

Working Instruction, Mechanical

Applicable for V800/V802se, Z800i

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Disassembly

Tools

- Torque screwdriver. Bits Torx T5
- Torque screwdriver, set to 15 Ncm \pm 6%. Bits Torx T6
- Blunt pair of tweezers, pair of tweezers
- Front opening tool NTZ 112 1063
- Dentist hook
- Guitar Plectrum
- Upper Rear lid opening tool

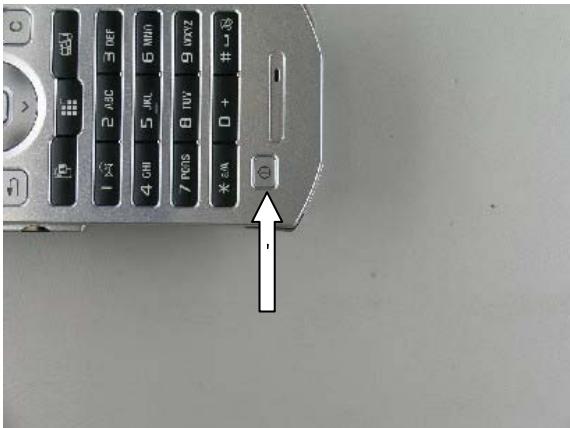

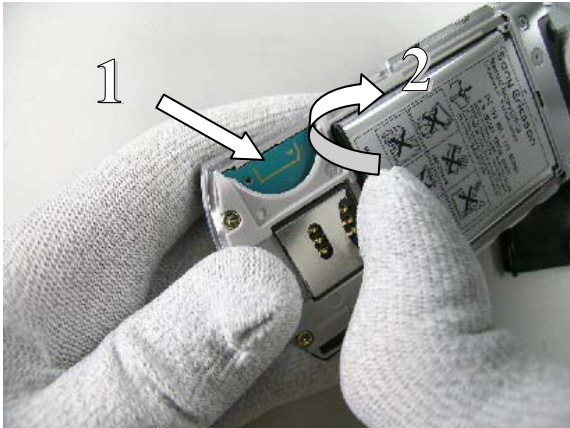
Equipment


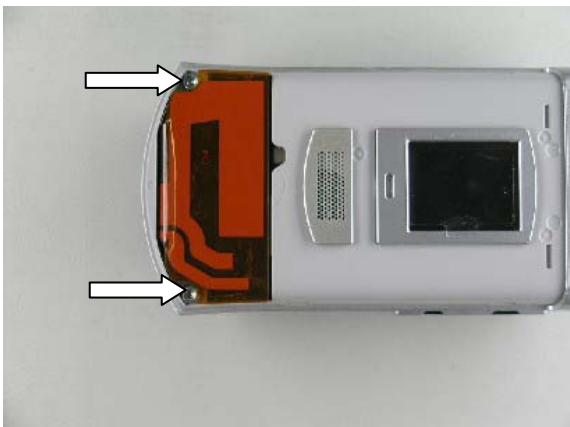
- ESD-gloves (cotton gloves)
- ESD-wristband



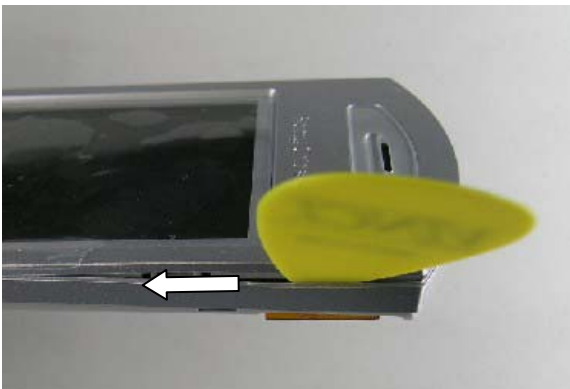

Instruction

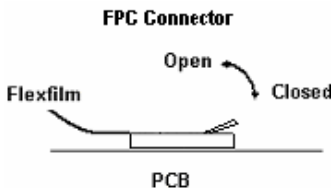



- Keep all contact surfaces clean of dirt and hand-grease
- Disassembly performed without Memory stick.

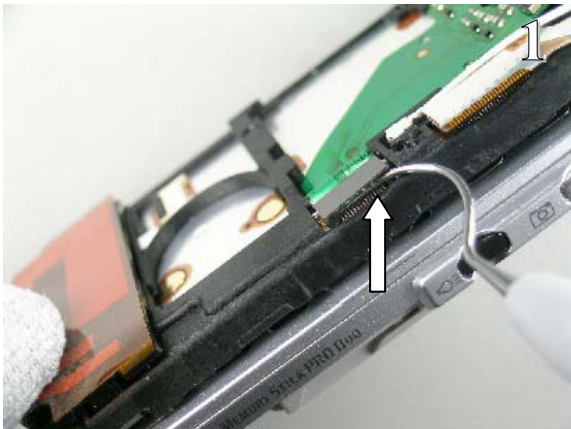
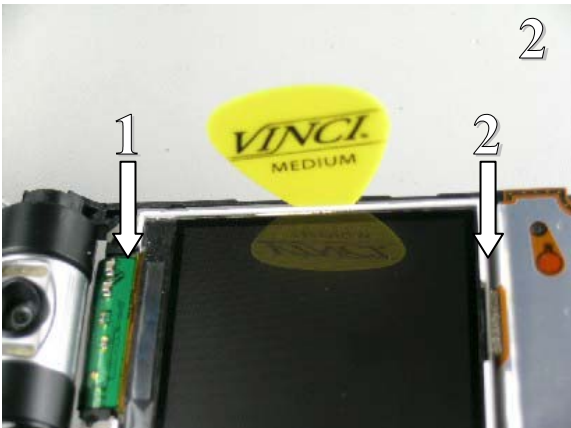
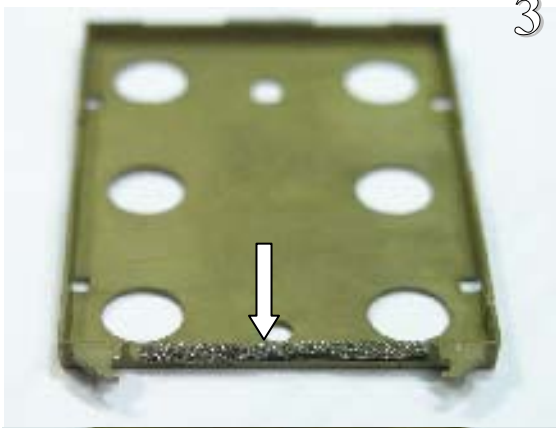
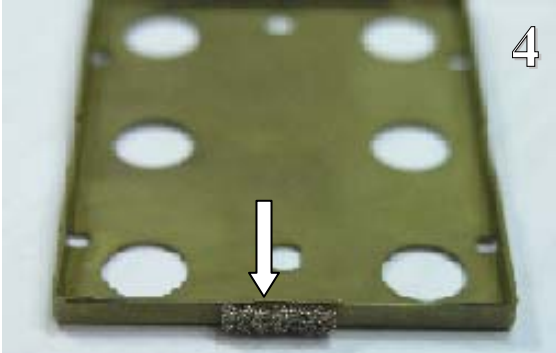
	Upper Front view	Upper Rear view
		
	Lower Front view	Lower Rear view
		



	Step-by-Step Instructions	
1	<p>NOTE!</p> <p>The On/Off Button is located according to the arrow.</p> <p>Turn off the phone by pushing the On/Off Button.</p>	
2	<p>Place your thumbs, according to the picture. Slide, according to the arrow, the Battery Cover upwards and remove it.</p>	
3	<p>NOTE!</p> <p>The place for the Memory Stick is placed according to the arrow (1). Confirm that the Memory Stick is removed.</p> <p>Use your fingers, according to the arrow (2), to remove the Battery from the phone.</p>	
4	<p>The disassembly of the Upper Half Assemblies will be carried out from operation 5 to 12.</p> <p>The disassembly of the Lower Half Assemblies will be carried out from operation 13 to 18.</p>	


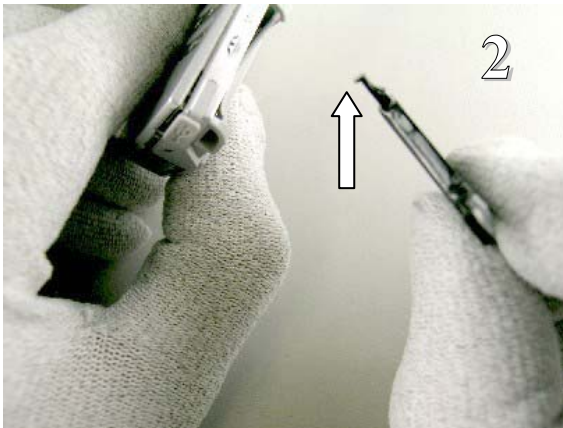


	Step-by-Step Instructions	
5	<p>NOTE!</p> <p>Be careful not to damage the edges on the Upper Rear Lid and the Upper Rear Cover Assy when using the plectrum.</p> <p>The plectrum angle should be 130 degrees according to the Upper Lid, according to the picture.</p> <p>Use a Plectrum, according to the picture, to remove the Upper Rear Lid Assy. Start at the middle and slide along upwards, according to the arrow (1), and downwards, according to the arrow (2).</p> <p>Repeat the procedure on the opposite side.</p>	
6	<p>NOTE!</p> <p>Be careful not to damage the Antenna Flex Film.</p> <p>Remove the two screws at the antenna with the screwdriver (T6). Use a pair of tweezers to carefully fold the Antenna Flex Film when removing the untighten screws.</p> <p>NOTE!</p> <p>Removed screws cannot be reused.</p>	

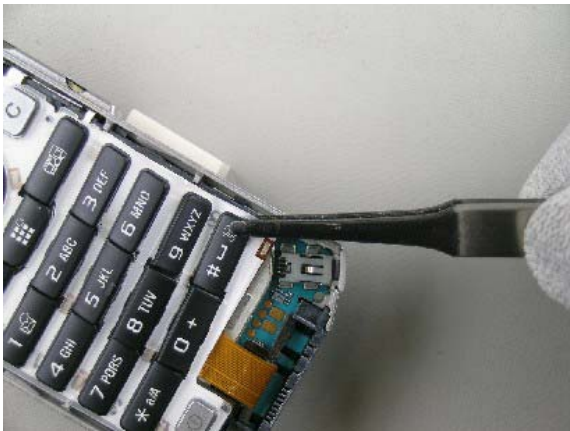
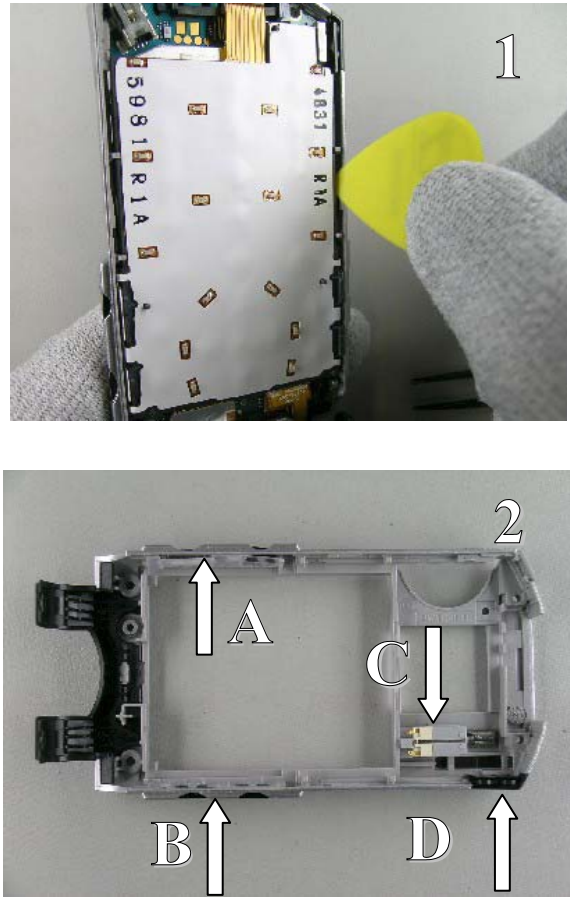
	Step-by-Step Instructions	
7	<p>NOTE!</p> <p>Be careful not to damage the phone.</p> <p>Open the phone between 90 and 180 degrees.</p> <p>Use a dentist hook to remove the Screw Protection Cover on the Upper Front Cover Assy, according to the picture (1).</p> <p>NOTE!</p> <p>Removed screw protection cannot be reused.</p> <p>Use a screwdriver (T6) to remove the two screws, which are placed according to the arrows (2), with the screwdriver.</p> <p>NOTE!</p> <p>Removed screws cannot be reused.</p>	 
8	<p>NOTE!</p> <p>The plectrum should have an angle of 130 degrees according to the Main Display, according to the picture.</p> <p>Use a plectrum to remove the Upper Front Cover Assy. Start at the Upper Part of the phone then slide towards the Hinge area, according to the arrow, while twisting the plectrum until the Snap Fit Latches opens.</p> <p>Separate the Upper Front Cover Assy from Upper rear complete and remove it.</p>	
9	<p>NOTE!</p> <p>Do not touch the Sub LCD. Cover it with a plastic protection.</p> <p>The width of opening should have an angle of 90 degrees, according to the picture.</p> <p>Use your thumbs to lift up the Upper Rear Complete from its position and remove it.</p>	

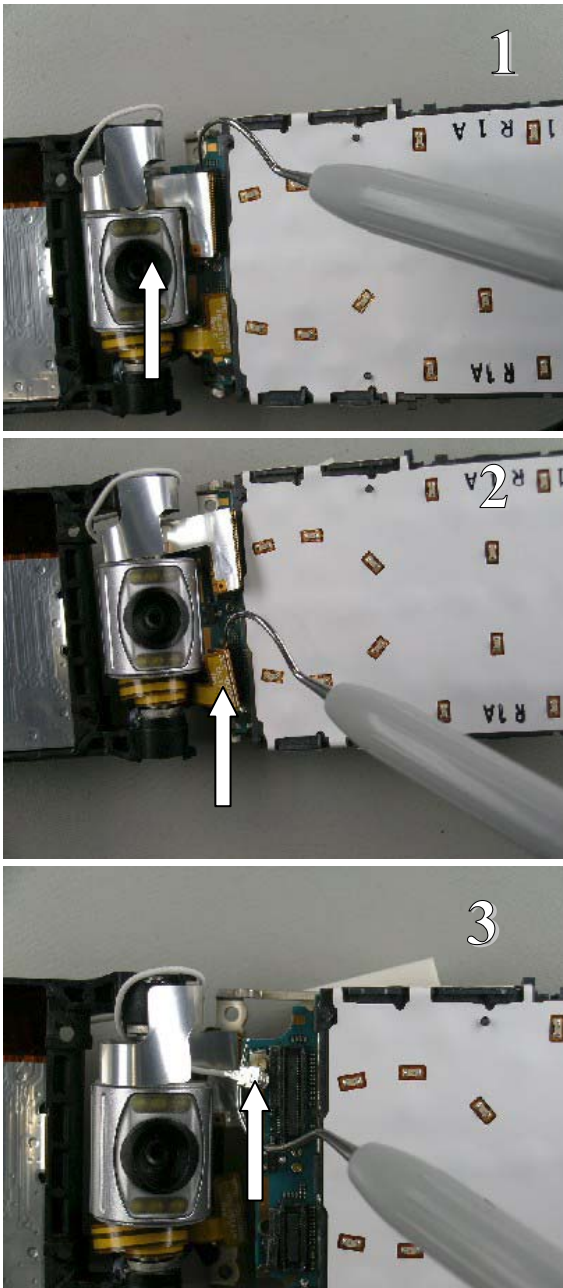
	Step-by-Step Instructions	
10	<p><i>Remove the Sub LCD.</i></p> <p>Close the phone so that the Upper Rear Cover is visible.</p> <p>NOTE!</p> <p>Be careful not to damage the Upper Rear Cover or other components.</p> <p>Open the FPC connector with the dentist hook, according to the picture (1).</p> <div data-bbox="284 645 619 831" data-label="Diagram">  <p style="text-align: center;">FPC Connector</p> <p>Flexfilm Open Closed</p> <p style="text-align: center;">PCB</p> </div> <p>NOTE!</p> <p>Be careful not to damage the Sub LCD Flex Film.</p> <p>Use a pair of tweezers to disassemble the flex film from the connector, according to the picture (2).</p> <p>NOTE!</p> <p>The flex film on the rear of the Sub LCD can be stuck in the FPC Connector. Twist gently the Flex Film while removing it.</p> <p>Be careful not to touch the Sub LCD glass plate.</p> <p>Be careful not to damage the flex film or other components.</p> <p>Use a dentist hook to lift up the Sub LCD in the left corner from the cavity, according to the picture (3).</p> <p>Grab the outside frame of the Sub LCD with your fingers and drag it towards the Hinge area.</p>	<div data-bbox="887 293 1461 719" data-label="Image">  </div> <div data-bbox="887 725 1461 1151" data-label="Image">  </div> <div data-bbox="935 1158 1461 1583" data-label="Image">  </div>


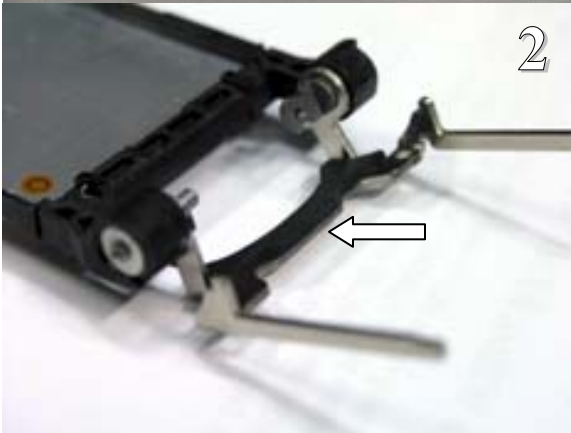
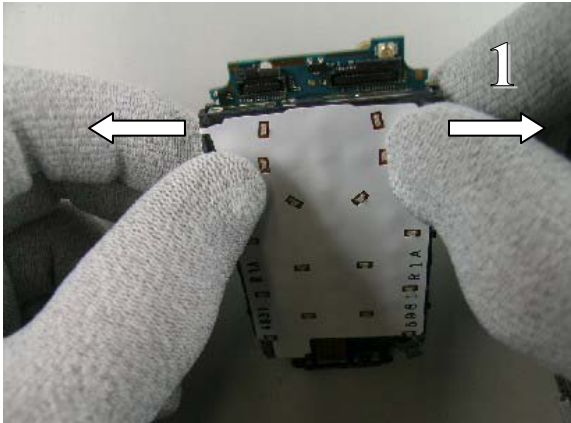
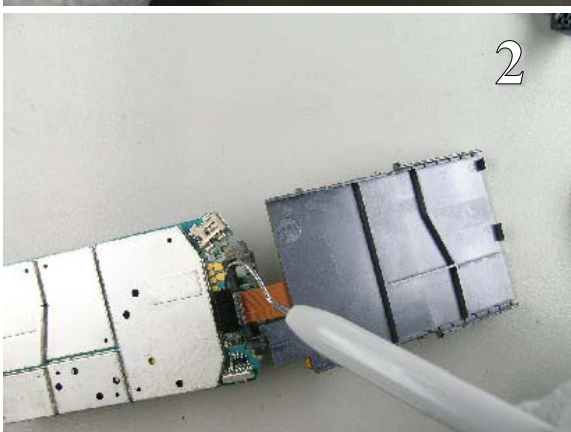
	Step-by-Step Instructions	
11	<p><i>Remove the Main LCD.</i></p> <p>NOTE!</p> <p>Be careful not to damage the Board-To-Board connector.</p> <p>Disconnect the Board-To-Board connector by using a dentist hook, according to picture 1.</p> <p>NOTE!</p> <p>Be careful not to damage the Flex Film.</p> <p>Carefully release/separate the flex film from the Antenna Flex Assy. The Main Display flex film is glued onto the Antenna Flex Assy.</p> <p>Open the phone so that the Main LCD is visible.</p> <p>NOTE!</p> <p>Be careful not to damage the Main LCD.</p> <p>Use the plectrum to release the Main LCD from the Upper Carrier Assy, according to picture 2.</p> <p>Carefully lift the LCD from the cavity in Upper Carrier Assy.</p> <p>There are two Gaskets which are placed according to the arrows.</p> <p>The Lower Gasket is placed under the Flex Film according to arrow 1 in picture 2. The Lower Gasket is mounted at the bottom of the Main LCD Cavity, according to the arrow in the picture (3).</p> <p>The Upper Gasket is placed according to arrow 2 in picture 2. The Lower Gasket is mounted at the top of the Main LCD Cavity, according to the arrow in the picture (4).</p>	   

	Step-by-Step Instructions	
12	<p>Close the phone, so the Coax connector is visible.</p> <p>NOTE!</p> <p>Be careful not to damage the Coax Cable.</p> <p>Disconnect the Coax Cable connector by using a dentist hook, according to the picture (1).</p> <p>NOTE!</p> <p>Be careful not to damage the Flex Film or the Board-To-Board connector</p> <p>Disconnect the Half-to-half Assy Board-To-Board connector on the Antenna Flex Film by using a dentist hook, according to the picture (2).</p>	 

	Step-by-Step Instructions	
13	<p>Close the phone so the lower rear is visible, according to the picture.</p> <p>Remove the four screws on the lower rear cover (T6), according to the arrows.</p> <p>NOTE!</p> <p>When performing the separation between the Lower Rear Cover Assy and the Lower front Cover Assy, the hook of the tool shall point downwards, according to the picture (2), against the Lower Rear Cover Assy.</p> <p>Be careful not to damage the edges of the Lower Rear Cover Assy or the Lower Front Cover Assy.</p> <p>Fold up the phone. Separate the Lower Front Cover Assy from the Lower Rear Cover Assy by lifting the Lower Front Cover Assy carefully. When there is enough gap between the two parts, insert the front opening tool NTZ 112 1063.</p> <p>NOTE!</p> <p>Be careful not to damage the Hall element on the PCB.</p> <p>Start to slide the opening tool at the lower end, according to the picture (3), and slide it all the way to the hinge area. Repeat the same procedure on the opposite side of the phone.</p> <p>When the two parts are totally separated (4), release the Lower Front Cover Assy from its position.</p> <p>NOTE!</p> <p>Removed screws cannot be reused.</p>	   

	Step-by-Step Instructions	
14	Use a pair of tweezers to remove the Keyboard, according to the picture.	
15	<p>Insert the plectrum, according to the picture (1), between the Lower Rear Cover Assy and the PCB.</p> <p>Gently bend the plectrum outwards and separate the Lower Rear Cover Assy from the PCB.</p> <p>Remove the Lower Rear Cover Assy.</p> <p>NOTE!</p> <p>Compare your Lower Rear Cover Assy to the picture number two. Confirm that the volume keys (A), the camera keys (B), vibrator (C) and the IrDA window (D) not have falling out.</p>	

	Step-by-Step Instructions	
16	<p><i>Remove the Key Foil Assy and the PCB.</i></p> <p>NOTE!</p> <p>Be careful not to damage the Board-To-Board connectors.</p> <p>Use a dentist hook to disconnect the Half-To-Half Assy Board-To-Board connector from PCB, according to the arrow (1).</p> <p>NOTE!</p> <p>Be careful not to damage the Coax Cable.</p> <p>Use a dentist hook to disconnect the Camera Board-To-Board connector from PCB, according to the arrow (2).</p> <p>NOTE!</p> <p>Hold the dentist hook according to the picture 3.</p> <p>Use a dentist hook to remove the Coax Cable, according to the picture.</p>	

	Step-by-Step Instructions	
17	<p>Remove the screw (T5) on the Camera axis, which is located according to the arrow in picture 1.</p> <p>NOTE!</p> <p>Removed screws cannot be reused.</p> <p>Be careful not to damage the Camera Flex Film.</p> <p>Bend the camera outwards.</p> <p>Drag the camera to the right, according to the arrow.</p> <p>Use a pair of tweezers to remove the Dust Gasket Hinge, which is located according to the arrow in the picture (2).</p>	 
18	<p>Separate the Key Foil Assy and the PWB from the Upper Carrier Assy.</p> <p>Grab the Key Foil Assy's clips, according to the picture (1). Bend gently the Key Foil Assy outwards, according to the arrows. At the same time, bend the Key Foil Assy towards you.</p> <p>Fold the Key Fold Assy, according to the picture (2).</p> <p>NOTE!</p> <p>Be careful not to damage the Board-To-Board connector.</p> <p>Use a dentist hook, according to the picture, to disconnect the Board-To-Board connector from the Key Foil Assy.</p>	 

Reassembly

Tools

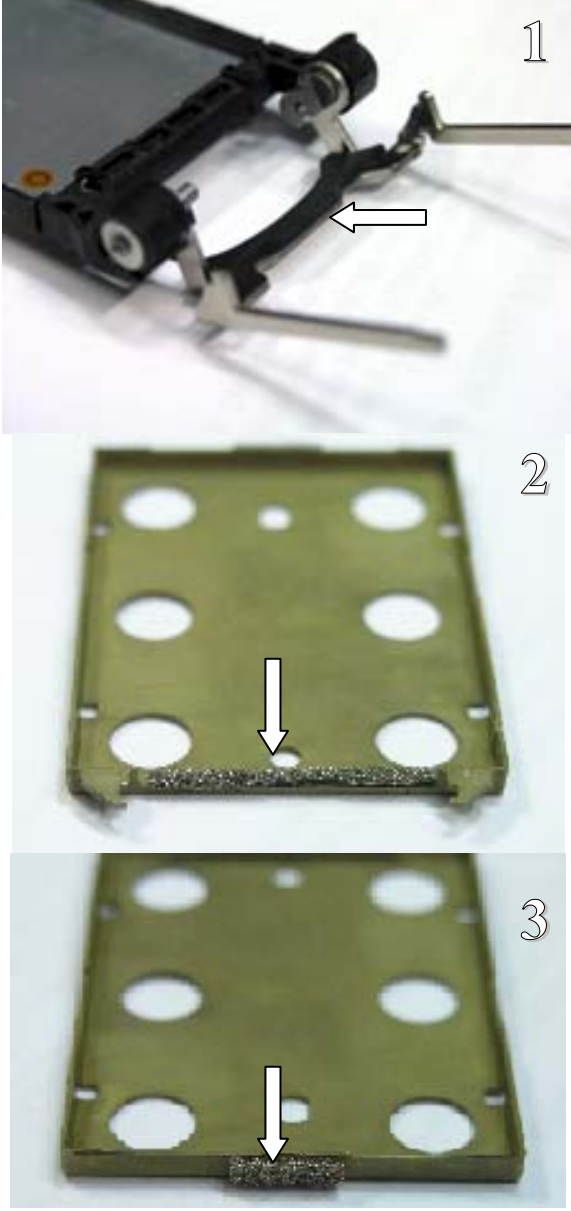
- Torque screwdriver. Bits Torx T5
- Torque screwdriver, set to 15 Ncm \pm 6%. Bits Torx T6
- Blunt pair of tweezers, pair of tweezers
- Front opening tool NTZ 112 1063
- Dentist hook
- Plectrum
- Upper Rear lid opening tool

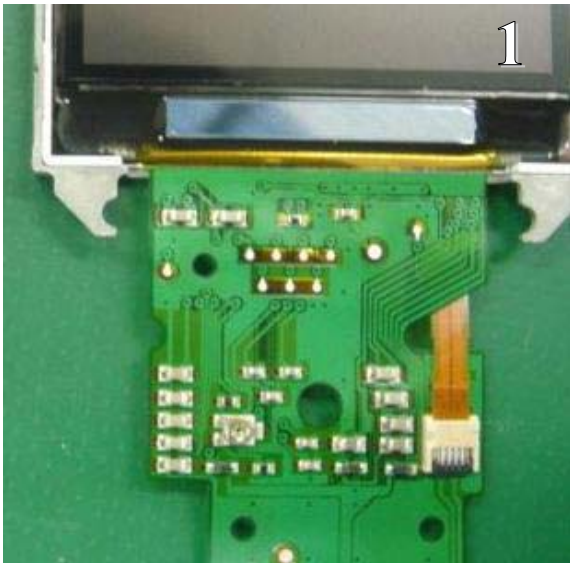
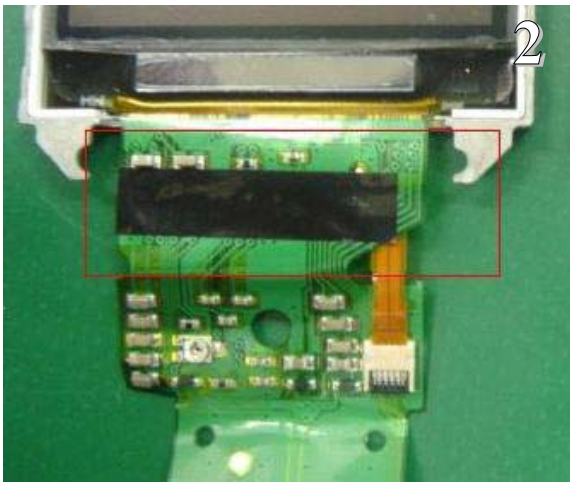
Equipment

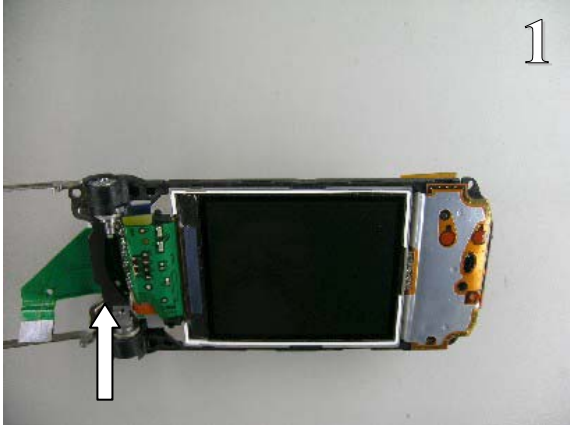
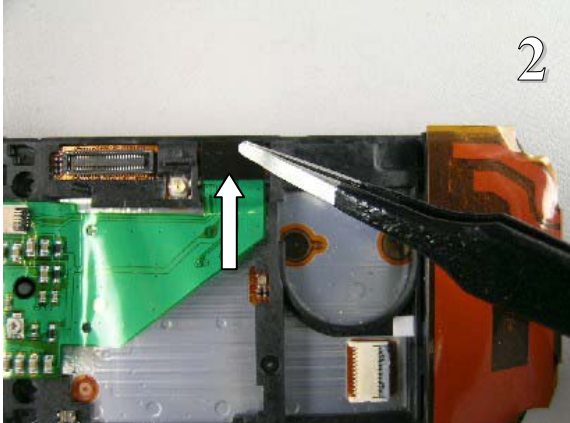

- ESD-gloves (cotton gloves)
- ESD-wristband

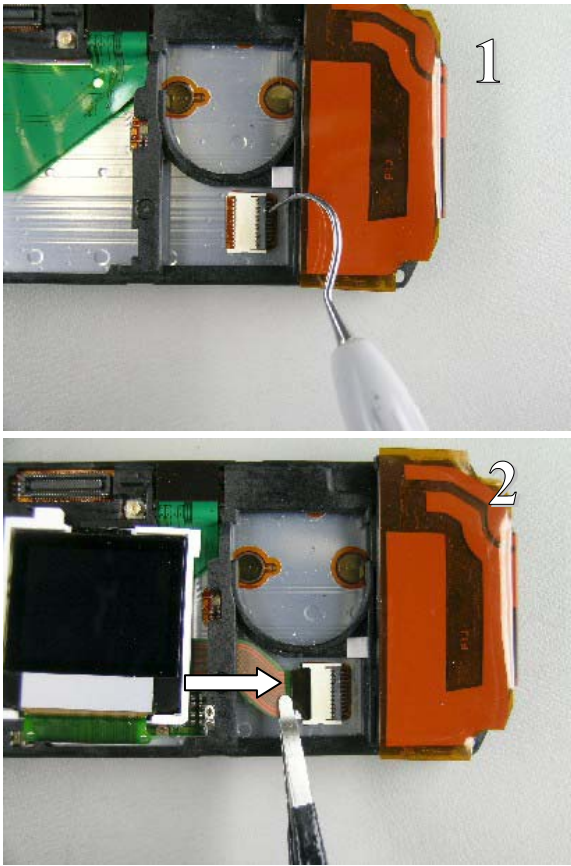
Instruction

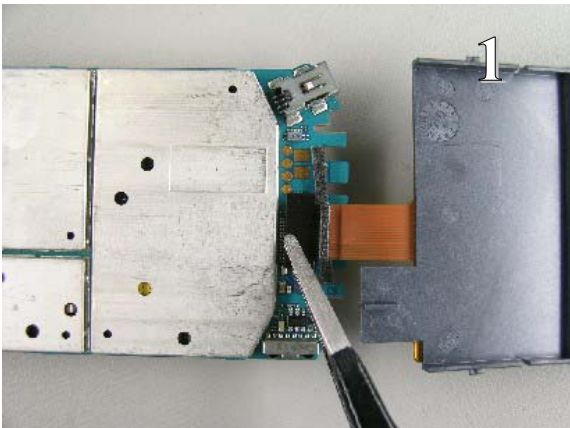
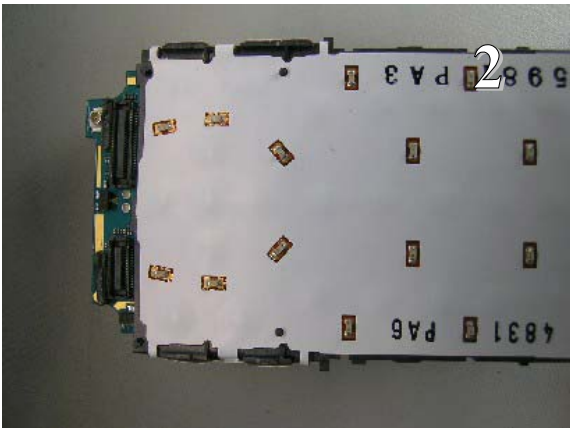
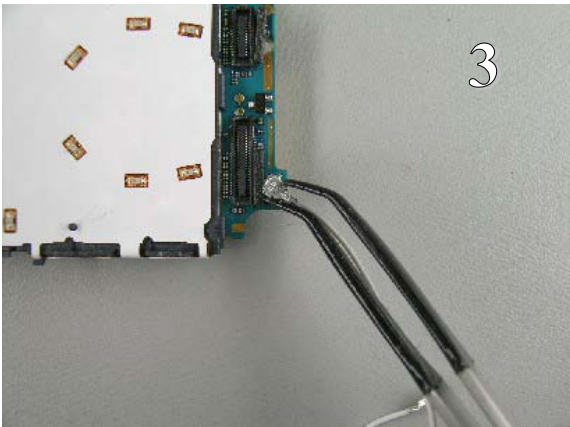
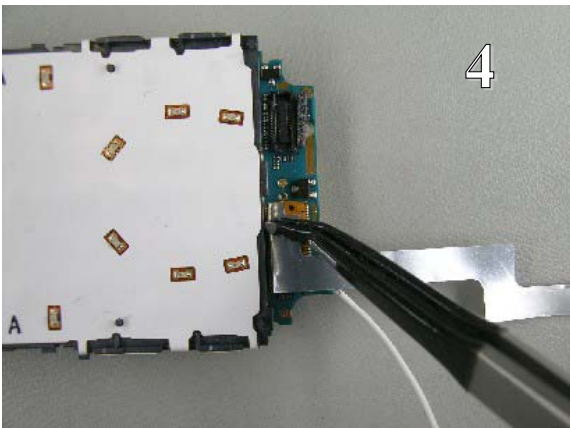
Keep all contact surfaces clean of dirt and hand-grease

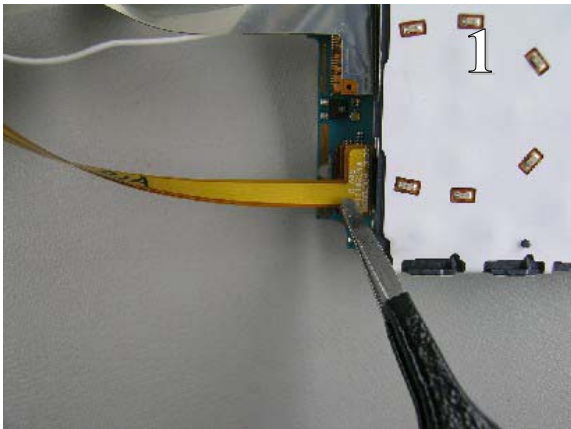
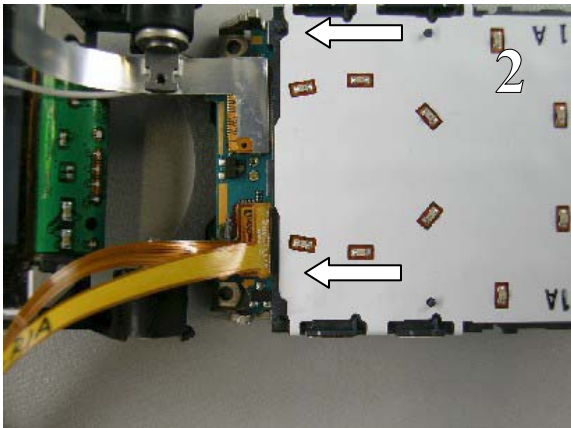

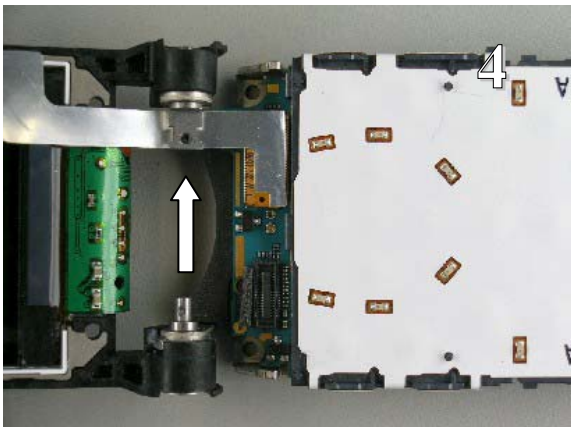
	Step-by-Step Instructions	
1	<p>Use a pair of tweezers to mount the Dust Gasket Hinge in the right position, according to the arrow in the picture (1).</p> <p>Use a pair of tweezers to mount the Lower Gasket at the bottom of the Main LCD Cavity, according to the arrow in the picture (2).</p> <p>Use a pair of tweezers to mount the Upper Gasket at the top of the Main LCD Cavity, according to the arrow in the picture (3).</p>	 <p>The right column contains three photographs illustrating the assembly steps. The first photograph, labeled '1', shows a pair of tweezers positioning a small metal hinge component. A white arrow points to the specific location on the device's frame where the hinge should be attached. The second photograph, labeled '2', shows a green rectangular LCD cavity with several circular holes. A white arrow points to the bottom edge of the cavity, indicating where a lower gasket should be placed. The third photograph, labeled '3', shows the same LCD cavity with a white arrow pointing to the top edge, indicating where an upper gasket should be placed.</p>

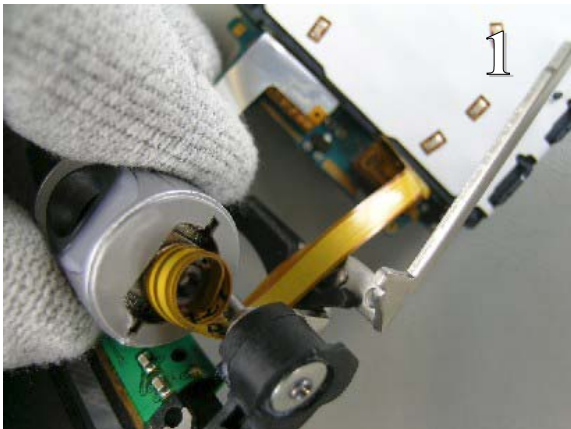
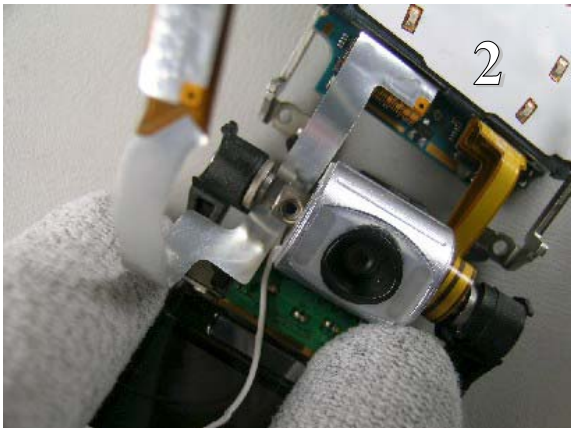
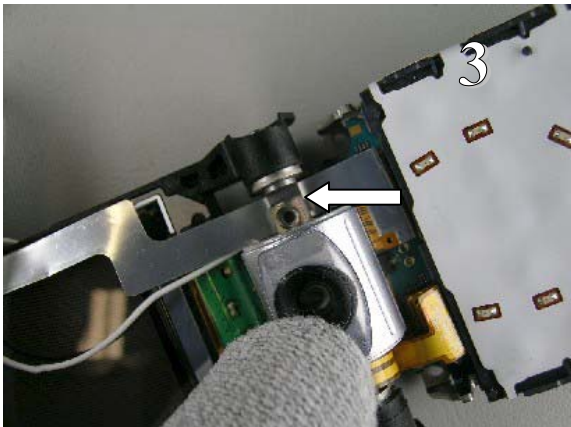

	Step-by-Step Instructions	
1	<p>NOTE!</p> <p>Be careful not to damage the Main LCD when mounting the black ESD Tape.</p> <p>Picture 1 shows the Flex Film of the Main LCD. Mount the ESD Tape according to picture 2.</p> <p>NOTE!</p> <p>Make sure that the ESD Tape is mounted according to the picture (2).</p>	 




	Step-by-Step Instructions	
2	<p><i>Assembling of the Main LCD.</i></p> <p>NOTE!</p> <p>Do not touch the Main LCD during the next procedure.</p> <p>Put the Main LCD in the cavity of the Upper Carrier Assy. Fold the flex film in the opening between the hinge mechanism and Upper Carrier Assy (1).</p> <p>Turn the Assembly.</p> <p>NOTE!</p> <p>Make sure that the flex film is correct mounted according to the pictures.</p> <p>Use a pair of tweezers to connect the Main Display Board-to-Board to the Antenna Flex Film Connector (2).</p> <p>Press gently the flex film on the adhesive. For the correct position of the Main Display Flex Film, use the guiding pin according to the picture (3).</p>	  

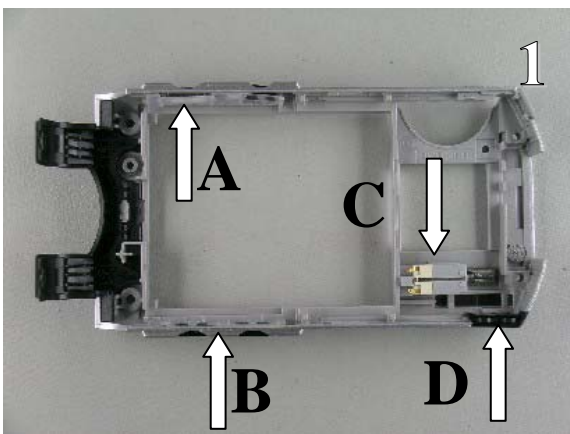
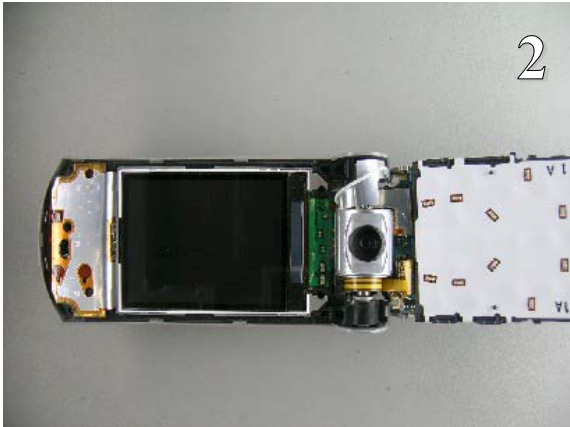
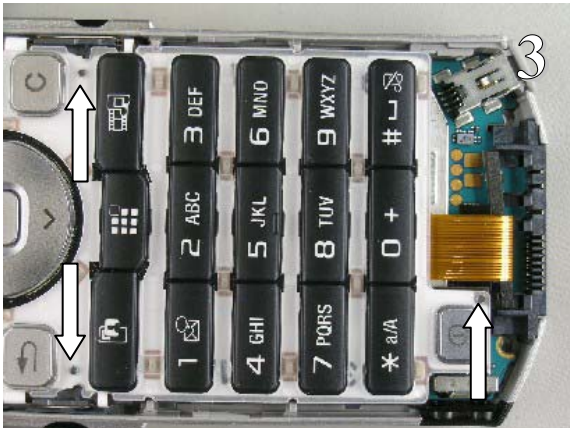
	Step-by-Step Instructions	
3	<p><i>Assembling of the Sub LCD</i></p> <p>NOTE!</p> <p>Be careful not to damage the Board-To-Board connector or the Antenna Flex Film.</p> <p>Use a dentist hook, according to the picture (1), to open the FPC connector.</p> <p>Slide the flex film under the bar on the Upper Carrier Assy, according to the picture (2).</p> <p>Use a pair of tweezers, according to the picture (2), to move the Flex Film straight forward into the connector.</p> <p>Close the FPC connector according to the picture below.</p> <div data-bbox="284 846 635 1048" data-label="Diagram"> </div> <p>NOTE!</p> <p>Make sure that the FPC-connector will be closed properly.</p>	

	Step-by-Step Instructions	
4	<p>NOTE!</p> <p>Be careful not damage the connector.</p> <p>Use a pair of tweezers, according to the picture (1), to connect the Key Foil Assy Board-to-Board Connector to the Board-to-Board Connector on the PCB.</p> <p>Fold the Key Foil Assy over the PCB and assemble it, according to the picture (2).</p> <p>Use a pair of tweezers, according to the picture (3), to connect the Coax Cable.</p> <p>Use a pair of tweezers, according to the picture (4), to connect the Board-To-Board connector of the Half-to-Half Assy.</p>	   

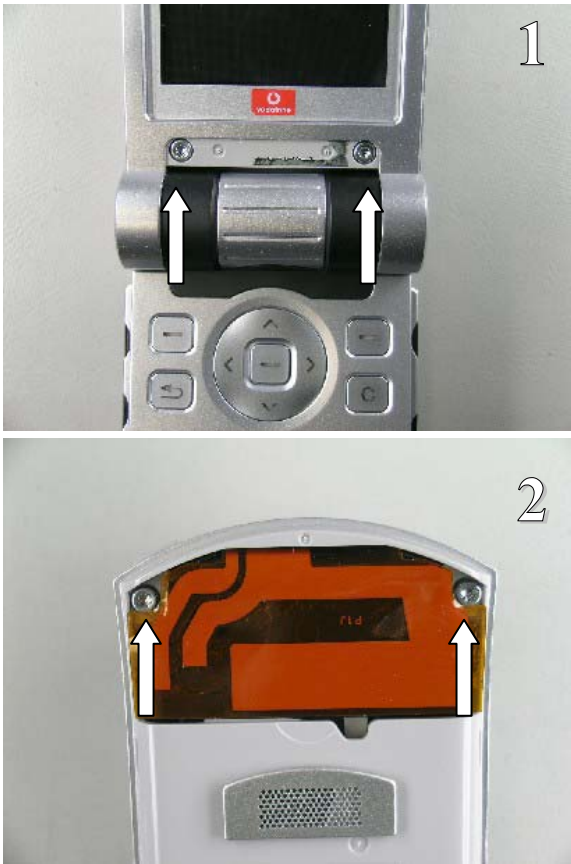

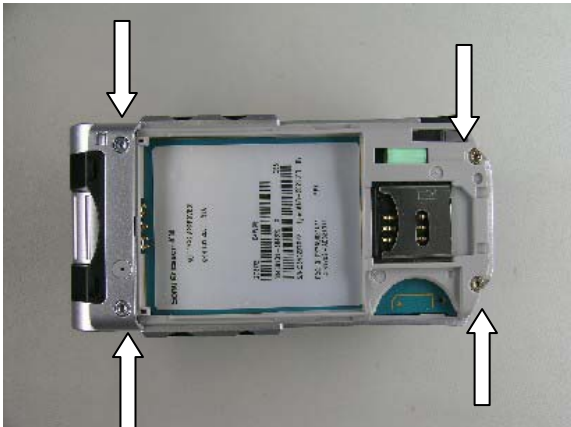
	Step-by-Step Instructions	
5	<p><i>Assemble the Camera</i></p> <p>NOTE!</p> <p>Be careful not damage the Flex Films or the Coaxial Cable.</p> <p>Use a pair of tweezers, according to the picture (1), to connect the Cameras Board-To-Board connector on the PCB.</p> <p>Slide the assembled PCB, according to the arrows (2), on the two carriers from the hinge mechanism all the way into the hinge, according to the arrows.</p> <p>NOTE!</p> <p>Be careful so that the Ground Springs stays intact in the next procedure. They are located on the top of the PCB. See picture (3) for an incorrect mounting.</p> <p>Confirm that the Camera flex films are positioned as the picture shows.</p> <p>NOTE!</p> <p>It's really important that the Coax Cable is properly mounted and not stretched during the whole reassembly.</p> <p>The Coax Cable should be behind the Half-to-Half Assy under the hinge shaft, according to the picture (4).</p>	   



	Step-by-Step Instructions	
6	<p>NOTE!</p> <p>Be careful not damage the Flex Films or the Coaxial Cable.</p> <p>Wind the Camera Flex Film two times around the hinge shaft of the camera module (1).</p> <p>NOTE!</p> <p>Use the screw hole to guide the assembly on the right shaft.</p> <p>Position the camera, according to the picture (2). Make sure that the hinge shaft is placed in the Camera cavity, according to the picture (3).</p> <p>NOTE!</p> <p>Use new screw (T5).</p> <p>Mount and tighten the screw on to the Camera shaft.</p>	   

	Step-by-Step Instructions	
7	<p>NOTE!</p> <p>Be careful not damage the Half-to half Assy and its connector.</p> <p>Turn the Half-to-Half Assy and connect it to the Board-to-Board connector by using a pair of tweezers, according to the picture (1).</p> <p>NOTE!</p> <p>Be careful not damage the Coaxial Cable and its connector.</p> <p>Turn the Coaxial Cable and connect it to the Board-to-Board connector by using a pair of tweezers, according to the picture (2).</p> <p>NOTE!</p> <p>The Coaxial Cable should be placed on top of the Half-to-Half Assy, according to the picture (3).</p>	  

	Step-by-Step Instructions	
8	<p>NOTE!</p> <p>Confirm that the volume keys (A), the camera keys (B), vibrator (C) and the Irda window (D) are in place, according to the picture (1). Be careful not to damage the Coaxial Cable.</p> <p>Open the phone 90 degrees. Place the assembly into the Lower Rear Cover Assy and press gently it together (2).</p> <p>Use a pair of tweezers to place the Key board. Use the guiding pins, according to the arrow (3), to fix the Key board on the Key Foil Assy.</p>	  

	Step-by-Step Instructions	
9	<p>NOTE!</p> <p>Do not damage the Coax Cable or the Half-to-Half Assy.</p> <p>Assemble the Lower Front with the Lower Rear Cover.</p> <p>Start at the hinge area. Position the two black covers from the Lower Rear Cover together with the two black covers from the Lower Front Cover.</p> <p>Press at the hinge covers, according to the arrows, until the two parts snaps fits together. After that, continue to press together the Lower Front Cover onto the Lower Rear Cover.</p>	
10	<p>Partly close the phone so it has an angle of 90 degrees, according to the picture.</p> <p>NOTE!</p> <p>Do not damage the coax-cable and the Half-to-Half Assy.</p> <p>Assemble the Upper Rear Cover Assy. Start at the hinge area and gentle press into correct position.</p>	
11	<p>NOTE!</p> <p>Do not damage the coax-cable and the Half-to-Half Assy.</p> <p>Assemble the Upper Front Cover Assy. Start at the hinge area and snap fit it into the Upper Rear Cover.</p>	

	Step-by-Step Instructions	
12	<p>NOTE!</p> <p>Use new screws and new screw protection cover.</p> <p>Clean the surface before assemble the screw protection cover with Isopropyl alcohol.</p> <p>Assemble and tighten the two long screws (T6) at the hinge area, according to the arrows (1).</p> <p>Assemble the screw protection cover into the cavity.</p> <p>Turn the phone.</p> <p>Assemble and tighten the two short screws (T6) at the Antenna Flex Film, according to the arrows (2).</p>	
13	<p>Assemble the Upper rear lid assy. Press it into correct position.</p>	
14	<p>NOTE!</p> <p>Use new screws.</p> <p>Assemble and tighten two short screws at the hinge area, according to the left arrows.</p> <p>Assemble and tighten two long screws at the bottom, according to the right arrows.</p>	

	Step-by-Step Instructions	
15	<p>Assemble the battery (1).</p> <p>Assemble the Battery Cover Assy (2).</p>	 <p>1</p>  <p>2</p>

Replacement of Mechanical Parts

Equipment

- ESD-gloves (cotton gloves)
- ESD-wristband
- Dentist hook
- Blunt pair of tweezers
- Front opening tool NTZ 112
- Torque screwdriver, set t 15 Ncm \pm 6%. Bits Torx T6 NTZ 112 1052
- Bits Torx T5

Instruction

- Keep all contact surfaces clean of dirt and hand-grease

1.1 Main LCD

Replacement of *Main LCD*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.2 Sub LCD

Replacement of *Sub LCD*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.3 Battery Cover Assy

Replacement of *Battery Cover Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.4 Lower Rear Cover Assy

Replacement of *Lower Rear Cover Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.5 Lower Front Cover Assy

Replacement of *Lower Front Cover Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.6 Upper Rear Complete

Replacement of *Upper Rear Complete*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.7 Upper Front Complete

Replacement of *Upper Front Complete*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.8 Upper Rear Lid

Replacement of *Upper Rear Lid*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.9 Upper Rear Lid Assy

Replacement of *Upper Rear Lid Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.10 Upper Carrier Assy

Replacement of *Upper Carrier Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.11 Key Foil Assy

Replacement of *Upper Carrier Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.12 Keyboard

Replacement of *Upper Carrier Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.13 Coax Cable

Replacement of *Upper Carrier Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.14 Half to Half Flex Assy

Replacement of *Upper Carrier Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.15 Antenna Lid

See under 3.18 *Antenna Flex Assy* .

1.16 Adhesives

Replacement of all the *Adhesives*:

Clean the surface where the adhesive was assembled with Isopropyl Alcohol.

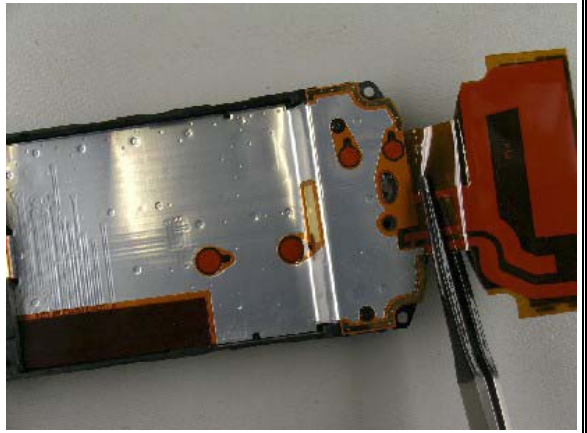
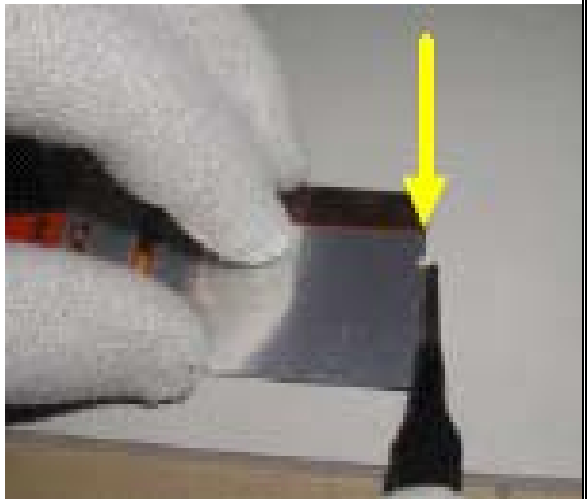
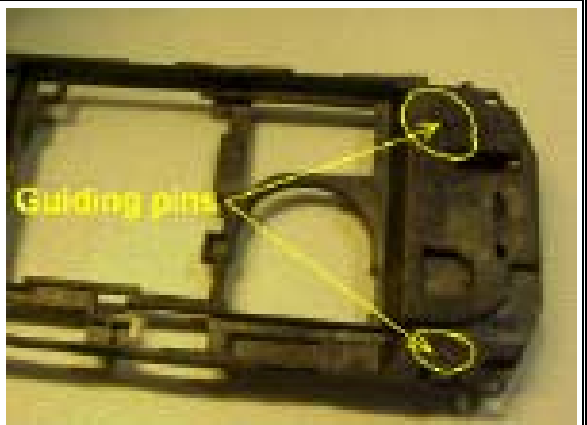
Use a dentist hook or a blunt pair of tweezers to remove the old used adhesive and replace it with a new one.


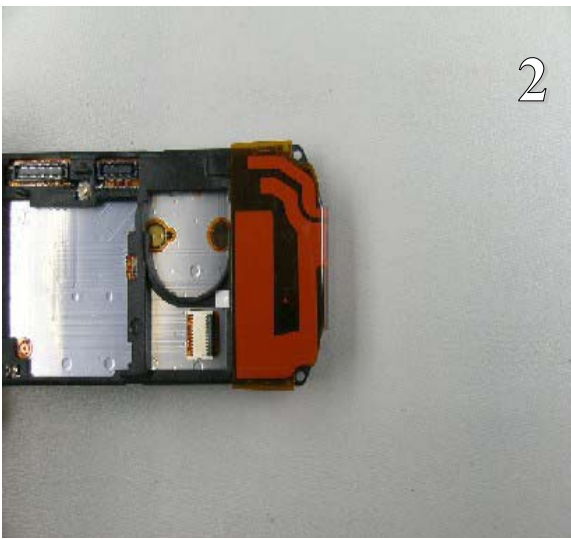
1.17 Screw protection Tape

Replacement of *Upper Carrier Assy*: Follow the Disassembly and the Reassembly headings and pay attention to the Note comments.

1.18 Antenna Flex Assy

Disassemble the phone as described in Disassembly

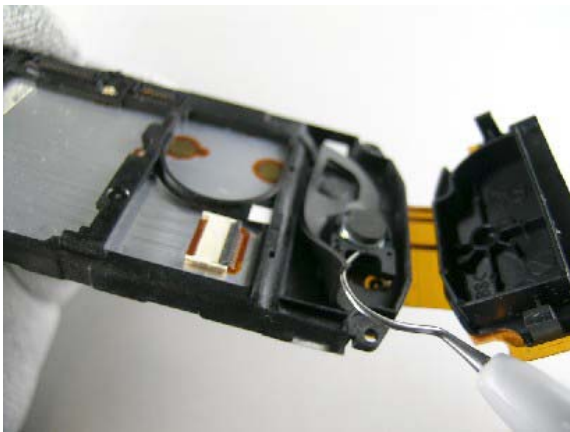

	Step-by-Step Instructions	
1	<p>Use a pair of tweezers to remove the old Antenna Flex Assy, according to the picture.</p> <p>Note!</p> <p>Do not reuse a Antenna Flex Assy.</p>	
2	<p>Note!</p> <p>Use a new Antenna Flex Assy.</p> <p>Place the Antenna Flex Assy on the table with the connectors facing downwards, according to the picture.</p> <p>Locate the protruding edge to the right on Antenna Flex Assy, according to the arrow.</p> <p>Use a pair of tweezers to bend the protruding edge 90 degrees upwards, according to the picture.</p>	
3	<p>NOTE!</p> <p>Do not scratch the Antenna Flex Assy.</p> <p>Clean the Antenna Lid surface with Isopropyl alcohol.</p> <p>NOTE!</p> <p>When assembling the Antenna Flex Film Assy use the guiding pins on the Upper Carrier Assy, according to the arrows.</p>	

	Step-by-Step Instructions	
4	<p>Note!</p> <p>Make sure that the Antenna Lid is mounted on the Upper Carrier Assy.</p> <p>Insert the Antenna Flex Film in the Upper Carrier Assy cavity. Turn the Upper Carrier Assy with the Antenna Flex Assy in it, so it has the same view as the picture (1).</p> <p>Remove the protective tape on the Antenna Flex Part. Fold it down and apply it onto the Antenna Lid, according to the picture (2).</p>	 

- Assemble the phone as described in Reassembly

1.19 Antenna lid gasket



- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the Antenna Gasket.</p> <p>Remove the old Antenna Gasket. Use a dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse a damaged Antenna Gasket.</p>	
2	<p>Clean the surface with Isopropyl Alcohol.</p> <p>Assemble the Antenna Gasket in the cavity of the Upper Carrier Assy. Use a pair of tweezers, according to the picture.</p>	

- Assemble the phone as described in Reassembly

1.20 External Antenna Plug

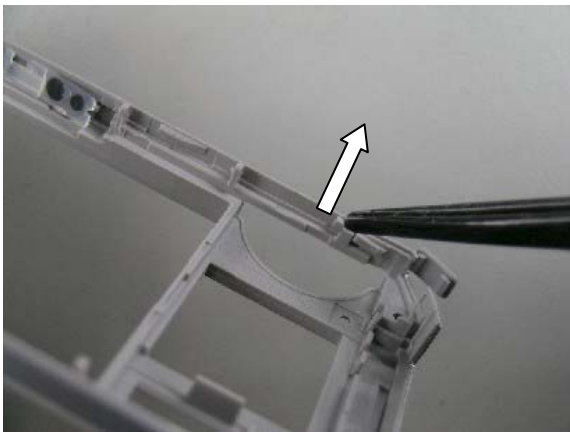
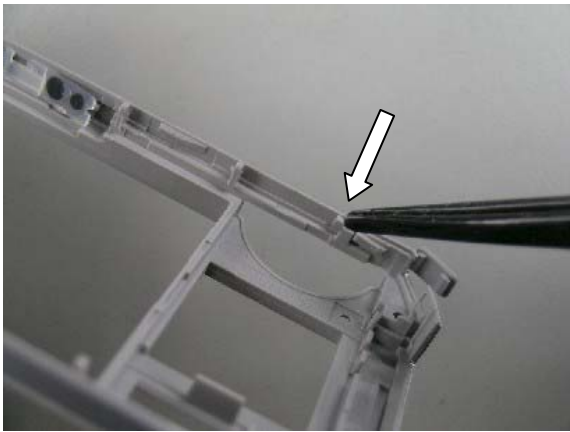
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the phone.</p> <p>Use a dentist hook to remove the External Antenna Plug, according to the picture.</p>	
2	<p>Use a pair of tweezers to assemble the External Antenna Plug, according to the picture.</p>	

- Assemble the phone as described in Assembly

1.21 USB cover


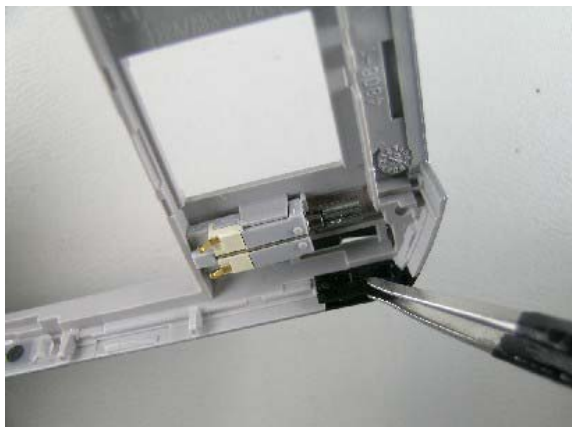
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>Use a pair of tweezers, according to the picture, to remove the USB Cover. Unhook the USB Cover, according to the arrow.</p> <p>Release and remove the USB Cover from the Lower Rear Cover Assy.</p>	
2	<p>Assemble the USB Cover in the cavity in the Lower Inside Cabinet.</p> <p>Use a pair of tweezers, according to the picture, to hook the USB Cover into the Lower Rear Cover Assy cavity, according to the arrow.</p>	

- Assemble the phone as described in Assembly

1.22 Irda window


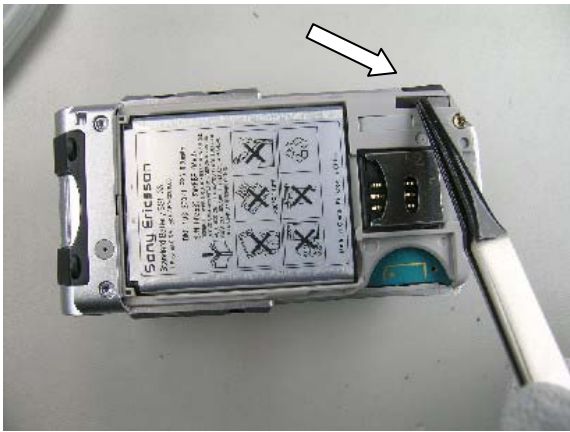
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the IrDA window.</p> <p>Remove the IrDA window with a dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse a damaged IrDA window.</p>	
2	<p>NOTE!</p> <p>Be careful not to damage the IrDA window.</p> <p>Make a visual control to be sure that the IrDA window is not damaged or scratched.</p> <p>Assemble the new IrDA window in the Lower Rear Cover with a pair of tweezers, according to the picture.</p>	

- Assemble the phone as described in Assembly

1.23 Battery Lock Spring

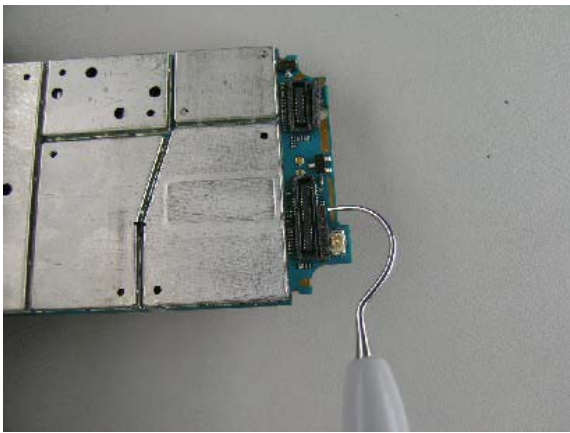
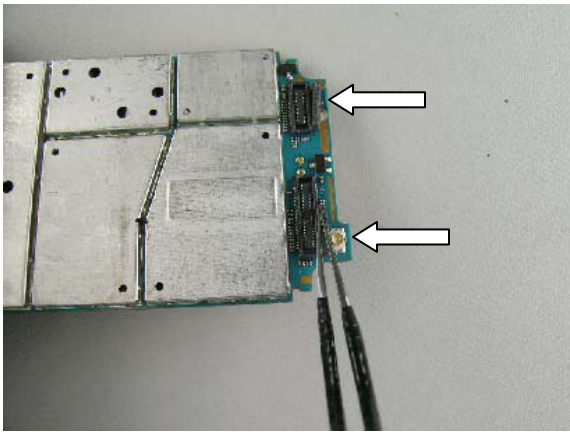
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the Lower Rear Cover Assy.</p> <p>Remove the Battery Lock Spring. Use a dentist hook, according to the picture.</p> <p>NOTE!</p> <p>Do not reuse a damaged Battery Lock Spring.</p>	
2	<p>NOTE!</p> <p>Be careful not to damage the Battery Lock Spring.</p> <p>Assemble the Battery Lock Spring into the Lower Rear Cover and place it into the cavity, according to arrow.</p> <p>Use a pair of tweezers, according to the picture.</p>	

- Assemble the phone as described in Assembly

1.24 Sealing Gasket

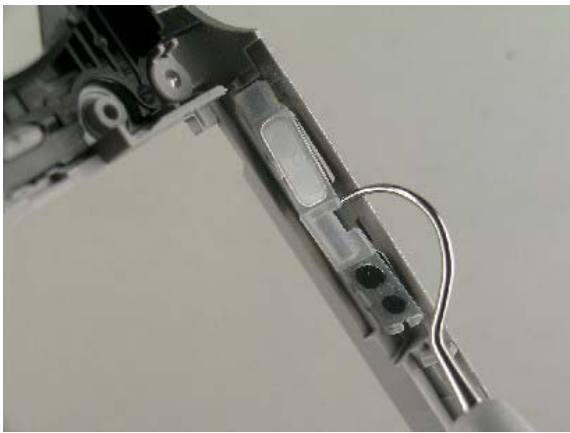
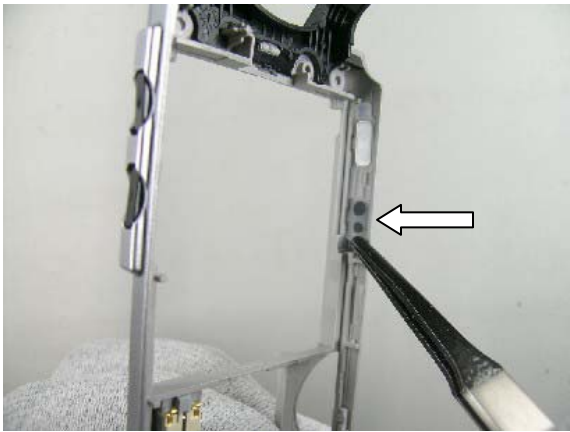
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the PCB or other components.</p> <p>Remove the Sealing Gaskets. Use a dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse a Sealing Gasket.</p>	
2	<p>Clean the surface of the PCB with Isopropyl Alcohol.</p> <p>Assemble the new sealing gaskets, according to the arrows. Use a pair of tweezers, according to the picture.</p>	

- Assemble the phone as described in Assembly

1.25 Camera Keys

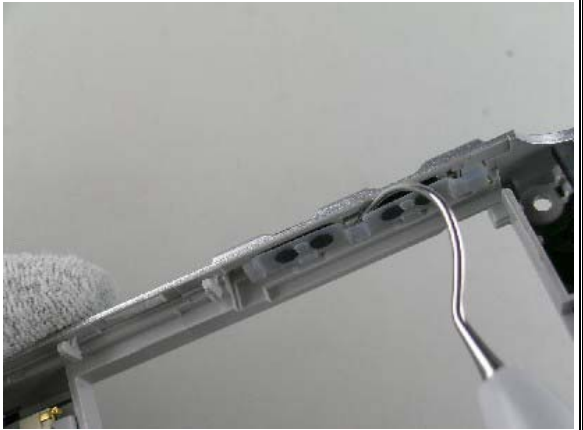
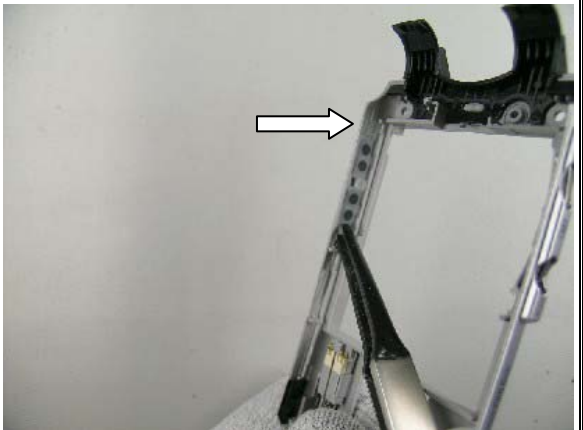
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the Lower Rear Cover Assy.</p> <p>Remove the Camera Keys. Use the dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse damaged Camera Keys.</p>	
2	<p>NOTE!</p> <p>Place in right direction. The black dots should be located on the Camera Led Bottom, according to the arrow.</p> <p>Place the Camera Keys in the Lower Rear Cover Assy. Press gently to secure the assembly.</p> <p>Use a pair of tweezers, according to the picture.</p>	

- Assemble the phone as described in Assembly

1.26 Volume Keys

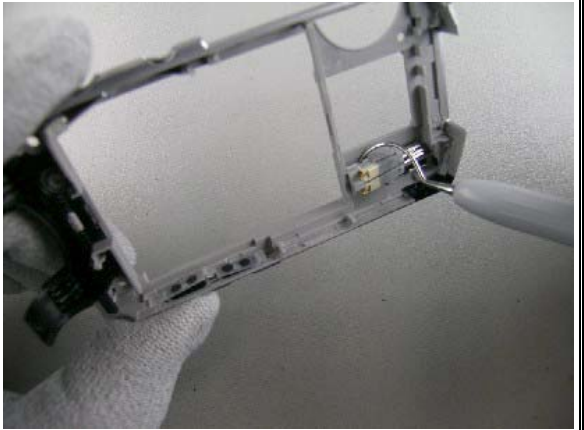
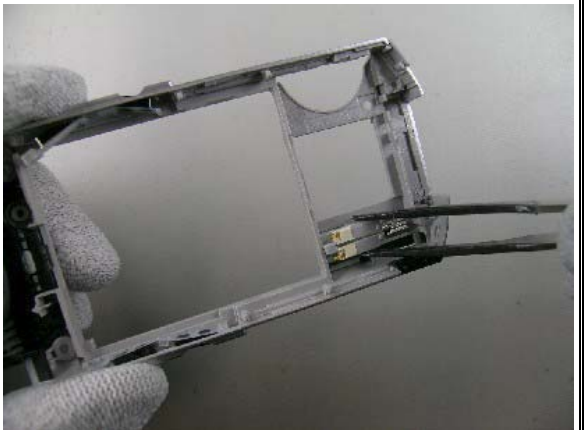
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the Lower Rear Cover Assy.</p> <p>Remove the Volume Keys. Use the dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse damaged Volume Keys.</p>	
2	<p>NOTE!</p> <p>Place in right direction. The Lower Rear Cover Assy has a guiding pin, which is located according to the arrow, and the Volume Keys has a guiding hole.</p> <p>Place the new volume keys in the Lower Rear Cover Assy and press the guiding pin into the Volume Keys guiding hole.</p> <p>Press slightly to secure the assembly.</p>	

- Assemble the phone as described in Assembly

1.27 Vibrator

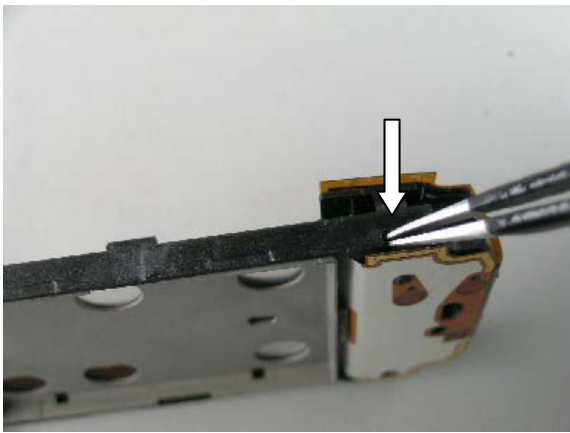
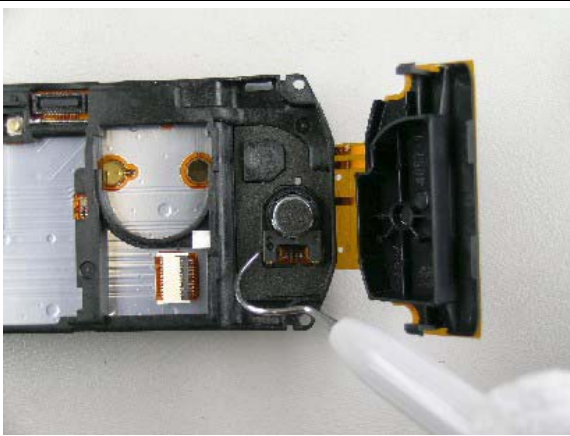
- Disassemble the phone as described in Disassembly


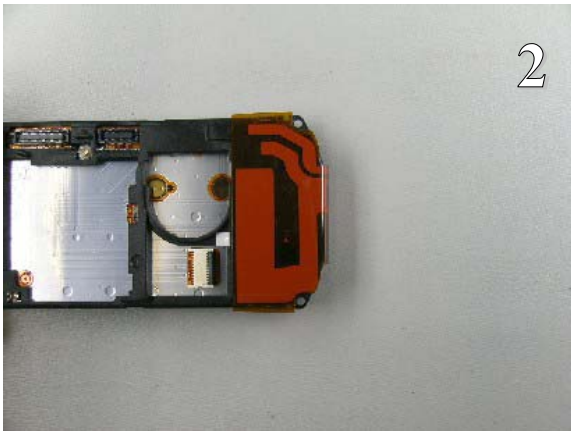
Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Do not lift the Vibrator in the flywheel.</p> <p>Be careful not to damage the Connector Pins or the Coating of the Vibrator.</p> <p>Use a dentist hook, according to the picture, or a pair of tweezers to remove the Vibrator .</p> <p>NOTE!</p> <p>Do not reuse a damaged Vibrator.</p>	
2	<p>NOTE!</p> <p>Be careful not to damage the Connector Pins or the Coating of the Vibrator.</p> <p>Place the new Vibrator in cavity of Lower Rear Cover Cavity. Use a pair of tweezers, according to the picture, to press it into the correct position.</p>	

- Assemble the phone as described in Assembly

1.28 Earspeaker

- Disassemble the phone as described in Disassembly

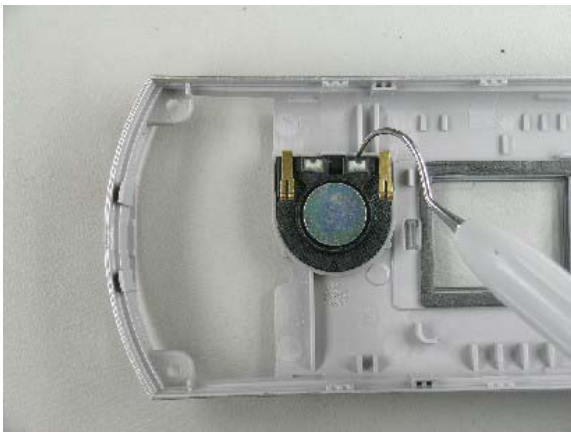

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the snap hooks of the Antenna Lid.</p> <p>There are two snap hooks. One is located on the left side of the Antenna Lid, according to the arrow, and the other one is located on the right side.</p> <p>Unhook the two snaps hooks of the Antenna Lid. Use a pair of tweezers, according to the picture.</p> <p>Gently fold up the Antenna Flex Film Assy.</p>	
2	<p>NOTE!</p> <p>Be careful not to damage Ear Speaker.</p> <p>Remove the Ear Speaker. Use the dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse a damaged Ear Speaker.</p>	

	Step-by-Step Instructions	
3	<p>Clean the cavity in the Upper Carrier Assy with Isopropyl Alcohol.</p> <p>Remove the protective tape of the Ear Speaker.</p> <p>Assemble the Ear Speaker in the cavity of the Upper Carrier Assy.</p> <p>Press gently with a pair of tweezers, according to the picture (1).</p> <p>Fold down the Antenna Lid, according to the picture (2).</p>	 

- Assemble the phone as described in Assembly

1.29 Loud Speaker


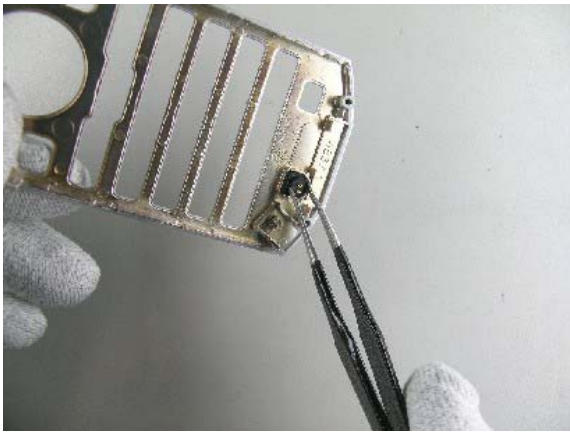
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage Loud Speaker</p> <p>Remove the Loud Speaker with a dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse a damaged Loud Speaker</p>	
2	<p>NOTE!</p> <p>Be careful not to damage the Connector springs on the Loud Speaker.</p> <p>Place the Speaker in the cavity of Upper Rear Cover Assy.</p> <p>Press gently down the Speaker with your fingers, according to the picture.</p>	

- Assemble the phone as described in Assembly

1.30 Microphone

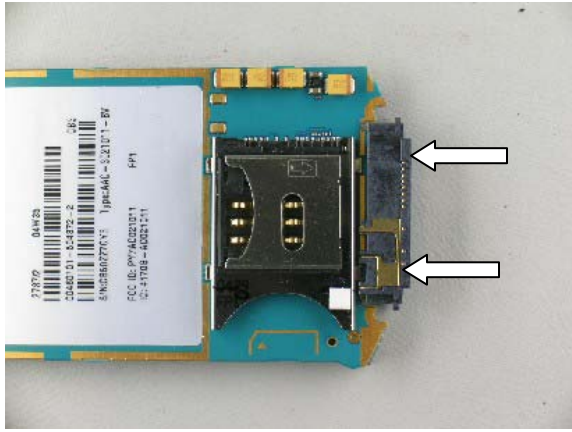
- Disassemble the phone as described in Disassembly

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to damage the Microphone or the Lower Front Assy.</p> <p>Remove the Microphone by using a dentist hook, according to the picture, or a pair of tweezers.</p> <p>NOTE!</p> <p>Do not reuse a damage Microphone.</p>	
2	<p>NOTE!</p> <p>Be careful not to damage the connecting pins</p> <p>Press down the Microphone with a pair of tweezers, according to picture.</p>	

- Assemble the phone as described in Assembly

1.31 System Connector

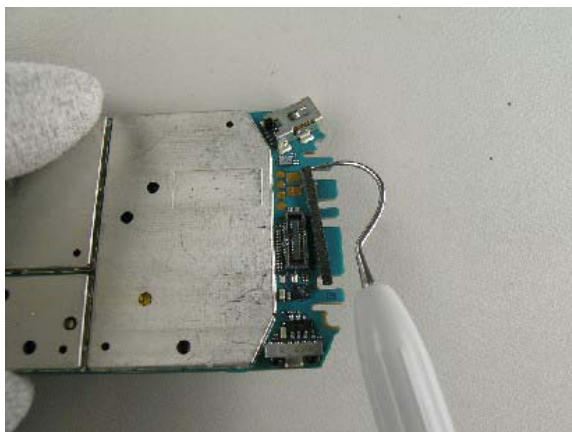
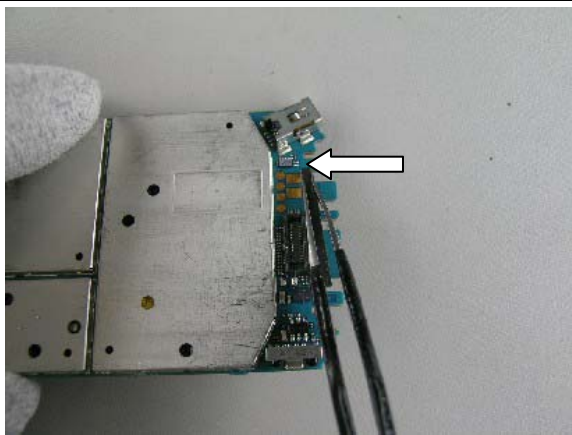
- Disassemble the phone as described in Disassembly

	Step-by-Step Instructions	
1	<p>Remove the System Connector. Use your fingers.</p> <p>Assemble the System Connector. Press it, according to the arrows, all the way into the PCB. Use your fingers.</p>	

- Assemble the phone as described in Assembly

1.32 Light Gasket

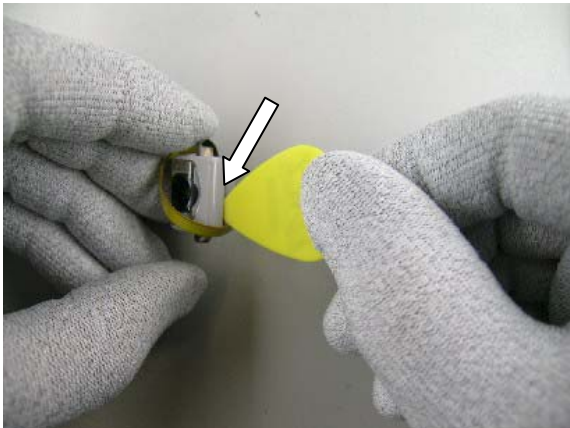
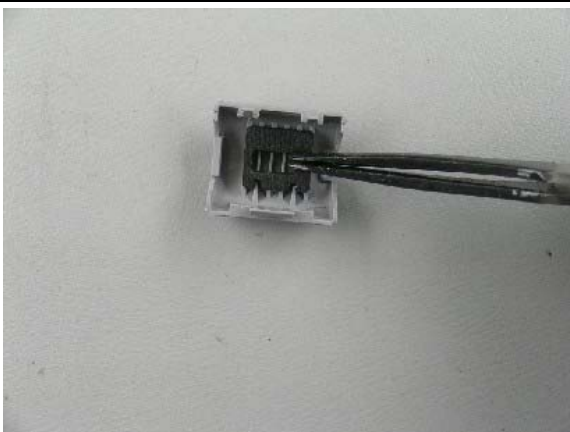

- Disassemble the phone as described in Disassembly

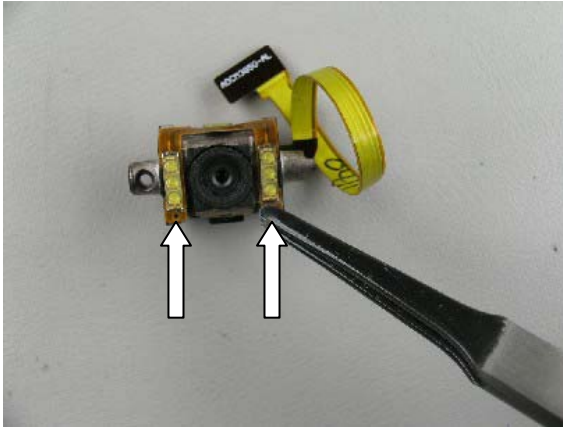
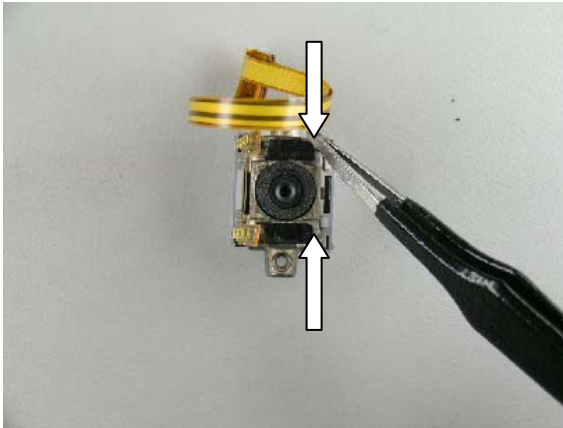
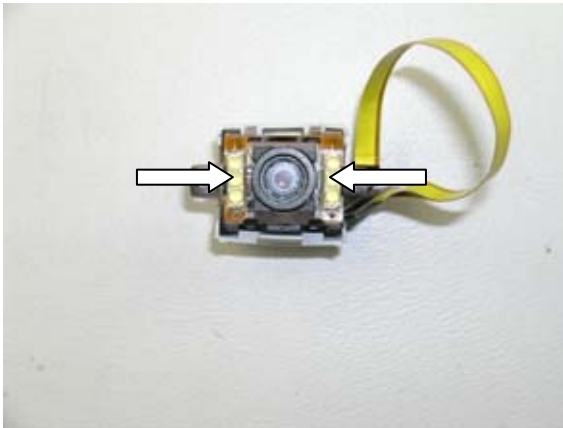
	Step-by-Step Instructions	
1	<p>NOTE!</p> <p>Be careful not to damage the PCB or other components.</p> <p>Remove the Light Gasket. Use a dentist hook, according to the picture.</p> <p>NOTE!</p> <p>Do not reuse a Light Gasket.</p>	
2	<p>Clean the PCB with Isopropyl Alcohol.</p> <p>NOTE!</p> <p>Be careful not to damage the Light Gasket, PCB or other components.</p> <p>Assemble the Light Gasket, according to the arrow. Use a pair of tweezers, according to the picture.</p>	



- Assemble the phone as described in Assembly

1.33 Camera

- Disassemble the phone as described in Disassembly

	Step-by-Step Instructions	
1	<p>NOTE!</p> <p>There is a small gap between the Camera Back Cover and the Camera Front Assy. This is where the Plectrum should be inserted, according to the arrow.</p> <p>Separate the Camera Back Cover and Camera Front Assy by insert the Plectrum in the gap, according to the arrow.</p> <p>NOTE!</p> <p>Do not reuse the Camera Back Cover or the Camera Front Assy.</p>	
2	<p>NOTE!</p> <p>All parts of the camera must be new parts.</p> <p>Use a pair of tweezers to apply the Camera Gasket on the Camera Back Cover, according to the picture.</p>	
3	<p>NOTE!</p> <p>All parts of the camera must be new parts.</p> <p>Use a pair of tweezers to assemble the magnet in the cavity of the Camera Carrier, according to the picture.</p>	


	Step-by-Step Instructions	
4	<p>NOTE!</p> <p>All parts of the camera must be new parts.</p> <p>Be careful not to damage the Camera Lens.</p> <p>There are two guiding pins on the Camera Carrier and there are two guiding holes in the Flex Film that carries the LED's. They are located according to the arrows.</p> <p>Insert the Camera Module into the Camera Carrier.</p> <p>Use a pair of tweezers to fold down, and apply, the Flex Film that carries the LED's over the Camera Carrier, according to the picture. Match the guiding pins of the Camera Carrier with the guiding holes of the Flex Film that carries the LED's.</p>	
5	<p>NOTE!</p> <p>All parts of the camera must be new parts.</p> <p>The Conductive Tape's has a bevelled edges and the Camera Carrier has guiding pins. They are located according to the arrows.</p> <p>Clean the cavity in the top of the Camera Carrier with Isopropyl Alcohol.</p> <p>Use a pair of tweezers, according to the picture, to apply the two Conductive Tapes on the top of the Camera Carrier.</p> <p>Match the bevelled edge of the Conductive Tape with the guiding pin of the Camera Carrier.</p>	
6	<p>NOTE!</p> <p>All parts of the camera must be new parts.</p> <p>Be careful not to damage the Flex Film.</p> <p>Use your fingers to snap the Camera Module into the Camera Back Cover. Press according to the arrows.</p> <p>A click sound will confirm that the covers are correct mounted.</p> <p>NOTE!</p> <p>Confirm that the Magnet on the Camera Carrier is still in the correct position.</p>	

Step-by-Step Instructions		
7	<p>NOTE!</p> <p>All parts of the camera must be new parts.</p> <p>Be careful not to damage the Camera Lens.</p> <p>Clean the Camera Lens with Isopropyl Alcohol.</p> <p>Apply the Light Gasket with a pair of tweezers, according to the picture, on the Camera Lens edge.</p>	
8	<p>NOTE!</p> <p>Be careful not to damage the Camera Flex Film.</p> <p>The Camera Back Cover and the Camera Front Assy must be assembled in straight Z-direction, according to the picture. This is important because the snap hooks of the Camera Back Cover are sensitive and can easily be damaged. Do not use damaged covers.</p> <p>Snap the Front Cover Assy over the Camera Back Cover. A click sound will confirm that the covers are correct mounted.</p>	

- Assemble the phone as described in Assembly

1.34 ESD Ground Pad, Cabinet


- Disassemble the phone as described in Disassembly

	Step-by-Step Instructions	
1	<p>Use a pair of tweezers to remove the ESD Ground Pad from the Lower Front Cover.</p> <p>NOTE!</p> <p>Do not reuse a ESD Ground Pad.</p> <p>Clean the surface of the Lower Front Cover with Isoproyl Alcohol.</p> <p>Assemble the ESD Ground Pad on the Lower Front Cover, according to the arrow.</p>	

- Assemble the phone as described in Assembly

1.35 Dust Gasket Lower Front


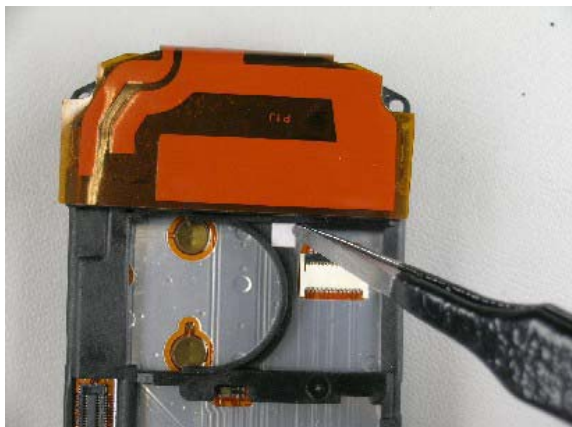
- Disassemble the phone as described in Disassembly

	Step-by-Step Instructions	
1	<p>Use a pair of tweezers to remove the Dust Gasket Lower Front from the Lower Front Cover.</p> <p>NOTE!</p> <p>Do not reuse a Dust Gasket Lower Front.</p> <p>Clean the surface of the Lower Front Cover with Isoproyl Alcohol.</p> <p>Assemble the Dust Gasket Lower Front on the Lower Front Cover, according to the arrow.</p>	

- Assemble the phone as described in Assembly

1.36 Water Indicator

- Disassemble the phone as described in Disassembly

	Step-by-Step Instructions	
1	<p>NOTE!</p> <p>Be careful not to damage the Upper Carrier Assy or the Antenna Flex Film.</p> <p>Use a dentist hook, according to the picture, to remove the Water Indicator.</p> <p>NOTE!</p> <p>Do not reuse a Water Indicator.</p>	
2	<p>Clean the surface of the Upper Carrier Assy with Isopropyl Alcohol.</p> <p>Use a pair of tweezers, according to the picture, to apply the Water Indicator on the Upper Carrier Assy.</p>	

Label

Tools

- Hot air flow solder station
- Tweezers
- Zebra printer and computer

Instruction

This instruction should be used when you will replace a label.

1. Read the old label and write the information into the LabelMake II program.
2. Heat up the label with a hot air flow solder station.
3. Carefully remove the label. Do not scratch the frame. Clean the surface with Isopropyl alcohol.

NOTE! Only one label is allowed on the frame.

4. Check that the right label format is loaded in the Zebra printer. See Part List for correct part number.
5. Write a new label by using the LabelMake II program. Confirm that the printing is ok.
6. Apply the new label into the frame, according to figure 4.1. Assure that label is placed in the correct position.



figure 4.1

Revision History

Rev.	Date	Changes / Comments
A	2004-11-04	First Release
B	2004-12-13	Due to system problem
C	2004-12-15	Due to system problem
D	2004-12-20	Corrected wrong R-state references
E	2005-02-11	Updated Chapter Disassembly
F	2005-04-21	Z800i added
G	2005-05-02	Added ESD Tape chapter Re-Assembly
H	2005-11-17	Updated Step 5 in Reassembly