



Sony Ericsson

Working Instructions

- mechanical -



XPERIA X10 Mini Pro
U20i, U20a



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



1 Exterior Views

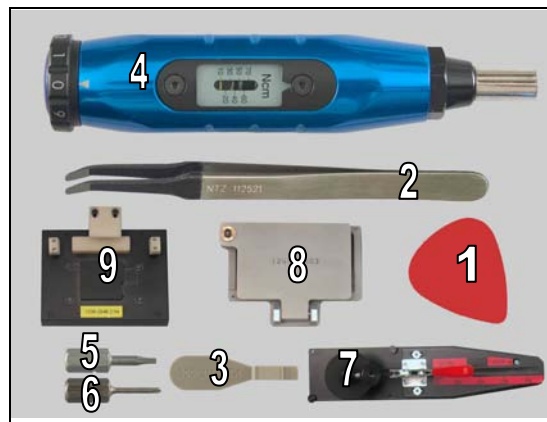
1.1 U20i, U20a



2 Tools

SPECIAL TOOLS

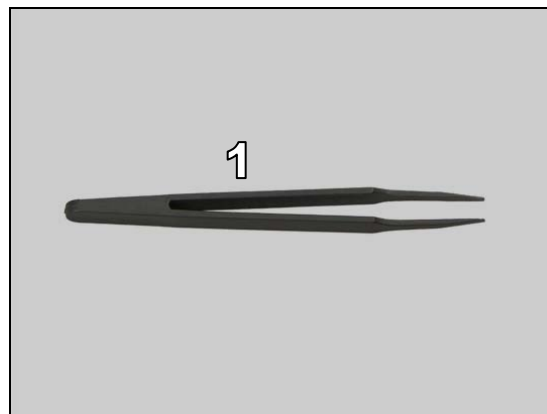
1. Guitar Pick
2. Flex Film Assembly Tool
3. Front Opening Tool
4. Torque Screwdriver
5. Bit(T5)
6. Bit(JCIS)
7. Pressure Tool
8. Pressure Fixture
9. Front Cover Fixture



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

STANDARD TOOLS

1. Tweezers



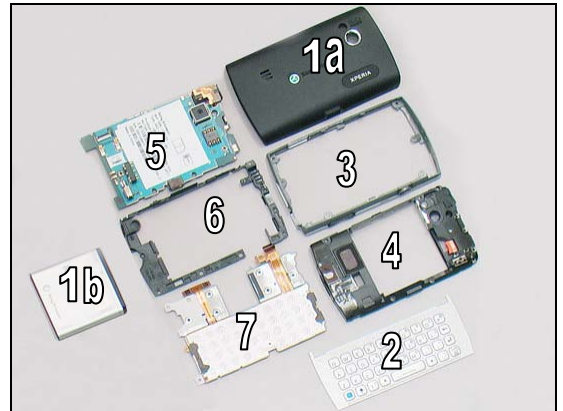


3 Disassembly

3.1 Lower Unit

The disassembly is done in the following order:

1. Battery Cover (a) & Battery (b)
2. Keyboard
3. Base Cover Middle Deco belt Assy
4. Bottom Carrier Frame Assy
5. PBA Assy
6. Carrier Plastic Qwerty Support Assembly
7. Carrier Metal Qwerty Support Assy



3.1.1 Battery Cover

Push upwards to unsnap the hooks of the Battery Cover from this side as shown.

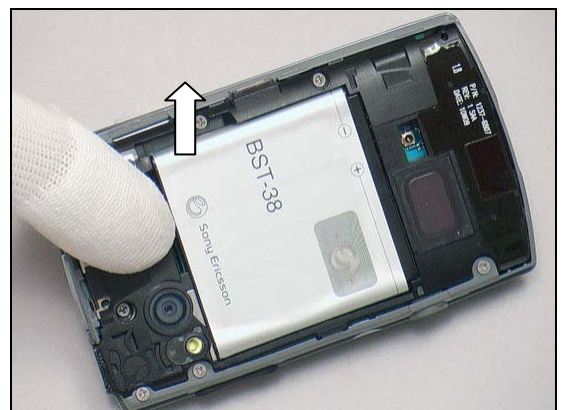


Turn the Battery Cover over to remove it.



3.1.2 Battery

Use fingers to release the battery.



Disassembly: Lower Unit

Lift to remove the Battery.



3.1.3 Keyboard

Turn the phone over and open the slider.

Insert a front opening tool underneath and slide back and forth to release the Keyboard following the order as shown.



Use fingers to remove Keyboard as shown.

Scrap! Cannot be reused!



Use Guitar pick to push down the glued PBA H2H Flex above the PBA dome.

Important! It may otherwise push up the keyboard if it is not glued to the slider.



Disassembly: Lower Unit

3.1.4 Base Cover Middle Deco belt Assy

Remove the four screws by T5.



Slide the phone to close position and turn the phone over.
Remove the three screws by JCIS No.0 bit.

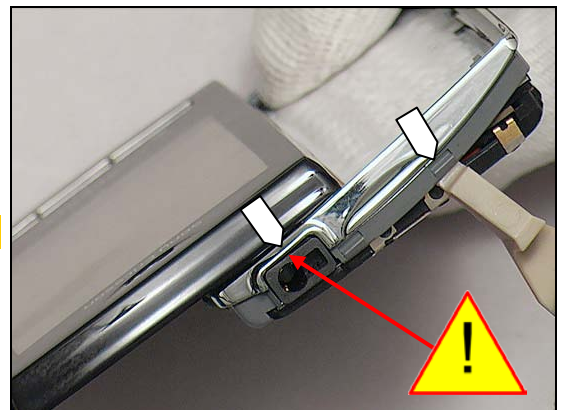


Slide the phone to open position and turn the phone over.
Unsnap the four hooks as shown.



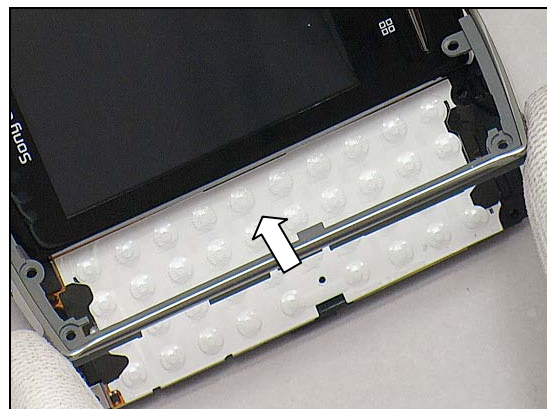
Release the hooks of this side.

Be careful to release the audio jack!



Disassembly: Lower Unit

Push the Base Cover Middle Deco belt Assy gently to release it.



Turn the phone over.
Push the Base Cover Middle Deco belt Assy to remove it.





Disassembly: Lower Unit

3.1.5 Bottom Carrier Frame Assy

Close the slider and remove the three screws by JCIS No.0 bit.



Unsnap the two hooks of this side by using a front opening tool.



Do the same for the opposite side





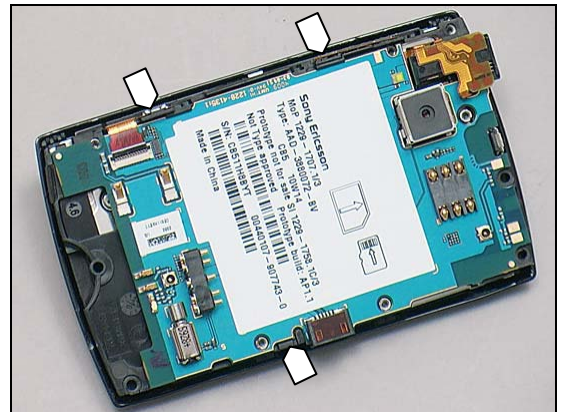
Disassembly: Lower Unit

Lift to remove the Bottom Carrier Frame Assy.



3.1.6 PBA Assy

There are three hooks securing the PBA Assy.



Unsnap the ZIF connector by using a front opening tool.

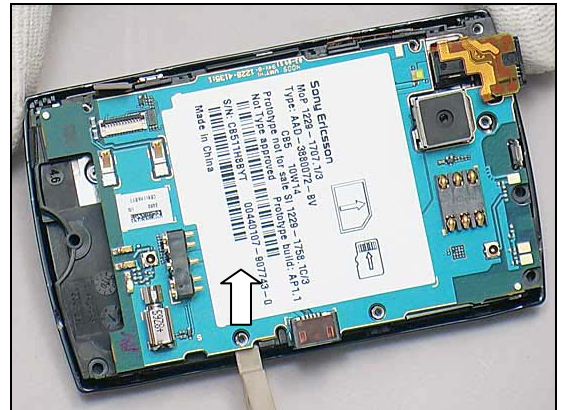


Release the flex part from the ZIF connector.

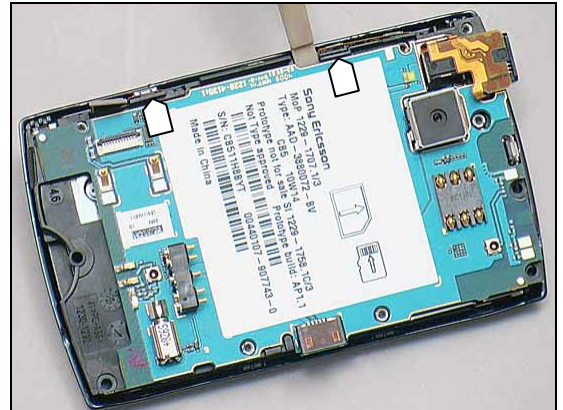


Disassembly: Lower Unit

Release the hook of this side on the PBA Assy.



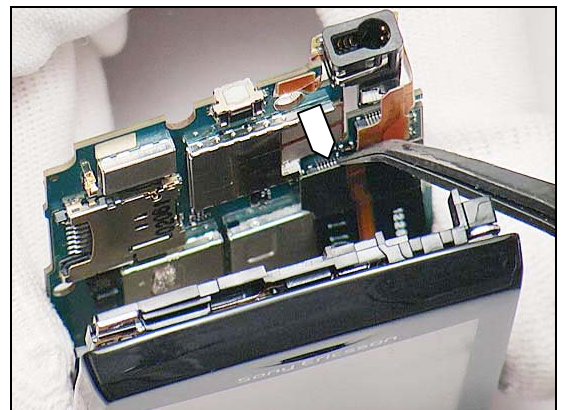
Release the two hooks of the opposite side.



Lift the PBA Assy at 30° approximately gently from the top side.



Unsnap the BtB connector by using a flex film assembly tool.





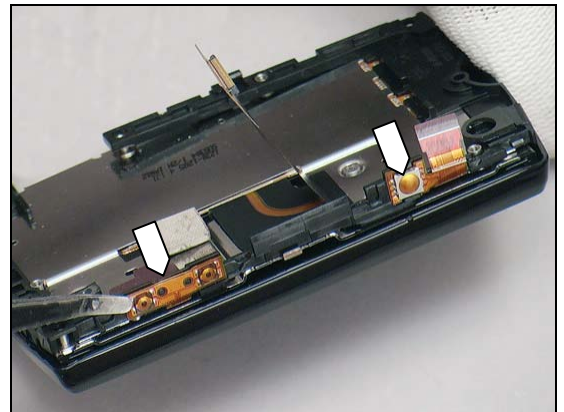
Disassembly: Lower Unit

Separate the PBA Assy and the unit.

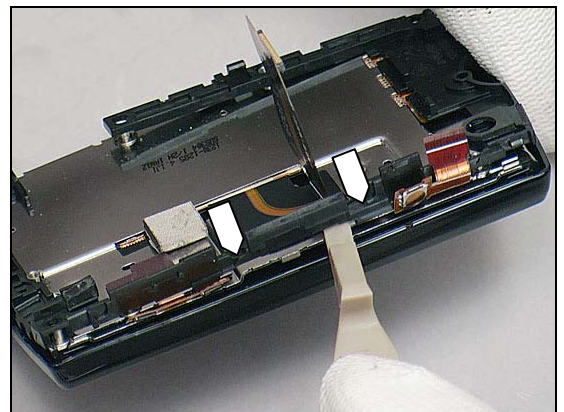


3.1.7 Carrier Plastic Qwerty Support Assembly

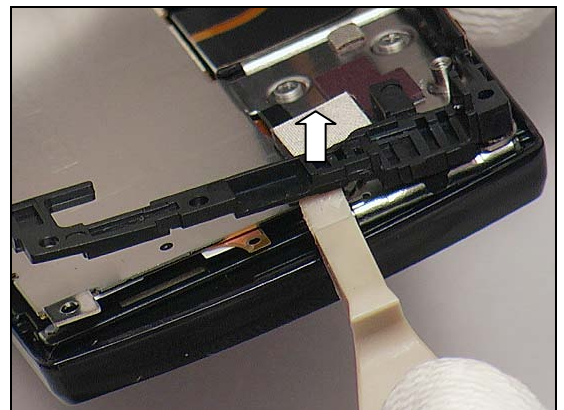
Release the two FPC from the Carrier Plastic Qwerty Support Assembly gently.



Release the hooks of the Carrier Plastic Qwerty Support Assembly.



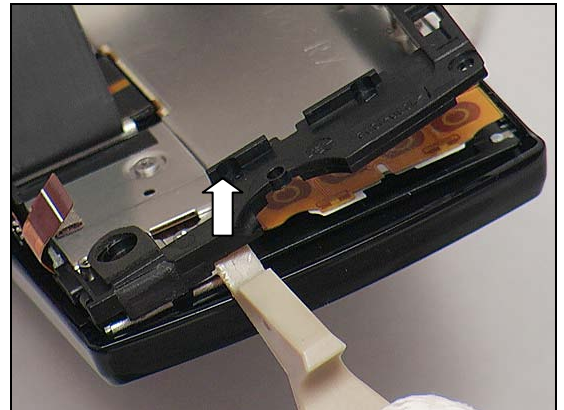
Do the same for the top side.



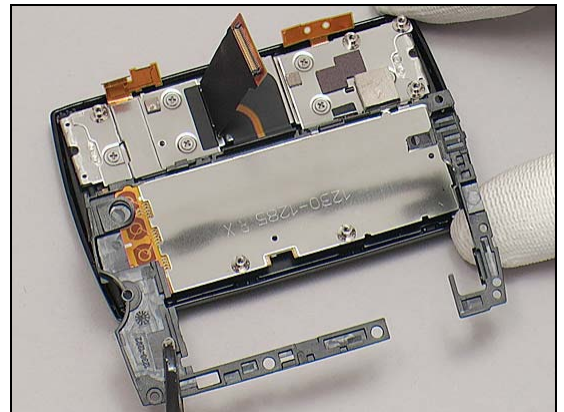


Disassembly: Lower Unit

Do the same for the bottom side.

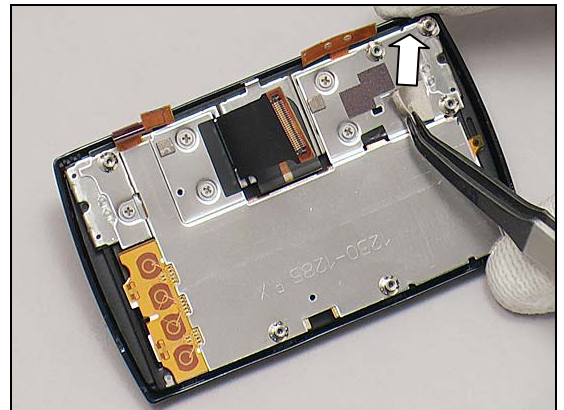


Lift to remove it.

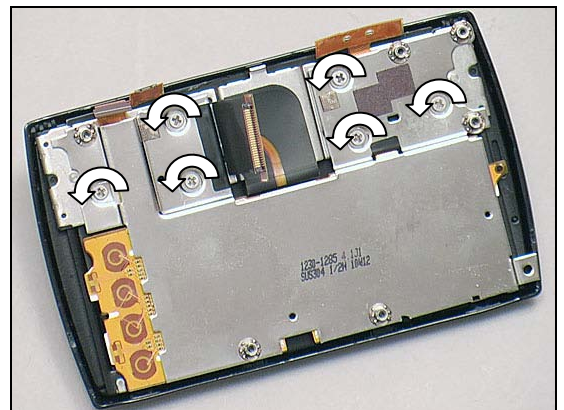


3.1.8 Carrier Metal Qwerty Support Assy

Remove the Cushion 0.0 mm Conductive Camera Support by using a flex film assembly tool.

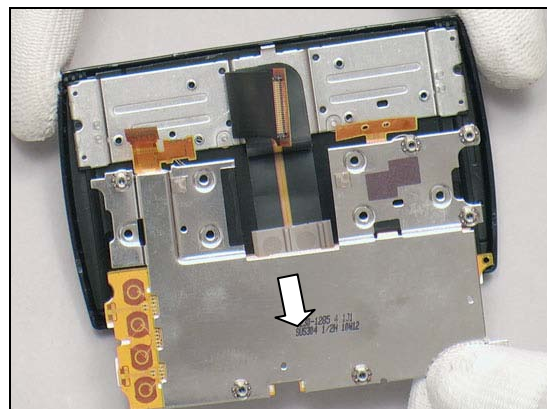


Remove the six screws by JCIS No.0 bit.



Disassembly: Lower Unit

Lift to remove the Carrier Metal Qwerty Support Assy.



Disassembly

3.2 Upper Unit

The disassembly is done in the following order:

1. Battery Cover (a) & Battery (b)
2. Front Cover Assy
3. Display



3.2.1 Battery Cover

Push upwards to unsnap the hooks of the Battery Cover from this side as shown.



Turn the Battery Cover over to remove it.



3.2.2 Battery

Use fingers to release the battery.





Disassembly: Upper Unit

Lift to remove the Battery.



3.2.3 Front Cover Assy

Warning!

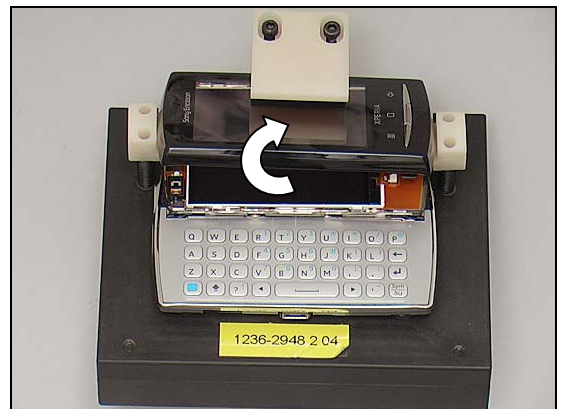
It is very important that the units is placed in the front cover fixture

Unsnap the Front Cover Assy from the USB connector side by sliding the guitar pick.



Put the unit on the fixture as shown.

Lift to open the Front Cover Assy from this side to an angle no more than 40°.



Unlock the ZIF connector underneath the Front Cover Assy by using a flex film assembly tool as shown.





Disassembly: Upper Unit

Release the flex from the ZIF connector.



Remove the Front Cover Assy.

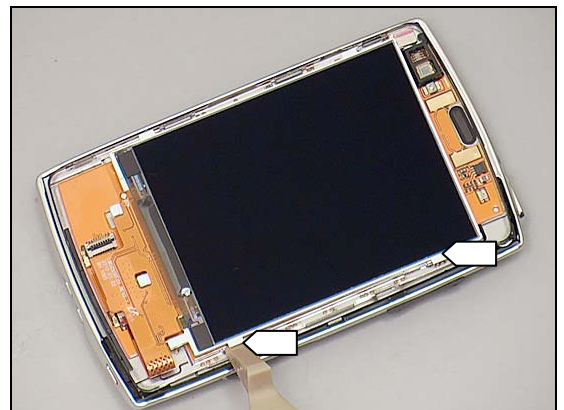


3.2.4 Display

Push upwards to release the two hooks on this side.



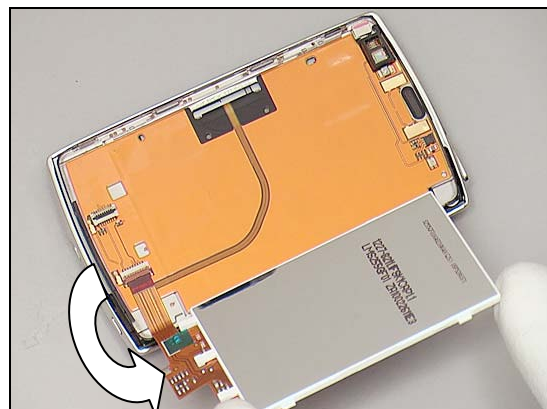
Do the same for the other hooks on the opposite side.



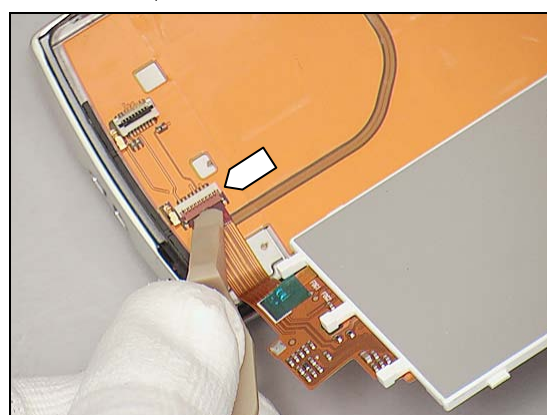
Disassembly: Upper Unit

Turn the Display over carefully.

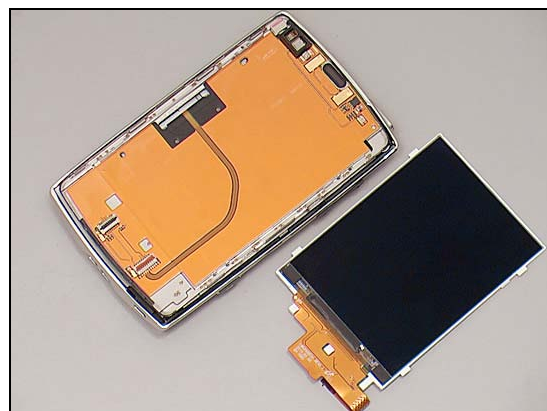
Do not touch the screen of the Display!



Disconnect the ZIF connector.



Separate the Display and the unit.





4 Replacement

4.1 Keyboard

Follow the 3.1.1 – 3.1.3 Disassembly instructions!

Prepare a Keyboard.

Follow the 5.2.6 – 5.2.8 Reassembly instructions!

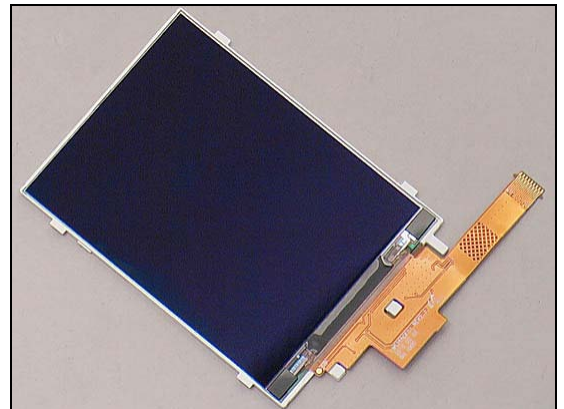


4.2 Display

Follow the 3.2.1 – 3.2.4 Disassembly instructions!

Prepare a Display.

Follow the 5.1.1 – 5.1.4 Reassembly instructions!

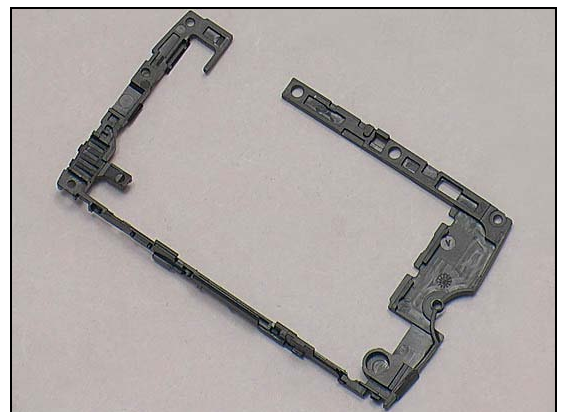


4.3 Carrier Plastic Qwerty Support Assembly

Follow the 3.1.1 – 3.1.7 Disassembly instructions!

Prepare a Carrier Plastic Qwerty Support Assembly.

Follow the 5.2.2 – 5.2.8 Reassembly instructions!



4.4 Bottom Carrier Frame Assy

Follow the 3.1.1 – 3.1.5 Disassembly instructions!

Prepare a Bottom Carrier Frame Assy.

Follow the 5.2.4 – 5.2.8 Reassembly instructions!





Replacement

4.5 Battery Cover

Follow the 3.1.1 Disassembly instructions!

Follow the 4.13 Cobrand Label Removal instruction!

Prepare a Battery Cover.

Follow the 4.13 Cobrand Label Installation instruction!

Follow the 5.2.8 Reassembly instructions!



4.6 Base Cover Middle Deco belt

Follow the 3.1.1 – 3.1.4 Disassembly instructions!

Follow the 4.9 Camera Key Removal instruction!

Follow the 4.22 Key lock/onoff Removal instruction!

Follow the 4.32 Volume Key Removal instruction!

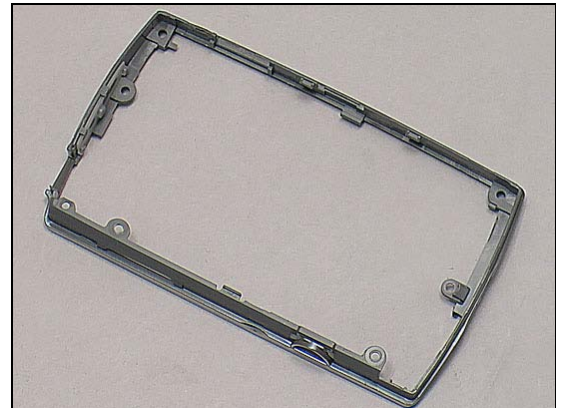
Prepare a Base Cover Middle Deco belt.

Follow the 4.9 Camera Key Installation instruction!

Follow the 4.22 Key lock/onoff Installation instruction!

Follow the 4.32 Volume Key Installation instruction!

Follow the 5.2.5 – 5.2.8 Reassembly instructions!





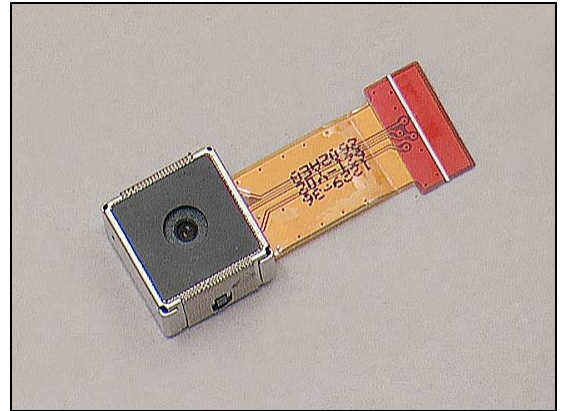
Replacement

4.7 Camera 5 MPixel & Shield Can Camera

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

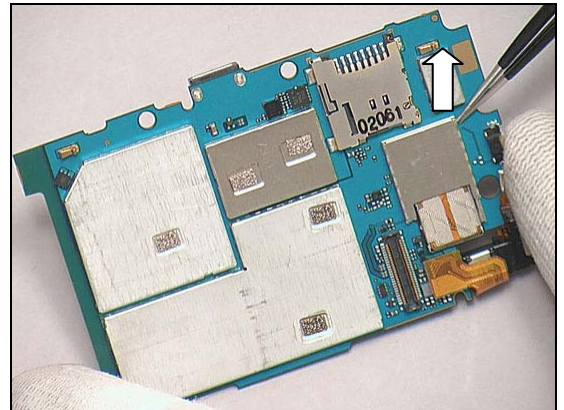
Prepare a Camera 5 MPixel and a Shield Can Camera.

Follow the 5.2.3 – 5.2.8 Reassembly instructions!

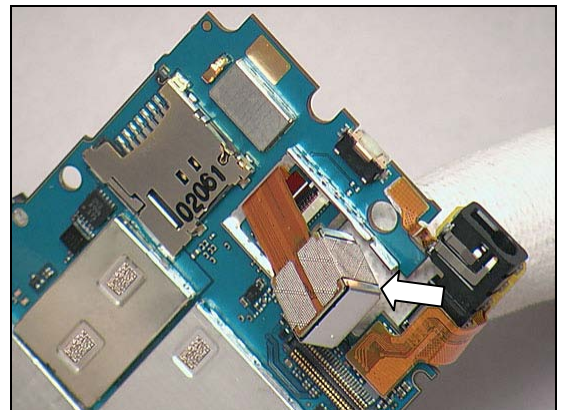


REMOVAL

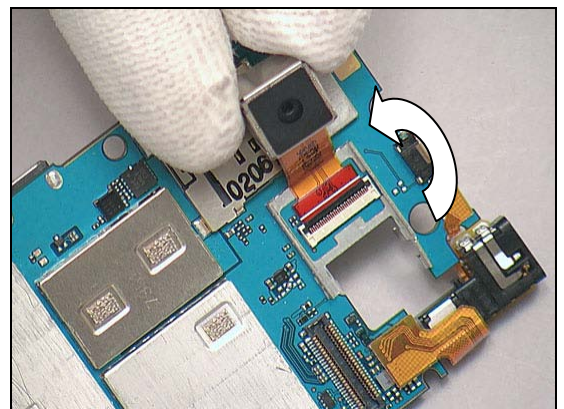
Unsnap the corners of the Shield Can Camera with a pair of tweezers and pull upwards to remove it.



Push from the other side to release the Camera 5 MPixel from the slot gently.

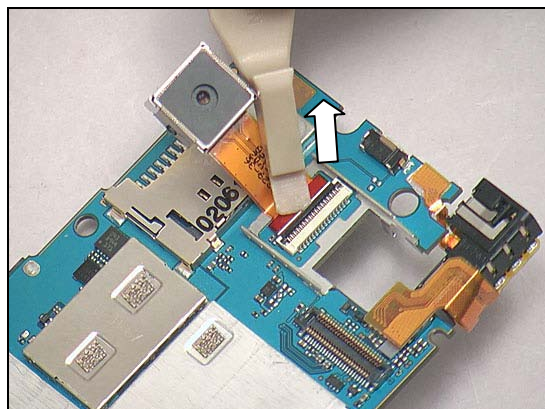


Turn it over as shown.

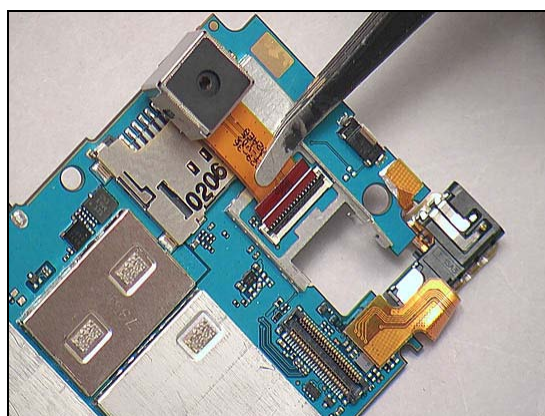


Replacement: Camera 5 MPixel

Disconnect the ZIF connector by using a front opening tool.

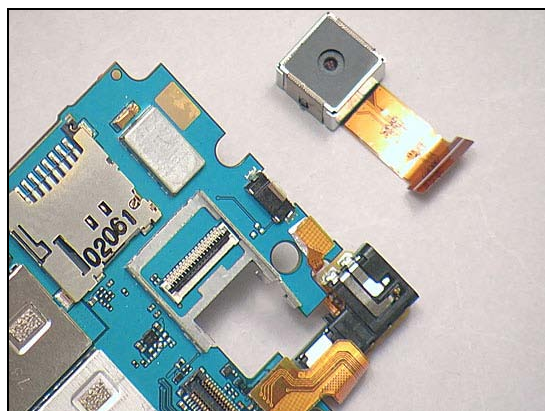


Lift to remove it.

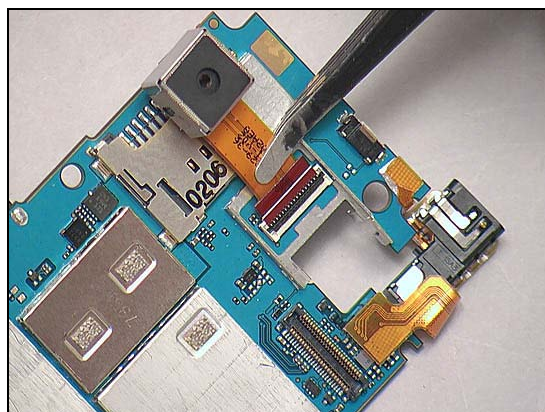


INSTALLATION

Place a Camera 5 MPixel in place with proper direction.

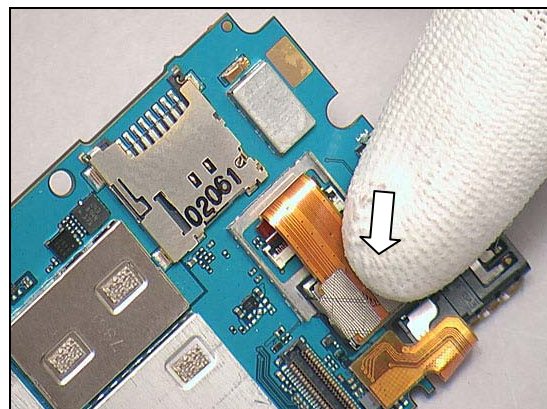


Connect the ZIF connector.

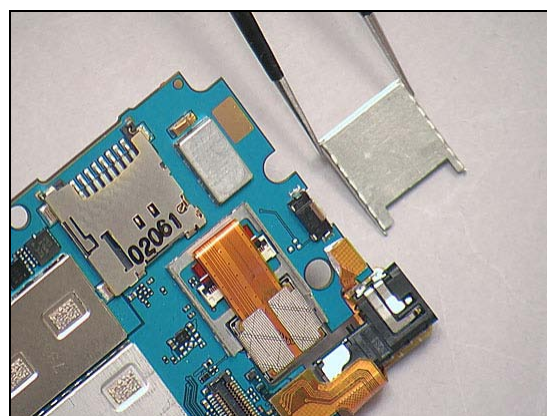


Replacement: Camera 5 MPixel

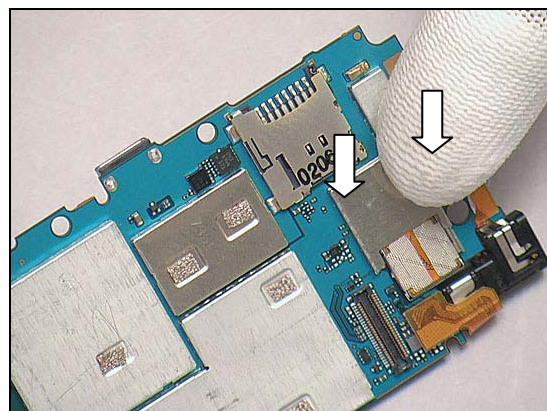
Turn it over and press it into the cavity.



Put a Shield Can Camera in place.



Press to snap it.





Replacement

4.8 Camera Gasket

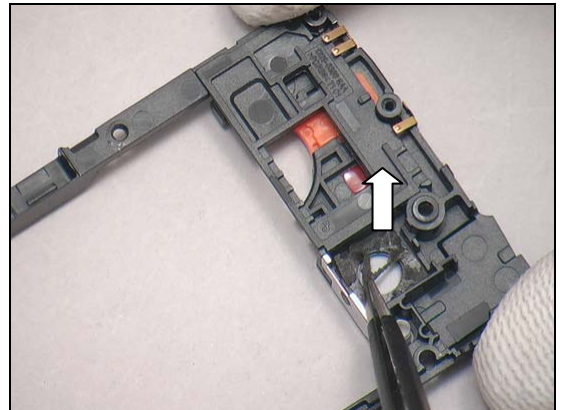
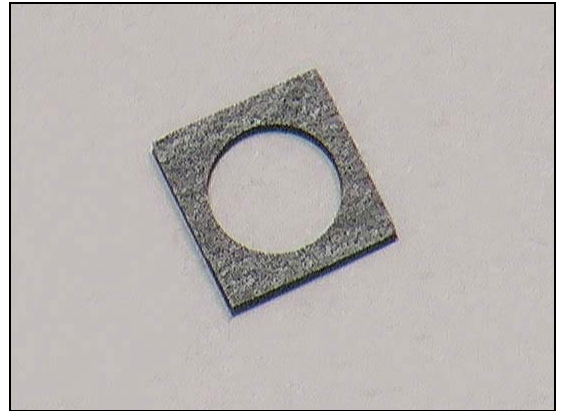
Follow the 3.1.1– 3.1.5 Disassembly instructions!

Prepare a new Camera Gasket.

Follow the 5.2.4 – 5.2.8 Reassembly instructions!

REMOVAL

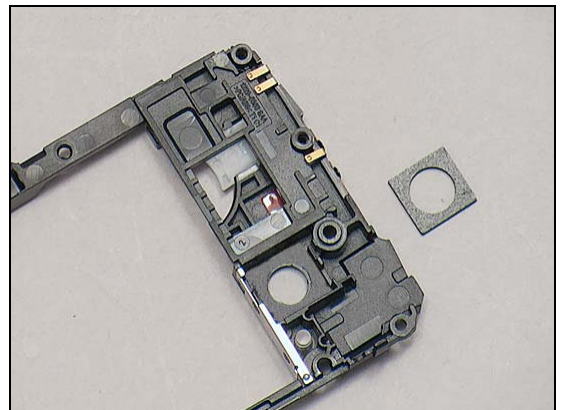
Detach to remove it from this corner carefully.



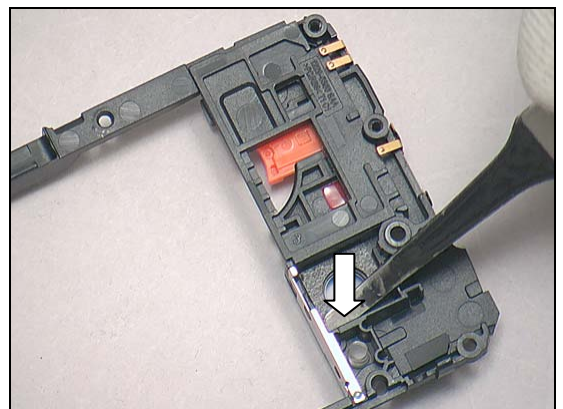
INSTALLATION

No reuse of this component

Place a new Camera Gasket.



Press to attach it.





Replacement

4.9 Camera Key

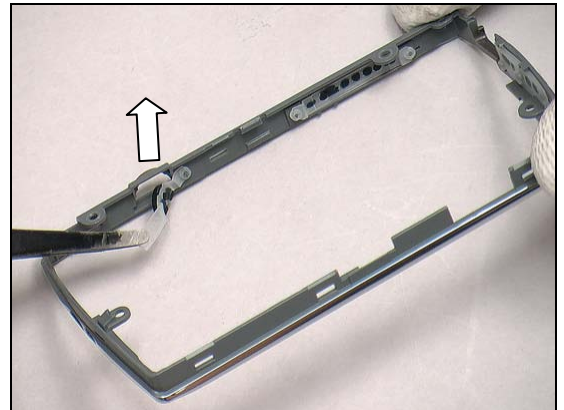
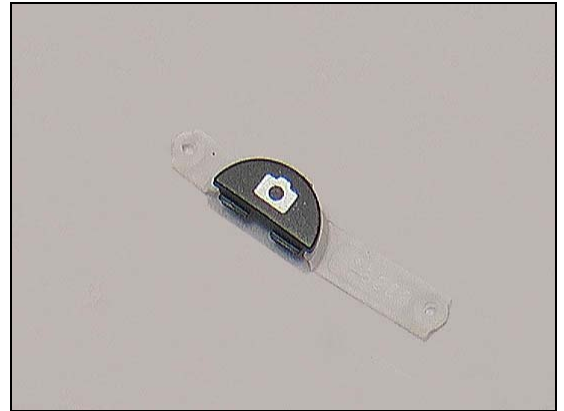
Follow the 3.1.1 – 3.1.4 Disassembly instructions!

Prepare a Camera Key.

Follow the 5.2.5 – 5.2.8 Reassembly instructions!

REMOVAL

Lift to remove the Camera Key from the Base Cover Middle Deco belt Assy.

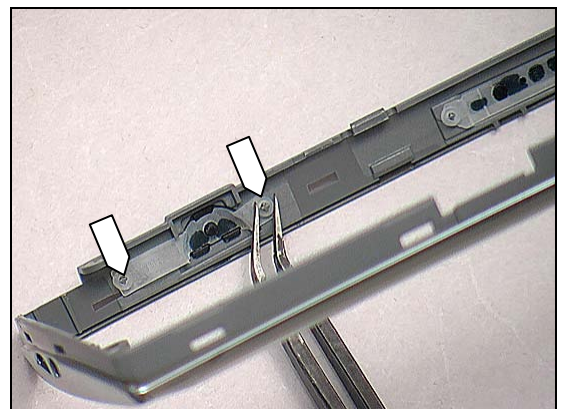


INSTALLATION

Place the Camera Key with proper direction into the slot.



Align the key by using two guiding pins as shown.





Replacement

4.10 Camera Window

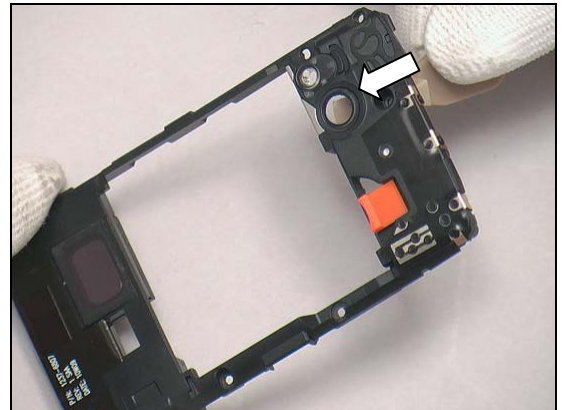
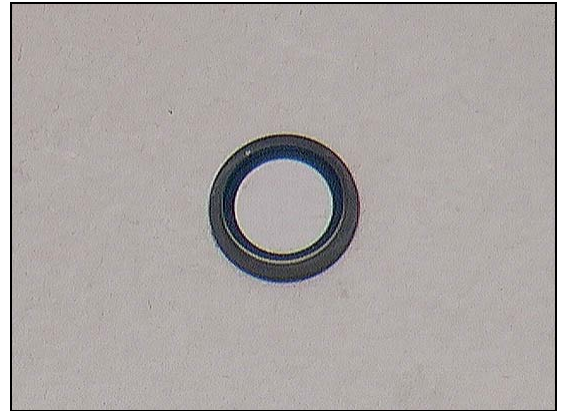
Follow the 3.1.1 – 3.1.5 Disassembly instructions!

Prepare a Camera Window.

Follow the 5.2.4 – 5.2.8 Reassembly instructions!

REMOVAL

Push from the back side to release the Camera Window.

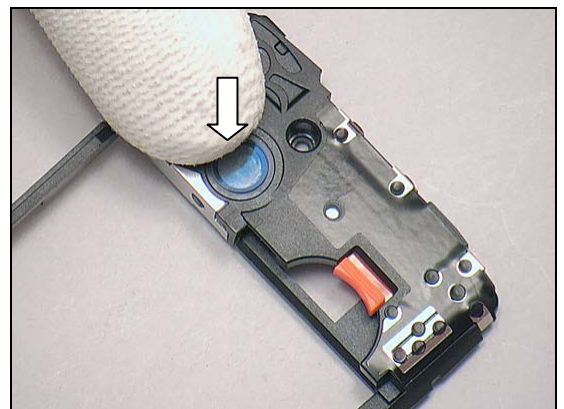


INSTALLATION

Place the Camera Window as shown.



Press with finger to make sure it is securely attached.





Replacement

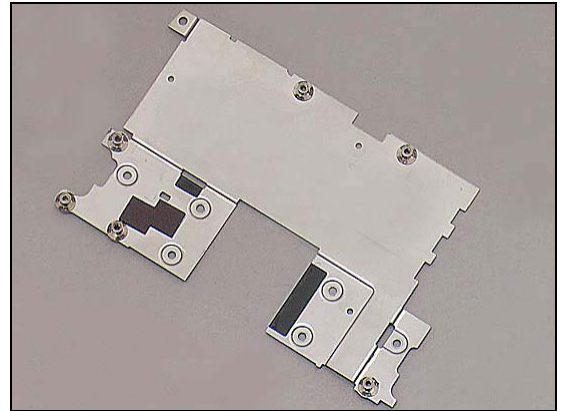
4.11 Carrier Metal Qwerty Support Assy

Follow the 3.1.1 – 3.1.8 Disassembly instructions!

Prepare a new PBA Dome, Complete, a new Carrier Metal Qwerty Support Assy, a new Cushion 0.0 mmConductive Camera Support and two new Cushion Grounding Hinges.

Follow the 4.25 PBA Dome, Complete Installation instructions!

Follow the 4.15 Cushion 0.0 mmConductive Camera Support Installation instructions!



Follow the 4.16 Cushion Grounding Hinge Installation instructions!

Follow the 5.2.1 – 5.2.8 Reassembly instructions!

Replacement

4.12 Center Qwerty Support

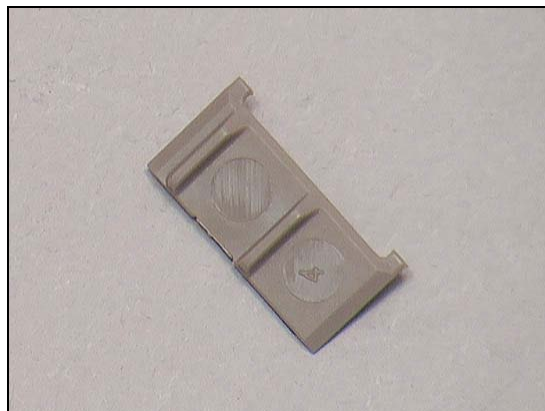
Follow the 3.1.1 – 3.1.8 Disassembly instructions!

Prepare a new Center Qwerty Support.

Follow the 5.2.1 – 5.2.8 Reassembly instructions!

REMOVAL

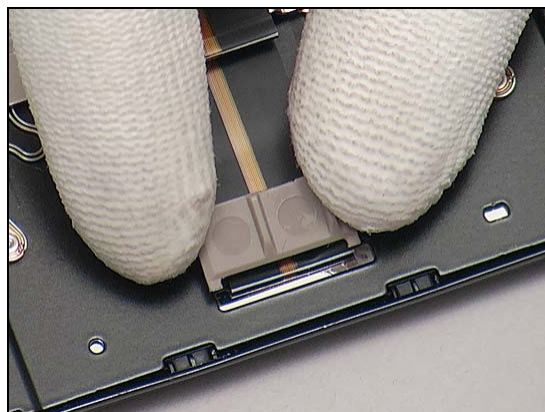
Detach to remove it by using a front opening tool carefully.



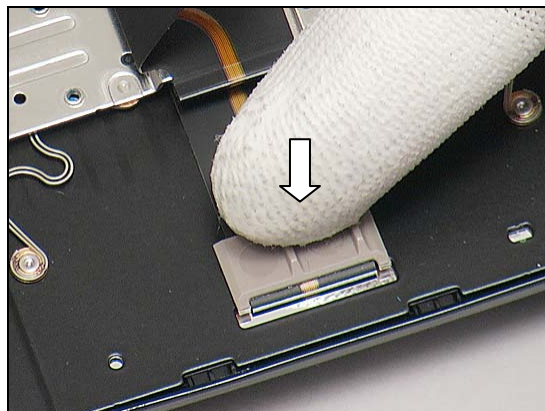
INSTALLATION

No reuse of this component

Place a new Center Qwerty Support aligning to the guiding line of the FPC as shown.



Press to attach it.





Replacement

4.13 Cobrand label

Follow the 3.1.1 Disassembly instructions!

Prepare a new Cobrand label.

Follow the 5.2.8 Reassembly instructions!

REMOVAL

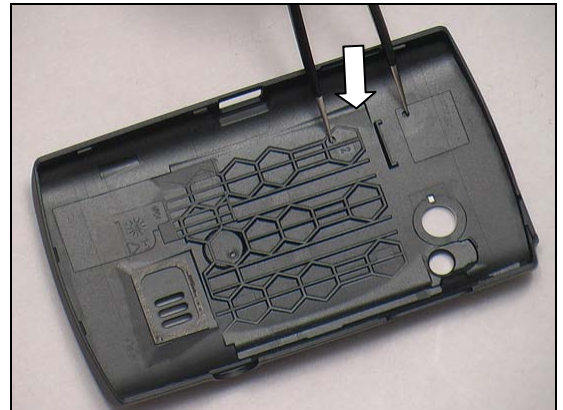
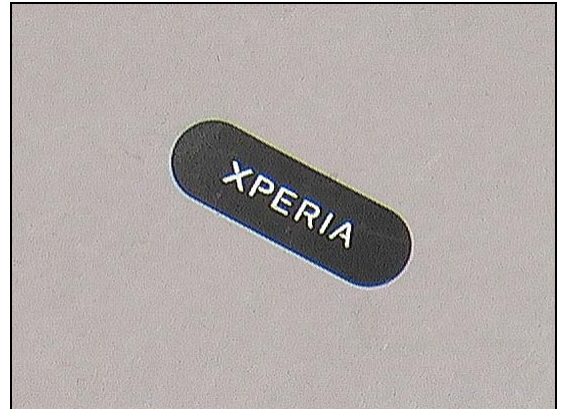
Push from the holes on the back side of the Battery Cover by using a pair of tweezers.

Detach to remove it from the Battery Cover.

INSTALLATION

No reuse of this component

Place a new Cobrand label on the Battery Cover.



Replacement: Cobrand label

Press along to secure its attachment.



Replacement

4.14 Core unit label

Follow the 3.1.1 – 3.1.2 Disassembly instructions!

Prepare a new Core unit label.

Follow the 5.2.1 – 5.2.8 Reassembly instructions!

REMOVAL

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

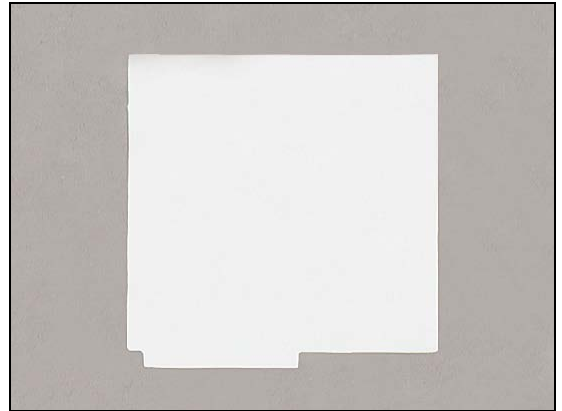
Remove the Label carefully.

INSTALLATION

No reuse of this component

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

One label only is allowed!



Replacement: Core unit label

Press the new Core Unit Label onto the Main PBA.





Replacement

4.15 Cushion 0.0 mmConductive Camera Support

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

Prepare a new Cushion 0.0 mmConductive Camera Support.

Follow the 5.2.3 – 5.2.8 Reassembly instructions!

REMOVAL

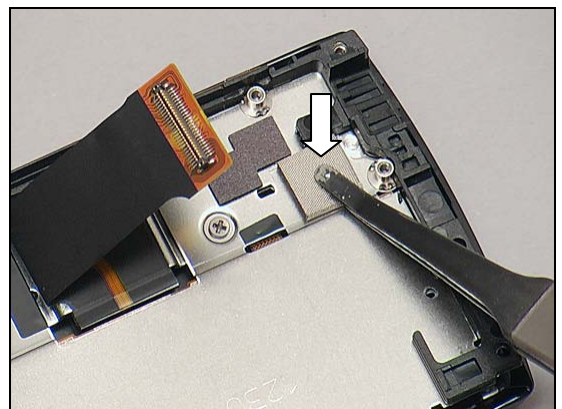
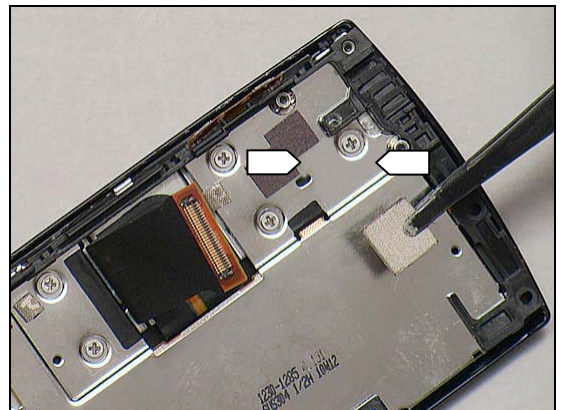
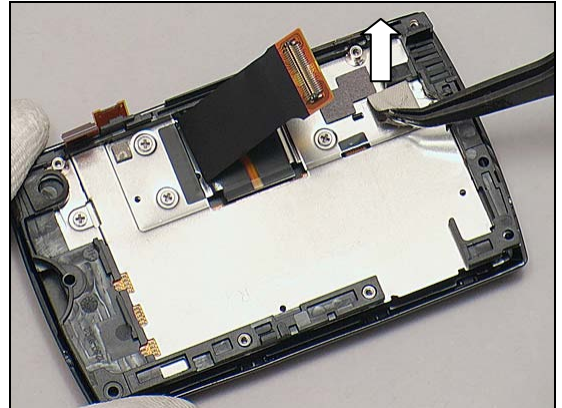
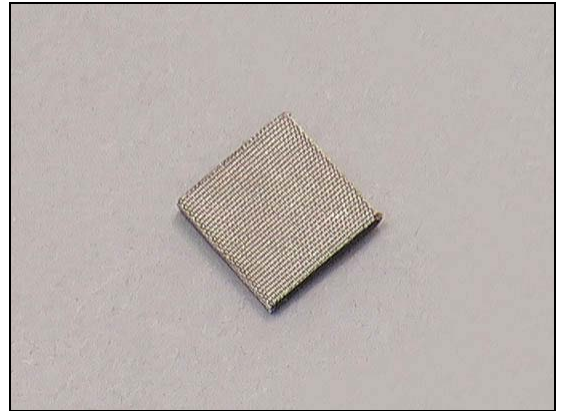
Detach to remove it from the Hinge Assembly.

INSTALLATION

No reuse of this component

Place a new Cushion 0.0 mmConductive Camera Support by aligning to the two guiding lines.

Press it with the proper position.





Replacement

4.16 Cushion Grounding Hinge

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

Prepare two new Cushion Grounding Hinges.

Follow the 5.2.3 – 5.2.8 Reassembly instructions!

REMOVAL

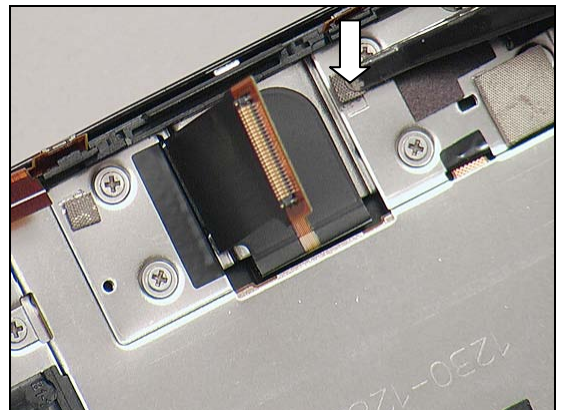
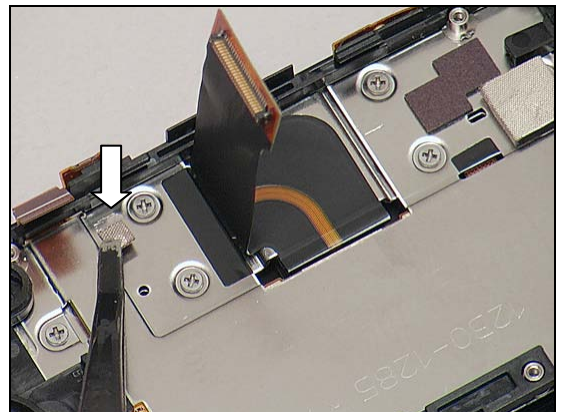
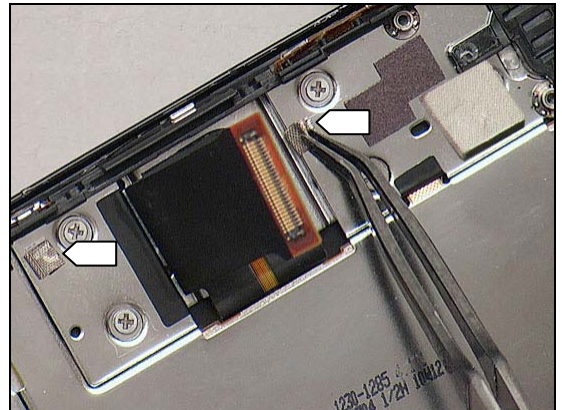
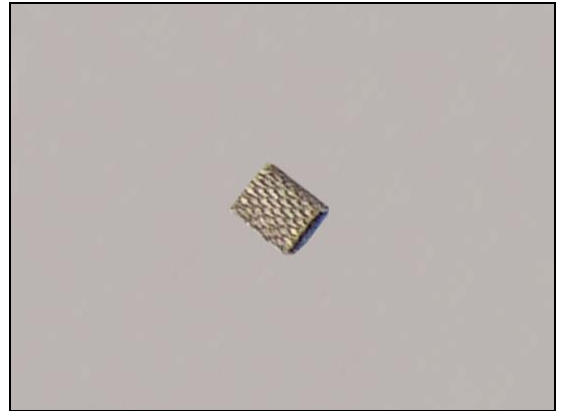
Detach to remove the two Cushion Grounding Hinges by using a flex film assembly tool.

INSTALLATION

No reuse of this component

Attach a new Cushion Grounding Hinge aligning to the guiding lines as shown.

Attach another new Cushion Grounding Hinge aligning to the guiding lines as shown.





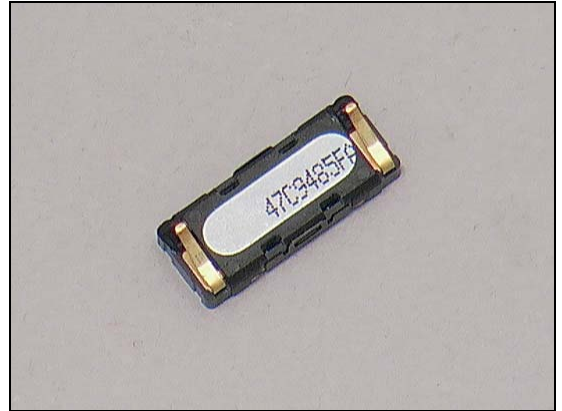
Replacement

4.17 Ear Speaker & Gasket Ear Speaker

Follow the 3.2.1 – 3.2.3 Disassembly instructions!

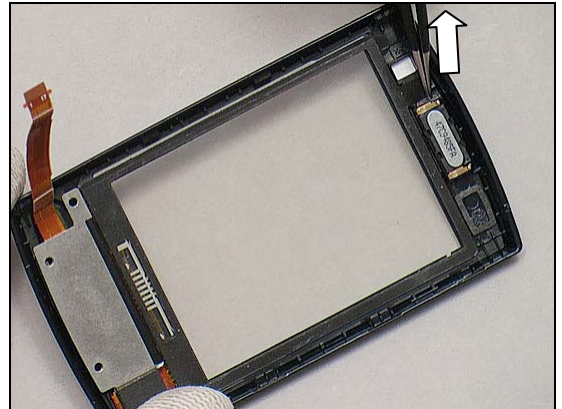
Prepare a new Ear Speaker and the Gasket Ear Speaker.

Follow the 5.1.2 – 5.1.4 Reassembly instructions!

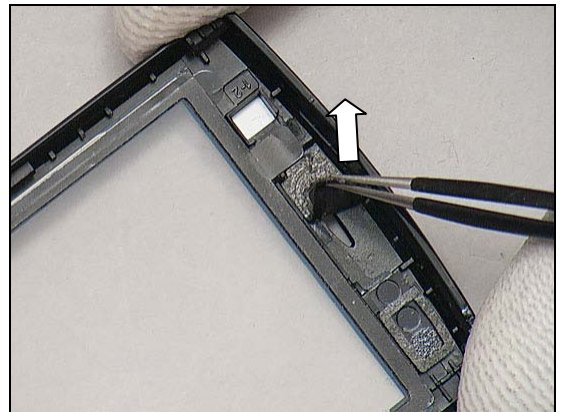


REMOVAL

Insert a pair of tweezers underneath the Ear Speaker and lift to separate the Ear Speaker.



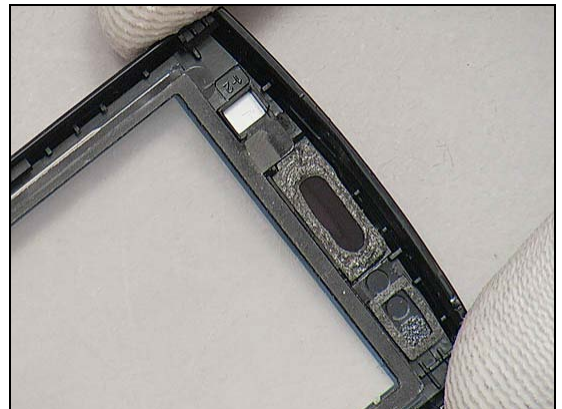
Detach to remove the Gasket Ear Speaker.



INSTALLATION

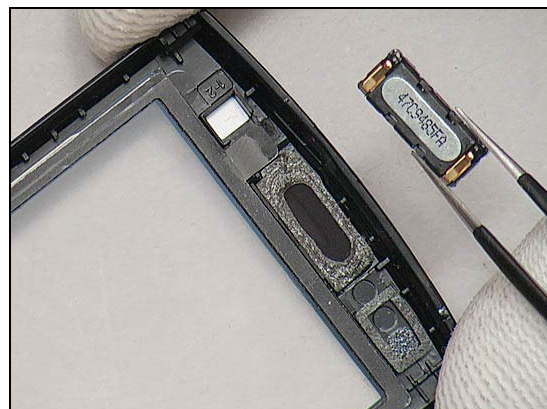
No reuse of this component

Attach a new Gasket Ear Speaker.



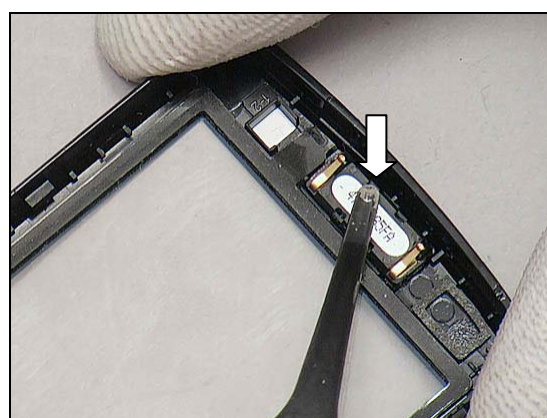
Replacement: Ear Speaker & Gasket Ear Speaker

Place a Ear Speaker in place.



Press it into the cavity as shown.

Do not touch the contact pin!





Replacement

4.18 Flash Lens Window & Flash Lens Foil Adhesive

Follow the 3.1.1 – 3.1.2 Disassembly instructions!

Prepare a Flash Lens Window and a new Flash Lens Foil Adhesive.

Follow the 5.2.7 – 5.2.8 Reassembly instructions!



REMOVAL

Insert a flex film assembly tool and lift to release the Flash Lens Window from the Bottom Carrier Frame Assy.



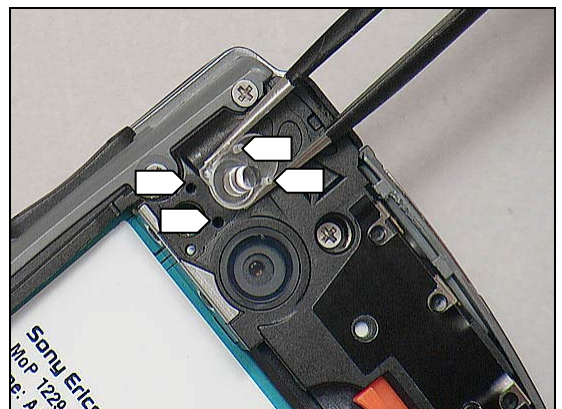
INSTALLATION

No reuse of this component

Attach a new Flash Lens Foil Adhesive onto the Unit.



Place a Flash Lens Window aligning to the two guiding holes.



Replacement: Flash Lens Window

Press it into the cavity and make sure it is securely attached.





Replacement

4.19 Foil Adhesive Double Side Conductive 0.0

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

Prepare a new Foil Adhesive Double Side Conductive 0.0.

Follow the 5.2.3 – 5.2.8 Reassembly instructions!

REMOVAL

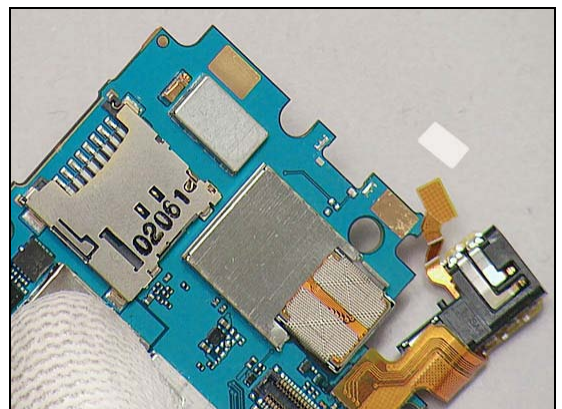
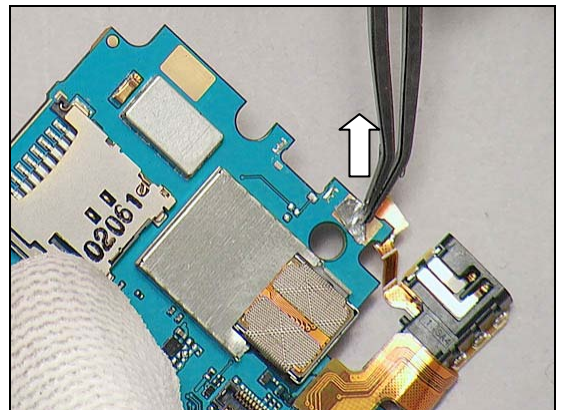
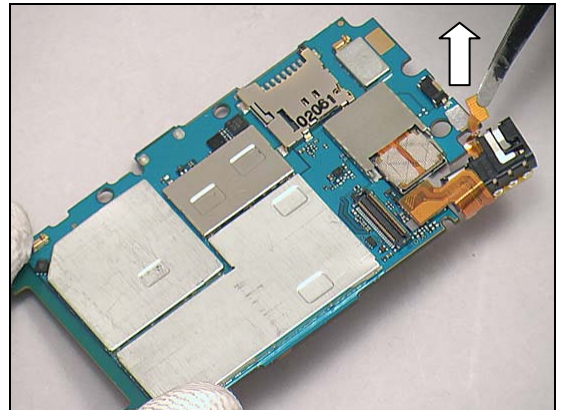
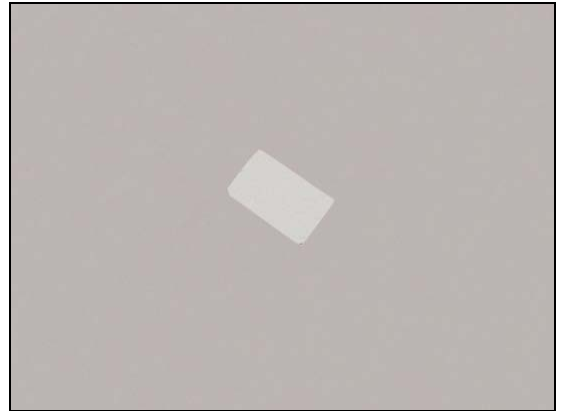
Detach the PBA AVP assy by using a flex film assembly tool.

Detach to remove the Foil Adhesive Double Side Conductive 0.0

INSTALLATION

No reuse of this component

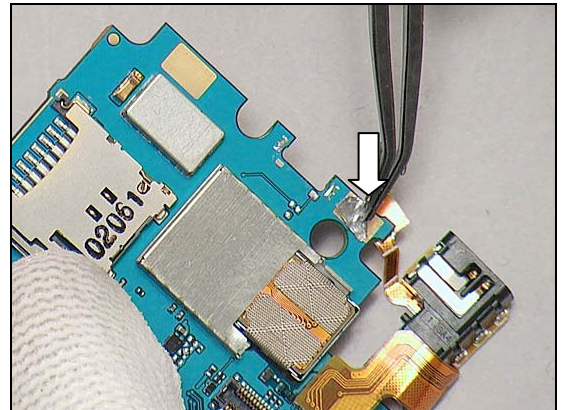
Put a new Foil Adhesive Double Side Conductive 0.0 in place.



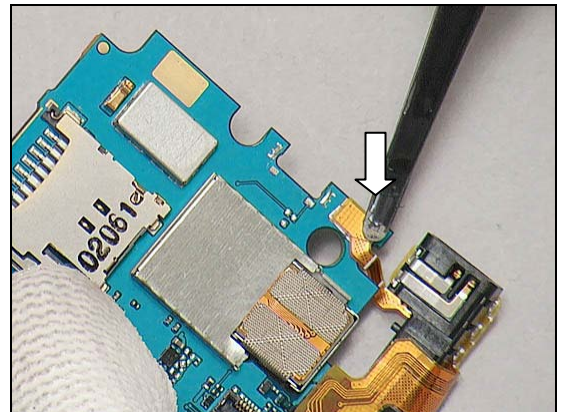


Replacement: Foil Adhesive Double Side Conductive 0.0

Attach the Foil Adhesive Double Side Conductive 0.0 aligning to the golden pad.



Press to attach the contact pin of the PBA AVP assy.



Replacement

4.20 Front Cover Assembly

Follow the 3.2.1 – 3.2.3 Disassembly instructions!

Follow the 4.17 Ear Speaker & Gasket Ear Speaker Removal instructions!

Prepare a Front Cover Assembly, a new Ear Speaker and a new Gasket Ear Speaker.

Follow the 4.17 Ear Speaker & Gasket Ear Speaker Installation instructions!

Follow the 5.1.2 – 5.1.4 Reassembly instructions!





Replacement

4.21 Gasket Conductive 3,8x2,3

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

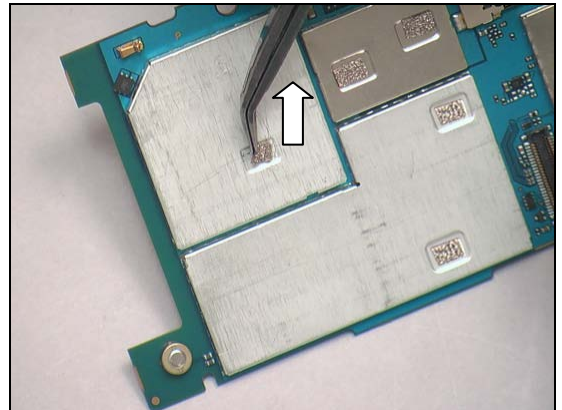
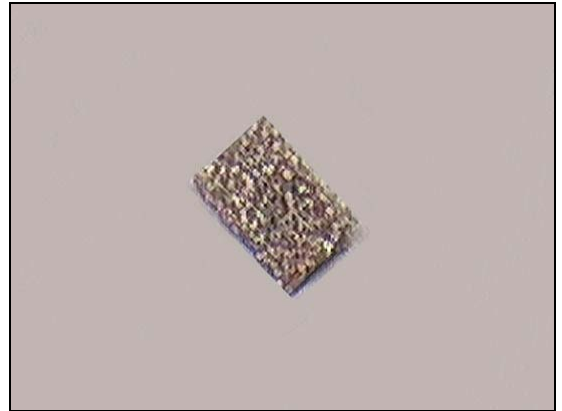
Prepare a new Gasket Conductive 3,8x2,3.

Follow the 5.2.3 – 5.2.8 Reassembly instructions!

REMOVAL

Detach to remove it.

Do the same with the other four Gasket Conductive 3,8x2,3!

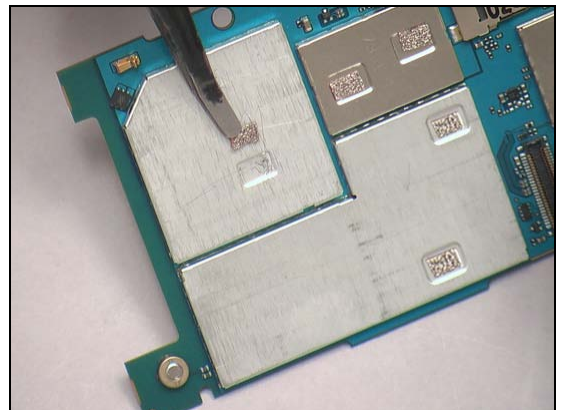


INSTALLATION

No reuse of this component

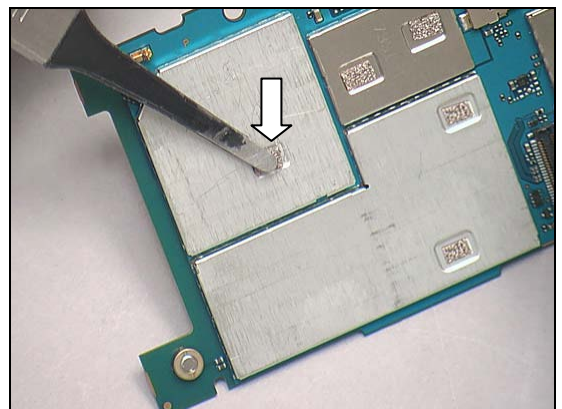
Place a new Gasket Conductive 3,8x2,3.

Do the same with the other four Gasket Conductive 3,8x2,3!



Press it into the cavity as shown.

Do the same with the other four Gasket Conductive 3,8x2,3!





Replacement

4.22 Key lock/onoff

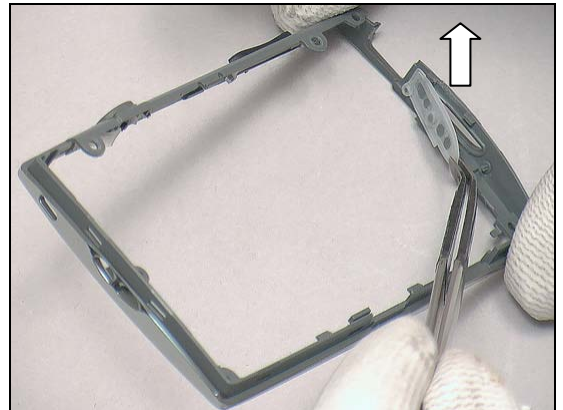
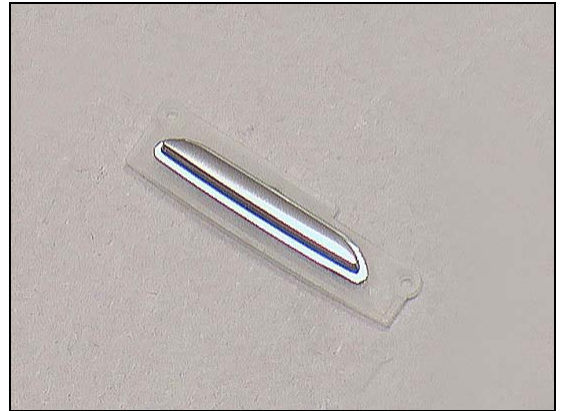
Follow the 3.1.1 – 3.1.4 Disassembly instructions!

Prepare a Key lock/onoff.

Follow the 5.2.5 – 5.2.8 Reassembly instructions!

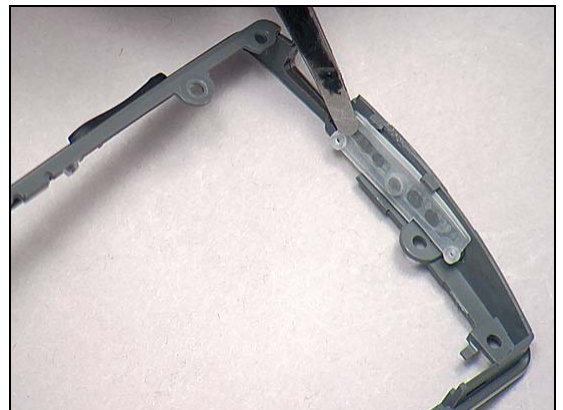
REMOVAL

Lift to remove the Key lock/onoff from the Base Cover Middle Deco belt Assy.

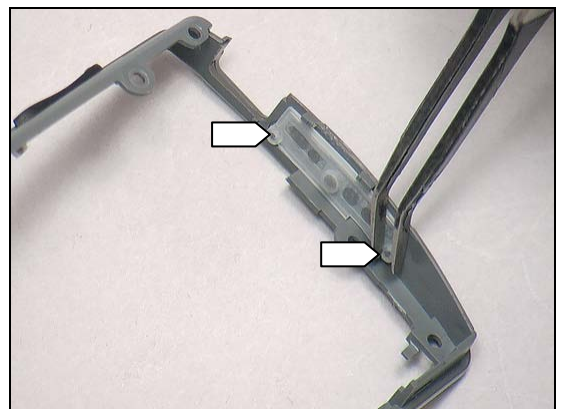


INSTALLATION

Place the Key lock/onoff with proper direction into the slot.



Align the key by using two guiding pins as shown.





Replacement

4.23 Loudspeaker Mesh

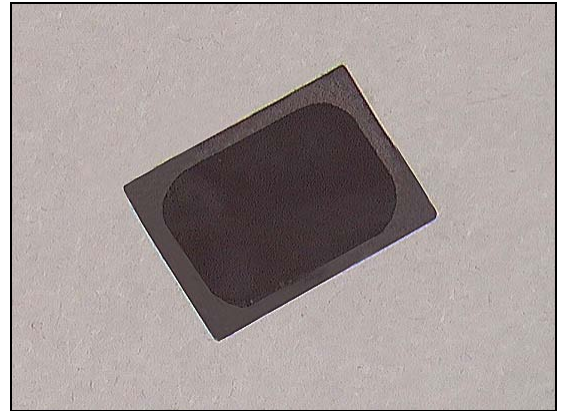
Follow the 3.1.1– 3.1.2 Disassembly instructions!

Prepare the new Loudspeaker Mesh.

Follow the 5.2.7 – 5.2.8 Reassembly instructions!

REMOVAL

Detach to remove it by using a flex film assembly tool.



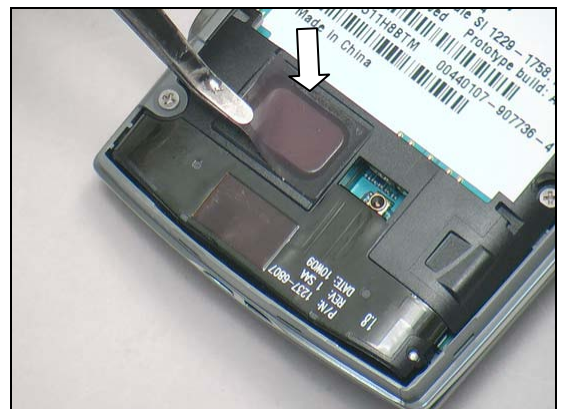
INSTALLATION

No reuse of this component

Place a new Loudspeaker Mesh.



Press to attach it aligning to the edge of loud speaker securely.





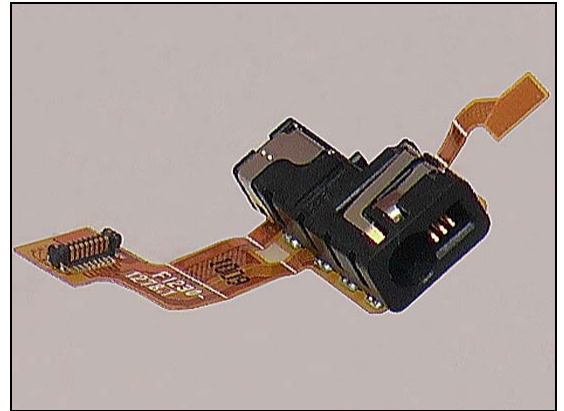
Replacement

4.24 PBA AVP assy

Follow the 3.1.1– 3.1.6 Disassembly instructions!

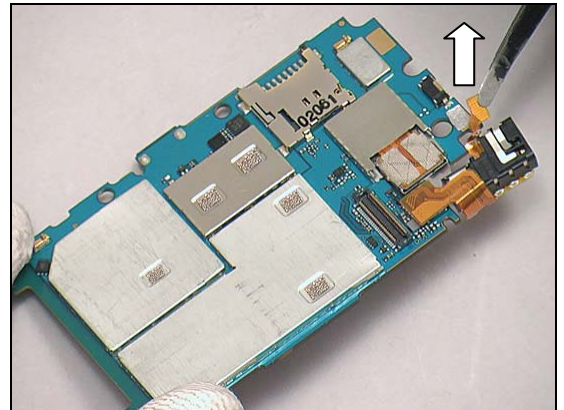
Prepare a PBA AVP assy.

Follow the 5.2.3 – 5.2.8 Reassembly instructions!

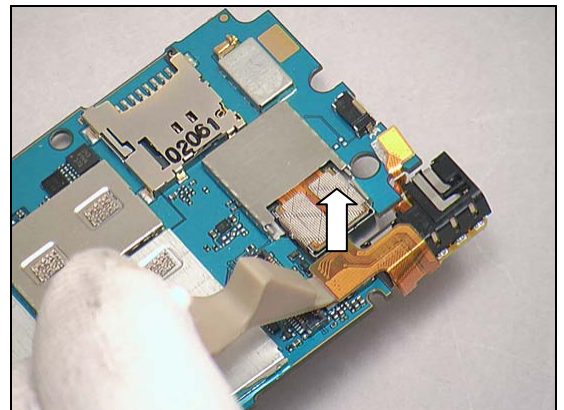


REMOVAL

Detach the contact pin by using a flex film assembly tool.

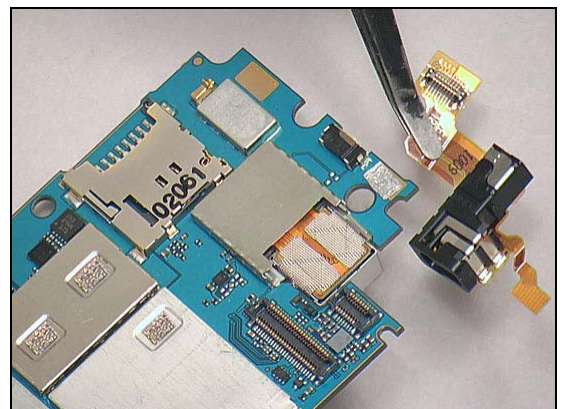


Unsnap the BtB connector by using a front opening tool.



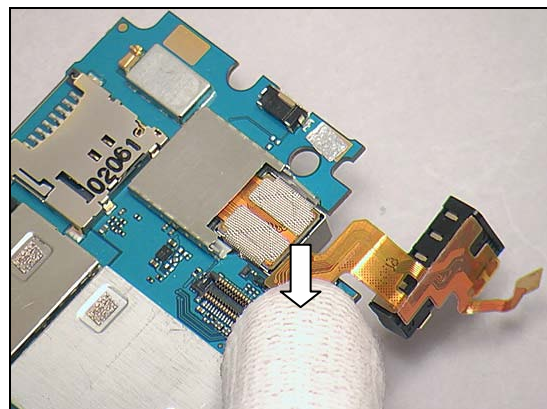
INSTALLATION

Put a PBA AVP assy in place.

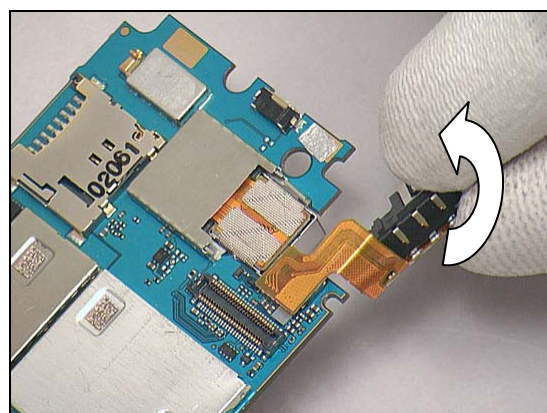


Replacement: PBA AVP assy

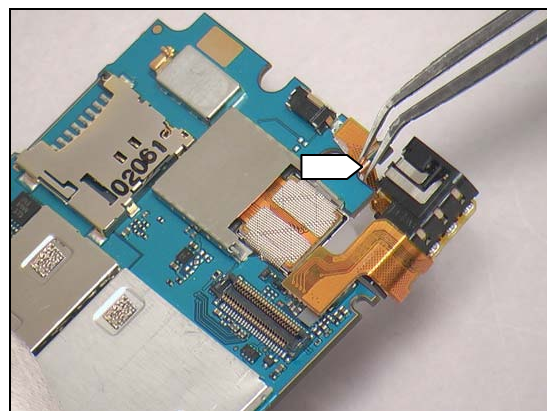
Snap to connect the BtB connector.



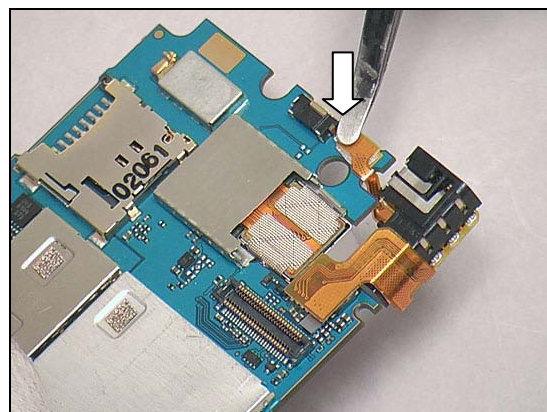
Turn it over as shown.



Fold the FPC along the guiding line as shown.



Press to attach the contact pin securely.





Replacement

4.25 PBA Dome, Complete

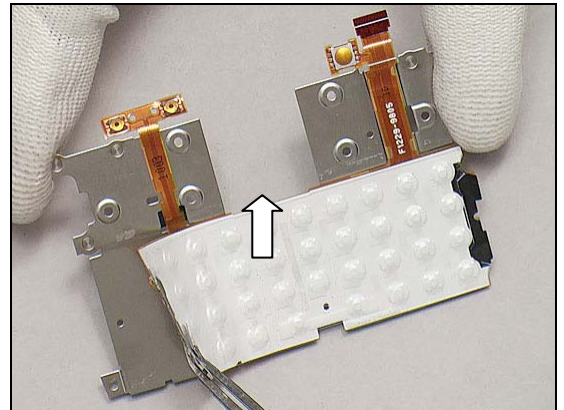
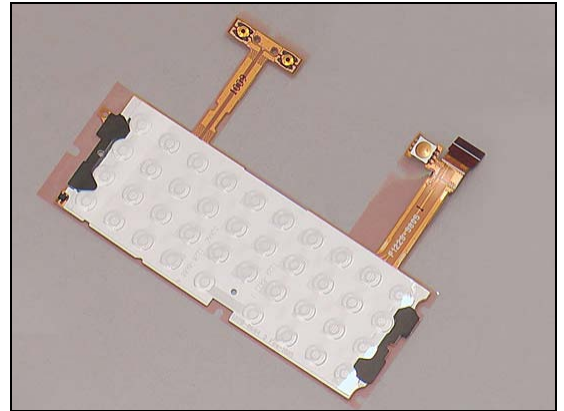
Follow the 3.1.1 – 3.1.8 Disassembly instructions!

Prepare a new PBA Dome, Complete.

Follow the 5.2.1 – 5.2.8 Reassembly instructions!

REMOVAL

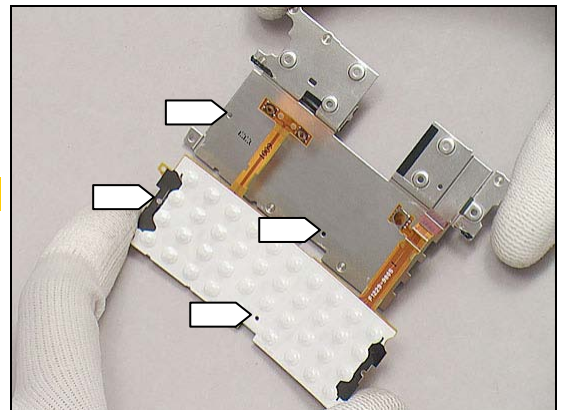
Detach to release the PBA Dome, Complete by using a flex film assembly tool.



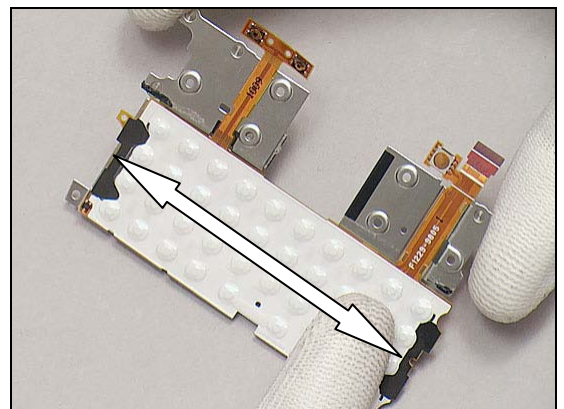
INSTALLATION

No reuse of this component

Place the PBA Dome, Complete aligning to the two guiding poles as shown.



Press around the surface to secure its attachment.





Replacement

4.26 PBA H2H Flex

Follow the 3.2.1 – 3.2.4 Disassembly instructions!

Follow the 3.1.3 – 3.1.8 Disassembly instructions!

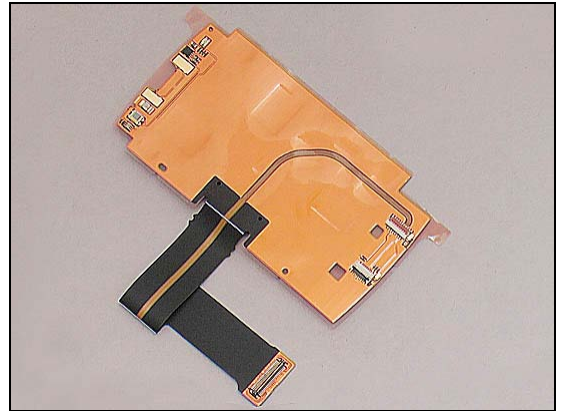
Prepare a PBA H2H Flex.

Follow the 4.27 Plastic Cover Proximity Installation instructions and Follow 4.12 Center Qwerty Support!

Follow the 5.2.1 – 5.2.5 Reassembly instructions!

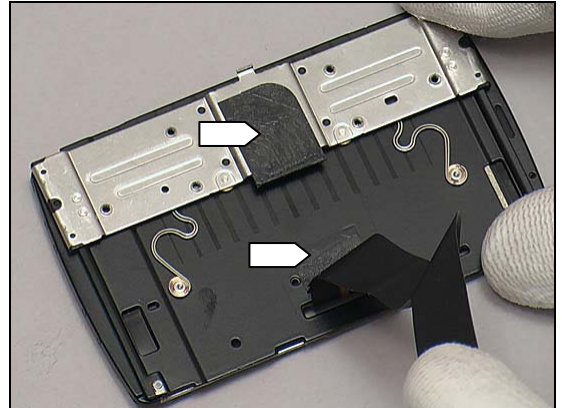
Follow the 5.1.1 – 5.1.2 Reassembly instructions!

Follow the 5.2.6 – 5.2.8 Reassembly instructions!

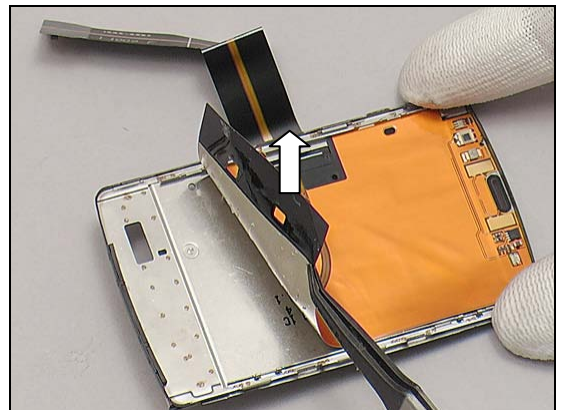


REMOVAL

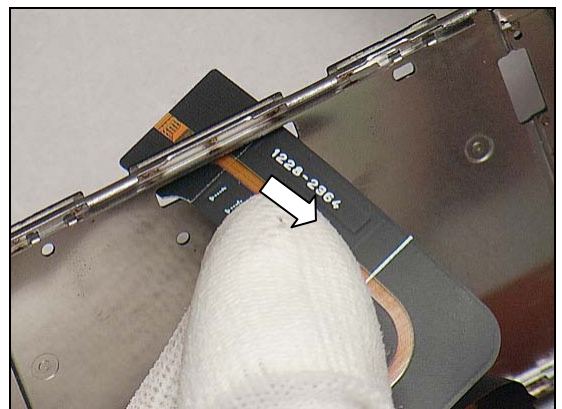
Detach to release the PBA H2H Flex from the adhesive on the Hinge assembly gently.



Turn it over and detach to release the PBA H2H Flex by using a flex film assembly tool.



Release the head of the PBA H2H Flex through the hole.



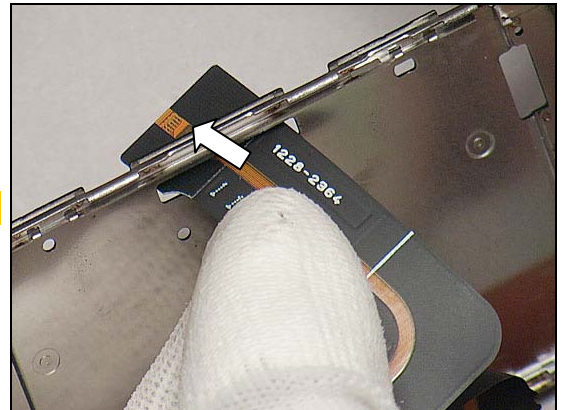


Replacement: PBA H2H Flex

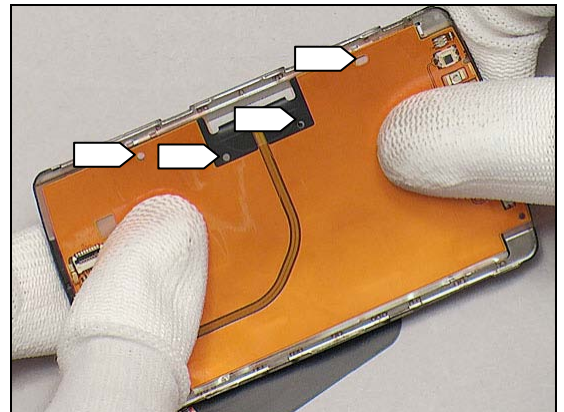
INSTALLATION

No reuse of this component

Insert the head of the PBA H2H Flex through the hole



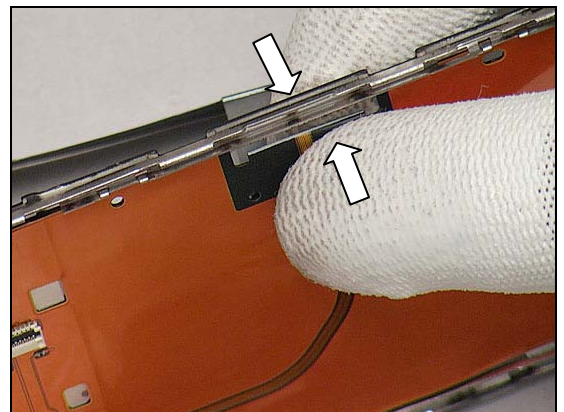
Place the PBA H2H Flex aligning to the four guiding poles.



Press around the surface to secure its attachment.



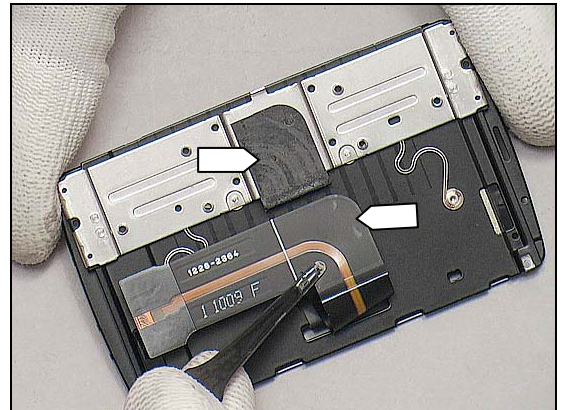
Press on both sides to fold the FPC through the hole aligning to the guiding line as shown.



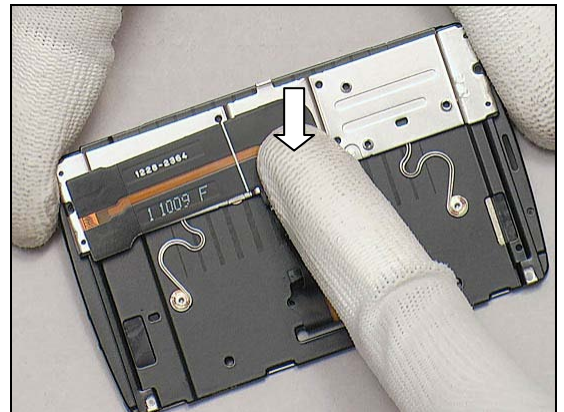


Replacement: PBA H2H Flex

Attach the FPC aligning to the adhesive of the Hinge assembly.



Press to secure its attachment.



Open the slider and fold the FPC aligning to the guiding line as shown.





Replacement

4.27 Plastic Cover Proximity

Follow the 3.2.1 – 3.2.3 Disassembly instructions!

Prepare a new Plastic Cover Proximity.

Follow the 5.1.2 – 5.1.4 Reassembly instructions!

REMOVAL

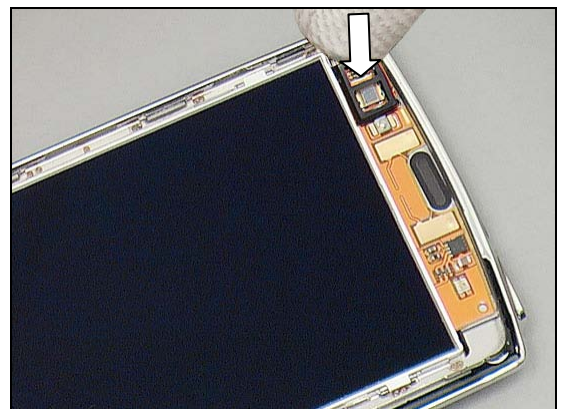
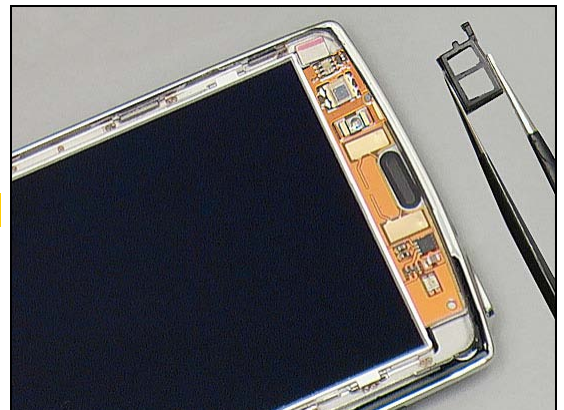
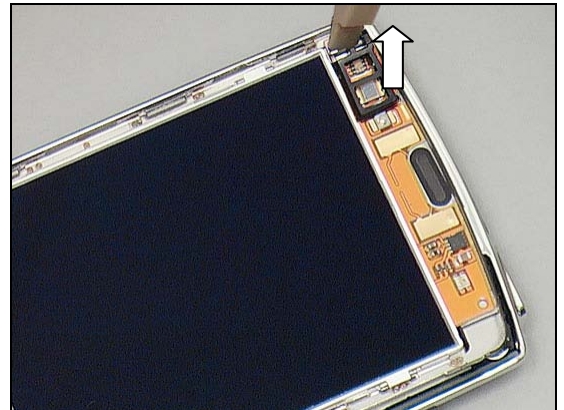
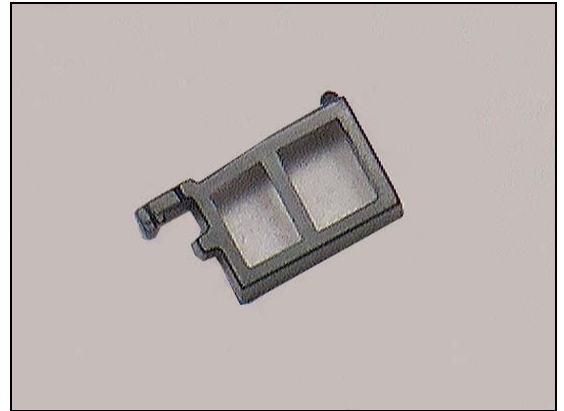
Detach to remove it gently.

INSTALLATION

No reuse of this component

Put a new Plastic Cover Proximity in place.

Press to secure its attachment.





Replacement

4.28 Hinge assembly

Follow the 3.2.1 – 3.2.4 Disassembly instructions!

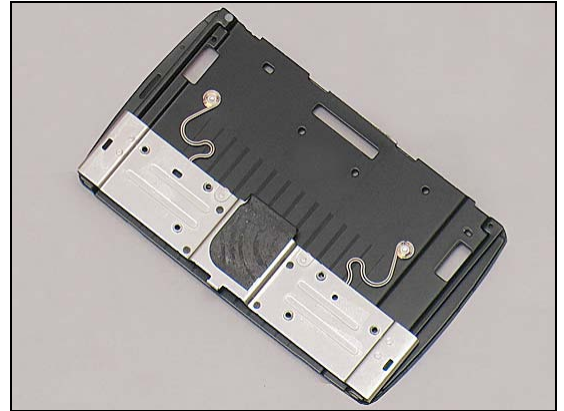
Follow the 3.1.3 – 3.1.8 Disassembly instructions!

Prepare a Hinge assembly, a new Plastic Cover Proximity, a new PBA H2H Flex and a new Center Qwerty Support

Follow the 4.26 PBA H2H Flex Installation instructions!

Follow the 4.27 Plastic Cover Proximity Installation instructions!

Follow 4.12 Center Qwerty Support!



Follow the 5.2.1 – 5.2.5 Reassembly instructions!

Follow the 5.1.1 – 5.1.2 Reassembly instructions!

Follow the 5.2.6 – 5.2.8 Reassembly instructions!



Replacement

4.29 Shield Can Lid BB

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

Prepare the new Shield Can Lid BB.

Follow the 4.21 Gasket Conductive 3,8x2,3 Installation instructions!

Follow the 5.2.3 – 5.2.8 Reassembly instructions!

REMOVAL

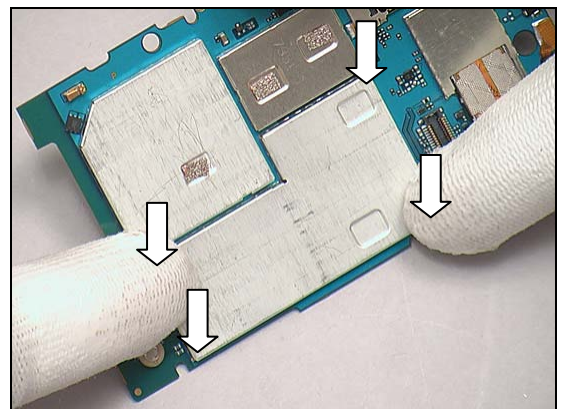
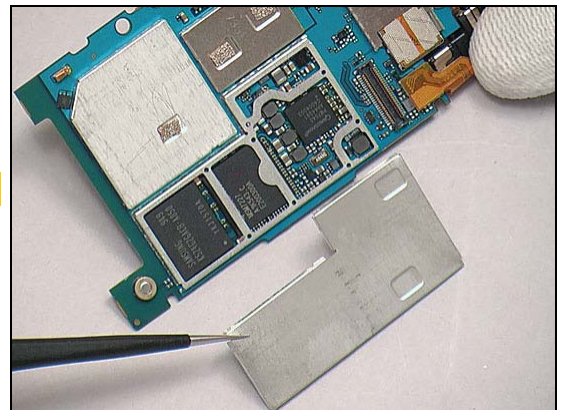
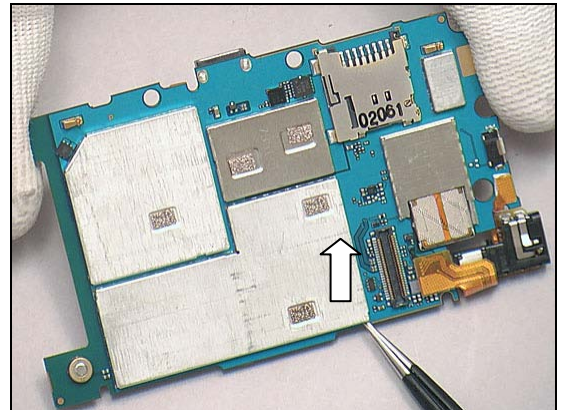
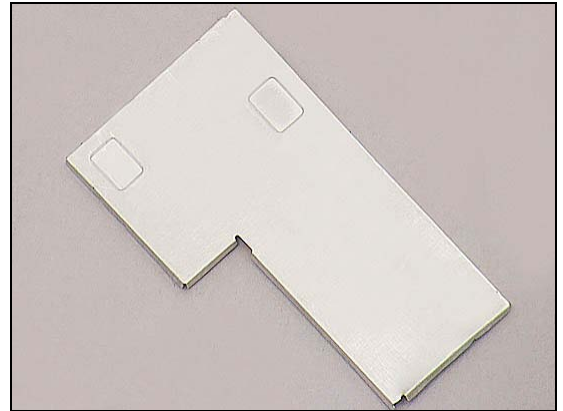
Unsnap the corners of the Shield Can Lid BB with a pair of tweezers and pull upwards to remove it.

INSTALLATION

No reuse of this component

Put a new Shield Can Lid BB in place.

Press to snap it.





Replacement

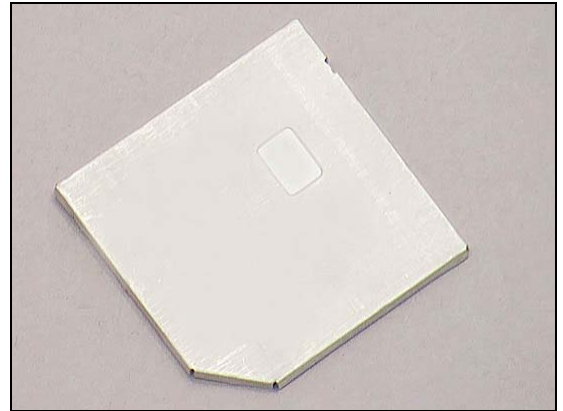
4.30 Shield Can Lid Radio

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

Prepare a new Shield Can Lid Radio.

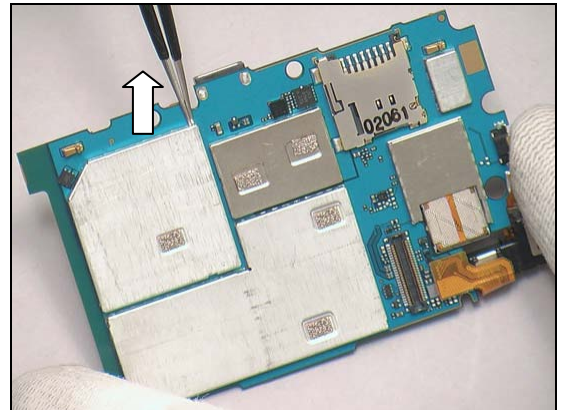
Follow the 4.21 Gasket Conductive 3,8x2,3 Installation instructions!

Follow the 5.2.3 – 5.2.8 Reassembly instructions!



REMOVAL

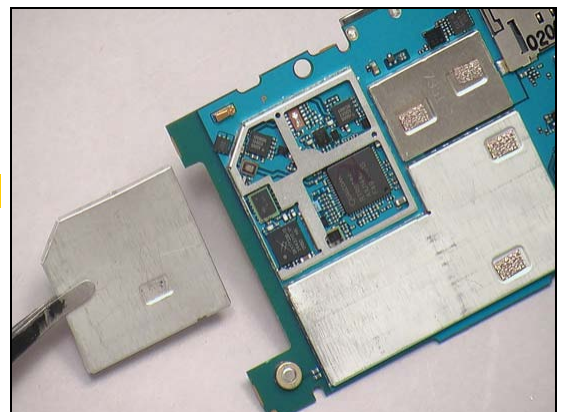
Unsnap the corners of the Shield Can Lid Radio with a pair of tweezers and pull upwards to remove it.



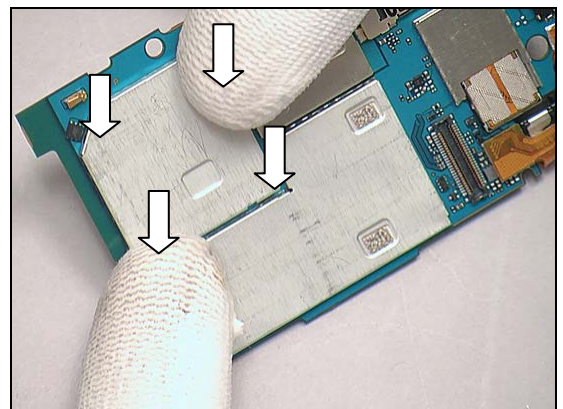
INSTALLATION

No reuse of this component

Put a new Shield Can Lid Radio in place.



Press to snap it.





Replacement

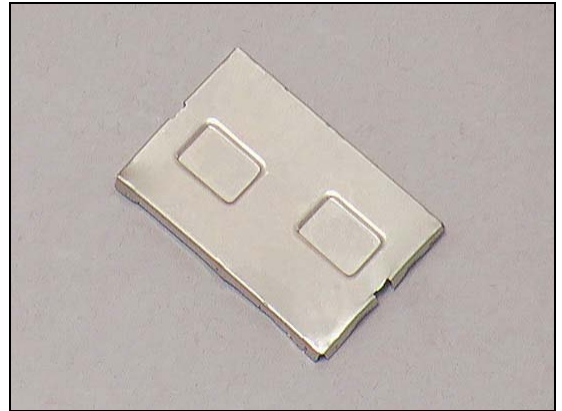
4.31 Shield Can Lid WLAN

Follow the 3.1.1 – 3.1.6 Disassembly instructions!

Prepare a new Shield Can Lid WLAN.

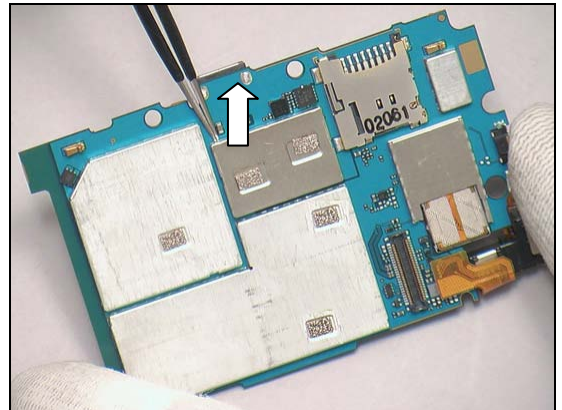
Follow the 4.21 Installation instructions!

Follow the 5.2.3 – 5.2.8 Reassembly instructions!



REMOVAL

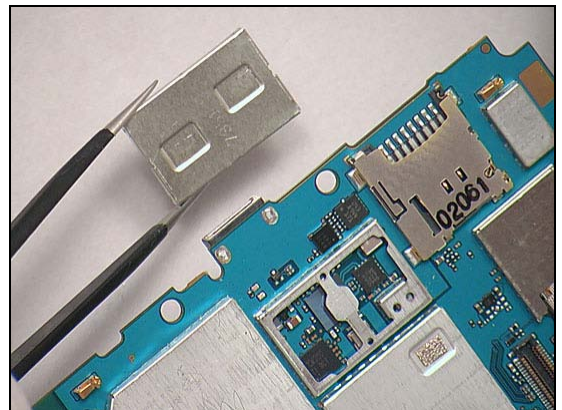
Unsnap the corners of the Shield Can Lid WLAN with a pair of tweezers and pull upwards to remove it.



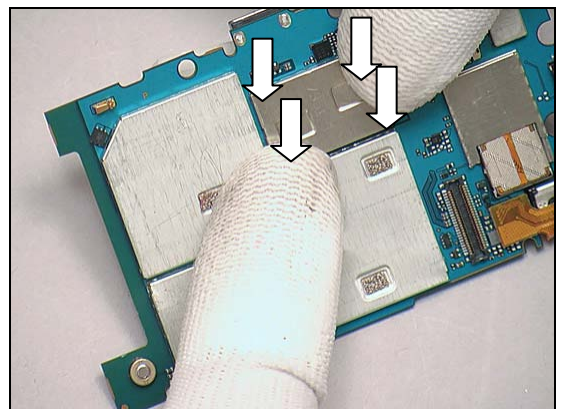
INSTALLATION

No reuse of this component

Put a new Shield Can Lid WLAN in place.



Press to snap it.





Replacement

4.32 Volume Key

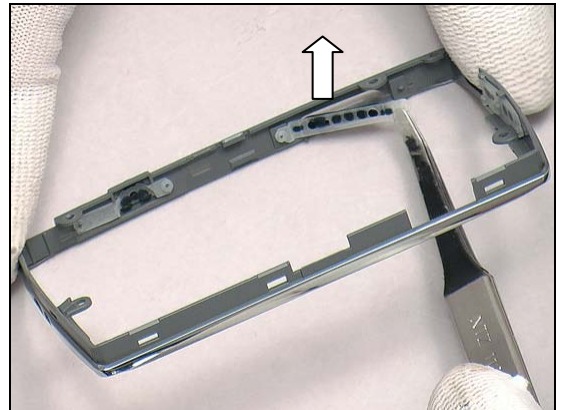
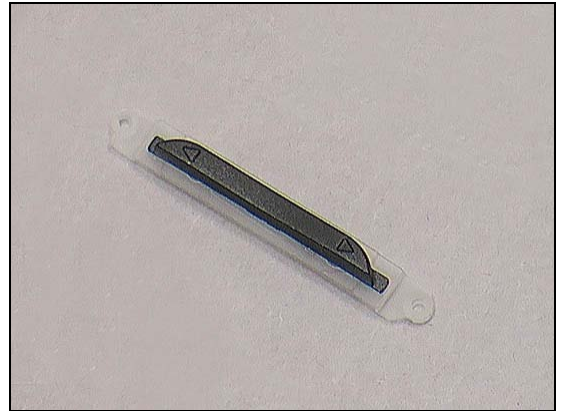
Follow the 3.1.1 – 3.1.4 Disassembly instructions!

Prepare a Volume Key.

Follow the 5.2.5 – 5.2.8 Reassembly instructions!

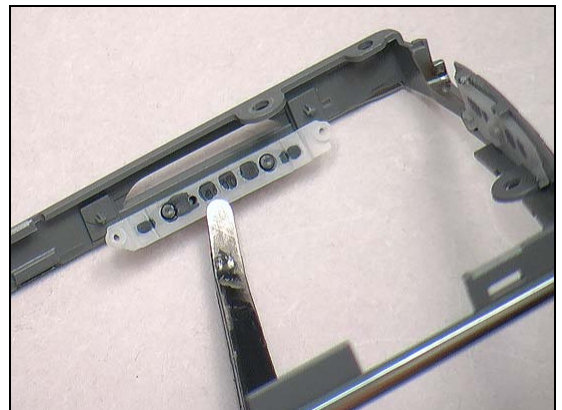
REMOVAL

Lift to remove it from the Base Cover Middle Deco belt Assy.

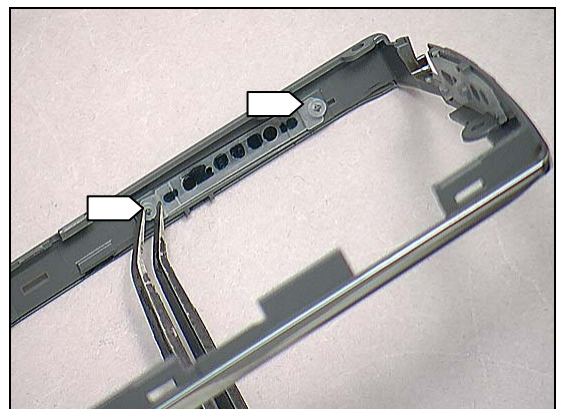


INSTALLATION

Place the Volume Key with proper direction into the slot.



Align the key by using two guiding pins as shown.





Replacement

4.33 Water Indicator 3x3

Follow the 3.2.1 – 3.2.3 Disassembly instructions!

Follow the 3.1.1 – 3.1.5 Disassembly instructions!

Prepare a new Water Indicator 3x3.

Follow the 5.1.2 – 5.1.4 Reassembly instructions!

Follow the 5.2.4 – 5.2.8 Reassembly instructions!

REMOVAL

Detach to remove the activated Water Indicator carefully.

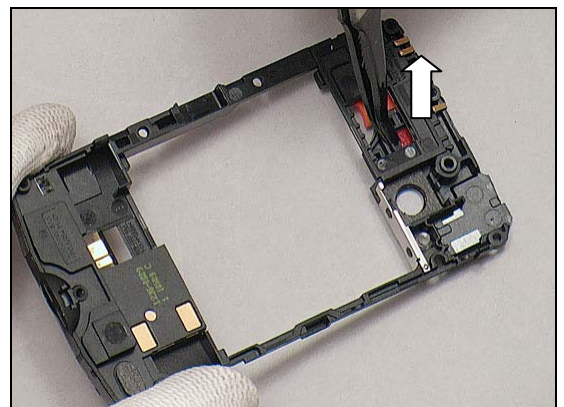
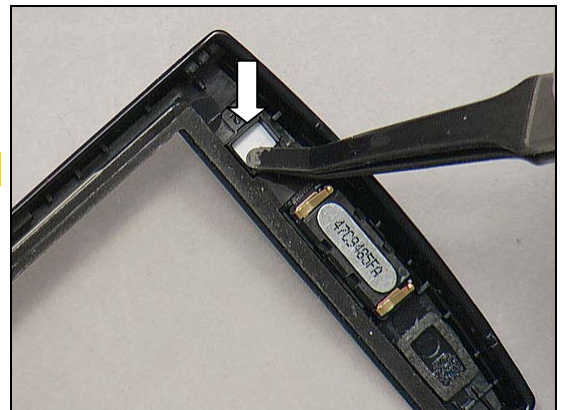
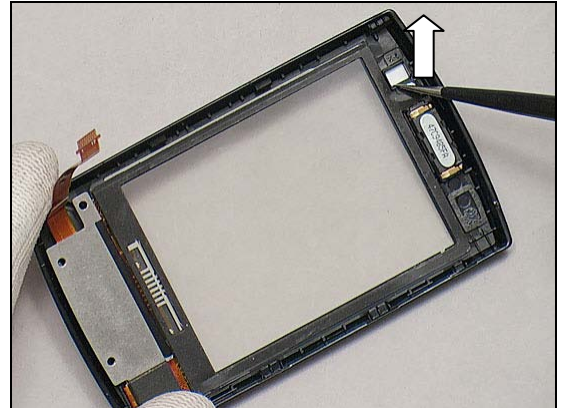
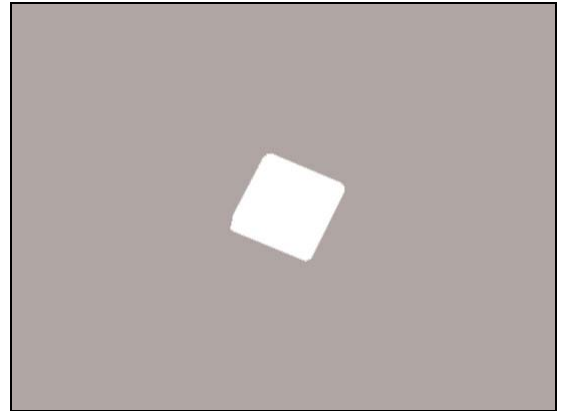
INSTALLATION

No reuse of this component

Attach a new Water Indicator into the cavity.

REMOVAL

Detach to remove the activated Water Indicator with the flex film assembly tool.

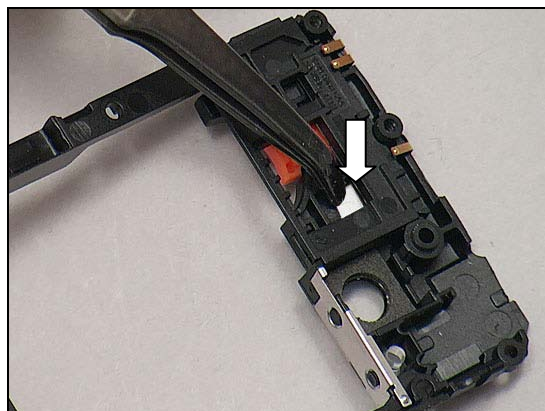


Replacement: Water Indicator 3x3

INSTALLATION

No reuse of this component

Attach a new Water Indicator into the cavity.



Replacement: Board Swap

4.34 Board Swap - Replacement

Follow the 3.1.3 – 3.1.6 Disassembly instructions.

Follow the 4.7 and 4.24 Removal instructions.

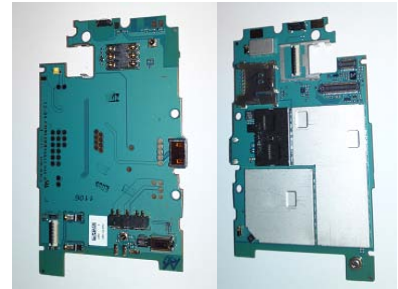
Replace the Swap Board.

Reuse the Camera 3 MPixel and PBA AVP Assy

Follow the 4.7, 4.19, 4.21(5 pcs) and 4.24 Installation instructions.

Follow the 5.2.3 – 5.2.6 Reassembly instructions.

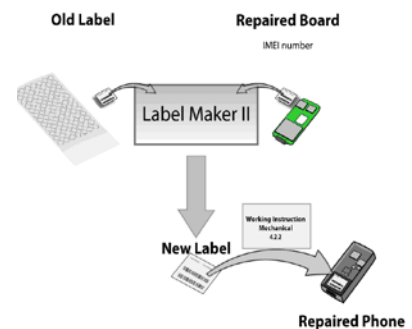
Startup the unit to initialize settings, before performing Customize Phone in Emma.



4.35 Board Swap – Change Label

CHANGE LABEL

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



4.36 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

5.1 Upper Unit

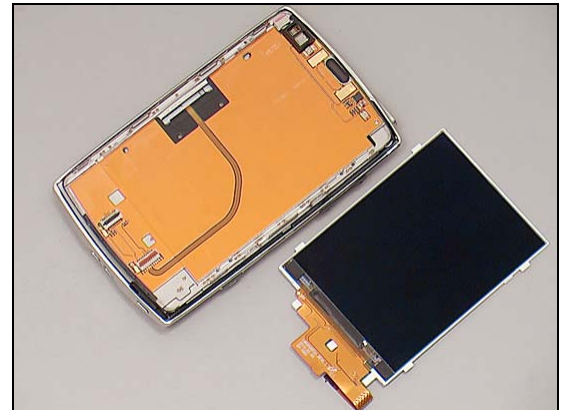
The reassembly is done in the following order:

1. Display
2. Front Cover Assembly
3. Battery Cover (a) & Battery (b)



5.1.1 Display

Place the Display and the unit in place.



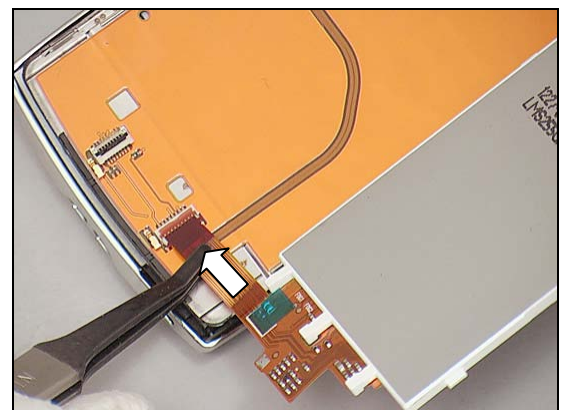
Place the Tape Insulation Touch on the H2H flex (prevents a grounding problem seen on a few LCDs which may result in ghost keys).

Do not place the Tape Insulation Touch over the cavity!
Make sure the Tape Insulation Touch is assembled next to the edge of the hinge assembly!

No reuse of this component



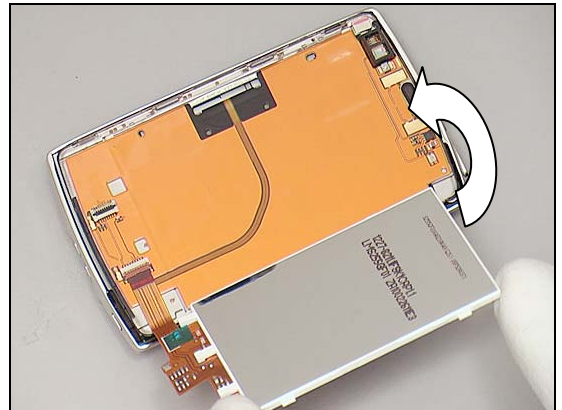
Connect the ZIF connector at the bottom side.



Reassembly: Upper Unit

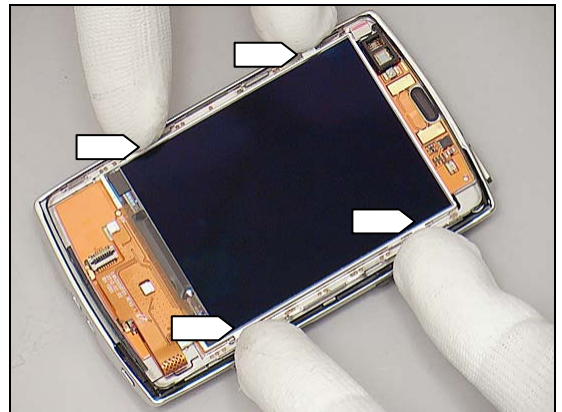
Turn the Display over carefully.

Do not touch the screen!



Press to snap the four hooks of the Display.]

Do not touch the screen!



5.1.2 Front Cover Assembly

Warning!

It is very important that the units is placed in the front cover fixture

Place the Front Cover Assembly beside the unit.

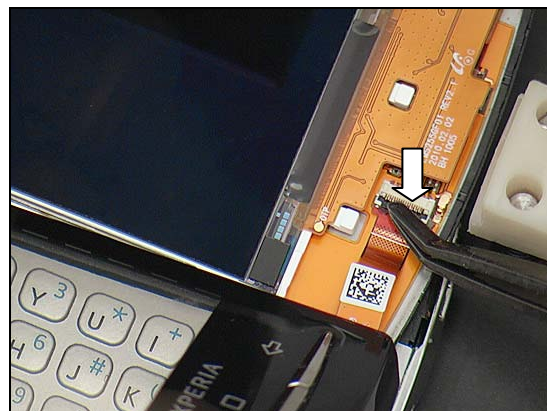


Connect the ZIF connector by using a flex film assembly tool.



Reassembly: Upper Unit

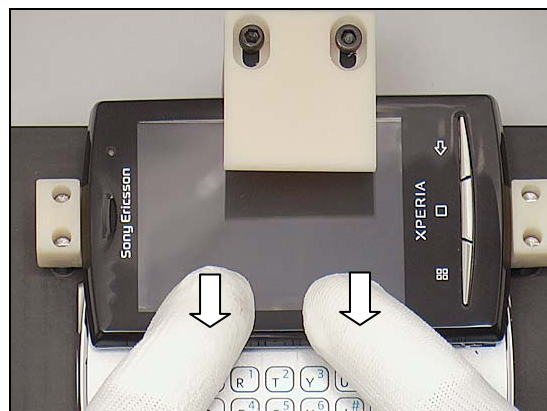
Lock the ZIF connector.



Push one side of the Front Cover Assembly to install.



Press to snap the Front Cover Assy with fingers.



5.1.3 Battery

Close the slider and turn it over.

Put the Battery in place.



Reassembly: Upper Unit

Press the Battery into its cavity.



5.1.4 Battery Cover

Hook the Battery Cover from this side.

Make sure the USB connect is inserted!



Press to snap it.



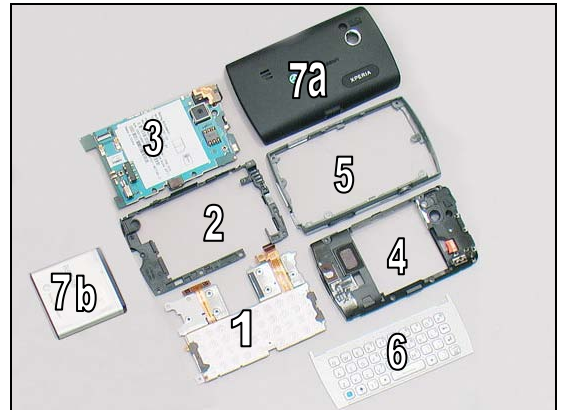


Reassembly

5.2 Lower Unit

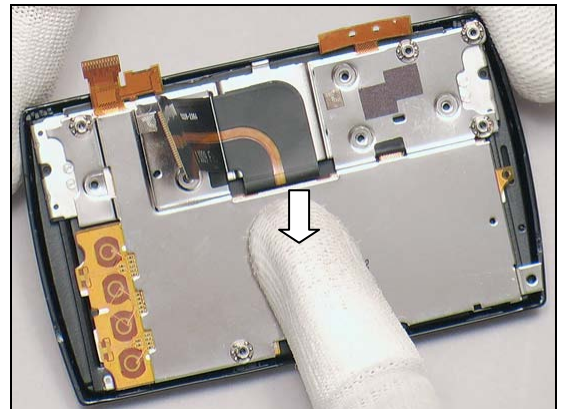
The reassembly is done in the following order:

1. Carrier Metal Qwerty Support Assy
2. Carrier Plastic Qwerty Support Assembly
3. PBA Assy
4. Bottom Carrier Frame Assy
5. Base Cover Middle Deco belt Assy
6. Keyboard
7. Battery Cover (a) & Battery (b)

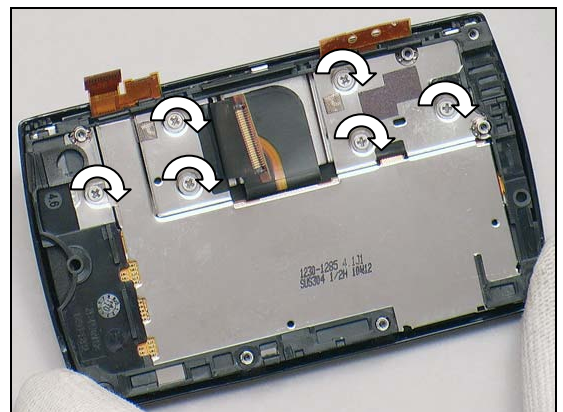


5.2.1 Carrier Metal Qwerty Support Assy

Place the Carrier Metal Qwerty Support Assy on to the Unit aligning to the six screw pins.



Apply 15Ncm \pm 1.5Ncm torque when tightening the six new Screw Philips Len:1.6 Diam:1.4 Screw M1, with JCIS No.0 bit.



Attach a new Cushion 0.0 mmConductive Camera Support onto the unit.

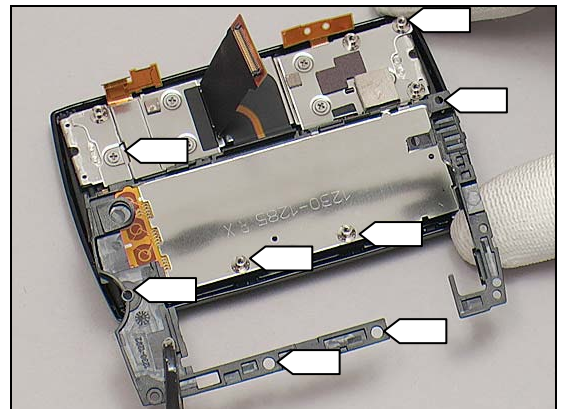




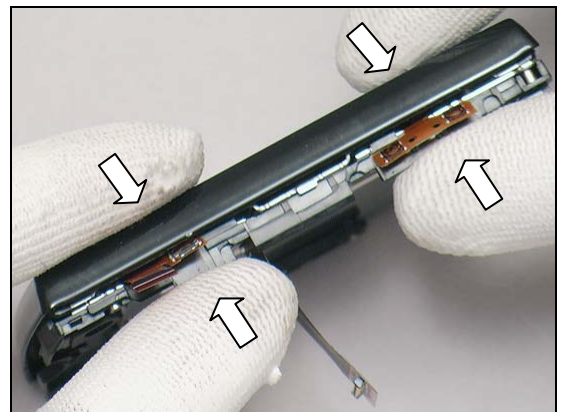
Reassembly: Lower Unit

5.2.2 Carrier Plastic Qwerty Support Assy

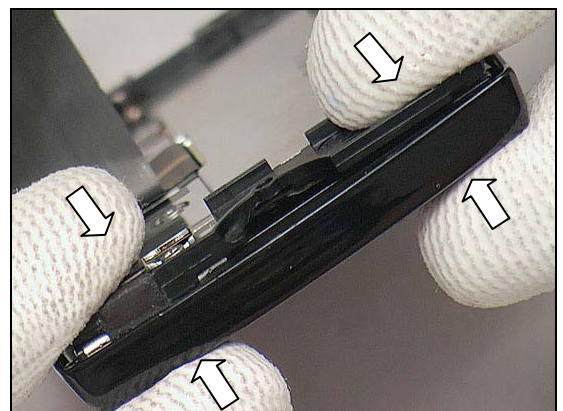
Place the Carrier Plastic Qwerty Support Assy aligning the four screw pins.



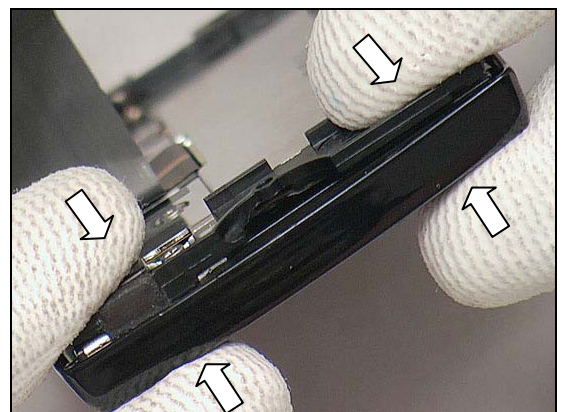
Press to snap this side.



Do the same for the bottom side.

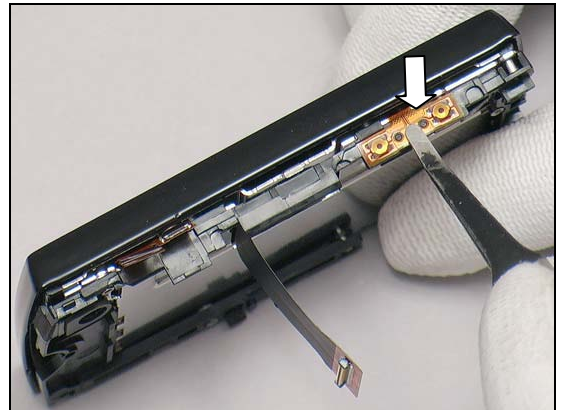


Do the same for the top side.

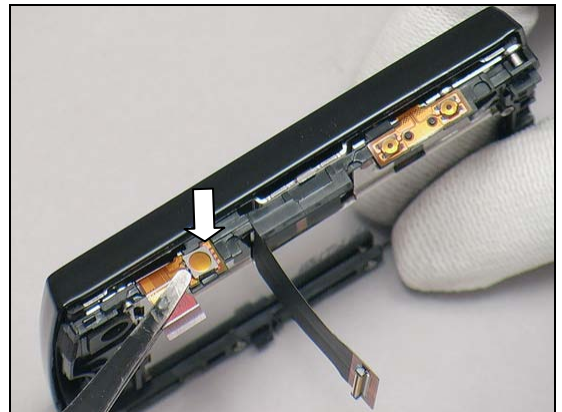


Reassembly: Lower Unit

Attach the side key FPC aligning to the two guiding poles as shown.



Do the same for the other FPC.

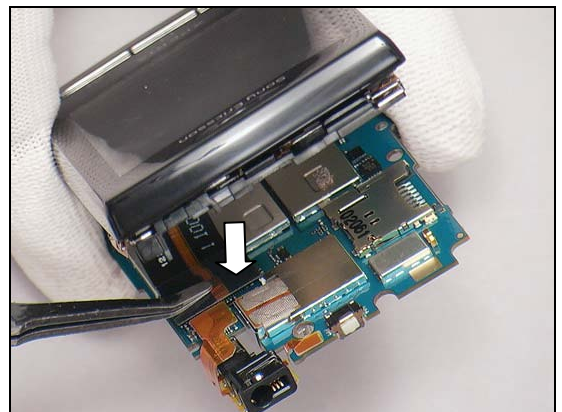


5.2.3 PBA Assy

Place the PBA Assy at 45° approximately below the Unit as shown



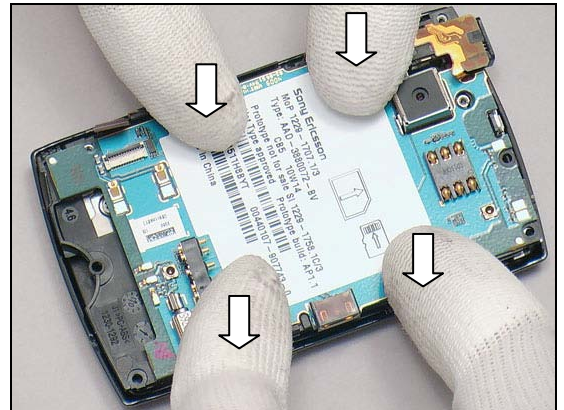
Press to snap the BtB connector by using a flex film assembly tool.





Reassembly: Lower Unit

Turn the PBA Assy to horizontal position and press to snap it as shown.



Connect the ZIF connector by using a flex film assembly tool.

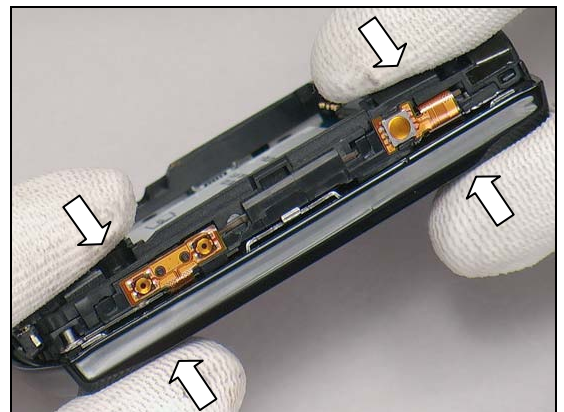


5.2.4 Bottom Carrier Frame Assy

Put the Bottom Carrier Frame Assy onto the Unit.

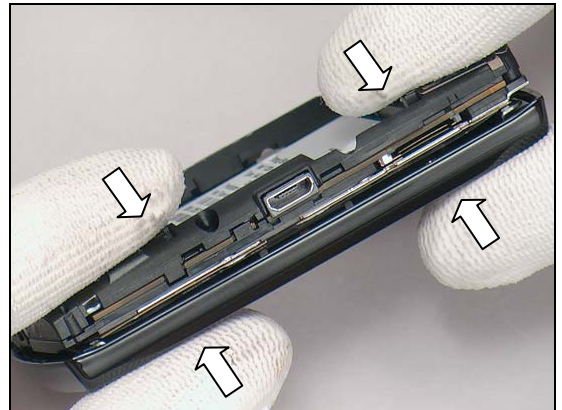


Press to snap this side.



Reassembly: Lower Unit

Do the same for the opposite side.



Apply 10 Ncm torque when tightening the three new Screw Philips Len:3.0 Diam:1.4 with JCIS No.0 bit.



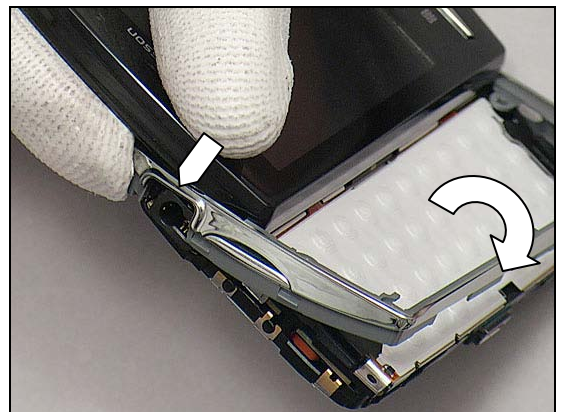
5.2.5 Base Cover Middle Deco belt Assy

Turn the Unit over and slide it to open position.

Thread the Base Cover Middle Deco belt Assy onto the unit as shown.



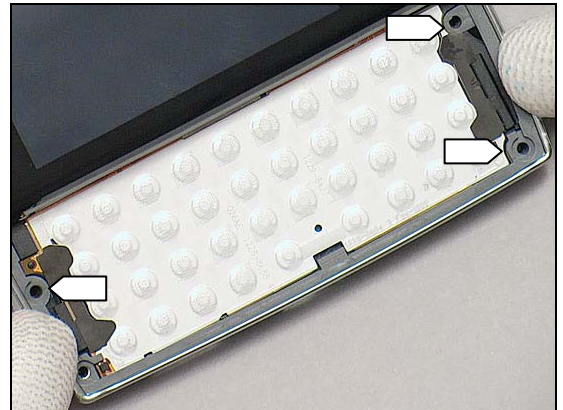
Turn the Base Cover Middle Deco belt Assy horizontally and pull it a little to hook the audio jack into the cavity of the Base Cover Middle Deco belt Assy.



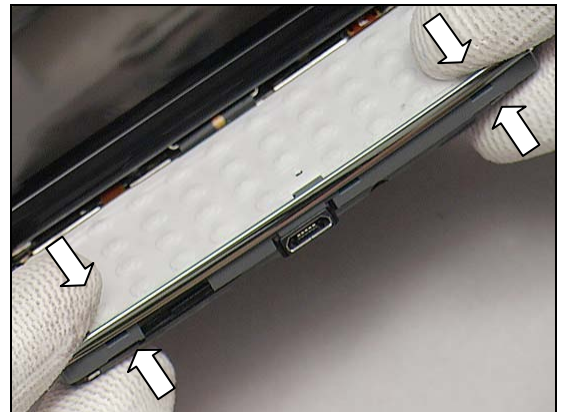


Reassembly: Lower Unit

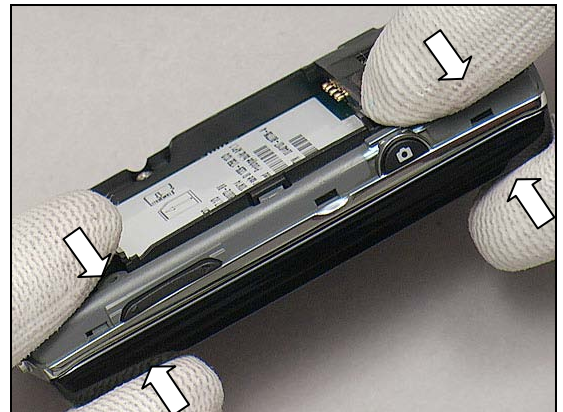
Press to hook the three screw holes into the cavity as shown.



Press to snap the hooks of this side as shown.



Do the same for the opposite side.



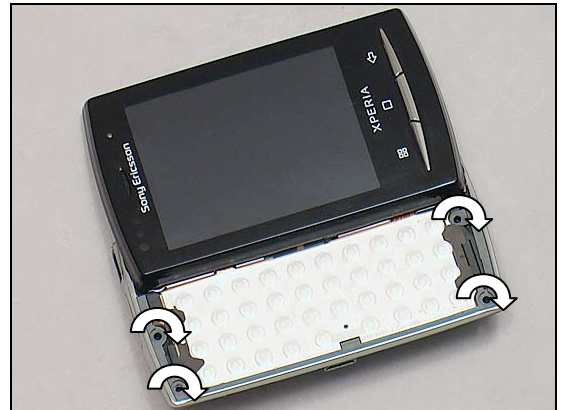
Apply 10 Ncm torque when tightening the three new Screw Philips Len:5.5 Diam:1.4 with JCIS No.0 Bit.





Reassembly: Lower Unit

Apply 15 Ncm torque when tightening the four new Screw
Torx T5 Len:5.0 Diam:1.6 No color with Torx Bit No. 5.



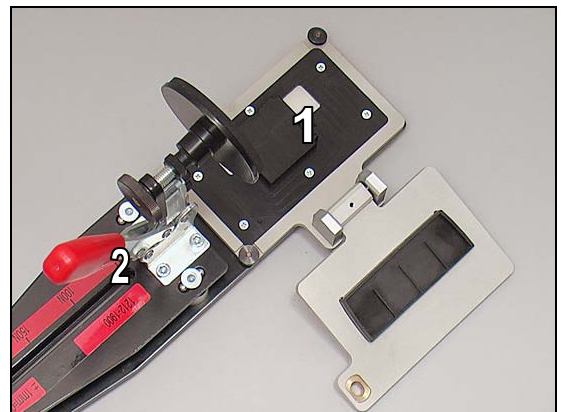
5.2.6 Keyboard

Remove the Front Cover Assembly.

Follow the 3.2.3 Disassembly instructions!



Fasten the fixture (1) to the Pressure tool (2).

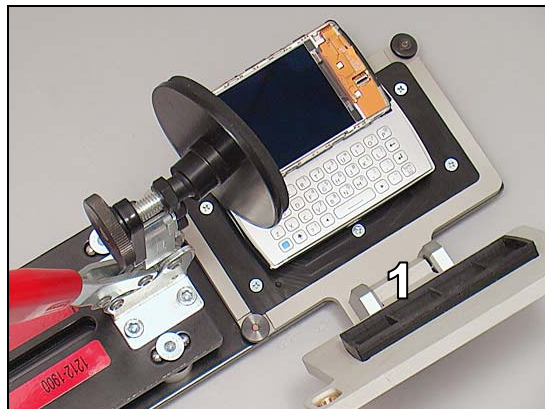


Attach a new Keyboard onto the unit.

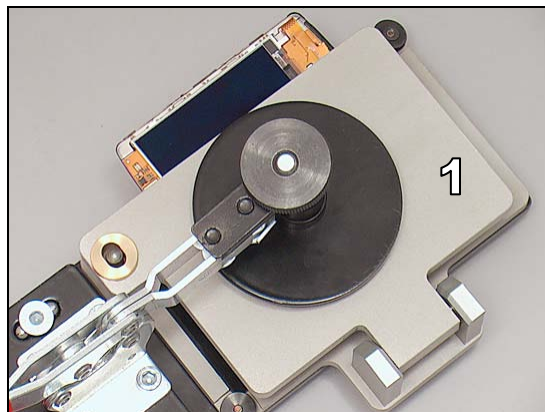


Reassembly: Lower Unit

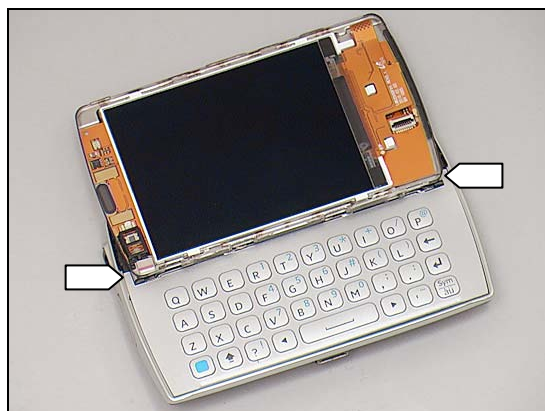
Put the phone in the fixture (1) as shown.



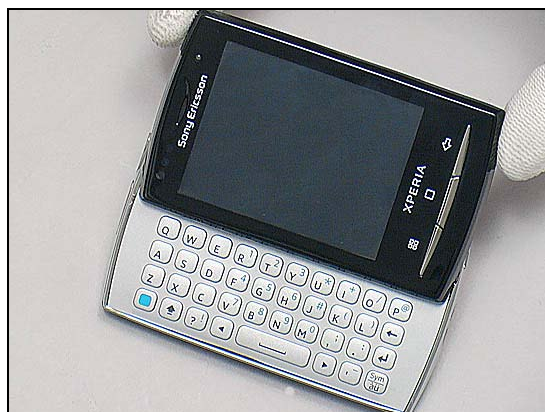
Fasten the phone in fixture (1).
Press it with a pressure value of 50N for eight seconds.



Make sure these two corners are securely pressed!



Reassembly the Front Cover Assembly.
Follow the 5.1.2 Reassembly instructions!



Reassembly: Lower Unit

5.2.7 Battery

Close the slider and turn it over.
Put the Battery in place.



Press the Battery into its cavity.



5.2.8 Battery Cover

Hook the Battery Cover from this side.

Make sure the USB connect is inserted!



Press to snap it.





6 Revision History

Rev.	Date	Changes / Comments
1	2010-June-28	Initial release
2	2010-Sept-14	Corrected chapter information for Plastic Cover Proximity from 4.28 to 4.27 and Warning that Front cover fixture needs to be used.
3	2010-11-25	Add of Board Swap info
4	2010-12-27	3.13 Keyboard has information added about the PBA H2H flex. 5.11 Display has had Tape Insulation touch added.
5	2011-02-01	5.11 Tape Insulation touch, don't reuse added.