

# SONY

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## Working Instructions

- mechanical -



*Xperia™ ZL*  
*C6502, C6503, C6506 & L35h*

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**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

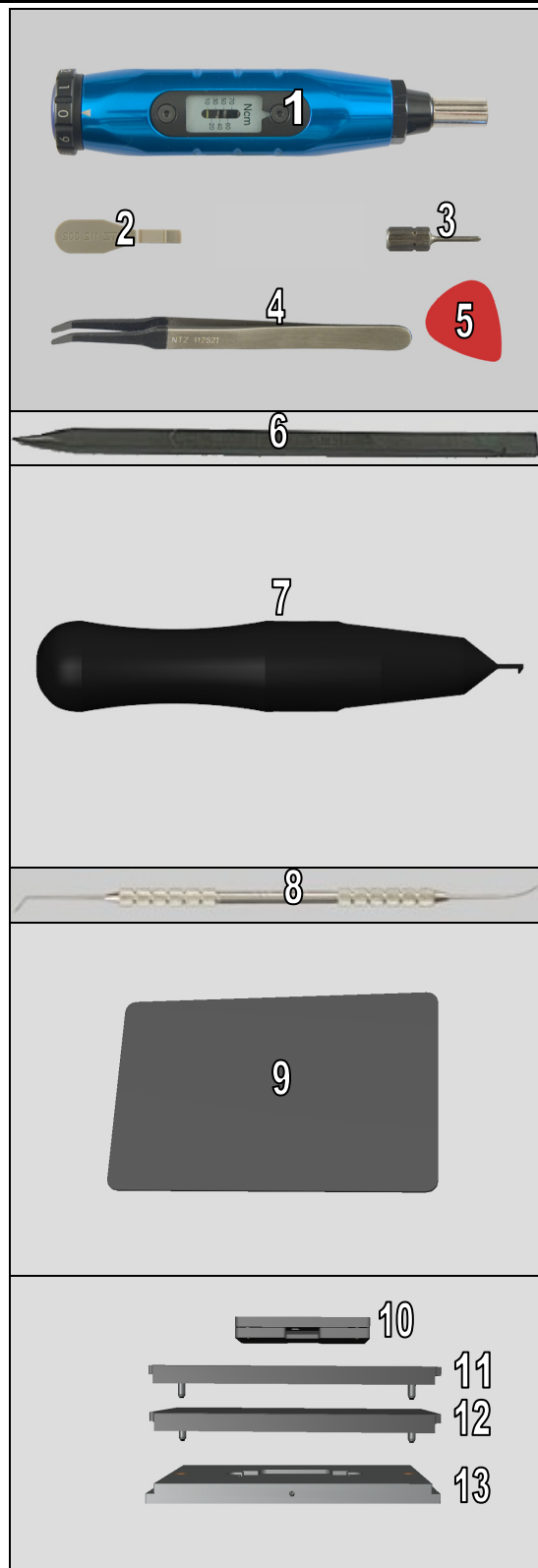
6. Nylon pointer

7. Battery Connector Removal Tool

8. Dentist hook

9. Battery Removal Tool

10. Backcover Adhesive alignment fixture
11. Backpanel press Top Inlay
12. Battery press Top Inlay
13. Bottom Press Inlay



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

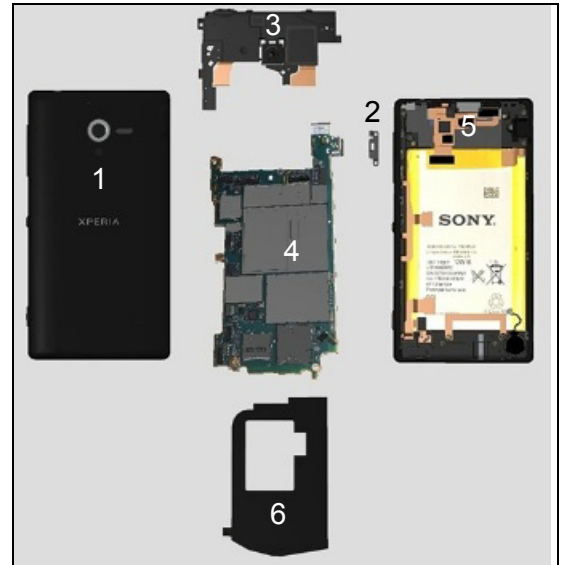


## 3 Disassembly

The Disassembly is done to the following modules:

1. Back Cover Assy\*
2. Clip USB
3. Carrier Spbox Assy\*
4. PBA Complete Assy\*
5. Front Assy Unit\*
6. Ant NFC

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



## Disassembly

### 3.1 Back Cover Assy

Open the Cover Card.

**SIM card and Memory Card needs to be removed!**

Unfold the label to remove the 2 Screw 3.0 by using a screwdriver with Bits (JCIS No 0).

**Scrap! Not to be reused!**

Insert a Guitar Pick as shown in picture loosen the adhesive along the right side according to the picture.

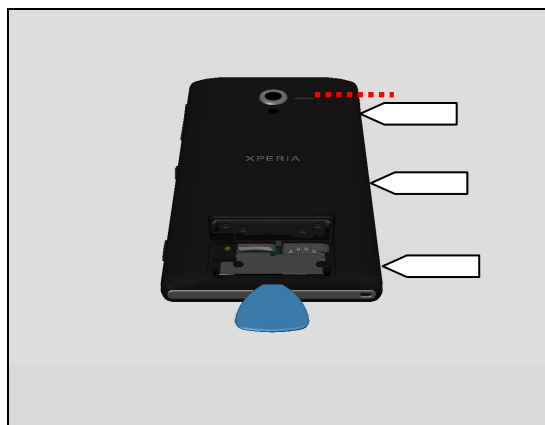
Unlatch the 3 snaps with a Guitar pick.

**Stop at the red line (5mm below the Flash LED) to avoid damage on hidden flex!**

Gently break open the Back Cover Assy with a counter clockwise movement.

**Gently rub with a Nylon Pointer to remove the Adhesive Backcover.**

**Remove and clean any remaining adhesive residue found on Back Cover Assy and Front Assy Unit**

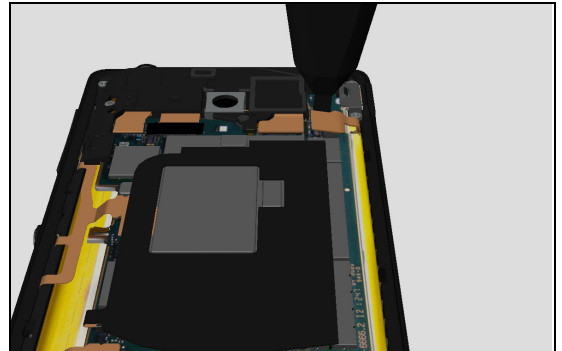


## Disassembly

### 3.2 Disconnect battery

Use the Battery Connector Removal Tool to remove the BtB connector from the Battery 2300 mAh.

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

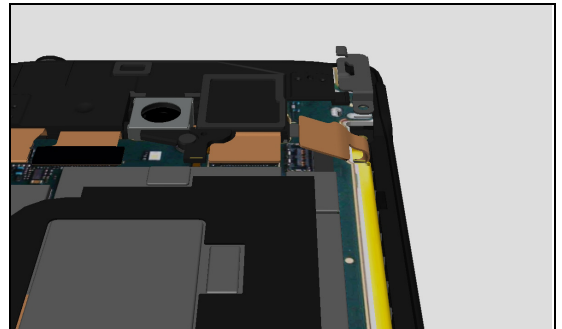


### 3.3 Clip USB

Remove the two Screw 3.0 screws holding the Clip USB by using a screwdriver with Bits (JCIS No 0).

**Scrap! Not to be reused!**

Remove the Clip USB.



## Disassembly

### 3.4 Carrier Spbox

Remove the BtB connectors from the Camera 13MP and the FPC AVP with the Front Opening Tool.

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

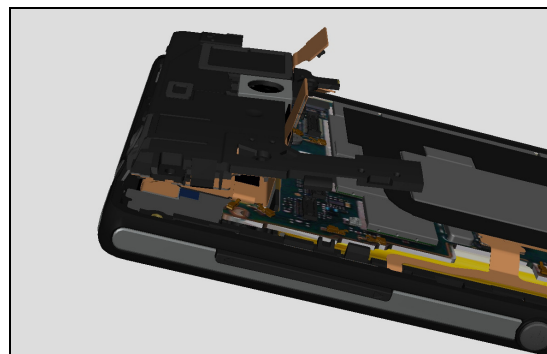
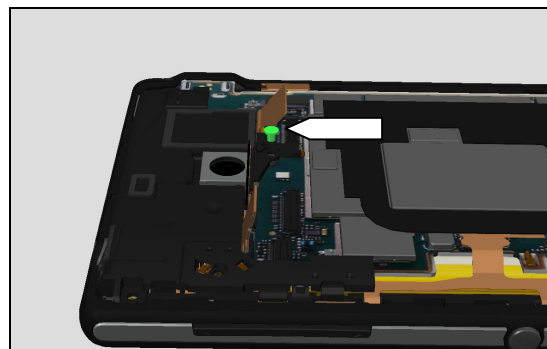
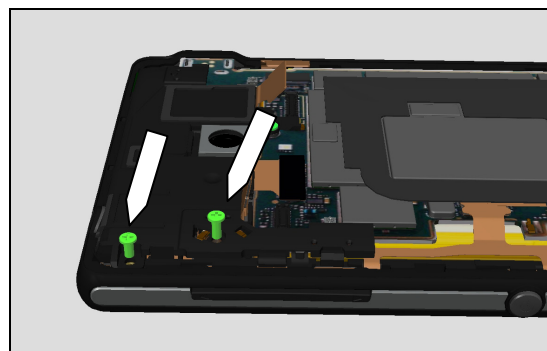
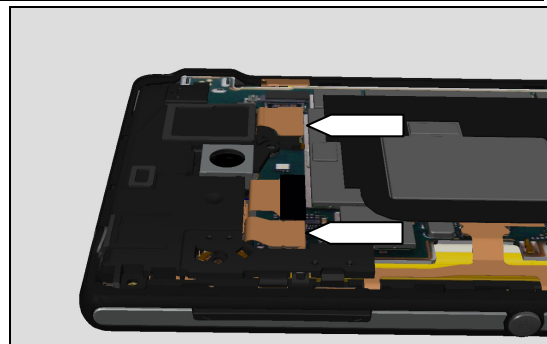
Remove the two Screw 3.0 screws holding the Carrier Spbox Assy by using a screwdriver with Bits (JCIS No 0).

**Scrap! Not to be reused!**

Also remove the Screw 3.5 screw holding the Carrier Spbox Assy, by using a screwdriver with Bits (JCIS No 0).

**Scrap! Not to be reused!**

Gently lift up the Carrier Spbox Assy.

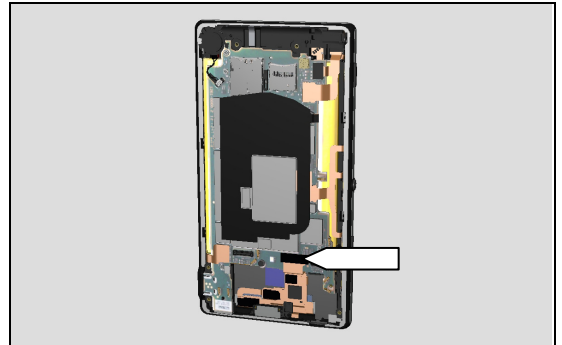


## Disassembly

### 3.5 PBA Complete Assy

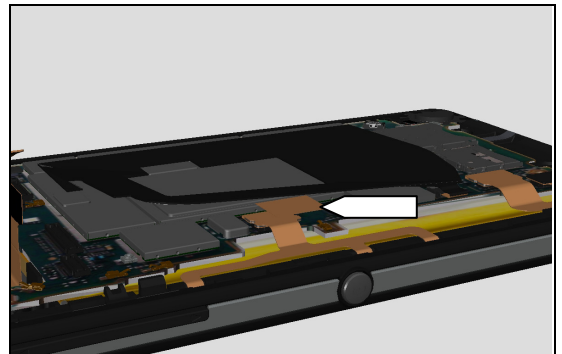
Use the Front Opening Tool to remove the BtB connector from Front Assy Unit connected to the PBA Complete Assy.

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



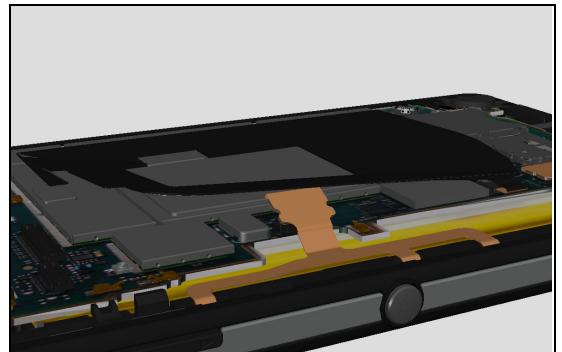
Gently lift the part of the Ant NFC that is above the BtB connector from FPC Side Key and peel of the Adhesive NFC from the BtB with a Flex Film Assembly Tool.

**Do not damage the Ant NFC!**



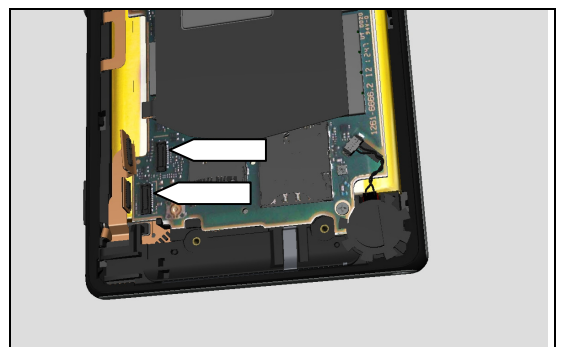
Use the Front Opening Tool to remove the BtB connector from the FPC Side Key.

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



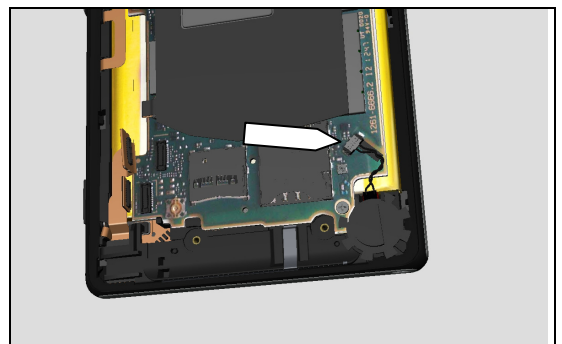
Also remove the BtB connector from the Camera 2.2 MP and the FPC camera Key PBA from the PBA Complete with a Front Opening Tool.

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



Use the Front Opening Tool to remove the BtB connector from the PBA Complete and loosen the wire from the Adhesive Vibrator.

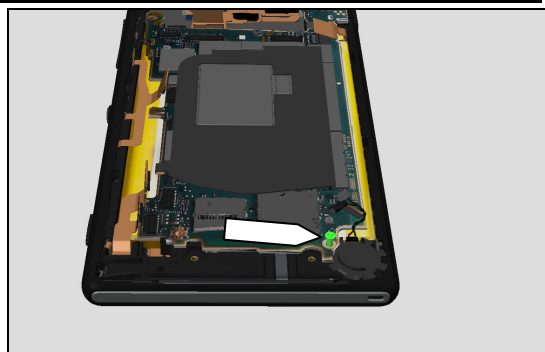
Do not damage the components on the PBA Complete!



## Disassembly

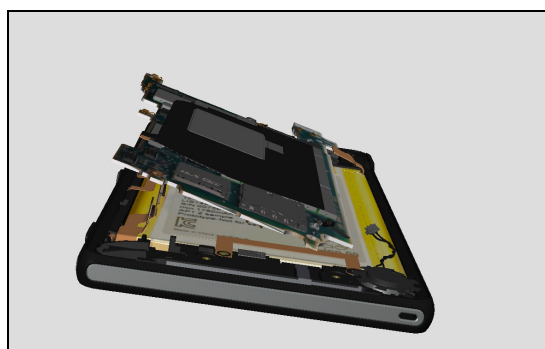
Remove the Screw 3.0 holding the PBA Complete Assy by using a screwdriver with Bits (JCIS No 0).

**Scrap! Not to be reused!**



Gently lift the PBA Complete Assy, Front left side first as shown in picture.

**Do not damage the Flex Films or the wires!**



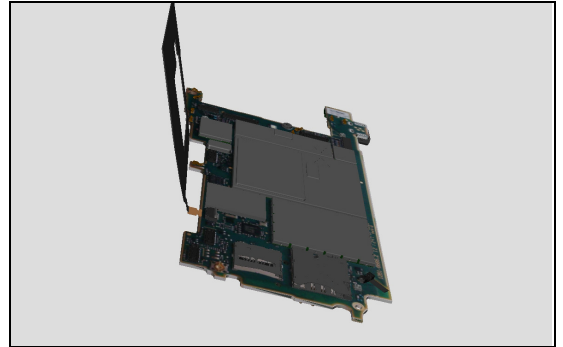
## Disassembly

### 3.6 Ant NFC

Gently peel off and lift the Ant NFC starting from the opposite side of the connector.

Open the ZIF connector with the Front Opening Tool and loosen the Ant NFC from the PBA Complete.

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



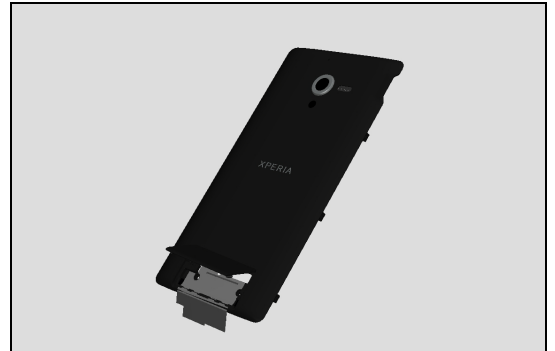
## 4 Replacement

### 4.1 Back Cover Assy

*Follow the 3.1 Disassembly instructions!*

Prepare a new Back Cover Assy.

Follow the 5.6 Reassembly instructions!

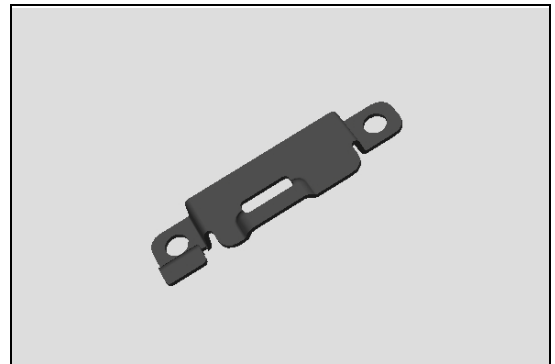


### 4.2 Clip USB

*Follow the 3.1 – 3.3 Disassembly instructions!*

Prepare a new Clip USB.

Follow the 5.4 – 5.6 Reassembly instructions!

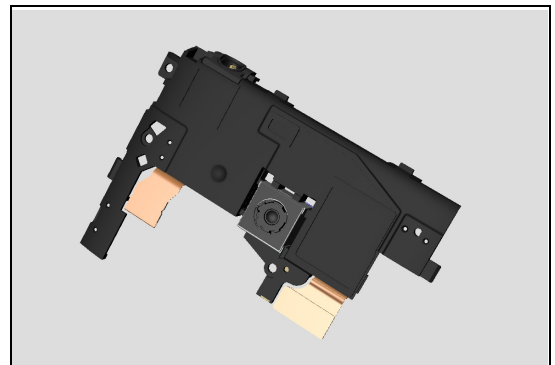


### 4.3 Carrier Spbox Assy

*Follow the 3.1 – 3.4 Disassembly instructions!*

Prepare a new Carrier Spbox Assy.

Follow the 5.3 – 5.6 Reassembly instructions!



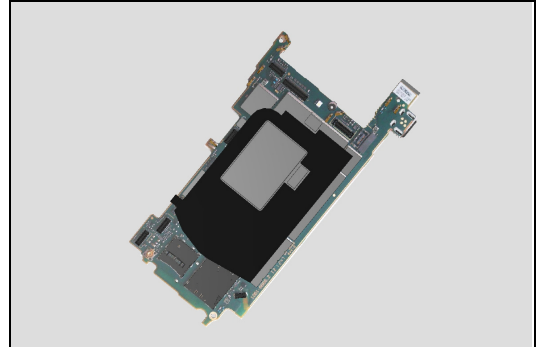
## Replacement

### 4.4 PBA Complete Assy

*Follow the 3.1 – 3.5 Disassembly instructions!*

Prepare a new PBA Complete Assy.

Follow the 5.2 – 5.6 Reassembly instructions!



### 4.5 Front Assy Unit

*Follow the 3.1 – 3.5 Disassembly instructions!*

Prepare a new Front Assy Unit.

Follow the 5.2 – 5.6 Reassembly instructions!



## Replacement

### 4.6 Adhesive Backcover

*Follow the 3.1 Disassembly instructions!*

*Prepare a new Adhesive Backcover.*

*Carry out the Installation as described below!*

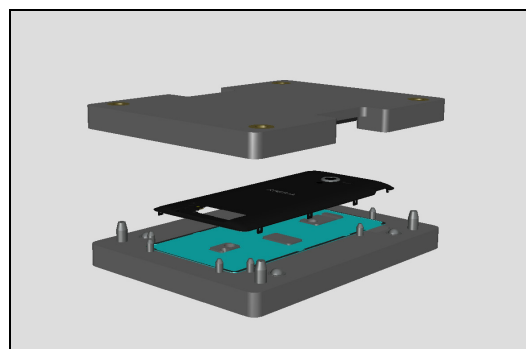
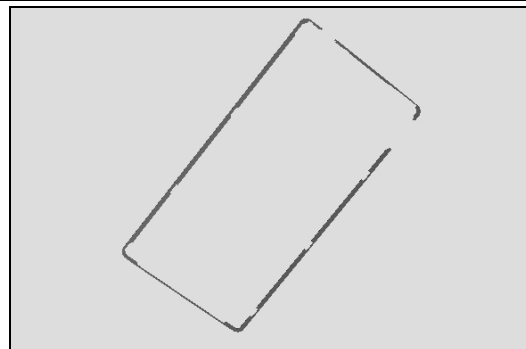
*Follow the 5.6 Reassembly instructions!*

#### INSTALLATION

*Place the new Backcover Adhesive in the Backcover Adhesive alignment fixture.*

*Place the Back Cover on top of the Backcover in the Backcover Adhesive alignment fixture.*

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



#### REMOVAL

***Make sure that both the Back Cover Assy and the Front Assy Unit is clean from old Adhesive Battery.***



## Replacement

### 4.7 Adhesive Battery

*Follow the 3.1 – 3.5 Disassembly instructions!*  
*Follow the 4.50, 4.9, 4.15 and 4.14 Removal instructions!*  
*Carry out the Removal as described below!*  
*Prepare a new Adhesive Battery.*  
*Carry out the Installation as described below!*  
*Follow the 4.14, 4.15, 4.9 and 4.50 Installation instructions!*  
*Follow the 5.2 – 5.6 Reassembly instructions!*

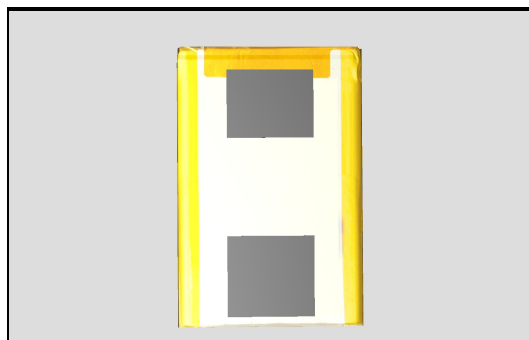
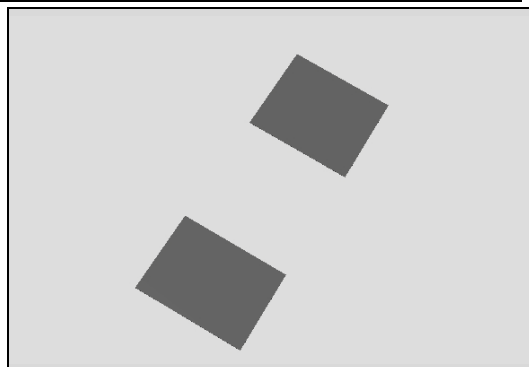
**Scrap the Adhesive Battery, not to be reused!**

#### REMOVAL

Peel of the old Adhesive Battery and its residue with your fingers.

#### INSTALLATION

Place the Adhesive Battery with the protection film at its place on the Battery 2300 mAh and apply some pressure with your fingers before removing the protection film.



## Replacement

### 4.8 Adhesive Label

*Carry out the Removal as described below!*

Prepare a new Adhesive Label.

*Carry out the Installation as described below!*

#### REMOVAL

Open the Cover Card.

**SIM card and Memory Card needs to be removed!**

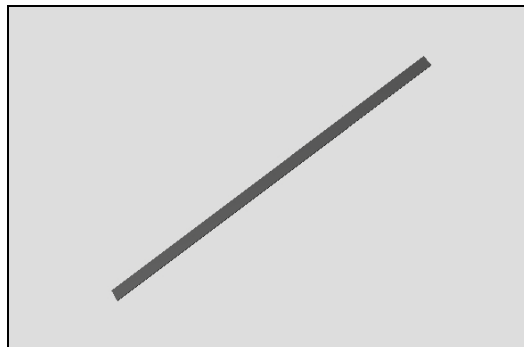
Open the Cover Card and unfold the Label Mobile Phone.

Gently peel off the Adhesive Label.

**Scrap the Adhesive Label! Not to be reused!**

#### INSTALLATION

Attach a new Adhesive Label to the Label Mobile Phone according to the picture.



## Replacement

### 4.9 Adhesive Vibrator

*Follow the 3.1 – 3.2 Disassembly instructions!*

*Follow the 4.50 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Adhesive Vibrator.*

*Carry out the Installation as described below!*

*Follow the 4.50 Installation instructions!*

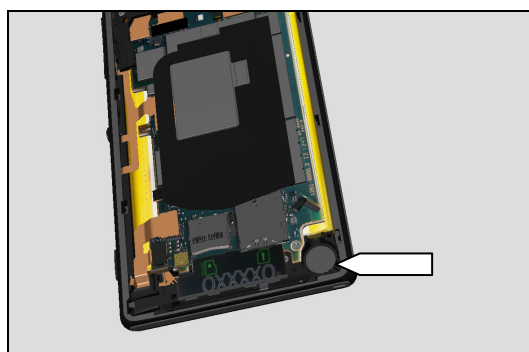
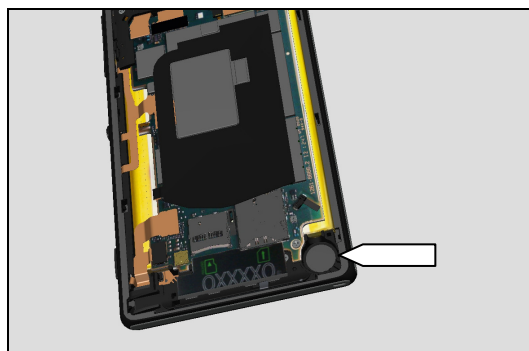
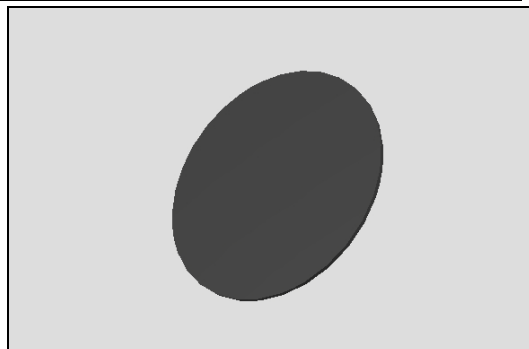
*Follow the 5.5 – 5.6 Reassembly instructions!*

#### REMOVAL

*Use the Flex Film Assembly Tool to peel of the Adhesive Vibrator.*

#### INSTALLATION

Place the new Adhesive Vibrator in the cavity for the vibrator.



## Replacement

### 4.10 Adhesive Vibrator Wire

*Follow the 3.1 – 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Adhesive Vibrator Wire.*

*Carry out the Installation as described below!*

*Follow the 5.5 – 5.6 Reassembly instructions!*

#### REMOVAL

Use the Front Opening Tool to remove the BtB connector from the Vibrator and remove the wire from the Vibrator Adhesive.

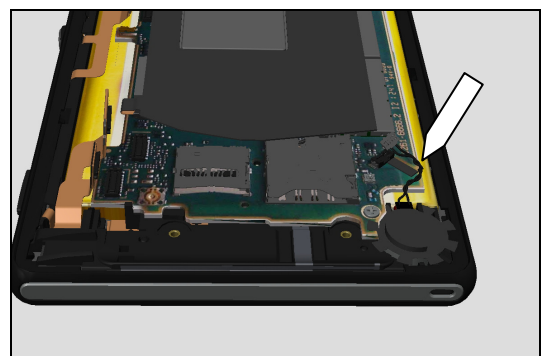
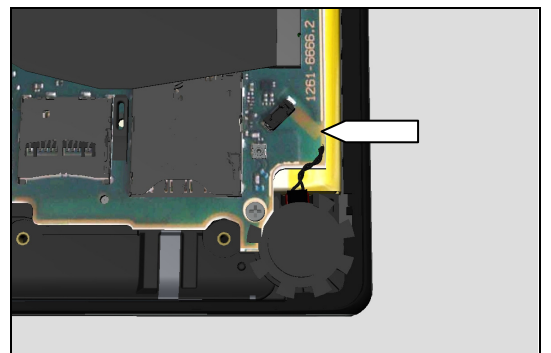
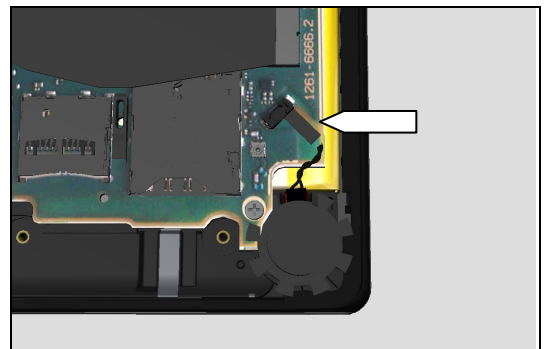
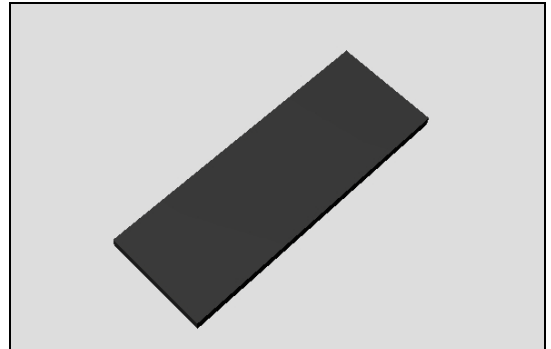
**Do not damage the components on the PBA Complete!**

Gently peel of the Adhesive Vibrator Wire.

#### INSTALLATION

Place the new Adhesive Vibrator Wire on the PBA Complete according to marking in PBA Complete.

Connect the BtB Connector from the Vibrator to the PBA Complete and secure its wires on the Adhesive Vibrator Wire with your fingers.



## Replacement

### 4.11 Ant NFC

*Follow the 3.1 – 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Ant NFC.*

*Carry out the Installation as described below!*

*Follow the 5.5 – 5.6 Reassembly instructions!*

#### REMOVAL

Gently peel off and lift the Ant NFC starting from the opposite side of the connector.

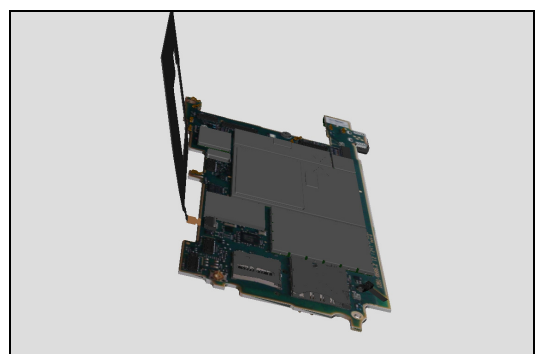
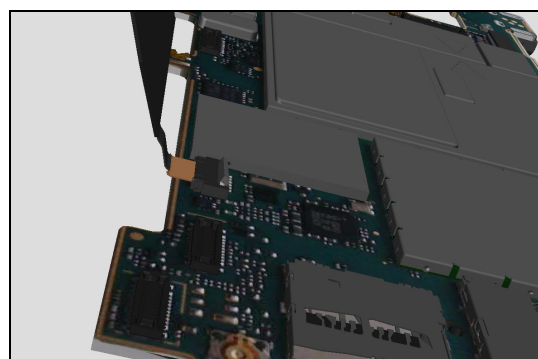
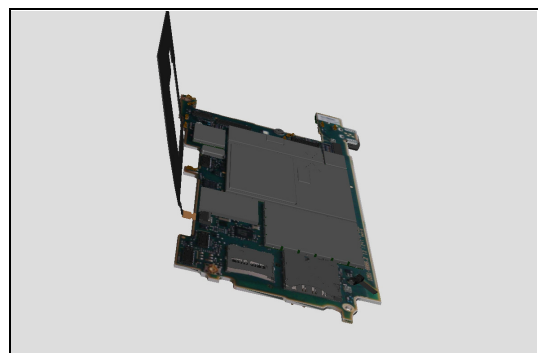
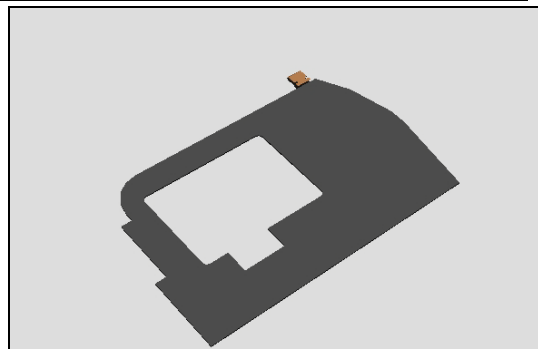
Open the ZIF connector with the Front Opening Tool and loosen the Ant NFC from the PBA Complete.

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

#### INSTALLATION

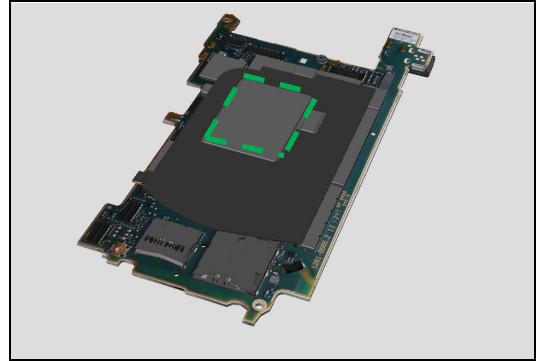
Use the Flex Film Assembly Tool to securely attach the ZIF connector from the Ant NFC to the BPA Complete.

Lock the ZIF connections with the Front Opening Tool



## Replacement

Fold the Ant NFC on to the PBA Complete using the shielding lid's elevation as a guide according to picture and secure it with your fingers.



## Replacement

### 4.12 Attachment Power Key

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.26, 4.19 and 4.46 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Attachment Power Key.*

*Carry out the Installation as described below!*

*Follow the 4.46, 4.19, 4.26, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

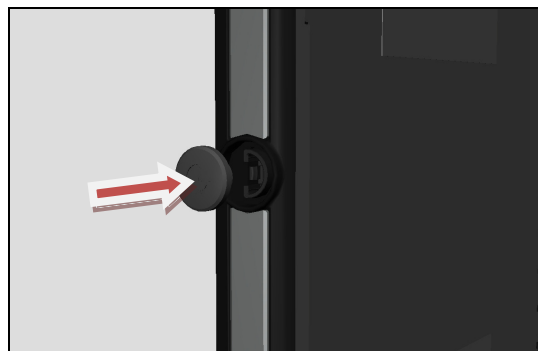
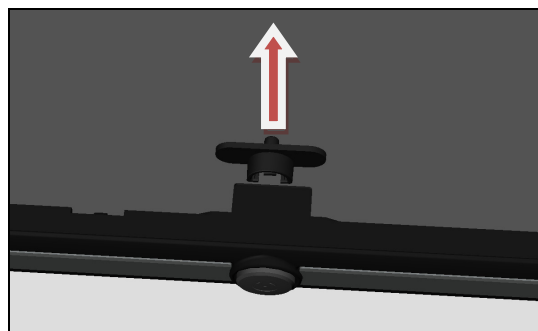
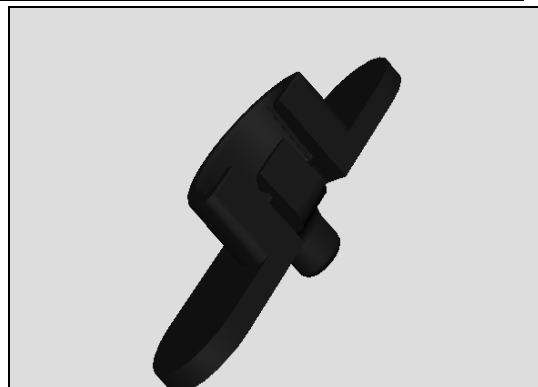
Use the Flex Film Assembly tool to remove the Attachment Power Key.

#### INSTALLATION

Place the new Attachment Power Key with the flat side downwards.

***When changing the Attachment Power Key, also change the Key Power.***

***Hold the Attachment Power Key in place while snapping the Key Power in place!***



## Replacement

### 4.13 Back Cover

*Follow the 3.1 Disassembly instructions!*

*Carry out 4.23 Removal Instructions!*

Prepare a new Back Cover.

*Carry out 4.23 Installation Instructions!*

Follow the 5.6 Reassembly instructions!



## Replacement

### 4.14 Battery 2300 mAh

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9 and 4.15 Removal instructions!*

*Carry out the Removal as described below!*

*Follow the 4.7 Removal and Installation instructions!*

*Prepare a new Battery 2300 mAh.*

*Carry out the Installation as described below!*

*Follow the 4.15, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

Use the Battery Removal Tool to expand the gap between the Battery 2300 mAh and its cavity.

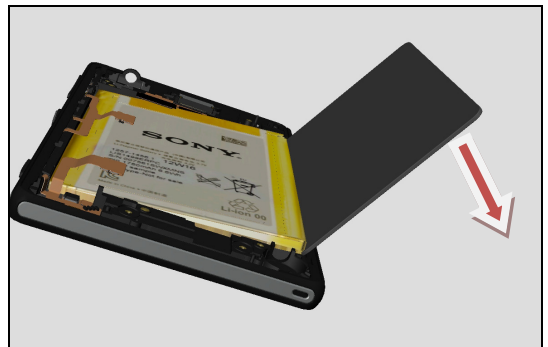
**Be careful not to puncture the Battery!**

Place the Front Cover Assy in a closable ESD bag before placing it in the freezer, set to -20degC, for 30 min.

Re-insert the Battery Removal Tool in the previously expanded gap and firmly lift the Battery 2300 mAh out from its cavity.

**Be careful not to apply force to / bend the Flex Films as they are very fragile when frozen!**

**Let both the Battery 2300 mAh and the Front Assy dry before re-use!**



## Replacement

### INSTALLATION

Place the Adhesive Battery with the protection film in place on the Battery 2300 mAh and apply some pressure with your fingers before removing the protection film.

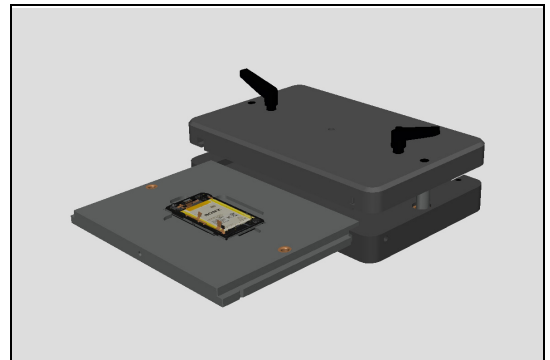
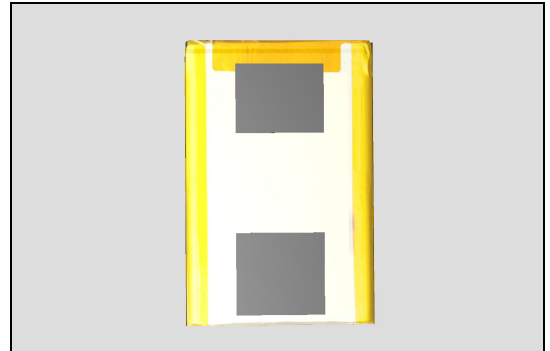
Place the Battery 2300 mAh in its cavity and fixate it with the pressure tool at **150N** in **5s**.

**Make sure that nothing else gets squashed!**

Upper inlay = Battery 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.



## Replacement

### 4.15 Battery Grounding

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Battery Grounding.*

*Carry out the Installation as described below!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

Use the Flex Film Assembly tool to peel off the Battery grounding.

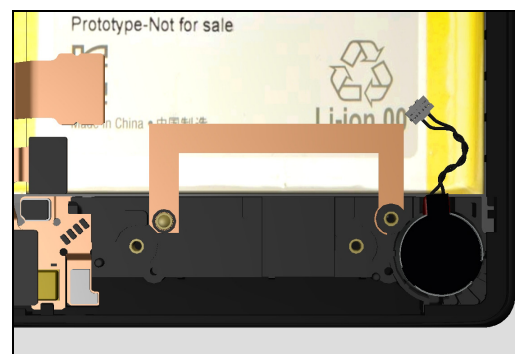
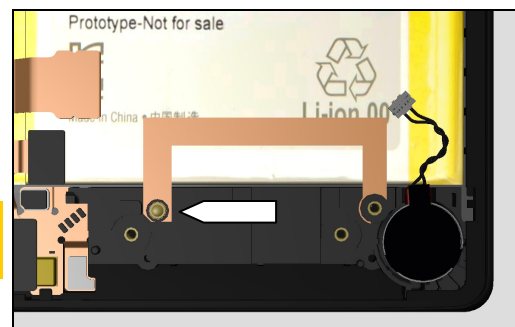
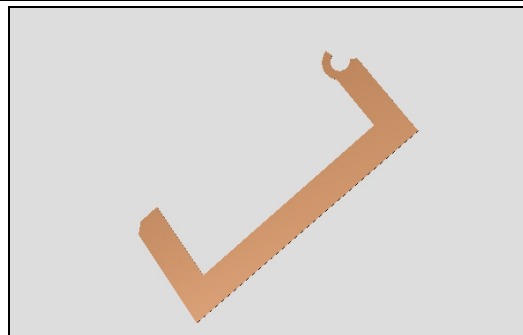
Start from the left side (arrow).

**Be careful not to puncture / damage the battery!**

**Scrap the Battery Grounding, not to be reused!**

#### INSTALLATION

Place the new Battery Grounding at the correct place according to picture and secure it with your fingers.



## Replacement

### 4.16 Camera 13 MP

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Camera 13 MP.*

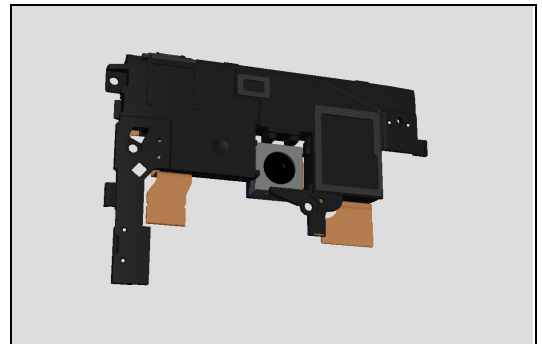
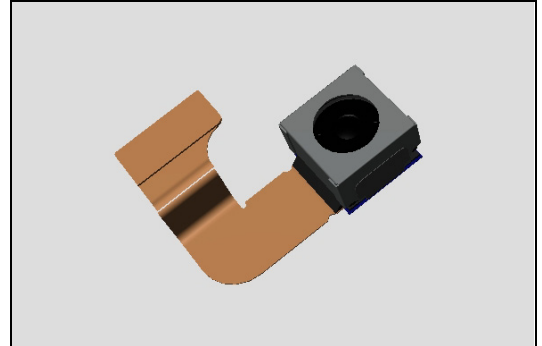
*Carry out the Installation as described below!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

*Gently peel of the Camera 13 MP from the Carrier Spbox with your fingers.*

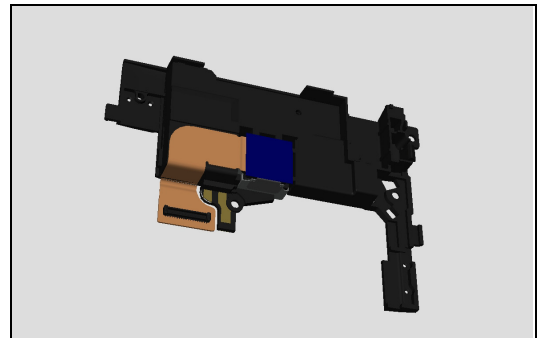
***Be careful not to touch the lens of the Camera 13 MP!***



#### INSTALLATION

Place the Camera 13MP in the Carrier Spbox.

***Be careful not to touch the lens of the Camera 13MP!***



## Replacement

### 4.17 Camera 2.2 MP

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.18 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Camera 2.2 MP.*

*Carry out the Installation as described below!*

*Follow the 4.18 Installation instructions!*

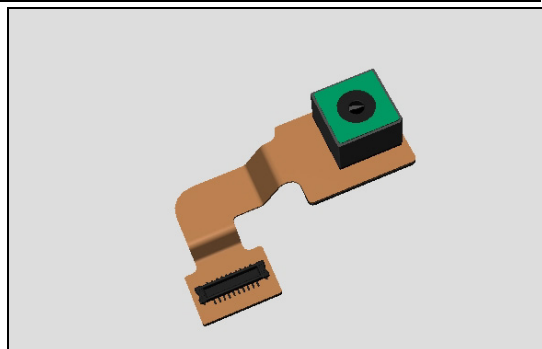
*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

*Use the Flex Film Assembly Tool to gently remove the Camera 2.2 MP.*

***Be careful not to touch the lens of the Camera 2.2 MP!***

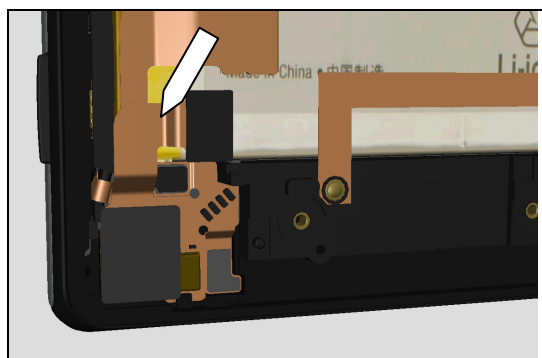
***Make sure that the Mic Protection Tape is not affected***



#### INSTALLATION

*Place the Camera 2.2 MP in its proper position.*

***Be careful not to touch the lens of the Camera 2.2 MP!***



## Replacement

### 4.18 Carrier Antenna

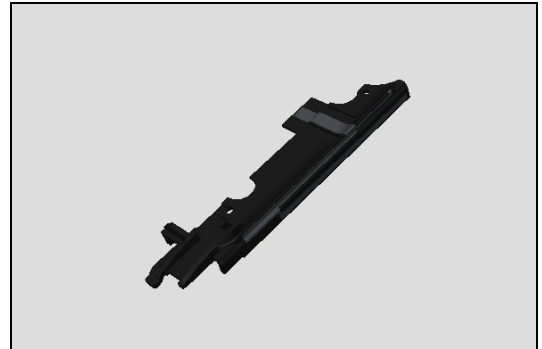
*Follow the 3.1 – 3.5 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Carrier Antenna!*

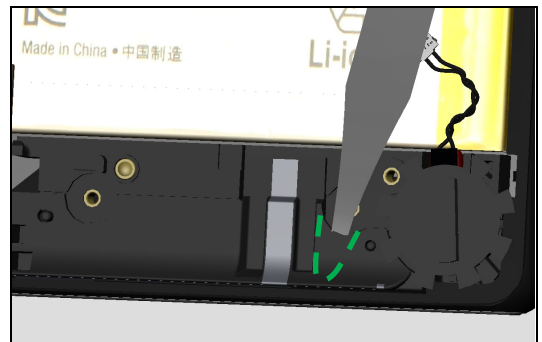
*Carry out the Installation as described below!*

*Follow the 5.2 – 5.6 Reassembly instructions!*



#### REMOVAL

*Remove the Carrier Antenna with the Front Opening Tool.*  
Insert the tool as far as it goes and lift the Carrier Antenna with the tip of the tool.



#### INSTALLATION

Mount the Carrier Antenna from the opposite side of the Vibrator first and secure its position with your fingers.



## Replacement

### 4.19 Carrier Sidekey

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14 and 4.7*

*Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Carrier Sidekey!*

*Carry out the Installation as described below!*

*Follow the 4.37, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50*

*Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

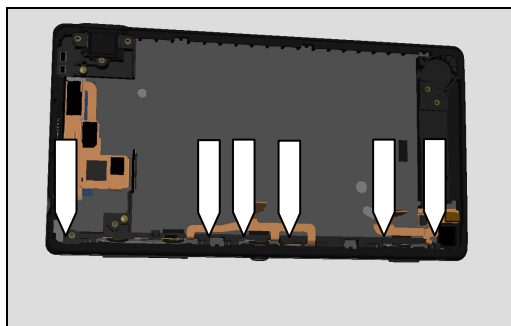
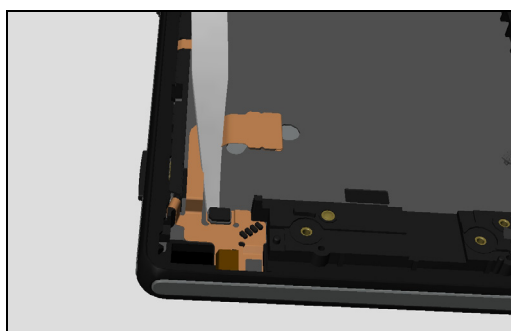
*Loosen the Carrier Camera key PBA by lifting the part that is attached to the Front Assy Unit by forcing a Flex Film Assembly Tool in between.*

*Remove the Carrier Sidekey Assy with the Front Opening Tool by unlatching the 6 hooks that holds it in place.*

***Make sure that you don't damage the Front Assy Unit!***

***Make sure that you don't damage the Front Assy Unit!***

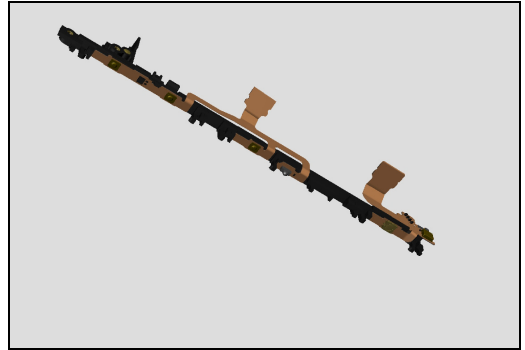
***Scrap the FPC Camera key PBA and FPC Side Key, not to be reused!***



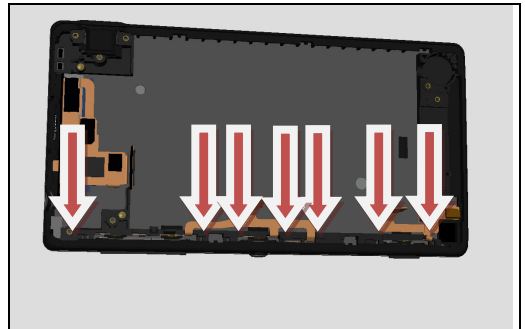
## Replacement

### INSTALLATION

Attach a new FPC Camera key PBA and FPC Side Key according to the picture and secure it with your fingers.



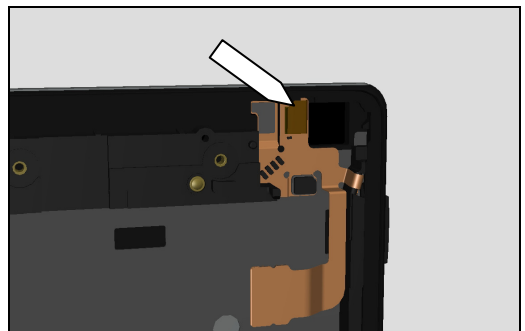
Place the Carrier Sidekey Assy in the Front Assy Unit and make sure that the 7 snaps have locked by adding some extra force on those locations.



Fold the flex on the FPC Camera Key PBA place in its proper position located on the Front Assy unit as shown in picture.

Secure its position with your fingers.

**Don't forget to install new Mic Protection Tape!**



## Replacement

### 4.20 Carrier Spbox

*Follow the 3.1 – 3.4 Disassembly instructions!*

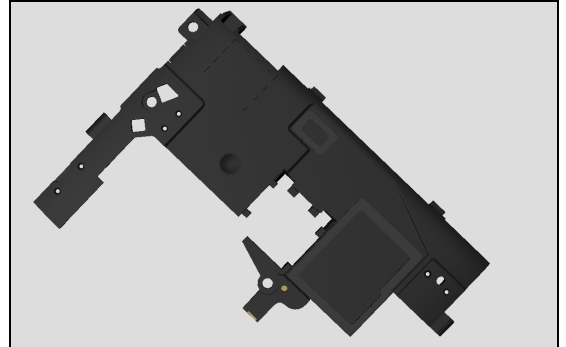
*Follow the 4.16 and 4.32 Removal instructions!*

*Prepare a new Carrier Spbox!*

*Carry out the Installation as described below!*

*Follow the 4.32 and 4.16 Installation instructions!*

*Follow the 5.3 – 5.6 Reassembly instructions!*



## Replacement

### 4.21 Carrier Ear Piece Holder

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Carrier Ear Piece Holder!*

*Follow the 4.24 Installation instructions!*

*Carry out the Installation as described below!*

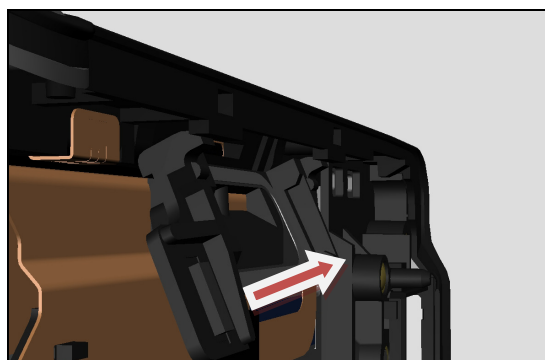
*Follow the 5.3 – 5.6 Reassembly instructions!*



#### REMOVAL

*Gently lift the Carrier Ear Piece Holder (with Earspeaker mounted) with your fingers.*

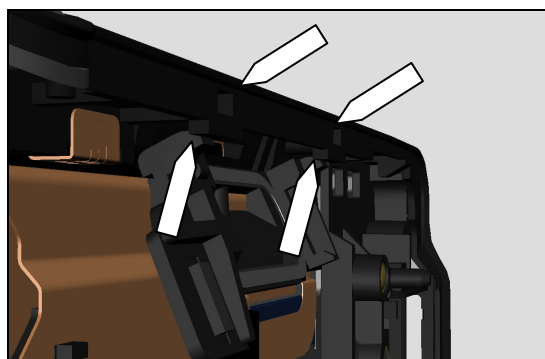
**Earspeaker can't be reused!**



#### INSTALLATION

Put the *Carrier Ear Piece Holder* in place in the frame of the Front Assy Unit.

Use the steering pins from the Carrier Ear Piece Holder to guide it.



## Replacement

### 4.22 Clip USB

*Follow the 3.1 – 3.3 Disassembly instructions!*

*Prepare a new Clip USB!*

*Follow the 5.4 – 5.6 Reassembly instructions!*



## Replacement

### 4.23 Cover Card

*Follow the 3.1 Disassembly instructions!*

*Follow the 4.6 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Cover Card!*

*Carry out the Installation as described below!*

*Follow the 4.6 Installation instructions!*

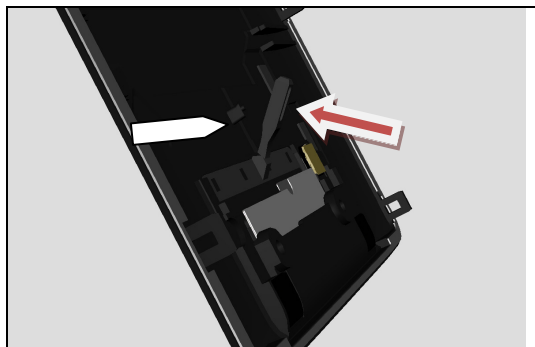
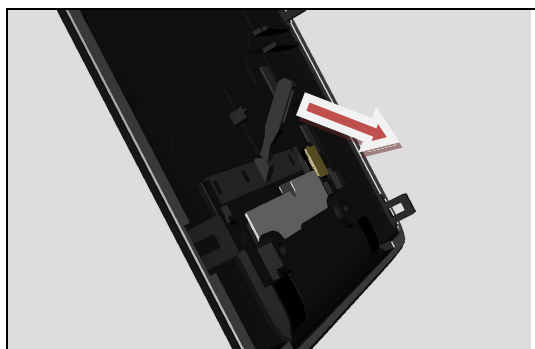
*Follow the 5.6 Reassembly instructions!*

#### REMOVAL

*Loosen the Cover Card from the Back Cover with your fingers.*

#### INSTALLATION

*Fasten the Cover Card to the pin on the Back Cover with your fingers.*



## Replacement

### 4.24 Earspeaker

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Follow the 4.21 Removal instructions!*

*Prepare a new Earspeaker!*

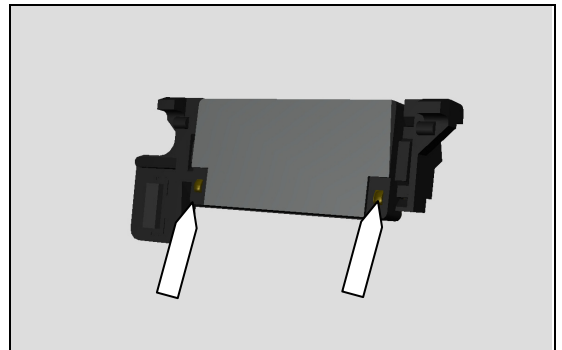
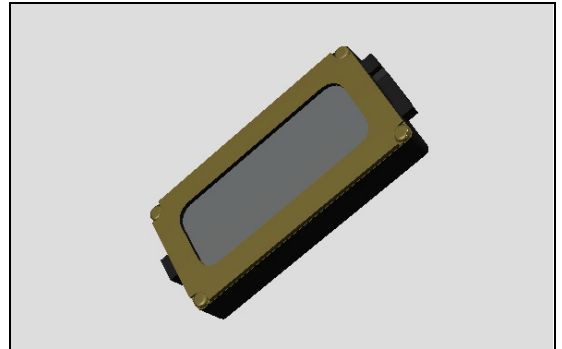
*Carry out the Installation as described below!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### INSTALLATION

Place the Earspeaker in the cavity on the Carrier Ear Piece Holder at correct position.

***The Springs from the Earspeaker should be according to picture!***



## Replacement

### 4.25 FPC AVP

*Follow the 3.1 – 3.4 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!*

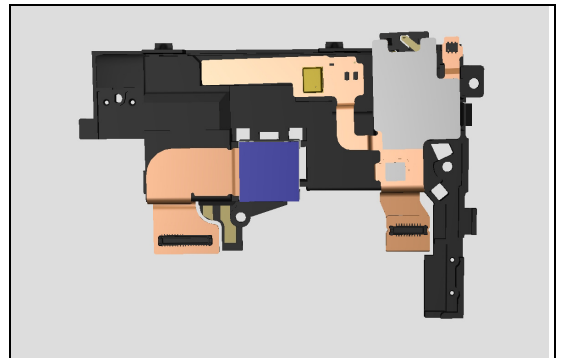
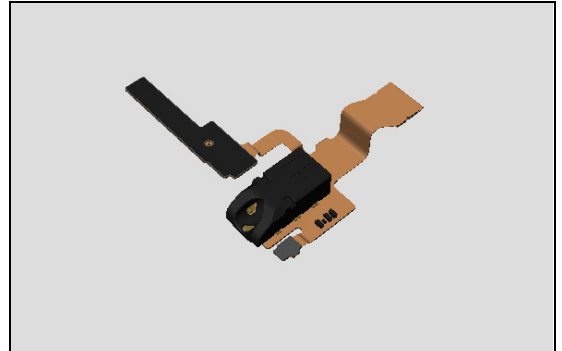
*Follow the 5.3 – 5.6 Reassembly instructions!*

#### REMOVAL

Gently peel of the FPC AVP from the Carrier Spbox Assy with your fingers.

#### INSTALLATION

Place it on the FPC AVP at correct position.



## Replacement

### 4.26 FPC Camera key PBA

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7 and 4.19 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new FPC Camera key PBA!*

*Carry out the Installation as described below!*

*Follow the 4.19, 4.37, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

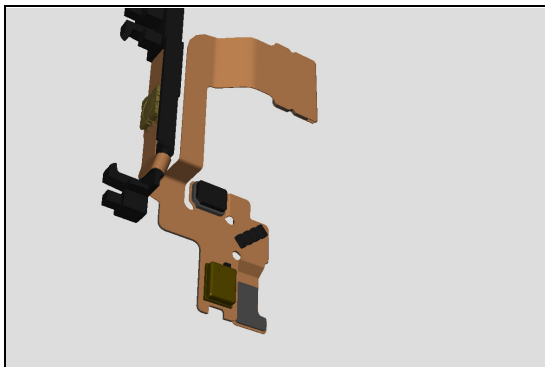
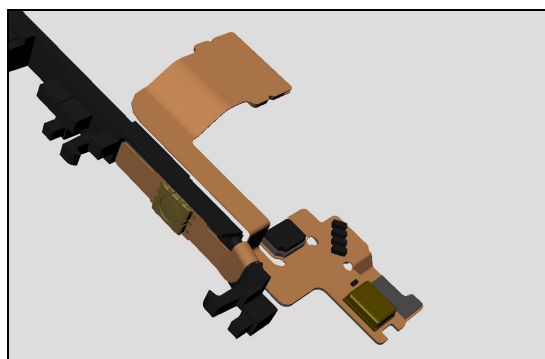
#### REMOVAL

Peel of the FPC Camera key PBA from the Carrier Sidekey.

**Scrap the FPC Camera key PBA, not to be reused!**

#### INSTALLATION

Attach the FPC Camera key PBA to the Carrier Sidekey according to the picture.



## Replacement

### 4.27 FPC Side Key

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.19 and 4.26 Removal instructions!*

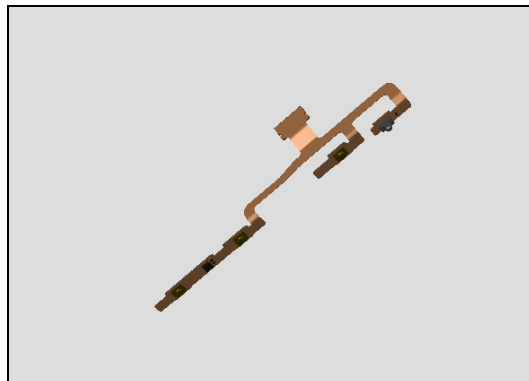
*Carry out the Removal as described below!*

*Prepare a new FPC Side Key!*

*Carry out the Installation as described below!*

*Follow the 4.26, 4.19, 4.37, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

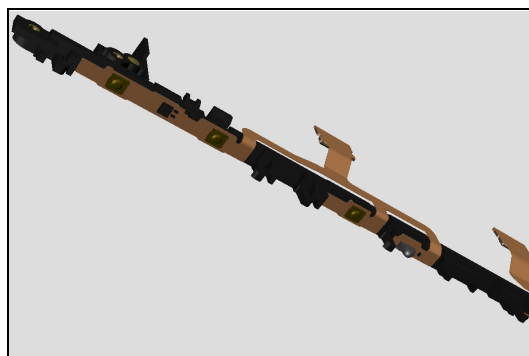
*Follow the 5.2 – 5.6 Reassembly instructions!*



#### REMOVAL

Peel of the FPC Side Key from the Carrier Sidekey.

**Scrap the FPC Side Key, not to be reused!**



#### INSTALLATION

Attach the new FPC Side Key to the Carrier Sidekey according to the picture.



## Replacement

### 4.28 Front Assy

*Follow the 3.1 – 3.5 Disassembly instructions!*

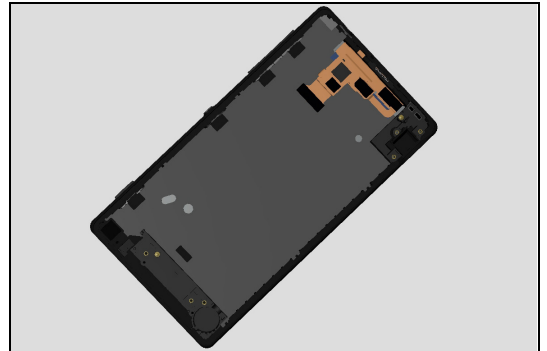
*Follow the 4.21, 4.50, 4.18, 4.17, 4.44, 4.15, 4.14, 4.19 and 4.26 Removal instructions!*

*Prepare a new Front Assy!*

*Carry out the Installation as described below!*

*Follow the 4.26, 4.19, 4.7, 4.14-15, 4.44, 4.17-18, 4.9, 4.50 and 4.21 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*



## Replacement

### 4.29 Gasket Battery FPC Support

*Follow the 3.1 – 3.2 Disassembly instructions!  
Carry out the Removal as described below!  
Prepare a new Gasket Battery FPC Support!  
Carry out the Installation as described below!  
Follow the 5.5 – 5.6 Reassembly instructions!*

#### REMOVAL

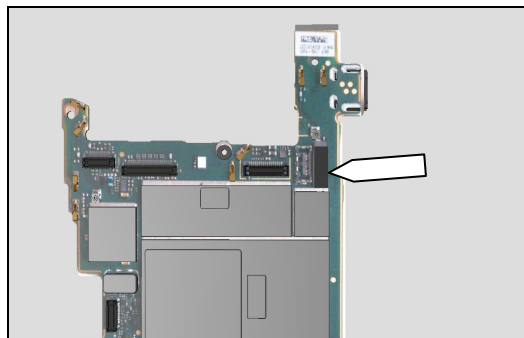
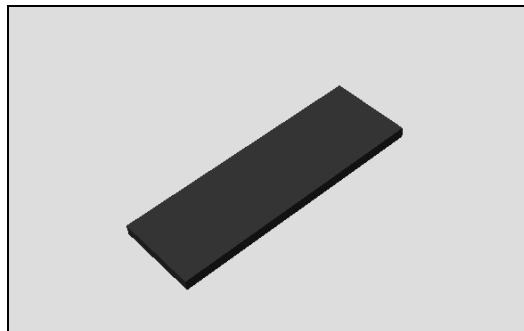
*Use the Flex Film Assembly Tool to remove the Gasket Battery FPC Support.*

***Be careful not to damage the component under the Gasket Battery FPC Support!***

***Scrap the Gasket Battery FPC Support, not to be reused!***

#### INSTALLATION

Place the new Gasket Battery FPC Support according to the picture and secure its position with your fingers



## Replacement

### 4.30 Gasket Proximity

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Gasket Proximity!*

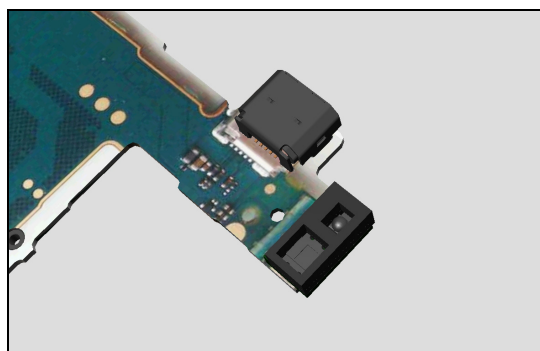
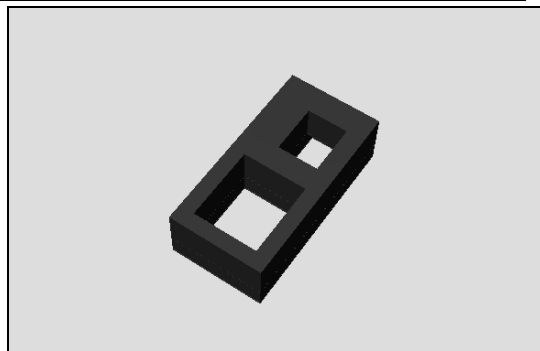
*Carry out the Installation as described below!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

Peel of the Gasket Proximity with your fingers.

**Scrap the Gasket Proximity, not to be reused!**

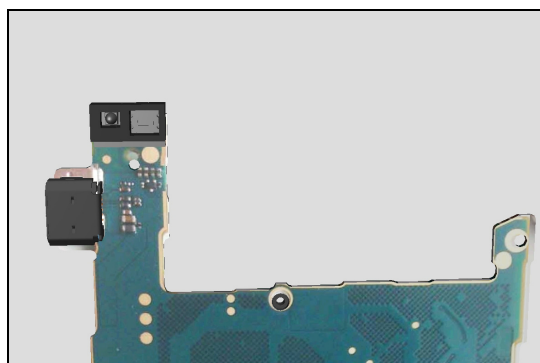


#### INSTALLATION

Place the new Gasket Proximity according to the picture.

Secure its position with your fingers.

**Make sure that the components on the PBA Complete are not covered!**



## Disassembly

### 4.31 Gasket Vibrator

*Follow the 3.1 – 3.2 Disassembly instructions!*

*Follow the 4.50 and 4.9 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Gasket Vibrator!*

*Carry out the Installation as described below!*

*Follow the 4.9 and 4.50 Installation instructions!*

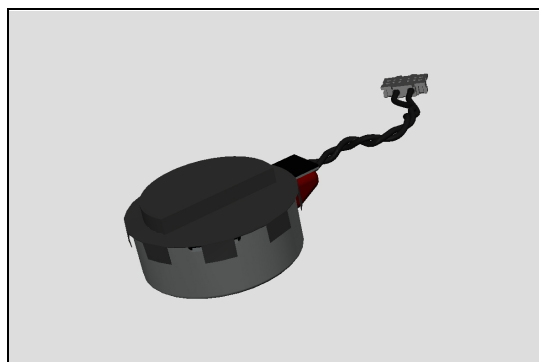
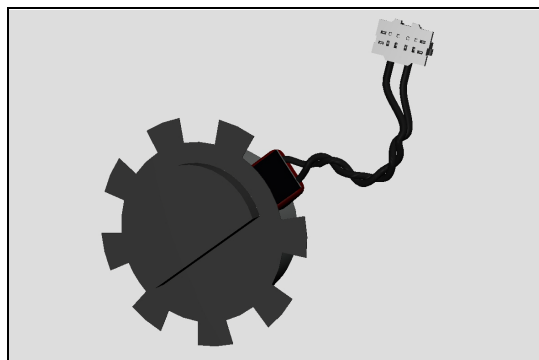
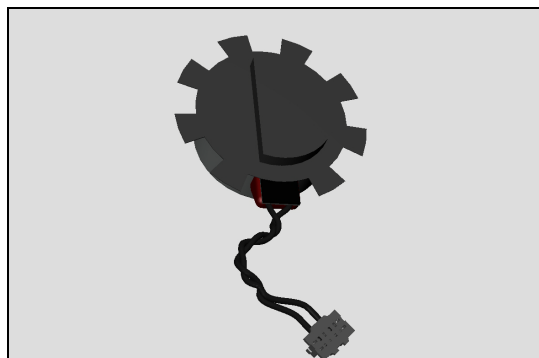
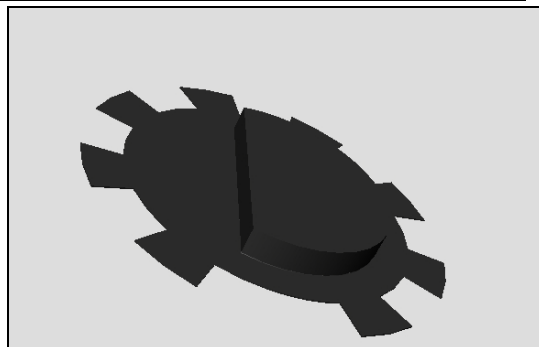
*Follow the 5.5 – 5.6 Reassembly instructions!*

#### REMOVAL

*Peel of the Gasket Vibrator with your fingers.*

***Scrap the Gasket Vibrator, not to be reused!***

***Be careful not to damage the wires from the Vibrator!***



#### INSTALLATION

Place the new Gasket Proximity according to the picture.

Fold the tabs over the Vibrator.  
Secure its position with your fingers.

## Disassembly

### 4.32 Grommet AVP

*Follow the 3.1 – 3.4 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Grommet AVP!*

*Carry out the Installation as described below!*

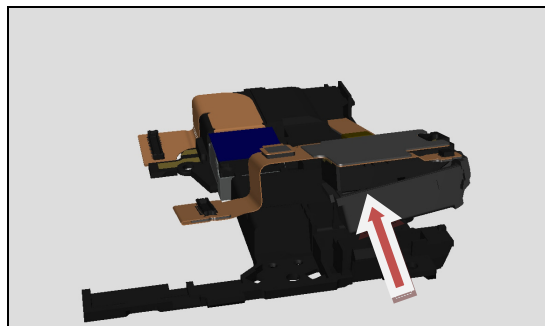
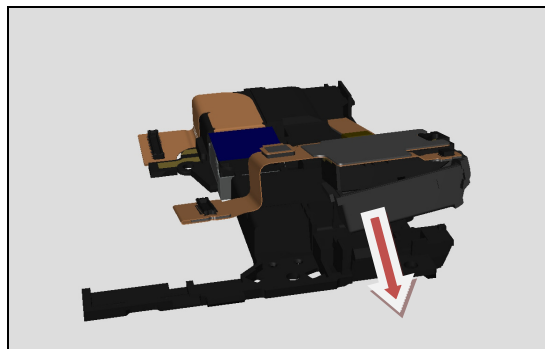
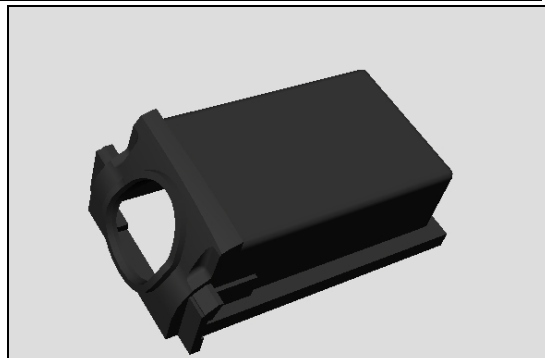
*Follow the 5.3 – 5.6 Reassembly instructions!*

#### REMOVAL

Gently lift the AVP Socket from the cavity on the Carrier Spbox Assy without losing the adhesive.  
Gently peel of the Grommet AVP from the FPC AVP with your fingers.

#### INSTALLATION

Place the Grommet AVP on the AVP Socket on the FPC AVP at correct position and place the AVP socket in the cavity.



## Disassembly

### 4.33 Key Camera

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.19, 4.26 and 4.45 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Key Camera!*

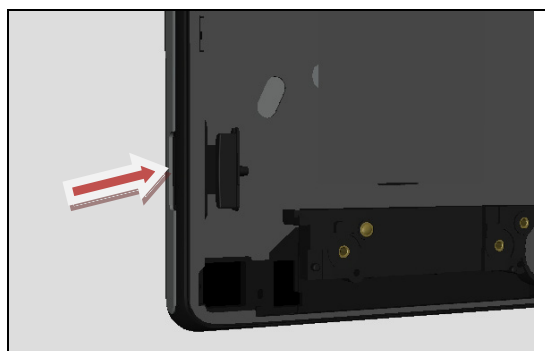
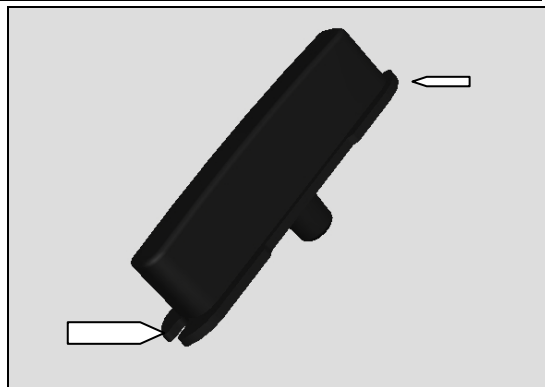
*Carry out the Installation as described below!*

*Follow the 4.26, 4.45, 4.19, 4.37, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

Use your fingers to push the Key Camera from the outside in.



#### INSTALLATION

Place Key Camera from the inside out and the largest edge closest to the Key Power (see first picture on this page).

***It will not fit the other way around!***



## Disassembly

### 4.34 Key Power

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.19, 4.26, 4.46 and 4.12 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Key Power!*

*Carry out the Installation as described below!*

*Follow the 4.46, 4.26, 4.19, 4.37, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

#### REMOVAL

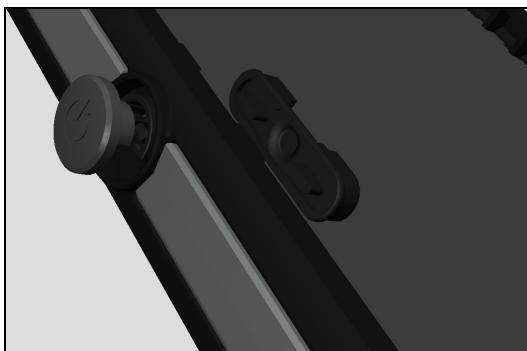
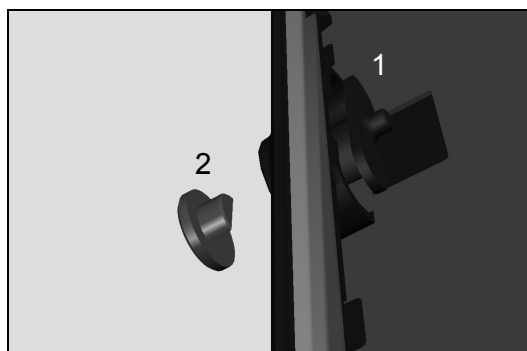
Use the Flex Film Assembly Tool to remove the Attachment Power Key from the inside, then the Key Power will be loose and can be removed from the outside.

#### INSTALLATION

Place the Attachment Power Key with the flat side downwards.

**When changing the Key Power, also change the Attachment Power Key.**

**Hold the Attachment Power Key in place while snapping the Key Power in place!**



## Disassembly

### 4.35 Key Volume

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.19, 4.26 and 4.47 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Key Volume!*

*Carry out the Installation as described below!*

*Follow the 4.47, 4.26, 4.19, 4.37, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

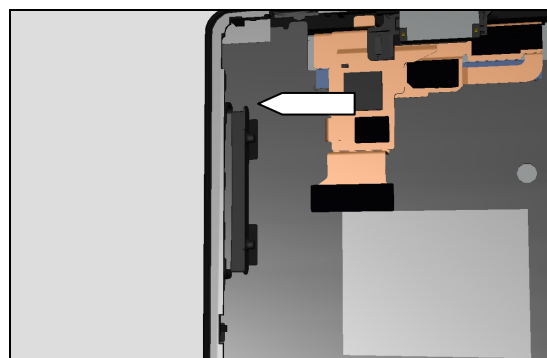
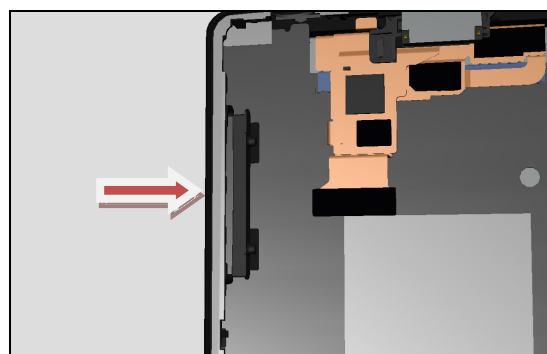
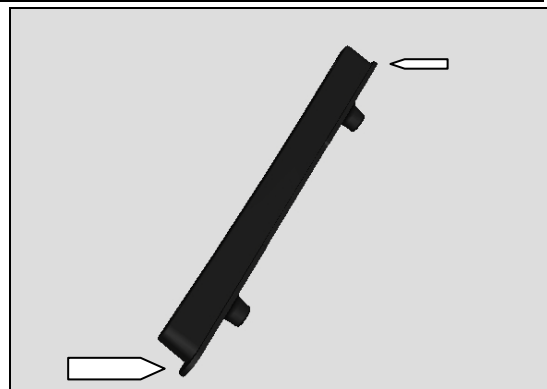
#### REMOVAL

Use your fingers to push the Key Volume from the outside in.

#### INSTALLATION

Place Key Volume from the inside out with the largest edge on the Key Volume closest to the short side of the unit (see first picture on this page).

***It will not fit the other way around!***



## Disassembly

### 4.36 Label Mobile Phone

*Carry out the Removal as described below!*

*Prepare a new Label Mobile Phone!*

*Carry out the Installation as described below!*

#### REMOVAL

*Open the Cover Card.*

***SIM card and Memory Card needs to be removed!***

*Use the Flex Film Assembly Tool to remove the Label Mobile Phone.*

***Scrap the Label Mobile Phone! Not to be reused!***

#### INSTALLATION

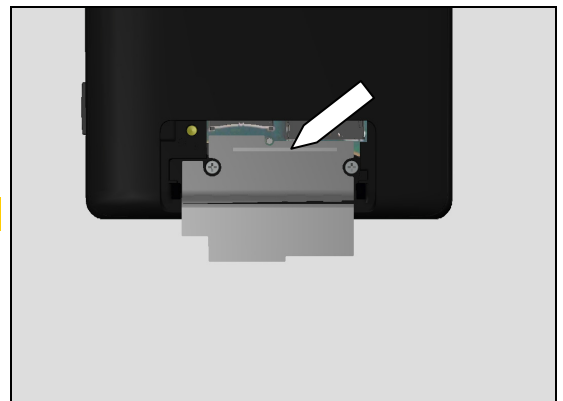
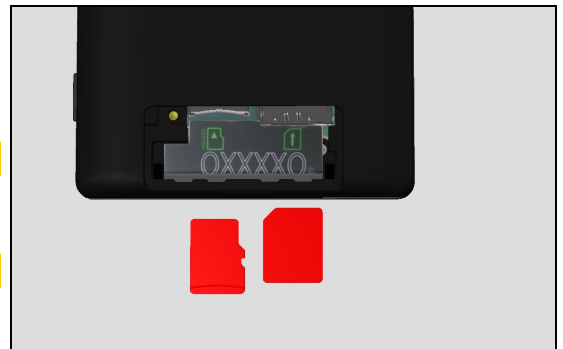
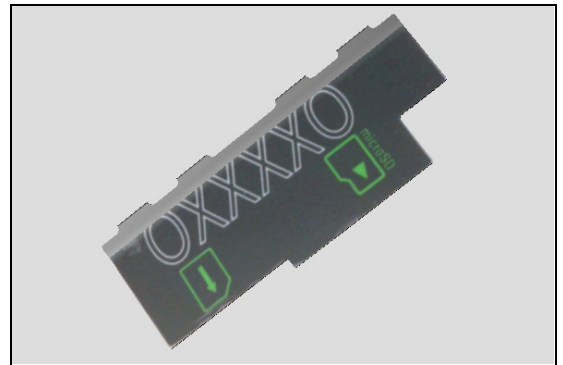
Check that the proper label format is loaded in the Zebra printer and print a new label by using the 'Label Print Solution' software.

***One label only is allowed!***

*Place the new Label Mobile Phone, use the screws as reference for placement.*

*Put the Adhesive Label at the top of the Label Mobile Phone and fold the Label Mobile Phone.*

*Close the Cover Card.*



## Disassembly

### 4.37 Mic Protection Tape

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.18 and 4.17 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Mic Protection Tape!*

*Carry out the Installation as described below!*

*Follow the 4.17 and 4.18 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

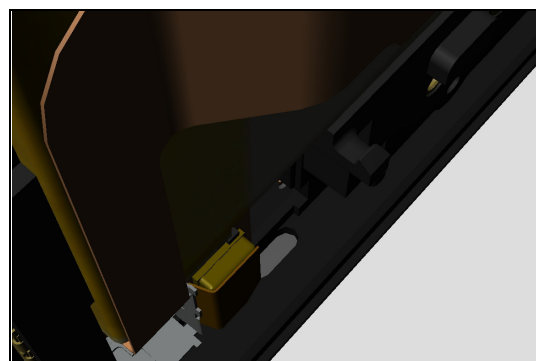
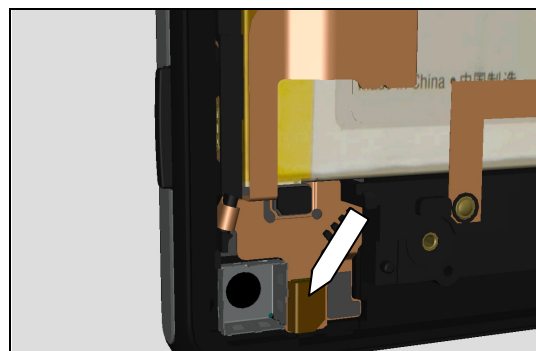
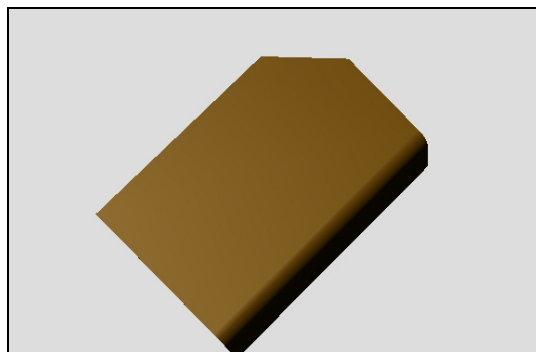
#### REMOVAL

*Use the Flex Film Assembly Tool to remove the Mic Protection Tape.*

**Scrap the Mic Protection Tape! Not to be reused!**

#### INSTALLATION

*Place the new Mic Protection Tape as shown in the picture.*



## Disassembly

### 4.38 Panel Bottom

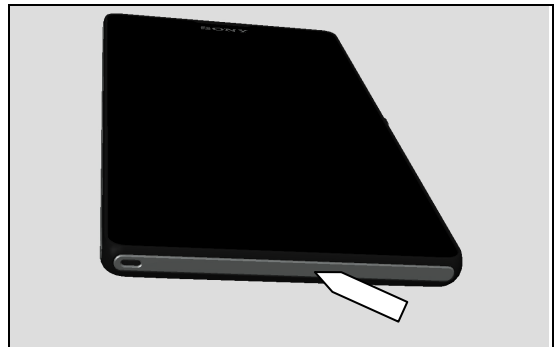
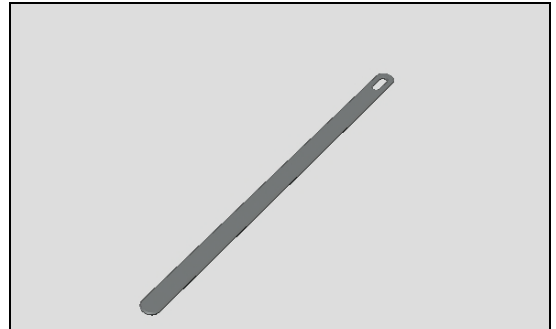
*Carry out the Removal as described below!  
Prepare a new Panel Bottom!  
Carry out the Installation as described below!*

#### REMOVAL

*Use the Flex Film Assembly Tool to remove the Panel Bottom.*

**Scrap the Panel Bottom! Not to be reused!**

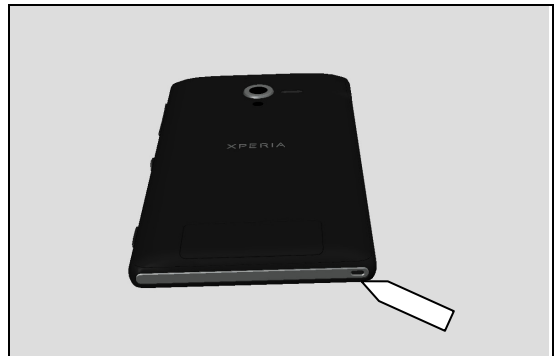
**Be careful not to damage the Front Assy**



#### INSTALLATION

*Place the new Panel Bottom in place guided by the hole as reference.*

**Don't bend the Panel Bottom as it might crack!**



## Disassembly

### 4.39 Panel Side Left

*Carry out the Removal as described below!*

*Prepare a new Panel Side Left!*

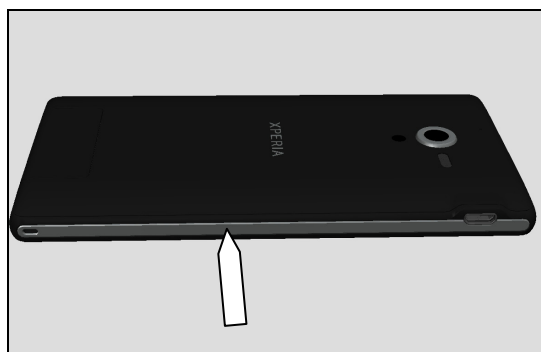
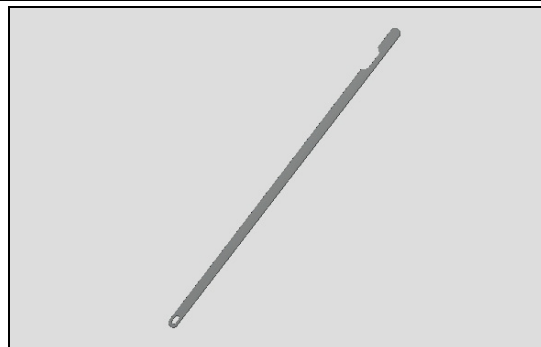
*Carry out the Installation as described below!*

#### REMOVAL

*Use the Flex Film Assembly Tool to remove the Panel Side Left.*

**Scrap the Panel Side Left! Not to be reused!**

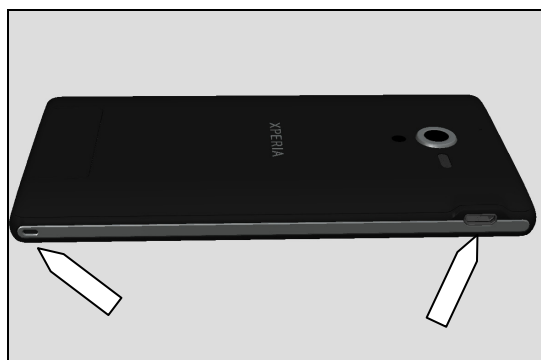
**Be careful not to damage the Front Assy**



#### INSTALLATION

*Place the new Panel Side Left in place guided by the hole and chamfering as reference.*

**Don't bend the Panel Side Left as it might crack!**



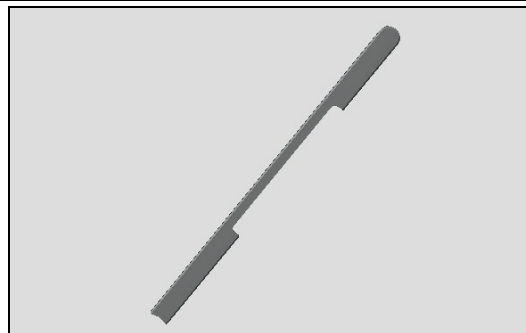
## Replacement

### 4.40 Panel Side Right 1

*Carry out the Removal as described below!*

*Prepare a new Panel Side Right 1!*

*Carry out the Installation as described below!*

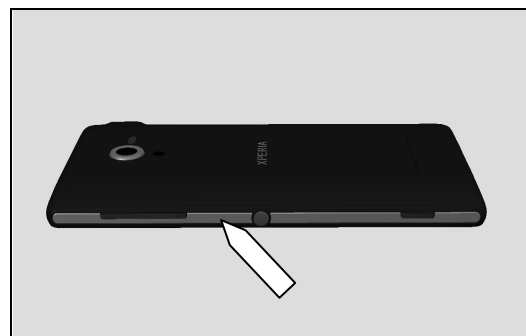


#### REMOVAL

*Use the Flex Film Assembly Tool to remove the Panel Side Right 1.*

**Scrap the Panel Side Right 1! Not to be reused!**

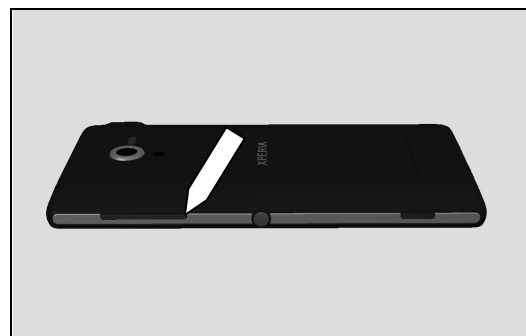
**Be careful not to damage the Front Assy**



#### INSTALLATION

*Place the new Panel Side Right 1 in place guided by the chamfering as reference.*

**Don't bend the Panel Side Right 1 as it might crack!**



## Replacement

### 4.41 Panel Side Right 2

*Carry out the Removal as described below!*

*Prepare a new Panel Side Right 2!*

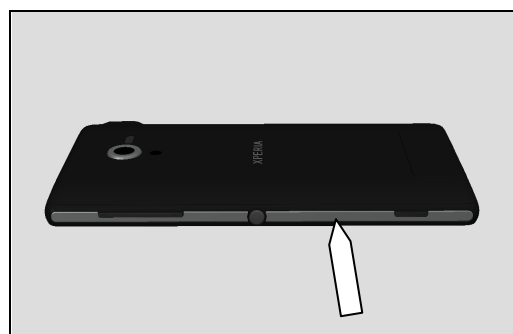
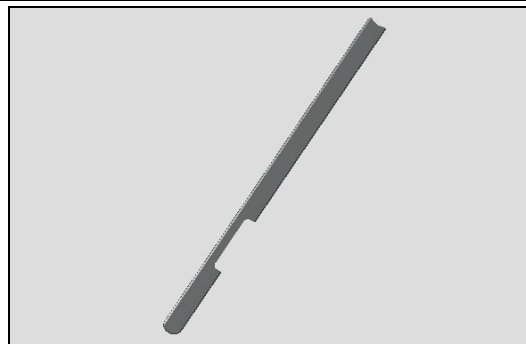
*Carry out the Installation as described below!*

#### REMOVAL

*Use the Flex Film Assembly Tool to remove the Panel Side Right 2.*

**Scrap the Panel Side Right 2! Not to be reused!**

**Be careful not to damage the Front Assy**



#### INSTALLATION

*Place the new Panel Side Right 2 in place guided by the chamfering as reference.*

**Don't bend the Panel Side Right 2 as it might crack!**



## Replacement

### 4.42 Panel Top

*Carry out the Removal as described below!*

*Prepare a new Panel Top!*

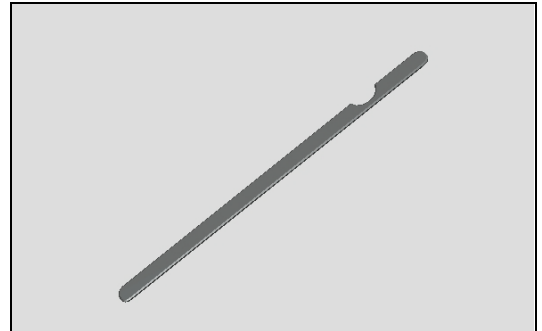
*Carry out the Installation as described below!*

#### REMOVAL

*Use the Flex Film Assembly Tool to remove the Panel Top.*

**Scrap the Panel Top! Not to be reused!**

**Be careful not to damage the Front Assy!**



#### INSTALLATION

*Place the new Panel Top in place guided by the hole as chamfering as reference.*

**Don't bend the Panel Top as it might crack!**



## Replacement

### 4.43 PBA Complete

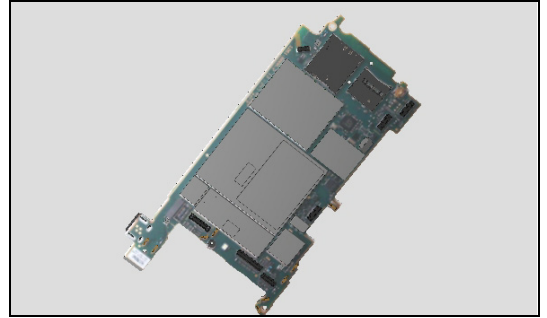
*Follow the 3.1 – 3.6 Disassembly instructions!*

*Prepare a new PBA Complete!*

*Carry out the Installation as described below!*

*Follow the 4.10, 4.29, 4.31, 4.49 and 4.50 Installation instructions!*

*Follow the 5.1 – 5.6 Reassembly instructions!*



## Replacement

### 4.44 Shield Can Chat Camera

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.18 and 4.17 Removal instructions!*

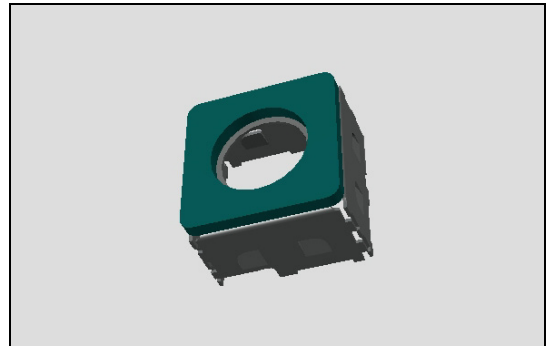
*Carry out the Removal as described below!*

*Prepare a new Shield Can Chat Camera!*

*Carry out the Installation as described below!*

*Follow the 4.17 and 4.18 Installation instructions!*

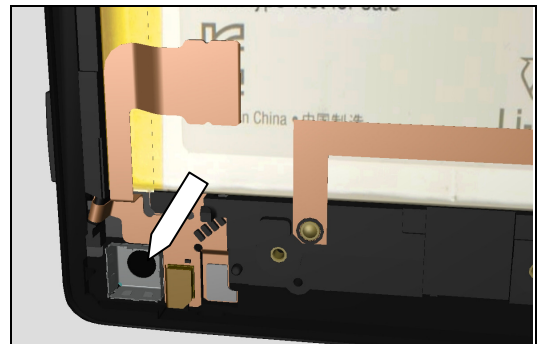
*Follow the 5.2 – 5.6 Reassembly instructions!*



#### REMOVAL

*Use the Flex Film Assembly Tool to remove the Shield Can Chat Camera.*

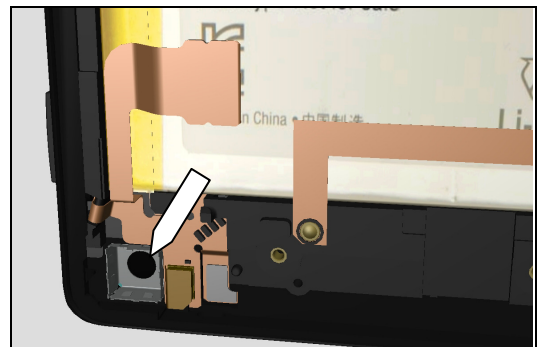
***Make sure that the Mic Protection Tape is not affected!***



#### INSTALLATION

*Place the new Shield Can Chat Camera in the cavity in the bottom left corner of the unit.*

***Make sure that the Mic Protection Tape is not affected!***



## Replacement

### 4.45 Silicon Camera Key

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.26, and 4.19 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Silicon Camera Key!*

*Carry out the Installation as described below!*

*Follow the 4.26, 4.19, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

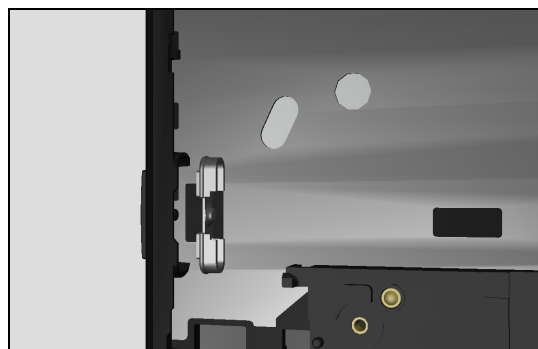
#### REMOVAL

Use the Flex Film Assembly Tool to remove the *Silicon Camera Key*.

#### INSTALLATION

Use the Flex Film Assembly Tool to place the Silicon Camera Key in the cavity for the Silicon Camera Key in the Front Assy.

**Be aware of the unsymmetrical shape of the part!**



## Replacement

### 4.46 Silicon Power Key

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.26, and 4.19 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Silicon Power Key!*

*Carry out the Installation as described below!*

*Follow the 4.26, 4.19, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

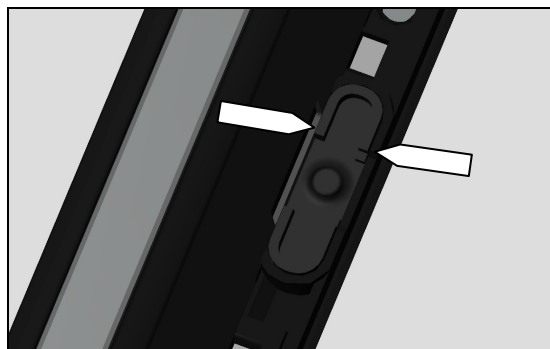
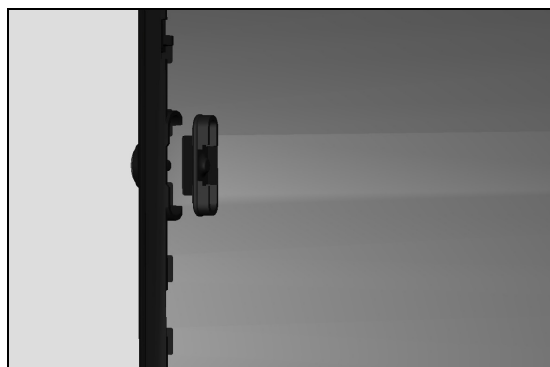
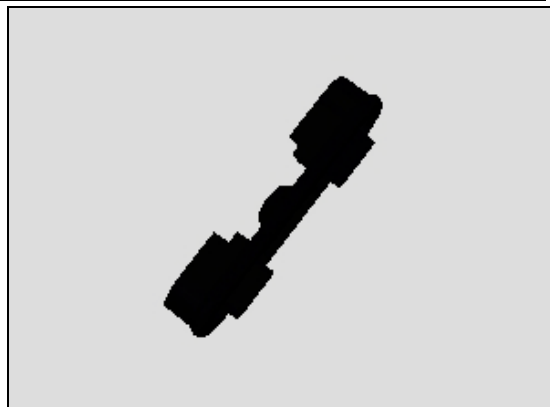
#### REMOVAL

Use the Flex Film Assembly Tool to remove the Silicon Power Key.

#### INSTALLATION

Use the Flex Film Assembly Tool to place the Silicon Power Key in the cavity for the Silicon Power Key in the Front Assy.

**Be aware of the unsymmetrical shape of the part!**



## Replacement

### 4.47 Silicon Volume Key

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.50, 4.9, 4.18, 4.17, 4.44, 4.15, 4.14, 4.7, 4.26, and 4.19 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new Silicon Volume Key!*

*Carry out the Installation as described below!*

*Follow the 4.26, 4.19, 4.7, 4.14-15, 4.44, 4.17-18, 4.9 and 4.50 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

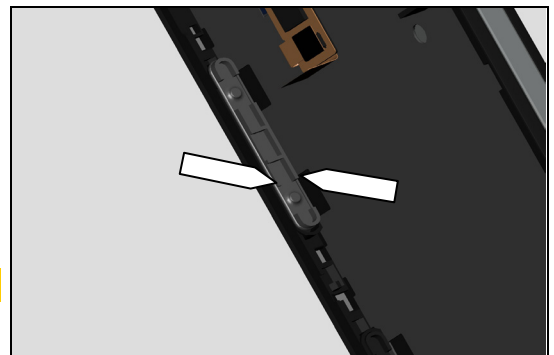
#### REMOVAL

Use the Flex Film Assembly Tool to remove the *Silicon Volume Key*.

#### INSTALLATION

Use the Flex Film Assembly Tool to place the Silicon Volume Key in the cavity for the Silicon Power Key in the Front Assy.

**Be aware of the unsymmetrical shape of the part!**



## Replacement

### 4.48 WI Bottom

*Follow the 3.1 – 3.5 Disassembly instructions!*

*Follow the 4.29 and 4.30 Removal instructions!*

*Carry out the Removal as described below!*

*Prepare a new WI Bottom!*

*Carry out the Installation as described below!*

*Follow the 4.30 and 4.29 Installation instructions!*

*Follow the 5.2 – 5.6 Reassembly instructions!*

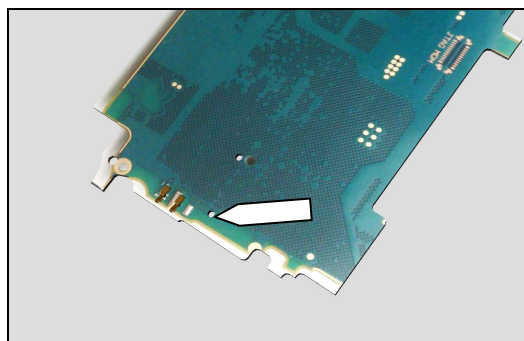
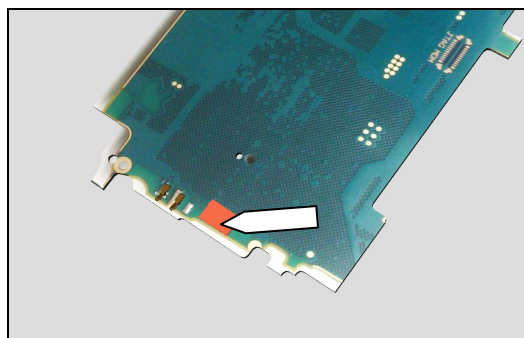
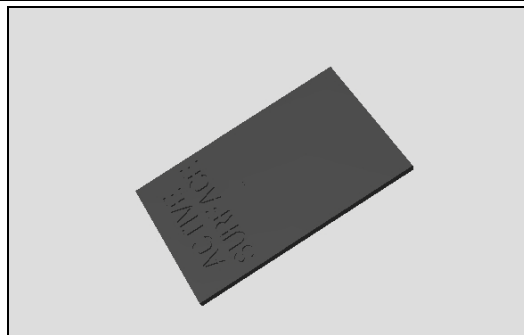
#### REMOVAL

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

**Scrap the WI Bottom! Not to be reused!**

#### INSTALLATION

Place the new WI Bottom over the hole on the PBA Complete.



## Replacement

### 4.49 WI Top

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

*Prepare a new Camera WI Top.*

*Carry out the Installation as described below!*

*Follow the 5.5 and 5.6 Reassembly instructions!*

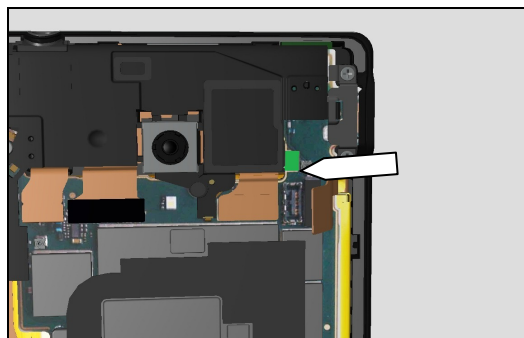
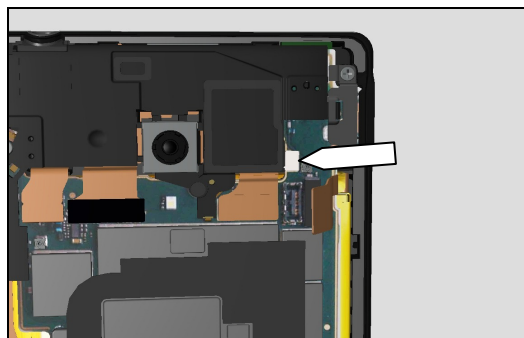
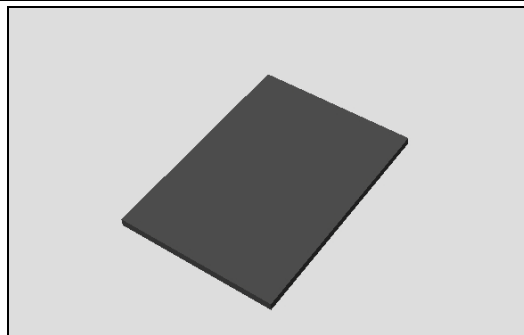
#### REMOVAL

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

**Scrap the WI Top! Not to be reused!**

#### INSTALLATION

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



## Replacement

### 4.50 Vibrator

*Follow the 3.1 and 3.2 Disassembly instructions!*

*Carry out the Removal as described below!*

Prepare a new Vibrator.

*Follow the 4.9 and 4.31 Installation instructions!*

*Carry out the Installation as described below!*

Follow the 5.5 and 5.6 Reassembly instructions!

#### REMOVAL

Use the Front Opening Tool to remove the BtB connector from the PBA Complete and loosen the wire from the Vibrator Adhesive.

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

Use the Dentist hook to remove the Vibrator.

**Secure placement of Dentist hook according marked cavity in picture!**

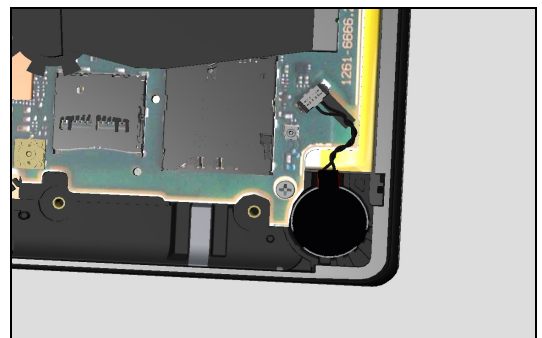
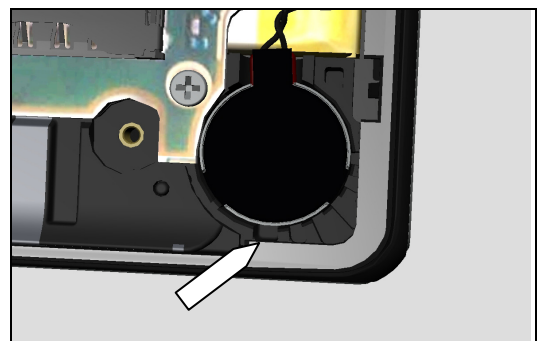
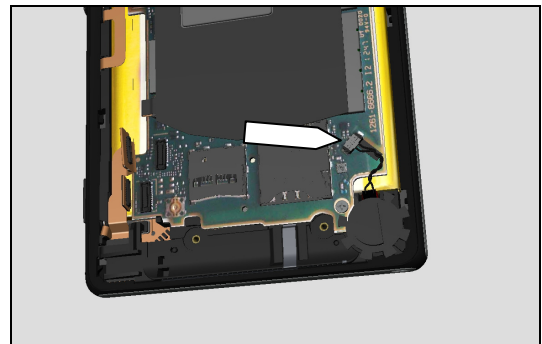
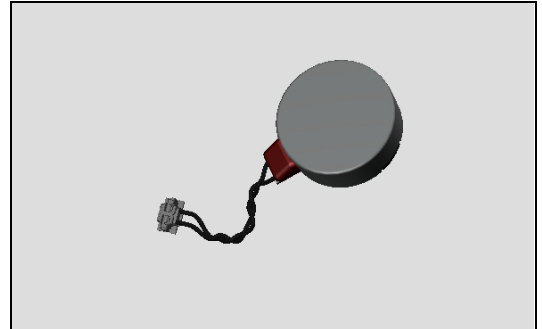
#### INSTALLATION

Twist the wires 5 turns.

Place the Vibrator in the bottom right cavity on the Front Assy.

Attach the BtB connector to the PBA Complete and position the wires on the Adhesive Vibrator Wire

Secure it with your fingers.



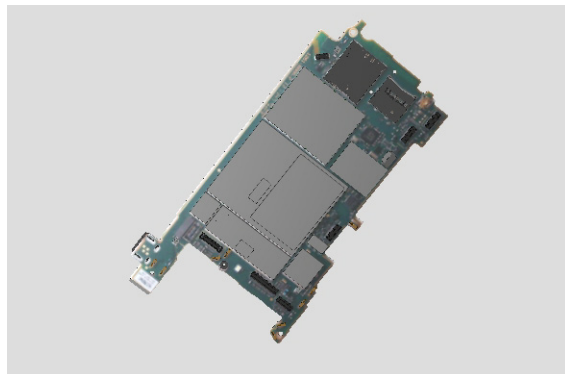
## Replacement

### 4.51 Board Swap - Replacement

*Follow the 3.1 – 3.6 Disassembly instructions!*

Replace the Swap Board.

*Carry out 4.10, 4.29 and 4.30 Installation instructions!*



*Follow the 5.1 – 5.6 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!***

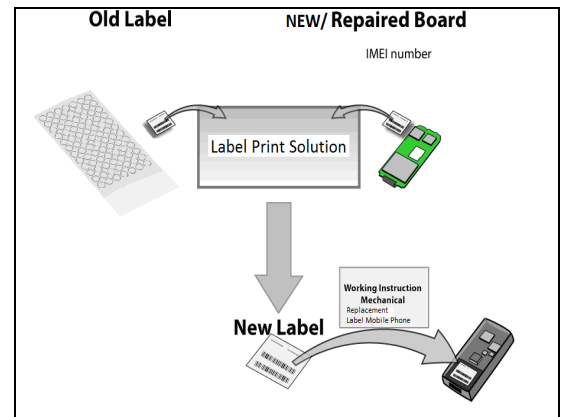
*After "Select Language" menu, turn off the phone.*

## Replacement

### 4.52 Board Swap – Change Label

#### CHANGE LABEL

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

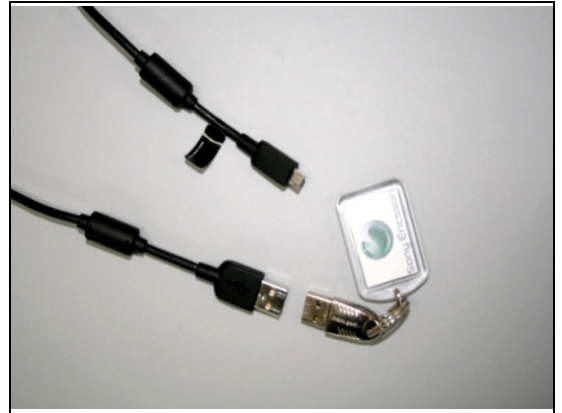


## Replacement

### 4.53 Board Swap – Customize of Software

#### CUSTOMIZE OF SOFTWARE

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

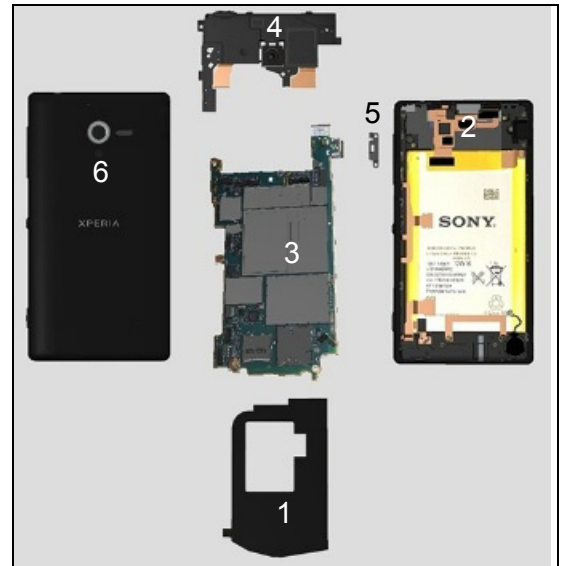


## 5 Re-Assembly

The Disassembly is done to the following modules:

1. Ant NFC
2. Front Assy Unit\*
3. PBA Complete Assy\*
4. Carrier Spbox Assy\*
5. Clip USB
6. Back Cover Assy\*

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



## Re-Assembly

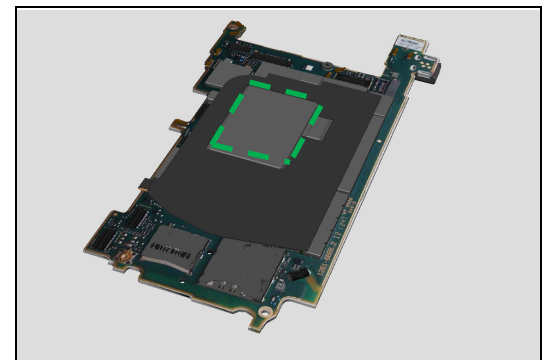
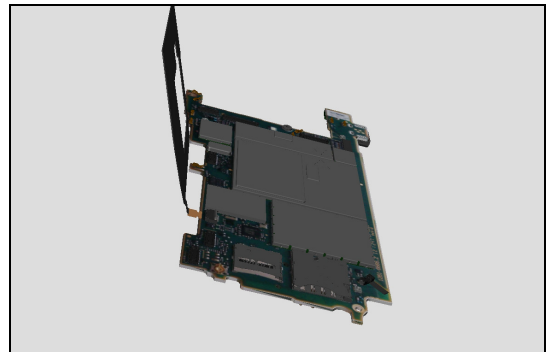
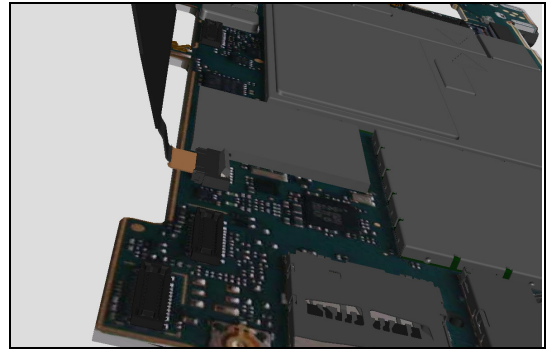
### 5.1 Ant NFC

Prepare a new Ant NFC

Use the Flex Film Assembly Tool to securely attach the ZIF connector from the Ant NFC to the PBA Complete.

Lock the ZIF connector with an Front Opening Tool

Fold the Ant NFC on to the PBA Complete using the shielding lid's elevation as a guide according to picture and secure it with your fingers.



## Re-Assembly

### 5.2 PBA Complete Assy

Prepare the PBA Complete Assy.

Gently insert the PBA Complete Assy, the right side first.

**Do not damage the Flex Films or the wires!**

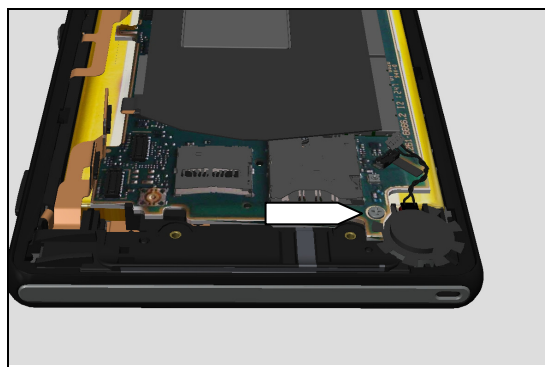
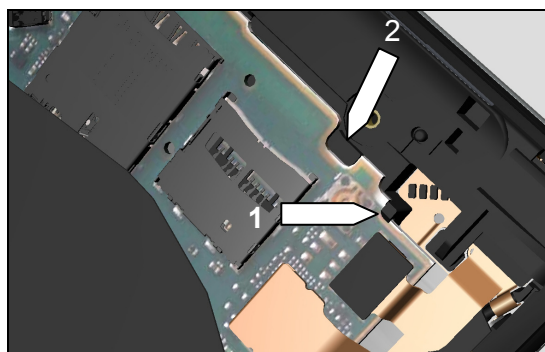
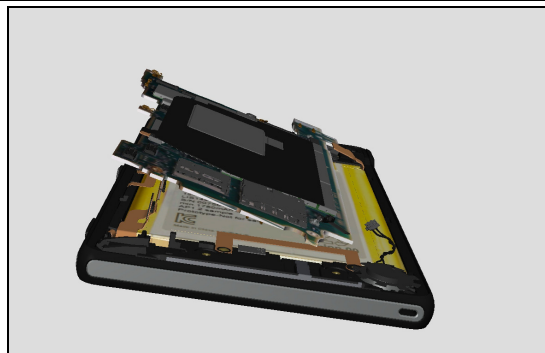
**Make sure that the Gasket Proximity does not get deformed or misplaced during this activity!**

When lowered into place, the snap (1) should lock and the steering (2) must be placed correctly in the PBA Complete's slot.

Secure its position by with a new Screw 3.0.

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

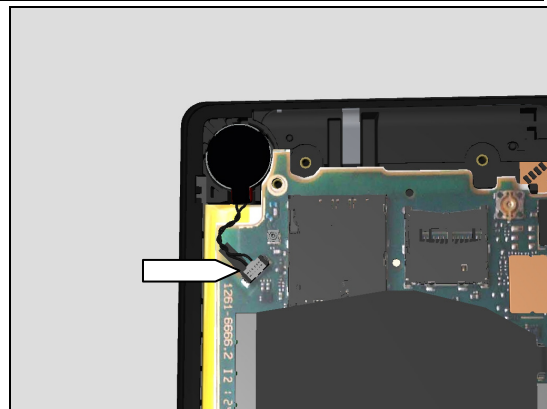
**Do not damage the components on the PBA Complete!**



## Re-Assembly: PBA Complete Assy

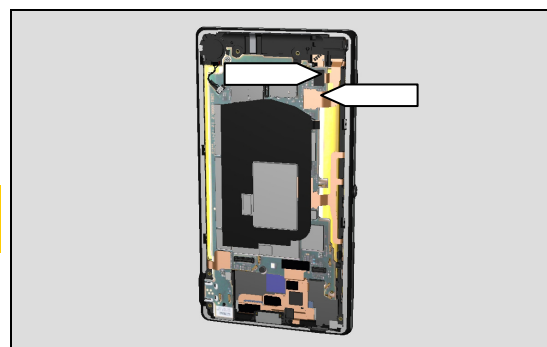
Attach the BtB connector from the Vibrator and secure the Vibrator wire on the Adhesive Vibrator Wire according to picture.

**Secure the BtB connector is in place with your fingers!**



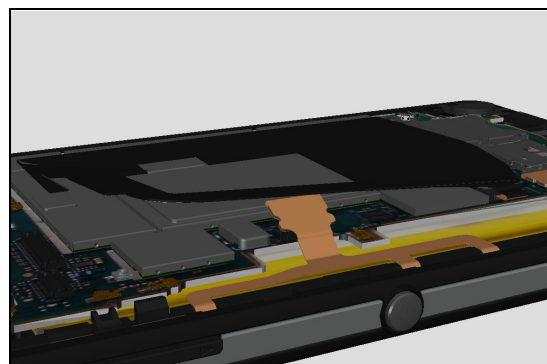
Attach the BtB connectors from FPC camera Key PBA and Camera 2.2 MP and Front Assy.

**Secure the BtB connectors are in place with your fingers!**

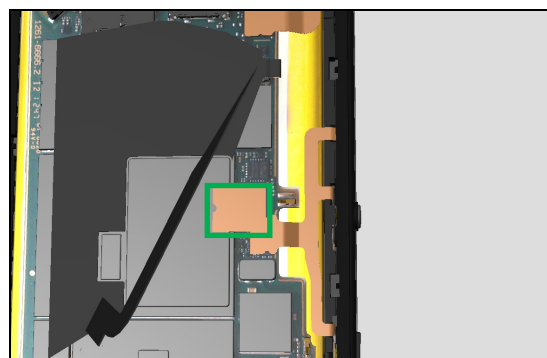


Gently lift the part of the Ant NFC that is above the BtB to the FPC Side Key and connect the BtB Connector from the FPC Side Key.

**Secure the BtB connector is in place with your fingers!**



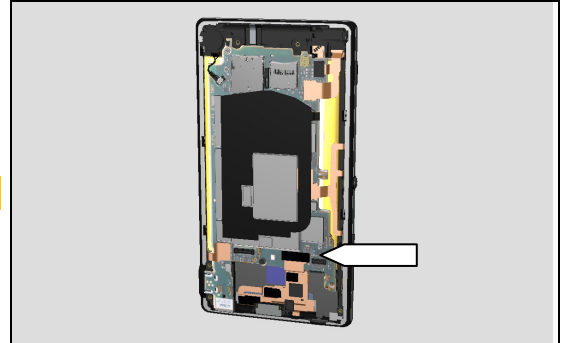
Place the new Adhesive NFC according to the picture.



## Re-Assembly: PBA Complete Assy

Attach the BtB connectors from the Front Assy Unit.

**Secure the BtB connector is in place with your fingers!**



## Re-Assembly

### 5.3 Carrier Spbox Assy

Insert the Carrier Spbox Assy into the frame, upper side of the part first.

**Secure that the Carrier Spbox Assy have snapped into place!**

Secure it with a new Screw 1.6 screw.

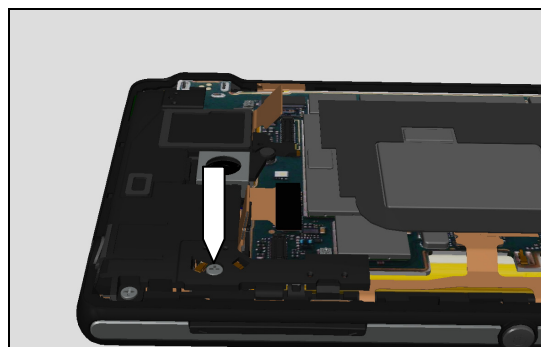
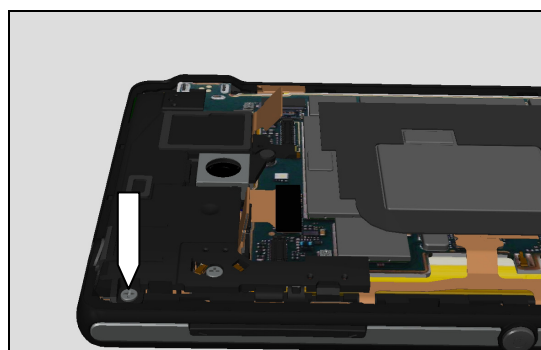
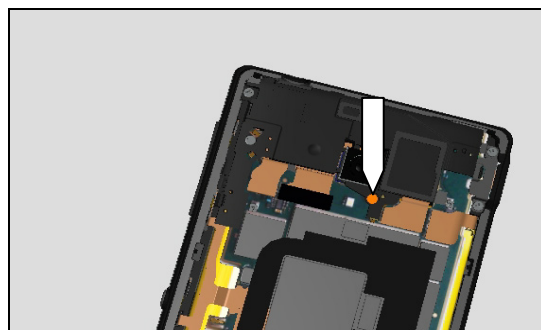
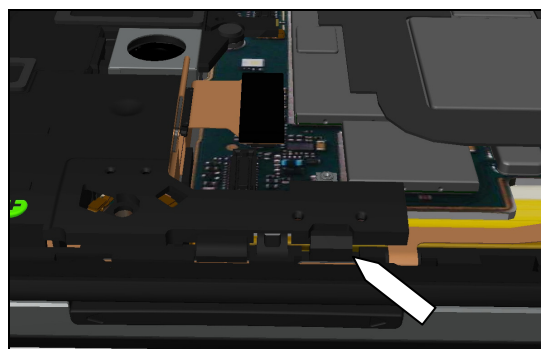
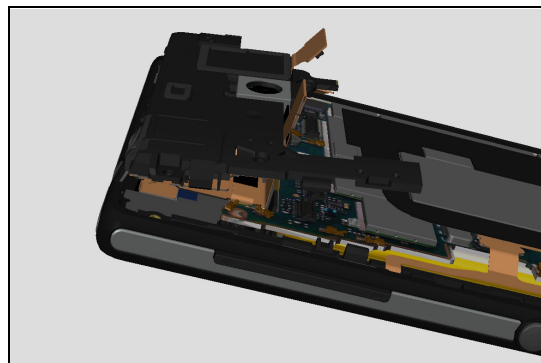
Use Bits (JCIS No 0 →  $8 \pm 2$  Ncm torque).

Secure it with a new Screw 3.0 screw.

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

Secure it with a new Screw 3.5 screw.

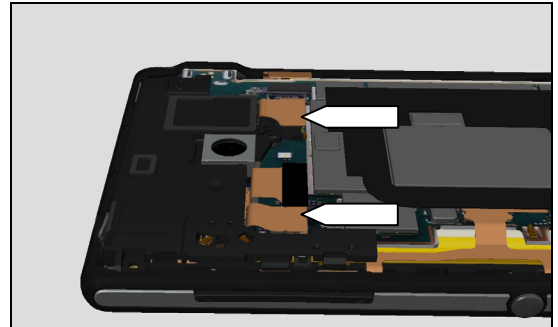
Use Bits (JCIS No 0 →  $14 \pm 2$  Ncm torque).



## Re-Assembly: Carrier Spbox Assy

Connect the BtB connectors from the FPC AVP and Camera 13 MP to the BPA Complete.

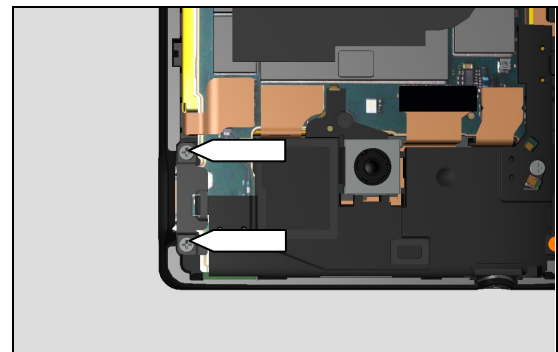
**Secure the BtB connections are in place with your fingers!**



### 5.4 Clip USB

Place the Clip USB according to picture and secure with two new Screw 3.0 Screws.

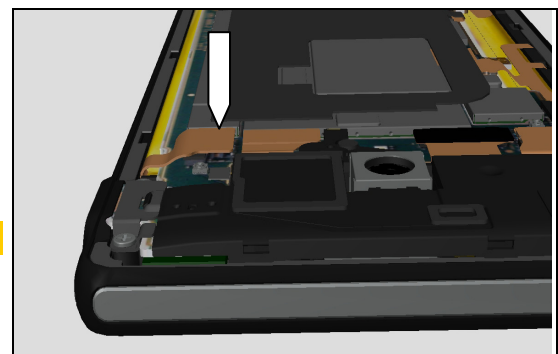
Use Bits (JCIS No 0 → 12 ± 2 Ncm torque).



### 5.5 Connect battery

Connect the BtB connector from the Battery 2300 mAh.

**Secure the BtB connection is in place with your fingers!**



## Re-Assembly

### 5.6 Back Cover Assy

**Remove and clean any remaining adhesive residue found on Back Cover Assy and Front Assy Unit.**

Prepare a new Adhesive Backcover and use the Backcover Adhesive alignment fixture to attach the Adhesive Backcover to the Back Cover Assy.

Start with the top side.

**Note the hooks!**

Secure the Back Cover Assy's by pressing from top down and by snapping all the 6 hooks.

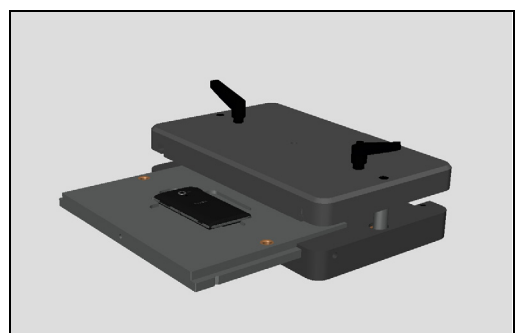
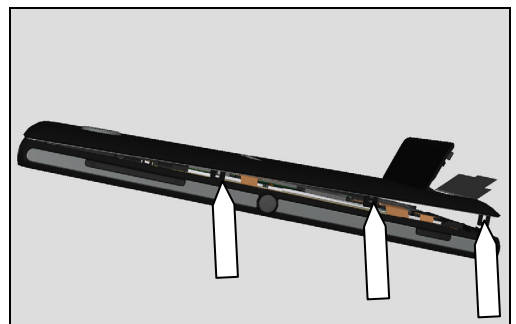
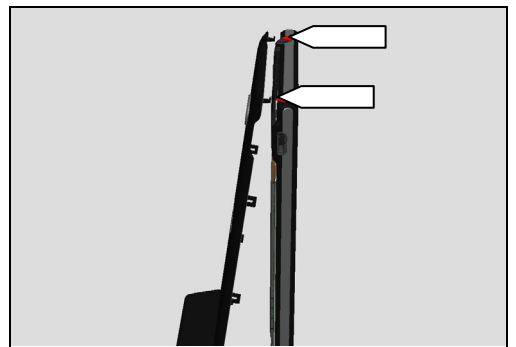
**Note the hooks!**

Secure the Back Cover Assy with the pressure tool at **250N** in **10s**.

Upper inlay = Backpanel 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.



## Re-Assembly

Secure the Back Cover Assy with two new Screw 3.0 Screws

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

**Insert the SIM card and Memory Card if present!**

Fold the label and close the Cover Card.



## 6 Revision History

Rev.	Date	Changes / Comments
1	2013-Feb-27	First Release
2	2013-Mars-28	New removal procedure for battery