

## Working Instruction - mechanical -



*Xperia L2*  
*H3311, H3321,*  
*H4311 (Dual SIM), H4331 (Dual SIM)*

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

**Always firstly disconnect the Battery FPC BtB connector to cut off power supply when the Antenna is disassembled.**

**Always finally connect the Battery FPC BtB connector before the Antenna is reassembled.**

**After repairing/reassembling the unit, calibration by CS-Everest, and flashing software Customize by Emma is required.**

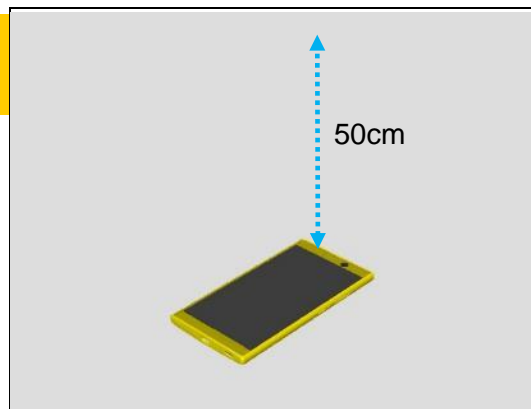
**Calibration tool “CS-Everest 1309-7255” is available at Repair Information.**

**It is posted under the RE4251: Repair - Mechanical - Tools and Equipment (including Repair Software).**

**Note: Aged Battery Reset in EMMA must be performed when replaced the Battery to delete the Battery log data.**

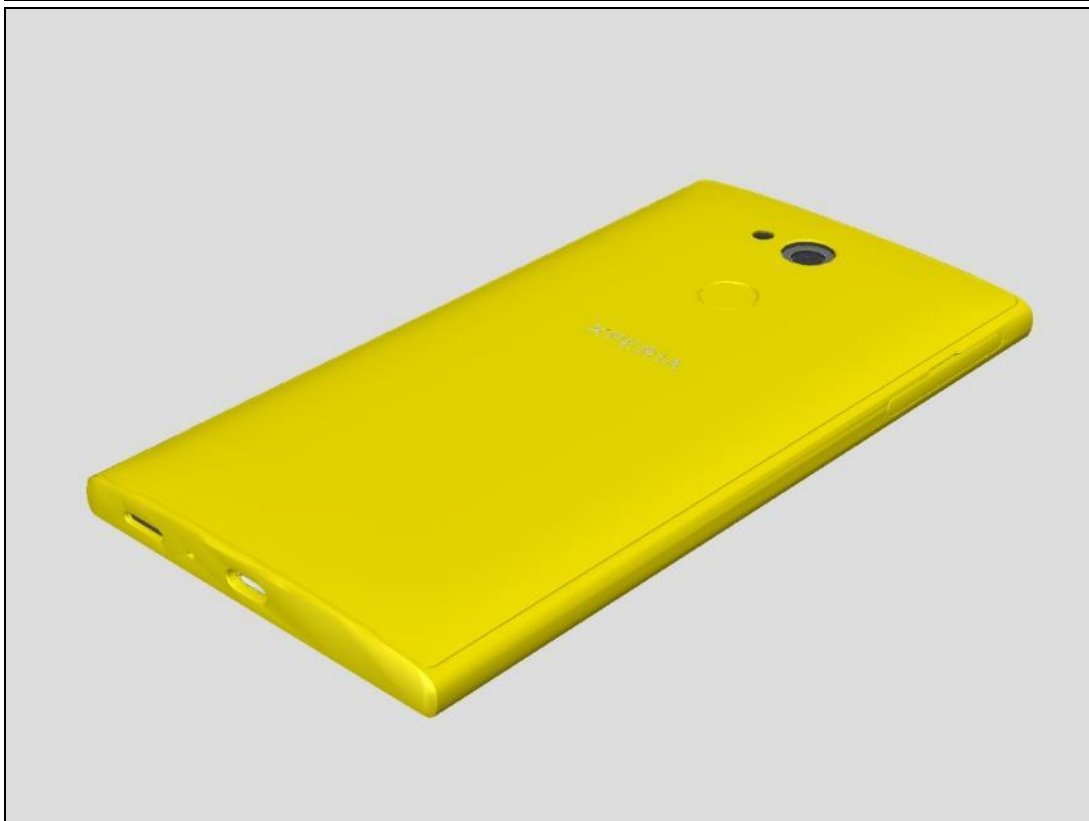
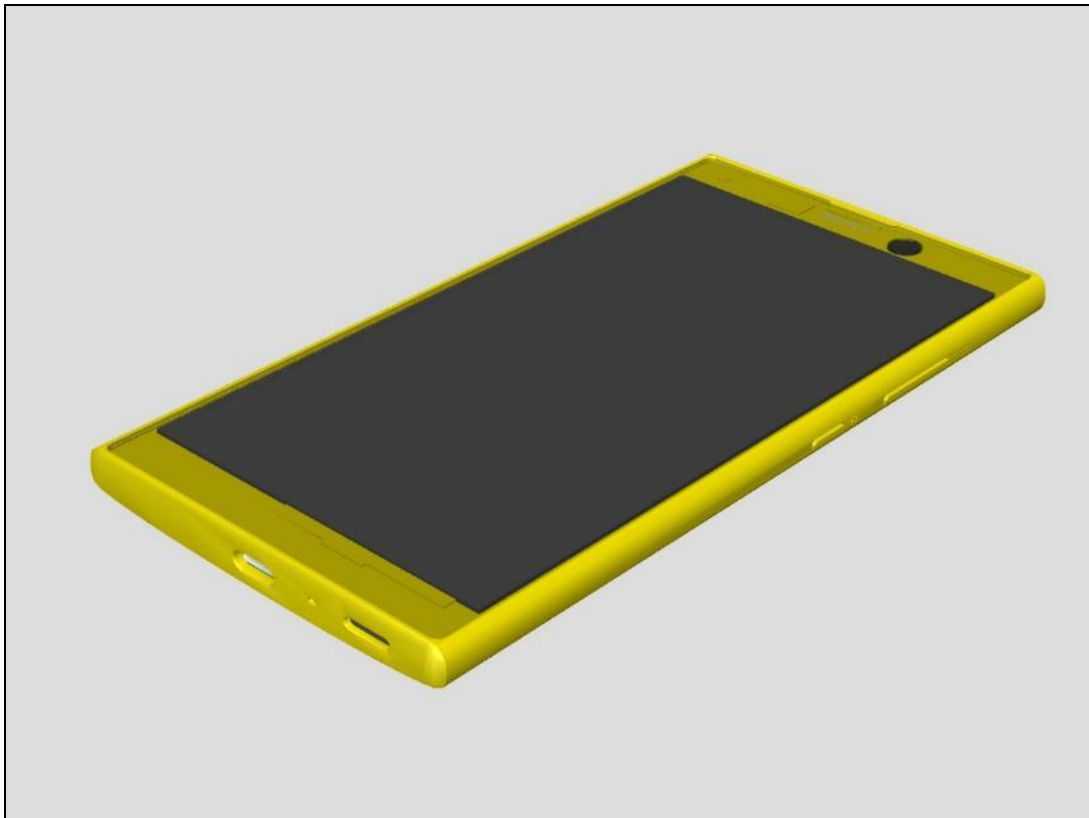
**When performing proximity sensor calibration, put the phone unit on a stable place, facing up, and no any objects within 50cm.**

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



## 1 Exterior Views

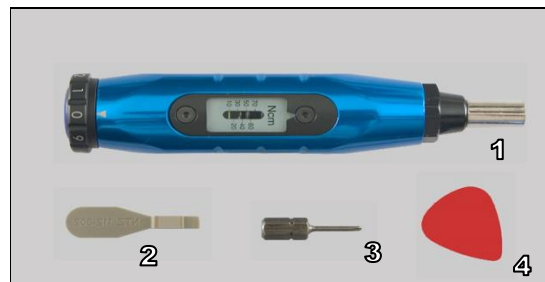
### 1.1 H3311, H3321, H4311, H4331



## 2 Tools

### SPECIAL TOOLS

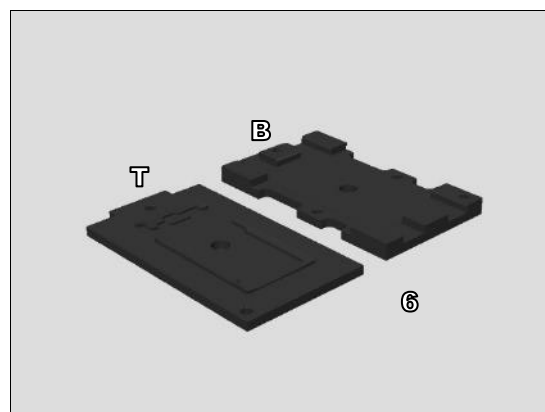
1. Torque Screwdriver 2-30Ncm (1233-2284)
2. Front Opening Tool (NTZ 112 302/2)
3. Guitar Pick (NTZ 112 590)
4. Torx Bits T5 (NTZ 112 478)



5. Generic Wheel Press Tool (1311-1952)



6. Press Rubber Inlay (1311-8504)  
For Bottom side: Press Rubber Inlay (B)  
For Top side: Press Rubber Inlay (T)



7. Press Battery Inlay (1313-1745)

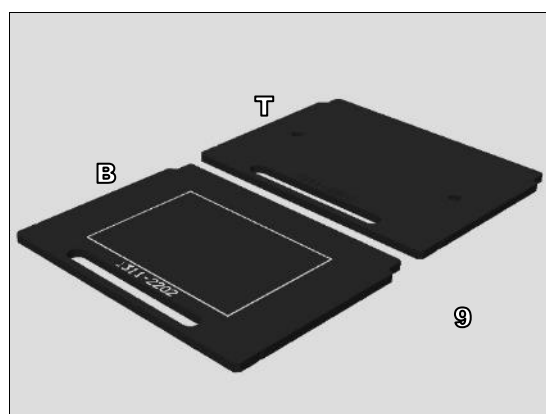


## Tools

8. Media Cable TypeC Cable (Black) (1302-1935)



9. Inlay Adaptor (1311-2202)  
For Bottom side: Inlay Adaptor (B)  
For Top side :Inlay Adaptor (T)

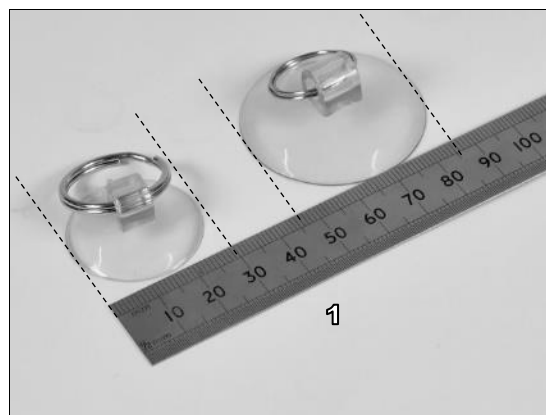


10. Load cell measurement kit (1274-3895)  
11. Generic Fixture for Press Tool (1273-4413)  
12. Toothed Rack Press (1281-2676)



### STANDARD TOOLS

1. Suction Cup (Diameter from 30mm to 40mm)



## 3 Mandatory Replacement Parts List

The Mandatory Replacement Parts List is embedded.

When replace the target part, replace all mandatory replacement parts to refer to the list.

Double click the icon to open the file.→



Mandatory  
Replacement Part

Refer to the following how to read the Mandatory Replacement Parts List.

Targeted replacement parts are listed

H3311/H3321/H4311/H4321 Mandatory Replacement Parts List

| Mandatory replacement part    | Part #           | Refurbishment | Target replacement part |               |             |           |            |              |             |          |          |         |          |             |
|-------------------------------|------------------|---------------|-------------------------|---------------|-------------|-----------|------------|--------------|-------------|----------|----------|---------|----------|-------------|
|                               |                  |               | Antenna                 | Battery Cover | Ear Speaker | FP Sensor | Front Assy | Front Camera | Main Camera | Main FPC | PBA Main | PBA Sub | RF Cable | Speaker Box |
| Adhesive Battery Cover        |                  |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Adhesive Battery Cover Bottom | A/415-81030-0011 |               | 1                       |               | 1           |           | 1          | 1            | 1           | 1        | 1        | 1       | 1        | 1           |
| Adhesive Battery Cover Top    | A/415-81030-0012 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Adhesive Battery Cover Mid    | A/415-81030-0013 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Adhesive Battery              | A/415-81030-0009 |               |                         |               |             |           | 1          |              |             | 1        |          |         |          |             |
| Adhesive Battery 2            | A/415-81030-0010 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Adhesive Ear Speaker          | A/415-81030-0014 |               |                         |               | 1           |           |            |              |             |          |          |         |          |             |
| Antenna                       | A/330-0000-00448 | 1             | 1                       |               |             |           |            |              |             |          |          |         |          |             |
| Antenna                       | A/330-0000-00449 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Battery Cover Assy            |                  |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Battery Cover Assy Black      | A/8CS-81030-0005 | 1             |                         | 1             |             | 1         |            |              |             |          |          |         |          |             |
| Battery Cover Assy Gold       | A/8CS-81030-0006 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Battery Cover Assy Pink       | A/8CS-81030-0007 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Ear Speaker                   | A/313-0000-00303 |               |                         |               | 1           |           |            |              |             |          |          |         |          |             |
| Front Assy                    |                  |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Front Assy black              | A/8CS-81030-0001 | 1             |                         |               |             |           | 1          |              |             |          |          |         |          |             |
| Front Assy gold               | A/8CS-81030-0002 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Front Assy pink               | A/8CS-81030-0003 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Front Camera                  | A/335-0000-00251 |               |                         |               |             |           |            | 1            |             |          |          |         |          |             |
| Label MOP                     | 1311-0352.1      | 1             |                         |               |             |           |            |              |             |          | 1        |         |          |             |
| Main camera                   | A/335-0000-00250 |               |                         |               |             |           |            |              | 1           |          |          |         |          |             |
| Main FPC                      | A/321-M000-00191 | 1             |                         |               |             |           | 1          |              |             | 1        |          |         |          |             |
| PBA Main                      |                  | 1             |                         |               |             |           |            |              |             |          | 1        |         |          |             |
| PBA Sub                       | A/8CS-81030-0004 | 1             |                         |               |             |           |            |              |             |          |          | 1       |          |             |
| RF Cable                      | A/415-81030-0008 |               |                         |               |             |           |            |              |             |          |          |         | 1        |             |
| Screw T5 1.6mm x 3.5mm        | A/409-00000-0250 | 10            | 4                       |               | 4           |           | 10         | 4            | 4           |          | 4        | 6       | 10       | 6           |
| SIM tray door                 |                  |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| SIM tray door single Black    | A/405-81030-0001 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| SIM tray door single Gold     | A/405-81030-0002 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| SIM tray door single Pink     | A/405-81030-0003 | 1             |                         |               |             |           |            |              |             |          |          |         |          |             |
| SIM tray door double Black    | A/405-81040-0001 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| SIM tray door double Gold     | A/405-81040-0002 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| SIM tray door double Pink     | A/405-81040-0003 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Speaker Box                   |                  |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Speaker Box                   | A/313-0000-00326 |               |                         |               |             |           |            |              |             |          |          |         |          | 1           |
| Speaker Box                   | A/313-0000-00330 |               |                         |               |             |           |            |              |             |          |          |         |          |             |
| Tray CU Label                 | A/415-81030-0016 | 1             |                         |               |             |           |            |              |             |          |          |         |          |             |
| Water Intrusion Label         | A/428-810300-019 | 1             |                         |               |             |           |            |              |             |          |          |         |          |             |

Mandatory replacement parts for refurbishment.

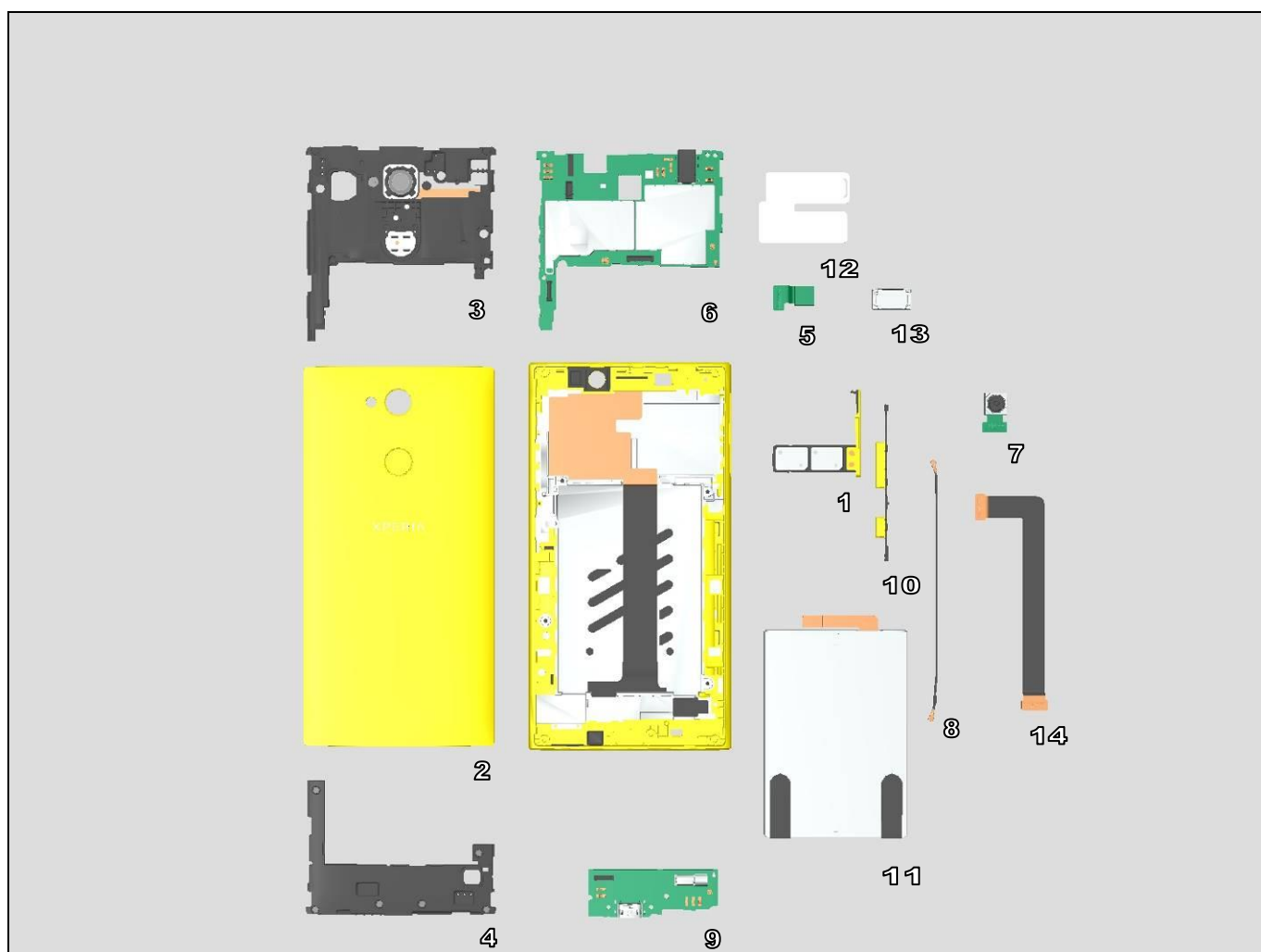
Parts that is required to replace in addition to target replacement parts.

Number in the cells indicates parts require replacing for target part reapplying.  
Target replacement part is indicated by red.

## 4 Disassembly

The disassembly is done in the following order:

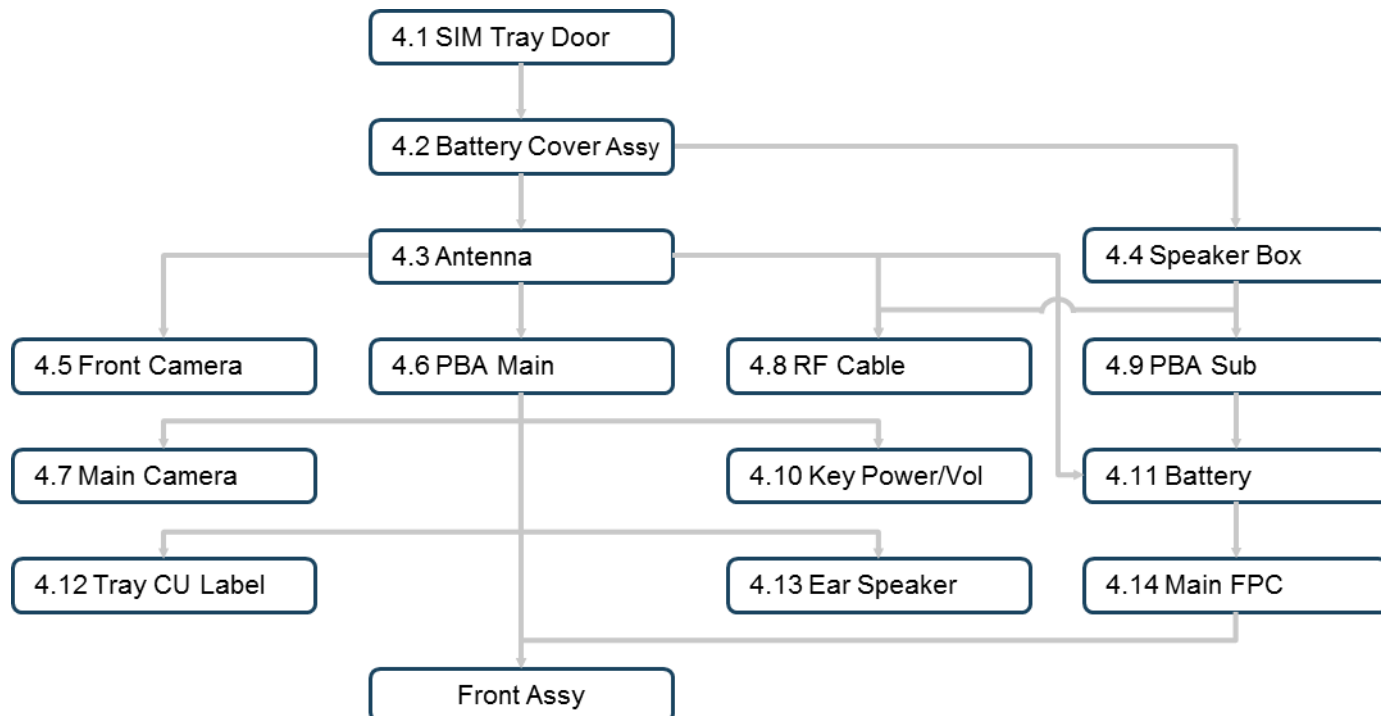
- |                       |                   |
|-----------------------|-------------------|
| 1. SIM Tray Door      | 8. RF Cable       |
| 2. Battery Cover Assy | 9. PBA Sub        |
| 3. Antenna            | 10. Key Power/Vol |
| 4. Speaker Box        | 11. Battery       |
| 5. Front Camera       | 12. Tray CU Label |
| 6. PBA Main           | 13. Ear Speaker   |
| 7. Main Camera        | 14. Main FPC      |





## Disassembly

### Quick Reference for Disassembling

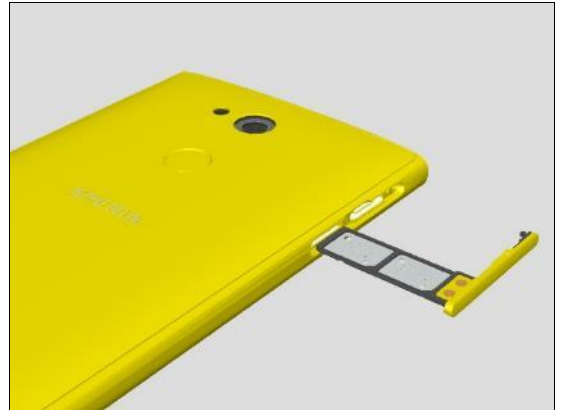


|      | Target             | Required Disassembly Steps    |
|------|--------------------|-------------------------------|
| 4.1  | SIM Tray Door      | 4.1                           |
| 4.2  | Battery Cover Assy | 4.1, 2                        |
| 4.3  | Antenna            | 4.1, 2, 3                     |
| 4.4  | Speaker Box        | 4.1, 2, 4                     |
| 4.5  | Front Camera       | 4.1, 2, 3, 5                  |
| 4.6  | PBA Main           | 4.1, 2, 3, 6                  |
| 4.7  | Main Camera        | 4.1, 2, 3, 6, 7               |
| 4.8  | RF Cable           | 4.1, 2, 3, 4, 8               |
| 4.9  | PBA Sub            | 4.1, 2, 4, 9                  |
| 4.10 | Key Power/Vol      | 4.1, 2, 3, 6, 10              |
| 4.11 | Battery            | 4.1, 2, 3, 4, 8, 9, 11        |
| 4.12 | Tray CU Label      | 4.1, 2, 3, 6, 12              |
| 4.13 | Ear Speaker        | 4.1, 2, 3, 6, 13              |
| 4.14 | Main FPC           | 4.1, 2, 3, 4, 6, 8, 9, 11, 14 |

## Disassembly

### 4.1 SIM Tray Door

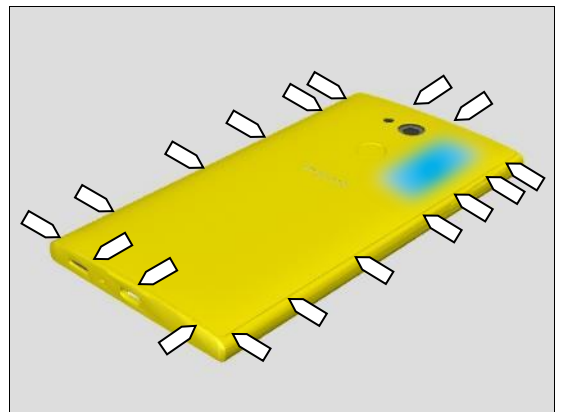
Remove the SIM Tray Door.



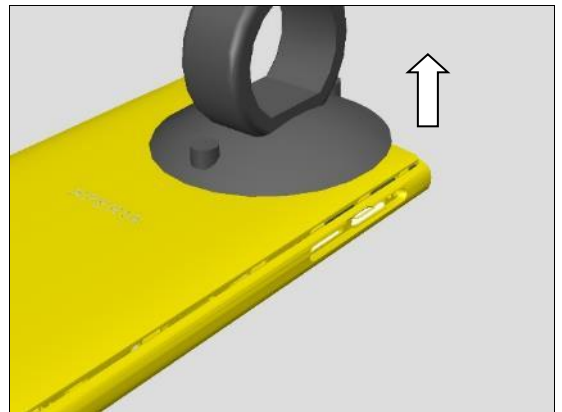
### 4.2 Battery Cover Assy

Place the Suction Cup on the indicated area.  
There are 18 hooks.

**Do not touch Front Assy by Front Opening Tool.**



Pull up the Battery Cover Assy by Suction Cup.

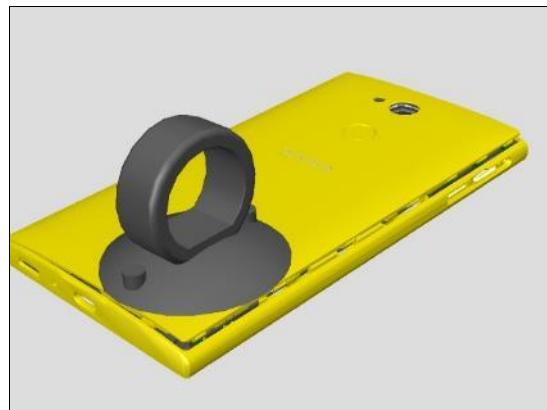


Place the Guitar Pick to indicated position to open the Battery Cover Assy further.

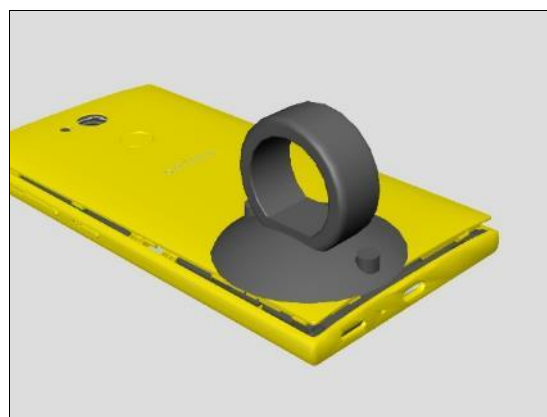


## Disassembly

Place the Suction Cup on the indicated area and pull up the Battery Cover Assy.



Place the Suction Cup on the indicated area and pull up the Battery Cover Assy.



Open the Battery Cover Assy further to disconnect FPS BtB connector then remove the Battery Cover Assy from phone and remove residue of adhesives both from the Battery Cover Assy and the unit.

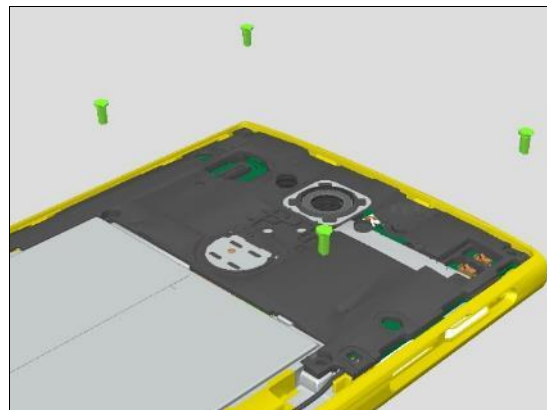


## Disassembly

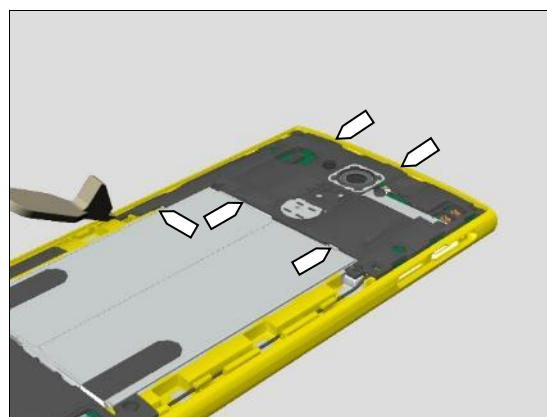
### 4.3 Antenna

Remove 4 pieces of the Screw T5 1.6mm x 3.5mm by using a screwdriver with Torx Bits T5.

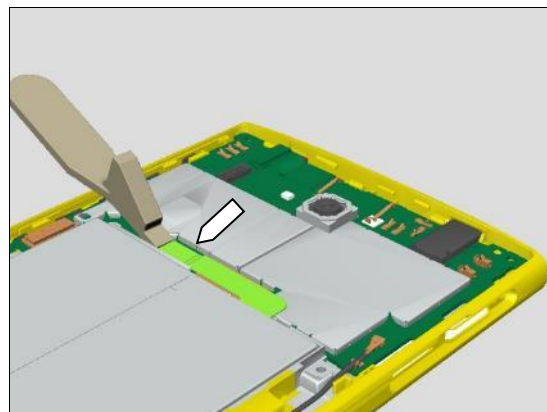
**Scrap! Don't reuse the screws!**



Insert the Front Opening Tool to indicated position and release hooks and open the Antenna  
There are 5 hooks.



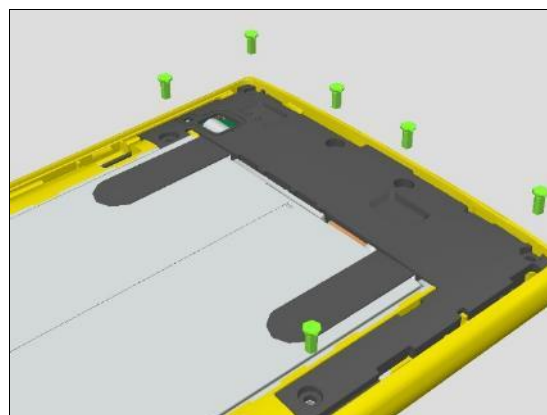
Disconnect the BtB connector of the Battery.



### 4.4 Speaker Box

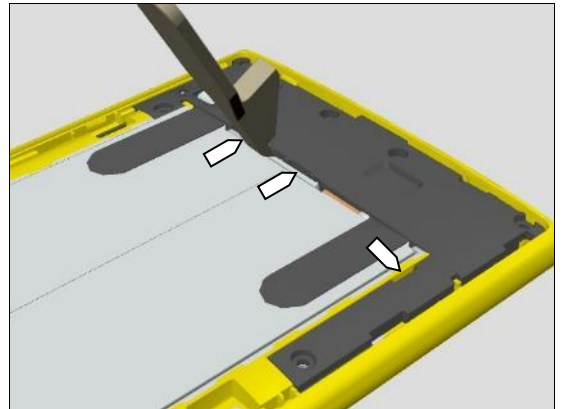
Remove 6 pieces of the Screw T5 1.6mm x 3.5mm by using a screwdriver with Torx Bits T5.

**Scrap! Don't reuse the screws!**



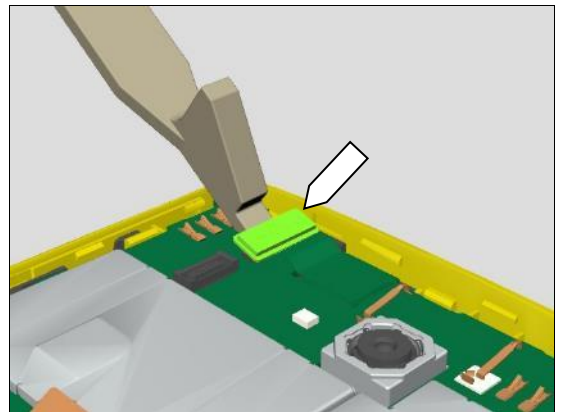
## Disassembly

Insert the Front Opening Tool to indicated position and remove the Speaker Box.  
There are 3 hooks.



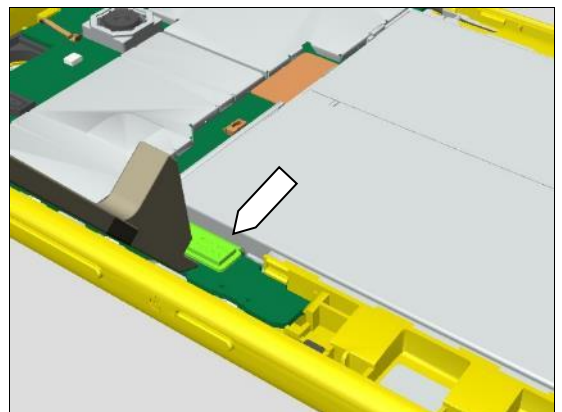
### 4.5 Front Camera

Disconnect the BtB connector of the Front Camera carefully by using the Front Opening Tool.

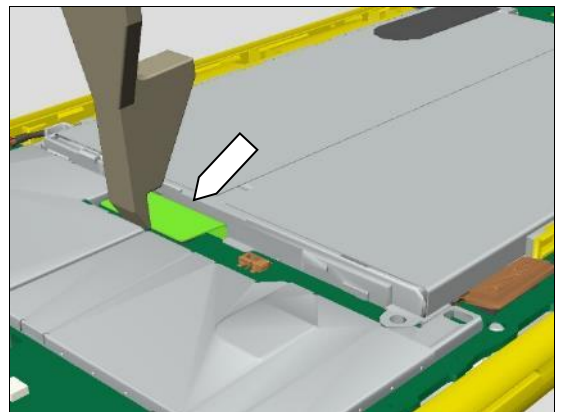


### 4.6 PBA Main

Disconnect the BtB connector of the Main FPC carefully by using the Front Opening Tool.

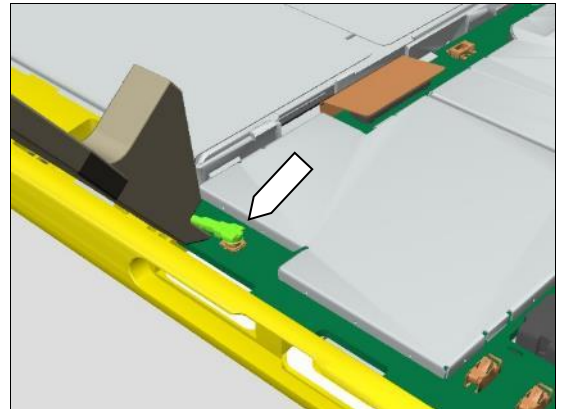


Disconnect the BtB connector of the Display FPC carefully by using the Front Opening Tool.

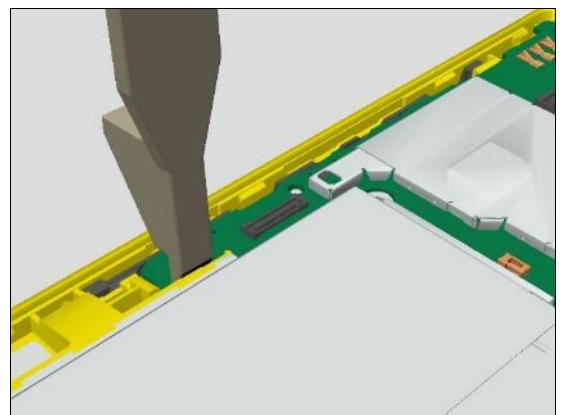


## Disassembly

Disconnect the RF connector carefully by using the Front Opening Tool.

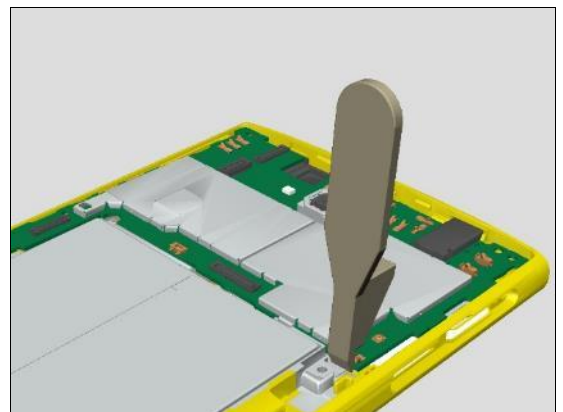


Insert the Front Opening Tool to indicated position and release hook



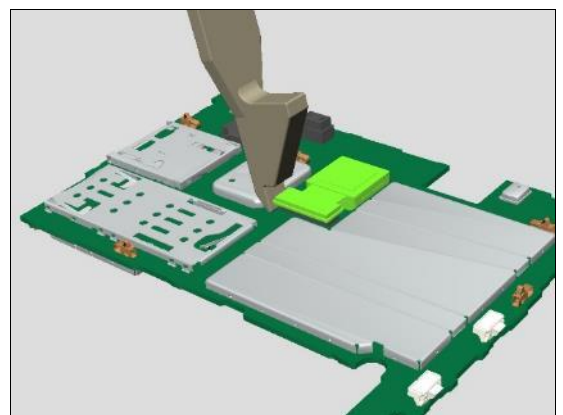
Insert the Front Opening Tool to indicated position and release hook and remove the PBA Main.

***Do not touch Front Assy by Front Opening Tool.***



### 4.7 Main Camera

Disconnect BtB connector of the Main Camera carefully by the Front Opening Tool and remove the Main Camera from the PBA Main

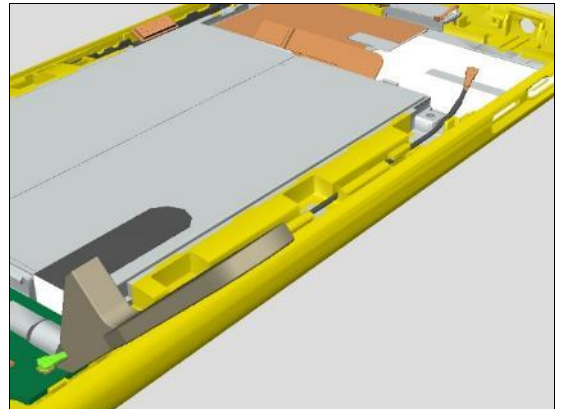




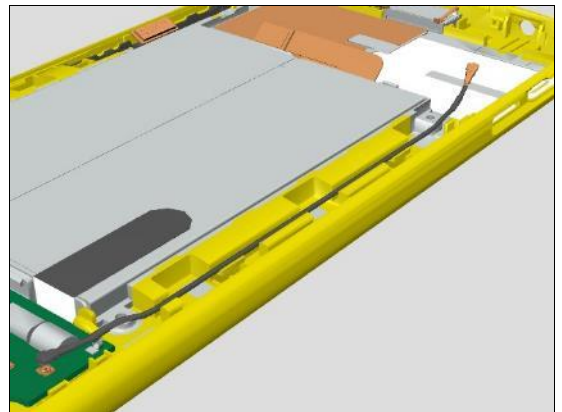
## Disassembly

### 4.8 RF Cable

Disconnect the RF connector carefully by using the Front Opening Tool

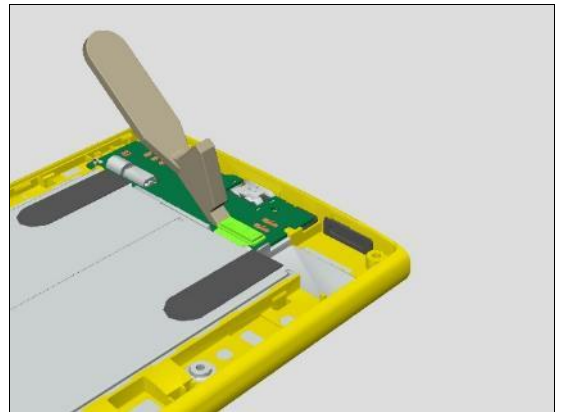


Remove the RF Cable from Front Assy

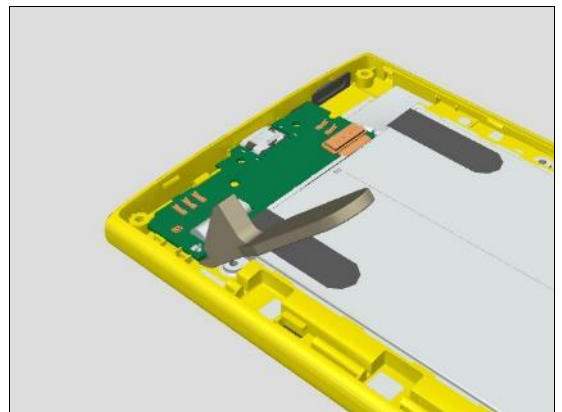


### 4.9 PBA Sub

Disconnect the BtB connector of the Main FPC carefully by using the Front Opening Tool.



Insert the Front Opening Tool to indicated position and remove the PBA Sub.

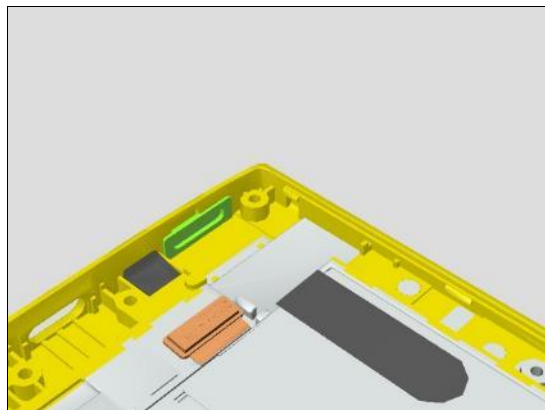


## Disassembly

### 4.9.1 Mesh Speaker

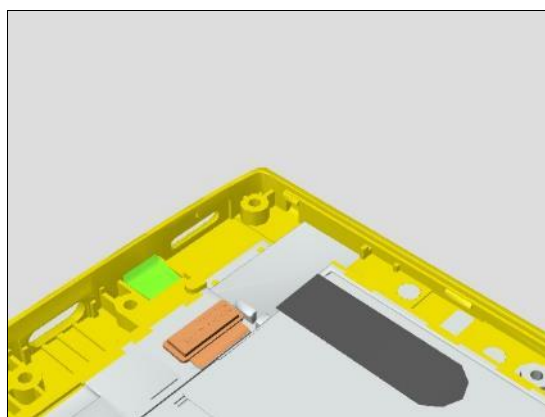
Remove the Mesh Speaker. Clean up adhesive residue.

**Scrap! The Mesh Speaker cannot be reused!**



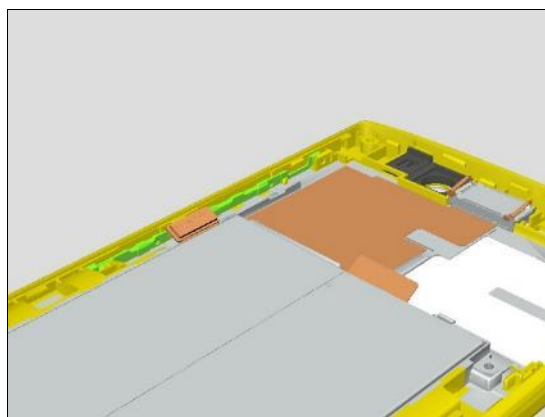
### 4.9.2 Rubber Main mic

Remove the Rubber Main mic.



### 4.10 Key Power/Vol

Pick up and remove the Key Power/Vol.





## Disassembly

### 4.11 Battery

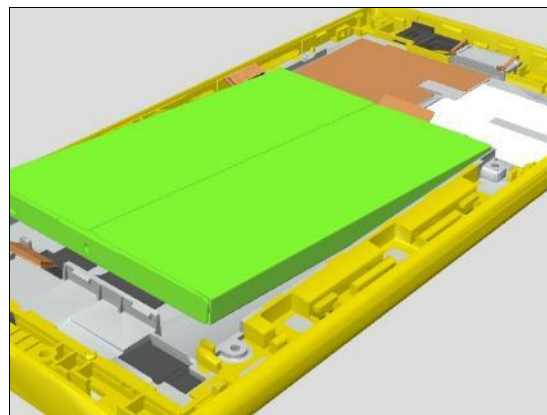
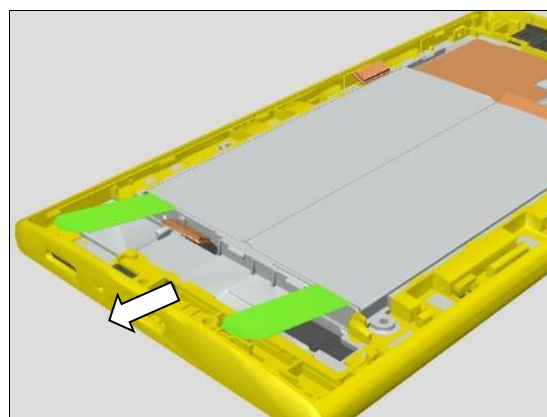
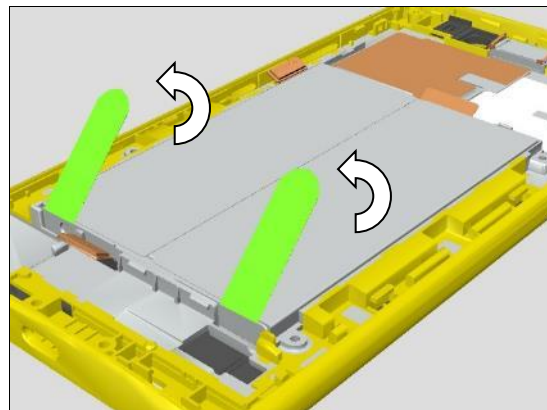
Pick up the tab of the Adhesive Battery and remove them from the Battery.

Pull the tab to indicated direction continuously until entire of the Adhesive Battery will be removed from the Battery.

***Even the Adhesive Battery breaks in the middle, as long as there are remains outside, continue to pull from the break part until its fully pull out.***

***Scrap! The Adhesive Battery cannot be reused!***

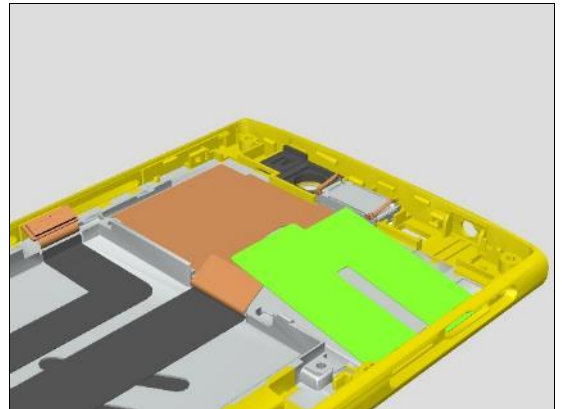
Remove the Battery.



## Disassembly

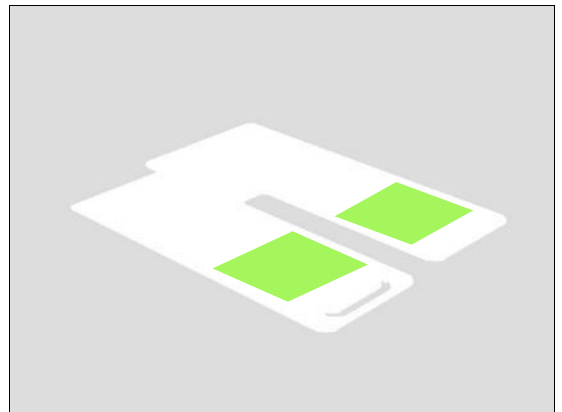
### 4.12 Tray CU Label

Remove the Tray CU Label from Front Cover



#### 4.12.1 Label MOP

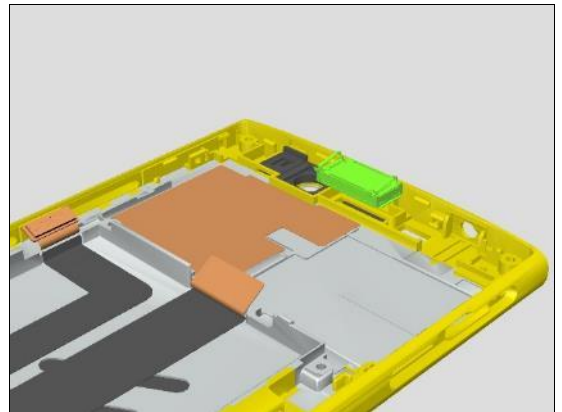
Remove the Label MOP



### 4.13 Ear Speaker

Pick up and remove the Ear Speaker. Clean up adhesive residue.

**Scrap! The Adhesive Ear speaker cannot be reused!**



#### 4.13.1 Rubber Secondary mic

Remove the Rubber Secondary mic

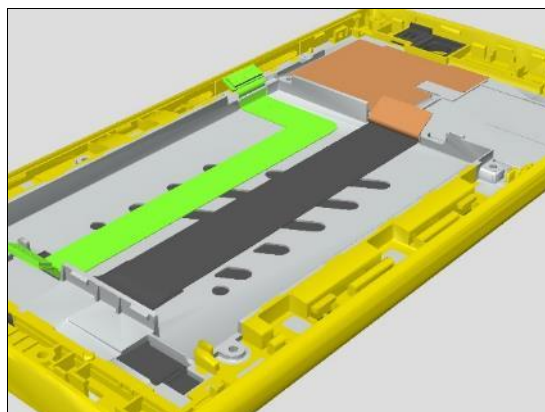


## Disassembly

### 4.14 Main FPC

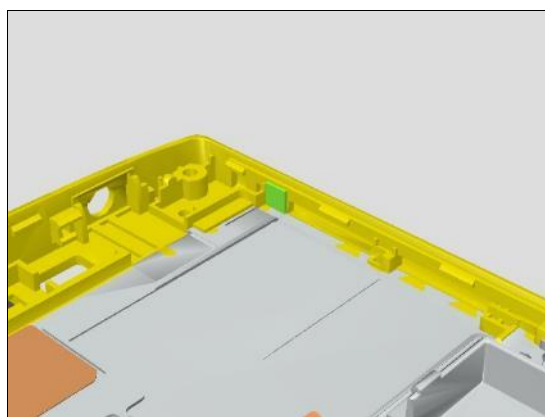
Remove the Main FPC from the Front Assy and clean adhesive residue.

**Scrap! The Main FPC cannot be reused!**



#### 4.14.1 Water Intrusion Label

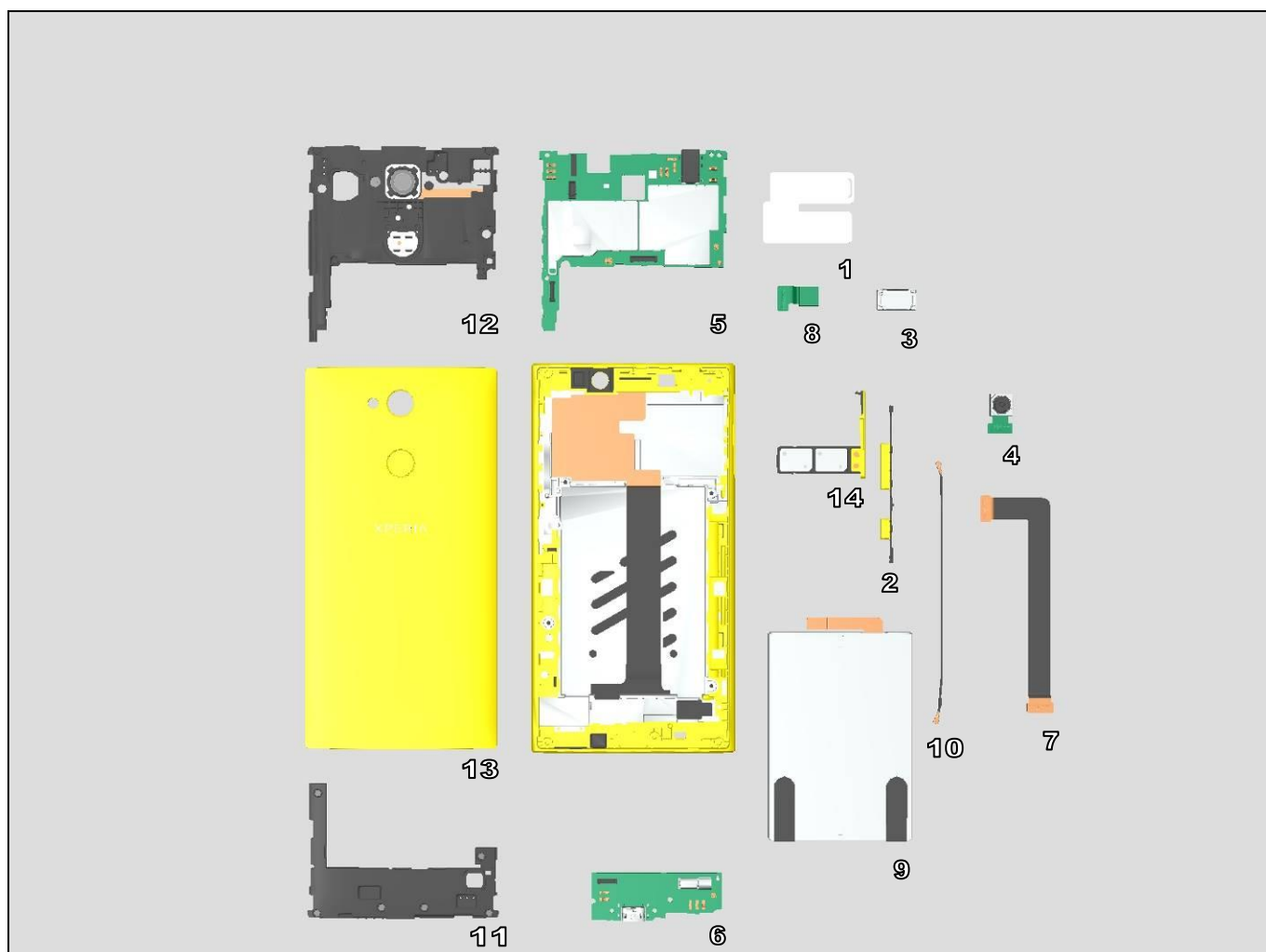
Remove the Water Intrusion Label.



## 5 Reassembly

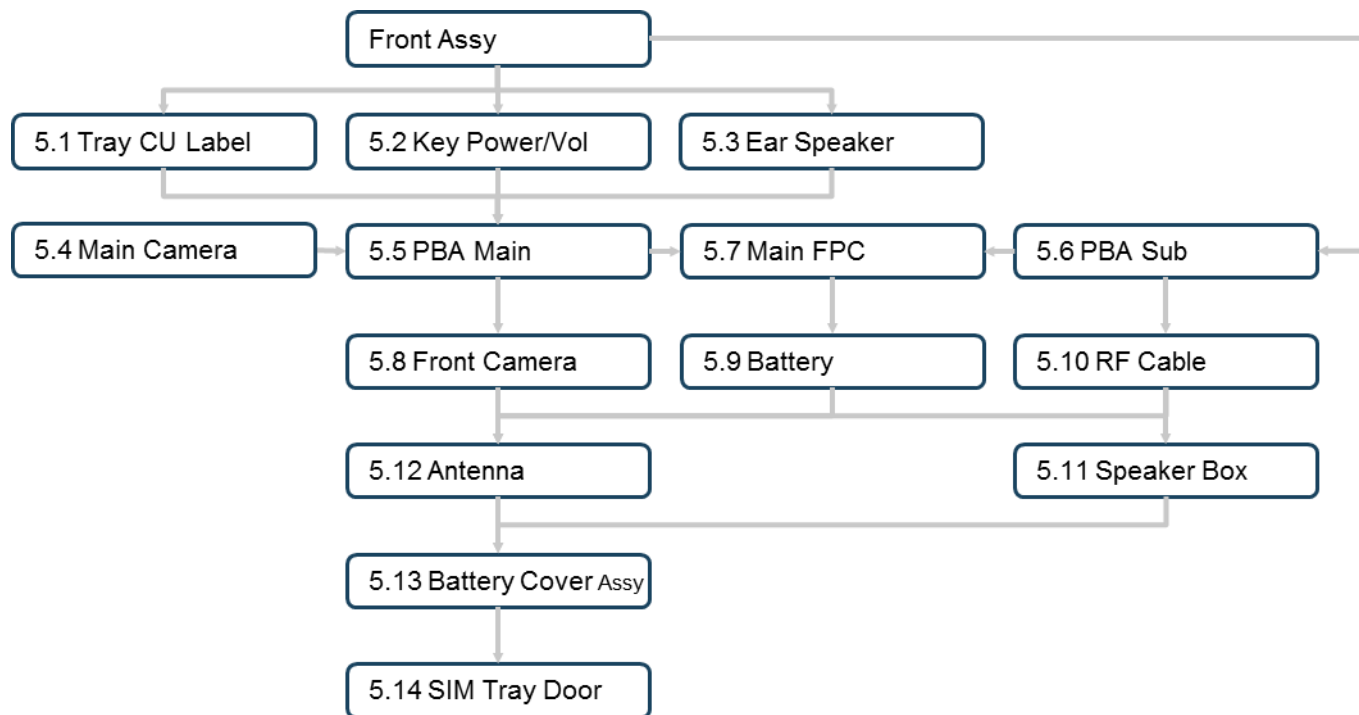
The Reassembly is done in the following order:

- |                  |                        |
|------------------|------------------------|
| 1. Tray CU Label | 8. Front Camera        |
| 2. Key Power/Vol | 9. Battery             |
| 3. Ear Speaker   | 10. RF Cable           |
| 4. Main Camera   | 11. Speaker Box        |
| 5. PBA Main      | 12. Antenna            |
| 6. PBA Sub       | 13. Battery Cover Assy |
| 7. Main FPC      | 14. SIM Tray Door      |



## Reassembly

### Quick Reference for Disassembling



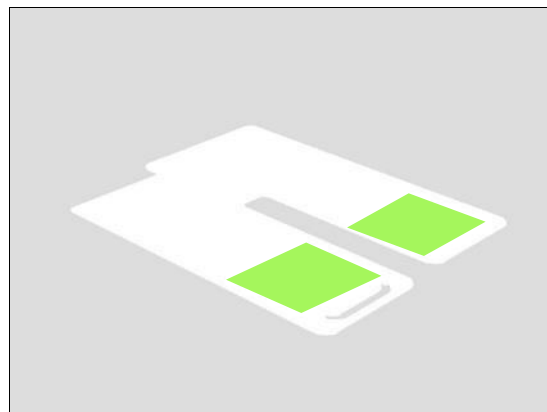
|      | Target             | Required Reassembly Steps     |
|------|--------------------|-------------------------------|
| 5.1  | Tray CU Label      | 5.1, 5, 8, 11, 13, 14         |
| 5.2  | Key Power/Vol      | 5.2, 5, 8, 11, 13, 14         |
| 5.3  | Ear Speaker        | 5.3, 5, 8, 11, 13, 14         |
| 5.4  | Main Camera        | 5.4, 5, 8, 11, 13, 14         |
| 5.5  | PBA Main           | 5.5, 8, 11, 12, 13, 14        |
| 5.6  | PBA Sub            | 5.6, 11, 13, 14               |
| 5.7  | Main FPC           | 5.6, 7, 9, 10, 11, 12, 13, 14 |
| 5.8  | Front Camera       | 5.8, 12, 13, 14               |
| 5.9  | Battery            | 5.9, 11, 12, 13, 14           |
| 5.10 | RF Cable           | 5.10, 11, 12, 13, 14          |
| 5.11 | Speaker Box        | 5.11, 13, 14                  |
| 5.12 | Antenna            | 5.12, 13, 14                  |
| 5.13 | Battery Cover Assy | 5.13, 14                      |
| 5.14 | SIM Tray Door      | 5.14                          |

## Reassembly

### 5.1 Tray CU Label

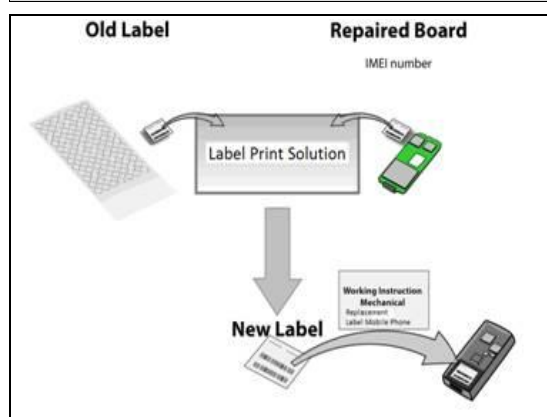
#### 5.1.1 Label MOP

Paste the Label MOP to the Tray CU Label to its proper position as shown in picture if replacement is required.

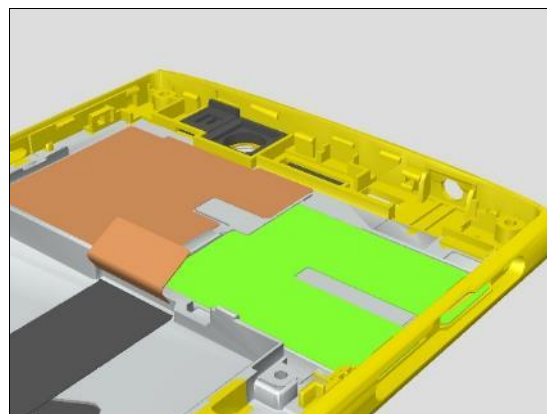


When replacing the PBA Main, replace the MoP Label.

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

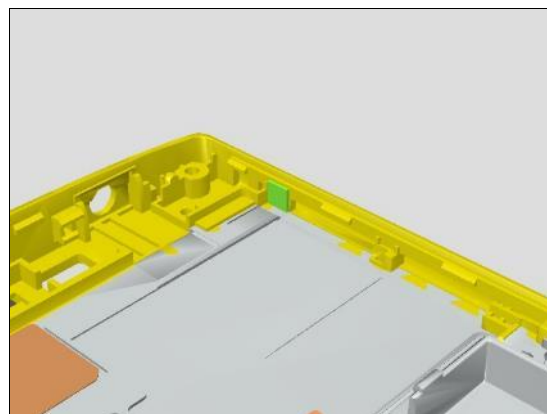


Place the Tray CU Label in its proper position as shown in picture.



#### 5.1.2 Water Intrusion Label

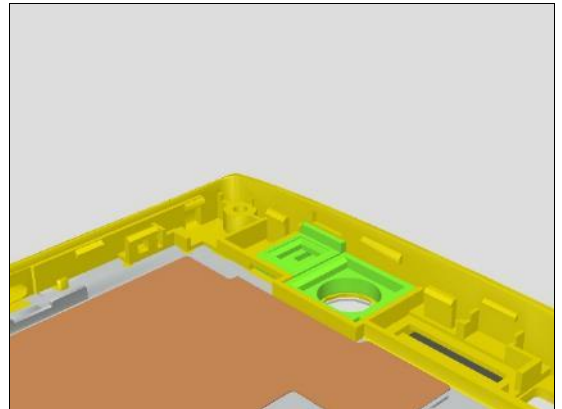
Paste the Water Intrusion label to its proper position as shown in picture if replacement is required.



## Reassembly

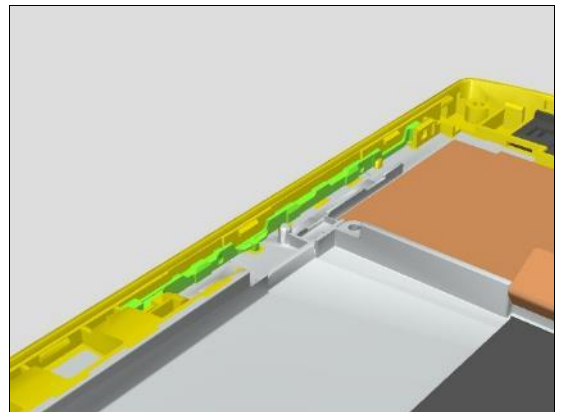
### 5.1.3 Rubber Secondary mic

Place the Rubber Secondary mic in its proper position as shown in picture if replacement is required.



### 5.2 Key Power/Vol

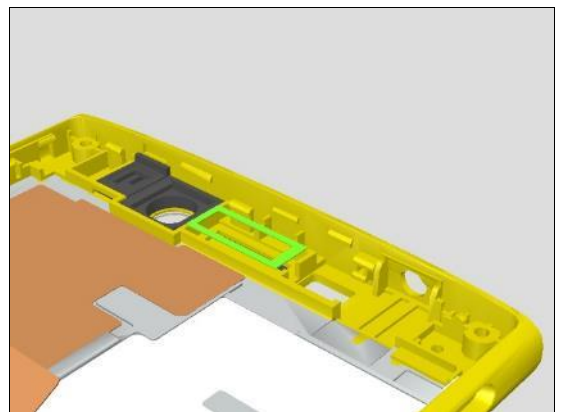
Place the Key Power/Vol in its proper position as shown in picture.



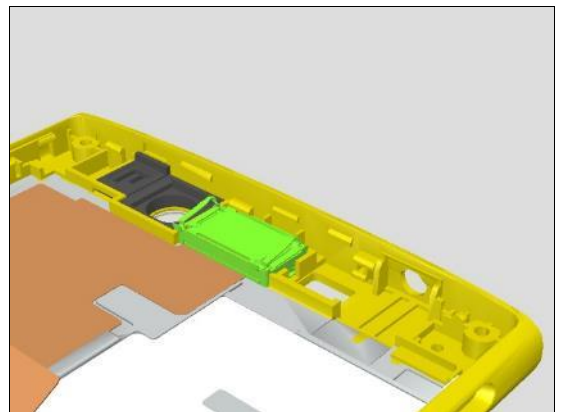
### 5.3 Ear Speaker

Paste the Adhesive Ear Speaker to Front Assy ,holding the release film tab.

Remove the release fim.



Place the Ear Speaker on its proper position as shown in picture.

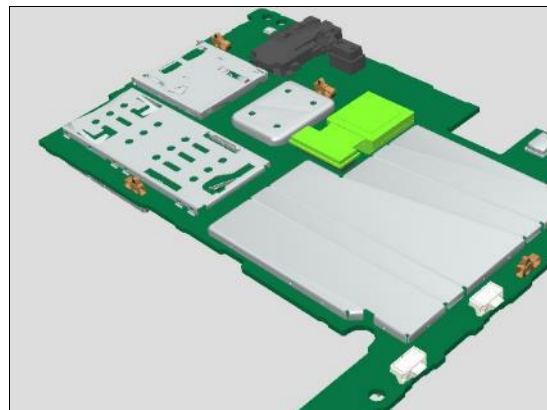




## Reassembly

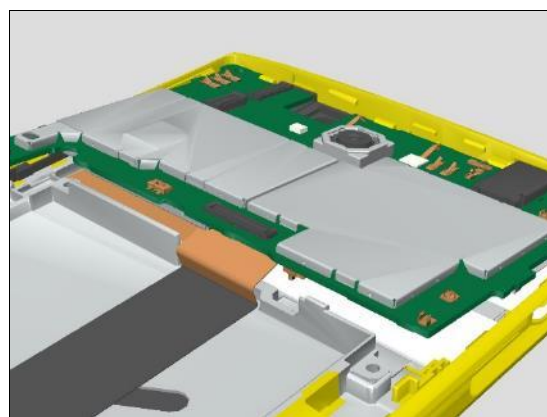
### 5.4 Main Camera

Place the Main Camera in its proper position as shown in picture and connect the BtB connector of the Main Camera.



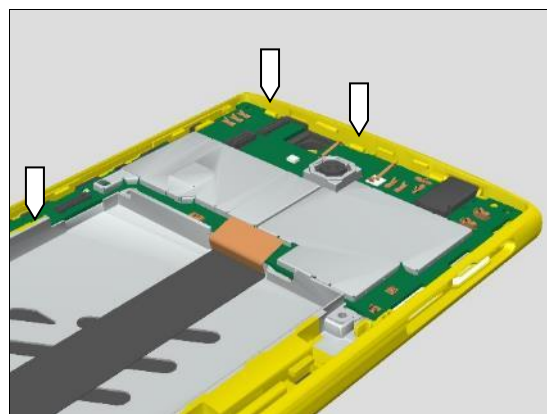
### 5.5 PBA Main

Insert the PBA Main as shown in picture.  
Make sure Audio Jack head into the hole properly.

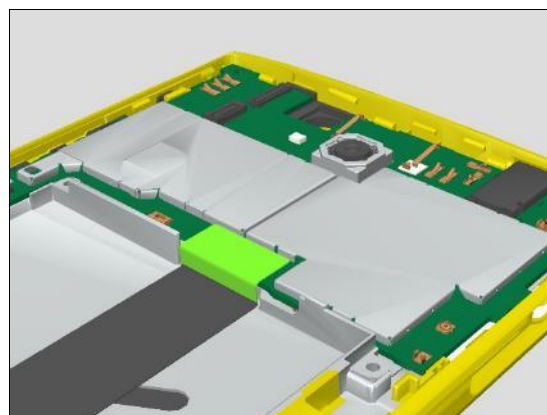


Press to secure the PBA Main by the hooks as arrows shown position.

**Be careful of not to touch Spring Pins on the edges of the PBA Main!**



connect the BtB connector of the Display FPC





## Reassembly

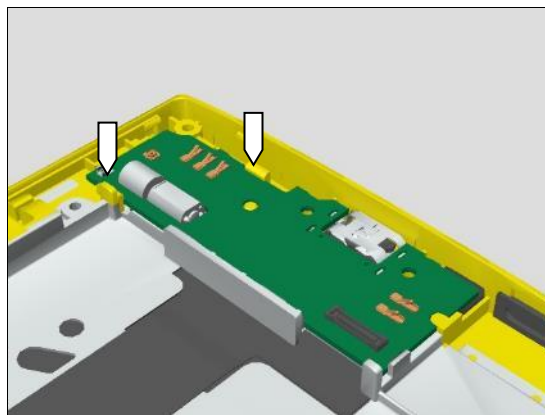
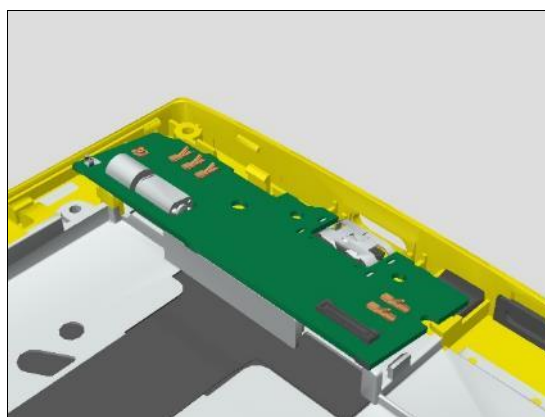
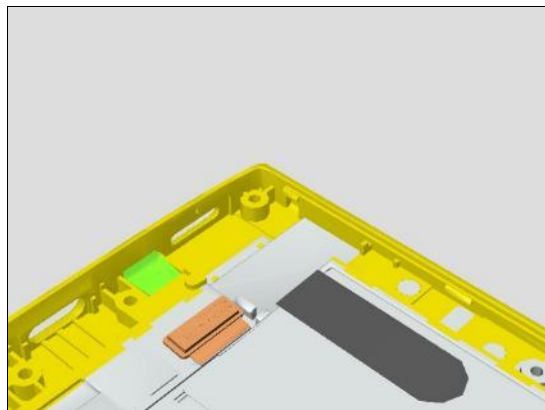
### 5.6 PBA Sub

#### 5.6.1 Rubber Main mic

Paste the Rubber Main mic in its proper position as shown in picture if replacement is required.

Insert the PBA Sub as shown in picture.  
Make sure the USB connector into the hole properly.

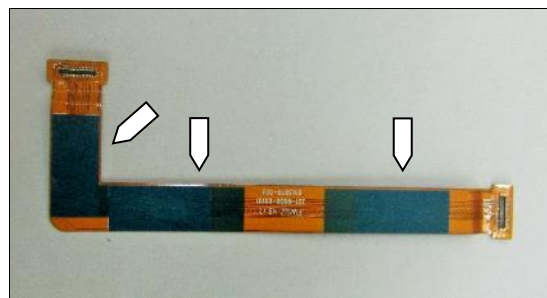
Press to secure the PBA Sub by the hooks as arrows shown position.



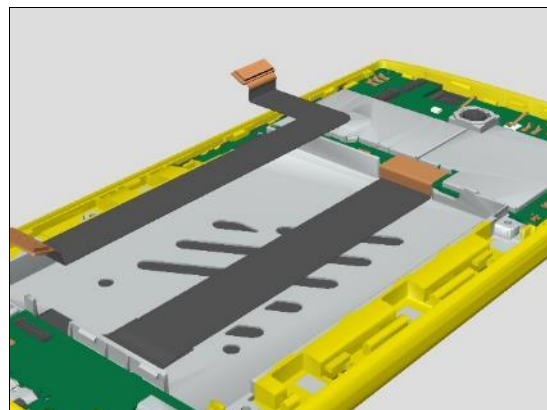
## Reassembly

### 5.7 Main FPC

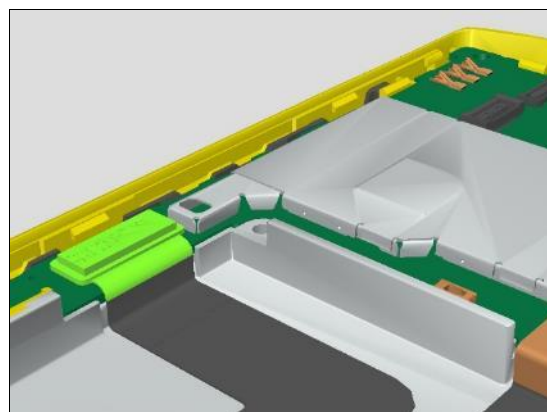
Remove the release film of the adhesives of the Main FPC as shown in picture.



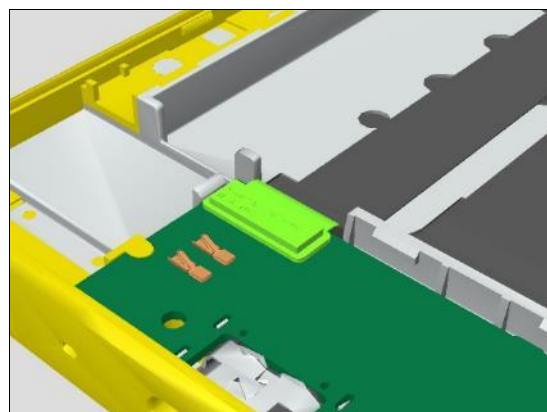
Paste the Main FPC to the Front Assy to align the BtB connectors of both sides.



Connect the BtB connector of the Main FPC.



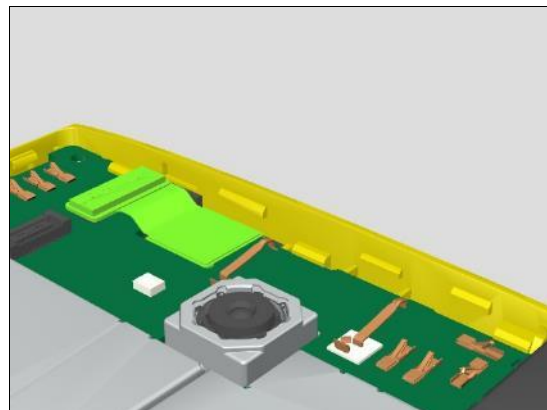
Connect the BtB connector of the Main FPC.



## Reassembly

### 5.8 Front Camera

Place the Front Camera in its proper position as shown in picture and connect the BtB connector of the Front Camera.



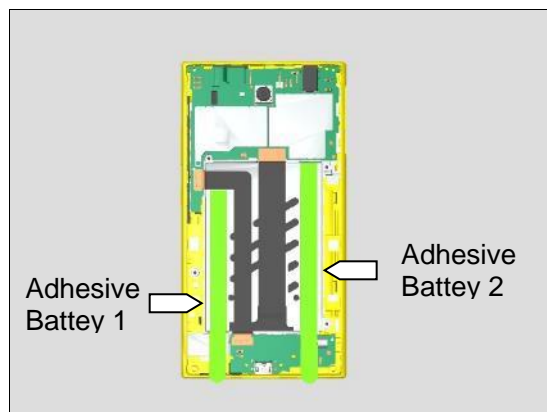
### 5.9 Battery

**Note:**

**Clean the Battery compartment by pressure air using with air duster spray can or ionized air blower. And make sure no foreign materials in the Battery compartment of the unit. Any foreign materials put into between the Battery and unit will be cause of the Battery damage.**

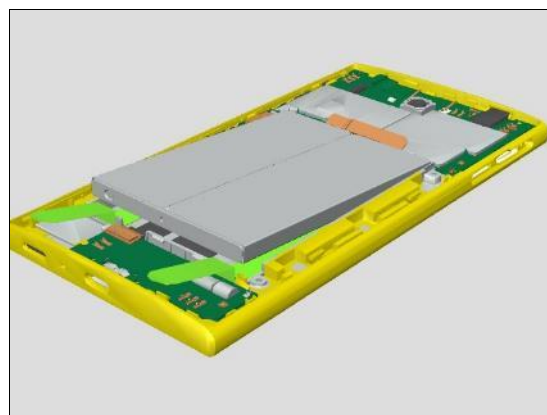


Paste the Adhesive Battery 1 and Adhesive Battery 2 as shown in picture.



Remove the release film of the Adhesive Battery 1 and the Adhesive Battery 2.

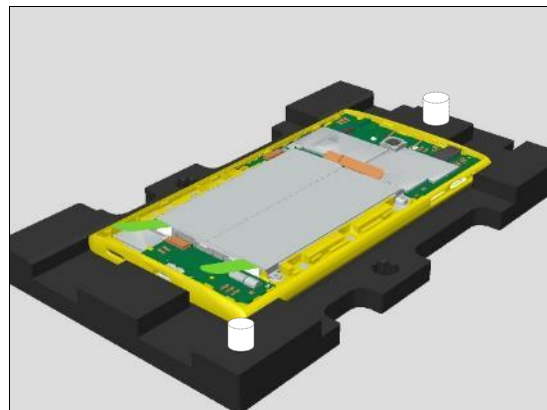
Place the Battery as shown in picture.



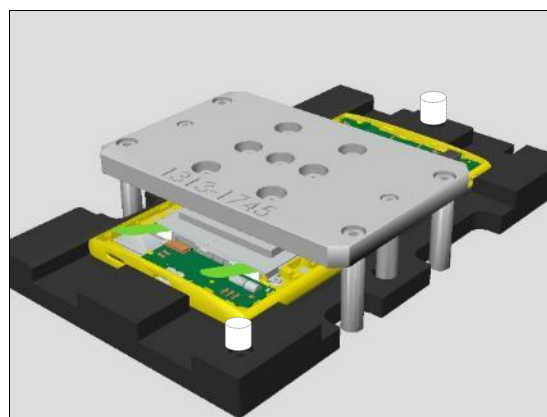
## Reassembly

Place the phone on the Press Rubber Inlay (B) as shown in picture.

**Note: Please make sure the direction of the unit against the Press Rubber Inlay.**



Place the Press Battery Inlay on top of the Battery carefully as shown in picture.



### 5.9.1 Press With the Generic Wheel Press Tool

Insert the unit to the Generic Wheel Press Tool as shown in picture.



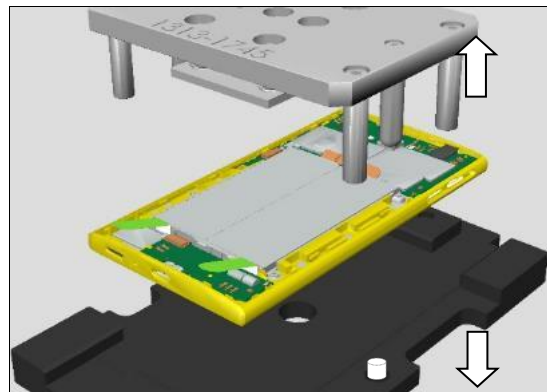
Place the unit to the Generic Wheel Press Tool as shown in picture and press the Battery on the unit.

Press Force : 200N +/-10% 30sec

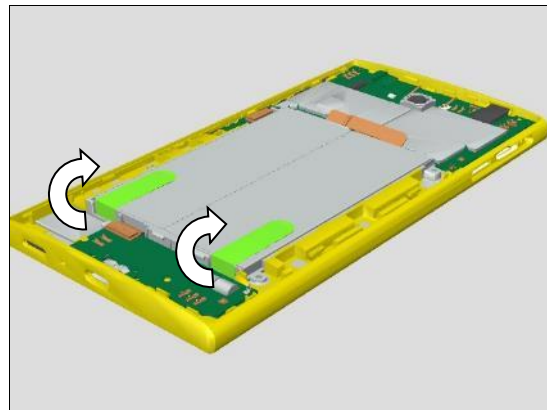


## Reassembly

Take out the unit from the Generic Wheel Press Tool and remove the Press Battery Inlay and the Press Rubber Inlay from the phone.



Remove the release film of the tab of the Adhesive Battery 1 and the Adhesive Battery 2.  
Paste them to the Battery as shown in picture.

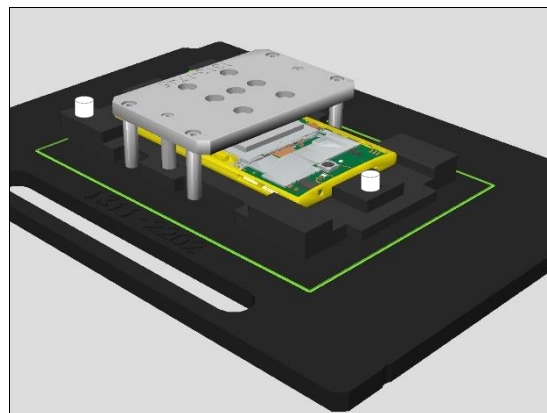


### 5.9.2 Press with the Generic Press Tool

The Battery can be pressed with the Generic Press Tool using the Inlay Adaptor.(B).

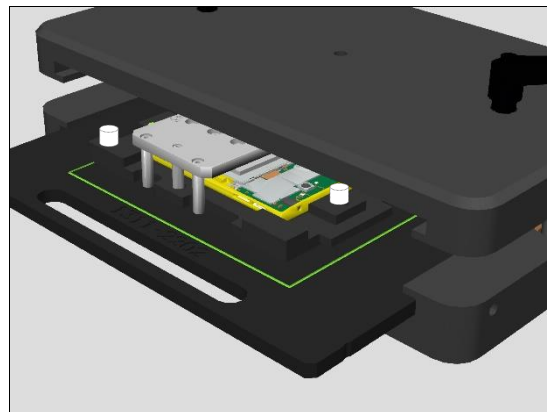
Place the unit to Inlay Adaptor (B) as shown in picture.

**Note: Please make sure the unit is within the square area as highlighted in picture.**



Inset the Inlay Adaptor (B) to the Generic Press Tool.

**Note: Please do not use the Inlay adaptor (T).**

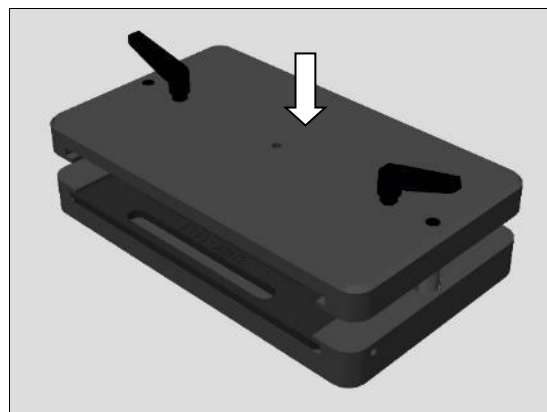




## Reassembly

Press the Battery on the unit.

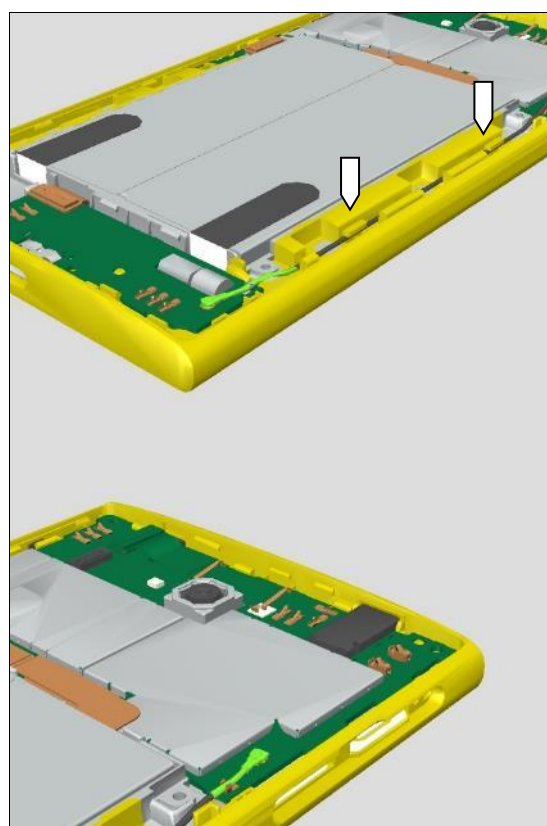
Press Force : 200N +/-10% 30sec



### 5.10 RF Cable

Place the cable as shown in picture and connect RF connector as shown in picture.

Connect RF connector with the PBA Sub and the PBA Main as shown in picture.



## Reassembly

### 5.11 Speaker Box

#### 5.11.1 Mesh Speaker

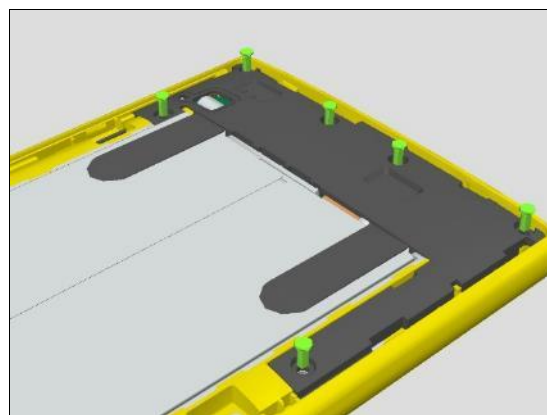
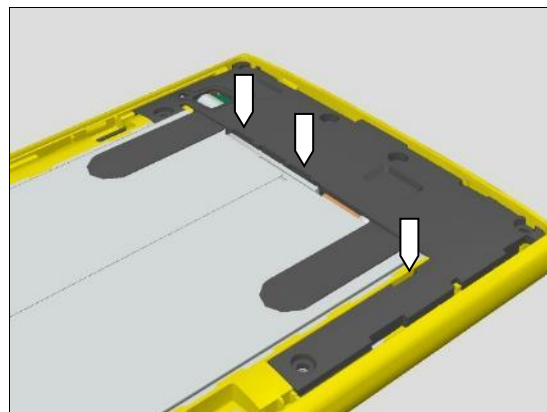
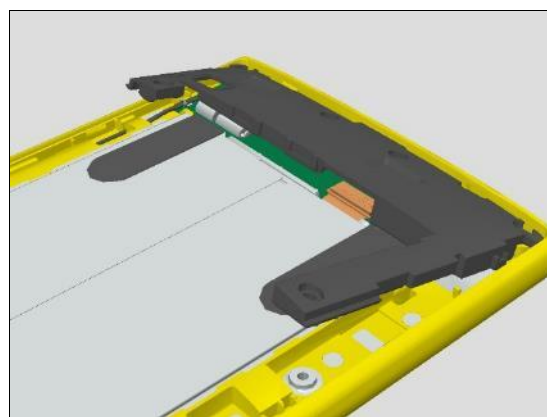
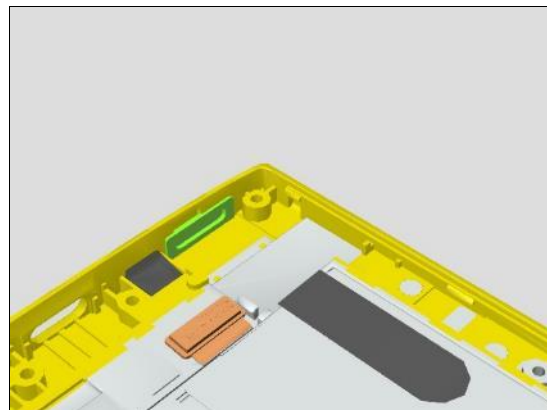
Paste the Mesh Speaker in its proper position as shown in picture if replacement is required.

Insert the Speaker Box as shown in picture.

Press to secure the Speaker Box by the hooks as arrows shown position.

Tighten 6 places of the Screw T5 1.6mm x 3.5mm with Torx Bits T5.

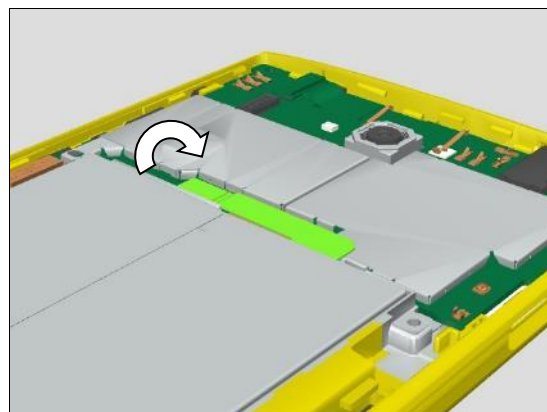
Torque:  $10 \pm 1$  [Ncm]



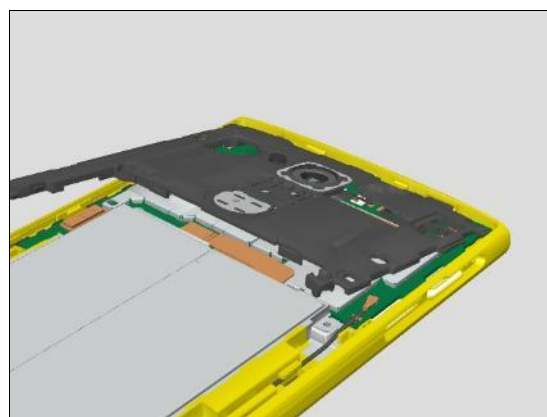
## Reassembly

### 5.12 Antenna

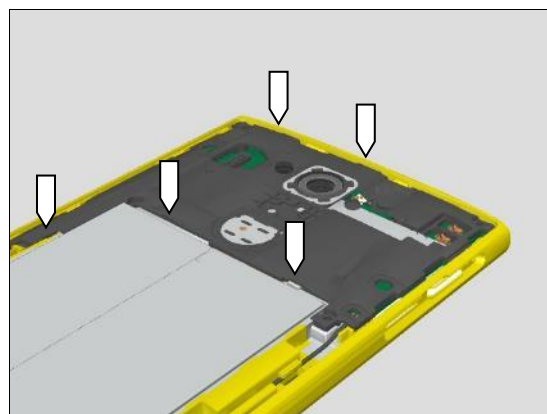
Connect the BtB connector of the Battery.



Insert the Antenna as shown in picture.

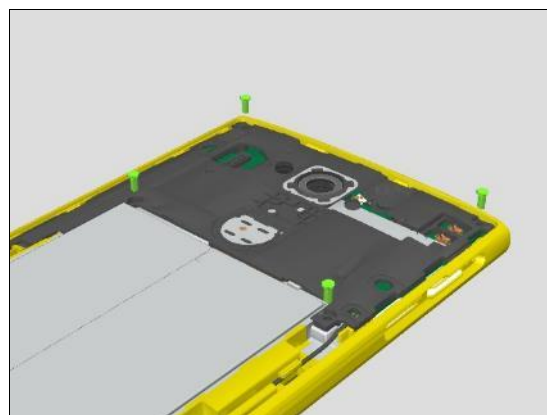


Press to secure the Antenna by the hooks as arrows shown position.



Tighten 4 places of the Screw T5 1.6mm x 3.5mm with Torx Bits T5.

Torque:  $10 \pm 1$  [Ncm]



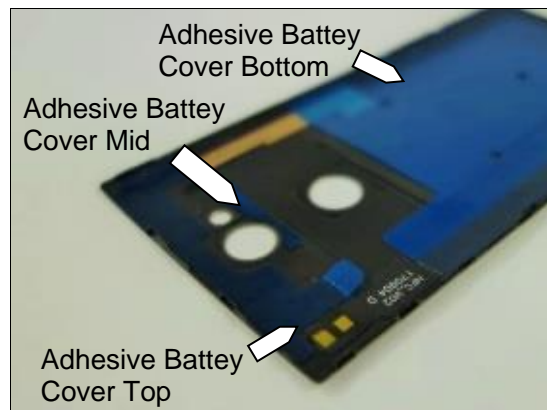


## Reassembly

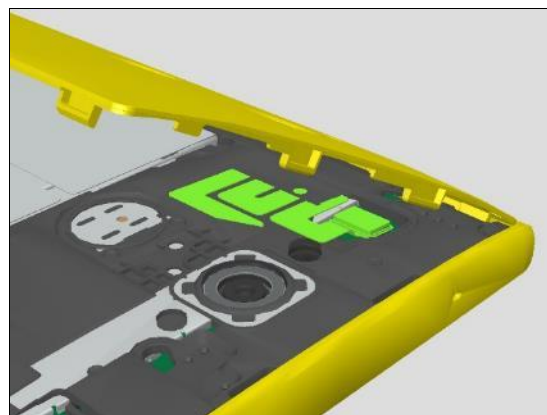
### 5.13 Battery Cover Assy

Paste the Adhesive Battery Cover Bottom / the Adhesive Battery Cover Mid / the Adhesive Battery Cover Top as shown in picture.

Remove release films.



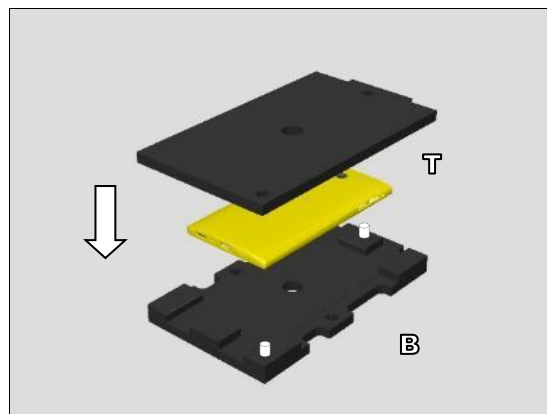
Connect BtB connector of FPS, keeping the Battery Cover Assy as shown in picture



Press to secure the Battery Cover Assy by the hooks for every edges.

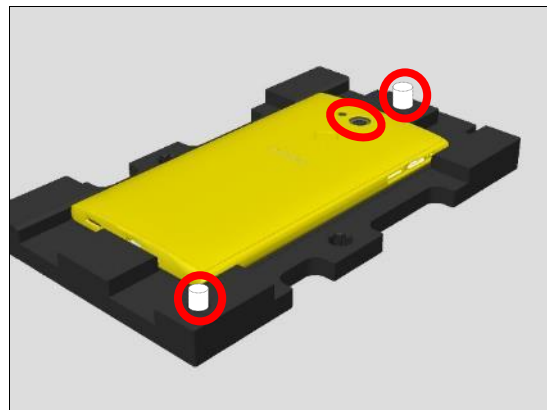


Place the unit to Press Rubber Inlay (B) then place the Press Rubber Inlay (T) on it as shown in picture.



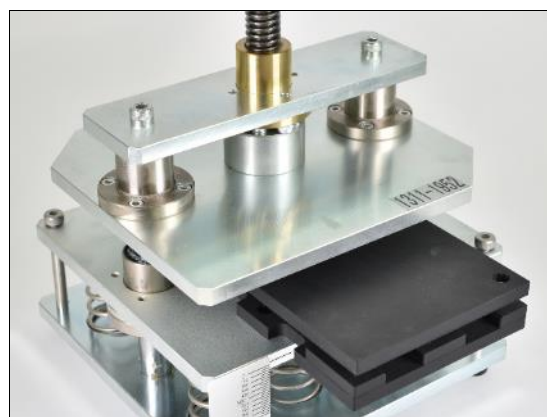
## Reassembly

**Note:** Please make sure the direction of the unit against the Press Rubber Inlay (B).



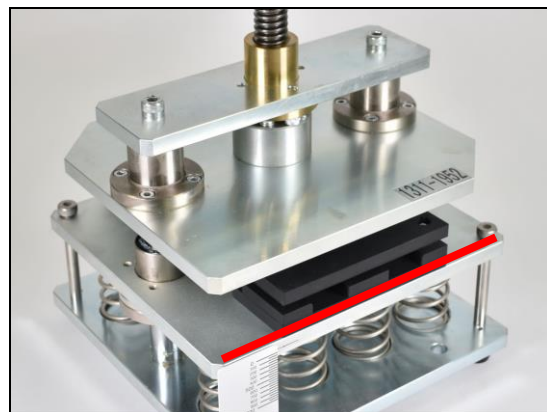
### 5.13.1 Press With the Generic Wheel Press Tool

Place the unit to the Generic Wheel Press Tool as shown in picture.



Place the unit to the Generic Wheel Press Tool as shown in picture and press the unit on the unit.

Press Force : 300N +/-10% 30sec

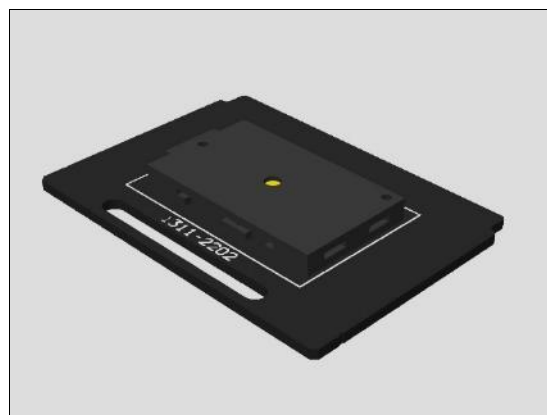


### 5.13.2 Press with the Generic Press Tool

The Battery Cover can be pressed by the Generic Press Tool with the Inlay Adaptor.

After placing the phone on the Press Rubber Inlay, place the unit to Inlay Adaptor (B) as shown in picture.

**Note:** Please make sure the unit is within the square area as highlighted in picture.



## Reassembly

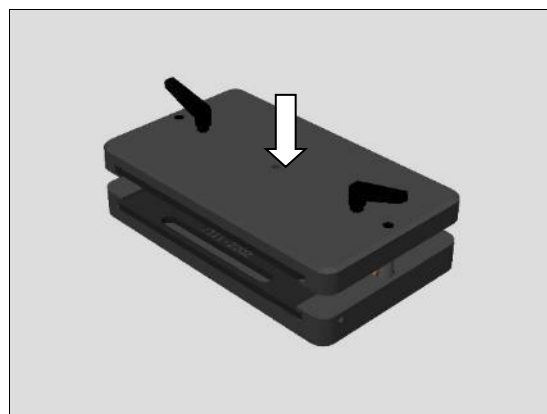
Insert the Inlay Adaptor (B) to the Generic Press Tool.



Insert the Inlay adaptor (T).to the Generic Press Tool and turn xxx.



Press the Battery on the unit.  
Press Force : 300N +/-10% 30sec



### 5.14 SIM Tray Door

Inset the Sim Tray Door.



## 6 Battery Reuse Instruction

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

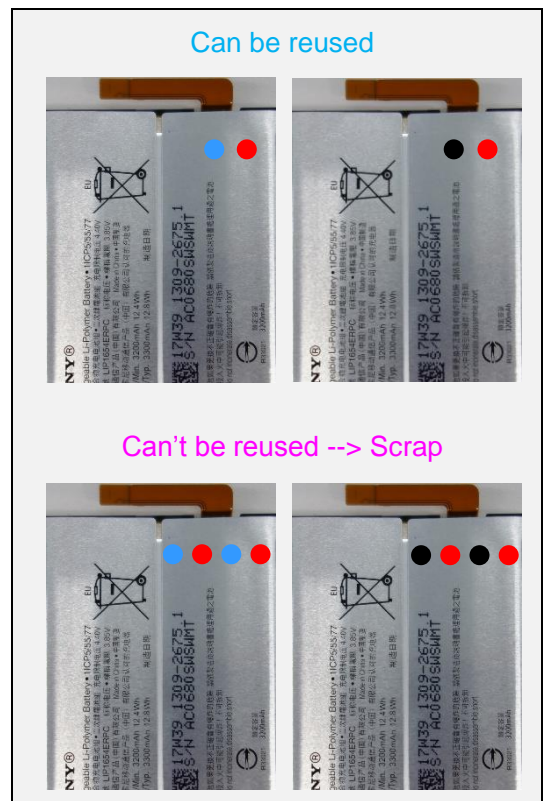
### 6.1 Battery Handling Notices

1. Don't damage the Battery foil with sharp objects.
2. Don't twist or deform the Battery.
3. If the Battery is dropped, don't reuse, and scrap.
4. Hold the Battery at the edge as shown in picture.



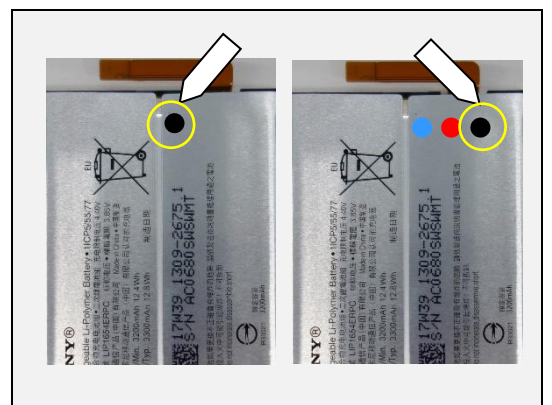
### 6.2 Dot Mark Check

Check if the Battery (which has been removed from the unit) has blue/red or black/red dots marking.  
Do not reuse, if the Battery has two (2) red dots marking, and scrap it.  
Blue and black dot indicates the Battery had been removed from the unit, and red dot indicates the Battery had been reinstalled (reused).  
Scrap! If the Battery has two (2) red dots marking, it can't be reused for third times.



### 6.3 Dot Marking 1

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



## Battery Reuse Instruction

### 6.4 Appearance Check

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

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

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

### Definition of Damages and Sample Pictures

#### Wrinkle:

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



#### Mark:

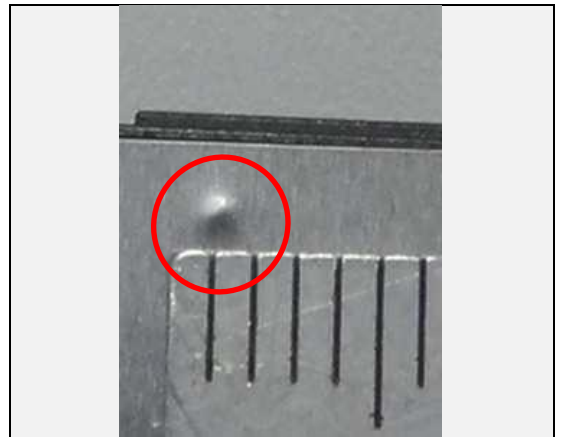
Surface is bulged as lined by foreign material is located between Al sheet and the Battery cell housing.



## Battery Reuse Instruction

### **Bubble:**

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



### **Dent:**

It is caused that is stuck by sharp pointed objects.



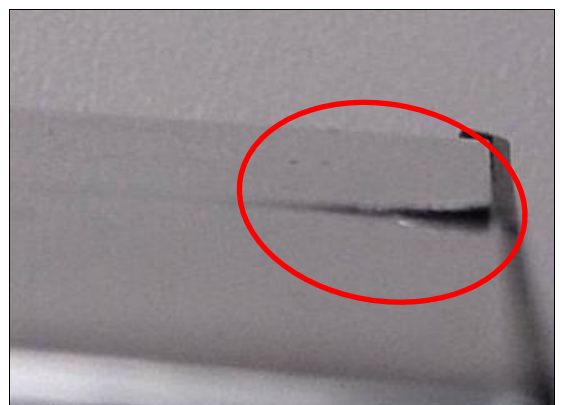
### **Scratch:**

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



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

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





## Battery Reuse Instruction

### **Twist:**

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



### **Line:**

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

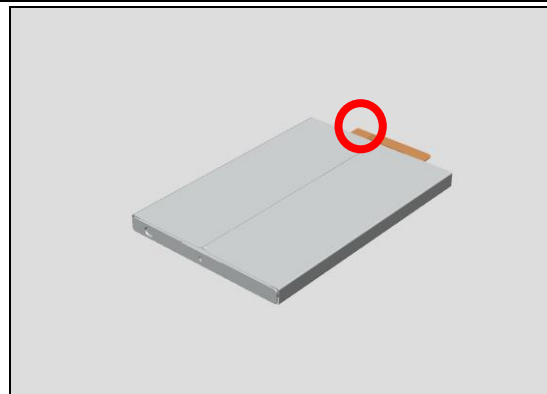


## Battery Reuse Instruction

### 6.5 BtB Connector Check

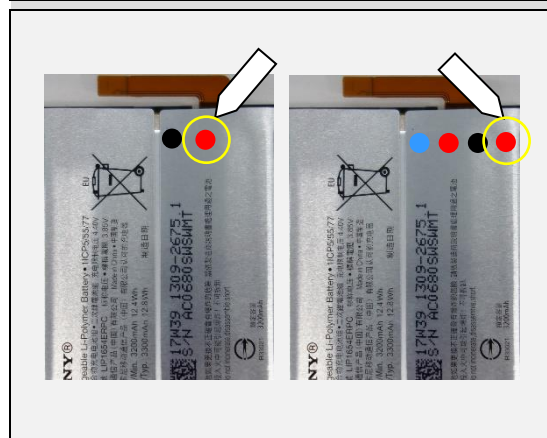
Check if BtB connector has damages.

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



### 6.6 Dot Marking 2

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

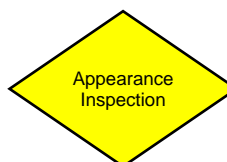


### Overall procedure for Battery Reusing

Check if the Battery has dot marking.

Put black dot.

Put red dot.



Pass

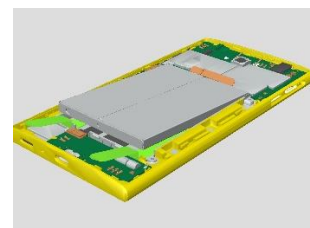


Fail

Scrap



Install on the unit.





## 7 Revision History

| Rev. | Date        | Changes / Comments |
|------|-------------|--------------------|
| 1    | 2018-Jan-12 | Initial release    |