



# Working Instruction, Mechanical

Applicable for Z770i

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# 1 Introduction

Z770i



## 1.1 Equipment

### SPECIAL TOOLS

- NTZ 112 459 Torque screwdriver (or equivalent)
- NTZ 112 288 Torx bit T6
- NTZ 112 478R1 Torx bit T5
- NTZ 122 521 Flex film assembly tool
- NTZ 112 302/2 Front opening tool



### STANDARD TOOLS

- Dentist hook
- Blunt pair of tweezers
- Guitar pick



### ESD EQUIPMENT

Protect the phone from ESD damage whenever it is opened by using:

- ESD-wristband
- ESD-gloves



### LABEL EQUIPMENT

The following special equipment is required when replacing or installing a new label:

- Hot air flow solder station
- Zebra printer connected to a computer





## 1.2 General Cautions

The following cautions are considered to be generic for all phone models and will not be repeated in the Disassembly, Replacements and Reassembly sections:

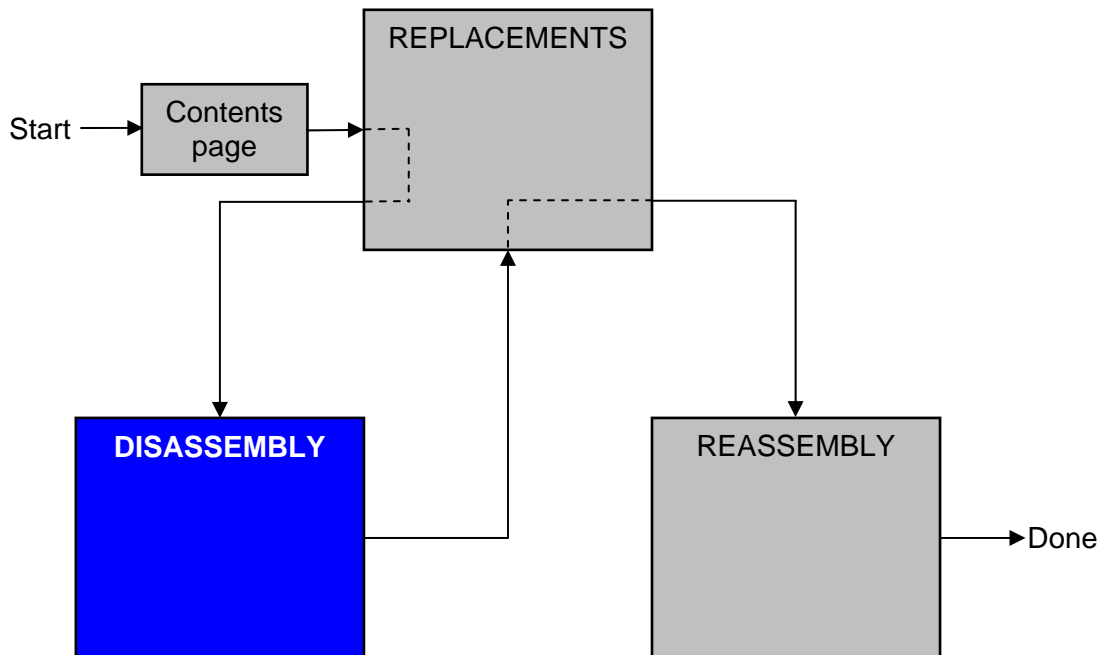
- ***SWITCH OFF THE PHONE AND REMOVE ANY MEMORY STICK BEFORE THE START OF THE DISASSEMBLY!***
- ***KEEP ALL CONTACT SURFACES CLEAN!***
- ***BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, OPENING TOOLS, GUITAR PICK ETC. TO AVOID SCRATCHES OR DAMAGES TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!***
- ***BE CAREFUL NOT TO DAMAGE ANY CONTACT SPRINGS!***
- ***REMEMBER TO REMOVE THE PROTECTION FOILS ON NEW PARTS SUCH AS THE FRONT COVER AND LCD!***
- ***NEVER TOUCH THE DISPLAY GLASS!***
- ***USE AIR BLOW EQUIPMENT TO KEEP THE FRONT WINDOW AND DISPLAY MODULE DUST FREE!***

## 1.3 Adhesives

Use a dentist hook and/or the tweezers to remove old adhesives.  
Clean the surface before attaching new adhesives.

## 2 Disassembly

When you are going to replace a part being listed in *Replacements*, the instruction of that section usually begins by directing you to this *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before returning to *Replacements* for the actual replacement.



### 2.1 Lower Unit

The disassembly is done in the following sequence:

1. Battery Cover (a) and Battery (b)
2. Lower Outer Screw Caps (not to be reused)
3. Lower Outer Assembly
4. PCBA
5. Hinge Clip (a) and Hinge (b)
6. Lower Inner Assembly





## 2.1.1 Battery Cover and Battery

Press on the top of the *Battery Cover* and push it forward to open up a gap.



Lift off the *Battery Cover*.



Place your finger here.



Raise and remove the *Battery*.



## 2.1.2 Lower Outer Screw Caps

Insert the dentist hook under one of the *Lower Outer Screw Caps* to detach it and then remove.



Repeat for the second *Screw Cap*.

***THE SCREW CAPS CANNOT BE REUSED AND MUST BE DISCARDED!***

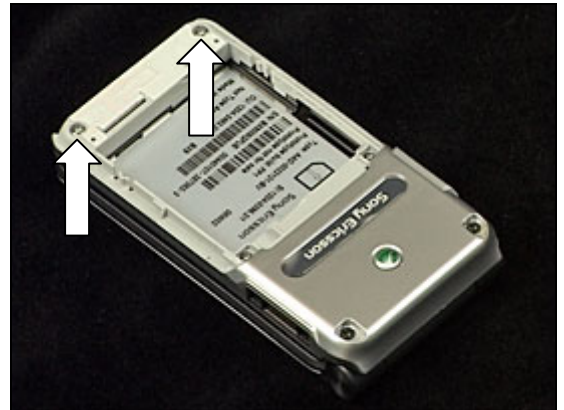




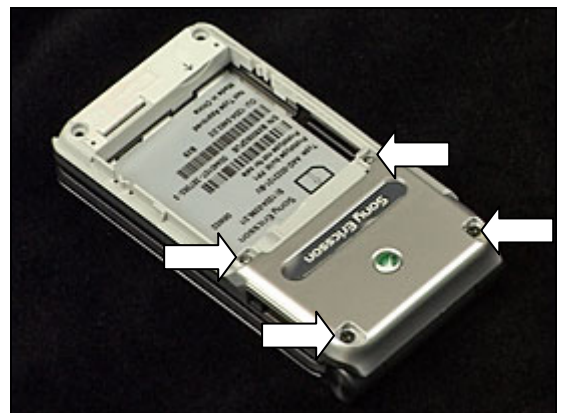


## 2.1.3 Lower Outer Assembly

Use torx bit T6 to remove the two Screws.



Use torx bit T5 to remove the four Screws.



There are seven snap hooks located as shown that have to be unlatched.



Insert the guitar pick at the bottom end of the phone and slide along the side to unlock the snap hooks. If necessary, slide back and forth until all hooks are unlatched.



## Lower Outer Assembly *continued*

Repeat for top of the phone.



Repeat for the opposite side.



Carefully lift off the *Lower Outer Assembly*.



## 2.1.4 PCBA

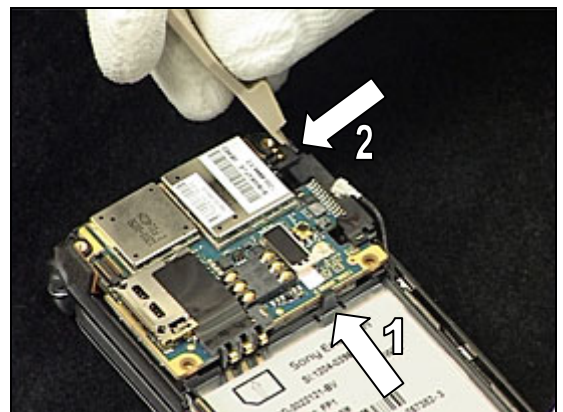
Disconnect the *Main Keyboard FPC* connector with the front opening tool.



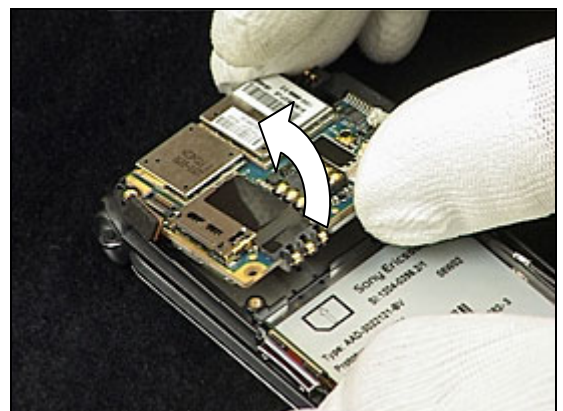
Disconnect the *Antenna Sub PCBA* connector with the tweezers as shown.



Unlatch the two snap hooks with the front opening tool.

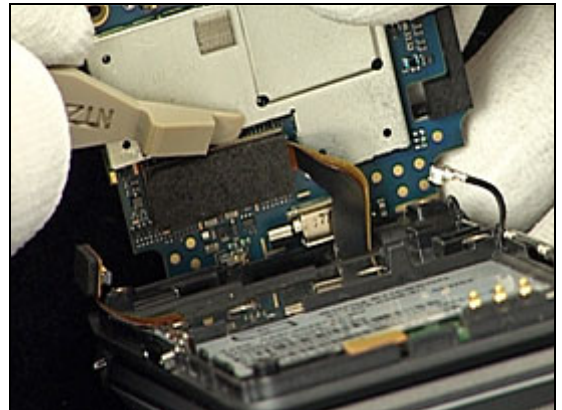


Lift the *PCBA* at the top and carefully turn it as shown to get access to the *Main Hinge FPC* connector on the other side of the *PCBA*.



## PCBA continued

Disconnect the *Main Hinge FPC* connector with the front opening tool.



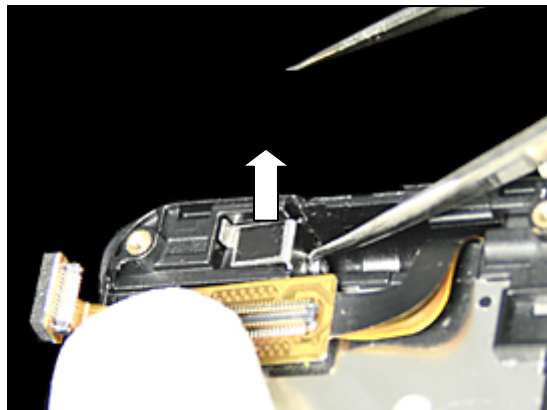
The *PCBA* removed.



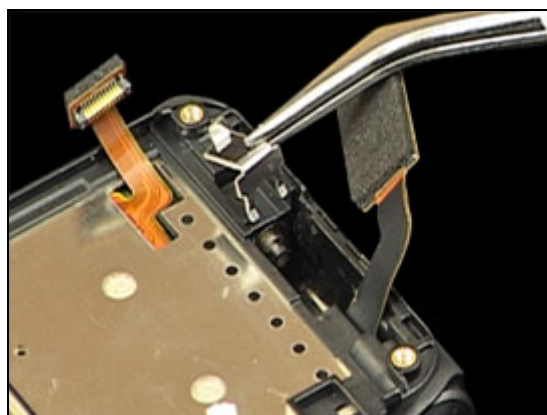


## 2.1.5 Lower Inner Assembly

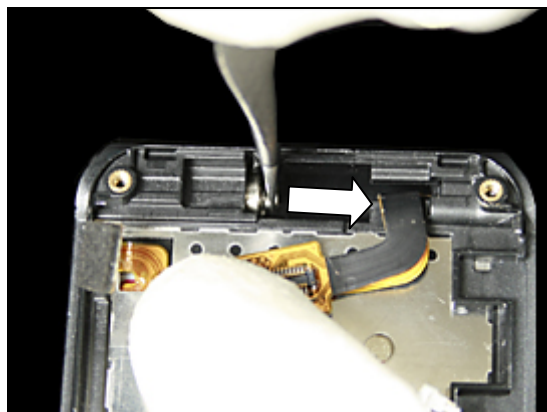
Use the tweezers to raise the *Hinge Clip* from its position.



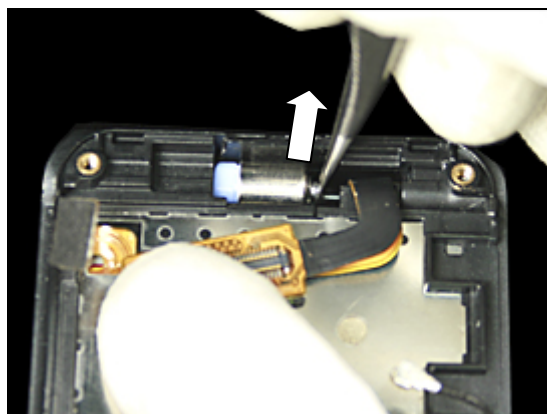
Remove the *Hinge Clip* with the tweezers.



Use the tweezers to pull the *Hinge* out of its cavity.



Remove the *Hinge*.



## Lower Inner Assembly *continued*

Move the *Lower Inner Assembly* in the direction of the arrow, until one end of the hinge section is separated from the upper unit.



Slide the flex film out of the hole in the *Lower Inner Assembly* in the direction of the arrow.



Separate the lower unit completely from the upper unit.





## 2.2 Upper Unit

The disassembly is done in the following sequence:

1. Co Brand Inner (not to be reused)
2. Inner Stoppers (not to be reused)
3. Upper Outer Cover Assy
4. Main Hinge FPC
5. Display 2.2 TFT
6. Upper Inner Cover Assy



## 2.2.1 Co Brand Inner

***BE CAREFUL NOT TO DAMAGE THE UPPER INNER COVER DURING THIS OPERATION!***

Carefully insert the dentist hook under the *Co Brand* to detach it.



Remove the *Co Brand* with the tweezers.

***THE CO BRAND CANNOT BE REUSED AND MUST BE DISCARDED!***



## 2.2.2 Inner Stopper

***BE CAREFUL NOT TO DAMAGE THE UPPER INNER COVER DURING THIS OPERATION!***

Carefully insert the dentist hook under one of the *Inner Stoppers* to detach it and then remove.



Do the same with the second *Inner Stopper*.

***THE INNER STOPPERS CANNOT BE REUSED AND MUST BE DISCARDED!***



## 2.2.3 Upper Outer Cover Assy

Use torx bit T5 to remove the four screws.



There are six snap hooks located as shown that have to be unlatched.



Insert the guitar pick as shown and slide it along the side to unlatch the snap hooks. If necessary, slide back and forth until all the hooks are unlatched.



Repeat for the end of the cover.

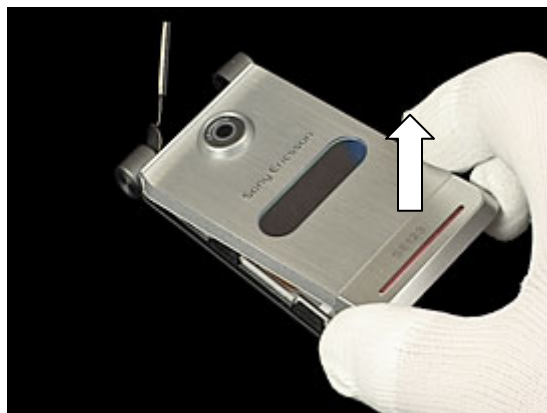


## Upper Outer Cover Assy continued

Repeat for the opposite side.



Carefully lift off the *Upper Outer Cover Assy*.

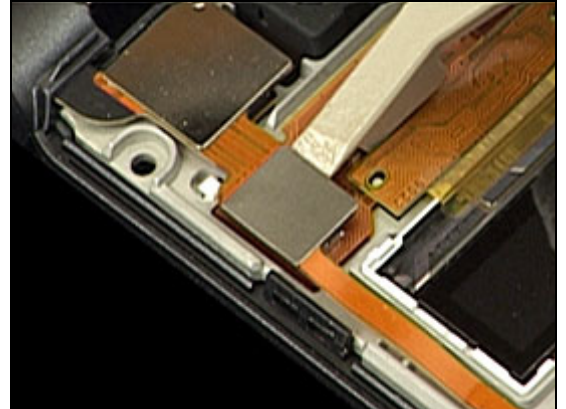


The *Upper Outer Cover Assy* removed.

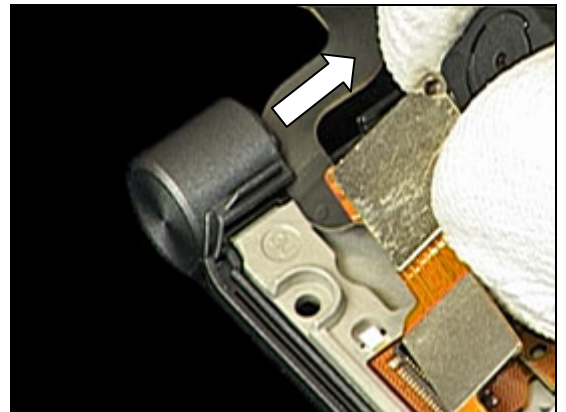


## 2.2.4 Upper Inner Cover Assy

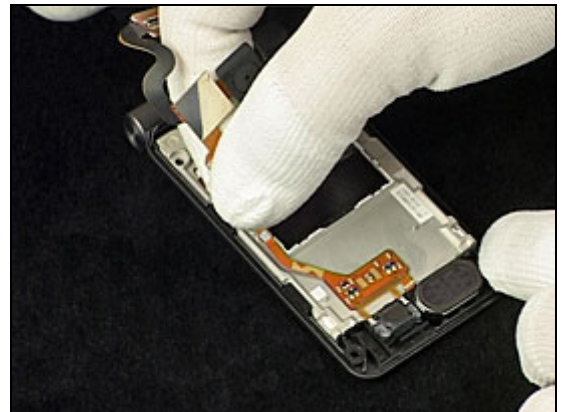
Disconnect the connector with the front opening tool.



Carefully slide the flex film out of the hinge section in the direction of the arrow.



Carefully lift the *Main Hinge FPC* and detach it from the *Display frame*.



*Main Hinge FPC* removed.

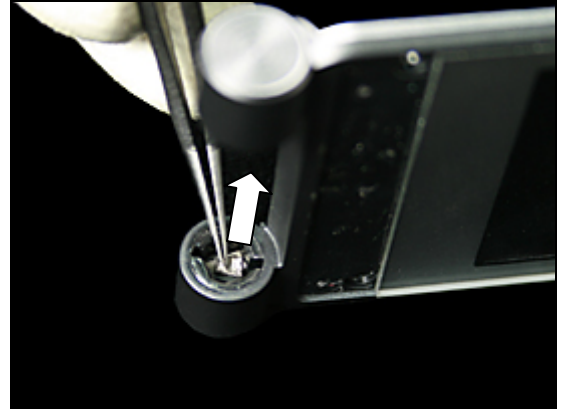




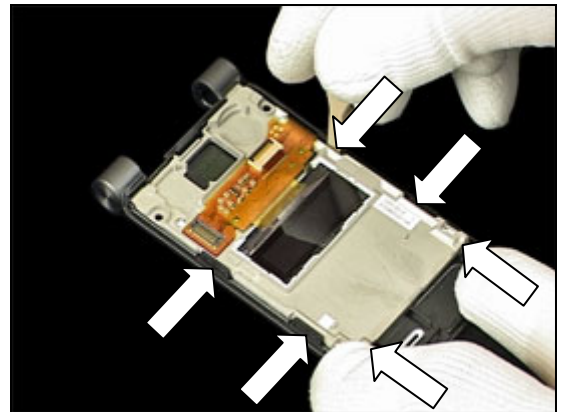
## Upper Inner Cover Assy *continued*

Remove the *Gasket Hinge* from the *Display* frame with the tweezers.

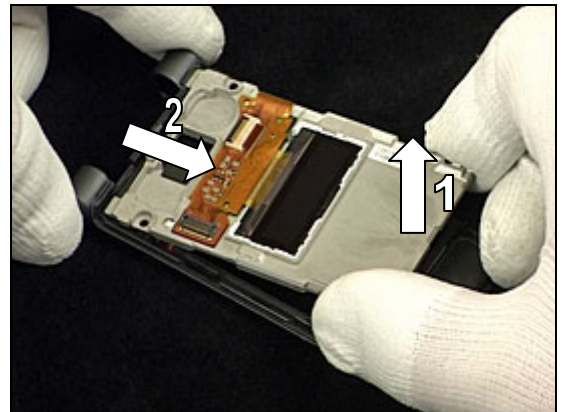
**THE GASKET CANNOT BE REUSED AND MUST BE DISCARDED!**



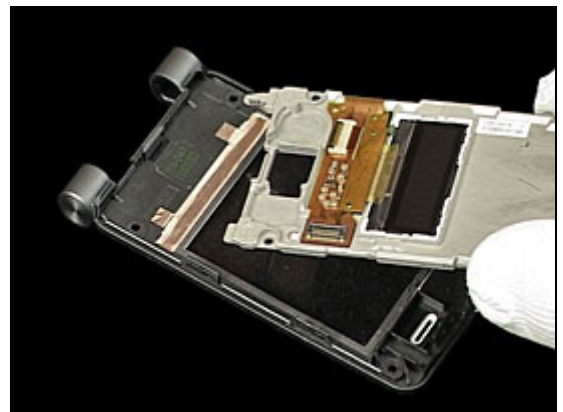
Use the front opening tool to unlatch the six snap hooks.



Lift the *Display* at the top in a slight vertical angle (1) and carefully pull it in the direction of the arrow (2).



Remove the *Display*.



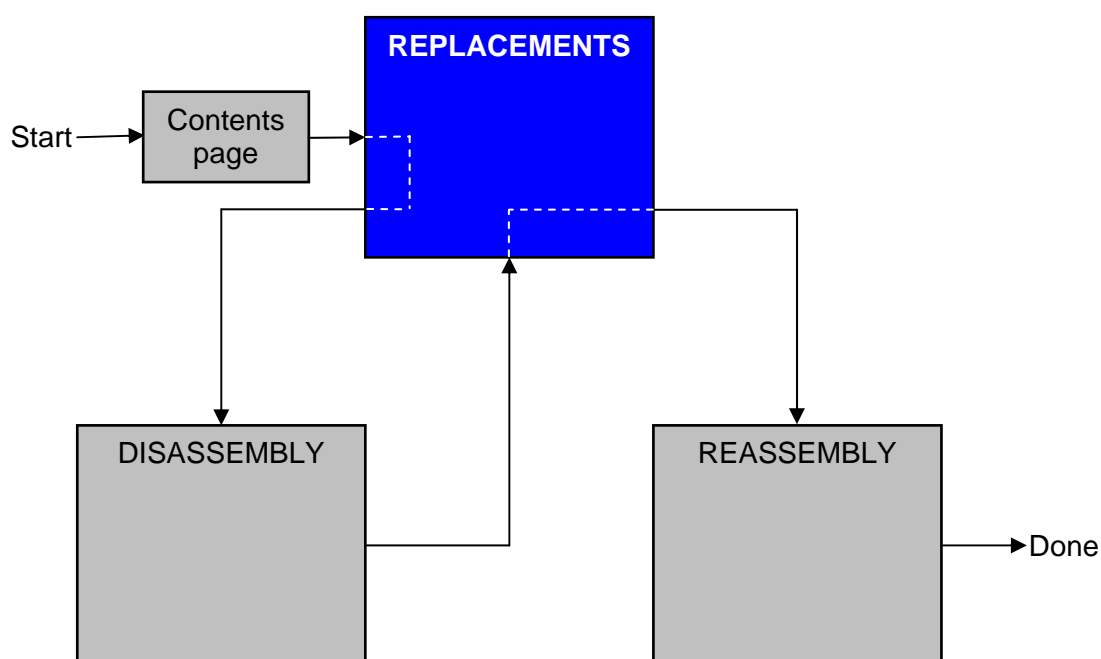
### 3 Replacements

Search for the part to be replaced on the Contents page and go to that instruction to be found in this *Replacements* section.

The instruction usually begins by directing you to the *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before the actual replacement.

Go back to this *Replacements* section and carry out the instruction.

The instruction usually ends by directing you to the *Reassembly* section with a specification of the instructions you have to carry out in order to reassemble the phone.





### 3.1 Battery Cover

*Follow the 2.1.1 Disassembly instructions!*

Prepare the new *Battery Cover*.

*Follow the 4.2.5 Reassembly instructions!*

### 3.2 Lower Outer Screw Caps

*Follow the 2.1.2 Disassembly instructions!*

Prepare the new *Lower Outer Screw Caps*.

*Follow the 4.2.4 Reassembly instructions!*

### 3.3 Lower Outer Assembly

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Prepare the new *Lower Outer Assembly*.

*Follow the 4.2.3 – 4.2.5 Reassembly instructions!*

### 3.4 Lower Inner Assembly

*Follow the 2.1.1 – 2.1.5 Disassembly instructions!*

Prepare the new *Lower Inner Assembly*.

*Follow the 4.2.1 – 4.2.5 Reassembly instructions!*

### 3.5 Hinge and Hinge Clip

*Follow the 2.1.1 – 2.1.5 Disassembly instructions!*

Prepare the new *Hinge and Hinge Clip*.

*Follow the 4.2.1 – 4.2.5 Reassembly instructions!*

**IMPORTANT: MAKE SURE THERE IS BLACK FILM ON HINGE CLIP, NOT MISSING.**

### 3.6 Co Brand Inner

*Follow the 2.2.1 Disassembly instructions!*

Prepare the new *Co Brand Inners*.

*Follow the 4.1.4 Reassembly instructions!*

### 3.7 Inner Stoppers

*Follow the 2.2.2 Disassembly instructions!*

Prepare the new *Inner Stoppers*.

*Follow the 4.1.3 Reassembly instructions!*



### 3.8 Upper Outer Cover Assy

*Follow the 2.2.1 – 2.2.3 Disassembly instructions!*

*Prepare the new Upper Outer Cover Assy.*

***FOLLOW THE 3.13 INSTALLATION INSTRUCTIONS!***

*Follow the 4.1.2 – 4.1.4 Reassembly instructions!*

### 3.9 Upper Inner Cover Assy

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

*Prepare the new Upper Inner Cover Assy.*

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*

### 3.10 Main Hinge FPC

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

*Follow the 3.15 Removal instructions!*

*Prepare the new Main Hinge FPC.*

***FOLLOW THE 3.14 INSTALLATION INSTRUCTIONS!***

*Follow the 3.15 Installation instructions!*

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*

### 3.11 Display 2.2 TFT

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

*Prepare the new Display.*

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*

### 3.12 Gasket Hinge (on Display frame)

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

*Prepare the new Gasket Hinge.*

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*

***IMPORTANT: MAKE SURE THIS GASKET IS WELL REASSEMBLED, NOT MISSING.***

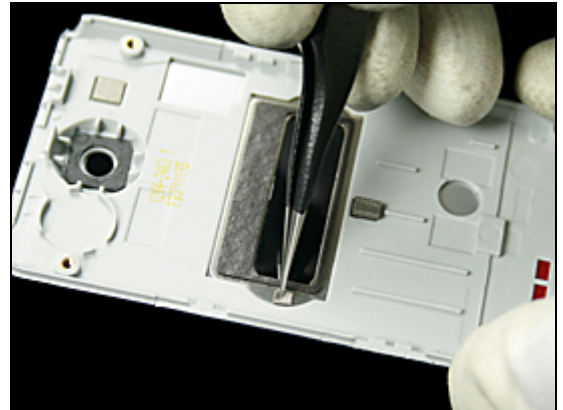


### 3.13 Gasket Hinge (on Upper Outer Cover Assy)

#### REMOVAL

*Follow the 2.2.1 – 2.2.3 Disassembly instructions!*

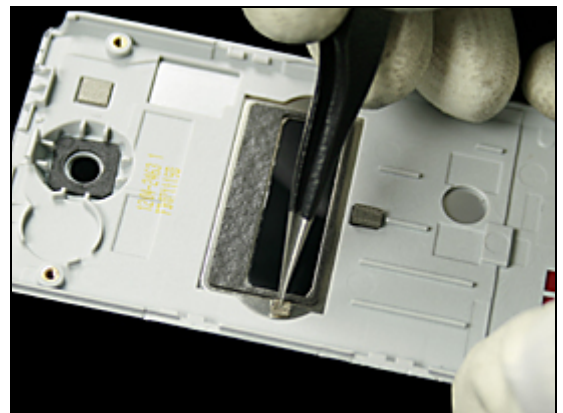
Use the tweezers to detach and remove the *Gasket Hinge* from the *Upper Outer Cover Assy* as shown.



#### INSTALLATION

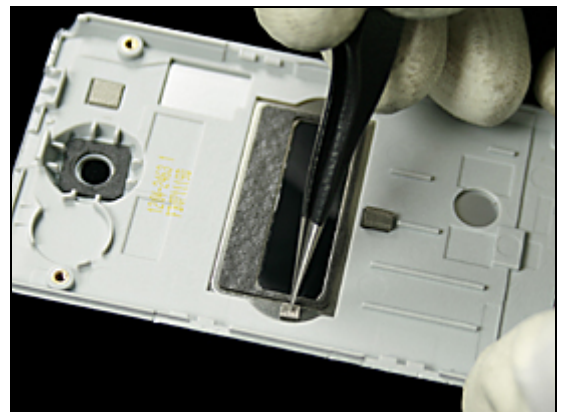
If necessary, clean the surface.

Use the tweezers to attach the new *Gasket* as shown.



Press to secure the attachment.

*Follow the 4.1.2 – 4.1.4 Reassembly instructions!*



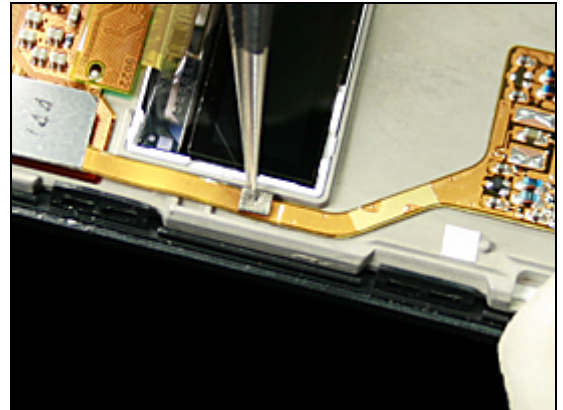


## 3.14 Gasket Hinge (on Main Hinge FPC)

### REMOVAL

*Follow the 2.2.1 – 2.2.3 Disassembly instructions!*

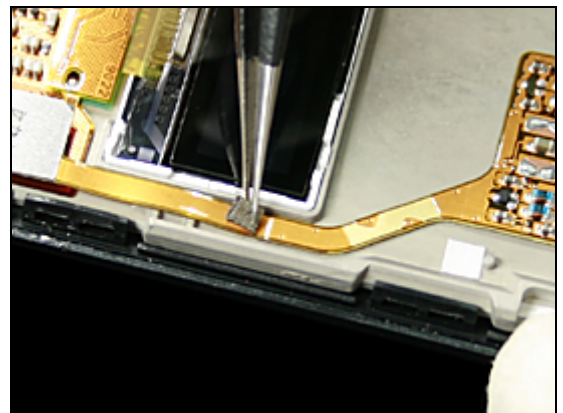
Use the tweezers to detach and remove the *Gasket Hinge* from the *Main Hinge FPC* as shown.



### INSTALLATION

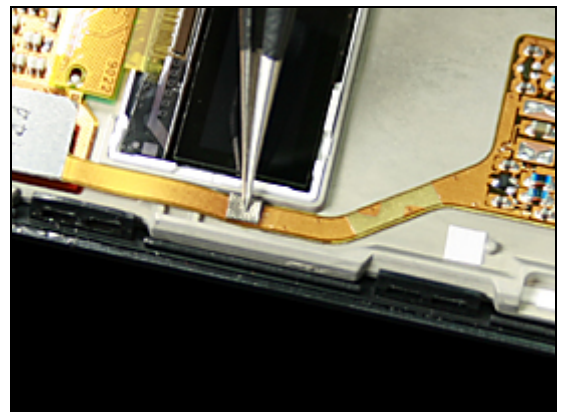
If necessary, clean the surface.

Use the tweezers to attach the new *Gasket* as shown.



Press to secure the attachment.

*Follow the 4.1.2 – 4.1.4 Reassembly instructions!*



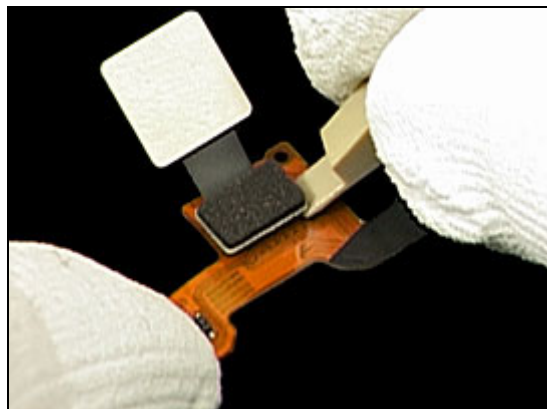


## 3.15 Camera

### REMOVAL

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

Use the front open tool to disconnect the *Camera* connector as shown in the picture.



Prepare a new *Camera*.



### INSTALLATION

Press down on the *Camera* connector to the *Main Hinge FPC* and secure the connection.

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*



## 3.16 Co Brand Outer

### REMOVAL

**BE CAREFUL NOT TO DAMAGE THE UPPER OUTER COVER ASSY DURING THIS OPERATION.**

Carefully insert the dentist hook under the *Co Brand Outer* to detach it.



Remove the *Co Brand Outer* with tweezers.



### INSTALLATION

If necessary, clean the cavity.

Locate the new *Co Brand Outer* in position with tweezers.



Press to secure the attachment.

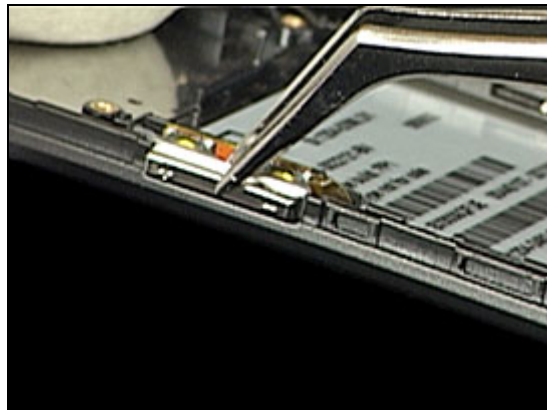


## 3.17 Volume Key

### REMOVAL

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Remove the *Volume Key* with tweezers.

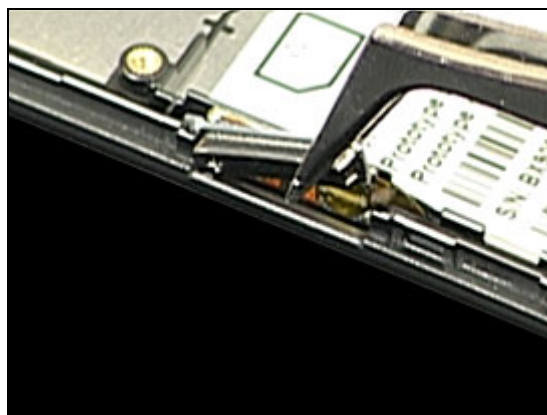


### INSTALLATION

***NOTE THE ORIENTATION OF THE VOLUME KEY!***

Place the new *Volume Key* in its correct position.

*Follow the 4.2.3 – 4.2.5 Reassembly instructions!*



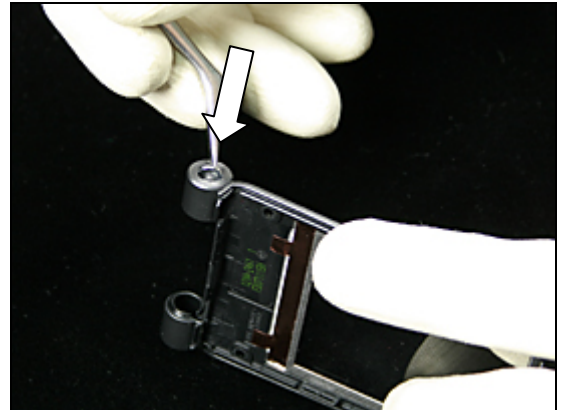


## 3.18 Metal Strap

### REMOVAL

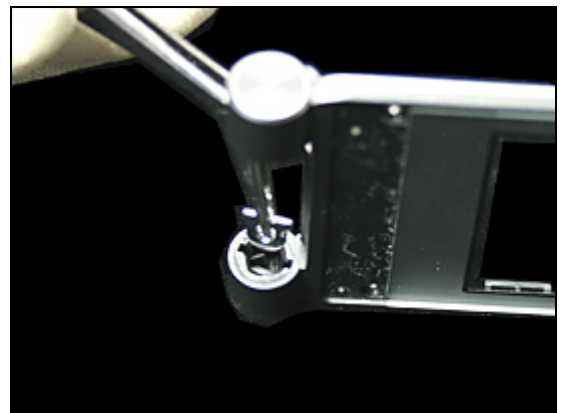
*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

Press with the tweezers on the *Metal Strap* to remove it.



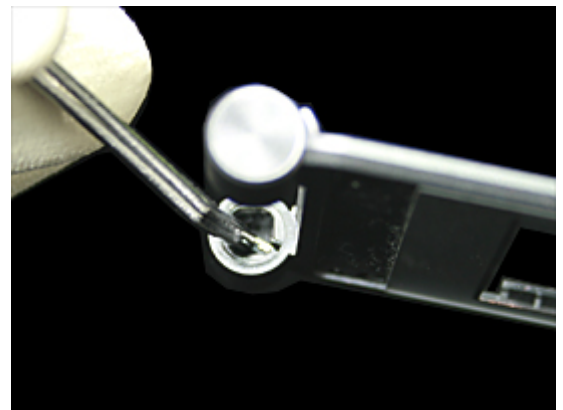
### INSTALLATION

Use the tweezers to locate the new *Metal Strap* in the cavity as shown.



Press on the *Metal Strap* until it is fully located.

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*



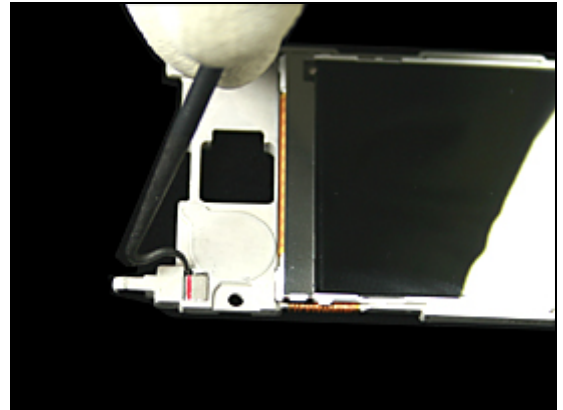


## 3.19 Magnet

### REMOVAL

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

Carefully insert the dentist hook under the *Magnet* to detach it and then remove.

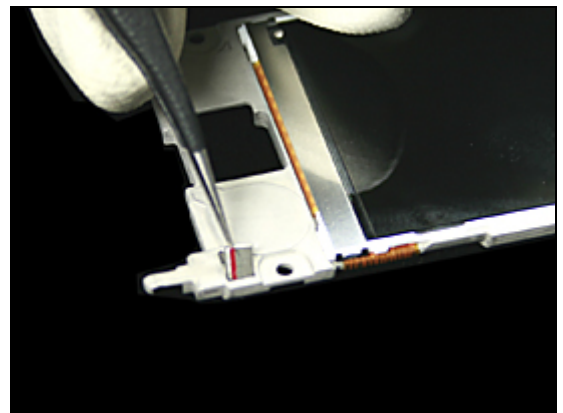


### INSTALLATION

If necessary, clean the cavity.

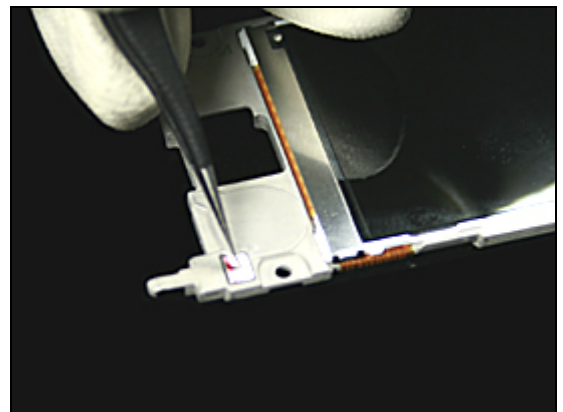
***NOTE THE ORIENTATION OF THE RED LINE ON THE MAGNET!***

Use the tweezers to locate the new *Magnet* in the cavity.



Press the *Magnet* to secure the attachment.

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*

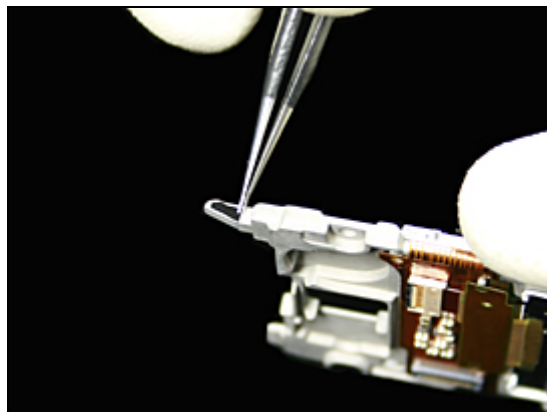


## 3.20 Film Tape (strap)

### REMOVAL

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

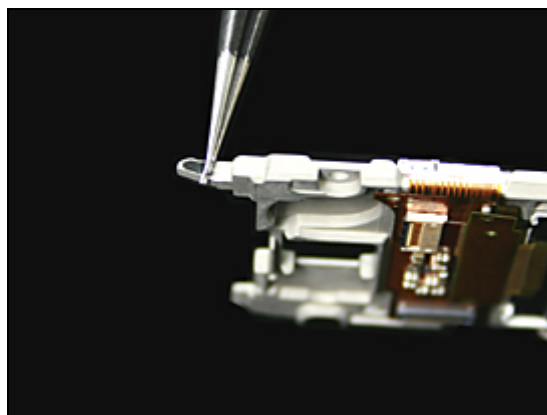
Use the tweezers to peel off the *Film Tape* from the *Display* frame.



### INSTALLATION

If necessary, clean the surface.

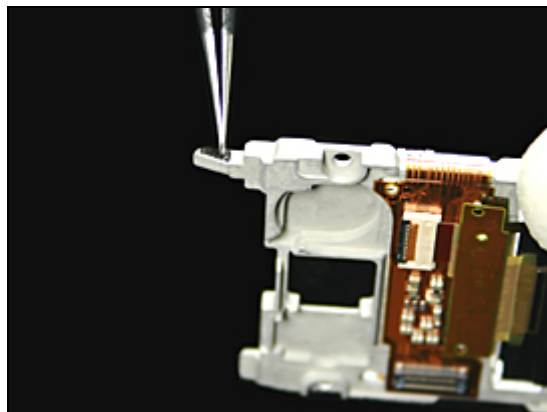
Use the tweezers to attach a new *Film Tape*.



Press to secure the attachment.

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*

**IMPORTANT: MAKE SURE THIS FILM IS WELL REASSEMBLED,  
NOT MISSING.**







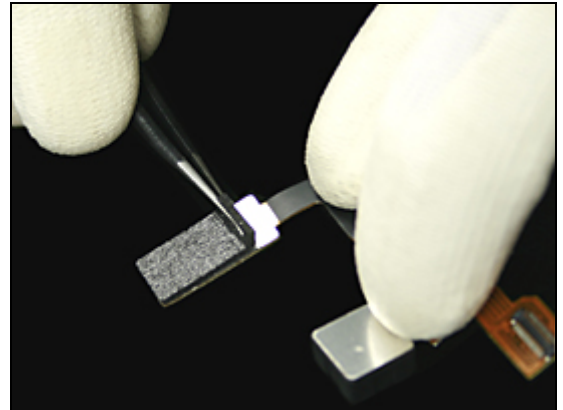
## 3.21 Gasket 70 Pin

### REMOVAL

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

**BE CAREFUL NOT TO DAMAGE THE FLEX FILM DURING THIS OPERATION.**

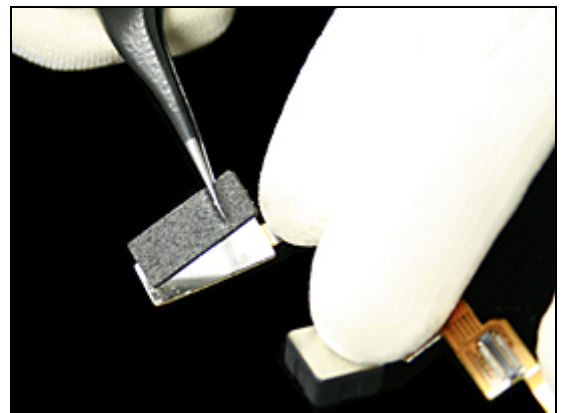
Use the tweezers to peel off the *Gasket* from the *Main Hinge FPC*.



### INSTALLATION

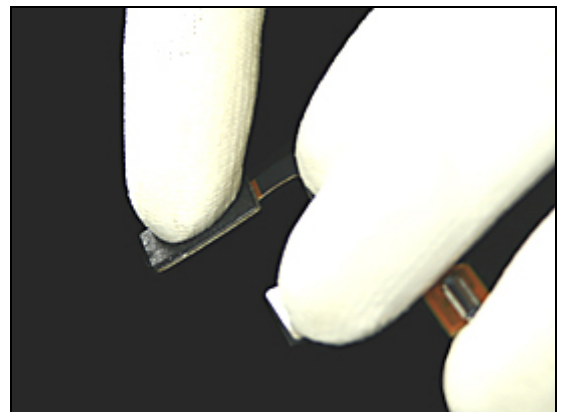
If necessary, clean the surface.

Use the tweezers to attach a new *Gasket*.



Press the *Gasket* to secure the attachment.

*Follow the 4.1.1 – 4.2.5 Reassembly instructions!*



## 3.22 Antenna Sub PCBA

### REMOVAL

Follow the 2.1.1 – 2.1.5 Disassembly instructions!

Use the tweezers to loosen the antenna cable from the cavity.



Use the front opening tool to release the *Antenna Sub PCBA*.



Use the tweezers to remove the *Antenna Sub PCBA*.



### INSTALLATION

Use the tweezers to locate the new *Antenna Sub PCBA*.



## Antenna Sub PCBA *continued*

Press the *Antenna Sub PCBA* to secure it in position.



Press the cable in to the cavity.

**MAKE SURE THAT THE METAL PARTS OF THE CABLE ARE FACING DOWN TO THE BOTTOM OF THE CAVITY.**

*Follow the 4.2.1 – 4.2.5 Reassembly instructions!*



## 3.23 Keypad

### REMOVAL

*Follow the 2.1.1 Disassembly instructions!*

*Follow the 3.32 Removal instructions!*

Use the tweezers to push the *Keypad* from behind, as shown in the picture, and detach it.



Insert the tweezers in the slot as shown in the picture to release the *Keypad*.



Use the tweezers to remove the *Keypad*.

**THE KEYPAD CANNOT BE REUSED AND MUST BE DISCARDED!**



### INSTALLATION

Prepare a new *Keypad* and remove the protection film as shown in the picture.



## Keypad *continued*

If necessary, clean the surface.

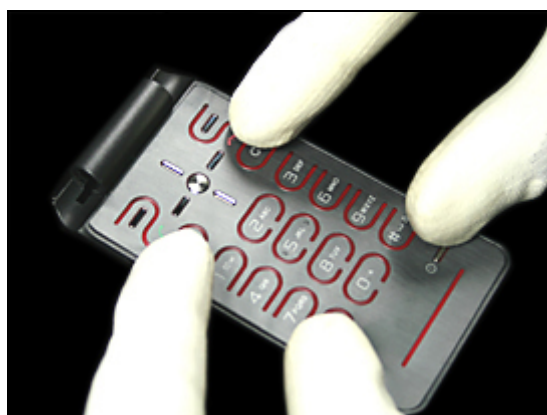
Locate the new *Keypad* in position.



Press **around the sides** and the corners of the *Keypad* *tightly* (5-7Second) to secure the attachment.

*Follow the 3.32 Installation instructions!*

*Follow the 4.2.5 Reassembly instructions!*







## 3.24 Main Keyboard FPC and Mic Conductive Rubber

### REMOVAL

*Follow the 2.1.1 – 2.1.5 Disassembly instructions!*

*Follow the 3.17 Removal instructions!*

*Follow the 3.23 Removal instructions!*

Use the front opening tool to release the *Mic*.



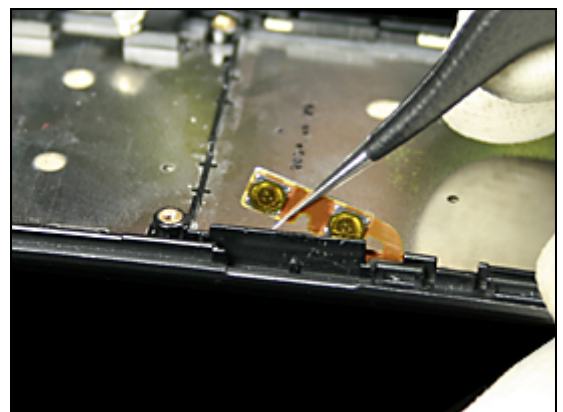
Use the tweezers to remove the *Conductive Rubber* from the *Mic* as shown.



Use the tweezers to detach the *Volume FPC* from its position.



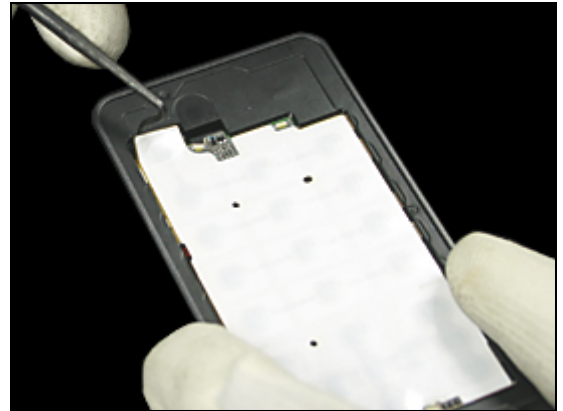
Lift the *Volume FPC* and locate it inside of the *Lower Inner Assembly* as shown.



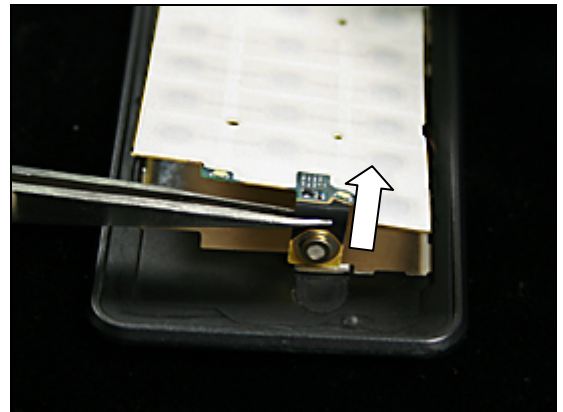


## Main Keyboard FPC and Mic Conductive Rubber *continued*

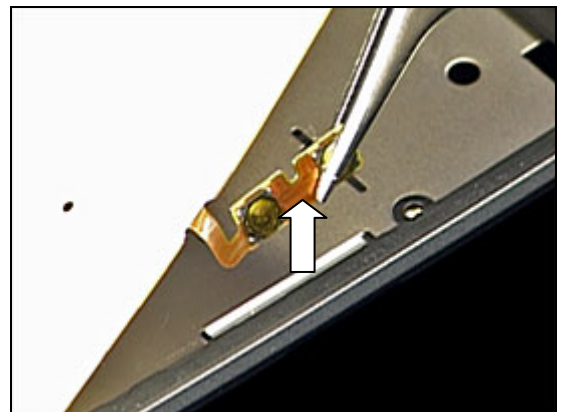
Carefully insert the dentist hook under the *Main Keyboard FPC* to detach it.



Use the tweezers to pull the *Mic* out of the hole as shown.

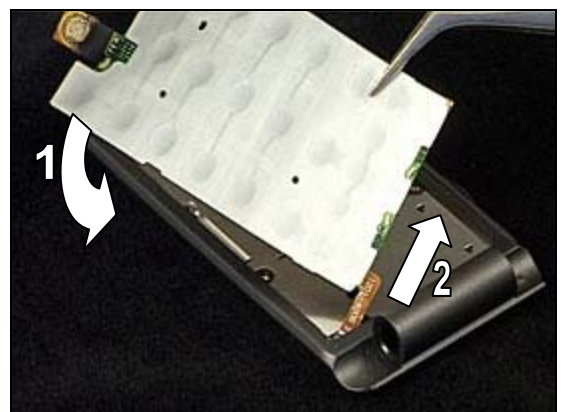


Use the tweezers to pull the *Volume FPC* out of the hole as shown.



Use the tweezers to peel off the *Main Keyboard FPC*. Turn the *Main Keyboard FPC* 90 degrees in the direction of the arrow (1), slide the flex film out of the hole (2).

**THE MAIN KEYBOARD FPC CANNOT BE REUSED AND MUST BE DISCARDED!**

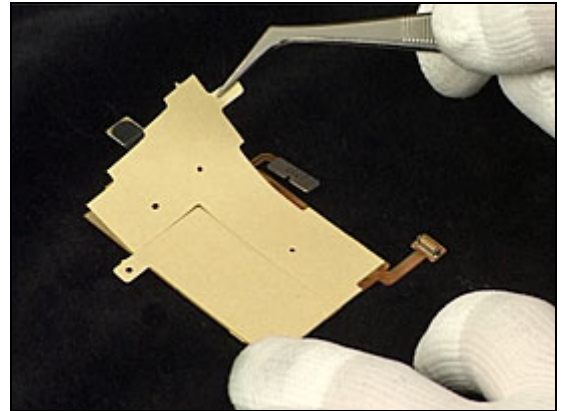




## Main Keyboard FPC and Mic Conductive Rubber *continued*

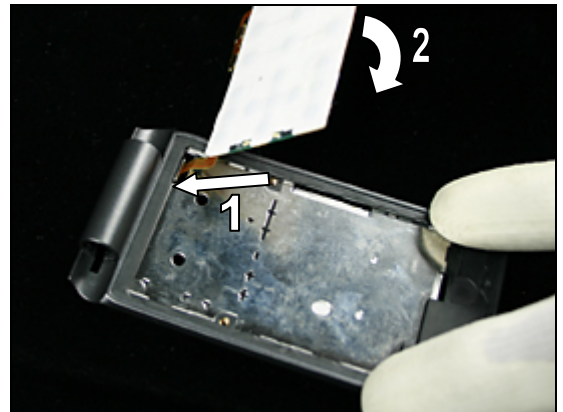
### INSTALLATION

Prepare a new *Main Keyboard FPC* and remove the protection paper as shown.

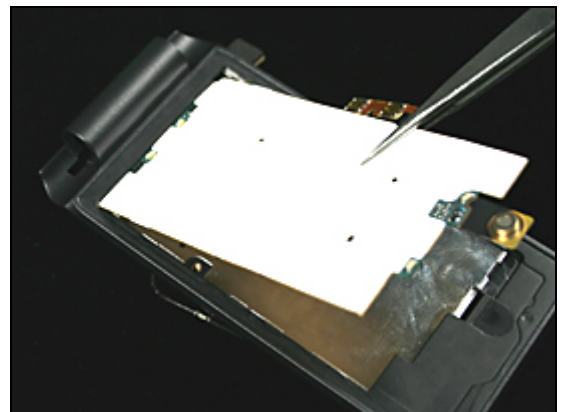


If necessary, clean the surface.

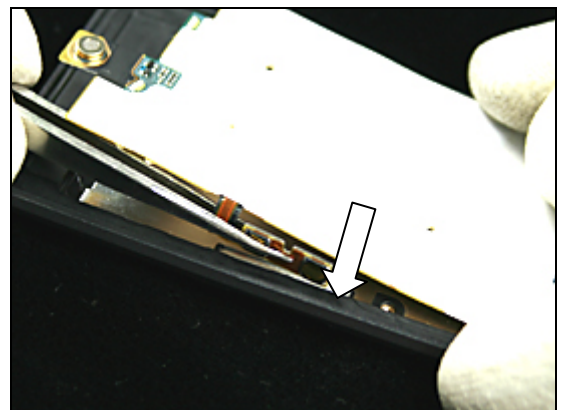
Insert the flex film in the hole (1) and turn the *Main Keyboard FPC* 90 degrees in the direction of the arrow (2).



Locate the *Main Keyboard FPC* in position.



Insert the *Volume FPC* through the hole with the tweezers as shown.



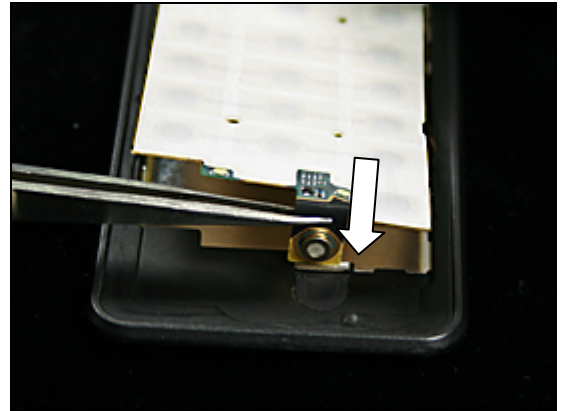




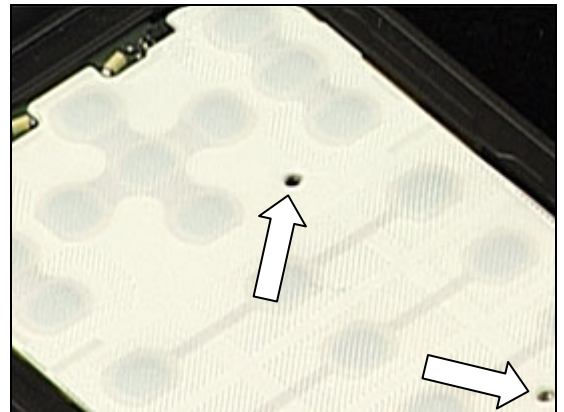
## Keypad, Main Keyboard FPC and Mic Conductive Rubber *continued*

Insert the *Mic* through the hole with the tweezers as shown.

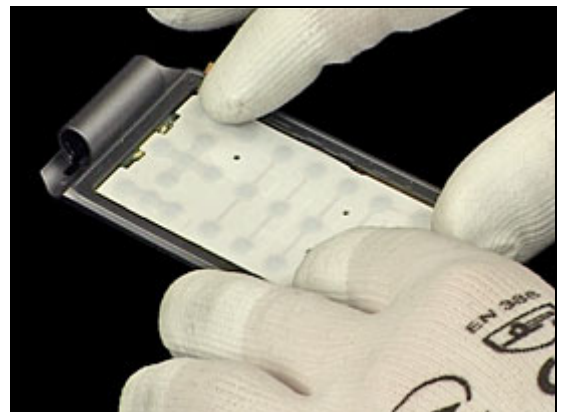
**IMPORTANT: BE CAREFUL NOT TO BREAK THE MIC FPC!**



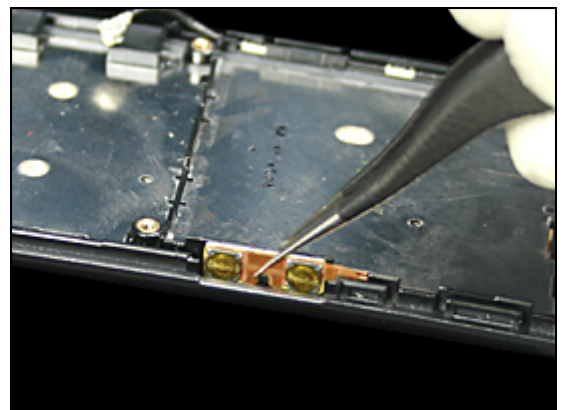
**MAKE SURE THAT THE GUIDING HOLES ON THE MAIN KEYBOARD FPC CORRESPOND TO THE HOLES ON THE LOWER INNER ASSEMBLY.**



Press the *Main Keyboard FPC* to secure the attachment.

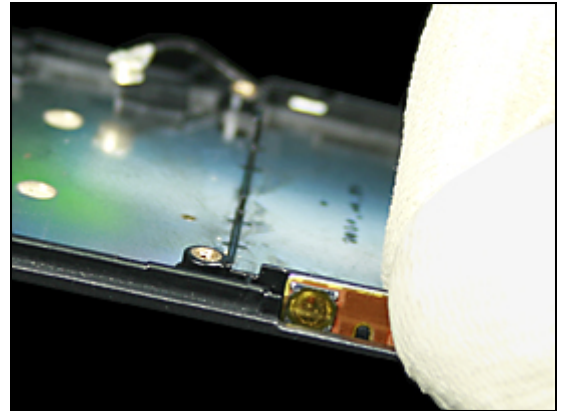


Use the tweezers to locate the *Volume FPC* in position.



## Main Keyboard FPC and Mic Conductive Rubber *continued*

Press to secure the attachment.



Use the tweezers to place the new *Mic Conductive Rubber* in the cavity as shown.

***IMPORTANT: BE CAREFUL NOT TO BREAK THE MIC FPC!***

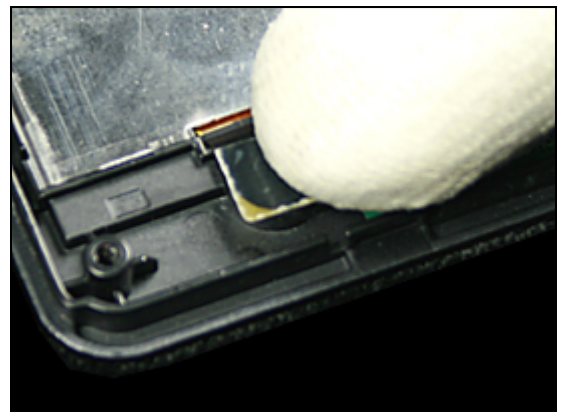


Press the *Mic* in the cavity to secure it.

*Follow the 3.17 Installation instructions!*

*Follow the 3.23 Installation instructions!*

*Follow the 4.2.1 – 4.2.5 Reassembly instructions!*





## 3.25 Gasket 22 Pin

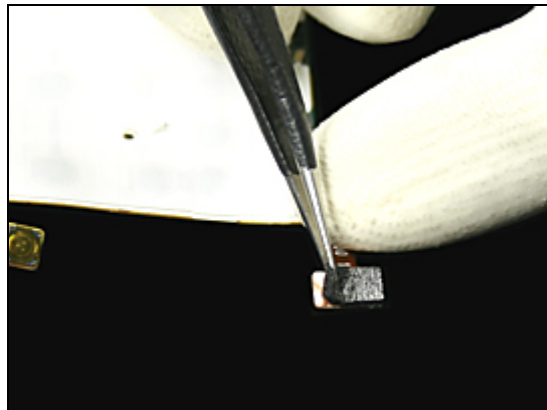
### REMOVAL

*Follow the 2.1.1 – 2.2.4 Disassembly instructions!*

*Follow the 3.23 – 3.24 Removal instructions!*

**BE CAREFUL NOT TO DAMAGE THE FLEX FILM DURING THIS OPERATION.**

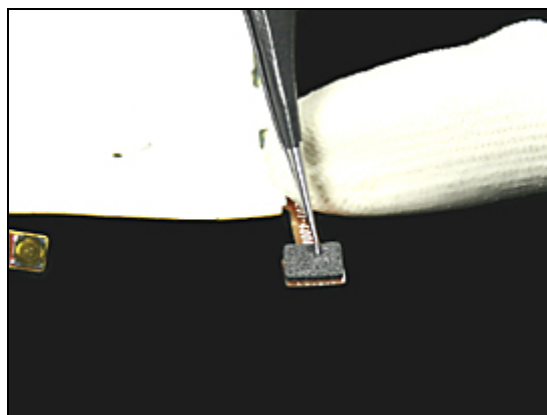
Use the tweezers to peel off the *Gasket* from the *Main Keyboard FPC*.



### INSTALLATION

If necessary, clean the surface.

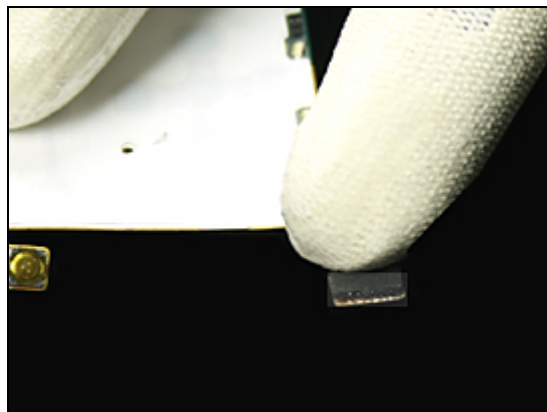
Use the tweezers to attach a new *Gasket*.



Press to secure the attachment.

*Follow the 3.23 – 3.24 Installation instructions!*

*Follow the 4.2.1 – 4.2.5 Reassembly instructions!*



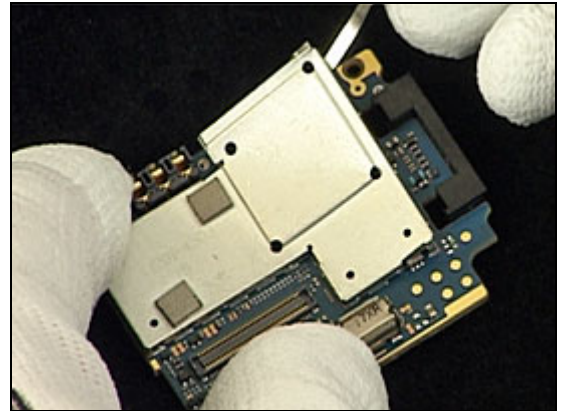


## 3.26 BB Shield Can Lid and Gasket ESD 2 BB Shielding Can

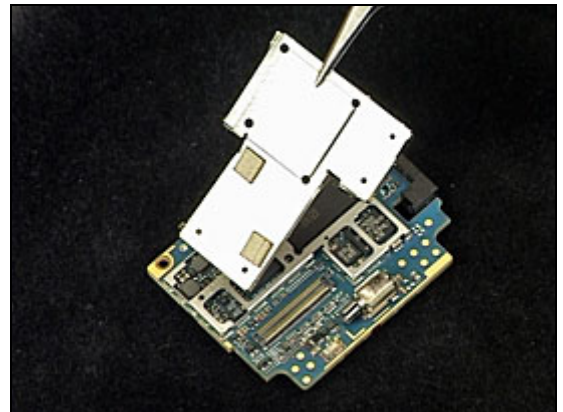
### REMOVAL

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

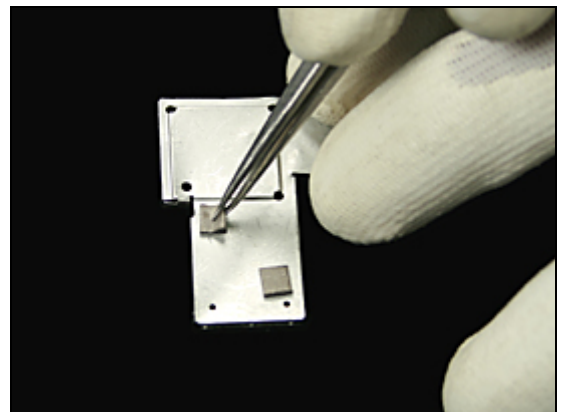
Use the dentist hook to loosen each side of the *BB Shield Can Lid*.



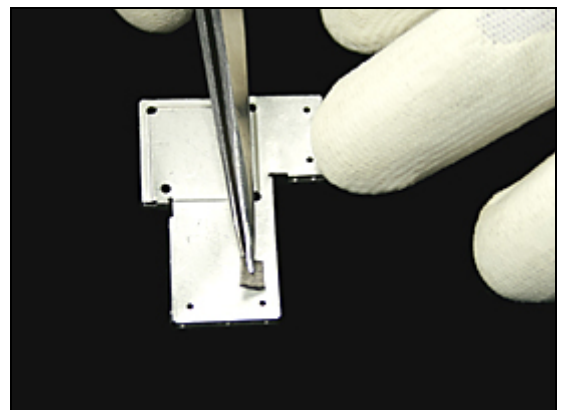
Lift off the *BB Shield Can Lid* with the tweezers.



Use the tweezers to detach and remove one of the two *Gaskets* as shown in the picture.



Repeat for the second *Gasket*.

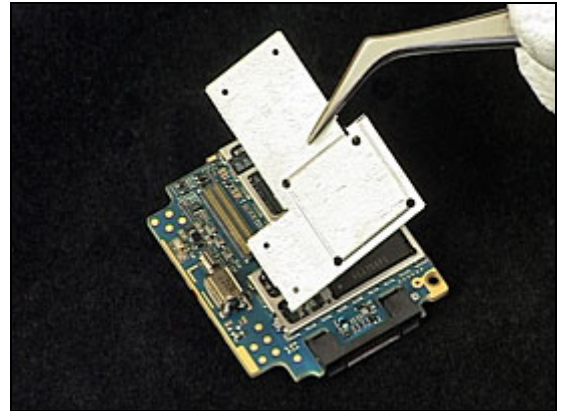




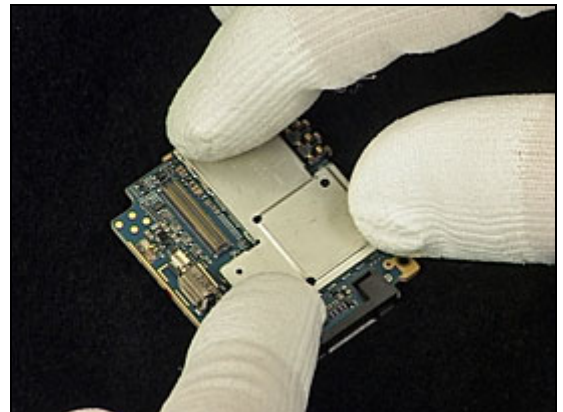
## BB Shield Can Lid and Gasket ESD 2 BB Shielding Can *continued*

### INSTALLATION

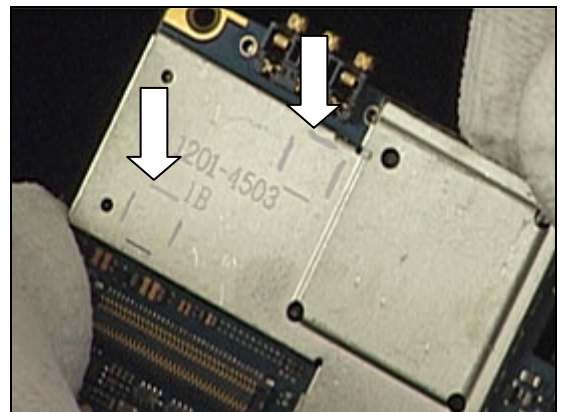
Position the new *BB Shield Can Lid* with tweezers.



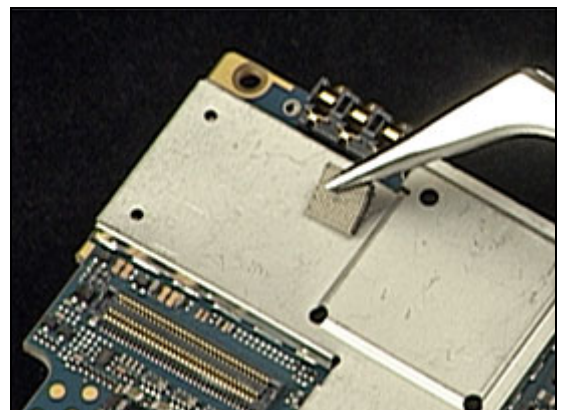
Press down on each corner to secure the placement.



Be aware of the marks on the *BB Shield Can Lid* for the two *Gaskets*.



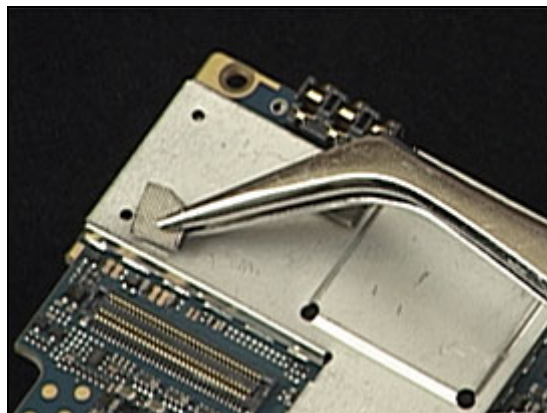
Use the tweezers to attach the first *Gasket* and press to secure the attachment.



## BB Shield Can Lid and Gasket ESD 2 BB Shielding Can *continued*

Attach the second *Gasket* and press to secure the attachment.

*Follow the 4.2.2 – 4.2.5 Reassembly instructions!*





## 3.27 M2 Reader Black Cushion Tape

### REMOVAL

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

Use the tweezers to peel off the *M2 Reader Black Cushion Tape*.



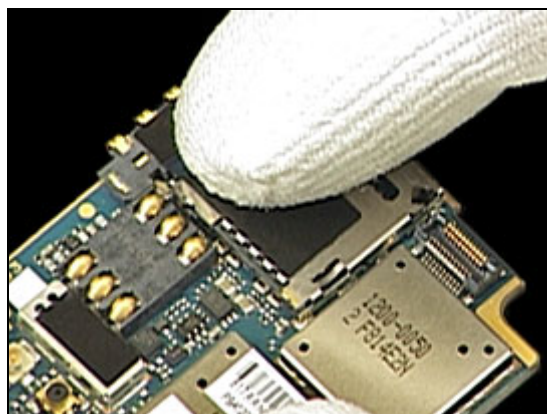
### INSTALLATION

Use the tweezers to attach the new *Tape*.



Press to secure the attachment.

*Follow the 4.2.2 – 4.2.5 Reassembly instructions!*



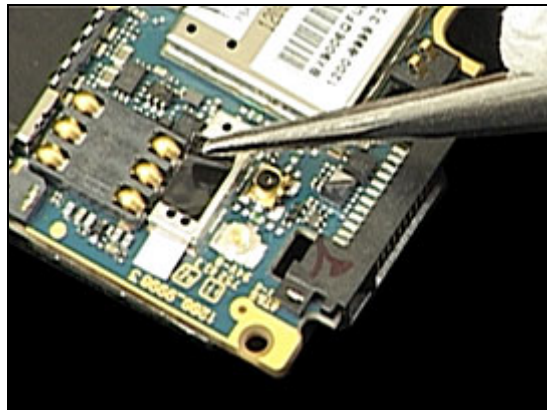


## 3.28 Film on Shielding

### REMOVAL

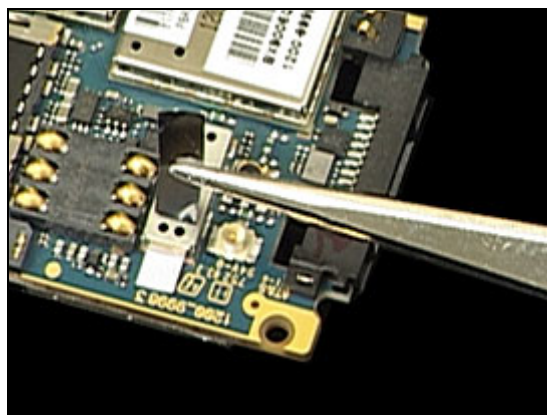
*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

Use the tweezers to peel off the *Film*.



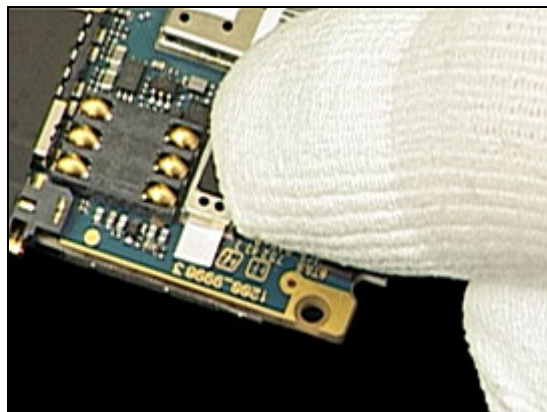
### INSTALLATION

Use the tweezers to attach the new *Film*.



Press to secure the attachment.

*Follow the 4.2.2 – 4.2.5 Reassembly instructions!*

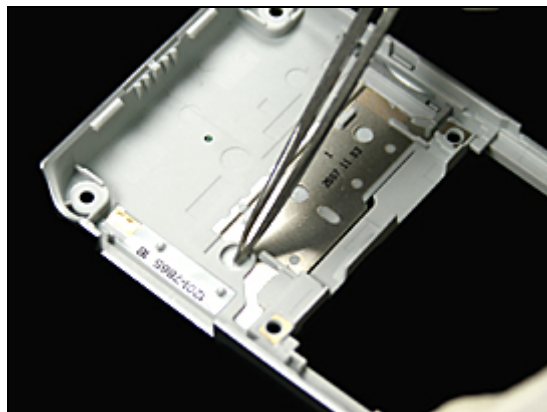


## 3.29 Lower Outer SE Logo

### REMOVAL

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Use the tweezers to push the *Lower Outer SE Logo* from behind to detach it as shown.



Remove the *Logo* with the tweezers.



### INSTALLATION

If necessary, clean the surface.

Locate the new *Logo* in position with tweezers.



Press to secure the attachment.

*Follow the 4.2.3 – 4.2.5 Reassembly instructions!*

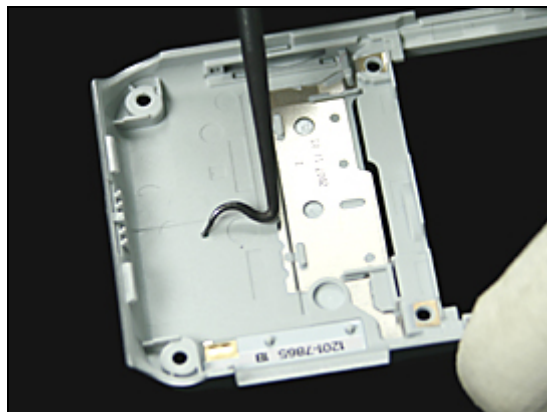


## 3.30 Icon 5.5

### REMOVAL

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Use the dentist hook to push the *Icon* from behind to detach it as shown.



Remove the *Icon* with the tweezers.

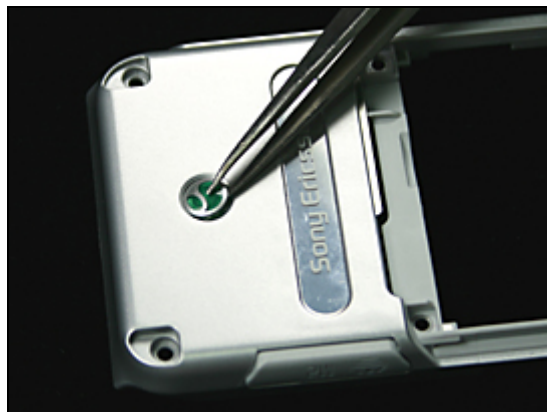


### INSTALLATION

If necessary, clean the surface.

**MAKE SURE THAT THE GUIDING PIN ON THE ICON CORRESPONDS TO THE GUIDING HOLE ON THE LOWER OUTER ASSEMBLY.**

Locate the new *Icon* in position with the tweezers.



Press to secure the attachment.

*Follow the 4.2.3 – 4.2.5 Reassembly instructions!*



## 3.31 M2 Card Cap

### REMOVAL

Open and pull out the *M2 Card Cap*.



### INSTALLATION

Position the new *Cap* into place with the tweezers as shown.



Press in the *Cap* and secure it to the *Lower Outer Assembly*.



## 3.32 Label

### REMOVAL

*Follow the 2.1.1 Disassembly instructions!*

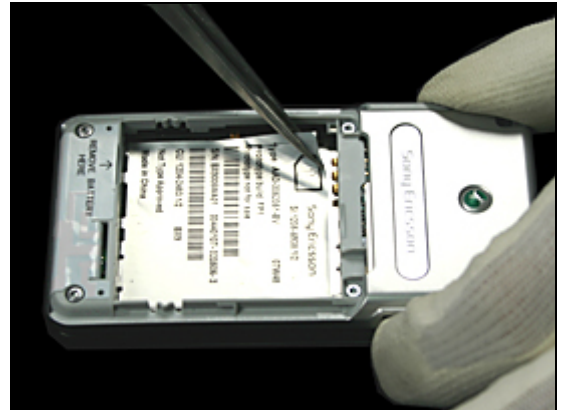
Read the old label and/or write the information into the “Label make” program before removal.

Note the position of the label before removal.

Heat up the label by using hot air, if needed.

Carefully remove the label without causing scratches.

If there still are residues, clean the surface.



### INSTALLATION

Check that the proper label format is loaded in the Zebra printer. Write a new label by using the program “Label make” and check that the printing is OK.

Take the new label and place it onto the frame as in the adjacent picture.

**ONE LABEL ONLY IS ALLOWED!**

*Follow the 4.2.5 Reassembly instructions!*





### 3.33 Liquid Intrusion Indicator (on PCBA)

#### REMOVAL

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Use the tweezers to peel off the *Liquid Intrusion Indicator*.



#### INSTALLATION

If necessary, clean the surface.

Use the tweezers to attach a new *Liquid Intrusion Indicator*.



Press to secure the attachment.

*Follow the 4.2.3 – 4.2.5 Reassembly instructions!*



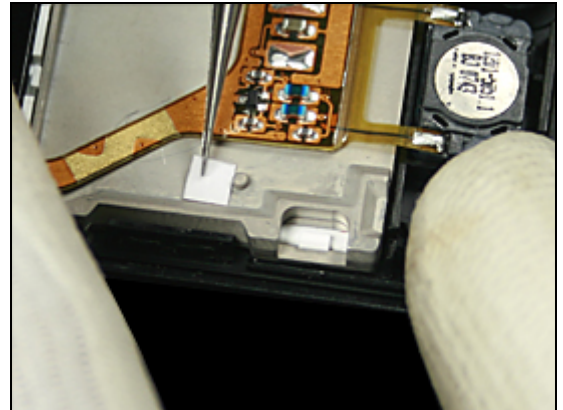


### 3.34 Liquid Intrusion Indicator (on Display Frame)

#### REMOVAL

*Follow the 2.1.1 – 2.2.3 Disassembly instructions!*

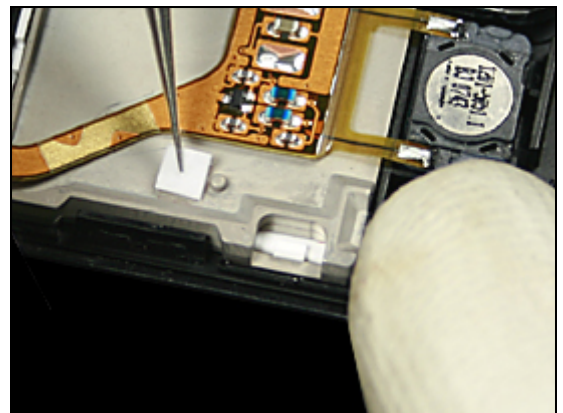
Use the tweezers to peel off the *Liquid Intrusion Indicator*.



#### INSTALLATION

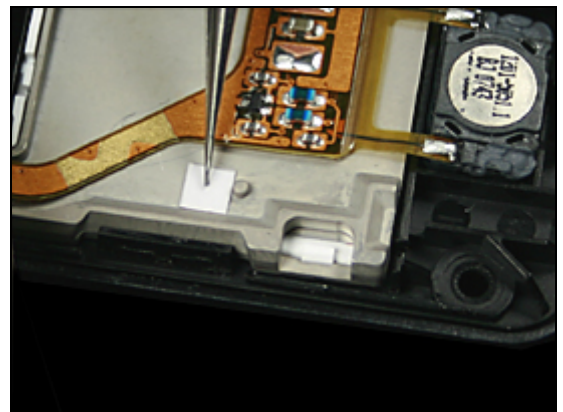
If necessary, clean the surface.

Use the tweezers to attach a new *Liquid Intrusion Indicator*.



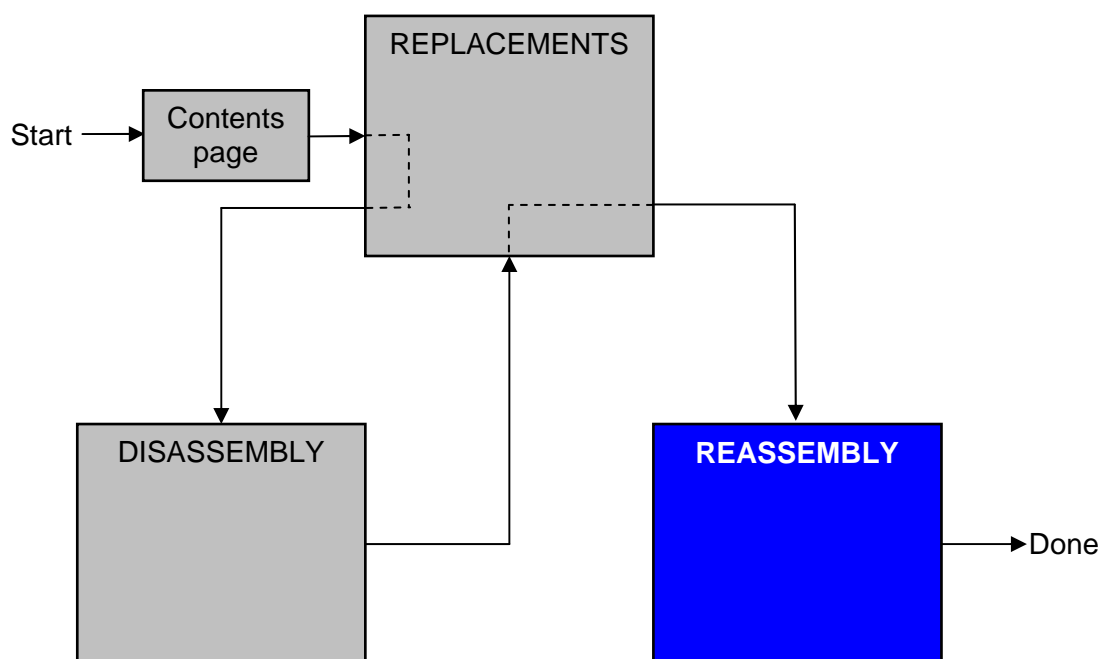
Press to secure the attachment.

*Follow the 4.1.2 – 4.2.5 Reassembly instructions!*



## 4 Reassembly

After replacing a part being listed in Replacements, the instruction of that section usually ends by directing you to this Reassembly section with a specification of the instructions you have to carry out in order to reassemble the phone.



### 4.1 Upper Unit

The reassembly is done in the following sequence:

1. Upper Inner Cover Assy
2. Display 2.2 TFT
3. Main Hinge FPC
4. Upper Outer Cover Assy
5. Inner Stoppers
6. Co Brand Inner





## 4.1.1 Upper Inner Cover Assy

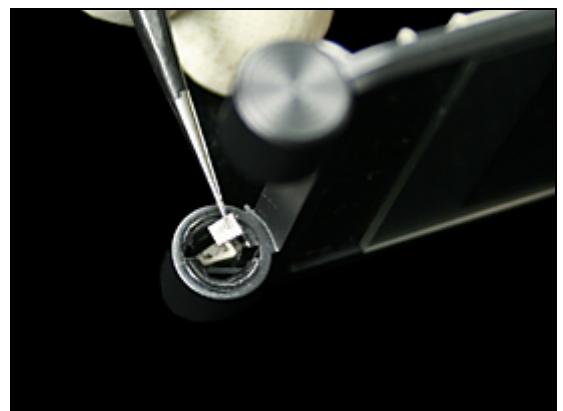
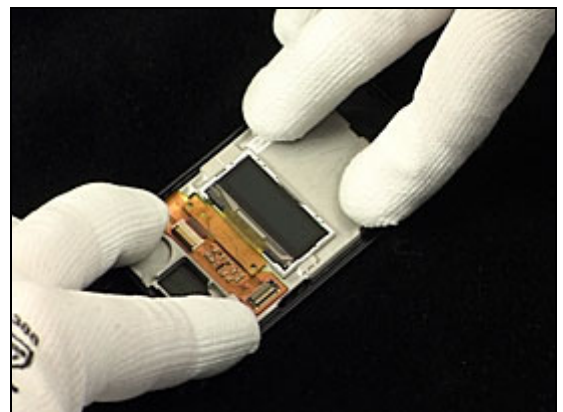
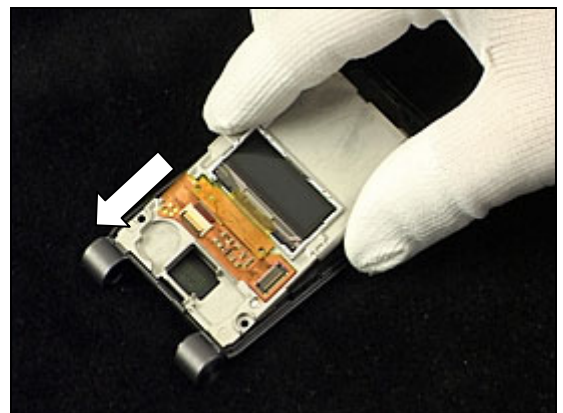
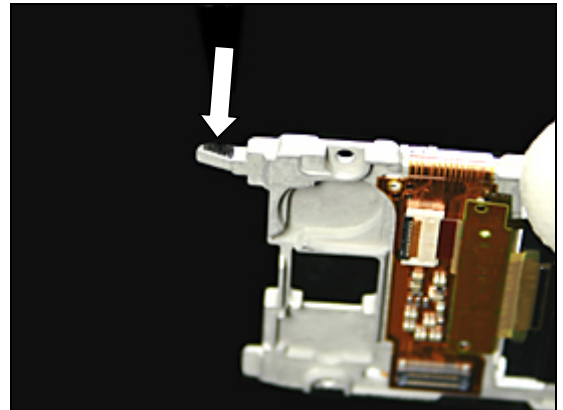
**IMPORTANT:**

**BEFORE REASSEMBLY, MAKE SURE THAT THE FILM TAPE STRAP IS IN PLACE AS SHOWN IN THE PICTURE!**

Hold the *Display* frame in a slight vertical angle and push it into the hinge section.

Press on the *Display* frame to secure it to the *Upper Inner Cover Assy*.

Use the tweezers to attach a new *Gasket* to the *Display* frame.



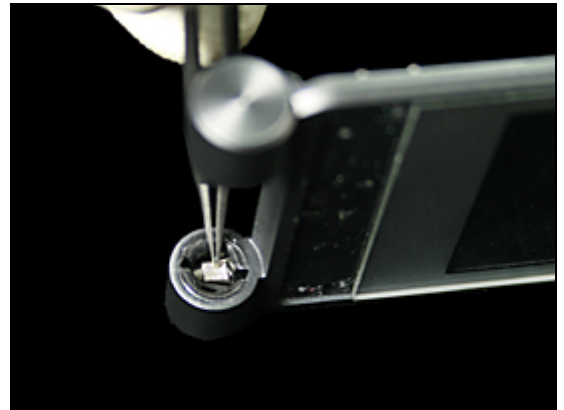




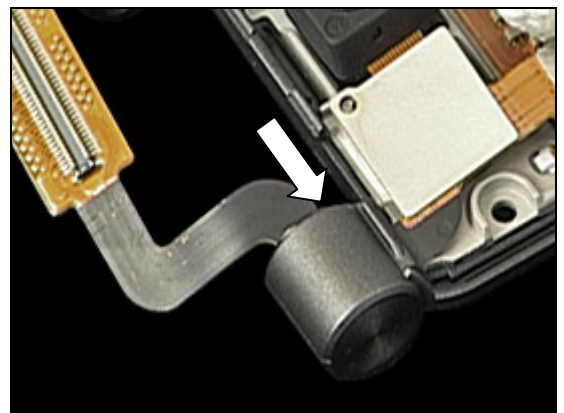
## Upper Inner Cover Assy *continued*

Press to secure the attachment.

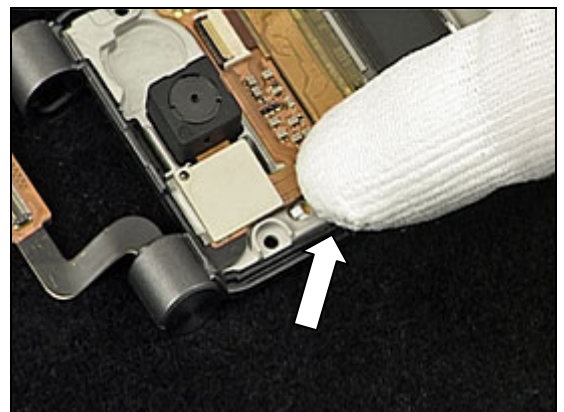
**IMPORTANT: MAKE SURE THIS GASKET IS WELL REASSEMBLED, NOT MISSING.**



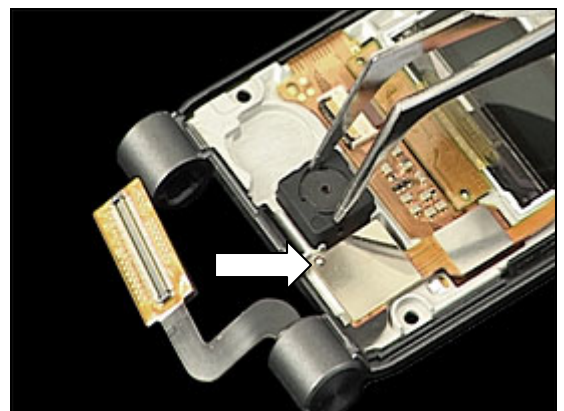
Move the *Main Hinge FPC* in the direction of the arrow to slide the flex film through the slot of the hinge section.



Press the connector to connect the *Main Hinge FPC* to the *Display* frame as shown.



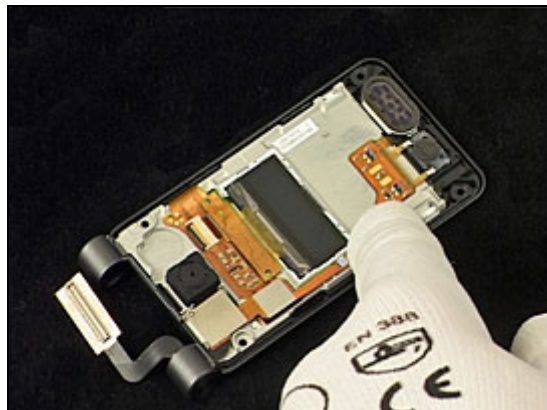
Use the tweezers to locate the *Camera*. Make sure that the guiding hole on the *Main Hinge FPC* corresponds to the guiding pin on the *Display* frame.





## Upper Inner Cover Assy *continued*

Press the *Main Hinge FPC* to secure the attachment as shown.



**IMPORTANT:**  
**MAKE SURE THAT THE GASKET IS CORRECTLY LOCATED AS SHOWN!**



## 4.1.2 Upper Outer Cover Assy

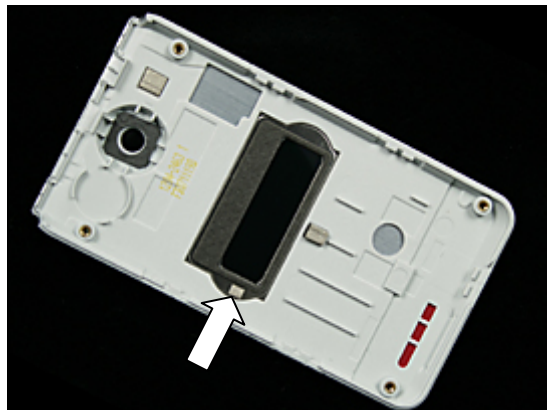
**IMPORTANT:**

**BEFORE REASSEMBLY, MAKE SURE THAT THE GASKET IS CORRECTLY LOCATED AS SHOWN!**

Locate the *Upper Outer Cover Assy* to the *Upper Inner Cover Assy*.

Press the *Upper Outer Cover Assy* until the two covers snap together without any gaps.

Tighten the two 2.5 × 1.6 Screws with torx bit T5 using torque pressure 10NCM.



## Upper Outer Cover Assy *continued*

Tighten the two 3.5 × 1.6 Screws with torx bit T5 using torque pressure 10NCM.



### 4.1.3 Inner Stopper

Clean the cavities.

***USE NEW INNER STOPPERS!***

Use the tweezers to attach the first *Inner Stopper* in the cavity and press to secure the attachment.



Attach the second *Inner Stopper* and press to secure the attachment.



## 4.1.4 Co Brand Inner

Clean the cavity.

***USE NEW CO BRAND!***

Use the tweezers to locate the *Co Brand* in the cavity.



Press to secure the attachment.





## 4.2 Lower Unit

The reassembly is done in the following sequence:

1. Lower Inner Assembly
2. Hinge (a) and Hinge Clip (b)
3. PCBA
4. Lower Outer Assembly
5. Lower Outer Screw Caps
6. Battery (a) and Battery Cover (b)



## 4.2.1 Lower Inner Assembly

**NOTE THE SHAPE OF THE HOLE WHERE THE HINGE WILL BE INSERTED!**

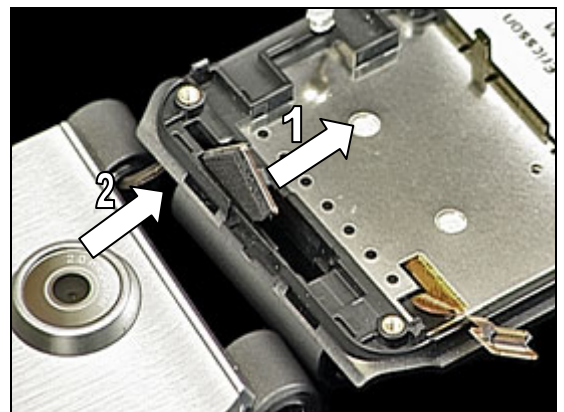
Insert the *Hinge* into the hole of the hinge section with the tweezers as shown.



Press the *Hinge* to its position as shown.



Insert the flex film of the *Main Hinge FPC* through the hole of the *Lower Inner Assembly* (1) and place one end of the hinge section against the upper unit (2).



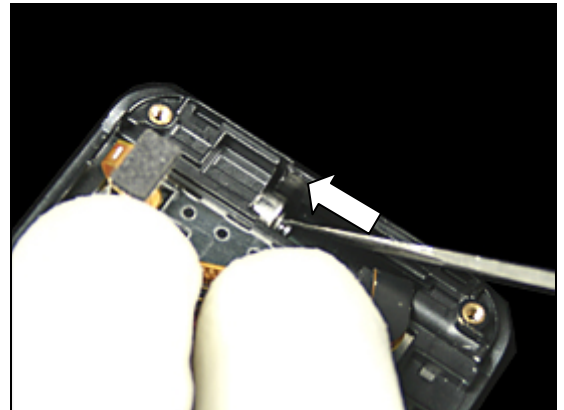
Push the upper unit in the direction of the arrow to make them properly jointed.





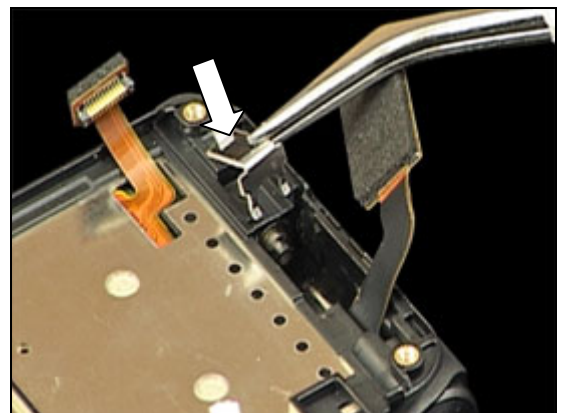
## Lower Inner Assembly *continued*

Push the *Hinge* into the bottom of its cavity with tweezers as shown.

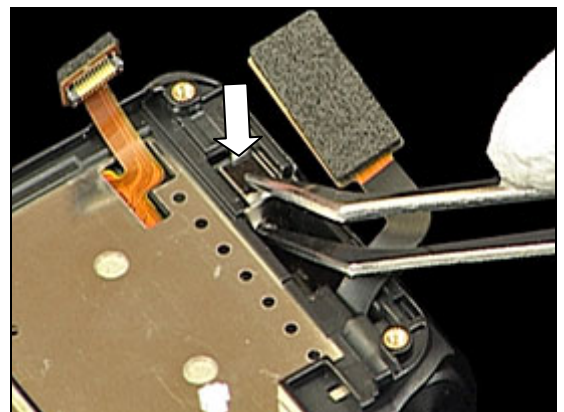


**IMPORTANT:**

**BEFORE REASSEMBLY, MAKE SURE THAT THE FILM TAPE IS CORRECTLY LOCATED AS SHOWN!**



Locate the *Hinge Clip* and press to secure as shown.

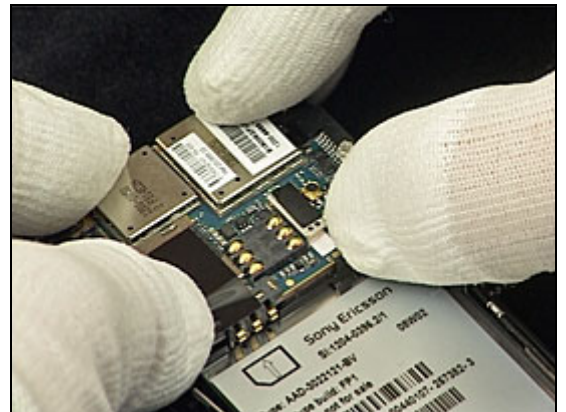


## 4.2.2 PCBA

Connect the *Main Hinge FPC* connector as shown.



Locate the *PCBA* in position and press to snap in to place.



Connect the *Main Keyboard FPC* connector as shown.



Connect the *Antenna Sub PCBA* connector as shown.





## 4.2.3 Lower Outer Assembly

Position the *Lower Outer Assembly* to the *Lower Inner Assembly*.



Press the *Lower Outer Assembly* until these two covers snap together without any gaps.



Tighten the two 2.5 × 1.6 Screws with torx bit T5 using torque pressure 10NCM.



Tighten the two 3.5 × 1.6 Screws with torx bit T5 using torque pressure 10NCM.





## Lower Outer Assembly *continued*

Tighten the two 1.7 × 4.5 Screws with torx bit T6 using torque pressure 18NCM.



## 4.2.4 Lower Outer Screw Caps

Clean the cavities.

**USE NEW SCREW CAPS!**

**THE TWO SCREW CAPS ARE NOT IDENTICAL!**

Use the tweezers to attach the first *Screw Cap* in the cavity and press to secure the attachment.

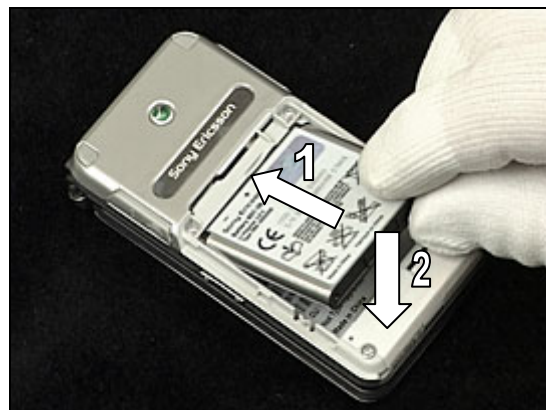


Attach the second *Screw Cap* and press to secure the attachment.



## 4.2.5 Battery and Battery Cover

As shown, insert the *Battery* by pushing it towards the top of the phone (1) and press it down at the bottom (2).



Locate the *Battery Cover* and slide towards the top of the phone,



Slide the *Battery Cover* until it is latched with no gaps.





## 5 Revision History

Rev.	Date	Changes / Comments
REV1	2008-03-17	First release
REV2	2008-03-26	Chapter 3.23 keypad replacement updated.