

## Working Instructions

- mechanical -



*Xperia XA1 Plus*

G3412, G3416, G3221, G3223, G3226

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

**Always firstly disconnect the Battery connector to cut off power supply when the Battery Cover Assy is disassembled.**

**Always finally connect the Battery connector before the Battery Cover Assy is reassembled.**

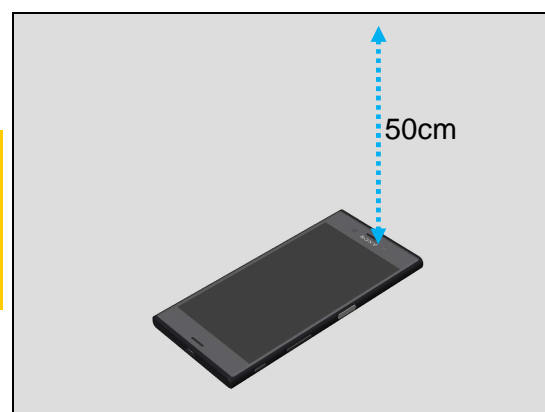
**If there are no special indications of 'G3412, G3416, G3421, G3423 or G3426', G3412, G3416, G3421, G3423 and G3426 share the same repair method as common sections, whose pictures are used with G3426.**

**1309-7255 CS-Everest (Repair -Mechanical- Tools and Equipment (include Repair Software), Info-Center number is RE4251) Calibration or Aged Battery Reset by Emma must be performed when following Reassembly or Replacement.**

		CS-Everest Calibration			Emma
		Proximity Light Sensor G Sensor	Smart Amp	Color ID Flashing	Aged Battery Reset
Reassembly	Main PBA	O			
	Display Cover Assy	O			
	Rubber PL Sensor	O			
Replacement	Main PBA	O	O	O	
	Display Cover Assy	O			
	Rubber PL Sensor	O			
	Battery				O
	Main Antenna Speaker Box		O		

**Note! When performing proximity sensor calibration, put the phone unit on a stable place, facing up, and no any objects within 50cm.**

**Remove the protection film if sensor window is covered by the protection film.**



## 1 Exterior Views

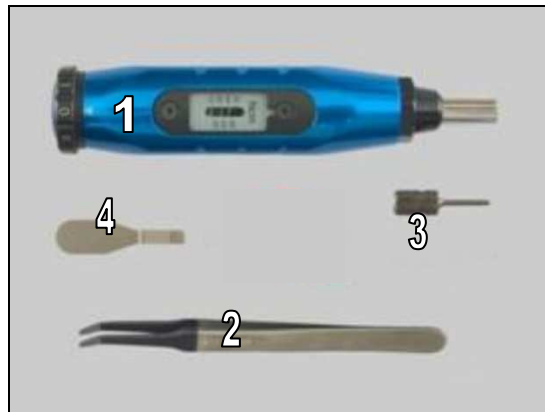
### 1.1 G3412,G3416,G3421,G3423,G3426



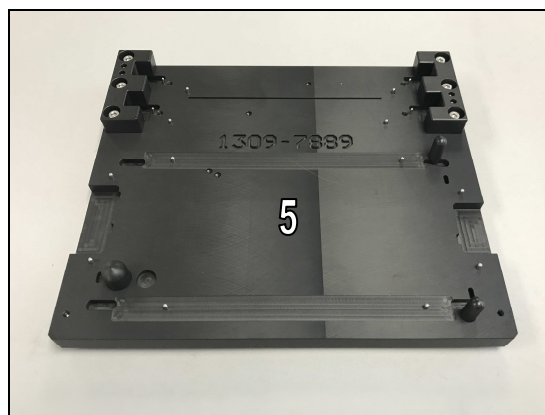
## 2 Tools

### SPECIAL TOOLS

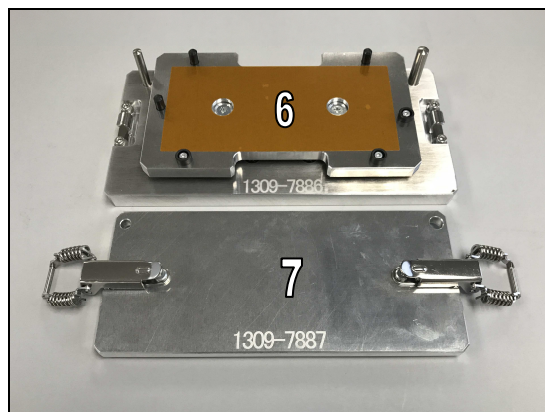
1. Torque Screwdriver 2-30Ncm (1233-2284)
2. Flex Film Assembly Tool (NTZ 112 521)
3. Bits JCIS No.0 (NTZ 112 1052)
4. Front Opening Tool (NTZ 112 302/2)



5. Panels Adhesive Fixture (1309-7889)



6. Press tool Bottom (1309-7886)
7. Press tool Top (1309-7887)

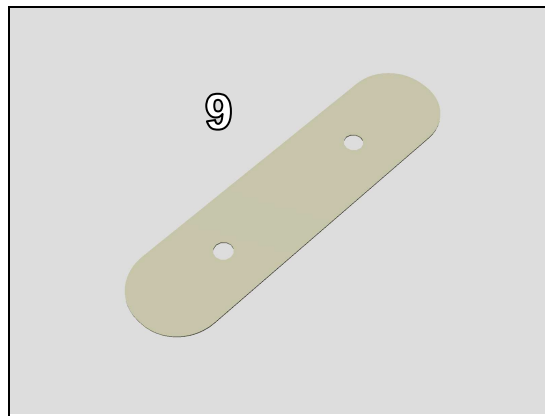


8. Press Clamp (1302-3698)



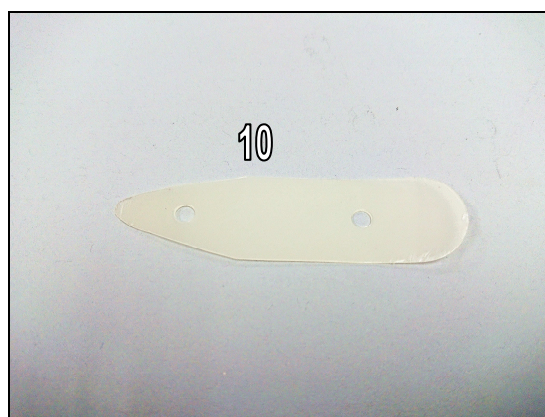
## Tools

9. Flexible Disassembly tool (1284-7796)



10. Customized Flexible Disassembly tool (1284-7796)

**Note! One end of Flexible Disassembly tool (1284-7796) cut and sharpened by using scissors and knife.**



11. Media Cable TyepC Cable (Black) (1302-1935)



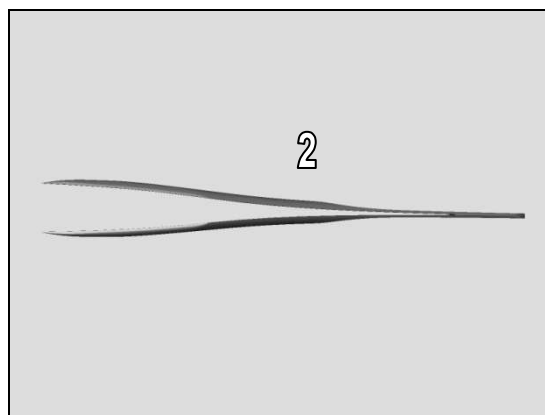
## Tools

### STANDARD TOOLS

1. Pointed Plastic Tweezers

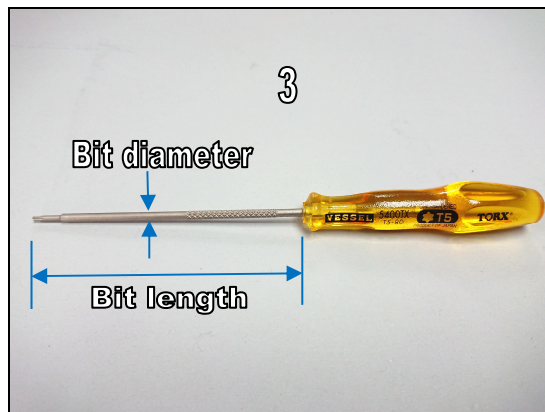


2. Blunt flat-tip Plastic Tweezers



3. T5 Screwdriver

**The bit length is no less than 70mm, and bit diameter is no thicker than 2.5mm.**



4. Hot Air Gun with Temp control



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

### 3 Mandatory Replacement Parts List

The Mandatory Replacement Parts List is embedded.  
Click the icon to open the file.



### G34 Mandatory Replacement List:



Targeted replacement parts are listed

[illegible]

Mandatory replacement parts for refurbishment.

Parts that is required to replace in addition to target replacement parts.

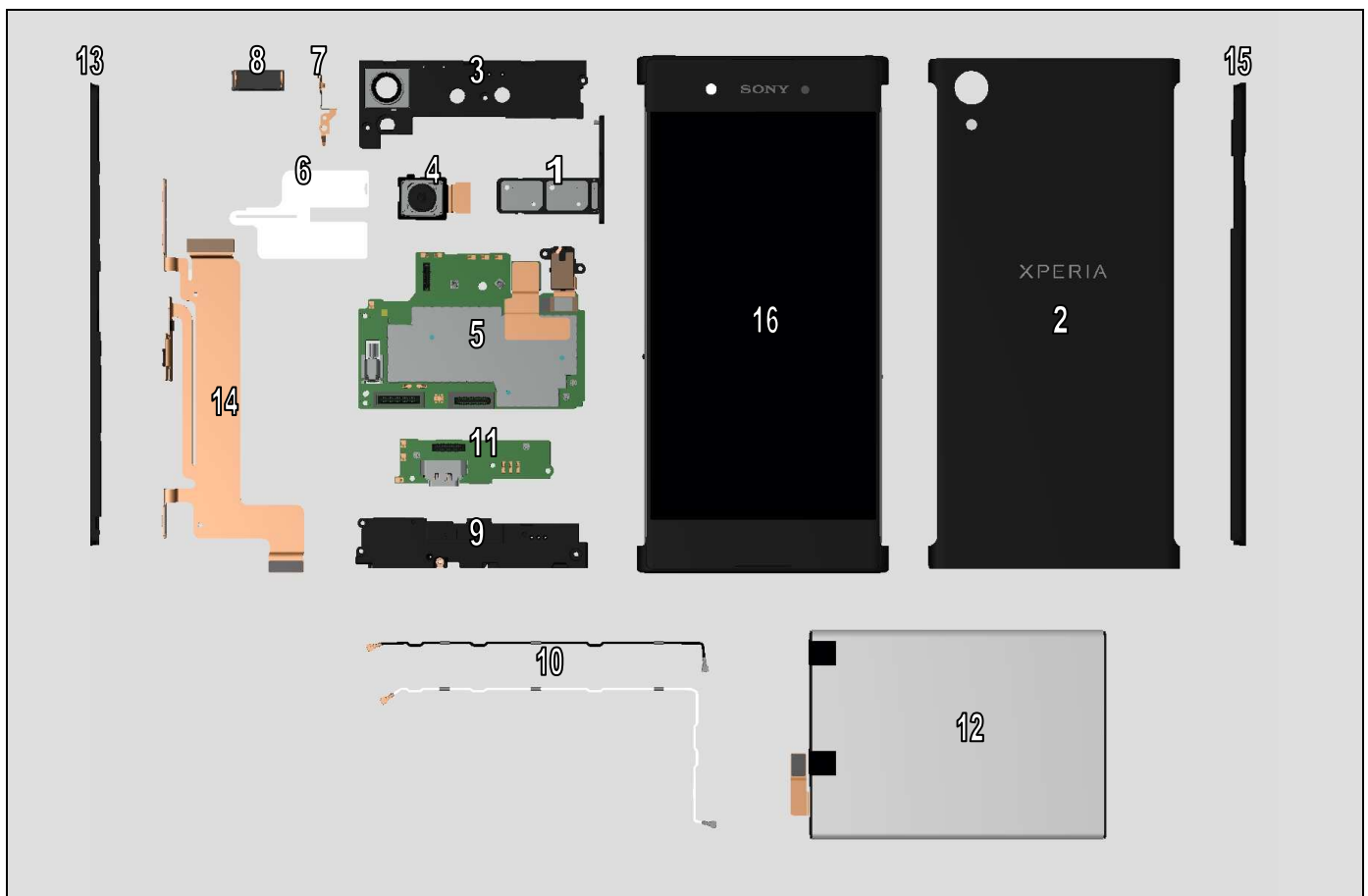
Number in the cells indicates parts  
require replacing for target part.



## 4 Disassembly

The G3412,G3416,G3421,G3423,G3426 disassembly is done in the following order:

- |   |  |
|---|--|
| 1. Cap Tray                             | 10. RF Cable                                 |
| 2. Battery Cover Assy                   | 11. Sub PBA Assy                             |
| 3. Sub Antenna                          | 12. Battery and Adhesive Battery             |
| 4. Main Camera                          | 13. Side Panel Keys, FP Module Assy and Keys |
| 5. Main PBA                             | 14. Sidekey FPC Assy                         |
| 6. CU Label Tray                        | 15. Side Panel SIM/SD                        |
| 7. Bracket Main Camera                  | 16. Display Cover Assy                       |
| 8. Ear Speaker and Adhesive Ear Speaker |  |
| 9. Main Antenna Speaker Box             |  |



## Disassembly

Disassembly Quick Reference Chart is embedded.

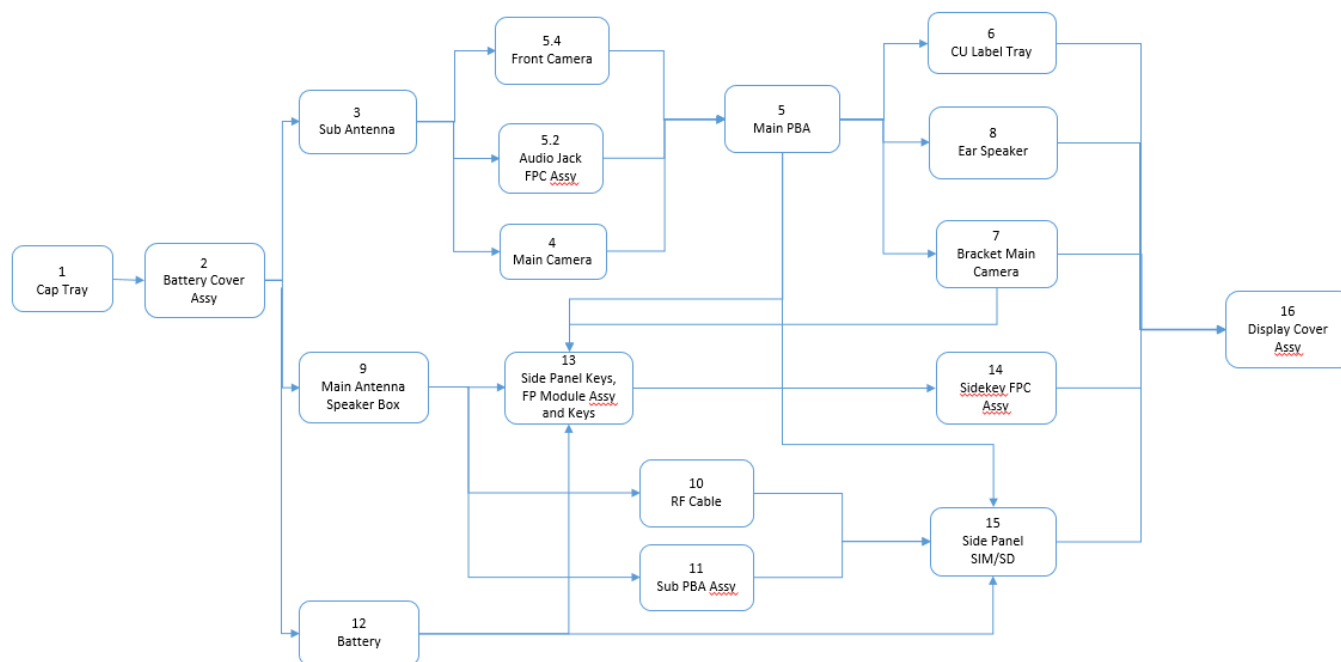


Disassembly  
Procedure.pdf



Required disassembly procedures of specific part removing can be identified by Disassembly Quick Reference Chart.

The sequence numbers of the target parts in the chart correspond to the disassembly chapter numbers. Please refer to corresponding chapter content for the parts not mentioned in this chart.



Replacement Target		Disassembly Procedure
1	Cap Tray	1
2	Battery Cover Assy	1, 2
3	Sub Antenna	1, 2, 3
4	Main Camera	1, 2, 3, 4
5	Main PBA	1, 2, 3, 4, 5.2, 5.4, 5
5.2	Audio Jack FPC Assy	1, 2, 3, 5.2
5.4	Front Camera	1, 2, 3, 5.4
6	CU Label Tray	1, 2, 3, 4, 5.2, 5.4, 5, 6
7	Bracket Main Camera	1, 2, 3, 4, 5.2, 5.4, 5, 7
8	Ear Speaker	1, 2, 3, 4, 5.2, 5.4, 5, 8
9	Main Antenna Speaker Box	1, 2, 9
10	RF Cable	1, 2, 9, 10
11	Sub PBA Assy	1, 2, 9, 11
12	Battery	1, 2, 12
13	Side Panel Keys, FP Module Assy and Keys	1, 2, 3, 4, 5.2, 5.4, 5, 7, 9, 12, 13
14	Sidekey FPC Assy	1, 2, 3, 4, 5.2, 5.4, 5, 7, 9, 12, 13, 14
15	Side Panel SIM/SD	1, 2, 3, 4, 5.2, 5.4, 5, 9, 10, 11, 12, 15
16	Display Cover Assy	1, 2, 3, 4, 5.2, 5.4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16

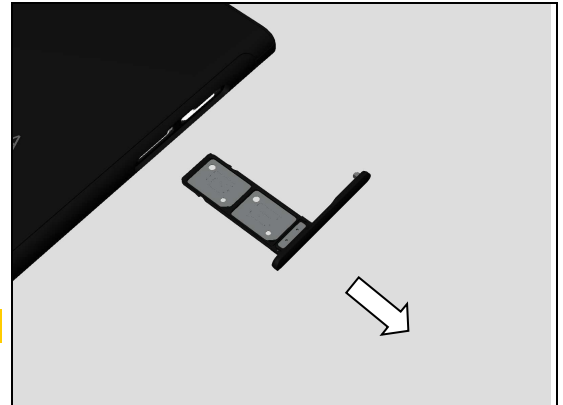
## Disassembly

### 4.1 Cap Tray

#### 4.1.1 Cap Tray Dual (G3412,G3416,G3426)

Remove the Cap Tray Dual with fingers.

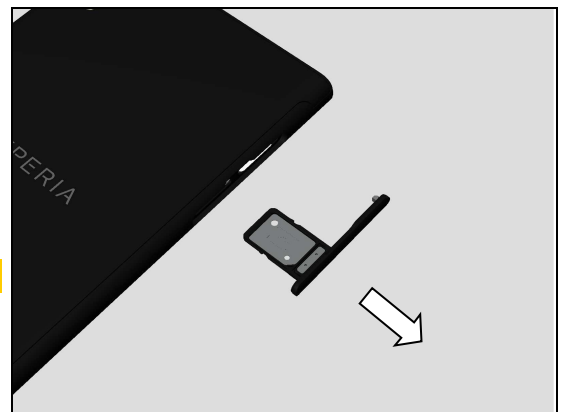
***This is only for G3412, G3416, G3426!***



#### 4.1.2 Cap Tray Single (G3421,G3423)

Remove the Cap Tray Single with fingers.

***This is only for G3421, G3423!***

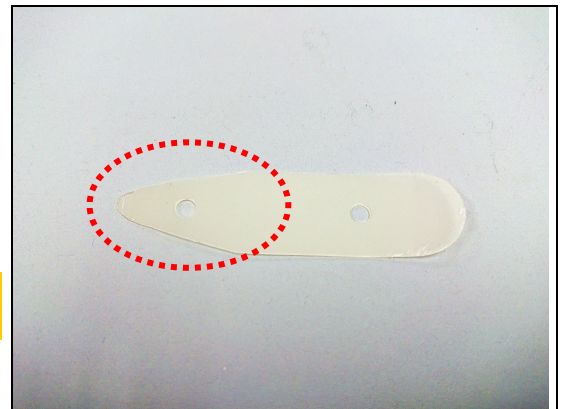


### 4.2 Battery Cover Assy

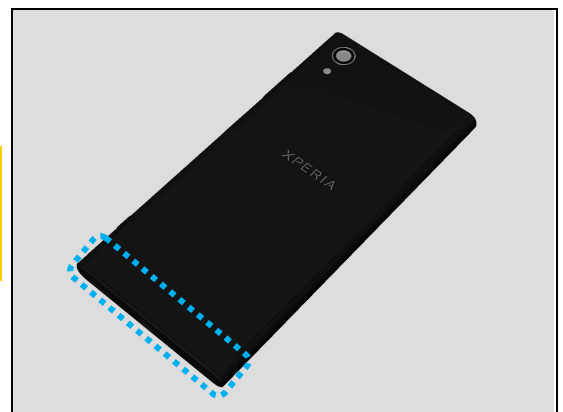
#### 4.2.1 Battery Cover Assy

Prepare two pieces Customized Flexible Disassembly tool.

***Note! One end of Flexible Disassembly tool (1284-7796) cut and sharpened by using scissors and knife.***

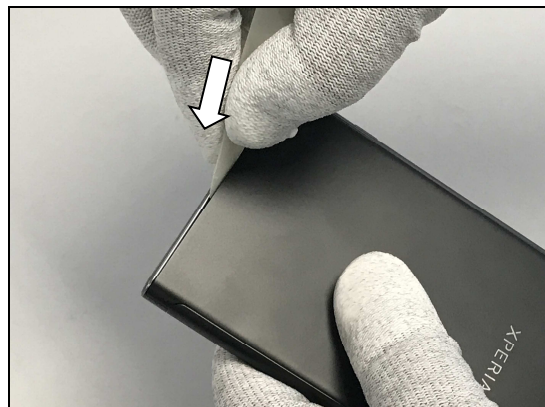


***Note! In order to make the two hooks at bottom corners a little loose, Heating bottom area of the Battery Cover Assy by using Hot Air Gun, temperature 70 degree, distance 1cm, time about 30 seconds to 1 minute.***

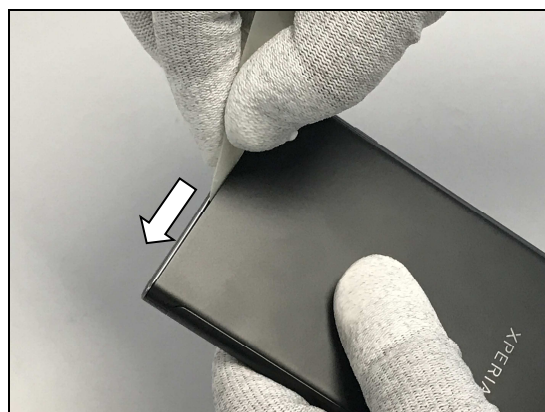


## Disassembly

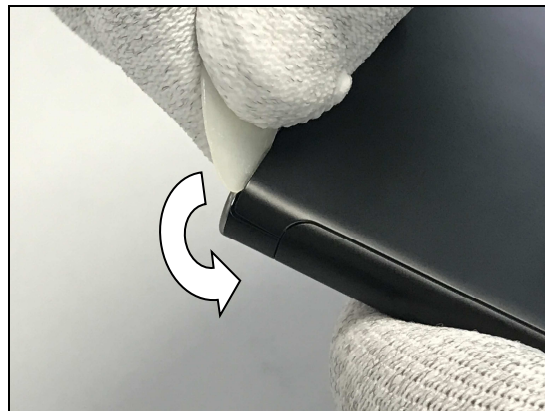
Insert the Customized Flexible Disassembly tool between Battery Cover Assy and front cover at this position as shown in picture.



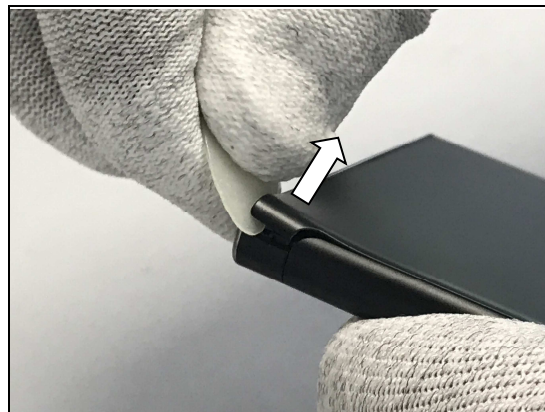
Slowly slide the Customized Flexible Disassembly tool to the corner side.



Very slowly slide along the corner as shown in picture.



Unsnap the corner hook.





## Disassembly

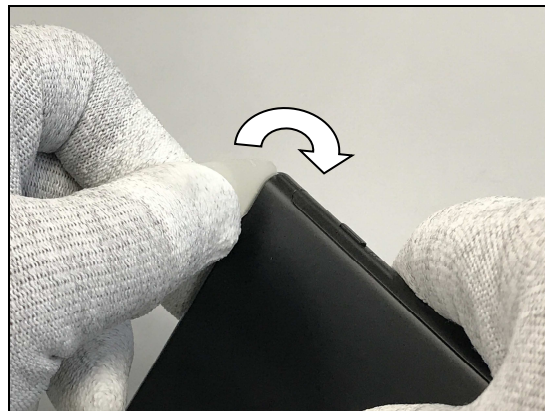
Again, insert the Customized Flexible Disassembly tool between Battery Cover Assy and front cover at this position as shown in picture.



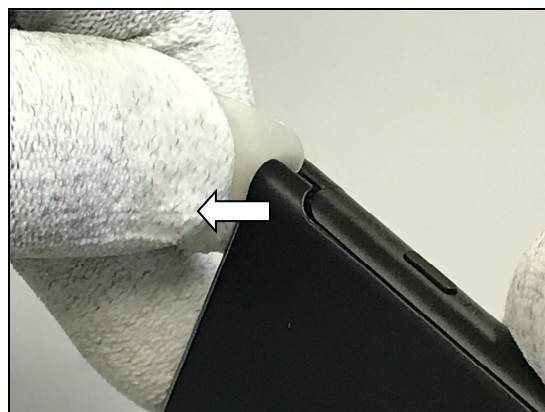
Slowly slide the Customized Flexible Disassembly tool to the corner side.



Very slowly slide along the corner as shown in picture.

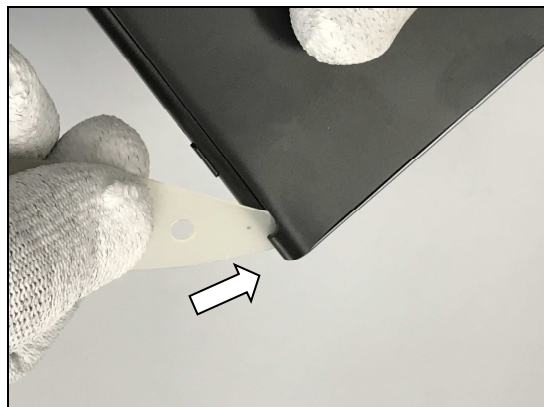


Unsnap the corner hook.

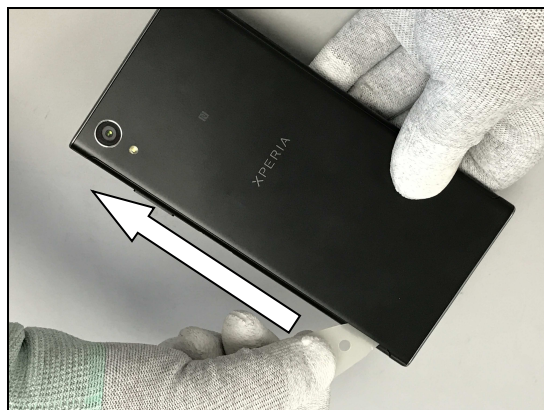


## Disassembly

Insert the Customized Flexible Disassembly tool between Battery Cover Assy and front cover at this corner.

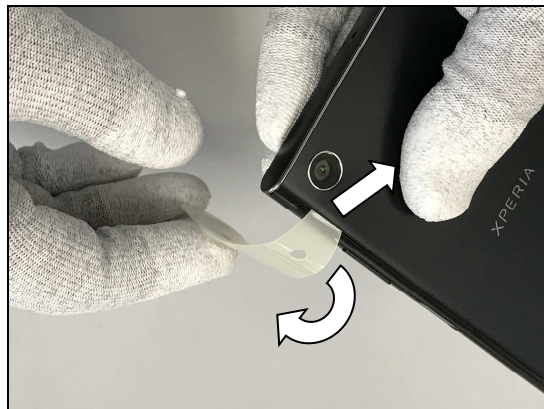


Slowly slide the Customized Flexible Disassembly tool to cut the Adhesive Battery Cover Right.



Slide the Customized Flexible Disassembly tool until top corner stop it.

Then bend the Customized Flexible Disassembly tool to push up the Battery Cover Assy as shown in picture.

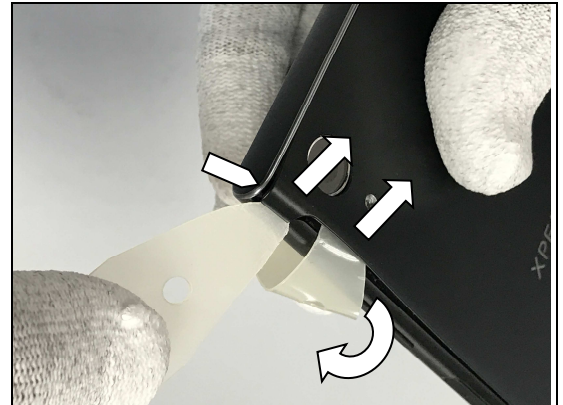


And then, a gap is made at the top corner between Battery Cover Assy and front cover.

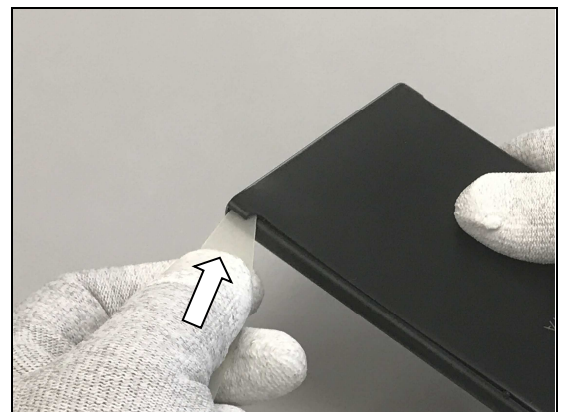


## Disassembly

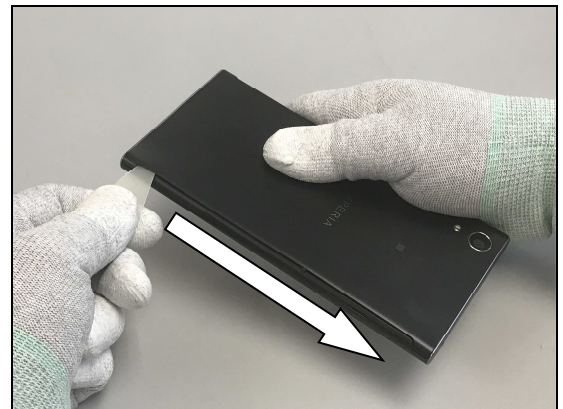
Keep the Customized Flexible Disassembly tool bending to push the Battery Cover Assy.  
Insert another Customized Flexible Disassembly tool into the gap at the top corner and then unsnap the corner hook.



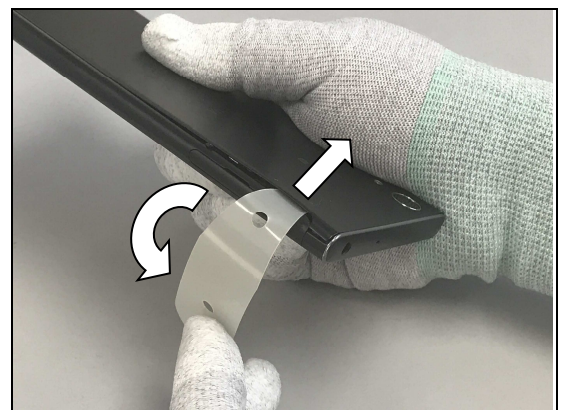
Insert the Customized Flexible Disassembly tool between Battery Cover Assy and front cover at this corner.



Slowly slide the Customized Flexible Disassembly tool to cut the Adhesive Battery Cover Left.



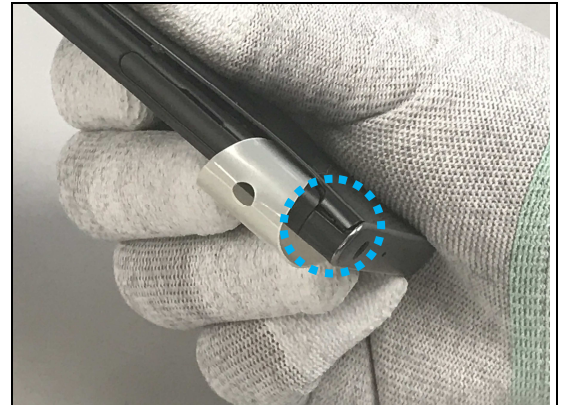
Slide the Customized Flexible Disassembly tool until top corner stop it.  
Then bend the Customized Flexible Disassembly tool to push up the Battery Cover Assy as shown in picture.



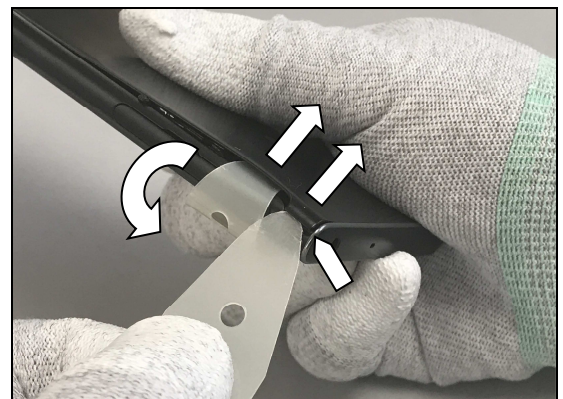


## Disassembly

And then, a gap is made at the top corner between Battery Cover Assy and front cover.



Keep the Customized Flexible Disassembly tool bending to push the Battery Cover Assy.  
Insert another Customized Flexible Disassembly tool into the gap at the top corner and then unsnap the corner hook.



Hold the bottom right area of the Battery Cover Assy by fingers to slowly detach the Adhesive Battery Cover Bottom.

**Note! During this action the Battery Cover Assy may deform to some extent, if not damaged it can be reused.**



Hold the middle right area of the Battery Cover Assy by fingers to slowly detach the Adhesive NFC area of the Battery Cover Assy.

**Be careful! When detaching the thumb should hold Copper Foil Battery Cover.**

**Detach the Adhesive NFC area from right side to left side!**

**Note! During this action the Battery Cover Assy may deform to some extent, if not damaged it can be reused.**





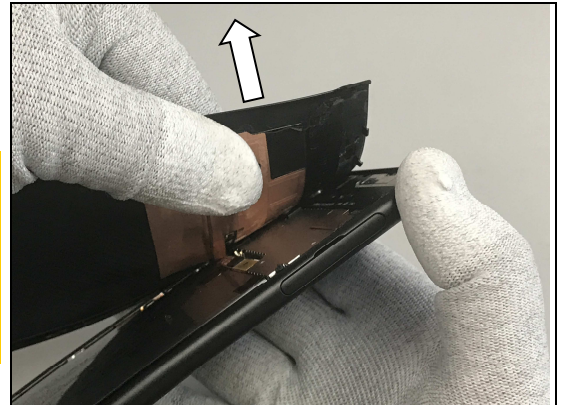
## Disassembly

Hold the middle area of the Battery Cover Assy by fingers to slowly detach the Adhesive NFC and Adhesive Battery Cover Top area of the Battery Cover Assy.

**Be careful! When detaching the thumb should hold Copper Foil Battery Cover.**

**Detach the Adhesive NFC area and Adhesive Battery Cover Top area from right side to left side!**

**Note! During this action the Battery Cover Assy may deform to some extent, if not damaged it can be reused.**

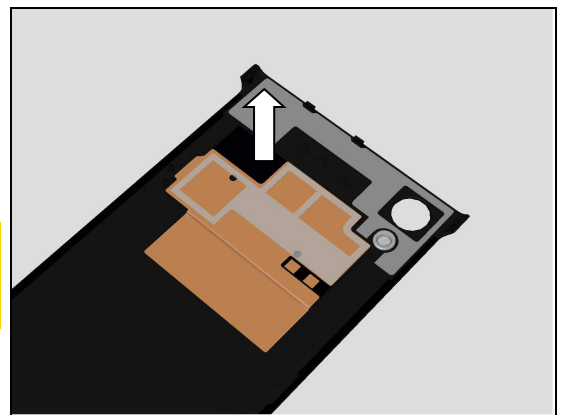


### 4.2.2 Adhesive NFC

Detach the Adhesive NFC.

**Scrap! Not to be reuse!**

**Make sure all remaining adhesive residue have been removed!**

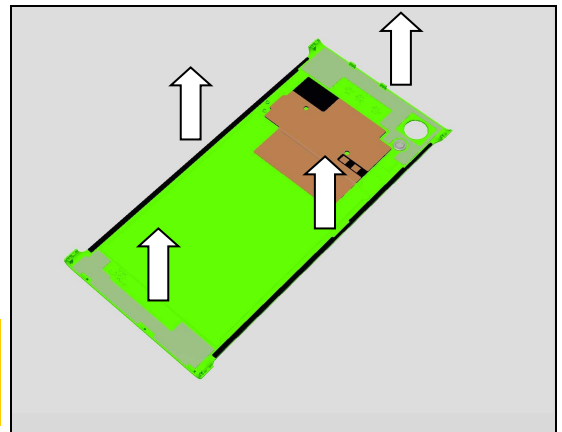


### 4.2.3 Adhesive Battery Cover Top, Adhesive Battery Cover Bottom, Adhesive Battery Cover Left and Adhesive Battery Cover Right

Detach the Adhesive Battery Cover Top, Adhesive Battery Cover Bottom, Adhesive Battery Cover Left and Adhesive Battery Cover Right.

**Scrap! Not to be reuse!**

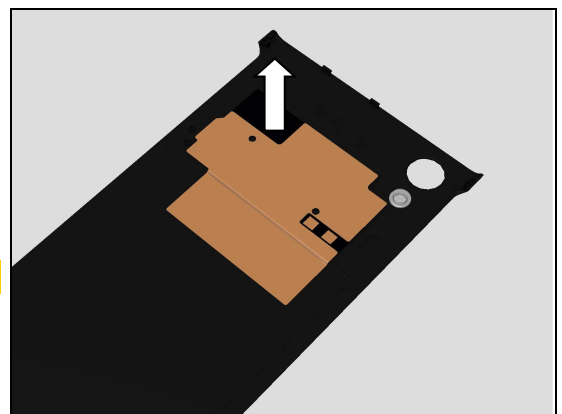
**Make sure all remaining adhesive residue have been removed!**



### 4.2.4 Copper Foil Battery Cover

Detach the Copper Foil Battery Cover.

**Scrap! Not to be reuse!**

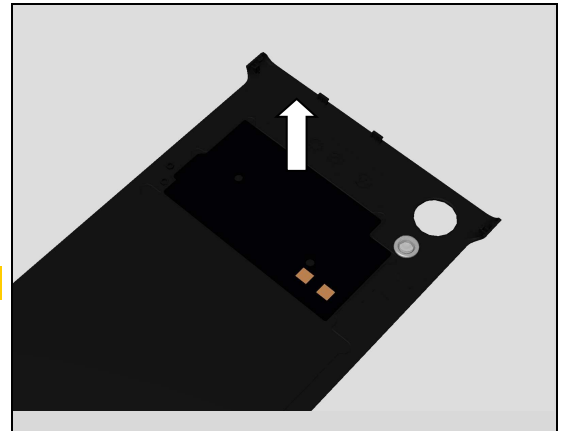


## Disassembly

### 4.2.5 Antenna NFC

Detach the Antenna NFC.

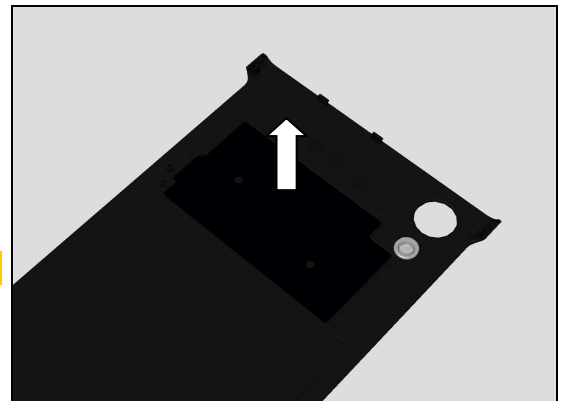
**Scrap! Not to be reuse!**



### 4.2.6 Mylar NFC

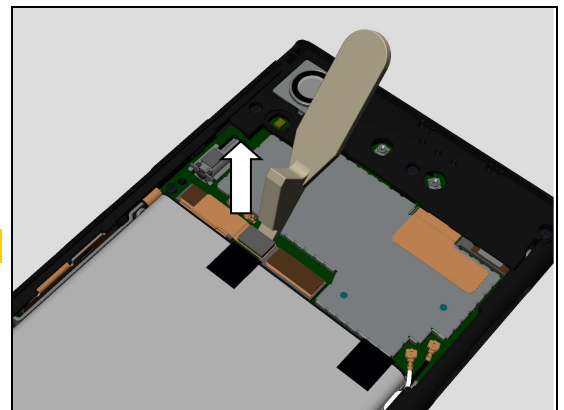
Detach the Mylar NFC.

**Scrap! Not to be reuse!**



Disconnect the Battery connector by using the Front Opening Tool.

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

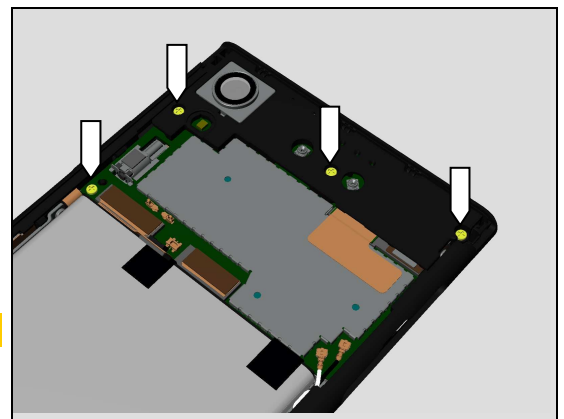


## 4.3 Sub Antenna

### 4.3.1 Sub Antenna

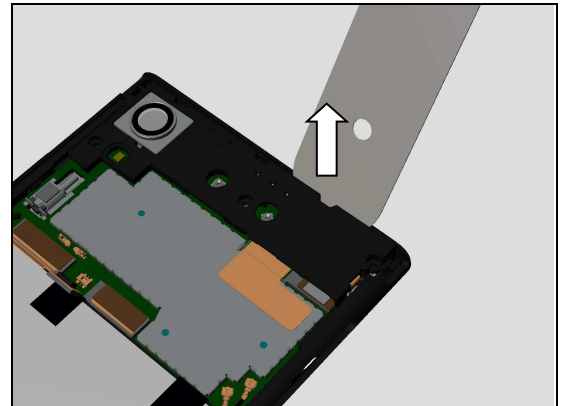
Remove the four Screw CROSS M1.2 L2.67 Black by using a screwdriver with Bits JCIS No.0.

**Scrap! Not to be reused!**

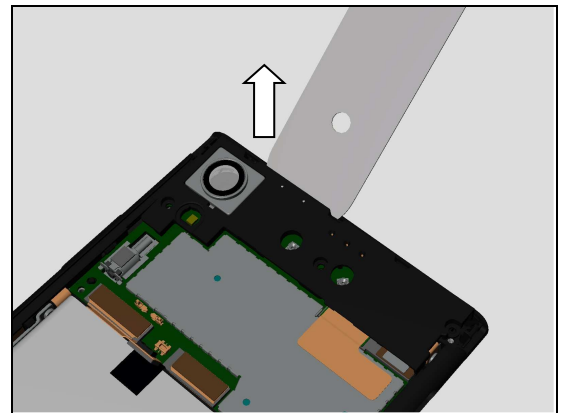


## Disassembly

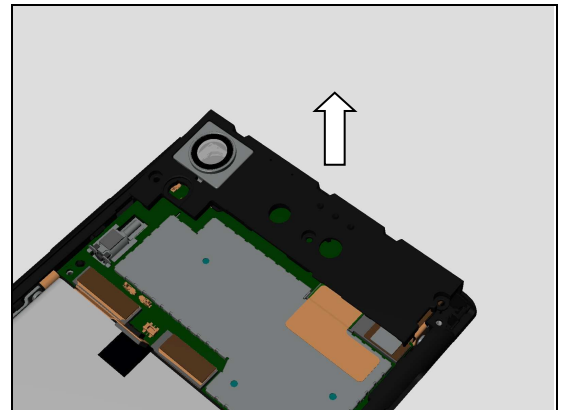
Release the Sub Antenna and Main Camera Lens Assy firstly from this position by using Flexible Disassembly tool as shown in picture.



Then release the Sub Antenna and Main Camera Lens Assy from this position by using Flexible Disassembly tool as shown in picture.

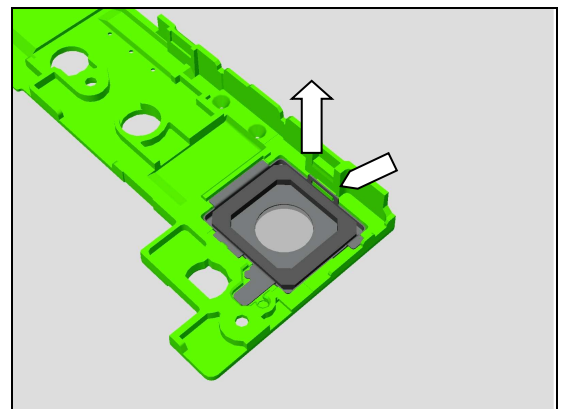


Remove the Sub Antenna and Main Camera Lens Assy.



### 4.3.2 Main Camera Lens Assy

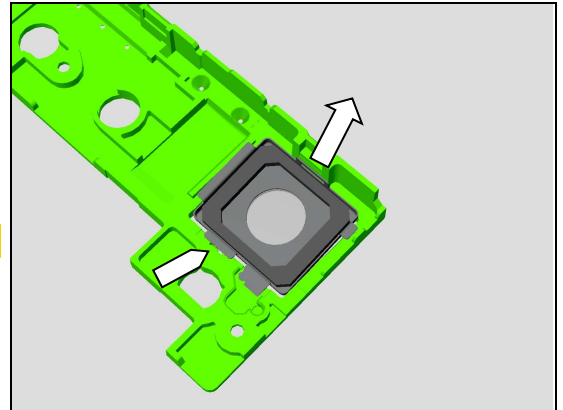
Deform the Sub Antenna a little to release this hook by fingers.



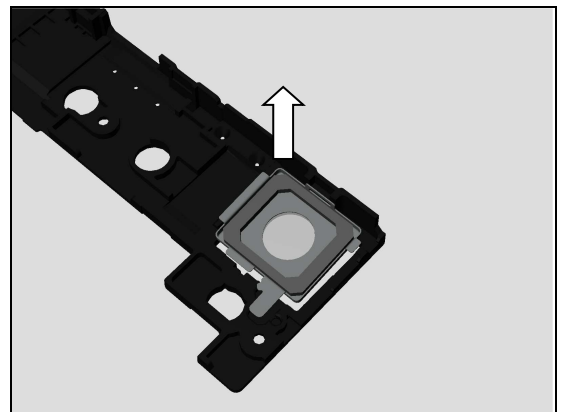
## Disassembly

Release the Main Camera Lens Assy from this small rib by fingers as shown in picture.

**Be careful! Do not damage the small rib.**



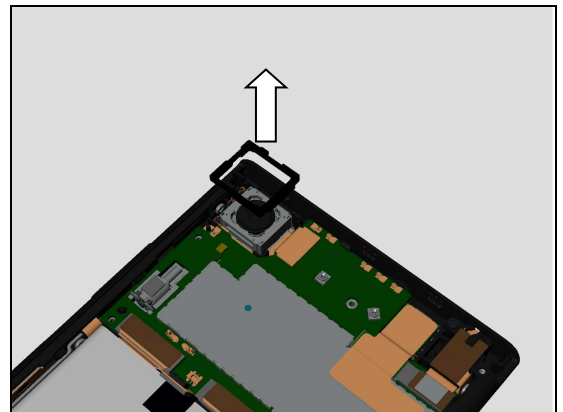
Remove the Main Camera Lens Assy.



### 4.4 Main Camera

#### 4.4.1 Rubber Main Camera

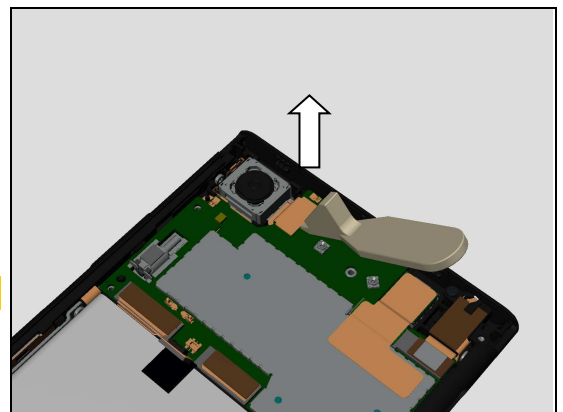
Remove the Rubber Main Camera.



#### 4.4.2 Main Camera

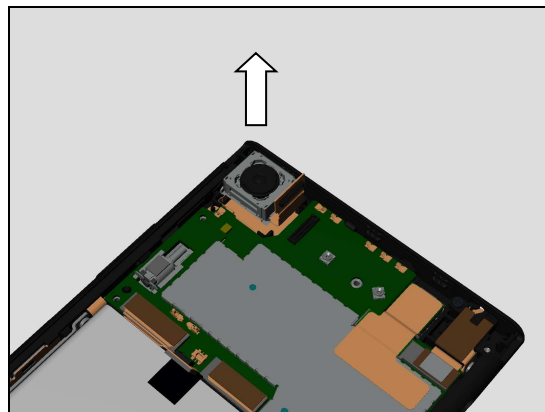
Disconnect the Main Camera BtB connector by using the Front Opening Tool.

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



## Disassembly

Remove the Main Camera.

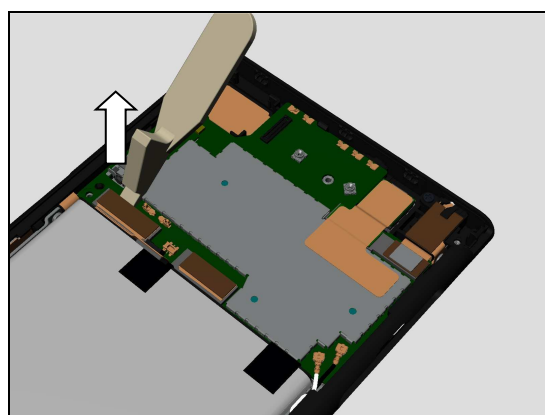


### 4.5 Main PBA

#### 4.5.1 Main PBA

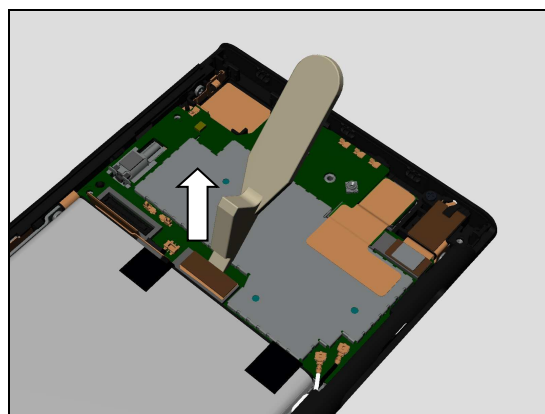
Disconnect the Sidekey FPC Assy BtB connector by using the Front Opening Tool.

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



Disconnect the Display FPC BtB connector by using the Front Opening Tool.

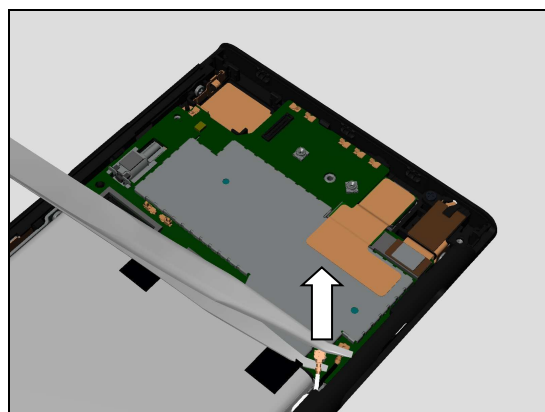
**Do not damage components on the Main PBA!**



Disconnect the RF Cable White connector by using the Flex Film Assembly Tool.

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

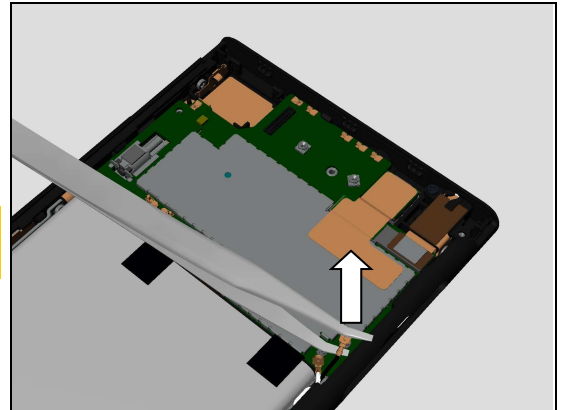
**This is only for G3421,G3423,G3426!**



## Disassembly

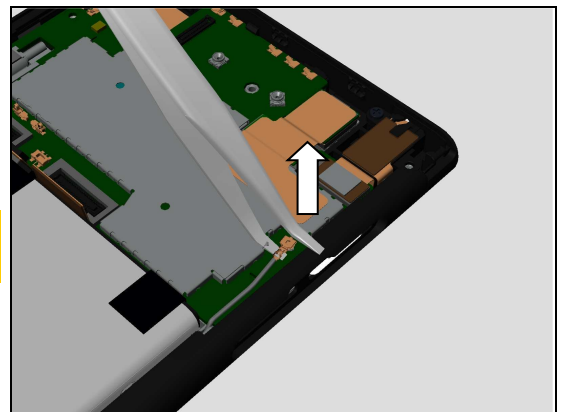
Disconnect the RF Cable Black connector by using the Flex Film Assembly Tool.

**Do not damage components on the Main PBA!**  
**This is only for G3421,G3423,G3426!**



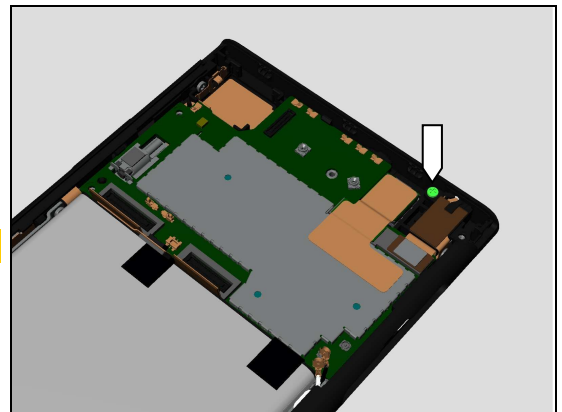
Disconnect the RF Cable Grey connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**  
**This is only for G3412,G3416!**

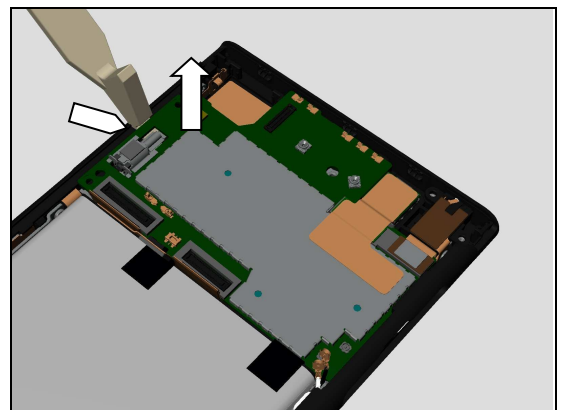


Remove the Screw CROSS M1.2 L2.67 Black by using a screwdriver with Bits JCIS No.0.

**Scrap! Not to be reused!**



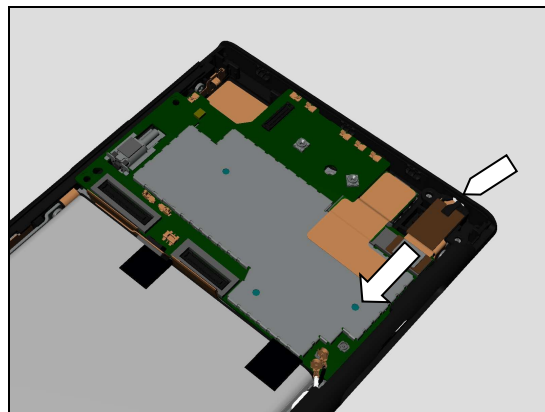
Release the Main PBA from this position by using the Front Opening Tool.



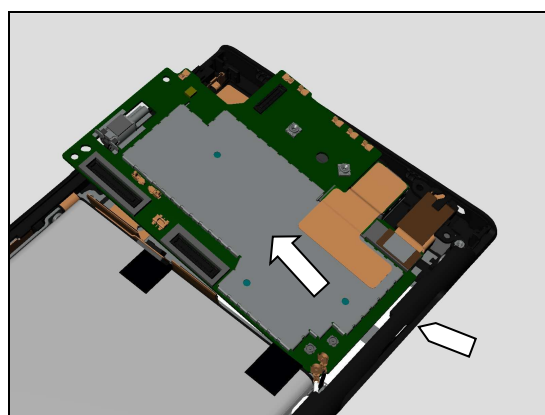


## Disassembly

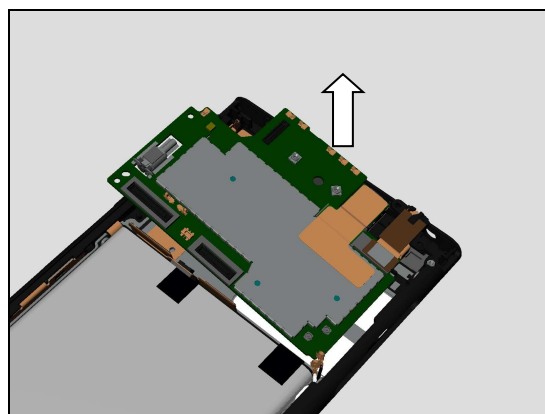
Release Audio Jack FPC Assy from its hole as shown in picture.



Release the Main PBA from SIM/SD hole as shown in picture.



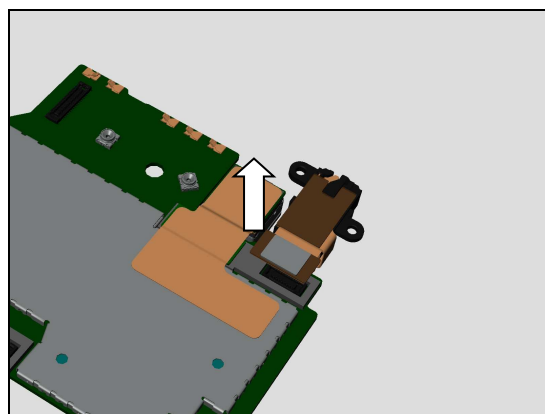
Remove the Main PBA.



### 4.5.2 Audio Jack FPC Assy

Disconnect the Audio Jack FPC Assy BtB connector and remove the Audio Jack FPC Assy.

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

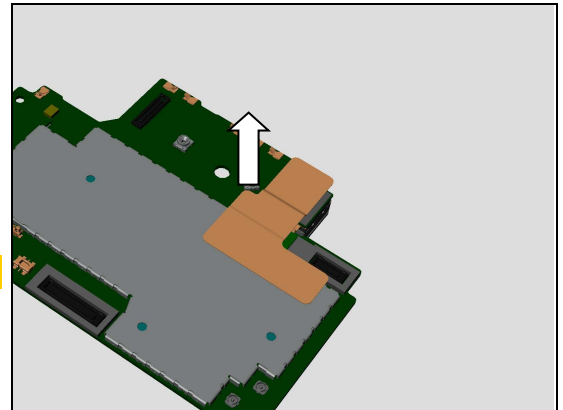


## Disassembly

### 4.5.3 Copper Foil Front Camera

Detach the Copper Foil Front Camera.

**Scrap! Not to be reused!**

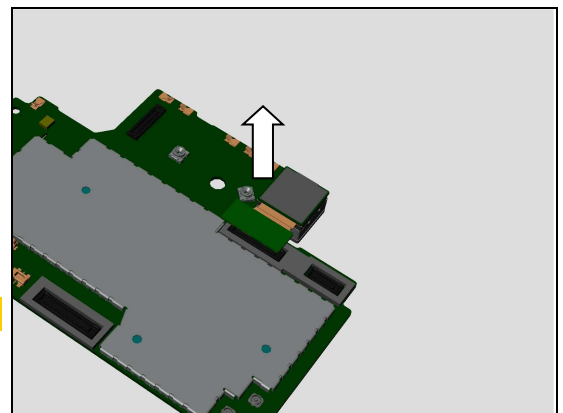


### 4.5.4 Front Camera

#### 4.5.4.1 Front Camera

Disconnect the Front Camera BtB connector and remove the Front Camera.

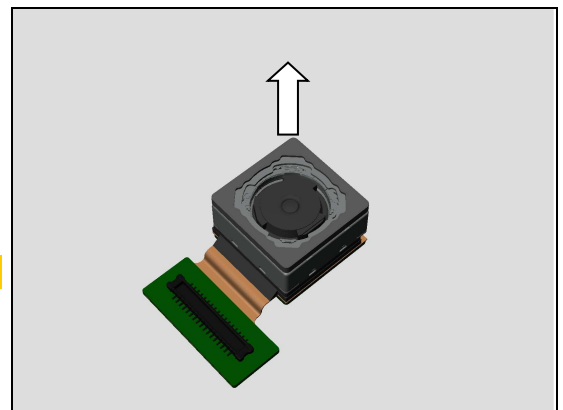
**Do not damage components on the Main PBA!**



#### 4.5.4.2 Sponge Front Camera

Detach the Sponge Front Camera.

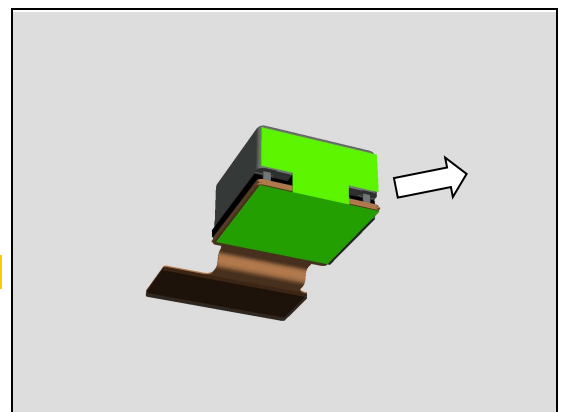
**Scrap! Not to be reused!**



#### 4.5.4.3 Conductive Tape Front Camera

Detach the Conductive Tape Front Camera.

**Scrap! Not to be reused!**

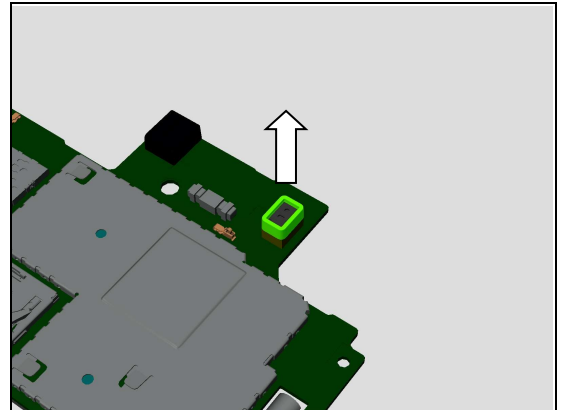




## Disassembly

### 4.5.5 Rubber PL Sensor

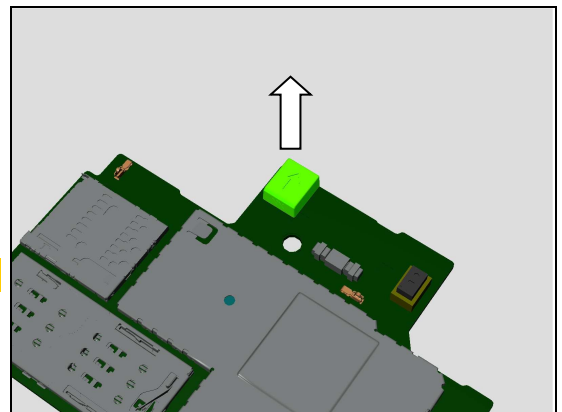
Remove the Rubber PL Sensor.



### 4.5.6 Rubber 2nd MIC

Detach the Rubber 2nd MIC.

**Scrap! Not to be reused!**

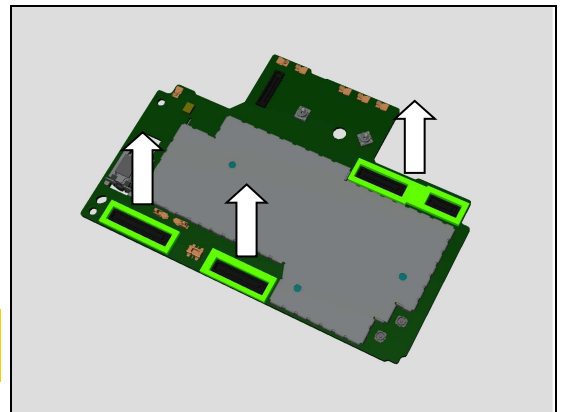


### 4.5.7 Adhesive Rubber BTB Front Cam&AJ, Adhesive Rubber BTB LCM and Adhesive Rubber BTB Sidekey FPC

Detach these Adhesive Rubber BTB.

**Scrap! Not to be reused!**

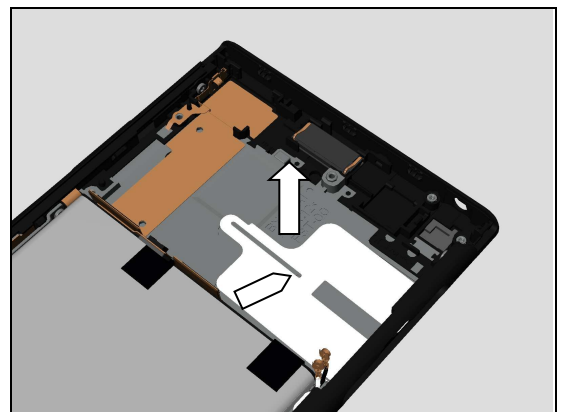
**Do not damage components on the Main PBA!**



## 4.6 CU Label Tray

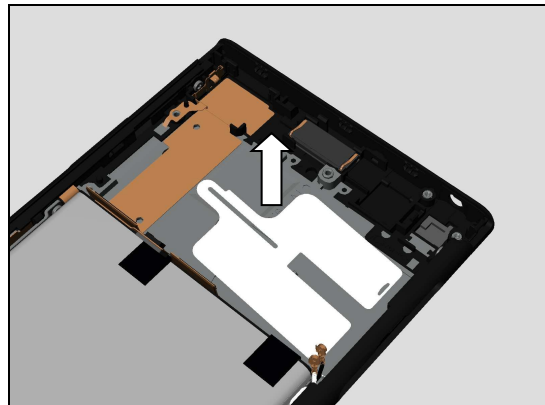
### 4.6.1 CU Label Tray

Release the CU Label Tray from its position pin.



## Disassembly

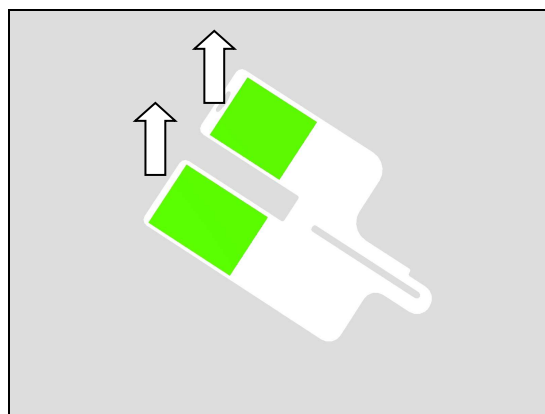
Remove the CU Label Tray.



### 4.6.2 CU Label

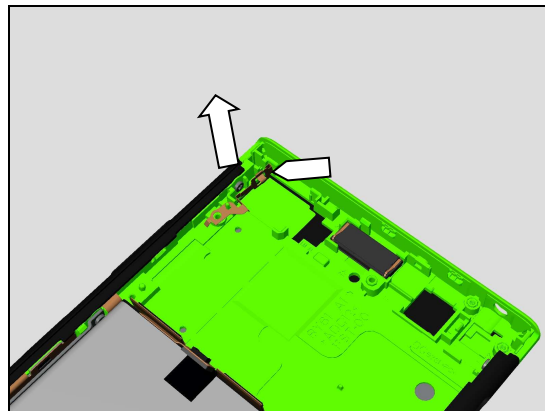
Detach the CU Label.

**Scrap! Not to be reused!**  
**Do not damage the CU Label Tray!**

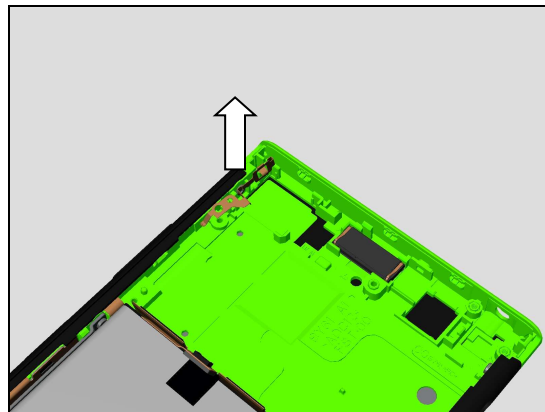


## 4.7 Bracket Main Camera

Release the Bracket Main Camera this side by using the plastic tweezers as shown in picture.



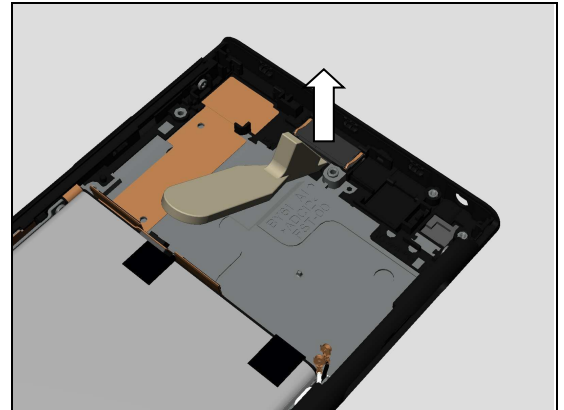
Remove the Bracket Main Camera.



## Disassembly

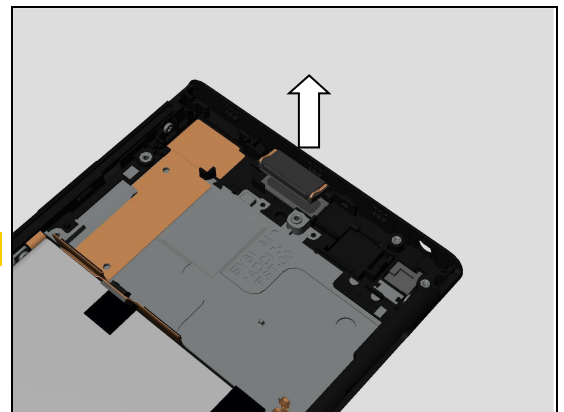
### 4.8 Ear Speaker and Adhesive Ear Speaker

Detach the Ear Speaker by using the Front Opening Tool.



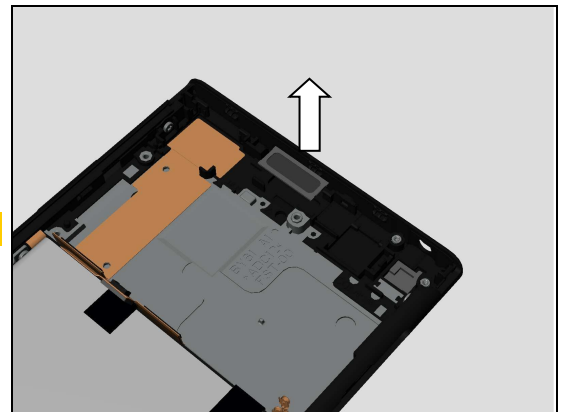
Remove the Ear Speaker.

**Scrap! Not to be reused!**



Detach the Adhesive Ear Speaker by using plastic tweezers.

**Scrap! Not to be reused!**

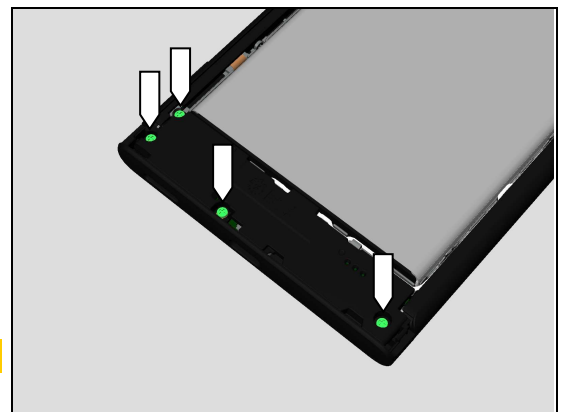


### 4.9 Main Antenna Speaker Box

#### 4.9.1 Main Antenna Speaker Box

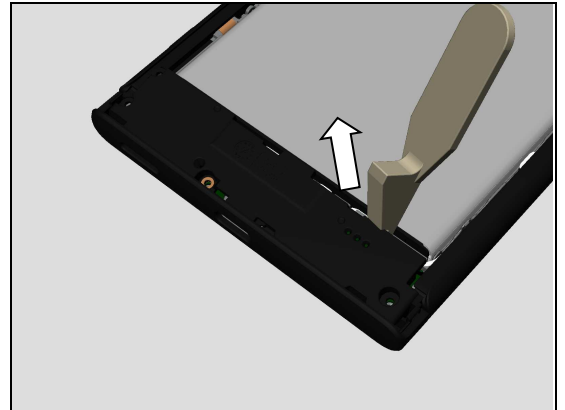
Remove the four Screw CROSS M1.2 L2.67 Black by using a screwdriver with Bits JCIS No.0.

**Scrap! Not to be reused!**

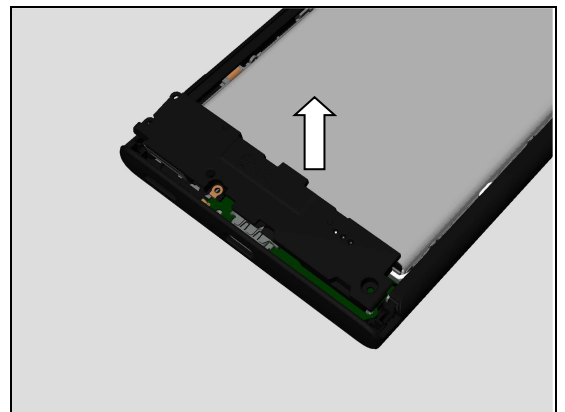


## Disassembly

Release the Main Antenna Speaker Box from this position by using the Front opening tool as shown in picture.



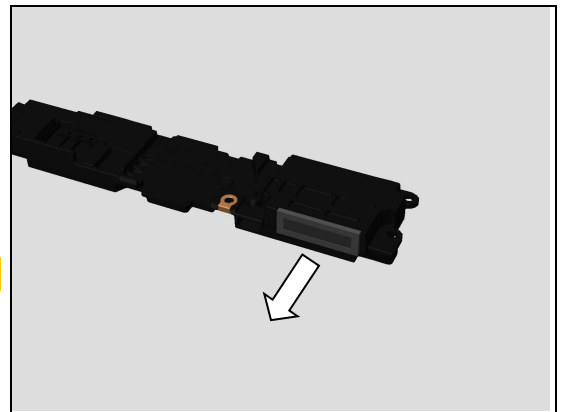
Remove the Main Antenna Speaker Box.



### 4.9.2 Speaker Sponge

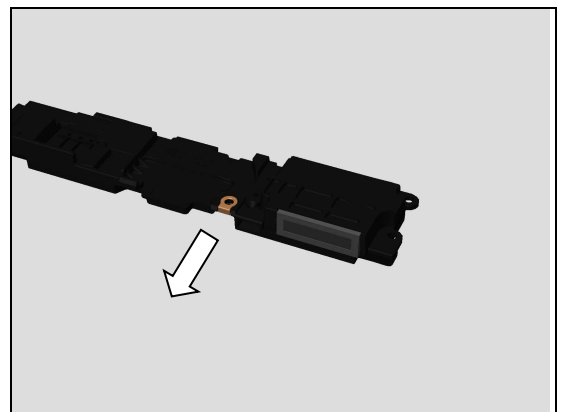
Detach the Speaker Sponge by using the plastic tweezers.

**Scrap! Not to be reused!**



### 4.9.3 Contact Clip Speaker Box

Remove the Contact Clip Speaker Box.



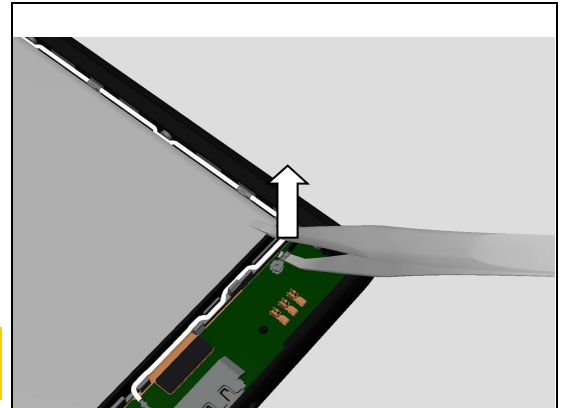
## Disassembly

### 4.10 RF Cable

#### 4.10.1 RF Cable White and RF Cable Black (G3421,G3423,G3426)

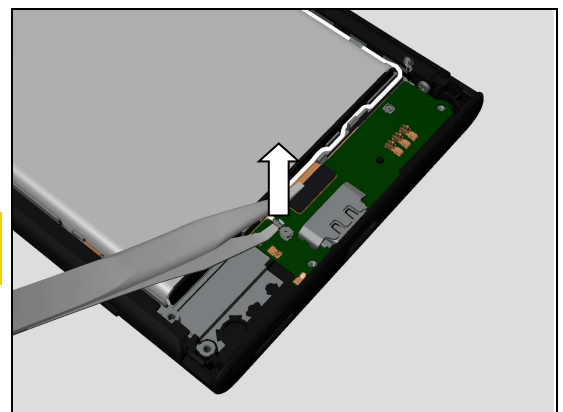
Disconnect the RF Cable Black connector by using the Flex Film Assembly Tool.

**Do not damage components on the Sub PBA!**  
**This is only for G3421,G3423,G3426!**



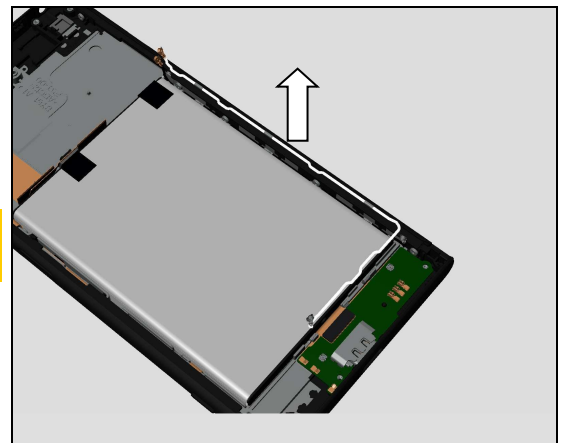
Disconnect the RF Cable White connector by using the Flex Film Assembly Tool.

**Do not damage components on the Sub PBA!**  
**This is only for G3421,G3423,G3426!**



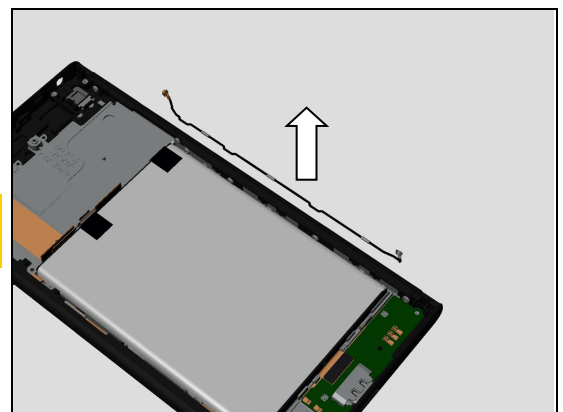
Remove the RF Cable White.

**This is only for G3421,G3423,G3426!**  
**Scrap! Not to be reused!**



Remove the RF Cable Black.

**This is only for G3421,G3423,G3426!**  
**Scrap! Not to be reused!**

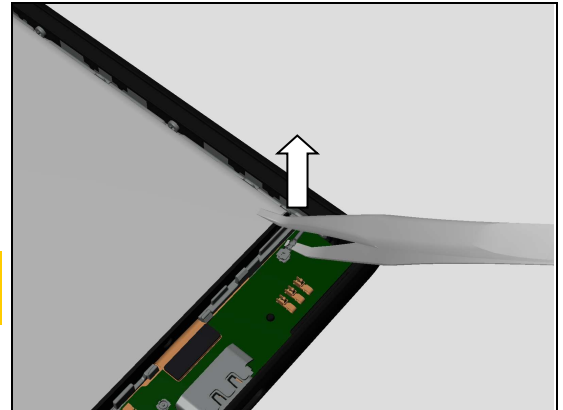


## Disassembly

### 4.10.2RF Cable Grey (G3412,G3416)

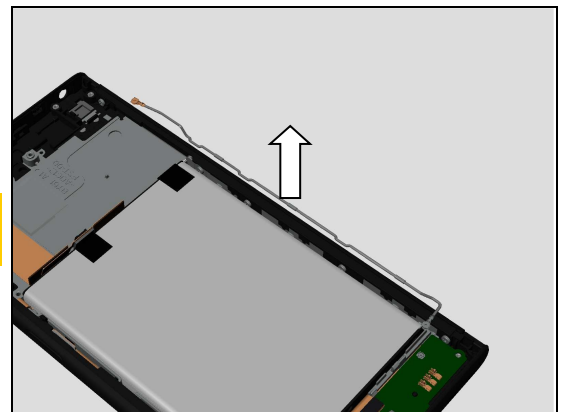
Disconnect the RF Cable Grey connector by using the Flex Film Assembly Tool.

**Do not damage components on the Sub PBA!**  
**This is only for G3412,G3416!**



Remove the RF Cable Grey.

**This is only for G3412,G3416!**  
**Scrap! Not to be reused!**

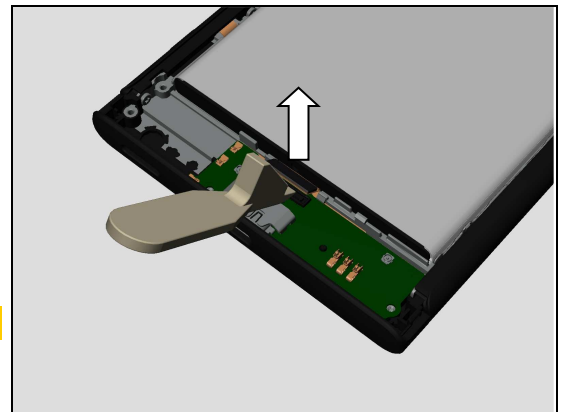


### 4.11 Sub PBA Assy

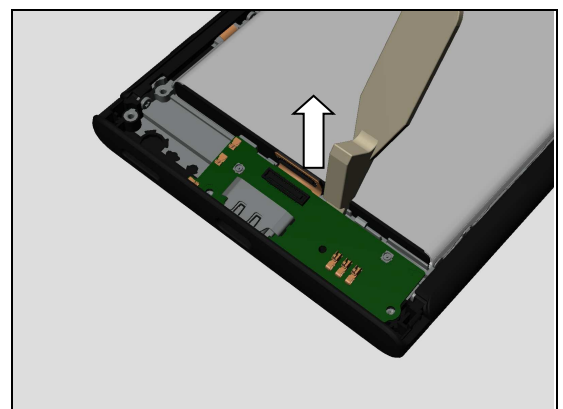
#### 4.11.1 Sub PBA Assy

Disconnect the Sidekey FPC Assy BtB connector by using the Front Opening Tool.

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

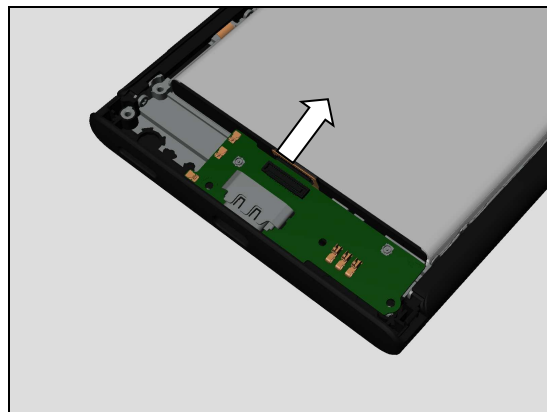


Release the Sub PBA Assy from this position by using the Front Opening Tool.

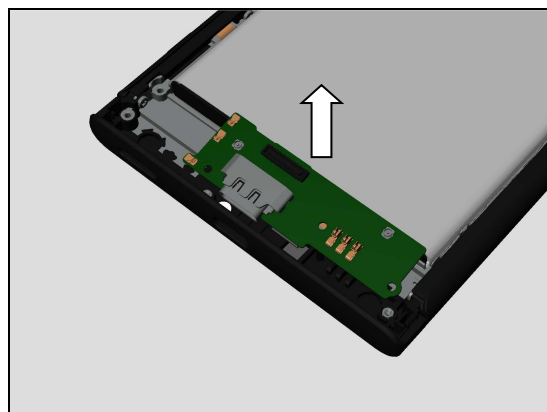


## Disassembly

Release the Sub PBA Assy from USB hole.



Remove the Sub PBA Assy

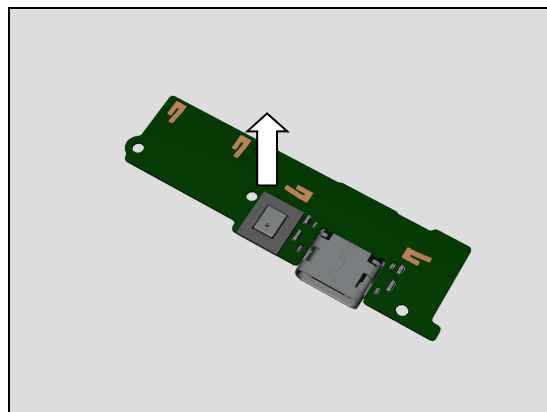


### 4.11.2Sponge 1st Mic

Detach Sponge 1st Mic.

**Scrap! Not to be reused!**

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

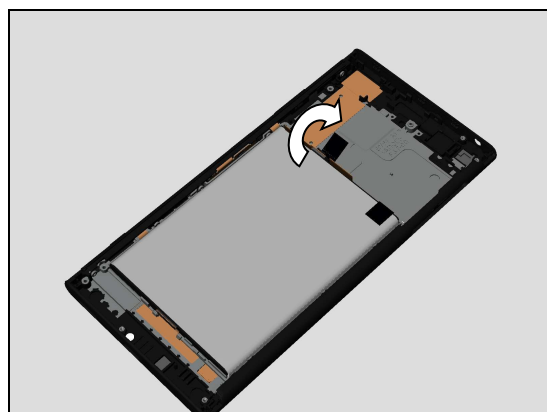


## 4.12 Battery and Adhesive Battery

### 4.12.1Battery and Adhesive Battery

Slowly detach the tab of the Adhesive Battery as shown in picture.

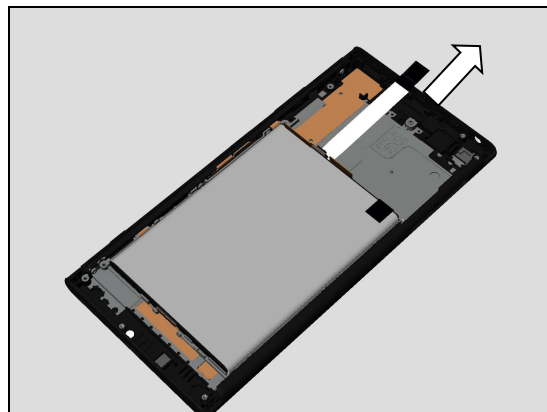
**Make sure not to damage the Battery!**



## Disassembly

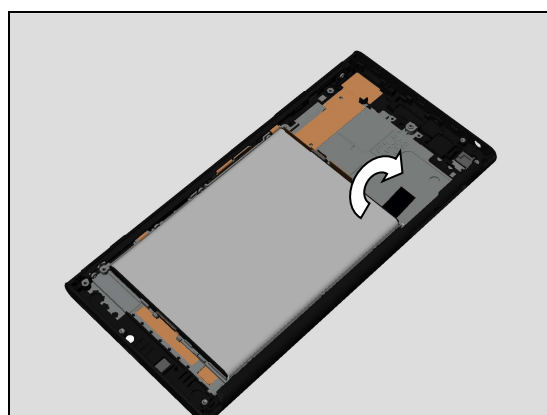
Slowly pull out the Adhesive Battery as shown in picture.

**Scrap! Not to be reused!**



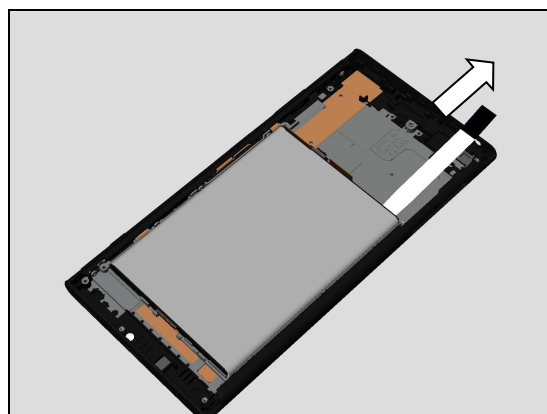
Slowly detach the tab of the Adhesive Battery as shown in picture.

**Make sure not to damage the Battery!**

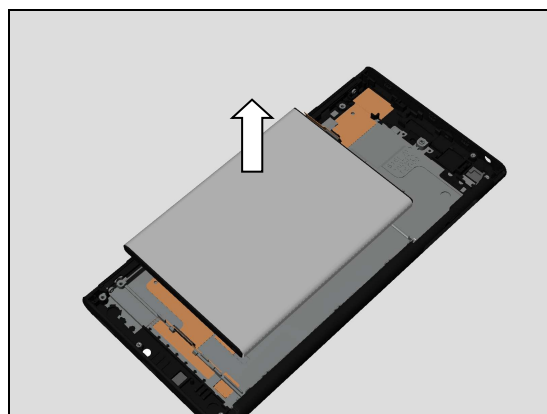


Slowly pull out the Adhesive Battery as shown in picture.

**Scrap! Not to be reused!**



Remove the Battery.



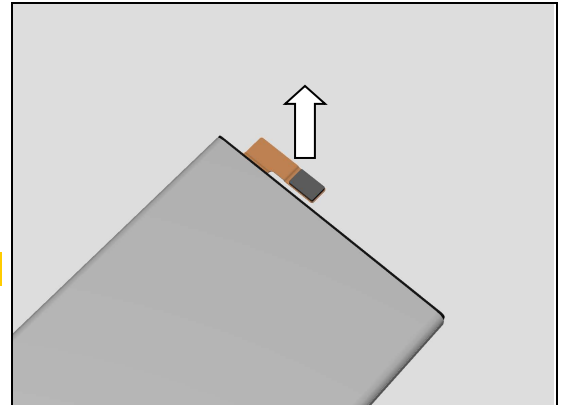


## Disassembly

### 4.12.2 Sponge Battery Connector

Detach the Sponge Battery Connector.

**Scrap! Not to be reused!**

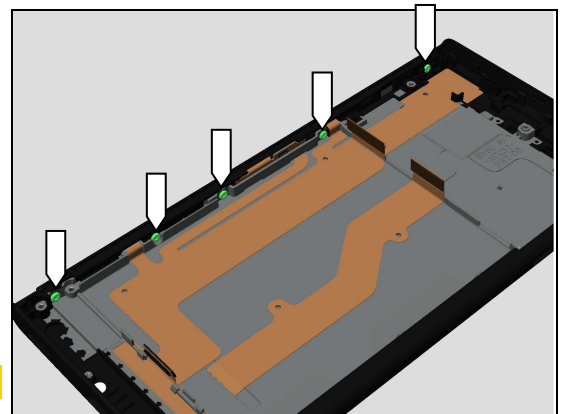


### 4.13 Side Panel Keys, FP Module Assy and Keys

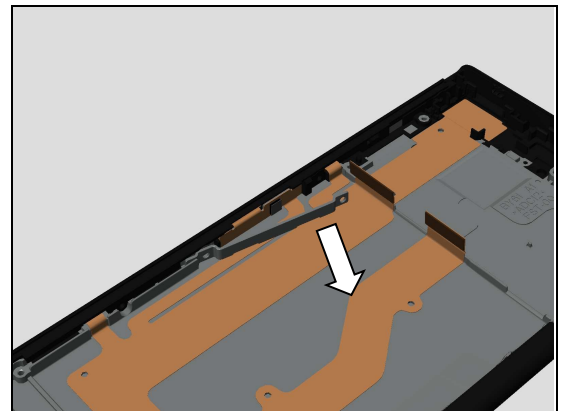
#### 4.13.1 Bracket FP Module, Side Panel Keys and Adhesive LCM

Remove the five Screw TORX M1.4 L3.25 Silver by using a T5 screwdriver.

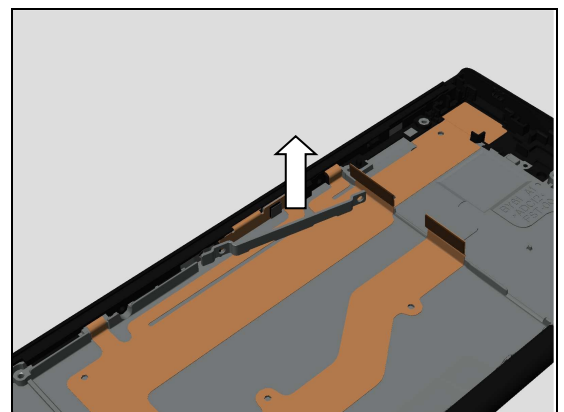
**Scrap! Not to be reused!**



Release this side of the Bracket FP Module.



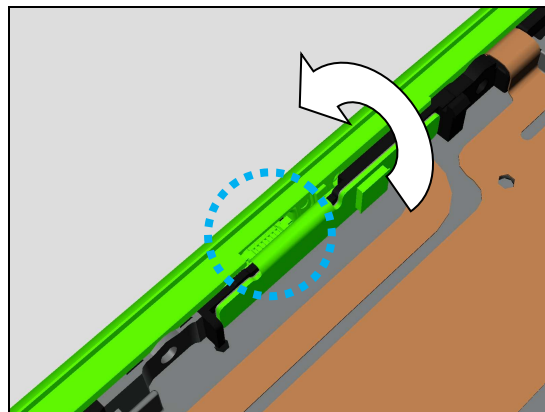
Remove the Bracket FP Module.



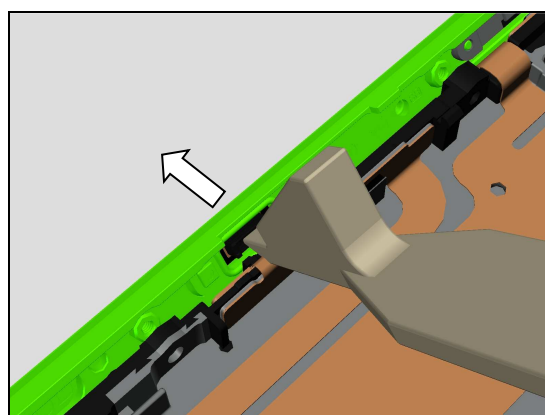
## Disassembly

Turn the Side Panel Keys a little to make space for applying tool as shown in picture.

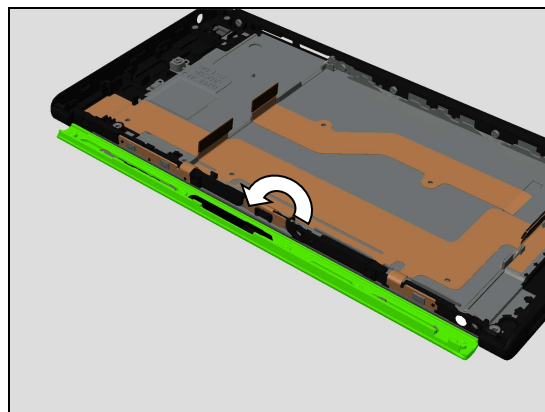
**Note! Do not directly detach the Side Panel Keys from front cover!**



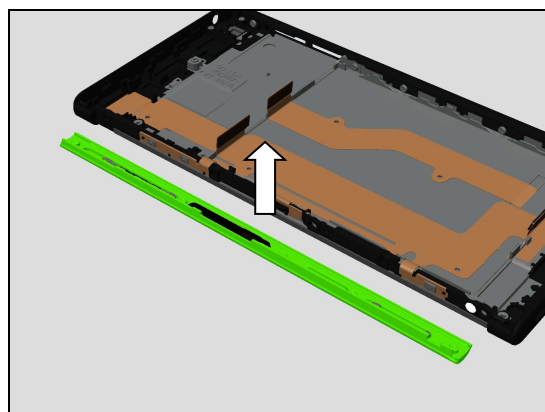
Disconnect FP Module BtB connector by using Front opening tool as shown in picture.



Detach the Side Panel Keys.



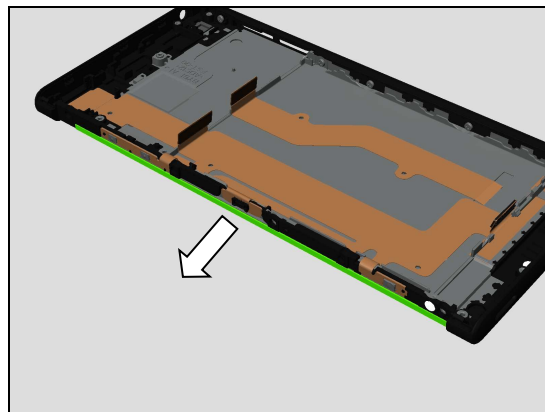
Remove the Side Panel Right.



## Disassembly

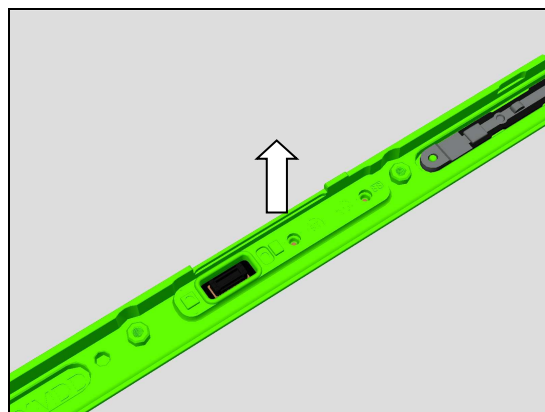
Detach the Adhesive LCM.

**Scrap! Not to be reused!**



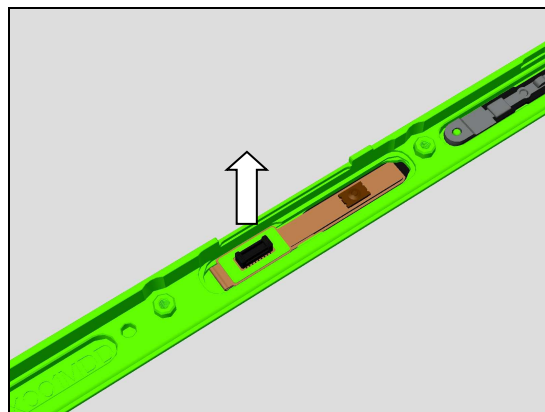
### 4.13.2 Holder FP Module, Adhesive BtB FP Module, FP Module Assy and Adhesive FP Module

Detach to remove the Holder FP Module.

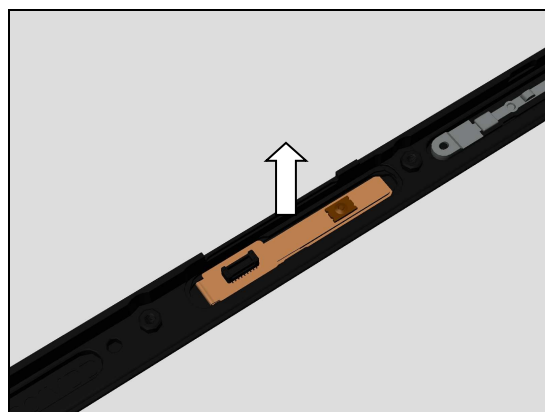


Detach the Adhesive BtB FP Module.

**Scrap! Not to be reused!**



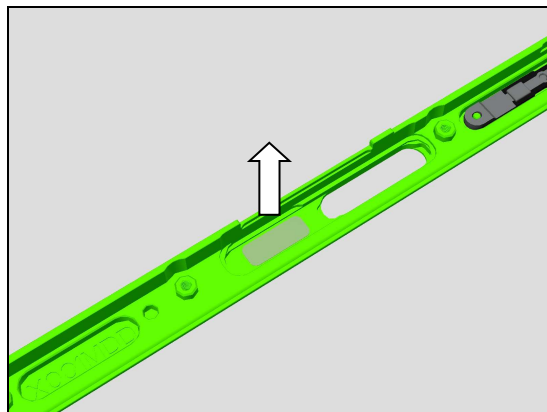
Detach to remove the FP Module Assy.



## Disassembly

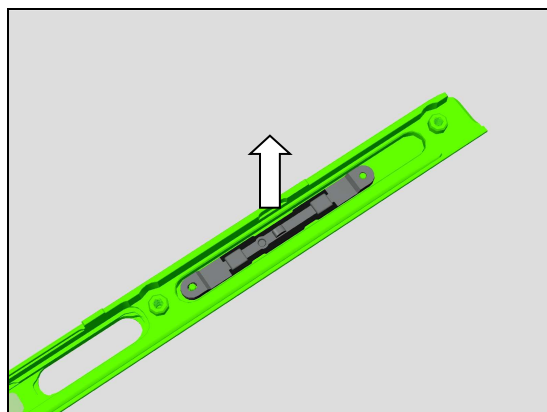
Detach the Adhesive FP Module.

**Scrap! Not to be reused!**

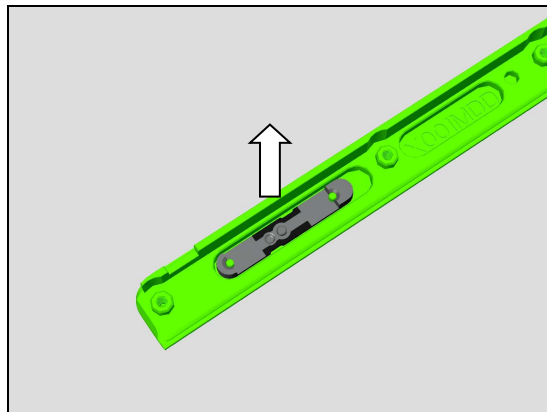


### 4.13.3 Key Volume and Key Camera

Remove the Key Volume.



Remove the Key Camera.

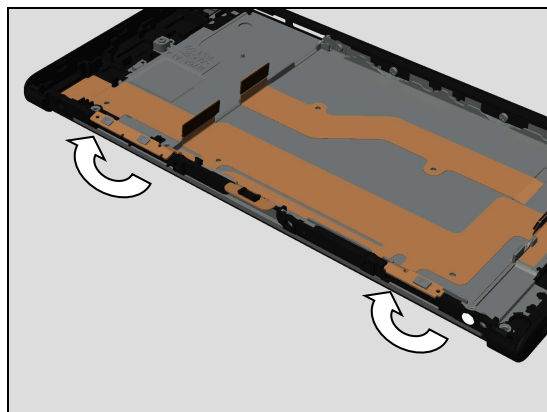


## 4.14 Sidekey FPC Assy

### 4.14.1 Sidekey FPC Assy

Detach the Volume key FPC and Camera Key FPC.

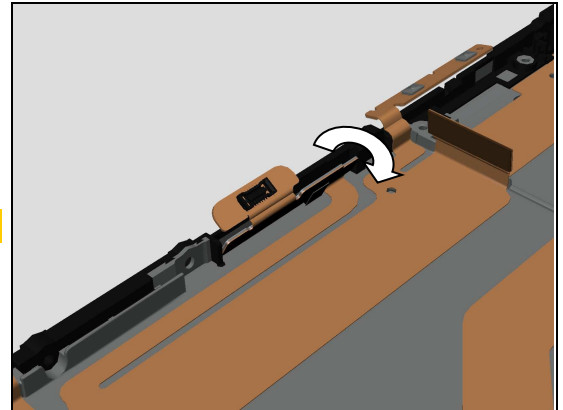
**Do not damage the FPC!**



## Disassembly

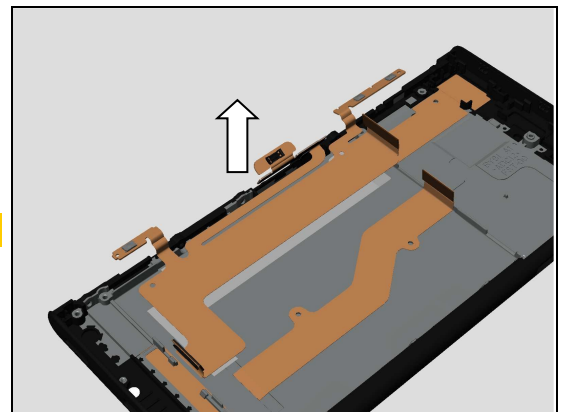
Detach the FP FPC.

**Do not damage the FPC!**



Detach the Sidekey FPC Assy.

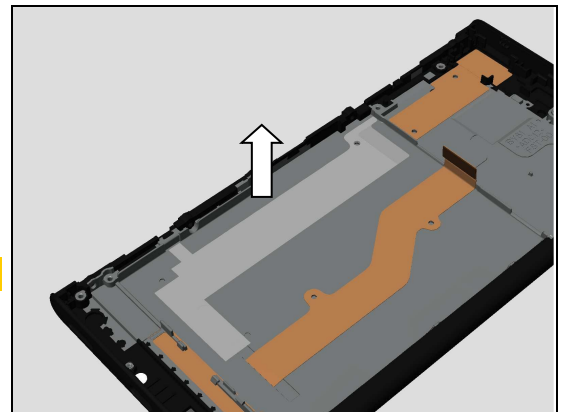
**Do not damage the Sidekey FPC Assy!**



### 4.14.2 Adhesive Sidekey FPC Main

Detach the Adhesive Sidekey FPC Main.

**Scrap! Not to be reused!**

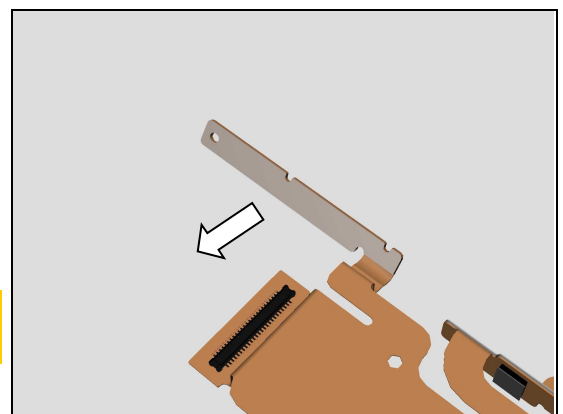


### 4.14.3 Adhesive Volume Key FPC, Adhesive Camera Key FPC and Adhesive FP FPC

Detach the Adhesive Volume Key FPC.

**Scrap! Not to be reused!**

**Do not damage FPC!**

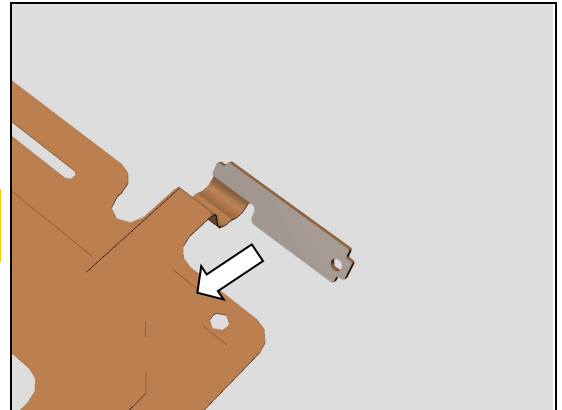


## Disassembly

Detach the Adhesive Camera Key FPC.

**Scrap! Not to be reused!**

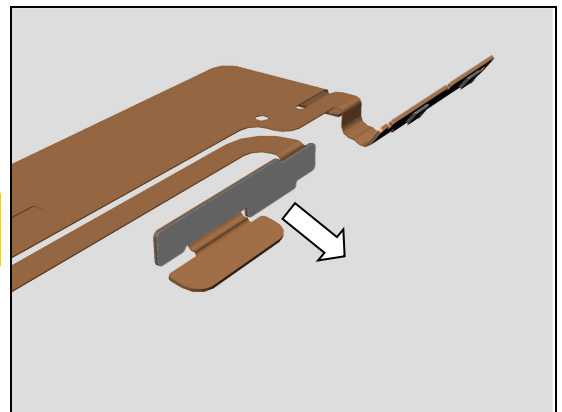
**Do not damage FPC!**



Detach the Adhesive FP FPC.

**Scrap! Not to be reused!**

**Do not damage FPC!**

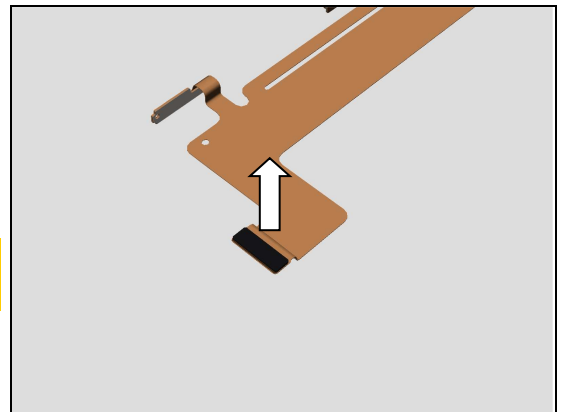


### 4.14.4Sponge BTB Sidekey FPC Assy

Detach the Sponge BTB Sidekey FPC Assy.

**Scrap! Not to be reused!**

**Do not damage FPC!**

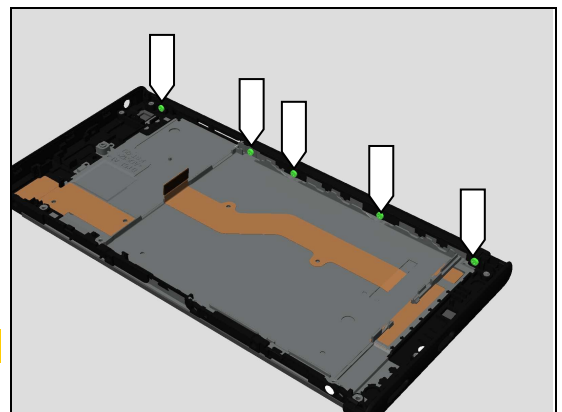


## 4.15 Side Panel SIM/SD

### 4.15.1Side Panel SIM/SD

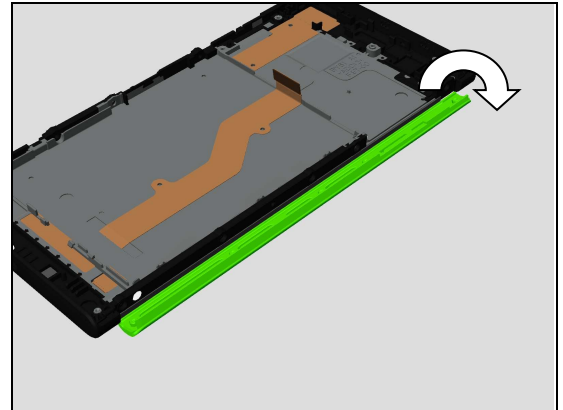
Remove the five Screw TORX M1.4 L3.25 Silver by using a T5 screwdriver.

**Scrap! Not to be reused!**

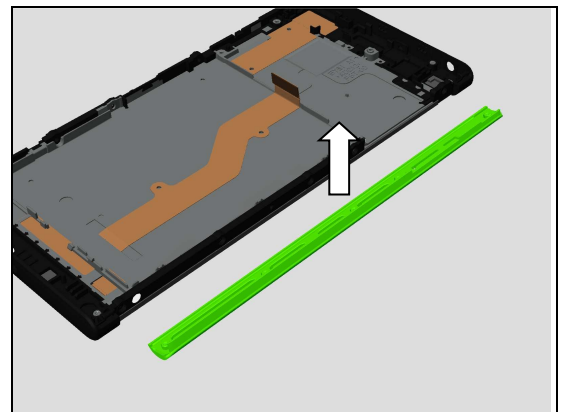


## Disassembly

Detach the Side Panel SIM/SD.



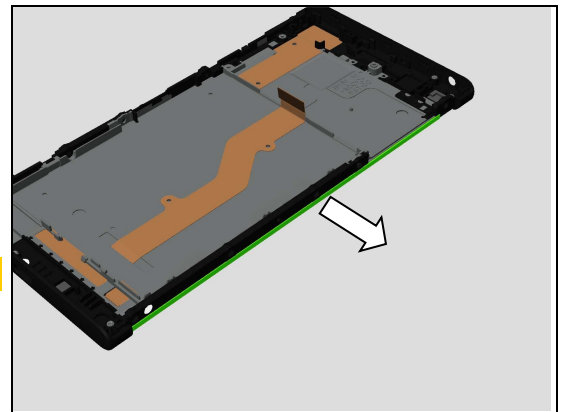
Remove the Side Panel SIM/SD.



### 4.15.2 Adhesive LCM

Detach the Adhesive LCM.

**Scrap! Not to be reused!**

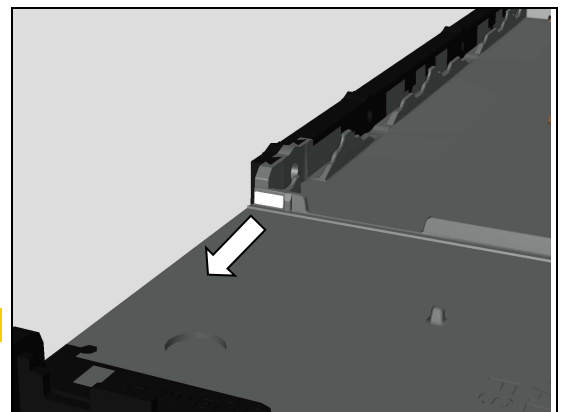


## 4.16 Display Cover Assy

### 4.16.1 Water Intrusion Label Rectangle

Detach the Water Intrusion Label Rectangle by using the plastic tweezers.

**Scrap! Not to be reused!**

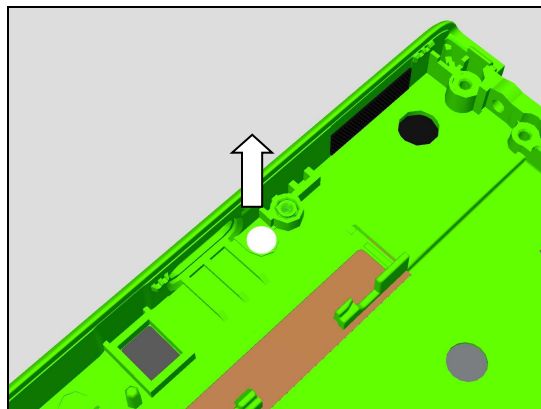


## Disassembly

### 4.16.2 Water Intrusion Label

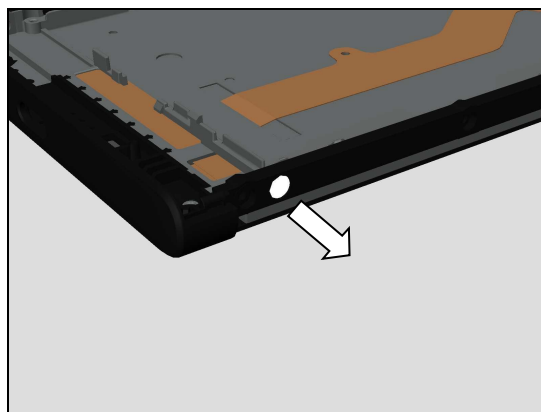
Detach the Water Intrusion Label by using the plastic tweezers.

**Scrap! Not to be reused!**



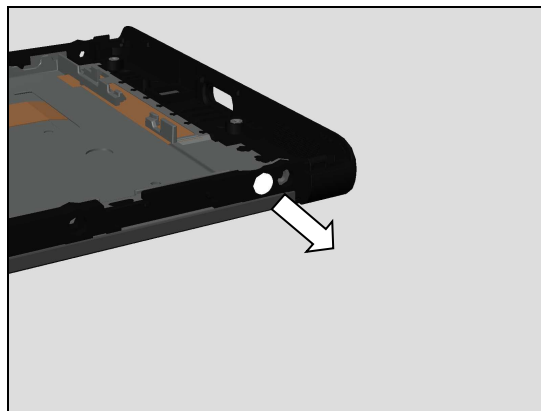
Detach the Water Intrusion Label by using the plastic tweezers.

**Scrap! Not to be reused!**



Detach the Water Intrusion Label by using the plastic tweezers.

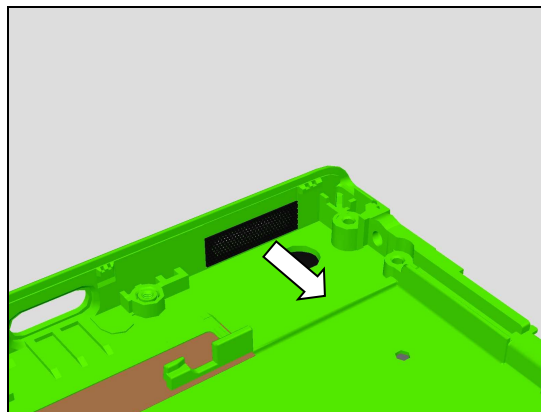
**Scrap! Not to be reused!**



### 4.16.3 Speaker Mesh

Detach the Speaker Mesh by using the plastic tweezers.

**Scrap! Not to be reused!**

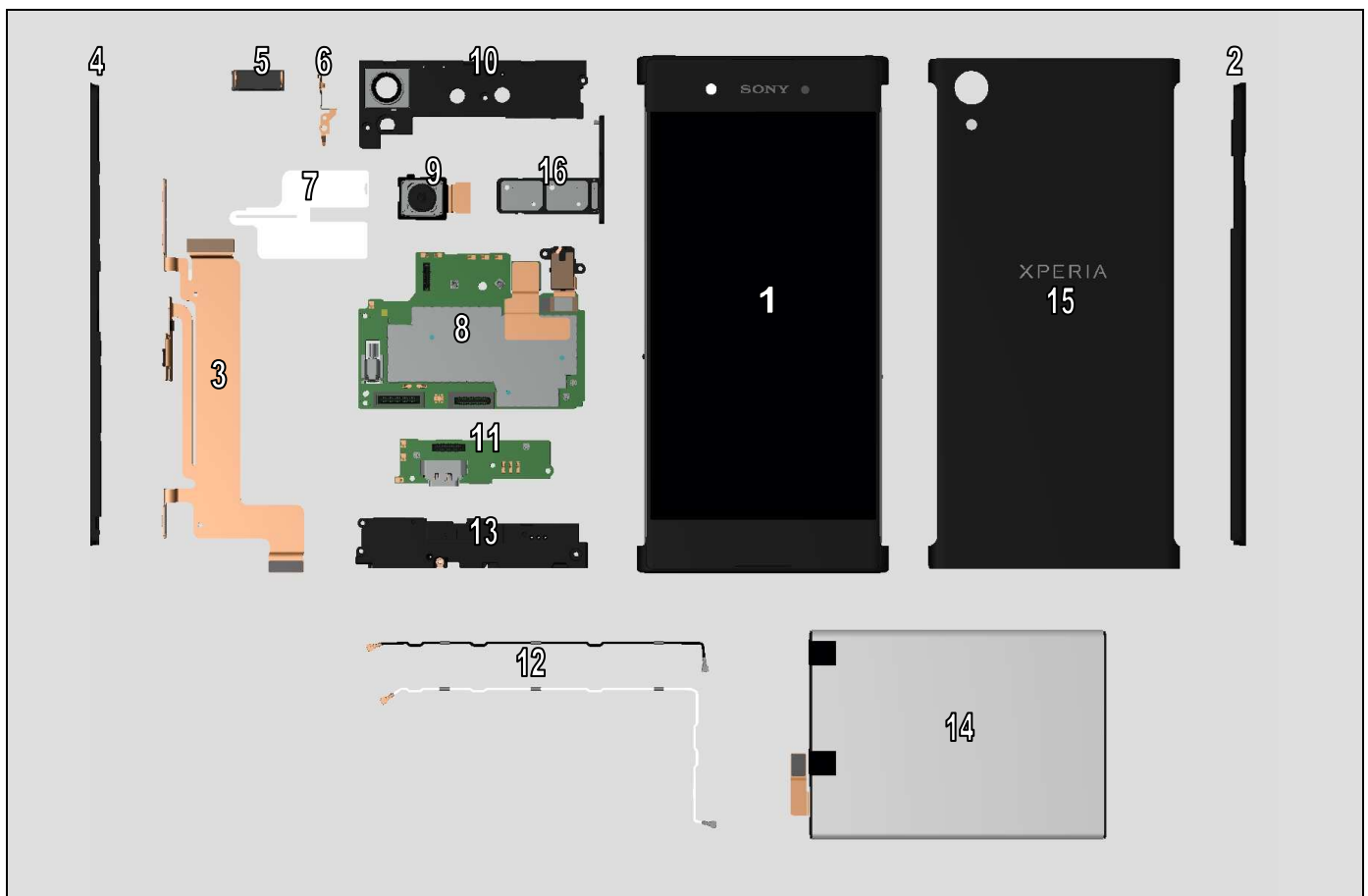




## 5 Reassembly

The G3412,G3416,G3421,G3423,G3426 reassembly is done in the following order:

1. Display Cover Assy
2. Side Panel SIM/SD
3. Sidekey FPC Assy
4. Side Panel Keys, FP Module Assy and Keys
5. Adhesive Ear Speaker and Ear Speaker
6. Bracket Main Camera
7. CU Label Tray
8. Main PBA
9. Main Camera
10. Sub Antenna
11. Sub PBA Assy
12. RF Cable
13. Main Antenna Speaker Box
14. Battery and Adhesive Battery
15. Battery Cover Assy
16. Cap Tray



## Reassembly

Reassembly Quick Reference Chart is embedded.

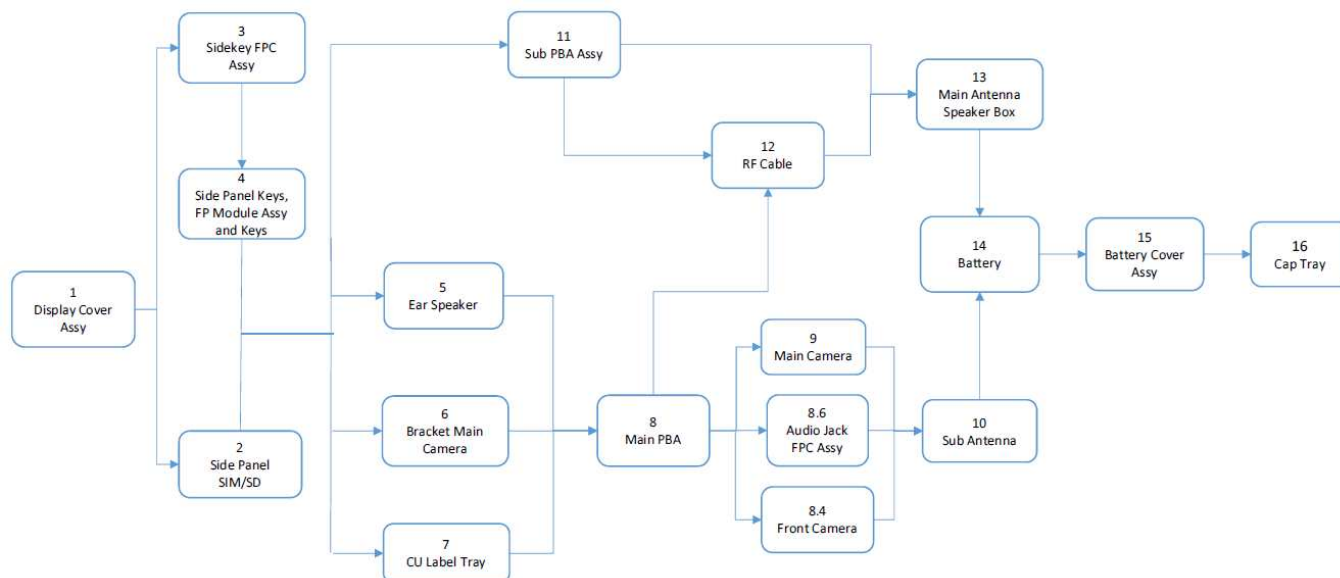


Reassembly  
Procedure.pdf



Required reassembly procedures of specific part replacement can be identified by Reassembly Quick Reference Chart.

The sequence numbers of the target parts in the chart correspond to the reassembly chapter numbers. Please refer to corresponding chapter content for the parts not mentioned in this chart.



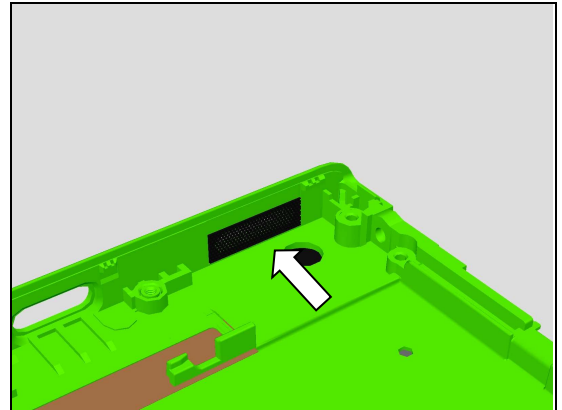
Replacement Target		Assembly Procedure
1	Display Cover Assy	1, 2, 3, 4, 5, 6, 7, 8, 8.4, 8.6, 9, 10, 11, 12, 13, 14, 15, 16
2	Side Panel SIM/SD	2, 5, 6, 7, 8, 8.4, 8.6, 9, 10, 11, 12, 13, 14, 15, 16
3	Sidekey FPC Assy	3, 4, 5, 6, 7, 8, 8.4, 8.6, 9, 10, 11, 12, 13, 14, 15, 16
4	Side Panel Keys, FP Module Assy and Keys	4, 5, 6, 7, 8, 8.4, 8.6, 9, 10, 11, 12, 13, 14, 15, 16
5	Ear Speaker	5, 8, 8.4, 8.6, 9, 10, 15, 16
6	Bracket Main Camera	6, 8, 8.4, 8.6, 9, 10, 15, 16
7	CU Label Tray	7, 8, 8.4, 8.6, 9, 10, 15, 16
8	Main PBA	8, 8.4, 8.6, 9, 10, 15, 16
8.4	Front Camera	8.4, 10, 15, 16
8.6	Audio Jack FPC Assy	8.6, 10, 15, 16
9	Main Camera	9, 10, 15, 16
10	Sub Antenna	10, 15, 16
11	Sub PBA Assy	11, 13, 15, 16
12	RF Cable	12, 13, 15, 16
13	Main Antenna Speaker Box	13, 15, 16
14	Battery	14, 15, 16
15	Battery Cover Assy	15, 16
16	Cap Tray	16

## Reassembly

### 5.1 Display Cover Assy

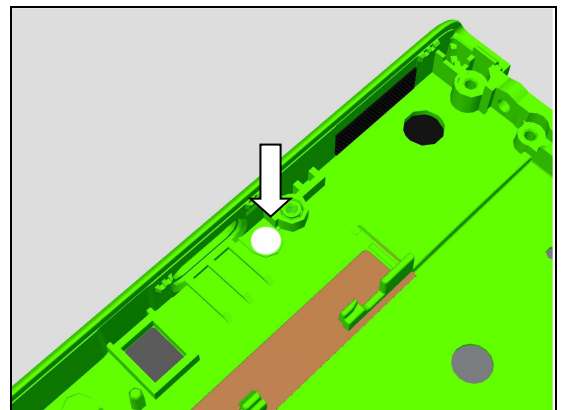
#### 5.1.1 Speaker Mesh

Attach a new Speaker Mesh onto its proper position as shown in picture.

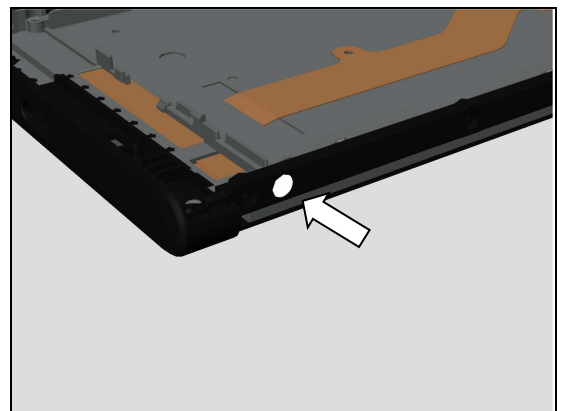


#### 5.1.2 Water Intrusion Label

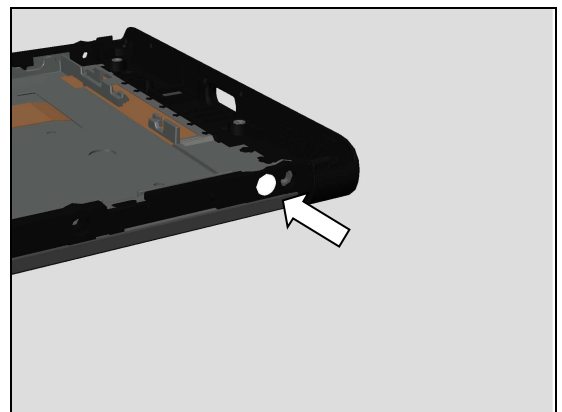
Attach a new Water Intrusion Label onto its proper position as shown in picture.



Attach a new Water Intrusion Label onto its proper position as shown in picture.



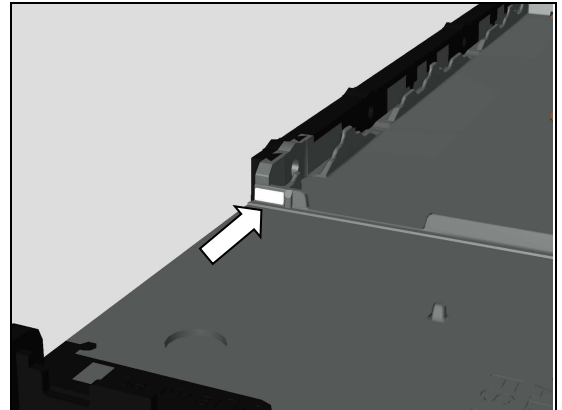
Attach a new Water Intrusion Label onto its proper position as shown in picture.



## Reassembly

### 5.1.3 Water Intrusion Label Rectangle

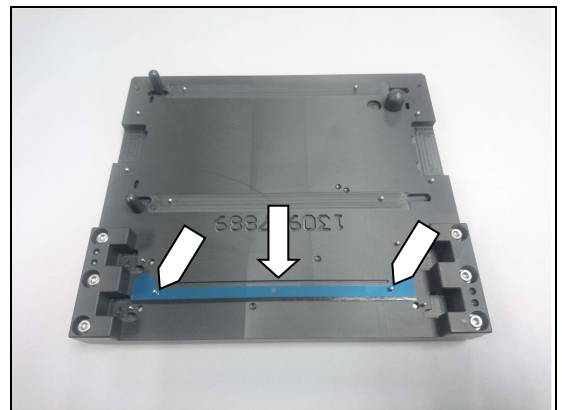
Attach a new Water Intrusion Label Rectangle onto its proper position as shown in picture.



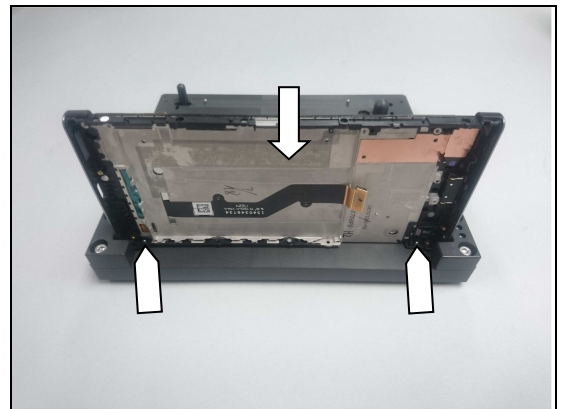
## 5.2 Side Panel SIM/SD

### 5.2.1 Adhesive LCM

Mount the Adhesive LCM onto its proper position of the Panels Adhesive Fixture as shown in picture.

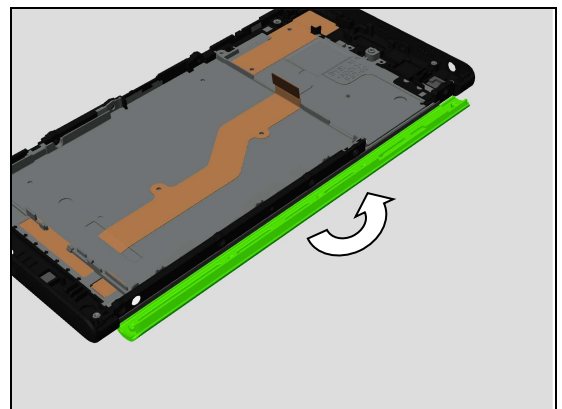


Press to attach the Adhesive LCM onto this side of Display Cover Assy as shown in picture.



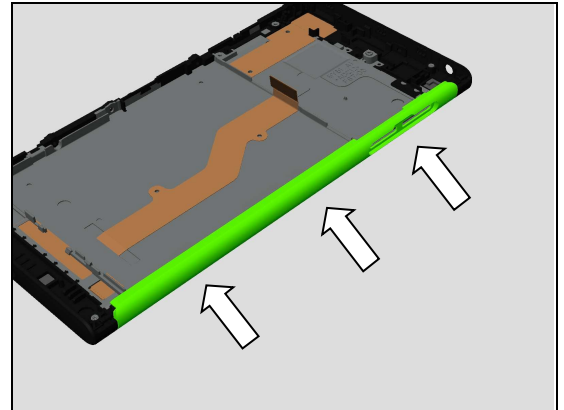
### 5.2.2 Side Panel SIM/SD

Mount the Side Panel SIM/SD as shown in picture.

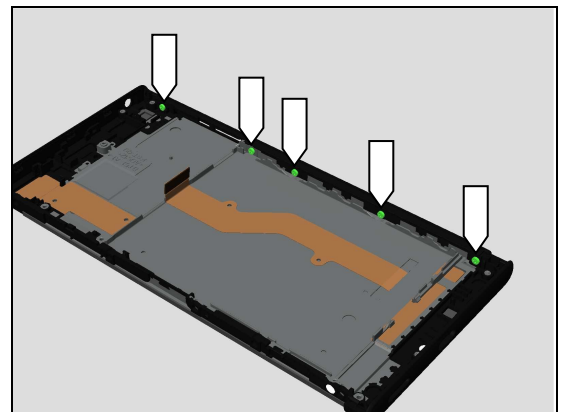


## Reassembly

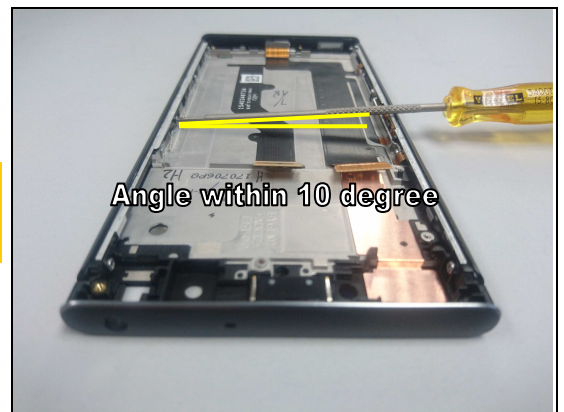
Then press the Side Panel SIM/SD after mounting.



Tighten the five Screw TORX M1.4 L3.25 Silver with T5 Screwdriver.



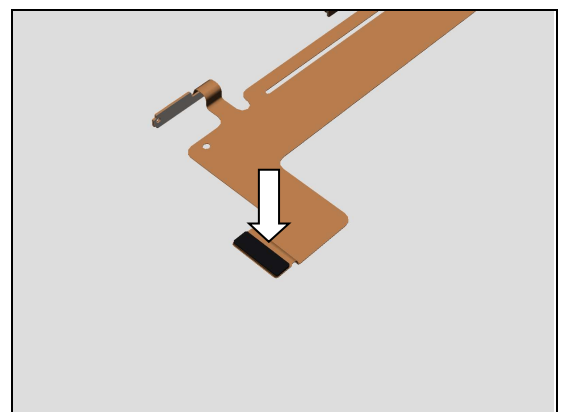
**Make sure to secure the angle between Screwdriver bit and front cover within 10 degree when tightening the screws.**



### 5.3 Sidekey FPC Assy

#### 5.3.1 Sponge BTB Sidekey FPC Assy

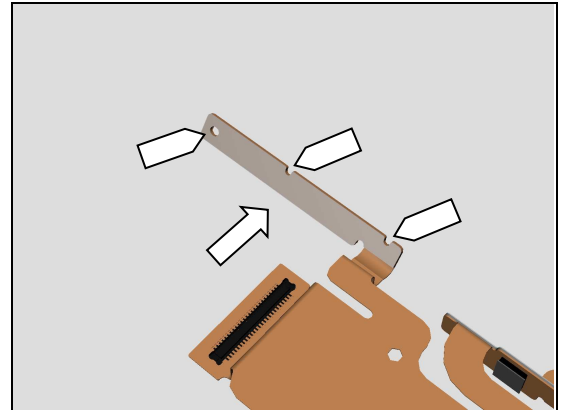
Attach a new Sponge BTB Sidekey FPC Assy onto its proper position as shown in picture.



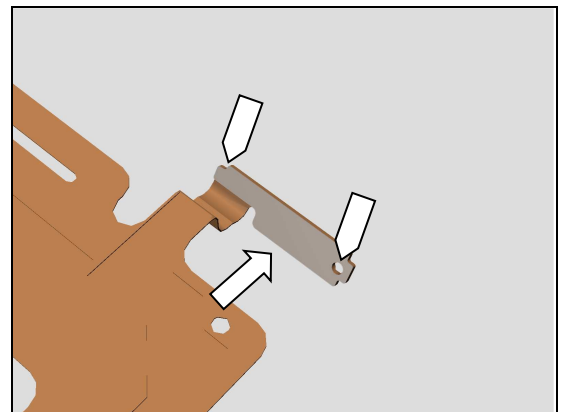
## Reassembly

### 5.3.2 Adhesive Volume Key FPC, Adhesive Camera Key FPC and Adhesive FP FPC

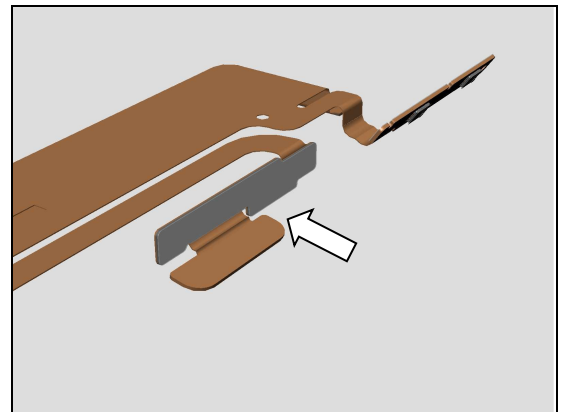
Attach a new Adhesive Volume Key FPC onto its proper position as shown in picture.



Attach a new Adhesive Camera Key FPC onto its proper position as shown in picture.

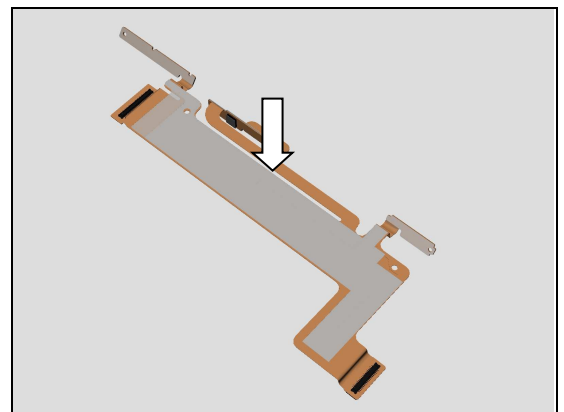


Attach a new Adhesive FP FPC onto its proper position as shown in picture.



### 5.3.3 Adhesive Sidekey FPC Main

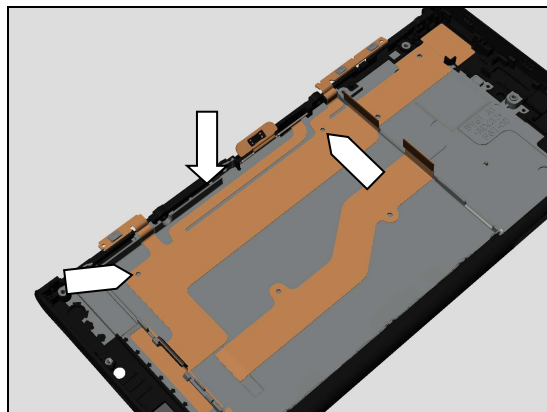
Attach a new Adhesive Side Key FPC Main in alignment with guiding lines on the FPC.



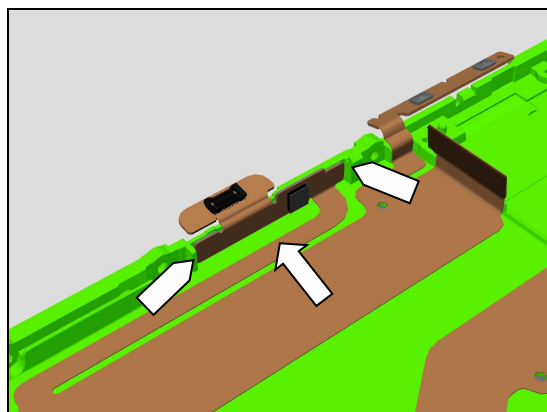
## Reassembly

### 5.3.4 Sidekey FPC Assy

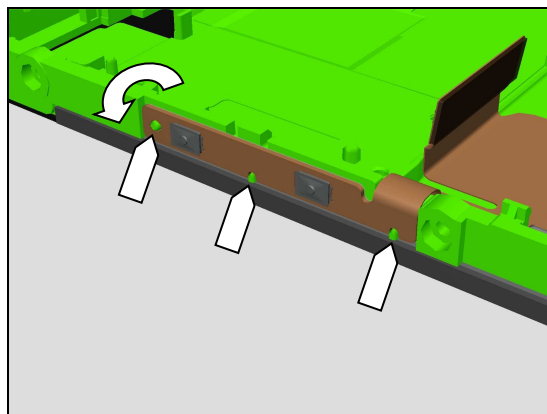
Attach the Sidekey FPC Assy onto its proper position as shown in picture.



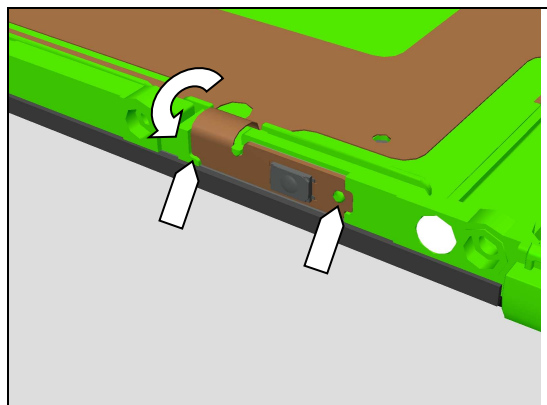
Attach the FP FPC onto its proper position as shown in picture.



Attach the Volume Key FPC onto its proper position as shown in picture.



Attach the Camera Key FPC onto its proper position as shown in picture.



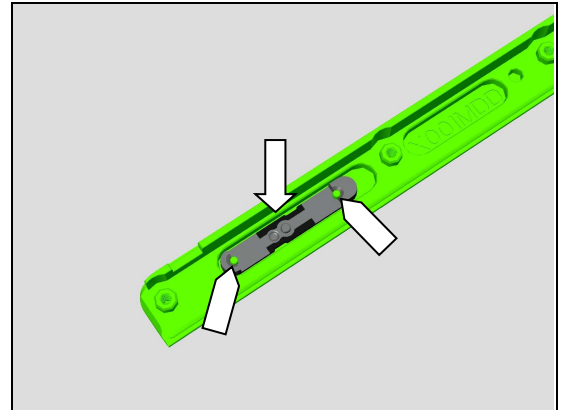


## Reassembly

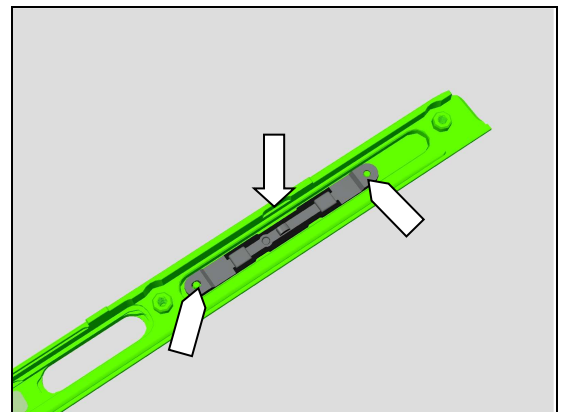
### 5.4 Side Panel Keys, FP Module Assy and Keys

#### 5.4.1 Key Camera and Key Volume

Mount the Key Camera onto its proper position as shown in picture.

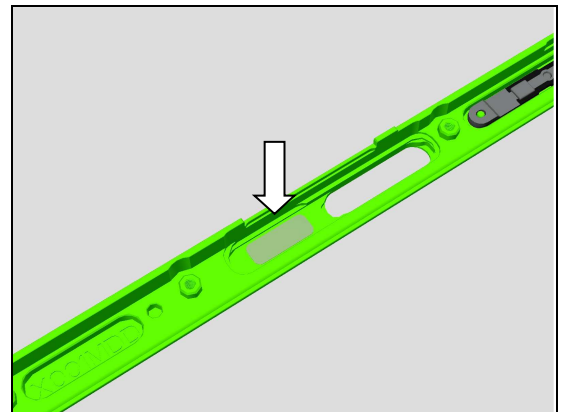


Mount the Key Volume onto its proper position as shown in picture.

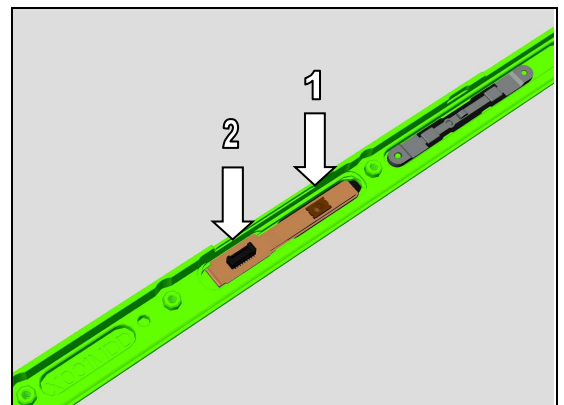


#### 5.4.2 Adhesive FP Module, FP Module Assy, Adhesive BtB FP Module and Holder FP Module

Attach a new Adhesive FP Module in alignment with guiding line on the Side Panel Keys as shown in picture.



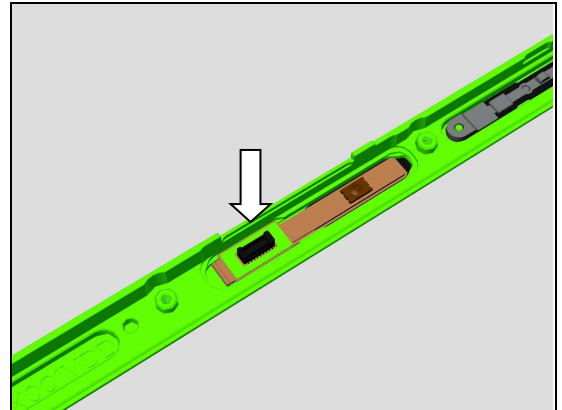
Mount the FP Module Assy into its hole, then press BtB connector to attach it onto the Side Panel Keys.



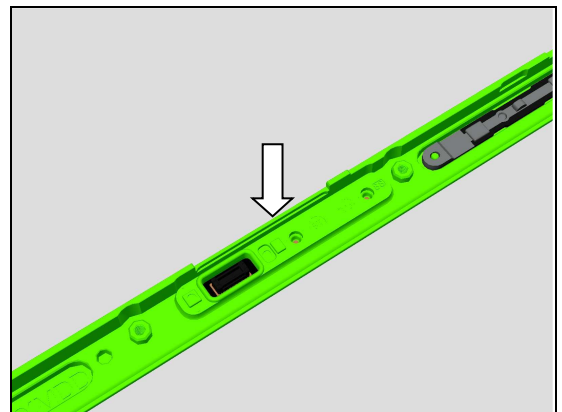


## Reassembly

Attach a new Adhesive BtB FP Module onto its proper position as shown in picture.

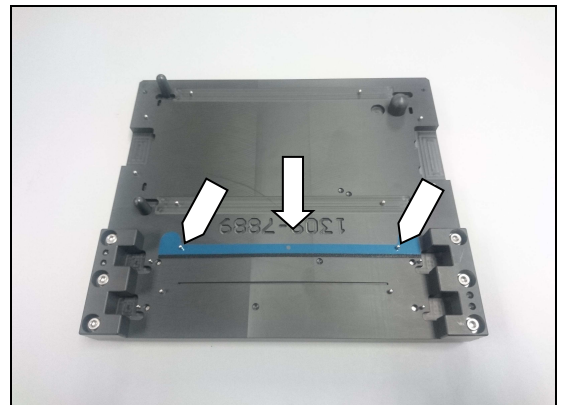


Mount the Holder FP Module into its cavity and press to attach it.

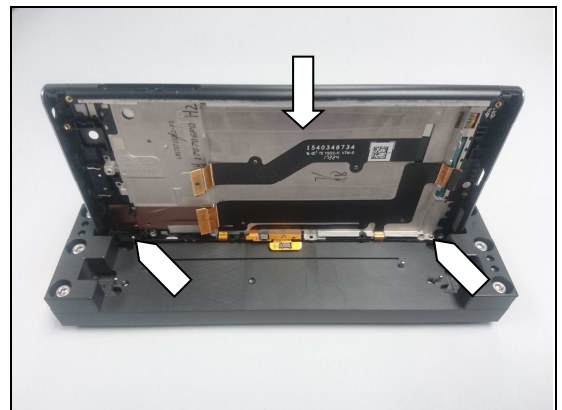


### 5.4.3 Adhesive LCM, Side Panel Keys and Bracket FP Module

Mount the Adhesive LCM onto its proper position of the Panels Adhesive Fixture as shown in picture.

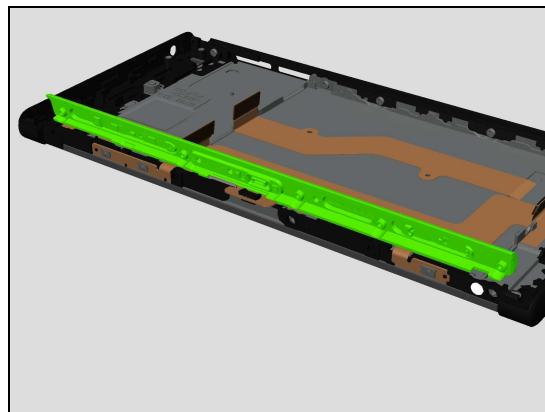


Press to attach the Adhesive LCM onto this side of the Display Cover Assy as shown in picture.

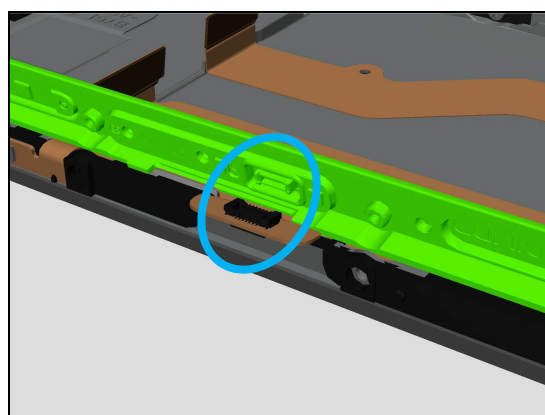


## Reassembly

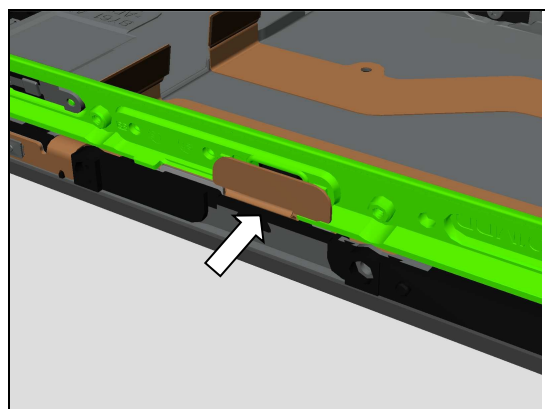
Prepare the Side Panel Keys before assembly as shown in picture.



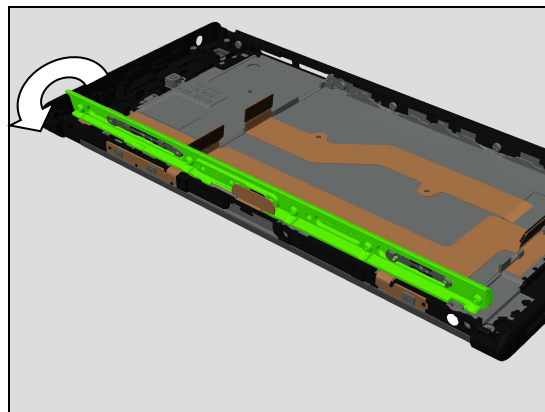
Align the BtB connectors as shown in picture.



Press to snap the BtB connector of the FP Module Assy.

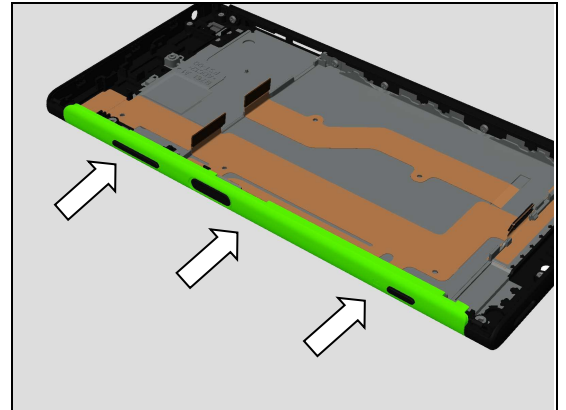


Mount the Side Panel Keys as shown in picture.

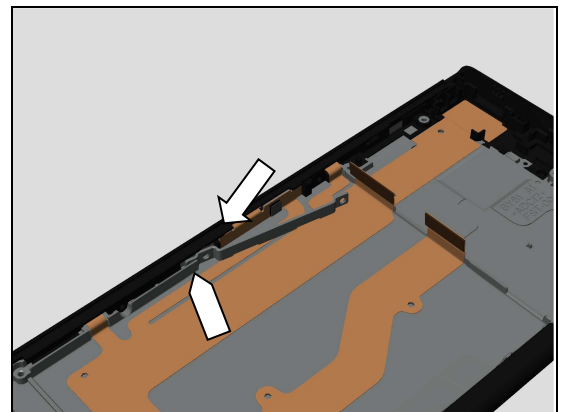


## Reassembly

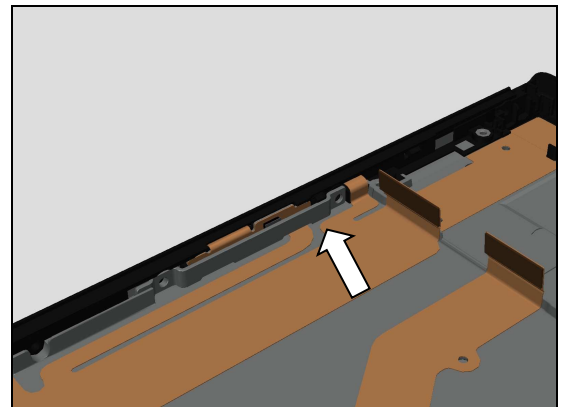
Then press the Side Panel Keys after mounting.



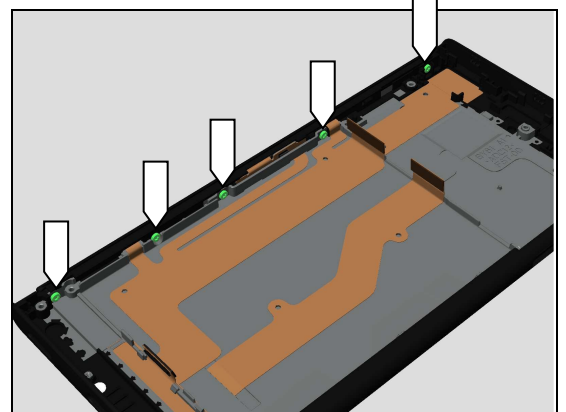
Mount this side of the Bracket FP Module as shown in picture.



Mount the other side of the Bracket FP Module.

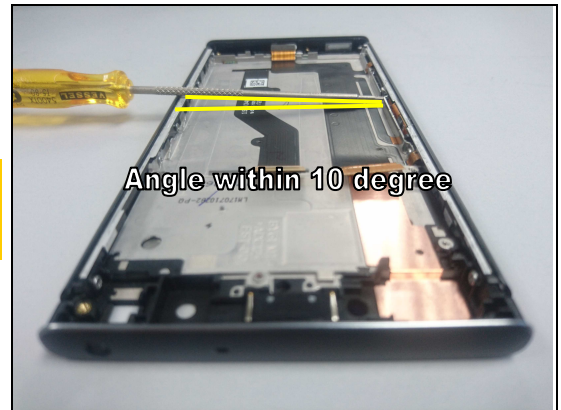


Tighten the five Screw TORX M1.4 L3.25 Silver with T5 Screwdriver.



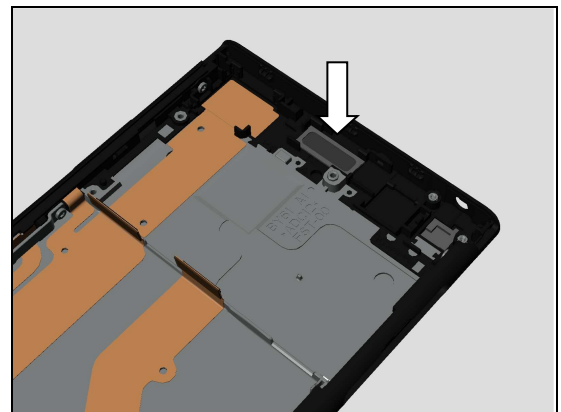
## Reassembly

**Make sure to secure the angle between Screwdriver bit and front cover within 10 degree when tightening the screws.**



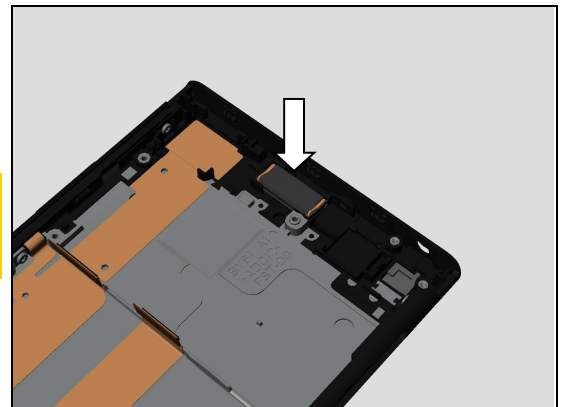
### 5.5 Adhesive Ear Speaker and Ear Speaker

Attach a new Adhesive Ear Speaker into its cavity as shown in picture.



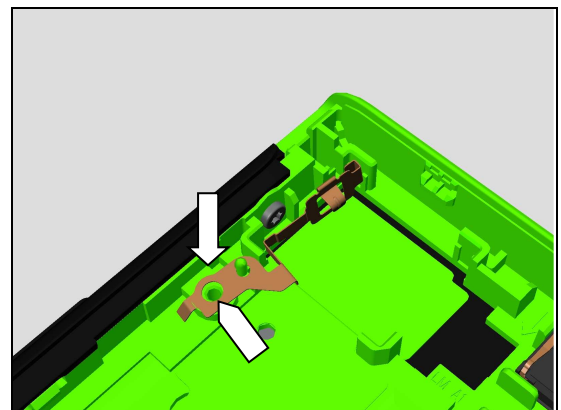
Mount a new Ear Speaker in its cavity and press it.

**Note the correct orientation of the Ear Speaker contact springs to be installed as shown in picture!**  
**Be careful! Do not press contact springs when pressing.**



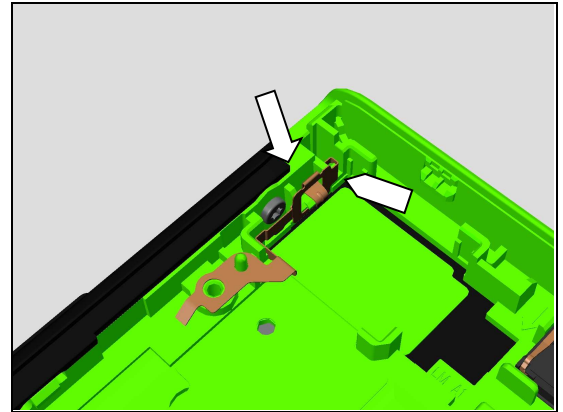
### 5.6 Bracket Main Camera

Mount this side of the Bracket Main Camera in its proper position by using plastic tweezers as shown in picture.



## Reassembly

Then mount the other side of the Bracket Main Camera by using plastic tweezers as shown in picture.

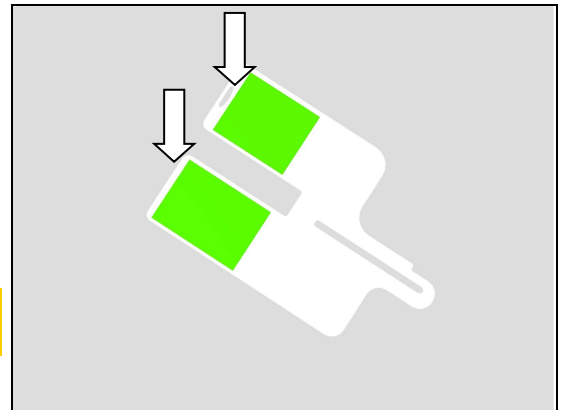


### 5.7 CU Label Tray

#### 5.7.1 CU Label

Attach a new CU Label onto its proper position as shown in picture.

**Note! New CU Label have to be replaced only when board swap.**

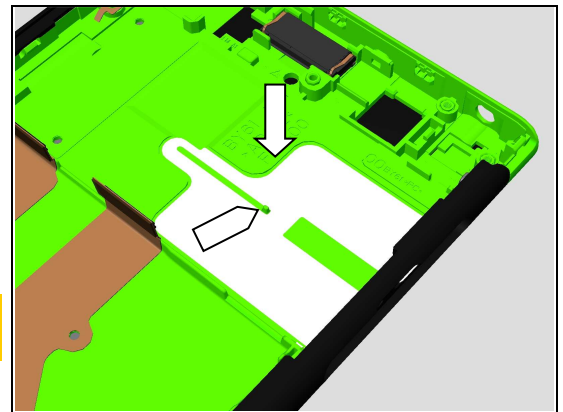


#### 5.7.2 CU Label Tray

Mount the position pin into the slot of the CU Label Tray as shown in picture.

Mount the CU Label Tray onto its proper position as shown in picture.

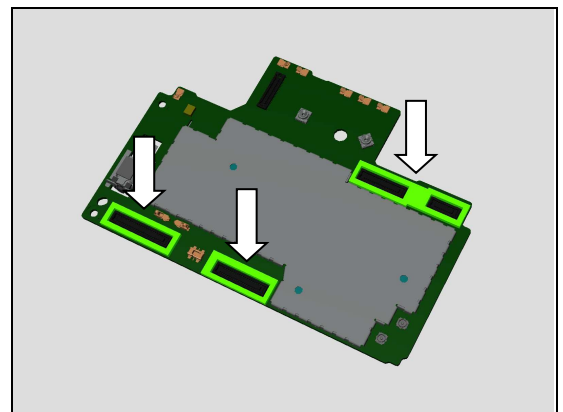
**Note the correct position of the position pin in the CU Label Tray slot!**



### 5.8 Main PBA

#### 5.8.1 Adhesive Rubber BTB Front Cam&AJ, Adhesive Rubber BTB LCM and Adhesive Rubber BTB Sidekey FPC

Attach new Adhesive Rubber BTB onto its proper position as shown in picture.

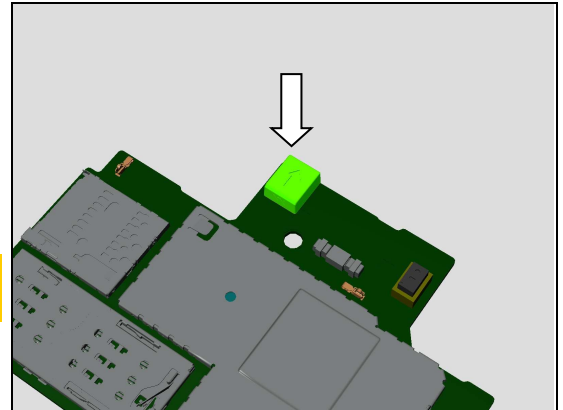


## Reassembly

### 5.8.2 Rubber 2nd MIC

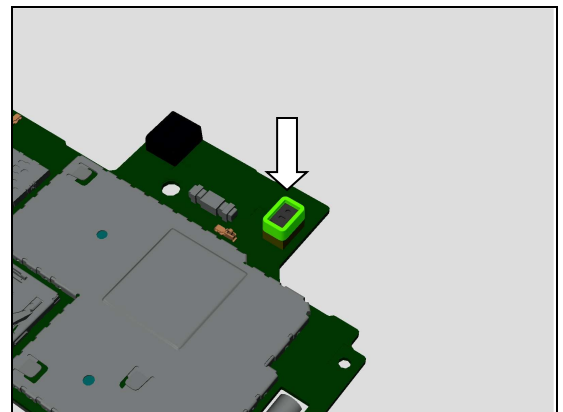
Attach a new Rubber 2nd MIC onto its proper position as shown in picture.

**Note the correct orientation of the Rubber 2nd MIC to be installed as shown in picture!**



### 5.8.3 Rubber PL Sensor

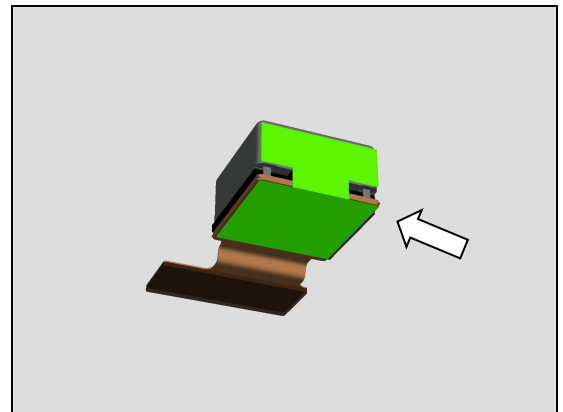
Mount the Rubber PL Sensor as shown in picture.



### 5.8.4 Front Camera

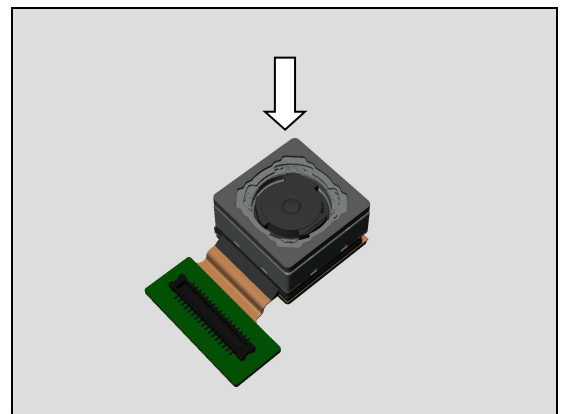
#### 5.8.4.1 Conductive Tape Front Camera

Attach a new Conductive Tape Front Camera as shown in picture.



#### 5.8.4.2 Sponge Front Camera

Attach a new Sponge Front Camera onto its proper position as shown in picture.

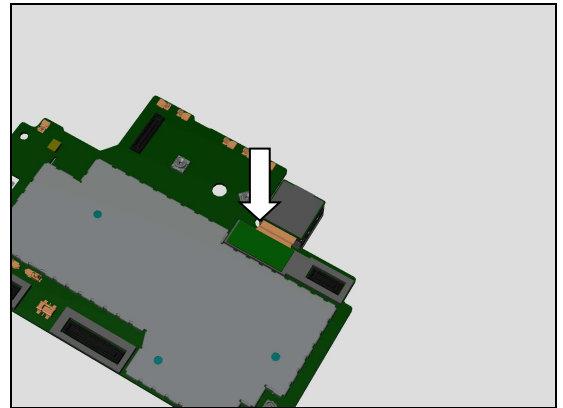




## Reassembly

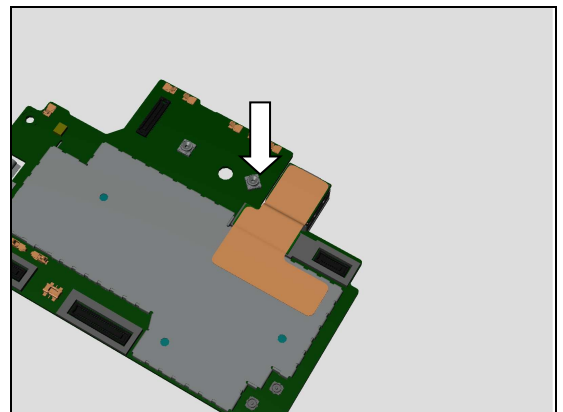
### 5.8.4.3 Front Camera

Press to snap the Front Camera connector.



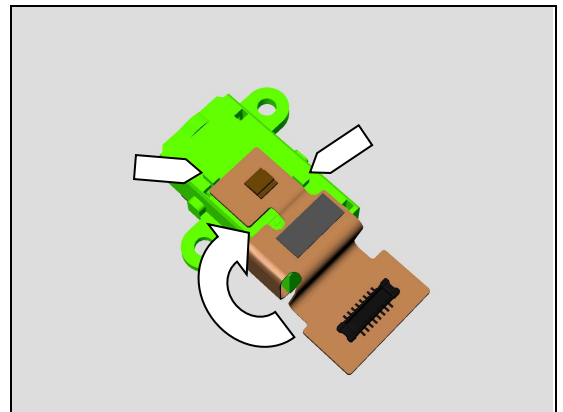
### 5.8.5 Copper Foil Front Camera

Attach a new Copper Foil Front Camera in alignment with guiding lines on the shielding can lid and Front Camera shape.

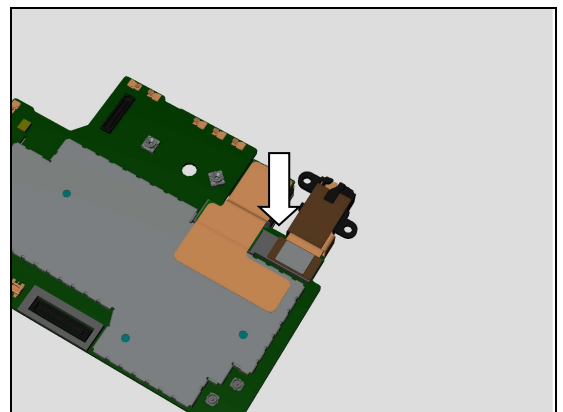


### 5.8.6 Audio Jack FPC Assy

In case replace a new Audio Jack FPC Assy, firstly fold and attach the FPC onto its proper position as shown in picture.



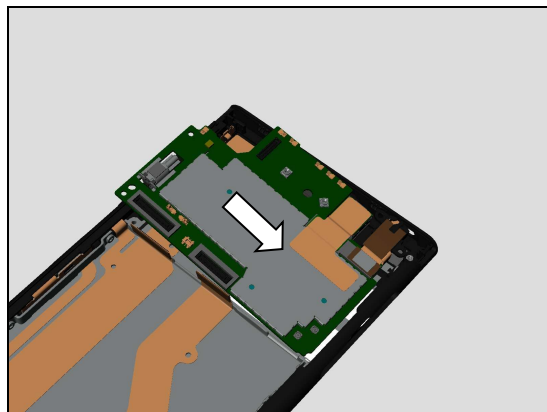
Press to snap the Audio Jack FPC Assy connector.



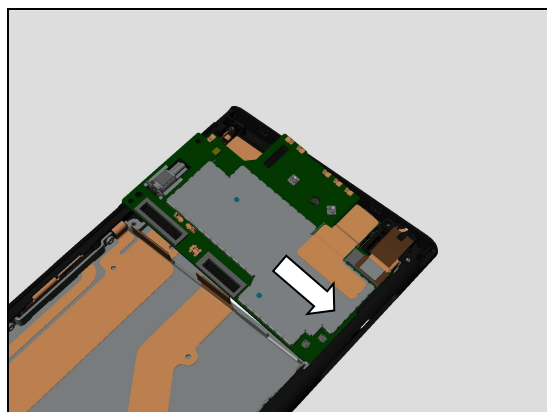
## Reassembly

### 5.8.7 Main PBA

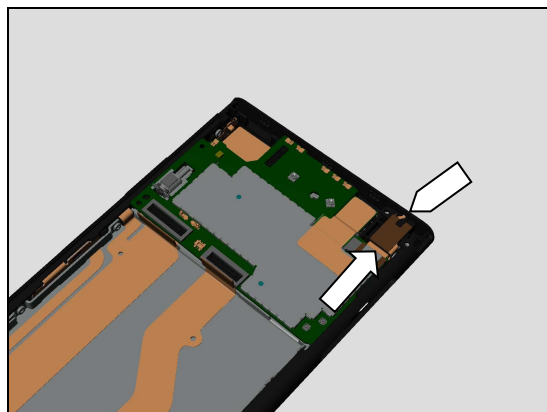
Align the Main PBA with SIM/SD hole as shown in picture.



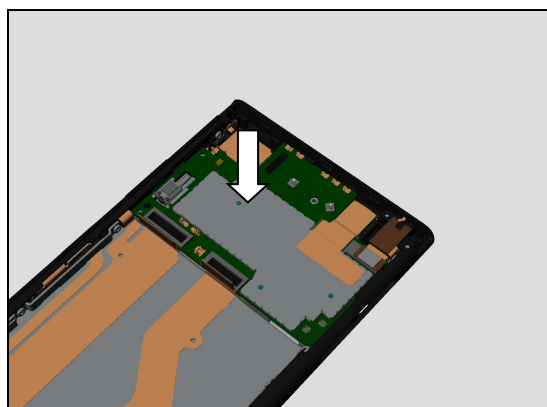
Insert to mount the Main PBA into the SIM/SD hole as shown in picture.



Insert to mount the Audio Jack FPC Assy into its hole as shown in picture.



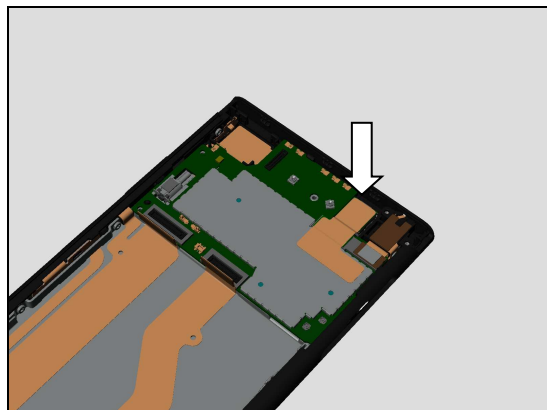
Press to snap the Main PBA.



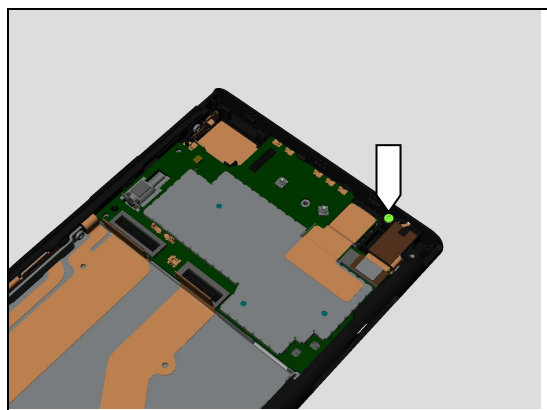


## Reassembly

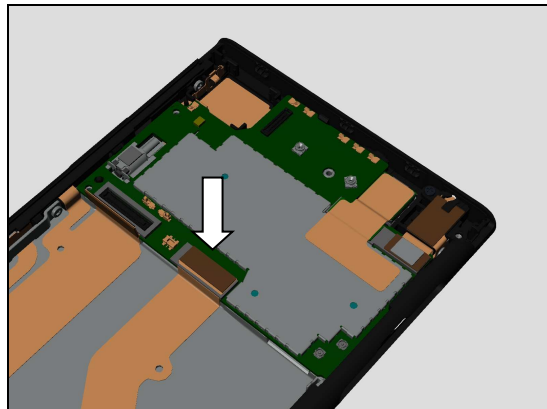
Press to secure the Front Camera into its cavity.



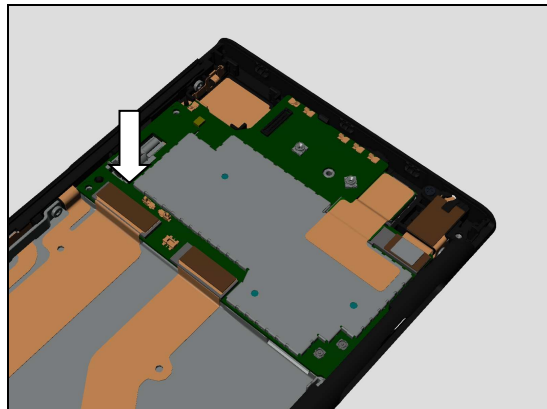
Apply 8Ncm torque when tightening the Screw CROSS M1.2 L2.67 Black with Bits JCIS No.0.



Press to snap the BtB connector of Display.



Press to snap the BtB connector of the Sidekey FPC Assy.

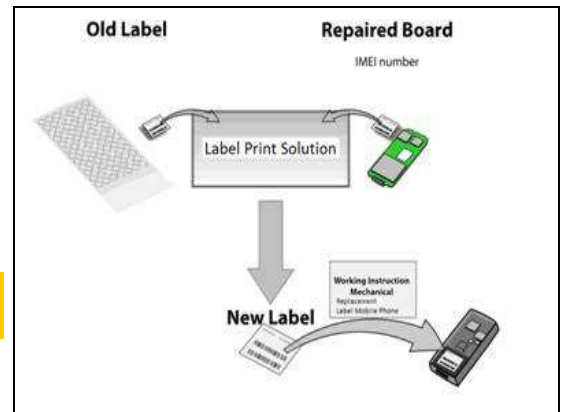


## Reassembly

### BOARD SWAP – CHANGE LABEL

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

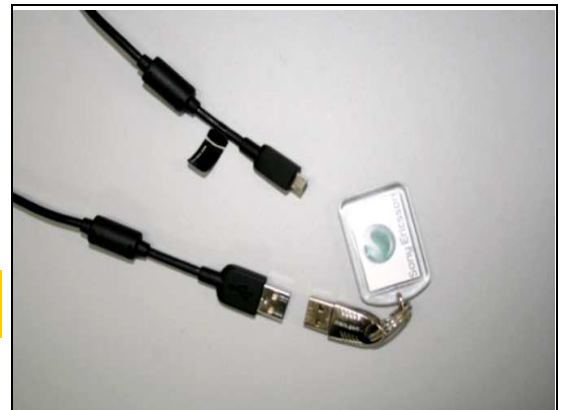
**Note! CU Label have to be replaced only when board swap.**



### Board Swap – Customize of Software

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

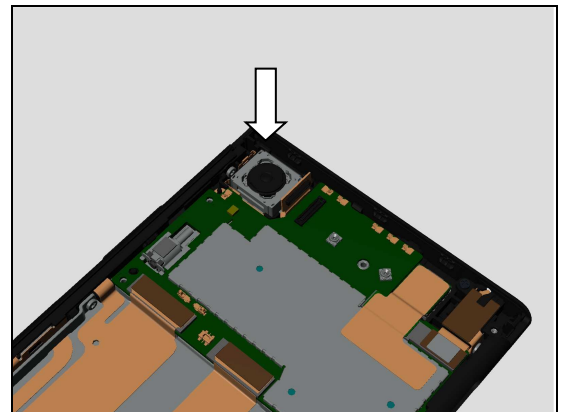
**Note! Customize of Software have to be performed only when board swap.**



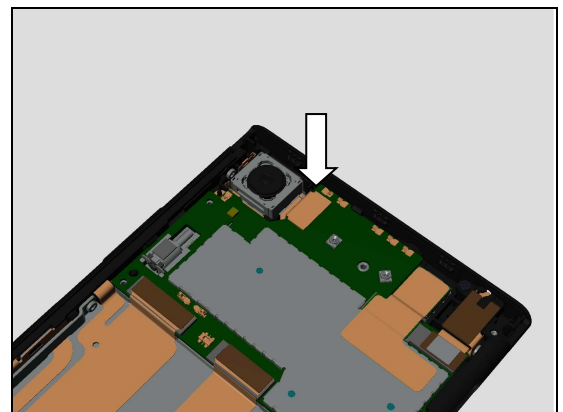
## 5.9 Main Camera

### 5.9.1 Main Camera

Mount the Main Camera into its cavity.



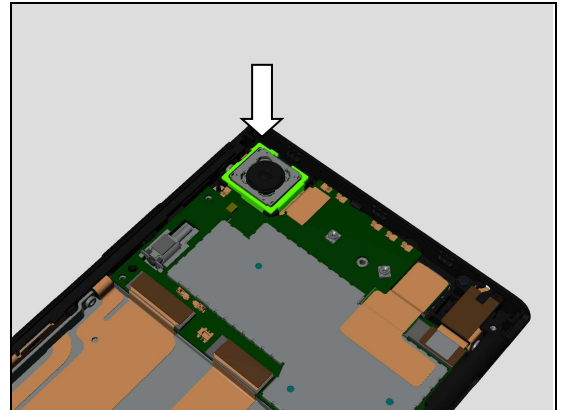
Press to snap the BtB connector of the Main Camera.



## Reassembly

### 5.9.2 Rubber Main Camera

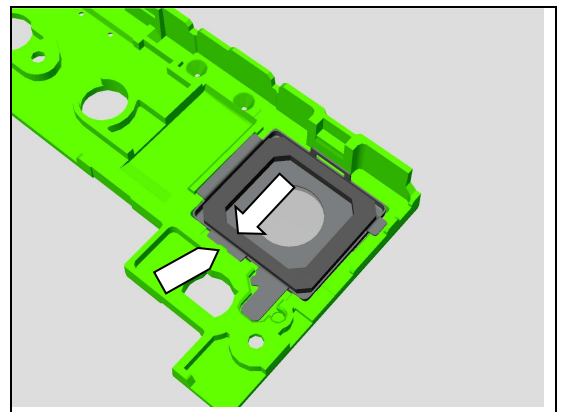
Mount the Rubber Main Camera onto its proper position as shown in picture.



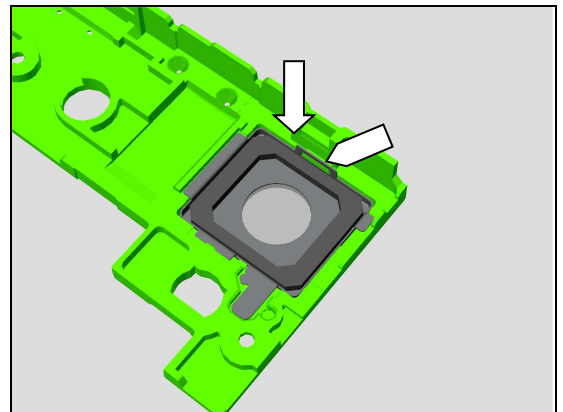
### 5.10 Sub Antenna

#### 5.10.1 Main Camera Lens Assy

Insert to mount the Main Camera Lens Assy under this small rib as shown in picture.

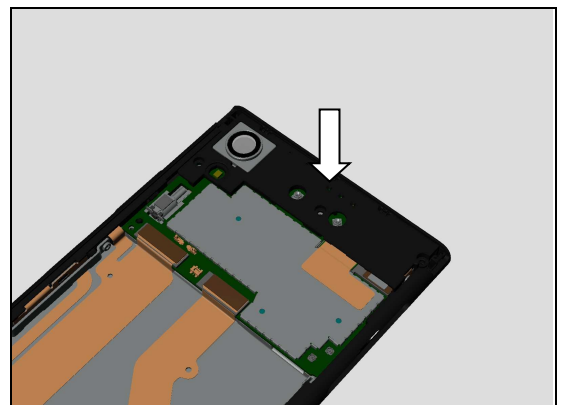


Press to snap the Main Camera Lens Assy onto the Sub Antenna as shown in picture.



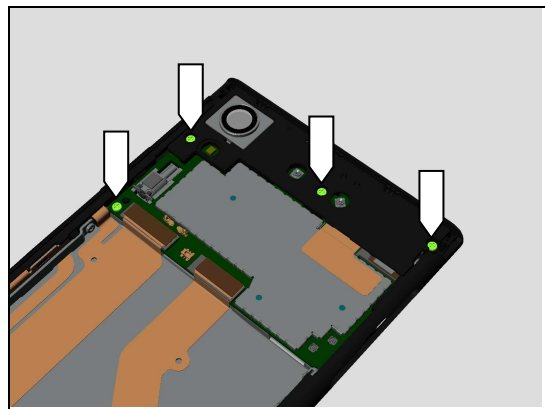
#### 5.10.2 Sub Antenna

Mount the Sub Antenna into its proper position as shown in picture and press to snap it.



## Reassembly

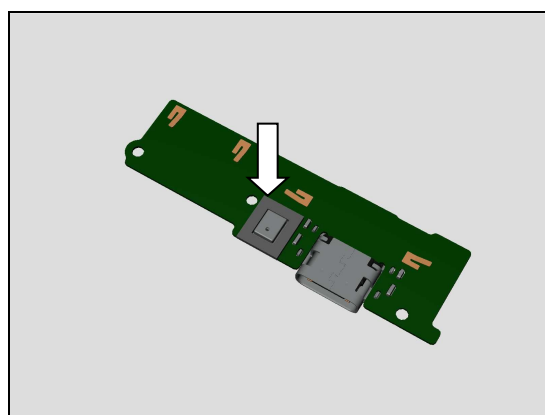
Apply 8Ncm torque when tightening the four Screw CROSS M1.2 L2.67 Black with Bits JCIS No.0.



### 5.11 Sub PBA Assy

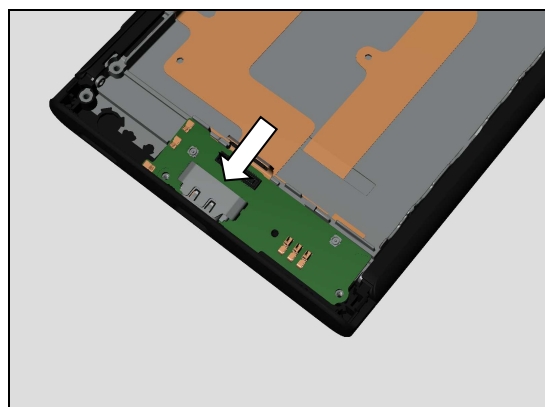
#### 5.11.1Sponge 1st Mic

Attach a new Sponge 1st Mic in its proper position as shown in picture.

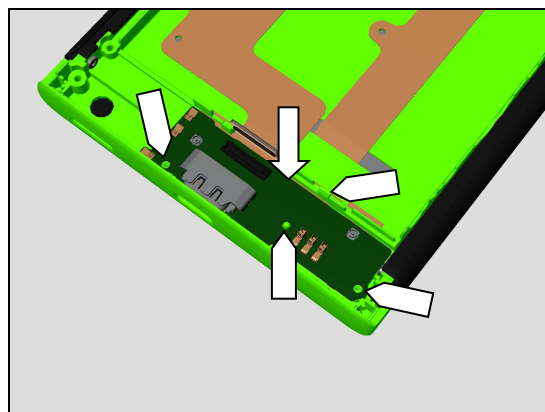


#### 5.11.2Sub PBA Assy

Insert to mount the Sub PBA Assy into USB hole as shown in picture.

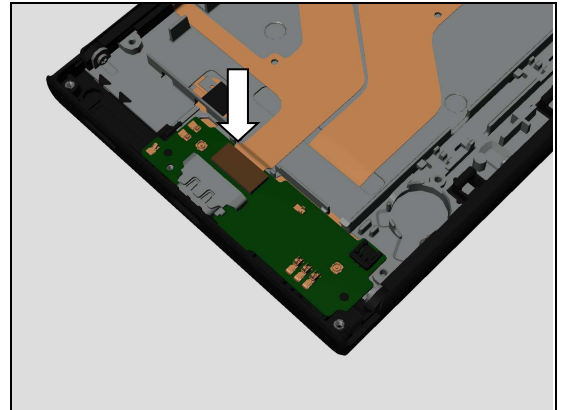


Press to snap the Sub PBA Assy into its proper position as shown in picture.



## Reassembly

Press to snap the BtB connector of the Sidekey FPC Assy.

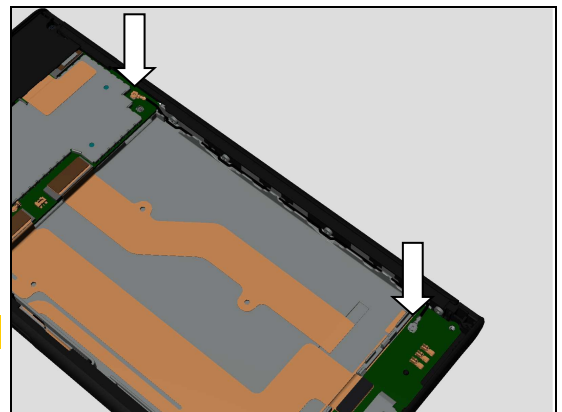


### 5.12 RF Cable

#### 5.12.1 RF Cable Black and RF Cable White (G3421,G3423,G3426)

Press to snap the RF Cable Black connectors.

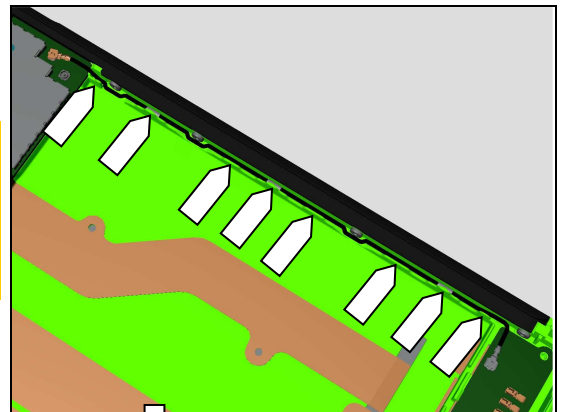
***This is only for G3421,G3423,G3426!***



***This is only for G3421,G3423,G3426!***

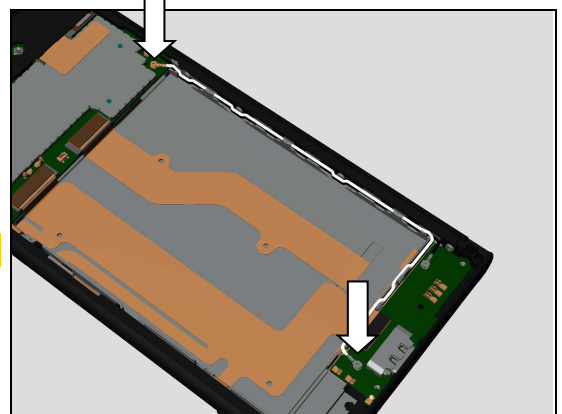
***Make sure the RF Cable Black is mounted into its cavity as shown in picture.***

***Make sure the three metal rings contact to the front cover.***



Press to snap the RF Cable White connectors.

***This is only for G3421,G3423,G3426!***

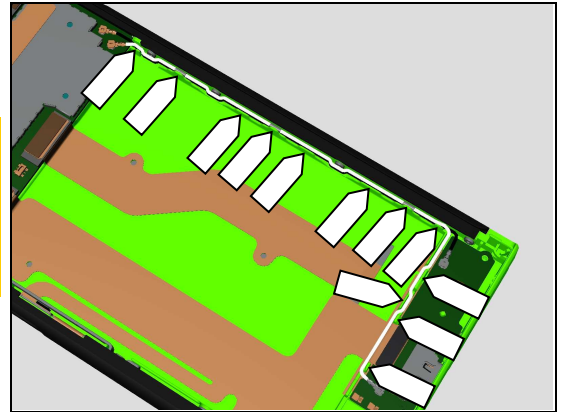


## Reassembly

***This is only for G3221,G3223,G3226!***

***Make sure the RF Cable White is mounted into its cavity as shown in picture.***

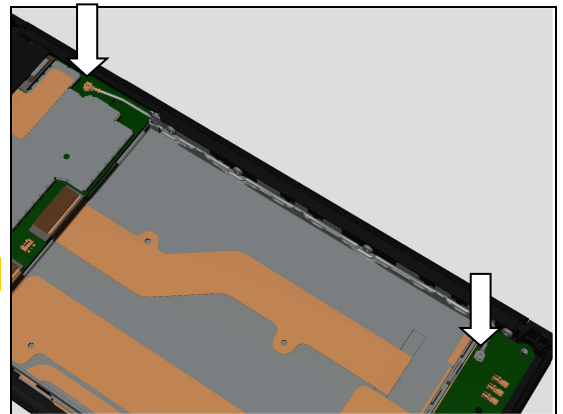
***Make sure the three metal rings contact to the front cover.***



### 5.12.2 RF Cable Grey (G3412, G3416)

Press to snap the RF Cable Grey connectors.

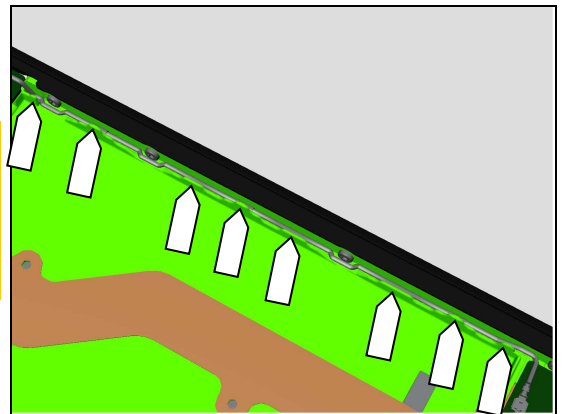
***This is only for G3412, G3416!***



***This is only for G3412, G3416!***

***Make sure the RF Cable Grey is mounted into its cavity as shown in picture.***

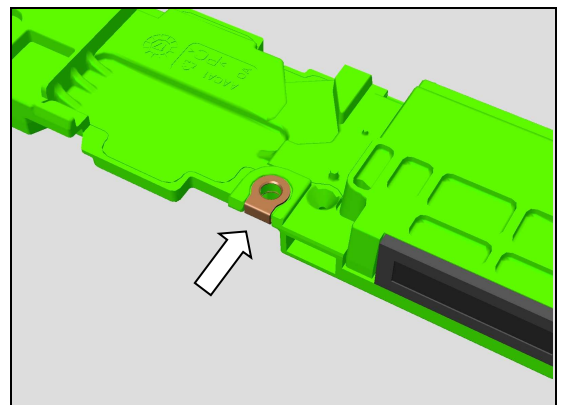
***Make sure the three metal rings contact to the front cover.***



## 5.13 Main Antenna Speaker Box

### 5.13.1 Contact Clip Speaker Box

Insert to mount the Contact Clip Speaker Box as shown in picture.

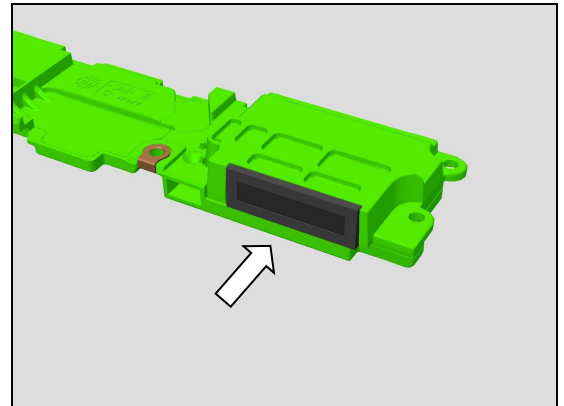




## Reassembly

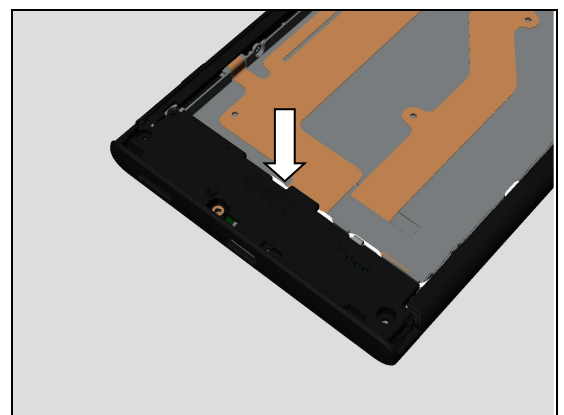
### 5.13.2 Speaker Sponge

Attach a new Speaker Sponge onto its proper position as shown in picture.

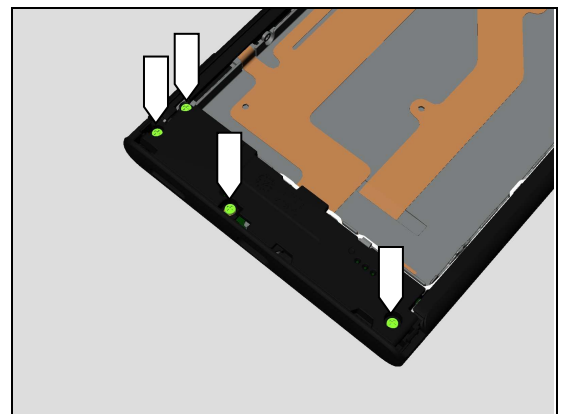


### 5.13.3 Main Antenna Speaker Box

Mount the Main Antenna Speaker Box to its proper position and press to snap it.



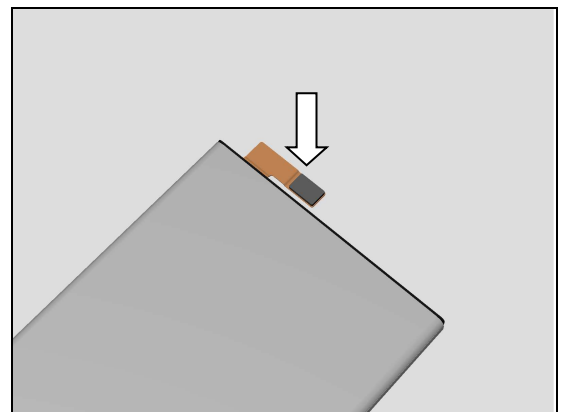
Apply 8Ncm torque when tightening the four Screw CROSS M1.2 L2.67 Black with Bits JCIS No.0.



## 5.14 Battery and Adhesive Battery

### 5.14.1 Sponge Battery Connector

Attach a new Sponge Battery Connector onto its proper position as shown in picture.

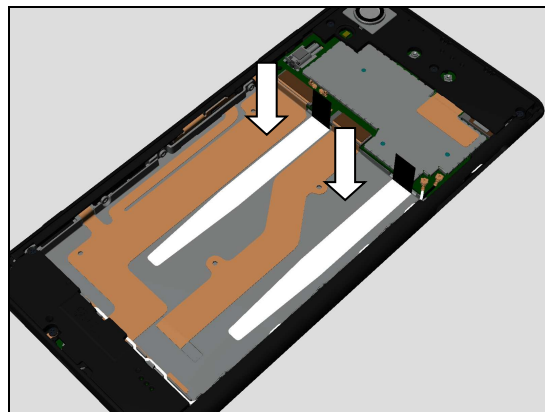


## Reassembly

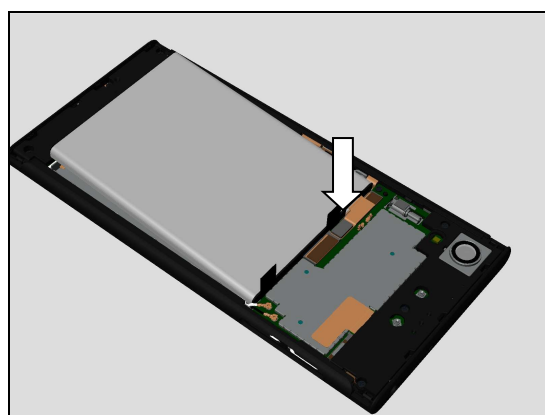
### 5.14.2 Adhesive Battery and Battery

Attach the two new Adhesive Battery in alignment with the guiding lines on the front cover as shown in picture.

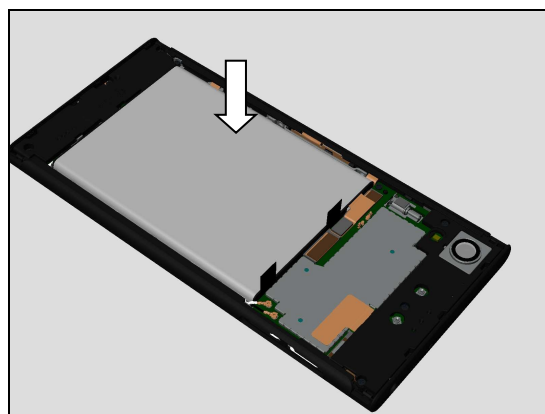
**Do not attach the Adhesive Battery onto the FPC.**



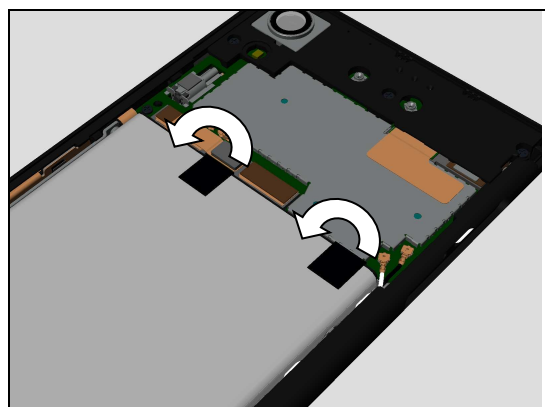
Firstly press to snap the Battery connector.



Then mount the Battery into its cavity.



Attach the two tabs onto the Battery as shown in picture.

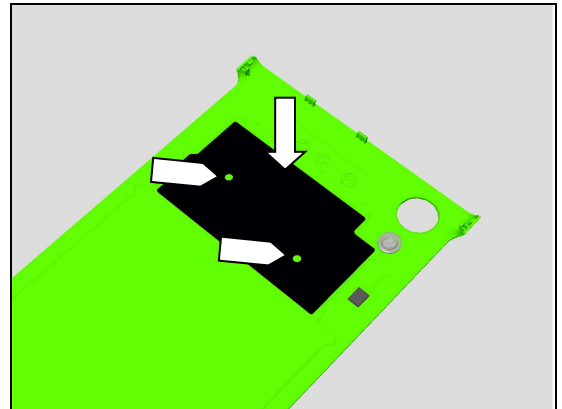


## Reassembly

### 5.15 Battery Cover Assy

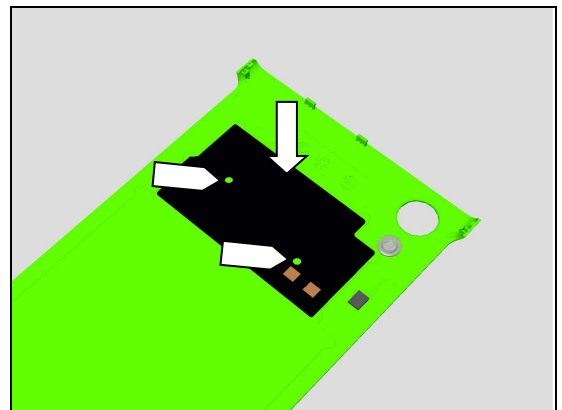
#### 5.15.1 Mylar NFC

Attach a new Mylar NFC in alignment with the guiding lines and pins on the Battery Cover Assy.



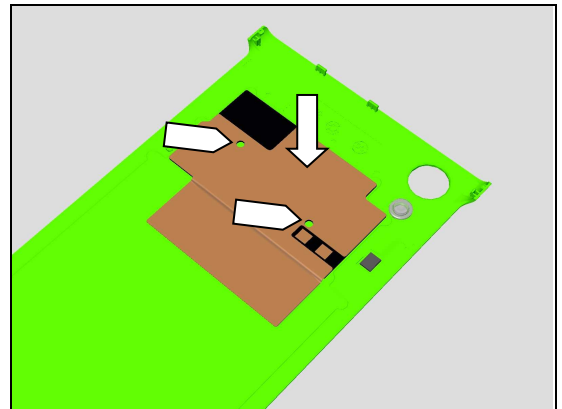
#### 5.15.2 Antenna NFC

Attach a new Antenna NFC in alignment with the guiding lines and pins on the Battery Cover Assy.



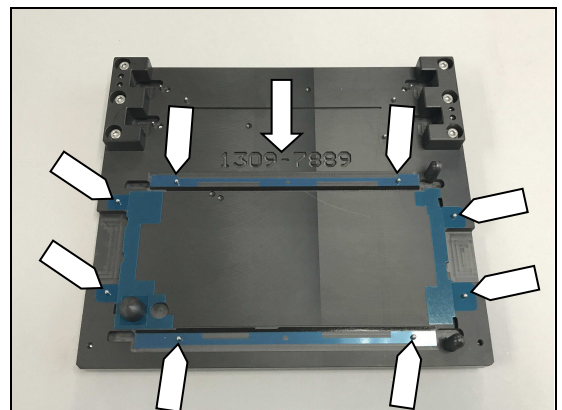
#### 5.15.3 Copper Foil Battery Cover

Attach a new Copper Foil Battery Cover in alignment with the guiding lines and pins on the Battery Cover Assy.



#### 5.15.4 Adhesive Battery Cover Top, Adhesive Battery Cover Bottom, Adhesive Battery Cover Left and Adhesive Battery Cover Right

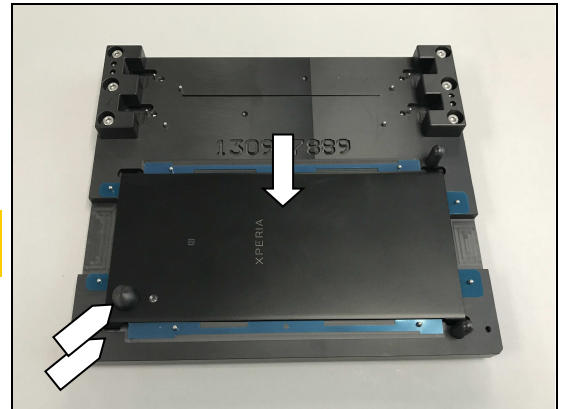
Mount a new Adhesive Battery Cover Top, Adhesive Battery Cover Bottom, Adhesive Battery Cover Left and Adhesive Battery Cover Right onto the Panels Adhesive Fixture as shown in picture.



## Reassembly

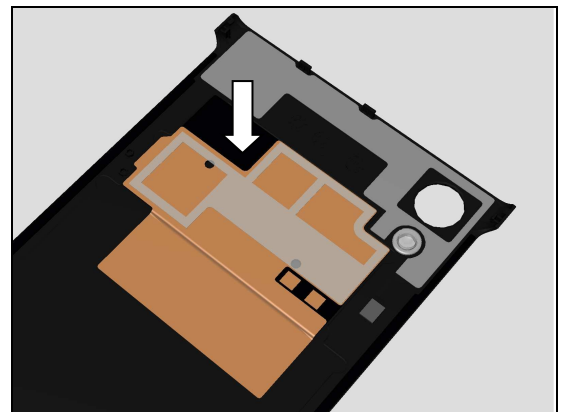
Mount the Battery Cover Assy onto the Panels Adhesive Fixture, then press the adhesive area to attach the adhesive.

***Make sure all remaining adhesive residue on the Battery Cover Assy have been removed before attaching!***



### 5.15.5 Adhesive NFC

Attach a new Adhesive NFC in alignment with the shape of the Copper Foil Battery Cover.



### 5.15.6 Battery Cover Assy

***Make sure all remaining adhesive residue on the Display Cover Assy have been removed before assembly!***

Mount the Battery Cover Assy from top side.



Press to snap the hooks on top side.

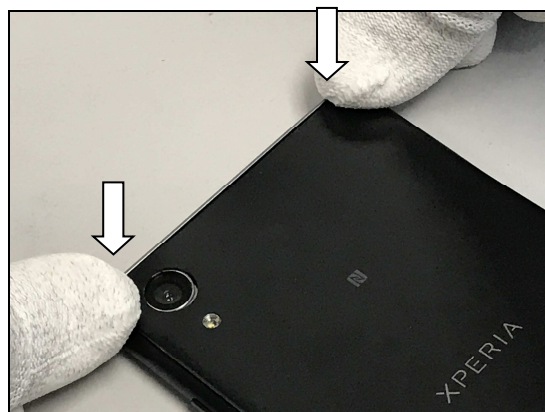


## Reassembly

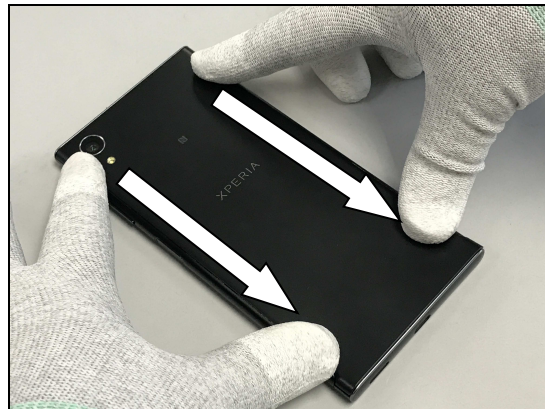
Secure the hooks on top side snapped.



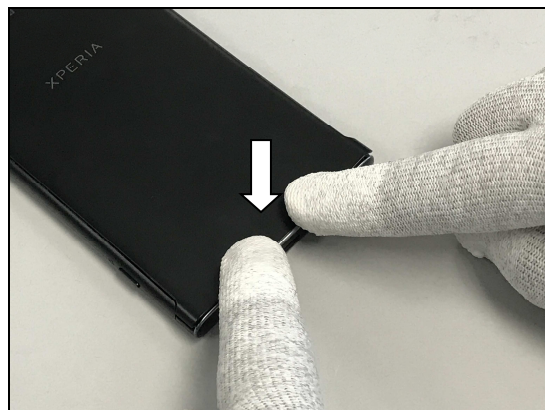
Press to snap the two top corner hooks.



Press left and right side to secure attachment.



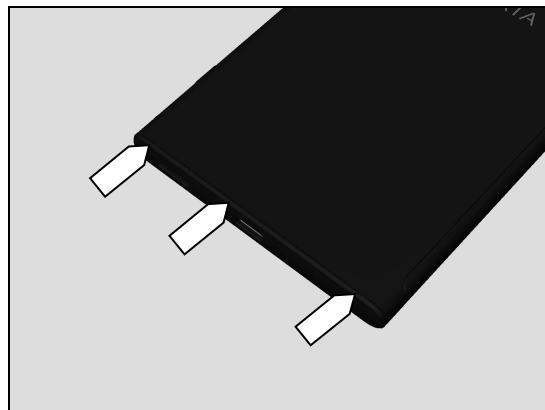
Press to snap the hooks on bottom side.



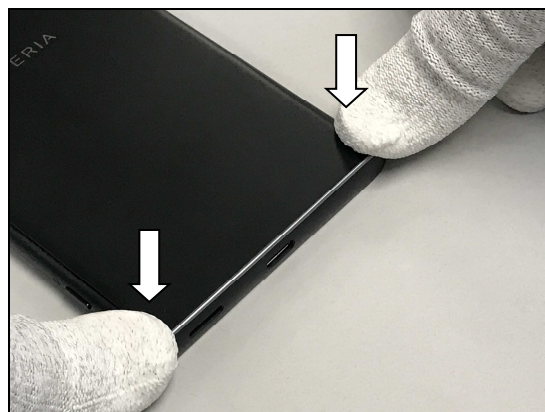


## Reassembly

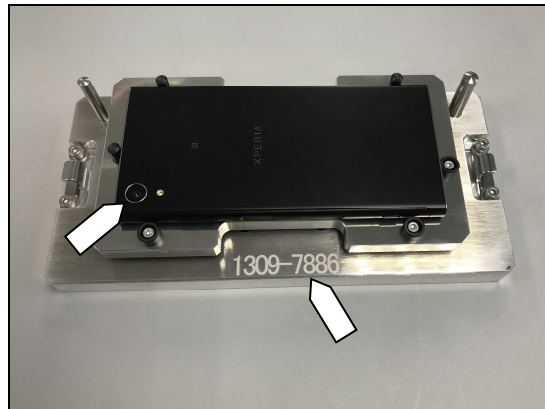
Secure the hooks on bottom side snapped.



Press to snap the two bottom corner hooks.

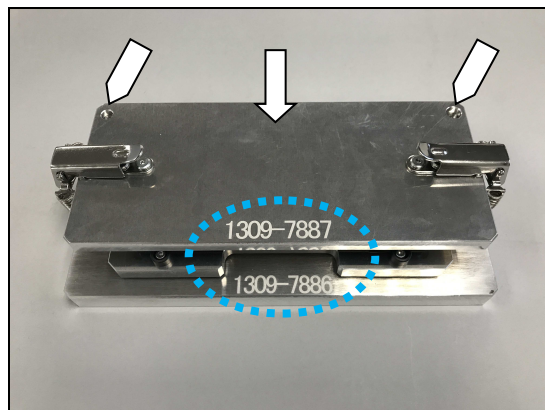


Mount the phone in its proper direction onto Press tool Bottom as shown in picture.



Mount the Press tool Top in its proper position by using position pins and holes and lock the Press tool Top to press the Battery Cover Assy for 1 minute.

**Note! The part numbers on the Press tool Top and Press tool Bottom in the same direction.**





## Reassembly

Press this half of Adhesive NFC area by using the Press Clamp for 5 seconds.

### **Note of how to use the Press Clamp:**

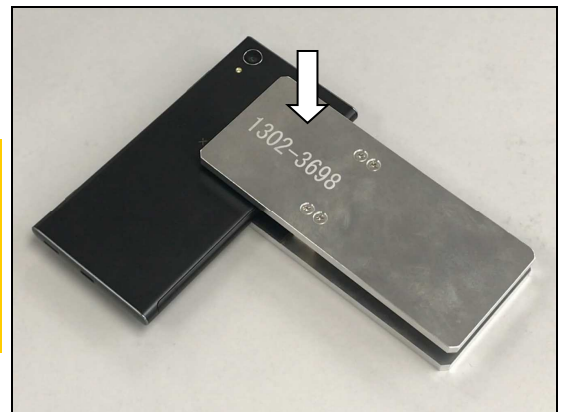
1. The smaller press pad is used for pressing the Adhesive NFC area.
2. Adjust phone position to secure the press pad can press onto the Battery Cover Assy. Do not insert the phone to the bottom.
3. Do not press the Camera lens.



Press the other half of Adhesive NFC area by using the Press Clamp for 5 seconds.

### **Note of how to use the Press Clamp:**

1. The smaller press pad is used for pressing the Adhesive NFC area.
2. Adjust phone position to secure the press pad can press onto the Battery Cover Assy. Do not insert the phone to the bottom.

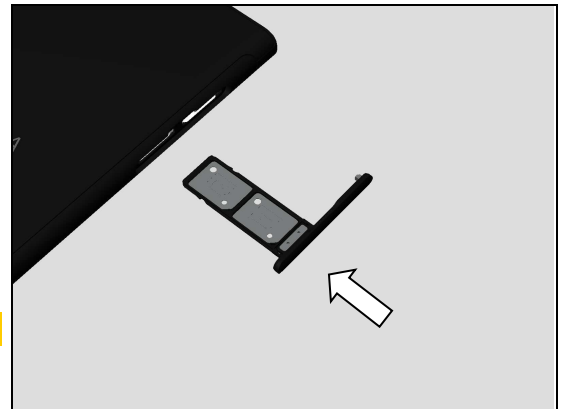


## 5.16 Cap Tray

### 5.16.1 Cap Tray Dual (G3412,G3416,G3426)

Insert the Cap Tray Dual.

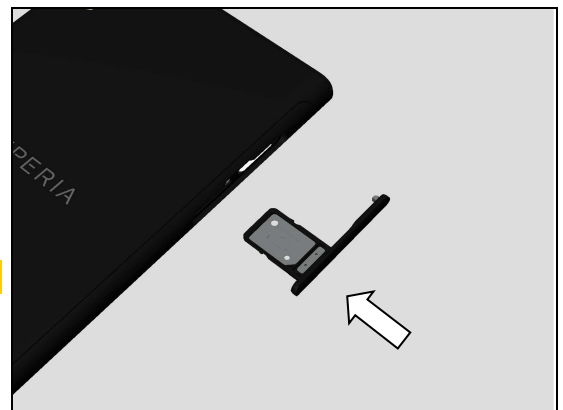
**This is only for G3412,G3416,G3426!**



### 5.16.2 Cap Tray Single (G3421,G3423)

Insert the Cap Tray Single.

**This is only for G3421,G3423!**



## 6 Battery Reuse Instruction

**If you intend to reuse the Battery, carefully follow the Battery Reuse Instruction.  
If it is failed, Don't reuse, and Scrap the Battery.**

### 6.1 Battery Handling Notices

1. Don't damage the battery foil with sharp objects.
2. Don't twist or deform the battery.
3. If the battery is dropped, don't reuse, and scrap.
4. Hold the battery at the frame edges of battery (green circled portion).



### 6.2 Dot Mark Check

**Check if the Battery (which has been removed from the unit) has blue/red or black/red dots marking.**

**Do not reuse, if the Battery has two (2) red dots marking, and scrap it.**

**Blue and black dot indicates Battery had been removed from the unit, and red dot indicates Battery had been reinstalled (reused).**

**Scrap! If the battery has two (2) red dots marking, it can't be reused for third times.**

Can be reused



Can't be reused → Scrap



### 6.3 Dot Marking 1

**If no dot marking on the Battery, put black dot marking with permanent pen.**



## Battery Reuse Instruction

### 6.4 Appearance Check

**Check if any damages on the battery such as Winkle, Bubble, Dent, Floating up the AL sheet, Twist, and/ or Line.**

**If it is out of below specification, do not reuse, and scrap the battery.**

Item of Damage	Limit of size	Limit of quantity
Winkle	Length $\leq 5\text{mm}$	1 wrinkle per Al sheet
Mark	No mark is allowed.	
Bubble	Diameter $\leq \Phi 2\text{mm}$	3 bubble per Al sheet
Dent	Diameter $\leq \Phi 2\text{mm}$	3 dents per surface
Scratch	Scratch is allowed as far as printed characters are visible.	
Lift up Al Sheet	No lifting up of the Al sheet is allowed.	
Twist	Twist line is allowed.	
Line	No line is allowed.	

### Definition of Damages and Sample Pictures

#### Wrinkle:

A slight line or fold on label or tape of the battery.



#### Mark:

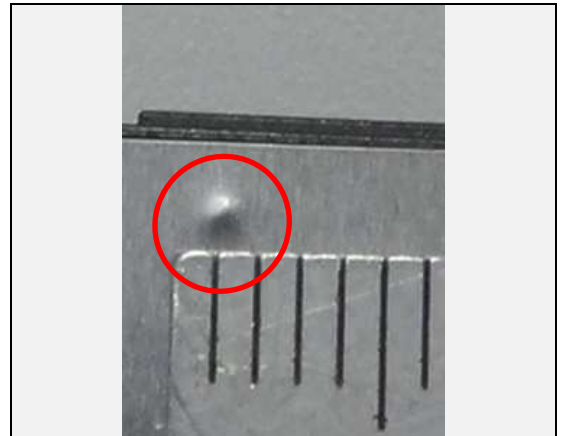
Surface is bulged as lined by foreign material is located between Al sheet and battery cell housing.



## Battery Reuse Instruction

### **Bubble:**

Surface is bulged as pointed by foreign material is located between Al sheet and battery cell housing.



### **Dent:**

It is caused that is stuck by sharp pointed objects.



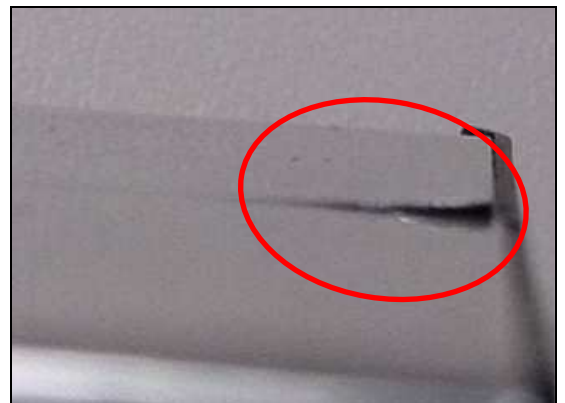
### **Scratch:**

It is caused that scratched by sharp edge/pointed objects.



### **Lift up Al Sheet:**

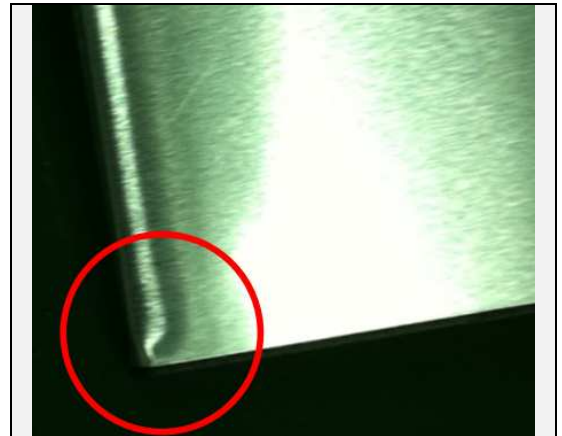
The edge of Al sheet is lifted caused by improper handling.



## Battery Reuse Instruction

### Twist:

Twisting line locates at the corner of battery pack that is created during Al sheet wrapping.



### Line:

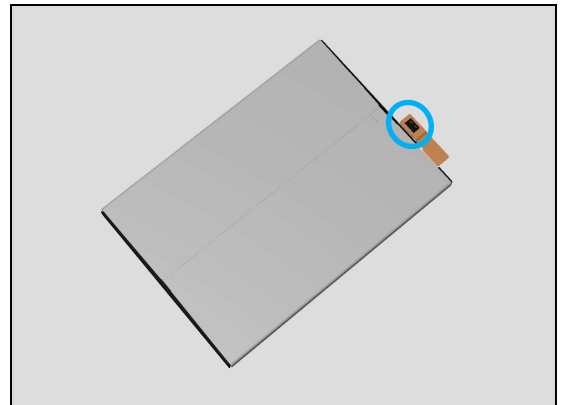
A slight line located at the border of battery cell and frame.



## 6.5 BtB Connector Check

Check if BtB connector has damages.

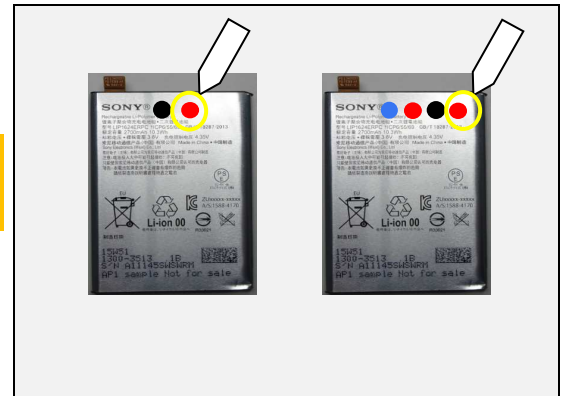
If any damages on the BtB connector, do not reuse, and scrap the battery.



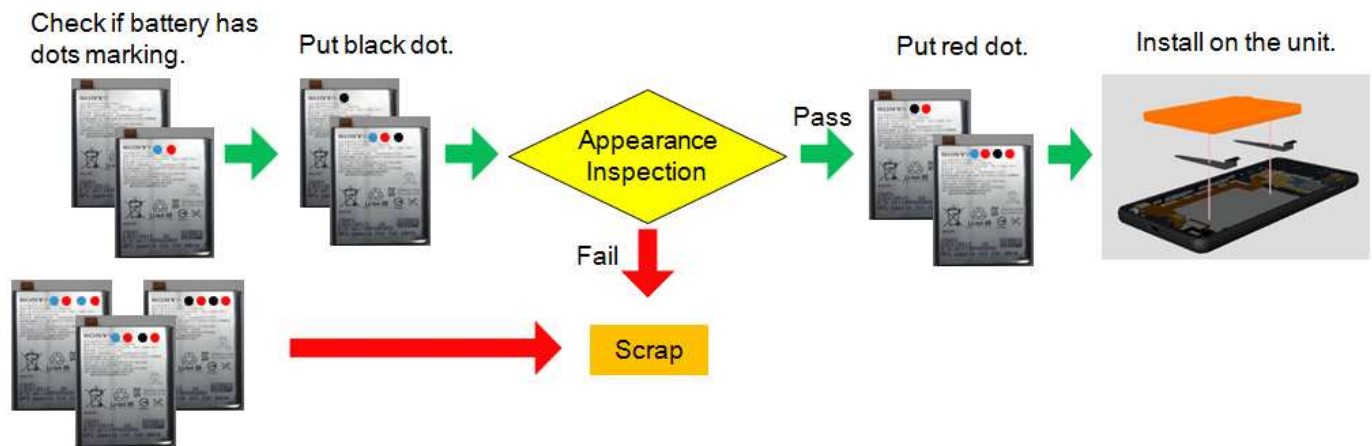
## Battery Reuse Instruction

### 6.6 Dot Marking 2

**If no failure has been detected by above appearance check, put the red dot marking on the Battery with permanent pen for reinstalling (reuse).**



#### Overall procedure for Battery Reusing





## 7 Revision History

Rev.	Date	Changes / Comments
1	2017-Sept-22	Initial release