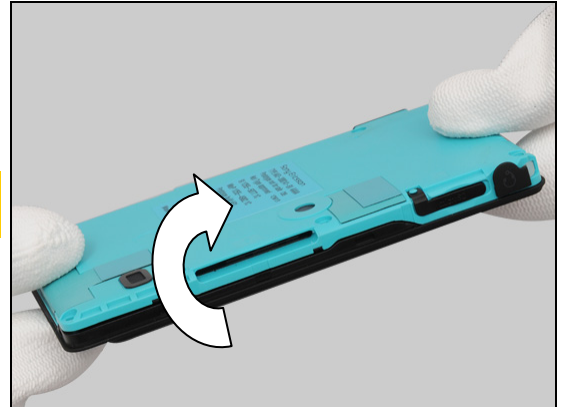
Press the phone tightly during all screws disassembly until the phone is turned over!



Disassembly

Turn over the phone.

Clamp the phone tightly with both hands when turning it over!

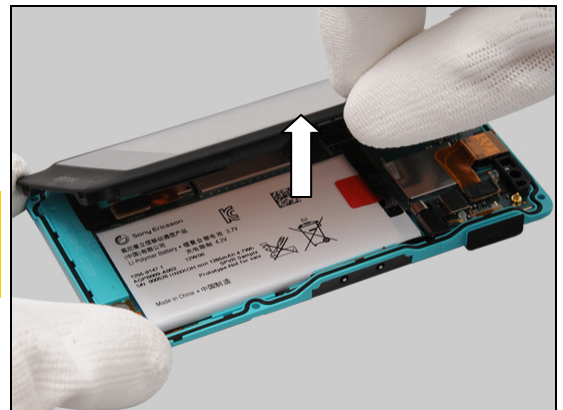


Turn over the phone to a horizontal position as shown in the picture.



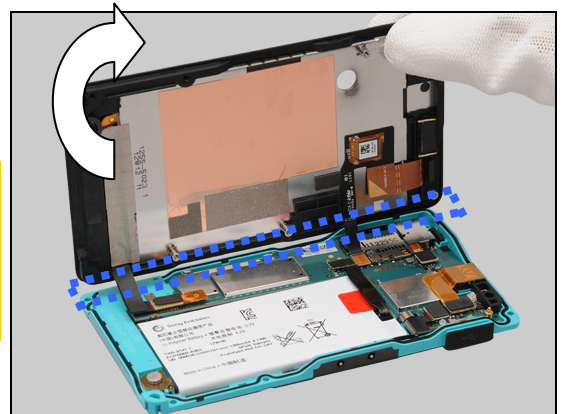
Open the Cover Front Housing Display Assy as shown to release the adhesive foil inside.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Turn over the Cover Front Housing Display Assy to a 90 degree angle and lift it up gently.

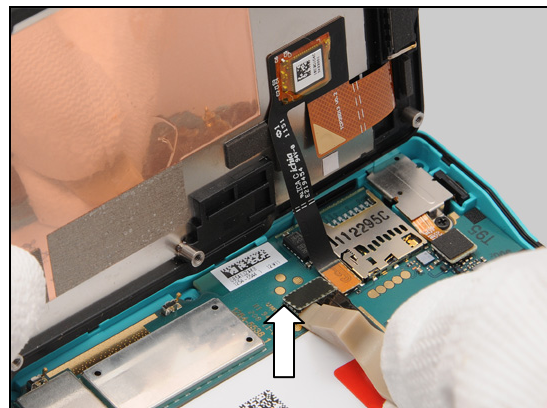
Do not touch the Main O Ring during operation!
Make sure there is some space to protect the Main O Ring.
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Disassembly

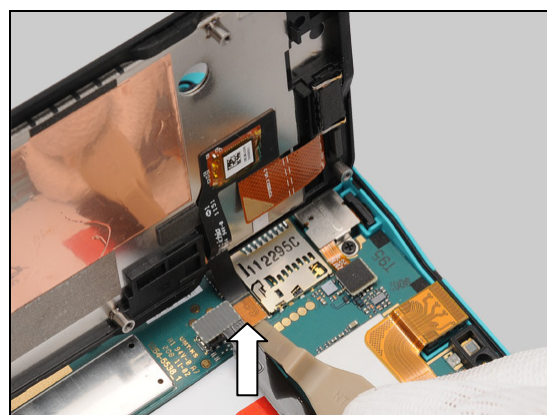
Unsnap the BtB connector of the Battery by using a Front Opening Tool.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Unsnap the BtB connector of the touch panel by using a Front Opening Tool.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



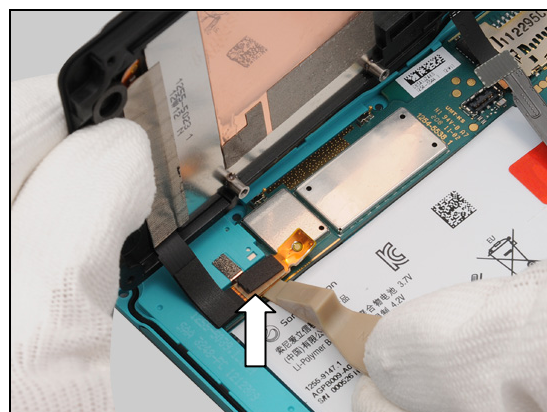
Detach the foil of the FPC.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Unsnap the BtB connector of the display by using a Front Opening Tool.

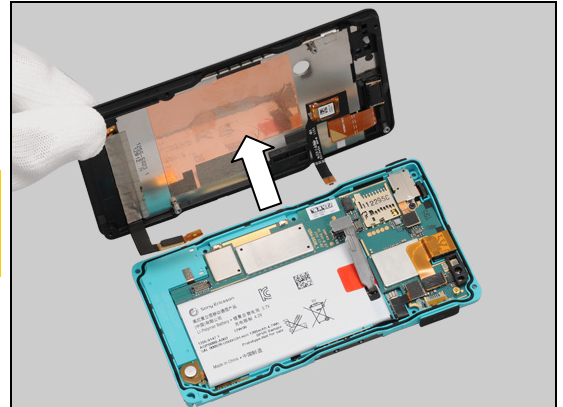
Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Disassembly

Remove the Cover Front Housing Display Assy.

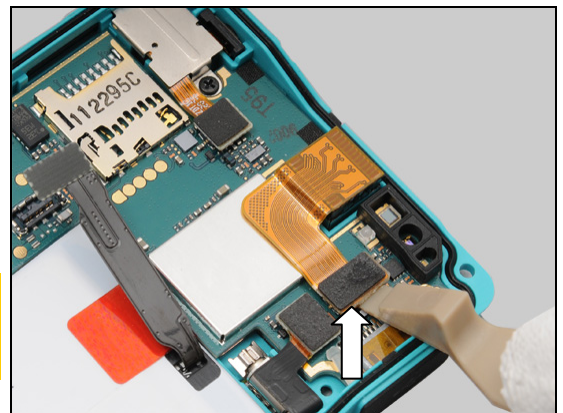
Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



3.4 Main Camera & Camera adhesive

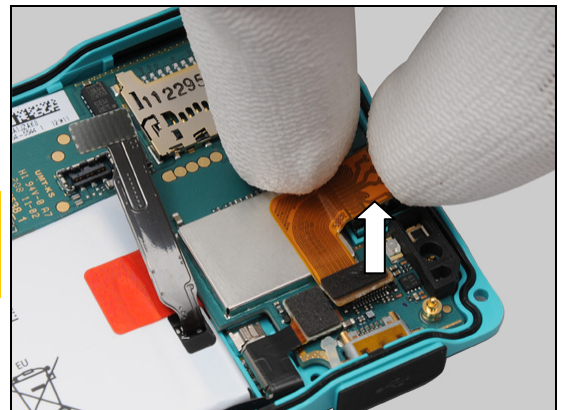
Unsnap the BtB connector of the Main Camera by using a Front Opening Tool.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



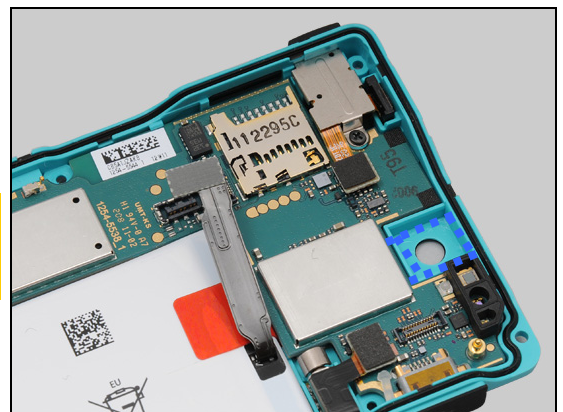
Lift up the Main Camera from the upper right corner and remove it.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Clean the Camera adhesive surplus on the Back Housing Assy.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Disassembly

Clean the surplus on the backside of the Main Camera.



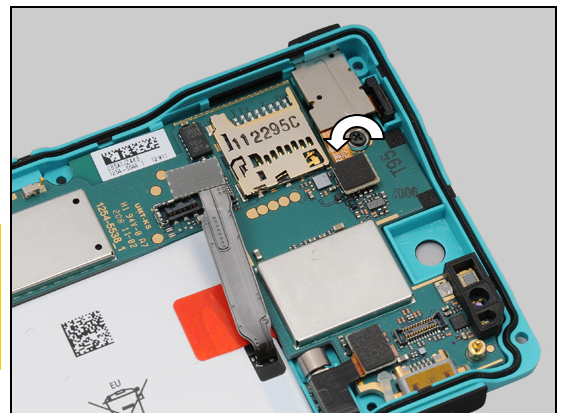
3.5 Audio Jack FPC

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

Scrap! Not to be reused!

Do not touch the Main O Ring during operation!

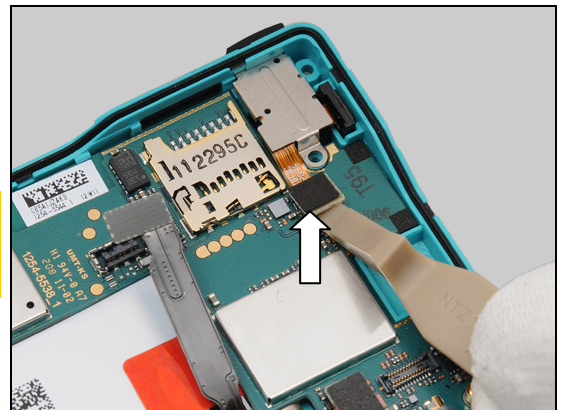
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Unsnap the BtB connector of the Audio Jack FPC by using a Front Opening Tool.

Do not touch the Main O Ring during operation!

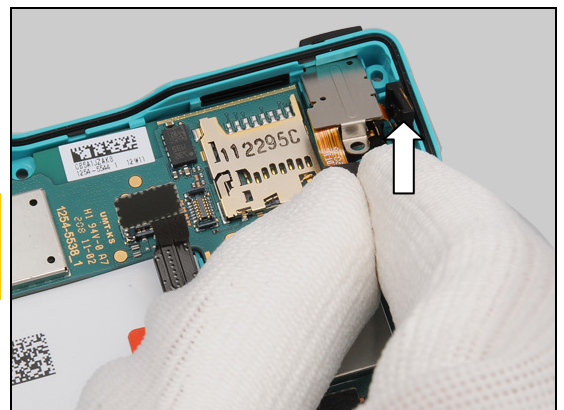
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Remove the power key on the Audio Jack FPC from its cavity.

Do not touch the Main O Ring during operation!

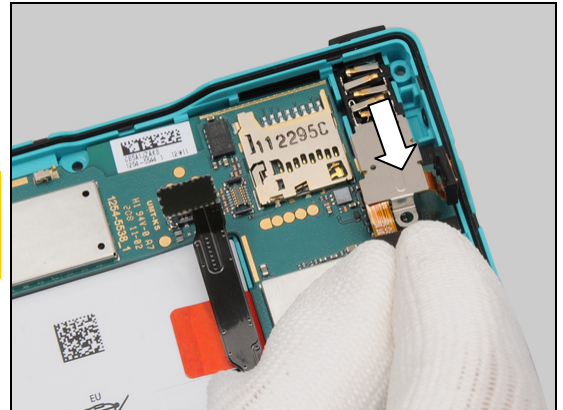
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Disassembly

Remove the Audio Jack FPC.

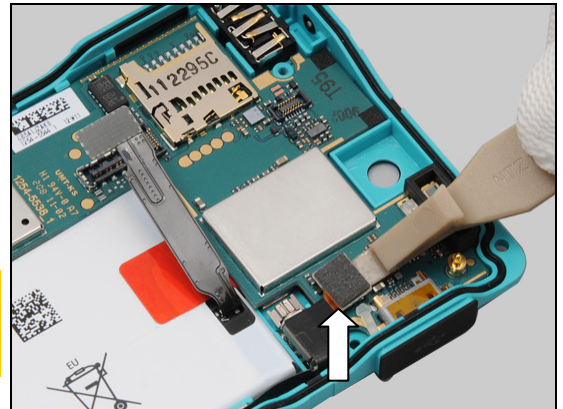
**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



3.6 Back Housing Assy & Main PBA

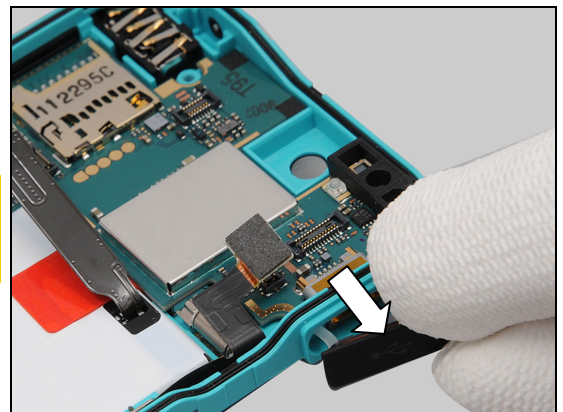
Unsnap the BtB connector of the Vibrator Main Mic Volume key FPC by using a Front Opening Tool.

**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



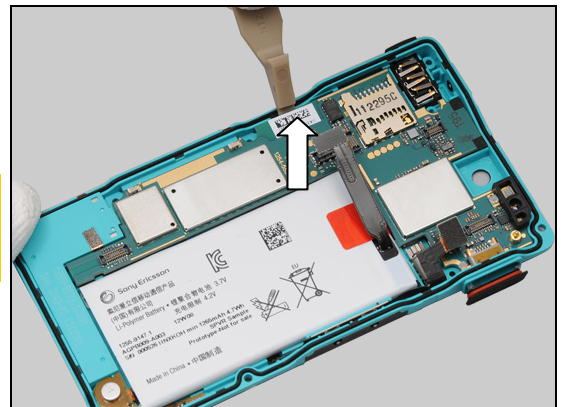
Open the Micro USB Cap.

**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Insert the Front Opening Tool to lift up the Main PBA.

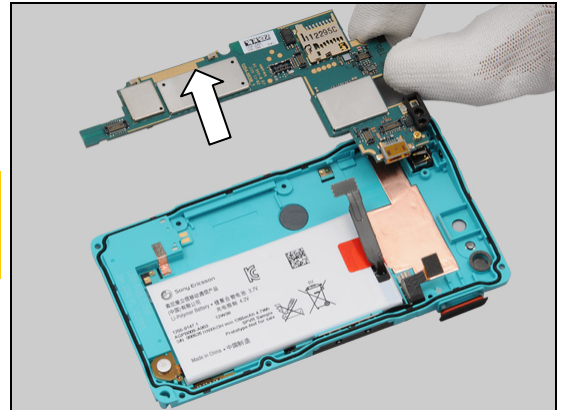
**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Disassembly

Remove the Main PBA.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!



4 Replacement

4.1 Battery Cover Assy

Follow the 3.1 Disassembly instructions!

Prepare the new Battery Cover Assy.

Follow the 5.6 Reassembly instructions!



4.2 SIM Drawer

Follow the 3.1 – 3.2 Disassembly instructions!

Prepare the new SIM Drawer.

Follow the 5.5 – 5.6 Reassembly instructions!



4.3 Cover Front Housing Display Assy

Follow the 3.1 – 3.3 Disassembly instructions!

Follow the 4.12, 4.16 and 4.20 Removal instructions!

Prepare the new Cover Front Housing Display Assy.

Follow the 4.12, 4.16 and 4.20 Installation instructions!

Follow the 5.4 – 5.6 Reassembly instructions!

Proxy sensor calibration has to be performed for all replaced units; 1262-6643 Trouble Shooting Application – mechanical.

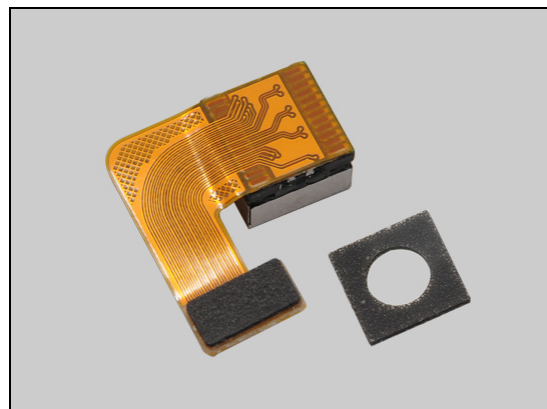


4.4 Main Camera & Camera adhesive

Follow the 3.1 – 3.4 Disassembly instructions!

Prepare the new Main Camera and Camera adhesive.

Follow the 5.3 – 5.6 Reassembly instructions!



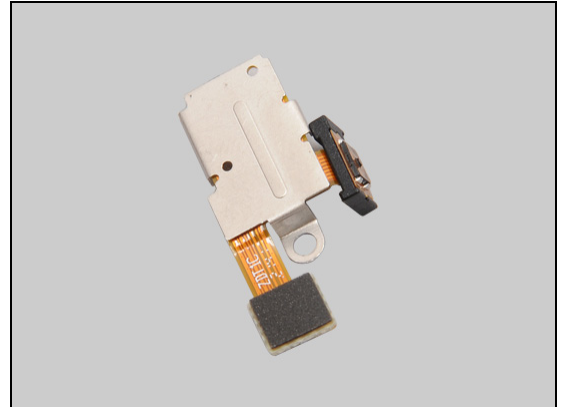
Replacement

4.5 Audio Jack FPC

Follow the 3.1 – 3.5 Disassembly instructions!

Prepare the new Audio Jack FPC.

Follow the 5.2 – 5.6 Reassembly instructions!



4.6 Back Housing Assy

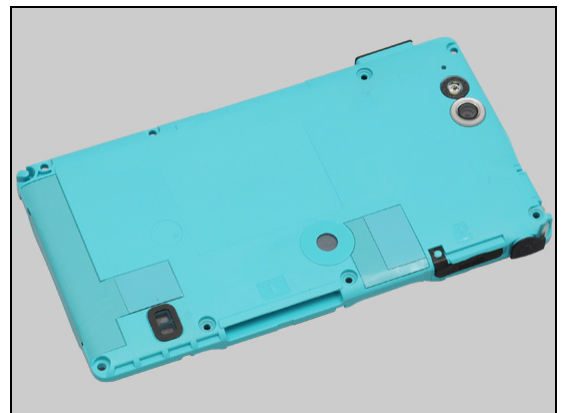
Follow the 3.1 – 3.6 Disassembly instructions!

Follow the 4.7, 4.8, 4.10, 4.11, 4.13, 4.14, 4.15, 4.17, 4.18, 4.19 and 4.21 Removal instructions!

Prepare the new Back Housing Assy.

Follow the 4.7, 4.8, 4.10, 4.11, 4.13, 4.14, 4.15, 4.17, 4.18, 4.19 and 4.21 Installation instructions!

Follow the 5.1 – 5.6 Reassembly instructions!



Replacement

4.7 Audio Jack Cap

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Audio Jack Cap.

Carry out the Installation as described below.

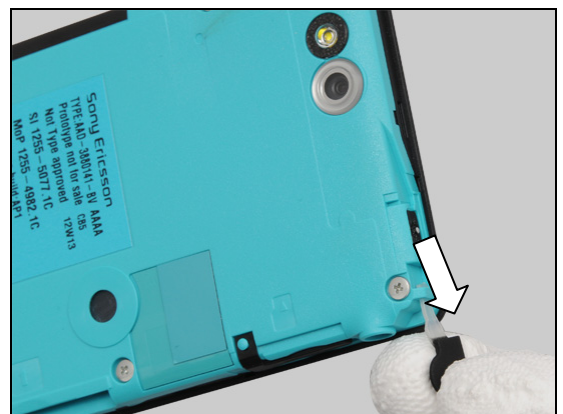
Follow the 5.6 Reassembly instructions!

REMOVAL

Open the Audio Jack Cap.



Pull it out of the hole.



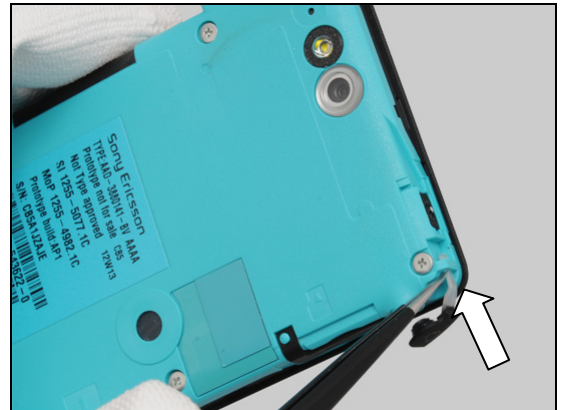
INSTALLATION

Place the Audio Jack Cap in the correct position as shown in the picture.



Replacement: Audio Jack Cap

Insert it into the hole by using a pair of tweezers.



Replacement

4.8 Battery & Battery Adhesive

Follow the 3.1 – 3.3 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Battery and Battery Adhesive.
 Carry out the Installation as described below.
Follow the 5.4 – 5.6 Reassembly instructions!

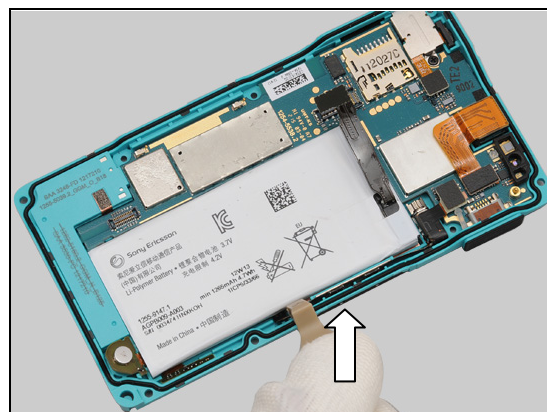
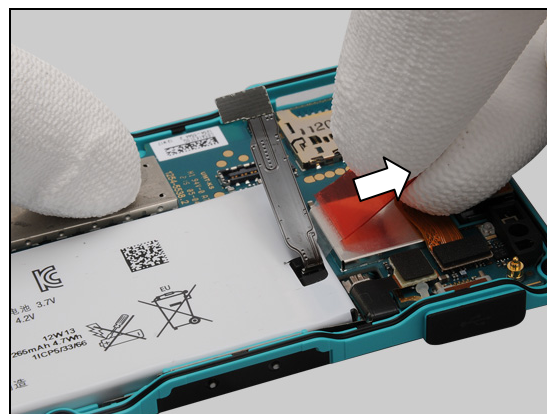
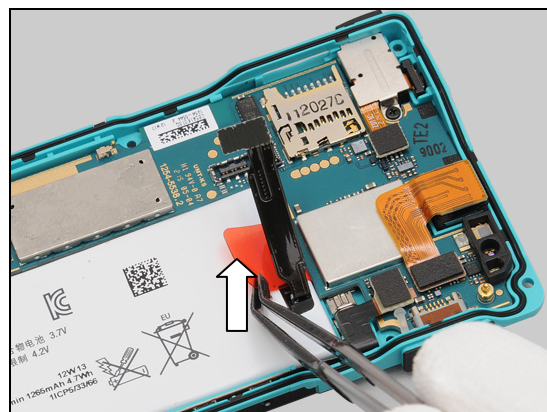
REMOVAL

Detach the foil of the Battery Adhesive by using a Flex Film Assembly Tool.

Gently pull out the Battery Adhesive.

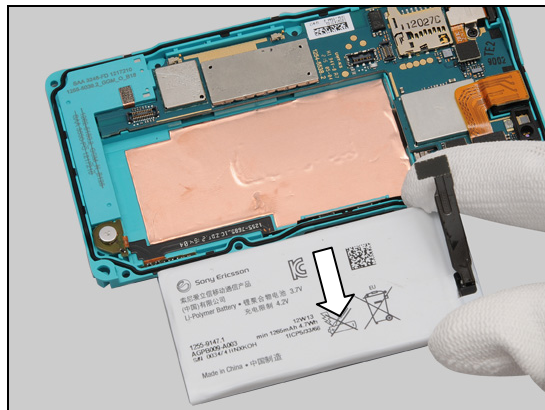
Insert the Front Opening Tool to lift up the Battery.

Do not touch the FPC!



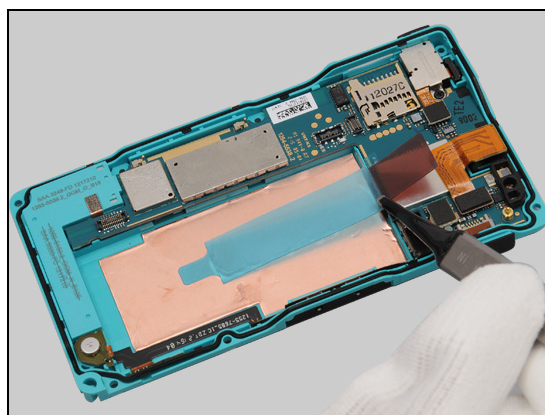
Replacement: Battery & Battery Adhesive

Remove the Battery.

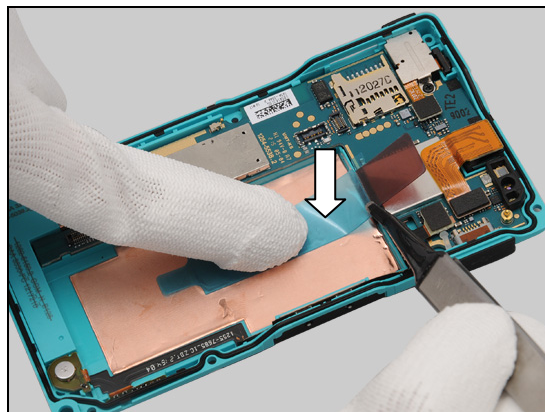


INSTALLATION

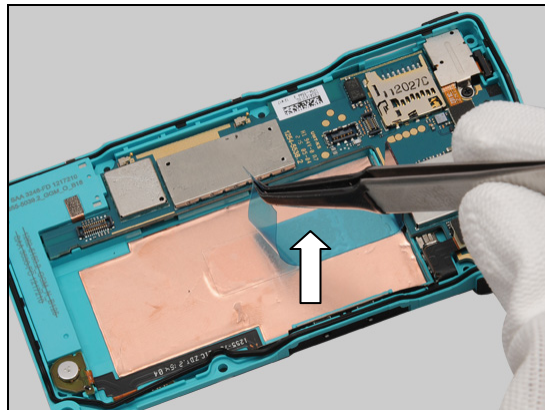
Place the Battery Adhesive in the correct position.



Press the protection tape to secure its attachment.

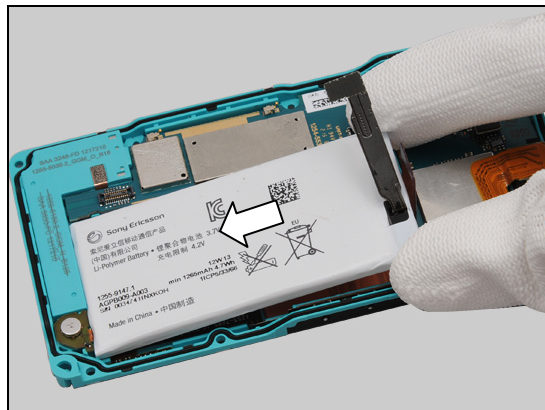


Peel off the protection tape.

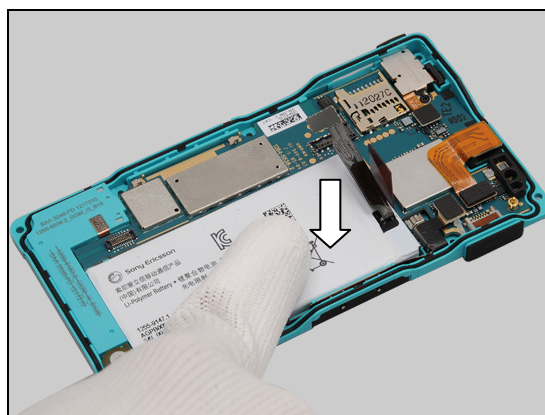


Replacement: Battery & Battery Adhesive

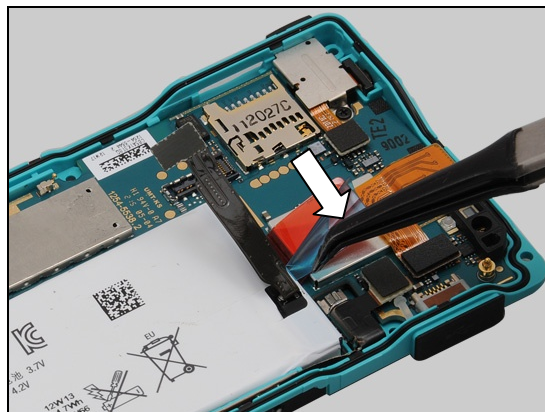
Insert the Battery into its cavity.



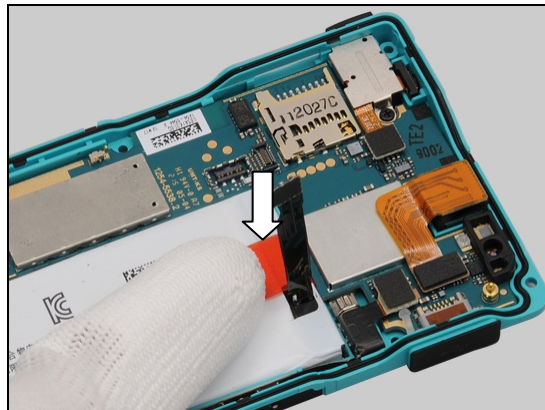
Press to secure its position and attachment.



Peel off the protection tape.



Press to secure its position and attachment.



Replacement

4.9 Bracket Proximity Sensor

Follow the 3.1 – 3.3 Disassembly instructions!

Carry out the Removal as described below.

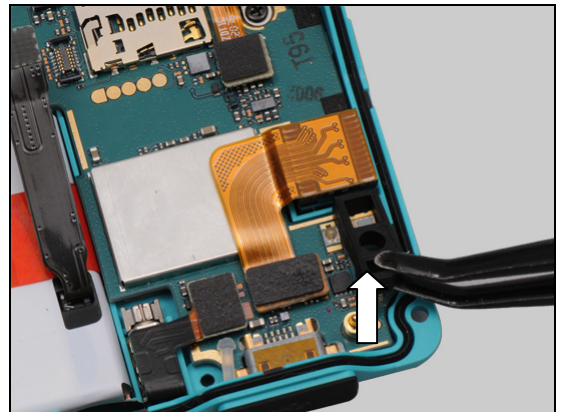
Prepare the new Bracket Proximity Sensor.

Carry out the Installation as described below.

Follow the 5.4 – 5.6 Reassembly instructions!

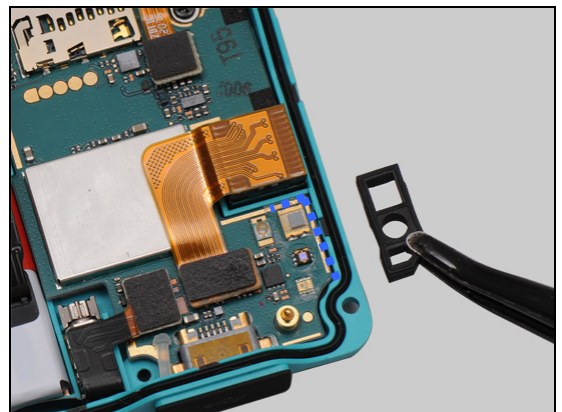
REMOVAL

Detach and remove the Bracket Proximity Sensor by using a Flex Film Assembly Tool.

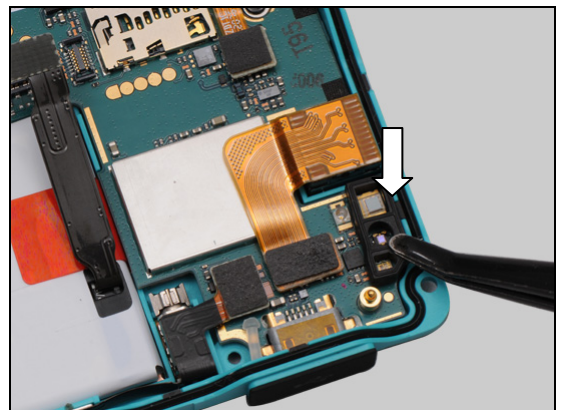


INSTALLATION

Place a new Bracket Proximity Sensor in the correct position.



Press to secure its position and attachment.



Replacement

4.10 Conn Audio Jack

Follow the 3.1 – 3.5 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Conn Audio Jack.

Carry out the Installation as described below.

Follow the 5.2 – 5.6 Reassembly instructions!

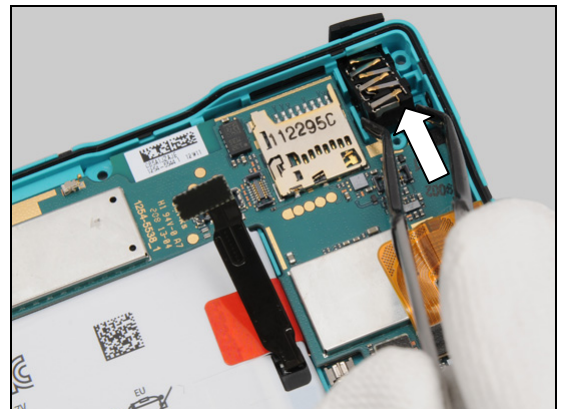
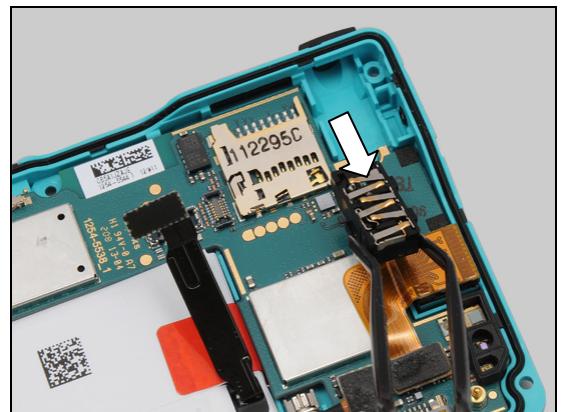
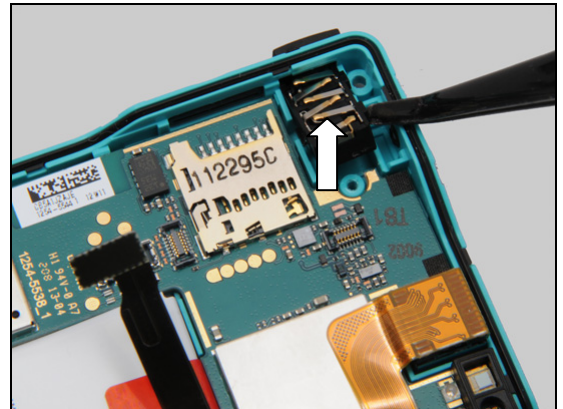
REMOVAL

Lift up the Conn Audio Jack from the top side by using a Flex Film Assembly Tool.

Remove the Conn Audio Jack.

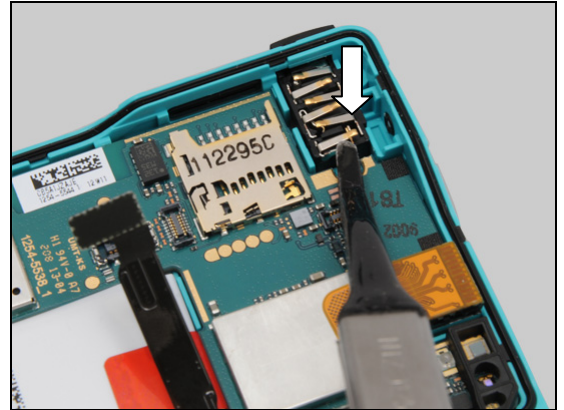
INSTALLATION

Insert the Conn Audio Jack into the hole of the Audio Jack Cap.



Replacement: Conn Audio Jack

Press to secure its position.



Replacement

4.11 Core Unit Label

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Core Unit Label.

Carry out the Installation as described below.

Follow the 5.6 Reassembly instructions!

REMOVAL

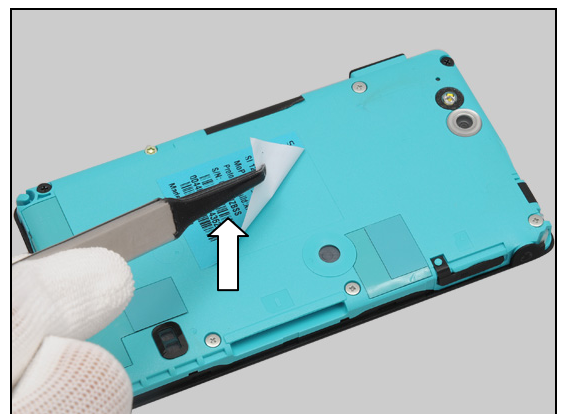
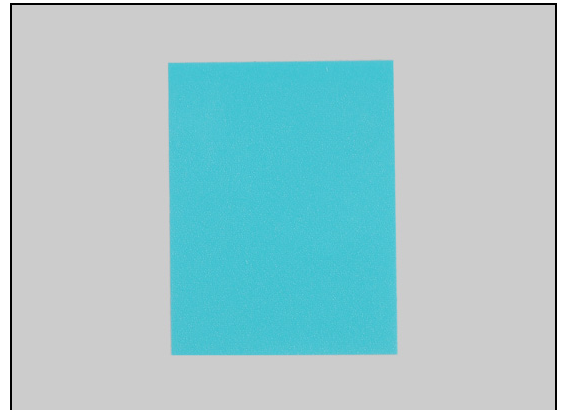
Copy the old Core Unit Label information into the 'LabelMake' program.

Carefully remove the Label by using a Flex Film Assembly Tool.

INSTALLATION

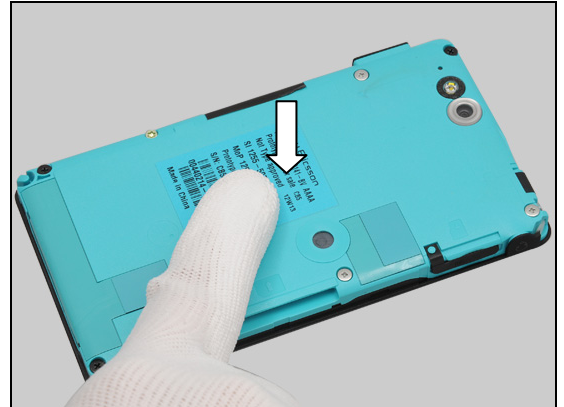
Check that the correct label format is loaded in the Zebra printer and print a new Label by using the 'LabelMake' software.

Only one label is allowed!



Replacement: Core Unit Label

Press along the surface to secure its attachment.



Replacement

4.12 Ear Speaker & Receiver Adhesive

Follow the 3.1 – 3.3 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Ear Speaker and Receiver Adhesive.

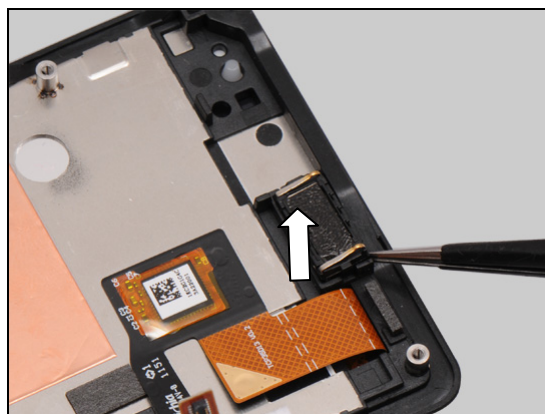
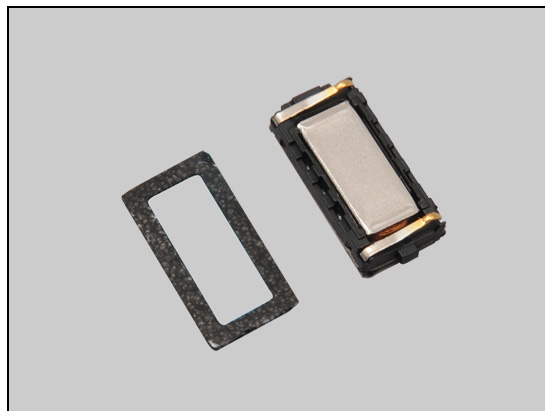
Carry out the Installation as described below.

Follow the 4.20 Installation instructions!

Follow the 5.4 – 5.6 Reassembly instructions!

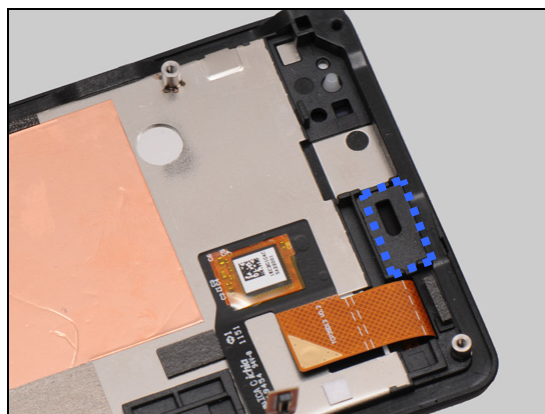
REMOVAL

Detach the Ear Speaker by using a pair of tweezers.



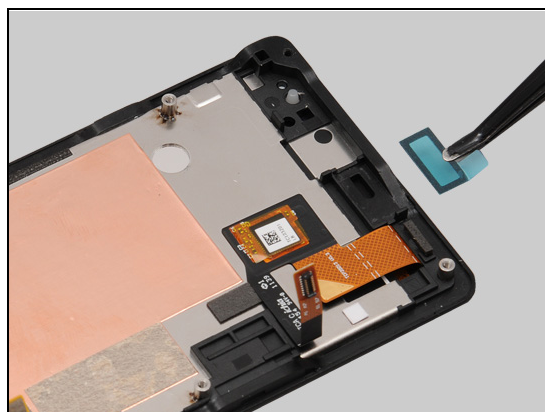
Clean the remaining foil of the Receiver Adhesive on the Cover Front Housing Display Assy.

Scrap! The Receiver adhesive is not allowed to be reused!



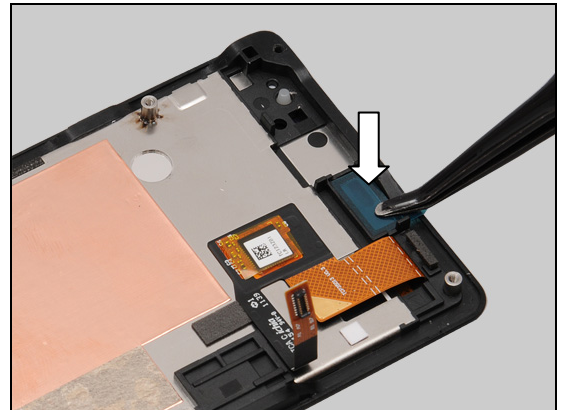
INSTALLATION

Place a new Receiver Adhesive in the correct position.

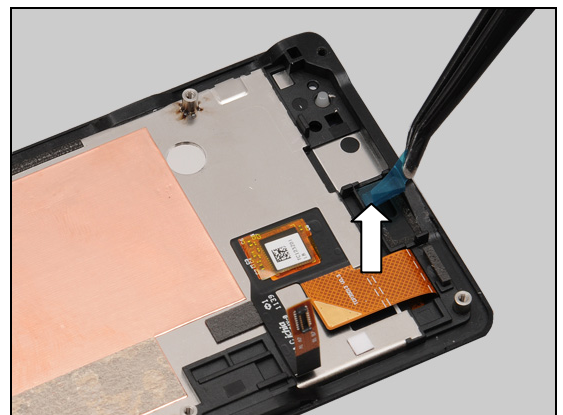


Replacement: Ear Speaker & Receiver Adhesive

Press to secure its attachment.



Peel off the protection tape.



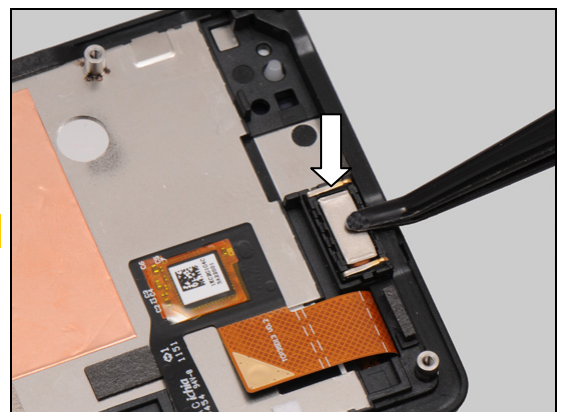
Place a new Ear Speaker in the correct position.

**The pin direction should be as shown in the picture!
Make sure there is no adhesive on the back side of the Ear Speaker.**



Press to secure its attachment.

Do not touch the pins of the Ear Speaker!



Replacement

4.13 Key Sealing Gasket

Follow the 3.1 Disassembly instructions!

Follow the 4.14 and 4.15 Removal instructions!

Carry out the Removal as described below.

Prepare the new Key Sealing Gasket.

Carry out the Installation as described below.

Follow the 4.14 and 4.15 Installation instructions!

Follow the 5.6 Reassembly instructions!

REMOVAL

There are three Key Sealing Gaskets as shown in the picture.

Detach the Key Sealing Gasket.

INSTALLATION

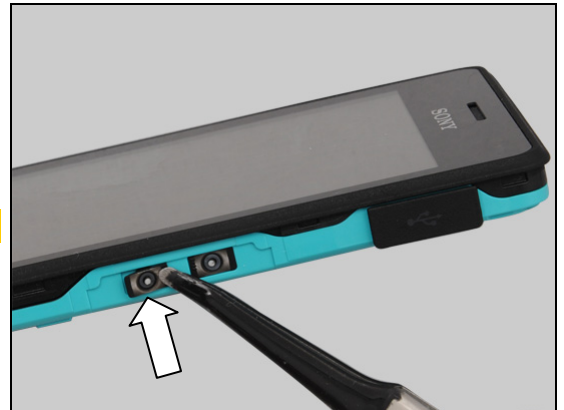
Place a new Key Sealing Gasket in the correct position.



Replacement: Key Sealing Gasket

Press to secure its attachment.

It's related water proof, mount them closely!



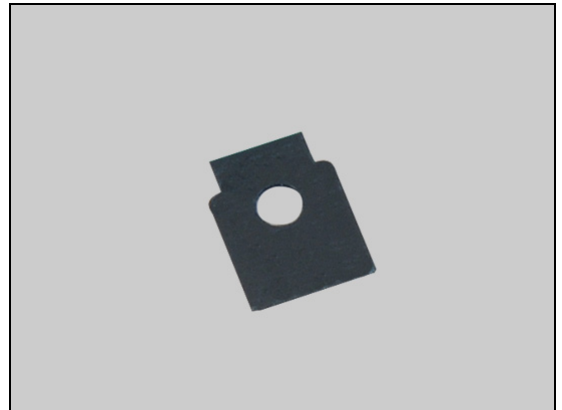
Replacement

4.14 Key sealing Shading film for power key

Follow the 3.1 Disassembly instructions!
Carry out the Removal as described below.
 Prepare the new Key sealing Shading film for power key.
Carry out the Installation as described below.
Follow the 5.6 Reassembly instructions!

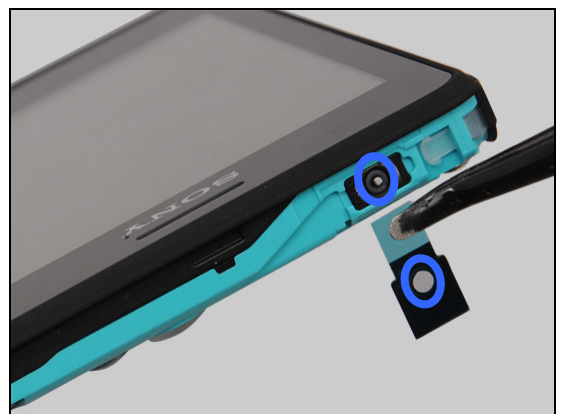
REMOVAL

Peel off the Key sealing Shading film for power key.



INSTALLATION

Place a new Key sealing Shading film for power key in the correct position.



Press to secure its position and attachment.



Replacement: Key sealing Shading film for power key

Peel off the protection tape.



Replacement

4.15 Key sealing Shading film for volume key

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

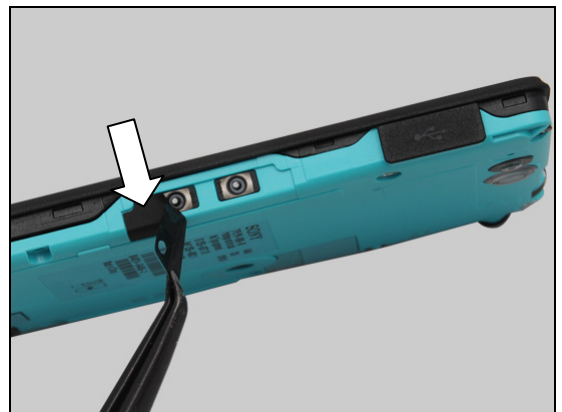
Prepare the new Key sealing Shading film for volume key.

Carry out the Installation as described below.

Follow the 5.6 Reassembly instructions!

REMOVAL

Peel off the Key sealing Shading film for volume key.



INSTALLATION

Place a new Key sealing Shading film for volume key in the correct position.



Press to secure its position and attachment.

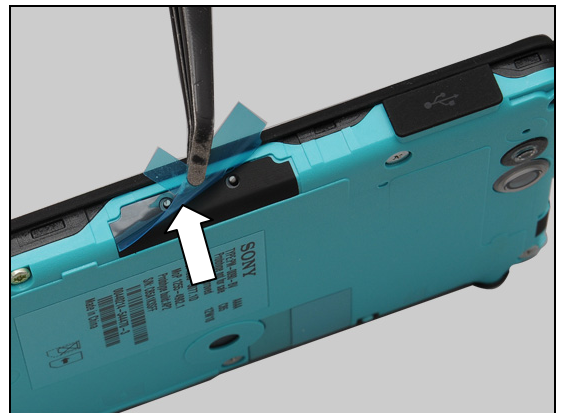


Replacement: Key sealing Shading film for volume key

Press to secure its position and attachment.



Peel off the protection tape.



Replacement

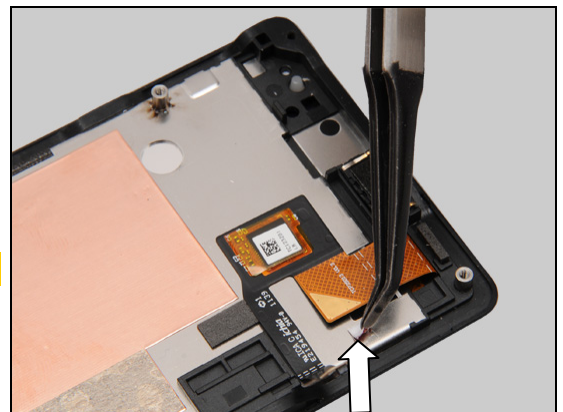
4.16 Liquid Indicator

Follow the 3.1 – 3.3 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Liquid Indicator.
 Carry out the Installation as described below.
Follow the 5.4 – 5.6 Reassembly instructions!

REMOVAL

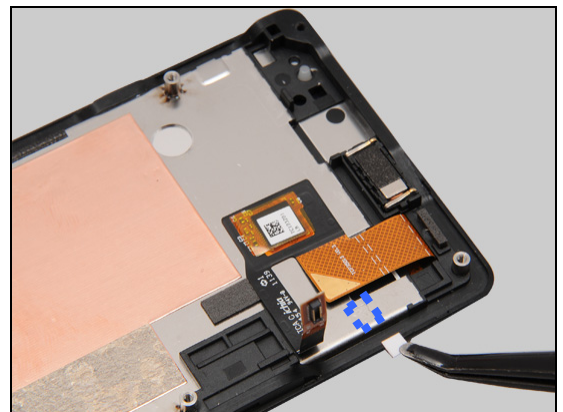
Detach the Liquid Indicator.

Scrap! Not to be reused!

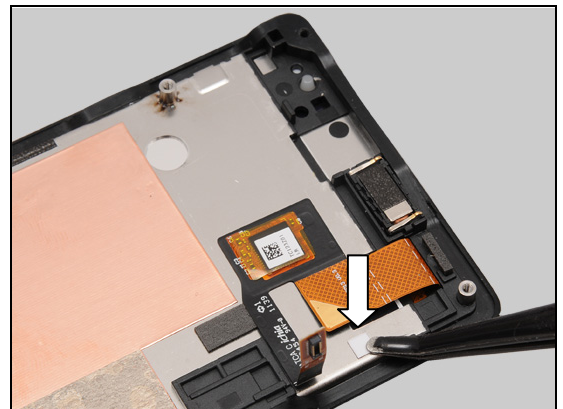


INSTALLATION

Place a new Liquid Indicator in the correct position.



Press to secure its attachment.



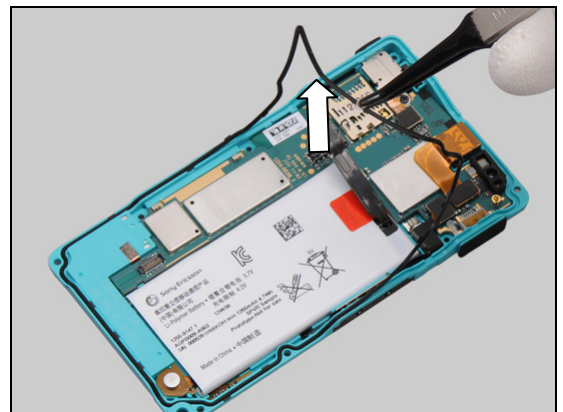
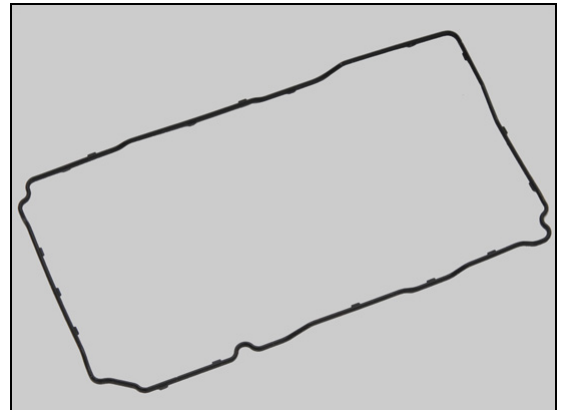
Replacement

4.17 Main O Ring

Follow the 3.1 – 3.3 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Main O Ring.
 Carry out the Installation as described below.
 Follow the 5.4 – 5.6 Reassembly instructions!

REMOVAL

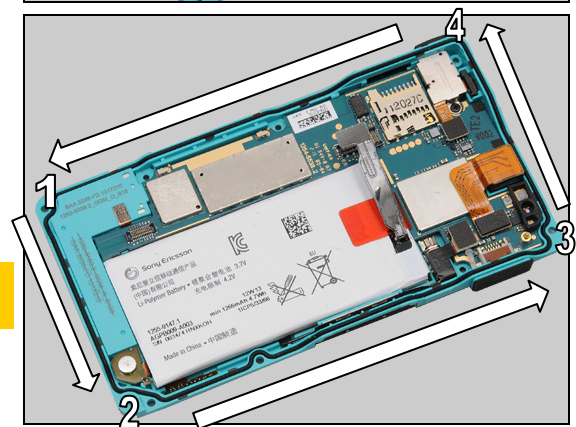
Lift up the Main O Ring by using a Flex Film Assembly Tool.



INSTALLATION

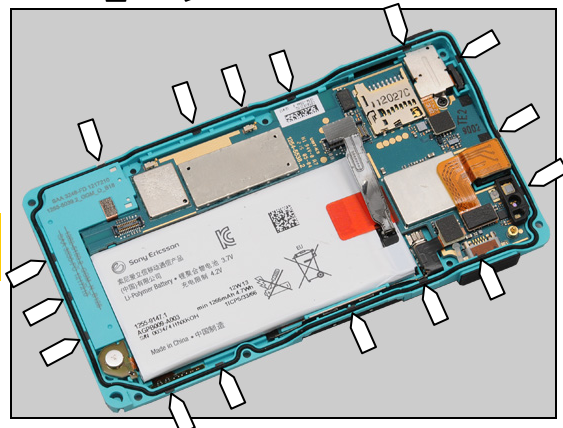
Place a new Main O Ring into the cavity according to sequence 1-4 as shown in the picture.

Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Check all the hooks one by one around the Main O Ring to make sure it is in the correct position.

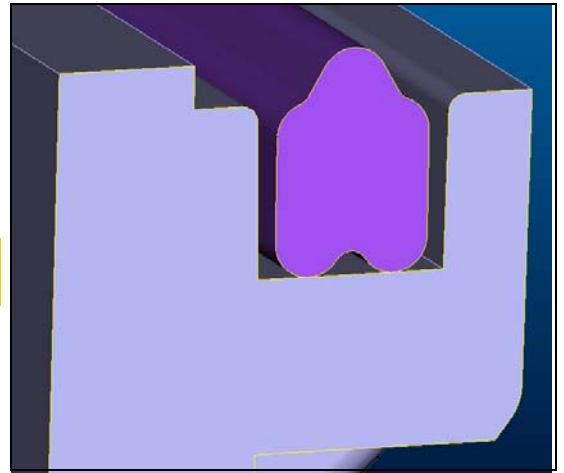
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Replacement: Main O Ring

Check the Main O Ring transect status to make sure it is assembled correctly, no twisted.

Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Replacement

4.18 Micro SD Cover

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Micro SD Cover.

Carry out the Installation as described below.

Follow the 5.6 Reassembly instructions!

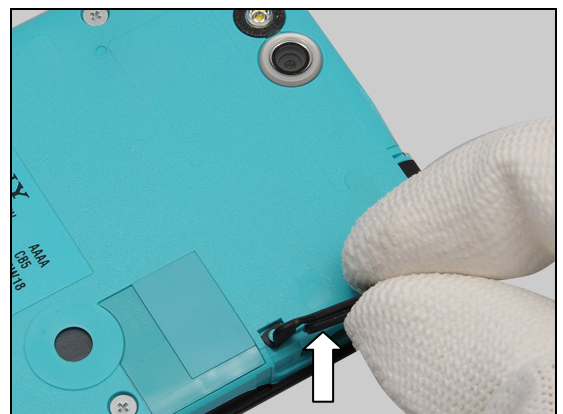
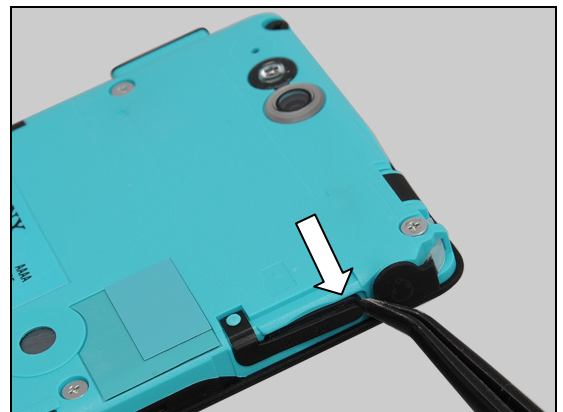
REMOVAL

Open the Micro SD Cover by using a Flex Film Assembly Tool.

Pull it out from the pillar.

INSTALLATION

Place the Micro SD Cover in the correct position.



Replacement: Micro SD Cover

Press the Micro SD Cover into the pillar to secure its position.



Push it into the cavity.



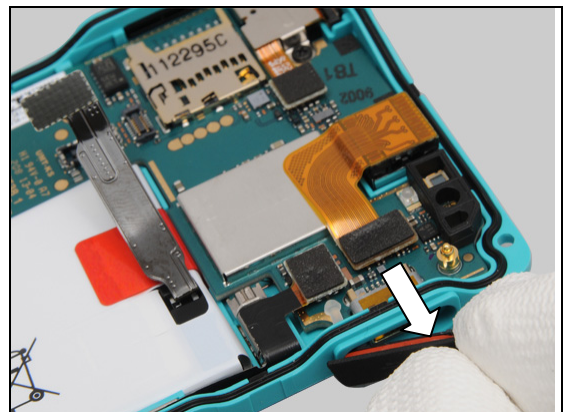
Replacement

4.19 Micro USB Cap

Follow the 3.1 – 3.3 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Micro USB Cap.
 Carry out the Installation as described below.
Follow the 5.4 – 5.6 Reassembly instructions!

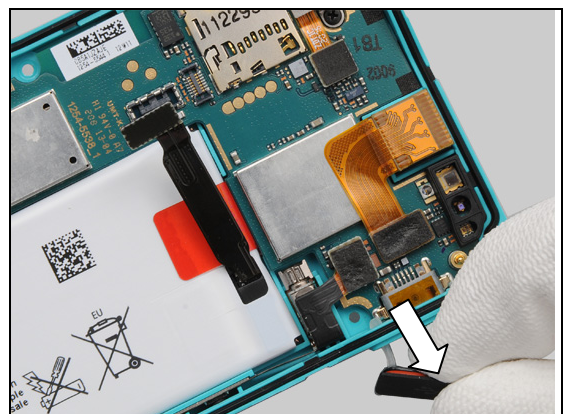
REMOVAL

Open the Micro USB Cap.



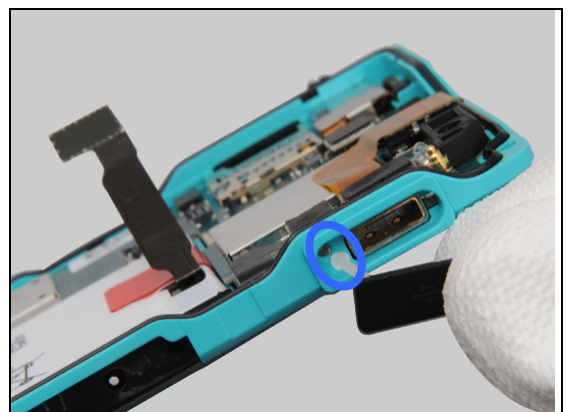
Pull it out from the hole.

Note: If the pillar is broken inside phone, remove it!



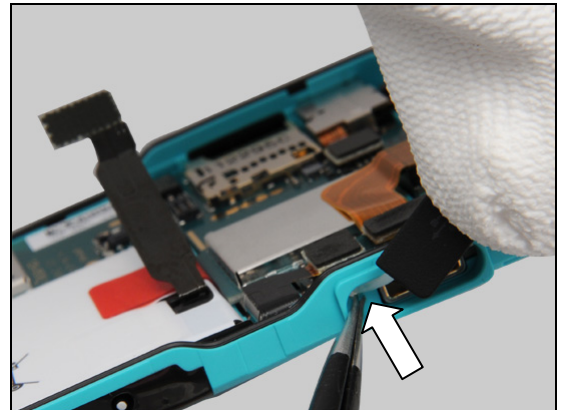
INSTALLATION

Place the Micro USB Cap in the correct position.



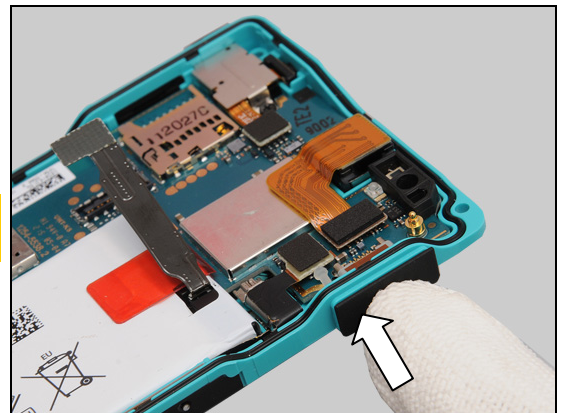
Replacement: Micro USB Cap

Insert the pillar into the hole by using a pair of tweezers.



Press the Micro USB Cap into its cavity.

Make sure the pillar of the Micro USB Cap is above the Main PBA!



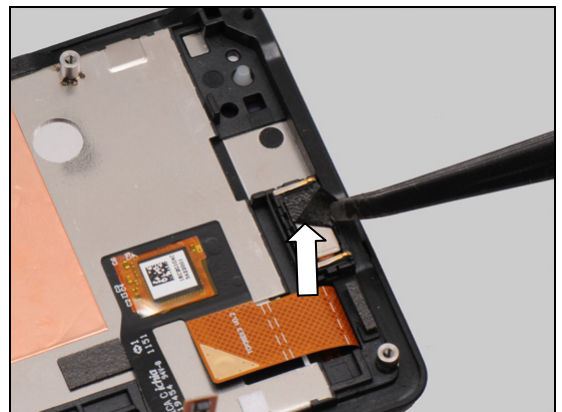
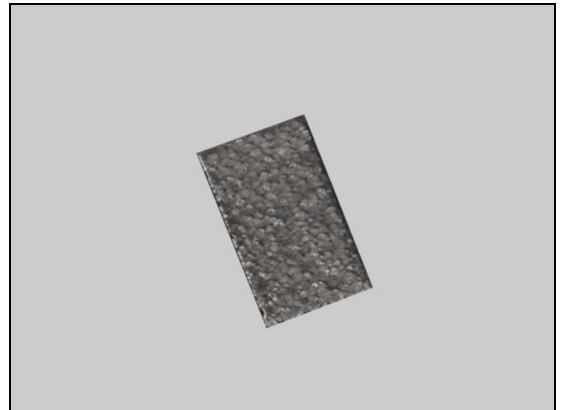
Replacement

4.20 Receiver Film back side

Follow the 3.1 – 3.3 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Receiver Film back side.
 Carry out the Installation as described below.
Follow the 5.4 – 5.6 Reassembly instructions!

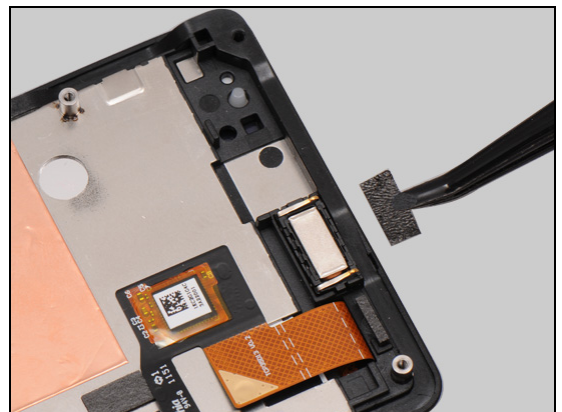
REMOVAL

Peel off the Receiver Film back side.

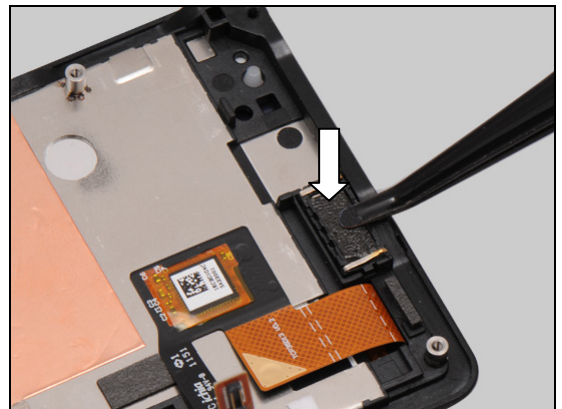


INSTALLATION

Place a new Receiver Film back side in the correct position.



Press to secure its attachment.



Replacement

4.21 Vibrator Main Mic Volume key FPC

Follow the 3.1 – 3.3 Disassembly instructions!

Follow the 4.8 Removal instructions!

Carry out the Removal as described below.

Prepare the new Vibrator Main Mic Volume key FPC.

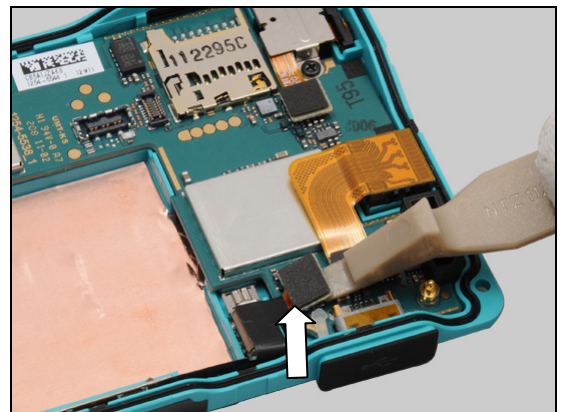
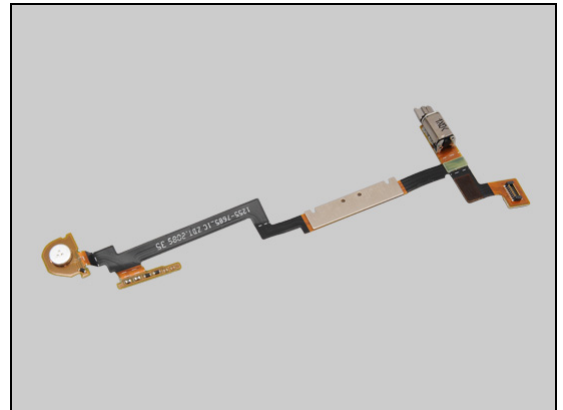
Carry out the Installation as described below.

Follow the 4.8 Installation instructions!

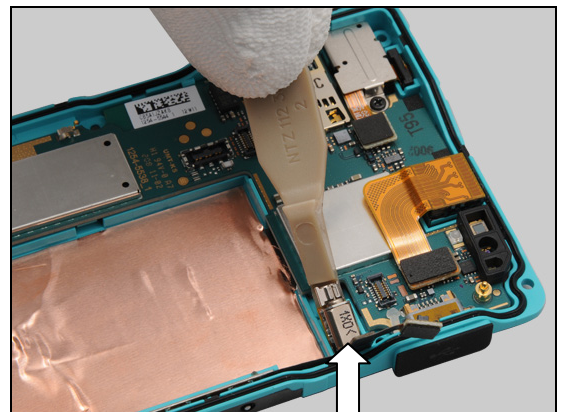
Follow the 5.4 – 5.6 Reassembly instructions!

REMOVAL

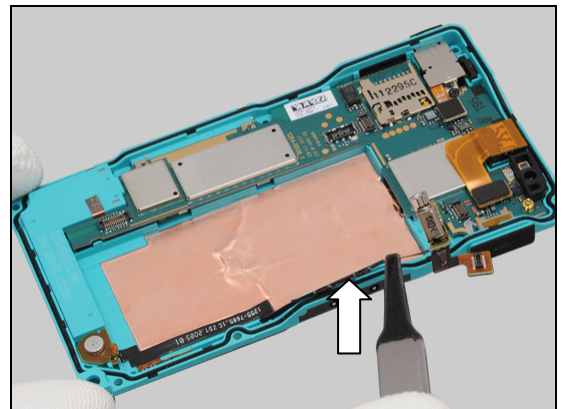
Unsnap the BtB connector by using a Front Opening Tool.



Lift up the vibrator by using a Front Opening Tool.

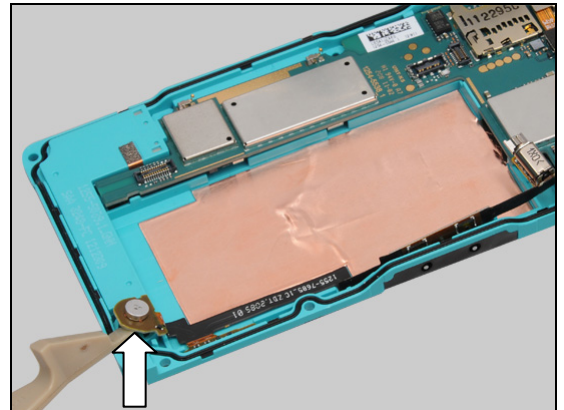


Release the FPC.

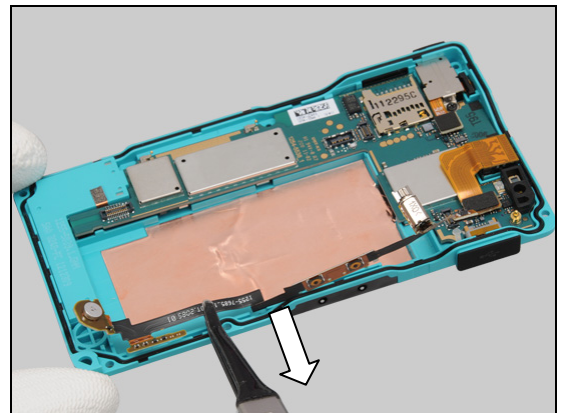


Replacement: Vibrator Main Mic Volume key FPC

Detach the foil under the mic by using a Front Opening Tool.

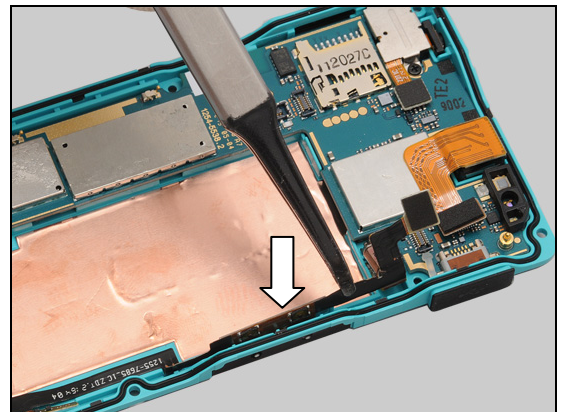


Remove the Vibrator Main Mic Volume key FPC by using a Flex Film Assembly Tool.

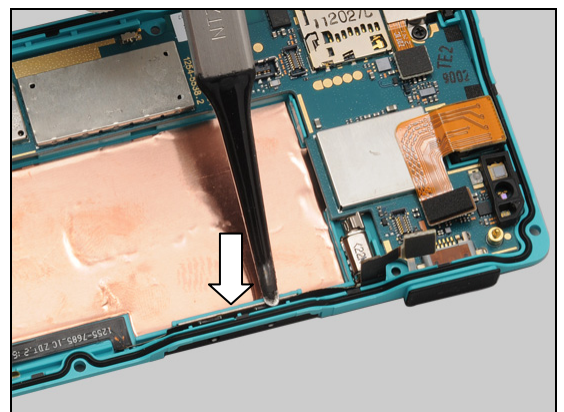


INSTALLATION

Place the key dome into the cavity.

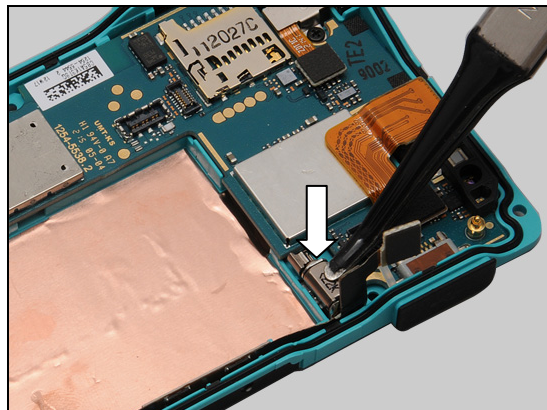


Press to secure its position.

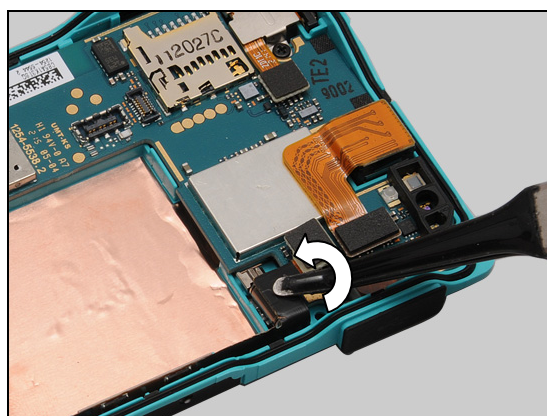


Replacement: Vibrator Main Mic Volume key FPC

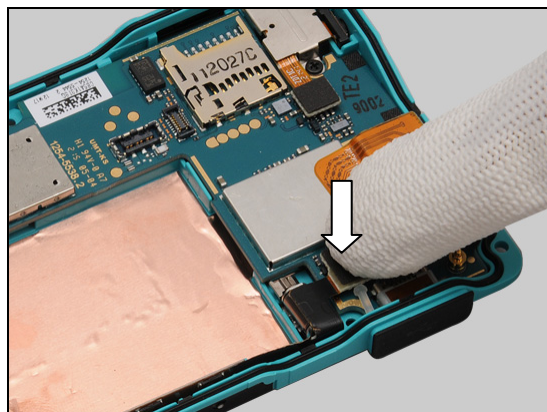
Press the vibrator into the cavity to secure its position.



Turn over the FPC.

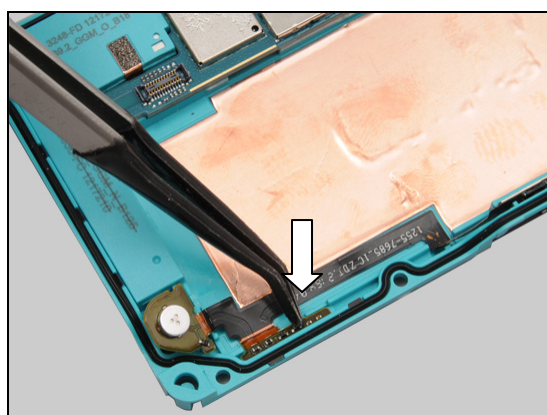


Snap the BtB connector.



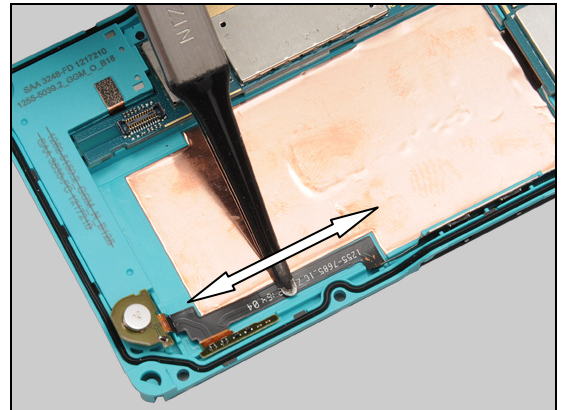
Place the component into the cavity to secure its position.

Do not touch the pins on the component!

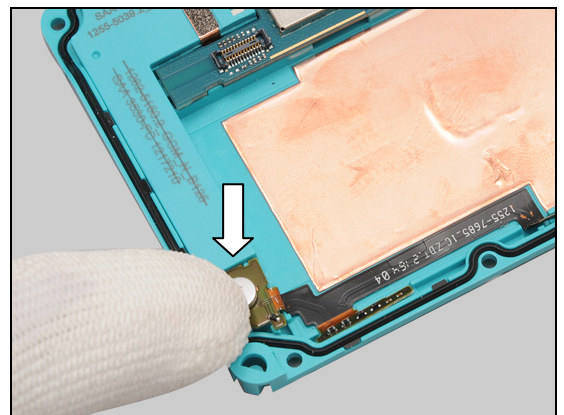


Replacement: Vibrator Main Mic Volume key FPC

Press along the FPC to secure its attachment.



Press the mic to secure its position.



Replacement

4.22 Board Swap - Replacement

Follow the 3.1 – 3.6 Disassembly instructions!

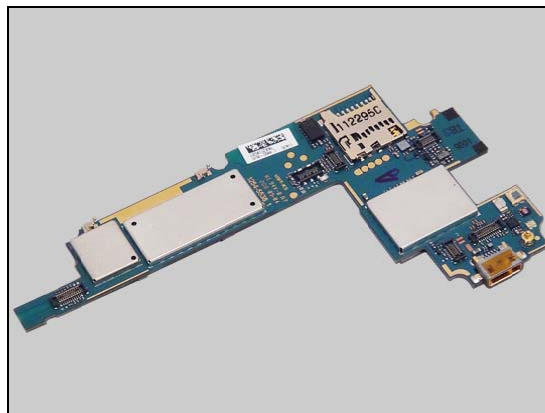
Follow the 4.9 Removal instructions!

Replace the Swap Board.

Follow the 4.9 Installation instructions!

Follow the 5.1 – 5.6 Reassembly instructions!

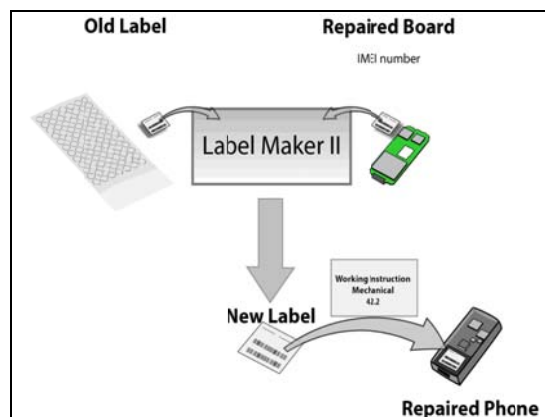
Proxy sensor calibration has to be performed for all replaced units; 1262-6643 Trouble Shooting Application – mechanical.



4.23 Board Swap – Change Label

CHANGE LABEL

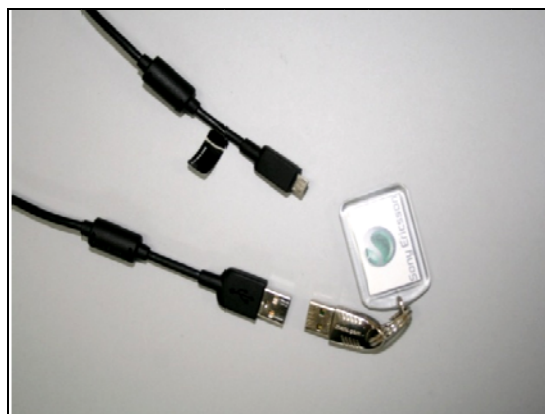
Follow the instructions in the Generic Repair Manual – Build swap for change of label.



4.24 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

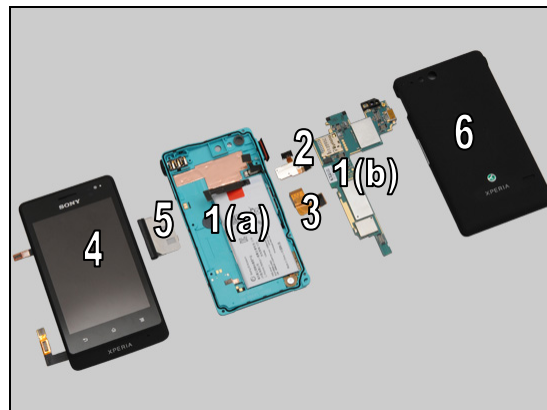
Follow the instructions in the Generic Repair Manual – Build swap for customization of the software.



5 Reassembly

The disassembly is done in the following order:

1. Back Housing Assy (a) & Main PBA (b)
2. Audio Jack FPC
3. Main Camera
4. Cover Front Housing Display Assy
5. SIM Drawer
6. Battery Cover Assy



5.1 Back Housing Assy & Main PBA

Insert the Micro USB connector on the Main PBA into its hole on the Back Housing Assy.

Make sure the Micro USB Cap is open.

Do not touch the Main O Ring during operation!

Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!

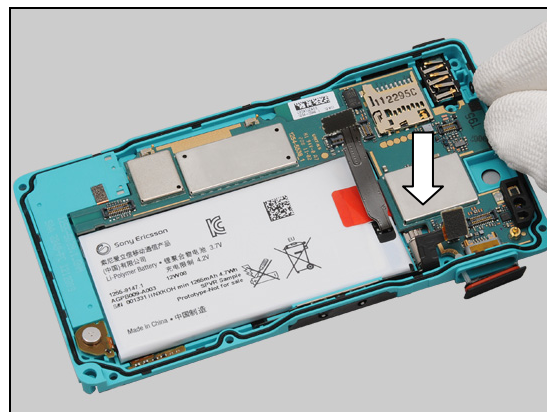


Place the Main PBA into the cavity.

Make sure the pillar of the Micro USB Cap is above the Main PBA!

Do not touch the Main O Ring during operation!

Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!

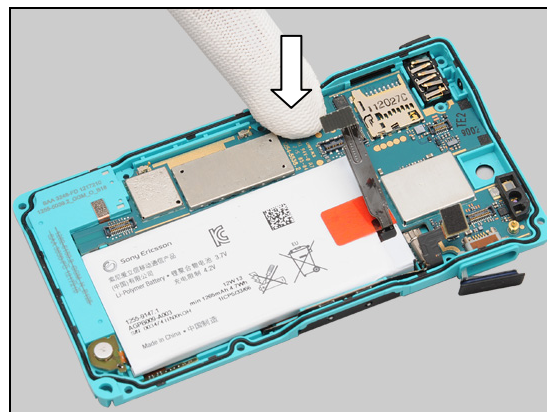


Press to secure its position.

Make sure the pillar of the Micro USB Cap is above the Main PBA!

Do not touch the Main O Ring during operation!

Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



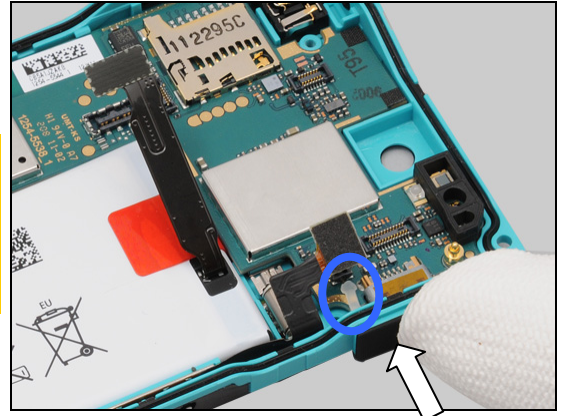
Reassembly

Press the Micro USB Cap into its cavity.

Make sure the pillar of the Micro USB Cap is above the Main PBA as shown in the picture!

Do not touch the Main O Ring during operation!

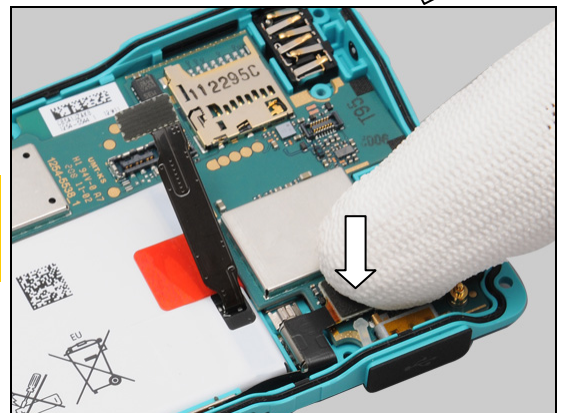
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Snap the BtB connector with fingers.

Do not touch the Main O Ring during operation!

Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!

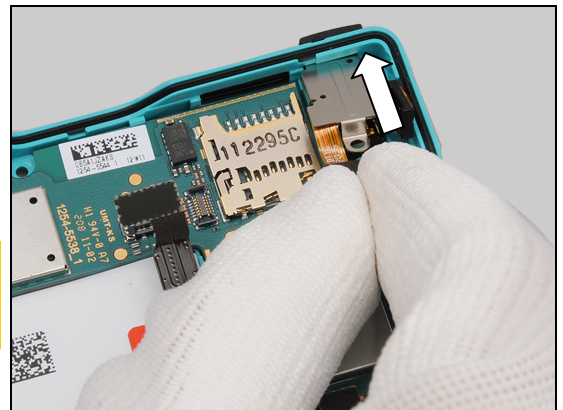


5.2 Audio Jack FPC

Insert the Audio Jack FPC into the cavity of the Audio Jack Cap.

Do not touch the Main O Ring during operation!

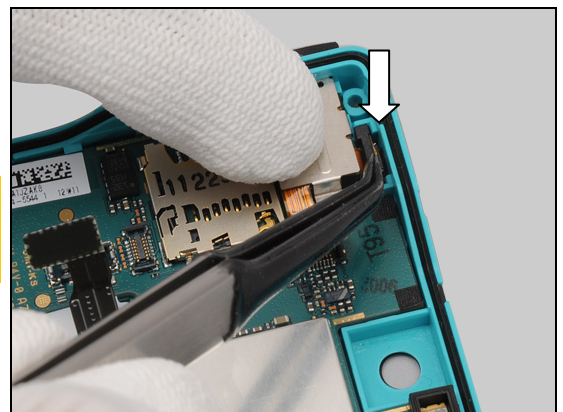
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Insert the power key into its cavity.

Do not touch the Main O Ring during operation!

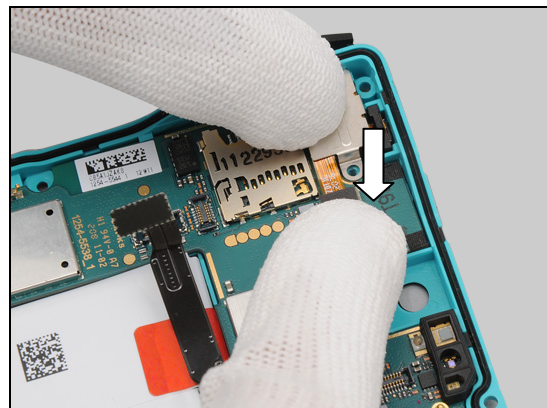
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Reassembly

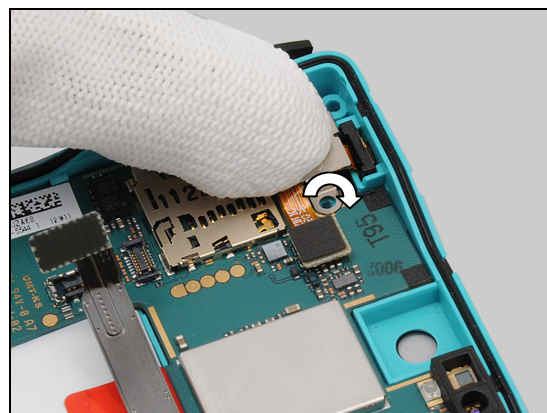
Snap the BtB connector with fingers.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Apply 12 ± 1 Ncm torque when tightening the Screw Other Len:2.0 Diam:1.4 with Bits (JCIS No 0).

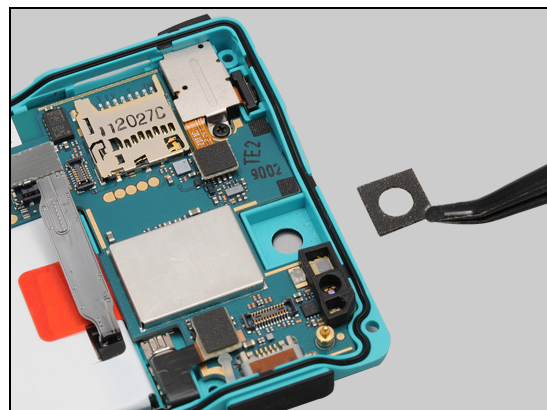
Take new screws!
Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



5.3 Main Camera & Camera adhesive

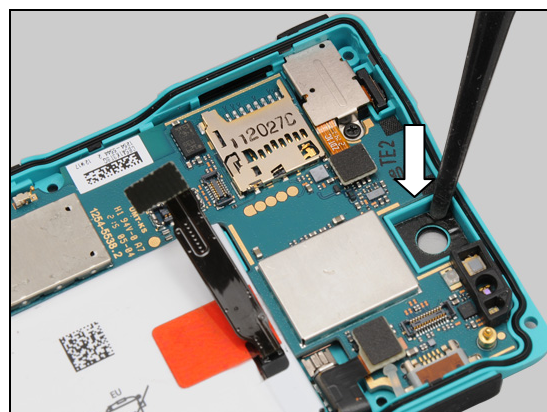
Place the Camera adhesive in the correct position.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Press to secure its attachment.

Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



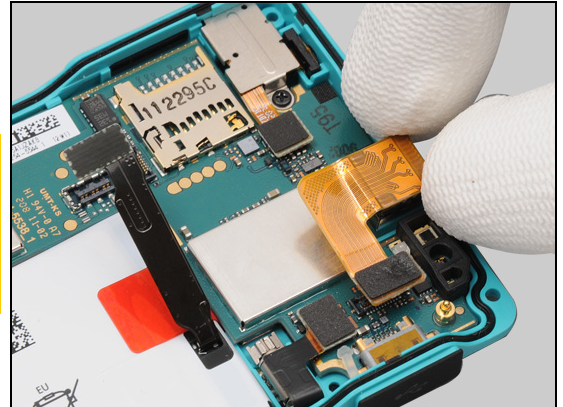
Reassembly

Place the Main Camera into the cavity.

Make sure there is no adhesive on the back side of Main Camera!

Do not touch the Main O Ring during operation!

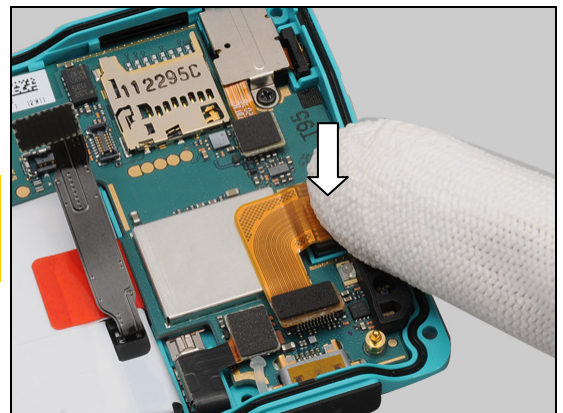
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Press to secure its position and attachment.

Do not touch the Main O Ring during operation!

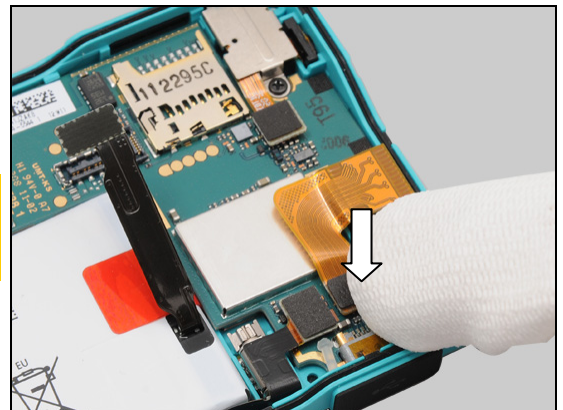
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



Snap the BtB connector with fingers.

Do not touch the Main O Ring during operation!

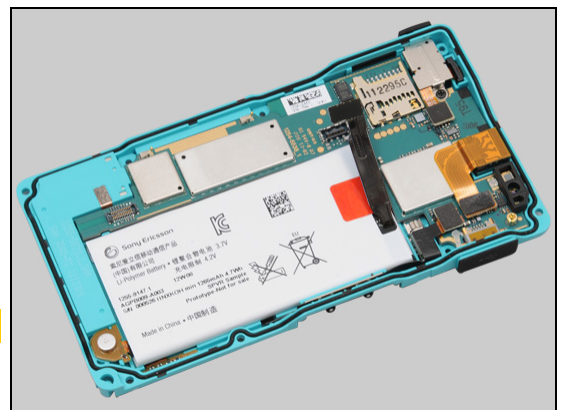
Make sure the Main O Ring is not damaged, broken, twisted or dusty before reassembly!



5.4 Cover Front Housing Display Assy

Check the Main O Ring to make sure it is not damaged, broken, twisted or dusty before reassembly!

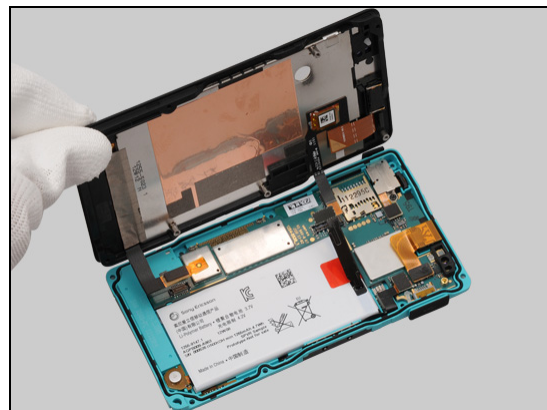
Do not touch the Main O Ring during operation!



Reassembly

Place the Cover Front Housing Display Assy in the correct position.

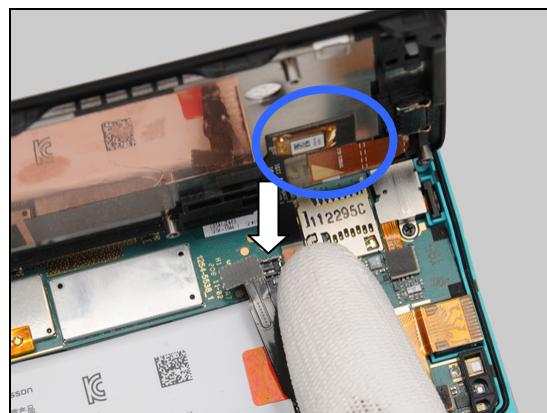
**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Snap the BtB connector of the touch panel.

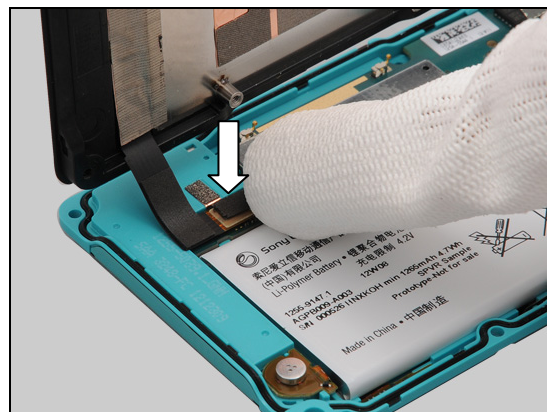
Check if the touch panel FPC is attached in correct position as shown in the picture!

**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Snap the BtB connector of the display.

**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Press to secure the FPC attachment.

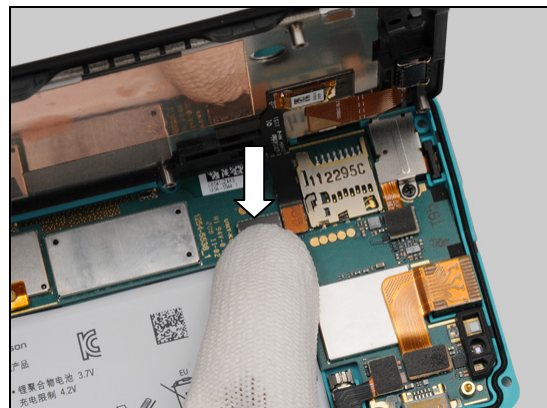
**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Reassembly

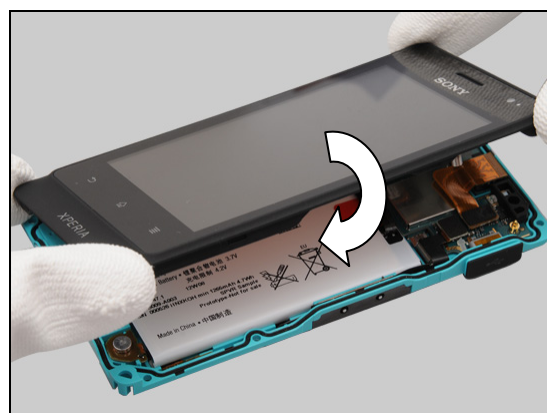
Snap the BtB connector of the Battery.

**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Turn over the Cover Front Housing Display Assy.

**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



Turn over the Cover Front Housing Display Assy to a horizontal position before putting it down.

**Do not touch the Main O Ring during operation!
Make sure the Main O Ring is not damaged, broken,
twisted or dusty before reassembly!**



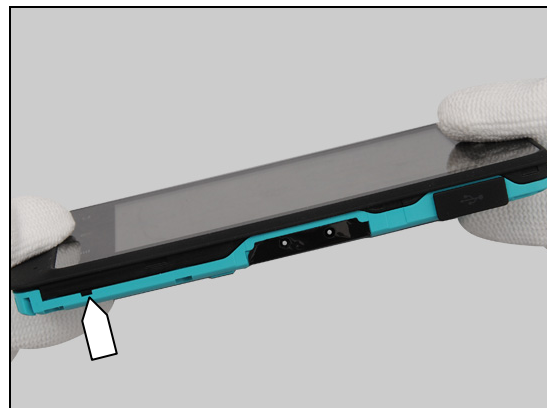
Place the Cover Front Housing Display Assy in the correct position and press to secure its position and attachment.

**It related water proof function, please reassembly with
great care and follow the procedure strictly!**



Reassembly

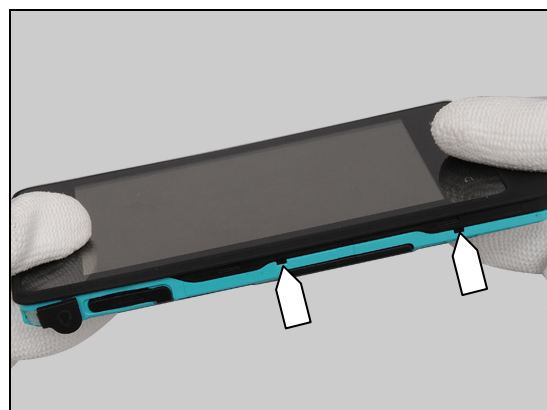
Check the holes to make sure the Main O Ring is properly assembled.



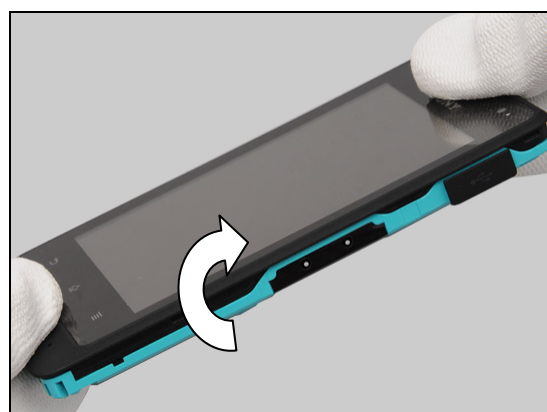
Check the holes to make sure the Main O Ring is properly assembled.



Check the holes to make sure the Main O Ring is properly assembled.



Hold the phone tightly and turn over it.



Reassembly

Turn over the phone to a horizontal position as shown in the picture.



Apply 16 ± 1.6 Ncm torque when tightening the Screw Other
Len:0.0 Diam:1.4 water proof with Bits (JCIS No 0).

Press the phone tightly!

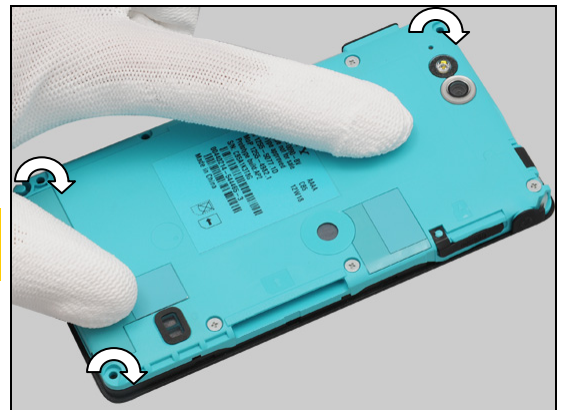
Take new screws!



Apply 18 ± 1.8 Ncm torque when tightening the Screw Other
Len:4.2 Diam:1.7 selftap with Bits (JCIS No 0).

Press the phone tightly!

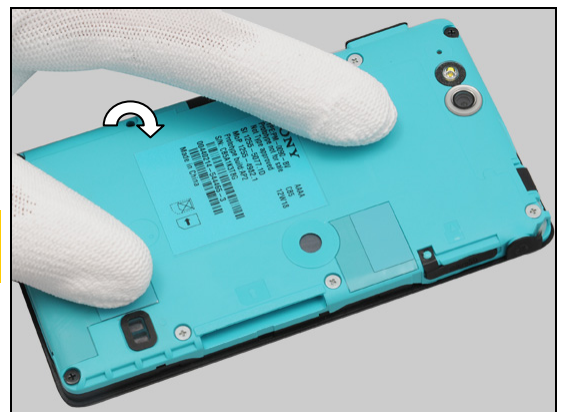
Take new screws!



Apply 14 ± 1.4 Ncm torque when tightening the Screw Other
Len:3.5 Diam:1.7 selftap with Bits (T6).

Press the phone tightly!

Take new screws!



Reassembly

Install the Pressure Fixture insert onto the Pressure Tool and adjust the pressure to 250 N.



Place ST27 onto the Pressure Fixture.



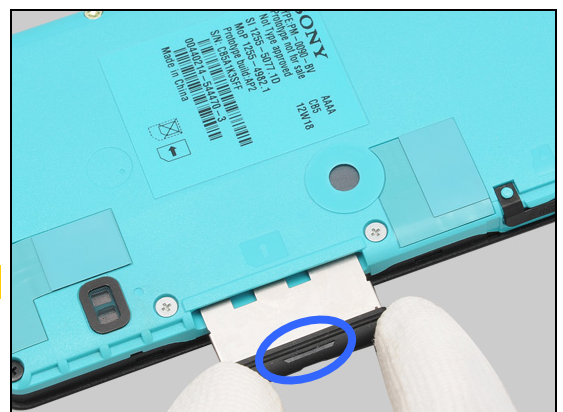
Close the Pressure Fixture insert.
Press down the Pressure Tool to press this ST27 for 15 seconds.



5.5 SIM Drawer

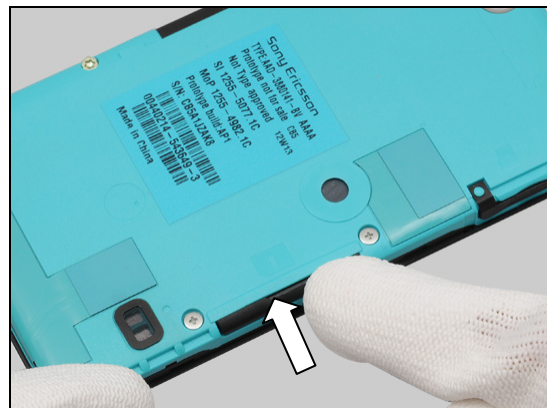
Place the SIM Drawer in the correct position.

Note its correct direction as shown in the picture!



Reassembly

Push in to secure its position.



5.6 Battery Cover Assy

Place the Battery Cover Assy in the correct position.



Press to secure its position.



6 Revision History

Rev.	Date	Changes / Comments
1	2012-Jun-25	Initial release
2	2012-Jul-3	Update pictures of Pressure Tool.
3	2012-08-14	Update pictures of Pressure Tool.