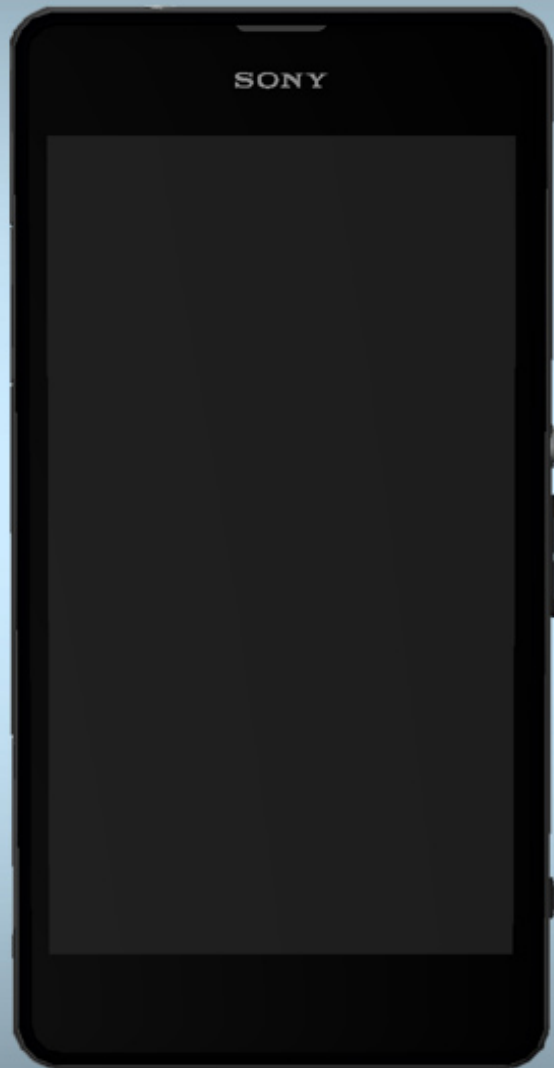


Working Instructions

- mechanical -



Xperia™ Z1 Compact
D5503, M51w

CONTENTS

1	Exterior Views.....	5
1.1	D5503	5
2	Tools	6
3	Disassembly.....	8
3.1	Panel Rear Assy	8
3.2	Battery.....	10
3.3	Cover Rear	11
3.4	Carrier Holder Speaker Assy.....	13
3.5	Plate Label & SIM Tray.....	13
3.6	Holder USB	15
3.7	Display	16
3.8	Main PBA & Frame Main Assy.....	19
4	Replacement	22
4.1	Panel Rear Assy	22
4.2	Battery.....	22
4.3	Cover Rear	22
4.4	Carrier Holder Speaker Assy.....	22
4.5	Plate Label	23
4.6	SIM Tray	23
4.7	Holder USB	23
4.8	Display	23
4.9	Frame Main Assy.....	24
4.10	Adhesive Battery.....	25
4.11	Adhesive Battery Panel Rear.....	26
4.12	Adhesive Conductive A	27
4.13	Adhesive Holder USB	28
4.14	Adhesive Loudspeaker	29
4.15	Adhesive WP 2nd Mic	30
4.16	Adhesive WP Audio Jack	31
4.17	Adhesive WP Cover Rear	32
4.18	Adhesive WP Display.....	34
4.19	Adhesive WP Earspeaker & Ear Speaker WR	36
4.20	Adhesive WP Panel Rear	38
4.21	Antenna BT + WLAN	40
4.22	Antenna NFC	41
4.23	Camera Chat 2MPixel.....	43
4.24	Camera Chat Holder.....	44

4.25	Camera Main Holder.....	45
4.26	Camera Main MPixel.....	46
4.27	Cap SD.....	47
4.28	Cap SIM.....	48
4.29	Cap USB.....	49
4.30	Cushion 0.0mmSi Speaker + Cushion WP Speaker.....	50
4.31	Cushion Con Vibrator	52
4.32	Cushion FPC Audio Jack.....	53
4.33	FPC Audio Jack + Adhesive FPC Audio Jack A + Adhesive FPC Audio Jack B	54
4.34	FPC Camera Key	57
4.35	FPC Side Key.....	58
4.36	Gasket PBA A.....	59
4.37	Gasket PBA B.....	60
4.38	Label Core Unit.....	61
4.39	Loudspeaker.....	63
4.40	Magnetic Connector.....	64
4.41	MComp Sheet (G) Camera	65
4.42	Net Front.....	67
4.43	Rear Net Earspeaker	68
4.44	Panel Speaker.....	69
4.45	Plate Label Base.....	70
4.46	Sheet Con Battery	71
4.47	Sheet Graphite.....	72
4.48	Sheet Thermal Conductive Camera	73
4.49	Vibrator + Adhesive Vibrator + Holder Vibrator	74
4.50	Water Indicator (Cover Rear).....	76
4.51	Water Indicator (Holder USB).....	77
4.52	Board Swap – Replacement	78
4.53	Board Swap – Change Label	78
4.54	Board Swap – Customize of Software	78
5	Reassembly.....	79
5.1	Main PBA Assy & Frame Main Assy	79
5.2	Display	80
5.3	Holder USB	81
5.4	Plate Label and SIM Tray	81
5.5	Carrier Holder Speaker Assy.....	82
5.6	Cover Rear.....	82
5.7	Battery.....	84
5.8	Panel Rear Assy	85

6 Revision History 87

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

***Sony Xperia Z1 Compact (D5503) is unibody designed phone this allows the Display section 3.8
of disassembly and 5.8 of reassembly to be replaced directly or disassembled fully following
disassembly/reassembly procedure!***

***Quality assurance for each replacement and reassembly steps inspect each part before assembly
clean using Isopropyl Alcohol to remove dust, dirt or any foreign objects, performing cleaning
process ensures water proof reliability!***

1 Exterior Views

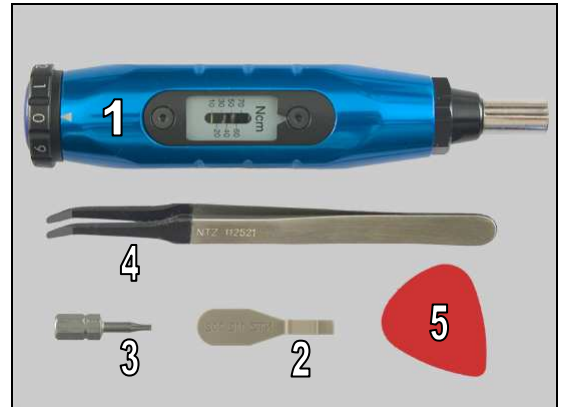
1.1 D5503



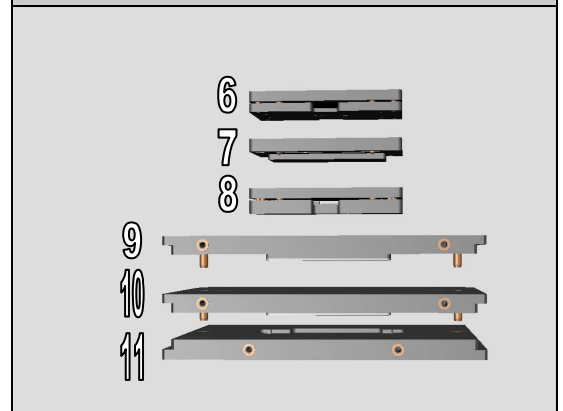
2 Tools

SPECIAL TOOLS

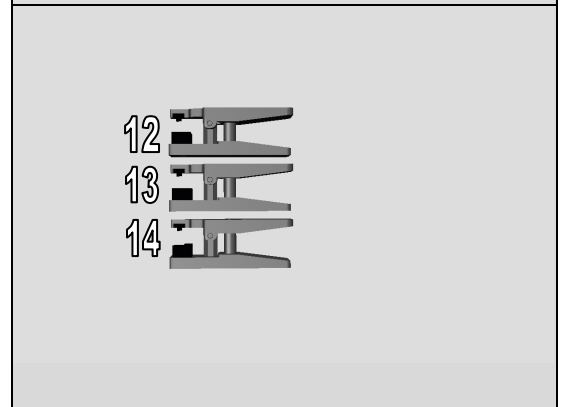
1. Torque Screwdriver
2. Front Opening Tool
3. Torx JCIS
4. Flex Film Assembly Tool
5. Guitar Pick



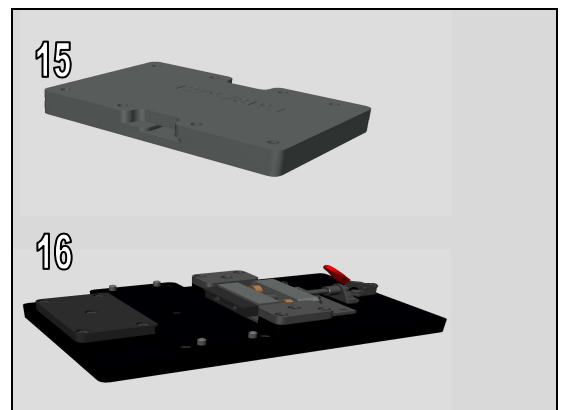
6. Display Adhesive alignment fixture
7. Rear Cover Adhesive alignment fixture
8. Back Panel Adhesive alignment fixture
9. Rear Cover Press Top Inlay
10. Rear Panel Press Top Inlay
11. Display Press Bottom Inlay



12. Press Tool Earspeaker
13. Press Tool Loudspeaker
14. Audio Jack press

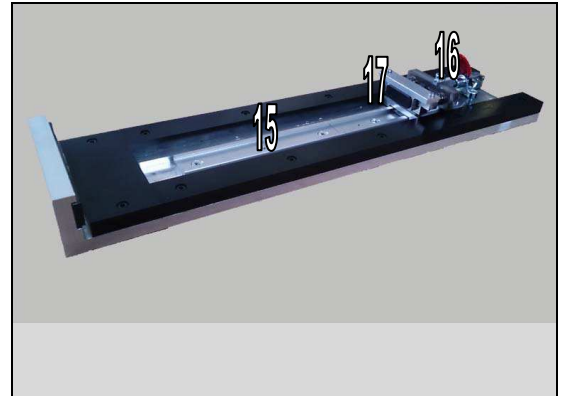


15. NFC Antenna Alignment Fixture.
16. Manual Display disassembly fixture



Tools

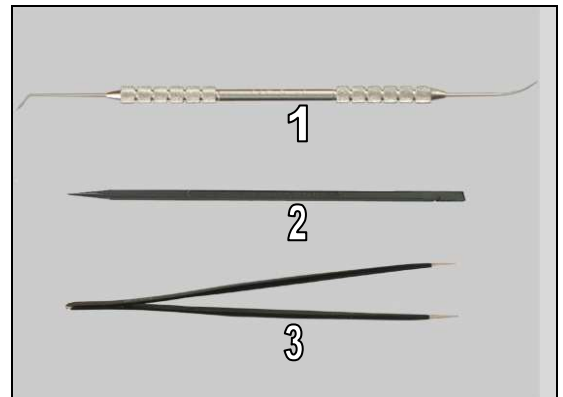
- 15. Side Panel press
- 16. Side Panel Press Head
- 17. Charge connector press pad



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

STANDARD TOOLS

- 1. Dentist Hook
- 2. Nylon Pointer
- 3. Tweezer



- 4. Suction cup



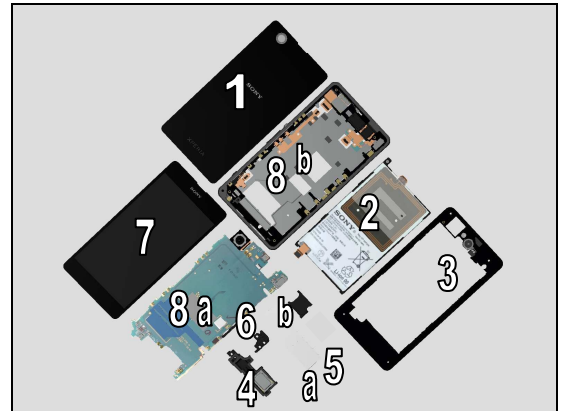
- 5. Hot Air with Temperature Control.



3 Disassembly

The disassembly is done in the following order:

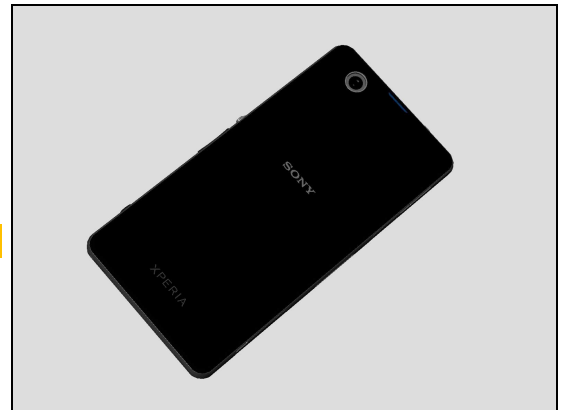
1. Panel Rear Assy
2. Battery
3. Cover Rear
4. Carrier Holder Speaker Assy
5. Plate Label & SIM Tray
6. Holder USB
7. Display
8. Main PBA & Frame Main Assy



3.1 Panel Rear Assy

Remove SD card if inserted!

Use heat gun at low temperature at bottom area of phone for 5 minutes to soften adhesive shown in picture.

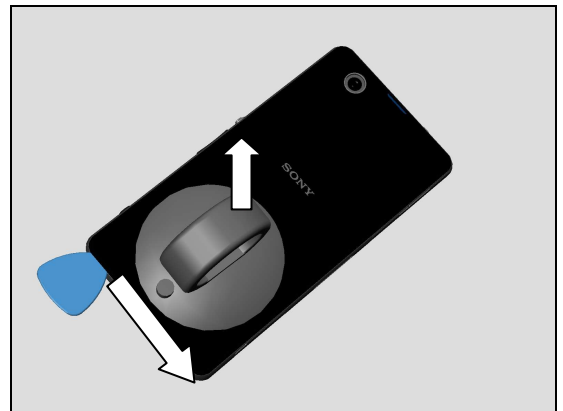


Use Suction cup to get space for inserting the Guitar Pick.

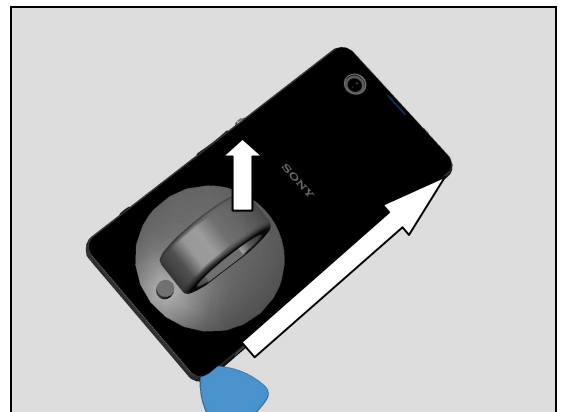


Disassembly

Insert Guitar Pick and gently slide the Guitar Pick along bottom as shown, releasing Panel Rear Assy.

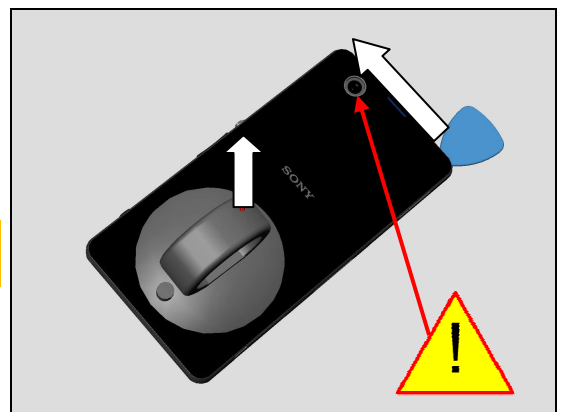


Repeat action for other side.

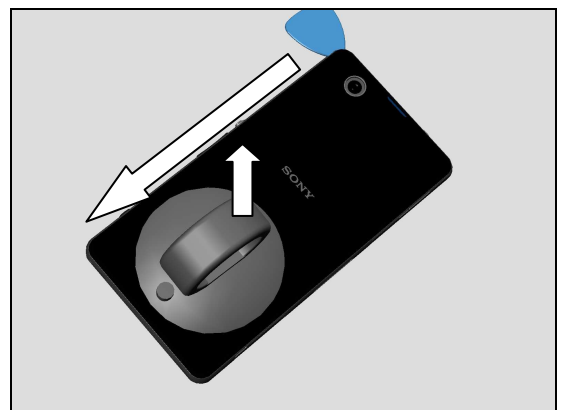


Repeat action for top side.

Be careful not to damage camera when using plectrum on the top of phone!



Repeat action for other side.



Disassembly

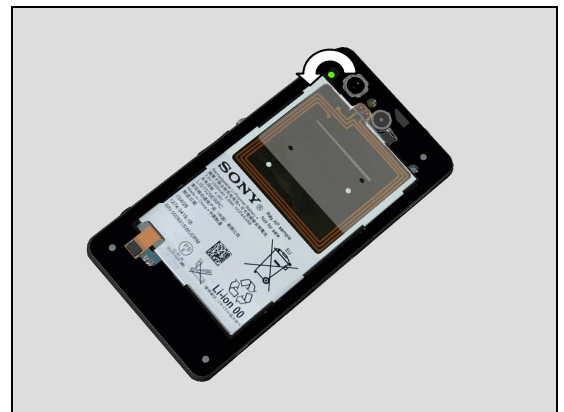
Remove the Panel Rear Assy by using the Suction cup.

Be careful when removing the Panel Rear Assy small portion adhesive may still be attached!

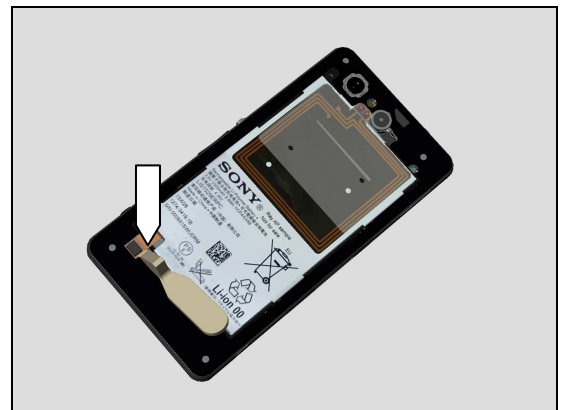


3.2 Battery

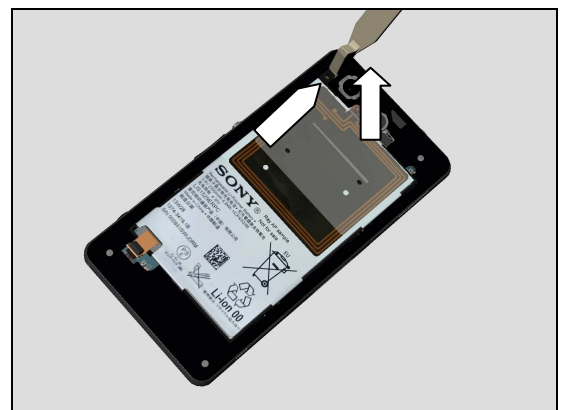
Remove the Screw Other Len:2.6 Diam:1.4 M, by using a screwdriver with Torx Bits JCIS



Use Front Opening Tool to disconnect the BtB connector.



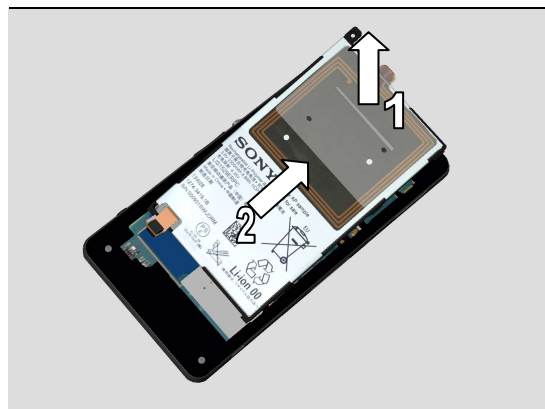
Use Front Opening Tool gently to tilt up the battery as shown in picture.



Disassembly

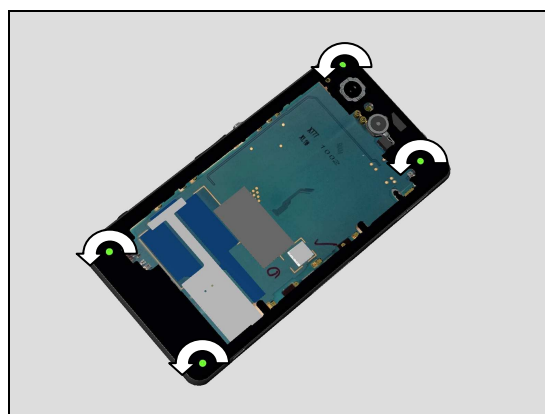
1. Raise the Battery with fingers gripping at both sides.
2. Lift it off to remove it.

**Carefully inspect the Battery after removing it.
Battery with visual signs of been punctured etc. should
be scraped after removal!**

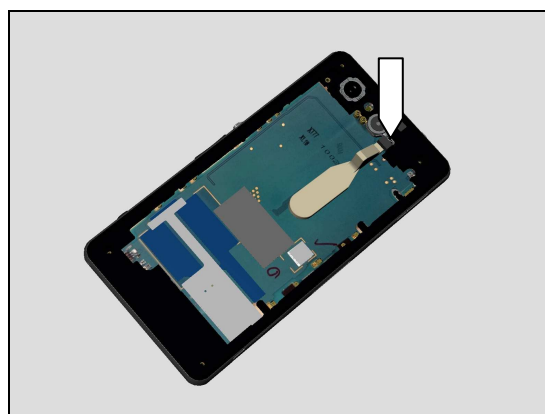


3.3 Cover Rear

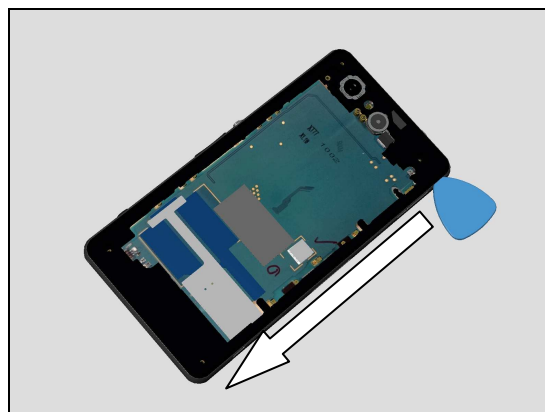
Remove the four Screw Len:4.5 Diam:1.4, by using a screwdriver with Torx Bits JCIS



Use Front Opening Tool to disconnect the Vibrator BtB connector.

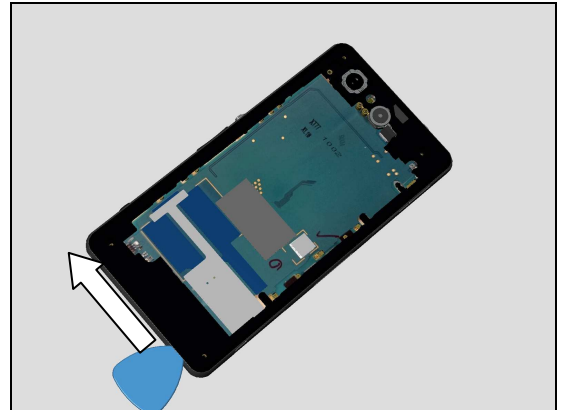


Insert Guitar Pick and gently slide the Guitar Pick along side of phone as shown, releasing Rear Cover.

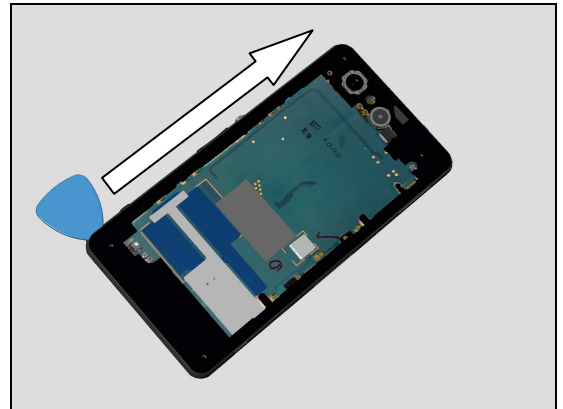


Disassembly

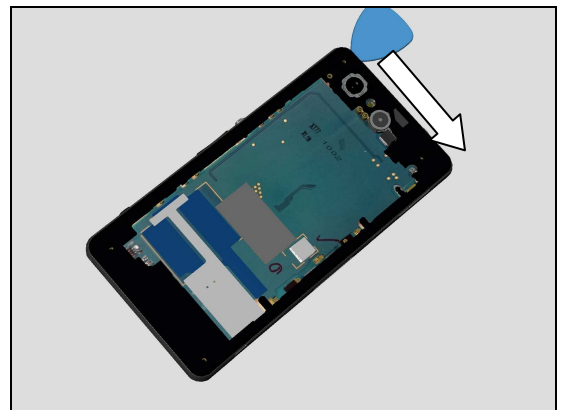
Repeat action for bottom side.



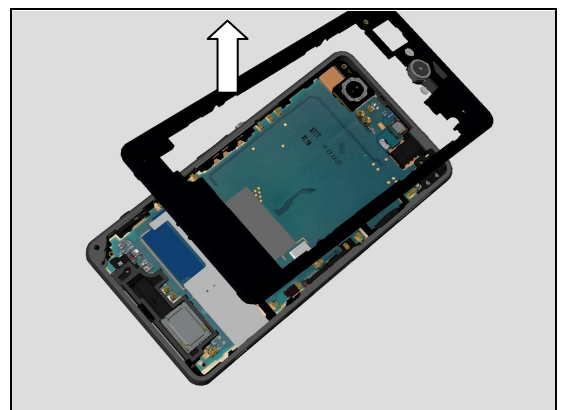
Repeat action for other side.



Repeat action for topside.



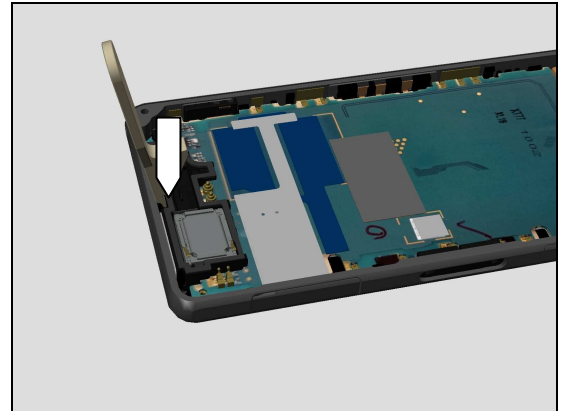
Remove the Rear Cover with fingers.



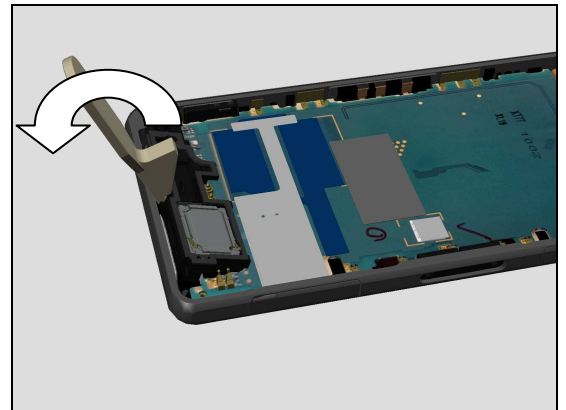
Disassembly

3.4 Carrier Holder Speaker Assy

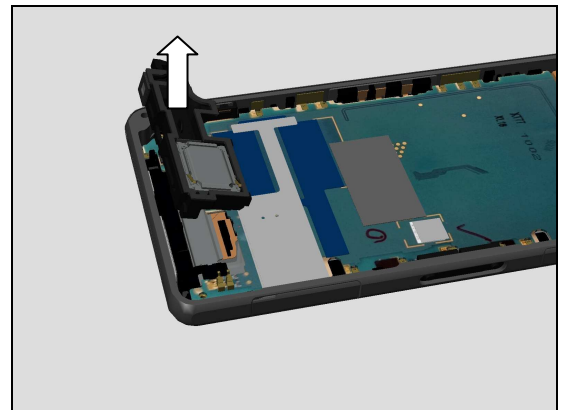
Insert Front Opening Tool into Carrier Holder Speaker Assy cavity as shown in picture.



Use Front Opening Tool gently to tilt up the Carrier Holder Speaker Assy as shown in picture.

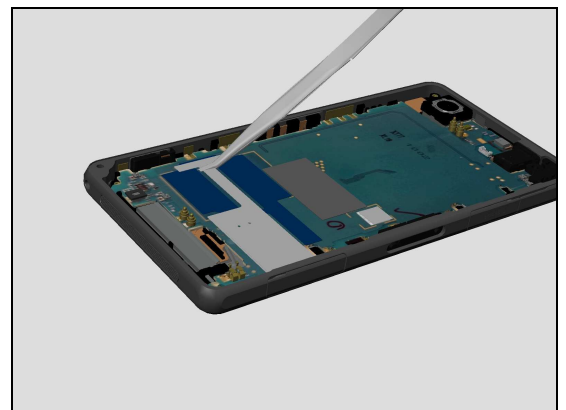


Remove the Carrier Holder Speaker Assy with fingers.



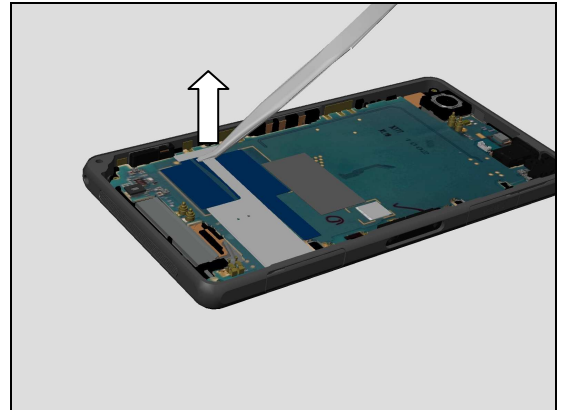
3.5 Plate Label & SIM Tray

Using Flex Film Assembly Tool gently grip Plate Label as shown in picture.

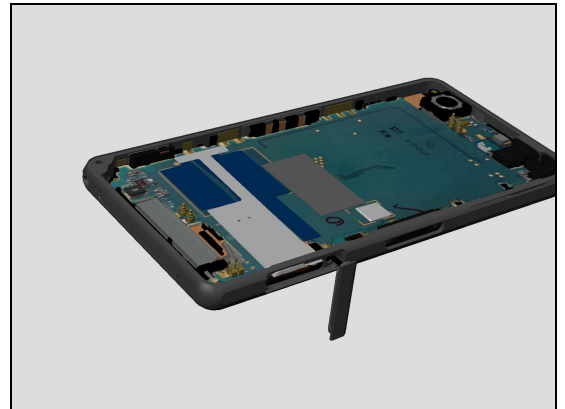


Disassembly

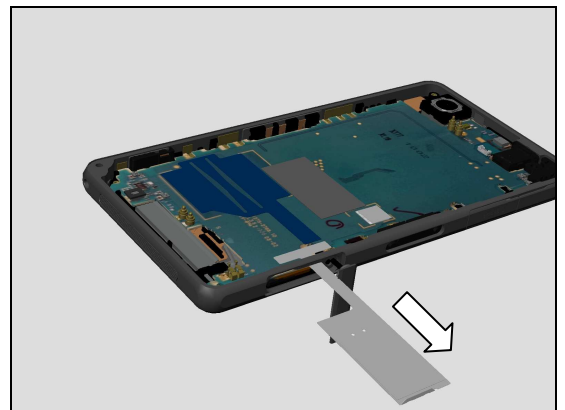
Using Flex Film Assembly Tool gently lift up Plate Label above Plate Label Base as shown in picture.



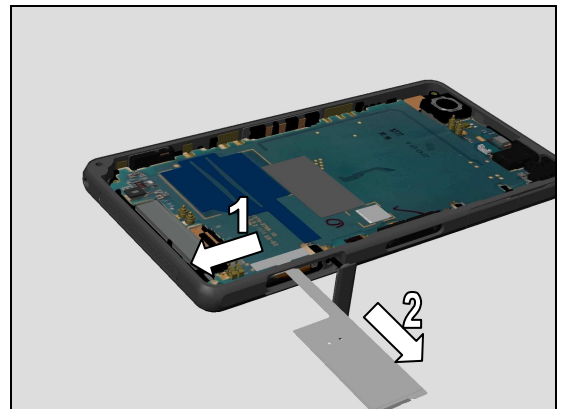
Open Cap SIM.



Using fingers pullout Plate Label as shown in picture.

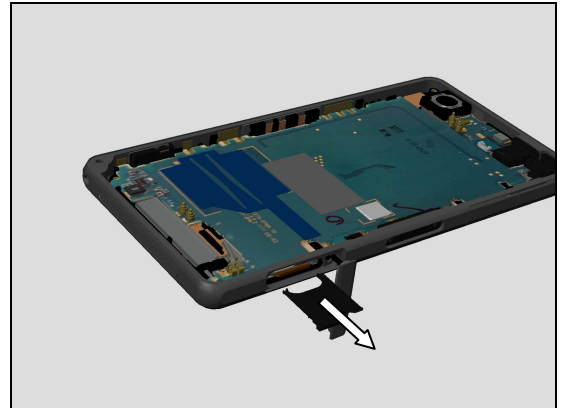


1. Slide Plate Label as shown in picture.
2. Remove Plate Label.

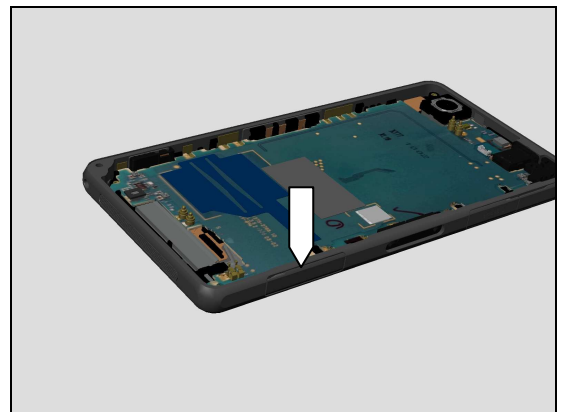


Disassembly

Remove the SIM Tray with fingers.

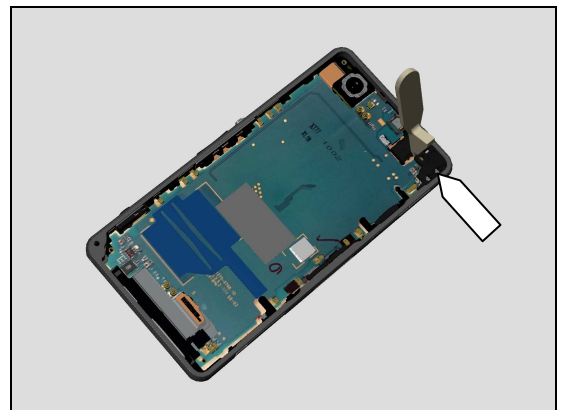


Close Cap SIM.

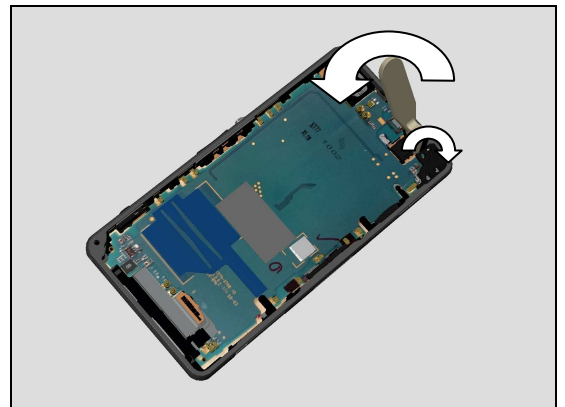


3.6 Holder USB

Insert Front Opening tool as shown in picture



Tilting Front Opening Tool, this action will simultaneously raise Holder USB.



Disassembly

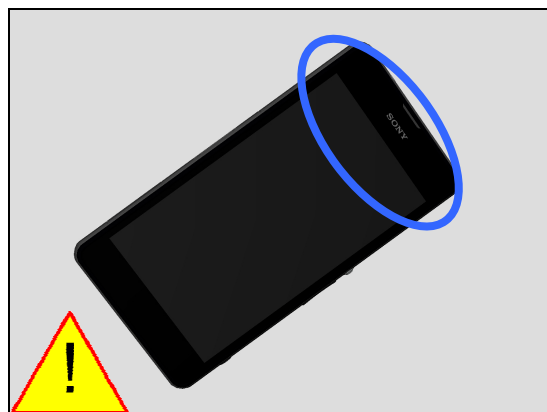
Remove Holder USB with fingers.



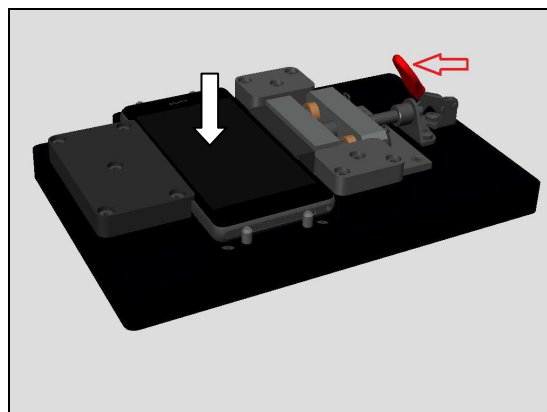
3.7 Display

Heat topside area of Display with Hot Air Gun for 10 min at maximum temperature of 85 (°C) .

Temperature must not exceed 85 (°C) !
Note: If temperature controlled component baking oven available onsite can used placing complete Front Assy into oven 85 (°C) for 30 minutes!

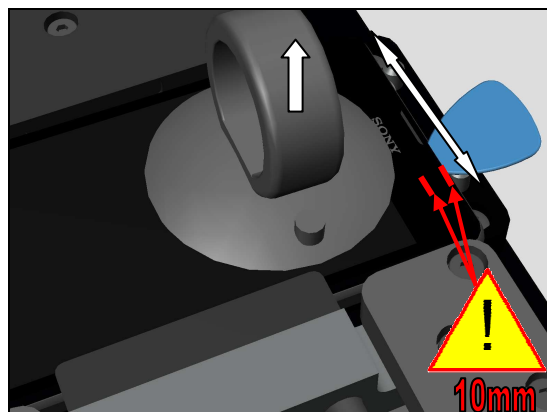


Place phone into Manual Display disassembly fixture, then secure phone by closing lever as shown in picture.



Use Suction cup to get space for inserting the Guitar Pick. as shown in picture to release Adhesive WP Display.

Do not insert Guitar Pick deeper than 10mm, deeper insertion will damage Display!
Do not insert Guitar Pick on either side of phone this will damage Display!

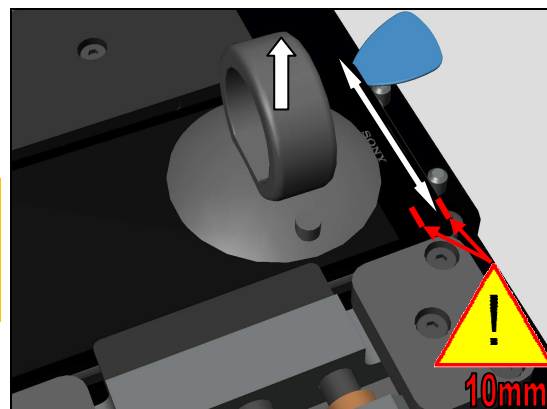


Disassembly

Slide Guitar Pick back and forth to loosen Adhesive WP Display.

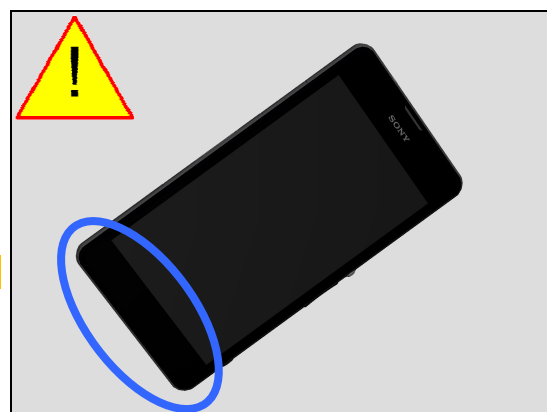
Do not insert Guitar Pick deeper than 10mm, deeper insertion will damage Display!

Do not insert Guitar Pick on either side of phone this will damage Display!

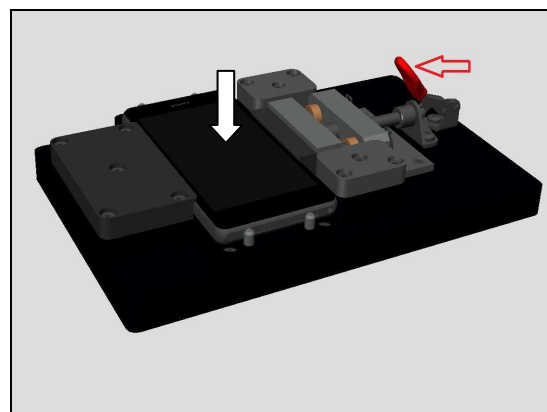


Heat bottom side area of Display with Hot Air Gun for 10 min at maximum temperature of 85 (°C) .

Temperature must not exceed 85 (°C) !



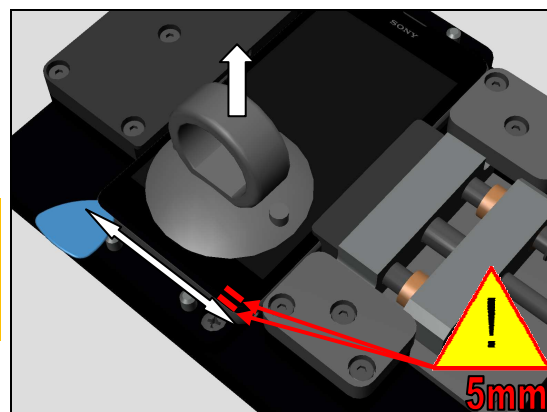
Place phone into Manual Display disassembly fixture, then secure phone by closing lever as shown in picture.



Use Suction cup to get space for inserting the Guitar Pick. Insert the Guitar Pick as shown in picture and gently slide to release Adhesive WP Display at bottom of Display.

Do not insert Guitar Pick deeper than 5mm, deeper insertion will damage Display!

Do not insert Guitar Pick on either side of phone this will damage Display!

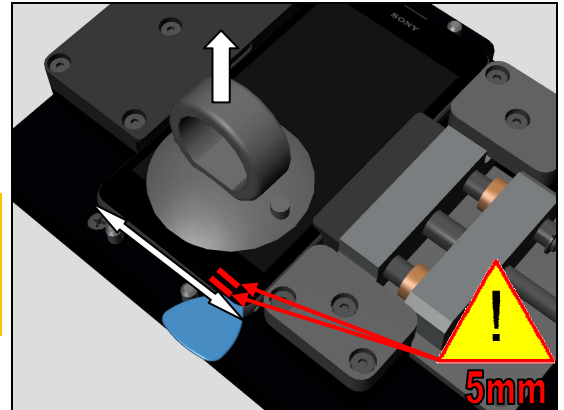


Disassembly

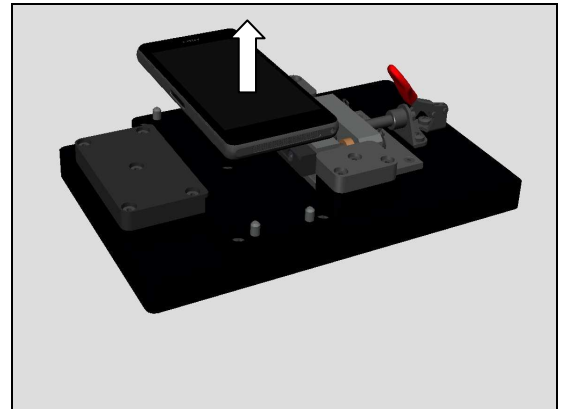
Slide Guitar Pick back and forth to loosen Adhesive WP Display.

Do not insert Guitar Pick deeper than 5mm, deeper insertion will damage Display!

Do not insert Guitar Pick on either side of phone this will damage Display!

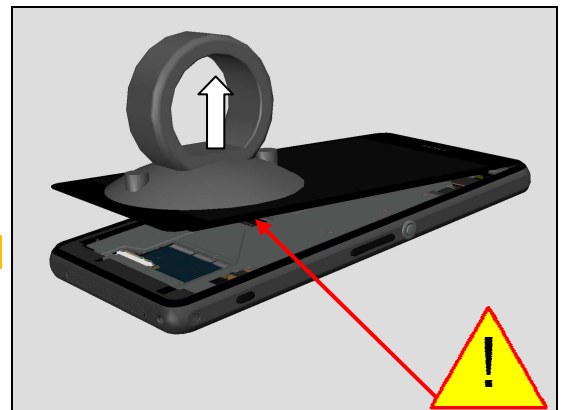


Remove from Manual Display disassembly fixture.

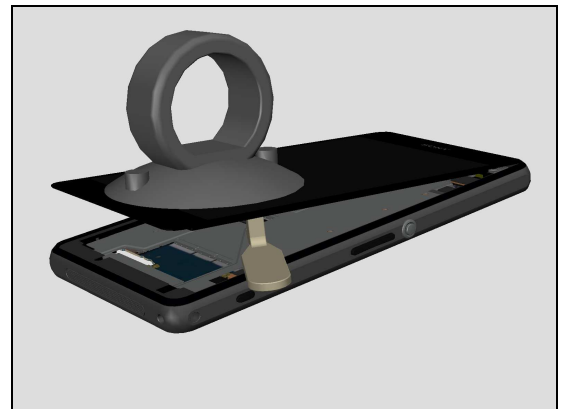


Gently lift up Display as shown in picture.

Be careful not to damage Display FPC!

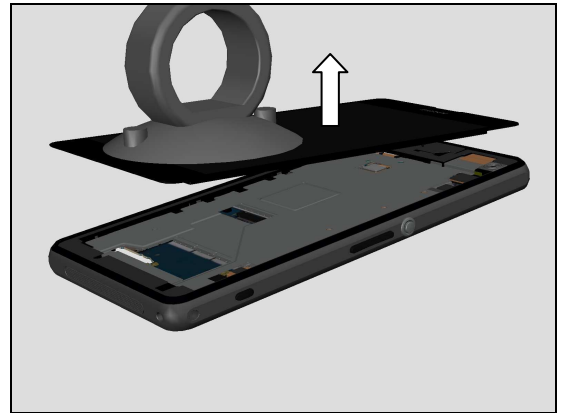


Use Front Opening Tool to disconnect the Display BtB connector.



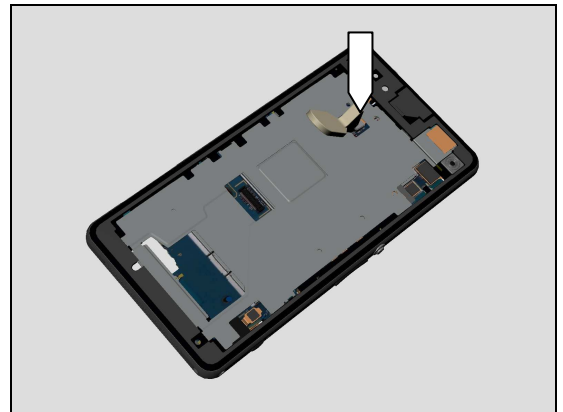
Disassembly

Remove the Display from Frame Main Assy

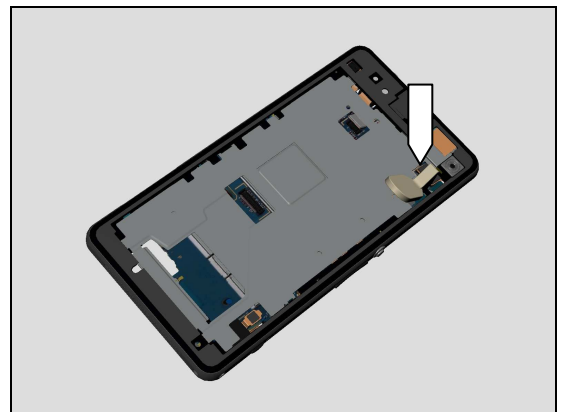


3.8 Main PBA & Frame Main Assy

Use Front Opening Tool to disconnect the FPC Audio Jack BtB connector.

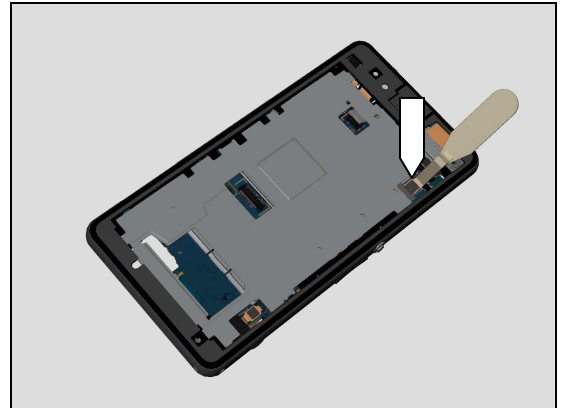


Use Front Opening Tool to disconnect the Camera Chat 2MPixel BtB connector.

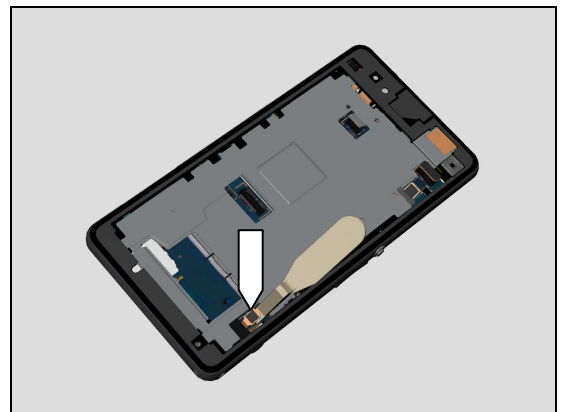


Disassembly

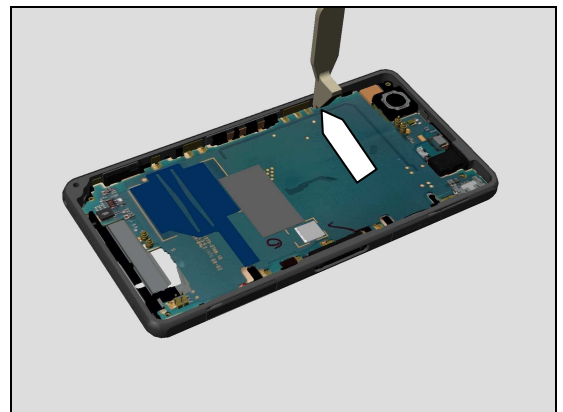
Use Front Opening Tool to disconnect the FPC Camera Key BtB connector.



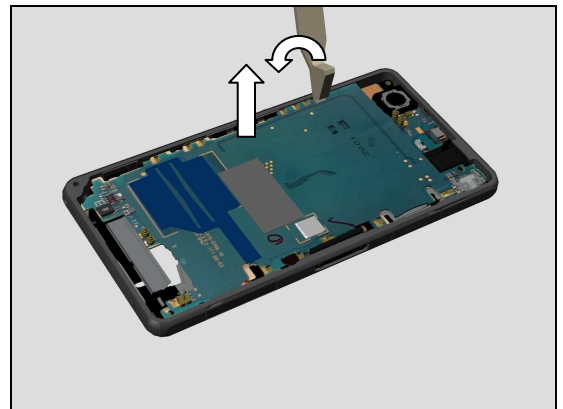
Use Front Opening Tool to disconnect the FPC Side Key BtB connector.



Insert Front Open Tool into cavity as shown in picture.

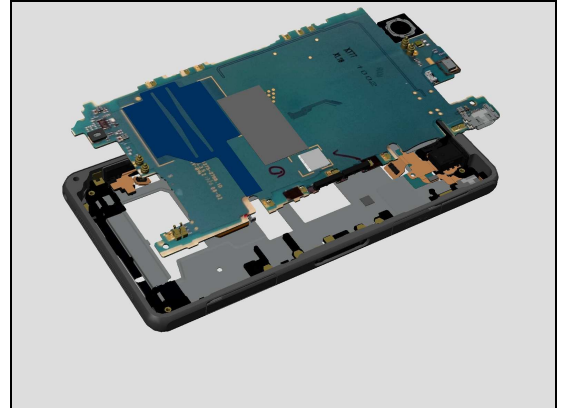


Tilting Front Opening Tool, this action will simultaneously raise PBA Assy.



Disassembly

Remove the Main PBA Assy from Frame Main Assy with fingers.



4 Replacement

4.1 Panel Rear Assy

Follow the 3.1 Disassembly instructions!

Note! If reuse of Panel Rear Assy follow 4.20 Removal Instruction!

Prepare a new Panel Rear Assy!

Note! If reuse of Panel Rear Assy follow 4.20 Installation Instruction!

Follow the 5.8 Reassembly instructions!

Caution: Be careful, middle section of Cover Rear may raise up during the disassembly of Panel Rear Assy, this could damage WP seal between Cover Rear and Main Frame Assy!



4.2 Battery

Follow the 3.1 and 3.2 Disassembly instructions!

Follow the 4.10, 4.11, 4.22 and 4.46 Removal instructions!

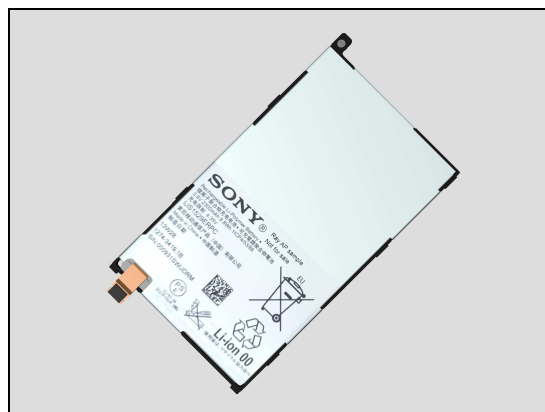
Carry out the Removal as described below!

Prepare a new Battery!

Carry out the Installation as described below!

Follow the 4.10, 4.11, 4.22 and 4.46 Installation instructions!

Follow the 5.7 and 5.8 Reassembly instructions!



4.3 Cover Rear

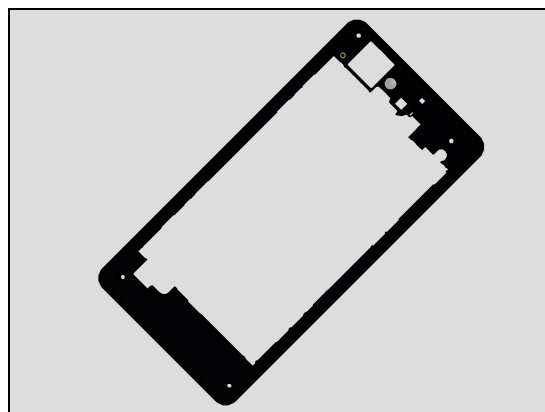
Follow the 3.1 - 3.3 Disassembly instructions!

Note! If reuse of Cover Rear follow 4.17 Removal Instruction!

Prepare a new Cover Rear!

Note! If reuse of Cover Rear follow 4.17 Installation Instruction!

Follow the 5.6 - 5.8 Reassembly instructions!



4.4 Carrier Holder Speaker Assy

Follow the 3.1 - 3.4 Disassembly instructions!

Follow the 4.14 and 4.40 Removal instructions!

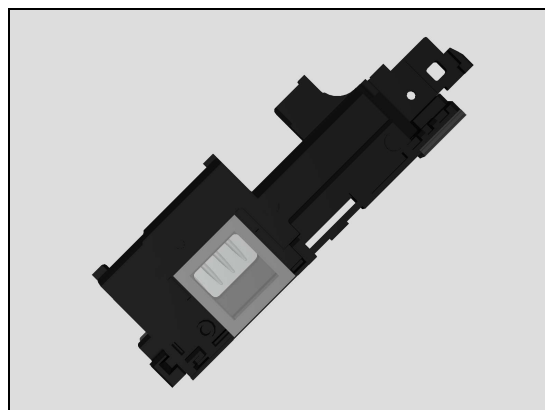
Carry out the Removal as described below!

Prepare a new Carrier Holder Speaker Assy!

Carry out the Installation as described below!

Follow the 4.14 and 4.40 Installation instructions!

Follow the 5.5 - 5.8 Reassembly instructions!



Replacement

4.5 Plate Label

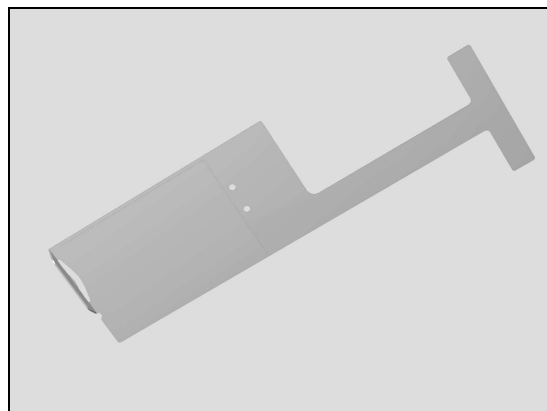
Follow the 3.1 - 3.5 Disassembly instructions!

Follow the 4.39 Removal instructions!

Prepare a new Plate Label!

Follow the 4.39 Installation instructions!

Follow the 5.4 - 5.8 Reassembly instructions!

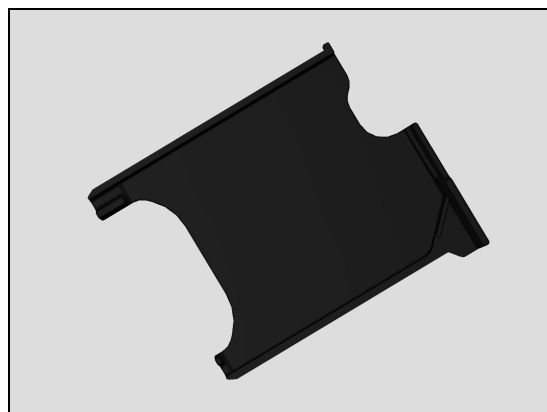


4.6 SIM Tray

Follow the 3.1 - 3.5 Disassembly instructions!

Prepare a new SIM Tray!

Follow the 5.4 - 5.8 Reassembly instructions!



4.7 Holder USB

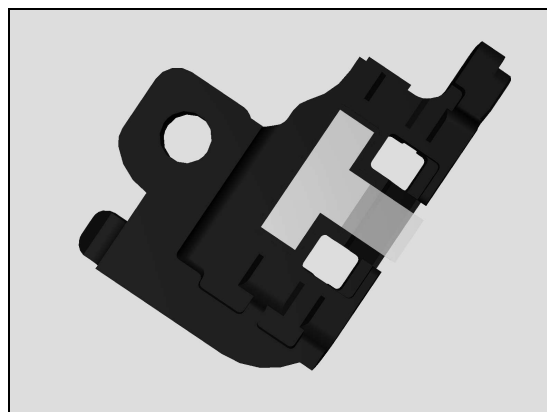
Follow the 3.1 - 3.6 Disassembly instructions!

Note! If reuse of Holder USB follow 4.13 Removal Instruction!

Prepare a new Holder USB!

Note! If reuse of Holder USB follow 4.13 Installation Instruction!

Follow the 5.3 - 5.8 Reassembly instructions!



4.8 Display

Follow the 3.7 Disassembly instructions!

Note! If reuse of Display follow 4.18 Removal Instruction!

Prepare a new Display!

Note! If reuse of Display follow 4.18 Installation Instruction!

Follow the 4.47 Installation instructions!

Follow the 5.2 Reassembly instructions!

Follow the 5.8 Reassembly instruction (Rack Press Chapter)



Replacement

4.9 Frame Main Assy

Follow the 3.1 – 3.8 Disassembly instructions!

Follow the 4.37, 4.38 Removal instructions!

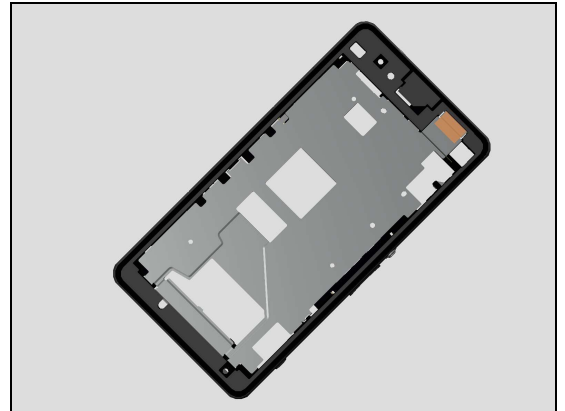
Carry out the Removal as described below!

Prepare a new Frame Main Assy!

Carry out the Installation as described below!

Follow the 4.38, 4.40 Installation instructions!

Follow the 5.1 - 5.8 Reassembly instructions!



Replacement

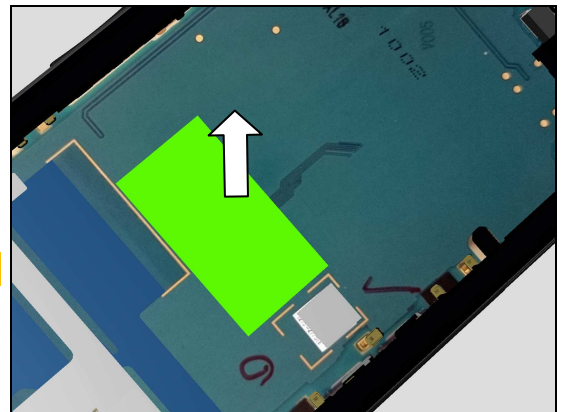
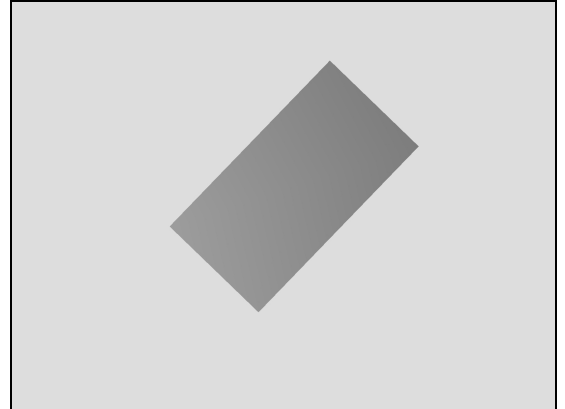
4.10 Adhesive Battery

*Follow the 3.1 and 3.2 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive Battery!
Carry out the Installation as described below!
Follow the 5.7 and 5.8 Reassembly instructions!*

REMOVAL

Detach to remove the Adhesive Battery with the Dentist Hook.

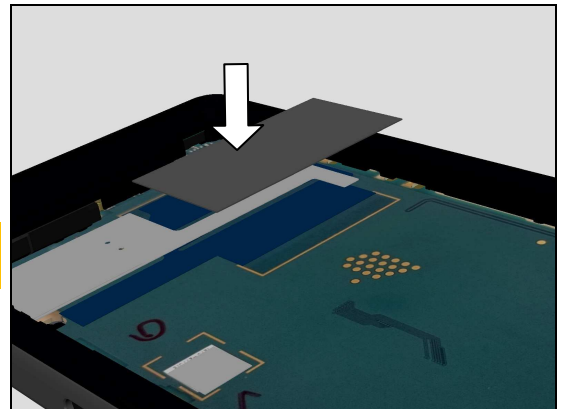
Scrap! Not to be reused!



INSTALLATION

Place a new Adhesive Battery in its proper position using Flex Film Assembly Tool.

Adhesive Battery positional guidance, use PBA label and Plate Base markings!



Replacement

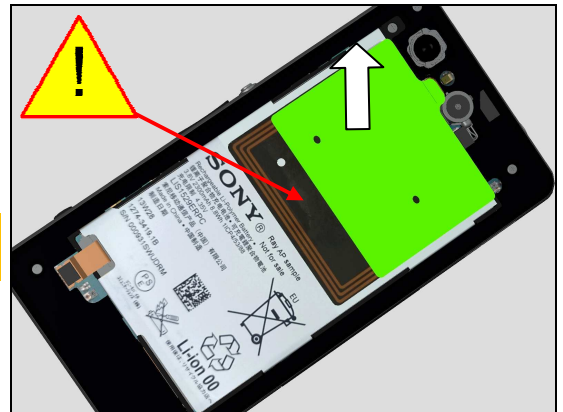
4.11 Adhesive Battery Panel Rear

Follow the 3.1 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive Battery Panel Rear!
Carry out the Installation as described below!
Follow the 5.8 Reassembly instructions!

REMOVAL

Detach to remove the Adhesive Battery Panel Rear with Flex Film Assembly Tool.

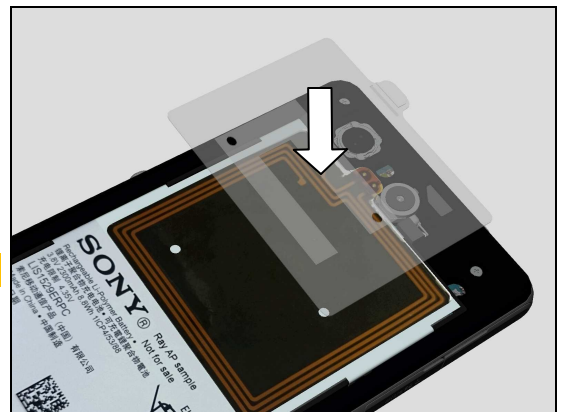
Scrap! Not to be reused!
Be careful not to damage Antenna NFC!



INSTALLATION

Place a new Adhesive Battery Panel Rear in its proper using Flex Film Assembly Tool.

Use Antenna NFC outline for positional guidance!



Replacement

4.12 Adhesive Conductive A

Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.40 Removal instructions!
Carry out the Removal as described below!
Prepare a new Adhesive Conductive A!
Carry out the Installation as described below!
Follow the 4.40 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

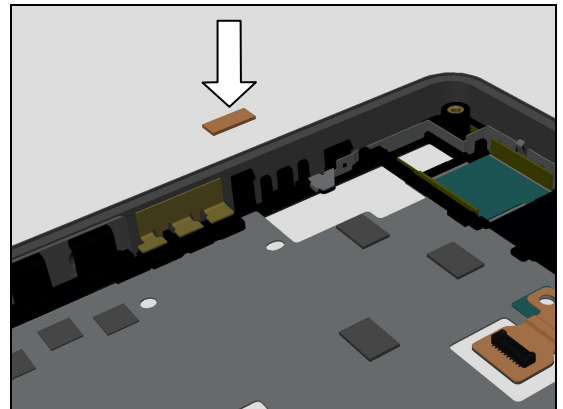
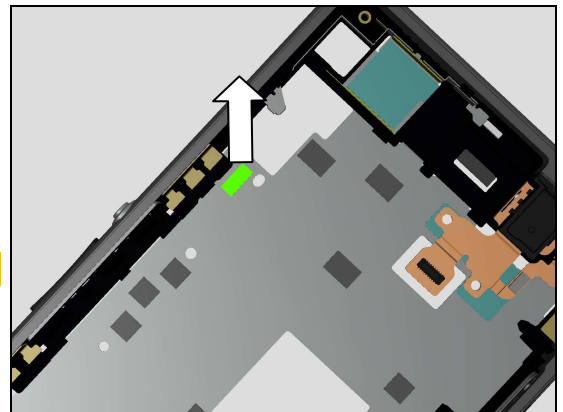
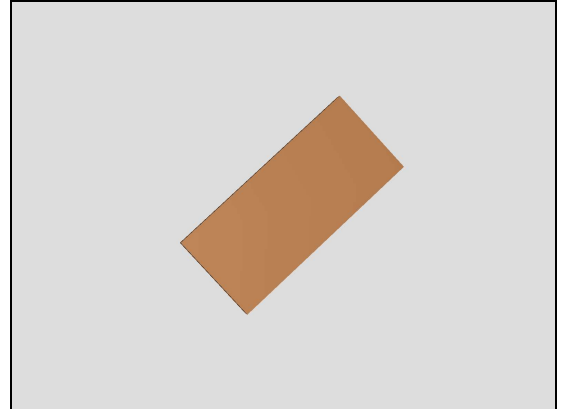
REMOVAL

Detach to remove the Adhesive Conductive A with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place a new Adhesive Conductive A using a Flex Film Assembly Tool.



Replacement

4.13 Adhesive Holder USB

*Follow the 3.1 - 3.6 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive Holder USB!
Carry out the Installation as described below!
Follow the 5.3 - 5.8 Reassembly instructions!*

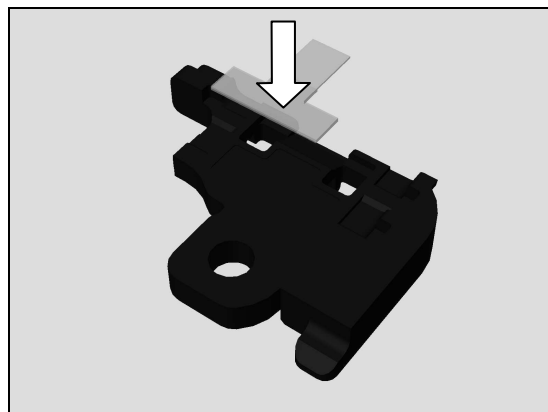
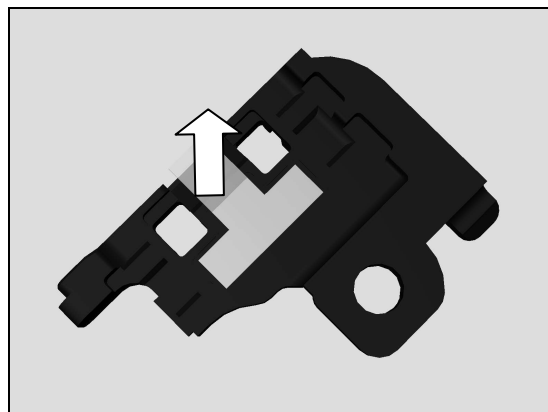
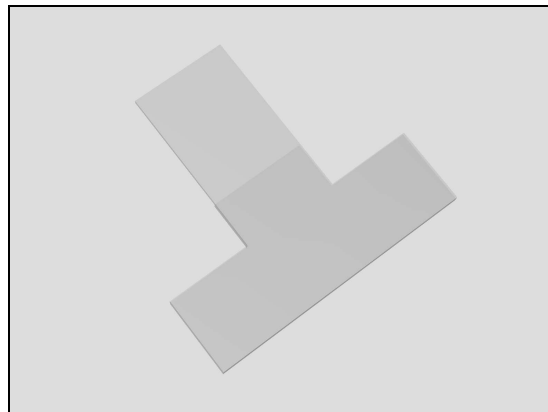
REMOVAL

Detach to remove the Adhesive Holder USB with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place new Adhesive Holder USB using a Flex Film Assembly Tool into its proper position.



Replacement

4.14 Adhesive Loudspeaker

Follow the 3.1 - 3.4 Disassembly instructions!
Follow the 4.40 Removal instructions!
Carry out the Removal as described below!
Prepare a new Adhesive Loudspeaker!
Carry out the Installation as described below!
Follow the 4.40 Installation instructions!
Follow the 5.5 - 5.8 Reassembly instructions!

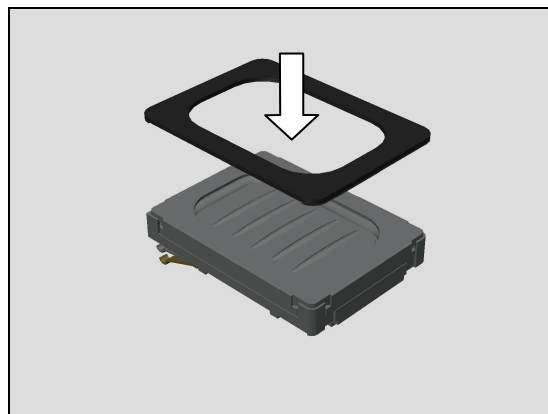
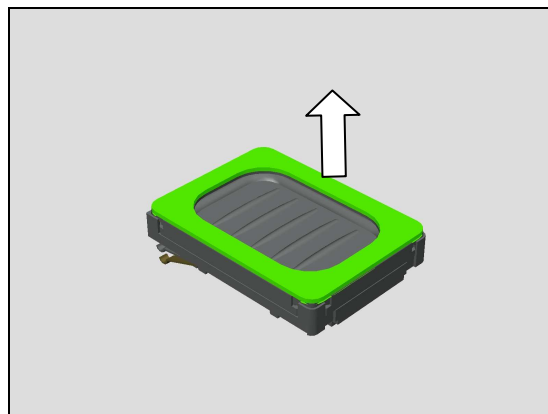
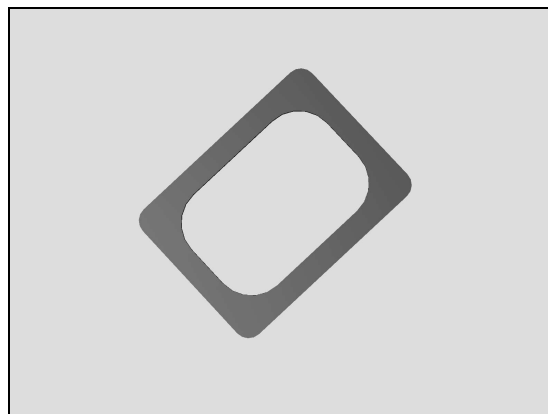
REMOVAL

Detach to remove the Adhesive Loudspeaker with the Dentist Hook.

Clean any remaining adhesive residue!
Scrap! Not to be reused!

INSTALLATION

Place new Adhesive Loudspeaker using a Flex Film Assembly Tool into its proper position.



Replacement

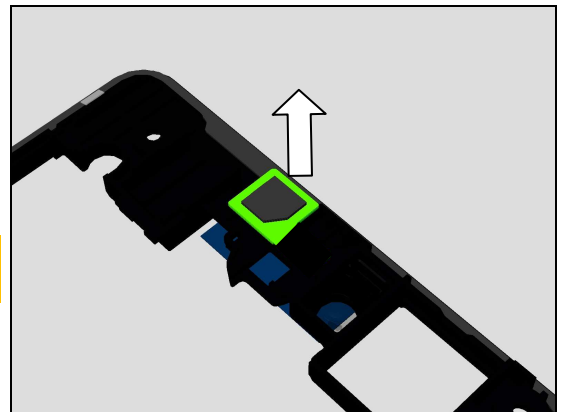
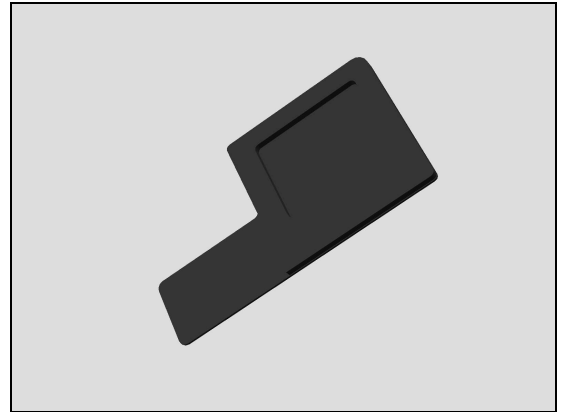
4.15 Adhesive WP 2nd Mic

*Follow the 3.1 - 3.3 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive WP 2nd Mic!
Carry out the Installation as described below!
Follow the 5.6 - 5.8 Reassembly instructions!*

REMOVAL

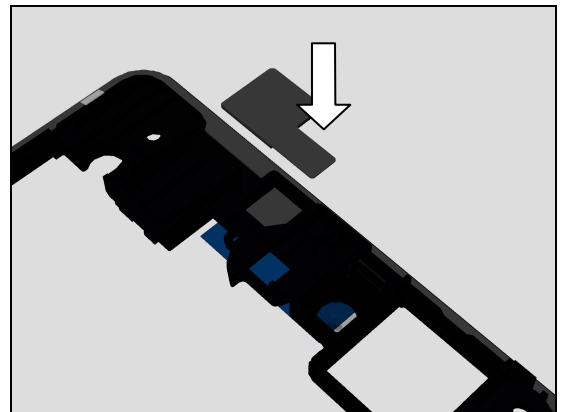
Detach to remove the Adhesive WP 2nd Mic with the Dentist Hook.

Clean any remaining adhesive residue!
Scrap! Not to be reused!



INSTALLATION

Place new Adhesive WP 2nd Mic using a Flex Film Assembly Tool into its proper position.



Replacement

4.16 Adhesive WP Audio Jack

*Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.33, 4.34 Removal instructions!
Carry out the Removal as described below!
Prepare a new Adhesive WP Audio Jack.
Carry out the Installation as described below!
Follow the 4.33, 4.34 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!*

REMOVAL

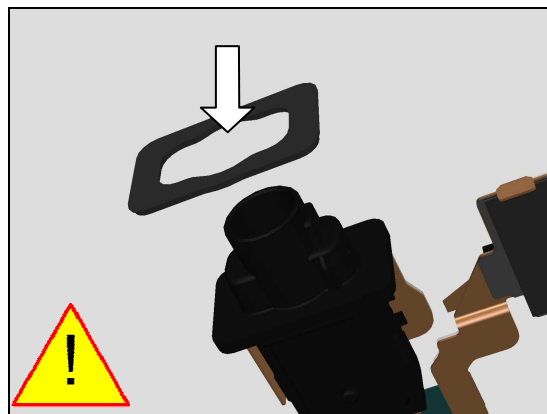
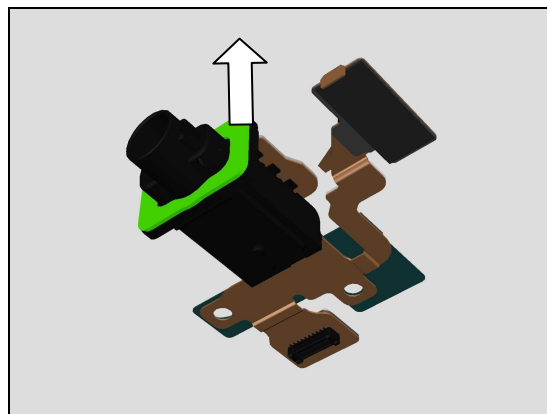
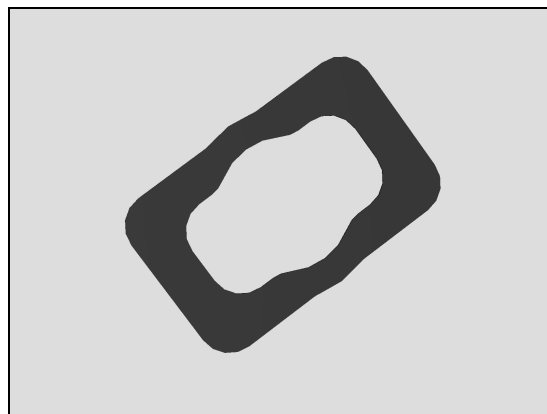
Detach to remove the Adhesive WP Audio Jack with the Dentist Hook.

**Clean any remaining adhesive residue!
Scrap! Not to be reused!**

INSTALLATION

Place new Adhesive WP Audio Jack using a Flex Film Assembly Tool into its proper position.

Perform cleaning on FPC Audio Jack using Isopropyl Alcohol before assembly important to make sure that old adhesive is fully removed plus inspect FPC Audio Jack for any dirt or dust before installation because of WRT requirement!



Replacement

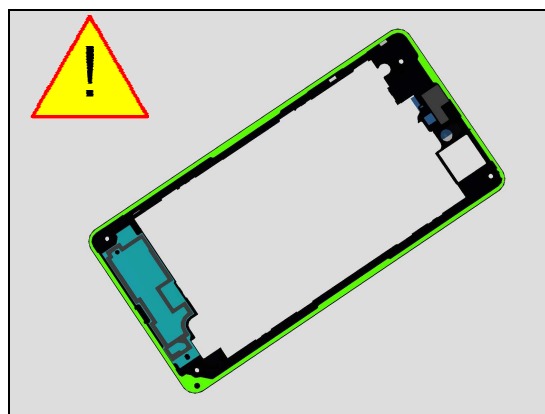
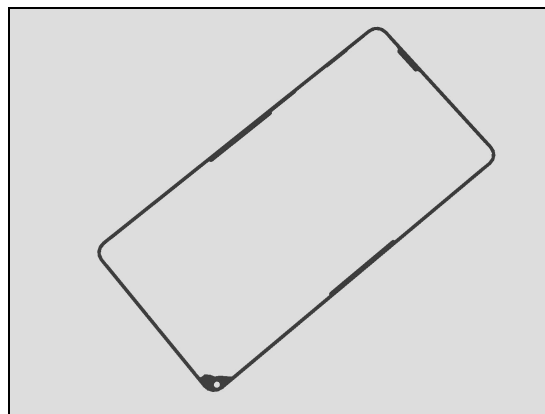
4.17 Adhesive WP Cover Rear

*Follow the 3.1 - 3.3 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive WP Cover Rear.
Carry out the Installation as described below!
Follow the 5.6 - 5.8 Reassembly instructions!*

REMOVAL

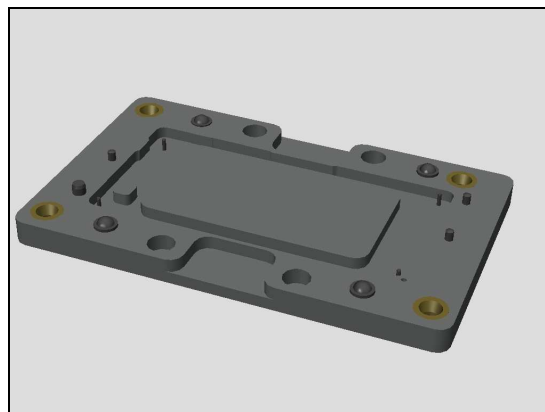
Remove the Adhesive WP Cover Rear with fingers.

Use IPA Isopropyl Alcohol for cleaning!
Scrap! Not to be reused!

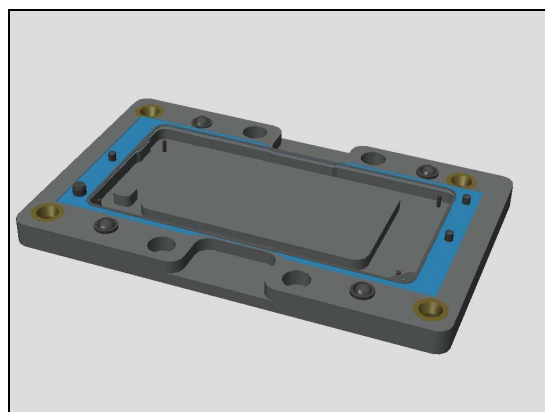


INSTALLATION

Prepare the Bottom Part of the Rear Cover Adhesive Alignment Fixture.



Place a new Adhesive WP Cover Rear with fingers in the Rear Cover Adhesive Alignment Fixture (Bottom Part).



Replacement:

Position then place, the Cover Rear above the Adhesive WP Cover Rear

Perform cleaning on Cover Rear using Isopropyl Alcohol before assembly important to make sure that old adhesive is fully removed plus inspect Cover Rear for any dirt or dust before installation because of WRT requirement!

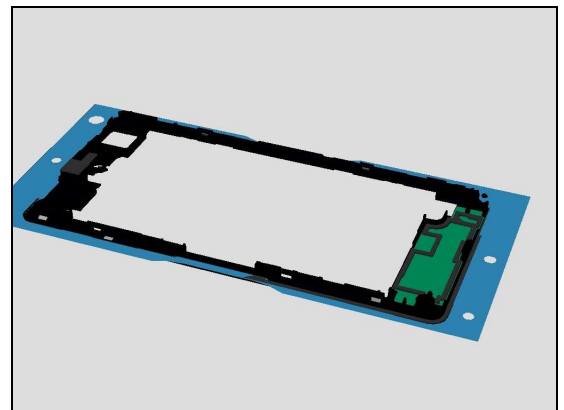
Please be careful not to peel off Rear Net Earspeaker when cleaning!



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



Remove Adhesive transfer sheet on Cover Rear part, only when ready to use Cover Rear!



Replacement

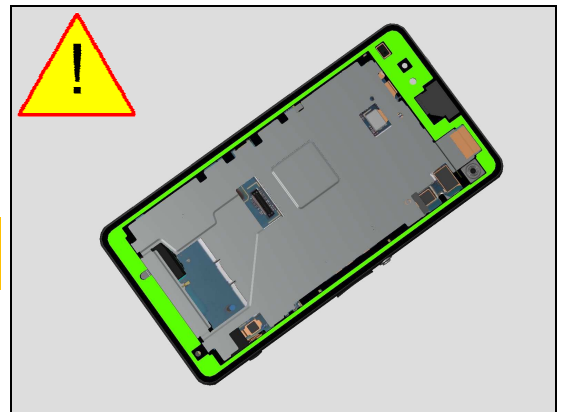
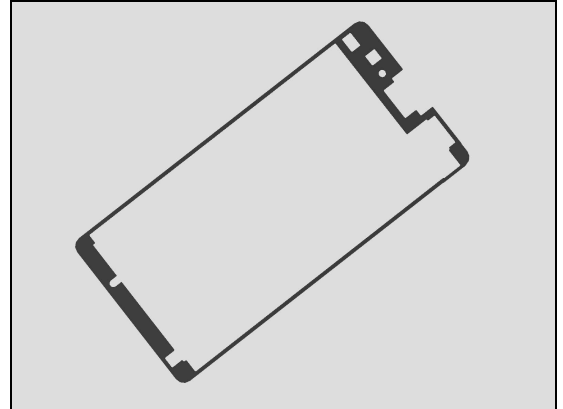
4.18 Adhesive WP Display

*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive WP Display.
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

REMOVAL

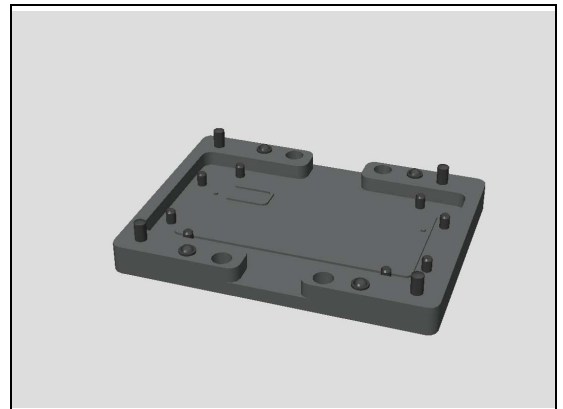
Remove the Adhesive WP Display with fingers.

***Use Isopropyl Alcohol for cleaning!
Scrap! Not to be reused!***

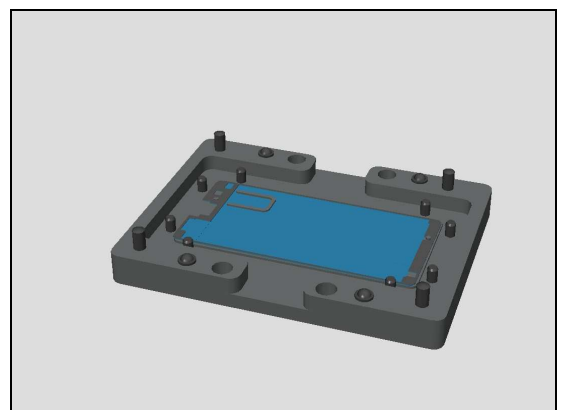


INSTALLATION

Prepare the Bottom Part of the Display Adhesive Alignment Fixture.



Place a new Adhesive WP Display with fingers in the Display Adhesive Alignment Fixture (Bottom Part).



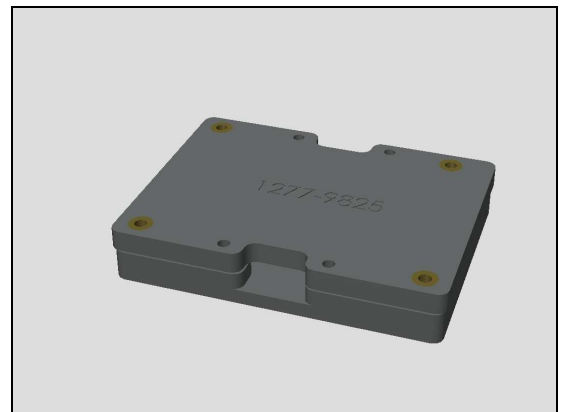
Replacement:

Position then place, the Phone Assy minus Display part above the Adhesive WP Display as shown in picture.

Perform cleaning on Frame Main Assy using Isopropyl Alcohol before assembly important to make sure that old adhesive is fully removed plus inspect Frame Main Assy for any dirt or dust before installation because of WRT requirement!



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



Remove Adhesive transfer sheet on Phone Assy located on front of Frame Main Assy part, only when ready to attach Display!



Replacement

4.19 Adhesive WP Earspeaker & Ear Speaker WR

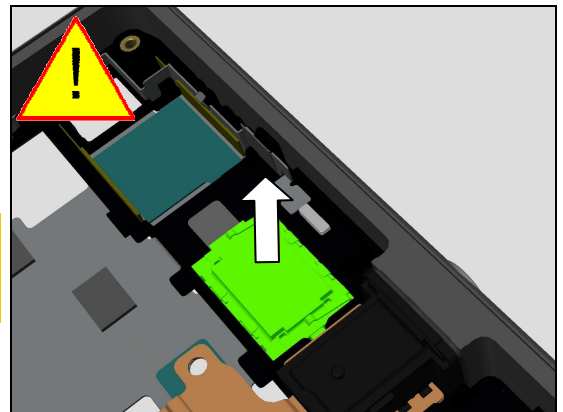
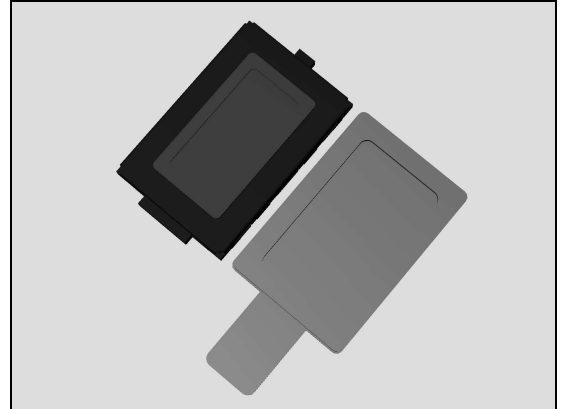
*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive WP Earspeaker & Ear Speaker WR!
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

REMOVAL

Insert the Front Opening Tool as shown in picture and gently remove the Ear Speaker WR.

Scrap! Not to be reused!

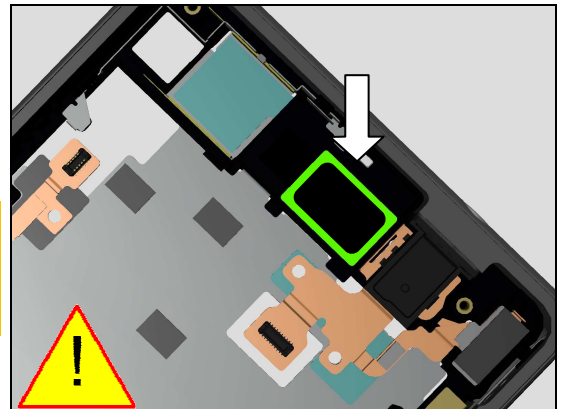
Use Isopropyl Alcohol for cleaning Frame Main Assy cavity!



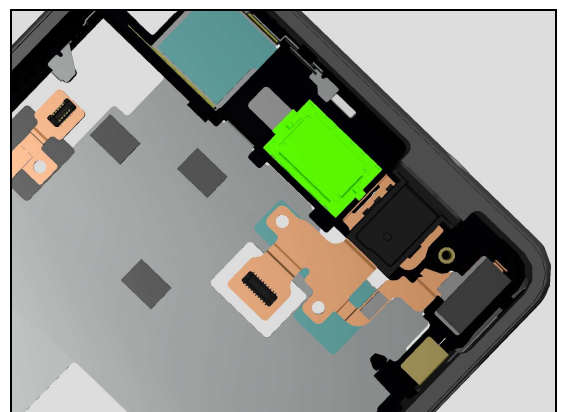
INSTALLATION

Attach a new Adhesive WP Earspeaker as shown in the picture.

Important to make sure that old adhesive is fully removed plus inspect Frame Main Assy cavity for any dirt or dust before installation because of WRT requirement!

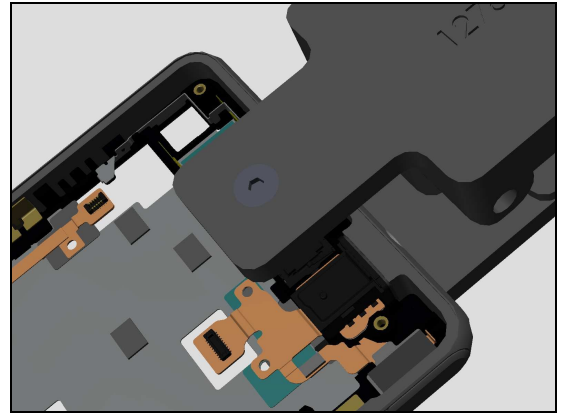


Position and place a new Ear Speaker WR into Frame Main Assy cavity as shown in picture.



Replacement

Use Press Tool Earspeaker and press for 5sec.



Replacement

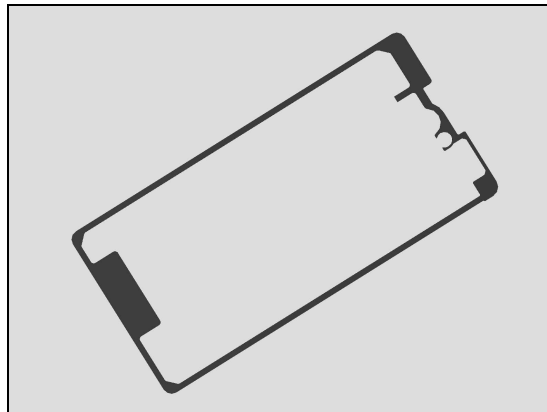
4.20 Adhesive WP Panel Rear

*Follow the 3.1 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Adhesive WP Panel Rear!
Carry out the Installation as described below!
Follow the 5.1 Reassembly instructions!*

REMOVAL

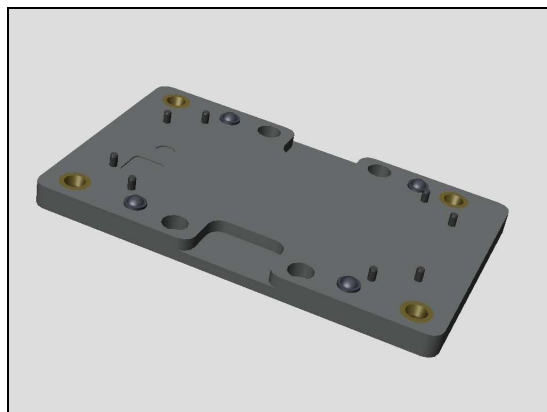
Remove the Adhesive WP Panel Rear with fingers.

Use Isopropyl Alcohol for cleaning!
Scrap! Not to be reused!

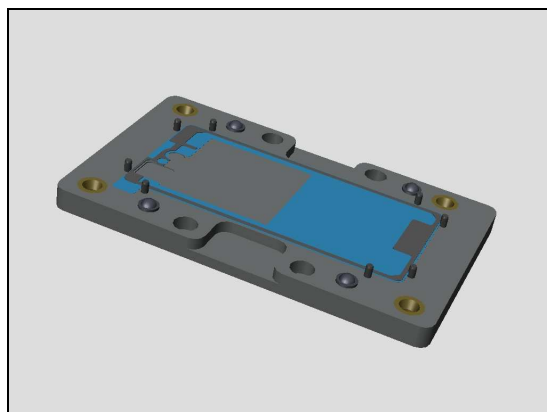


INSTALLATION

Prepare the Bottom Part of the Back Panel Adhesive Alignment Fixture.



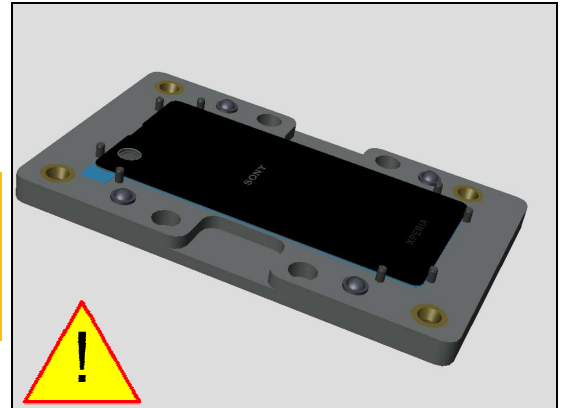
Place a new Adhesive WP Panel Rear with fingers in the Back Panel Adhesive Alignment Fixture (Bottom Part).



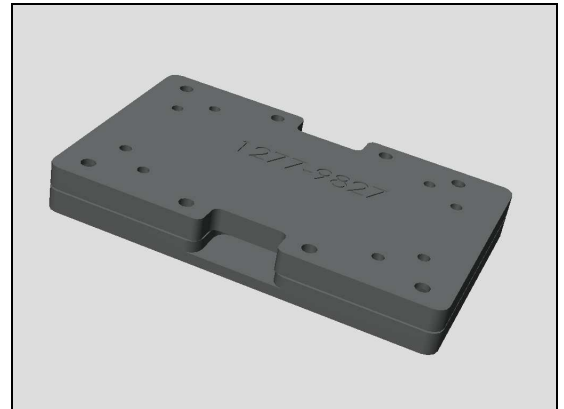
Replacement

Position then place, the Panel Rear Assy above the Adhesive WP Panel Rear.

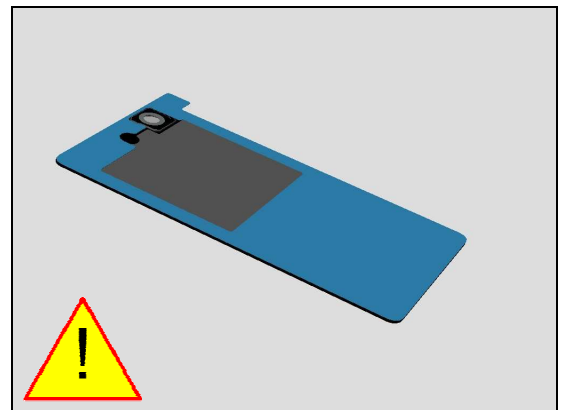
Perform cleaning on Panel Rear Assy using Isopropyl Alcohol before assembly important to make sure that old adhesive is fully removed plus inspect Panel Rear Assy for any dirt or dust before installation because of WRT requirement!



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



Remove Adhesive transfer sheet on Panel Rear Assy, only when ready to use Panel Rear Assy!



Replacement

4.21 Antenna BT + WLAN

*Follow the 3.1 - 3.3 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Antenna BT + WLAN!
Carry out the Installation as described below!
Follow the 5.6 - 5.8 Reassembly instructions!*

REMOVAL

Detach to remove the Antenna BT + WLAN with the Dentist Hook.

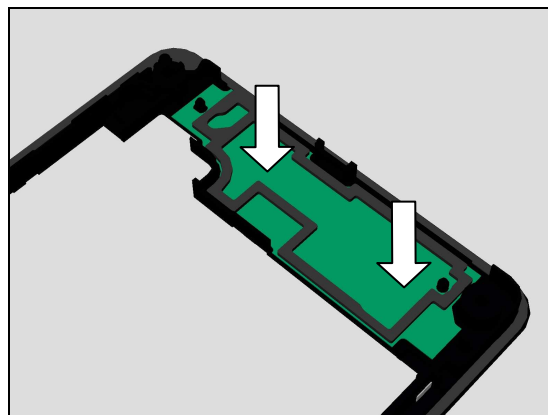
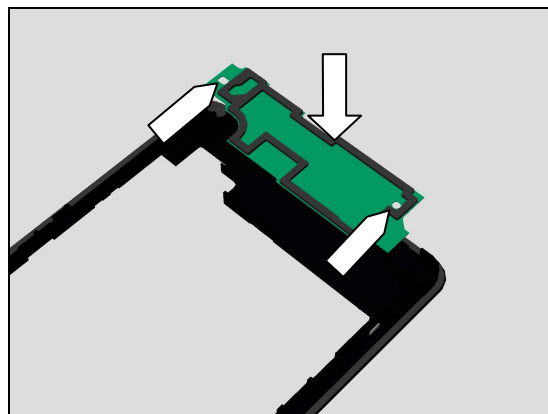
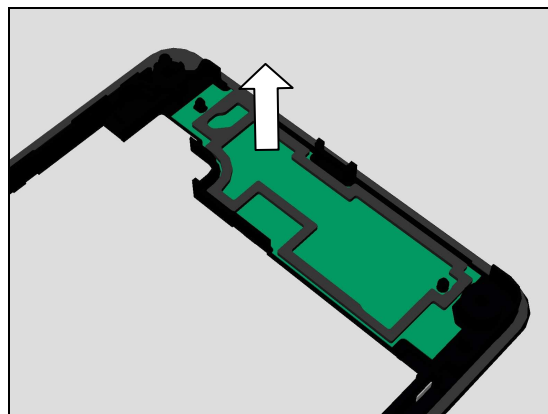
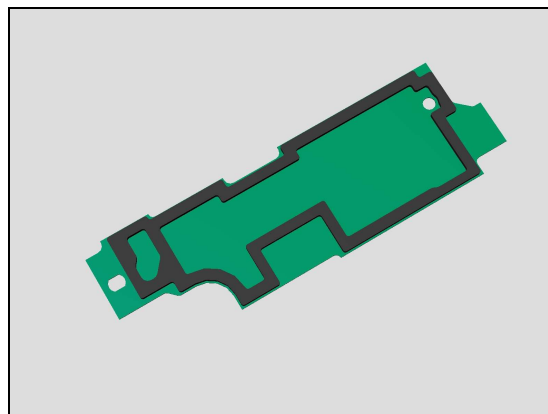
Clean any remaining adhesive residue!
Scrap! Not to be reused!

INSTALLATION

Place new Antenna BT + WLAN using a Flex Film Assembly Tool into its proper position.

Two guiding holes shown in picture!

Press with fingers to secure Antenna BT + WLAN



Replacement

4.22 Antenna NFC

Follow the 3.1 - 3.2 Disassembly instructions!
Follow the 4.11 Removal instructions!
Carry out the Removal as described below!
Prepare a new Antenna NFC
Carry out the Installation as described below!
Follow the 4.11 Installation instructions!
Follow the 5.7 - 5.8 Reassembly instructions!

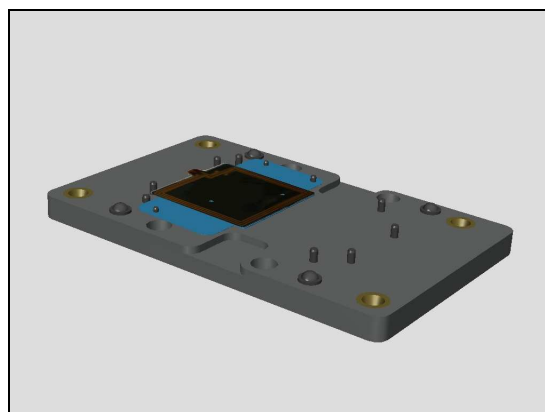
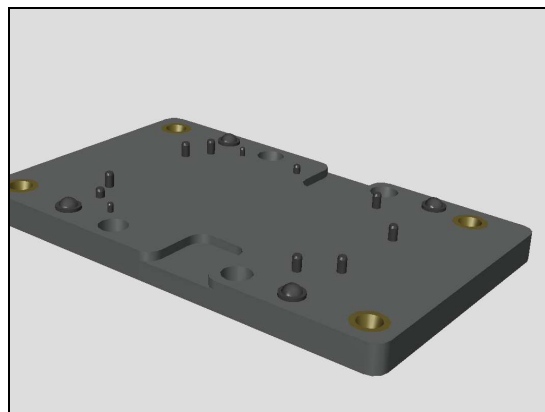
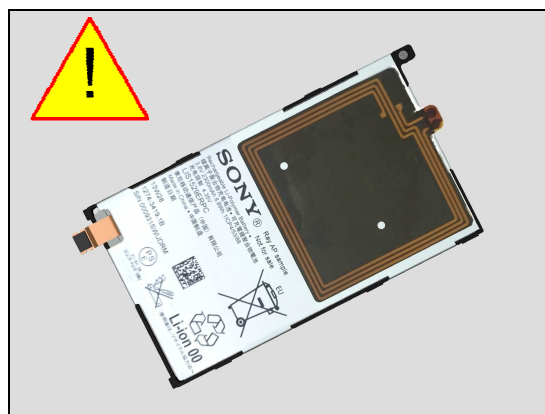
REMOVAL

Scrap Antenna NFC & Battery! Not to be reused due to high risk of damage to battery cells!

INSTALLATION

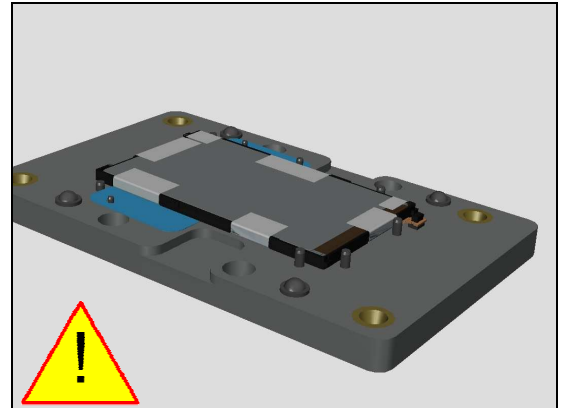
Prepare the Bottom Part of the NFC Antenna Alignment Fixture.

Place a new Antenna NFC with fingers in the NFC Antenna Alignment Fixture (Bottom Part)

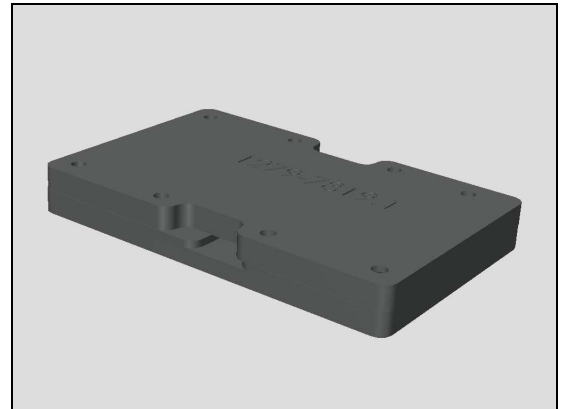


Replacement

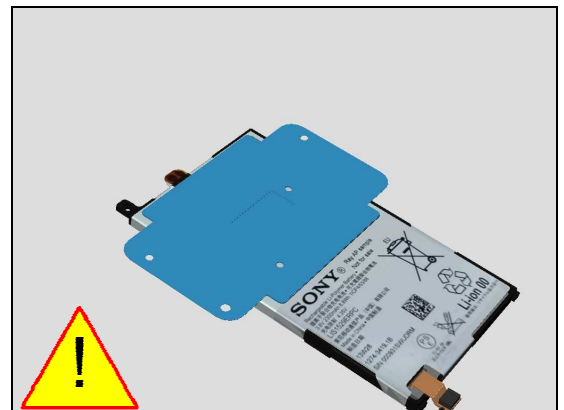
Position then place, new Battery above the Antenna NFC.
Inspect Battery for any dirt or dust before installation!



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



Remove Adhesive transfer sheet on Antenna NFC, only when ready to use Battery!



Replacement

4.23 Camera Chat 2MPixel

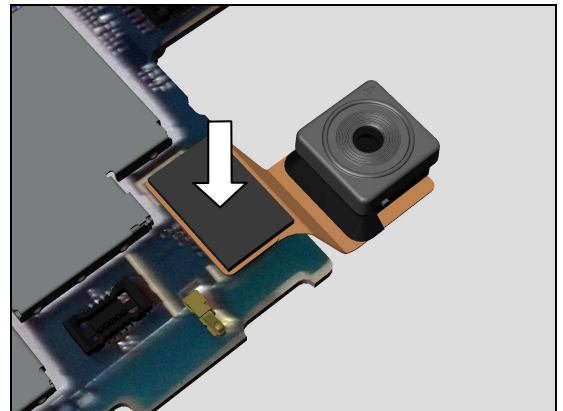
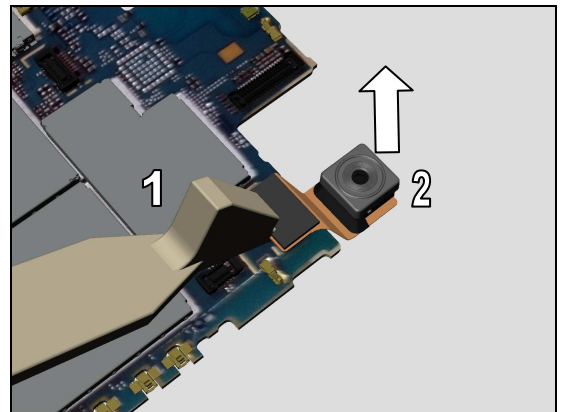
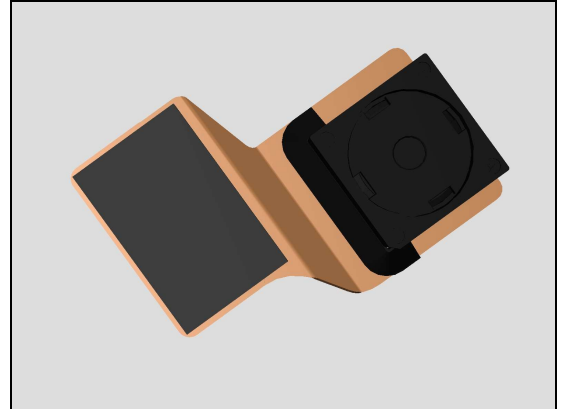
Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.24 Removal instructions!
Carry out the Removal as described below!
Prepare a new Camera Chat 2MPixel!
Carry out the Installation as described below!
Follow the 4.24 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

REMOVAL

1. Disconnect Camera Chat 2MPixel BtB using Front Open Tool from Main PBA Assy.
2. Remove Camera Chat 2MPixel.

INSTALLATION

Place the Camera Chat 2MPixel on top of the Main PBA Assy, Camera Chat 2MPixel BtB connector and press gently until it is securely attached.



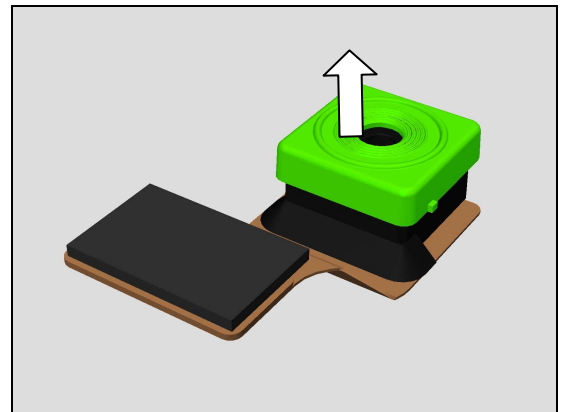
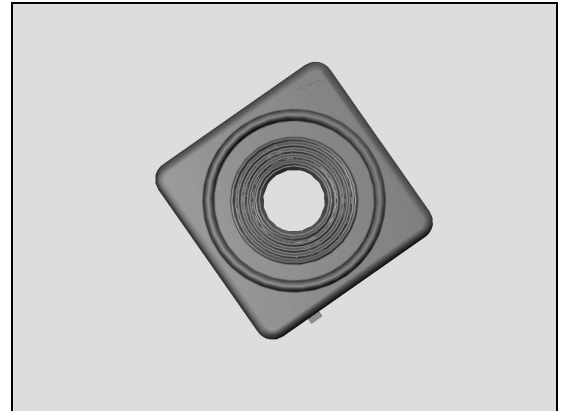
Replacement

4.24 Camera Chat Holder

Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.23 Removal instructions!
Carry out the Removal as described below!
Prepare a new Camera Chat Holder!
Carry out the Installation as described below!
Follow the 4.23 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

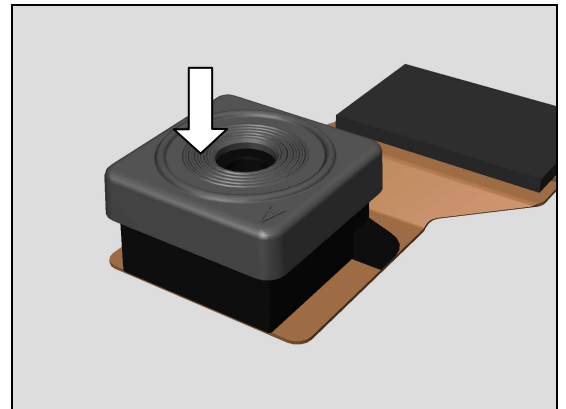
REMOVAL

Remove the Camera Chat Holder with fingers.



INSTALLATION

Attach a new Camera Chat Holder with fingers.



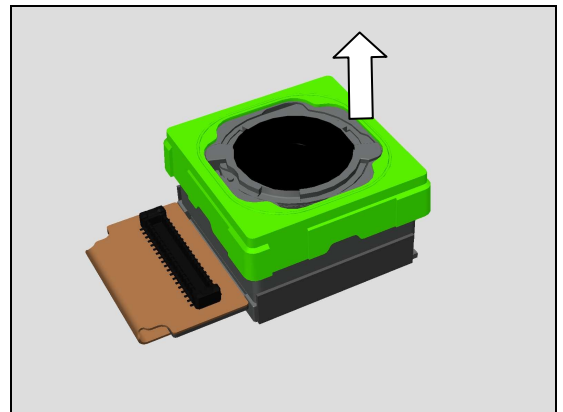
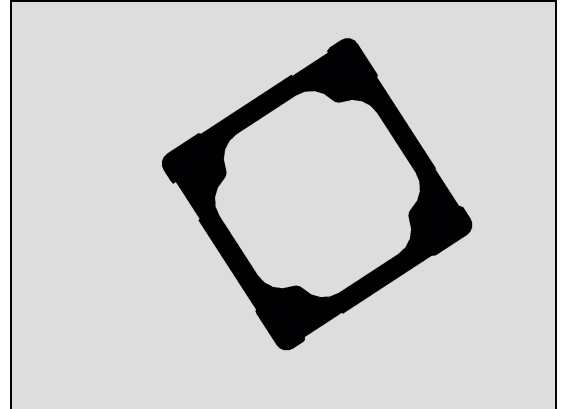
Replacement

4.25 Camera Main Holder

Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.26 Removal instructions!
Carry out the Removal as described below!
Prepare a new Camera Main Holder!
Carry out the Installation as described below!
Follow the 4.26 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

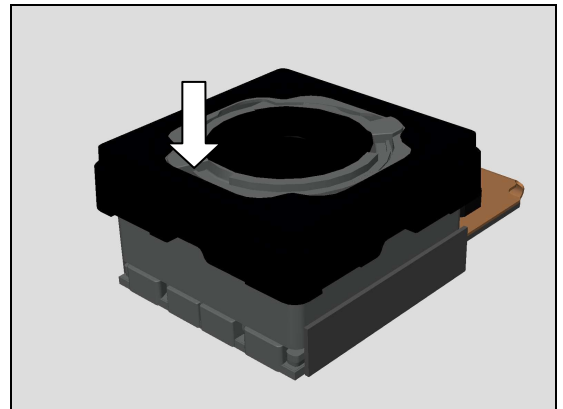
REMOVAL

Remove the Camera Main Holder with fingers.



INSTALLATION

Attach a new Camera Main Holder with fingers.



Replacement

4.26 Camera Main MPixel

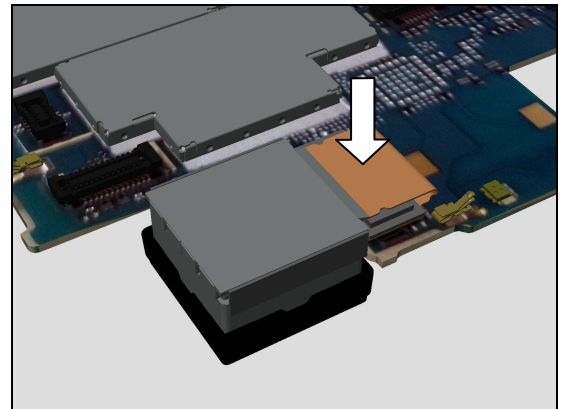
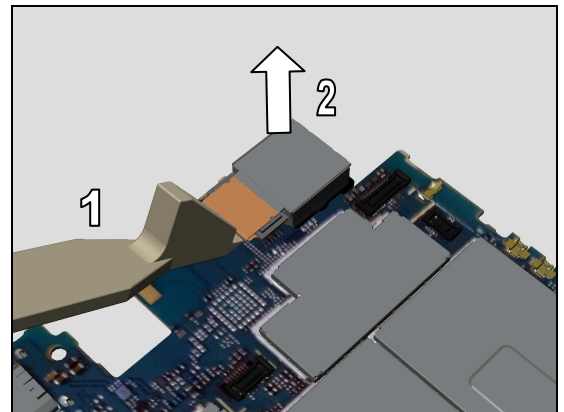
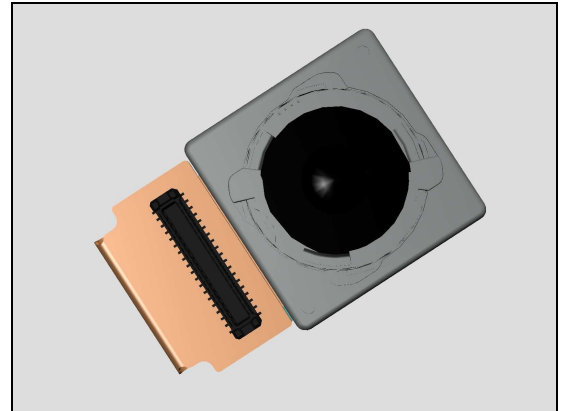
Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.25 Removal instructions!
Carry out the Removal as described below!
Prepare a new Camera Main MPixel!
Carry out the Installation as described below!
Follow the 4.25 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

REMOVAL

1. Disconnect Camera Main MPixel BtB using Front Open Tool from Main PBA Assy.
2. Remove Camera Main MPixel.

INSTALLATION

Place the Camera Main MPixel on top of the Main PBA Assy, Camera Main MPixel BtB connector and press gently until it is securely attached.



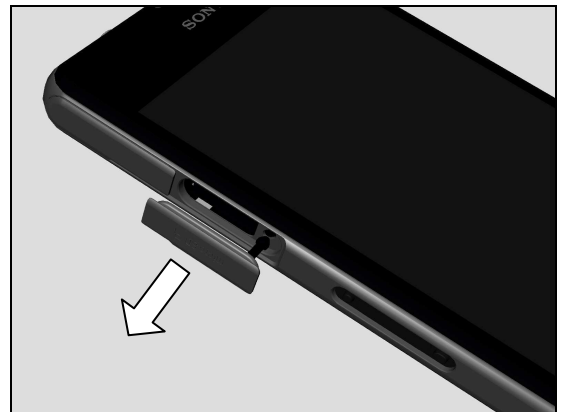
Replacement

4.27 Cap SD

*Carry out the Removal as described below!
Prepare a new Cap SD!
Carry out the Installation as described below!*

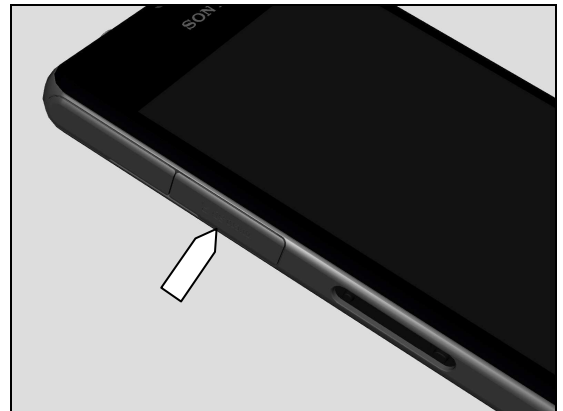
REMOVAL

Detach and then remove Cap SD using fingers.



INSTALLATION

Place a new Cap SD with fingers and a pair of tweezers if necessary.



Replacement

4.28 Cap SIM

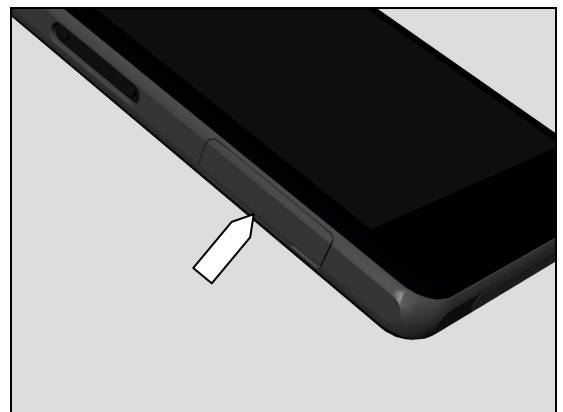
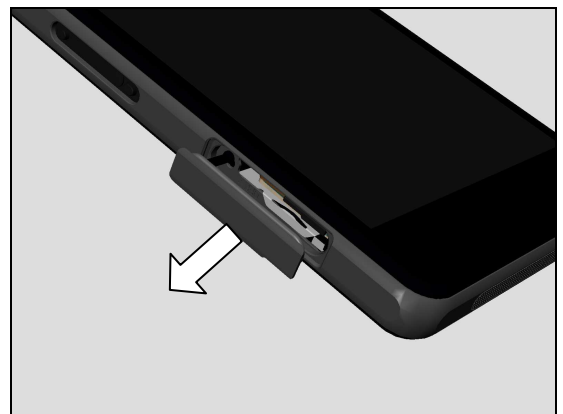
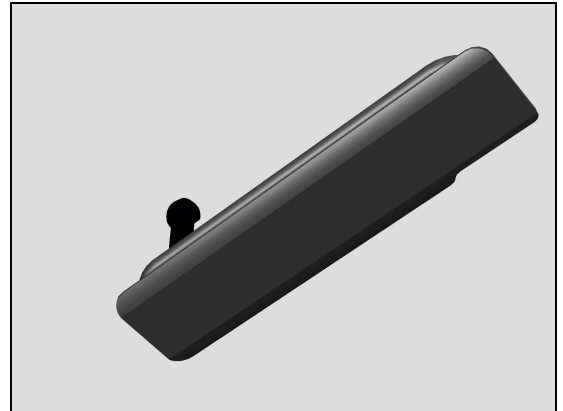
*Carry out the Removal as described below!
Prepare a new Cap SIM!
Carry out the Installation as described below!*

REMOVAL

Detach and then remove Cap SIM using fingers.

INSTALLATION

Place a new Cap SIM with fingers and a pair of tweezers if necessary.



Replacement

4.29 Cap USB

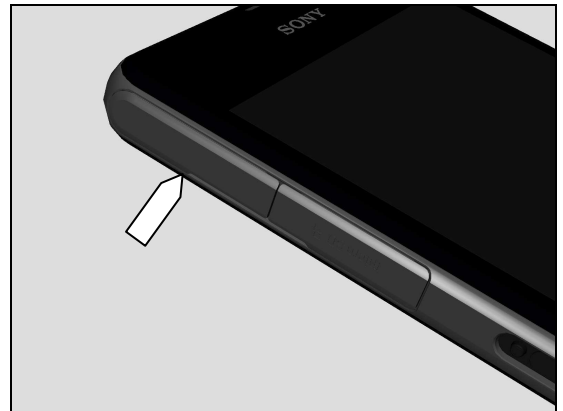
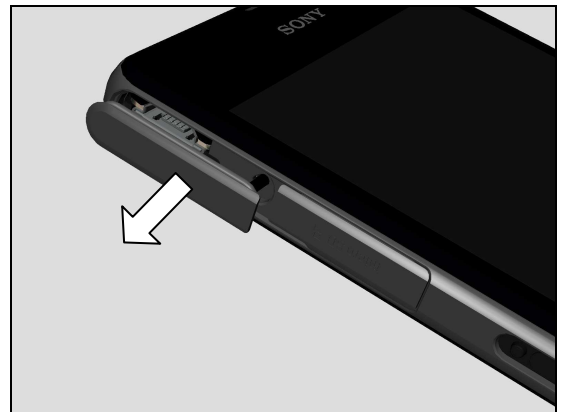
*Carry out the Removal as described below!
Prepare a new Cap USB!
Carry out the Installation as described below!*

REMOVAL

Detach and then remove Cap SIM using fingers.

INSTALLATION

Place a new Cap SIM with fingers and a pair of tweezers if necessary.



Replacement

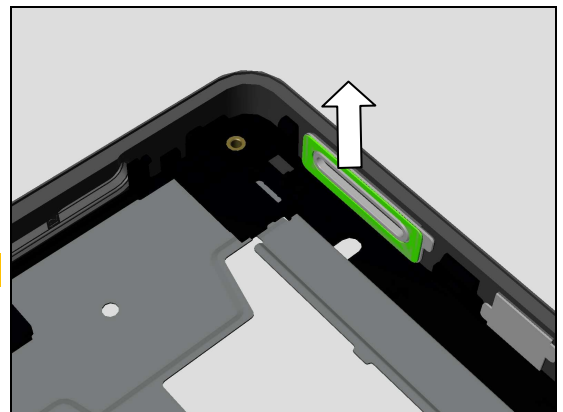
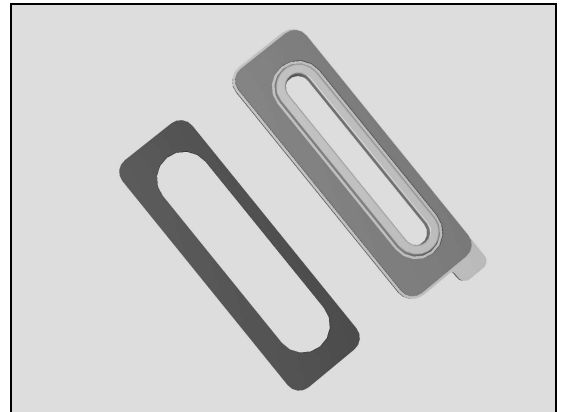
4.30 Cushion 0.0mmSi Speaker + Cushion WP Speaker

*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Cushion 0.0mmSi Speaker & Cushion WP Speaker!
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

REMOVAL

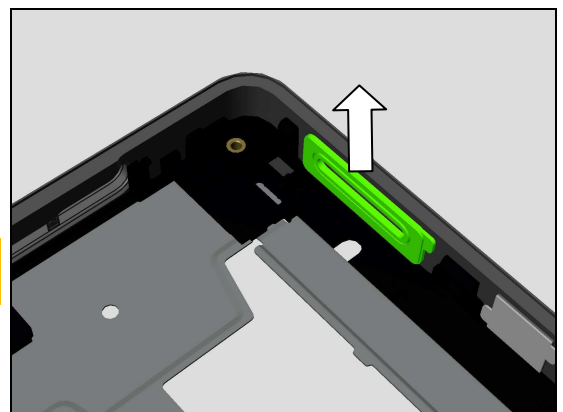
Detach to remove the Cushion 0.0mm SI Speaker with the Dentist Hook.

Scrap! Not to be reused!



Detach to remove the Cushion WP Speaker with the Dentist Hook.

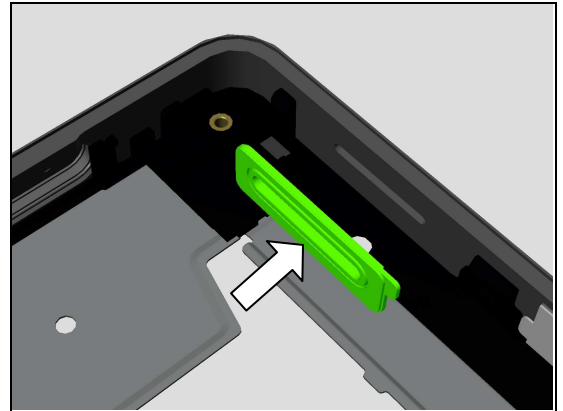
Clean any remaining adhesive residue!
Scrap! Not to be reused!



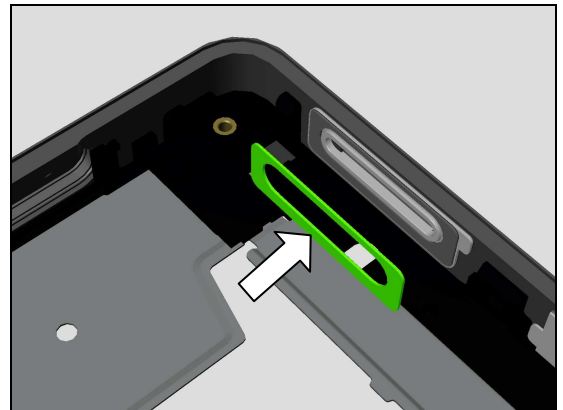
Replacement

INSTALLATION

Place new Adhesive Cushion WP Speaker using a Flex Film Assembly Tool into its proper position.



Place new Adhesive Cushion 0.0mm SI Speaker using a Flex Film Assembly Tool into its proper position.



Replacement

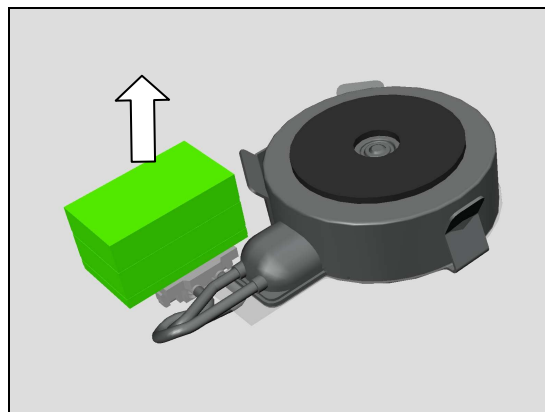
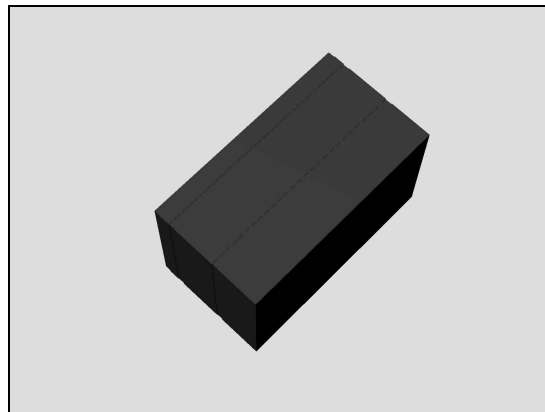
4.31 Cushion Con Vibrator

Follow the 3.1 - 3.2 Disassembly instructions!
Follow the 4.48 Removal instructions!
Carry out the Removal as described below!
Prepare a new Cushion Con Vibrator.
Carry out the Installation as described below!
Follow the 4.48 Installation instructions!
Follow the 5.7 - 5.8 Reassembly instructions!

REMOVAL

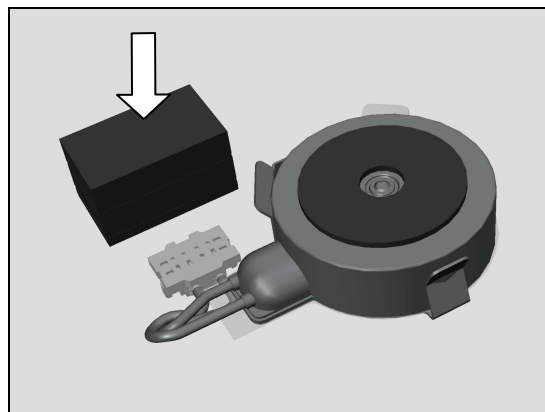
Detach to remove the Cushion Con Vibrator with the Dentist Hook.

Scrap! Not to be reused!



INSTALLATION

Place new Adhesive Cushion Con Vibrator using a Flex Film Assembly Tool into its proper position.



Replacement

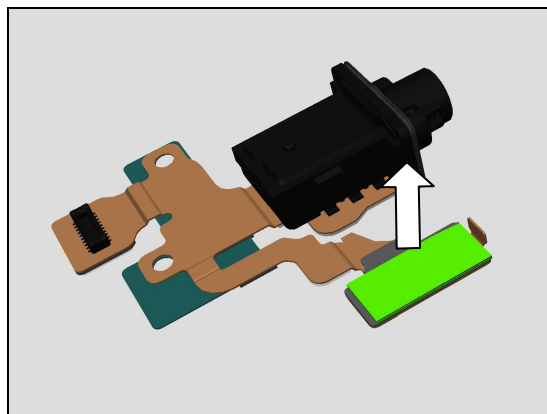
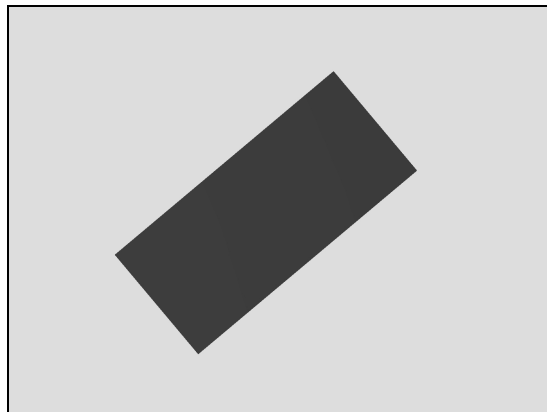
4.32 Cushion FPC Audio Jack

Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.34 Removal instructions!
Carry out the Removal as described below!
Prepare a new Cushion FPC Audio Jack!
Carry out the Installation as described below!
Follow the 4.34 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

REMOVAL

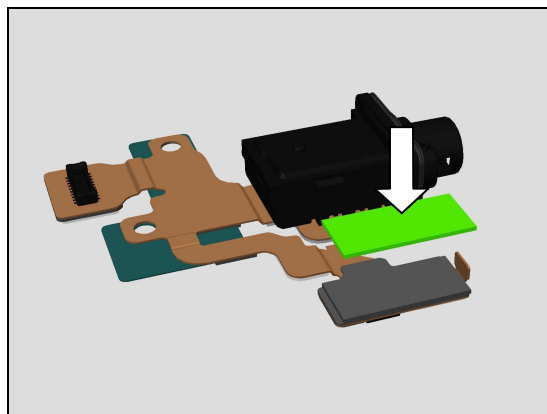
Detach to remove the Cushion Con Vibrator with the Dentist Hook.

Scrap! Not to be reused!



INSTALLATION

Place new Adhesive Cushion Con Vibrator using a Flex Film Assembly Tool into its proper position.



Replacement

4.33 FPC Audio Jack + Adhesive FPC Audio Jack A + Adhesive FPC Audio Jack B

Follow the 3.1 - 3.8 Disassembly instructions!

Follow the 4.33 Removal instructions!

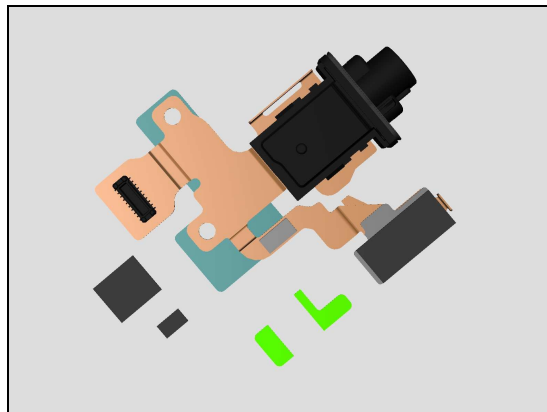
Carry out the Removal as described below!

Prepare a new FPC Audio Jack & Adhesive FPC Audio Jack A & Adhesive FPC Audio Jack B!

Carry out the Installation as described below!

Follow the 4.33 Installation instructions!

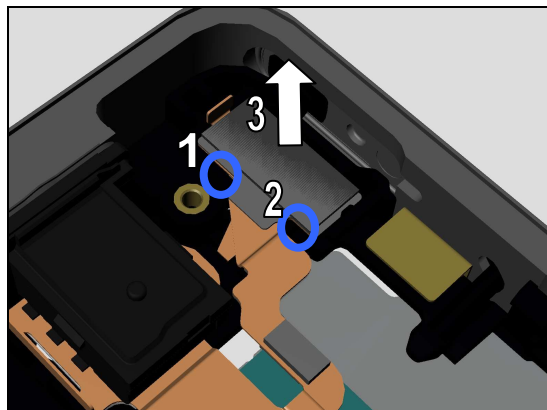
Follow the 5.1 - 5.8 Reassembly instructions!



REMOVAL

Detach the Proximity Sensor Area of the FPC Assy Audio Jack.

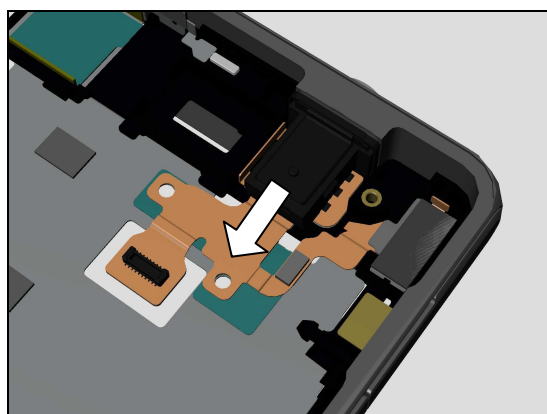
1. Gently insert Dentist Hook and then gently lift up the Proximity Sensor Area of the FPC Assy Audio Jack to loosen.
2. Gently insert Dentist Hook and then gently lift up the Proximity Sensor Area of the FPC Assy Audio Jack to loosen.
3. Raise Proximity Sensor slightly out of its cavity.



Detach to remove the FPC Assy Audio Jack by using the Front Opening Tool.

Scrap! Not to be reused!

Clean any remaining adhesive residue!

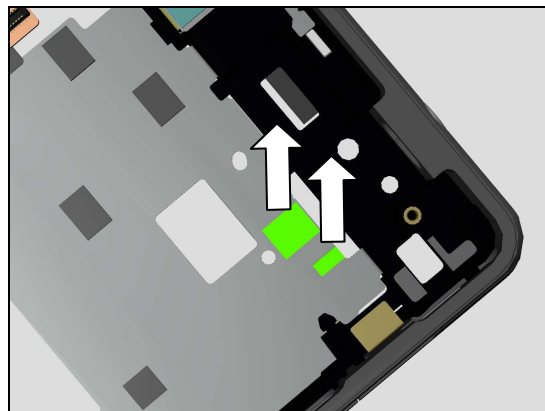


Replacement

Detach to remove the Adhesive FPC Audio Jack A with the Dentist Hook.

Scrap! Not to be reused! Clean any remaining adhesive residue!

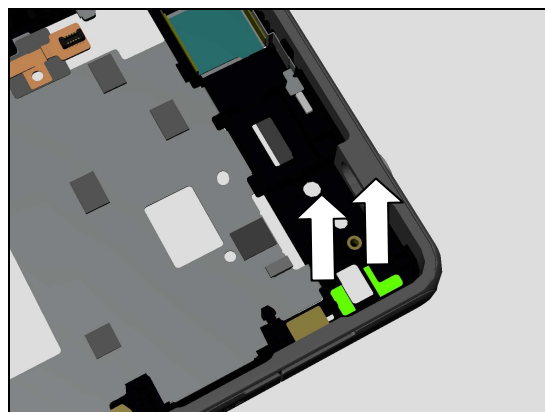
Note: Adhesive Audio Jack A is two parts!



Detach to remove the Adhesive FPC Audio Jack B with the Dentist Hook.

Scrap! Not to be reused! Clean any remaining adhesive residue!

Note: Adhesive Audio Jack B is two parts!

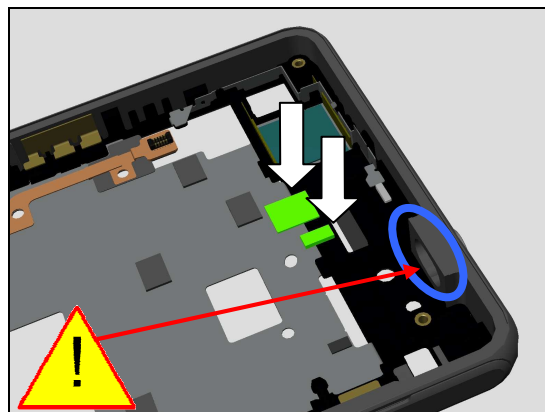


INSTALLATION

Place new Adhesive FPC Audio Jack A parts using a Flex Film Assembly Tool.

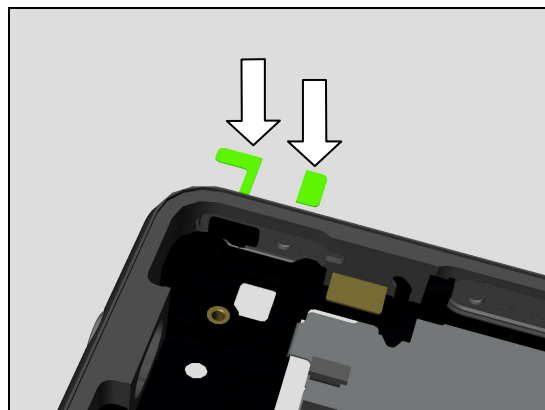
Perform cleaning using Isopropyl Alcohol on Frame Main Assy Audio Jack Cavity!

Note: Adhesive Audio Jack A is two parts!



Place new Adhesive FPC Audio Jack B parts using a Flex Film Assembly Tool.

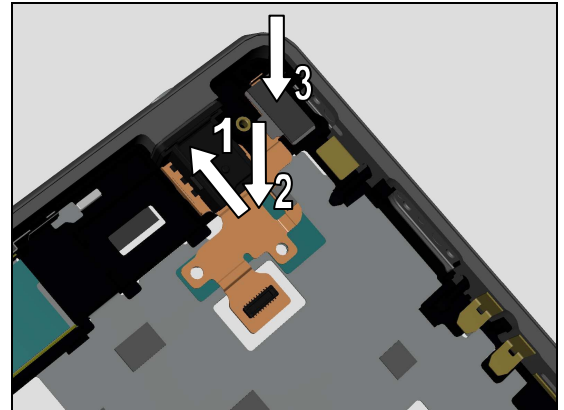
Note: Adhesive Audio Jack B is two parts!



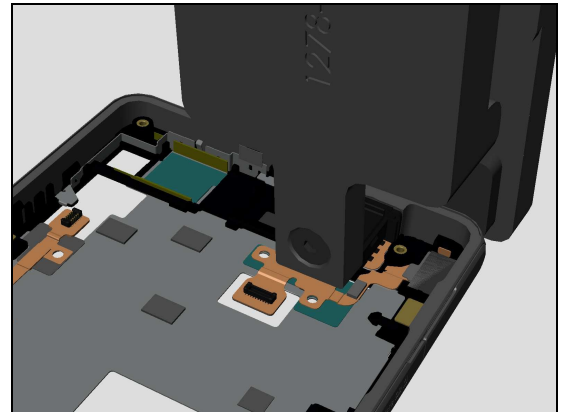
Replacement

Position new FPC Audio Jack as shown in picture

1. Push to mount a new FPC Assy Audio Jack into its hole
2. Then press the FPC to secure it attachment to Frame Main Assy as shown in picture.
3. Then press the FPC to secure it attachment of Proximity Sensory into its cavity as shown in picture.



Press FPC Audio Jack by using the Audio Jack Press tool for 10sec securing its attachment.



Replacement

4.34 FPC Camera Key

*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new FPC Camera Key!
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

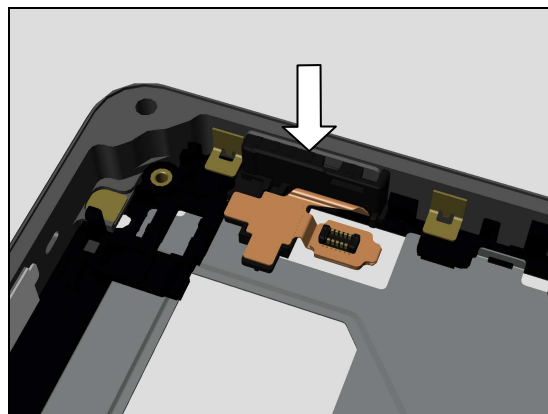
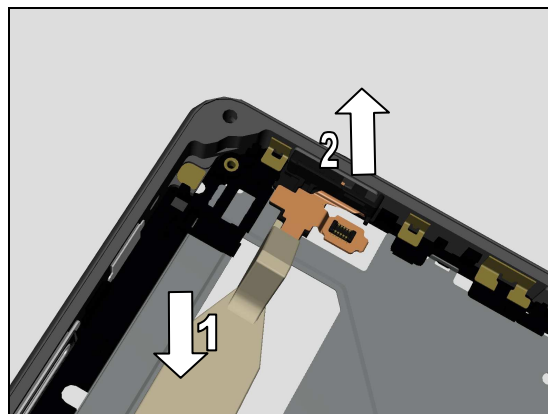
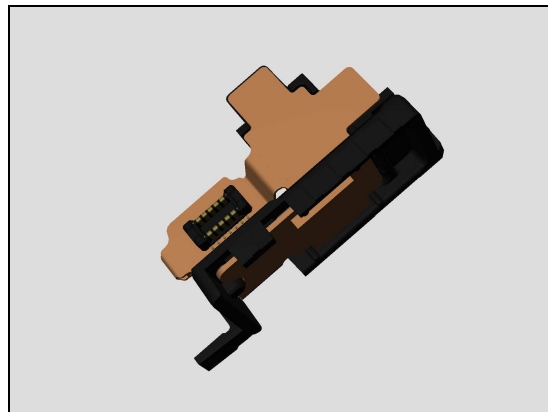
REMOVAL

Gently insert Front Open Tool as shown in picture

1. Gently lift up the FPC Camera Key with the Front Opening Tool loosening from cavity.
2. Detach and remove the FPC Camera Key using fingers.

INSTALLATION

Place new FPC Camera Key using fingers into its proper position.



Replacement

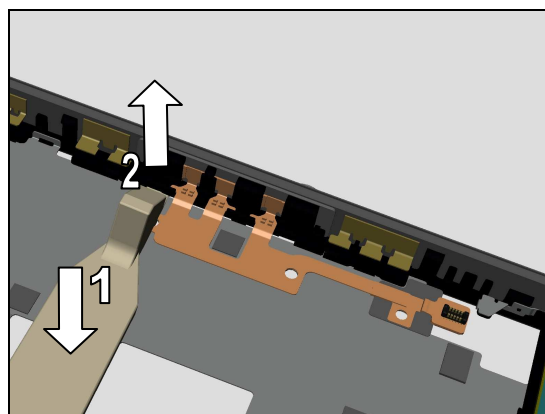
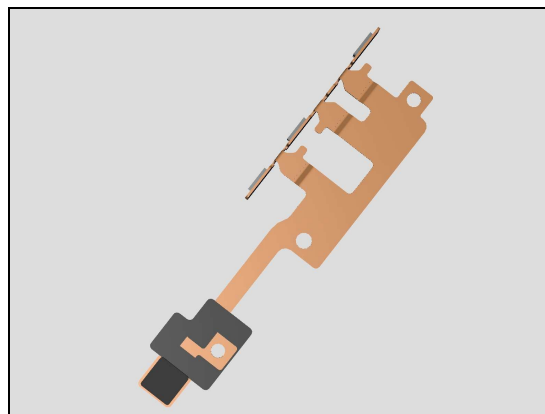
4.35 FPC Side Key

Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.12 Removal instructions!
Carry out the Removal as described below!
Prepare a new FPC Side Key!
Carry out the Installation as described below!
Follow the 4.12 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

REMOVAL

Gently insert Front Open Tool as shown in picture

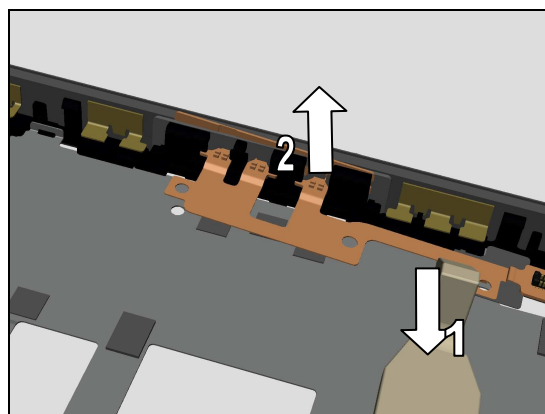
1. Gently lift up the FPC Side Key with the Front Opening Tool loosening from cavity.
2. Detach the FPC Side Key slightly rising from cavity.



Gently insert Front Open Tool as shown in picture

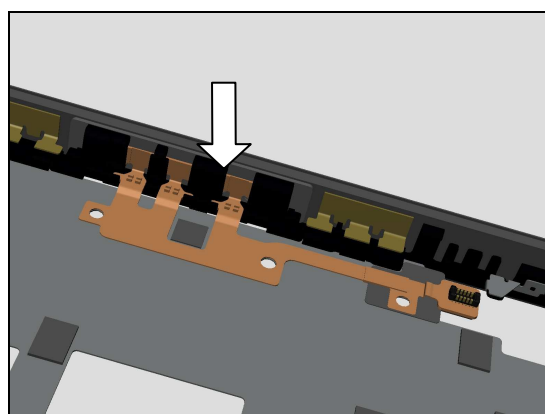
1. Gently lift up the FPC Side Key with the Front Opening Tool loosening from Adhesive Conductive A.
2. Detach and remove the FPC Side Key using fingers.

Scrap! Not to be reused! Clean any remaining adhesive residue!



INSTALLATION

Place new FPC Side Key using fingers into its proper position.



Replacement

4.36 Gasket PBA A

*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Gasket PBA A.
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

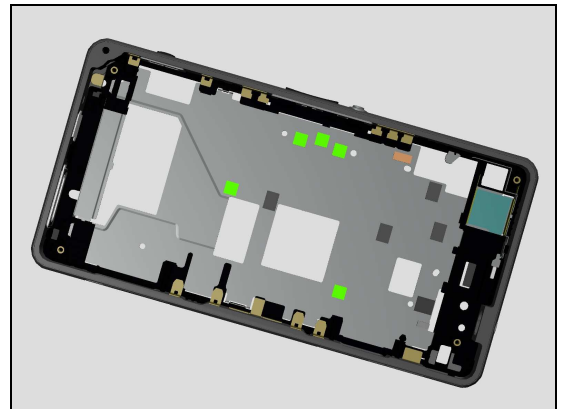
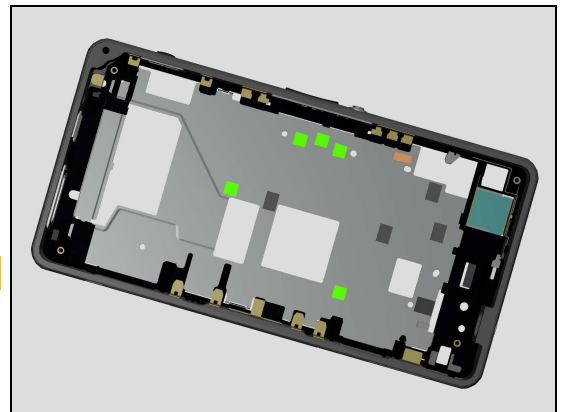
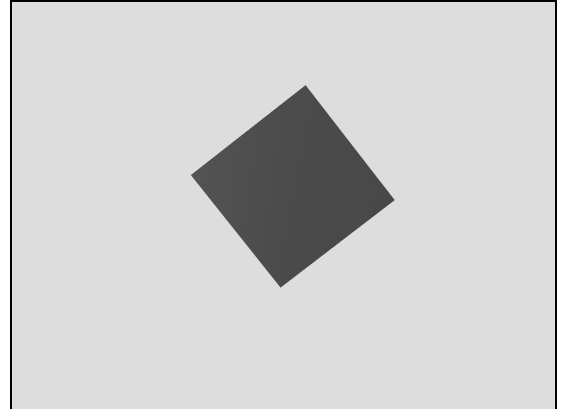
REMOVAL

Detach to remove the Gasket PBA A with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place new Gasket PBA A using Flex Film Assembly Tool into its proper position.



Replacement

4.37 Gasket PBA B

*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Gasket PBA B.
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

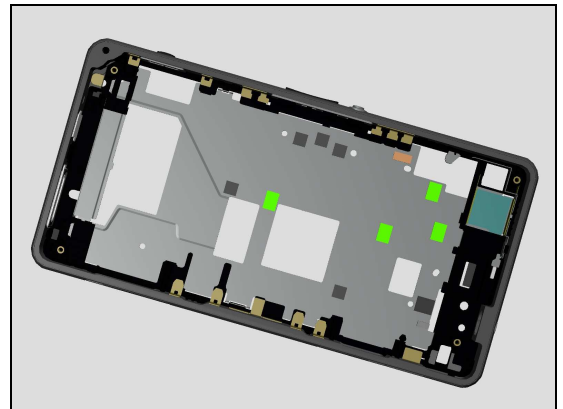
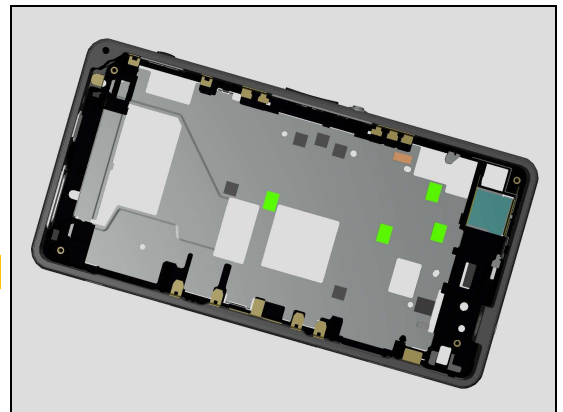
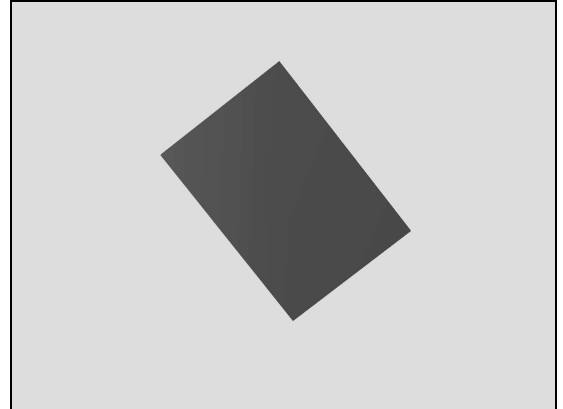
REMOVAL

Detach to remove the Gasket PBA A with the Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place new Gasket PBA A using Flex Film Assembly Tool into its proper position.



Replacement

4.38 Label Core Unit

Carry out the Removal as described below!
Prepare a new Label Core Unit.
Carry out the Installation as described below!

REMOVAL

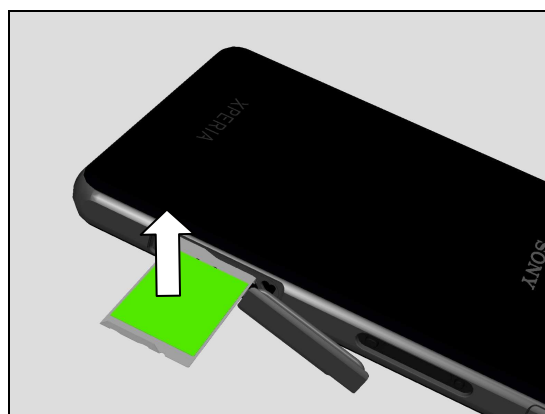
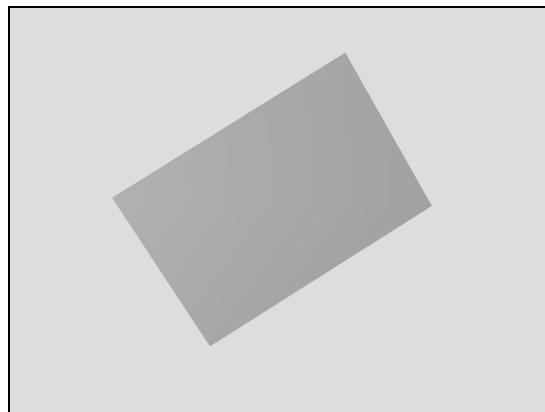
Open Cap SIM

Pull out the Plate Label with fingers.

Read the old Core Unit Label and/or write the information into the 'Label Print Solution' program before removal.
Carefully remove the Label Core Unit by using the Flex Film Assembly Tool and fingers from Plate Label.

Scrap! Not to be reused!

Be careful not to damage Plate Label!

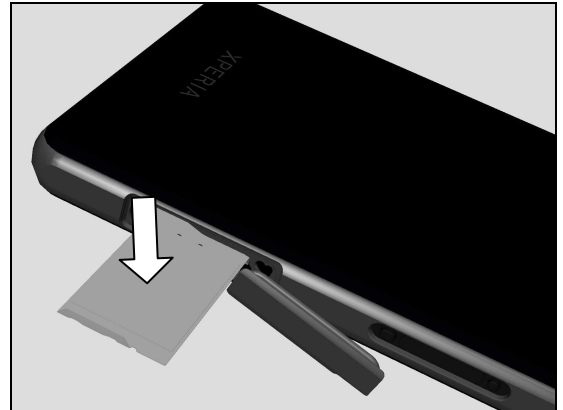


Replacement

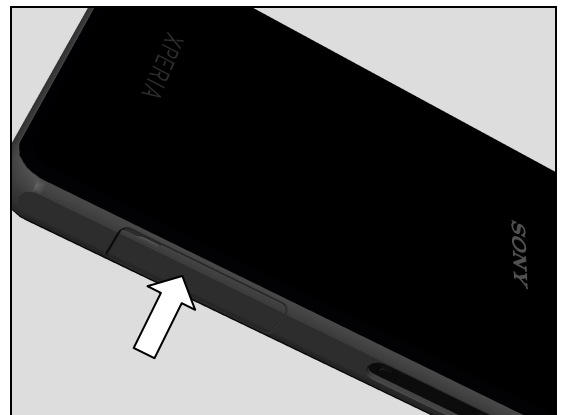
INSTALLATION

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

Attach a new Label Core Unit onto Plate Label in proper position.



Insert Plate Label and close Cap SIM.



Replacement

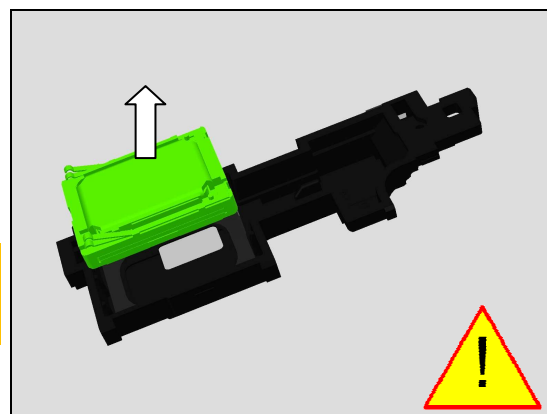
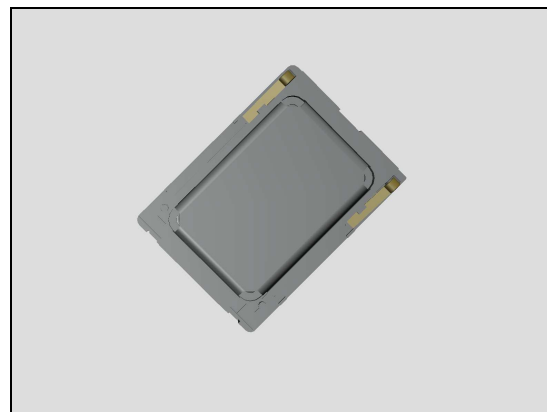
4.39 Loudspeaker

Follow the 3.1 - 3.4 Disassembly instructions!
Follow the 4.14 Removal instructions!
Carry out the Removal as described below!
Prepare a new Loudspeaker!
Carry out the Installation as described below!
Follow the 4.14 Installation instructions!
Follow the 5.5 - 5.8 Reassembly instructions!

REMOVAL

Detach to remove the Loudspeaker with the Front Opening Tool.

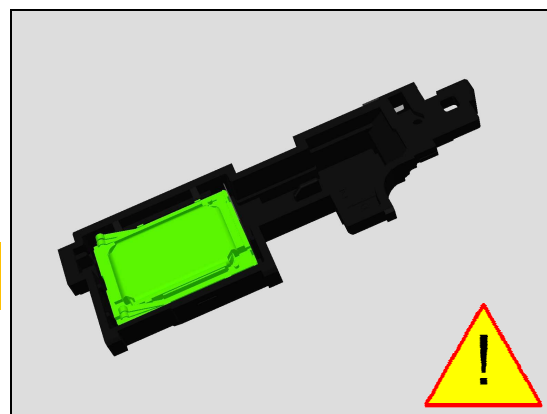
Scrap! Not to be reused!
Use Isopropyl Alcohol for cleaning Carrier Holder Speaker Assy



INSTALLATION

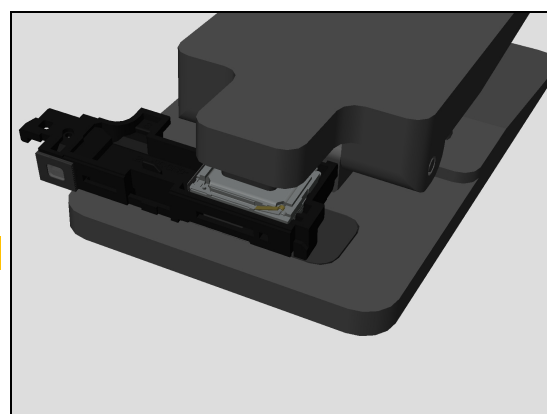
Place a new Loudspeaker by using fingers.

Inspect and clean Carrier Holder Speaker Assy cavity before assembly!



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

Do not touch the contact pins!



Replacement

4.40 Magnetic Connector

*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Magnetic Connector!
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

REMOVAL

Push the two pads of Magnetic Connector by using Flex Film Assembly Tool.

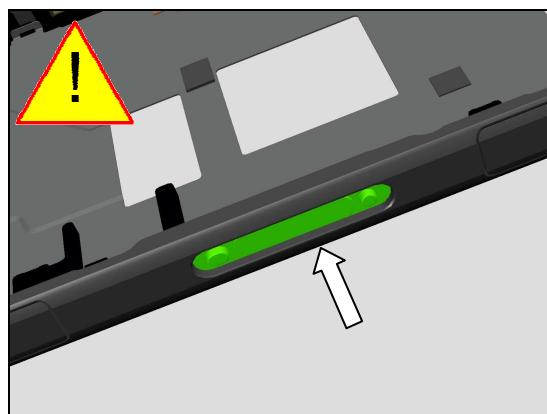
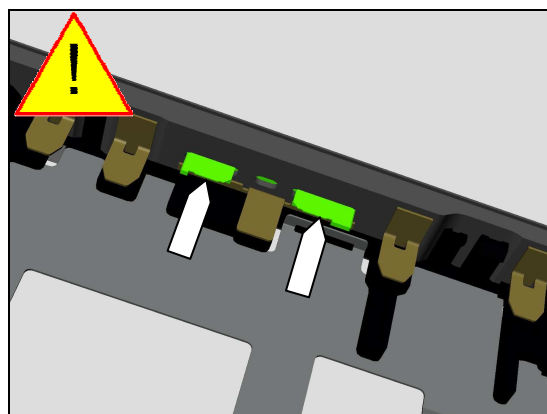
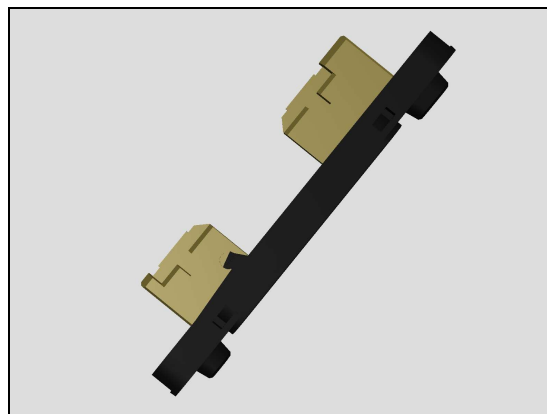
Scrap! Not to be reused!
Use Isopropyl Alcohol for cleaning Frame Main Assy!

INSTALLATION

Mount a new Magnetic Connector by fingers, check and press the two pins into its cavities by using the Front Opening Tool.

**Inspect and clean using Isopropyl Frame Main Assy
Magnetic Connector cavity before assembly!**

Fully assemble the phone then use Side Panel press, Side Panel Press Head and Charge connector press pad with the force of 60N for five seconds. According to 1003-9107 Tool Catalogue – mechanical and document Side Panel press Instruction for use.



Replacement

4.41 MComp Sheet (G) Camera

Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.26 Removal instructions!
Carry out the Removal as described below!
Prepare a new MComp Sheet (G) Camera!
Carry out the Installation as described below!
Follow the 4.26 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

REMOVAL

Detach to remove the 1st MComp Sheet (G) Camera with the Dentist Hook.

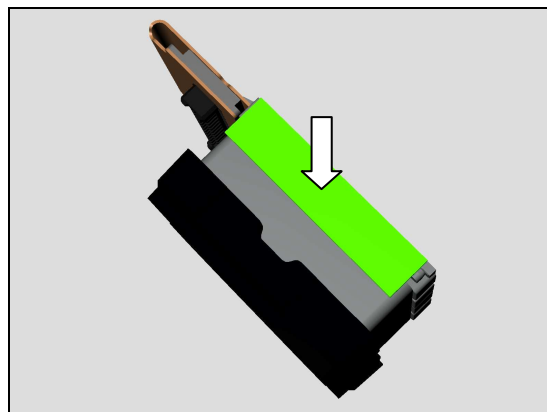
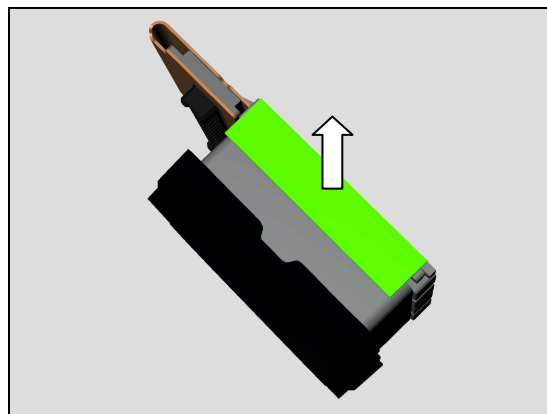
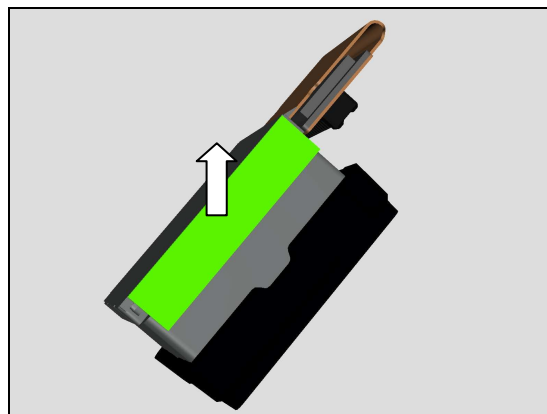
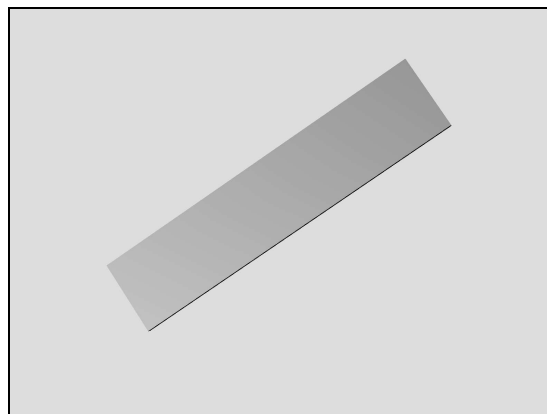
Scrap! Not to be reused!

Detach to remove the 2nd MComp Sheet (G) Camera on opposite side with the Dentist Hook.

Scrap! Not to be reused!

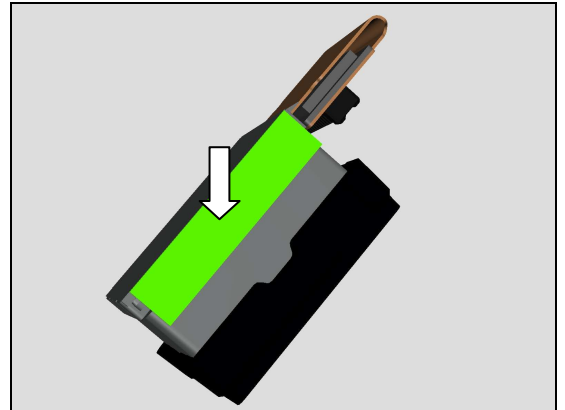
INSTALLATION

Place 1st new MComp Sheet (G) Camera Flex Film Assembly Tool into its proper position.



Replacement

Place 2nd new MComp Sheet (G) Camera Flex Film Assembly Tool into its proper position on opposite side.



Replacement

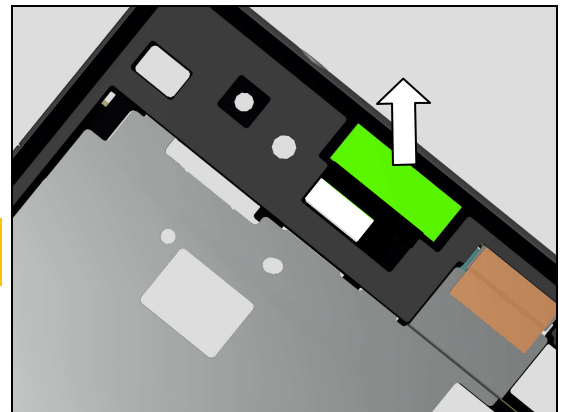
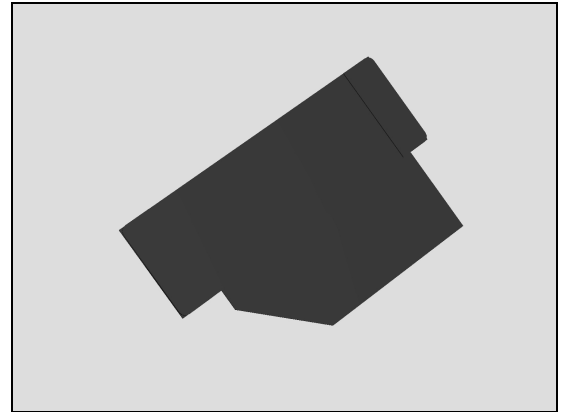
4.42 Net Front

*Follow the 3.1 - 3.8 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Net Front.
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

REMOVAL

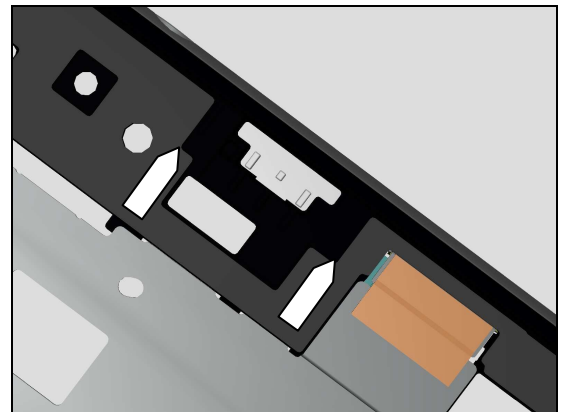
Detach to remove the Net Front with the Dentist Hook.

Clean any remaining adhesive residue!
Scrap! Not to be reused!

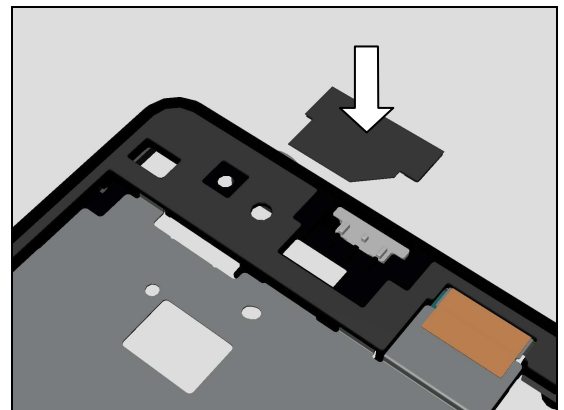


INSTALLATION

Use these ribs as alignment located on Frame Main Assy for aligning Net Front during installation.



Place new Net Front using a Flex Film Assembly Tool into its proper position.



Replacement

4.43 Rear Net Earspeaker

*Follow the 3.1 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Rear Net Earspeaker!
Carry out the Installation as described below!
Follow the 5.1 - 5.8 Reassembly instructions!*

REMOVAL

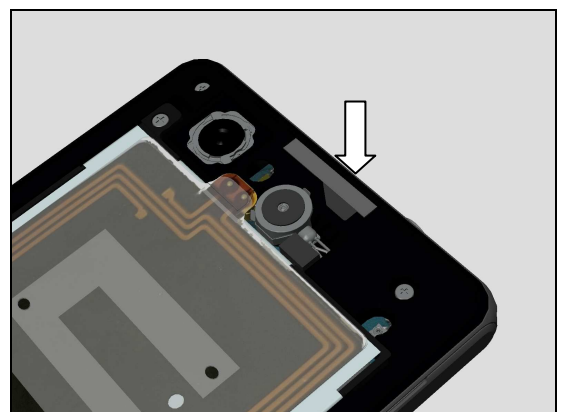
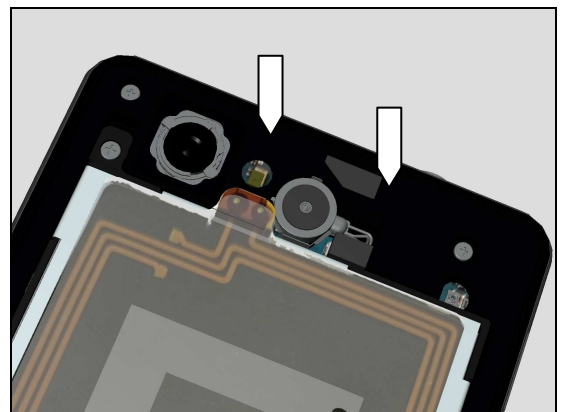
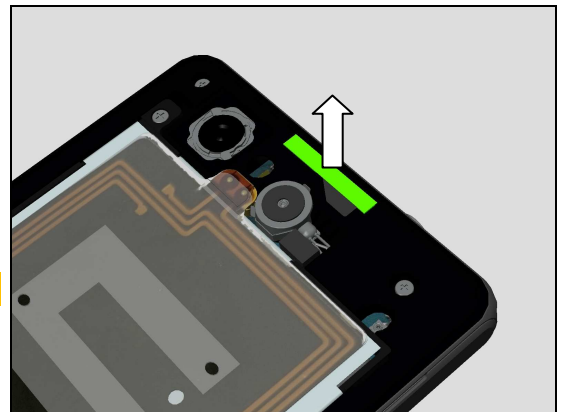
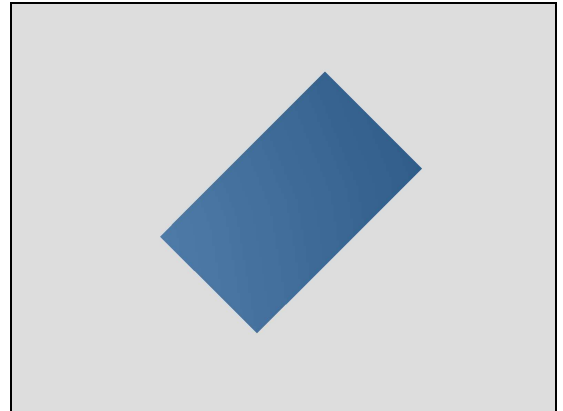
Detach to remove the Rear Net Earspeaker with the Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Use alignment markings located on Cover Rear area shown in picture for aligning Rear New Earspeaker in correct position.

Place new Rear Net Earspeaker using Flex Film Assembly Tool into its proper position.



Replacement

4.44 Panel Speaker

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

REMOVAL

Detach to remove the Panel Speaker by using the Dentist Hook.

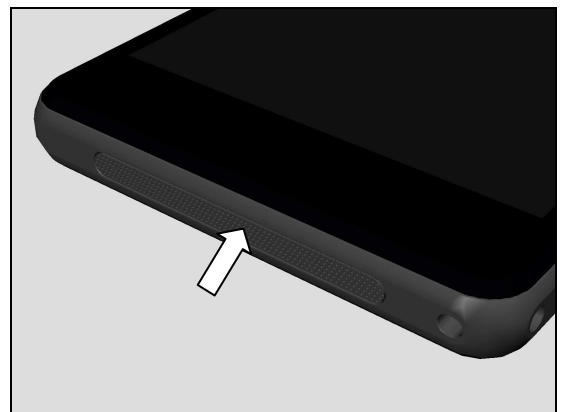
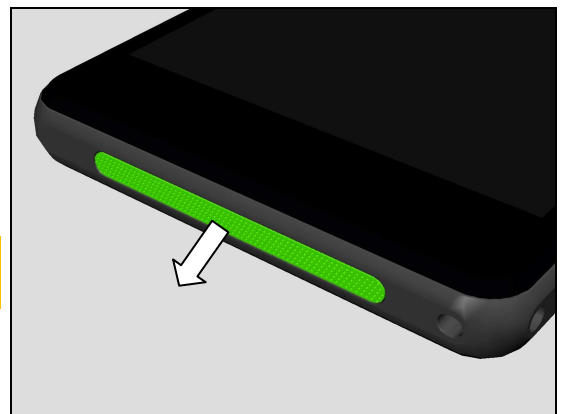
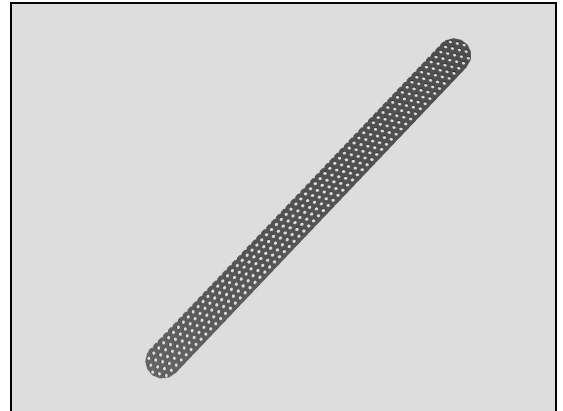
Scrap not to be reused!

Clean any remaining adhesive residue!

INSTALLATION

Attach a new Panel Speaker in its cavity as shown in picture using Flex Film Assembly Tool.

Press with fingers to secure its attachment.



Replacement

4.45 Plate Label Base

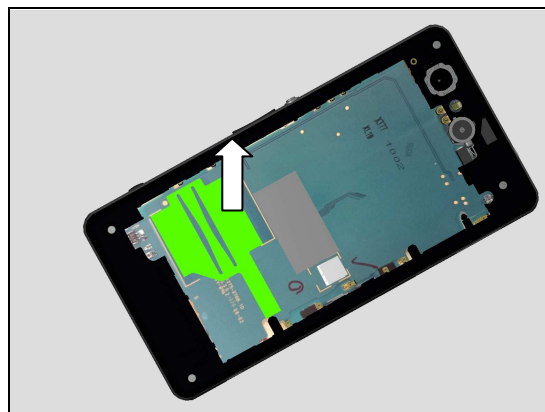
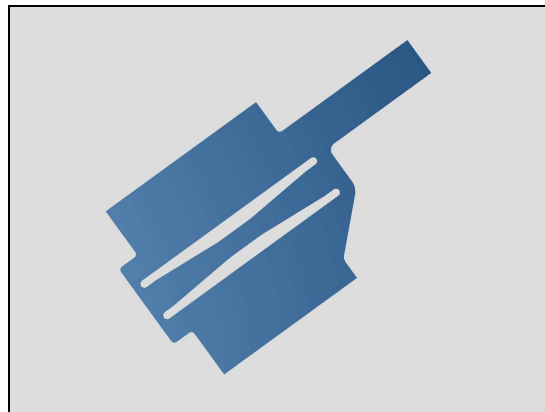
*Follow the 3.1 - 3.5 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Plate Label Base!
Carry out the Installation as described below!
Follow the 5.4 - 5.8 Reassembly instructions!*

REMOVAL

Detach to remove the Speaker Panel by using the Flex Film Assembly Tool.

Scrap not to be reused!

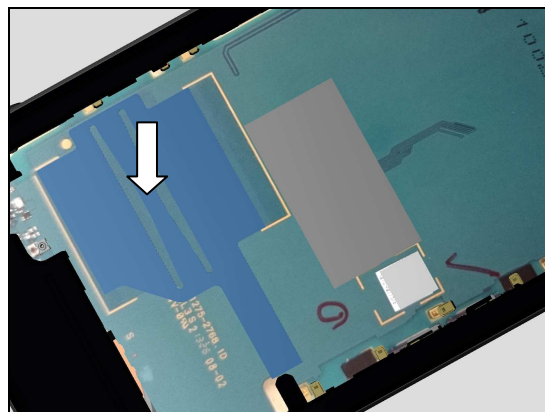
Clean any remaining adhesive residue!



INSTALLATION

Attach a new Plate Label Base onto Main PBA as shown in picture using Flex Film Assembly Tool.

Note: Use PBA markings for positional alignment of Plate Labe Base.



Replacement

4.46 Sheet Con Battery

*Follow the 3.1 - 3.2 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Sheet Con Battery
Carry out the Installation as described below!
Follow the 5.7 - 5.8 Reassembly instructions!*

REMOVAL

Detach to remove the Sheet Con Battery by using the Dentist Hook.

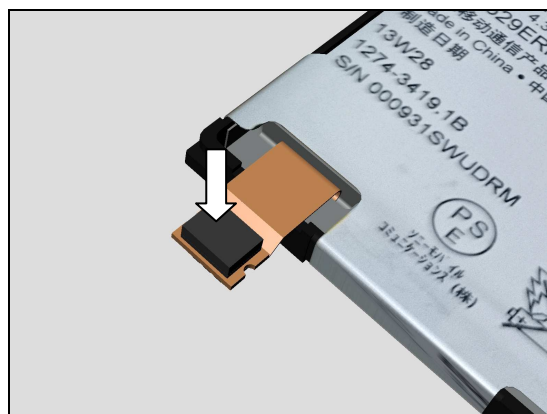
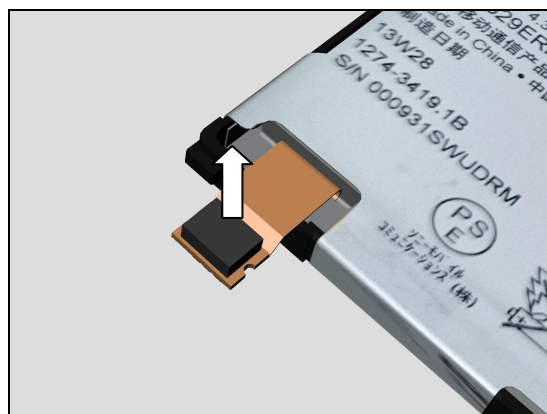
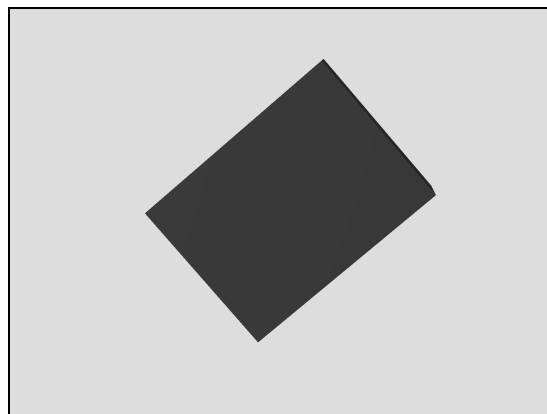
Scrap not to be reused!

Be careful not to damage Battery FPC or Connector!

INSTALLATION

Attach a new Sheet Con Battery onto Battery Connector as shown in picture using Flex Film Assembly Tool.

Be careful not to damage Battery FPC or Connector!



Replacement

4.47 Sheet Graphite

Follow the 3.1 - 3.7 Disassembly instructions!

Prepare new Sheet Graphite.

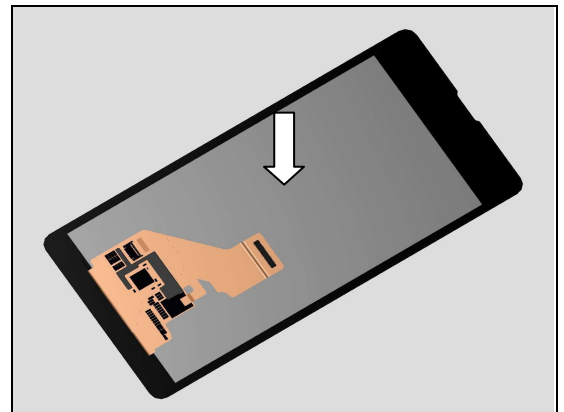
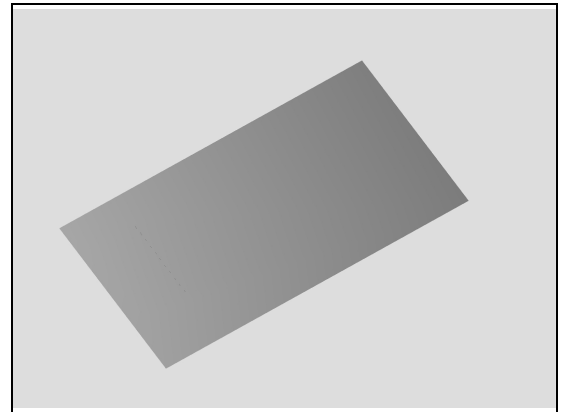
Carry out the Installation as described below!

Follow the 5.2 - 5.8 Reassembly instructions!

Do not remove Sheet Graphite as it will damage Display!

INSTALLATION ONLY

Place new Sheet Graphite using Flex Film Assembly Tool into its proper position.



Replacement

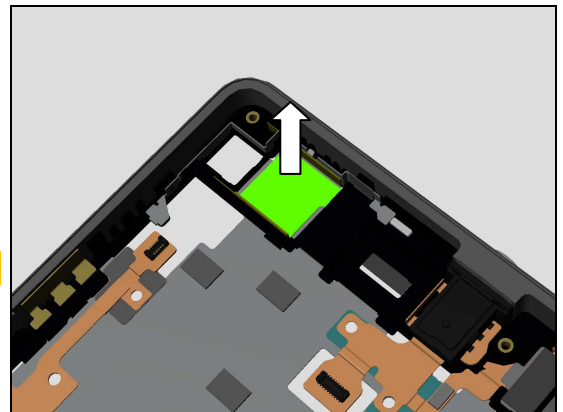
4.48 Sheet Thermal Conductive Camera

Follow the 3.1 - 3.8 Disassembly instructions!
Follow the 4.26 Removal instructions!
Carry out the Removal as described below!
Prepare a new Sheet Thermal Conductive Camera!
Carry out the Installation as described below!
Follow the 4.26 Installation instructions!
Follow the 5.1 - 5.8 Reassembly instructions!

REMOVAL

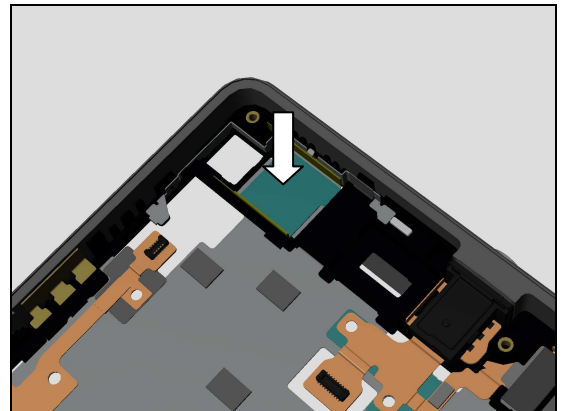
Detach to remove the Sheet Thermal Conductive Camera by using the Dentist Hook.

Scrap not to be reused!



INSTALLATION

Place new Sheet Thermal Conductive Camera using Flex Film Assembly Tool into its proper position.



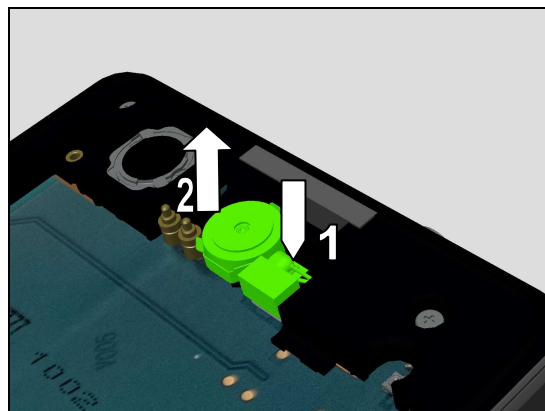
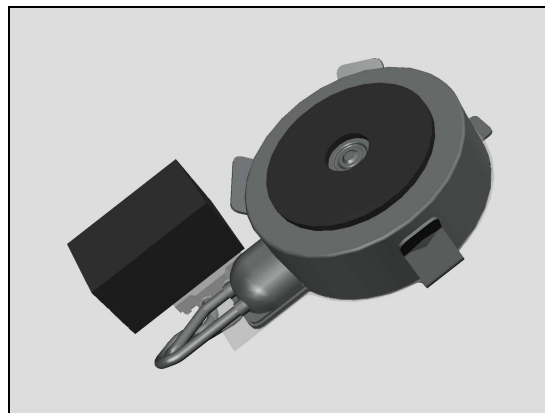
Replacement

4.49 Vibrator + Adhesive Vibrator + Holder Vibrator

Follow the 3.1 - 3.2 Disassembly instructions!
 Follow the 4.32 Removal instructions!
 Carry out the Removal as described below!
 Prepare a new Vibrator & Adhesive Vibrator & Holder Vibrator!
 Carry out the Installation as described below!
 Follow the 4.32 Installation instructions!
 Follow the 5.7 - 5.8 Reassembly instructions!

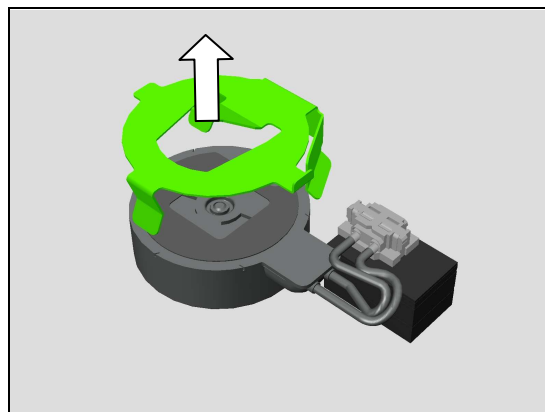
REMOVAL

1. Disconnect Vibrator connector by using the Front Opening Tool.
2. Remove Vibrator Assy using front opening tool.



Remove Holder Vibrator using fingers.

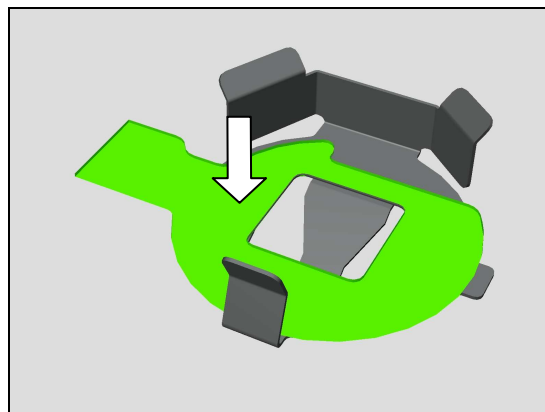
Clean any remaining adhesive residue from both parts!



INSTALLATION

Attach a new Adhesive Vibrator to upper side of Holder Vibrator as shown in picture.

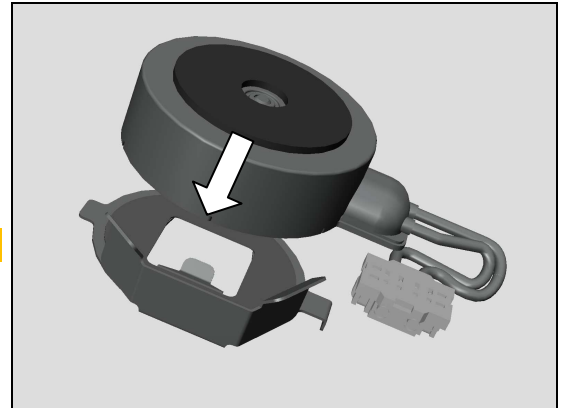
Align Adhesive Vibrator using inner hole of Holder Vibrator!



Replacement

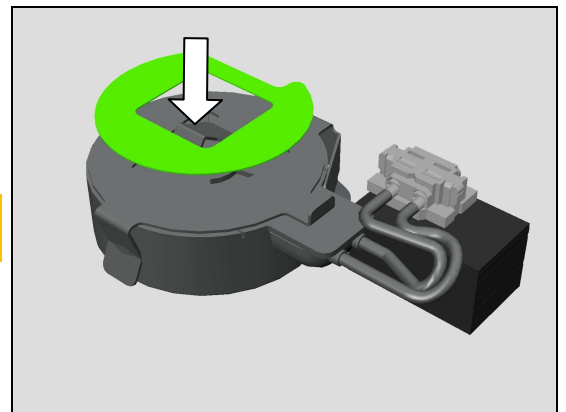
Attach Vibrator to Holder Vibrator as shown in picture, secure with fingers.

Align Vibrator to Holder Vibrator as shown in picture!



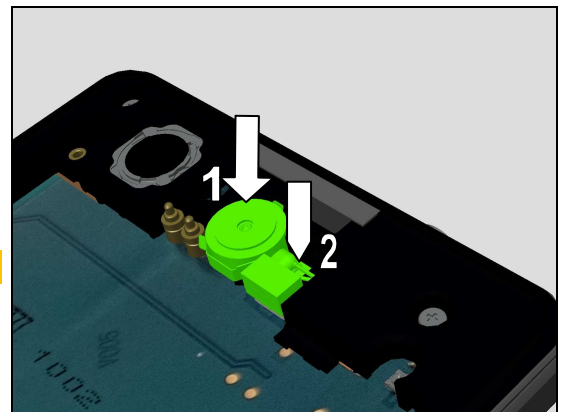
Attach a new Adhesive Vibrator to bottom side of Holder Vibrator as shown in picture.

Align Adhesive Vibrator using inner hole of Holder Vibrator!



1. Attach Vibrator Assy by using fingers.
2. Connect the Vibrator Assy by pressing its connector from the top into the Main PBA connector using Front Opening tool.

Inspect the connector to ensure it's securely attached!



Replacement

4.50 Water Indicator (Cover Rear)

*Follow the 3.1 - 3.3 Disassembly instructions!
Carry out the Removal as described below!
Prepare a new Water Indicator!
Carry out the Installation as described below!
Follow the 5.6 - 5.8 Reassembly instructions!*

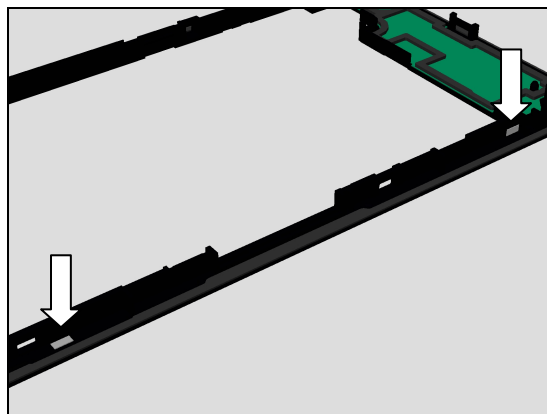
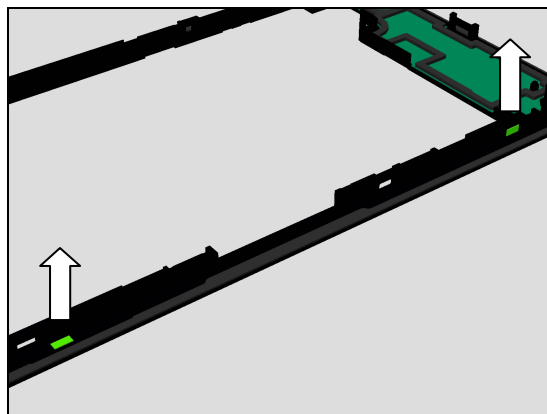
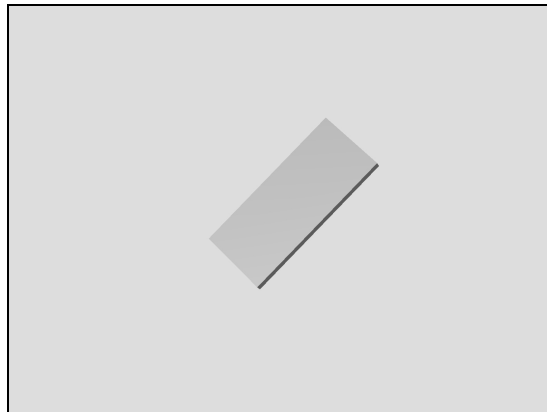
REMOVAL

Detach to remove the Water Indicator by using a Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Attach a new Water indicator in its proper position by using a Flex Film Assembly Tool as shown in picture.



Replacement

4.51 Water Indicator (Holder USB)

Follow the 3.1 - 3.6 Disassembly instructions!
Follow the 4.13 Removal instructions!
Carry out the Removal as described below!
Prepare a new Water Indicator!
Carry out the Installation as described below!
Follow the 4.13 Installation instructions!
Follow the 5.3 - 5.8 Reassembly instructions!

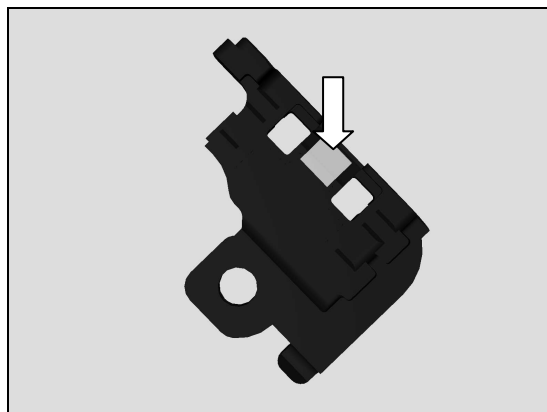
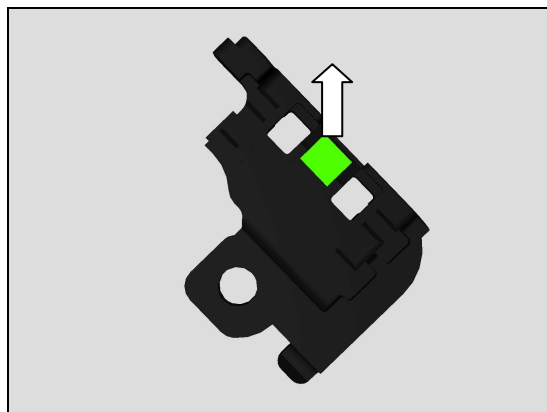
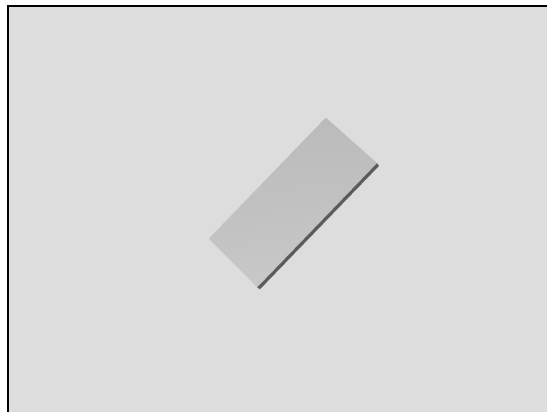
REMOVAL

Detach to remove the Water Indicator by using a Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Attach a new Water indicator in its proper position by using a Flex Film Assembly Tool as shown in picture.

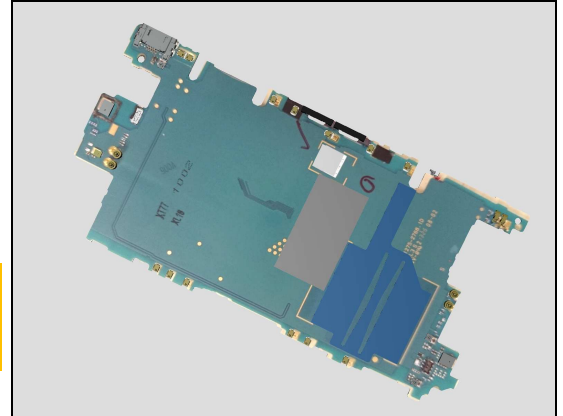


Replacement

4.52 Board Swap – Replacement

Follow the 3.1 – 3.8 Disassembly instructions!
Follow the 4.10, 4.26 and 4.45 Removal instructions!
 Replace the Swap Board.
Follow the 4.10, 4.26 and 4.45 Installation instructions!
Follow the 5.1 – 5.8 Reassembly instructions!

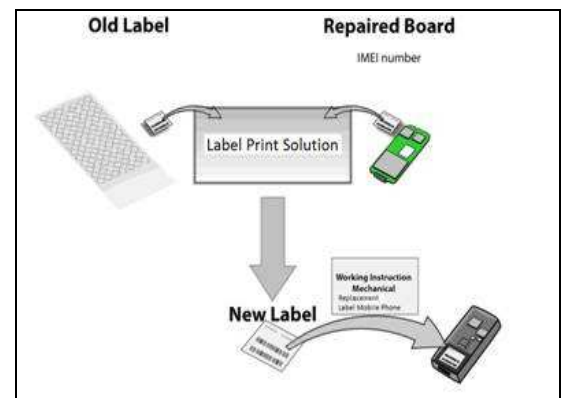
Reuse the Camera, Chat Camera and Battery!
Please refer to: Trouble Shooting Application 1257-2706
for applicable D5503 calibrations!



4.53 Board Swap – Change Label

CHANGE LABEL

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

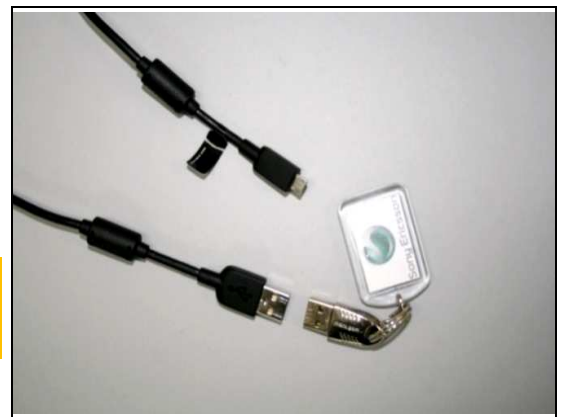


4.54 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

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

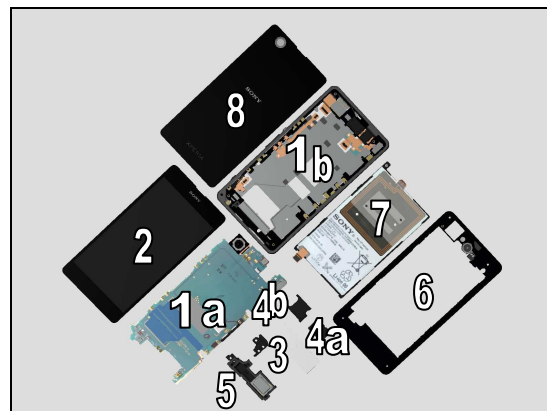
After SW Flash press the Key On/Off to power on the phone, place unit on flat desk and wait 4 minutes until system boot up has been completed!



5 Reassembly

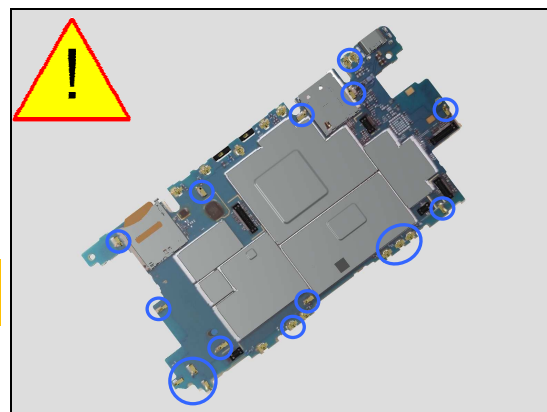
The reassembly is done in the following order:

1. Main PBA & Frame Main Assy
2. Display
3. Holder USB
4. Plate Label & SIM Tray
5. Carrier Holder Speaker Assy
6. Cover Rear
7. Battery
8. Panel Rear Assy



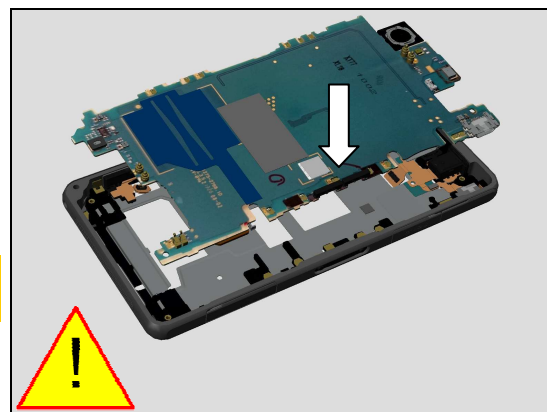
5.1 Main PBA Assy & Frame Main Assy

Inspect PBA Leaf Spring Connector before assembly for any damage!

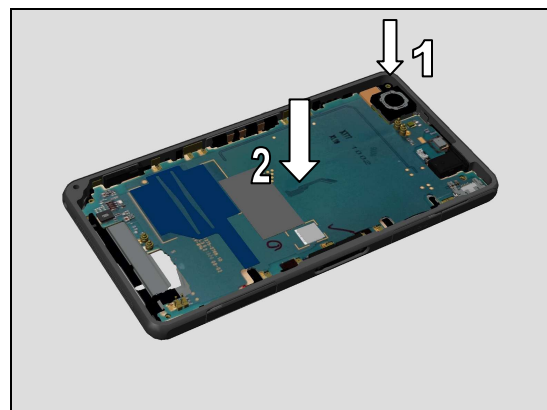


Place the Main PBA gently into the cavity of Frame Main Assy, tilt Main PBA to place Magnetic Connector side first, as shown in picture.

Perform cleaning on Frame Main Assy, Inspect the area before assembly to ensure it's clean of dust and dirt!

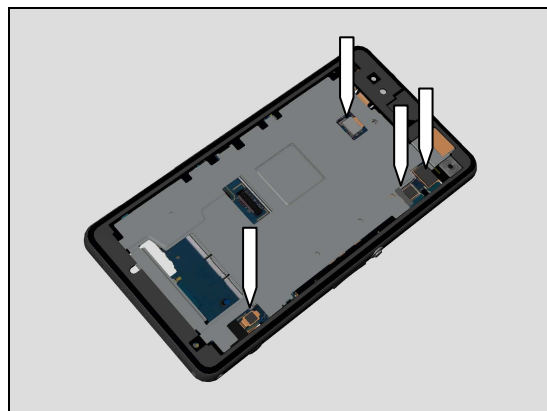


1. Inspect Camera Main MPixel is in its proper position.
2. Press on Main PBA gently with fingers to secure its position.

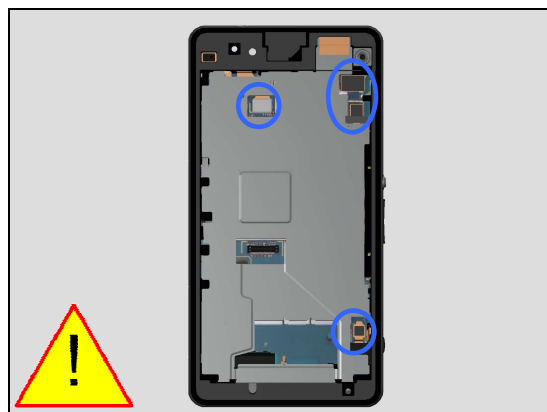


Reassembly

Press with fingers to secure the position of all BtB connectors, shown in the picture.



Press directly on top of each B2B connector using nylon pointer for 5sec each to fully secure BtB connector attachment!



5.2 Display

Remove and clean any remaining adhesive residue found on Frame Main Assy and Display before assembly!

Follow the 4.18 Removal and Installation instructions to replace a new Adhesive WP Display!

Hold the Display in a slight angle and insert it at the top of phone as indicated by the arrow.



Securely attach Display BtB using Nylon Pointer.

Be careful not to damage FPC!



Reassembly

Press on Display surface with fingers to secure temporary attachment.

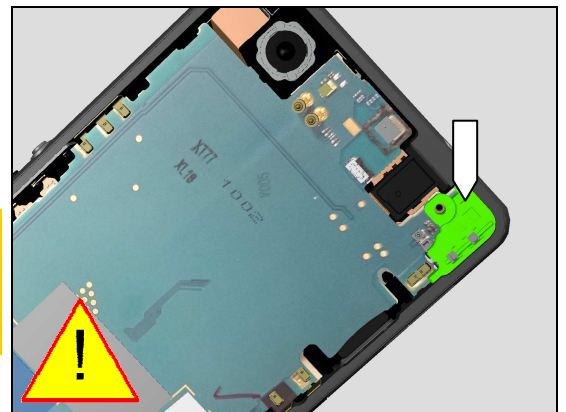


5.3 Holder USB

Place Holder USB in its proper position using fingers then press down to secure its attachment as shown in picture.

Inspect the area before assembly to ensure it's clean of dust and dirt!

Follow the 4.13 Removal and Installation instructions to replace a new Adhesive Holder USB!

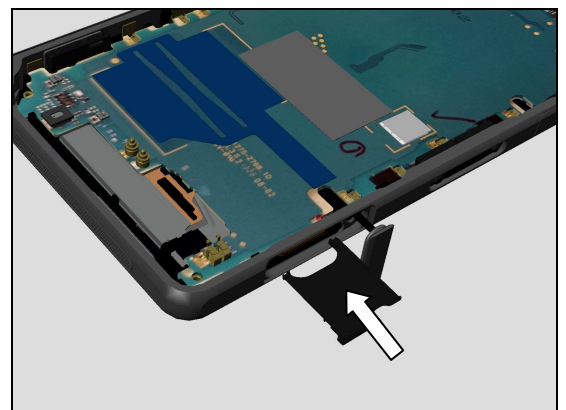


5.4 Plate Label and SIM Tray

Open Cap SIM as shown in picture.

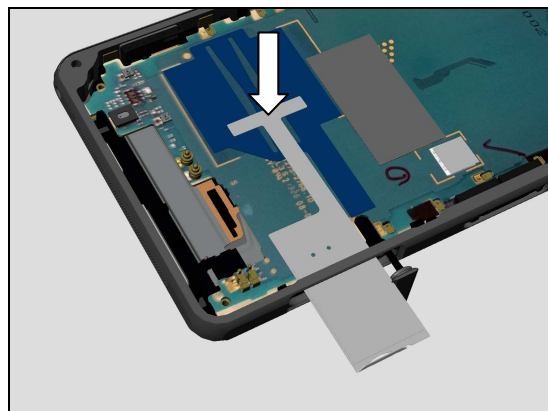


Insert SIM Tray using fingers as shown in picture.

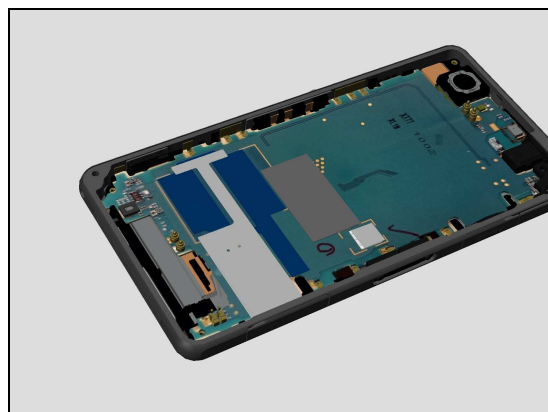


Reassembly

Insert Plate Label with fingers, then using Flex Film Assembly Tool to attach the Plate Label under Plate Label Base.



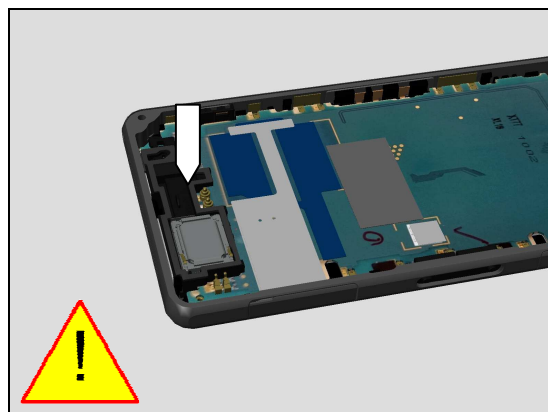
Close Cap SIM.



5.5 Carrier Holder Speaker Assy

Place Carrier Holder Speaker Assy in its proper position using fingers then press down to secure its attachment as shown in picture.

Inspect the area before assembly to ensure it's clean of dust and dirt!



5.6 Cover Rear

Follow the 4.15 removal and installation instruction to replace a new Adhesive WP 2nd Mic!

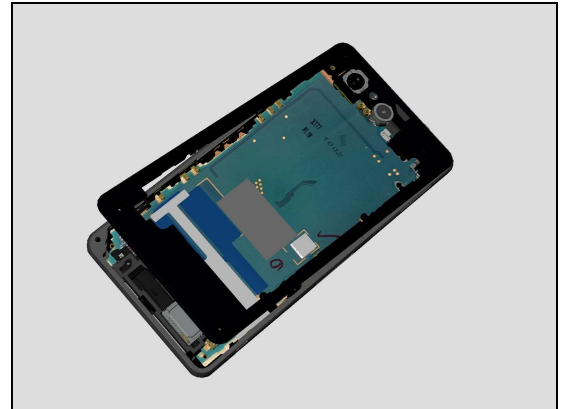
Follow the 4.17 removal and installation instruction to replace a new Adhesive WP Cover Rear!

Use Isopropyl Alcohol for cleaning around the edges of Main Frame Assy before assembly Rear Cover Assy. Inspect area before assembly to ensure it's clean of dust and dirt!

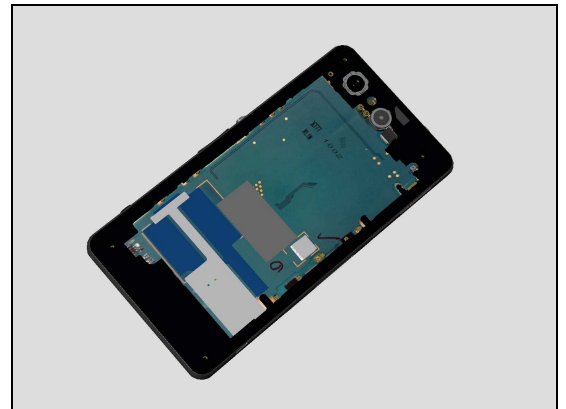


Reassembly

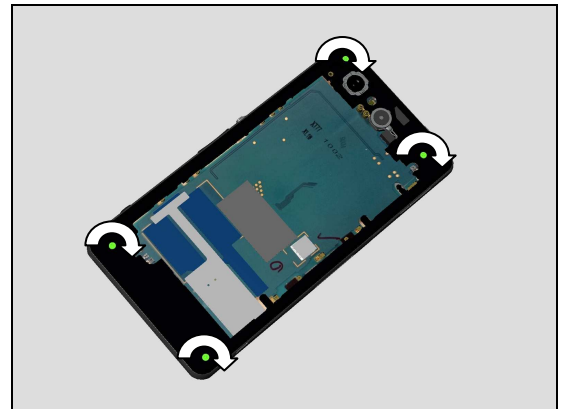
Place the Cover Rear on the Frame Main Assy as shown in the picture.



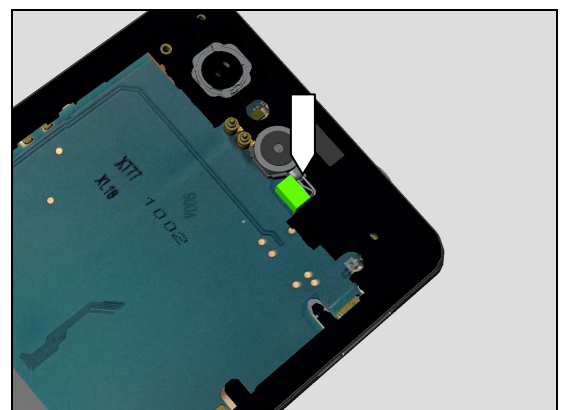
Press with fingers to secure the Cover Rear.



Apply 13 Ncm torque when tightening the Screw Len:4.5
Diam:1.4 with Torx Bits JCIS.



Connect the Vibrator by pressing its connector from the top into the connector of the Main PBA.

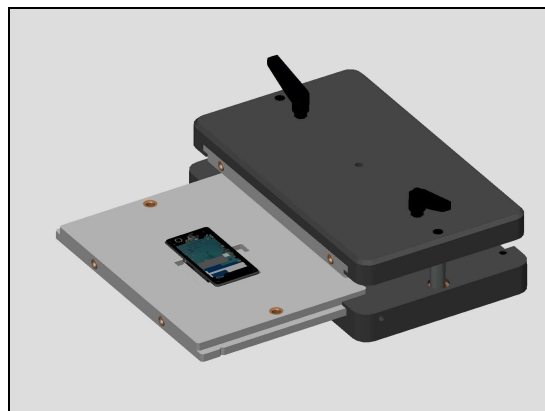


Reassembly

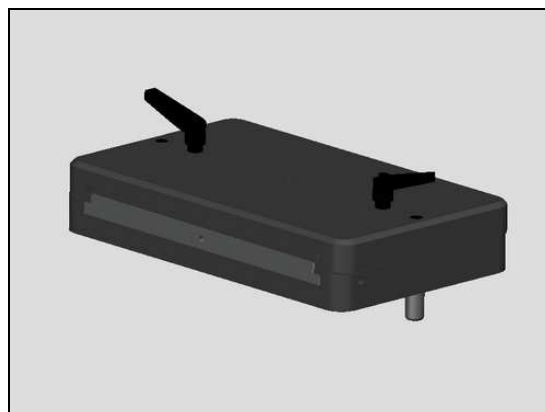
Upper inlay = Rear Cover Press Top Inlay

Lower inlay = Display Press Bottom 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.



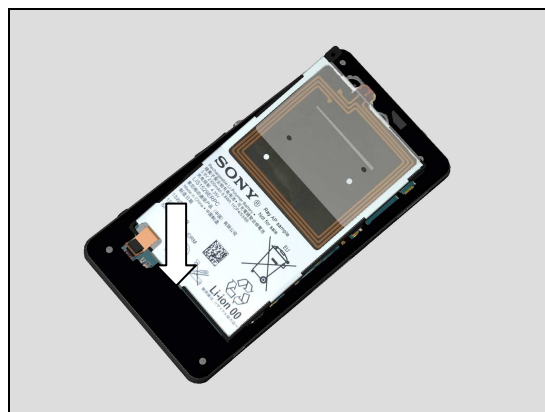
Press it with a pressure value of 386N +/- 50 N / 10 sec (pressure value is adjust from 450N because of the weight of the press fixture)



5.7 Battery

Carefully inspect the Battery after removing it. Battery with visual signs of being bent, having been punctured, bubbles etc. should be scraped after removal!

Place the Battery gently into the cavity, bottom side first.

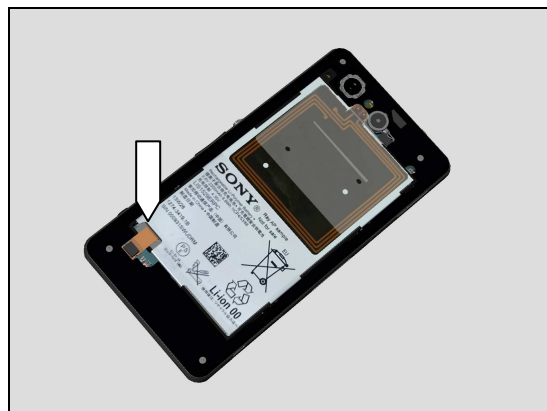


Use fingers to secure the position of the Battery



Reassembly

Connect the Battery by pressing its connector from the top into the connector of the Main PBA.



Apply 13 Ncm torque when tightening the Screw Other Len:2.6 Diam:1.4 M with Torx Bits JCIS.



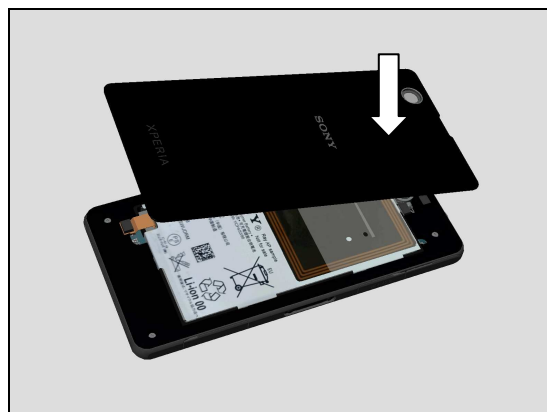
5.8 Panel Rear Assy

Follow the 4.20 removal and installation instruction to replace a new Adhesive WP Panel Rear!

Use Isopropyl Alcohol for cleaning around the edges of Rear Cover before assembly Panel Rear Assy.
Inspect area before assembly to ensure it's clean of dust and dirt!



Place the Panel Rear Assy in its proper position onto the Rear Cover.



Reassembly

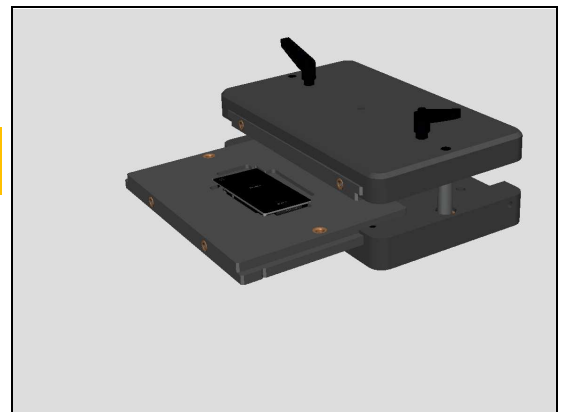
Inspect the Panel Rear Assy, make sure of good alignment and Panel Rear Assy is centered.



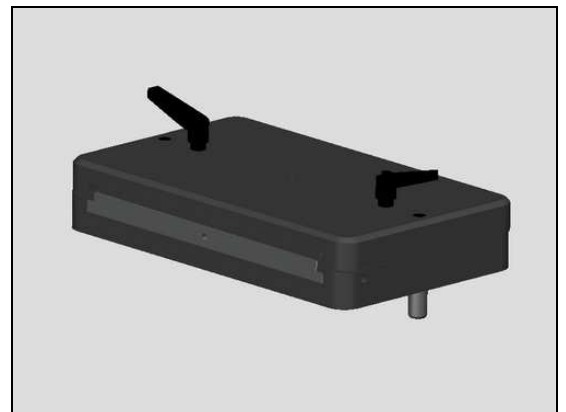
Upper inlay = Rear Panel Press Top Inlay

Lower inlay = Display Press Bottom 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 386N +/- 50 N / 10 sec.
(pressure value is adjust from 500N because of the weight of the press fixture)



Perform WRT test according to instruction Water Resistance Test for PC 1269-3536, if phone passes WRT testing, leave the phone to stand for 1 hour and retest WRT again to verify results!



6 Revision History

Rev.	Date	Changes / Comments
1	2014-Jan-29	Released
2	2014-Jan-31	RTL Version
3	2014-Feb-03	Page3 Table Contents Edited
4	2014-Feb-05	Chapter 3.7 Display updated (temperature)
5	2014-Feb-11	M51w Added
6	2014-Feb-26	Net Front & Sheet Graphite added. Cushion 0.0mm Receiver Removed
7	2014-Feb-27	Chapter 4.8 updated
8	2014-Mar-13	Chapter 3.7 & 4.1 updated