

# SONY

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## Working Instructions

- mechanical -



*Xperia™ ZR*  
**C5502, C5503 & M36h**

## CONTENTS

<b>1</b>	<b>Exterior Views.....</b>	<b>5</b>
<b>2</b>	<b>Tools .....</b>	<b>6</b>
<b>3</b>	<b>Disassembly.....</b>	<b>7</b>
	3.1 Cover Battery.....	8
	3.2 Battery 2300 mAh BA950 .....	8
	3.3 Sheet FPC Relay.....	9
	3.4 Display .....	10
	3.5 Support Plate.....	11
	3.6 Camera.....	13
	3.7 Main PBA .....	14
	3.8 RF Coax Cable.....	16
	3.9 Lightguide.....	16
	3.10 Lightguide Sheet.....	16
	3.11 Sheet Battery Side .....	17
	3.12 Holder Side Keys.....	17
	3.13 FPC Relay Assy.....	18
<b>4</b>	<b>Replacement .....</b>	<b>19</b>
	4.1 Cover Battery.....	19
	4.2 Battery 2300 mAh BA950 .....	19
	4.3 Sheet FPC Relay.....	19
	4.4 Display .....	19
	4.5 Support Plate.....	20
	4.6 Camera.....	20
	4.7 Main PBA .....	20
	4.8 RF Coax Cable.....	21
	4.9 Lightguide.....	22
	4.10 Lightguide Sheet.....	22
	4.11 Sheet Battery Side .....	22
	4.12 Holder Side Keys.....	22
	4.13 FPC Relay .....	23
	4.14 Cover Main.....	25
	4.15 Adhesive Display .....	25
	4.16 Card Connector Tray.....	26
	4.17 Cushion 2 <sup>nd</sup> MIC .....	27
	4.18 Cushion 3 x 3 mm .....	28
	4.19 Cushion 3 x 8 mm .....	29
	4.20 Cushion MIC .....	30

4.21	Cushion Window .....	31
4.22	FPC PBA NFC .....	32
4.23	FPC Top Compl .....	33
4.24	Gasket 2 <sup>nd</sup> MIC .....	35
4.25	Gasket Chat Camera .....	36
4.26	Gasket Key .....	37
4.27	Gasket Key Cam .....	38
4.28	Key Camera .....	39
4.29	Key Power .....	40
4.30	Key Volume .....	41
4.31	Label Mobile Phone .....	42
4.32	Loudspeaker & Adhesive Speaker .....	43
4.33	Net Speaker .....	44
4.34	Nut .....	45
4.35	Panel Key Power & Adhesive Panel Key Power .....	46
4.36	Panel Side L .....	47
4.37	Panel Side R Bottom .....	48
4.38	Panel Side R Top .....	49
4.39	PBA Antenna & Adhesive PBA Antenna .....	50
4.40	Sheet Magnetic NFC .....	52
4.41	Water Indicator .....	53
4.42	Washer Key Power .....	56
4.43	Board Swap - Replacement .....	57
4.44	Board Swap – Change Label .....	58
4.45	Board Swap – Customize of Software .....	59
5	Re-Assembly .....	60
5.1	FPC Relay Assy .....	61
5.2	Holder Side Keys .....	62
5.3	Sheet Battery Side .....	63
5.4	Lightguide Sheet .....	63
5.5	Lightguide .....	63
5.6	RF Coax Cable .....	64
5.7	Main PBA .....	65
5.8	Camera .....	67
5.9	Support Plate .....	68
5.10	Display .....	69
5.11	Sheet FPC Relay .....	70
5.12	Battery 2300 mAh BA950 .....	70
5.13	Cover Battery .....	70
6	Revision History .....	71

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



## 1 Exterior Views



## 2 Tools

### SPECIAL TOOLS

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

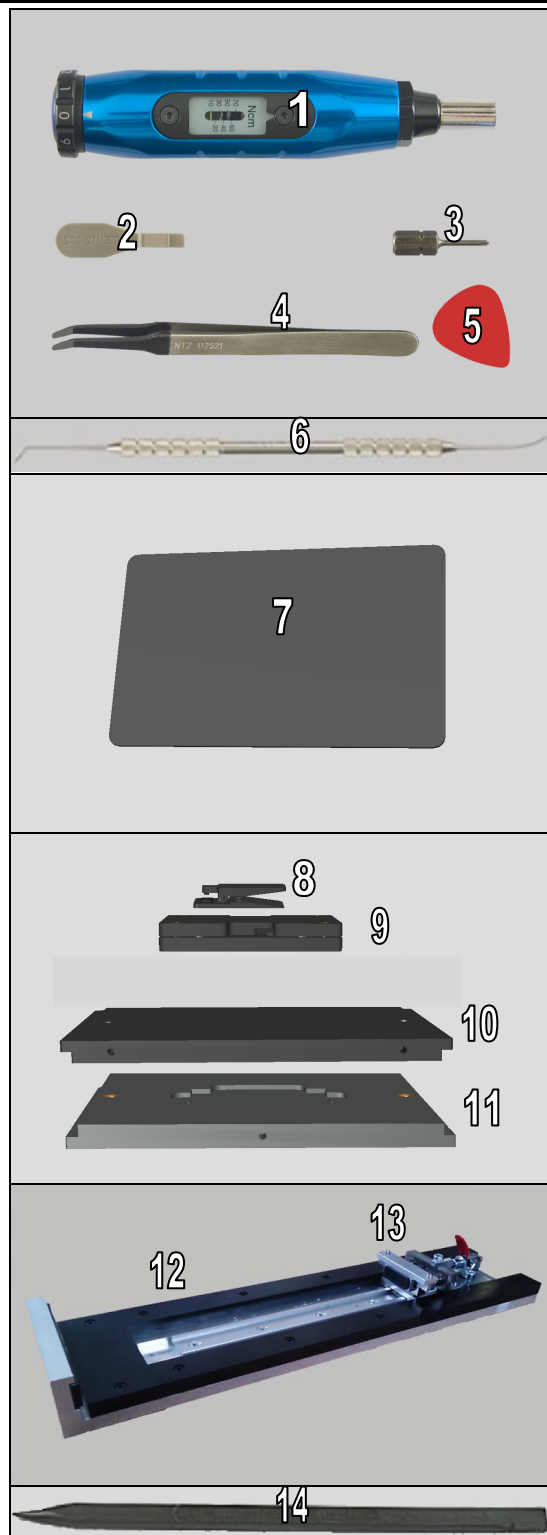
6. Dentist hook

7. Battery Removal Tool

8. Generic Press Clamp 45N
9. Display Adhesive alignment fixture
10. Display Press Top Inlay
11. Bottom Press Inlay

12. Side Panel press
13. Side Panel Press Pad

14. Nylon pointer



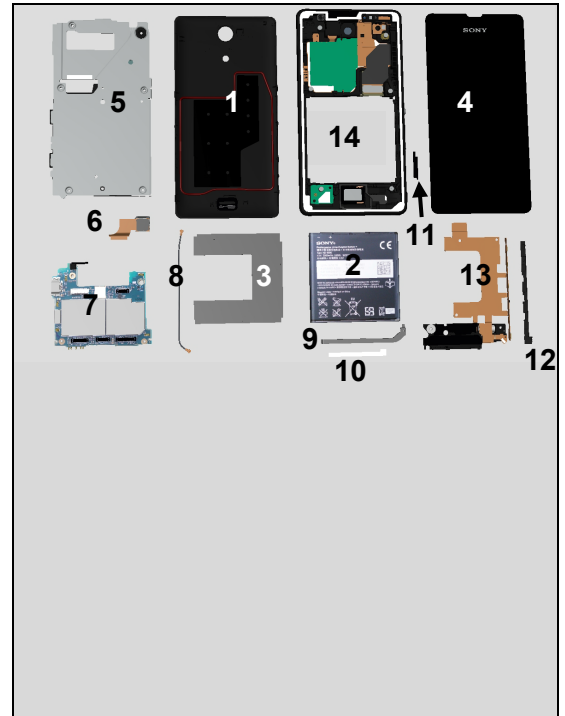
**For part not on the tools above, refer to the 'Tools Catalogue/Matrix'!**

## 3 Disassembly

The Disassembly is done to the following modules:

1. Cover Battery
2. Battery 2300 mAh BA950
3. Sheet FPC Relay
4. Display
5. Support Plate
6. Camera
7. Main PBA
8. RF Coax Cable
9. Lightguide
10. Lightguide Sheet
11. Sheet Battery Side
12. Holder Side Keys
13. FPC Relay Assy\*
14. Cover Main Assy\*

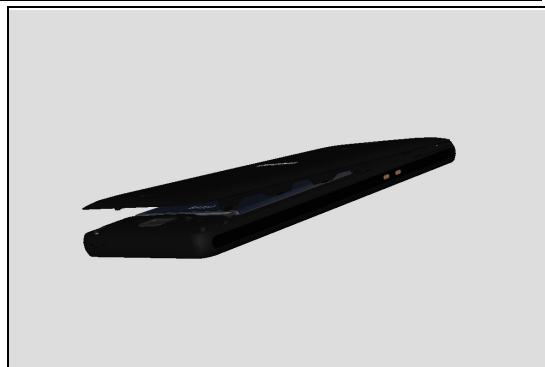
\*) Assy and Unit is used when several parts are handled



## Disassembly

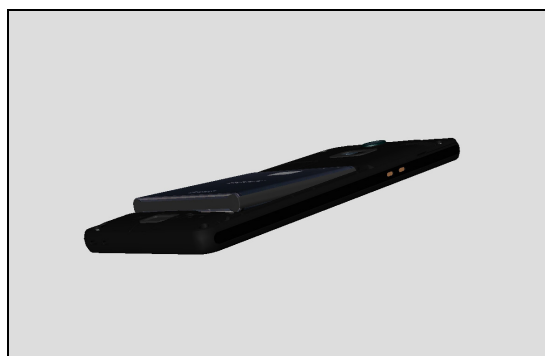
### 3.1 Cover Battery

Open the Cover Battery, bottom side first.



### 3.2 Battery 2300 mAh BA950

Remove Battery, bottom side first.



## Disassembly

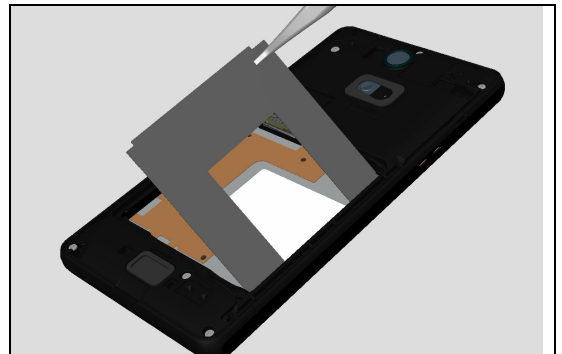
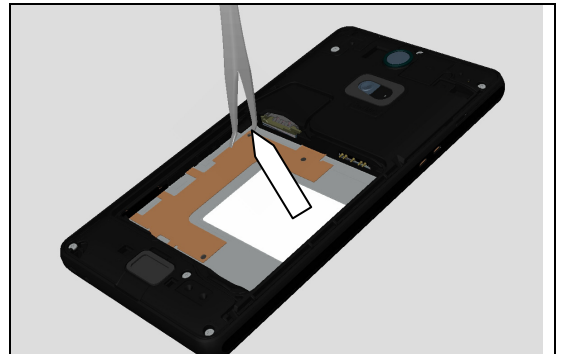
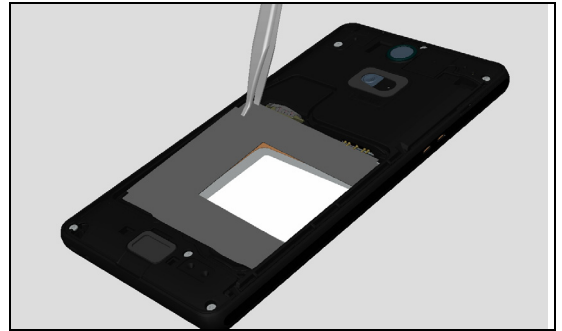
### 3.3 Sheet FPC Relay

Use a Flex Film Assembly Tool to grab the Sheet FPC Relay in the upper left corner.

**Do not damage the FPC beneath!**

Gently peel of the Sheet FPC Relay!

**Scrap! Not to be reused!**

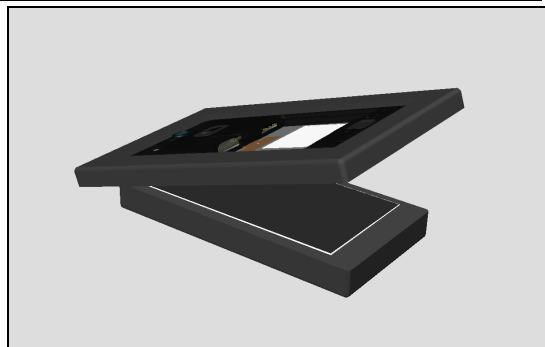


## Disassembly

### 3.4 Display

Use the "Disassembly Machine" (1276-0592) and follow the associated instruction.

***The Disassembly Machine must be used when removing the Display!***

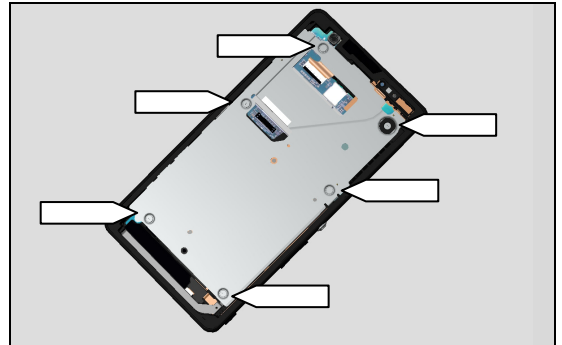


## Disassembly

### 3.5 Support Plate

Remove the 6 screws holding the Support Plate by using a screwdriver with Bits **(JCIS No 0)**.

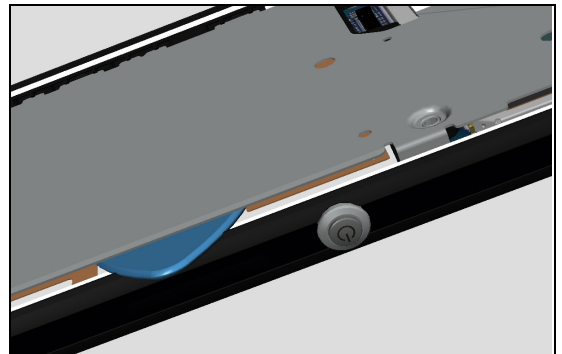
**Scrap! Not to be reused!**



Push the Support Plate from the battery side to make a gap between the Support Plate and the Cover Main Assy.

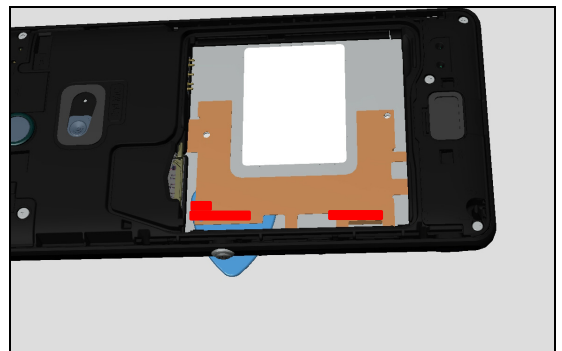
Insert a Guitar Pick just below the On/Off button (between the areas marked in red on the picture below).

**Do not damage the Cover Main!**



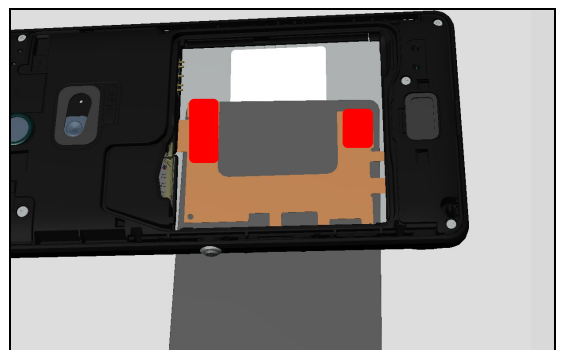
Loosen the adhesive marked on the picture by sliding the Guitar Pick to each side.

**Do not damage the Cover Main!**

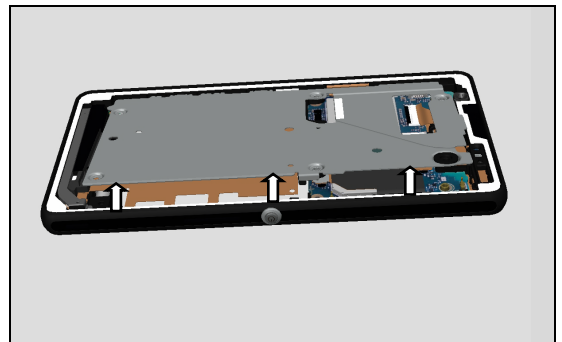


Loosen the adhesive marked on the picture by inserting the Battery Removal Tool.

**Do not damage the Cover Main!**

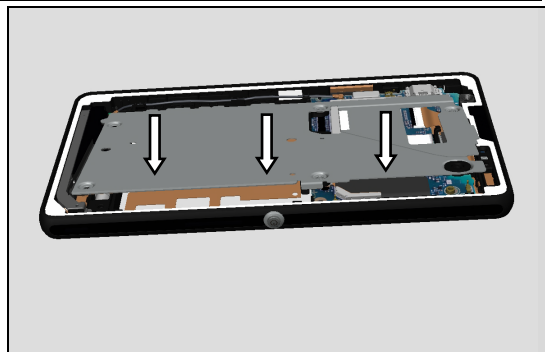


When the all the adhesive is loosened, lift the long side of the Support Plate to make it free from the Cover Main.



## Disassembly: Support Plate

Move the Support Plate in the arrows direction to free it from the Cover Main.





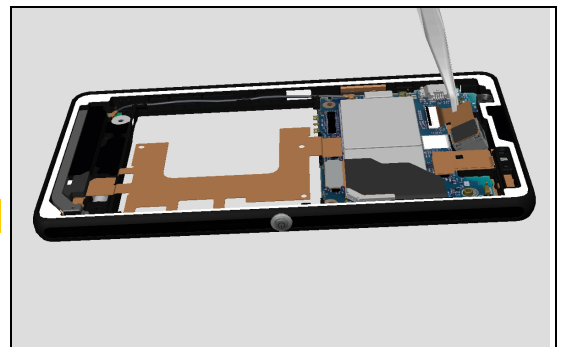
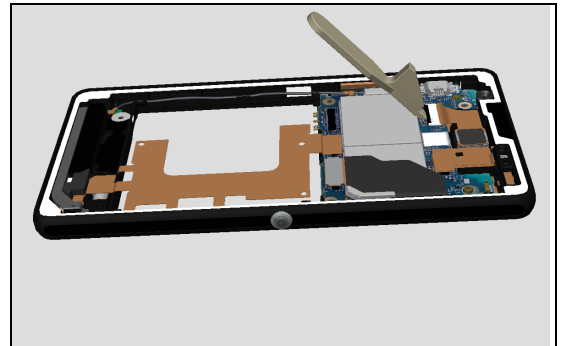
## Disassembly

### 3.6 Camera

Open the ZIF connector with the Front Opening Tool.

Use a Flex Film Assembly Tool to remove the Camera by lifting it out from its cavity.

**Do not damage the Camera!**

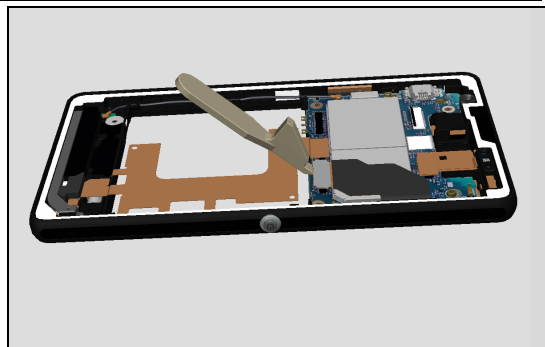


## Disassembly

### 3.7 Main PBA

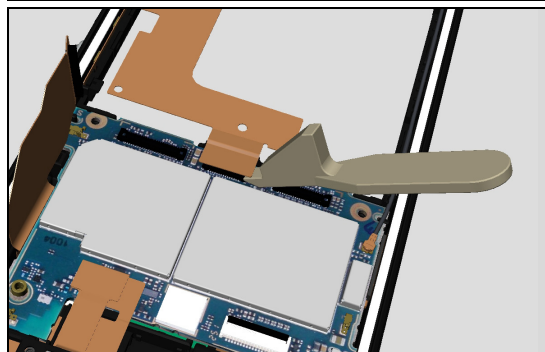
Gently loosen the BtB from the FPC BPA NTC with a Front Opening Tool.

**Do not damage the components on the Main PBA!**



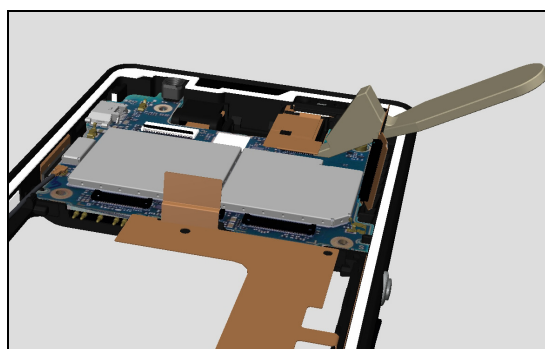
Gently loosen the BtB from the FPC Relay with a Front Opening Tool.

**Do not damage the components on the Main PBA!**

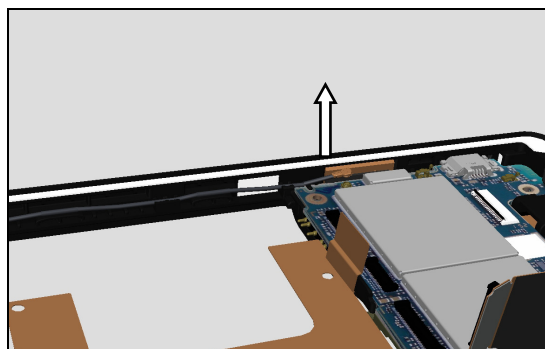


Gently loosen the BtB from the FPC Top Compl. with a Front Opening Tool.

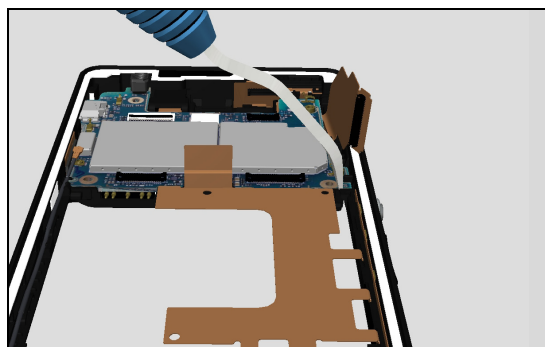
**Do not damage the components on the Main PBA!**



Gently loosen the connector on the RF Coax Cable from the Main PBA with your fingers.

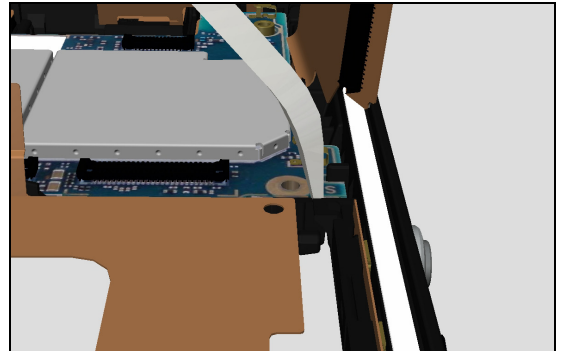


Use a Dentist Hook to loosen the Main PBA from its cavity.



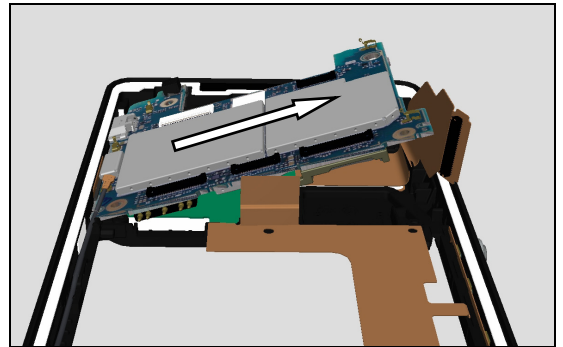
## Disassembly: Main PBA

***Use the pre-made chamfer on the Main PBA!***  
***Do not damage the Main PBA!***



Lift the Main PBA to free it from the FPC's before removing it by moving the Main PBA in the arrows direction.

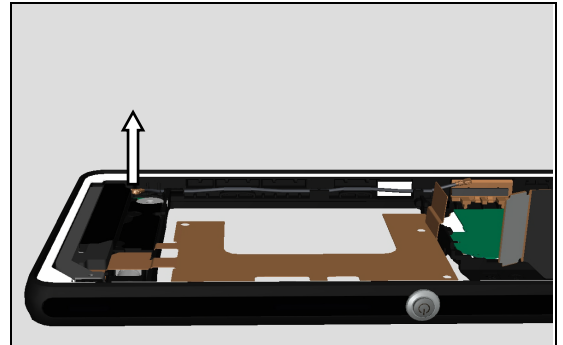
***Do not damage the FPC's!***



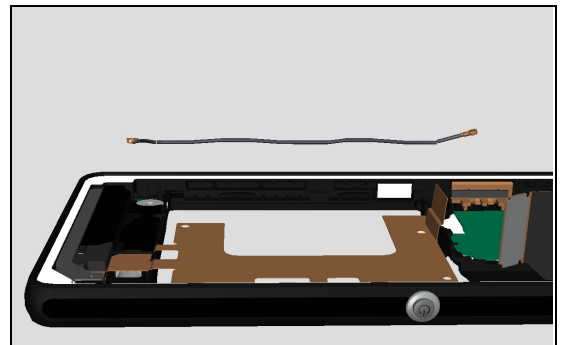
## Disassembly

### 3.8 RF Coax Cable

Gently loosen the connector on the RF Coax Cable from the PBA Antenna with your fingers.

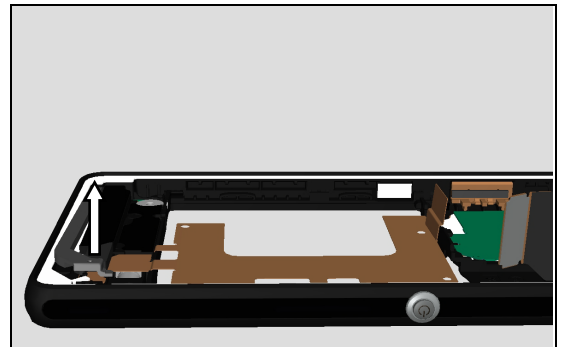


Lift the RF Coax Cable from the Cover Main.



### 3.9 Lightguide

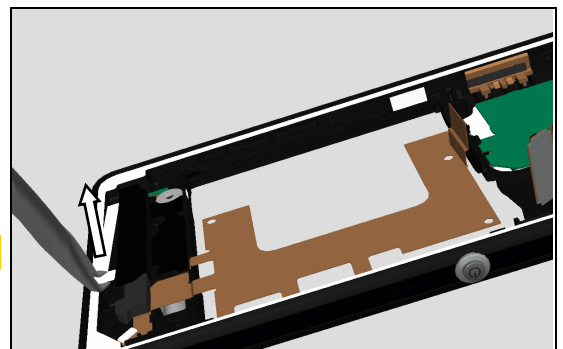
Gently lift the Lightguide from its cavity with your fingers.



### 3.10 Lightguide Sheet

Gently lift the Lightguide Sheet from its cavity with a Flex Film Assembly Tool.

**Scrap, not to be reused!**

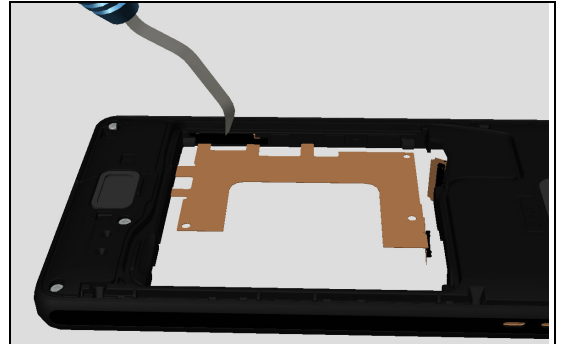


## Disassembly

### 3.11 Sheet Battery Side

Use a Dentist Hook to remove the Sheet Battery Side.

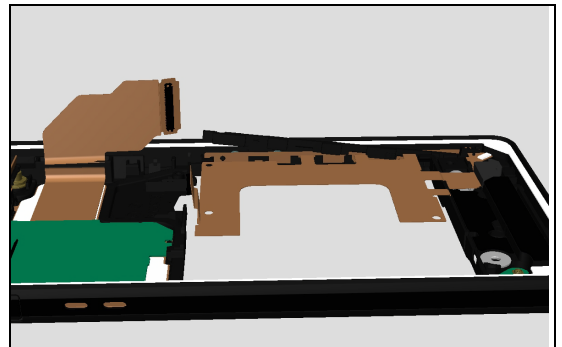
**Scrap, not to be reused!**



### 3.12 Holder Side Keys

Remove the Holder Side Keys with your fingers.

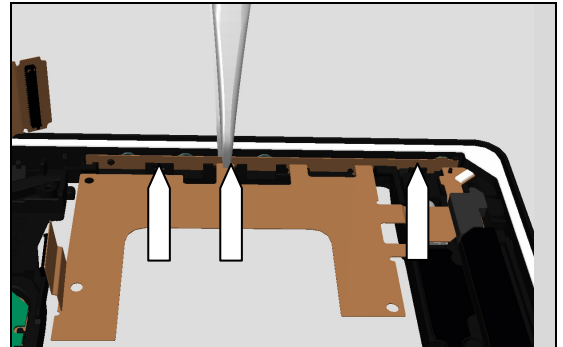
**Scrap, not to be reused!**



## Disassembly

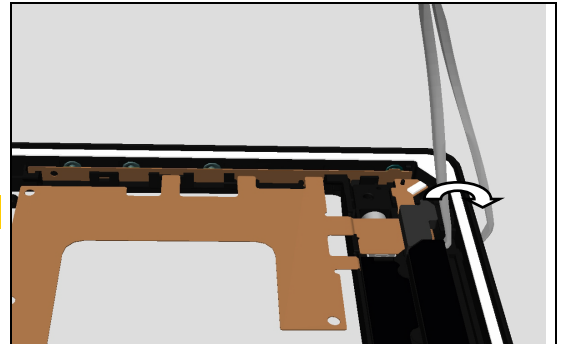
### 3.13 FPC Relay Assy

Use a Flex Film Assembly Tool to loosen adhesive on the FPC from the Cover Main on the 3 places marked on the picture.

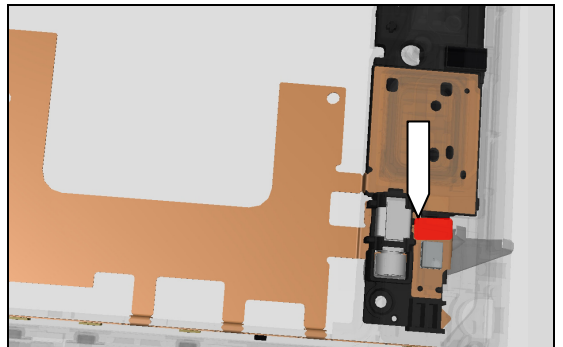


Use a Flex Film Assembly Tool to completely loosen the FPC Relay Assy from the Cover Main.

**Scrap, not to be reused!**



**Be careful not to damage the FPC or the components on the FPC underneath.**



## 4 Replacement

### 4.1 Cover Battery

Follow the 3.1 Disassembly instructions!  
Prepare a new Cover Battery.  
Follow the 5.13 Reassembly instructions!



### 4.2 Battery 2300 mAh BA950

Follow the 3.1 – 3.2 Disassembly instructions!  
Prepare a new Battery 2300 mAh BA950.  
Follow the 5.12 – 5.13 Reassembly instructions!

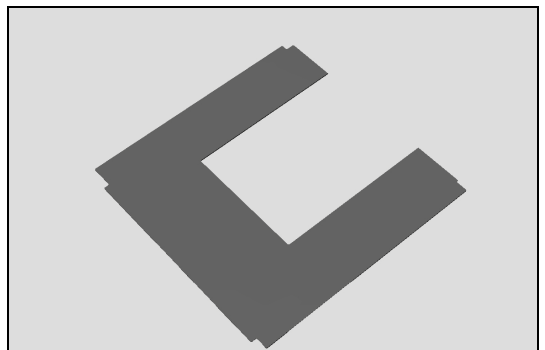


### 4.3 Sheet FPC Relay

Follow the 3.1 – 3.3 and Disassembly instructions!

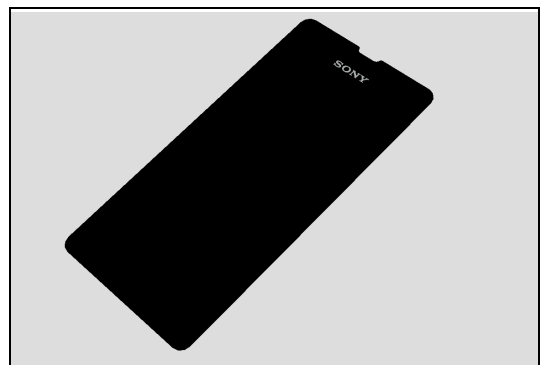
**Scrap Sheet FPC Relay, not to be reused!**

Prepare a new Sheet FPC Relay.  
Follow the 5.11 – 5.13 Reassembly instructions!



### 4.4 Display

Follow the 3.1 – 3.4 Disassembly instructions!  
Prepare a new Display.  
Follow the 5.10 – 5.13 Reassembly instructions!



## Replacement

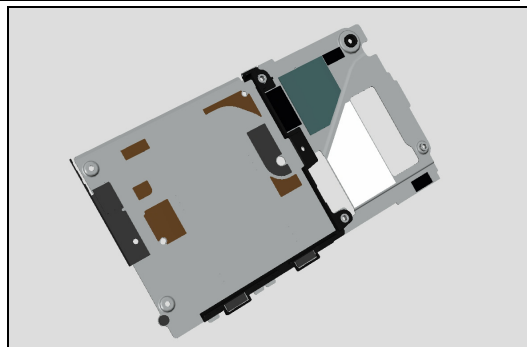
### 4.5 Support Plate

*Follow the 3.1 – 3.5 Disassembly instructions!*

**Scrap Support Plate, not to be reused!**

Prepare a new Support Plate.

Follow the 5.9 – 5.13 Reassembly instructions!



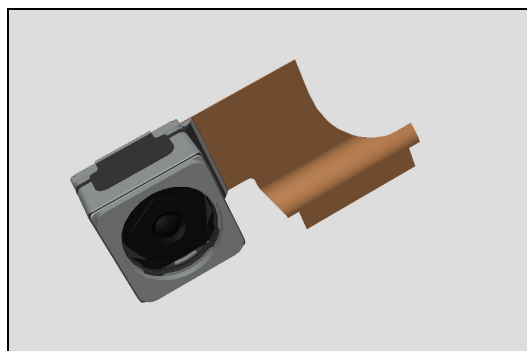
### 4.6 Camera

*Follow the 3.1 – 3.6 Disassembly instructions!*

Prepare a new Camera.

*Carry out the Installation as described below!*

Follow the 5.8 – 5.13 Reassembly instructions!



### 4.7 Main PBA

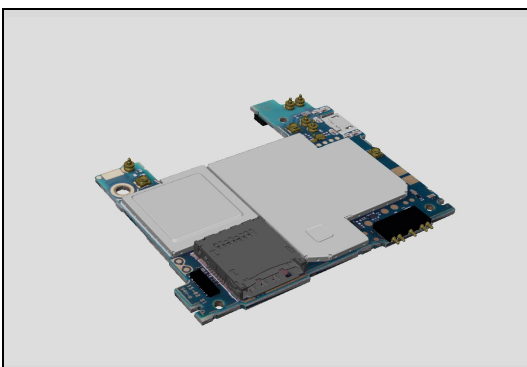
*Follow the 3.1 – 3.7 Disassembly instructions!*

Follow the 4.25 Removal instructions!

*Prepare a new Main PBA.*

Follow the 4.25 Reassembly instructions!

Follow the 5.7 – 5.13 Reassembly instructions!





## Replacement

### 4.8 RF Coax Cable

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new RF Coax Cable.*

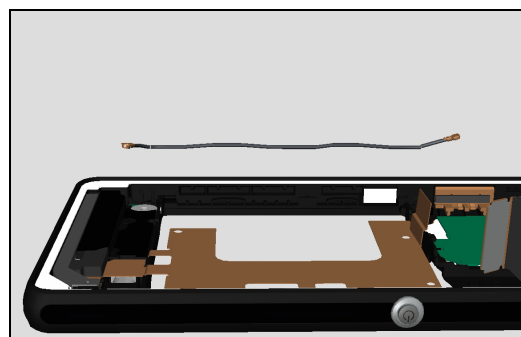
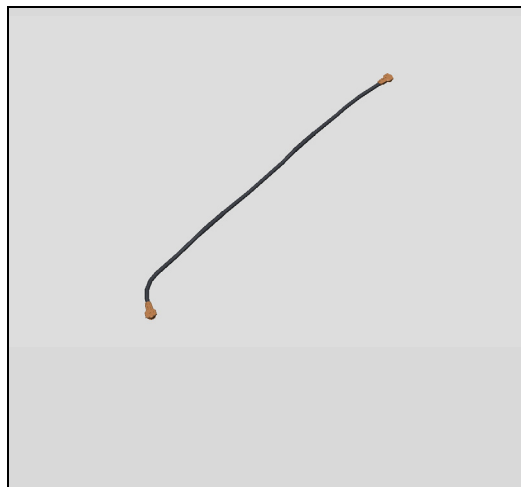
*Carry out the Installation as described below!*

*Follow the 5.6 – 5.13 Reassembly instructions!*

#### REMOVAL

Gently loosen the connector on the RF Coax Cable from the Main PBA and the PBA Antenna with your fingers.

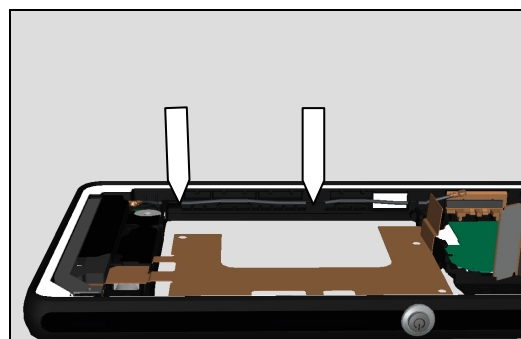
Lift the RF Coax Cable from the Cover Main



#### INSTALLATION

Insert the RF Coax Cable into the Cover Main.

**Secure that the RF Coax Cable have snapped into place!**



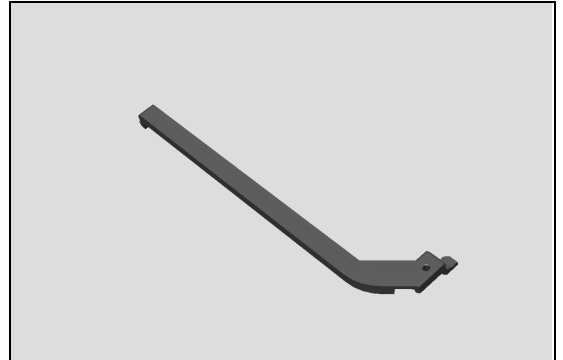
## Disassembly

### 4.9 Lightguide

*Follow the 3.1 – 3.5 and 3.9 Disassembly instructions!*

*Prepare a new Lightguide.*

*Follow the 5.5 and 5.9 – 5.13 Reassembly instructions!*



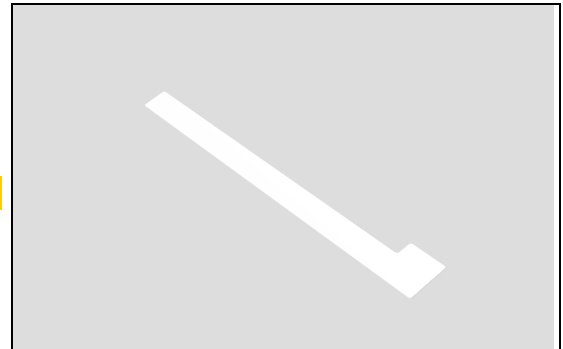
### 4.10 Lightguide Sheet

*Follow the 3.1 – 3.5 and 3.9 – 3.10 Disassembly instructions!*

**Scrap Lightguide Sheet, not to be reused!**

*Prepare a new Lightguide Sheet.*

*Follow the 5.4 – 5.5 and 5.9 – 5.13 Reassembly instructions!*



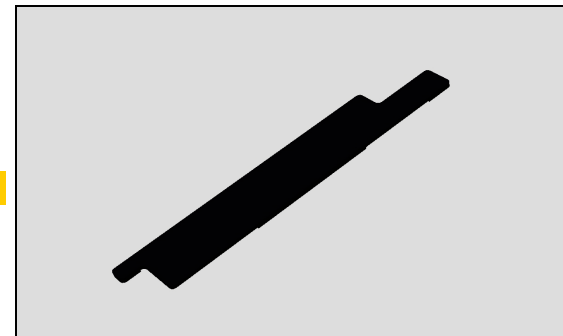
### 4.11 Sheet Battery Side

*Follow the 3.1 – 3.2 and 3.11 Disassembly instructions!*

**Scrap Sheet Battery Side, not to be reused!**

*Prepare a new Sheet Battery Side.*

*Follow the 5.3 and 5.12 – 5.13 Reassembly instructions!*

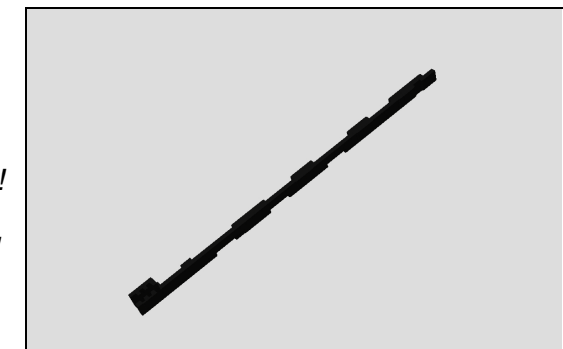


### 4.12 Holder Side Keys

*Follow the 3.1 – 3.2 and 3.11 – 3.12 Disassembly instructions!*

*Prepare a new Holder Side Keys!*

*Follow the 5.2 – 5.3 and 5.12 – 5.13 Reassembly instructions!*



## Replacement

### 4.13 FPC Relay

*Follow the 3.1 – 3.5, 3.9 – 3.12 Disassembly instructions!*

*Carry out the Removal as described below!*

*Follow the 3.13 Disassembly instructions!*

*Follow the 4.20 and 4.39 Disassembly instructions!*

**Scrap FPC Relay, not to be reused!**

*Prepare a new FPC Relay!*

*Follow the 4.39 and 4.20 – 4.21 Reassembly instructions!*

*Follow the 5.1 Reassembly instructions!*

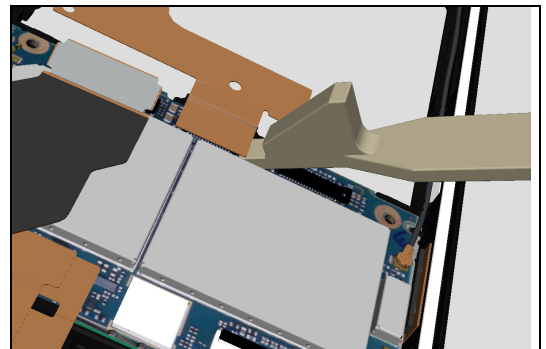
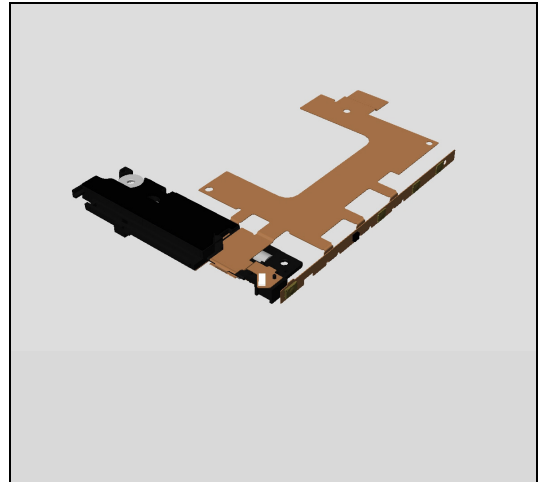
*Carry out the Installation as described below!*

*Follow the 5.2 – 5.5 and 5.9 – 5.13 Reassembly instructions!*

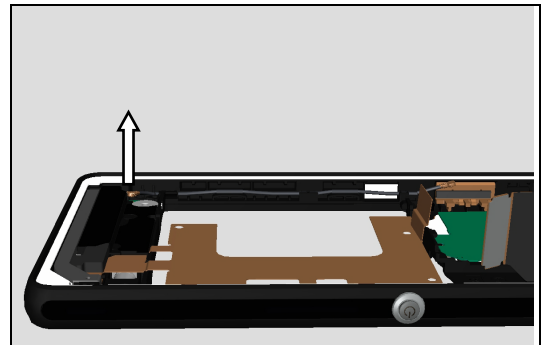
#### REMOVAL

Gently loosen the BtB from the FPC Relay with a Front Opening Tool.

**Do not damage the components on the Main PBA!**



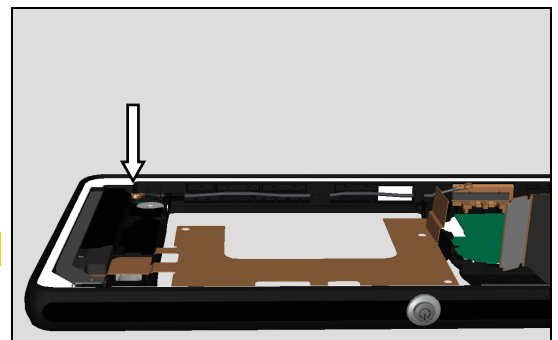
Gently loosen the connector on the RF Coax Cable from the PBA Antenna with your fingers.



#### INSTALLATION

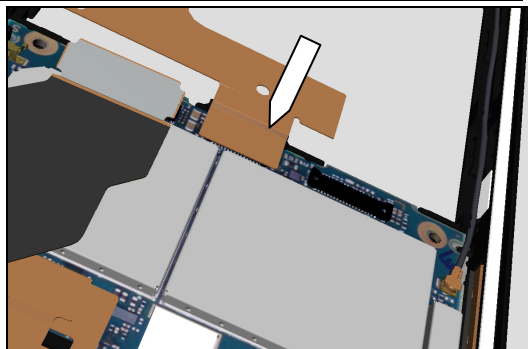
Attach the lower part of the RF Coax Cable on to the PBA Antenna.

**Secure the position with your fingers!**



## Replacement

Attach the BtB from the FPC Relay to Main PBA.



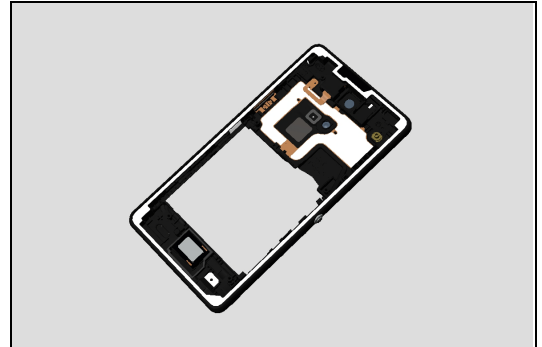
## Replacement

### 4.14 Cover Main

*Follow the 3.1 – 3.13 Disassembly instructions!*

*Prepare a new Cover Main!*

*Follow the 5.1 – 5.13 Reassembly instructions!*



### 4.15 Adhesive Display

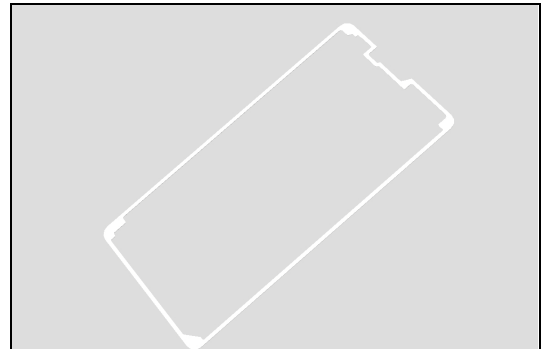
*Follow the 3.1 – 3.4 Disassembly instructions!*

**Scrap Adhesive Display, not to be reused!**

**Remove and clean any remaining adhesive residue found on Display and Cover Main!**

*Prepare a new Adhesive Display.*

*Follow the 5.10 – 5.13 Reassembly instructions!*



## Replacement

### 4.16 Card Connector Tray

*Follow the 3.1 – 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

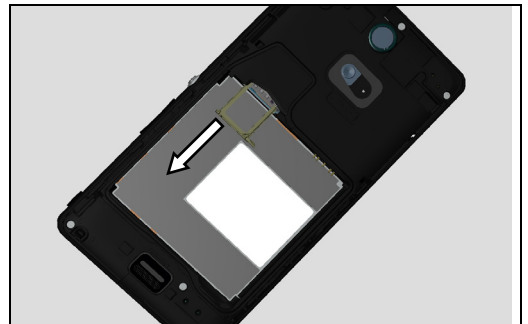
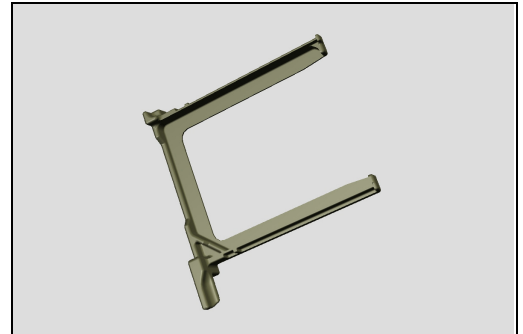
*Prepare a new Card Connector Tray.*

*Carry out the Installation as described below!*

*Follow the 5.12 – 5.13 Reassembly instructions!*

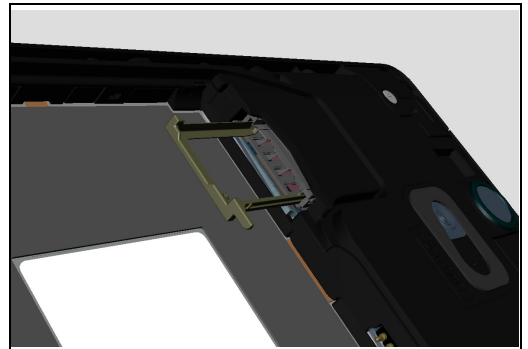
#### REMOVAL

Use your fingers to pull the Card Connector Tray out from SIM Card Holder



#### INSTALLATION

Use your fingers to mount the Card Connector Tray according to picture.



## Replacement

### 4.17 Cushion 2<sup>nd</sup> MIC

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Follow the 4.22 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion 2<sup>nd</sup> MIC.*

*Carry out the Installation as described below!*

*Follow the 4.22 Reassembly instructions!*

*Follow the 5.7 – 5.13 Reassembly instructions!*

#### REMOVAL

*Gently peel of the Cushion 2<sup>nd</sup> MIC from the FPC PBA NFC with your fingers.*

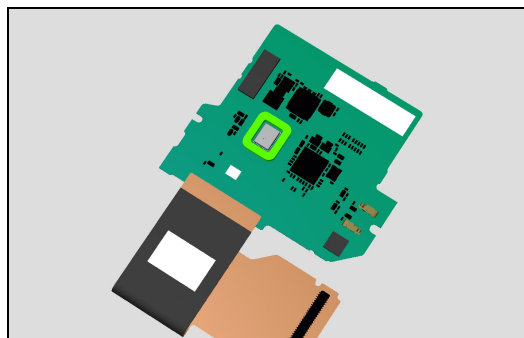
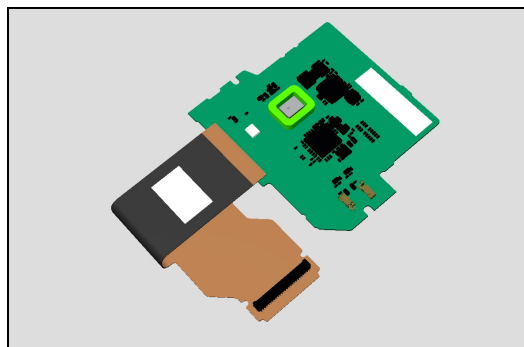
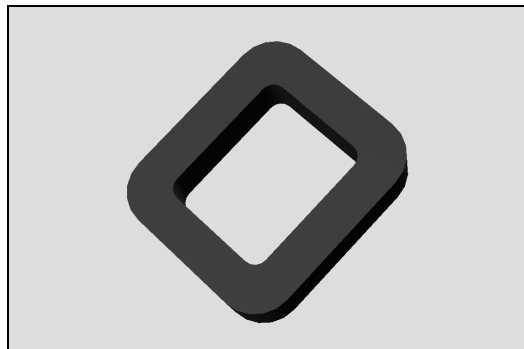
***Be careful not to damage the FPC PBA NFC!***

***Scrap Cushion 2<sup>nd</sup> MIC, not to be reused!***

#### INSTALLATION

*Place the Cushion 2<sup>nd</sup> MIC at the FPC PBA NFC according to marking on PBA.*

***Secure the position with your fingers!***



## Replacement

### 4.18 Cushion 3 x 3 mm

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Follow the 4.22 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion 3 x 3 mm.*

*Carry out the Installation as described below!*

*Follow the 4.22 Reassembly instructions!*

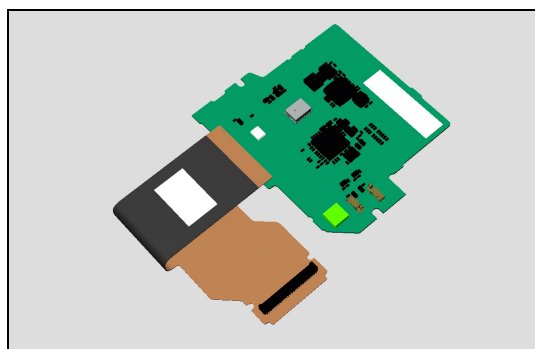
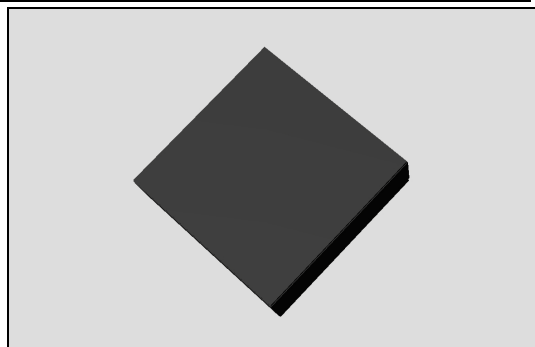
*Follow the 5.7 – 5.13 Reassembly instructions!*

#### REMOVAL

Gently peel of the Cushion 3 x 3 mm from the FPC PBA NFC with your fingers.

**Be careful not to damage the FPC PBA NFC!**

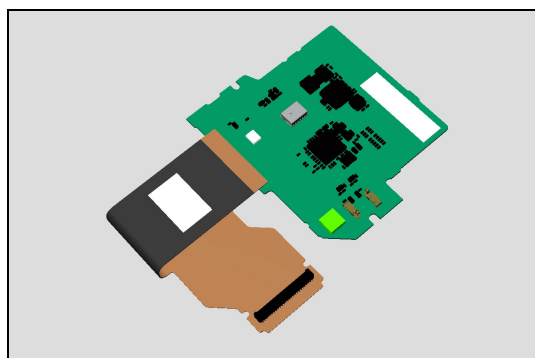
**Scrap Cushion 3 x 3, not to be reused!**



#### INSTALLATION

Place the Cushion 3 x 3 mm at the FPC PBA NFC according to marking on PBA.

**Secure the position with your fingers!**





## Replacement

### 4.19 Cushion 3 x 8 mm

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Follow the 4.22 Disassembly instructions!*

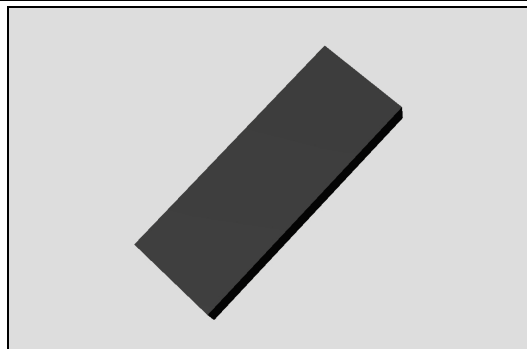
*Carry out the Removal as described below!*

*Prepare a new Cushion 3 x 8 mm.*

*Carry out the Installation as described below!*

*Follow the 4.22 Reassembly instructions!*

*Follow the 5.7 – 5.13 Reassembly instructions!*

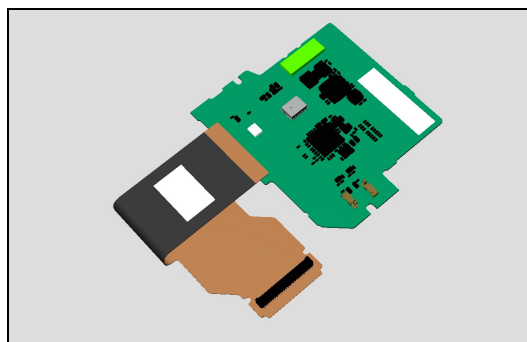


#### REMOVAL

*Gently peel of the Camera Cushion 2<sup>nd</sup> MIC from the FPC PBA NFC with your fingers.*

***Be careful not to damage the FPC PBA NFC!***

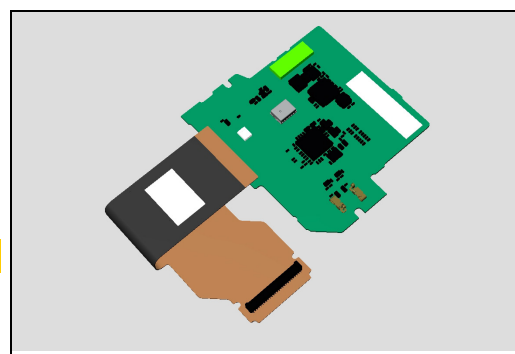
***Scrap Cushion 3 x 8, not to be reused!***



#### INSTALLATION

*Place the Cushion 3 x 8 mm at the FPC PBA NFC according to marking on PBA.*

***Secure the position with your fingers!***



## Replacement

### 4.20 Cushion MIC

*Follow the 3.1 – 3.5, 3.9 – 3.12 Disassembly instructions!*

*Carry out the Removal as described below!*

*Follow the 3.13 Disassembly instructions!*

*Follow the 4.39 Disassembly instructions!*

*Prepare a new Cushion MIC!*

*Follow the 4.39 Reassembly instructions!*

*Follow the 5.1 Reassembly instructions!*

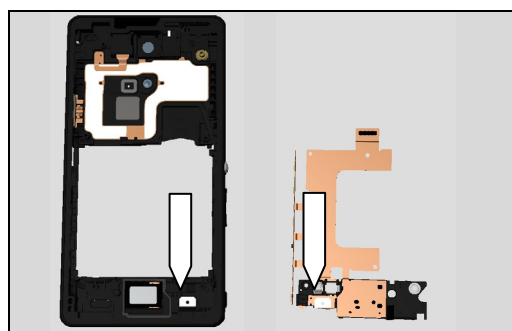
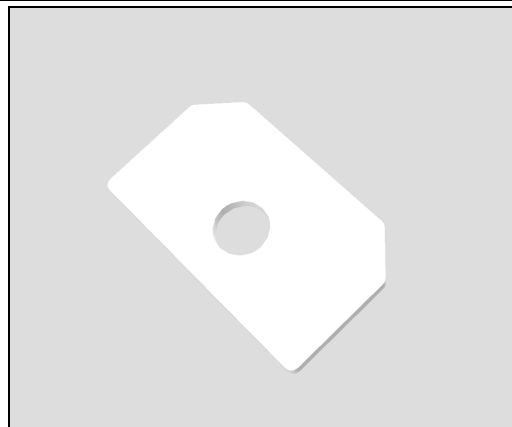
*Carry out the Installation as described below!*

*Follow the 5.2 – 5.5 and 5.9 – 5.13 Reassembly instructions!*

#### REMOVAL

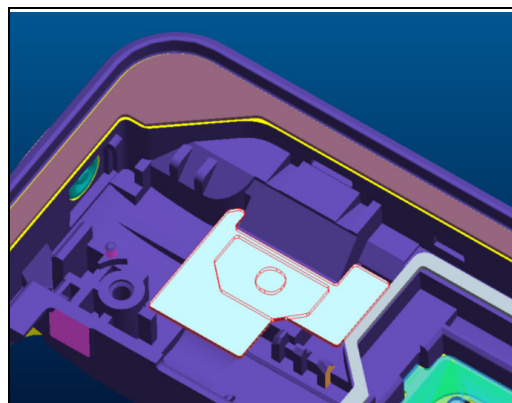
**Remove and clean any remaining adhesive residue found on Cover Main Assy and FPC Relay Assy.**

**Scrap Cushion MIC, not to be reused!**



#### INSTALLATION

Attach a new Cushion MIC with your fingers to the Cover Main according to the picture. Use the liner as guidance.



## Replacement

### 4.21 Cushion Window

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion Window.*

*Carry out the Installation as described below!*

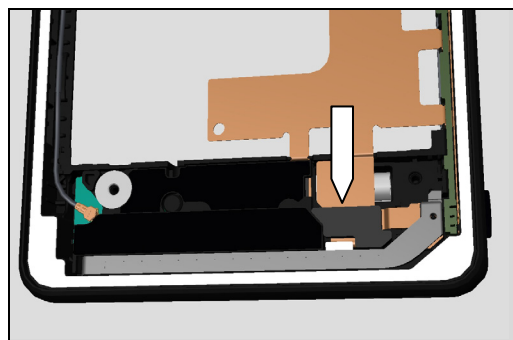
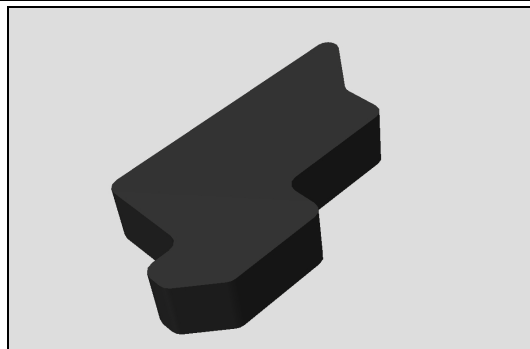
*Follow the 5.9 – 5.13 Reassembly instructions!*

#### REMOVAL

Peel of the Cushion Window with your fingers.

**Be careful not to damage the FPC PBA NFC!**

**Scrap Cushion Window, not to be reused!**

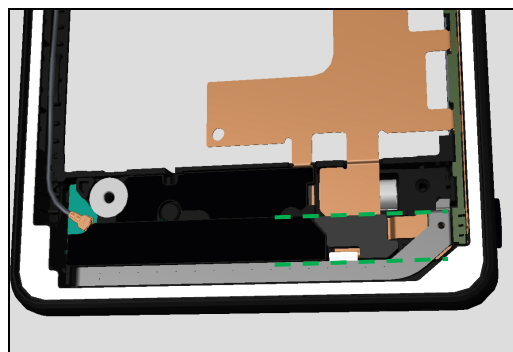


#### INSTALLATION

Attach a new Cushion Window with your fingers to the FPC Relay Assy guided by the 2 green lines according to the picture.

**Secure the position with your fingers!**

**Make sure that the Cushion Window is free from the Lightguide and the Lightguide Sheet!**



## Replacement

### 4.22 FPC PBA NFC

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cushion 3 x 8 mm.*

*Follow the 4.17 – 4.19 Reassembly instructions!*

*Carry out the Installation as described below!*

*Follow the 5.7 – 5.13 Reassembly instructions!*

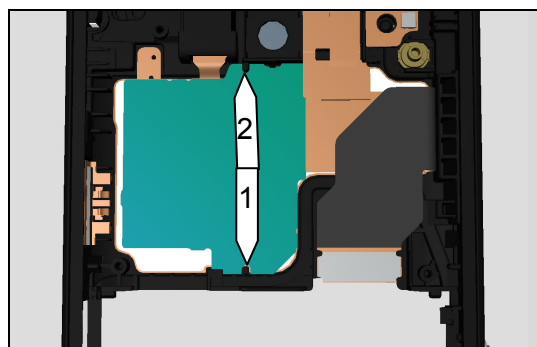
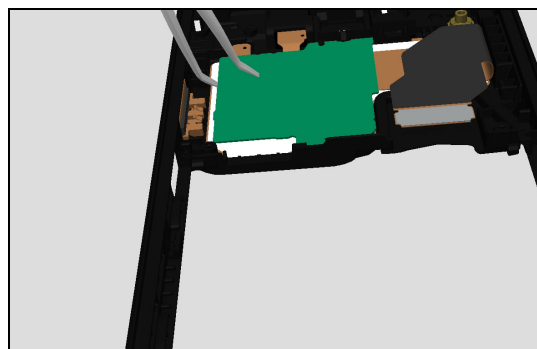
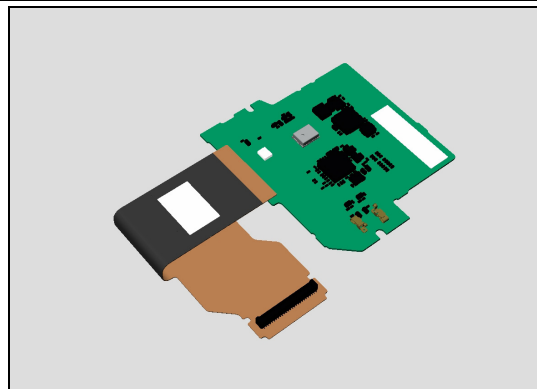
#### REMOVAL

*Use a Flex Film Assembly Tool to loosen the FPC PBA NFC from the Cover Main Assy.*

***Be careful not to damage the FPC PBA NFC!***

#### INSTALLATION

*Insert the FPC PBA NFC in the lower (1) part first before lowering the upper part (2) down into position with your fingers.*



## Replacement

### 4.23 FPC Top Compl

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Carry out the Removal as described below!*

*Follow the 4.32 Removal instructions!*

*Prepare a new FPC AVP!*

*Follow the 4.32 Installation instructions!*

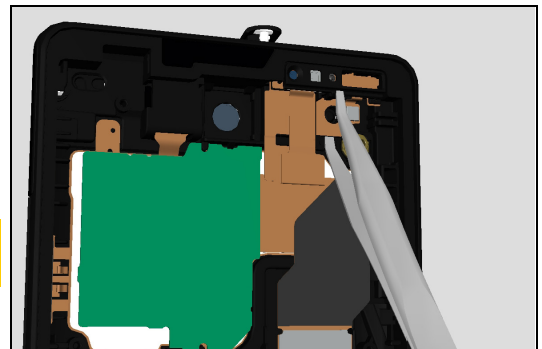
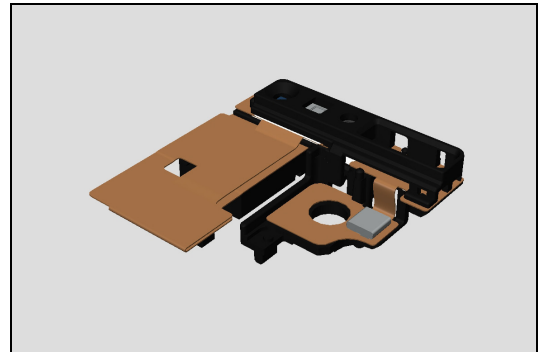
*Carry out the Installation as described below!*

*Follow the 5.7 – 5.13 Reassembly instructions!*

#### REMOVAL

Insert a Flex Film Assembly Tool to lift the right part (lower surface).

***Make sure that you inset the Flex Film Assembly Tool under the plastic part of the FPC Top Compl!***



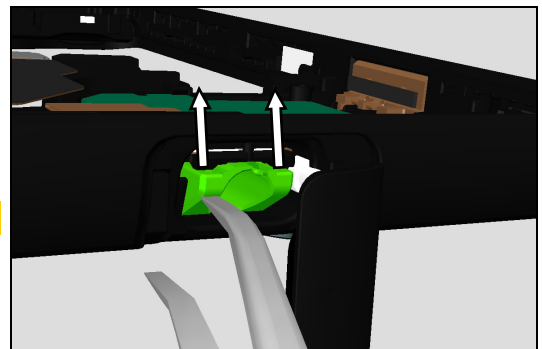
Use your fingers to slide the top part of the FPC Compl out of its cavity.

***Make sure that this part loosens complete from the cavity!***

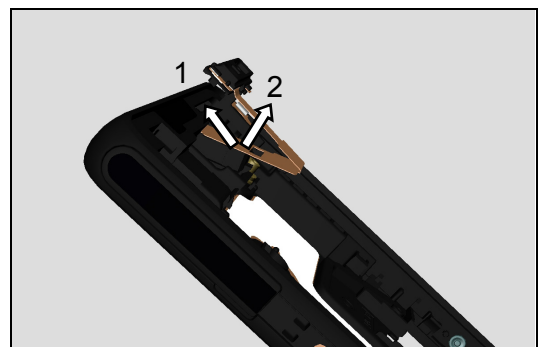


Use a Flex Film Assembly Tool to lift the rubber part sticking out of the Cover Main of the FPC Top Compl.

***Make sure that you only push on the rubber part!***



Now you can move the complete FPC Top Compl slightly forward (1) and out from its cavity (2) in the Cover Main.

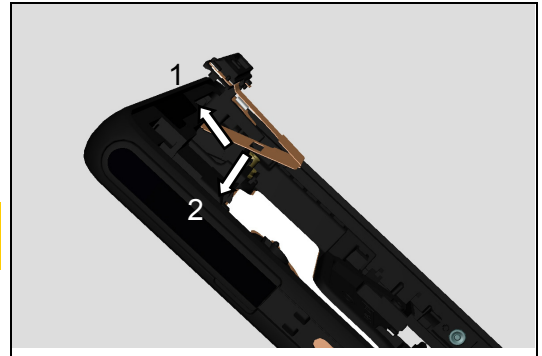


## Replacement: FPC Top Compl

### INSTALLATION

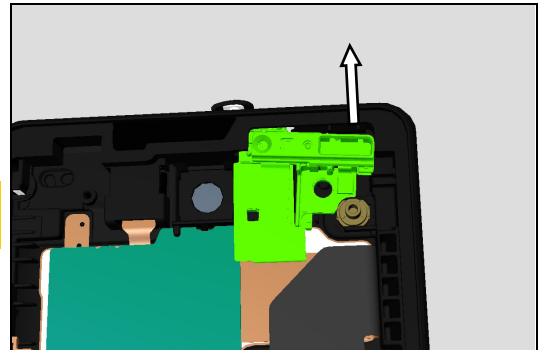
Insert the FPC Top Compl into its cavity.

***Push the FPC Top Compl forward (1) before lowering the back down(2)!***



Use your fingers to slide the top part of the FPC Compl into its cavity.

***Make sure that the lower part of the FPC Top Compl snaps into place in the Cover Main!***



## Replacement

### 4.24 Gasket 2<sup>nd</sup> MIC

*Follow the 3.1 Disassembly instructions!*

*Prepare a new Gasket 2<sup>nd</sup> MIC.*

*Follow the 5.13 Reassembly instructions!*

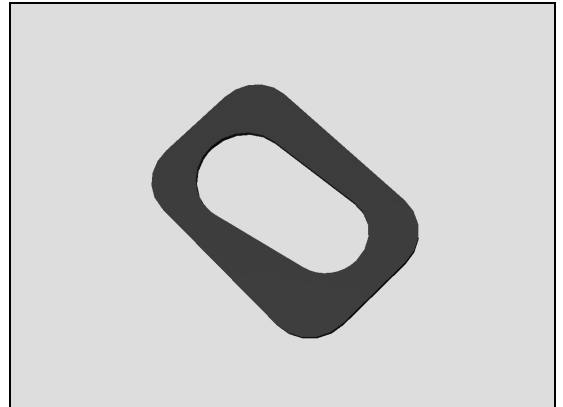
#### REMOVAL

Peel of the Gasket 2<sup>nd</sup> MIC from the Cover Main.

**Scrap Gasket 2<sup>nd</sup> MIC, not to be reused!**

#### INSTALLATION

Attach the Gasket 2<sup>nd</sup> MIC to the Cover Main according to the picture.



## Replacement

### 4.25 Gasket Chat Camera

*Follow the 3.1 – 3.4 Disassembly instructions!*

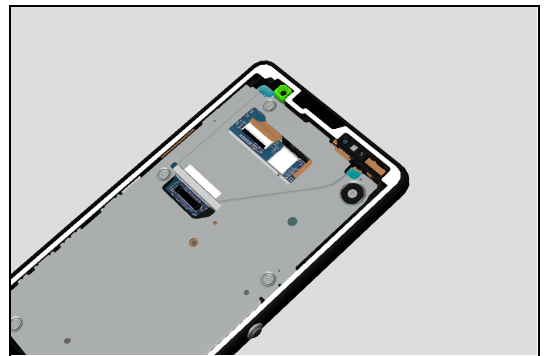
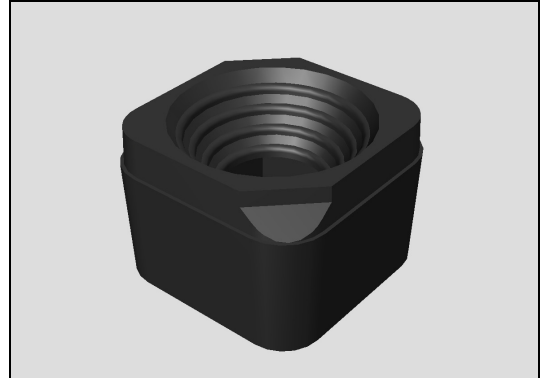
*Prepare a new Gasket Chat Camera.*

*Follow the 5.10 – 5.13 Reassembly instructions!*

#### REMOVAL

Use your fingers to disassemble the *Gasket Chat Camera*.

**Be careful not to touch the lens of the Chat Camera!**



#### INSTALLATION

Mount the *Gasket Chat Camera* to the Chat Camera on the

**Be careful not to touch the lens of the Chat Camera!**





## Replacement

### 4.26 Gasket Key

*Follow the 3.1 and 3.2 Disassembly instructions!*

Power Button: *Follow the 4.37 – 4.38, 4.35 and 4.28 – 4.30*

*Removal instructions!*

Other Buttons: *Follow the 4.37, 4.28 and 4.30 Removal instructions!*

*Prepare a new Gasket Key!*

*Carry out the Installation as described below!*

Other Buttons: *Follow the 4.30, 4.28 and 4.37 Reassembly instructions!*

Power Button: *Follow the 4.28 – 4.30, 4.35 and 4.37 – 4.38 Reassembly instructions!*

*Follow the 5.12 – 5.13 Reassembly instructions!*

#### REMOVAL

Use a Dentist Hook to remove the Gasket Key from the Cover Main.

**Be careful not to puncture or scratch anything!**

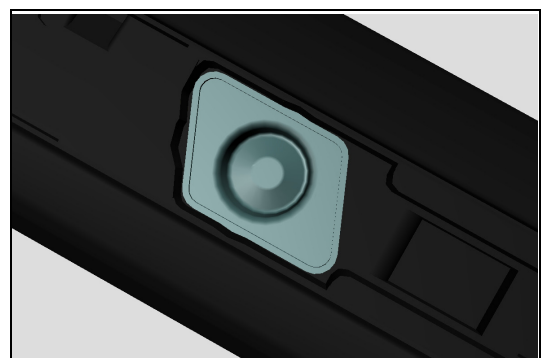
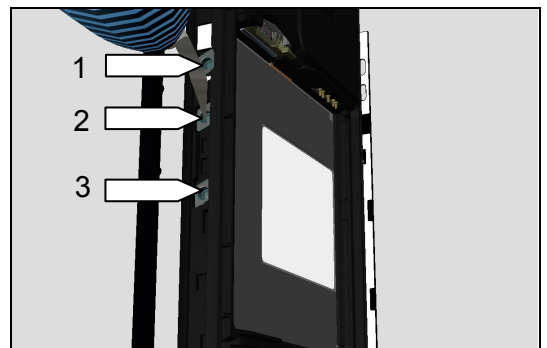
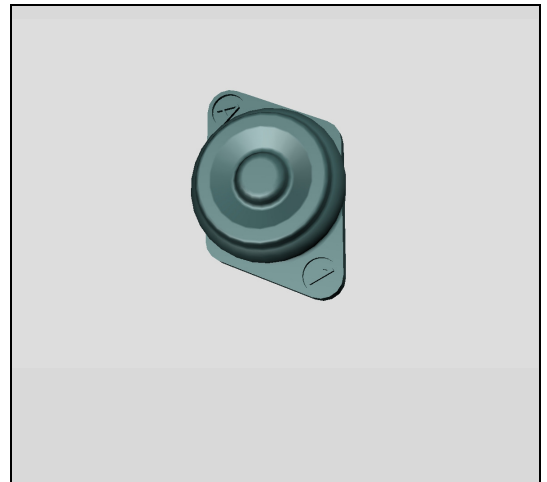
1. Power button
2. Volume Up
3. Volume Down

#### INSTALLATION

Use your fingers to mount the Gasket Key in its cavity in the Cover Main.

**Make sure that the Gasket Key is completely in the aimed cavity by securing its position with your fingers!**

**This is very important for a good feeling on the button!**



## Replacement

### 4.27 Gasket Key Cam

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Follow the 4.37 and 4.28 Removal instructions!*

*Prepare a new Gasket Key Cam!*

*Carry out the Installation as described below!*

*Follow the 4.28 and 4.37 Reassembly instructions!*

*Follow the 5.12 – 5.13 Reassembly instructions!*

#### REMOVAL

Use a Dentist Hook to remove the Gasket Key Cam from the Cover Main.

**Be careful not to puncture or scratch anything!**

#### INSTALLATION

Use your fingers to mount the Gasket Key Cam in its cavity in the Cover Main.

**Make sure that the Gasket Key Cam is completely in the aimed cavity by securing its position with your fingers!**

**This is very important for a good feeling on the button!**



## Disassembly

### 4.28 Key Camera

*Follow the 3.1 and 3.2 Disassembly instructions!*

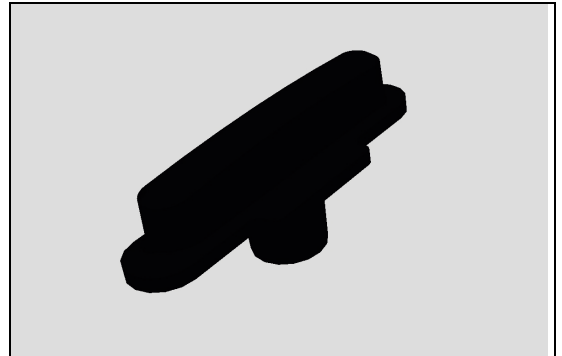
*Follow the 4.37 Removal instructions!*

*Prepare a new Key Camera!*

*Carry out the Installation as described below!*

*Follow the 4.37 Reassembly instructions!*

*Follow the 5.12 – 5.13 Reassembly instructions!*



#### REMOVAL

Gently remove the Key Camera with your fingers.



#### INSTALLATION

Place the Key Camera at the correct position according to picture.



## Disassembly

### 4.29 Key Power

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Follow the 4.37 – 4.38 and 4.35 Removal instructions!*

*Prepare a new Key Power!*

*Carry out the Installation as described below!*

*Follow the 4.35 and 4.37 – 4.38 Reassembly instructions!*

*Follow the 5.12 – 5.13 Reassembly instructions!*



#### REMOVAL

Gently remove the Key Power with your fingers.



#### INSTALLATION

Place the Key Power at the correct position according to picture.



## Disassembly

### 4.30 Key Volume

*Follow the 3.1 and 3.2 Disassembly instructions!*

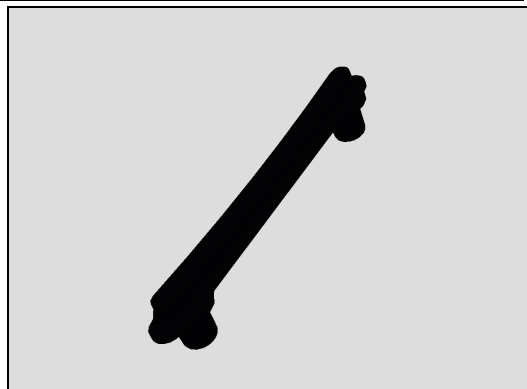
*Follow the 4.37 Removal instructions!*

*Prepare a new Key Volume!*

*Carry out the Installation as described below!*

*Follow the 4.37 Reassembly instructions!*

*Follow the 5.12 – 5.13 Reassembly instructions!*



#### REMOVAL

Gently remove the Key Volume with your fingers.



#### INSTALLATION

Place the Key Volume at the correct position according to picture.



## Disassembly

### 4.31 Label Mobile Phone

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Prepare a new Label Mobile Phone!*

*Follow the 5.12 – 5.13 Reassembly instructions!*

#### REMOVAL

Read the old Label Core Unit and write the information into the 'LabelPrint Solution' program.

Carefully remove the Label by using a Nylon Pointer.

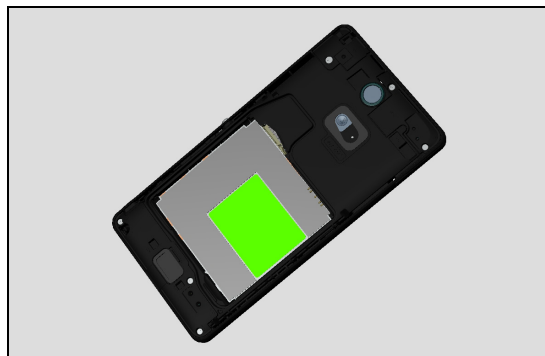
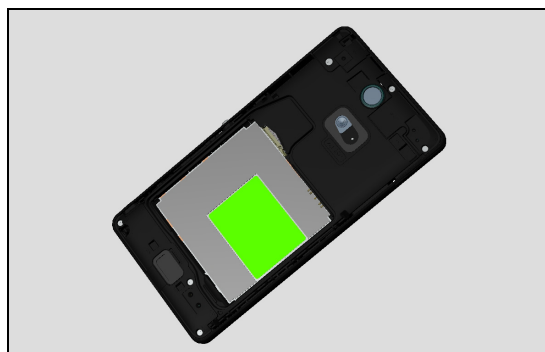
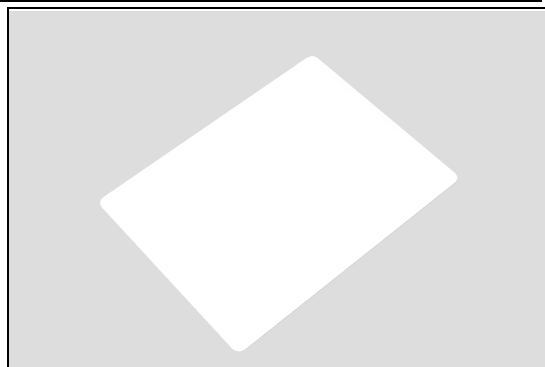
**Scrap Label Mobile Phone, not to be reused!**

***Remove and clean any remaining adhesive residue found on Support Plate!***

#### INSTALLATION

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

**One label only is allowed!**



## Disassembly

### 4.32 Loudspeaker & Adhesive Speaker

*Follow the 3.1 – 3.5, 3.9 – 3.13 Disassembly instructions!*

*Follow the 4.20 and 4.39 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Loudspeaker & Adhesive Speaker!*

*Carry out the Installation as described below!*

*Follow the 4.39 and 4.20 – 4.21 Reassembly instructions!*

*Follow the 5.1 – 5.5 and 5.9 – 5.13 Reassembly instructions!*

#### REMOVAL

*Use the Dentist Hook to remove the Loudspeaker from the cavity on the right hand side.*

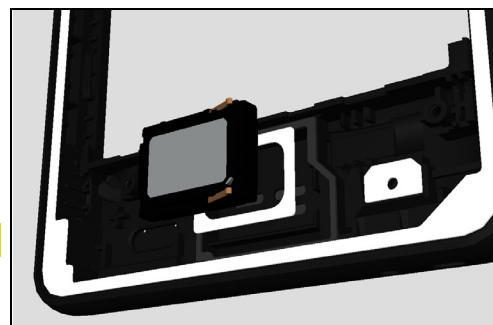
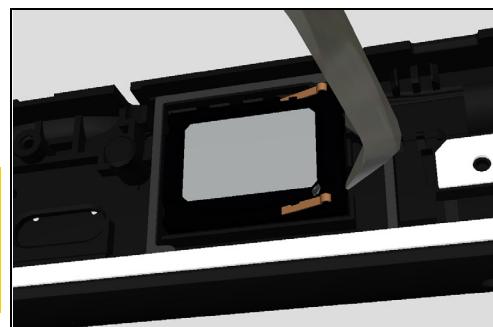
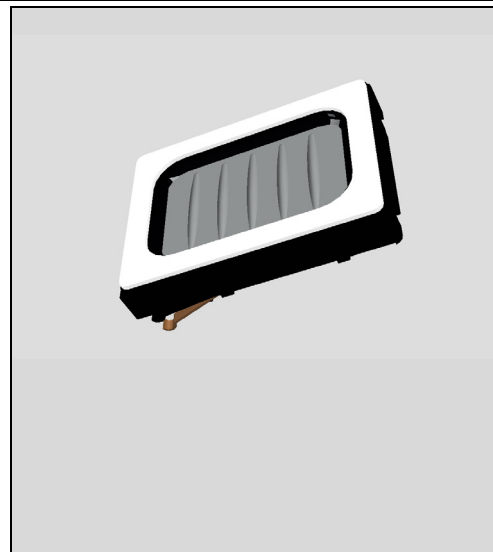
**Scrap both Loudspeaker and Adhesive Speaker, not to be reused!**

**Remove and clean any remaining adhesive residue found on Cover Main!**

#### INSTALLATION

*Place the new Adhesive Speaker and new Loudspeaker in the cavity.*

**Use the Generic Press Clamp 45N to fixate it for 10s!**



## Replacement

### 4.33 Net Speaker

*Follow the 3.1 – 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Net Speaker!*

*Carry out the Installation as described below!*

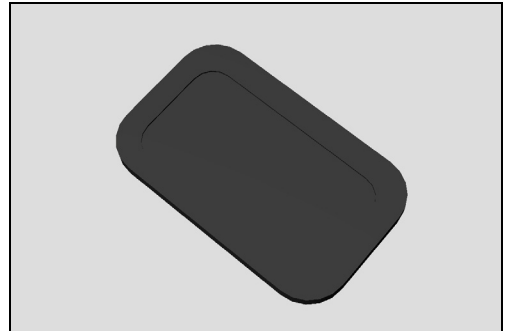
*Follow the 5.1 – 5.2 Reassembly instructions!*

#### REMOVAL

*Use your finger to peel of the Net Speaker.*

**Scrap Net Speaker, not to be reused!**

**Remove and clean any remaining adhesive residue found on Cover Main!**



#### INSTALLATION

*Place the new Net Speaker at correct position on the Cover Main and use a non sharp Nylon Pointer to add some extra force on the outer edge of the Net Speaker to secure that the adhesive is activated.*

**Be careful not to scratch the Net Speaker!**





## Replacement

### 4.34 Nut

*Follow the 3.1 – 3.7 Disassembly instructions!  
Carry out the Removal as described below!  
Prepare a new Nut!  
Carry out the Installation as described below!  
Follow the 5.7 – 5.13 Reassembly instructions!*

#### REMOVAL

Remove the Screw 2.2 by using a screwdriver with Bits (JCIS No 0).

**Scrap the Screw 2.2, not to be reused!**

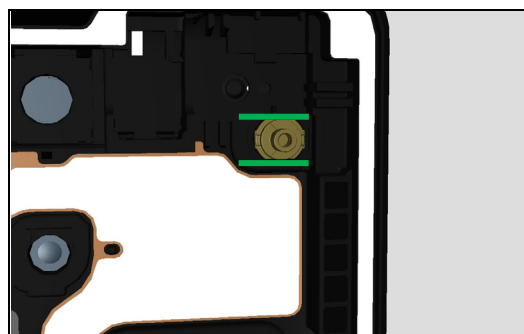
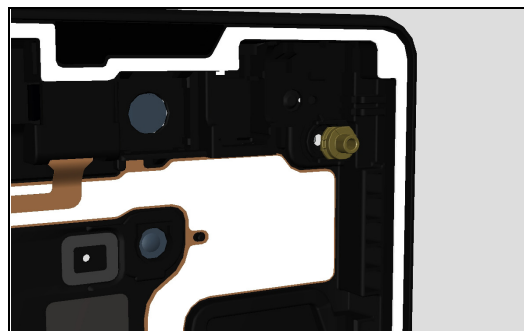
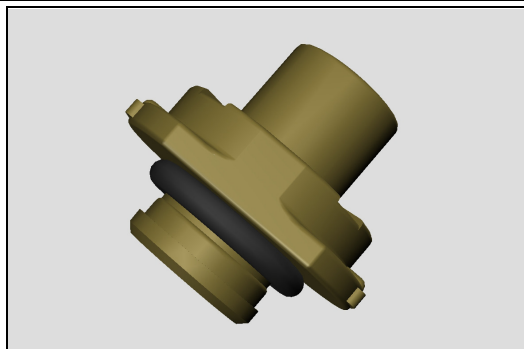
Remove the Nut with your hand.

#### INSTALLATION

*Place the Nut in place guided by the chamfering as reference.*

Secure the Nut by a new Screw 2.2.

Use Bits (JCIS No 0 →  $12 \pm 2$  Ncm torque).



## Replacement

### 4.35 Panel Key Power & Adhesive Panel Key Power

*Follow the 3.1 and 3.2 Disassembly instructions!*

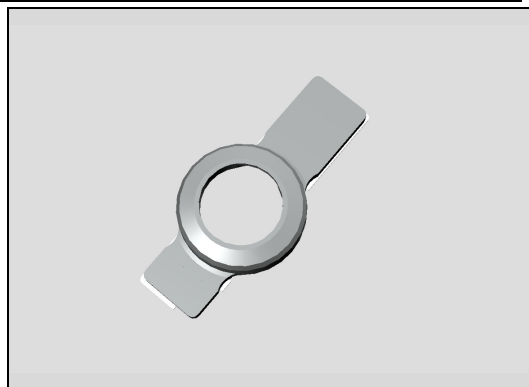
*Follow the 4.37 – 4.38 Removal instructions!*

*Prepare a new Panel Key Power & Adhesive Panel Key Power!*

*Carry out the Installation as described below!*

*Follow the 4.37 – 4.38 Reassembly instructions!*

*Follow the 5.12 and 5.13 Reassembly instructions!*



### REMOVAL

Gently remove the Panel Key Power with your fingers.

**Scrap the Panel Key Power and Adhesive Panel Key Power, not to be reused!**

**Remove and clean any remaining adhesive residue found on Cover Main!**



### INSTALLATION

Place the Adhesive Panel Key Power at the correct position according to picture before assemble the Panel Key Power.

**Secure its position with your fingers!**



## Replacement

### 4.36 Panel Side L

*Follow the 3.1 and 3.2 Disassembly instructions!  
Carry out the Removal as described below!  
Prepare a new Panel Side L!  
Carry out the Installation as described below!  
Follow the 5.12 and 5.13 Reassembly instructions!*

#### REMOVAL

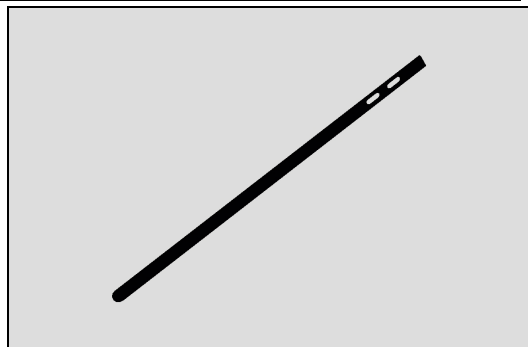
*Use a Dentist Hook to push Panel Side L out from the Cover Main.*

*Use cavity at the bottom of Cover Main for tool.*

***Make sure not to scratch or damage Cover Main!***

***Scrap Panel Side L, not to be reused!***

***Remove and clean any remaining adhesive residue found on Cover Main***



#### INSTALLATION

*Attach the Panel Side L according to picture.*

***Secure its position with your fingers!***



## Replacement

### 4.37 Panel Side R Bottom

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Panel Side R Bottom!*

*Carry out the Installation as described below!*

*Follow the 5.12 and 5.13 Reassembly instructions!*

#### REMOVAL

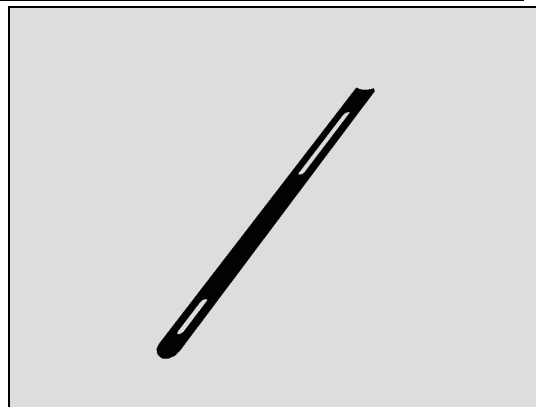
Use a Dentist Hook to push Panel Side R Bottom out from the Cover Main.

Use cavity at the bottom of Cover Main for tool.

**Make sure not to scratch or damage Cover Main!**

**Scrap Panel Side R Bottom, not to be reused!**

**Remove and clean any remaining adhesive residue found on Cover Main!**



#### INSTALLATION

Attach the Panel Side R Bottom according to picture.

**Secure its position with your fingers!**



## Replacement

### 4.38 Panel Side R Top

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Panel Side R Top!*

*Carry out the Installation as described below!*

*Follow the 5.12 and 5.13 Reassembly instructions!*

#### REMOVAL

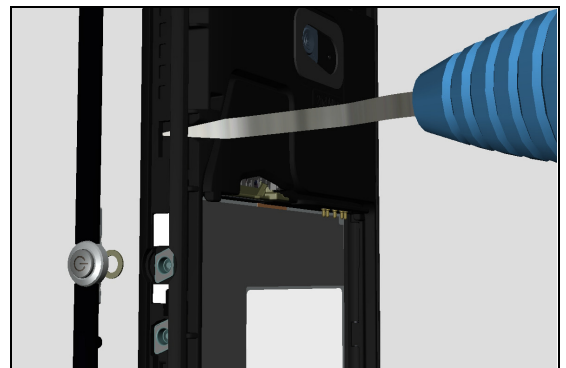
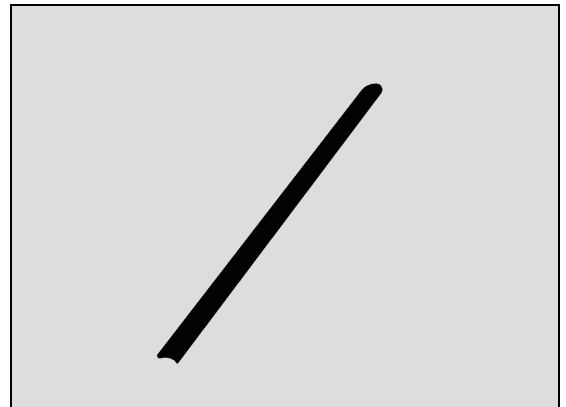
Use a Dentist Hook to push Panel Side R Top out from the Cover Main.

Use cavity closest to the Key Power for the tool.

**Make sure not to scratch or damage Cover Main!**

**Scrap Panel Side R Top, not to be reused!**

**Remove and clean any remaining adhesive residue found on Cover Main!**



#### INSTALLATION

Attach the Panel Side R Top according to picture.

**Secure its position with your fingers!**



## Replacement

### 4.39 PBA Antenna & Adhesive PBA Antenna

*Follow the 3.1 – 3.5 and 3.9 – 3.10 Disassembly instructions!*

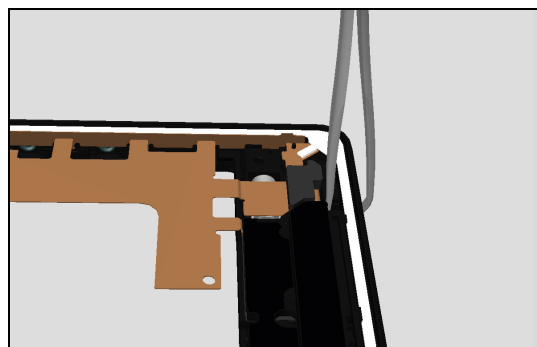
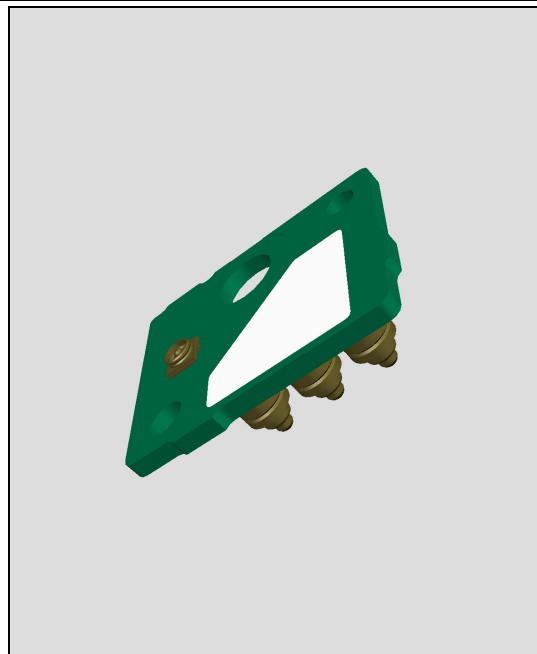
*Prepare a new PBA Antenna & Adhesive PBA Antenna!*

*Carry out the Installation as described below!*

*Follow the 5.4 – 5.5 and 5.9 – 5.13 Reassembly instructions!*

#### REMOVAL

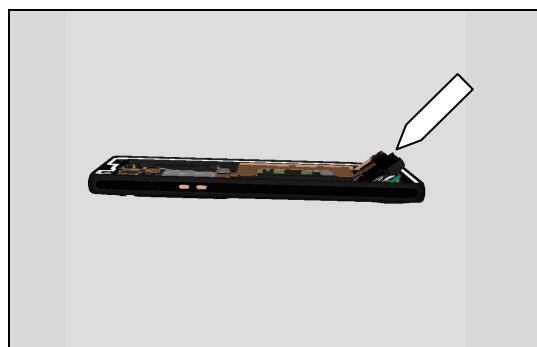
Use the Flex Film Assembly Tool to lift the lower part of the FPC Relay Assy



Loosen the PBA Antenna from the FPC Relay Assy.

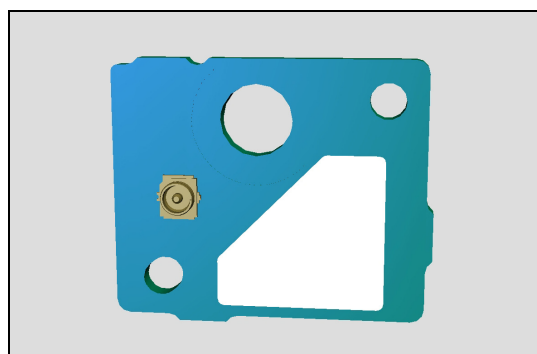
**Scrap the Adhesive PBA Antenna, not to be reused!**

**Make sure that no Adhesive residues are left on either PBA Antenna or FPC Relay Assy!**



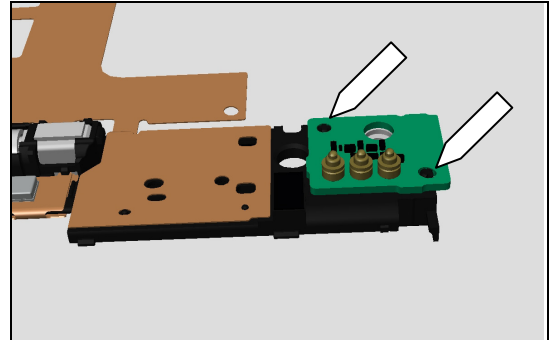
#### INSTALLATION

Place the Adhesive PBA Antenna on the PBA Antenna according to picture.



## Replacement: PBA Antenna & Adhesive PBA Antenna

Place the PBA Antenna according to picture guided by the two guiding pins and then lower it down to its cavity.



## Replacement

### 4.40 Sheet Magnetic NFC

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Follow the 4.22 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Sheet Magnetic NFC.*

*Carry out the Installation as described below!*

*Follow the 4.22 Reassembly instructions!*

*Follow the 5.7 – 5.13 Reassembly instructions!*

#### REMOVAL

Use your fingers to remove the Sheet Magnetic NFC from Cover Main Assy.

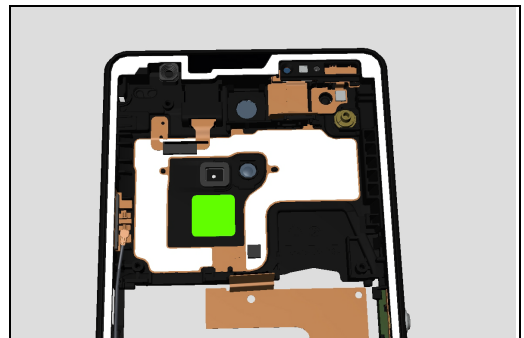
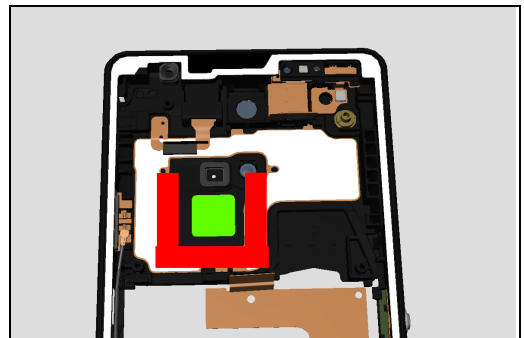
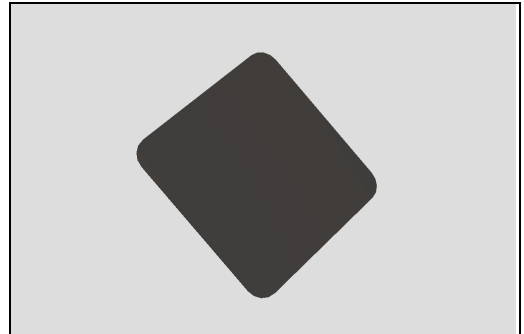
**Scrap the Sheet Magnetic NFC, not to be reused!**

**Make sure that you don't damage the FPC!**

**Remove and clean any remaining adhesive residue found on Cover Main!**

#### INSTALLATION

Place the new Sheet Magnetic on the Cover Main Assy according to picture.





## Replacement

### 4.41 Water Indicator

#### Pos.1

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Water Indicator.*

*Carry out the Installation as described below!*

*Follow the 5.7 and 5.13 Reassembly instructions!*

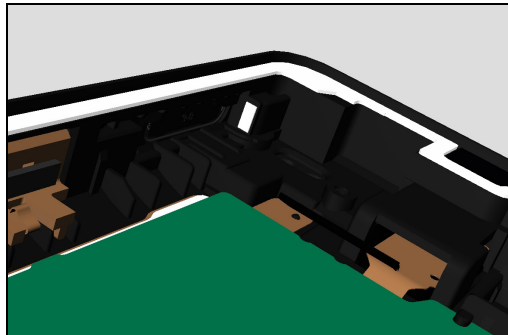
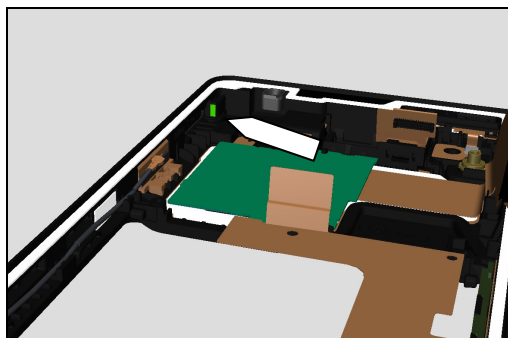
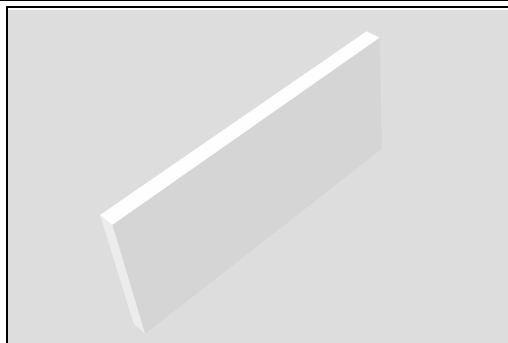
#### **Pos.1 REMOVAL**

Remove the old Water Indicator by peeling it off with the Nylon Pointer.

**Scrap Water Indicator, not to be reused!**

#### **Pos.1 INSTALLATION**

Place the new Water Indicator at the location marked on the picture guided by the shape of the surface on the Cover Main.



## Replacement: Water Indicator Pos.2

### Pos.2

*Follow the 3.1 – 3.7 Disassembly instructions!*

*Follow the 4.23 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Water Indicator.*

*Carry out the Installation as described below!*

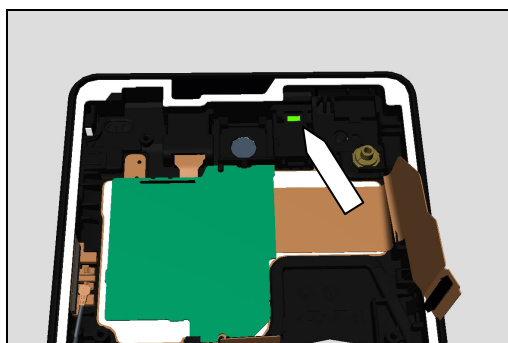
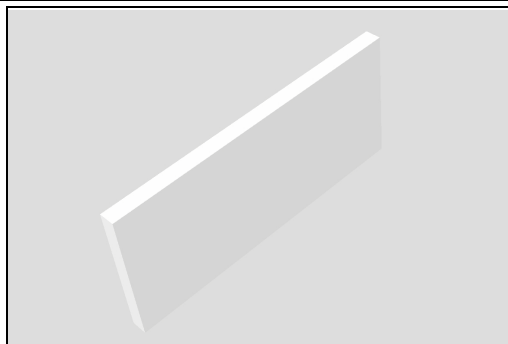
*Follow the 4.23 Reassembly instructions!*

*Follow the 5.7 and 5.13 Reassembly instructions!*

### **Pos.2 REMOVAL**

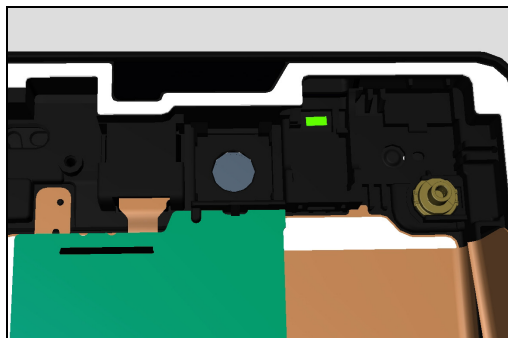
Remove the old Water Indicator by peeling it off with the Nylon Pointer.

**Scrap Water Indicator, not to be reused!**



### **Pos.2 INSTALLATION**

Place the new Water Indicator at the location marked on the picture guided by the shape of the surface on the Cover Main.



## Replacement: Water Indicator Pos.3

### Pos.3

*Follow the 3.1 – 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Water Indicator.*

*Carry out the Installation as described below!*

*Follow the 5.12 and 5.13 Reassembly instructions!*

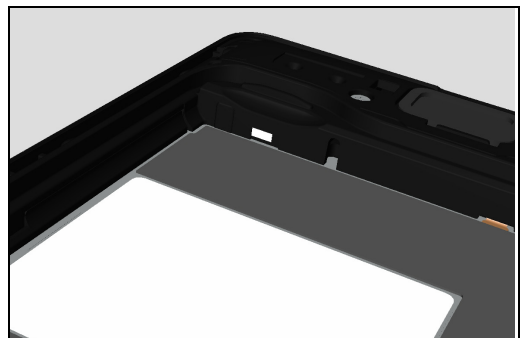
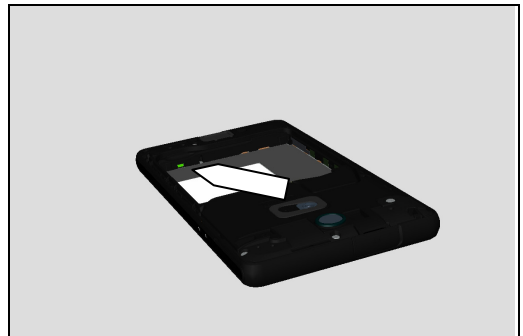
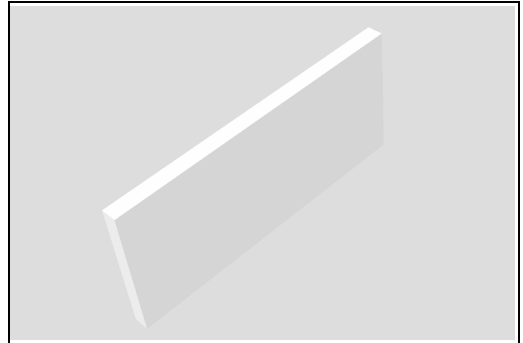
### **Pos.3 REMOVAL**

Remove the old Water Indicator by peeling it off with the Nylon Pointer.

**Scrap Water Indicator, not to be reused!**

### **Pos.3 INSTALLATION**

Place the new Water Indicator at the location marked on the picture guided by the shape of the surface on the Cover Main.



## Replacement

### 4.42 Washer Key Power

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Follow the 4.37 – 4.38 and 4.35 Removal instructions!*

*Prepare a new Washer Key Power!*

*Carry out the Installation as described below!*

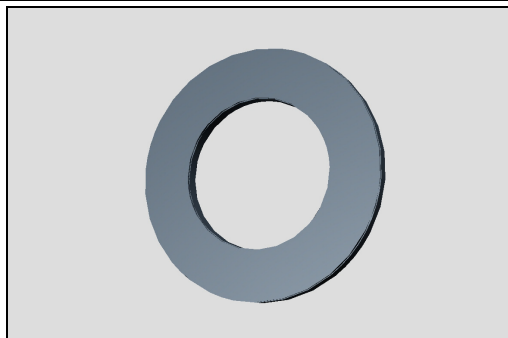
*Follow the 4.35 and 4.37 – 4.38 Reassembly instructions!*

#### REMOVAL

Remove the old WI Top by peeling it off with the Nylon Pointer.

#### INSTALLATION

Place the new WI Top at the location marked on the picture guided by the lines on the PBA Complete.



## Replacement

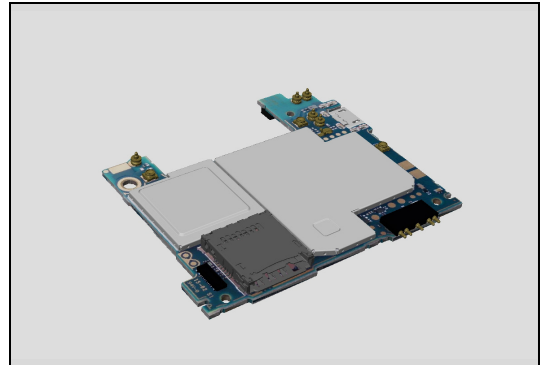
### 4.43 Board Swap - Replacement

*Follow the 3.1 – 3.7 Disassembly instructions!*

Follow the 4.25 Removal instructions!

Replace the Swap Board.

Follow the 4.25 Reassembly instructions!



*Follow the 5.7 – 5.13 Reassembly instructions!*

Press the Key On/Off to power on the phone, place unit on flat desk and wait 4 minutes until system boot up has been completed.

**Please DO NOT move the phone during starting up until "Select Language" menu is shown on the display!**

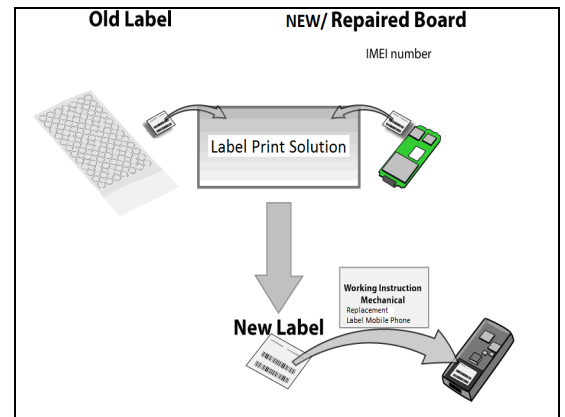
After "Select Language" menu, turn off the phone.

## Replacement

### 4.44 Board Swap – Change Label

#### CHANGE LABEL

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

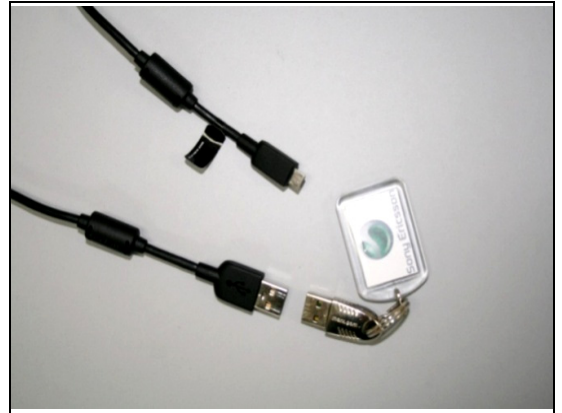


## Replacement

### 4.45 Board Swap – Customize of Software

#### CUSTOMIZE OF SOFTWARE

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

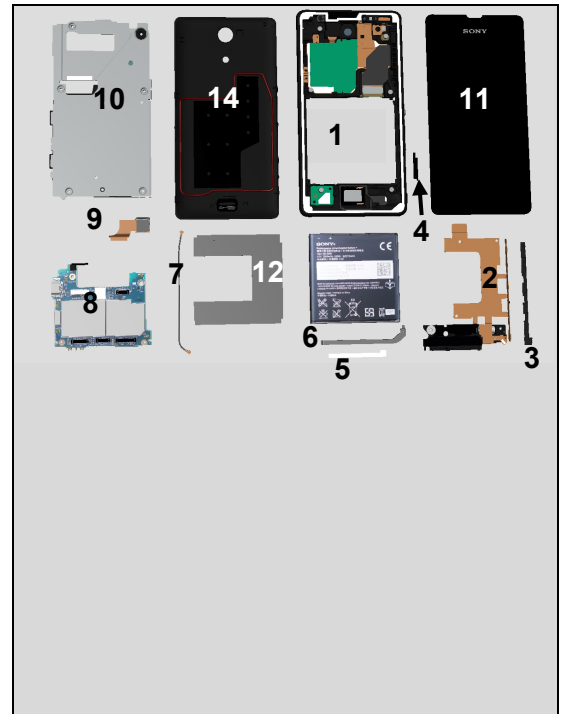


## 5 Re-Assembly

The Disassembly is done to the following modules:

1. Cover Main Assy\*
2. FPC Relay Assy\*
3. Holder Side Keys
4. Sheet Battery Side
5. Lightguide Sheet
6. Lightguide
7. RF Coax Cable
8. Main PBA
9. Camera
10. Support Plate
11. Display
12. Sheet FPC Relay
13. Battery 2300 mAh BA950
14. Cover Battery

\*) Assy and Unit is used when several parts are handled



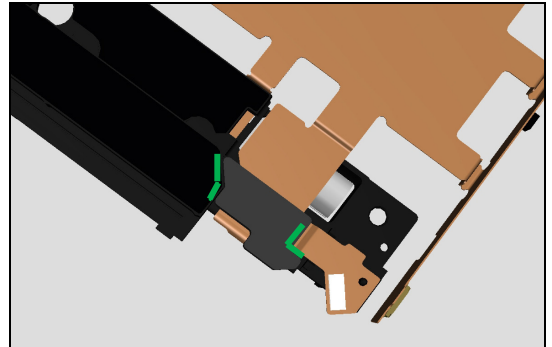


## Re-Assembly

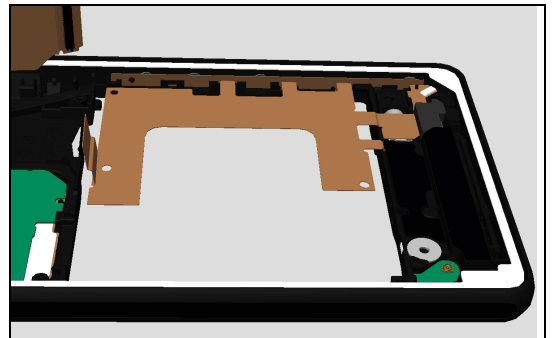
### 5.1 FPC Relay Assy

Prepare a new Cover Main and assemble a new Cushion Window onto it.

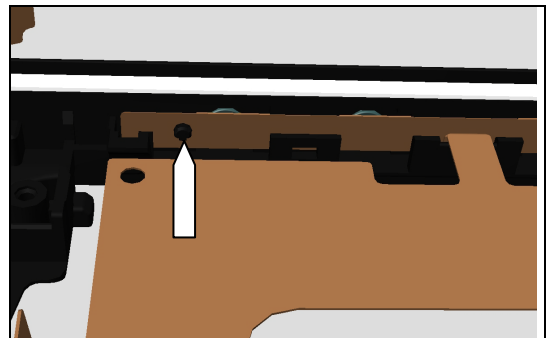
Align it according to picture.



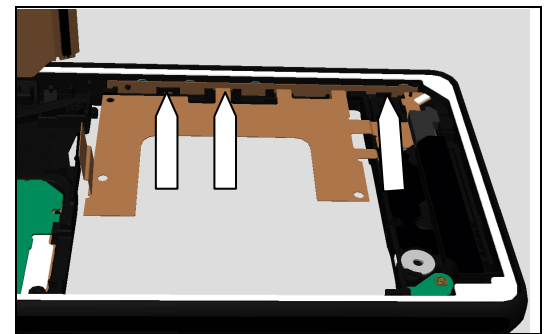
Place the Cover Main Assy into its cavity in the Cover Main



Align the FPC with the hole and steering pin.



Secure its position by adding some extra force to the 3 places where the adhesive are.

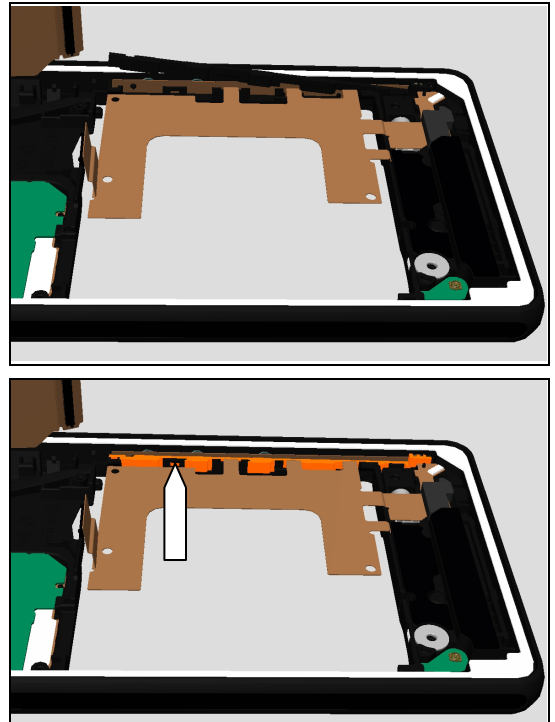


## Re-Assembly

### 5.2 Holder Side Keys

Insert a new Holder Side Keys into the Cover Main.

***Secure that the Holder Side Keys have snapped into place!***



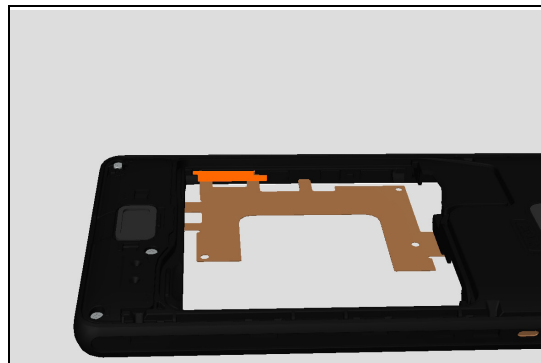
## Re-Assembly

### 5.3 Sheet Battery Side

Prepare a new Sheet Battery Side.

Place it into its cavity on the Cover Main according to picture.

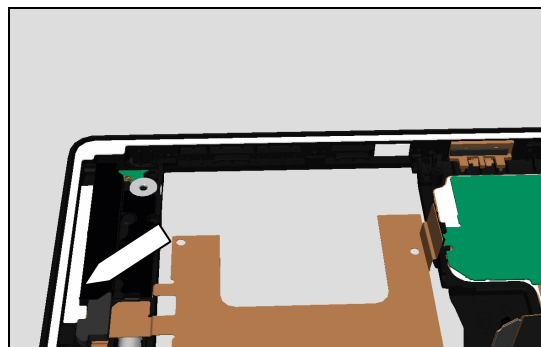
**Secure the Sheet Battery Side with your fingers!**



### 5.4 Lightguide Sheet

Prepare a new Lightguide Sheet.

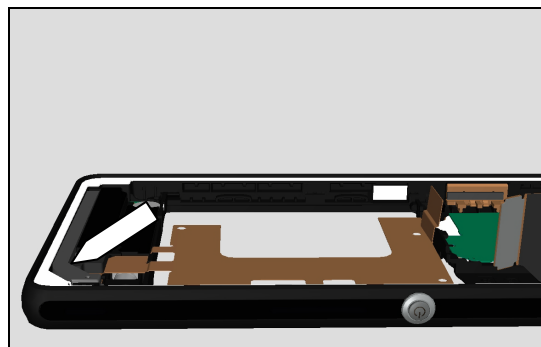
Place it into its cavity on the FPC Relay Assy according to picture.



### 5.5 Lightguide

Prepare the Lightguide.

Place it into its cavity on the FPC Relay Assy according to picture.



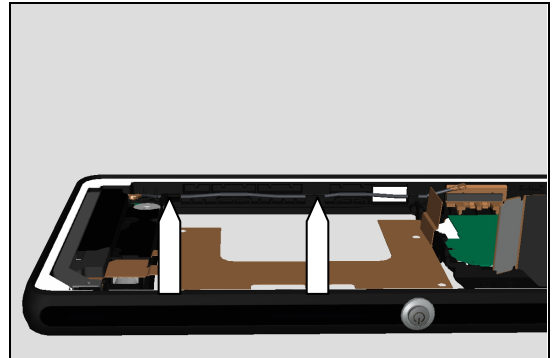
## Re-Assembly

### 5.6 RF Coax Cable

Prepare the RF Coax Cable

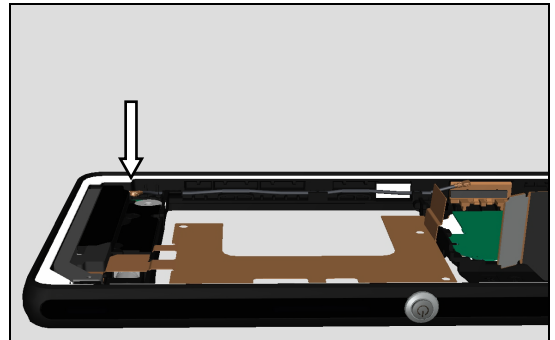
Insert the RF Coax Cable into the Cover Main.

**Secure that the RF Coax Cable have snapped into place!**



Attach the lower part of the RF Coax Cable on to the PBA Antenna.

**Secure the position with your fingers!**



## Re-Assembly

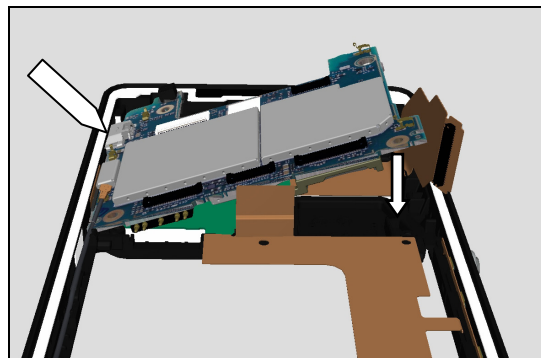
### 5.7 Main PBA

Prepare the Main PBA.

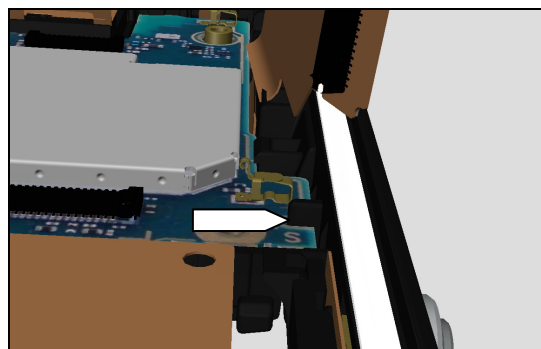
Insert first the Micro USB into the Cover Main as shown on the picture.

Then lower the Main PBA into place in the Cover Main.

**Secure that the FPC's are not squeezed or damaged!**

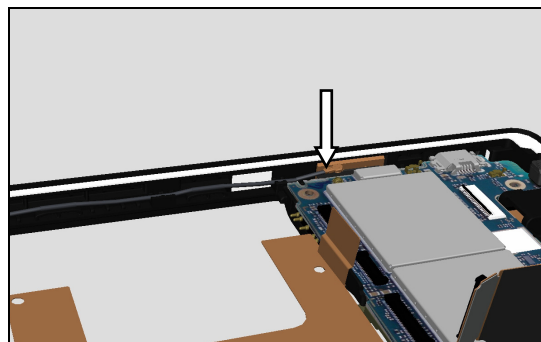


**Secure that the Main PBA have snapped into place!**



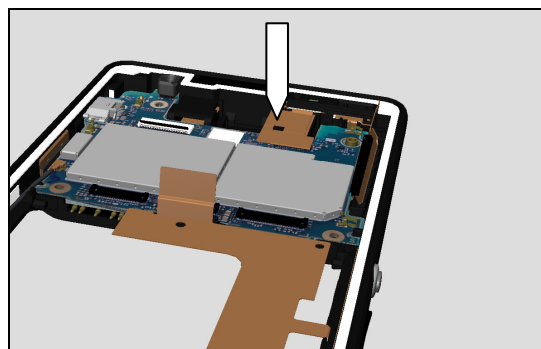
Attach the upper part of the RF Coax Cable on to the Main PBA.

**Secure the position with your fingers!**



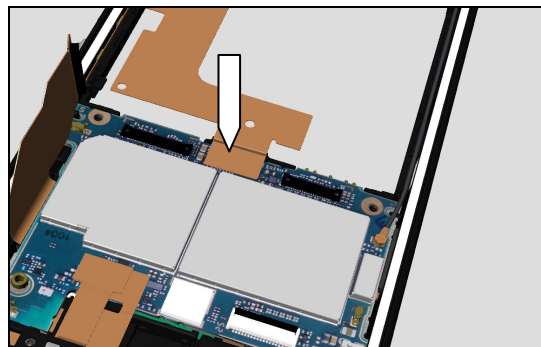
Attach the BtB from FPC Top Compl to the Main PBA.

**Secure the position with your fingers!**



Attach the BtB from FPC Relay to the Main PBA.

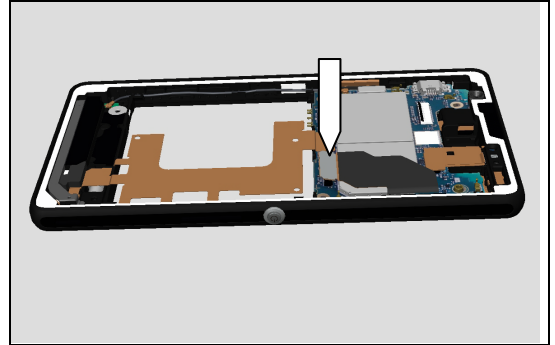
**Secure the position with your fingers!**



## Re-Assembly: Main PBA

Attach the BtB from FPC PBA NFC to the Main PBA.

**Secure the position with your fingers!**



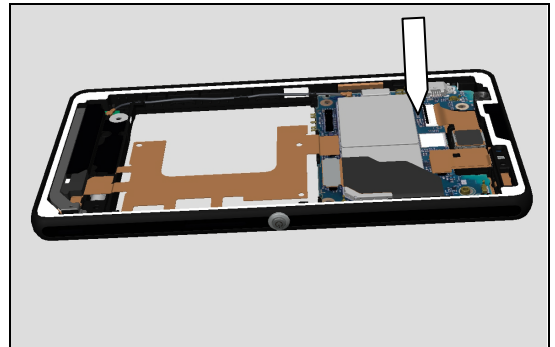
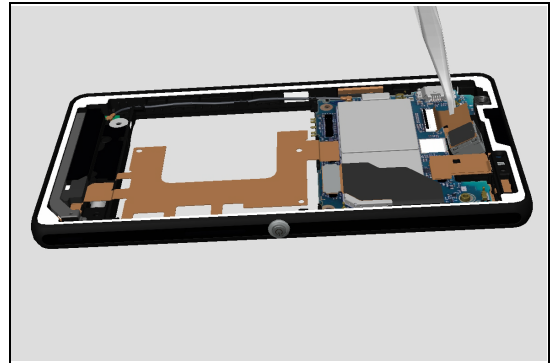
## Re-Assembly

### 5.8 Camera

Prepare the Camera.

Use a Flex Film Assembly Tool to insert the Camera into the ZIF contact on the Main PBA.

Lock the ZIF contact with your fingers.

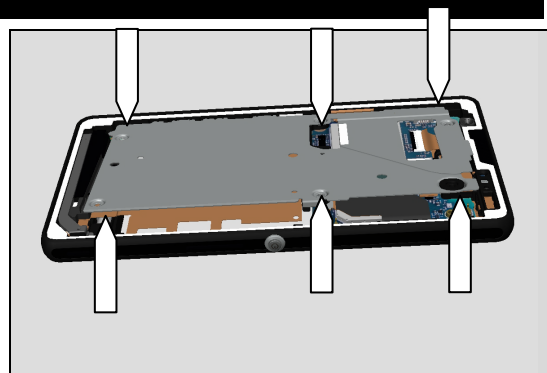


## Re-Assembly

### 5.9 Support Plate

Prepare a new Support Plate.

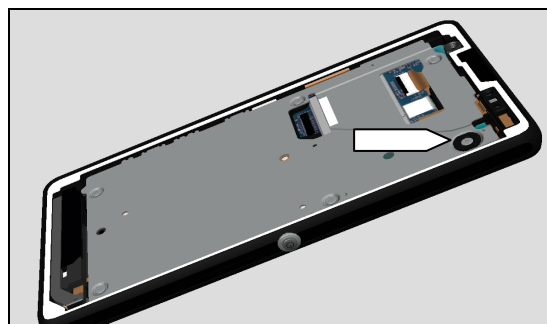
Gently insert the Support Plate, long-side first, into the Cover Main, guided by the holes for the screws.



Secure its position by with a new Screw 2.0.

Use Bits (JCIS No 0 →  $10 \pm 2$  Ncm torque).

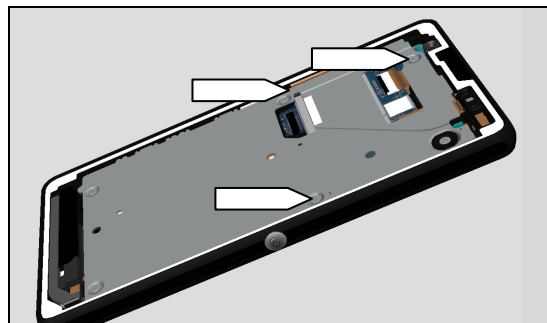
**Do not damage the components on the PBA Complete!**



Secure its position by with new Screws 3.4.

Use Bits (JCIS No 0 →  $12 \pm 2$  Ncm torque).

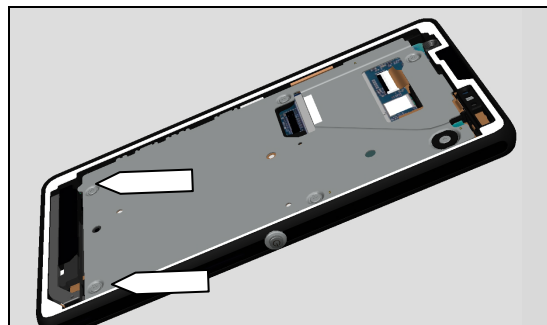
**Do not damage the components on the PBA Complete!**



Secure its position by with new Screws 5.0.

Use Bits (JCIS No 0 →  $12 \pm 2$  Ncm torque).

**Do not damage the components on the PBA Complete!**





## Re-Assembly

### 5.10 Display

**Remove and clean any remaining adhesive residue found on Cover Main Assy and Display.**

Place the new Adhesive Display in the Display Adhesive alignment fixture.

Place the Cover Main on top of the Adhesive Display in the Display Adhesive alignment fixture.

Secure its position by applying some pressure with your hand during 5s on the Main Cover

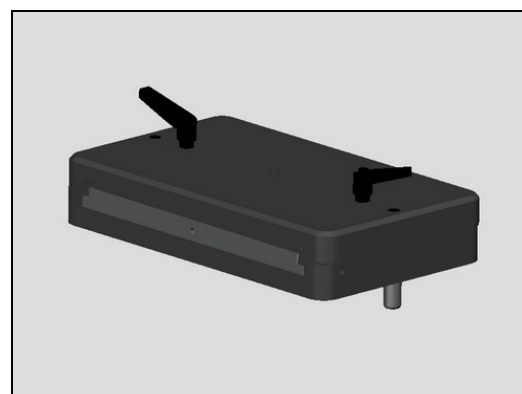
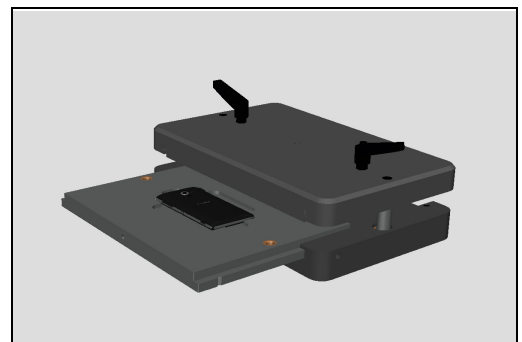
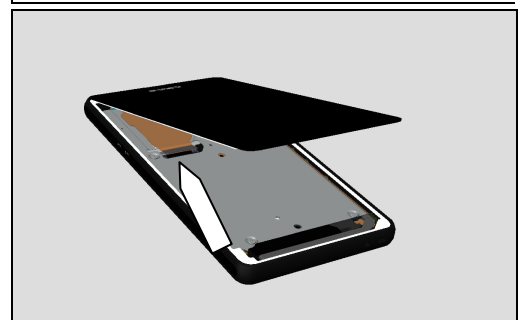
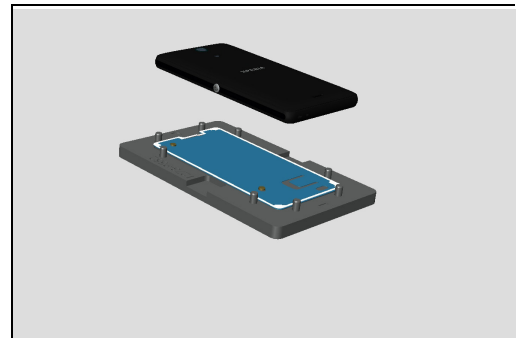
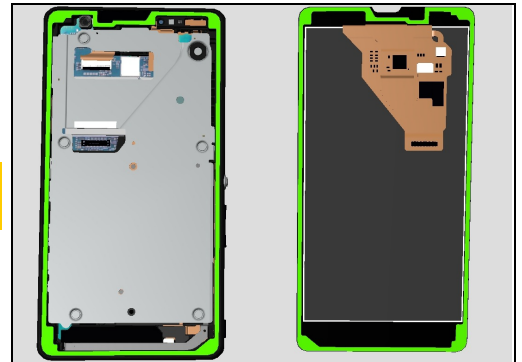
Mount the Display according to picture and attach the BtB connector from the Display to the Cover Main Assy before lowering the Display into place.

**Upper inlay = Display Press Top Inlay**

**Lower inlay = Bottom Press Inlay**

Place the phone 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 360N for ten seconds (pressure value is adjust from 480N because of the weight of the press fixture)

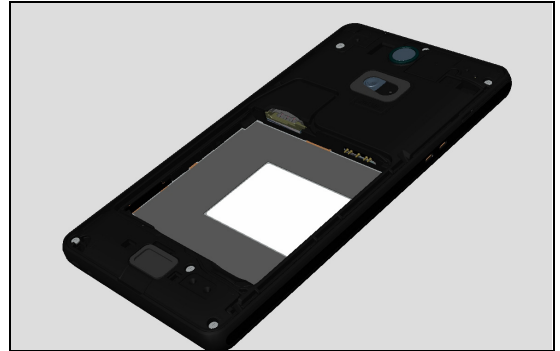


## Re-Assembly

### 5.11 Sheet FPC Relay

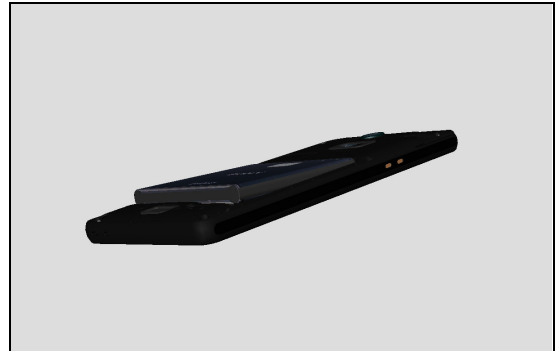
Prepare a new Sheet FPC Relay place it according to picture in the cavity form the Battery 2300 mAh BA950.

**Secure the Sheet FPC Relay is in place with your fingers!**



### 5.12 Battery 2300 mAh BA950

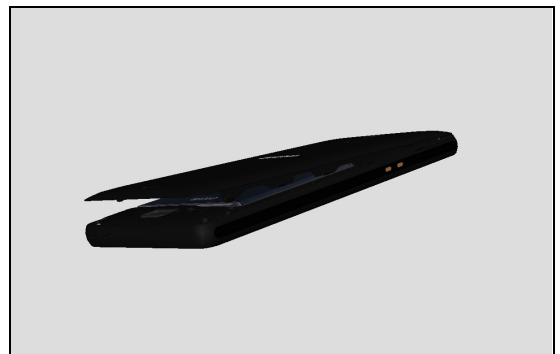
Insert the Battery 2300 mAh BA950 into its cavity in the Cover Main Assy.



### 5.13 Cover Battery

Assemble the Cover Battery to the Cover Main Assy.

**Secure that the Cover Battery is tight on all sides by firmly pressing it with your fingers!**



## 6 Revision History

Rev.	Date	Changes / Comments
1	2013-June-13	First Release