

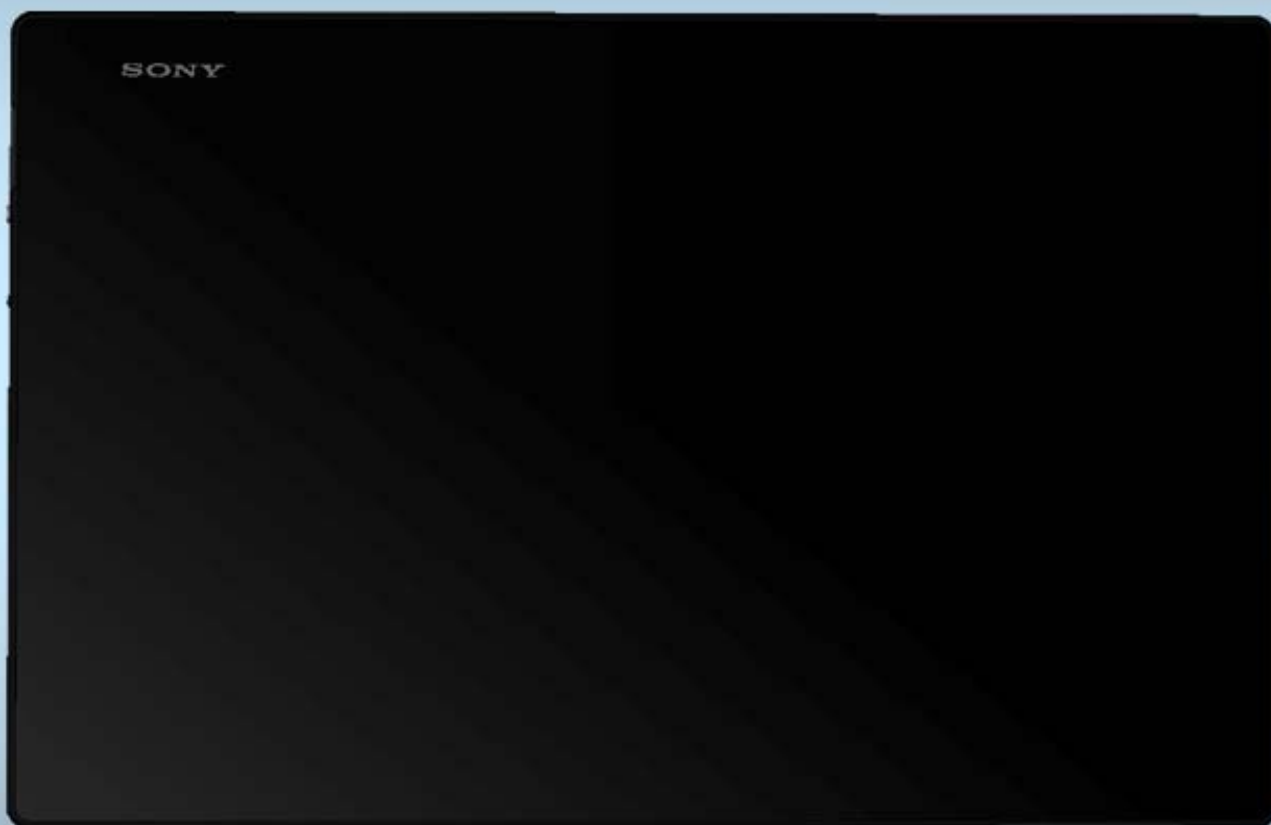
# SONY

make.believe

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## Working Instructions

- mechanical -



*Xperia™ Tablet Z*

*SGP311, SGP312, SGP321, SGP341, SGP351*

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

## 1 Exterior Views

### 1.1 SGP311, SGP312, SGP321, SGP341, SGP351



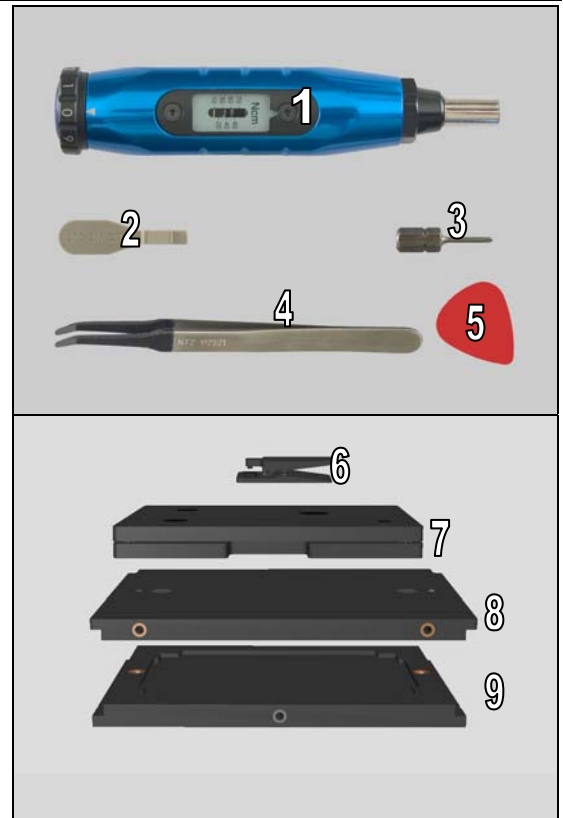
## 2 Tools

### SPECIAL TOOLS

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

6. Press Tool Loudspeaker
7. Backpanel Adhesive Fixture
8. Bottom Press Inlay
9. Backpanel press Top Inlay

10. Side Panel press
11. Side Panel Press Head
12. Side Panel Press Pad



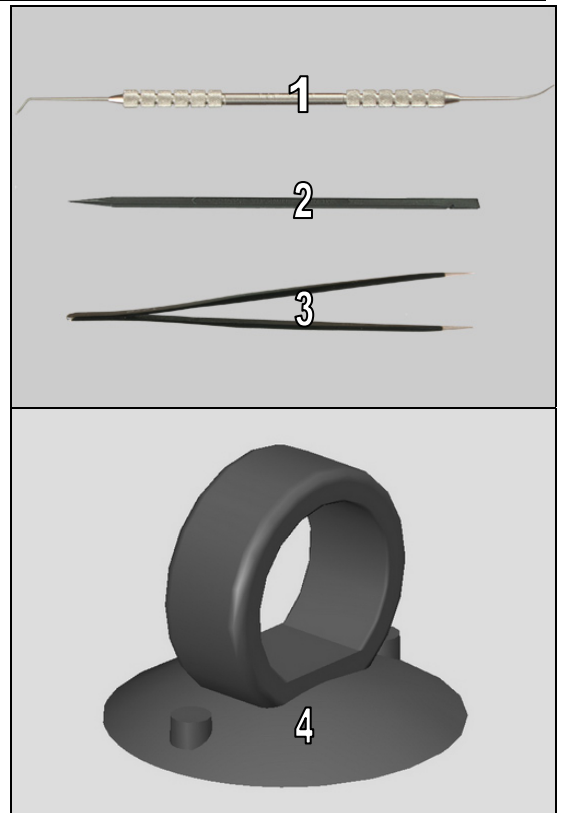
**For part not on the tools above, refer to the 'Tools Catalogue/Matrix'!**

## Tools

### STANDARD TOOLS

1. Dentist Hook
2. Nylon Pointer
3. Tweezer

4. Suction cup

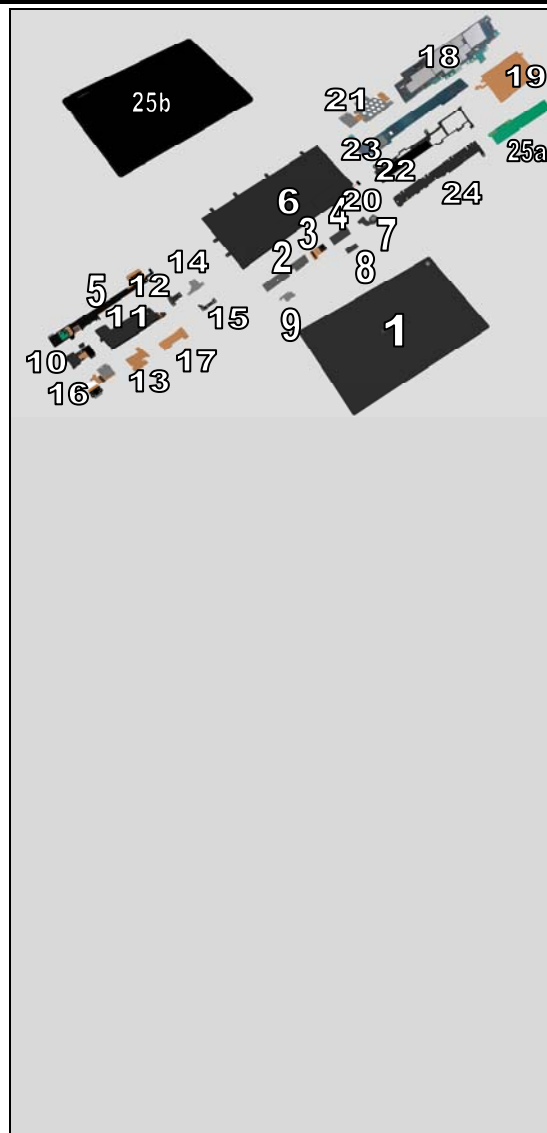




## 3 Disassembly

The Disassembly is done to the following modules:

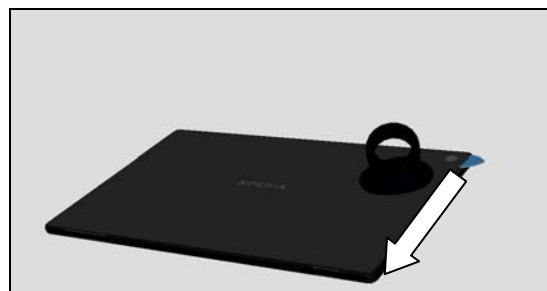
1. Back Panel Assy
2. Sheet Magnetic Top
3. Chat Camera
4. Sheet FPC TOP
5. FPC Assembly Top PBA
6. Battery
7. Main Camera
8. Sheet Jack K
9. Plate FPC Audio Jack
10. GPS antenna
11. Diversity antenna
12. FPC Assembly Charge PBA
13. FPC Assembly Relay SUB PBA
14. Plate USB
15. Carrier Holder USB
16. FPC Assembly USB PBA
17. FPC Assembly Relay LCD PBA
18. Main PBA
19. NFC antenna
20. SIM Tray (N/A for SGP311 and SGP312)
21. FPC Assembly SIM
22. Frame Sub PBA
23. PBA Complete Sub
24. Carrier Antenna Main
25. PBA Antenna LTE (a)(N/A for SGP311 and SGP312) and Front Assembly (b)



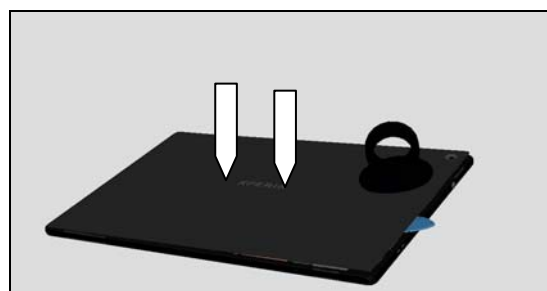
### 3.1 Back Panel Assy

Use Suction cup to get space for inserting the Guitar Pick. Gently slide the Guitar Pick along to the side.

**Note!** Only allowed to slide the guitar pick at this side otherwise flexes could be broken!

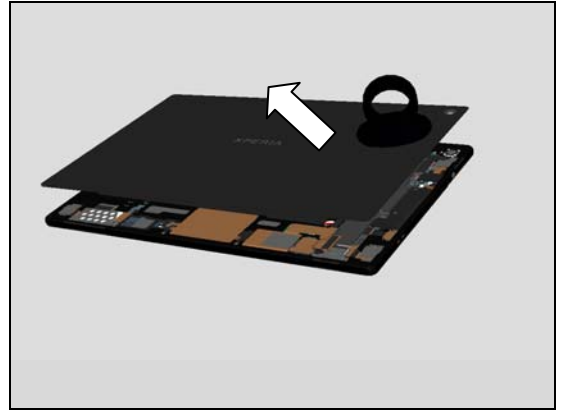


**Caution** when removing Back Panel Assy so the Battery is not destroyed by the two adhesive (see arrows).

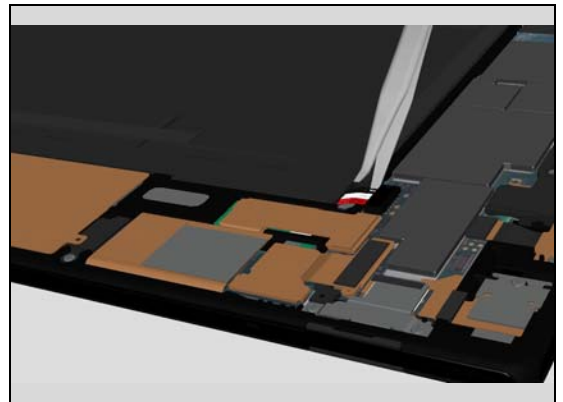


## Disassembly

Remove the Back Panel Assy by using the Suction cup and by hand in the direction of the arrow.

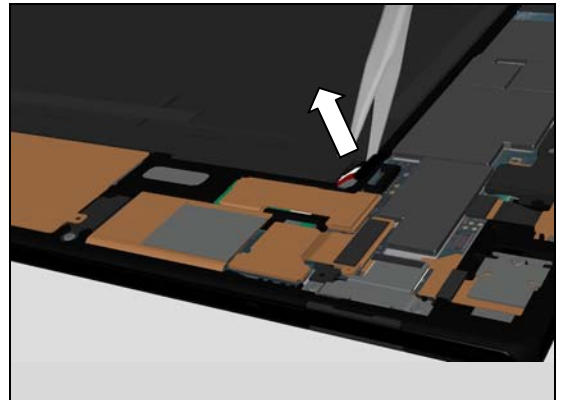


Use Flex Film Assembly Tool to disconnect battery connector



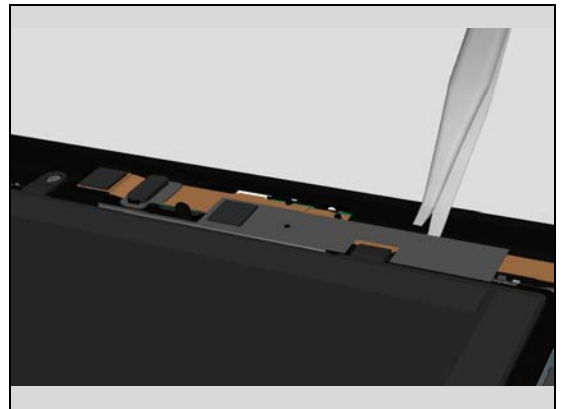
## Disassembly

Lift it up gently

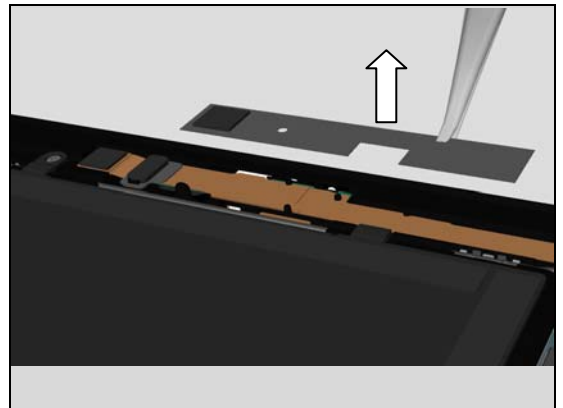


### 3.2 Sheet Magnetic Top

Insert the Flex Film Assembly to release Sheet Magnetic Top

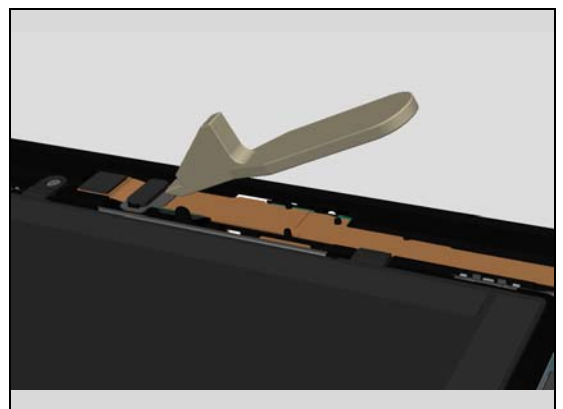


Remove it.



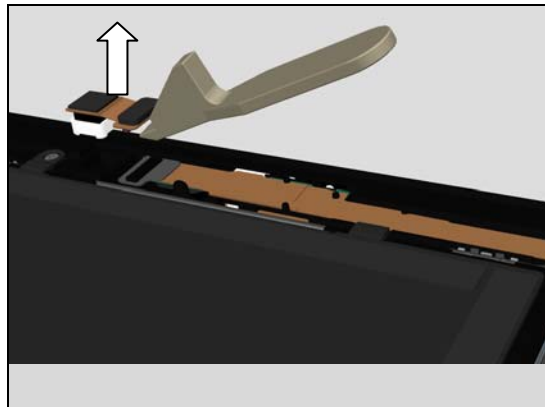
### 3.3 Chat Camera

Use a Front Opening Tool to disconnect the BtB connector.



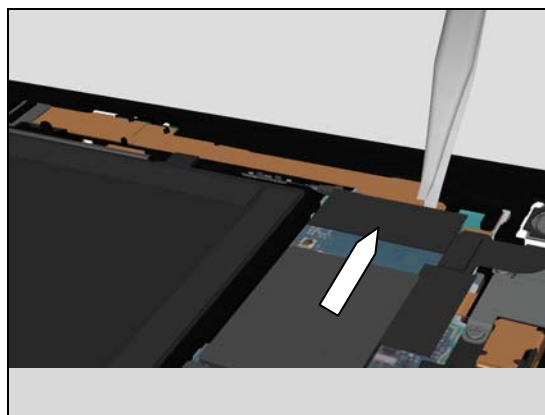
## Disassembly

Use the Front Opening Tool and fingers for removing the Chat Camera

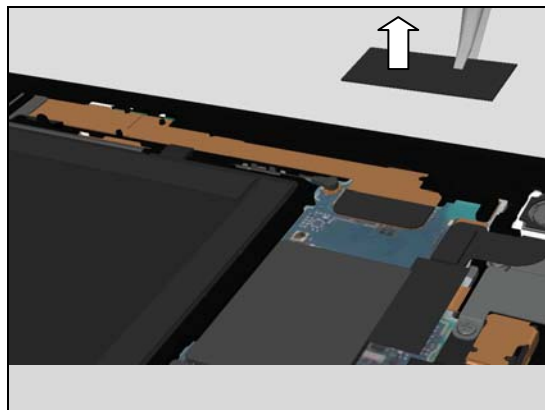


### 3.4 Sheet FPC TOP

Insert the Flex Film Assembly to release Sheet FPC TOP  
Caution when removing Sheet FPC TOP so not damaging connector or flex

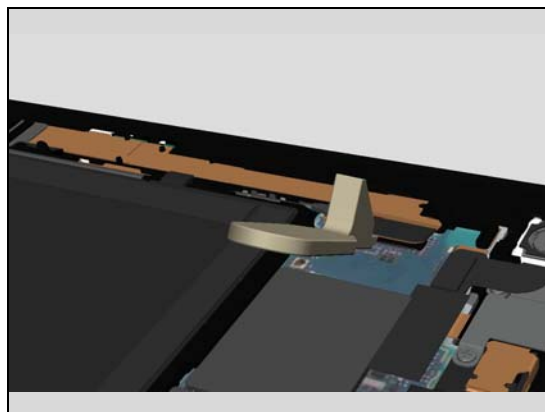


Remove it.



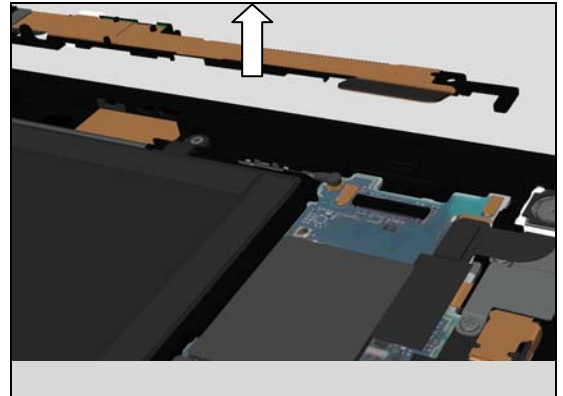
### 3.5 FPC Assembly Top PBA

Use a Front Opening Tool to disconnect the BtB connector.



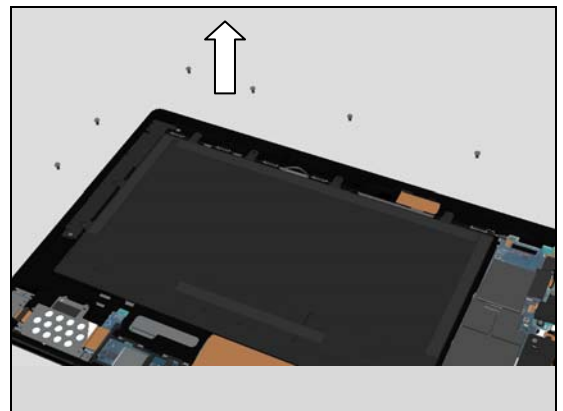
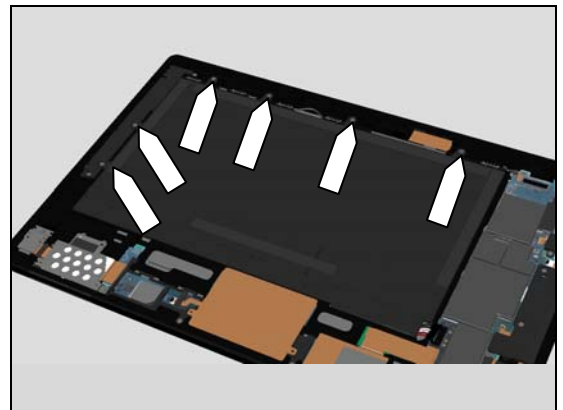
## Disassembly

Remove the FPC Assembly Top PBA with fingers.

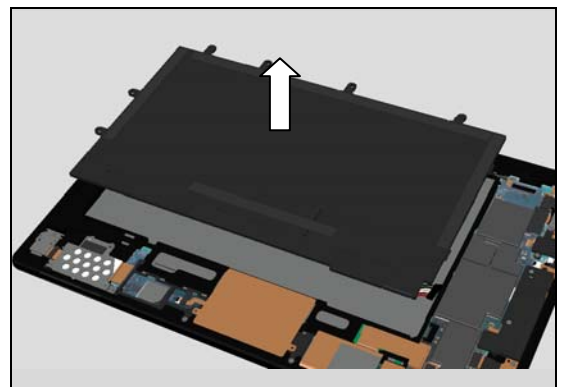


### 3.6 Battery

Remove the six Screw Other Len:2.6 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).



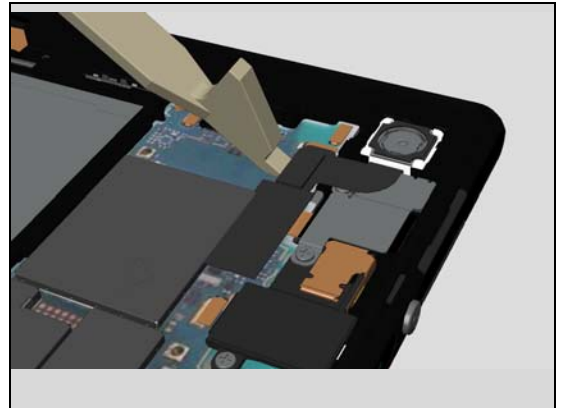
Remove the Battery with fingers



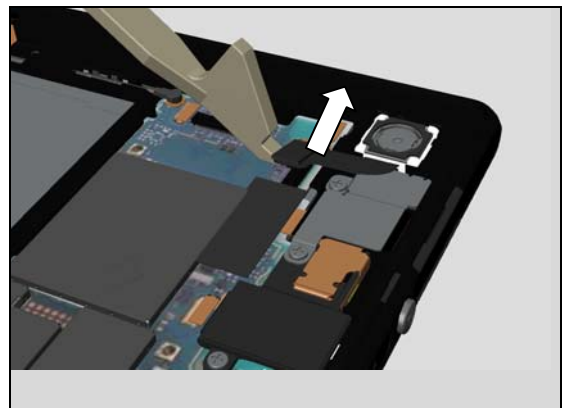
## Disassembly

### 3.7 Main Camera

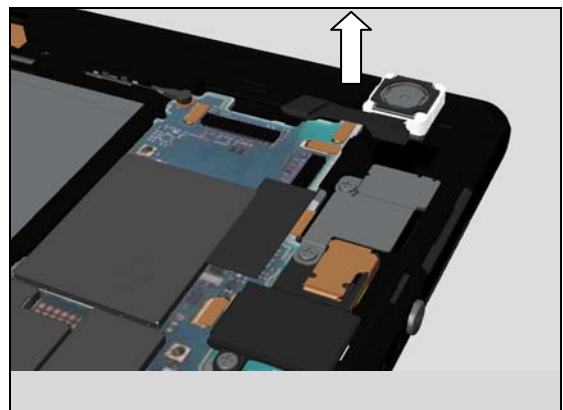
Use a Front Opening Tool to disconnect the BtB connector.



Lift the flex

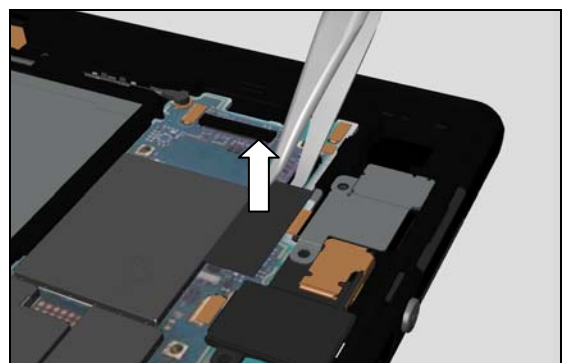


Remove the Main Camera with fingers



### 3.8 Sheet Jack K

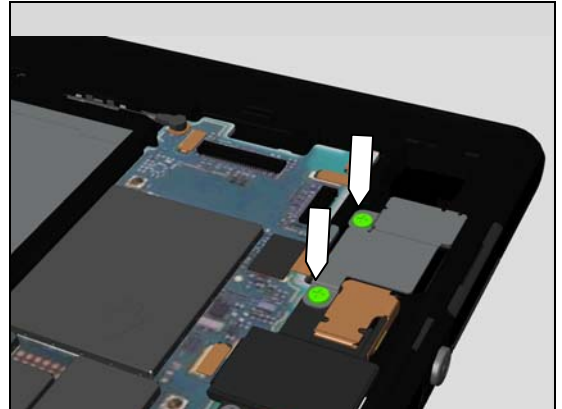
Insert the Flex Film Assembly to release Sheet Jack K.  
Caution when removing Sheet Jack K so not damaging connector or flex



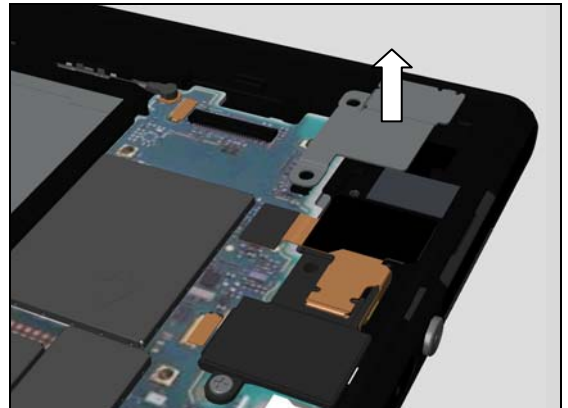
## Disassembly

### 3.9 Plate FPC Audio Jack

Remove the two Screw Other Len:3.0 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).



Remove the Plate FPC Audio Jack with fingers.

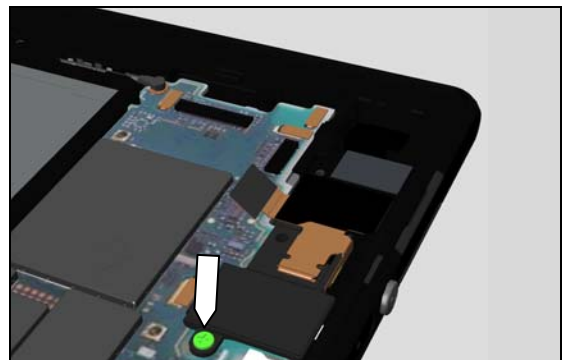


### 3.10 GPS antenna

Use a Front Opening Tool to disconnect the BtB connector.



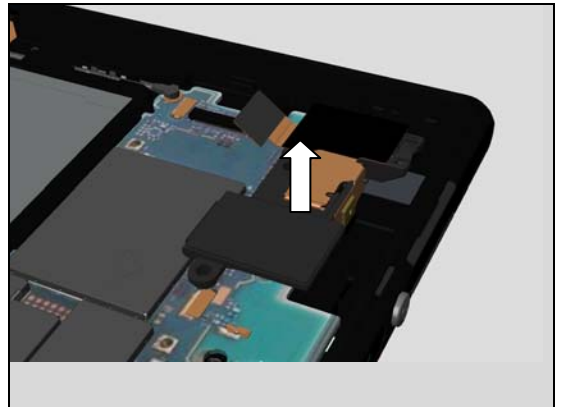
Remove the Screw Other Len:3.0 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).





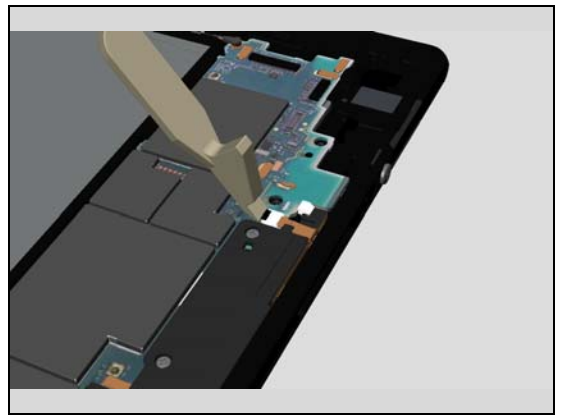
## Disassembly

Remove GPS antenna (FPC Audio Jack) with fingers

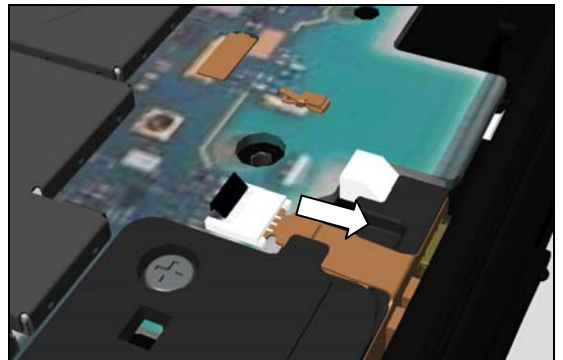


### 3.11 Diversity antenna

Use a Front Opening Tool to disconnect the zif connector.



Use the Flex Film Assembly to remove the flex

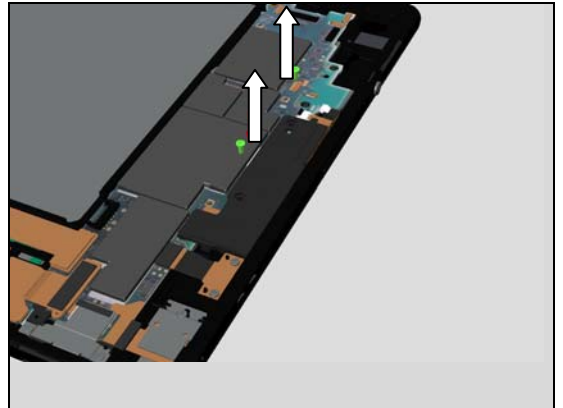


Remove the two Screw Other Len:3.0 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).

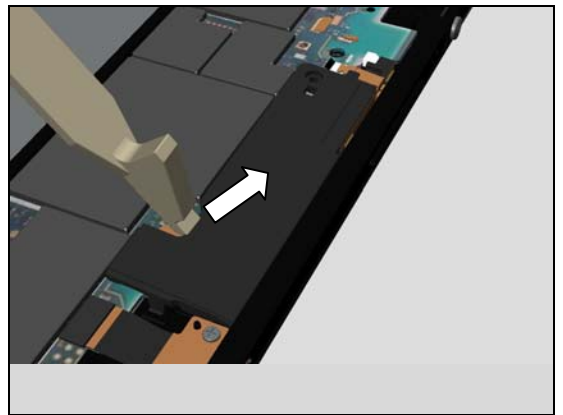




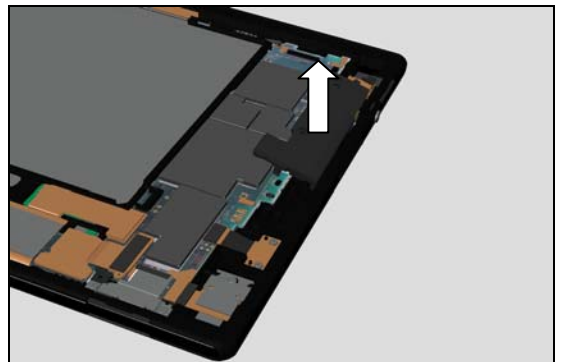
## Disassembly



Use a Front Opening Tool to unhook Diversity antenna.

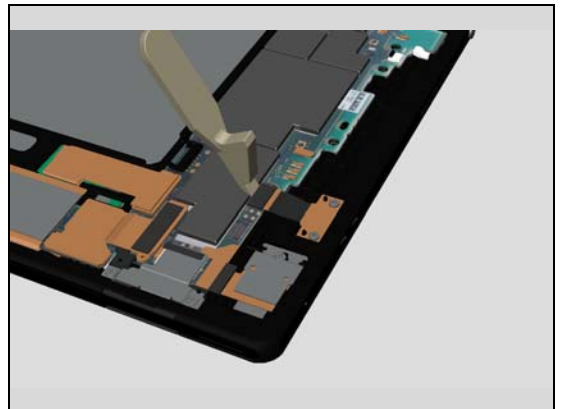


Remove Diversity antenna with fingers



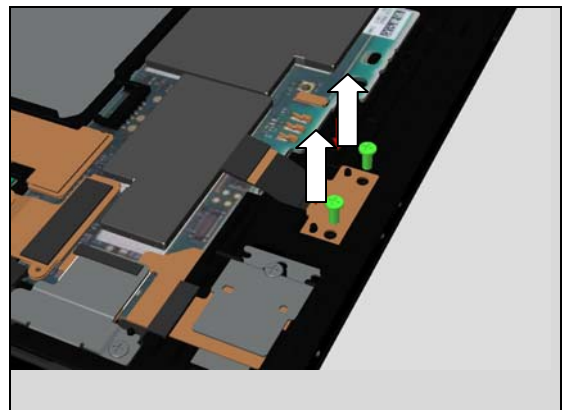
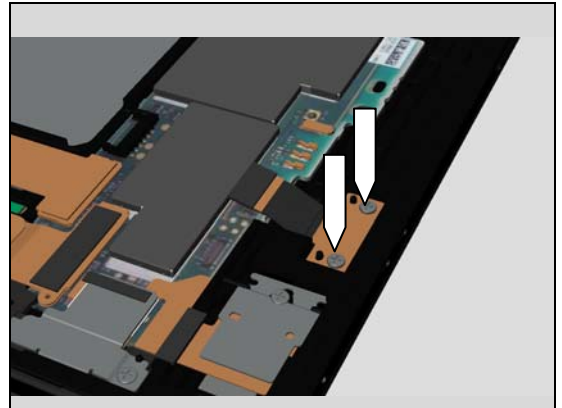
### 3.12 FPC Assembly Charge PBA

Use a Front Opening Tool to disconnect the BtB connector.

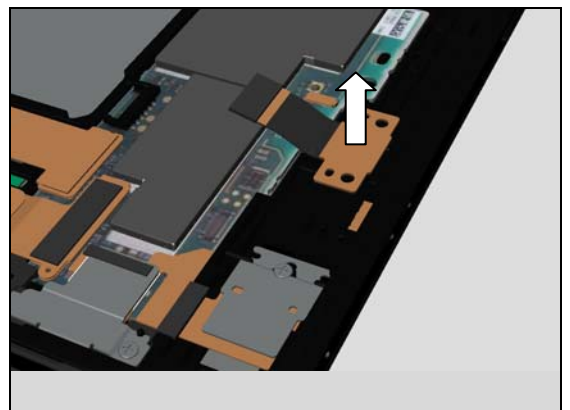


## Disassembly

Remove the two Screw Other Len:3.4 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).

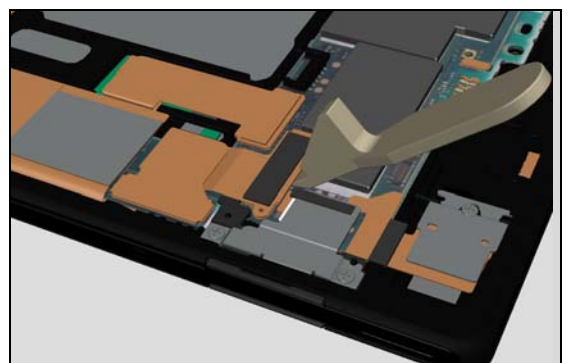


Remove FPC Assembly Charge PBA with fingers



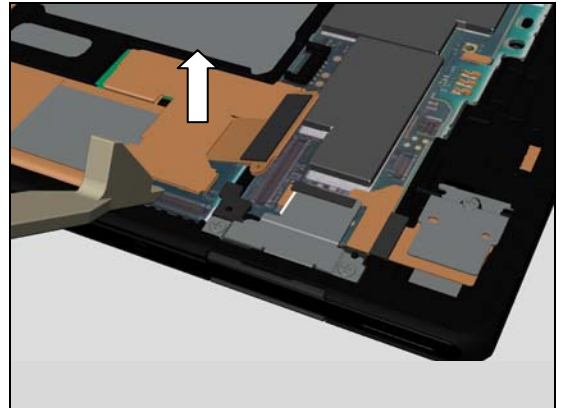
### 3.13 FPC Assembly Relay SUB PBA

Use a Front Opening Tool to disconnect the BtB connector.



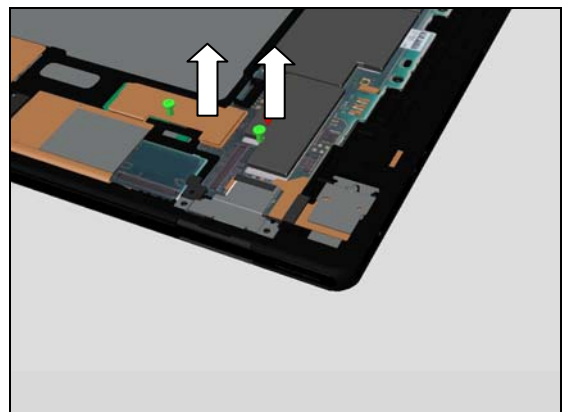
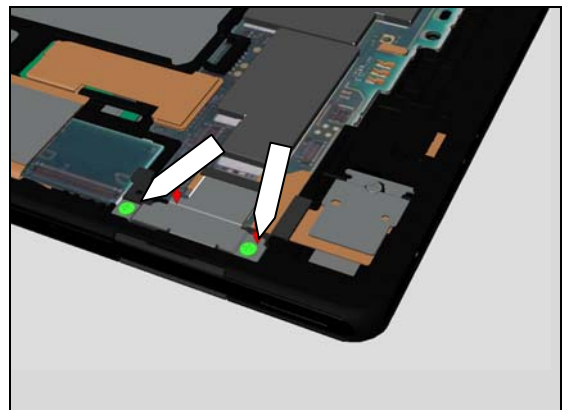
## Disassembly

Remove it.

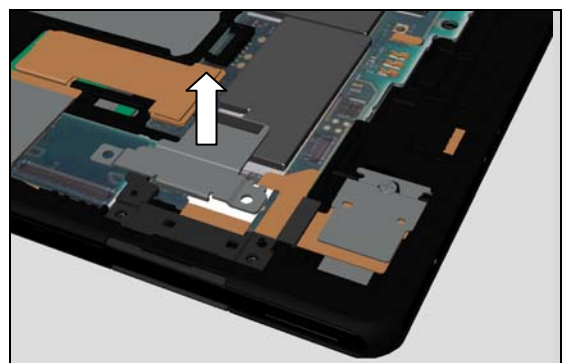


### 3.14 Plate USB

Remove the two Screw Other Len:2.6 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).



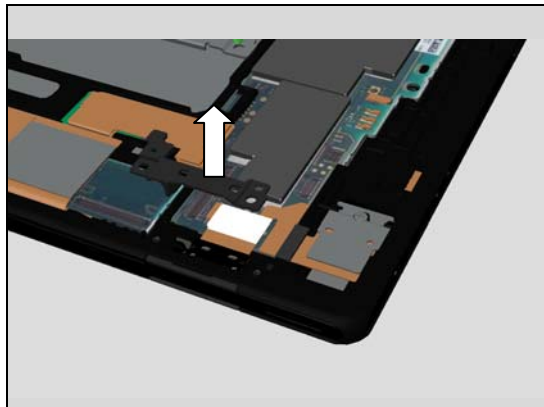
Remove Plate USB with fingers



## Disassembly

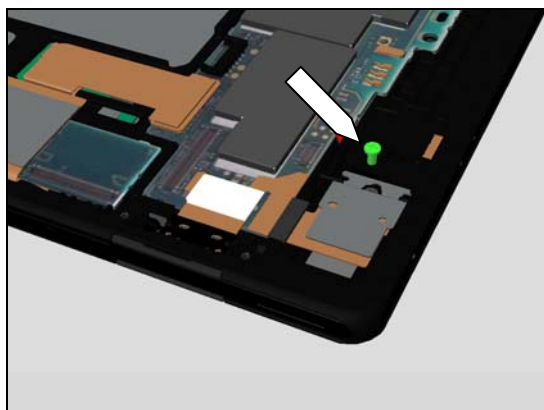
### 3.15 Carrier Holder USB

Remove Carrier Holder USB with fingers

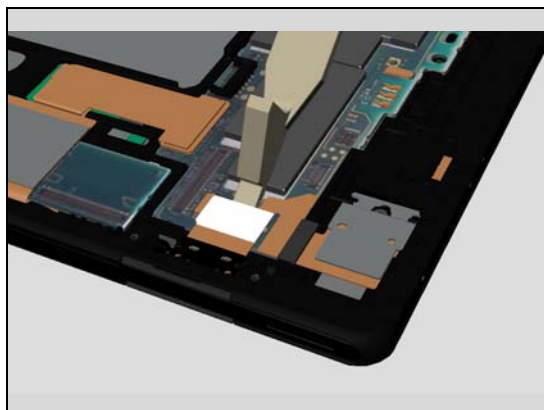


### 3.16 FPC Assembly USB PBA

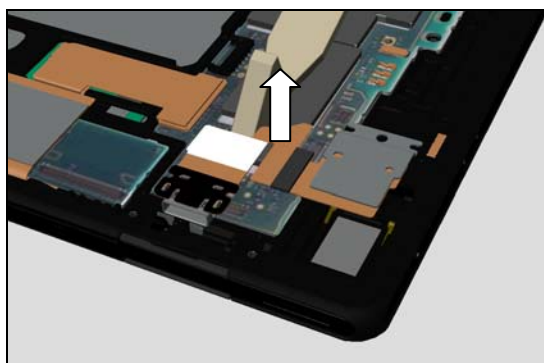
Remove the one Screw Other Len:2.6 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).



Use a Front Opening Tool to disconnect the BtB connector.



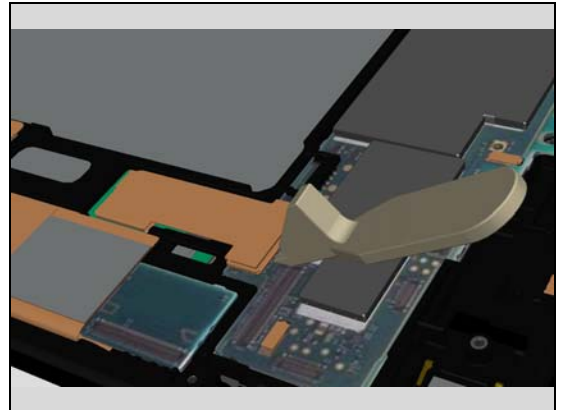
Remove the FPC Assembly USB PBA



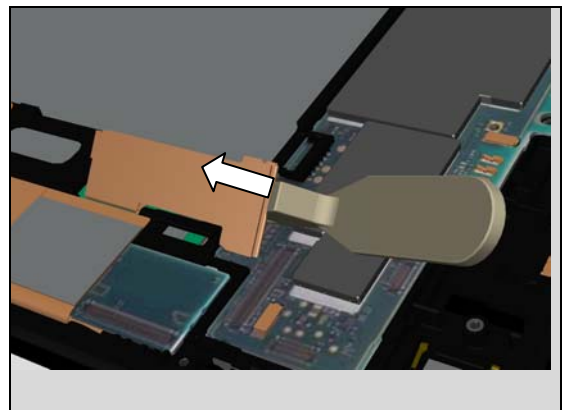
## Disassembly

### 3.17 FPC Assembly Relay LCD PBA

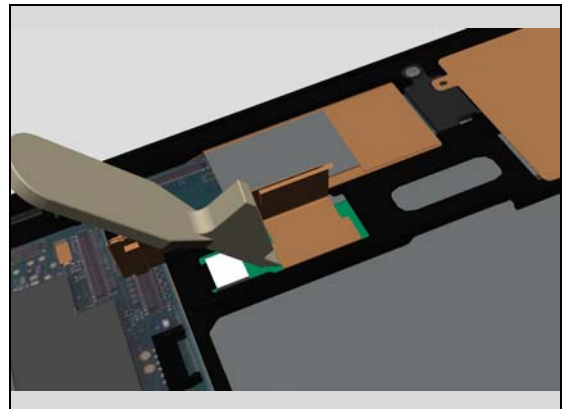
Use a Front Opening Tool to disconnect the BtB connector.



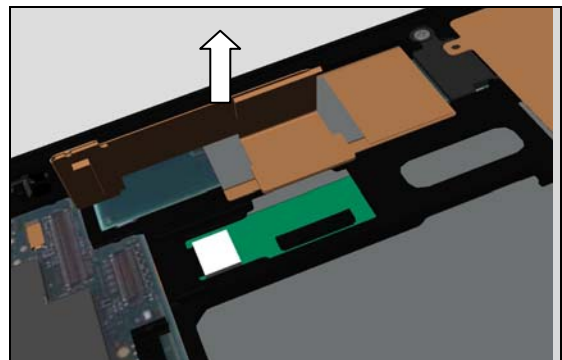
Use a Front Opening Tool to lift the flex to the side.



Use a Front Opening Tool to disconnect the BtB connector.



Remove the FPC Assembly Relay LCD PBA with fingers

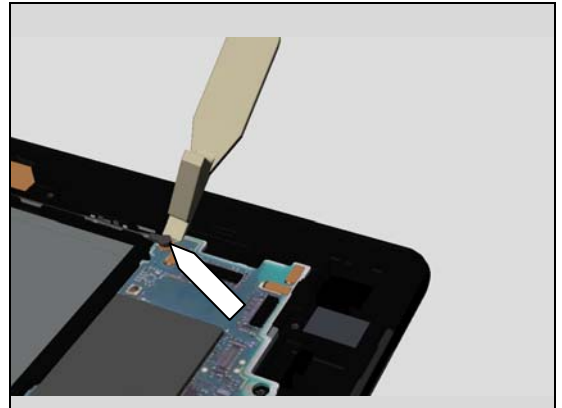




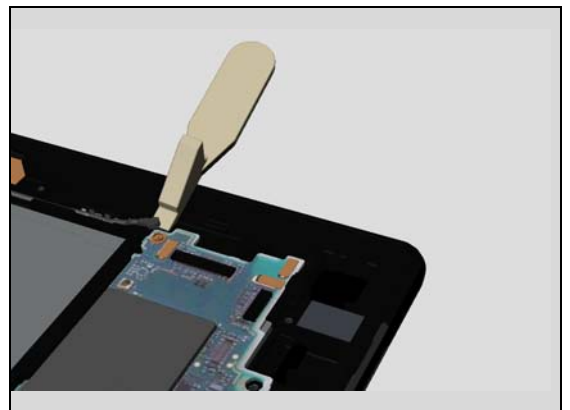
## Disassembly

### 3.18 Main PBA

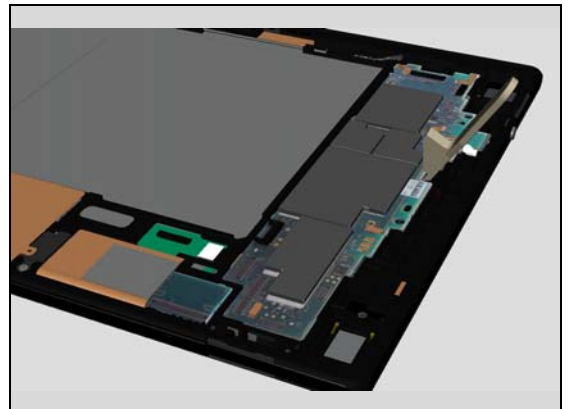
Use a Front Opening Tool to disconnect the RF Cable connector (N/A for SGP311 and SGP312)



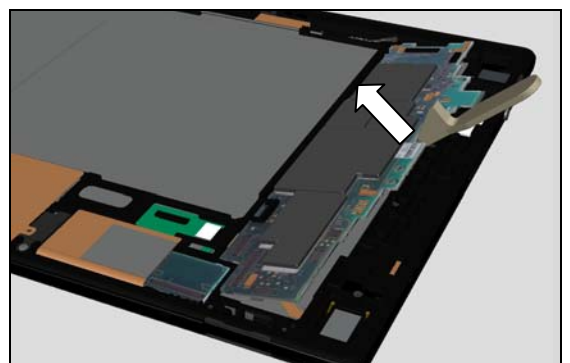
Lift it to the side gently



Use a Front Opening Tool to unhook the Main PBA

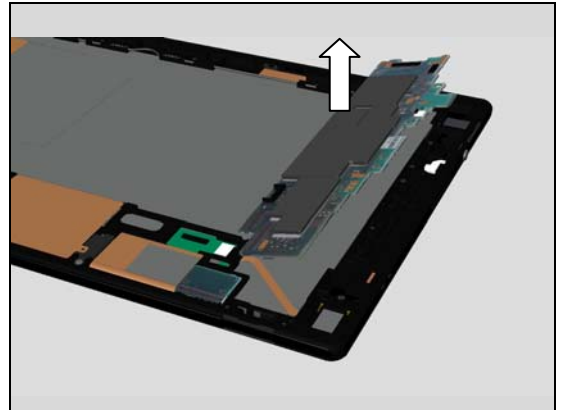


Lift the Main PBA with Front Opening Tool

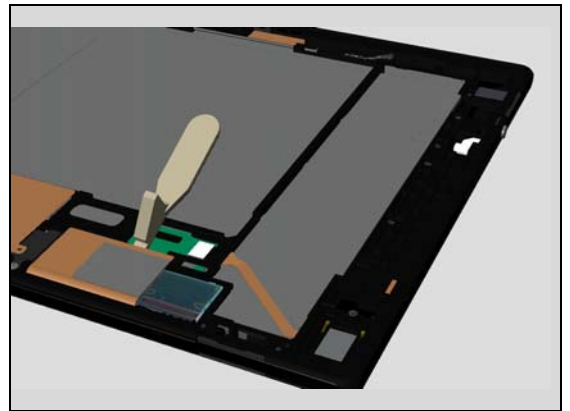


## Disassembly

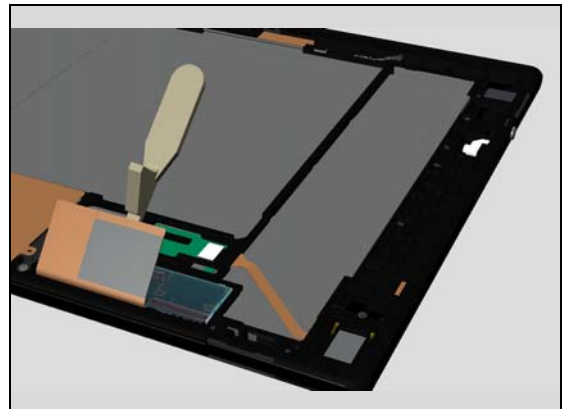
Remove it.



Use a Front Opening Tool to disconnect the BtB connector



Use a Front Opening Tool to lift the LCD flex



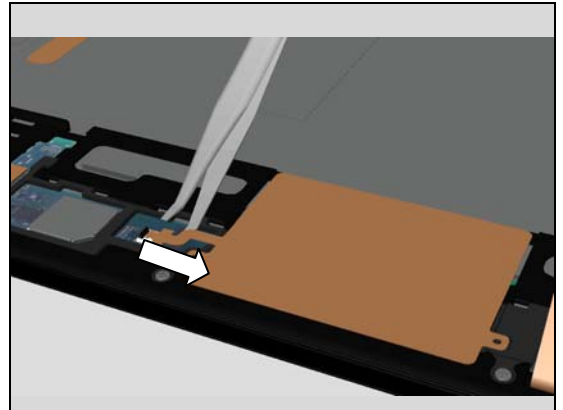
### 3.19 NFC antenna

Use a Front Opening Tool to disconnect the zif connector.

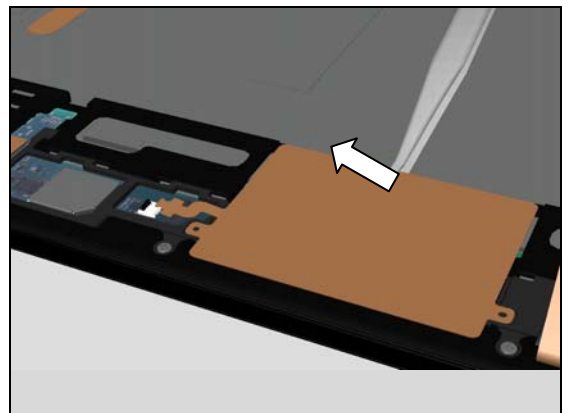


## Disassembly

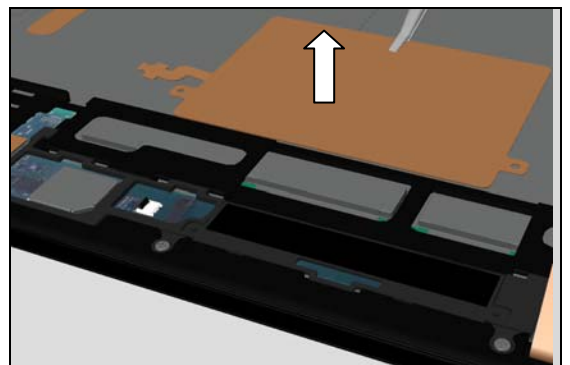
Use the Flex Film Assembly Tool to remove flex from zif connector



Lift the NFC antenna by using Flex Film Assembly Tool



Remove it.





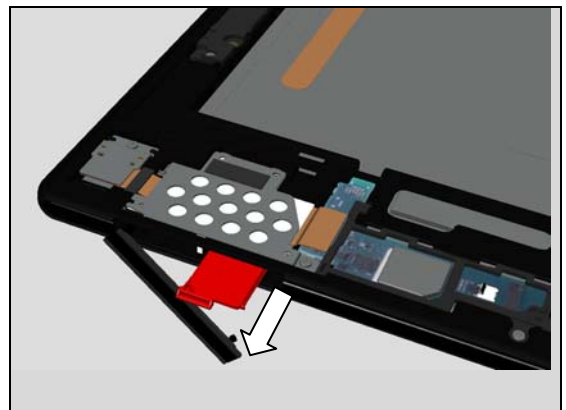
## Disassembly

### 3.20 SIM Tray (N/A for SGP311 and SGP312)

Open the lid to SIM Tray

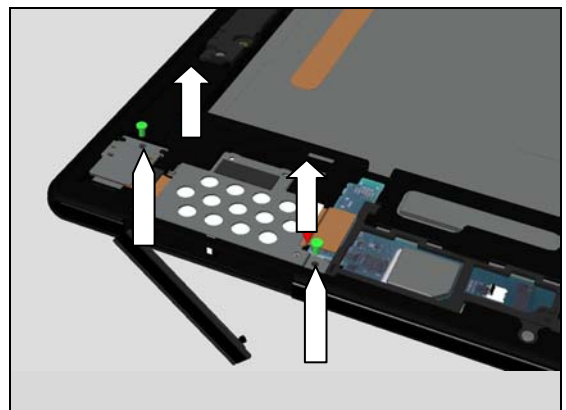


Remove SIM Tray by using fingers.

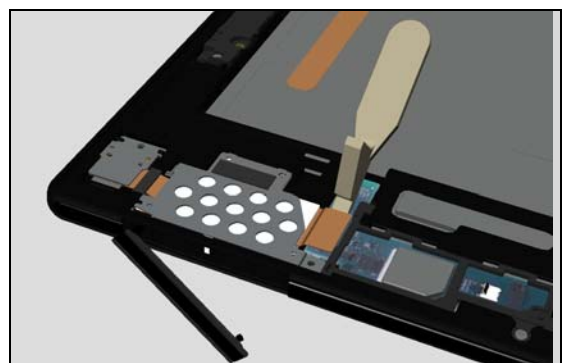


### 3.21 FPC Assembly SIM

Remove the two Screw Other Len:2.6 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).

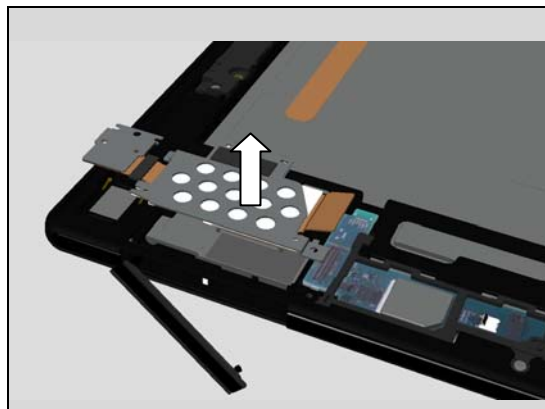


Use a Front Opening Tool to disconnect the BtB connector.



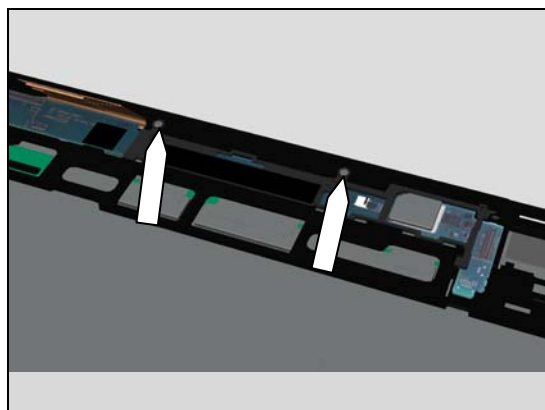
## Disassembly

Remove the FPC Assembly SIM

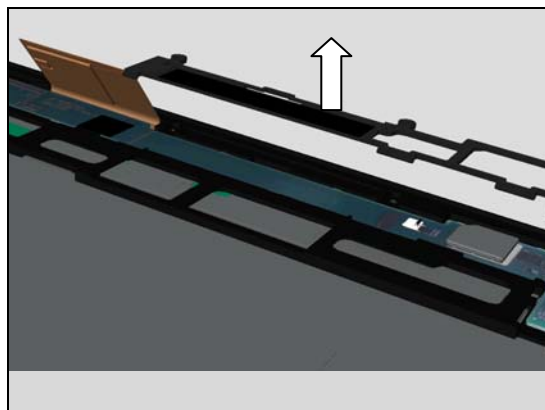


### 3.22 Frame Sub PBA

Remove the two Screw Other Len:2.6 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).

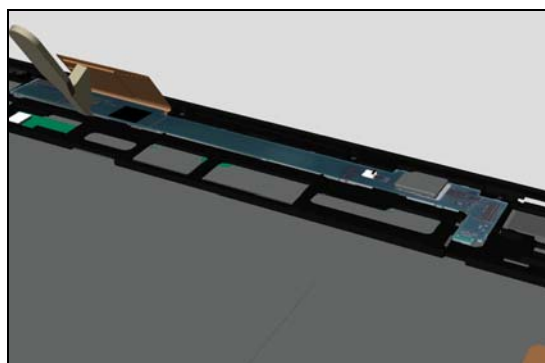


Remove the Frame Sub PBA with fingers



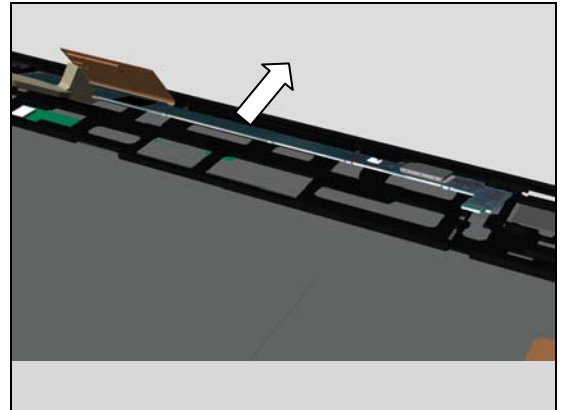
### 3.23 PBA Complete Sub

Use a Front Opening Tool to unhook the PBA Complete Sub.

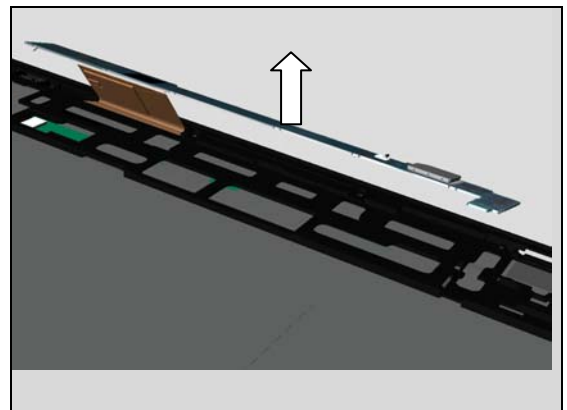


## Disassembly

Lift the PBA Complete Sub with Front Opening Tool

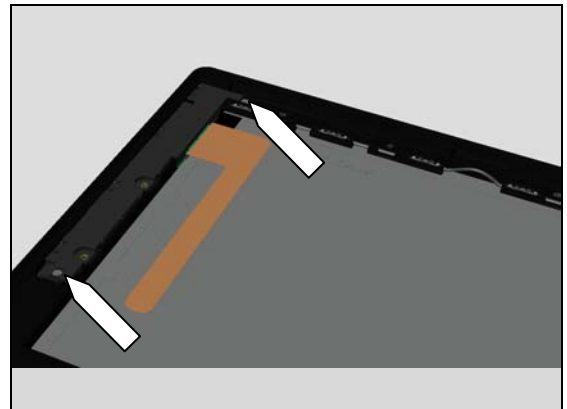


Remove the PBA Complete Sub with fingers.

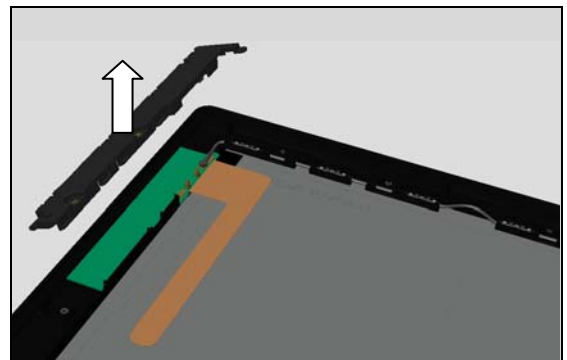


### 3.24 Carrier Antenna Main

Remove the two Screw Other Len:2.6 Diam:1.4 M by using a screwdriver with Bits (JCIS No 0).



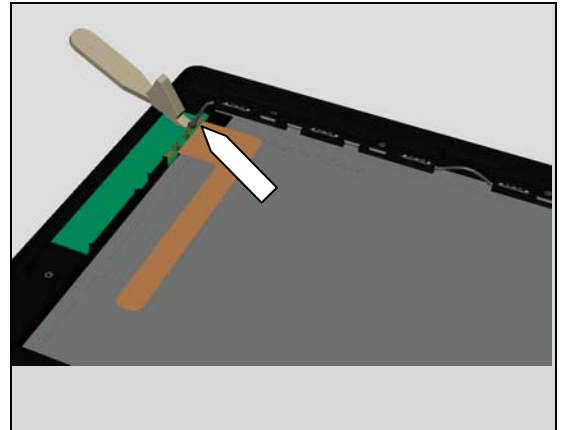
Remove the Carrier Antenna Main by fingers



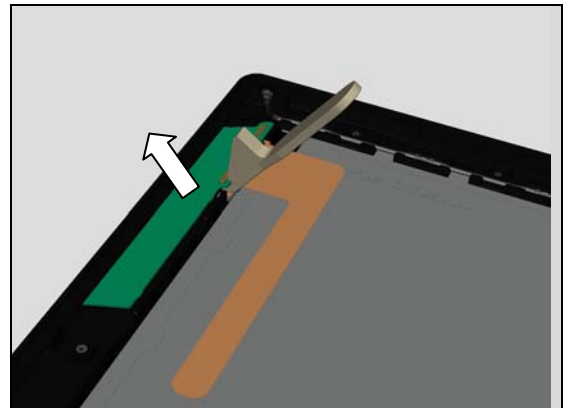
## Disassembly

### 3.25 PBA Antenna LTE and Front Assembly (N/A for SGP311 and SGP312)

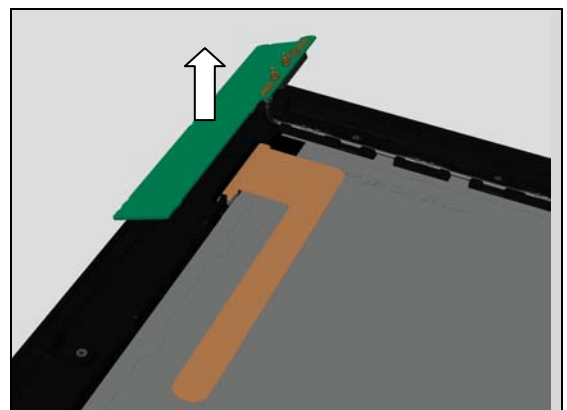
Use a Front Opening Tool to disconnect the RF Cable connector.



Use a Front Opening Tool to unhook PBA Antenna LTE



Remove PBA Antenna LTE with fingers



## 4 Replacement

### 4.1 Back Panel Assy

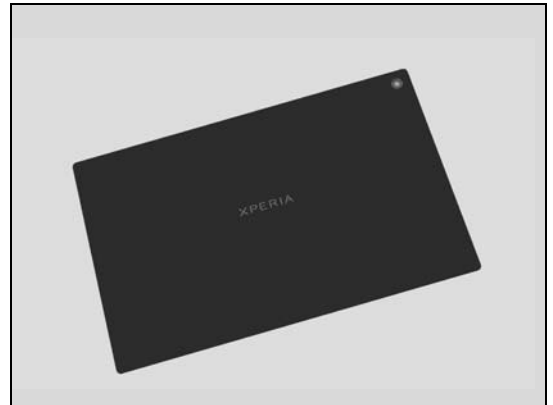
Follow the 3.1 Disassembly instructions!

**Note! If reuse of Back Panel Assy follow 4.27 Removal Instruction**

Prepare a new Back Panel Assy.

**Note! If reuse of Back Panel Assy follow 4.27 Installation Instruction**

Follow the 5.25 Reassembly instructions!



### 4.2 Sheet Magnetic Top

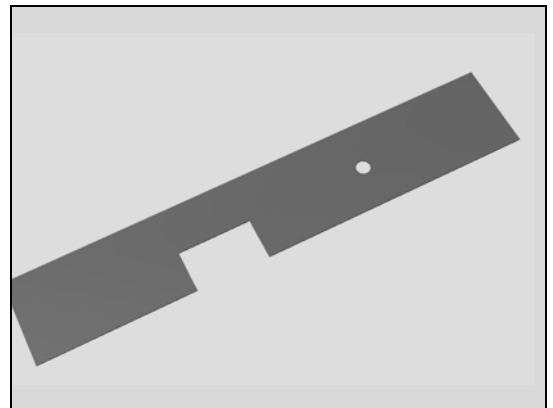
Follow the 3.1 - 3.2 Disassembly instructions!

**Scrap! Not to be reused!**

Prepare a new Sheet Magnetic Top.

Follow the 4.67 Installation instructions!

Follow the 5.24 - 5.25 Reassembly instructions!



### 4.3 Chat Camera

Follow the 3.1 and 3.3 Disassembly instructions!

Follow the 4.32 Removal instructions!

Prepare a new Chat Camera.

Follow the 4.32 Installation instructions!

Follow the 5.23 and 5.25 Reassembly instructions!



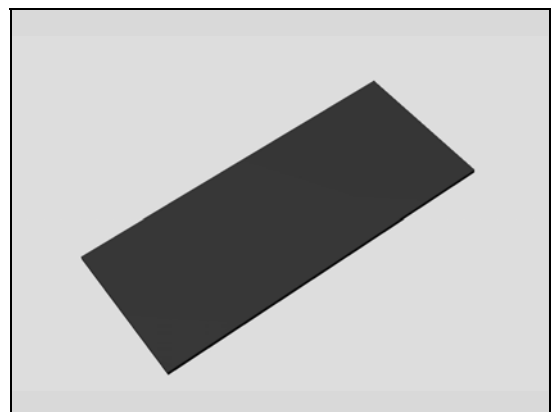
### 4.4 Sheet FPC TOP

Follow the 3.1 and 3.4 Disassembly instructions!

**Scrap! Not to be reused!**

Prepare a new Sheet FPC Top.

Follow the 5.22 and 5.25 Reassembly instructions!



## Replacement

### 4.5 FPC Assembly Top PBA

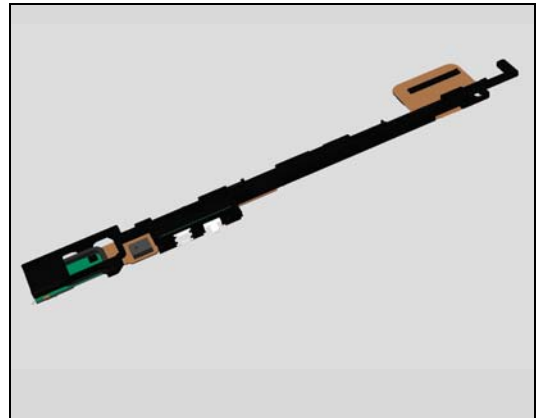
*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.34 Removal instructions!*

Prepare a new FPC Assembly Top PBA.

*Follow the 4.34 Installation instructions!*

Follow the 5.21 – 5.25 Reassembly instructions!



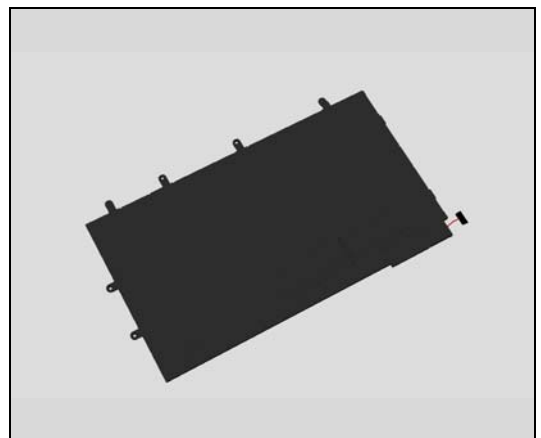
### 4.6 Battery

*Follow the 3.1 – 3.6 Disassembly instructions!*

Prepare a new Battery.

*Follow the 4.36, 4.37 and 4.66 Installation instructions!*

Follow the 5.20 - 5.25 Reassembly instructions!



### 4.7 Main Camera

*Follow the 3.1 and 3.7 Disassembly instructions!*

*Follow the 4.35 Removal instructions!*

Prepare a new Main Camera.

*Follow the 4.35 and 4.39 Installation instructions!*

Follow the 5.19 and 5.25 Reassembly instructions!



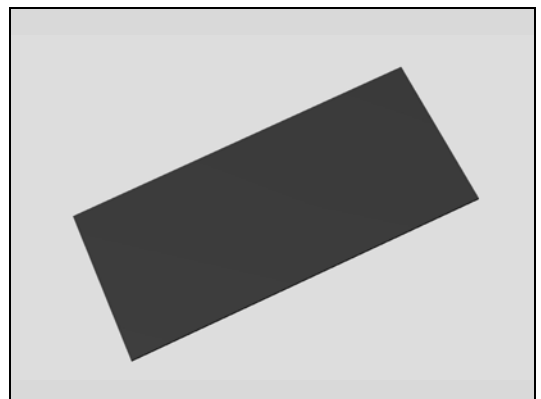
### 4.8 Sheet Jack K

*Follow the 3.1 and 3.8 Disassembly instructions!*

**Scrap! Not to be reused!**

Prepare a new Sheet Jack K.

Follow the 5.18 and 5.25 Reassembly instructions!



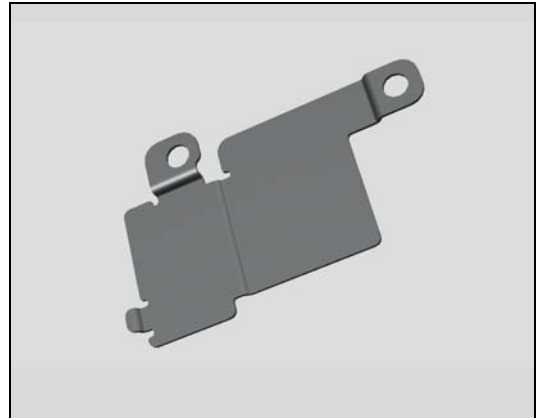
## Replacement

### 4.9 Plate FPC Audio Jack

*Follow the 3.1, 3.8 - 3.9 Disassembly instructions!*

Prepare a new Plate FPC Audio Jack.

Follow the 5.17 - 5.18 and 5.25 Reassembly instructions!



### 4.10 GPS antenna

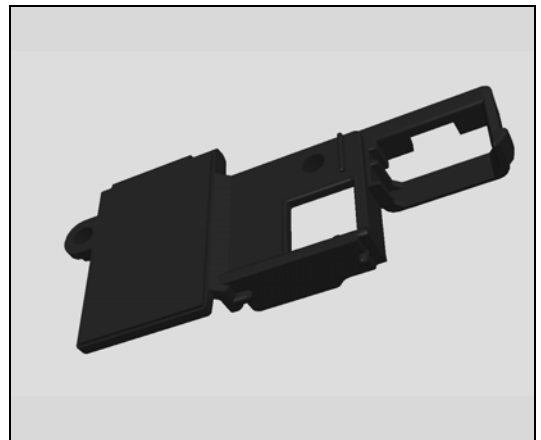
*Follow the 3.1 and 3.8 – 3.10 Disassembly instructions!*

*Follow the 4.49 Removal instructions!*

Prepare a new GPS antenna.

*Follow the 4.49 Installation instructions!*

Follow the 5.16 – 5.18 and 5.25 Reassembly instructions!



### 4.11 Diversity antenna

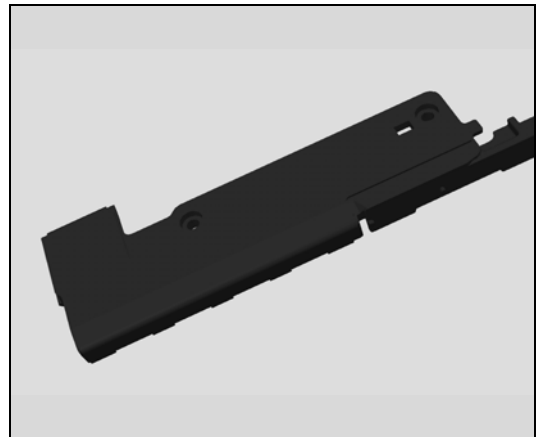
*Follow the 3.1 and 3.11 Disassembly instructions!*

*Follow the 4.48 Removal instructions!*

Prepare a new Diversity antenna.

*Follow the 4.48 Installation instructions!*

Follow the 5.15 and 5.25 Reassembly instructions!



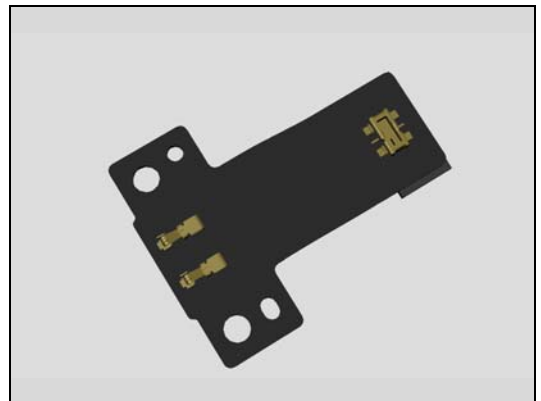
### 4.12 FPC Assembly Charge PBA

*Follow the 3.1 and 3.12 Disassembly instructions!*

Prepare a new FPC Assembly Charge PBA.

*Follow the 4.39 Installation instructions!*

Follow the 5.14 and 5.25 Reassembly instructions!





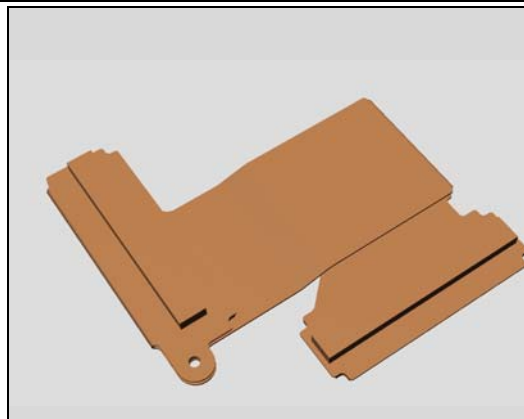
## Replacement

### 4.13 FPC Assembly Relay SUB PBA

*Follow the 3.1 and 3.13 Disassembly instructions!*

Prepare a new FPC Assembly Relay SUB PBA.

Follow the 5.13 and 5.25 Reassembly instructions!



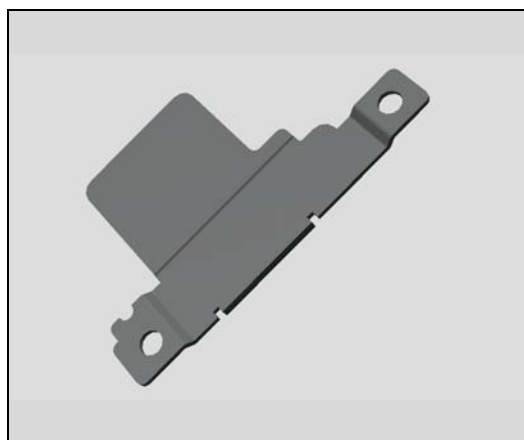
### 4.14 Plate USB

*Follow the 3.1 and 3.14 Disassembly instructions!*

Prepare a new Plate USB.

*Follow the 4.44 Installation instructions!*

Follow the 5.12 and 5.25 Reassembly instructions!



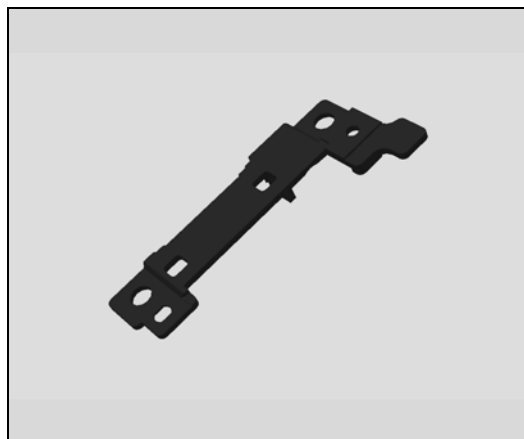
### 4.15 Carrier Holder USB

*Follow the 3.1 and 3.14 – 3.15 Disassembly instructions!*

Prepare a new Carrier Holder USB.

*Follow the 4.52 Installation instructions!*

Follow the 5.11 – 5.12 and 5.25 Reassembly instructions!



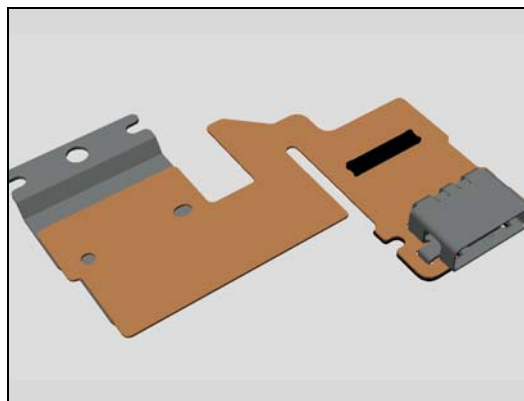
### 4.16 FPC Assembly USB PBA

*Follow the 3.1 and 3.13 – 3.16 Disassembly instructions!*

Prepare a new FPC Assembly USB PBA.

*Follow the 4.44 Installation instructions!*

Follow the 5.10 - 5.13 and 5.25 Reassembly instructions!

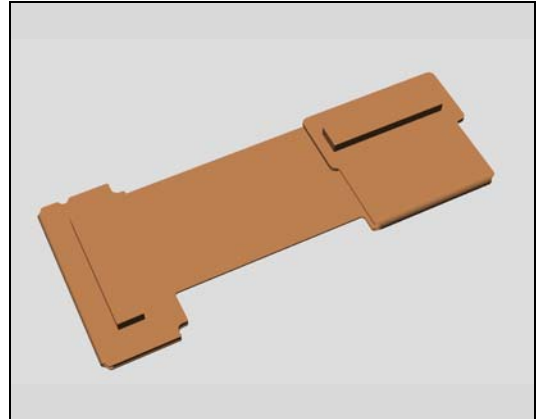




## Replacement

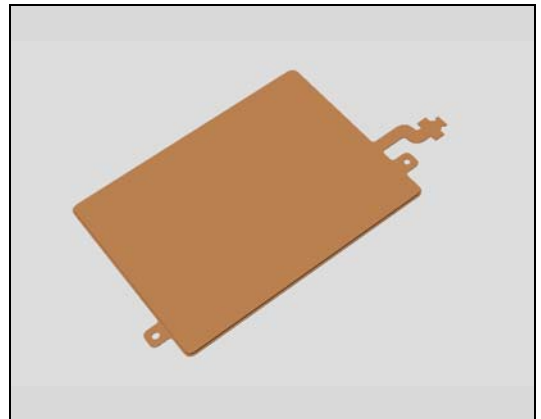
### 4.17 FPC Assembly Relay LCD PBA

*Follow the 3.1 and 3.17 Disassembly instructions!*  
Prepare a new FPC Assembly Relay LCD PBA.  
Follow the 5.9 and 5.25 Reassembly instructions!



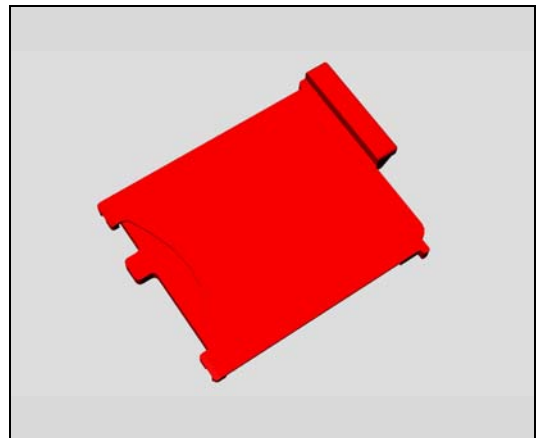
### 4.18 NFC antenna

*Follow the 3.1 and 3.19 Disassembly instructions!*  
Prepare a new NFC antenna.  
Follow the 5.7 and 5.25 Reassembly instructions!



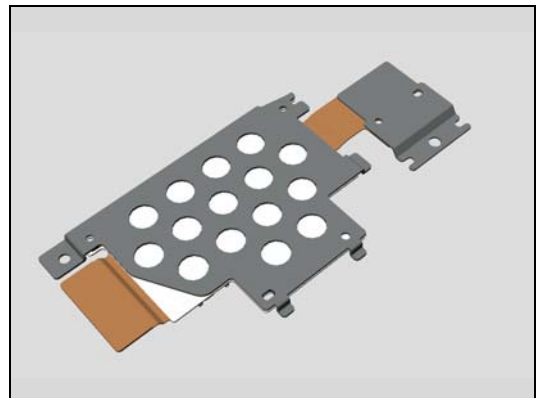
### 4.19 SIM Tray

*Follow the 3.20 Disassembly instructions!*  
Prepare a new SIM Tray.  
Follow the 5.6 Reassembly instructions!



### 4.20 FPC Assembly SIM

*Follow the 3.1 and 3.20 – 3.21 Disassembly instructions!*  
Prepare a new FPC Assembly SIM.  
Follow the 5.5 - 5.6 and 5.25 Reassembly instructions!



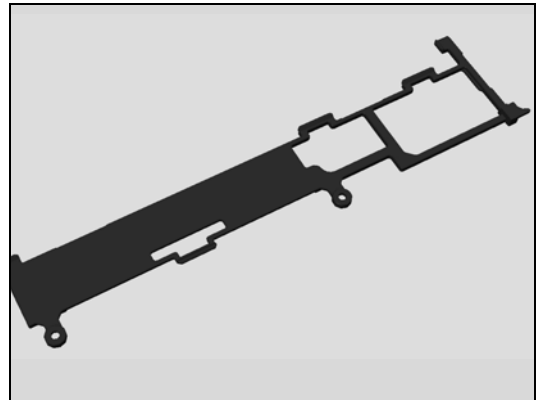
## Replacement

### 4.21 Frame Sub PBA

*Follow the 3.1, 3.17 and 3.19–3.22 Disassembly instructions!*

Prepare a new Frame Sub PBA.

Follow the 5.4-5.7, 5.9 and 5.11 Reassembly instructions!



### 4.22 PBA Complete Sub

*Follow the 3.1, 3.13 and 3.19–3.23 Disassembly instructions!*

Prepare a new PBA Complete Sub.

*Follow the 4.25 and 4.47 Installation instructions!*

Follow the 5.3-5.7, 5.13 and 5.25 Reassembly instructions!

Follow the Calibration chapter 3.1 and 3.2 in 1274-7274 Test Instruction – mechanical



### 4.23 Carrier Antenna Main

*Follow the 3.1 and 3.24 Disassembly instructions!*

Prepare a new Carrier Antenna Main.

*Follow the 4.51 and 4.60 Installation instructions!*

Follow the 5.2 and 5.25 Reassembly instructions!



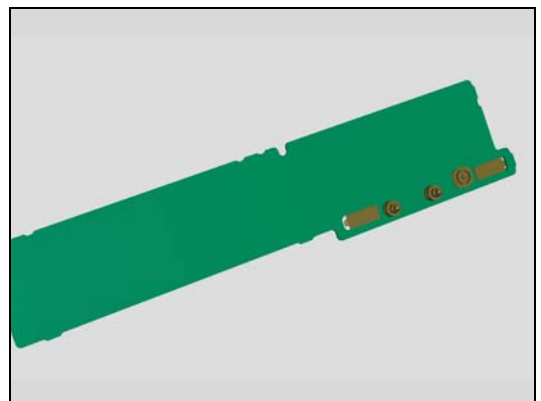
### 4.24 PBA Antenna LTE

*Follow the 3.1 and 3.24- 3.25 Disassembly instructions!*

Prepare a new PBA Antenna LTE.

*Follow the 4.40 Installation instructions!*

Follow the 5.1 – 5.2 and 5.25 Reassembly instructions!



## Replacement

### 4.25 Adhesive (TP)

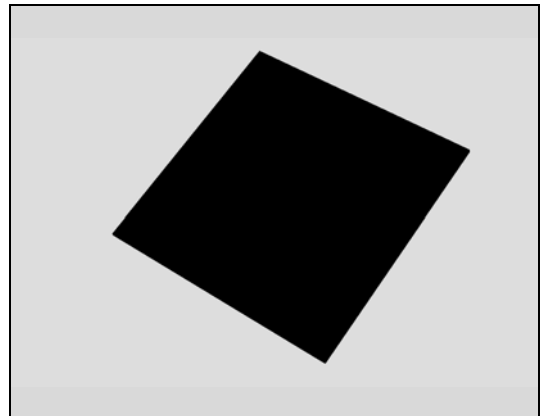
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Adhesive (TP)!*

*Carry out the Installation as described below!*

*Follow the 5.6 and 5.11 Reassembly instructions!*



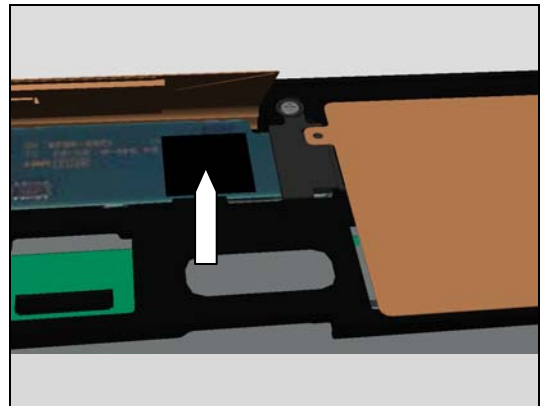
#### REMOVAL

Detach to remove the Adhesive (TP) with a dentist hook

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Adhesive (TP) with a Flex Film Assembly Tool on the PBA Complete Sub



## Replacement

### 4.26 Adhesive Panel Bottom

*Follow the 4.58 Removal instructions!  
Carry out the Removal as described below!  
Prepare a new Adhesive Panel Bottom!  
Carry out the Installation as described below!  
Follow the 4.58 Installation instructions!*

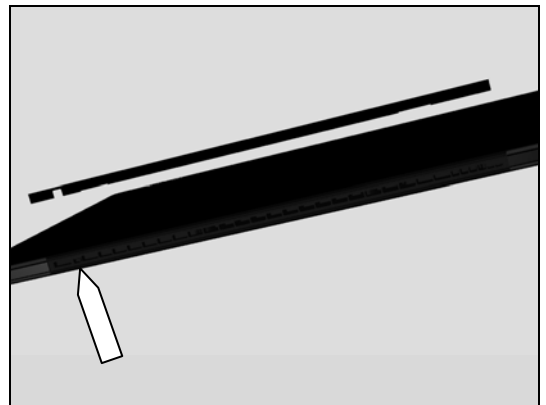
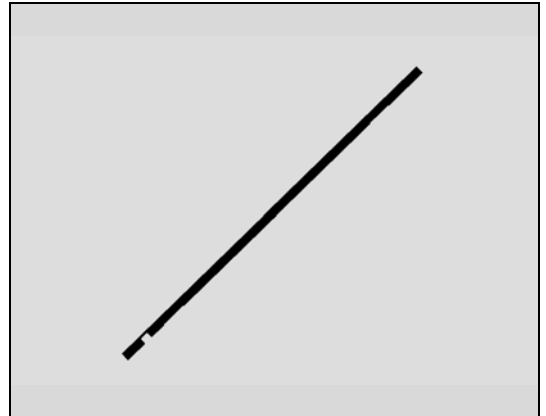
#### REMOVAL

Remove the Adhesive Panel Bottom with the dentist hook

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new *Adhesive Panel Bottom* with a *Flex Film Assembly Tool* on the *Front Assembly*



## Replacement

### 4.27 Adhesive WP Panel Rear

*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Adhesive WP Panel Rear!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*

#### REMOVAL

Remove the Adhesive WP Panel by using Nylon Pointer

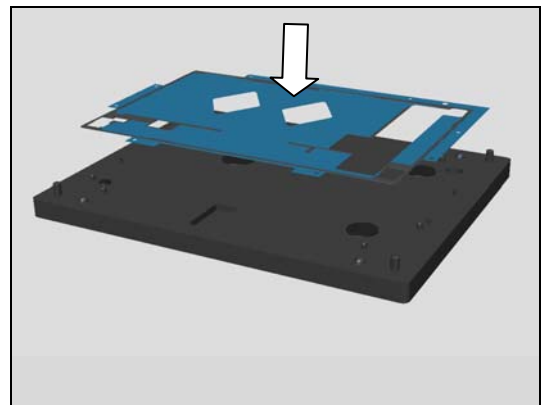
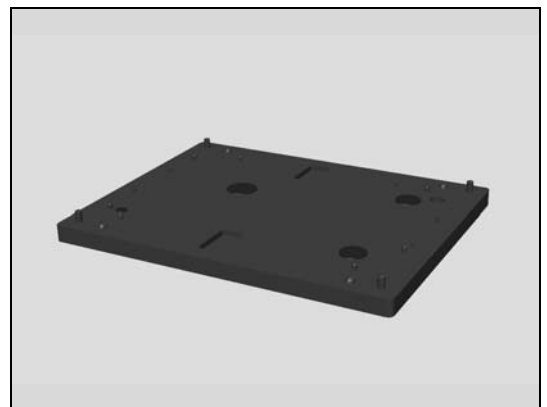
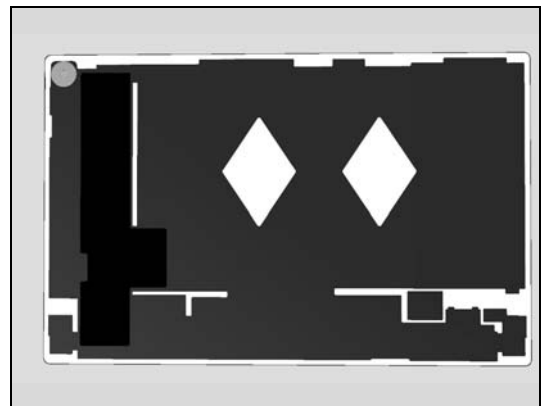
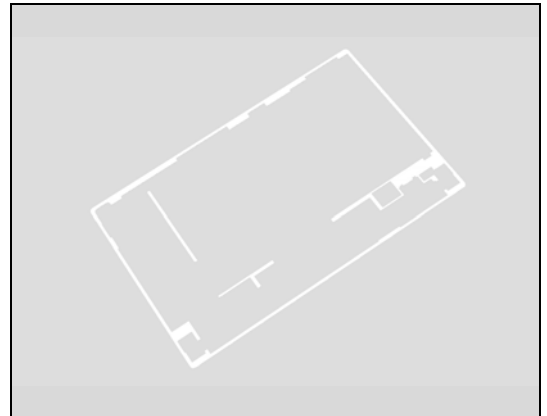
**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Adhesive WP Panel Rear

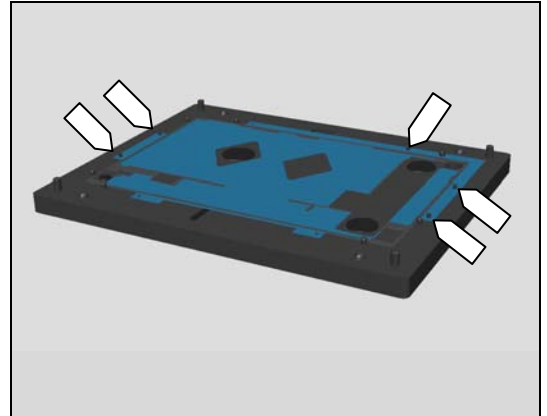
Start by using the bottom plate of Backpanel Adhesive Fixture

Place a new Adhesive WP Panel Rear in the fixture with fingers

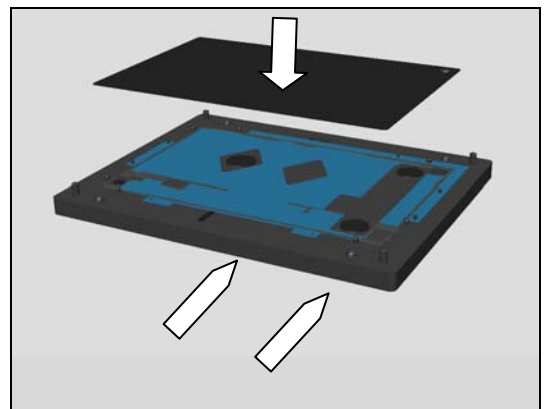


## Replacement

Align the Adhesive WP Panel Rear using guiding holes

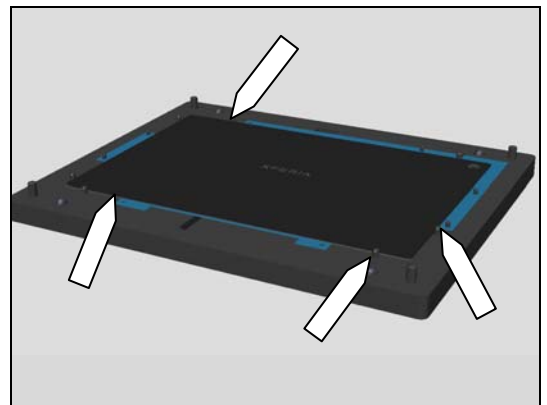


Place the Back Panel Assy with fingers

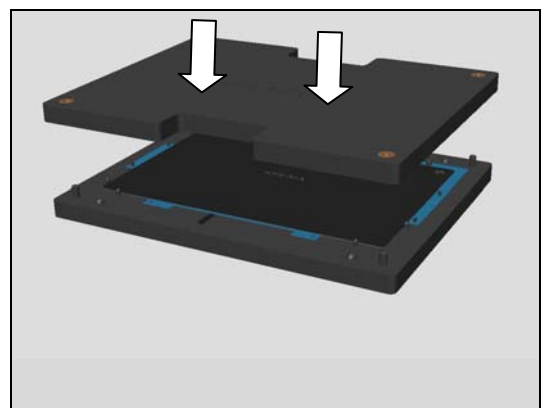


Use guiding pins for align the old Back Panel above the Adhesive WP Panel Rear.

**Important to make sure that old adhesive is removed before installation because of WRT requirement!**



Place the Upper part of the fixture and press by hand for 10 sec.



## Replacement

### 4.28 Adhesive WP Speaker

#### **Right Adhesive WP Speaker**

*Follow the 3.1 and 3.13 – 3.16 Disassembly instructions!*

#### **Left Adhesive WP Speaker**

*Follow the 3.1 and 3.20 – 3.21 Disassembly instructions!*

*Follow the 4.53 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Adhesive WP Speaker!*

*Carry out the Installation as described below!*

*Follow the 4.53 Installation instructions!*

#### **Right Adhesive WP Speaker**

*Follow the 5.10 – 5.13 and 5.25 Reassembly instructions!*

#### **Left Adhesive WP Speaker**

*Follow the 5.5 – 5.6 and 5.25 Reassembly instructions*

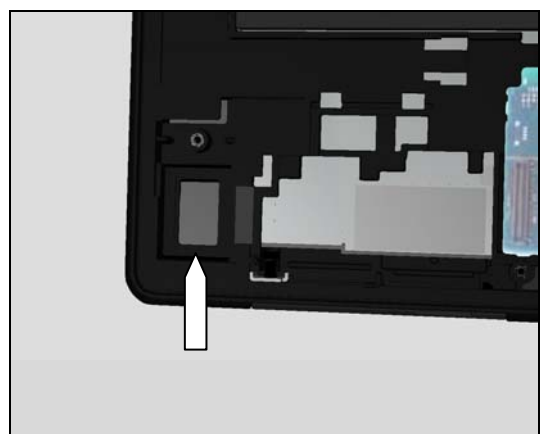
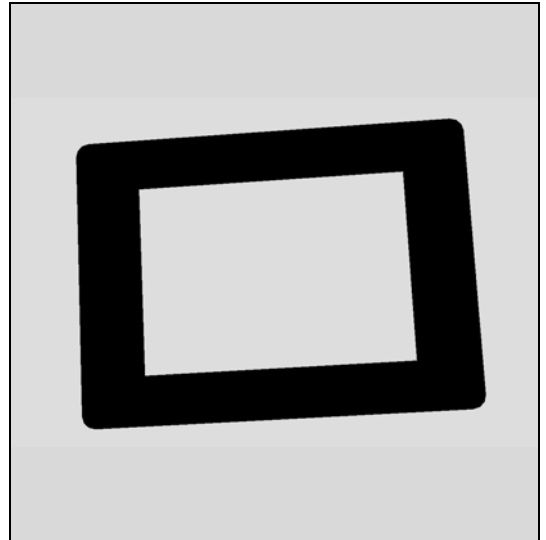
### REMOVAL

Detach to remove the Adhesive WP Speaker with dentist hook and Nylon Pointer

**Scrap! Not to be reused!**

### INSTALLATION

Place a new Adhesive WP Speaker using a Flex Film Assembly Tool on the Front Assembly.



## Replacement

### 4.29 Cap Audio Jack Assy

*Follow the 3.1 and 3.8 – 3.10 Disassembly instructions!*

*Follow the 4.33 and 4.57 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cap Audio Jack Assy!*

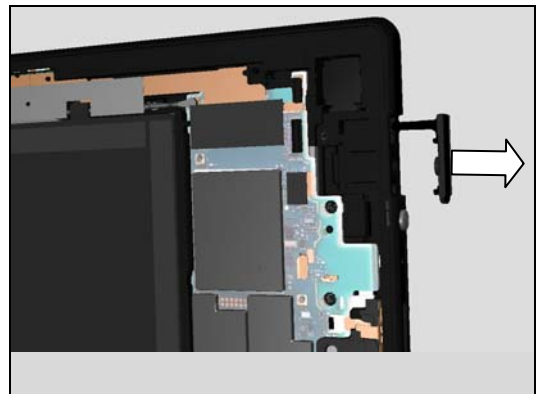
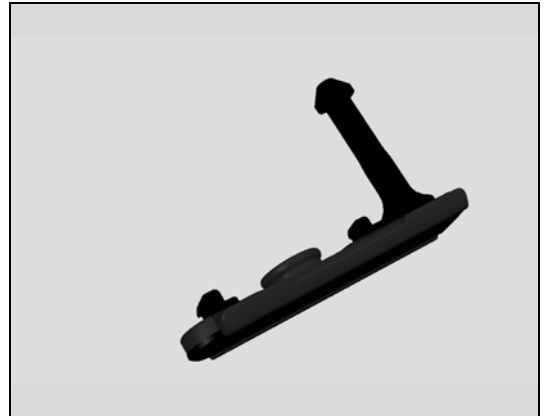
*Carry out the Installation as described below!*

*Follow the 4.33 and 4.57 Installation instructions!*

*Follow the 5.16 – 5.18 and 5.25 Reassembly instructions!*

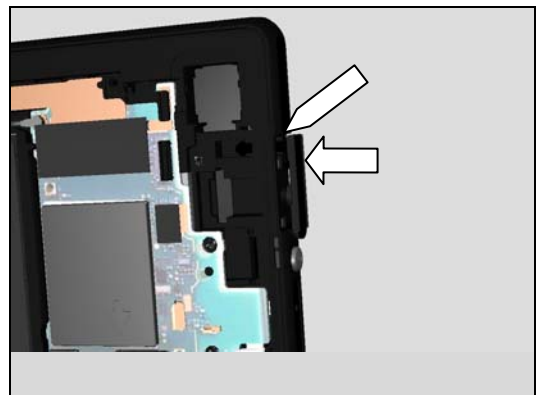
#### REMOVAL

Remove the Cap Audio Jack Assy with fingers

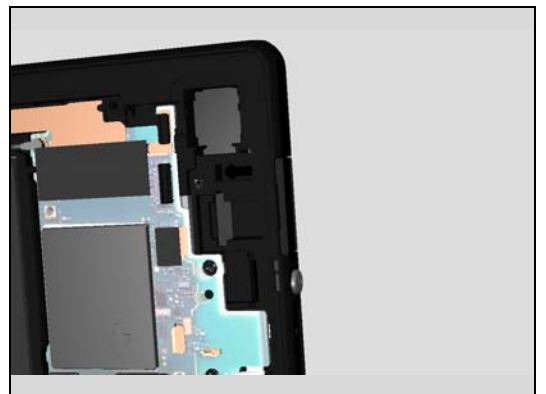


#### INSTALLATION

Place a new Cap Audio Jack Assy with fingers



Press it in place.





## Replacement

### 4.30 Cap SIM Assembly

*Follow the 3.1 and 3.20 – 3.21 Disassembly instructions!*

*Follow the 4.61 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cap SIM Assembly!*

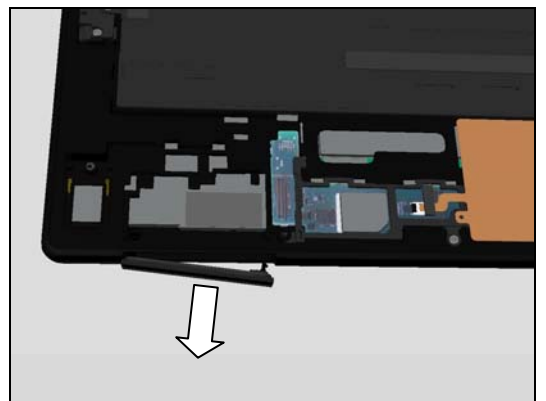
*Carry out the Installation as described below!*

*Follow the 4.61 Installation instructions!*

*Follow the 5.5 – 5.6 and 5.25 Reassembly instructions!*

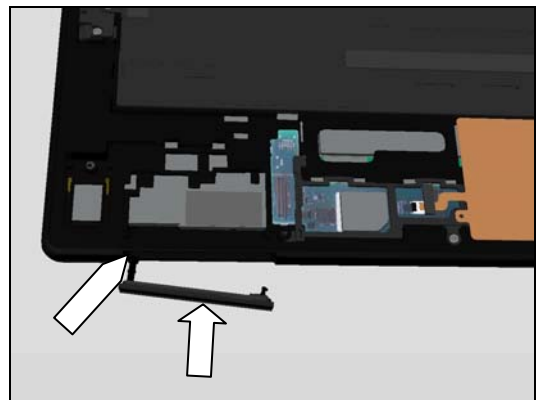
#### REMOVAL

Remove the Cap SIM Assembly with fingers



#### INSTALLATION

Place a new Cap SIM Assembly with fingers



Press it in place.



## Replacement

### 4.31 Cap USB Assembly

*Follow the 3.1 and 3.13 – 3.16 Disassembly instructions!*

*Follow the 4.45 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cap USB Assembly!*

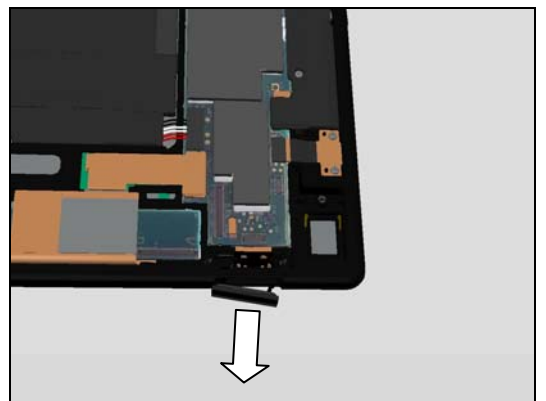
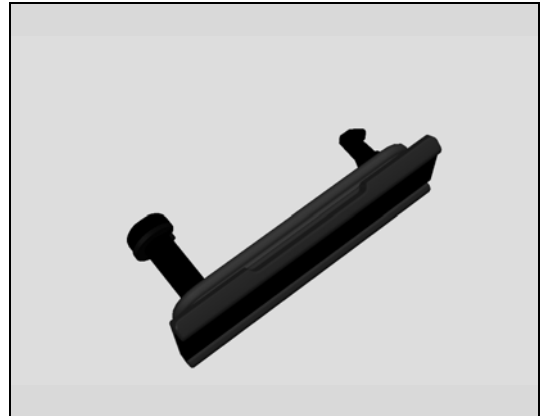
*Carry out the Installation as described below!*

*Follow the 4.45 Installation instructions!*

*Follow the 5.10 – 5.13 and 5.25 Reassembly instructions!*

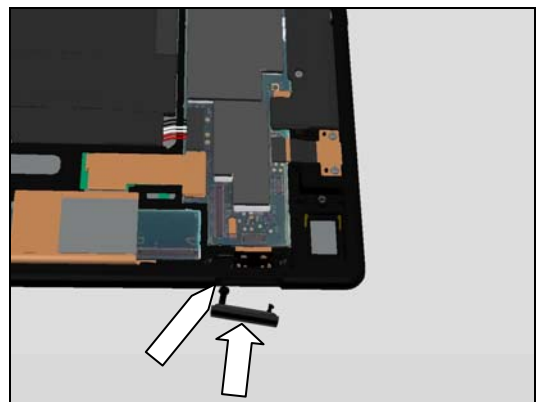
#### REMOVAL

Remove the Cap USB Assembly with fingers

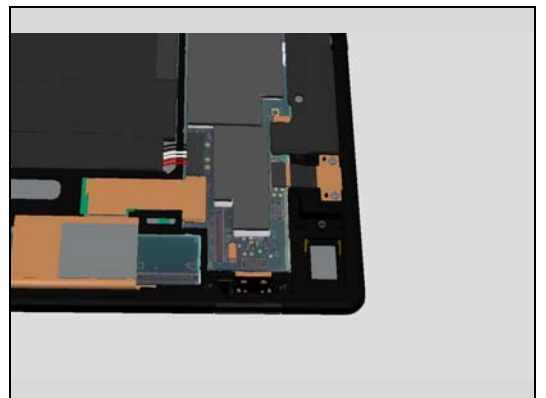


#### INSTALLATION

Place a new Cap USB Assembly with fingers



Press it in place



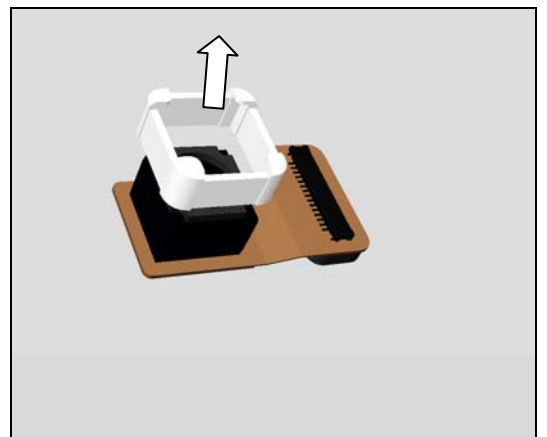
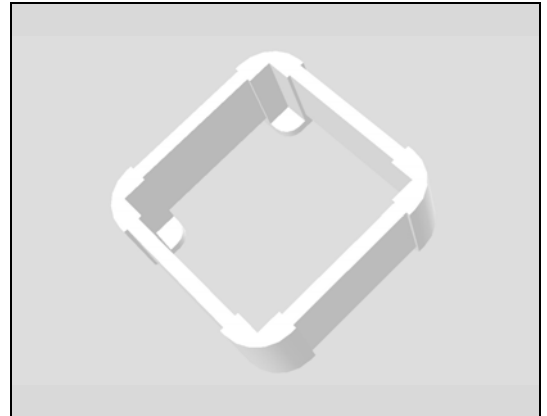
## Replacement

### 4.32 Carrier Chat Camera

*Follow the 3.1 and 3.3 Disassembly instructions!*  
*Carry out the Removal as described below!*  
*Prepare a new Carrier Chat Camera!*  
*Carry out the Installation as described below!*  
 Follow the 5.23 and 5.25 Reassembly instructions!

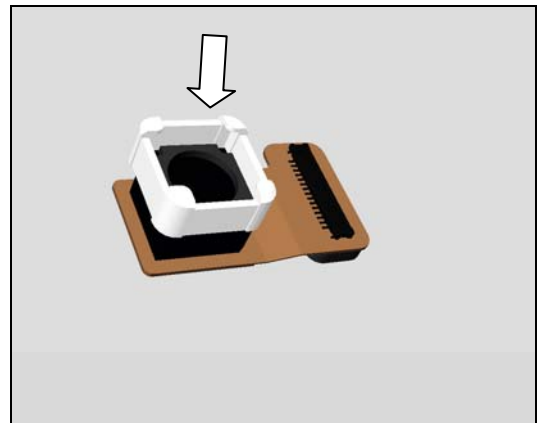
#### REMOVAL

Detach to remove the Carrier Chat Camera with fingers

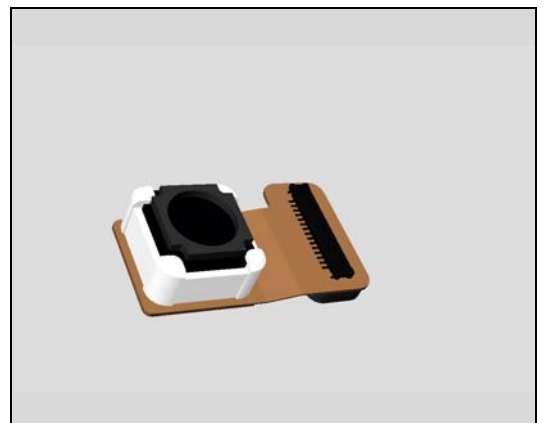


#### INSTALLATION

Place a new Carrier Chat Camera using a Flex Film Assembly Tool on the Chat Camera



Secure Carrier Chat Camera position using fingers



## Replacement

### 4.33 Carrier Frame Jack Arm

*Follow the 3.1 and 3.8 – 3.10 Disassembly instructions!*

*Follow the 4.57 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Carrier Frame Jack Arm!*

*Carry out the Installation as described below!*

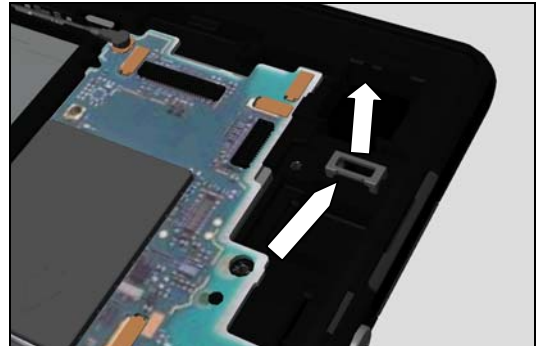
*Follow the 4.57 Installation instructions!*

*Follow the 5.16 – 5.18 and 5.25 Reassembly instructions!*



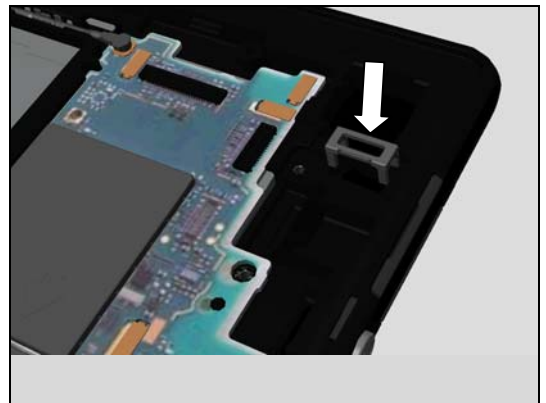
#### REMOVAL

Remove the Carrier Frame Jack Arm with Dentist Hook.



#### INSTALLATION

Place a new Carrier Frame Jack Arm using a pair of tweezers in the Front Assembly cavity.



## Replacement

### 4.34 Carrier Holder Mic

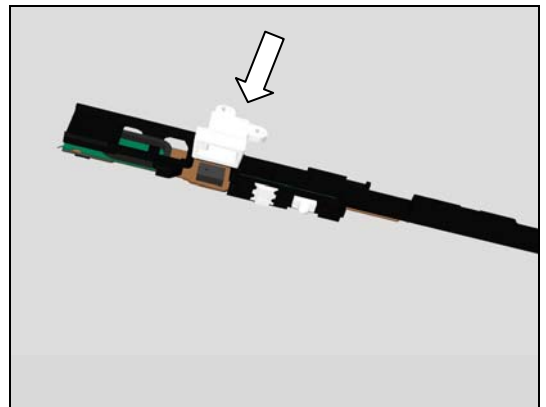
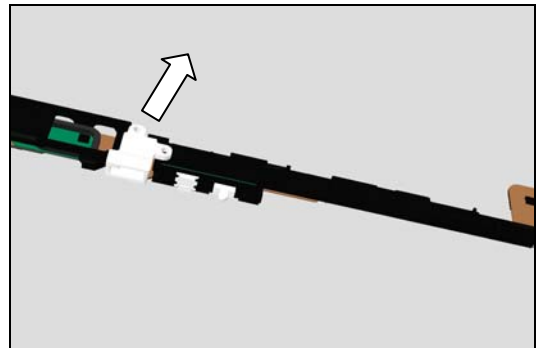
*Follow the 3.1 – 3.5 Disassembly instructions!*  
*Carry out the Removal as described below!*  
*Prepare a new Carrier Holder Mic!*  
*Carry out the Installation as described below!*  
Follow the 5.21 – 5.25 Reassembly instructions!

#### REMOVAL

Remove the Carrier Holder Mic with a pair of tweezers.

#### INSTALLATION

Place a new Carrier Holder Mic with fingers on the FPC Assembly Top PBA



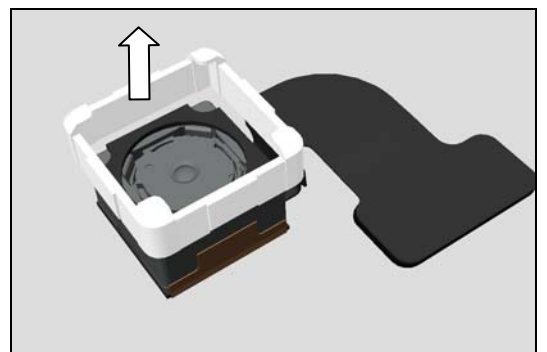
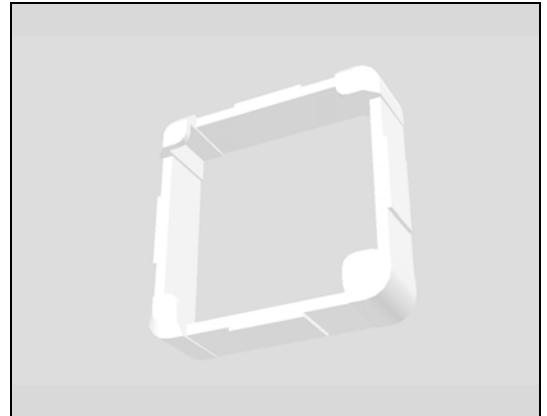
## Replacement

### 4.35 Carrier Main Camera

*Follow the 3.1 and 3.7 Disassembly instructions!*  
*Carry out the Removal as described below!*  
*Prepare a new Carrier Main Camera!*  
*Carry out the Installation as described below!*  
 Follow the 5.19 and 5.25 Reassembly instructions!

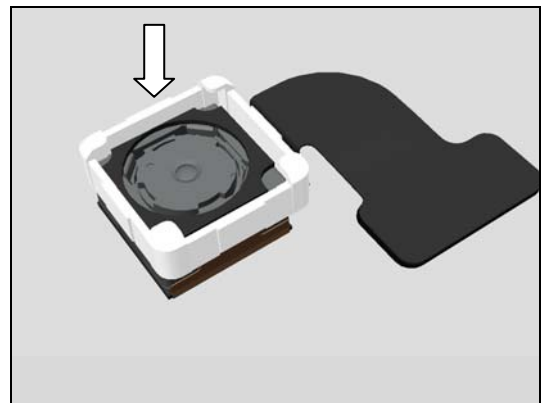
#### REMOVAL

Release the Carrier Main Camera using fingers



#### INSTALLATION

Place a new Carrier Main Camera using a Flex Film Assembly Tool on the Main Camera



Secure Carrier Main Camera position using fingers



## Replacement

### 4.36 Cushion Battery L

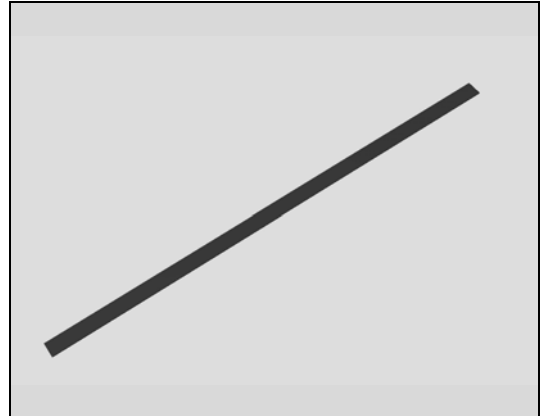
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion Battery L!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*



#### REMOVAL

Remove the Cushion Battery L with Flex Film Assembly Tool

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion Battery L using a Flex Film Assembly Tool on the Battery



## Replacement

### 4.37 Cushion Battery M

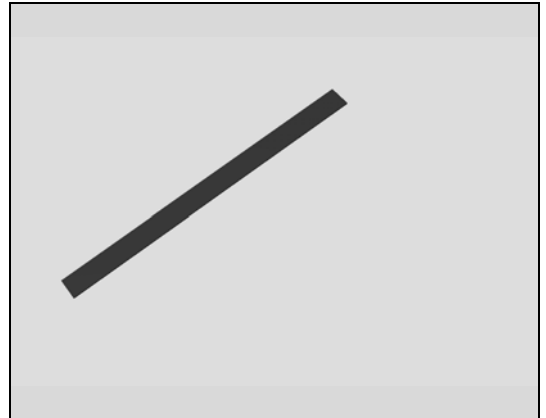
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion Battery M!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*



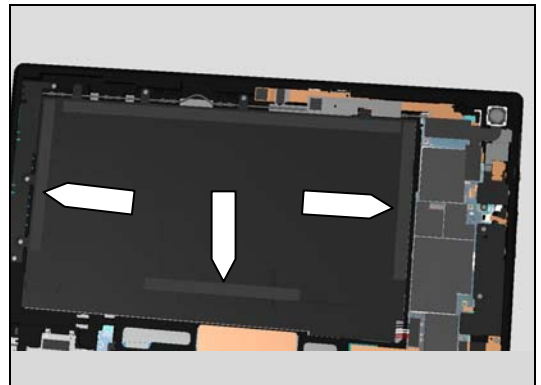
#### REMOVAL

Remove the Cushion Battery M with Flex Film Assembly Tool

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion Battery M using a Flex Film Assembly Tool on the Battery





## Replacement

### 4.38 Cushion BtoB L

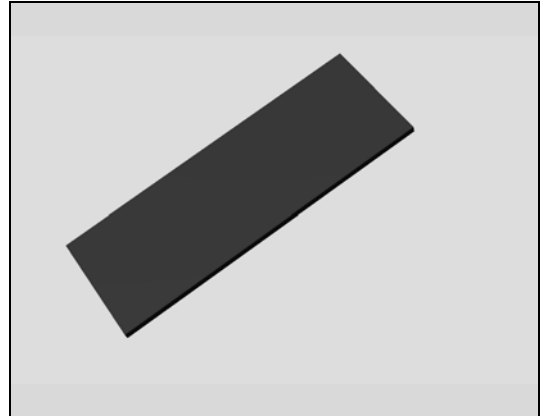
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion BtoB L!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*



#### REMOVAL

Remove the Cushion BtoB L with a Flex Film Assembly Tool.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion BtoB L with a Flex Film Assembly Tool.



## Replacement

### 4.39 Cushion BtoB S

*Follow the 3.1 Disassembly instructions!  
Carry out the Removal as described below!  
Prepare a new Cushion BtoB S!  
Carry out the Installation as described below!  
Follow the 5.25 Reassembly instructions!*

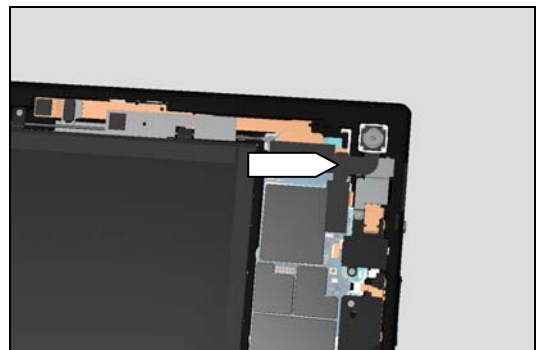
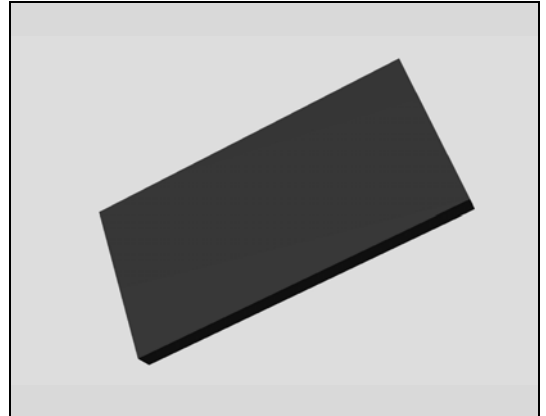
#### REMOVAL

Remove the Cushion BtoB S with a Flex Film Assembly Tool.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion BtoB S with a Flex Film Assembly Tool on the Main Camera.



## Replacement

### 4.40 Cushion Conductive

#### **Cushion Conductive on PBA Antenna LTE**

Follow the 3.1 and 3.24 – 3.25 Disassembly instructions!

#### **Cushion Conductive on Main PBA**

Follow the 3.1- 3.5 and 3.7 – 3.18 Disassembly instructions!

Carry out the Removal as described below!

Prepare a new Cushion Conductive!

Carry out the Installation as described below!

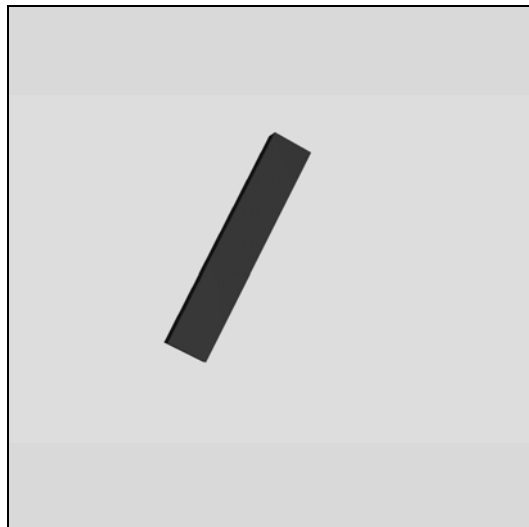
Follow the 4.25 Installation instructions!

#### **Cushion Conductive on PBA Antenna LTE**

Follow the 5.1 – 5.2 and 5.25 Reassembly instructions!

#### **Cushion Conductive on Main PBA**

Follow the 5.8 – 5.19 and 5.21 – 5.25 Reassembly instructions



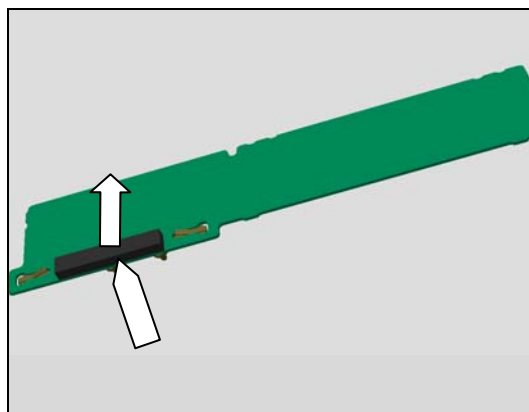
#### REMOVAL

Remove the Cushion Conductive on PBA Antenna LTE with the Flex Film Assembly Tool.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion Conductive on PBA Antenna LTE with the Flex Film Assembly Tool.



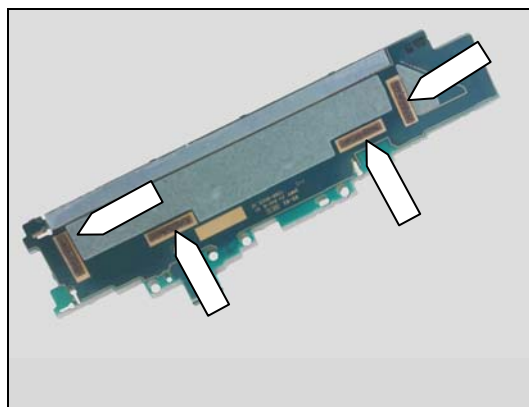
#### REMOVAL

Remove the Cushion Conductive on the Main PBA with the Flex Film Assembly Tool.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion Conductive on Main PBA with the Flex Film Assembly Tool.



## Replacement

### 4.41 Cushion SP

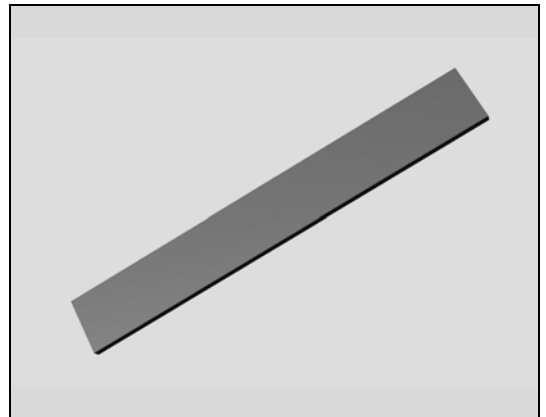
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion SP!*

*Carry out the Installation as described below!*

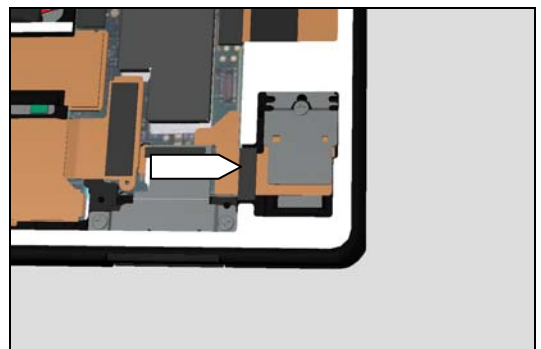
Follow the 5.25 Reassembly instructions!



#### REMOVAL

Detach to remove the Cushion SP (Right side) with a Flex Film Assembly Tool.

**Scrap! Not to be reused!**



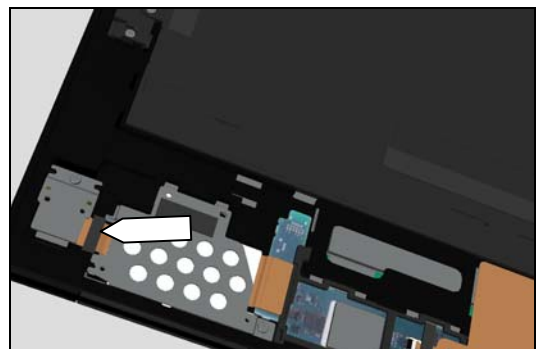
#### INSTALLATION

Place a Cushion SP (Right side) with a Flex Film Assembly Tool on the NFC antenna.

#### REMOVAL

Detach to remove the Cushion SP (Left side) with a Flex Film Assembly Tool.

**Scrap! Not to be reused!**



#### INSTALLATION

Place a Cushion SP (Left side) with a Flex Film Assembly Tool on the NFC antenna.

## Replacement

### 4.42 Cushion Thermal L

*Follow the 3.1 – 3.5 and 3.7 -3.18 Disassembly instructions!*

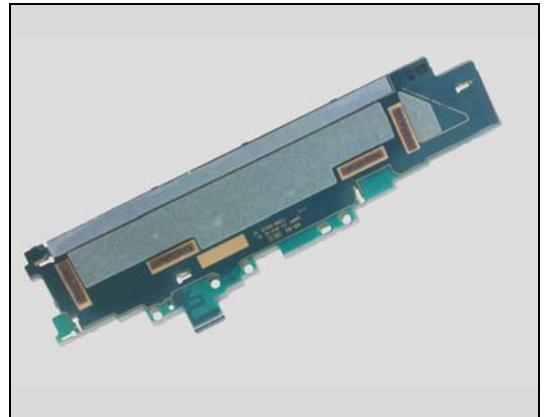
*Carry out the Removal as described below!*

*Prepare a new Cushion Thermal L!*

*Carry out the Installation as described below!*

*Follow the 4.25 Installation instructions!*

*Follow the 5.8 – 5.19 and 5.21–5.25 Reassembly instructions!*



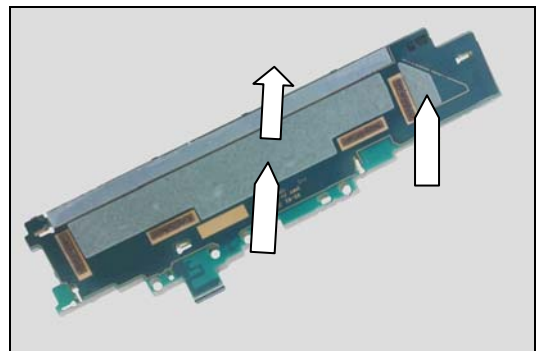
#### REMOVAL

Remove Cushion Thermal L with a pair of tweezers

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion Thermal L with fingers on the Main PBA



## Replacement

### 4.43 Cushion Thermal M

*Follow the 3.1 – 3.5 and 3.7 -3.18 Disassembly instructions!*

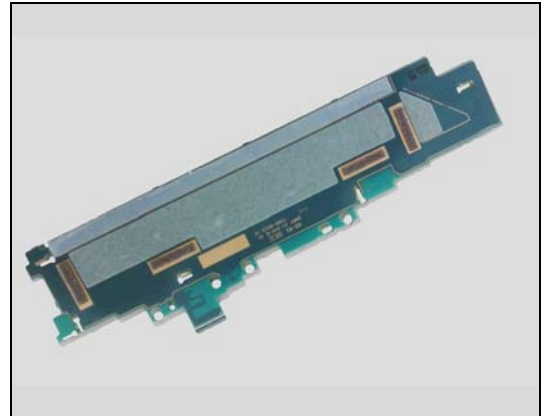
*Carry out the Removal as described below!*

*Prepare a new Cushion Thermal M!*

*Carry out the Installation as described below!*

*Follow the 4.25 Installation instructions!*

*Follow the 5.8 – 5.19 and 5.21–5.25 Reassembly instructions!*



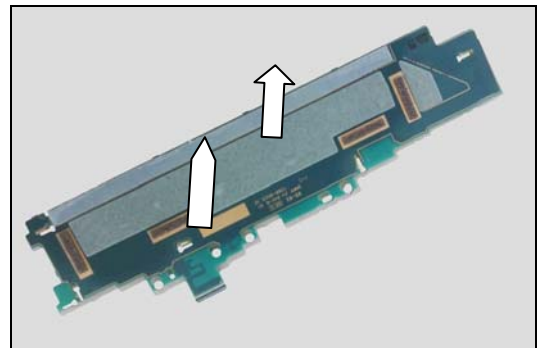
#### REMOVAL

Remove Cushion Thermal M with a pair of tweezers

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion Thermal M with fingers on the Main PBA



## Replacement

### 4.44 Cushion USB

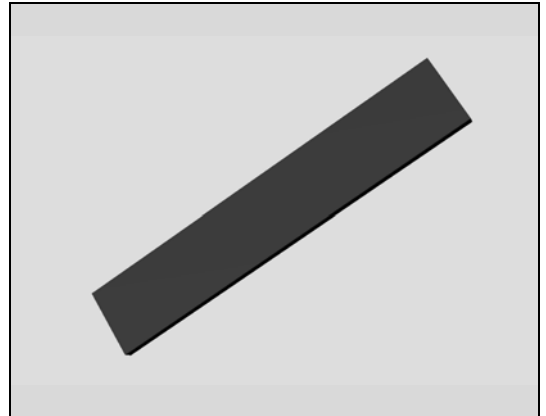
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion USB!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*



#### REMOVAL

Remove the Cushion USB with the Flex Film Assembly Tool.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Cushion USB with Flex Film Assembly Tool on the FPC Assembly USB PBA



## Replacement

### 4.45 E-Ring Cap USB/SIM/Audio

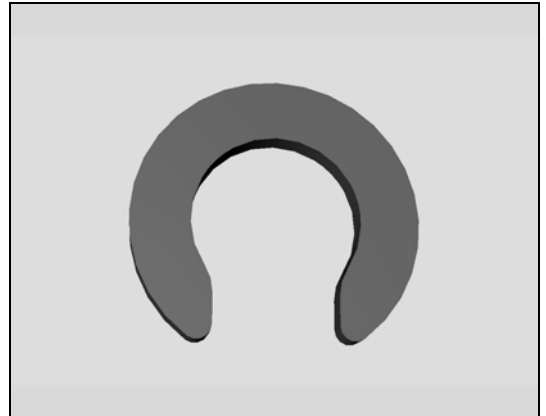
*Follow the 3.1 and 3.13 – 3.16 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new E-Ring Cap USB/SIM/Audio!*

*Carry out the Installation as described below!*

*Follow the 5.10 – 5.13 and 5.25 Reassembly instructions!*

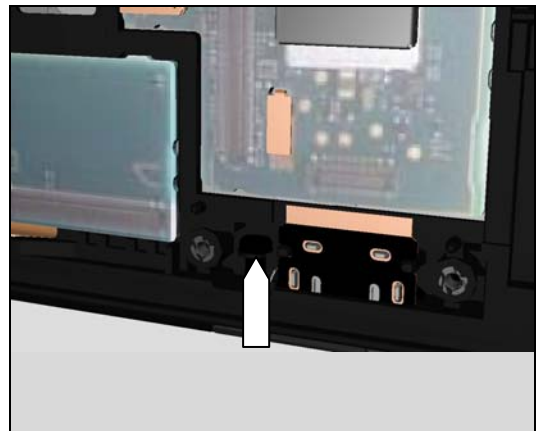


#### REMOVAL

Detach to remove the E-Ring Cap USB/SIM/Audio with a pair of tweezers

#### Installation

Place a new E-Ring Cap USB/SIM/Audio using a pair of tweezers.





## Replacement

### 4.46 Foil Adhesive Battery

*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Foil Adhesive Battery!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*



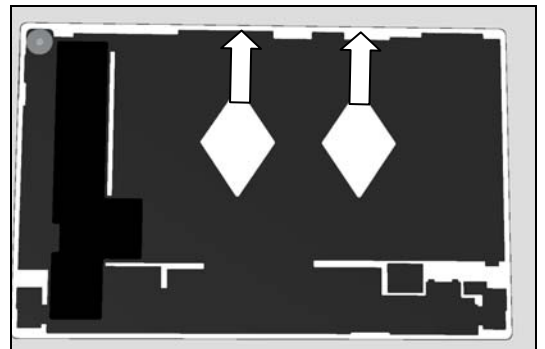
#### REMOVAL

Remove the Foil Adhesive Battery with Nylon Pointer

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Foil Adhesive Battery with fingers on the Back Panel Assy



## Replacement

### 4.47 Foil Adhesive PBA Sub

*Follow the 3.1, 5.13 and 5.19–5.23 Disassembly instructions!*

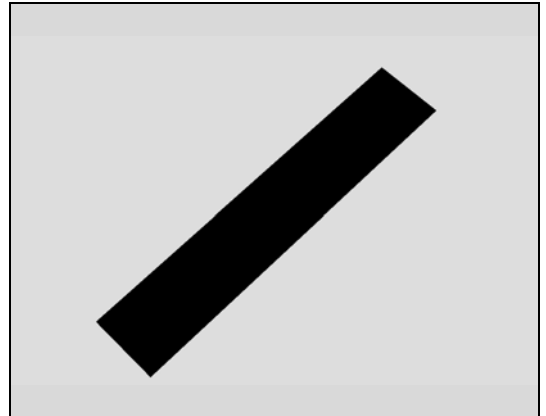
*Carry out the Removal as described below!*

*Prepare a new Foil Adhesive PBA Sub!*

*Carry out the Installation as described below!*

*Follow the 4.25 Installation instructions!*

*Follow the 5.3 – 5.7, 5.13 and 5.25 Reassembly instructions!*



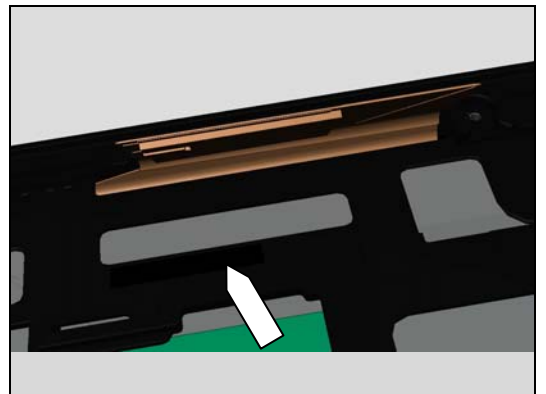
#### REMOVAL

Remove the Foil Adhesive PBA Sub with the Nylon Pointer.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Foil Adhesive PBA Sub with Flex Film Assembly Tool on the Frame Sub PBA



## Replacement

### 4.48 FPC Key PBA

*Follow the 3.1 and 3.11 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new FPC Key PBA!*

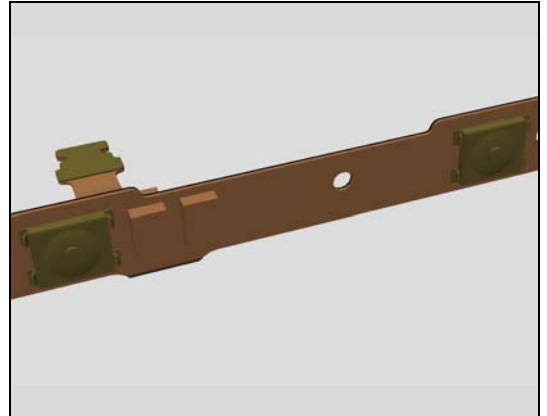
*Carry out the Installation as described below!*

*Follow the 5.15 and 5.25 Reassembly instructions!*

#### REMOVAL

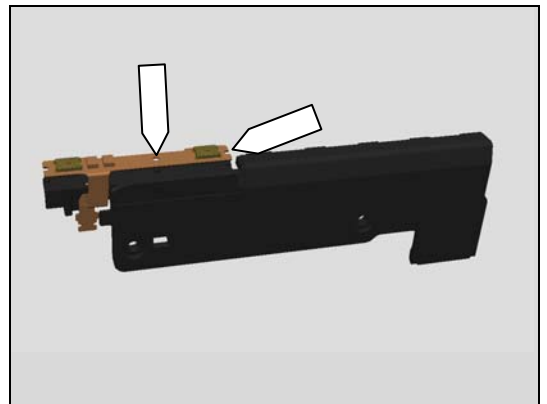
Remove the FPC Key PBA with a pair of tweezers.

**Scrap! Not to be reused!**

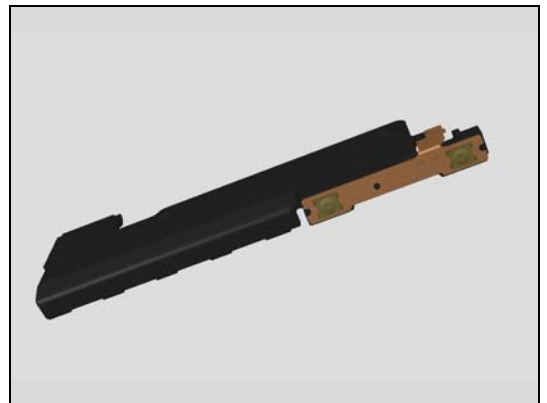


#### INSTALLATION

Place a new FPC Key PBA with a Flex Film Assembly Tool on the Diversity antenna.



Press by using fingers.



## Replacement

### 4.49 FPC Audio Jack

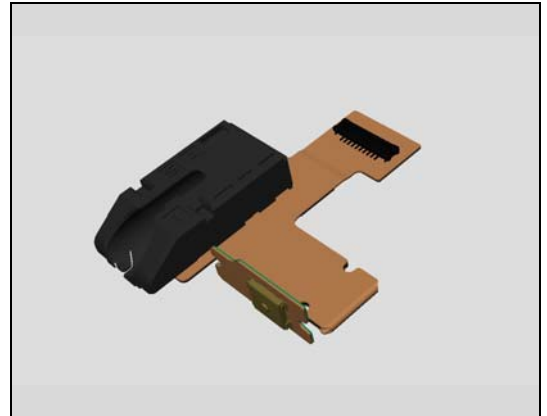
*Follow the 3.1 and 3.8 - 3.10 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new FPC Audio Jack!*

*Carry out the Installation as described below!*

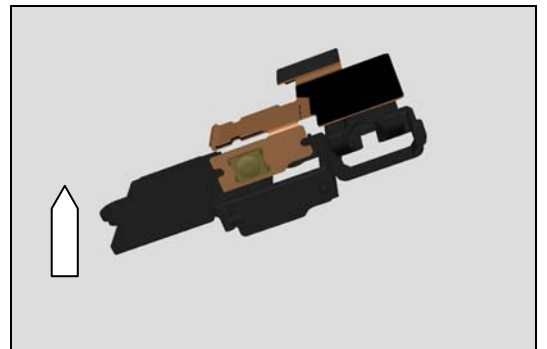
*Follow the 5.16 – 5.18 and 5.25 Reassembly instructions!*



#### REMOVAL

Remove the FPC Audio Jack with the Flex Film Assembly Tool.

**Scrap! Not to be reused!**



#### INSTALLATION

Place a new FPC Audio Jack using a Flex Film Assembly Tool on the GSP antenna.



Press it using fingers



## Replacement

### 4.50 Front Cover

*Follow the 3.1 – 3.25 Disassembly instructions!*

*Follow the 4.26, 4.53, 4.58, 4.59, 4.62, 4.65 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Front Cover!*

*Carry out the Installation as described below!*

*Follow the 4.26, 4.53, 4.58, 4.59, 4.62, 4.65 Installation instructions!*

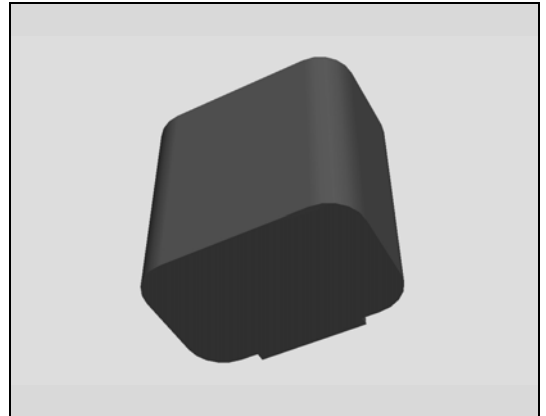
*Follow the 5.1-5.3, 5.6 and 5.11 Reassembly instructions!*



## Replacement

### 4.51 Gasket Antenna Main (N/A SGP311 and SGP312)

*Follow the 3.24 Disassembly instructions!  
Carry out the Removal as described below!  
Prepare a new Gasket Antenna Main!  
Carry out the Installation as described below!  
Follow the 5.2 Installation instructions!*



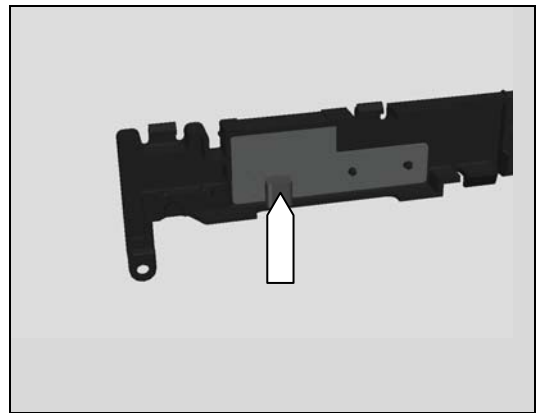
#### REMOVAL

Detach to remove the Gasket Antenna Main with a Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Gasket Antenna Main using a pair of tweezers.



## Replacement

### 4.52 Liquid Indicator

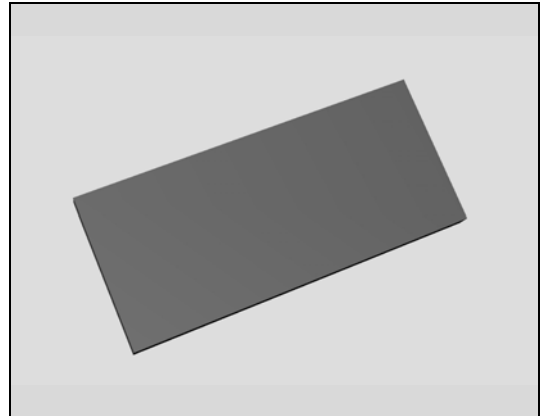
*Follow the 3.1 and 3.14 – 3.15 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Liquid Indicator!*

*Carry out the Installation as described below!*

*Follow the 5.11 – 5.12 and 5.25 Reassembly instructions!*



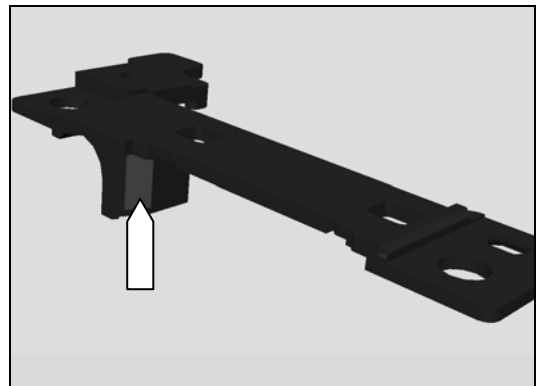
#### REMOVAL

Remove the Liquid Indicator with a Dentist Hook

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Liquid Indicator using a pair of tweezers.



## Replacement

### 4.53 Loudspeaker

#### **Right Loudspeaker**

Follow the 3.1 and 3.13 – 3.16 Disassembly instructions!

#### **Left Loudspeaker**

Follow the 3.1 and 3.20 – 3.21 Disassembly instructions!

Follow the 4.28 Removal instructions!

Carry out the Removal as described below!

Prepare a new Loudspeaker!

Carry out the Installation as described below!

Follow the 4.28 Installation instructions!

#### **Right Loudspeaker**

Follow the 5.10 – 5.13 and 5.25 Reassembly instructions!

#### **Left Loudspeaker**

Follow the 5.5 – 5.6 and 5.25 Reassembly instructions

## REMOVAL

Remove the Loudspeaker with Front Opening Tool.

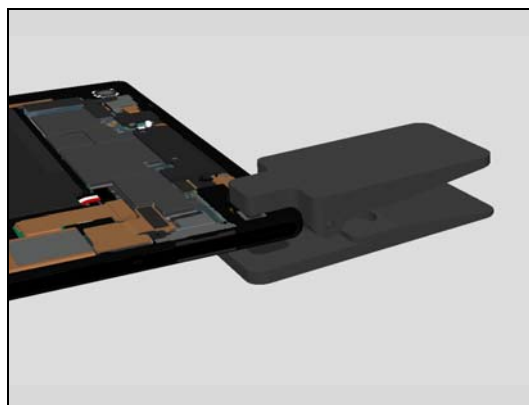
**Scrap! Not to be reused!**

## INSTALLATION

Place a new Loudspeaker using fingers

Press to secure its attachment by using Press Tool Loudspeaker for five seconds.

**Do not touch the contact pins!**





## Replacement

### 4.54 MComp Sheet 54

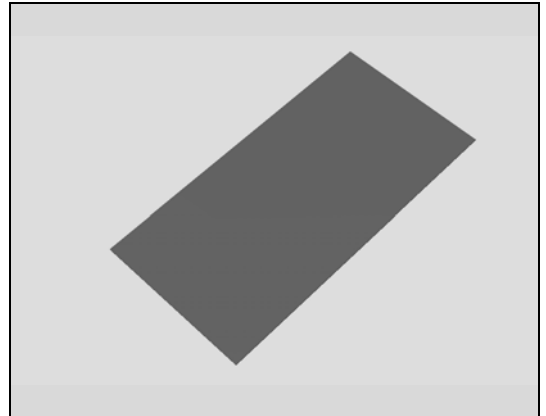
*Follow the 3.2 and 3.10-3.12 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new MComp Sheet 54!*

*Carry out the Installation as described below!*

*Follow the 5.1-5.3 and 5.11 Reassembly instructions!*



#### REMOVAL

Remove the Mcomp Sheet 54 with a Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new MCompSheet 54 with Flex Film Assembly Tool.



## Replacement

### 4.55 MComp Sheet Cu LCD (N/A SGP311 and SGP312)

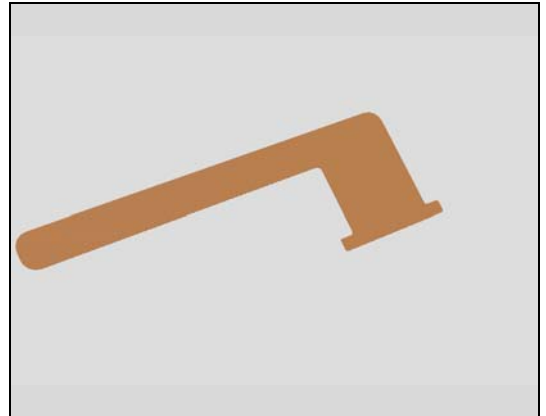
*Follow the 3.1 – 3.6 and 3.24 – 3.25 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Mcomp Sheet CU LCD!*

*Carry out the Installation as described below!*

*Follow the 5.1 - 5.2 and 5.20 – 5.25 Reassembly instructions!*



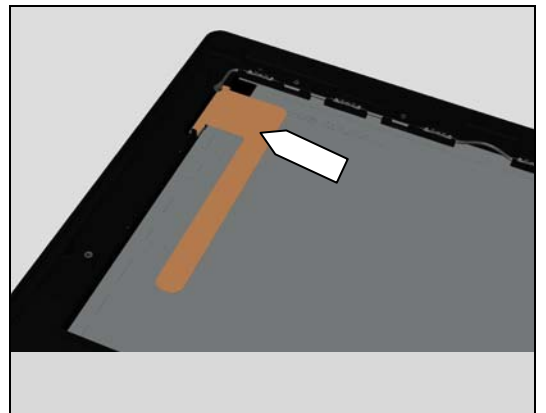
#### REMOVAL

Detach to remove the Mcomp Sheet Cu LCD with the Flex Film Assembly Tool.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Mcomp Sheet Cu LCD using a Flex Film Assembly Tool



## Replacement

### 4.56 MComp Sheet Window LCD (N/A SGP311 and SGP312)

*Follow the 3.1 – 3.6 and 3.24 – 3.25 Disassembly instructions!*

*Follow the 4.55 Removal instructions!*

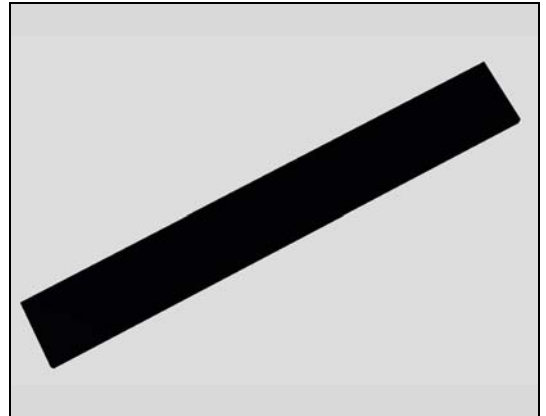
*Carry out the Removal as described below!*

*Prepare a new Mcomp Sheet CU LCD!*

*Carry out the Installation as described below!*

*Follow the 4.55 Installation instructions!*

*Follow the 5.1 - 5.2 and 5.20 – 5.25 Reassembly instructions!*



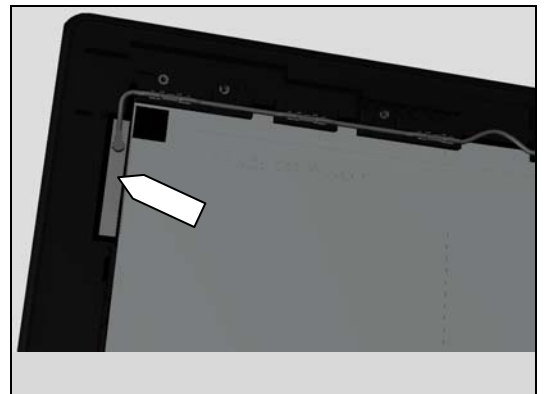
#### REMOVAL

Detach to remove the MComp Sheet Window LCD with Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new MComp Sheet Window LCD using a Flex Film Assembly Tool



## Replacement

### 4.57 MComp Sheet WP Jack

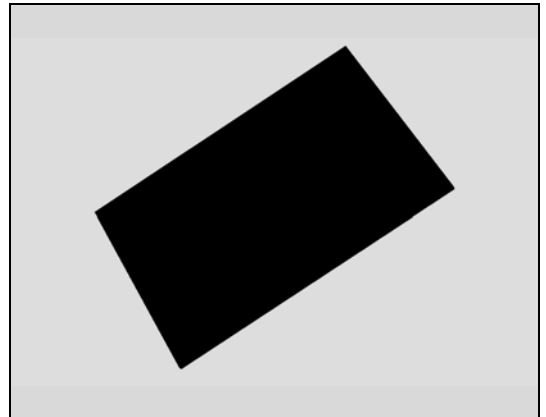
*Follow the 3.1 and 3.8 – 3.10 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new MComp Sheet WP Jack!*

*Carry out the Installation as described below!*

*Follow the 5.16 – 5.18 and 5.25 Reassembly instructions!*



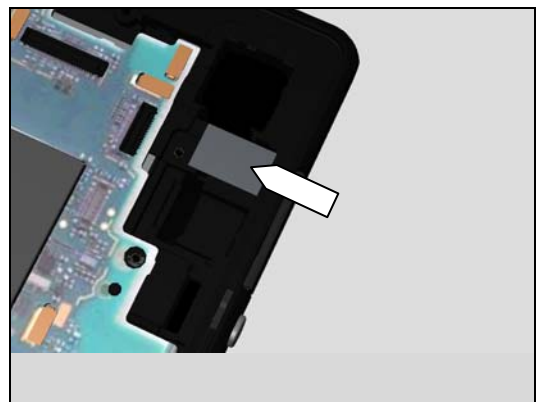
#### REMOVAL

Remove the MComp Sheet WP Jack with a Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new MComp Sheet Jack using a Flex Film Assembly Tool and press with fingers for 20 sec.



## Replacement

### 4.58 Panel Bottom

*Carry out the Removal as described below!*

*Prepare a new Panel Bottom!*

*Carry out the Installation as described below!*

#### REMOVAL

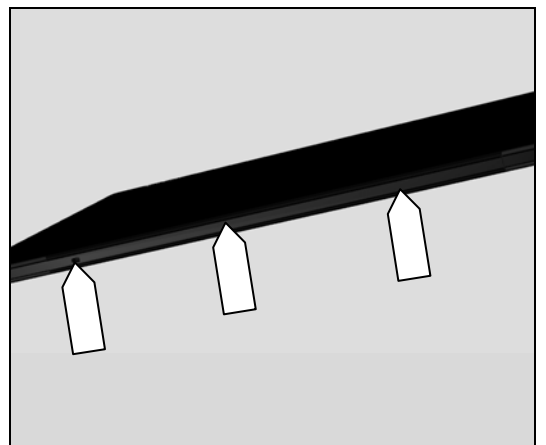
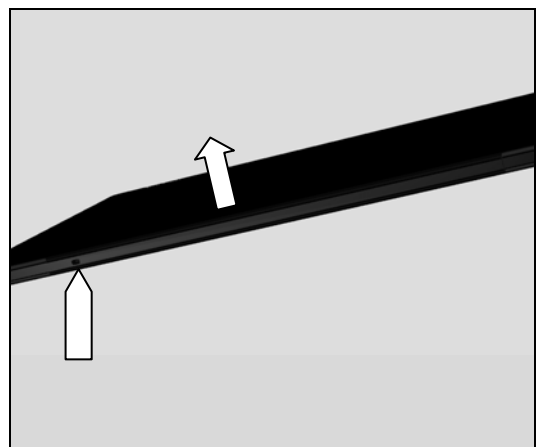
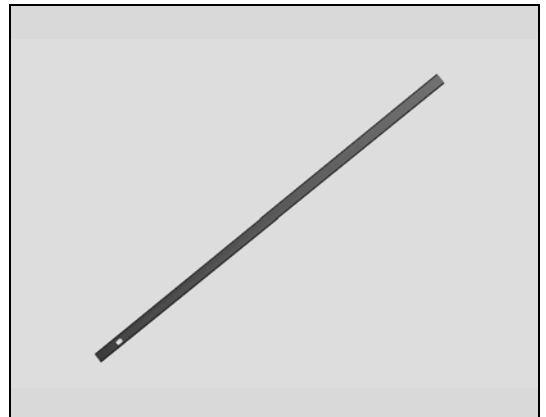
Remove the Panel Bottom with a Dentist Hook.

**Be careful not to scratch the Cover Panel Bottom for reuse!**

#### INSTALLATION

Place a new Panel Bottom with Flex Film Assembly Tool.

Use Side Panel press with the force of 80N for five seconds. Panel Bottom should be pressed three times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



## Replacement

### 4.59 Panel Top

*Carry out the Removal as described below!*

*Prepare a new Panel Top!*

*Carry out the Installation as described below!*

#### REMOVAL

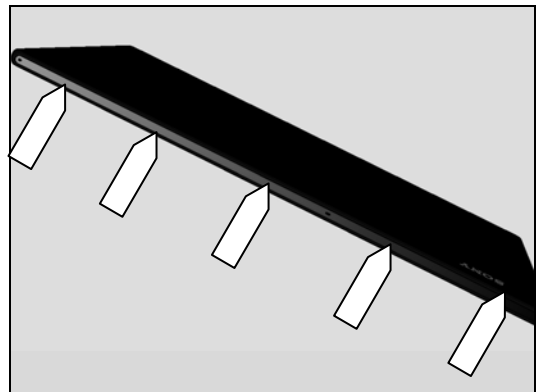
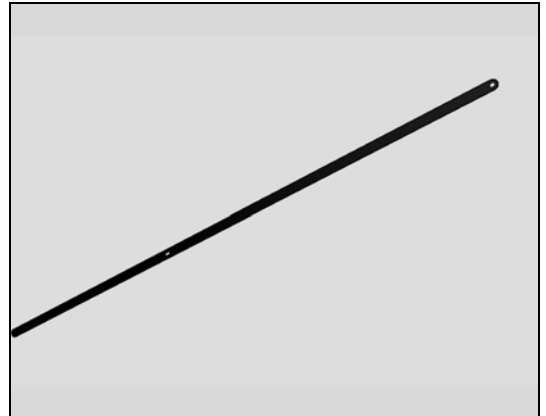
Detach to remove the Panel Top with Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Panel Top using a Flex Film Assembly Tool

Use Side Panel press with the force of 80N for five seconds. Panel Top should be pressed five times (see arrows) according to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



## Replacement

### 4.60 Plate Antenna Main (N/A SGP311 and SGP312)

*Follow the 3.1 and 3.24 Disassembly instructions!*  
*Carry out the Removal as described below!*  
*Prepare a new Plate Antenna Main!*  
*Carry out the Installation as described below!*  
*Follow the 4.51 Installation instructions!*  
*Follow the 5.2 and 5.25 Reassembly instructions!*

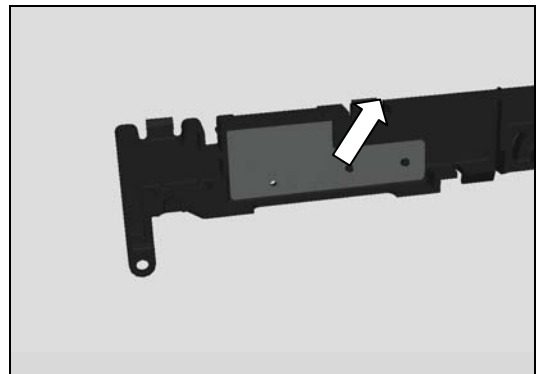
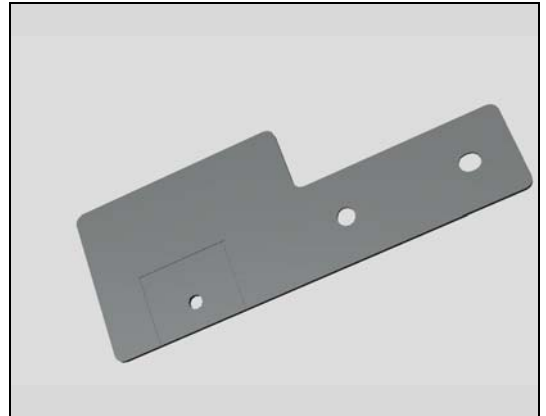
#### REMOVAL

Remove the Plate Antenna Main with Flex Film Assembly Tool.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Plate Antenna with fingers



## Re-Assembly

### 4.61 Plate Cap SIM

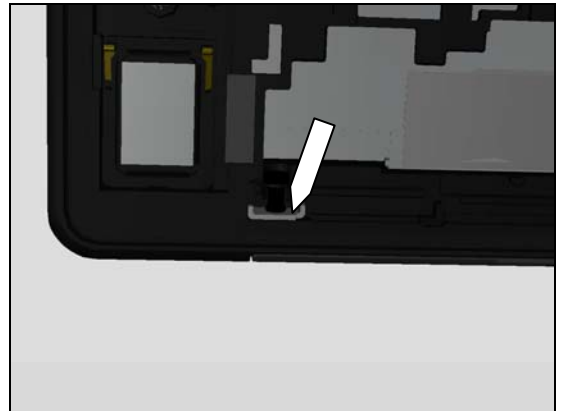
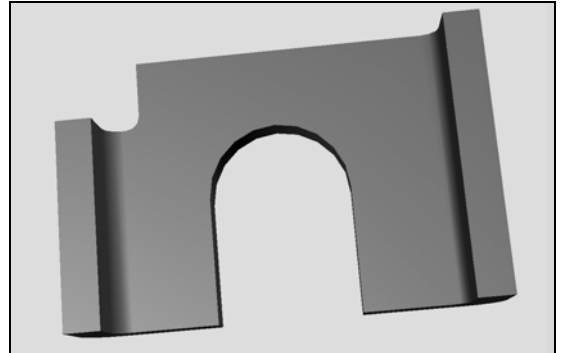
*Follow the 3.1 and 3.20 – 3.21 Disassembly instructions!*  
*Carry out the Removal as described below!*  
*Prepare a new Plate Cap SIM!*  
*Carry out the Installation as described below!*  
Follow the 5.5 – 5.6 and 5.25 Reassembly instructions!

#### REMOVAL

Remove the Plate Cap SIM with a pair of tweezers.

#### INSTALLATION

Place a new Plate Cap SIM with a pair of tweezers.





## Replacement

### 4.62 RF Cable (N/A SGP311 and SGP312)

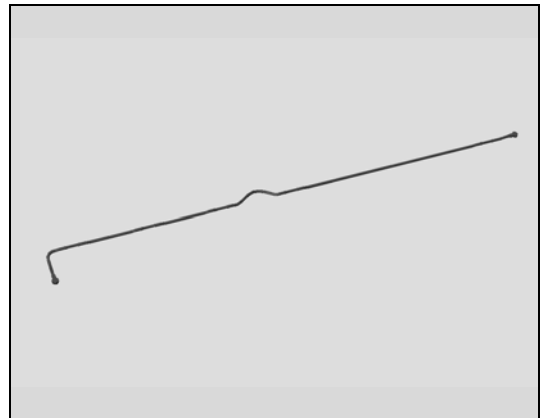
*Follow the 3.1 – 3.6 and 3.24 – 3.25 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new RF Cable!*

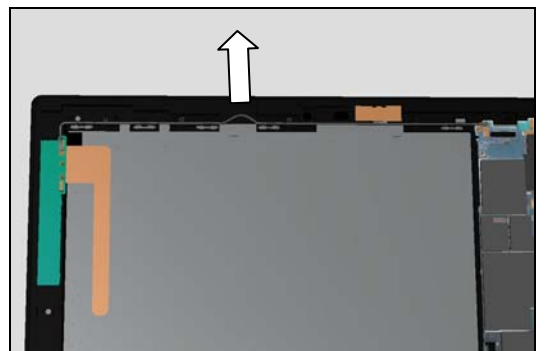
*Carry out the Installation as described below!*

*Follow the 5.1-5.2 and 5.20 – 5.25 Reassembly instructions!*



#### REMOVAL

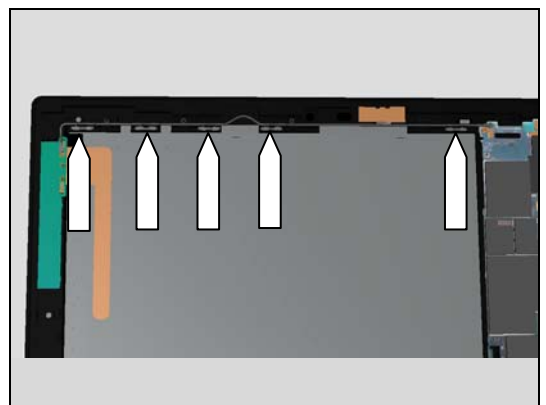
Remove the RF Cable with fingers.



#### INSTALLATION

Place a new RF Cable using a Flex Film Assembly Tool.

**Note!** Important that the silver parts of the RF Cable is placed in the five sockets.



## Replacement

### 4.63 Sheet B to B back

*Follow the 3.1 – 3.5 and 3.7 -3.18 Disassembly instructions!*

*Follow the 4.25 Removal instructions!*

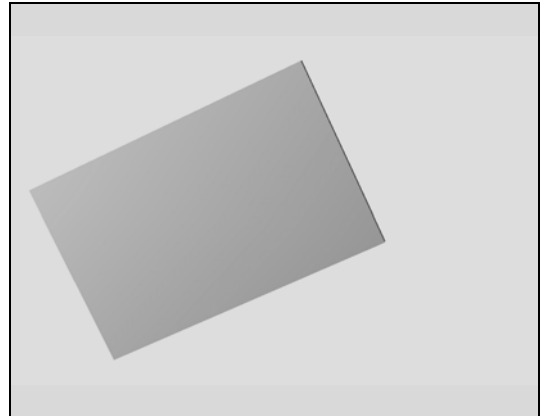
*Carry out the Removal as described below!*

*Prepare a new Sheet B to B back!*

*Carry out the Installation as described below!*

*Follow the 4.25 Installation instructions!*

*Follow the 5.8 – 5.19 and 5.21–5.25 Reassembly instructions!*



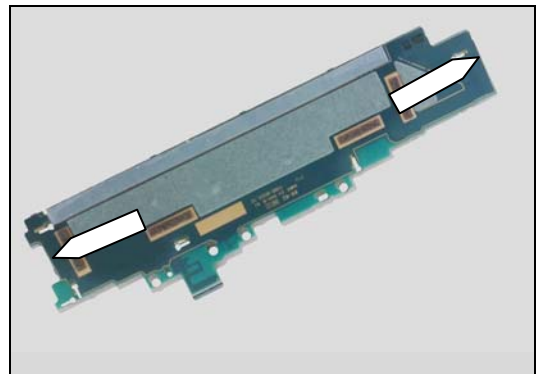
### REMOVAL

Remove the Sheet B to B back with a Dentist Hook.

**Scrap! Not to be reused!**

### INSTALLATION

Place a new Sheet B to B back using a Flex Film Assembly Tool



## Replacement

### 4.64 Sheet Graphite Panel Rear

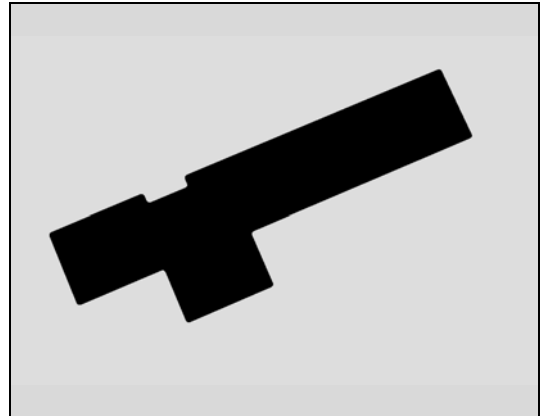
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Sheet Graphite Panel Rear!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*



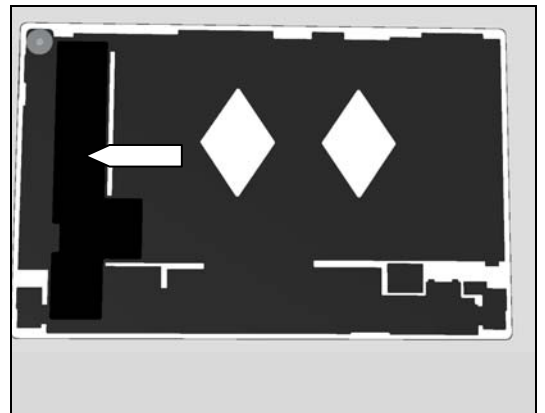
#### REMOVAL

Remove the Sheet Graphite Panel Rear with a pair of tweezers.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Sheet Graphite Panel Rear using a Flex Film Assembly Tool



## Replacement

### 4.65 Sheet Insulation Battery

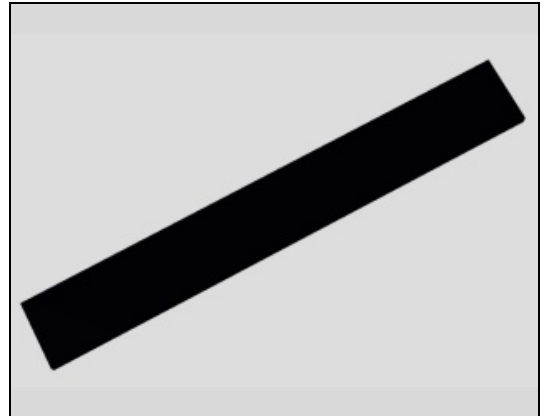
*Follow the 3.1 – 3.6 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Sheet Insulation Battery!*

*Carry out the Installation as described below!*

*Follow the 5.20 – 5.25 Reassembly instructions!*



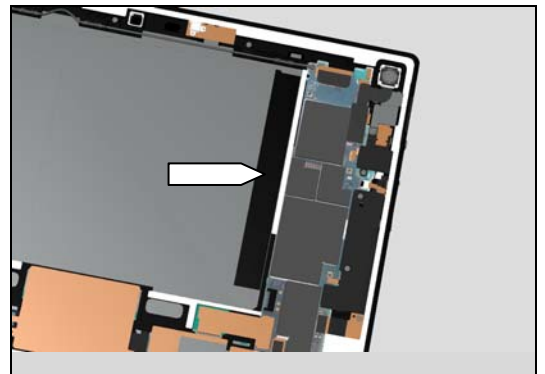
#### REMOVAL

Remove the Sheet Insulation Battery with a Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Sheet Insulation Battery using a Flex Film Assembly Tool



## Replacement

### 4.66 Sheet Insulation Cell

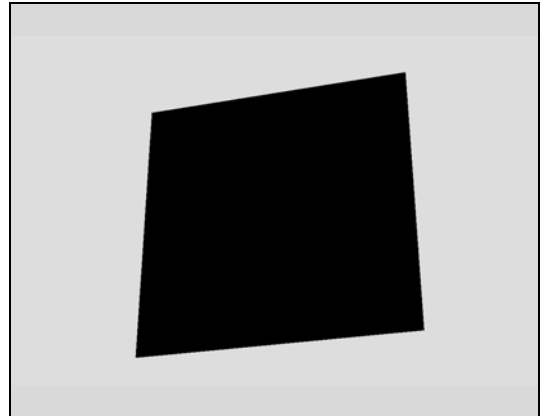
*Follow the 3.1 – 3.6 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Sheet Insulation Cell!*

*Carry out the Installation as described below!*

*Follow the 5.20 – 5.25 Reassembly instructions!*



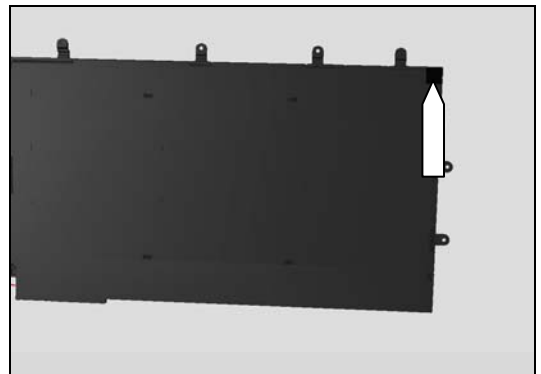
#### REMOVAL

Remove the Sheet Insulation Cell with a Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Sheet Insulation Cell using a Flex Film Assembly Tool



## Replacement

### 4.67 Spacer MIC

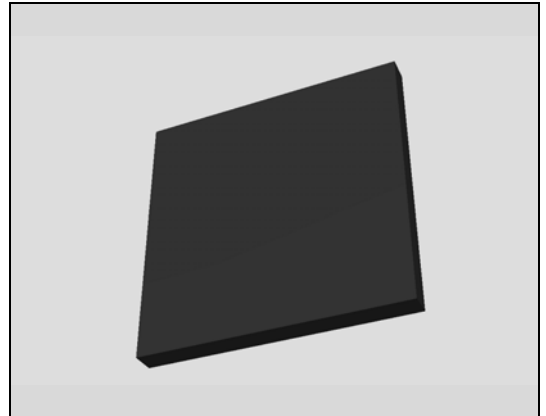
*Follow the 3.1 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Spacer MIC!*

*Carry out the Installation as described below!*

*Follow the 5.25 Reassembly instructions!*



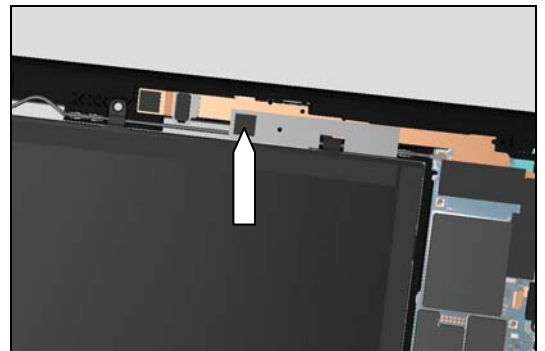
#### REMOVAL

Remove the Spacer MIC with a Dentist Hook.

**Scrap! Not to be reused!**

#### INSTALLATION

Place a new Spacer PIC using a Flex Film Assembly Tool



## Replacement

### 4.68 Spacer SIM Wifi (N/A SGP321, SGP341 and SGP351)

*Follow the 3.2, 3.7 and 3.10-3.12 Disassembly instructions!*

*Follow the 4.21 Removal instructions!*

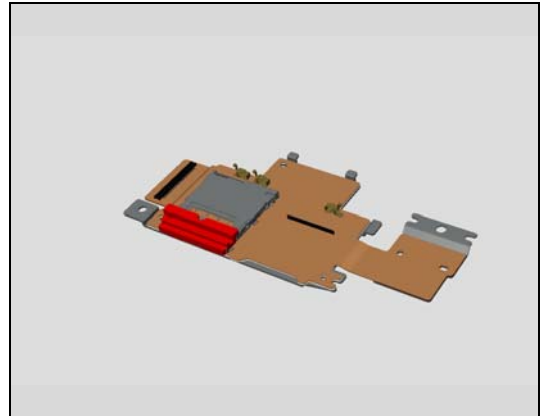
*Carry out the Removal as described below!*

*Prepare a new Spacer SIM Wifi!*

*Carry out the Installation as described below!*

*Follow the 4.21 Installation instructions!*

*Follow the 5.1-5.3, 5.6 and 5.11 Reassembly instructions!*

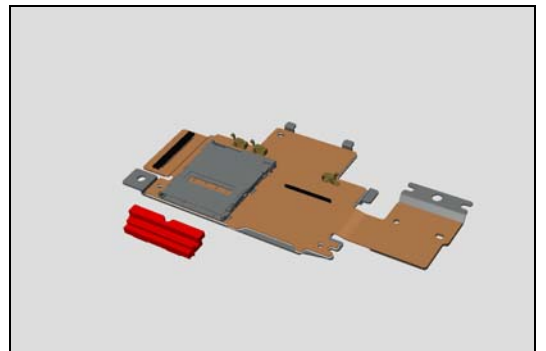


#### REMOVAL

Remove the Space SIM Wifi with fingers.

#### INSTALLATION

Place a new Space SIM Wifi with fingers.



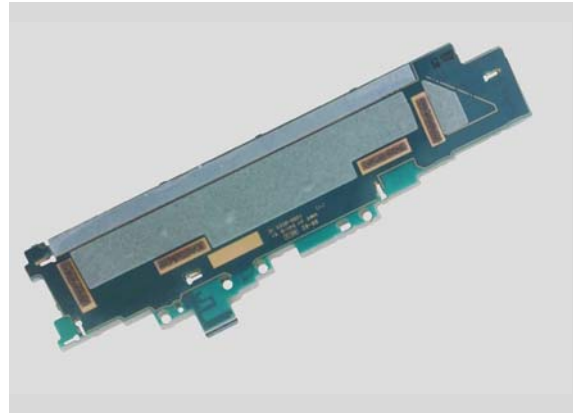
## Replacement

### 4.69 Board Swap - Replacement

*Follow the 3.1 – 3.5 and 3.7 -3.18 Disassembly instructions!*

**Reuse the Main Camera and Chat Camera**

Replace the Swap Board.



Follow the 5.8 – 5.19 and 5.21–5.25 Reassembly Press the Key On/Off to power on the tablet, place unit on flat desk and wait 4 minutes until system boot up has been completed.

**Please DO NOT move the tablet during starting up until “Select Language” menu is shown on the display!**

After “Select Language” menu, turn off the tablet.

**Follow the Calibration chapter 3.1 and 3.2 in 1274-7274**

**Test Instruction – mechanical**

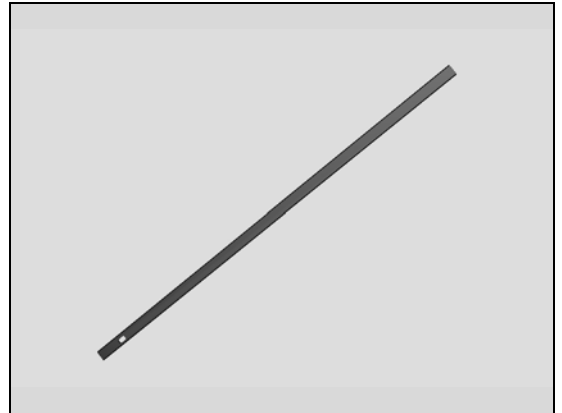


## Replacement

### 4.70 Board Swap – Change Label

#### CHANGE COVER PANEL BOTTOM

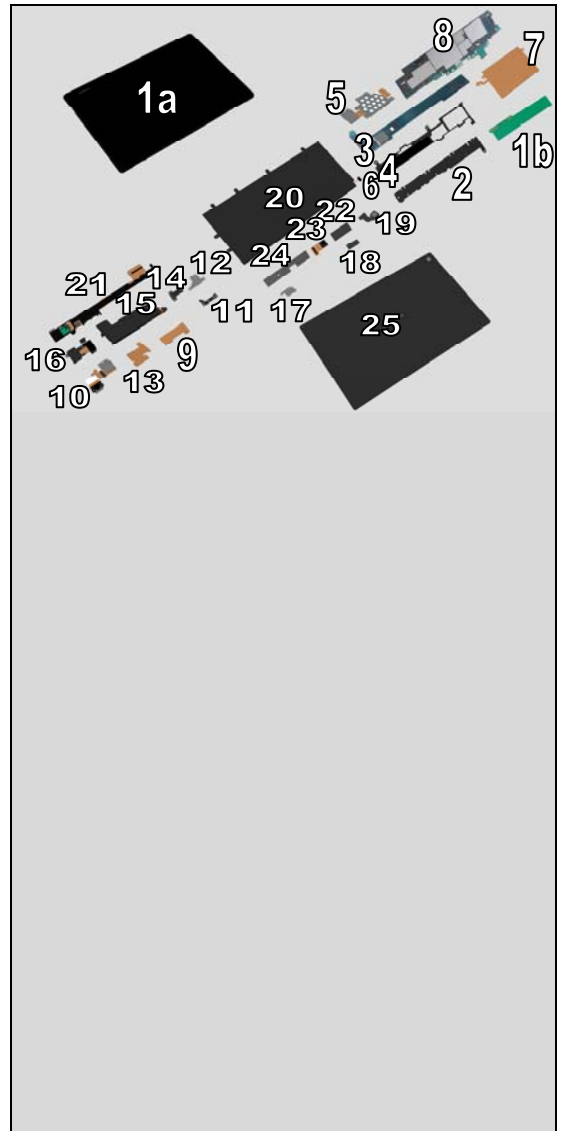
Follow the instructions in the 1221-5655 Generic Repair Manual – Build swap for change of label.



## 5 Re-Assembly

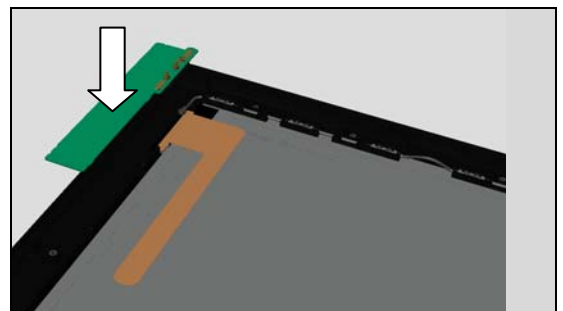
The Re-assembly is done to the following modules:

1. Front Assembly (a) and PBA Antenna LTE (b) (N/A for SGP311 and SGP312)
2. Carrier Antenna Main
3. PBA Complete Sub
4. Frame Sub PBA
5. FPC Assembly SIM
6. SIM Tray (N/A for SGP311 and SGP312)
7. NFC antenna
8. Main PBA
9. FPC Assembly Relay LCD PBA
10. FPC Assembly USB PBA
11. Carrier Holder USB
12. Plate USB
13. FPC Assembly Relay SUB PBA
14. FPC Assembly Charge PBA
15. Diversity antenna
16. GPS antenna
17. Plate FPC Audio Jack
18. Sheet Jack K
19. Main Camera
20. Battery
21. FPC Assembly Top PBA
22. Sheet FPC TOP
23. Chat Camera
24. Sheet Magnetic Top
25. Back Panel Assy

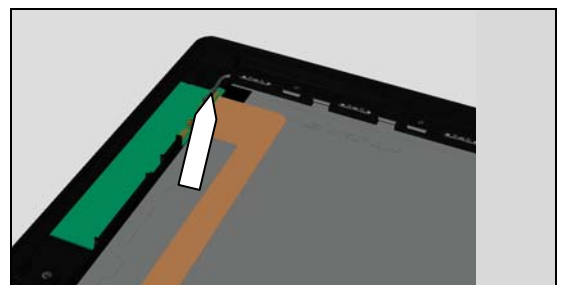


### 5.1 Front Assembly and PBA Antenna LTE (N/A for SGP311 and SGP312)

Place the PBA Antenna LTE into the cavity



Press with fingers to secure position of PBA Antenna LTE and connect RF Cable



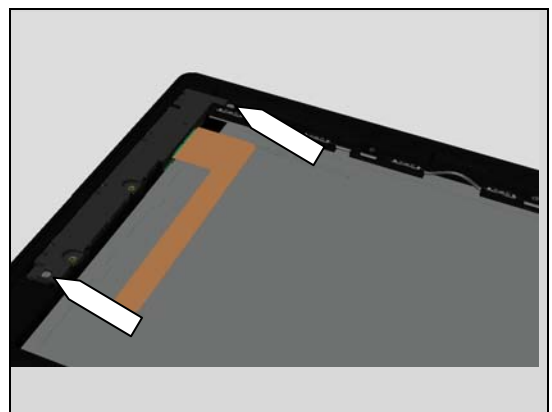
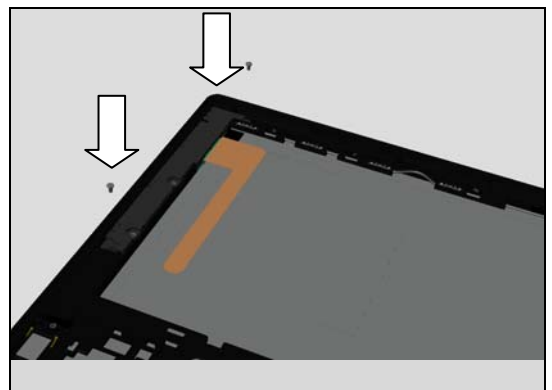
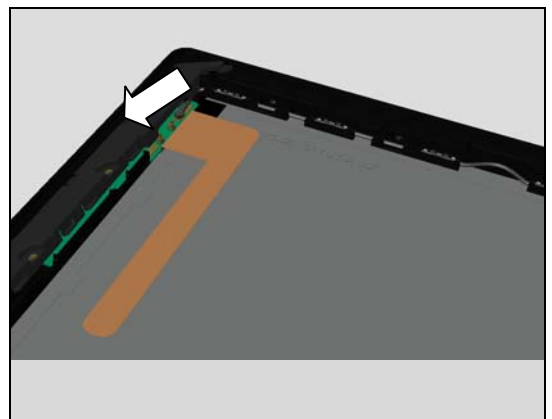
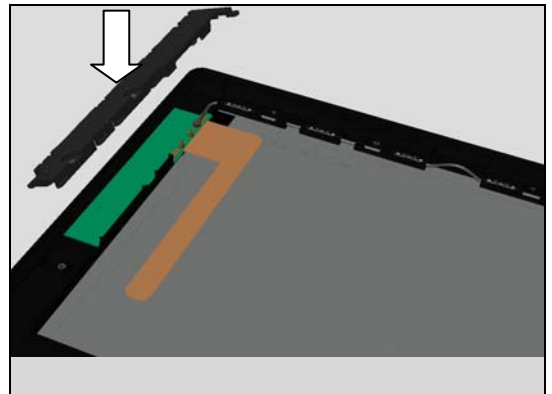
## Re-Assembly

### 5.2 Carrier Main Antenna

Place the Carrier Main Antenna with fingers

Position Carrier Main Antenna gently into the cavity

Apply 13 Ncm torque when tightening Screw Other Len:2.6  
Diam:1.4 with Bits (JCIS No 0).



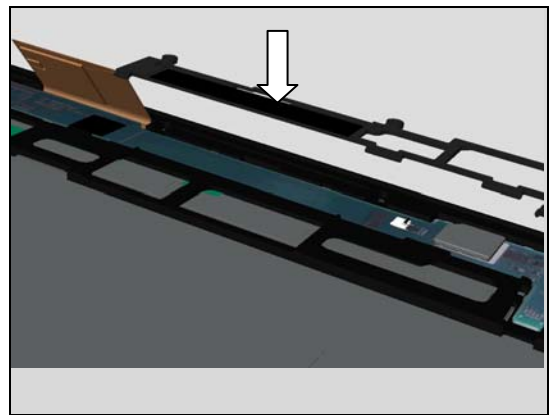
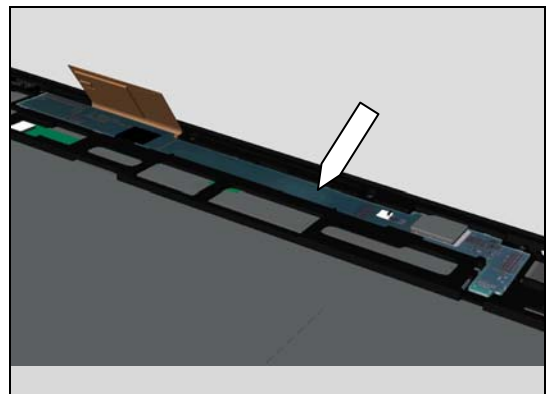
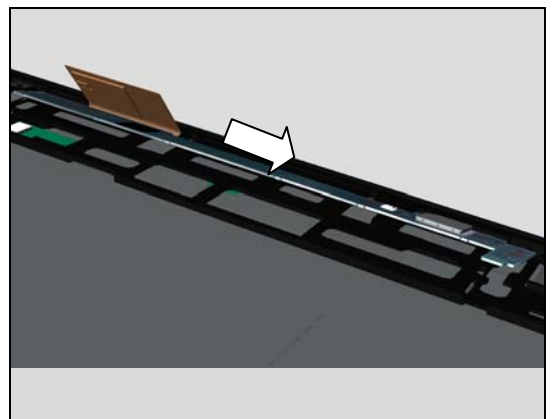
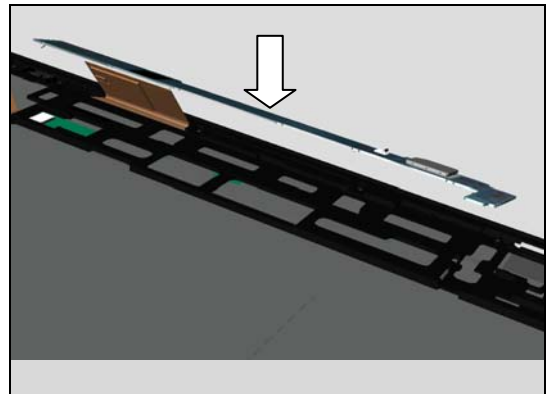
## Re-Assembly

### 5.3 PBA Complete Sub

Place PBA Complete Sub on the Front Assembly.

Position the PBA Complete Sub with fingers.

Secure PBA Complete Sub position using fingers



### 5.4 Frame Sub PBA

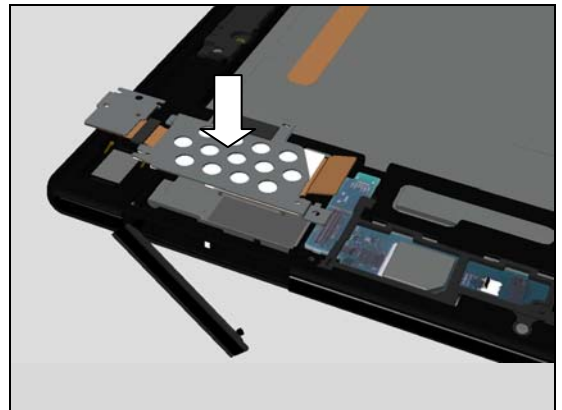
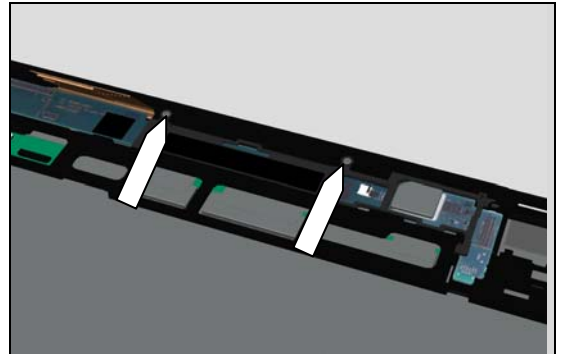
Place the Frame Sub PBA on the PBA Complete Sub with fingers

## Re-Assembly

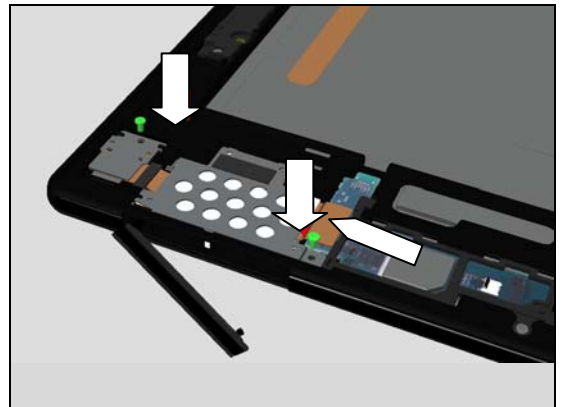
Apply 13 Ncm torque when tightening Screw Other Len:2.6  
Diam:1.4with Bits (JCIS No 0).

### 5.5 FPC Assembly SIM

Place the FPC Assembly SIM into the cavity

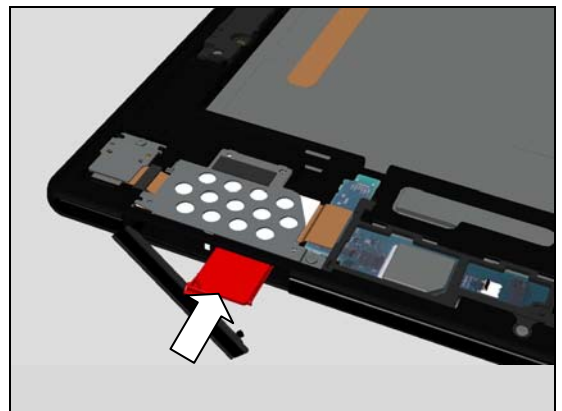


Press with fingers to secure the contact of BtB connector  
and apply 13 Ncm torque when tightening Screw Other  
Len:2.6 Diam:1.4 with Bits (JCIS No 0).



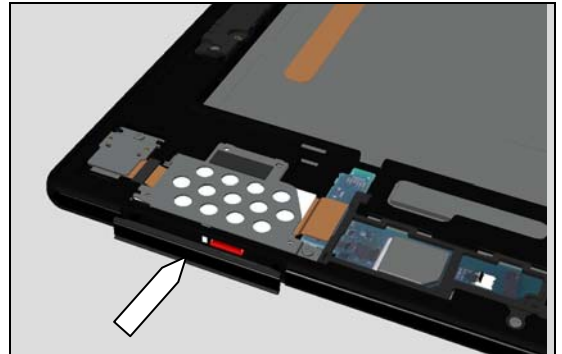
### 5.6 SIM Tray (N/A for SGP311 and SGP312)

Place the SIM Tray in the SIM card slot with fingers



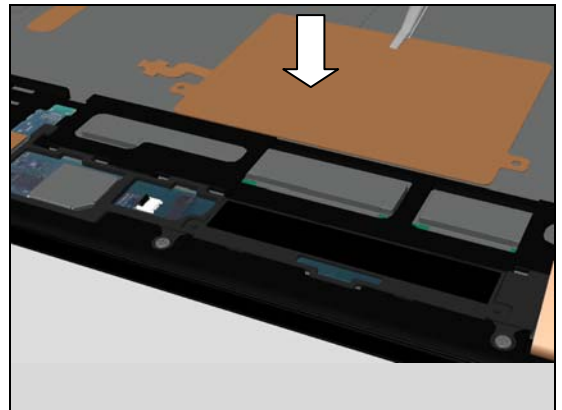
## Re-Assembly

Close Cap SIM Assembly

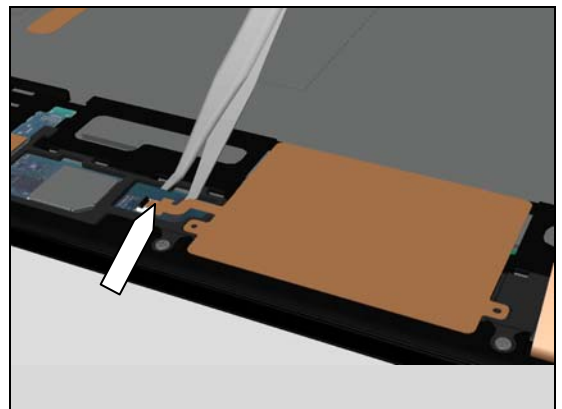


### 5.7 NFC antenna

Place NFC antenna on Frame Sub PBA using a Flex Film Assembly Tool.

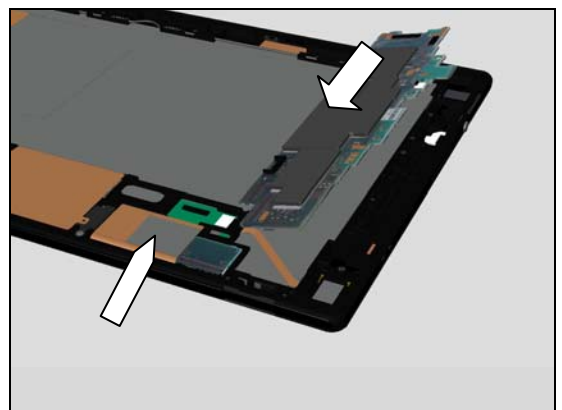


Use Flex Film Assembly Tool for secure the flex into the zif contact and close the zif contact.



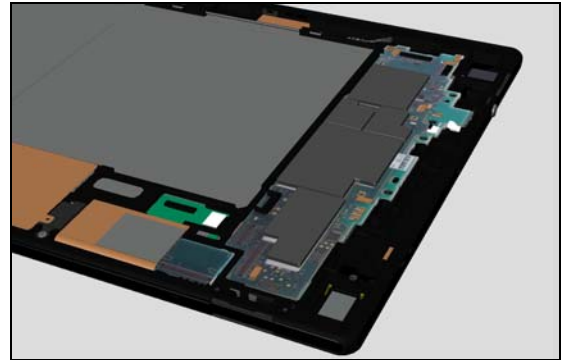
### 5.8 Main PBA

Fold down the LCD flex and connect BtB connector with fingers. Then place the Main PBA into the cavity

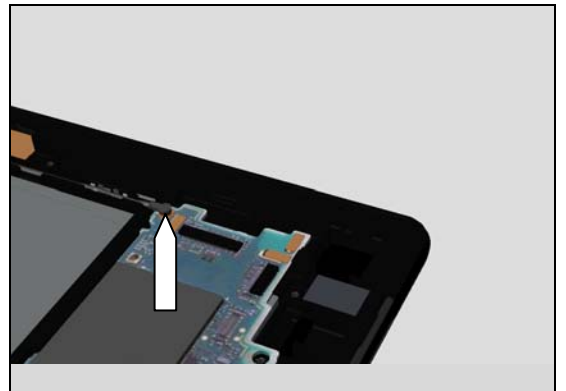
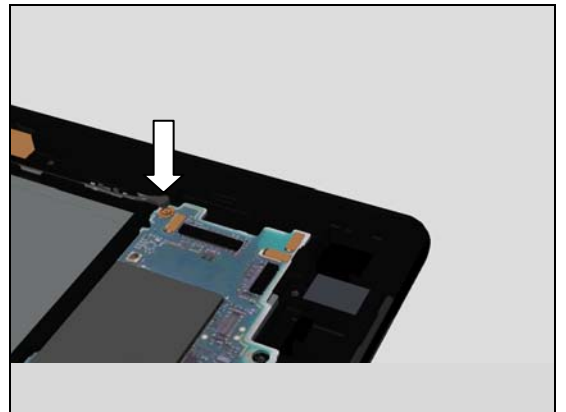


## Re-Assembly

Position the Main PBA with fingers

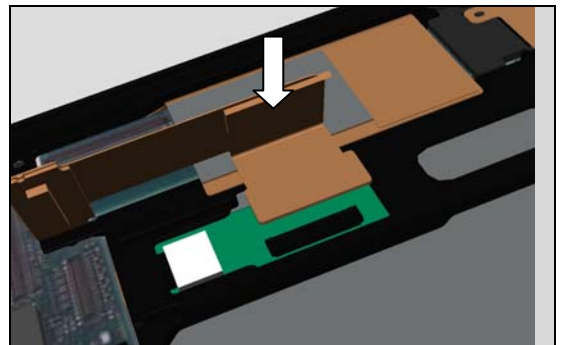


Press with fingers to secure the contact of RF Cable (N/A for SGP311 and SGP312)



## 5.9 FPC Assembly Relay LCD PBA

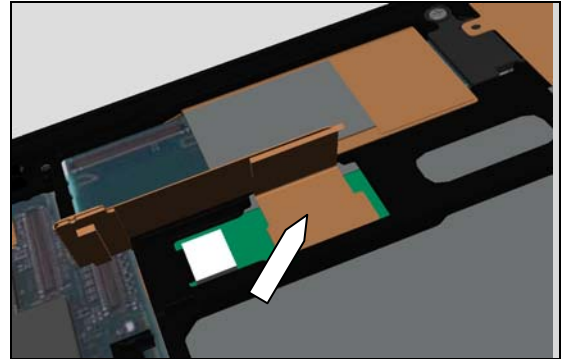
Place the FPC Assembly Relay LCD PBA with fingers



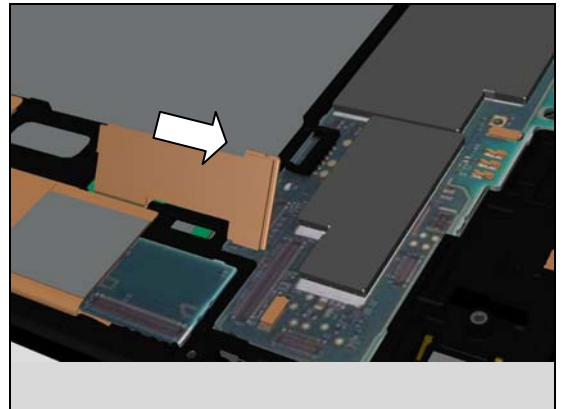


## Re-Assembly

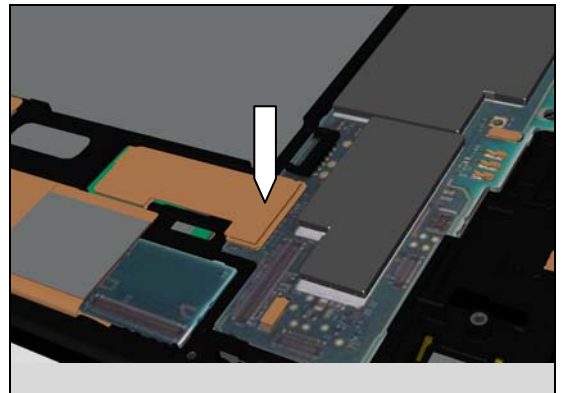
Press with fingers to secure the contact of BtB connector.



Fold over the FPC Assembly Relay LCD PBA

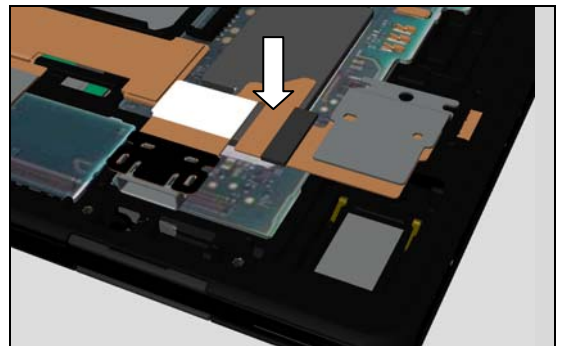


Press with fingers to secure the contact of BtB connector.



### 5.10 FPC Assembly USB PBA

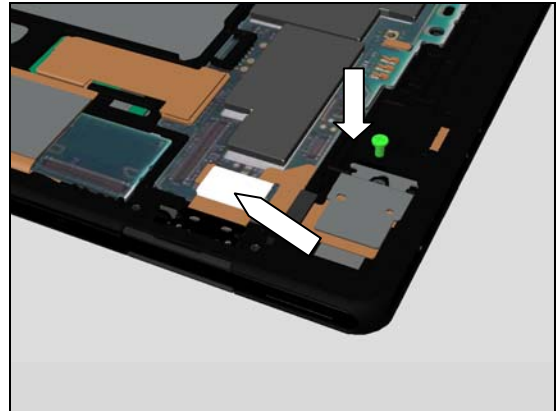
Place the FPC Assembly USB PBA into cavity





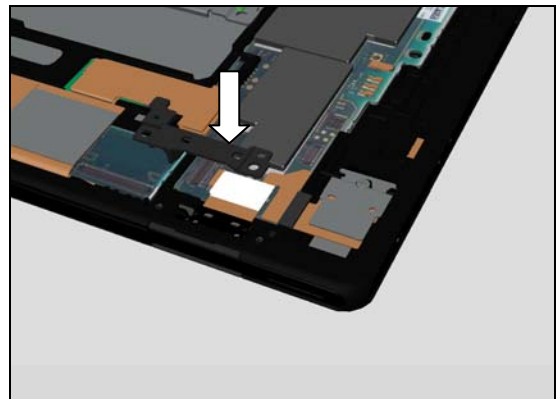
## Re-Assembly

Press with fingers to secure the contact of BtB connector and apply 13 Ncm torque when tightening Screw Other Len:2.6  
Diam:1.4with Bits (JCIS No 0).

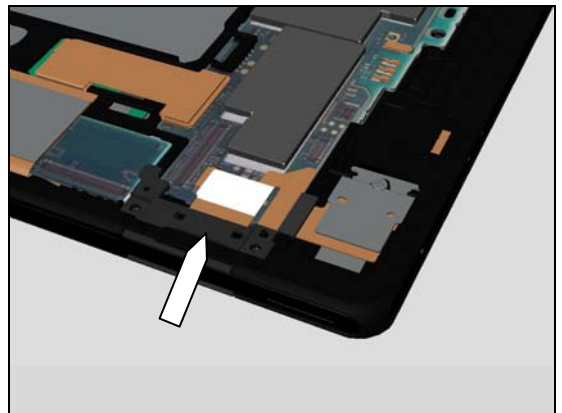


### 5.11 Carrier Holder USB

Place the Carrier Holder USB on FPC Assembly USB PBA

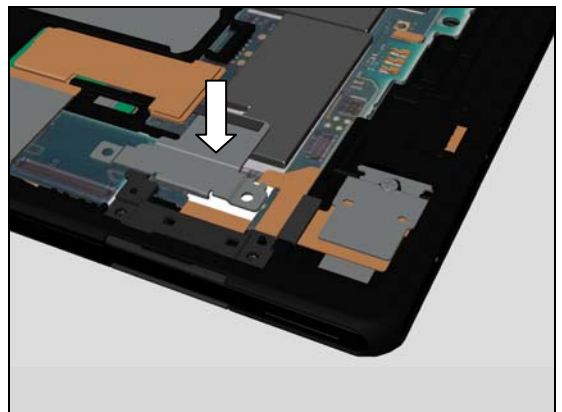


Position Carrier Holder USB with fingers



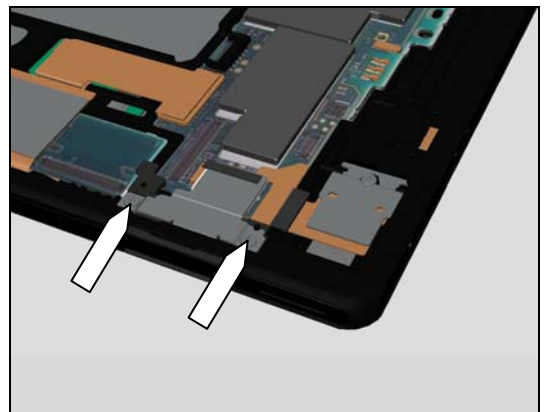
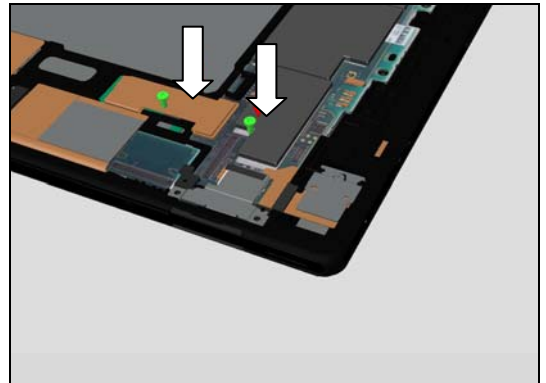
### 5.12 Plate USB

Place the Plate USB on Carrier Holder USB



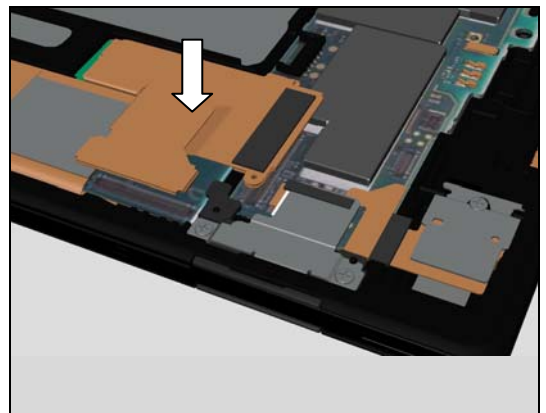
## Re-Assembly

Apply 13 Ncm torque when tightening Screw Other Len:2.6  
Diam:1.4with Bits (JCIS No 0).

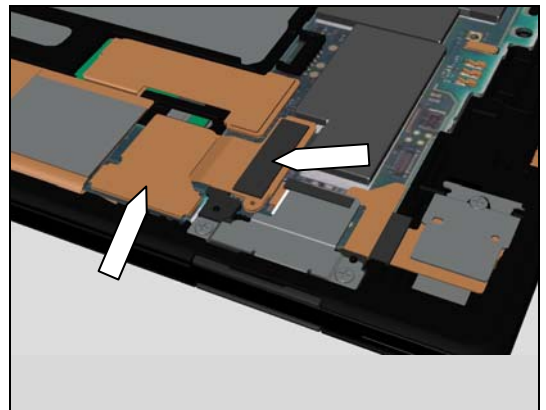


### 5.13 FPC Assembly SUB PBA

Place the FPC Assembly SUB PBA into position



Press with fingers to secure the contacts of BtB connectors.

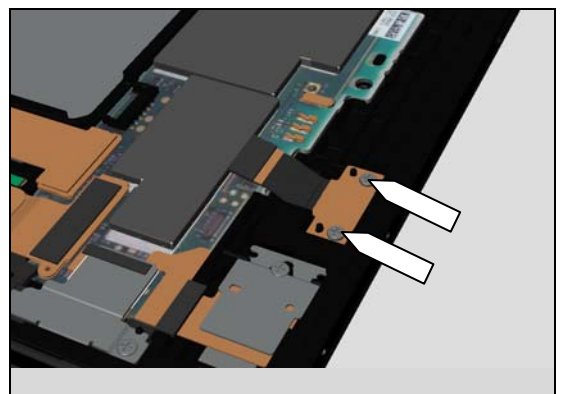
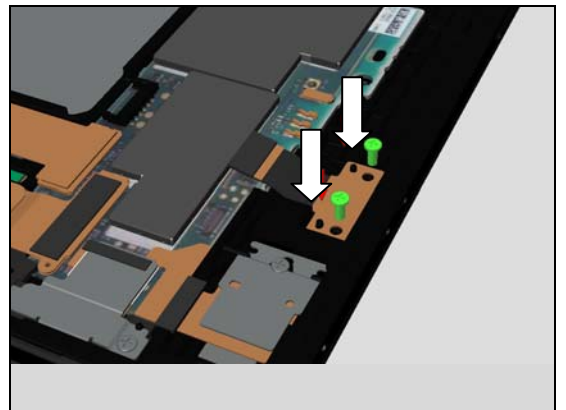
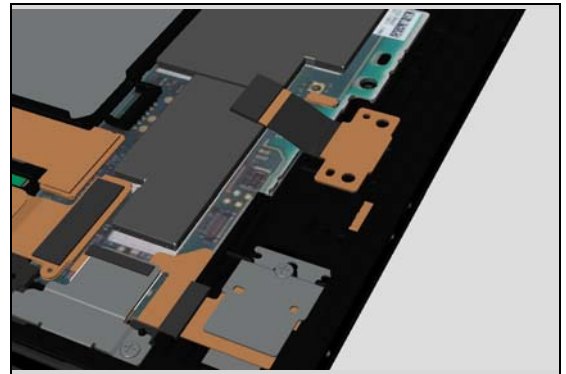


## Re-Assembly

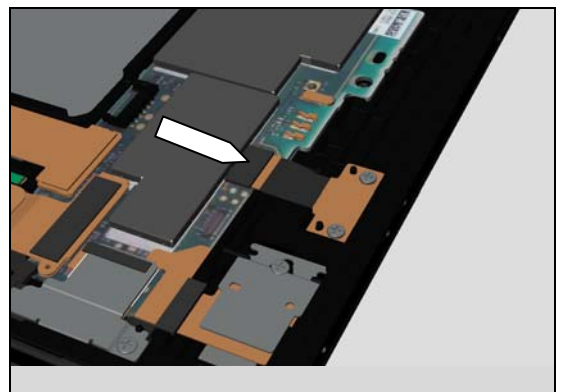
### 5.14 FPC Assembly Charge PBA

Place the FPC Assembly Charge PBA into cavity

Apply 18 Ncm torque when tightening Screw Other Len:3.4  
Diam:1.4 with Bits (JCIS No 0).



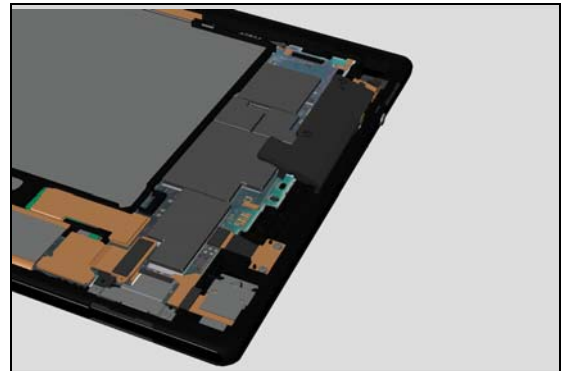
Press with fingers to secure the contact of BtB connector



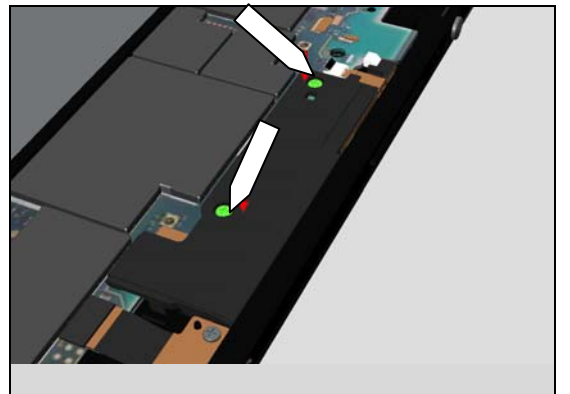
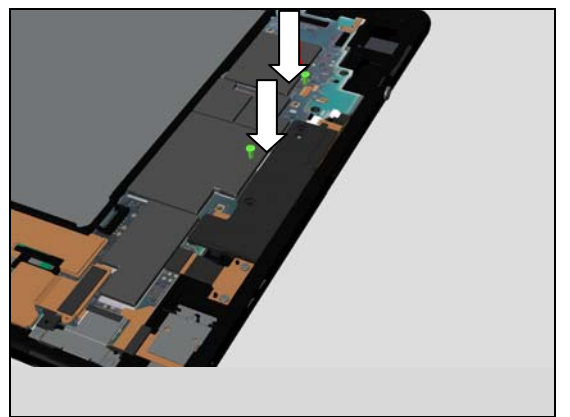
## Re-Assembly

### 5.15 Diversity antenna

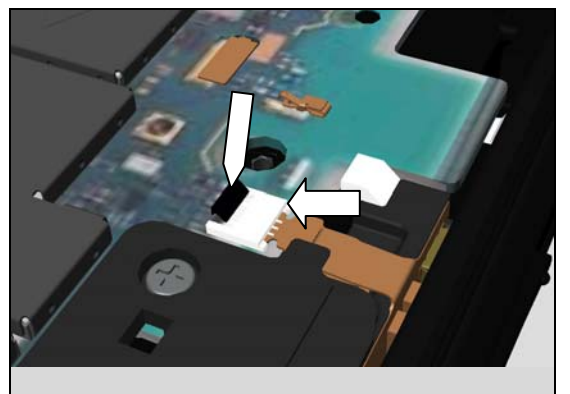
Place the Diversity antenna into cavity



Apply 13 Ncm torque when tightening Screw Other Len:3.0  
Diam:1.4 with Bits (JCIS No 0).



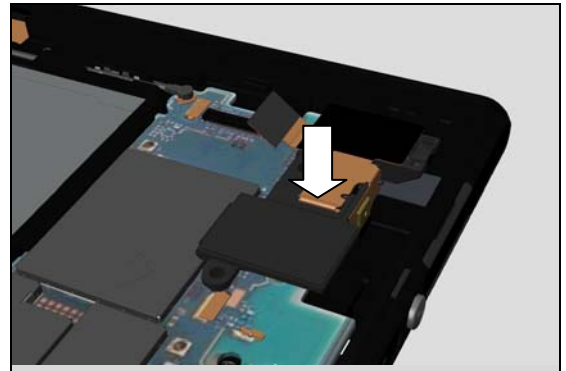
Use Flex Film Assembly Tool for secure the flex into the zif contact and close the zif contact.



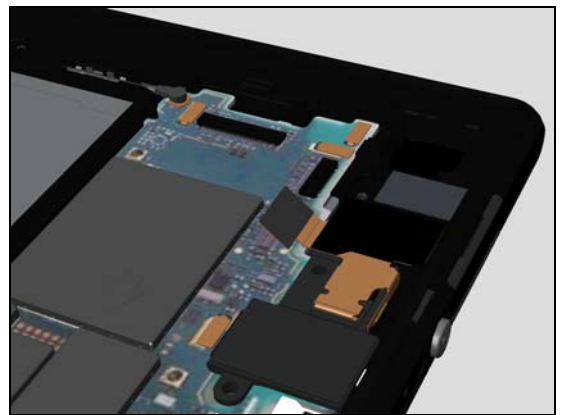
## Re-Assembly

### 5.16 GPS antenna

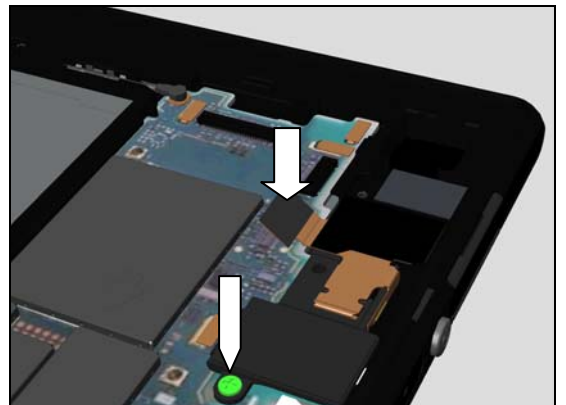
Place the GPS antenna into the cavity



Secure position with fingers

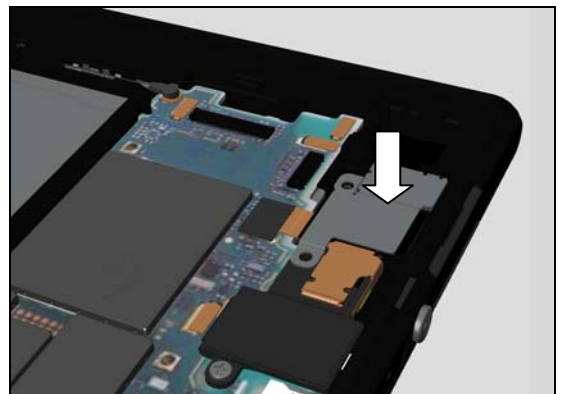


Apply 13 Ncm torque when tightening Screw Other Len:3.0  
Diam:1.4 with Bits (JCIS No 0) and press with fingers to  
secure the contact of BtB connector



### 5.17 Plate FPC Audio Jack

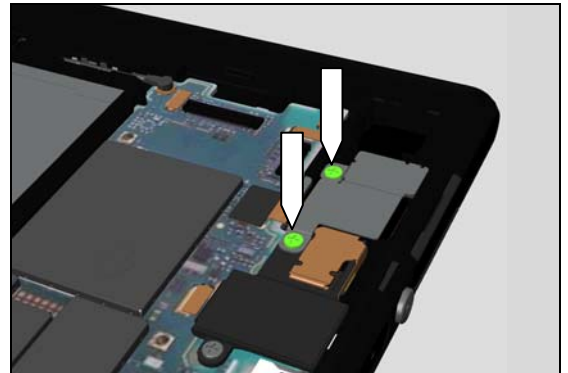
Place Plate FPC Audio Jack on GPS antenna





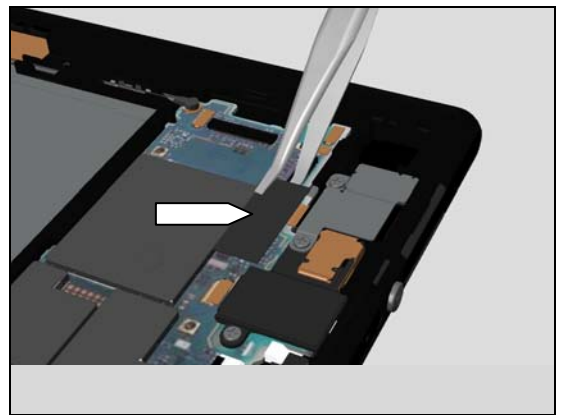
## Re-Assembly

Apply 13 Ncm torque when tightening Screw Other Len:3.0  
Diam:1.4 with Bits (JCIS No 0)



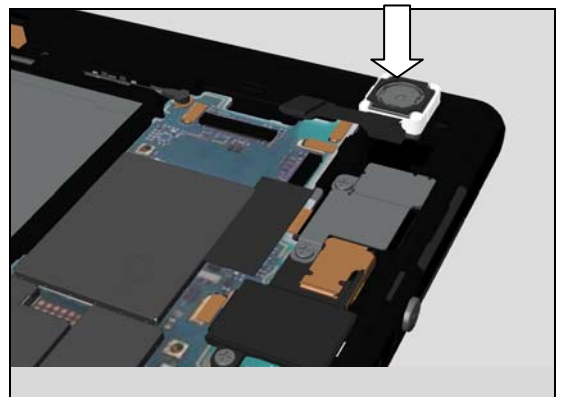
### 5.18 Sheet Jack K

Place the Sheet Jack K with a Flex Film Assembly Tool.

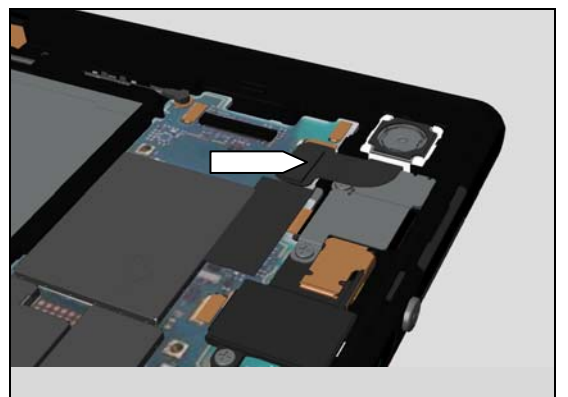


### 5.19 Main Camera

Place the Main Camera into the cavity



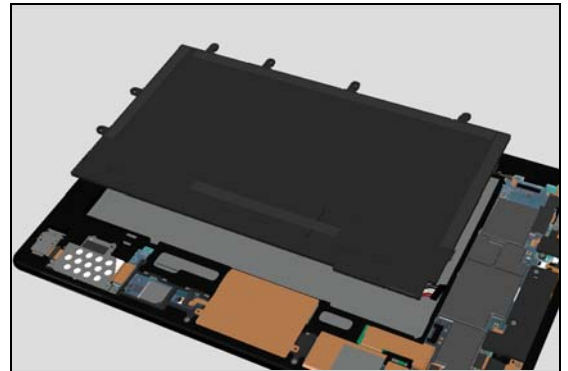
Press with fingers to secure the contact of BtB connector



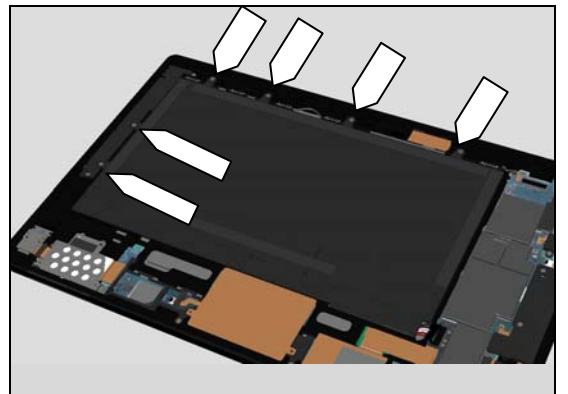
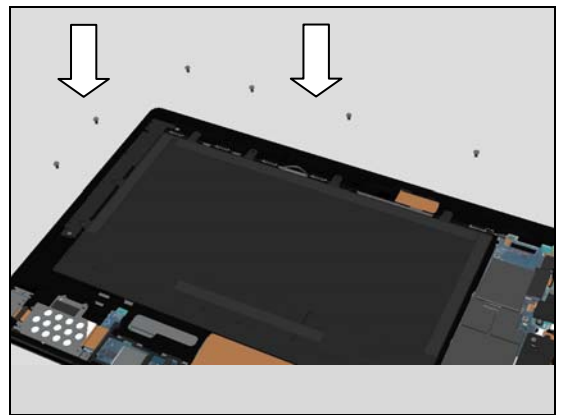
## Re-Assembly

### 5.20 Battery

Place the Battery into the cavity

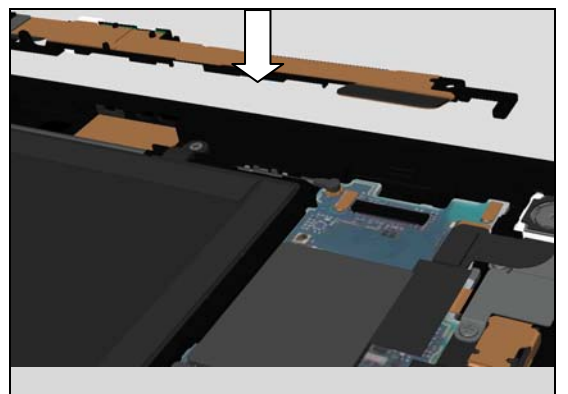


Apply 13 Ncm torque when tightening the Screw Other  
Len:2.6 Diam:1.4 with Bits (JCIS No 0).



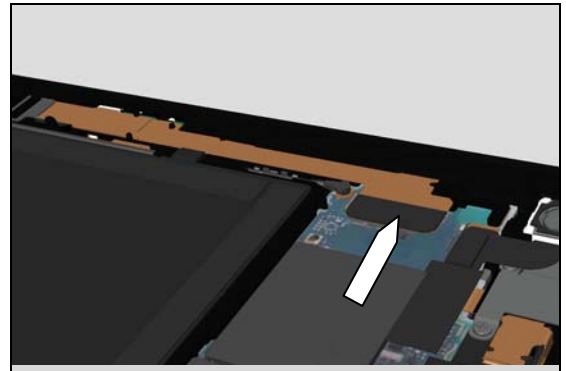
### 5.21 FPC Assembly Top PBA

Place the FPC Assembly Top PBA into the cavity



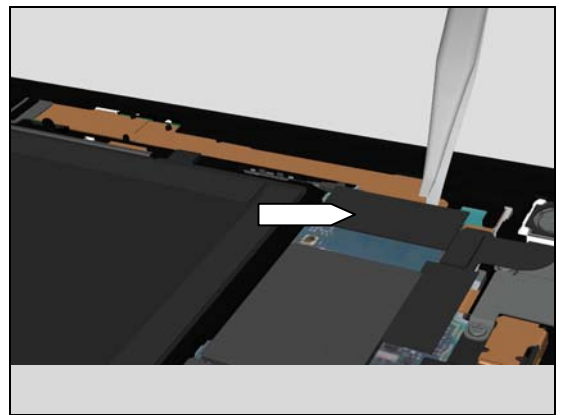
## Re-Assembly

Press with fingers to secure the contact of BtB connector.



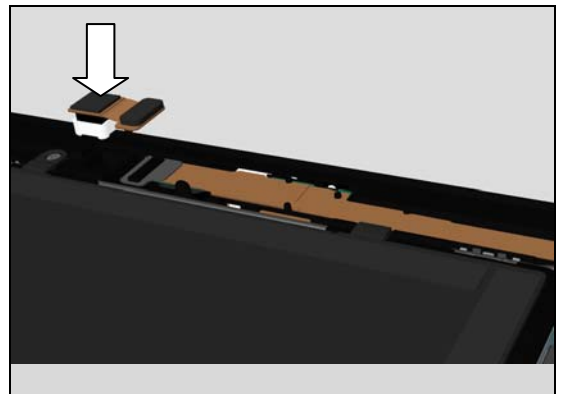
### 5.22 Sheet FPC TOP

Place the Sheet FPC TOP with Flex Film Assembly Tool.

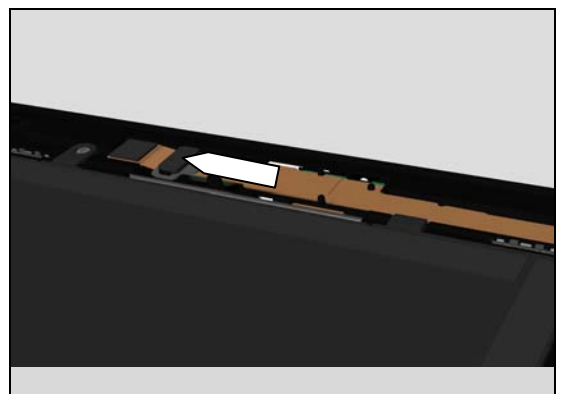


### 5.23 Chat Camera

Place the Chat Camera into the cavity



Press with fingers to secure the contact of BtB connector

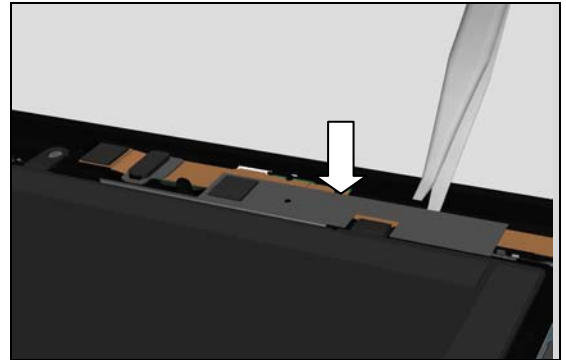




## Re-Assembly

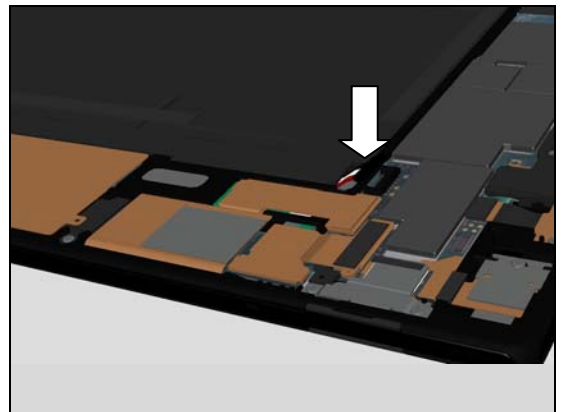
### 5.24 Sheet Magnetic Top

Place the Sheet Magnetic Top with Flex Film Assembly Tool

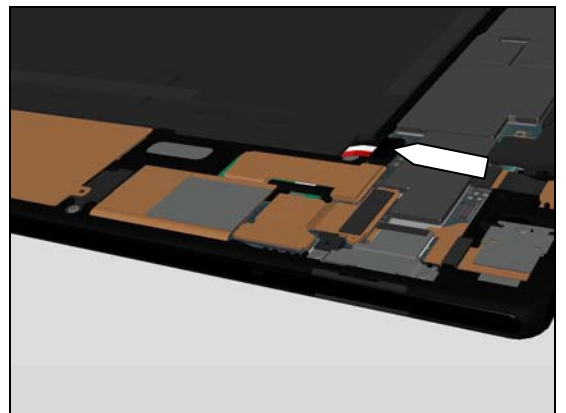


### 5.25 Back Panel Assy

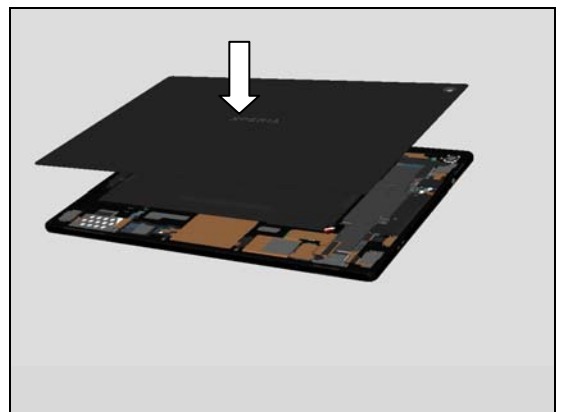
Position battery contact with fingers



Press to secure the contact of battery connector



Position Back Panel Assy using fingers



## Re-Assembly

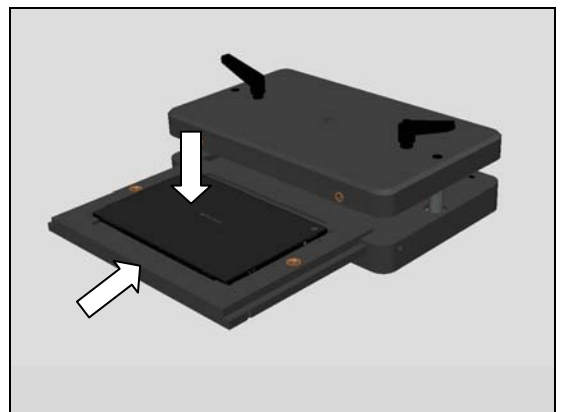
Secure Back Panel Assy position using fingers



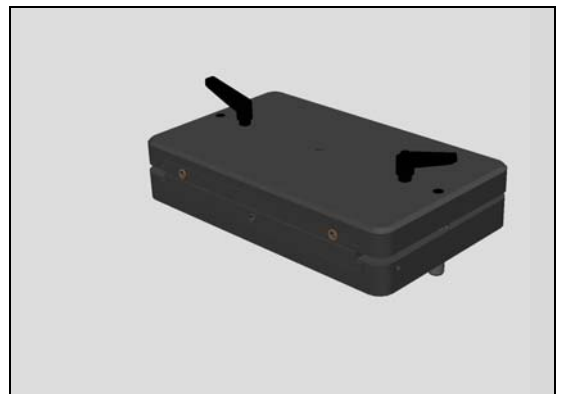
Upper inlay = Backpanel press Top Inlay

Lower inlay = Bottom Press Inlay

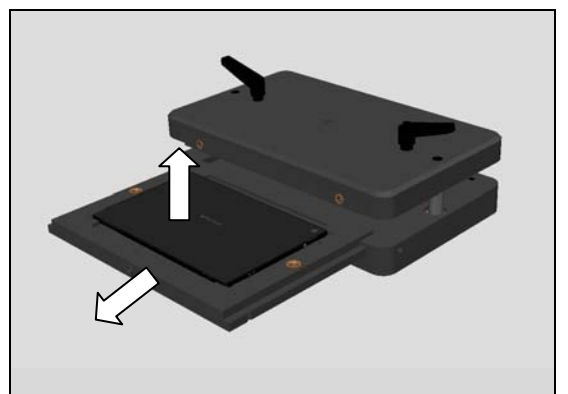
Place the tablet with Front Assy down in the Bottom Press Inlay and follow the instruction in 1003-9107 Tool Catalogue – mechanical and document Toothed Rack Press Instruction for use.



Press it with a pressure value of 883 N (+/- 10N) for 20 sec (pressure value is adjust from 1000N because of the weight of the press fixture)



Take it out



## 6 Revision History

Rev.	Date	Changes / Comments
1	2013-05-10	Initial Release