



Working Instruction, Mechanical

Applicable for S700i and S700c

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1 Disassembly

Tools

- Torque screwdriver, set to 9, 14, 17 and 20 Ncm \pm 6%. Bits NTZ 112 1052
- Flex film assembly tool NTZ 112 521
- Blunt pair of tweezers, pair of tweezers
- Front opening tool NTZ 112 302/2
- Dentist hook
- Slot screwdriver

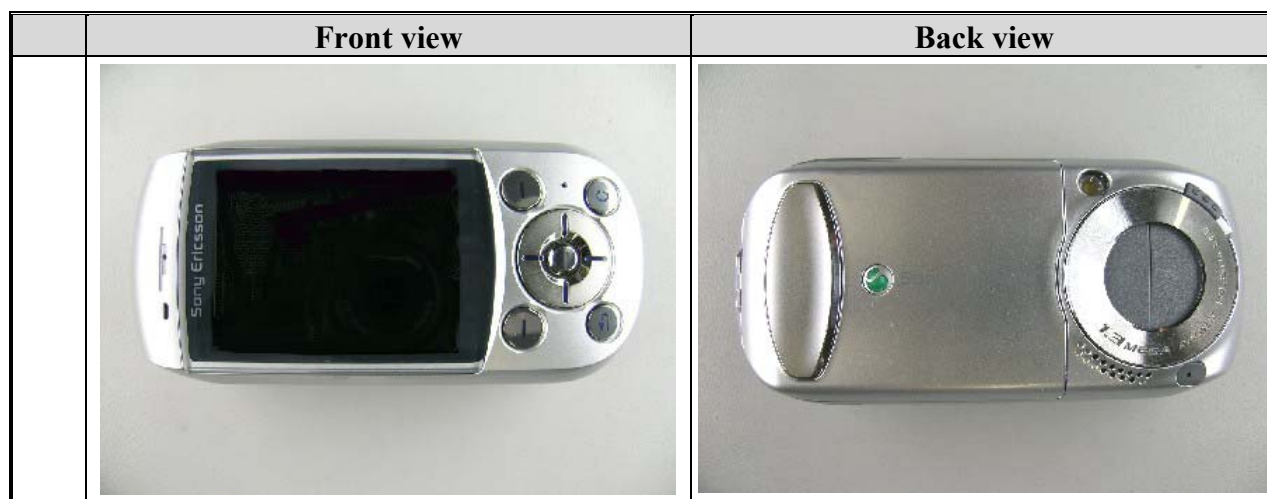
Equipment


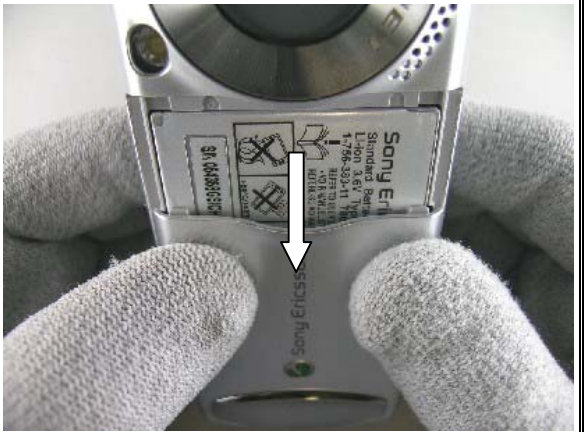

- ESD-gloves (cotton gloves)
- ESD-wristband




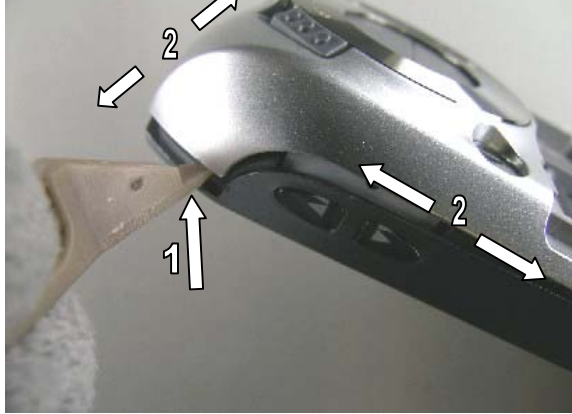
Instruction


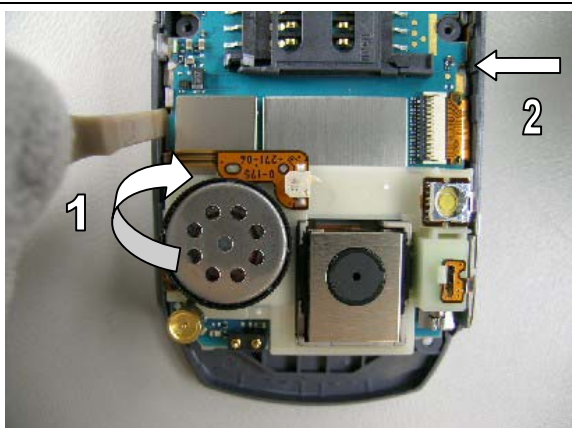
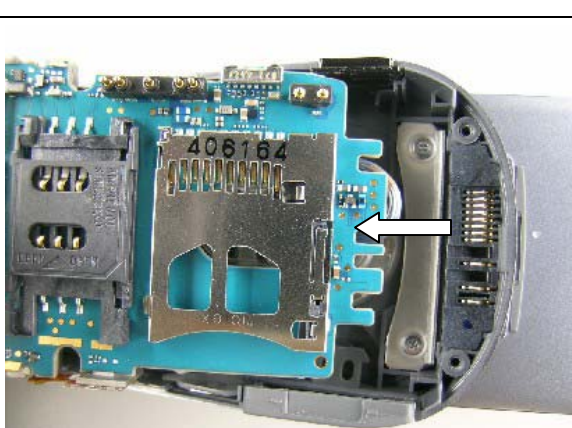
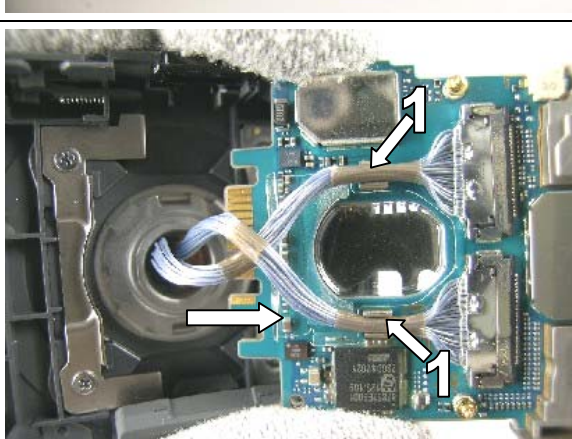
- Keep all contact surfaces clean of dirt and hand-grease

Phone views

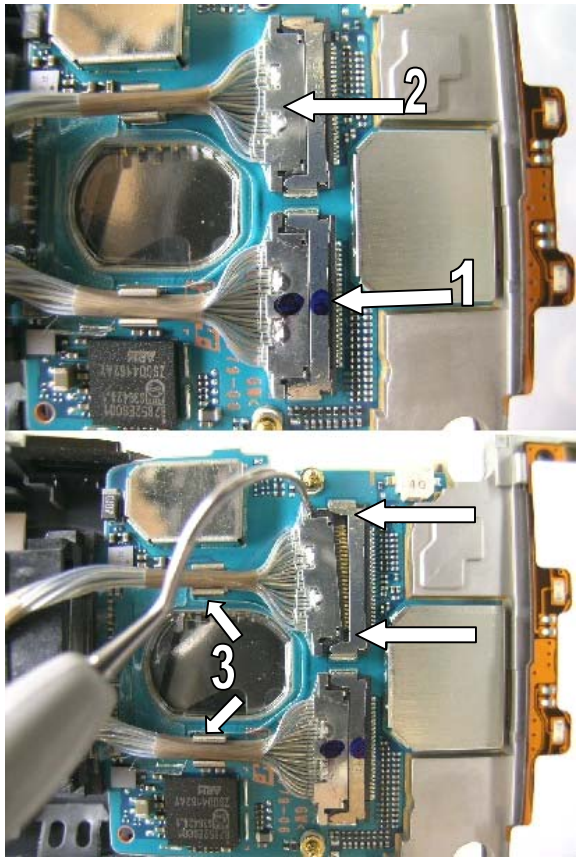



	Step-by-Step Instructions	
1	<p>NOTE! Turn off the phone.</p> <p>If there is a memory stick duo inside the phone – Please remove the MS before you start to disassemble.</p> <p>Remove the battery cover with your hand. Force the battery cover to slide from its mounted position towards the end of the phone.</p>	
2	<p>Slide down the battery cover completely and remove it.</p>	
3	<p>Remove the battery from the phone with your fingers. Start like the picture show.</p> <p>NOTE! Open out the phone 180°</p>	

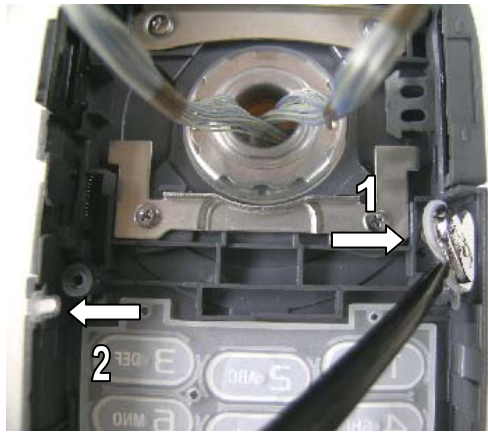



	Step-by-Step Instructions	
4	<p>NOTE! Be careful with the dentist hook. It's easy to scratch the frame.</p> <p>Use the dentist hook to gently bend/remove the panel key front.</p> <p>NOTE! If necessary – clean the surface of the panel key front cavity with Isopropyl alcohol.</p>	
5	<p>Remove the two case key front screws at the bottom of the phone.</p> <p>NOTE! 1. Removed screws cannot be reused and must be scrapped. 2. Turn the phone around.</p>	
6	<p>Remove the four case key rear screws .</p> <p>NOTE! Removed screws cannot be reused and must be scrapped.</p>	
7	<p>NOTE! Be careful not to scratch the phone with the opening tool.</p> <p>Open the phone with the front opening tool Begin as the picture shows (1).</p> <p>Then gently move the tool along the gap both ways until the case key rear is loose on all sides (2).</p> <p>If necessary do the same thing on the other side.</p>	

	Step-by-Step Instructions	
8	Open the lower cabinet cautiously.	
9	<p>NOTE! Be careful not to damage the circuit board with the opening tool.</p> <p>With the front opening tool, release catches that holds the main PBA in the case key front. Start like the picture show (1).</p> <p>If necessary do the same thing on the other side (2). (make sure to avoid prying on the flex films)</p> <p>NOTE! Sometimes it helps if you bend the frame a little side to side.</p>	
10	<p>To remove the main PBA, lift the camera end of the circuit board away from the case key front as high as it will easily move.</p> <p>With the PBA in the lifted position, wiggle the board back and forth while pulling the board away from the system connector.</p> <p>NOTE! Don't bend the circuit board to much upwards.</p>	
11	<p>NOTE! Always be careful with the "two main cables" (Harness) (1).</p> <p>Open out the main PBA from the frame</p> <p>NOTE! VERY IMPORTANT! Remember how the two main cables (Harness) are assembled "with a twist/crossover" to the main PBA</p>	

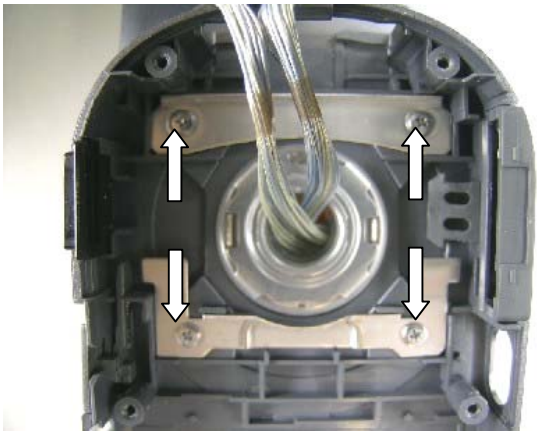
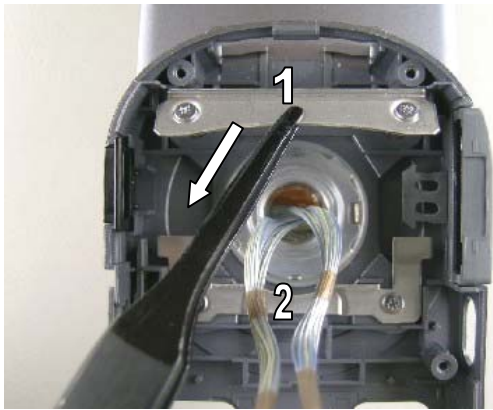

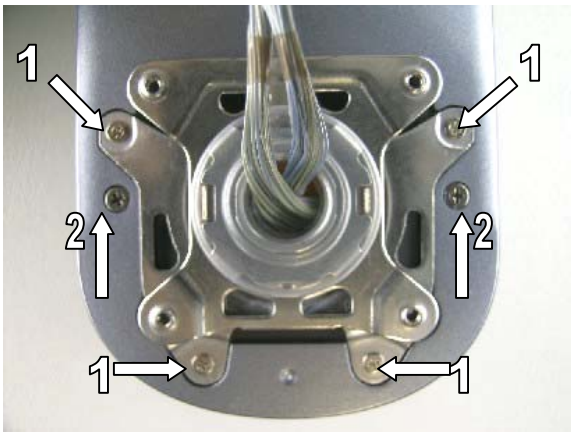



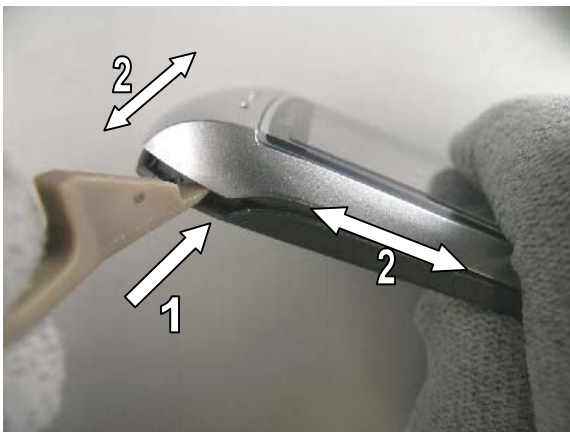
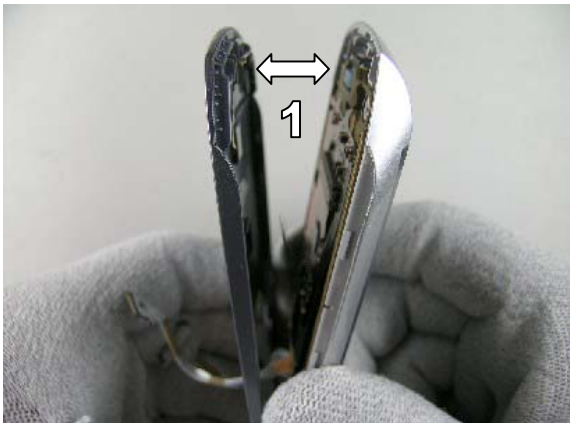
	Step-by-Step Instructions	
12	<p>Mark one of the contacts with a colour marker (1). Otherwise it's easy to mix up the cables when reassembling the phone.</p> <p>NOTE! Notice the two small “knobs” (2) on the UPPER side on the connector – they must be directed like the pictures shows when they are reassembled.</p> <p>NOTE! Remove the two cables from their clips (3).</p> <p>NOTE! Be careful not to damage the two cable connections when unplugging the connections using the dentist hook.</p> <p>NOTE! Do not pull on the mass of cables that make up the cable assembly.</p> <p>At one of the cable/board connections, use the dentist hook to unplug the cable connection from the board. There are two locations that the connector must be alternately pulled at to free the cable from its mating board connector. The location at the two parallel arrows, are the two pulling locations. The cable should be pulled towards the end of the circuit board in which the system connector mounts.</p> <p>Remove both connectors.</p>	
13	<p>Case key rear and circuit board disassembled.</p>	

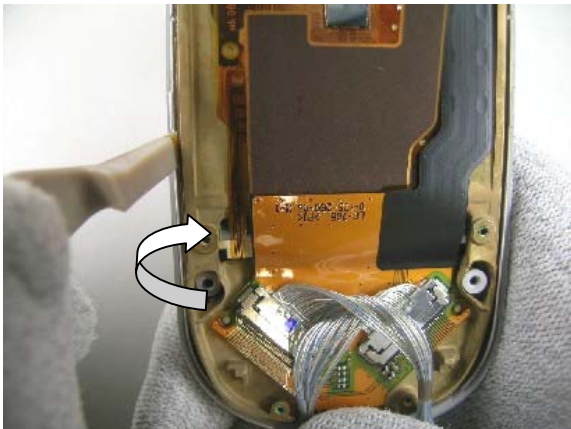
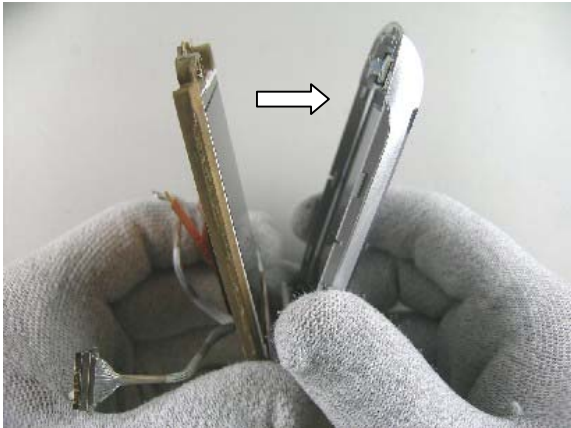



	Step-by-Step Instructions	
14	Sometimes the camera button (1) and the light guide (2) falls out after the main PBA is removed. If necessary remove the button and the light guide with a blunt pair of tweezers.	
15	Remove the button key by hand or with a blunt pair of tweezers.	
16	NOTE! Be careful with the dentist hook. It's easy to scratch the frame. Use the dentist hook to gently bend/remove the panel LCD rear from the case LCD rear.	
17	Remove the two case LCD rear screws at the bottom of the phone. NOTE! Removed screws cannot be reused and must be scrapped.	



	Step-by-Step Instructions	
18	<p>Remove the four hinge frame screws at the bottom of the case key front.</p> <p>NOTE! Keep track of the different sizes of screws used inside the phone.</p> <p>NOTE! The four removed screws cannot be reused.</p>	
19	<p>Remove the upper (1) and lower (2) hinge frame holdings with the flex film assembly tool.</p>	
20	<p>NOTE! Be careful not to damage the two cable assemblies when removing the inner half of the case key front.</p> <p>Remove the case key front.</p>	
21	<p>Remove the four hinge screws (1), then the two case LCD rear screws (2).</p> <p>NOTE! Keep track of the different sizes of the screws.</p> <p>Removed screws cannot be reused and must be scrapped.</p>	

	Step-by-Step Instructions	
22	<p>NOTE! Be careful not to damage the two main cables when folding them.</p> <p>Lift the hinge assembly from the display case and work the end of each cable assembly one at a time through the hole in the hinge assembly. (1).</p> <p>The Bush Hinge , transparent, (2) may fall off from the hingemechanism – put it back on the hinge-mechanism so you can keep a track on it.</p>	
23	<p>NOTE! Be careful not to scratch the phone with the opening tool.</p> <p>Open the LCD case with the opening tool. Begin like the pictures show (1).</p> <p>Then gently move the tool along the gap both ways until the front is loose on all sides (2).</p> <p>If necessary do the same thing on the other side.</p>	
24	<p>NOTE! Be careful not to damage the case key front and the case LCD rear.</p> <p>Open the upper cabinet with caution.</p> <p>Remove the case LCD front from the case LCD rear (1).</p>	

	Step-by-Step Instructions	
25	<p>NOTE! 1. Be careful not to damage the LCD unit with the opening tool. 2. When handling the main LCD be careful and do not ever touch the display glass.</p> <p>With the front opening tool, gently release the display carrier from the Case key front. If necessary do the same thing on the other side.</p> <p>NOTE! Sometimes it helps if you bend the frame a little side to side.</p>	
26	<p>Remove the the LCD unit (with the frame) from the case key front.</p>	
27	<p>Case LCD front and LCD unit disassembled.</p>	

2 Reassembly

Tools



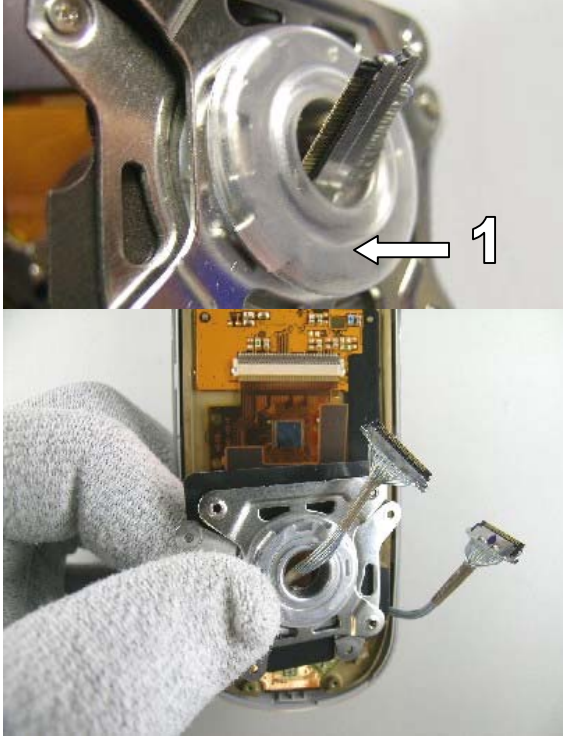
- Torque screwdriver, set to 9, 14, 17 and 20 Ncm \pm 6%. Bits NTZ 112 1052
- Flex film assembly tool NTZ 112 521
- Blunt pair of tweezers, pair of tweezers
- Front opening tool NTZ 112 302/2
- Dentist hook

Equipment

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

Instruction

Keep all contact surfaces clean of dirt and hand-grease


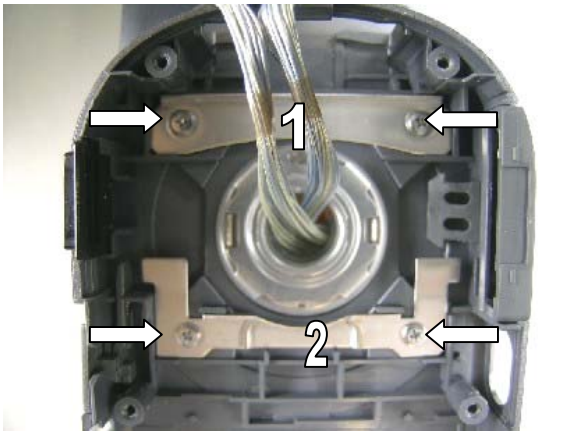
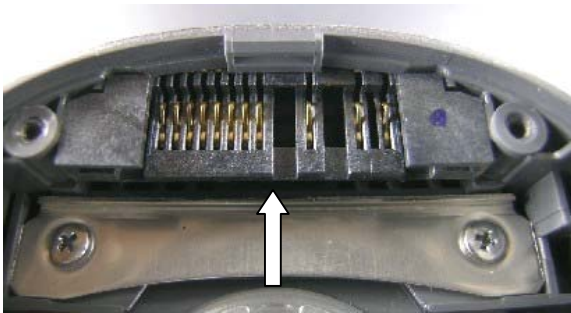
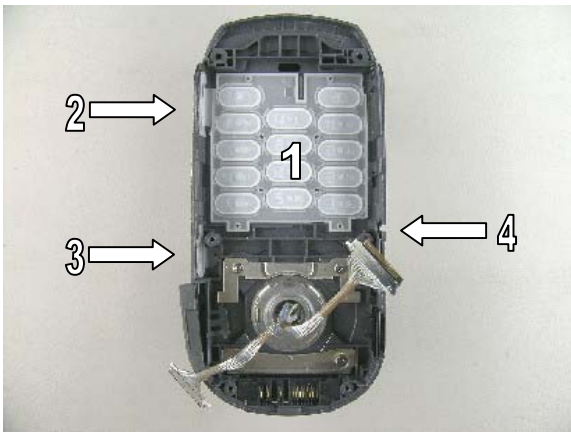
	Step-by-Step Instructions	
1	<p>Start like this when reassembling the upper cabinet.</p> <p>NOTE! Make sure that all of the LCD buttons (1) are correctly assembled.</p>	
2	<p>NOTE! Make sure that the front glass is clean. Use air blow equipment if necessary.</p> <p>Place the LCD unit in the case LCD front by hand</p> <p>NOTE! If you are going to assemble a new front: Don't forget to remove the protection foil inside the front, with a pair of tweezers. Be careful not to scratch the glass with the tweezers.</p>	
3	<p>NOTE! Be careful not to damage the two main cables when sliding them through the hinge mechanism.</p> <p>NOTE! Don't forget the bush hinge (1)</p> <p>Gently fold each end of the cables until they can slide through the center hole of the hingemechanism.</p>	



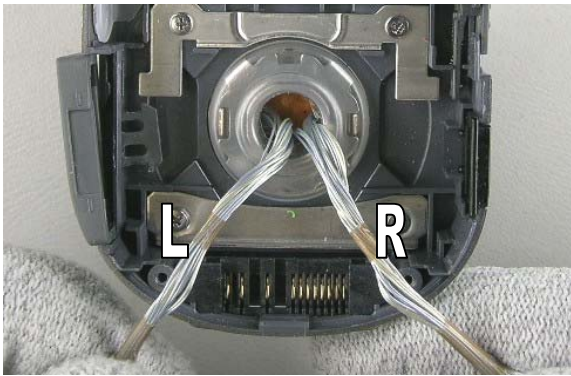
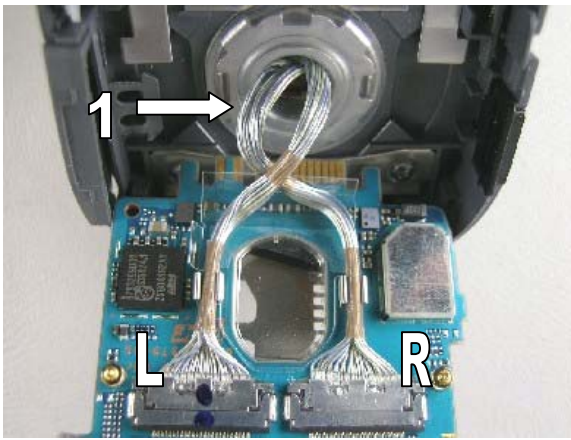
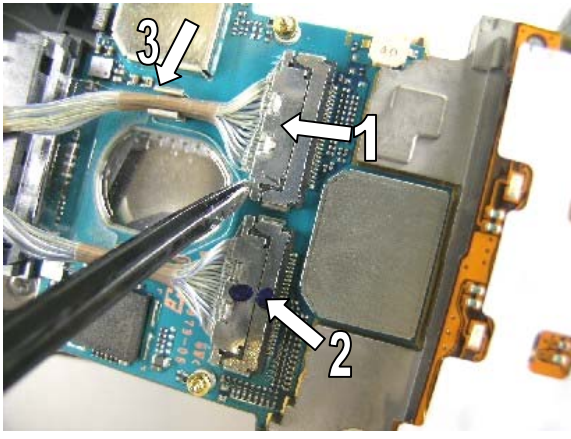
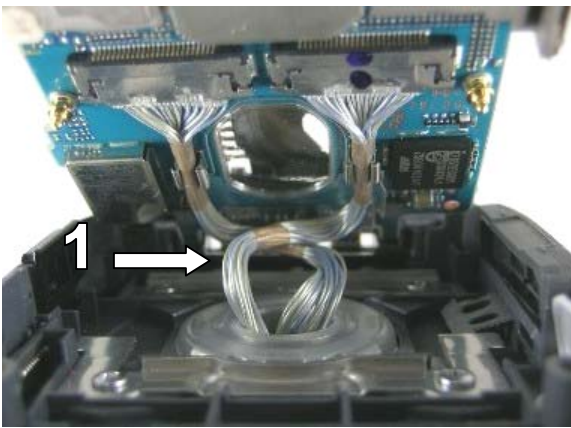
	Step-by-Step Instructions	
4	<p>Slide on the case LCD rear over the cables, hinge and on to the case LCD front and snap them together.</p> <p>NOTE! Check so the lower cabinet is properly assembled – there should be no gaps along the sides.</p>	
5	<p>NOTE! Use 9 Ncm of torque for the LCD hinge screws (1, 2, 3, and 4). Use 17 Ncm of torque for the LCD cabinet screws (5, 6).</p> <p>Assemble six new screws. Tighten the upper cabinet screws according to screw sequence shown in the picture.</p>	
6	<p>NOTE! Use 17 Ncm of torque for the screws.</p> <p>Assemble two new screws in the case LCD rear cavity.</p>	
7	<p>NOTE! If necessary – clean the surface of the panel LCD rear cavity with Isopropyl alcohol.</p> <p>Assemble the panel LCD rear (comes with a new adhesive) with your fingers.</p> <p>Upper cabinet resassembled.</p>	

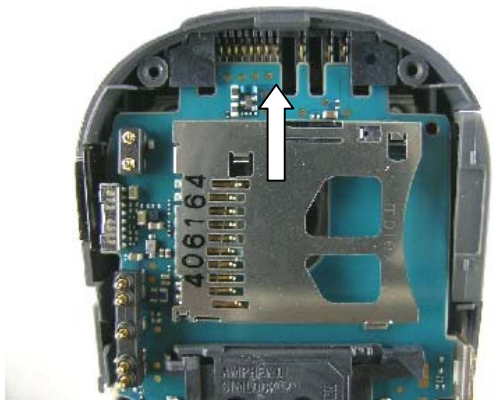
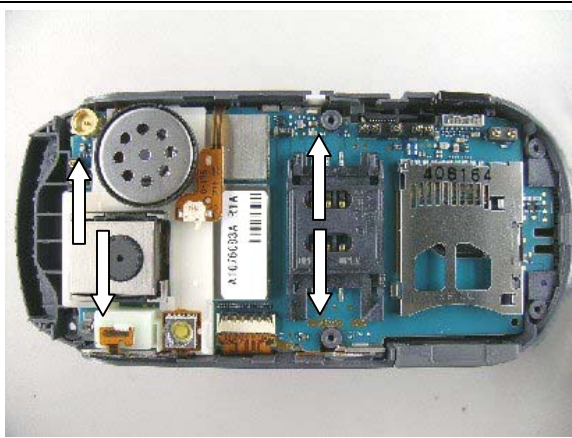

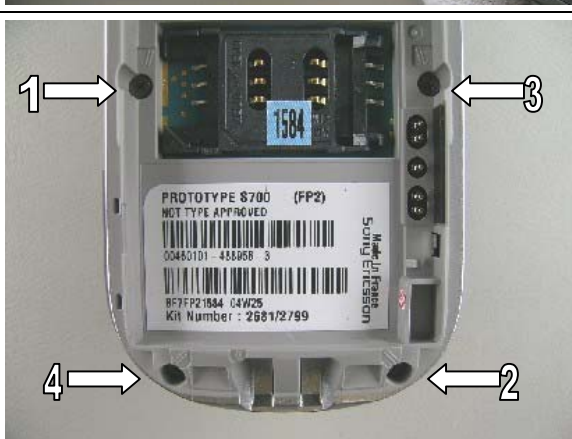









	Step-by-Step Instructions	
8	<p>NOTE! Be careful not to damage the two cables.</p> <p>Slide both cables through the hole in the case key front.</p>	
9	<p>NOTE! Use 14 Ncm of torque for the key hinge screws.</p> <p>Assemble the two upper (1) and lower (2) hinge frame holdings together with four new screws</p>	
10	<p>NOTE! If you have assembled a new case key front doesn't forget to assemble a new system connector.</p> <p>The picture shows a correctly mounted system connector.</p>	
11	<p>NOTE! Close the phone together 180°.</p> <p>If necessary, place a new keyboard inside the case key front by hand (1).</p> <p>NOTE! Make sure that the keyboard (1), volume keys (2), kamera key (3) and the light guide (4) are assembled and in the right position.</p>	



	Step-by-Step Instructions	
12	<p>NOTE! When reassembling the two main cables (harness) to the main PBA start like the picture shows.</p> <p>The left cable (L) should go to the left connector on the PBA (See picture 13).</p> <p>The right cable (R) should go to the right connector on the PBA (See picture 13).</p>	
13	<p>Place the main PBA against the case key front like the picture shows; start to connect the two cables to respectively left and right ZIF connector.</p> <p>Take notice of the “crossover” (1).</p>	
14	<p>NOTE! 1. Be careful not to damage the two main cables and the connectors with the tweezers.</p> <p>2. Notice on the two small “knobs” (1) on the UPPER side on the connector – they must be directed like the pictures shows when they are reassembled.</p> <p>Assemble the two main cables with a blunt pair of tweezers. Use your markings so they don’t get mixed up (2).</p> <p>Gently assemble the two cables in their clips (3).</p>	
15	<p>NOTE! After reassembling of the two ZIF-connectors it should look like this “with a crossover” (1) before you completely fold down the main PBA towards the case key front.</p> <p>Then carefully fold the main PBA over towards the case key front and start to slide it into the system connector.</p>	

	Step-by-Step Instructions	
16	<p>NOTE! Before you slide the main PBA to the bottom of the system connector, check all flexfilm connections, key buttons and the two main cables are folded correctly so nothing get squeezed or damaged between the PBA and the case key front frame.</p> <p>Slide the main PBA into the system connector.</p>	
17	<p>Place the main PBA completely into the case key front.</p> <p>Press gently on the PBA edges with your hand (by the arrows).</p> <p>NOTE! Make sure that the main PBA is mounted correctly in the case key front.</p>	
18	<p>NOTE! Open out the phone 180°.</p> <p>Assemble the case key rear over the case key front and gently snap them together.</p> <p>NOTE! Check so the lower cabinet is properly assembled – there should be no gaps along the sides.</p>	
19	<p>NOTE! Use 20 Ncm of torque for the case key rear screws.</p> <p>Assemble four new screws. Tighten the case key rear screws according to screw sequence shown in the picture.</p> <p>Turn the phone around.</p>	

	Step-by-Step Instructions	
20	<p>NOTE! Use 20 Ncm of torque for the case key front screws.</p> <p>Assemble two new screws in the case key front cavity.</p>	
21	<p>NOTE! If necessary – clean the surface of the case key front cavity with Isopropyl alcohol.</p> <p>Assemble the panel key front (comes with a new adhesive) with your fingers.</p>	
22	Place the battery like the picture show.	
23	Slide on the battery cover like the picture show.	

	Step-by-Step Instructions	
24	Upper and lower cabinet unit reassembled.	

3 Replacement of Mechanical Parts

Equipment

- ESD-gloves (cotton gloves)
- ESD-wristband
- Dentist hook
- Slot screwdriver
- Blunt pair of tweezers
- Flex film assembly tool NTZ 112 521
- Front opening tool NTZ 112 302/2
- Torque screwdriver, set to 9, 14, 17 and 20 Ncm \pm 6%. Bits NTZ 112 1052

Instruction

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

3.1 Case key rear

Replacement of *case key rear*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.2 Case key front

Replacement of *case key front*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.3 Case LCD front

Replacement of the *case LCD front*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.4 Case LCD rear

Replacement of the *case LCD rear*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.5 Hinge and Bush hinge

Replacement of the *hinge and bush hinge*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.6 Harness (Main cables)

Replacement of the *harness (main cables)*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.7 Battery cover assembly

Replacement of the *battery cover assembly*: Check Disassembly and Reassembly headings and draw attention to the Note comment.

3.8 Panel key front

Replacement of the *panel key front*: Check Disassembly and Reassembly headings and draw attention to the Note comment.

3.9 Panel LCD rear

Replacement of the *panel LCD rear*: Check Disassembly and Reassembly headings and draw attention to the Note comment.


3.10 Adhesives

NOTE!

If necessary – clean the surface where the adhesive was assembled with Isopropyl alcohol.

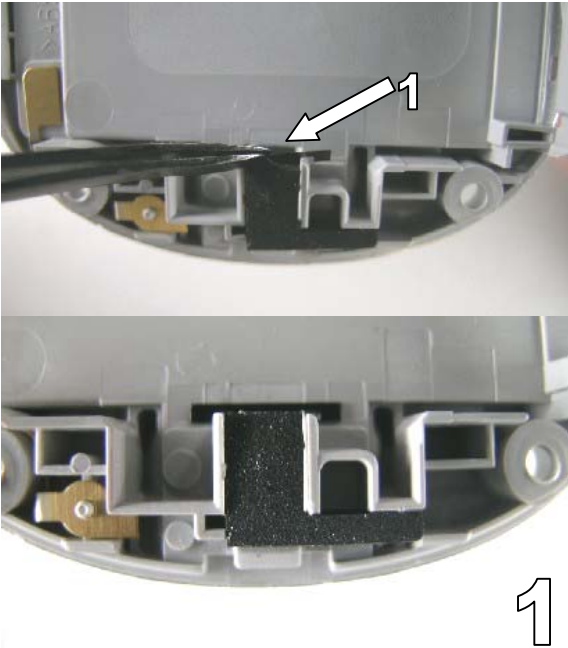
Replacement of all the *Adhesives*. Use a dentist hook or a blunt pair of tweezers to remove the old used adhesive and replace it with a new one.

3.11 Cover RF

	Step-by-Step Instructions	
1	<p>Remove the external antenna plug with the dentist hook.</p> <p>Assemble a new external antenna plug with your fingers.</p>	

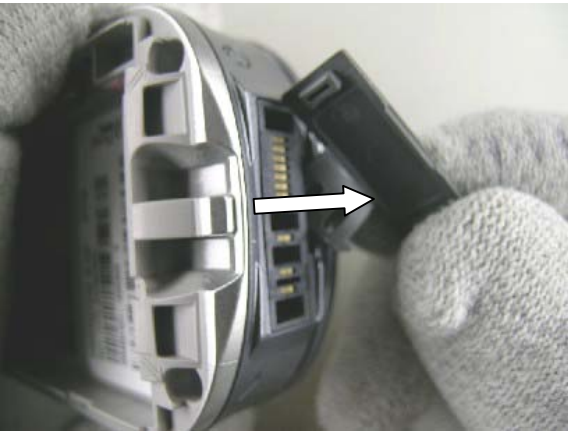
3.12 Sheet absorption A

- Disassemble the phone as described in *1 Disassembly*.


Step-by-Step Instructions		
1	<p>Remove the sheet absorption A with a blunt pair of tweezers.</p> <p>Assemble a new sheet absorption A with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.13 Cover system connector I/O

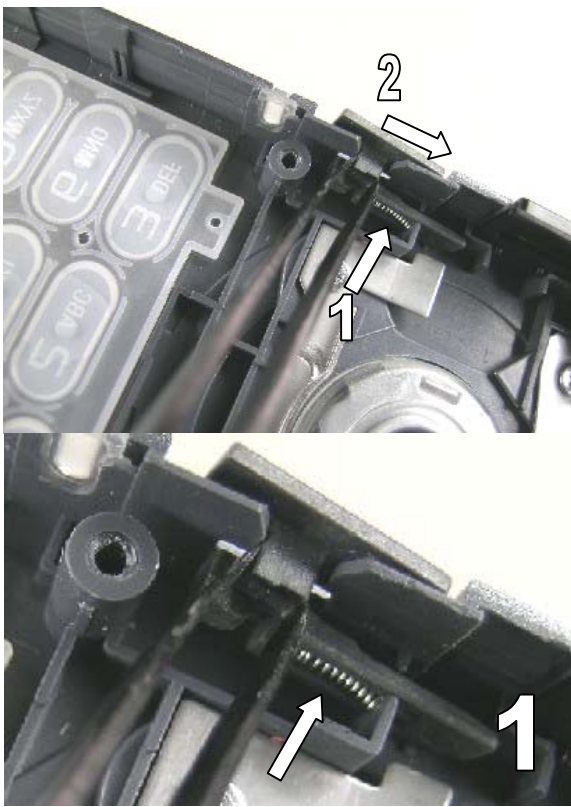
Step-by-Step Instructions		
1	<p>Remove the cover system connector I/O with your fingers.</p> <p>Assemble a new cover by hand.</p>	

3.14 Cover MS

	Step-by-Step Instructions	
1	<p>Remove the cover MS with your fingers.</p> <p>Assemble a new cover by hand.</p>	

3.15 Button lock switch assy

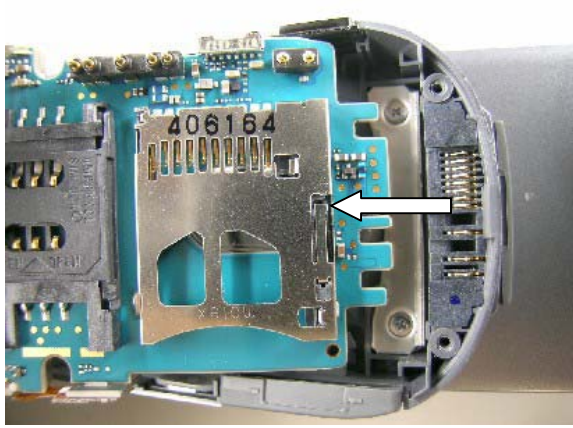
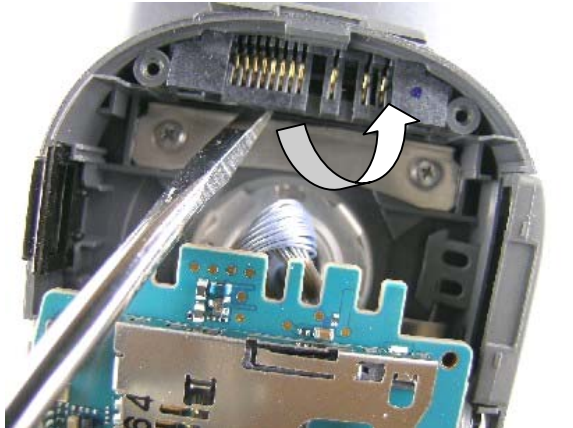
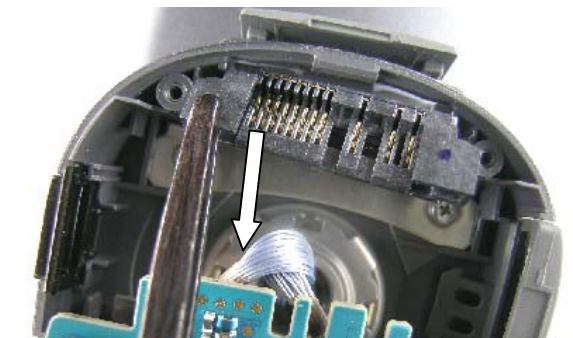

- Disassemble the phone as described in *1 Disassembly*.

	Step-by-Step Instructions	
1	<p>NOTE! Be careful with the spring (1).</p> <p>Remove the button lock switch assy with a blunt pair of tweezers (2).</p> <p>Assemble a new button lock switch assy with your fingers and with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.16 System Connector



- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>Slide the main PBA backwards from the system connector with your fingers.</p> <p>NOTE! Don't bend the PBA to much upwards.</p>	
2	<p>NOTE! Sometimes it needs quite a lot of force until the system connector become loose.</p> <p>With a slot screwdriver gently bend against the hinge frame holding (under the system connector) until the system connector become loose.</p>	
3	<p>Remove the old system connector with a blunt pair of tweezers.</p> <p>Assemble a new system connector with your fingers.</p> <p>NOTE! Press the system connector firmly to the bottom of the case key front cavity.</p>	
4	<p>Correctly mounted system connector.</p> <p>NOTE! Don't forget to reassemble the cover system connector I/O (3.13).</p>	

- Assemble the phone as described in *2 Reassembly*.

3.17 Cushion LCD hinge

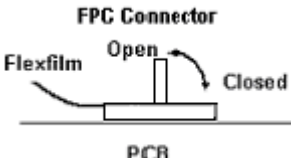


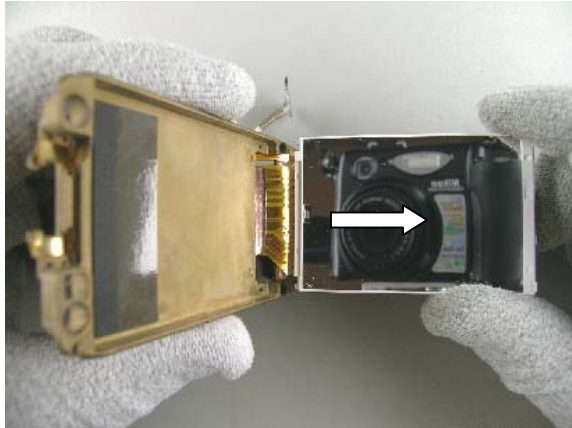
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	Remove the cushion LCD hinge by hand or with a blunt pair of tweezers.	
2	<p>NOTE!</p> <p>1. If necessary – clean the surface of the cushion LCD hinge with Isopropyl alcohol.</p> <p>2. The cushion LCD hinge should be aligned like the picture shows.</p> <p>Assemble a new cushion LCD hinge with your fingers or with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.18 LCD unit

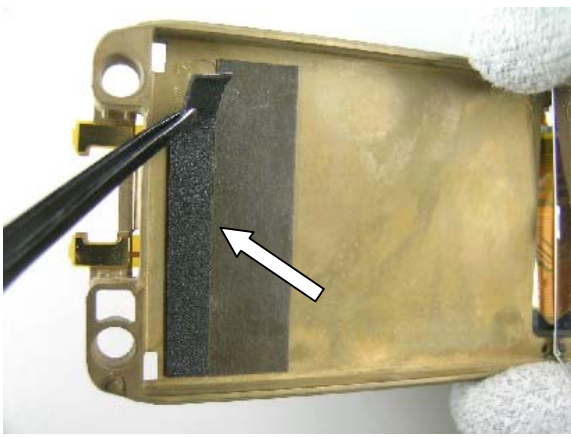
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Be very careful not to damage the FPC connector clamp when closing it. The clamp may fall off and then the connector must be replaced (electrical repair).</p> <p>Open the FPC connector with the flex film assembly tool.</p> <p>FPC Connector</p> 	
2	<p>NOTE! Do not touch the display glass with your fingers.</p> <p>Gently fold the LCD forward by hand.</p>	
3	<p>NOTE! Be careful with the LCD flexfilm.</p> <p>Slide the LCD screen and the flexfilm through and away from the LCD frame.</p> <p>Assemble a new LCD unit in the reverse direction.</p> <p>NOTE! Don't forget to remove the protection foil. Be careful not to scratch the glass.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.19 Cushion frame LCD

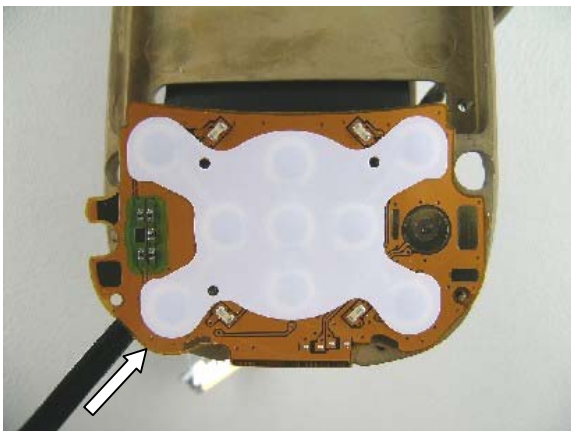


- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>1. If necessary – clean the surface of the frame LCD with Isopropyl alcohol.</p> <p>2. The cushion frame LCD should be assembled like the picture shows.</p> <p>Remove the old cushion frame LCD with a blunt pair of tweezers.</p> <p>Assemble a new one with with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.20 FPC hinge

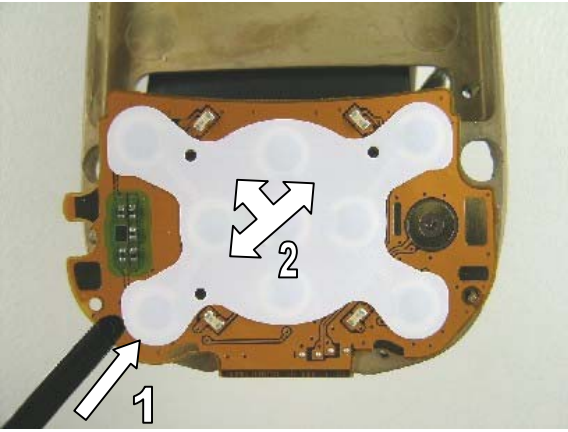
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! 1. Notice how the FPC hinge is assembled before you remove it. 2. Be careful with the tweezers.</p> <p>Gently bend with a blunt pair of tweezers under the FPC hinge until it become loose.</p>	
2	<p>Turn the LCD frame around and do the same thing again on the other side.</p>	
3	<p>NOTE! If necessary, clean the surface of the frame with Isopropyl alcohol before you assemble new adhesives.</p> <p>The picture shows the FPC hinge separated from the LCD unit frame.</p> <p>Assemble a new FPC hinge in the reverse direction.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.21 LCD flex sheet key


- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>Remove the old LCD flex sheet key with a blunt pair of tweezers (1) and with your hands.</p> <p>NOTE!</p> <p>1. If necessary – clean the surface of the FPC hinge with Isopropyl alcohol.</p> <p>2. The LCD flex sheet key should be aligned to the three holes on the FPC hinge (2).</p> <p>Assemble a new one with your fingers or with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.22 Frame LCD

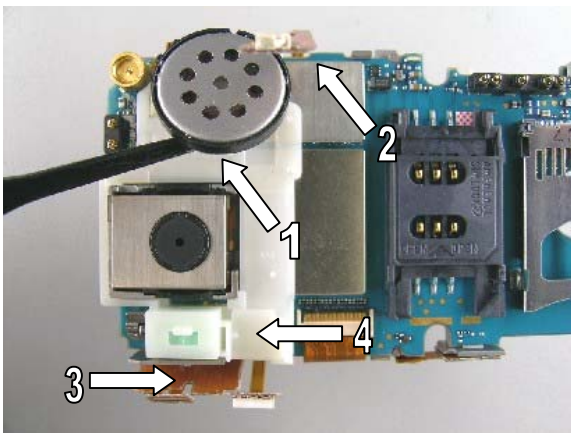
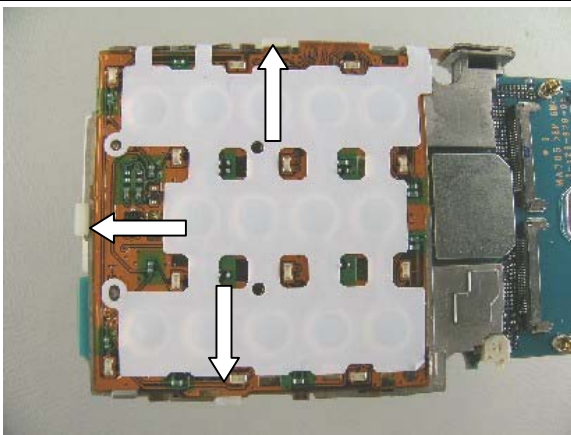
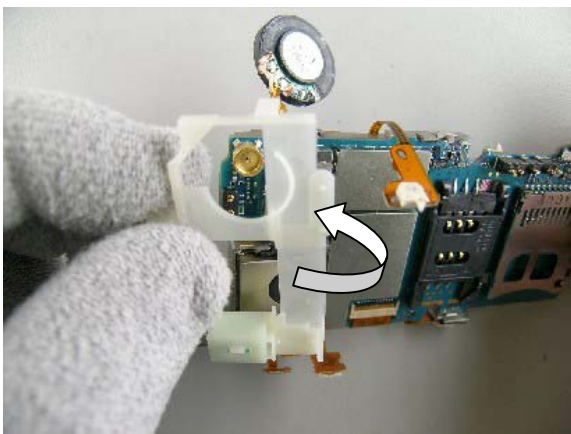
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>1. Remove the <i>LCD unit (3.18)</i> and the <i>FPC hinge (3.20)</i> first.</p> <p>Replace the old LCD frame with a new one.</p> <p>NOTE!</p> <p>Don't forget to assemble a new <i>Cushion frame LCD (3.19)</i> and all the adhesives.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.23 Frame RF

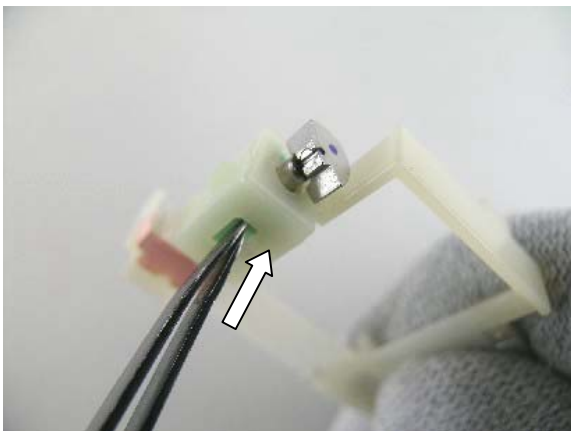
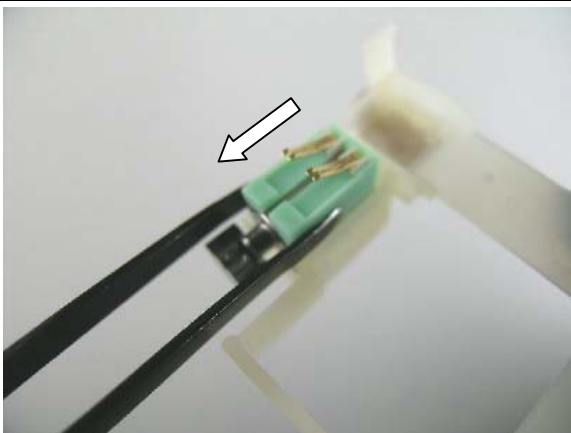
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Be careful with the tweezers.</p> <p>Remove the speaker (1), flex shutter (2), flex up/down (3) and flex p/light (4) with a blunt pair of tweezers.</p>	
2	<p>NOTE! Be very careful with the FPC key (Flexfilm) and the three hooks – they are very fragile.</p> <p>Gently bend the three RF frame hooks away from the main PBA with your fingers until the RF frame became loose.</p>	
3	<p>Lift away the old RF frame and replace it with a new one.</p> <p>NOTE! If necessary, clean the surface with Isopropyl alcohol before you assemble new adhesives.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.24 Vibrator

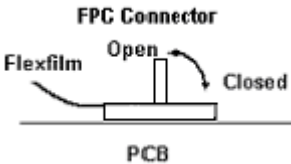
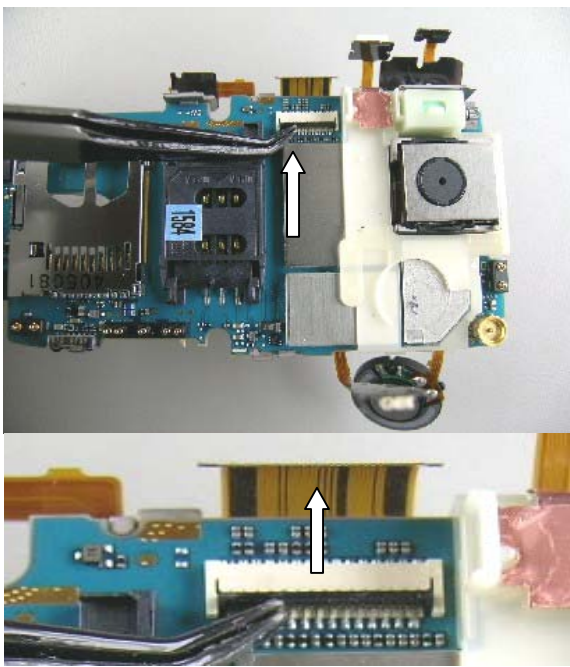
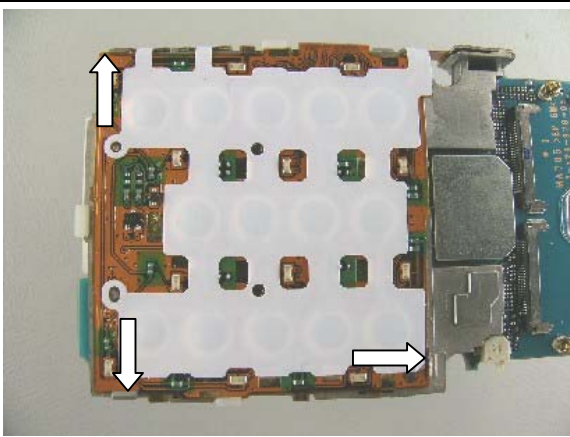
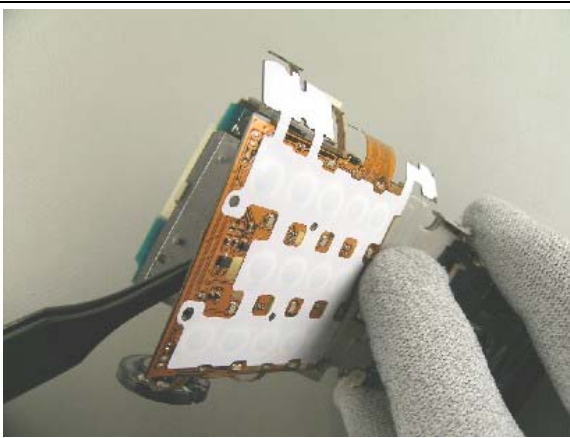
- Disassemble the phone as described in *1 Disassembly*.

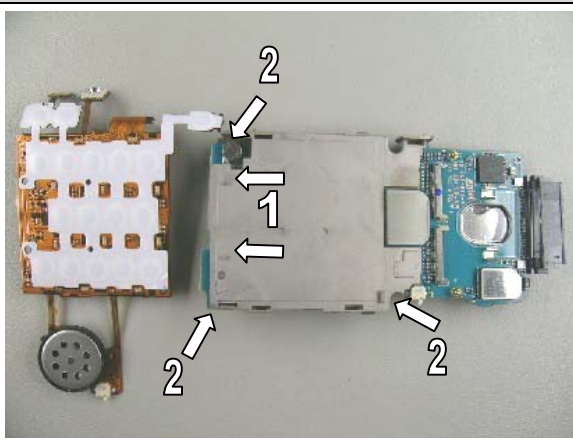
Step-by-Step Instructions		
1	<p>NOTE! 1. Remove the <i>Frame RF (3.23)</i> first.</p> <p>Push the vibrator out from the RF frame with a blunt pair of tweezers</p>	
2	<p>NOTE! Do not touch the vibrator contact springs or damage the flywheel.</p> <p>Lift up the vibrator motor with the tweezers like the picture shows.</p> <p>Assemble a new vibrator in the reverse direction.</p> <p>NOTE! Press the vibrator to the bottom of the cavity gently with a blunt pair of tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.25 Key FPC

- Disassemble the phone as described in *1 Disassembly*.

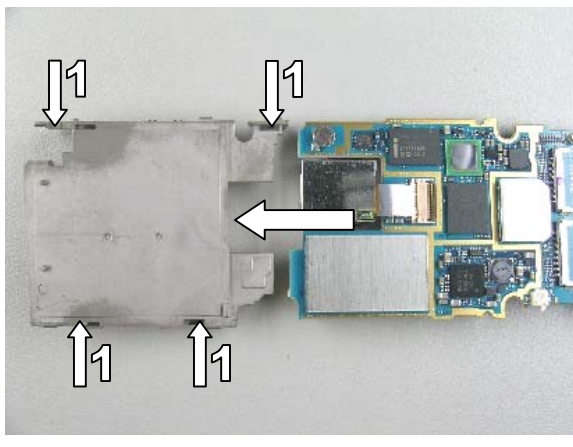
Step-by-Step Instructions		
1	<p>NOTE! Remove all the FPC key equipment connected by a adhesive with a blunt pair of tweezers like the pictures shows.</p> <p>Be very careful not to damage the FPC connector clamp when closing it. The clamp may fall off and then the connector must be replaced (electrical repair).</p> <p>Open the FPC connector with the flex film assembly tool and remove the flexfilm from the connector.</p> 	
2	<p>The FPC key is held in place to the frame BB with three hooks (by the arrows)</p>	
3	<p>Gently remove the old FPC key with a blunt pair of tweezers and with your hands like the picture shows.</p>	

Step-by-Step Instructions		
4	<p>NOTE! The key FPC should be aligned to the frame BB by the two guide pins (1) and to the three hooks (2).</p> <p>Assemble a new key FPC in the reverse direction.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.26 Frame BB

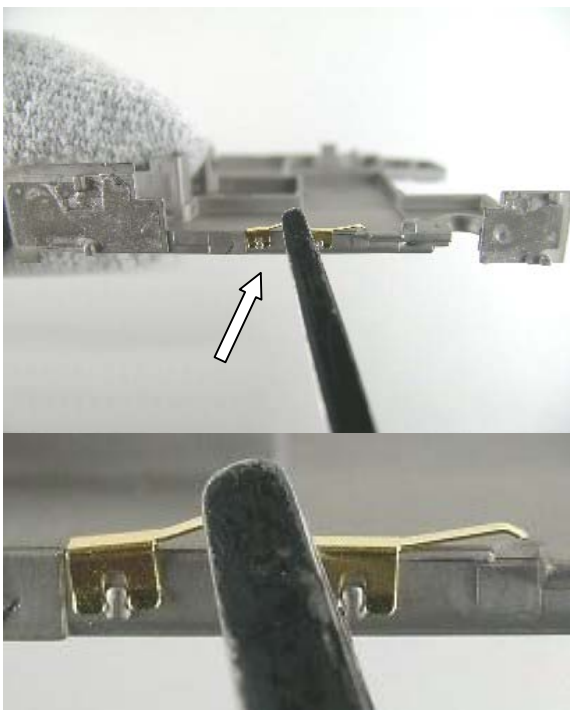
- Disassemble the phone as described in *1 Disassembly*

Step-by-Step Instructions		
1	<p>NOTE! 1. Remove the <i>Frame RF (3.23)</i> and the <i>Key FPC (3.25)</i> first.</p> <p>2. Be careful with the camera assembly</p> <p>3. Be very careful with the four little hooks.</p> <p>Remove the frame. It's attached to the PBA with four small hooks on the edges (1).</p> <p>Just bend with your hand until the frame become loose.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.27 Spring, A

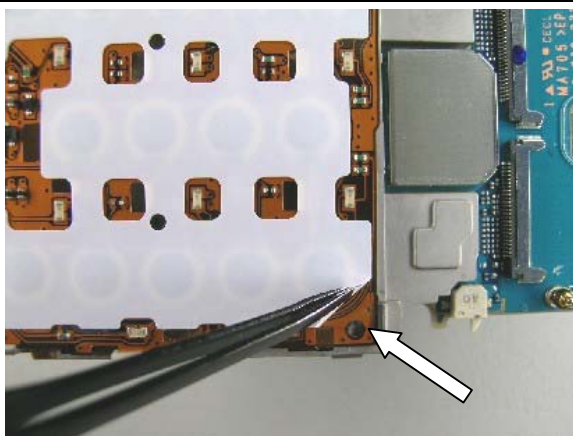
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Remove the <i>Frame RF (3.23)</i>, <i>Key FPC (3.25)</i> and the <i>Frame BB (3.26)</i> first.</p> <p>Replace the old Spring, A with new ones, use a blunt pair of tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.


3.28 Key flex sheet key (Domes)

- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>Remove the old key flex sheet key with a blunt pair of tweezers.</p> <p>NOTE!</p> <p>1. If necessary – clean the surface of the key FPC with Isopropyl alcohol.</p> <p>2. The Key flex sheet key should be aligned to the markings and the holes on the key FPC.</p> <p>Assemble a new one with your fingers or with the tweezers.</p>	

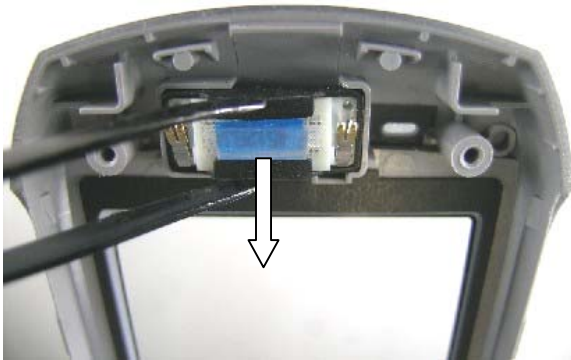
- Assemble the phone as described in *2 Reassembly*.

3.29 Operator badge

Step-by-Step Instructions		
1	<p>NOTE!</p> <p>Be careful not to scratch the front with the dentist hook.</p> <p>If necessary – clean the surface of the co-branded cavity with Isopropyl alcohol.</p> <p>Gently remove the old brand badge with a dentist hook like the picture shows.</p> <p>Assemble a new brand badge with a blunt pair of tweezers.</p>	

3.30 Receiver


- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! 1. Be careful with the tweezers. 2. Do not touch or damage the dual receiver contact springs with your fingers or with the assembly tools.</p> <p>Remove the old receiver with a blunt pair of tweezers.</p> <p>Place a new receiver into the frame cavity. Press gently on the receiver with the tweezers to secure a good fit.</p> <p>NOTE! Press the receiver to the bottom of the cavity.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.31 Microphone




- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>Remove the old microphone with a dentist hook.</p> <p>NOTE! 1. Do not press in the center of the microphone (damage may occur). 2. Do not touch or damage the dual microphone contact springs with your fingers or with the assembly tools.</p> <p>Place a new microphone into the frame cavity. Press gently on the microphone edges with a blunt pair of tweezers to secure a good fit.</p> <p>NOTE! Press the microphone to the bottom of the cavity.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.32 Buttons LCD (Top, Side, Base and Center)


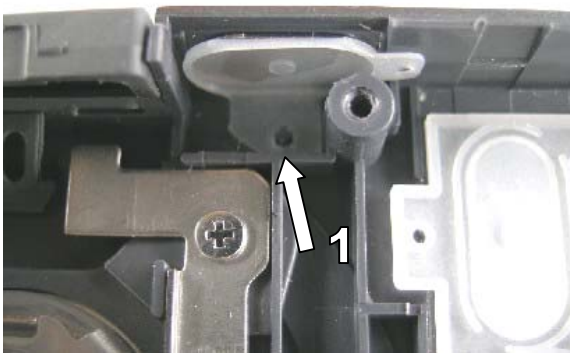
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>Remove the old LCD base button with a blunt pair of tweezers.</p> <p>Assemble a new base button with the tweezers or by hand.</p>	
2	<p>Remove the old LCD side button with a blunt pair of tweezers.</p> <p>Assemble a new side button with the tweezers or by hand.</p>	
3	<p>NOTE! Notice the LCD button position before removal.</p> <p>Remove the old LCD top button with a blunt pair of tweezers.</p> <p>Assemble a new top button by hand or with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.33 Button shutter

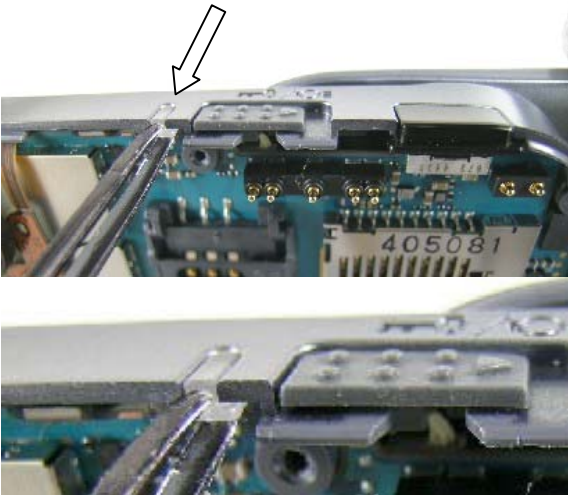
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Remove the main PBA first (See chapter 1. Disassembly).</p> <p>Remove the old shutter button with a blunt pair of tweezers.</p> <p>Assemble a new one with the tweezers.</p>	
2	<p>Use the guide pin (1) when reassembling the button shutter.</p> <p>NOTE! Make sure that the button shutter is assembled in the right position.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.34 Light Guide (Charge LED)


- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Be careful not to scratch the light guide with the tweezers.</p> <p>Remove the old light guide with a blunt pair of tweezers.</p> <p>Assemble a new one with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.35 Liquid intrusion indicator

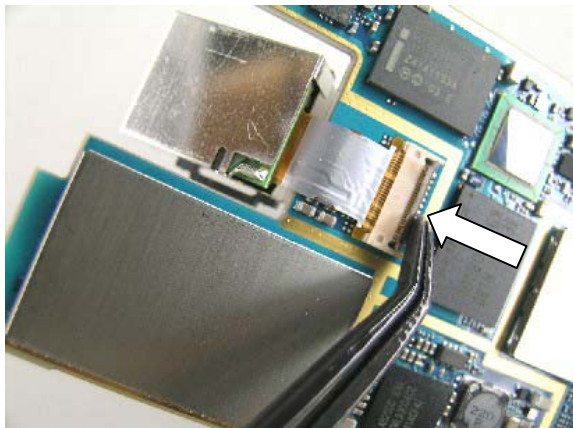
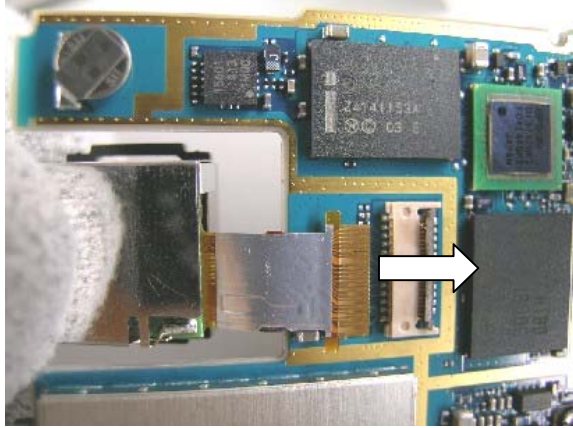
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Notice the liquid intrusion indicator position on the phone.</p> <p>If necessary clean the frame surface with Isopropyl alcohol before you assemble the new indicator.</p> <p>Remove the old liquid intrusion indicator and replace it with a new one.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.36 Camera 1,3M CCD (MCX-CC5)

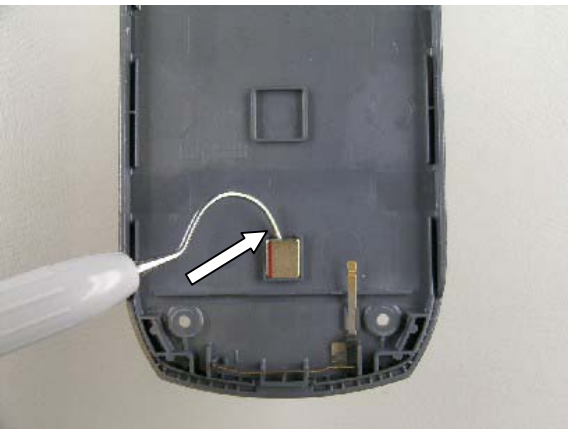
- Disassemble the phone as described in *1 Disassembly*

	Step-by-Step Instructions	
2	<p>NOTE! Remove the <i>Frame RF</i> (3.23), <i>Key FPC</i> (3.25) and the <i>Frame BB</i> (3.26) first.</p> <p>Be very careful not to damage the FPC connector clamp when opening or closing it. The clamp may fall off and then the connector must be replaced (electrical repair).</p> <p>Open the FPC connector with the flex film assembly tool.</p>	
3	<p>NOTE! Be careful with the camera assembly and flexfilm.</p> <p>Remove the old camera assembly.</p> <p>Assemble a new camera assembly, press it to the bottom of the FPC connector and close it with the flex film assembly tool.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.37 Magnet

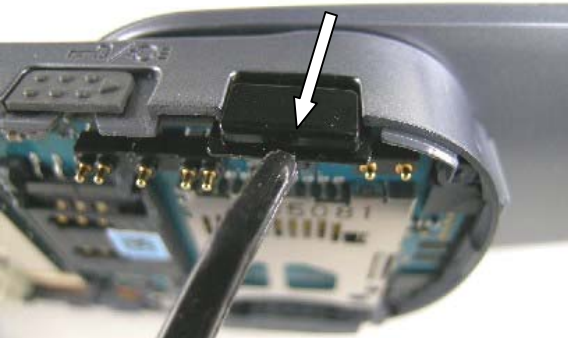
- Disassemble the phone as described in *1 Disassembly*

	Step-by-Step Instructions	
1	<p>NOTE! If necessary clean the surface of the LCD rear case with Isopropyl alcohol before you assemble a new adhesive.</p> <p>Remove the old magnet with a dentist hook.</p> <p>Assemble a new magnet with a blunt pair of tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.38 Panel IRDA


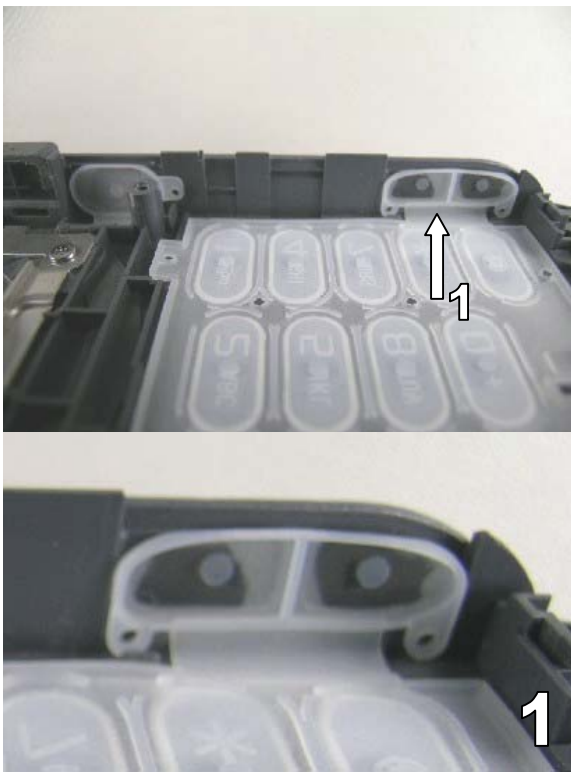
- Disassemble the phone as described in *1 Disassembly*

	Step-by-Step Instructions	
1	<p>NOTE! Be careful with the tweezers so you don't scratch the IRDA panel.</p> <p>Remove the old IRDA panel with a blunt pair of tweezers.</p> <p>Assemble a new one with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.39 Button key



- Disassemble the phone as described in *1 Disassembly*

Step-by-Step Instructions		
1	<p>NOTE! Be careful not to damage the button key with the tweezers.</p> <p>Remove the old button key with a blunt pair of tweezers or by hand.</p> <p>Assemble a new one by hand.</p>	
2	<p>NOTE! Check so the button key is correctly assembled.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.40 Panel camera

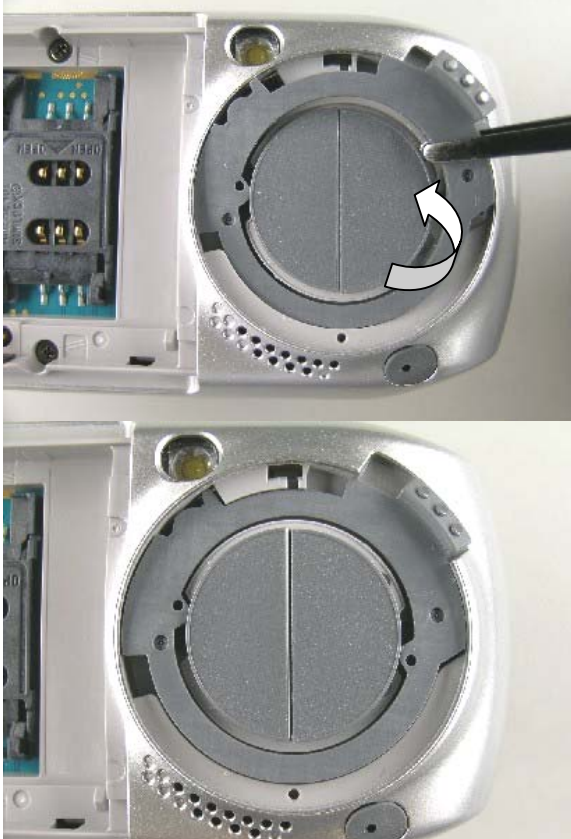
- Disassemble the phone as described in *1 Disassembly*

Step-by-Step Instructions		
1	<p>NOTE! Be careful with the dentist hook. It's easy to scratch the frame.</p> <p>Remove the old panel camera with a dentist hook.</p> <p>NOTE! If necessary clean the surface of the case key rear with Isopropyl alcohol before you assemble new adhesives.</p>	
2	<p>NOTE! Notice the tap (1) on the camera panel that should be inserted into the case key rear.</p> <p>Assemble a new panel camera by hand.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.41 Frame camera cover

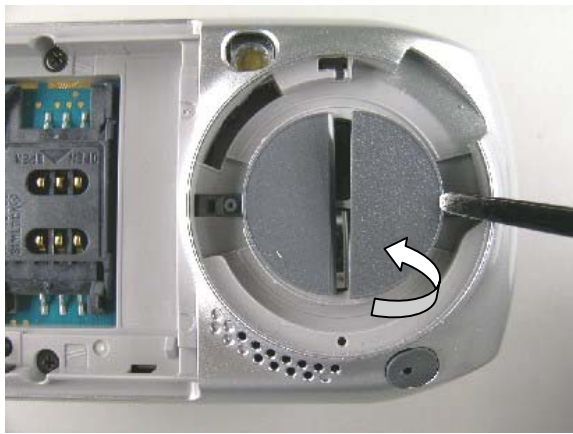
- Disassemble the phone as described in *1 Disassembly*

	Step-by-Step Instructions	
1	<p>NOTE! Be careful not to damage the frame camera cover with the tweezers.</p> <p>Remove the old frame camera cover with a blunt pair of tweezers.</p> <p>Assemble a new one with the tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.42 Cover camera R, Cover camera L


- Disassemble the phone as described in *1 Disassembly*

	Step-by-Step Instructions	
1	<p>NOTE! Notice which is left and right before removal, they are marked with an L and R on the back of the plastic.</p> <p>Remove the camera covers with a blunt pair of tweezers or by hand.</p> <p>Assemble new ones with the tweezers or by hand.</p>	

- Assemble the phone as described in *2 Reassembly*

3.43 GSM Antenna

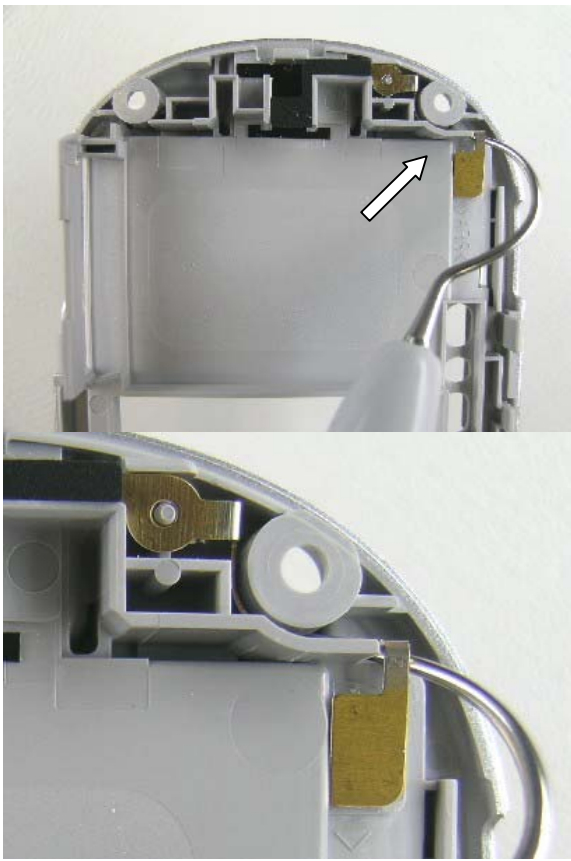
- Disassemble the phone as described in *1 Disassembly*.

	Step-by-Step Instructions	
1	<p>NOTE! Be very careful with the antenna screw and don't over tighten.</p> <p>Remove the old GSM antenna with a screwdriver and with your fingers.</p> <p>Assemble a new antenna and screw.</p>	

- Assemble the phone as described in *2 Reassembly*.

3.44 BT Antenna

- Disassemble the phone as described in *1 Disassembly*.

	Step-by-Step Instructions	
1	<p>NOTE! Notice the BT antenna position on the picture.</p> <p>Remove the old BT antenna with a dentist hook.</p> <p>Assemble a new antenna with a blunt pair of tweezers.</p>	

- Assemble the phone as described in *2 Reassembly*.

4 Label

Tools

- Hot air flow solder station
- Blunt pair of tweezers
- Zebra printer and computer

Instruction

This instruction should be used when you are intending to exchange an old label or assemble a new one.

NOTE!

Notice the position of the label before removal.

Only one label is allowed on the frame.

1. Read the old label and/or write the information into the Labelmake program.
2. Heat up the label with a hot air flow solder station, if needed.
3. Carefully remove the label, make sure that all residues are gone. If necessary clean the surface with Isopropyl alcohol. Do not scratch the frame.
4. Check that the right label format is loaded in the Zebra printer.
5. Write a new label by using the program Labelmake. Check that the printing is ok.
6. Take the new label and place it onto the frame according to *Fig 1*. Make sure that the label is placed in the right position.




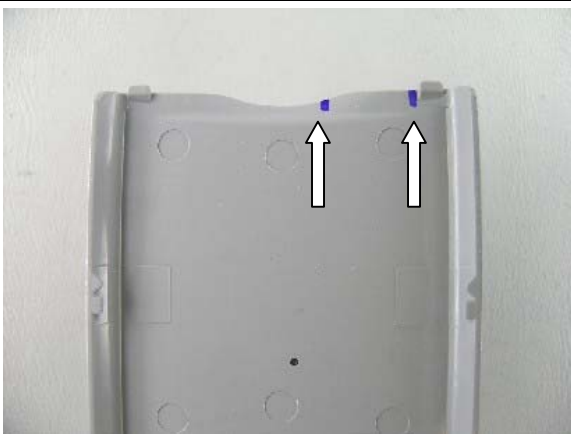

Fig 1.





5 Dummy Battery Cover

Tools

- Color marker
- Pair of scissors
- Side cutter

Instruction

Step-by-Step Instructions		
1	Take a new battery cover.	
2	Turn the battery cover around. Mark with some color where you gonna cut the opening.	
3	Cut the opening, for the dummy battery cables with the sissors (white lines).	

	Step-by-Step Instructions	
4	<p>Bend the part like the picture shows.</p> <p>NOTE! Bend as the picture shows, so that the edge doesn't damage the dummy battery cables.</p>	
5	<p>Cut off the part like the picture shows.</p>	
6	<p>Dummy battery cover ready.</p>	
7	<p>Dummy battery cover in use.</p>	

6 Revision History

Rev.	Date	Changes / Comments
A	2004-09-13	First release
B	2004-10-13	Updated Harness cables mounting info (Page 16), Updated with instruction for dummy battery cover (chapter 5)