

Working Instructions

- mechanical -



Xperia C5 Ultra

E5506, E5533, E5553, E5563

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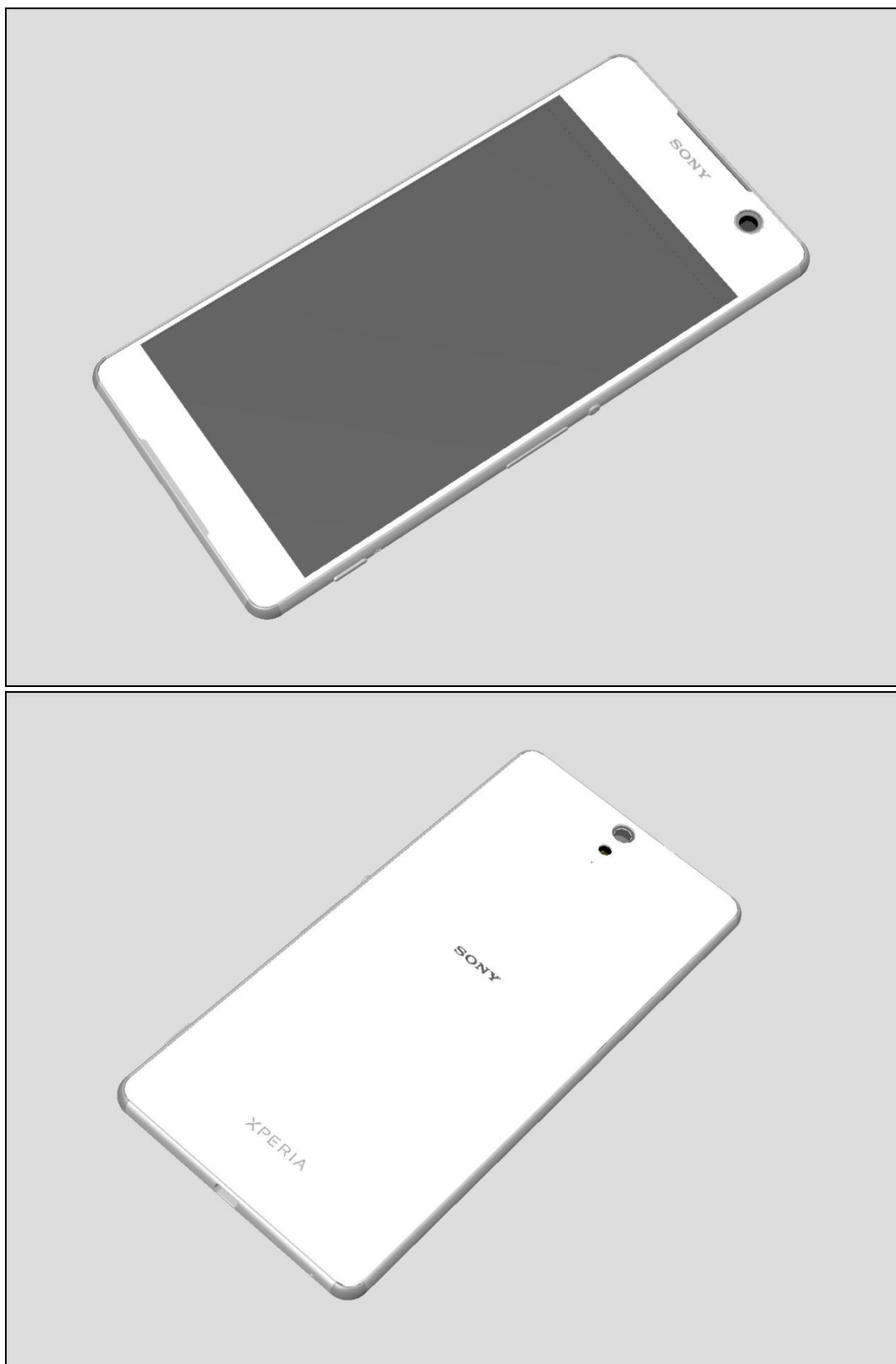
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For general information about mechanical repair related issues, refer to
1220-1333: Generic Repair Manual - mechanical

1 Exterior Views

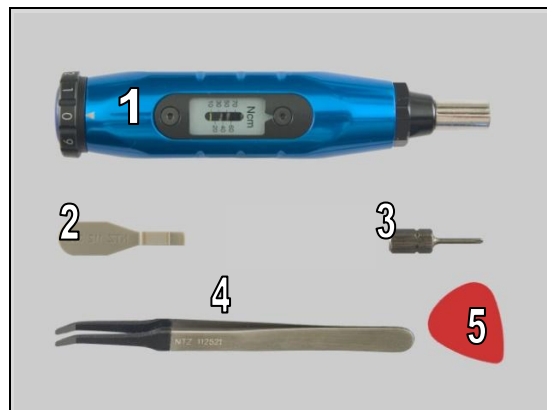
1.1 E5506, E5533, E5553, E5563



2 Tools

SPECIAL TOOLS

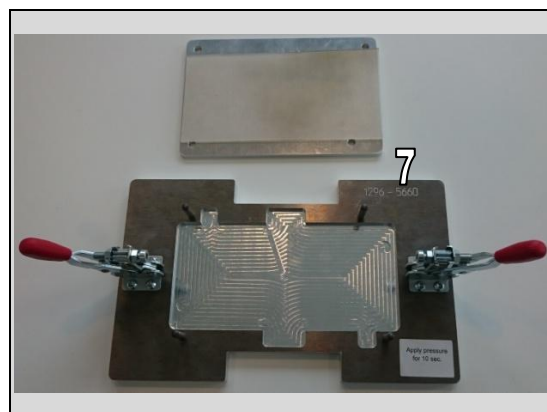
1. Torque Screwdriver
2. Front Opening Tool
3. Bits (T5)
4. Flex Film Assembly Tool
5. Guitar Pick



6. Battery Cover Adhesive Alignment Fixture(1296-5661)



7. Battery Cover Press Fixture(1296-5660)

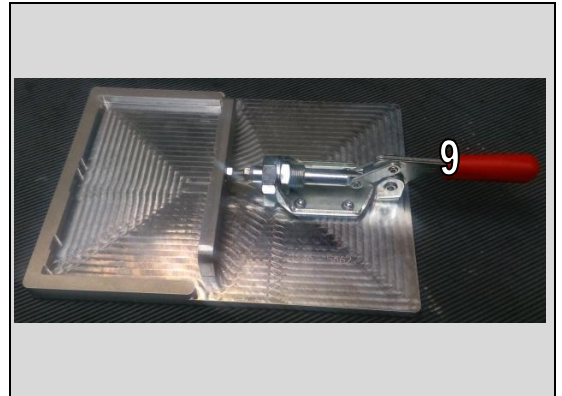


8. Keys Side Panel Adhesive Alignment Tool(1296-5664)



Tools

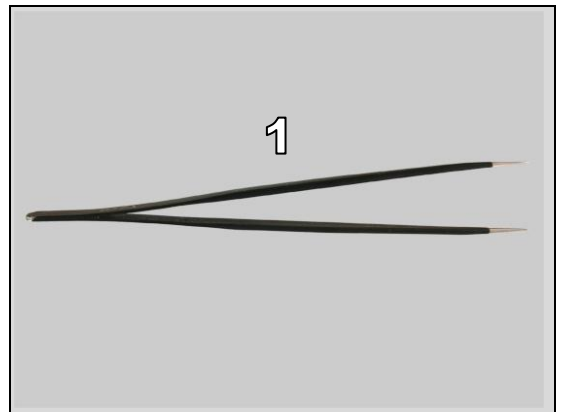
9. Side Panel Press Fixture(1296-5662)



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

STANDARD TOOLS

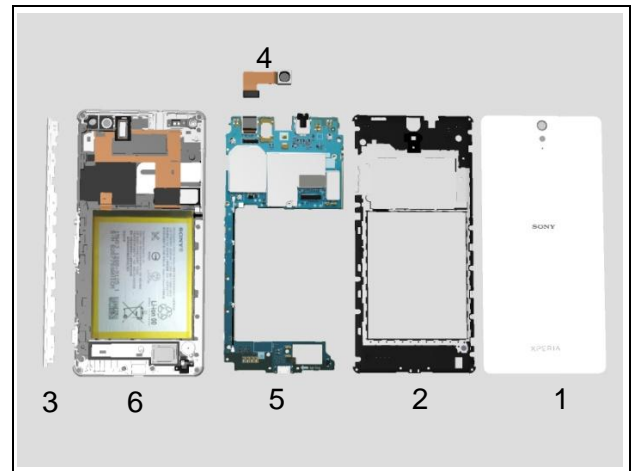
1. Tweezers



3 Disassembly

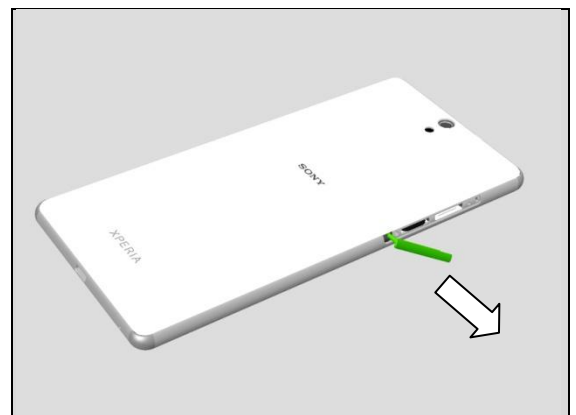
The disassembly is done in the following order:

1. Battery Cover Assy
2. Rear Cover Assy
3. Keys Side Panel Assy
4. Main Camera
5. Main PBA
6. Front Cover Assy



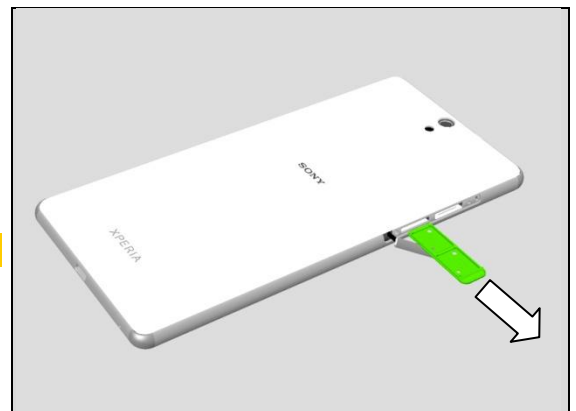
3.1 Battery Cover Assy

Open the SIM SD Cover.



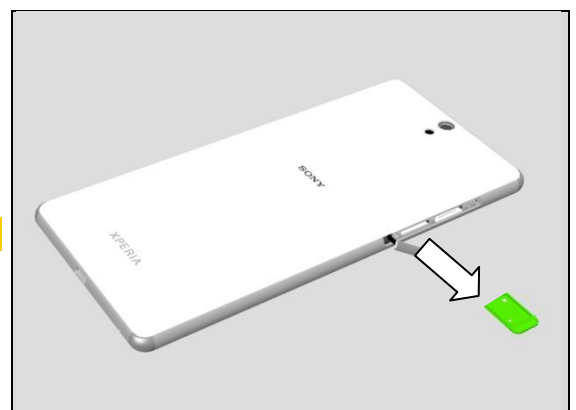
Remove the Tray Dual Nano SIM.

Note: E5533, E5563 have two Nano SIM Card.



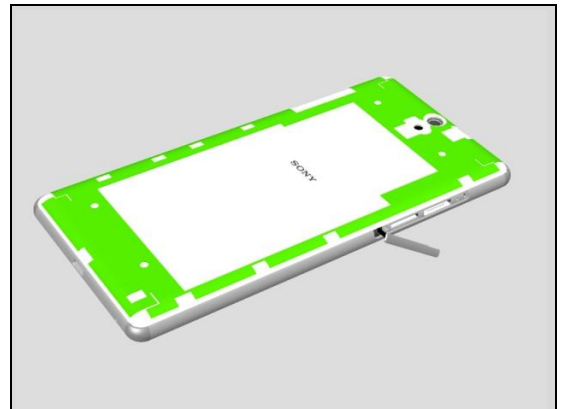
Remove the Tray Single Nano SIM.

Note: E5506, E5553 have only one SIM Card.

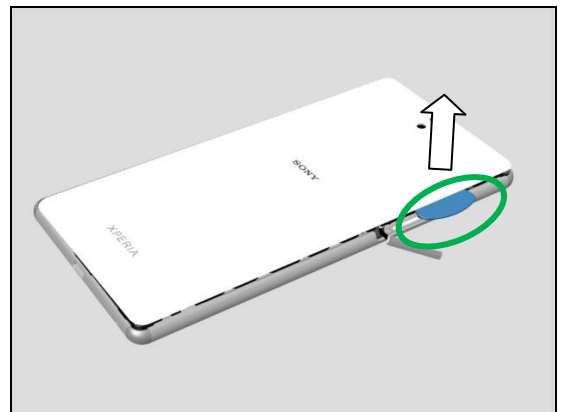


Disassembly

There are Adhesive Battery Cover as shown and hooks around four sides under Battery Cover Assy.



Insert Guitar Pick at shown position and lift it up carefully to detach its adhesive and hooks underneath.

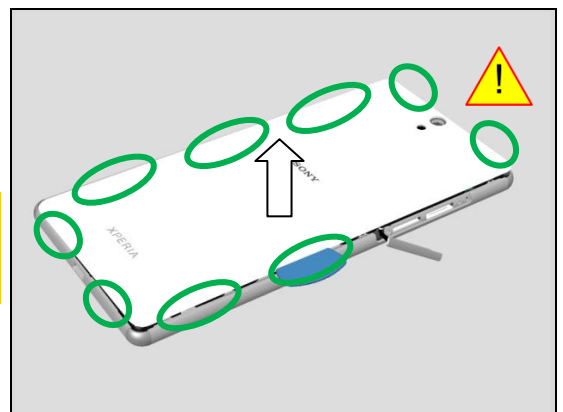


Do the same at shown positions to detach all adhesive and hooks underneath.

Note:

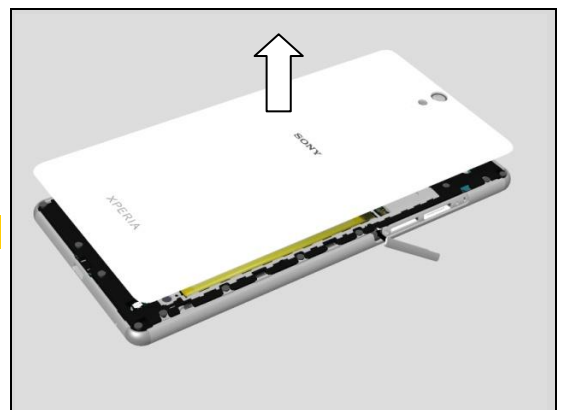
Do not insert Guitar Pick at Camera Lens Area.

Do not insert Guitar Pick too deep.



Remove the Battery Cover Assy

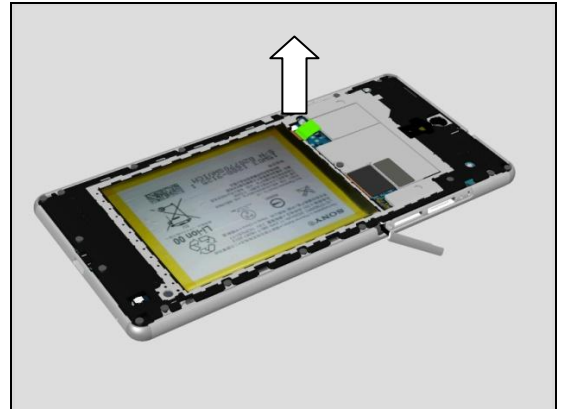
Note: Adhesive Battery Cover cannot be used.



Disassembly

3.2 Rear Cover Assy

Unsnap the BtB connector of the Battery.

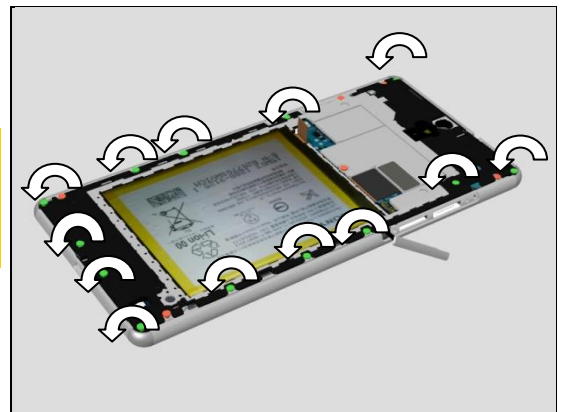


There are total 19 units of Screw 1.6mm x3mm_BLACK_T5.

13 units of Green screws as shown are used for Rear Cover Assy.

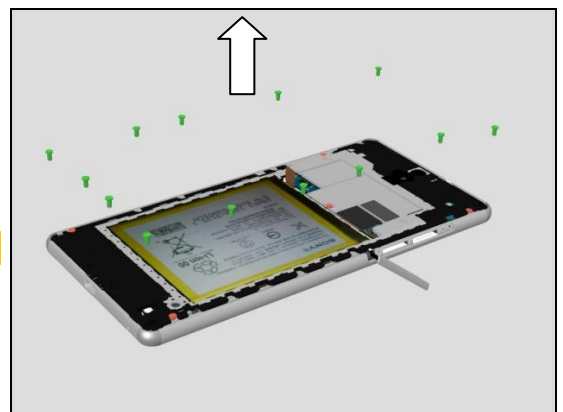
6 units of Red screws as shown are used for Side Panel Assy and Main PBA.

Remove the 13 units of Green Screw 1.6mm x 3mm_BLACK_T5 as shown by using a screwdriver with Bits (T5).



Remove the 13 units of Green Screw 1.6mm x 3mm_BLACK_T5 used for Rear Cover Assy.

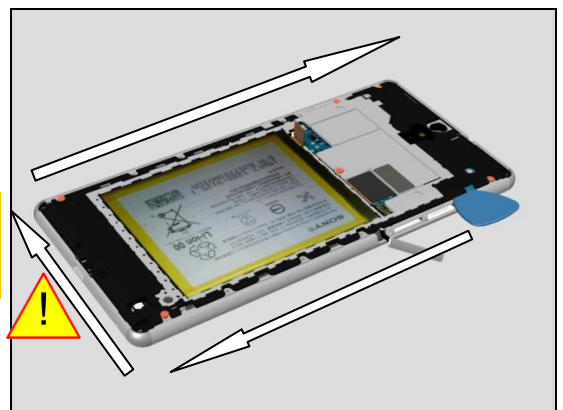
Scrap! Screws cannot be reused.



Insert Guitar Pick as shown then slide Guitar Pick along side of phone carefully and slowly loosening snap hooks as shown in picture.

Do not insert Guitar Pick too deep.

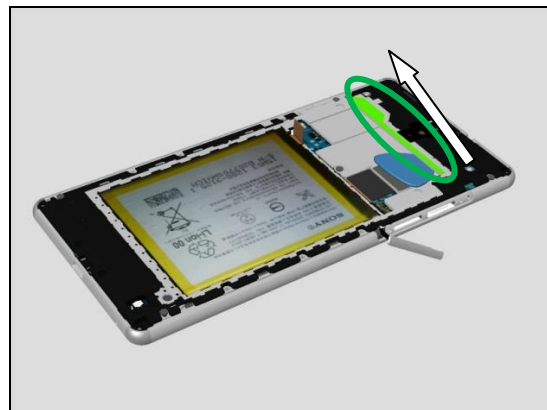
Be careful about left side area not to make Main PBA pops up.



Disassembly

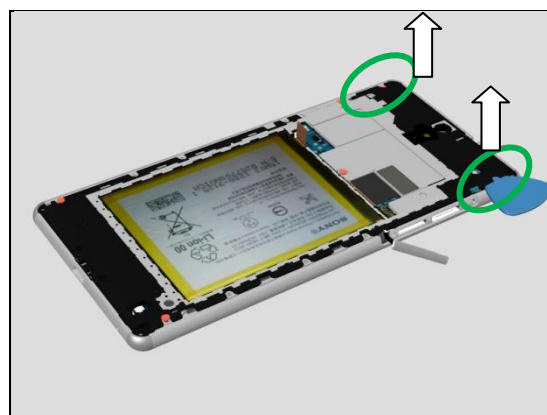
Insert Guitar Pick as shown under Rear Cover Assy and slide it to detach its Adhesive Rear Cover.

Scrap! Adhesive Rear Cover cannot be reused.

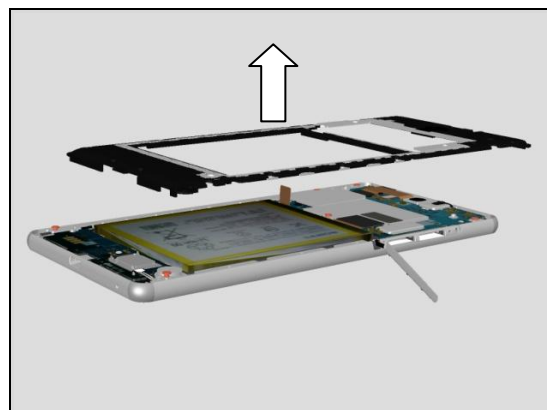


Insert Guitar Pick at shown positions to lift up the top side of Rear Cover Assy.

Carefully! Don't damage the Rear Cover Assy.



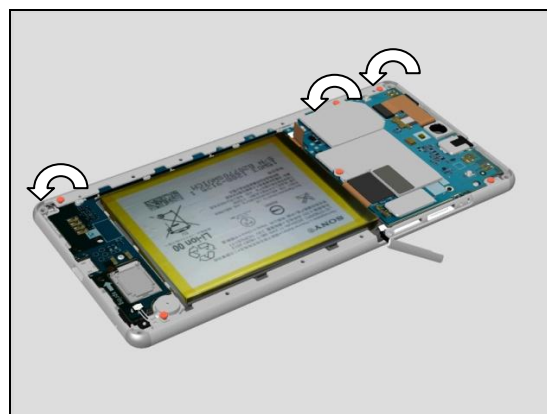
Remove the Rear Cover Assy.



3.3 Keys Side Panel Assy

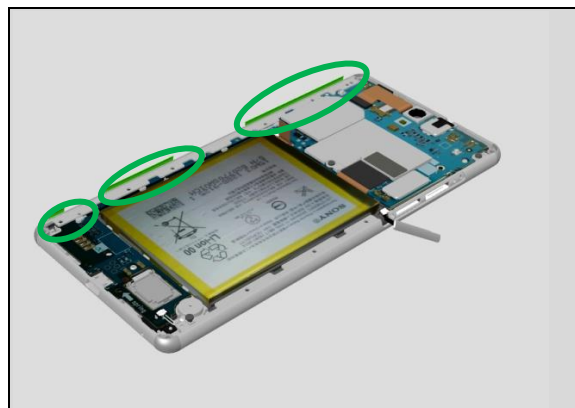
Remove the 3 units of Screw 1.6mm x 3mm_BLACK_T5 as shown by using a screwdriver with Bits (T5).

Scrap! Screws cannot be reused.



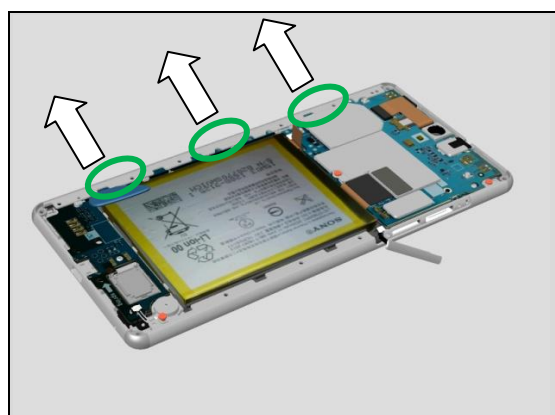
Disassembly

There has Adhesive Keys Side Panel as shown inside Keys Side Panel Assy.



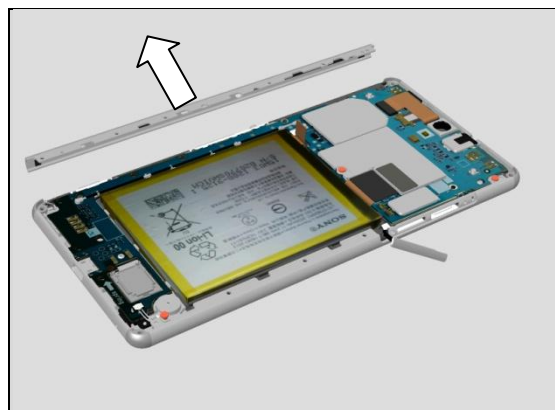
Insert Guitar Pick at shown positions and push it outside carefully and slowly to detach the Adhesive Keys Side Panel inside.

Scrap! Adhesive Keys Side Panel cannot be reused.



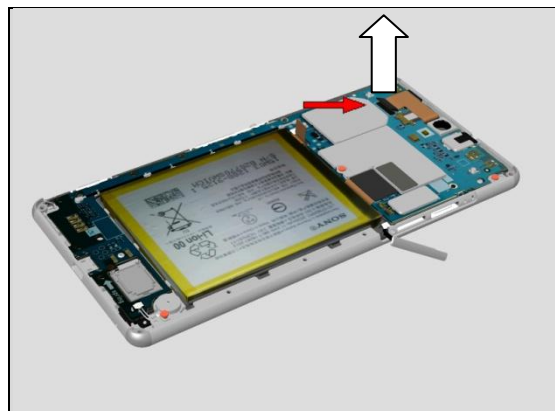
Remove the Keys Side Panel Assy carefully.

If Keys Side Panel Assy is deformed after disassembly, then it cannot be reused.



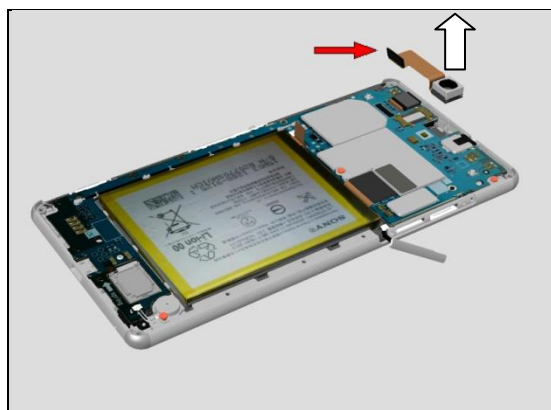
3.4 Main Camera

Unsnap the BtB connector of Main Camera.



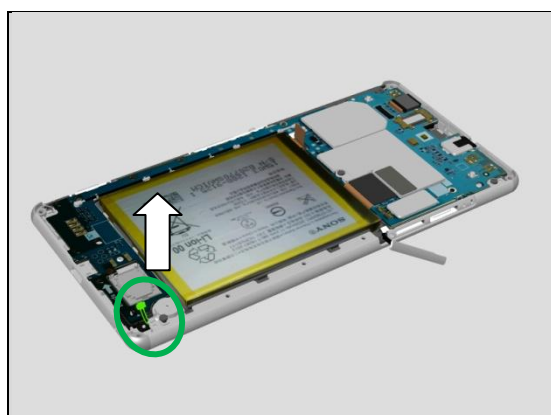
Disassembly

Remove the Main Camera.



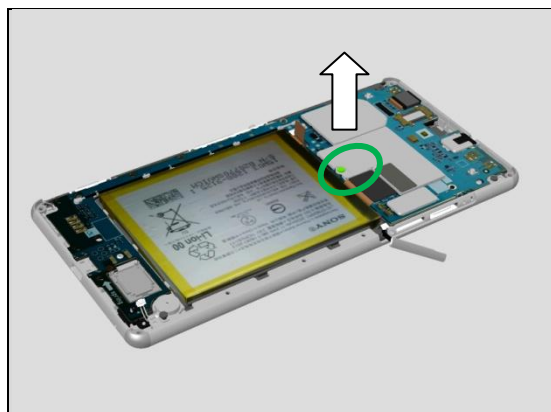
3.5 Main PBA

Unsnap the connector of Vibrator.

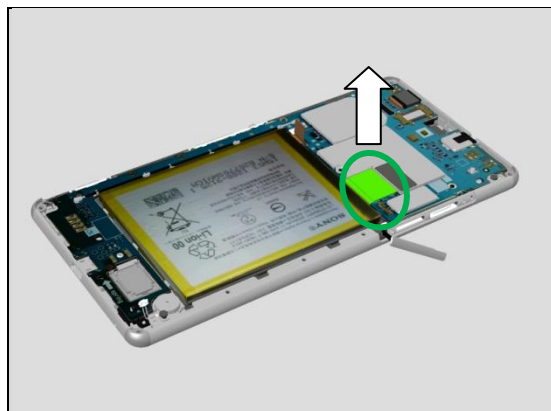


Remove the Screw 1.6mm x 3mm_BLACK_T5 as shown by using a screwdriver with Bits (T5).

Scrap! Screw cannot be reused.



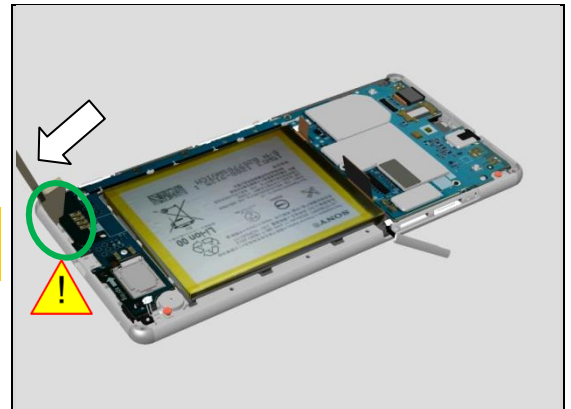
Unsnap the BtB connector of TP/LCM.



Disassembly

Insert Front Opening Tool at shown position to open this side hook of Main PBA carefully.

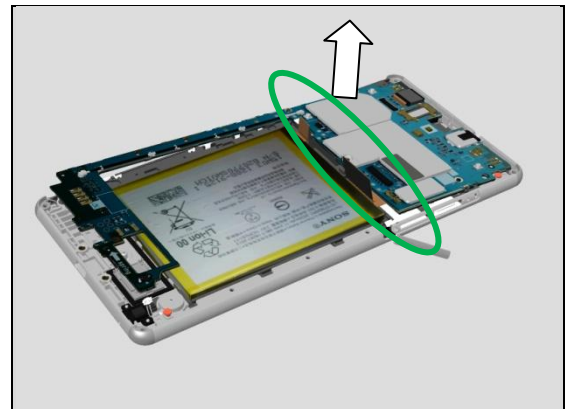
Be careful! Do not lift this slim side of Main PBA.
Don't make the Main PBA deformed at the slim area.



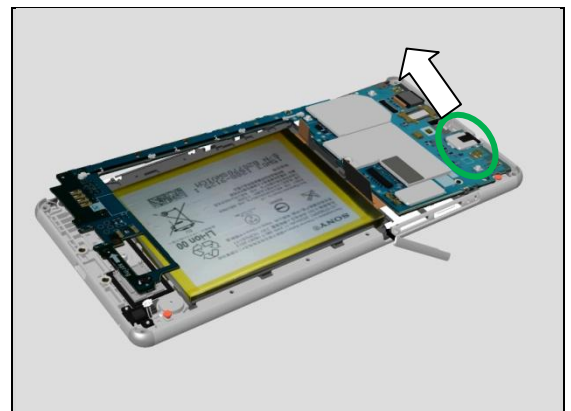
Insert Front Opening Tool at shown position to open the other side hooks of Main PBA.



Take the Middle hard side of Main PBA as shown.
Lift up the left slim side of Main PBA carefully first.

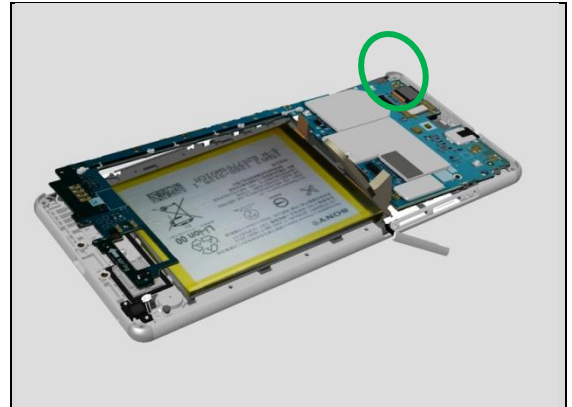


Pull out Audio Jack connector as shown from Front Cover Assy then.



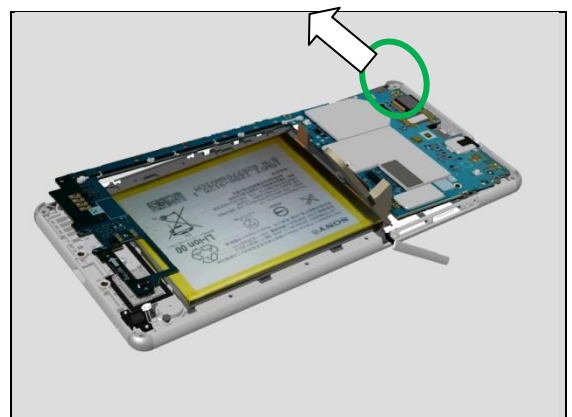
Disassembly

There is Sponge Front LED (adhesive) at the shown corner under Main PBA.

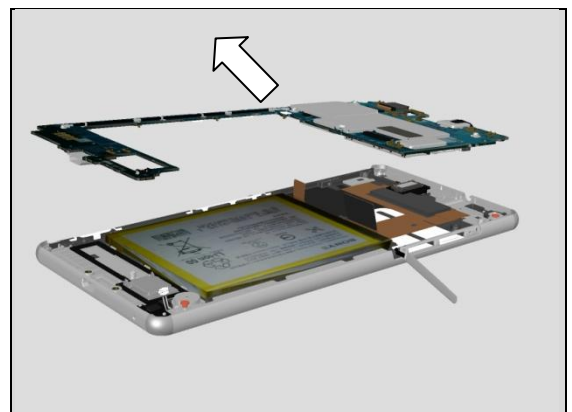


Remove Main PBA from Front Cover Assy to detach the Sponge Front LED.

If the Sponge Front LED is damaged after Main PBA disassembly, then it cannot be reused.

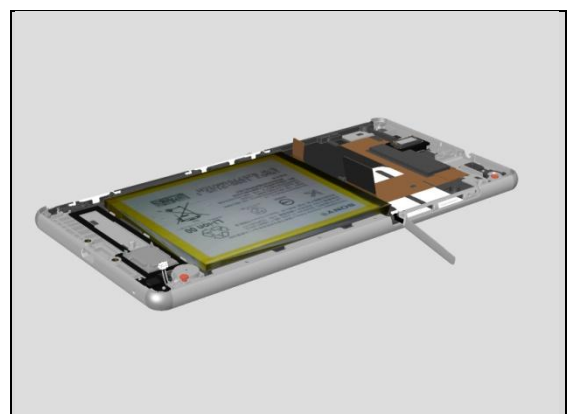


Remove the Main PBA from Front Cover Assy.



3.6 Front Cover Assy

Front Cover Assy as shown.



4 Replacement

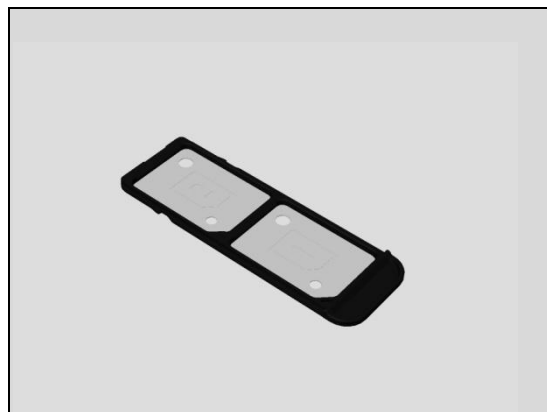
4.1 Tray Dual Nano SIM

Follow the 3.1 Disassembly instructions!

Prepare the new Tray Dual Nano SIM.

Follow the 5.6 Reassembly instructions!

Note: E5533, E5563 have two SIM Cards.



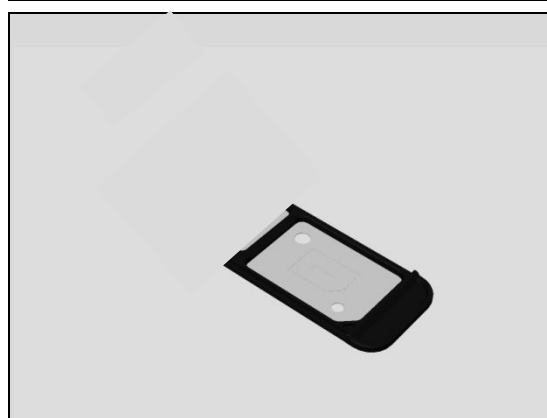
4.2 Tray Single Nano SIM

Follow the 3.1 Disassembly instructions!

Prepare the new Tray Single Nano SIM.

Follow the 5.6 Reassembly instructions!

Note: E5506, E5553 have one SIM Card only.



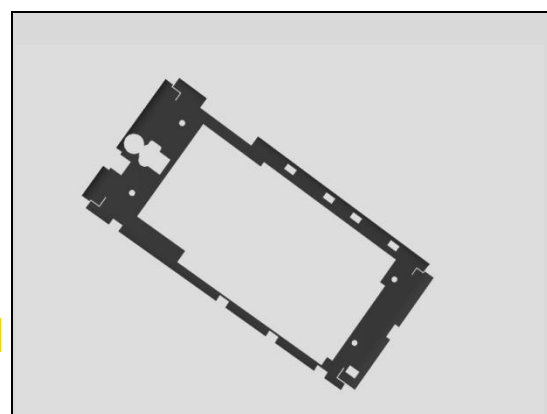
4.3 Adhesive Battery Cover

Follow the 3.1 Disassembly instructions!

Prepare the new Adhesive Battery Cover.

Follow the 5.6 Reassembly instructions!

Scrap! Cannot be reused.



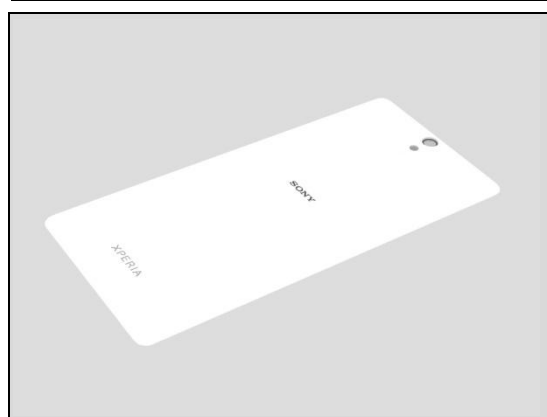
4.4 Battery Cover Assy

Follow the 3.1 Disassembly instructions!

Prepare the new Battery Cover Assy.

Follow the 5.6 Reassembly instructions!

Note: New Battery Cover Assy already has new Adhesive Battery Cover.



Replacement

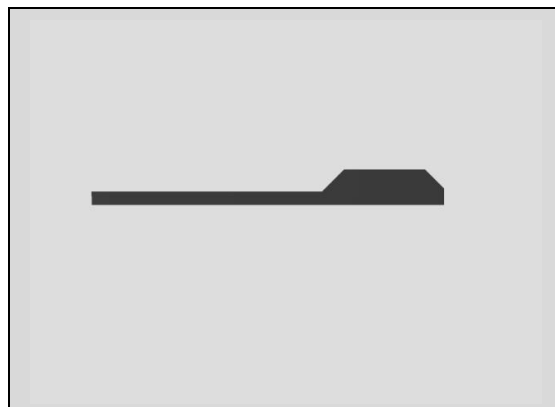
4.5 Adhesive Rear Cover

Follow the 3.1-3.2 Disassembly instructions!

Prepare the new Adhesive Rear Cover.

Follow the 5.5-5.6 Reassembly instructions!

Scrap! Cannot be reused.



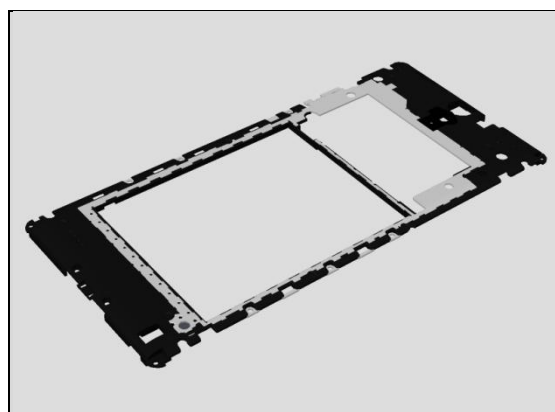
4.6 Rear Cover Assy

Follow the 3.1-3.2 Disassembly instructions!

Prepare the new Rear Cover Assy.

Follow the 5.5-5.6 Reassembly instructions!

Note: New Rear Cover Assy already has new Adhesive Rear Cover.



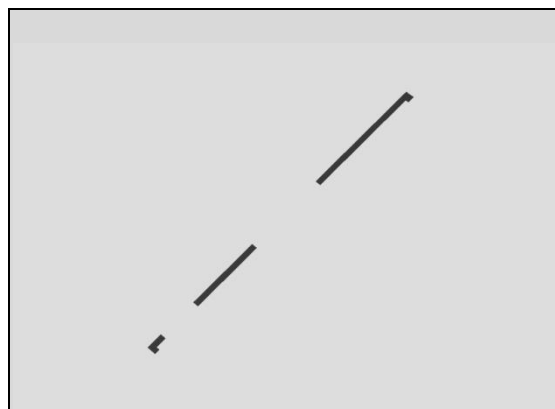
4.7 Adhesive Keys Side Panel

Follow the 3.1-3.3 Disassembly instructions!

Prepare the new Adhesive Keys Side Panel.

Follow the 5.4-5.6 Reassembly instructions!

Scrap! Cannot be reused.



4.8 Keys Side Panel Assy

Follow the 3.1-3.3 Disassembly instructions!

Prepare the new Keys Side Panel Assy.

Follow the 5.4-5.6 Reassembly instructions!

Note: New Keys Side Panel Assy already has new Adhesive Keys Side Panel.



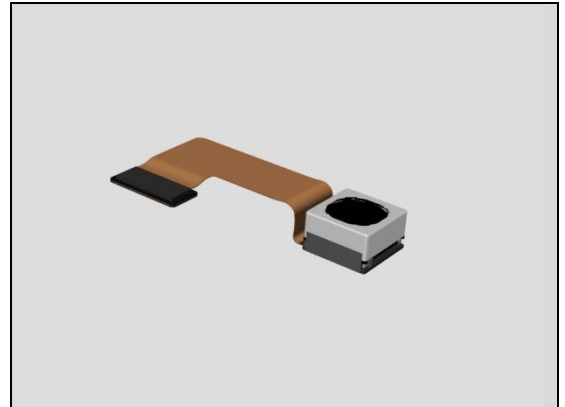
Replacement

4.9 Main Camera

Follow the 3.1-3.4 Disassembly instructions!

Prepare the new Main Camera.

Follow the 5.3-5.6 Reassembly instructions!



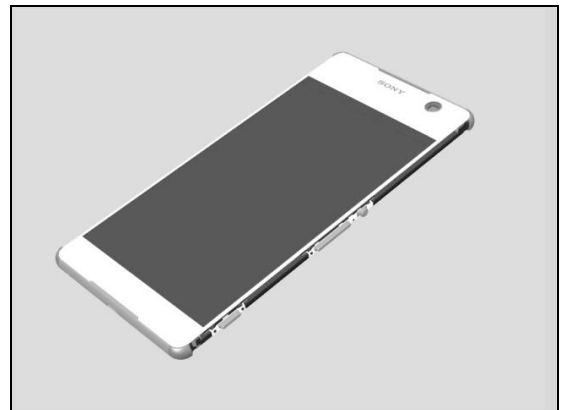
4.10 Front Cover Assy

Follow the 3.1-3.6 Disassembly instructions!

Prepare the new Front Cover Assy.

Follow the 5.1-5.6 Reassembly instructions!

**Follow the calibrations in Trouble Shooting Application
1289-2983 – mechanical**

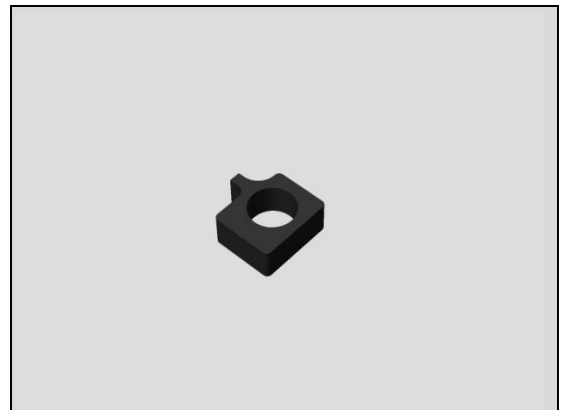


4.11 Sponge Front LED

Follow the 3.1-3.6 Disassembly instructions!

Prepare the new Sponge Front LED.

Follow the 5.1-5.6 Reassembly instructions!



Replacement

4.12 Battery& Adhesive Battery

Follow the 3.1-3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Battery& Adhesive Battery.

Follow the 5.5 Reassembly instructions!

Carry out the Installation as described below.

Follow the 5.6 Reassembly instructions!

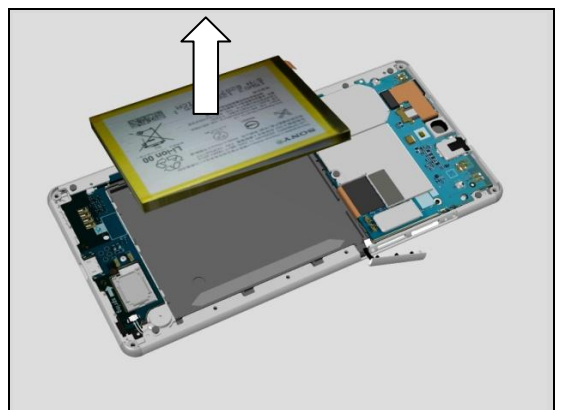
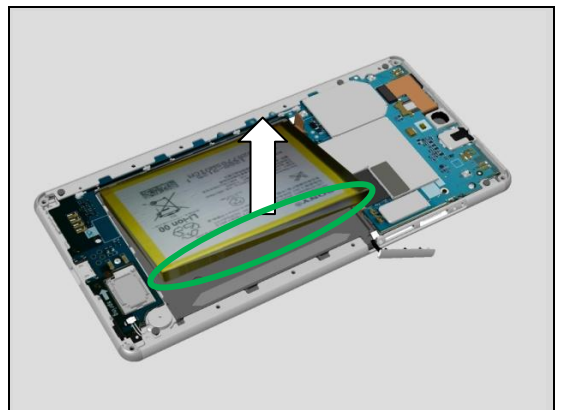
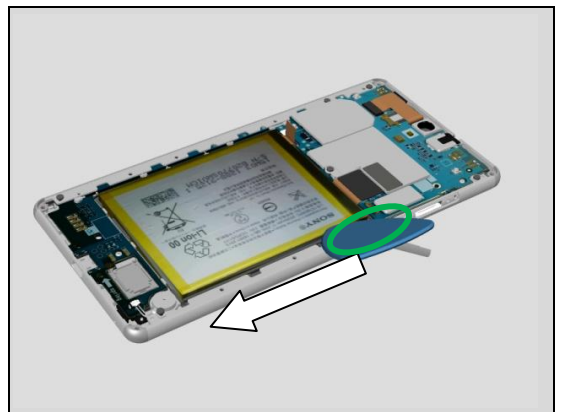
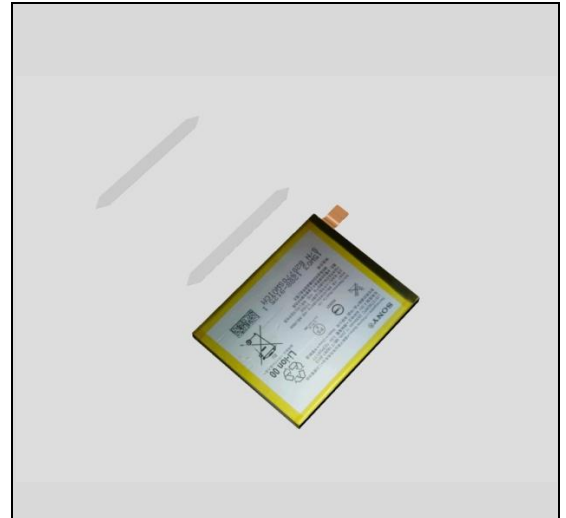
REMOVAL

Insert Guitar Pick at shown position and slide it as shown to detach its Adhesive Battery under Battery.

Lift up this side of Battery first.

Remove the Battery then.

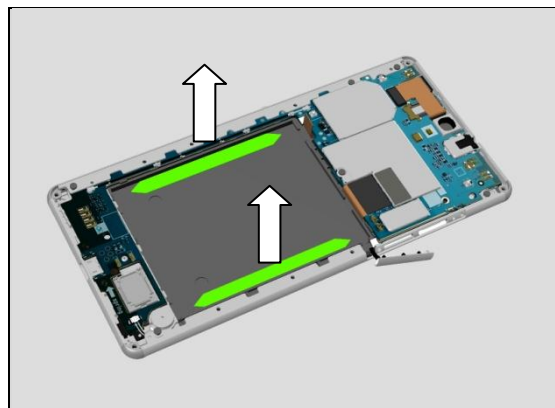
Note: Scrap! Cannot be reused due to too many bubbles after disassembly.



Replacement

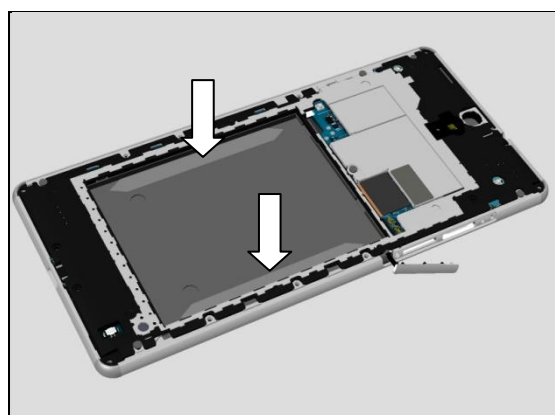
Remove the old surplus of Adhesive Battery.

Note: Scrap! Cannot be reused.

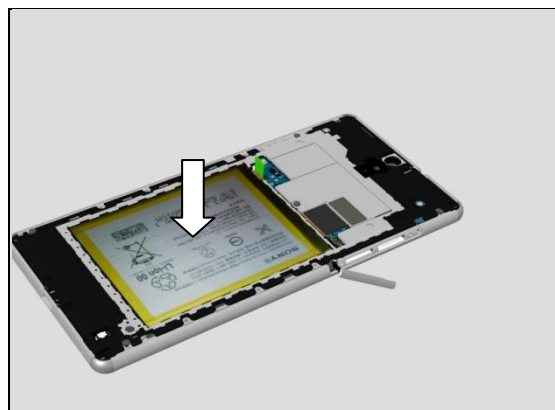


INSTALLATION

Assemble new Adhesive Battery at its correct position as shown.

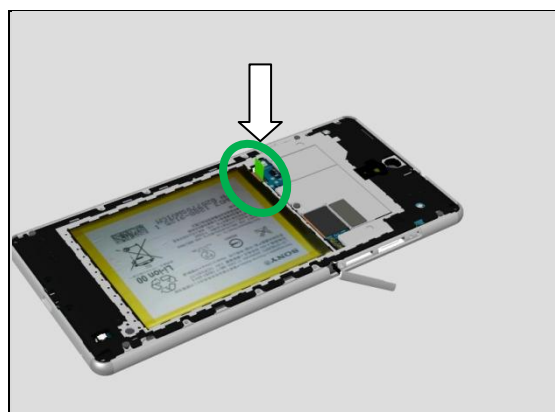


Assemble Battery at its correct position as shown.



Assemble the BtB connector of Battery on Main PBA.

Battery FPC is above Rear Cover Assy.



Replacement

4.13 Receiver & Adhesive Receiver Holder

Follow the 3.1-3.6 Disassembly instructions!

Carry out the Removal as described below.

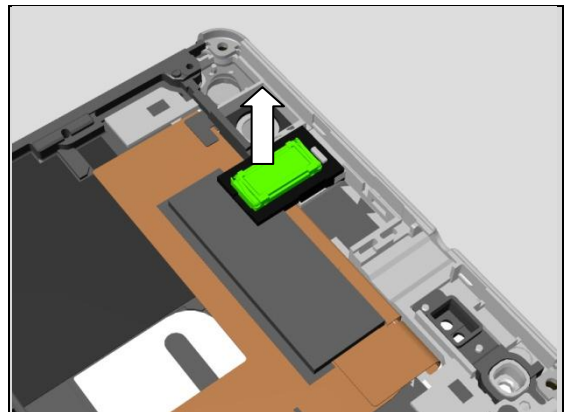
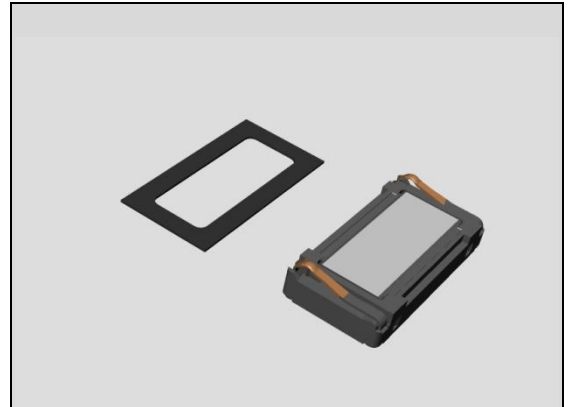
Prepare the new Receiver & Adhesive Receiver Holder.

Carry out the Installation as described below

Follow the 5.1-5.6 Reassembly instructions!

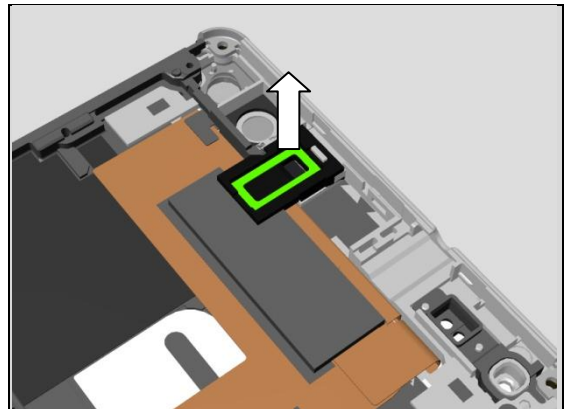
REMOVAL

Remove the Receiver from Receiver Holder.



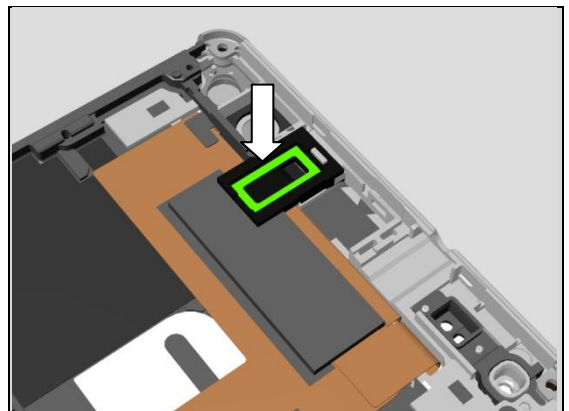
Clean surplus of Adhesive Receiver Holder from its cavity and Receiver Side.

Scrap! Cannot be reuse.



INSTALLATION

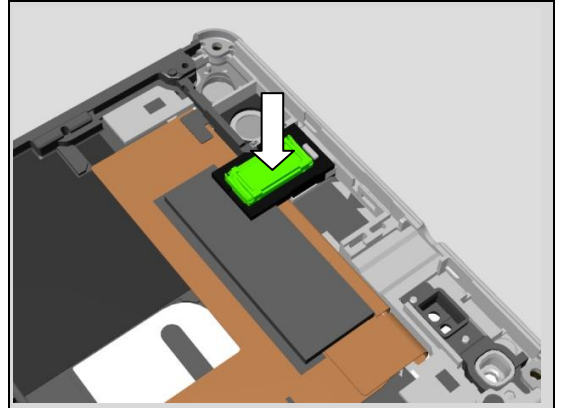
Assemble new Adhesive Receiver Holder into its cavity at its correct position as shown.



Replacement

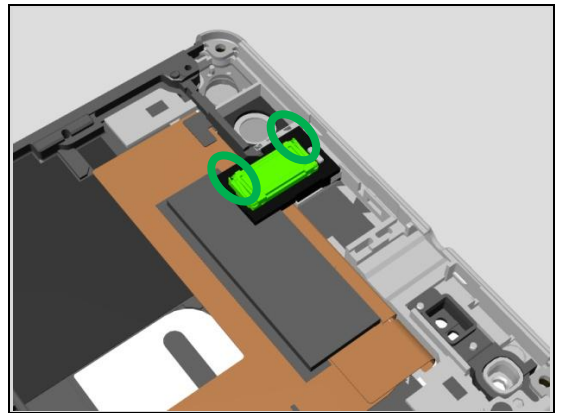
Assemble Receiver into its cavity then.

Do not touch the pins of the Receiver!



Press the Receiver to secure the attachment.

Do not touch the pins of the Receiver!



Replacement

4.14 Screw 1.6mm x 3mm_BLACK_T5

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Screw 1.6mm x 3mm_BLACK_T5

Carry out the Installation as described below

Follow the 5.6 Reassembly instructions!

REMOVAL

There are total 19 units of Screw 1.6mm x3mm_BLACK_T5.

13 units of Green screws as shown are used for Rear Cover Assy.

6 units of Red screws as shown are used for Side Panel Assy and Main PBA.

Remove the 19 units of Screw 1.6mm x 3mm_BLACK_T5 as shown by using a screwdriver with Bits (T5).

Scrap! Not to be reused.

INSTALLATION

Press four corners inside by hand tightly while assembling these four corner screws.

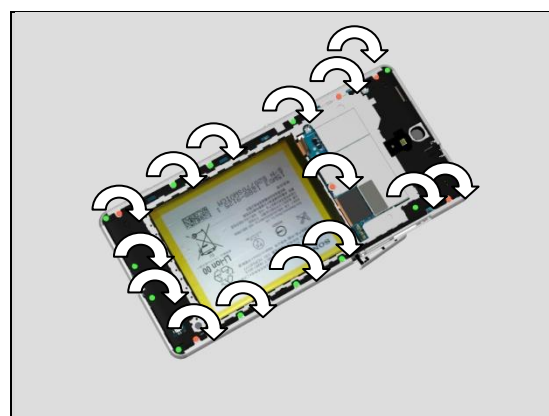
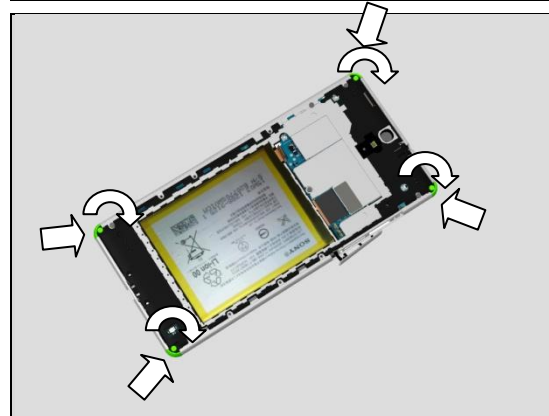
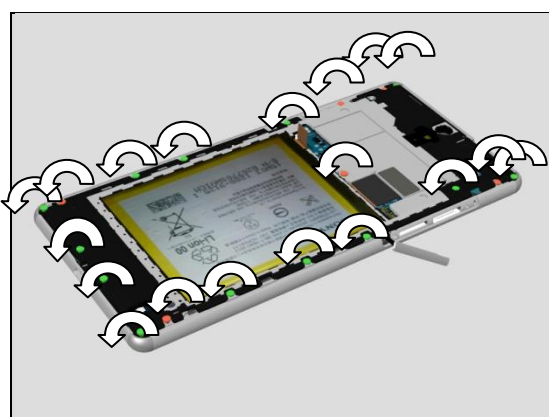
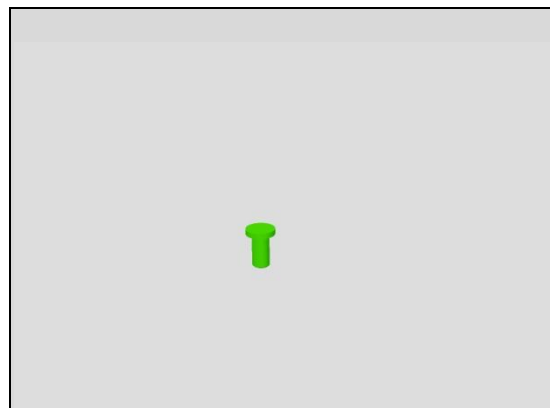
Apply 8 Ncm torque for these four units of Screw 1.6mm x 3mm_BLACK_T5 with Bits (T5).

Take new Screws!

Apply 8 Ncm torque for these 15 units of Screw 1.6mm x 3mm_BLACK_T5 with Bits (T5).

Take new Screws!

All 19 units of screws are assembled on Phone till this step(13 units of green screws and 6 units of red screws.



Replacement

4.15 Coaxial Cable

Follow the 3.1-3.2 Disassembly instructions!

Carry out the Removal as described below.

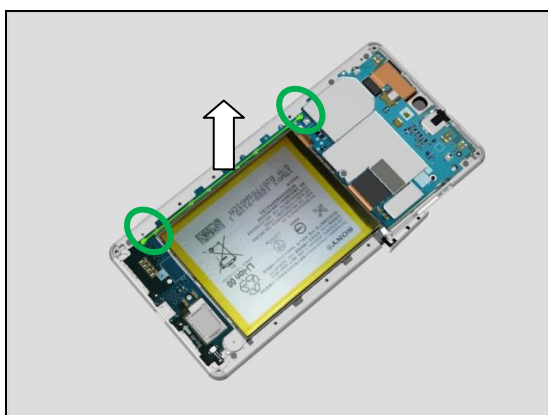
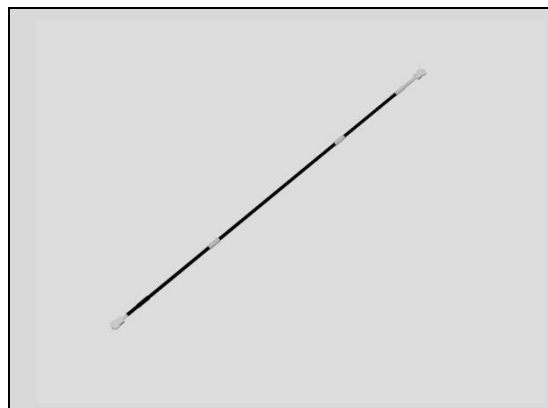
Prepare the new Coaxial Cable.

Carry out the Installation as described below

Follow the 5.5-5.6 Reassembly instructions!

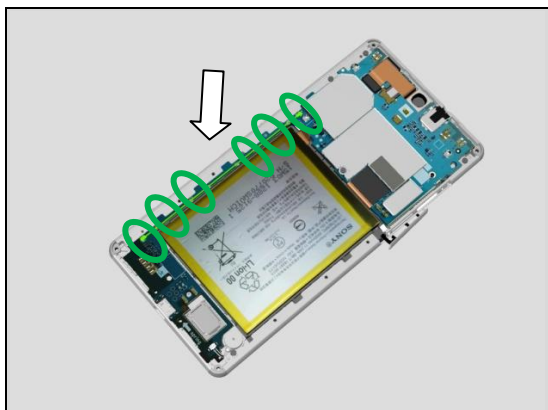
REMOVAL

Open two RF connectors and remove the Coaxial Cable from its cavity.



INSTALLATION

Assemble Coaxial Cable into its cavity and connect two RF connectors.



Replacement

4.16 Adhesive Receiver

Follow the 3.1 – 3.6 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Adhesive Receiver.

Carry out the Installation as described below.

Follow the 5.1 – 5.6 Reassembly instructions!

REMOVAL

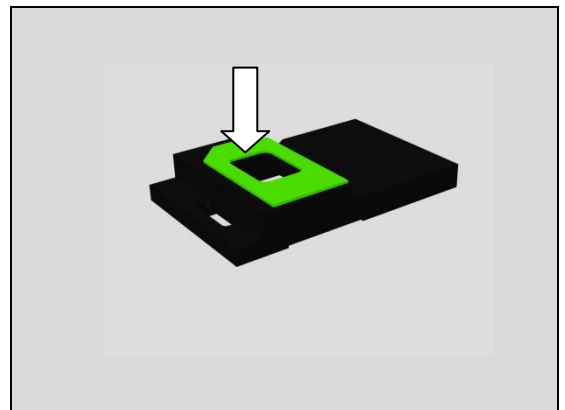
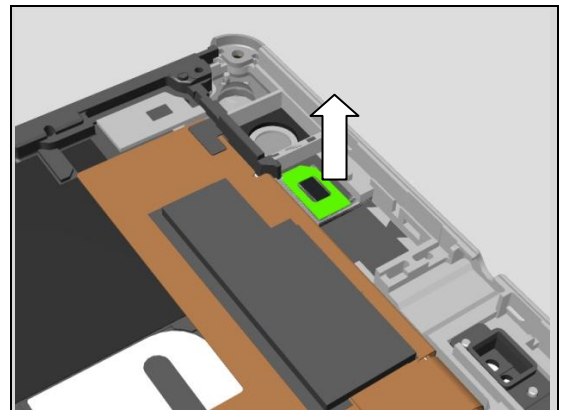
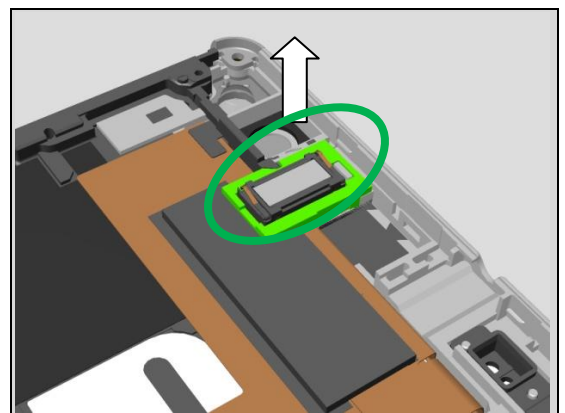
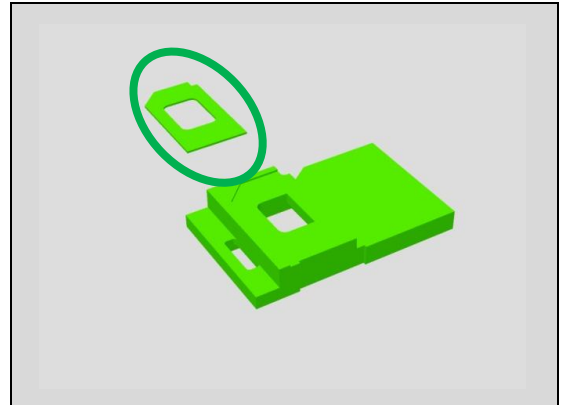
Remove the Receiver Holder together with Receiver from Front Cover Assy.

Clean surplus of Adhesive Receiver from its cavity and Receiver Holder Side.

Scrap! Cannot be reuse.

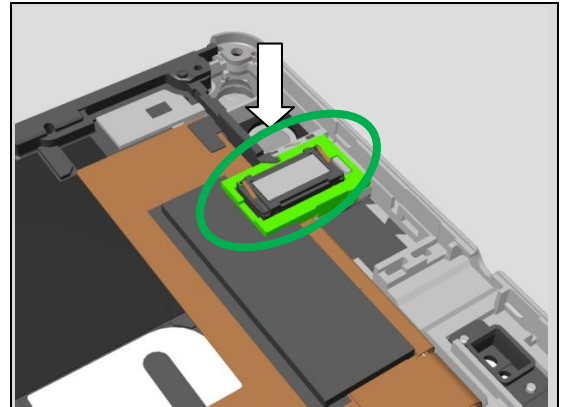
INSTALLATION

Place new Adhesive Receiver on Receiver Holder first.



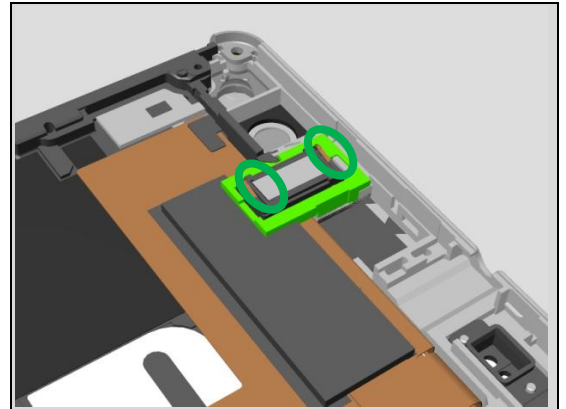
Replacement

Place the Receiver Holder Assy into its cavity on Front Cover Assy then.



Press the Receiver to secure the attachment.

Do not touch the pins of the Receiver!



Replacement

4.17 Vibrator & Adhesive Vibrator

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

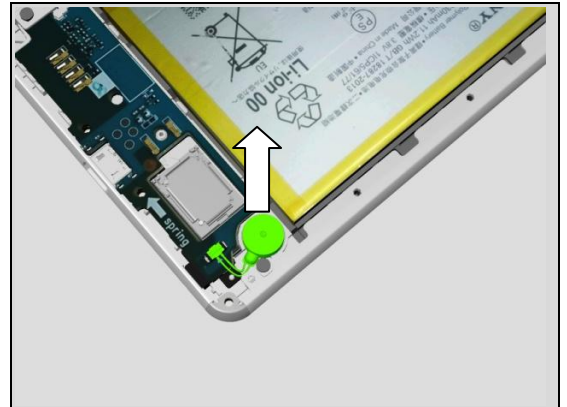
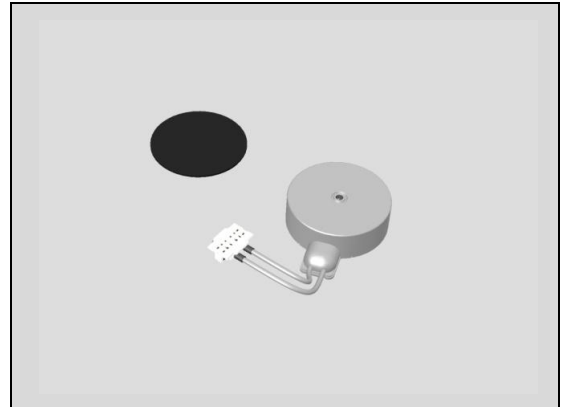
Prepare the new Vibrator & Adhesive Vibrator.

Carry out the Installation as described below.

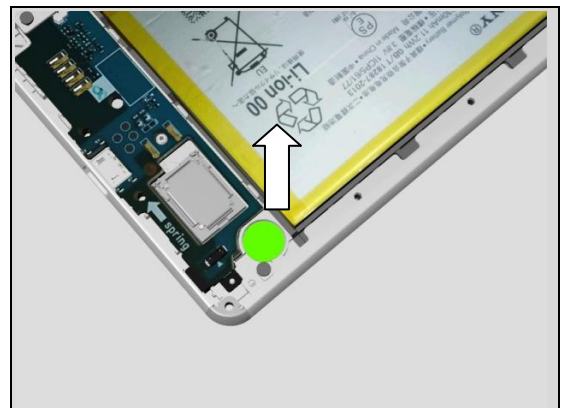
Follow the 5.5 – 5.6 Reassembly instructions!

REMOVAL

Open the Vibrator connector from Main PBA and remove the Vibrator.

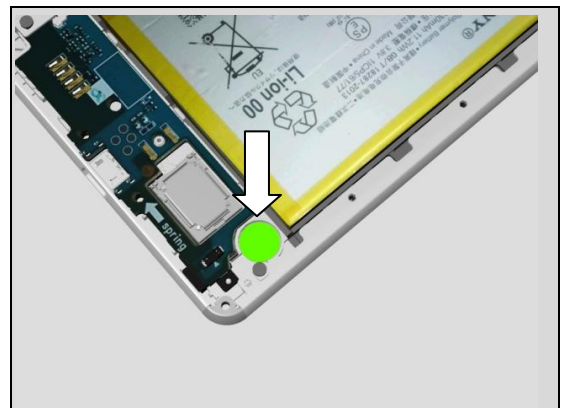


Remove the old surplus of Adhesive Vibrator from its cavity.



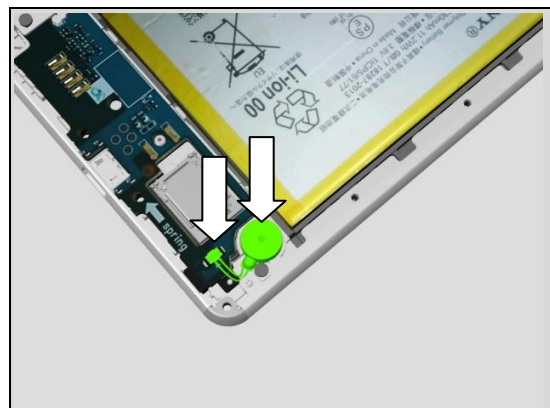
INSTALLATION

Assemble the new Adhesive Vibrator into its cavity first.



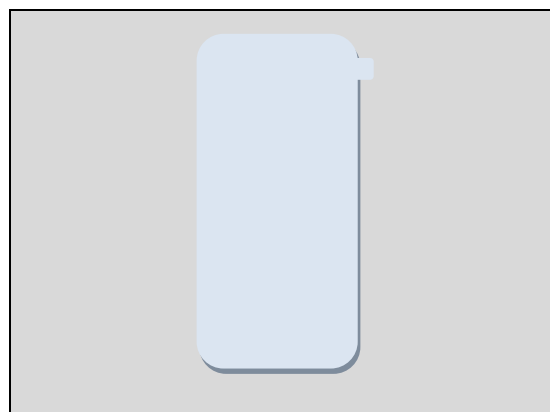
Replacement

Assemble the Vibrator into its cavity and snap its connector onto Main PBA then.

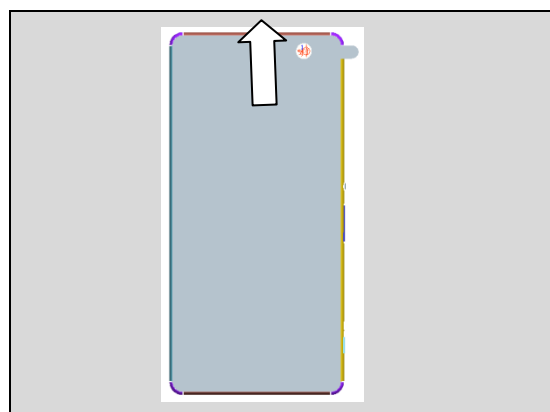


4.18 Protective Film

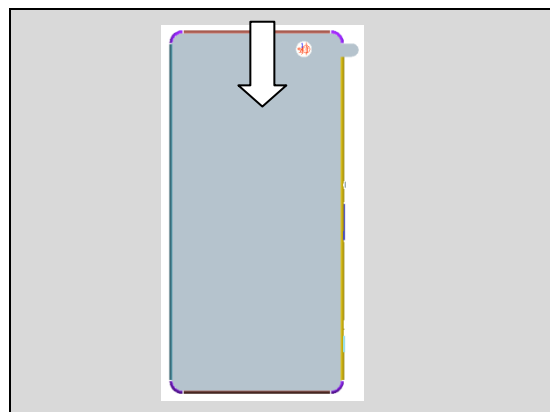
Carry out the Removal as described below.
Prepare the new Protective Film.
Carry out the Installation as described below.



Removal
Remove the Protective Film from Phone screen.



Installation
Assemble the new Protective Film on Phone screen.



Note: Ensure the Phone screen is clean!

Replacement

4.19 Front Camera

Follow the 3.1 – 3.6 Disassembly instructions!

Carry out the Removal as described below.

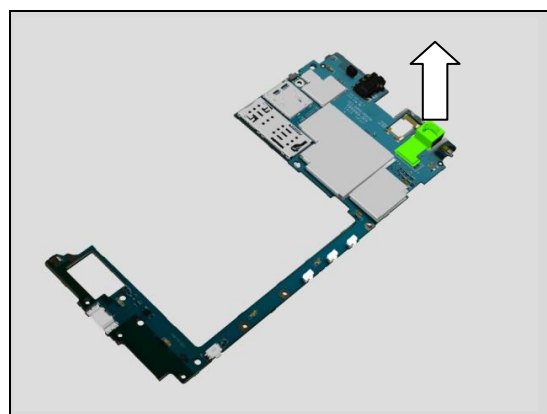
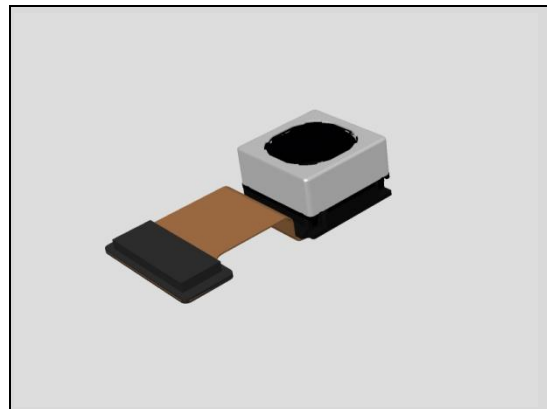
Prepare the new Front Camera.

Carry out the Installation as described below.

Follow the 5.1 – 5.6 Reassembly instructions!

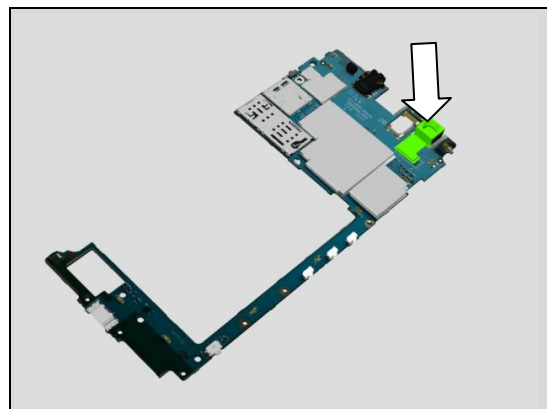
REMOVAL

Open the connector and remove the Front Camera.



INSTALLATION

Snap the BtB connector of Front Camera on Main PBA at its correct position.



Replacement

4.20 SIM SD Cover

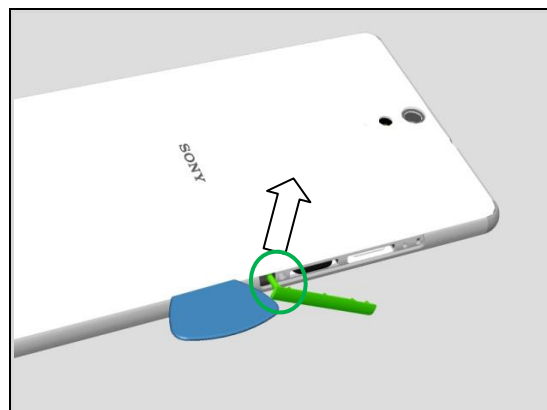
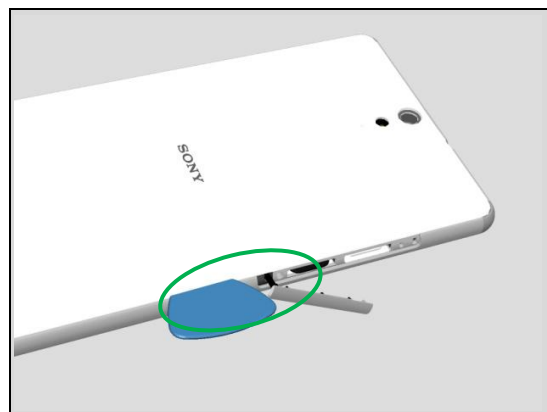
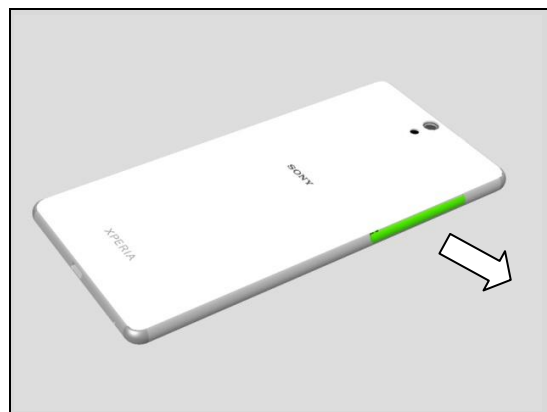
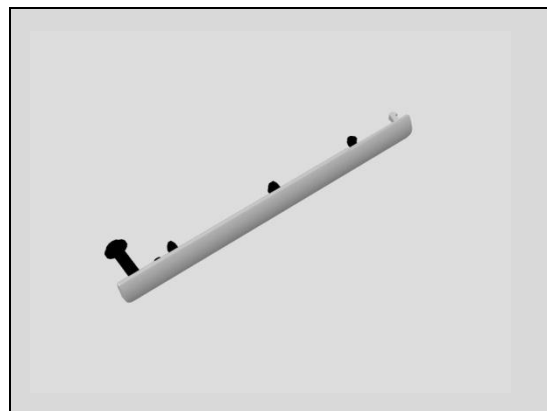
Carry out the Removal as described below.
Prepare the new Cap USB.
Carry out the Installation as described below.

REMOVAL

Open the SIM SD Cover.

Insert Guitar Pick at shown position to show some gap for the tail of SIM SD Cover.

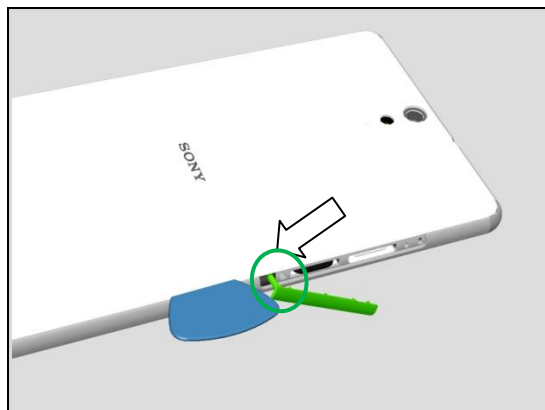
Pull the tail of SIM SD Cover out from the gap between Battery Cover Assy and Side Panel Assy as shown direction.



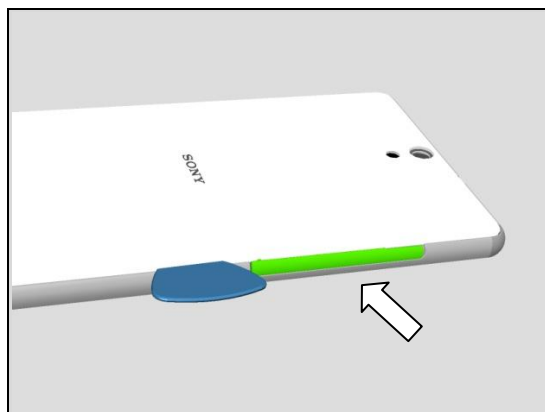
Replacement

INSTALLATION

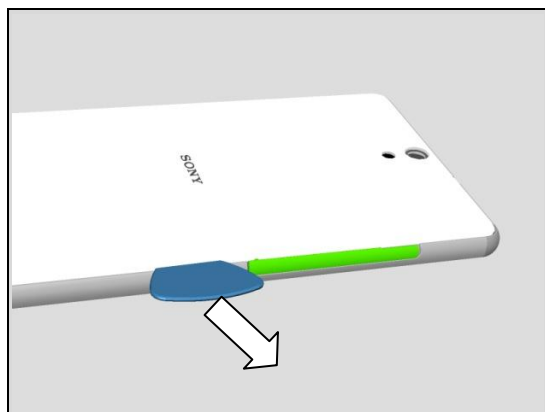
Insert the tail of new SIM SD Cover first into its hole from the gap between Battery Cover Assy and Side Panel Assy.



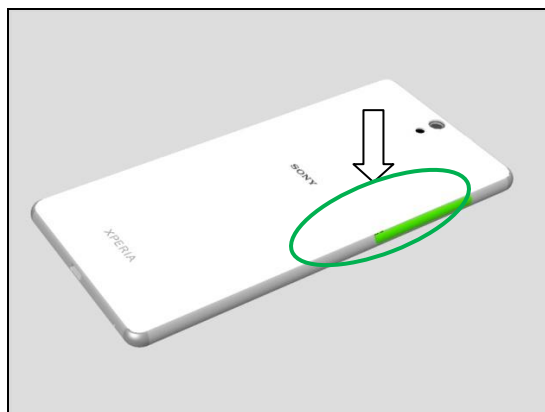
Push SIM SD Cover back into phone, Press to secure its position.



Remove Guitar Pick from the gap.



Press the gap area tightly by hand to secure the Battery Cover Assy's attachment and hooks in position.



Replacement

4.21 SD Side Panel Assy

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new SD Side Panel Assy.

Carry out the Installation as described below.

Follow the 5.5 – 5.6 Reassembly instructions!

Note: New SD Side Panel Assy already contains new Adhesive.

REMOVAL

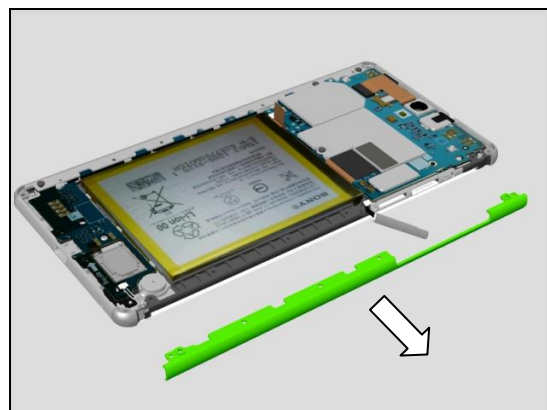
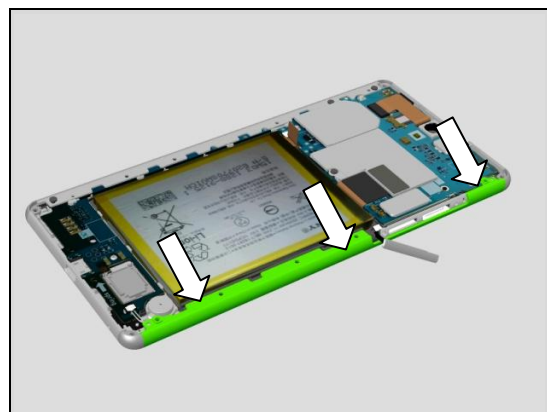
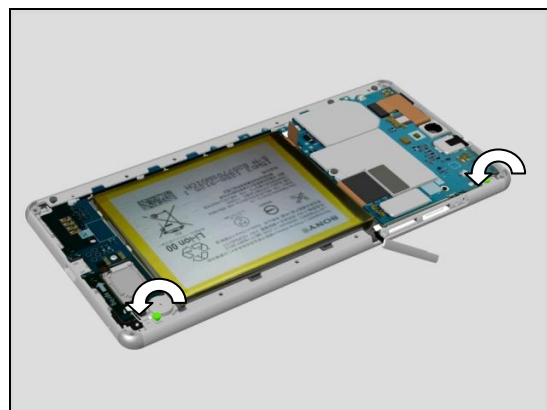
Remove the 2 units of Screw 1.6mm x 3mm_BLACK_T5 as shown by using a screwdriver with Bits (T5).

Scrap! Cannot be reused.

Push SD Side Panel Assy outside to detach its adhesive.

Remove the SD Side Panel Assy.

Scrap! Cannot be reused due to its always deformed after disassembly.

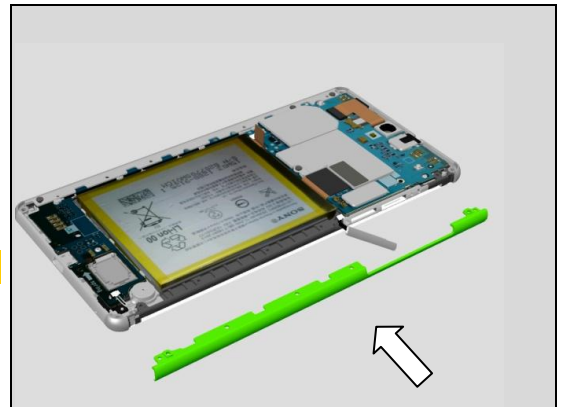


Replacement

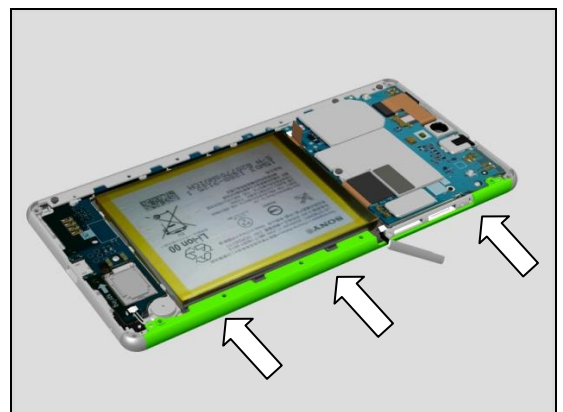
INSTALLATION

Assemble new SD Side Panel Assy onto phone as shown.

Note: make sure no surplus of adhesive on phone side.



Press the SD Side Panel Assy by hand first to ensure its correct position.



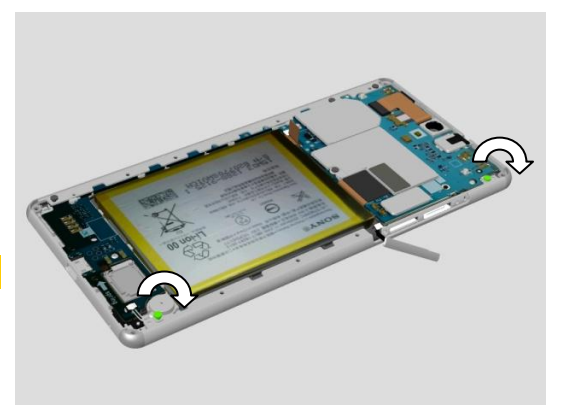
Put the units into Side Panel Press Fixture (1296-5662) and press both two side panels for 5 seconds.

Close the SIM SD Cover while pressing Side Panel Assy.



Apply 8 Ncm torque for these 2 units of Screw 1.6mm x 3mm_BLACK_T5 with Bits (T5).

Take new Screws!



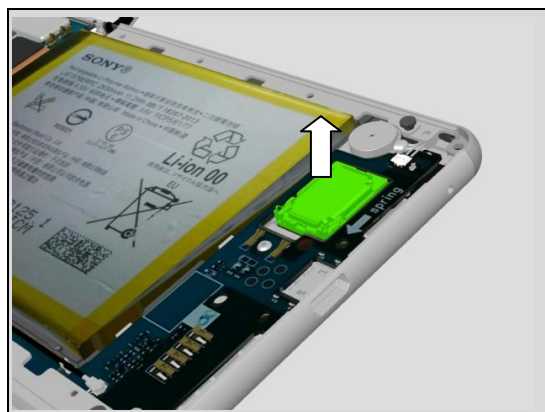
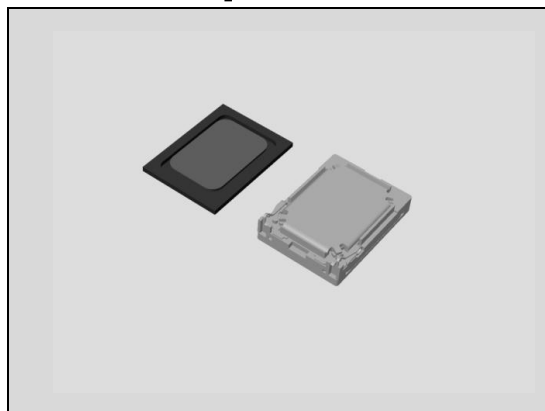
Replacement

4.22 Loudspeaker & Adhesive Mesh Speaker

Follow the 3.1 – 3.2 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Loudspeaker and Adhesive Mesh Speaker.
 Carry out the Installation as described below.
Follow the 5.5 – 5.6 Reassembly instructions!

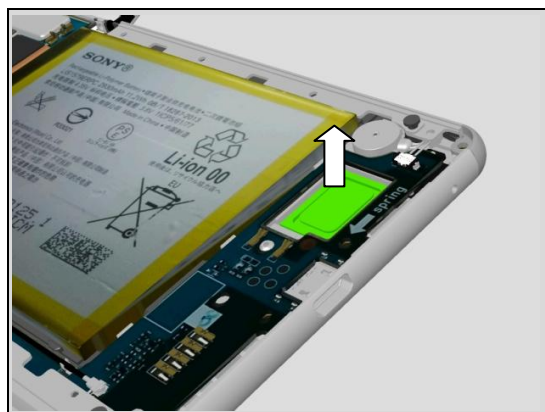
REMOVAL

Remove Loudspeaker from its cavity.



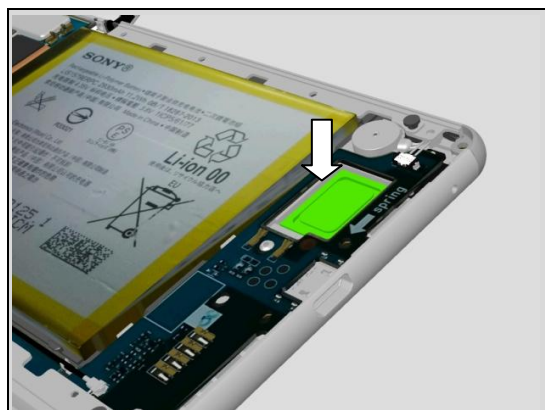
Remove the surplus of old Adhesive Mesh Speaker from its cavity and Loudspeaker side.

Scrap! Not to be reused!



INSTALLATION

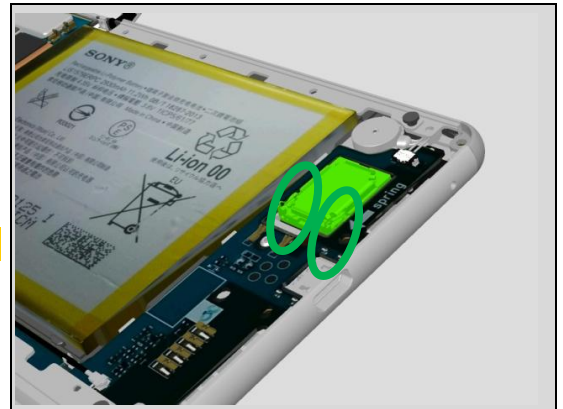
Place new Adhesive Mesh Speaker into its cavity.



Replacement:

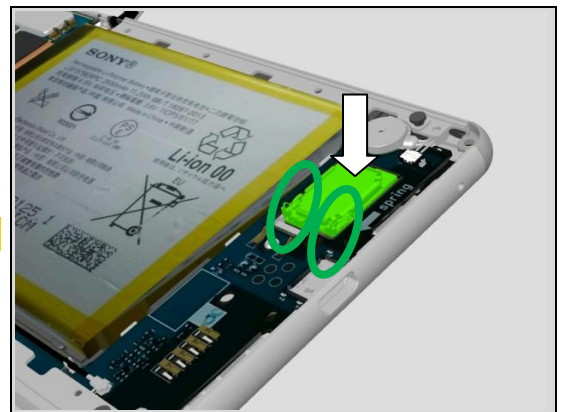
Place the new Loudspeaker into its cavity as shown in the picture.

Do not touch the pins of the Loudspeaker!



Press the Loudspeaker to secure the attachment.

Do not touch the pins of the Loudspeaker!



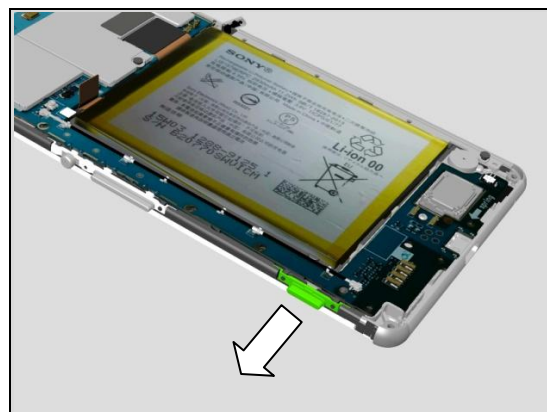
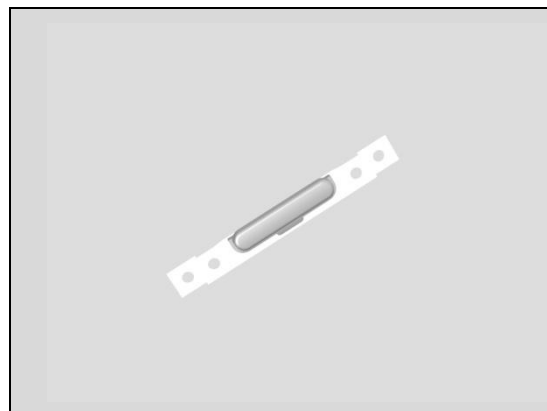
Replacement

4.23 Key Camera

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

REMOVAL

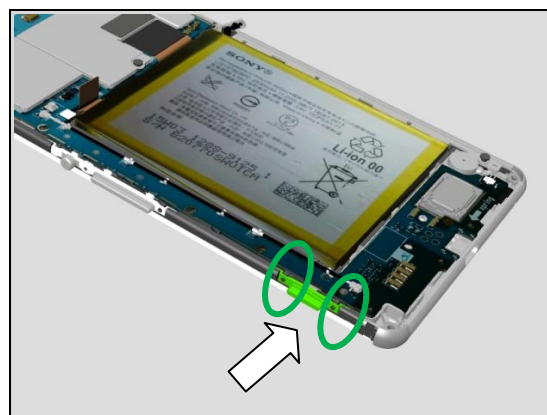
Remove the Key Camera from its position as shown.



INSTALLATION

Assemble new Key Camera on its correction position as shown.

Note: Pay more attention about its position pillar and cavity at two sides.



Replacement

4.24 Key Power Volume

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

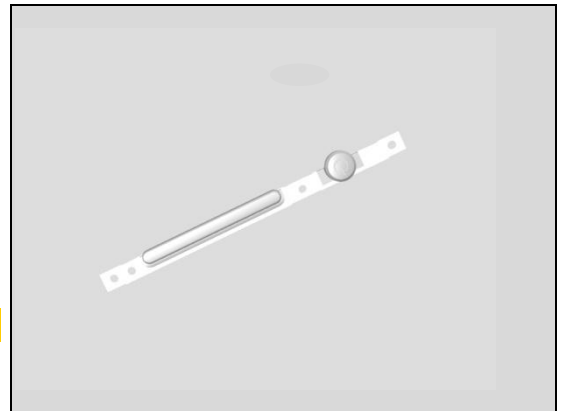
Prepare the new Charge FPC & Adhesive Charge FPC.

Carry out the Installation as described below.

Follow 4.31 Installation instructions.

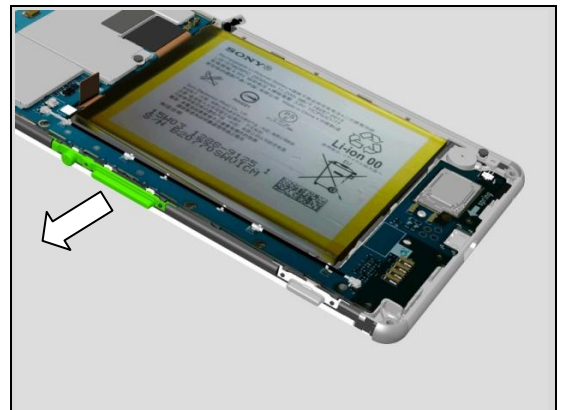
Follow the 5.5 – 5.6 Reassembly instructions!

Visual Inspektion of the Charge FPC.



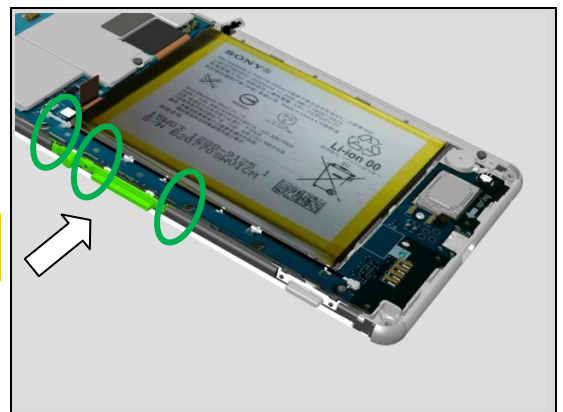
REMOVAL

Remove the Key Power Volume from its position as shown.



Assemble new Key Power Volume on its correction position as shown.

Note: Pay more attention about its position pillar and cavity at two sides.



Replacement

4.25 Liquid Intrusion Label

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Liquid Intrusion Label.

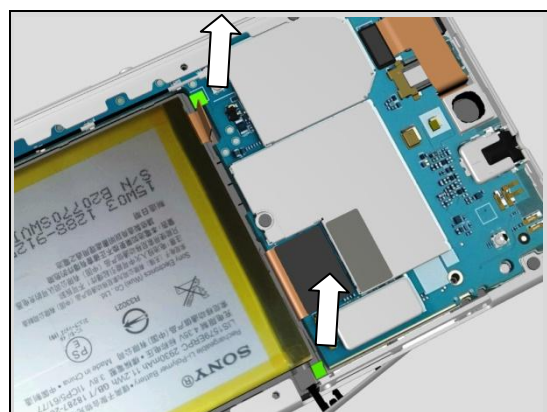
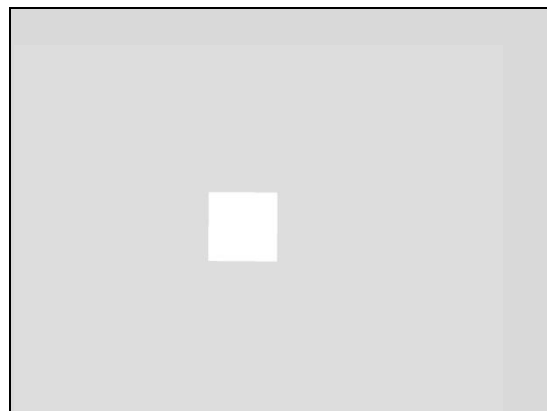
Carry out the Installation as described below.

Follow the 5.5 – 5.6 Reassembly instructions!

REMOVAL

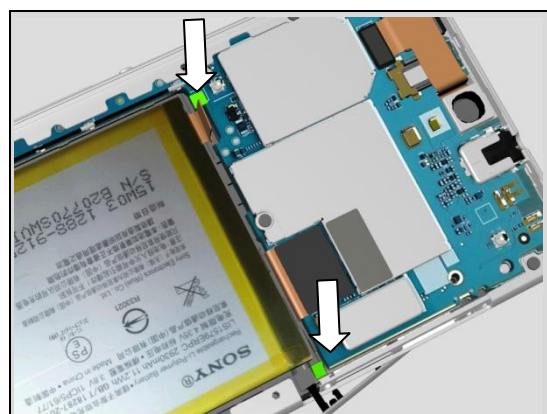
Remove the Liquid Intrusion Label as shown.

There are two pieces of Liquid Intrusion Label.



INSTALLATION

Place new Liquid Intrusion Label as shown.



Replacement

4.26 Receiver Holder

Follow the 3.1 – 3.6 Disassembly instructions!

Carry out the Removal as described below.

Prepare the *new Receiver Holder*.

Carry out the Installation as described below.

Follow the 5.1 – 5.6 Reassembly instructions!

Note: new Receiver Holder already contains new Adhesive Receiver and Adhesive Receiver Holder.

REMOVAL

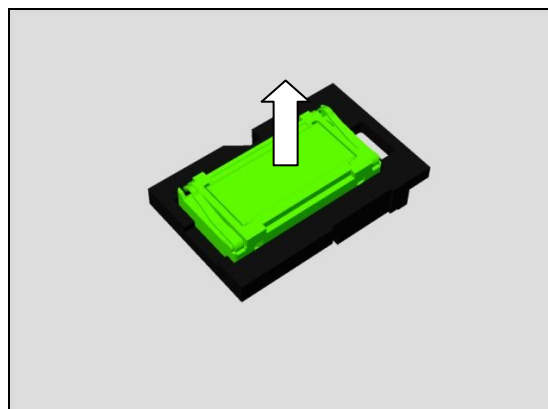
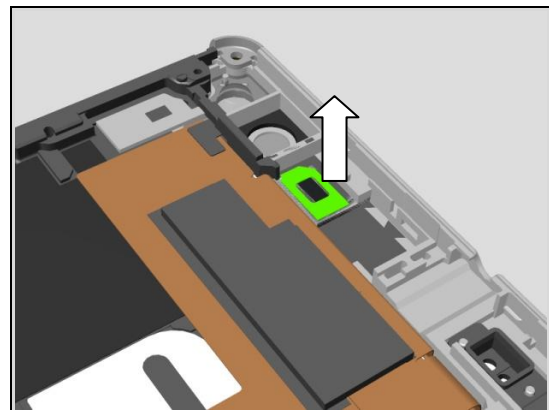
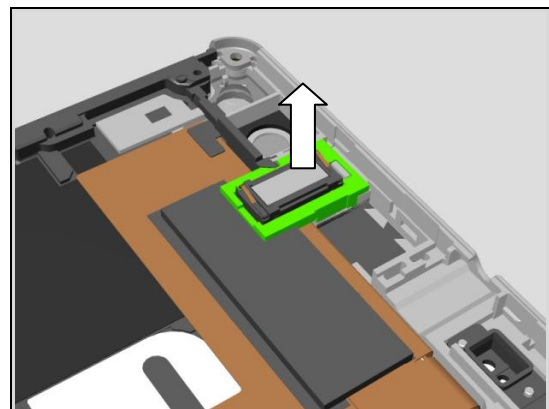
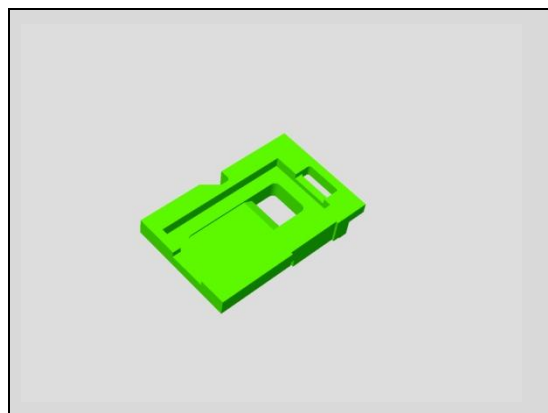
Remove the Receiver Holder together with Receiver from Front Cover Assy.

Clean surplus of Adhesive Receiver from its cavity and Receiver Holder Side.

Scrap! Cannot be reuse.

Remove the Receiver from Receiver Holder.

If Receiver is damaged after disassembly, then it cannot be reused.



Replacement

INSTALLATION

Prepare the *new Receiver Holder*.

Remove the protection tapes of Adhesive Receiver Holder and Adhesive Receiver first.

Note: new Receiver Holder already contains new Adhesive Receiver Holder and Adhesive Receiver.

Assemble the Receiver into its cavity on Receiver Holder first.

Ensure the protection tape of Adhesive Receiver Holder is already removed.

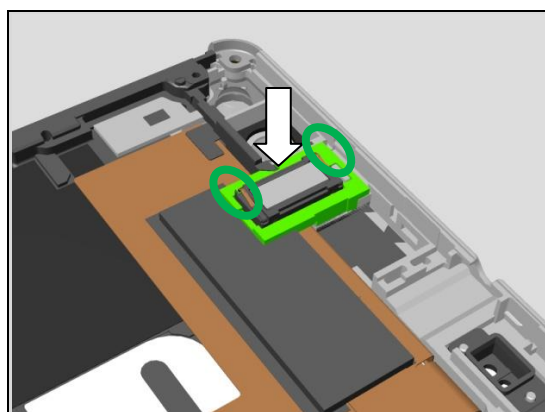
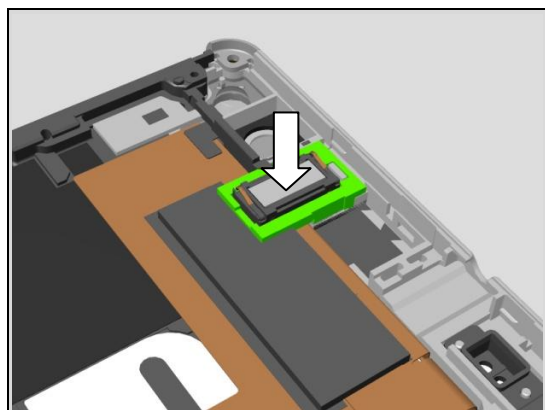
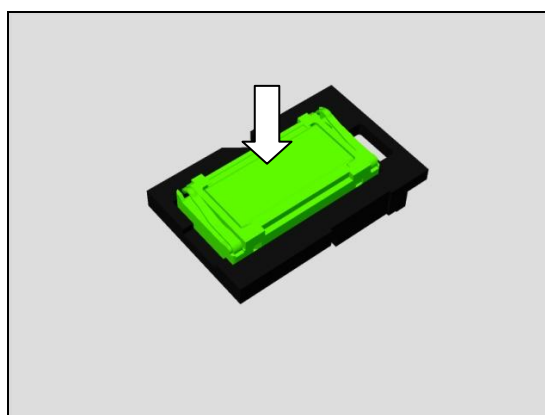
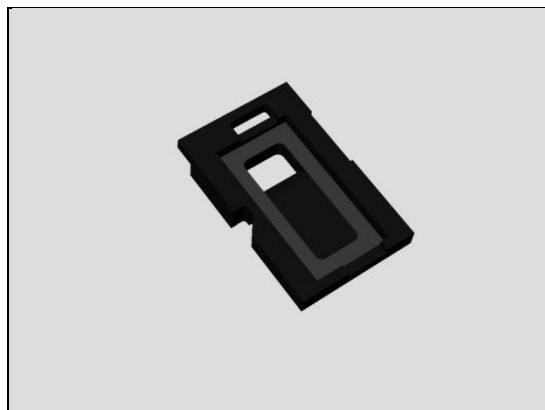
Do not touch the pins of the Receiver!

Assemble the Receiver Holder together with Receiver on Front Cover Assy.

Ensure the protection tape of Adhesive Receiver is already removed.

Press the Receiver to secure the attachment.

Do not touch the pins of the Receiver!



Replacement

4.27 CU Label

Carry out the Removal as described below.
Prepare the new CU Label.
Carry out the Installation as described below.

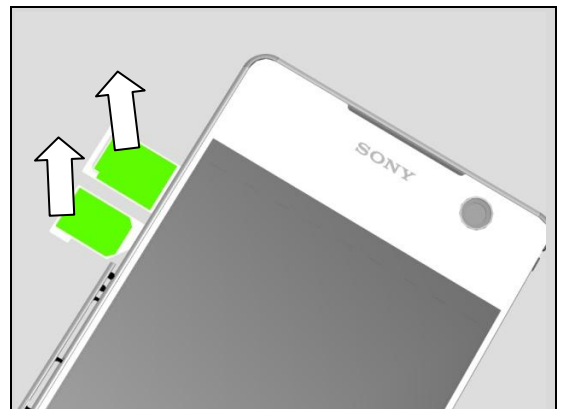
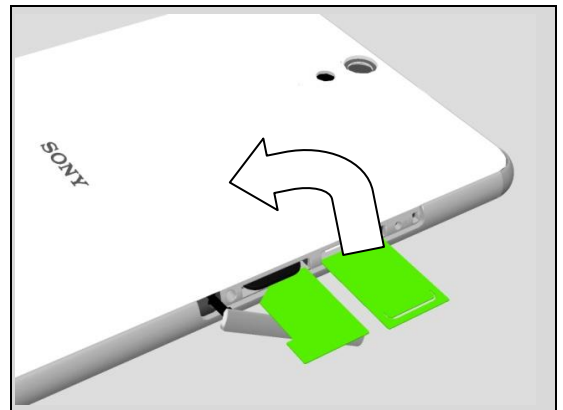
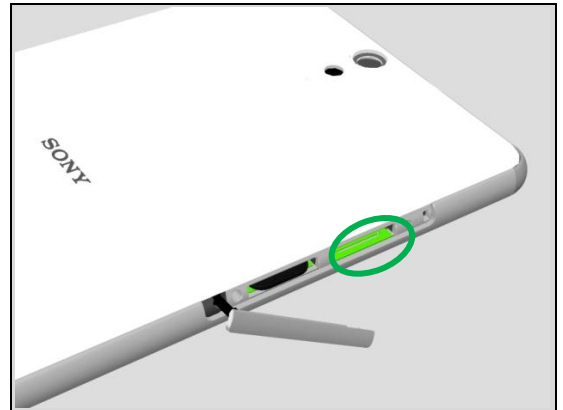
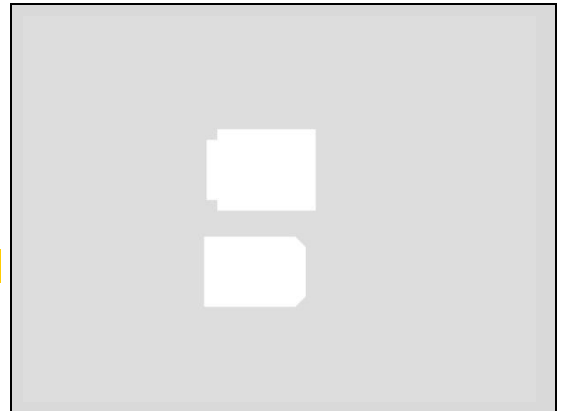
One label contains two pieces as shown.

REMOVAL

Open the SIM SD Cover, Pull out the CU Label Tray from shown position.

Turn around Phone upside down; the CU label is attached at back side of CU Label tray.

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



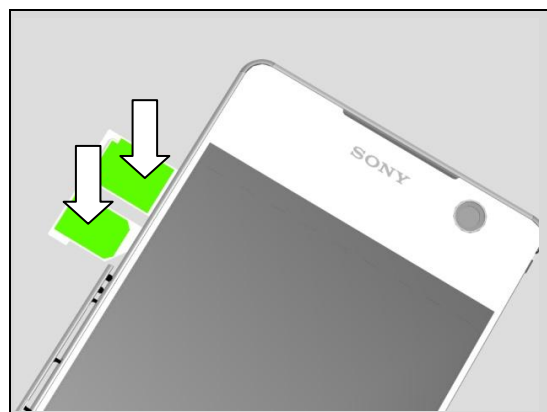
Replacement

INSTALLATION

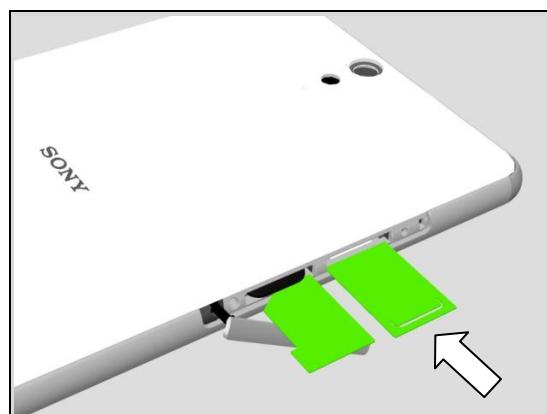
Check that the proper label format is loaded in the Zebra printer and write a new Label by using the 'Label Print' software.

Place and align a new CU Label in the correct position.
Press with a finger to secure the attachment.

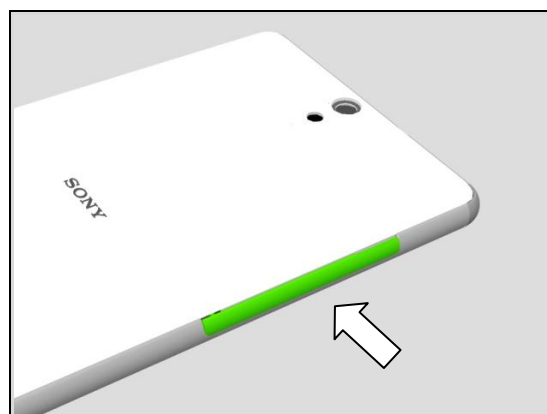
One label only is allowed.



Turn around Phone upside down; Push the CU Label tray back into Phone.



Close the SIM SD Cover.



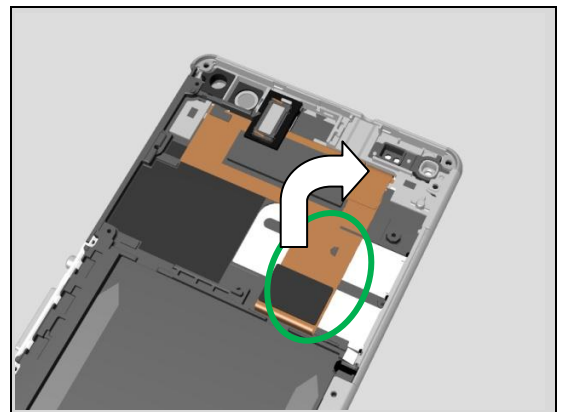
Replacement

4.28 CU Label tray

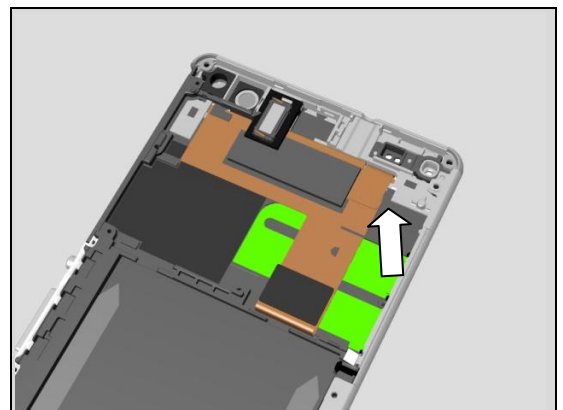
Follow the 3.1 – 3.6 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new Label tray.
 Carry out the Installation as described below.
Follow the 4.27 Installation instructions!
 Follow the 5.1 – 5.6 Reassembly instructions!

REMOVAL

Lift up the TP/LCM FPC as shown from Front Cover Assy.

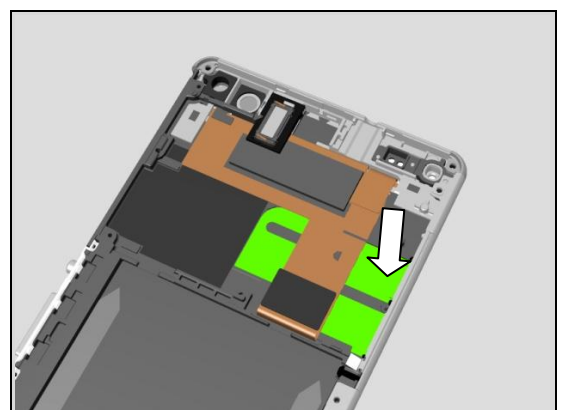


Remove the CU Label tray as shown direction from Front Cover Assy.



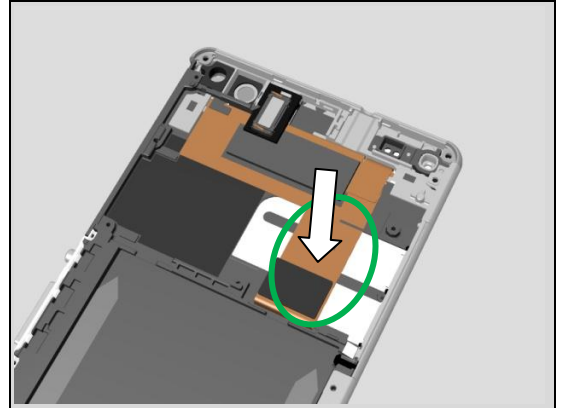
INSTALLATION

Assemble the CU Label tray according to its outline and position pillar on Front Cover Assy



Replacement

Put down the TP/LCM FPC as shown on Front Cover Assy, press it to secure its attachment.



Replacement

4.29 Board Swap - Replacement

Follow the 3.1 – 3.6 Disassembly instructions!

Follow the 4.19, 4.15 Removal instructions!

Replace the Swap Board.

Reuse the Main Camera and the Camera Chat.

Follow the 4.19 4.15 Installation instructions!

Follow the 5.1 – 5.6 Reassembly instructions!



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

Please DO NOT move the unit during the start up until "Select Language" menu is shown on the display!

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

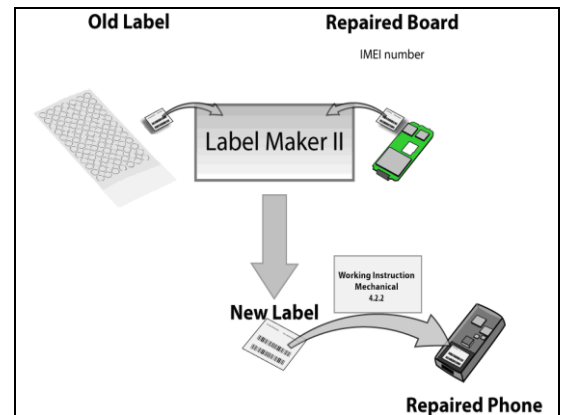
Follow the calibrations in Trouble Shooting Application 1289-2983 – mechanical

Replacement

4.30 Board Swap – Change Label

CHANGE LABEL

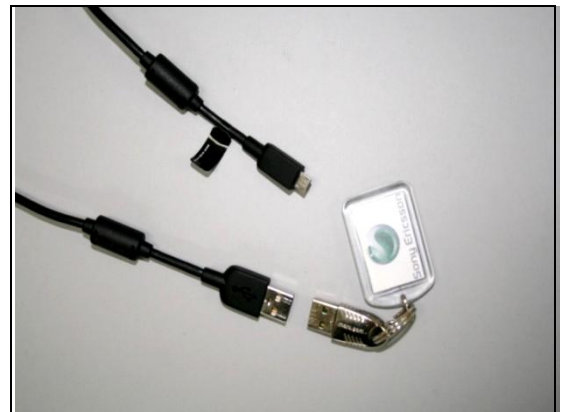
Follow the instructions in the Generic Repair Manual –
Build swap for change of label.



4.31 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

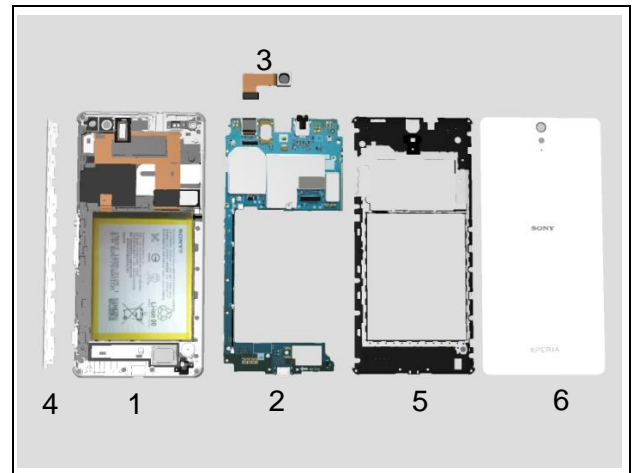
Follow the instructions in the Generic Repair Manual –
Build swap for customization of the software.



5 Reassembly

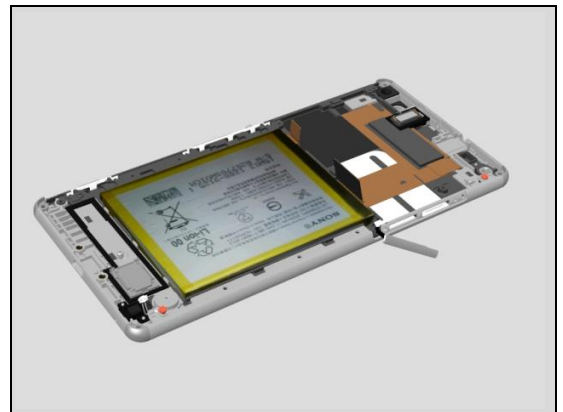
The reassembly is done in the following order:

1. Front Cover Assy
2. Main PBA
3. Main Camera
4. Keys Side Panel Assy
5. Rear Cover Assy
6. Battery Cover Assy



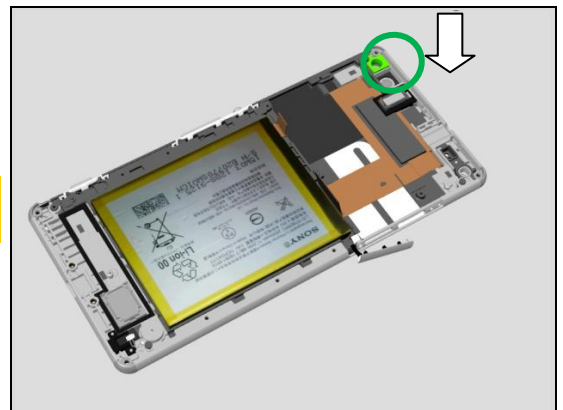
5.1 Front Cover Assy

Prepare the Front Cover Assy.



Check the Sponge Front LED on Front Cover Assy.

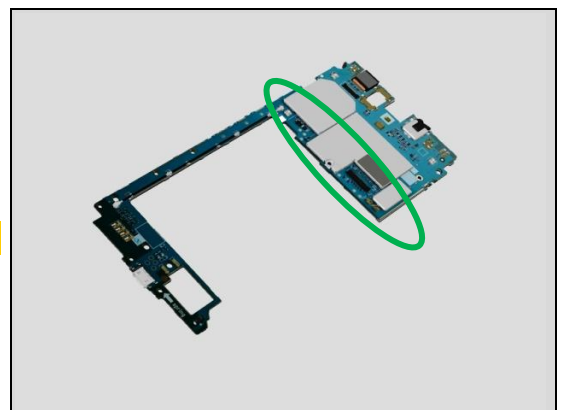
If the Sponge Front LED is damaged, replace a new Sponge Front LED then.



5.2 Main PBA

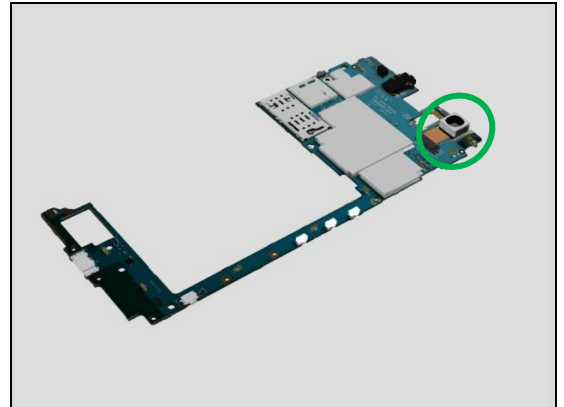
Prepare the Main PBA.

Take the middle hard side of Main PBA as shown.

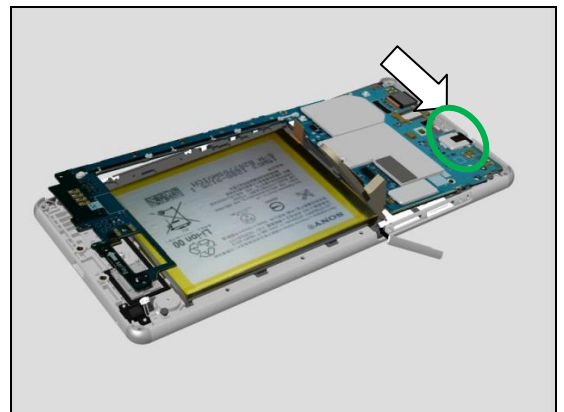


Reassembly

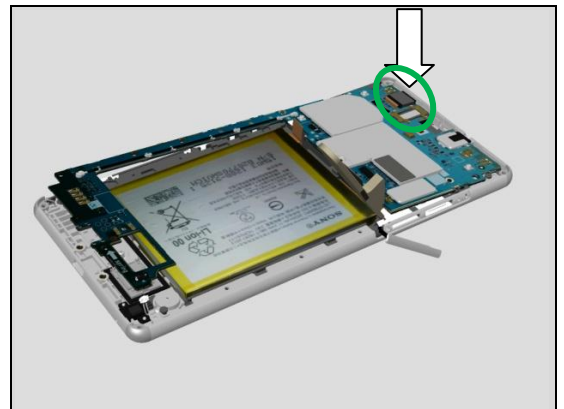
Check the Front Camera is well assembled on Main PBA.



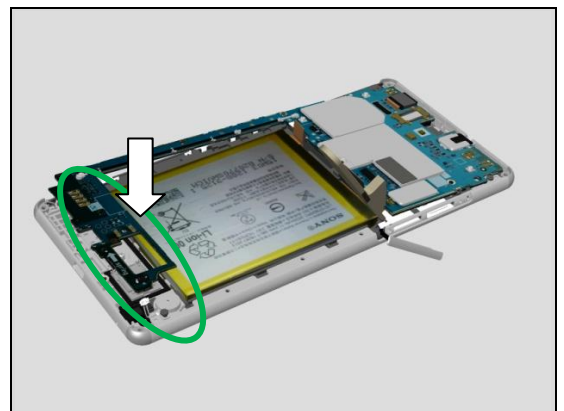
Insert Audio Jack connector into Front Cover Assy first.



Put Front Camera into its cavity then

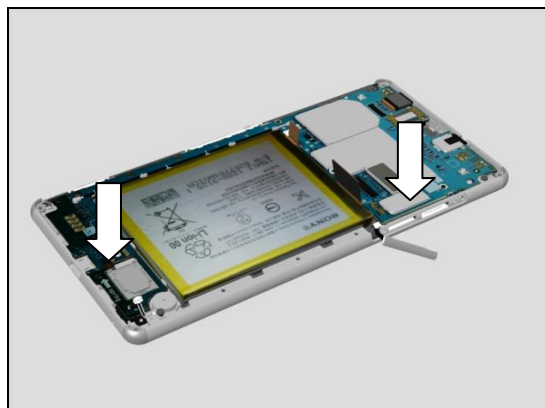


Put down the left slim side of Main PBA finally.

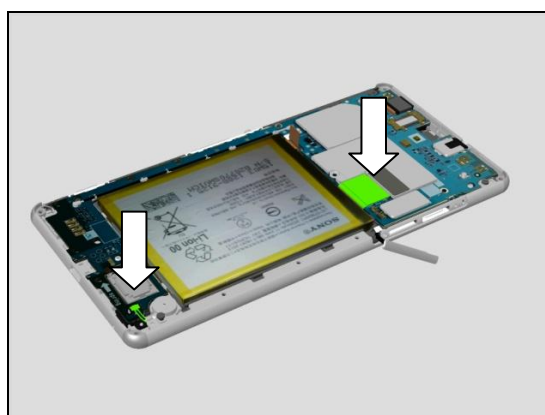


Reassembly

Press Main PBA as shown to lock its hooks.

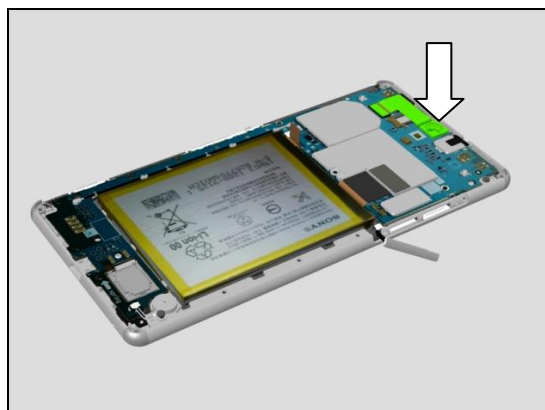


Assemble these two Connectors of Vibrator and LCM.

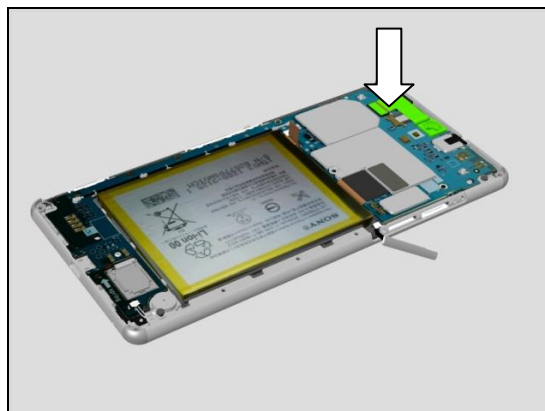


5.3 Main Camera

Place the Main Camera into its cavity on Front Cover Assy.



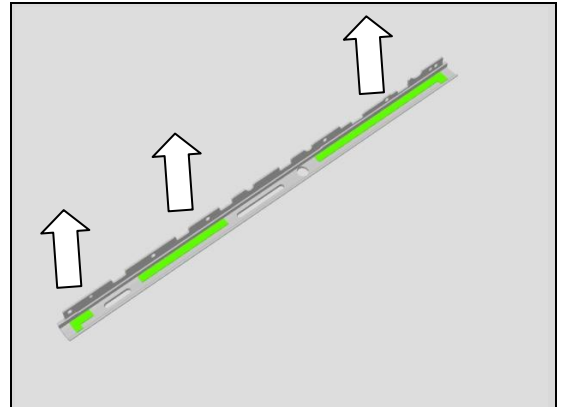
Assemble its BtB connector onto Main PBA



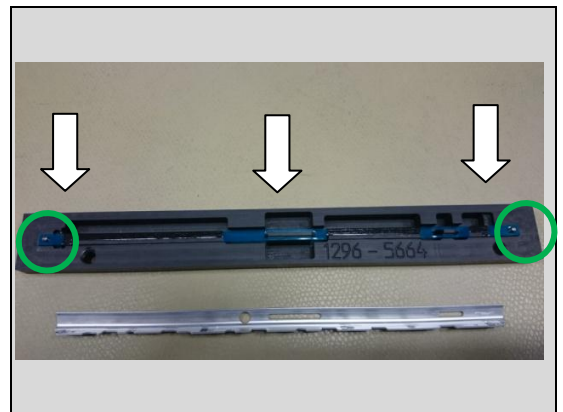
Reassembly

5.4 Keys Side Panel Assy

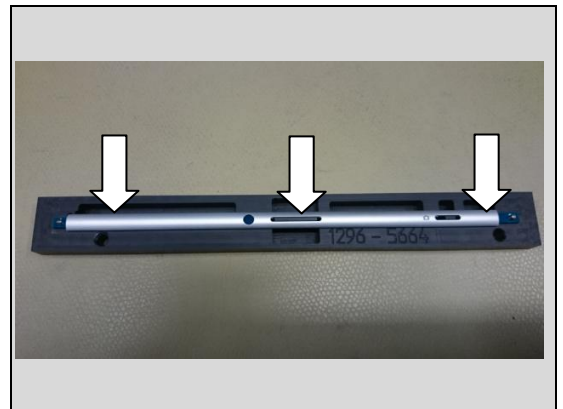
Remove the old surplus of Adhesive Keys Side Panel.



Put new Adhesive Keys Side Panel on Keys Side Panel Adhesive Alignment Tool (1296-5664).



Put Keys Side Panel on the Tool then and press it carefully by hand.



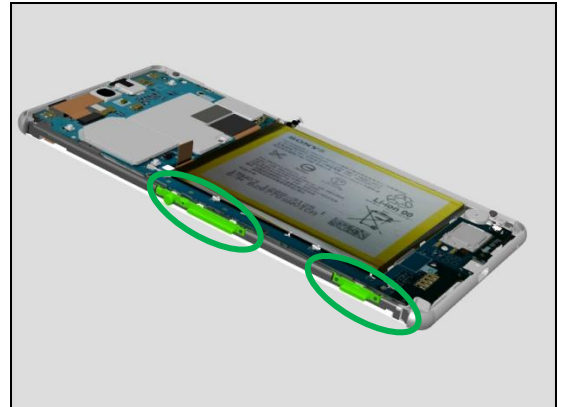
The new Keys Side Panel Assy with new Adhesive Keys Side Panel.

Remove the adhesive protection film before the new part is used.

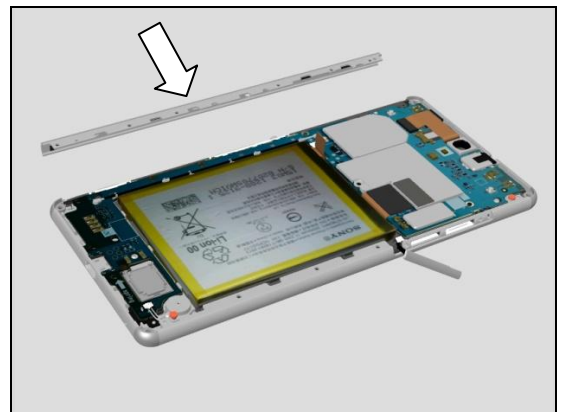


Reassembly

Check the Key Camera and Key Power Volume at their correct position.

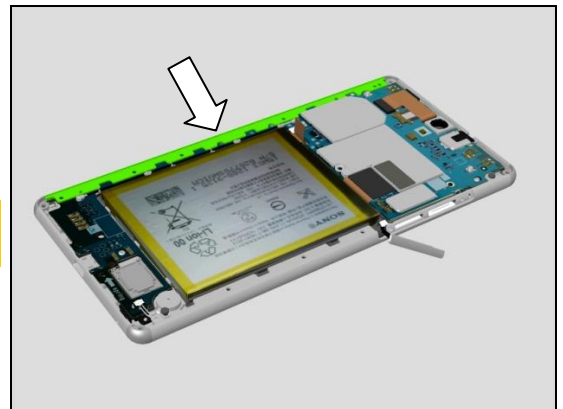


Assemble the new Keys Side Panel Assy carefully.



Press it carefully by hand first to ensure its correct position.

Check Key Camera and Key Power Volume if they work well.



Put the units into Side Panel Press Fixture (1296-5662).

**Close the SIM SD Cover while pressing Side Panel Assy.
The unit should be placed with LCD down; the orientation of the unit does not matter.**



Reassembly

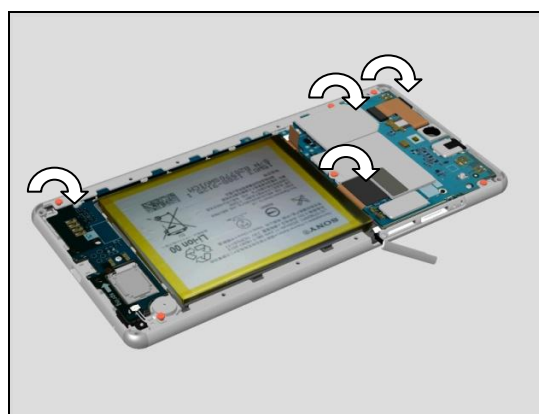
Lift the handle and keep 5 seconds to press the side panels.

Close the SIM SD Cover while pressing Side Panel Assy.



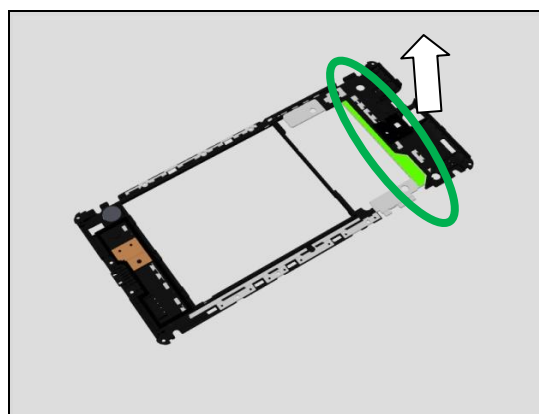
Apply 8 Ncm torque for these four units of Screw 1.6mm x 3mm_BLACK_T5 with Bits (T5) for Keys Side Panel Assy (3 units) and Main PBA (1 unit).

Take new Screws!

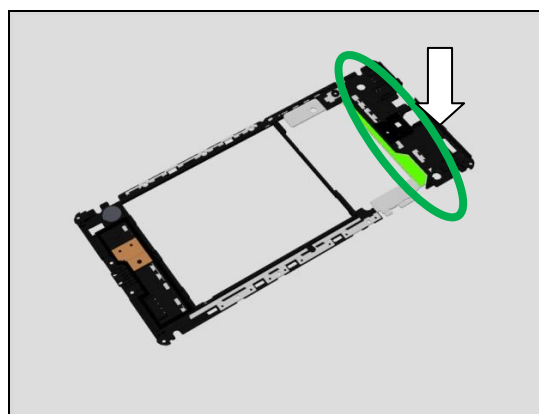


5.5 Rear Cover Assy

Remove the old Adhesive Rear Cover.

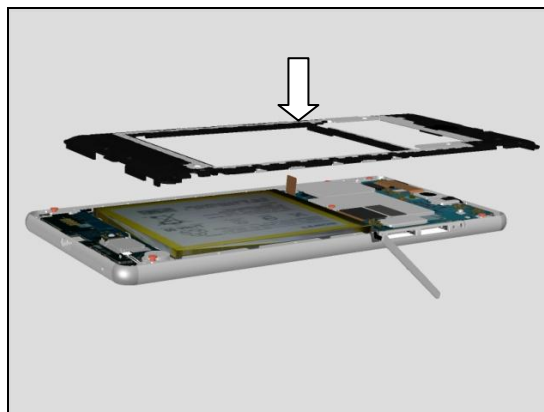


Place new Adhesive Rear Cover on Rear Cover Assy.

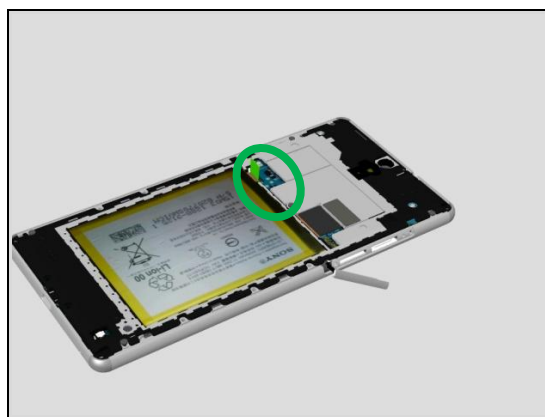


Reassembly

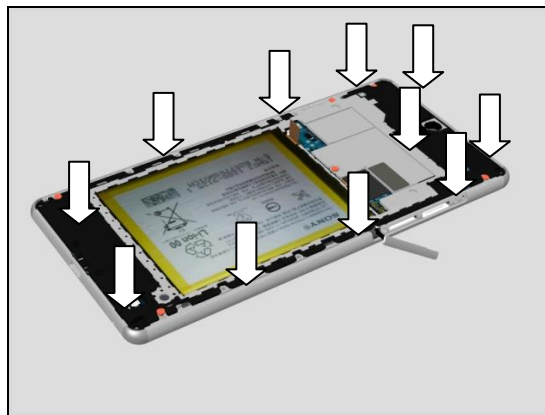
Assemble Rear Cover Assy on core unit.



The Battery FPC is above Rear Cover Assy.



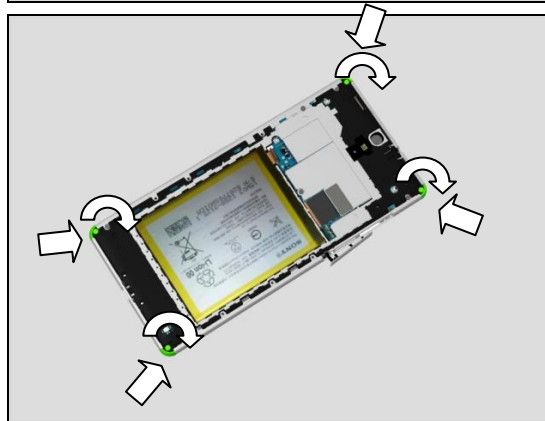
Press Rear Cover Assy four sides around and area of Adhesive Rear Cover to secure its hooks and attachment..



Press four corners inside by hand tightly while assembling these four corner screws.

Apply 8 Ncm torque for these four units of Screw 1.6mm x 3mm_BLACK_T5 with Bits (T5).

Take new Screws!

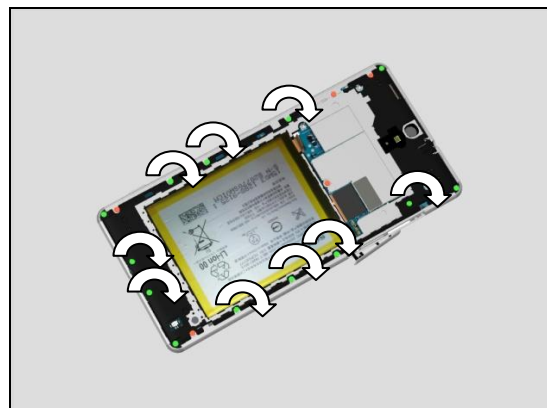


Reassembly

Apply 8 Ncm torque for these 9 units of Screw 1.6mm x 3mm_BLACK_T5 with Bits (T5).

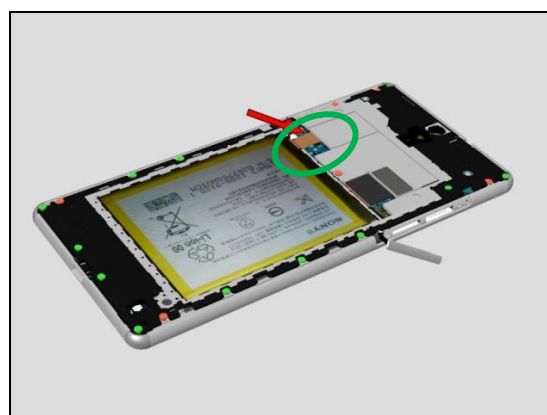
Take new Screws!

All 19 units of screws are assembled on Phone till this step(13 units of green screws and 6 units of red screws).



Assemble the BtB connector of Battery on Main PBA.

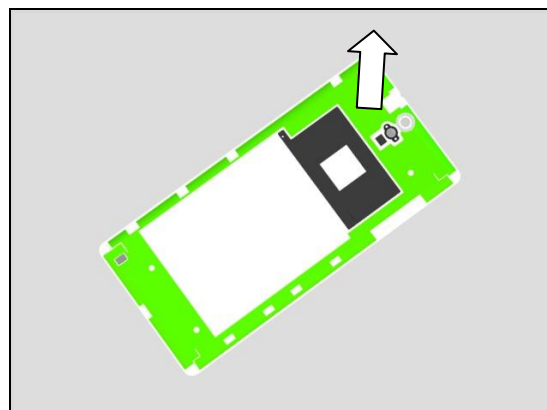
Battery FPC is above Rear Cover Assy.



5.6 Battery Cover Assy

Remove the surplus of old Adhesive Battery Cover.
Clean the edges of the Battery Cover carefully with alcohol before the new Adhesive Battery Cover is mounted.

Use Isopropyl Alcohol - 99 % for clean around the edges.



Place the new Adhesive Battery Cover in the Battery Cover Adhesive Alignment Fixture(1296-5661) at correct Position first.



Reassembly

Place Battery Cover on Battery Cover Adhesive Alignment Fixture (1296-5661) then.

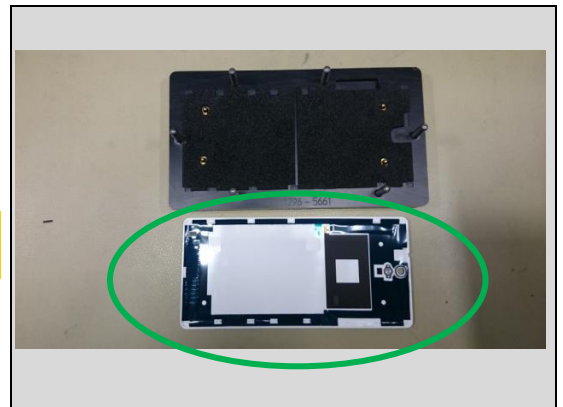


Press Battery Cover by hand to secure the new Adhesive Battery Cover attached on Battery Cover.



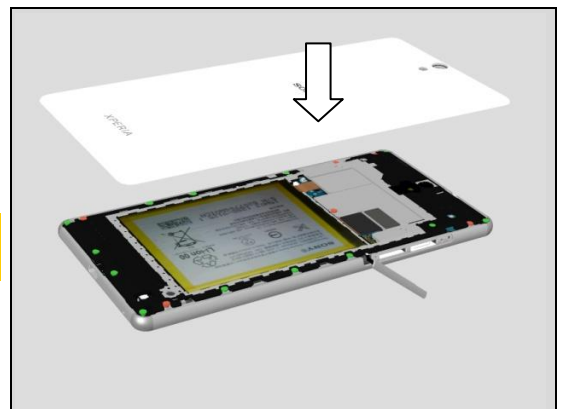
The New Battery Cover Assy with new Adhesive Battery Cover is ready to be used.

Remove the adhesive protection film before new part is used.



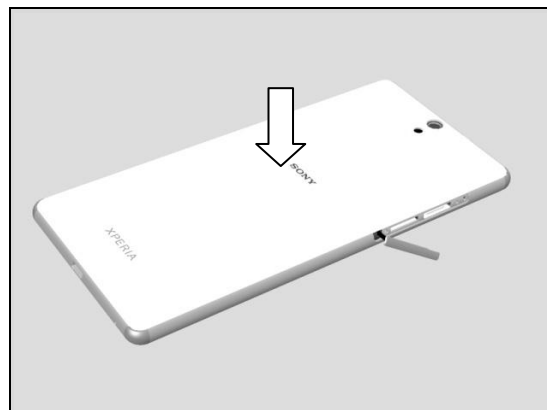
Place the Battery Cover Assy on Core Unit at its correct position.

Clean the surplus of Adhesive Battery Cover on Rear Cover Assy if has before assembly Battery Cover Assy.



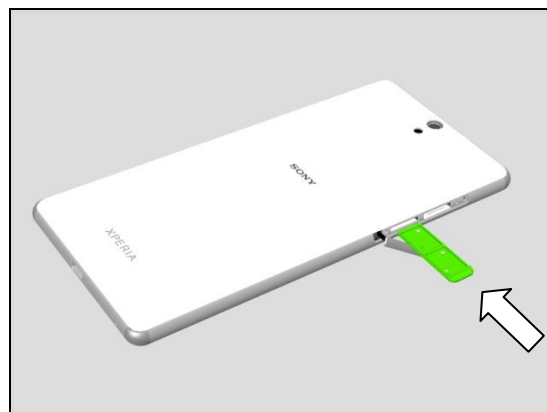
Reassembly

Press with fingers around to secure its attachment and hooks.



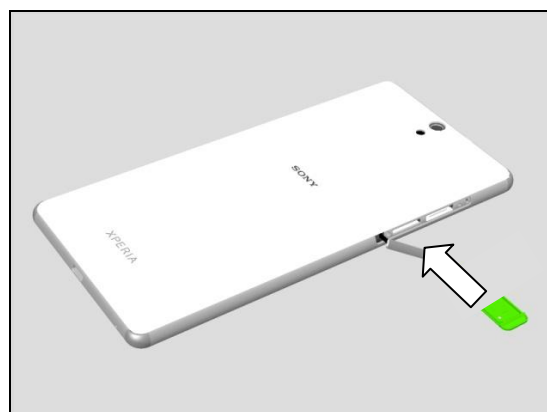
Assemble the Tray Dual Nano SIM.

Note: E5533, E5563 have two Nano SIM Card.

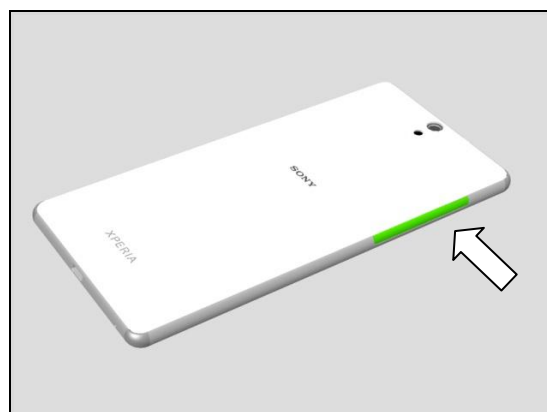


Assemble the Tray Single Nano SIM.

Note: E5506, E5553 have only one SIM Card.



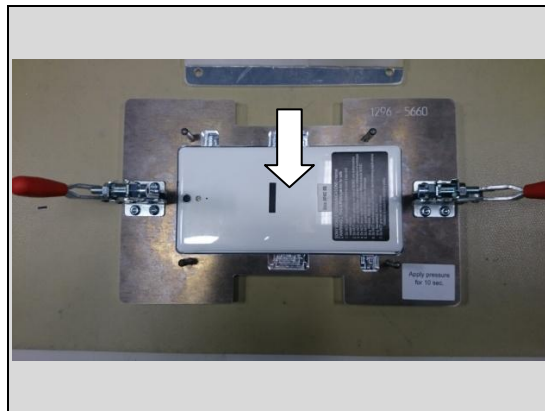
Assemble the SIM SD Cover.



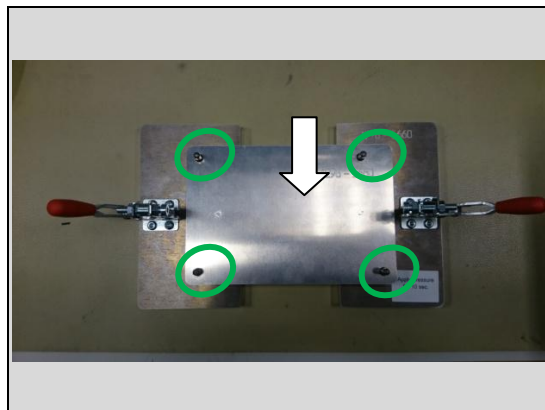
Reassembly

Place the phone in Bottom Part of Battery Cover Press Fixture (1296-5660).

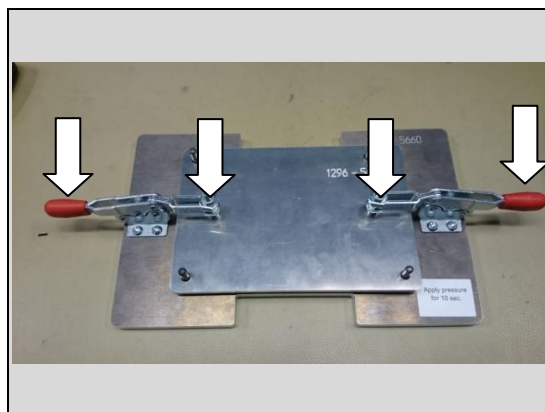
The LCD should be place down the orientation of the phone does not matter.



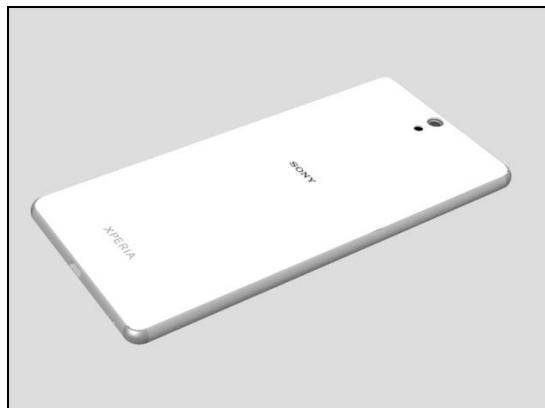
Place the Top Part of Press Fixture on the Phone then.



Press the handles and keep 10 seconds to press the Battery Cover Assy.



The phone is shown after pressing.



6 Revision History

Rev.	Date	Changes / Comments
1	2015-07-22	Initial release
2	2015-08-10	Update text error of "E5503" to "E5506" on Page 7 and Page 55.