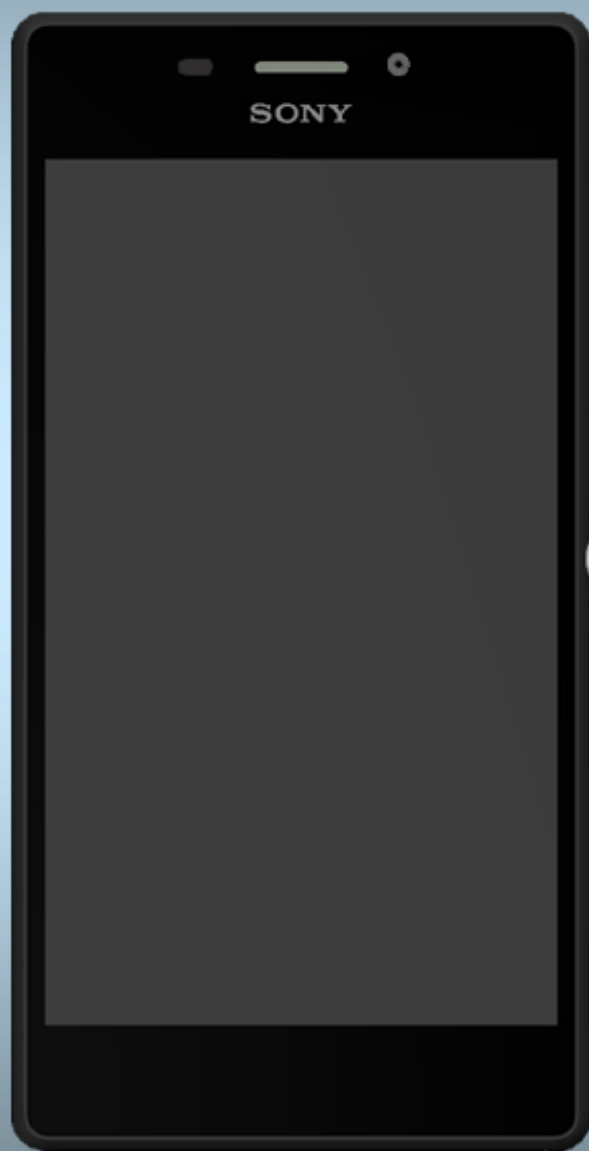


SONY

make.believe

Working Instructions

- mechanical -



Xperia M2

D2302, D2303, D2305, D2306, S50h

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

1 Exterior Views

1.1 D2302, D2303, D2305, D2306, S50h

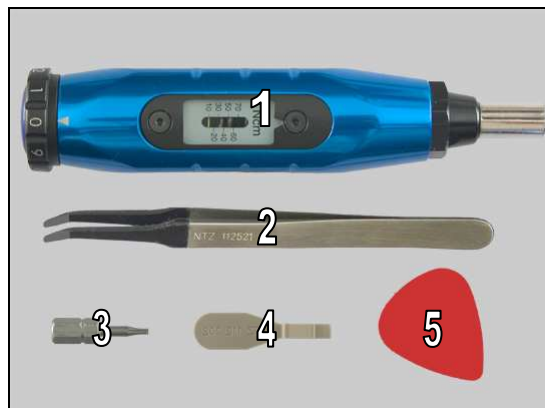
(Note: DS: Dual SIM card-- D2302, S50h; SS: Single SIM card—D2303, D2305, D2306)



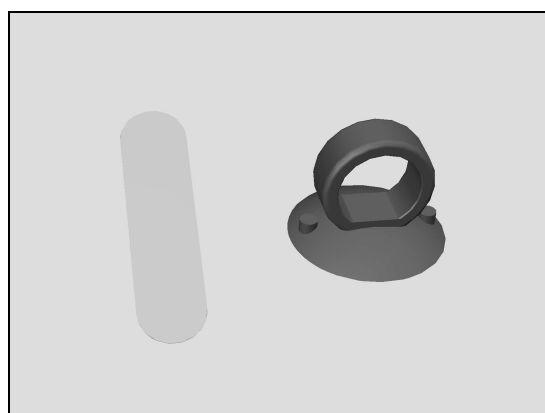
2 Tools

SPECIAL TOOLS

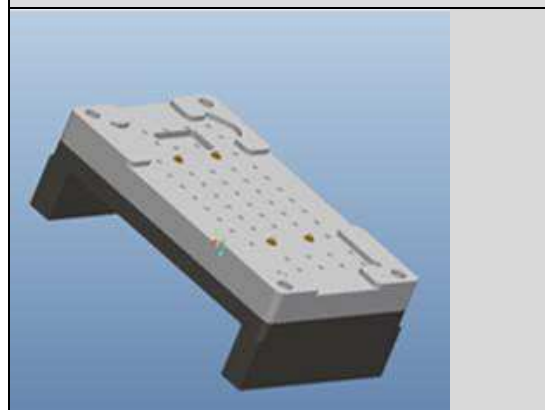
1. Torque Screwdriver
2. Flex Film Assembly Tool
3. Bits (T5)
4. Front Opening Tool
5. Guitar Pick



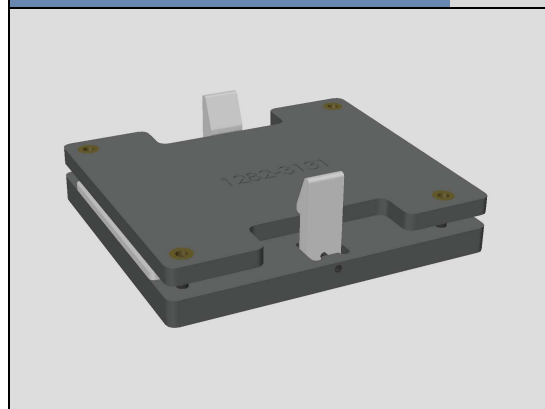
6. Flexible Disassembly tool(1284-7796)
7. Suction cup



8. Assembly fixture for BC Adhesive1 Battery Cover(1283-9600)



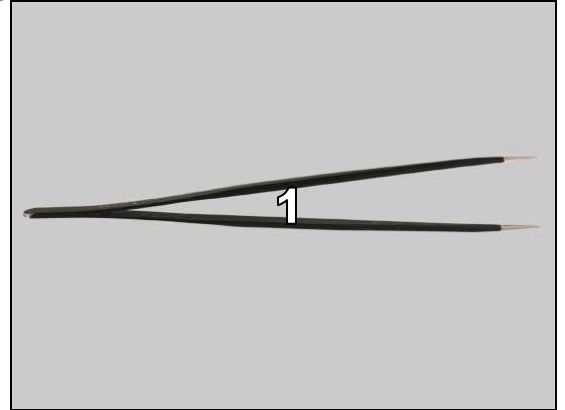
10. Battery Cover Press Fixture(1282-3131)



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

STANDARD TOOLS

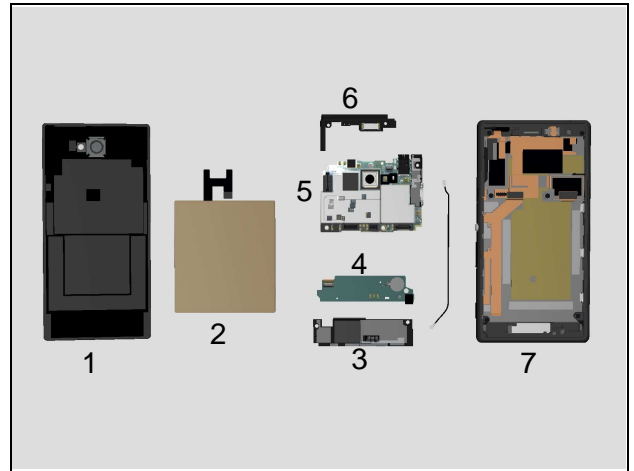
1. Tweezers



3 Disassembly

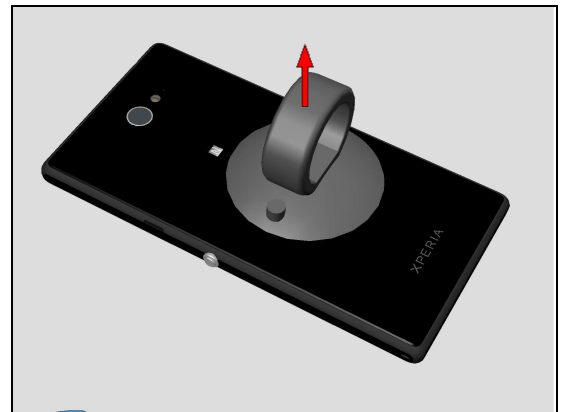
The disassembly is done in the following order:

1. Battery Cover Assy
2. Embedded Battery Assy
3. Main ANT Assy
4. Sub Board Assy
5. Main PBA
6. Antenna DIV
7. Front Cover LCM TP Assy



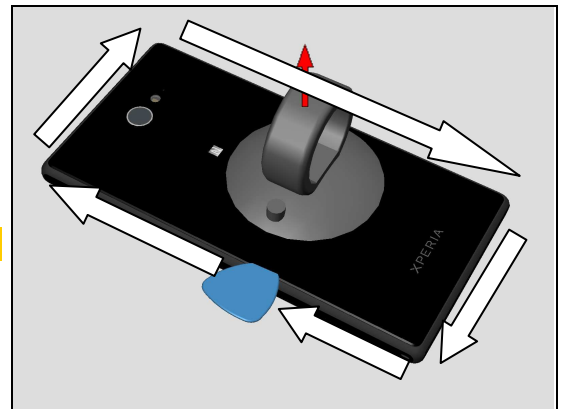
3.1 Battery Cover Assy

Use Suction cup to get space for inserting the Guitar Pick.

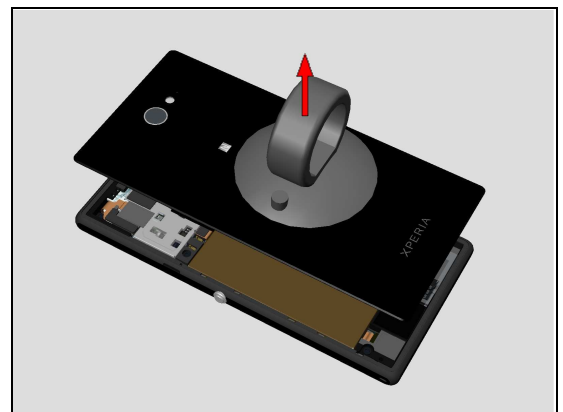


Gently slide the Guitar Pick along to release all sides of the Battery Cover Assy.

Note! Start in the middle of the left long side!

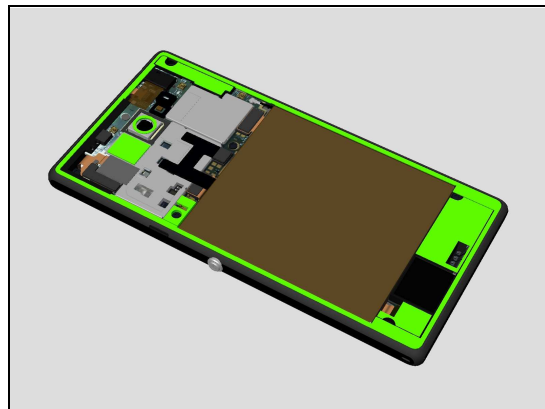


Remove the Battery Cover Assy by using the Suction cup.



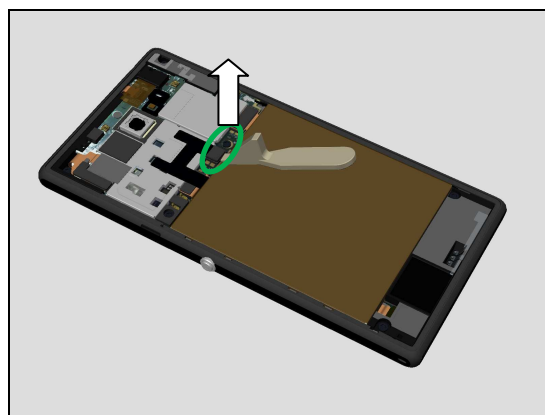
Disassembly

Note! Be careful when removing the Battery Cover Assy due to the adhesive between Battery Cover Assy and Core Unit as shown.

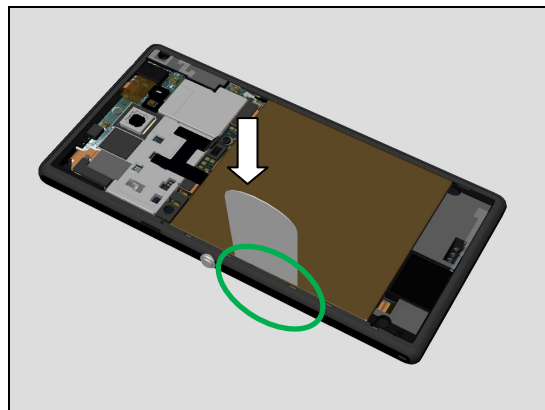


3.2 Embedded Battery Assy

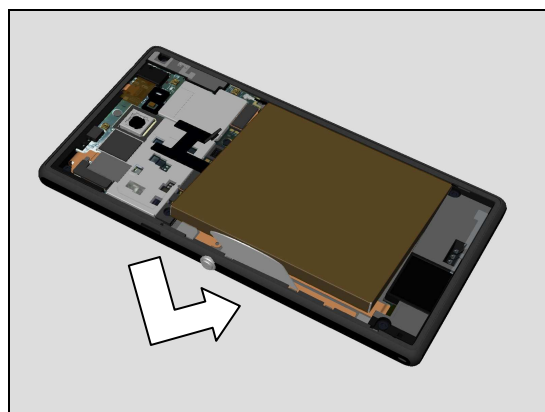
Open the BtB connectors of Embedded Battery Assy using Front Opening tool.



Insert Flexible Disassembly tool underneath Embedded Battery Assy as shown.

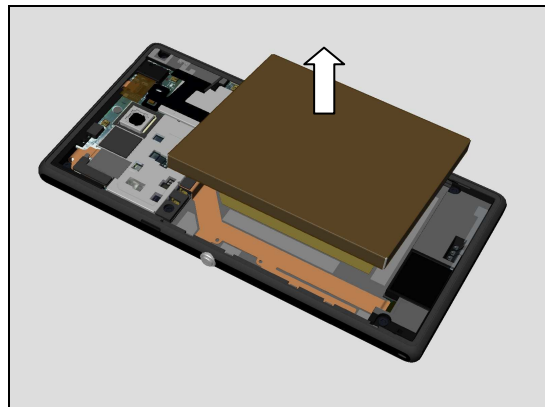


Flexible Disassembly tool is Inserted flexibly underneath Embedded Battery Assy as shown.



Disassembly

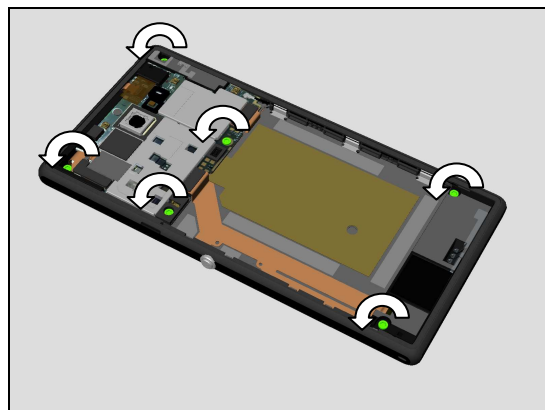
Remove the Embedded Battery Assy.



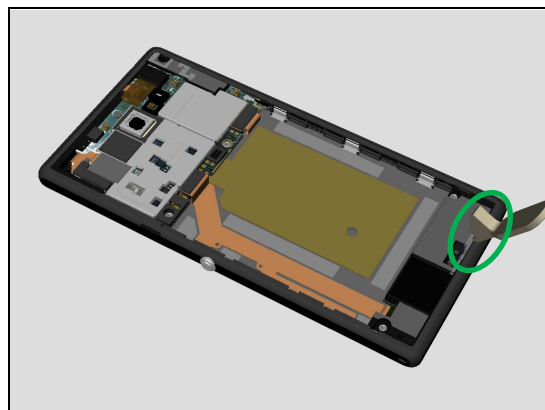
3.3 Main ANT Assy

Remove these six Screws by using a screwdriver with Bits (T5).

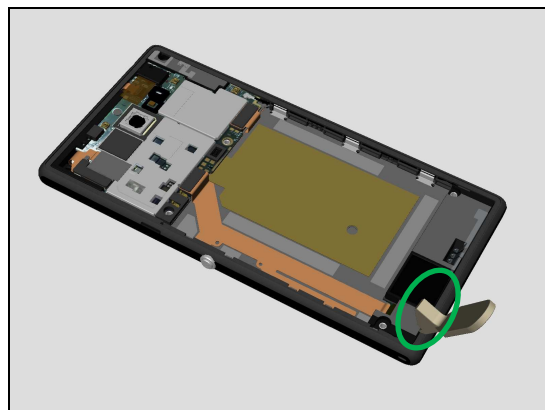
Scrap! Not to be reused!



Insert Front Opening Tool to release Main ANT Assy.

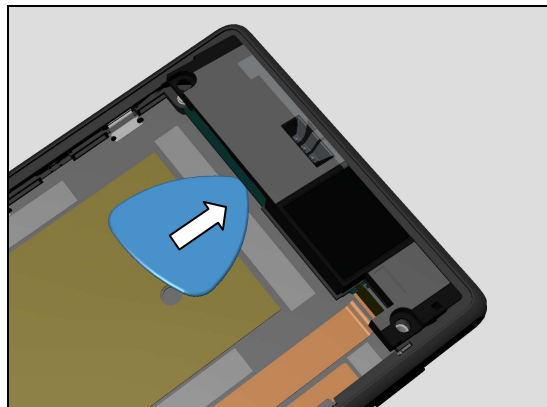


Insert Front Opening Tool to release Main ANT Assy.

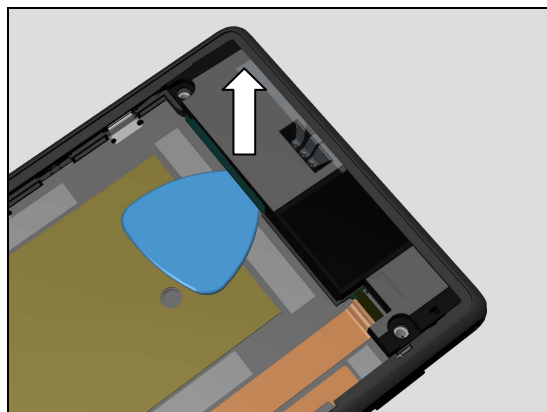


Disassembly

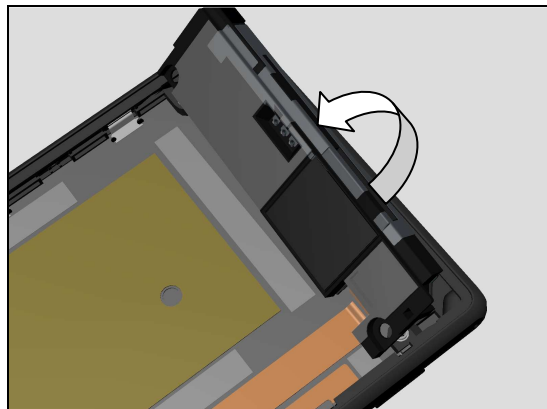
Insert Guitar Pick under Main ANT Assy.



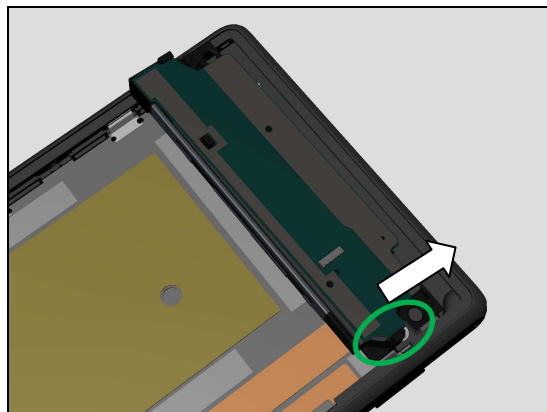
Lift up Main ANT Assy bottom side to release it.



Turn over the Main ANT Assy as shown.

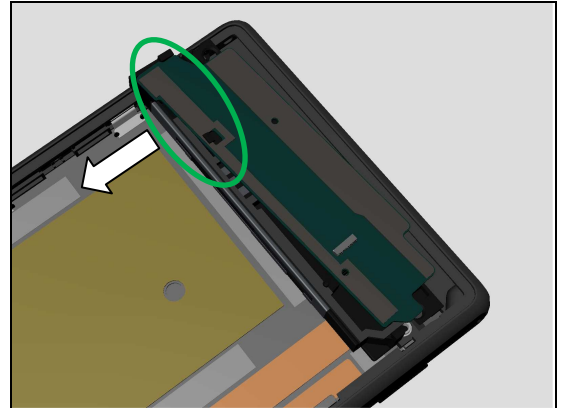


Push Sub Board Assy as shown to release its hook.

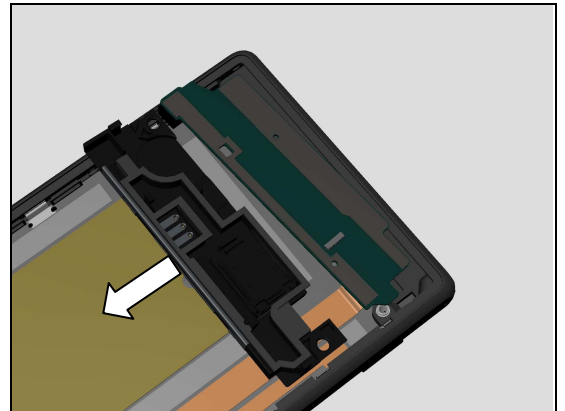


Disassembly

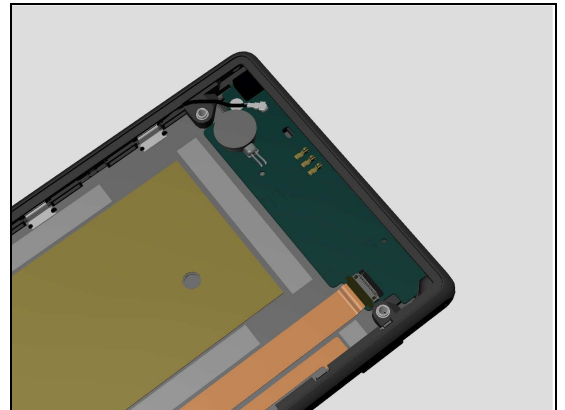
Release the other side hooks of Main ANT Assy.



Remove the Main ANT Assy.



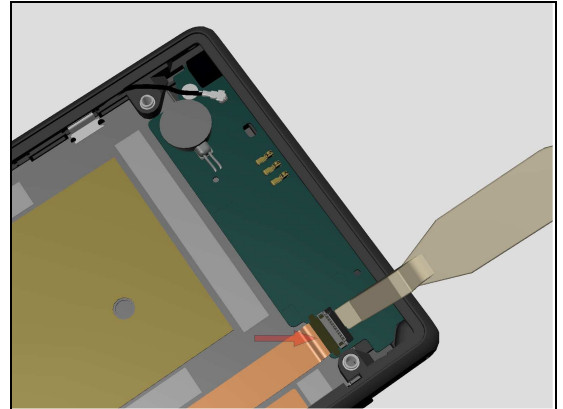
Turn over Sub Board Assy back on Core unit.



Disassembly

3.4 Sub Board Assy

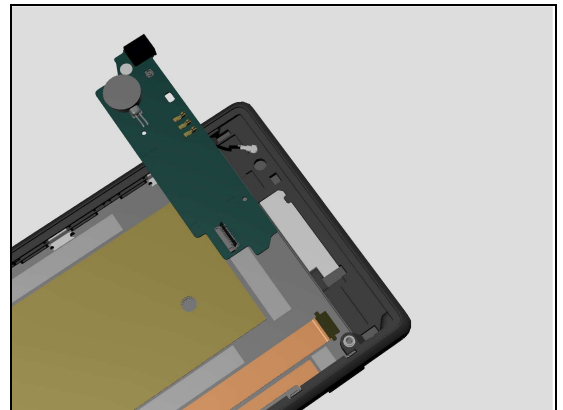
Open the ZIF connector on Sub Board Assy and pull FPC out.



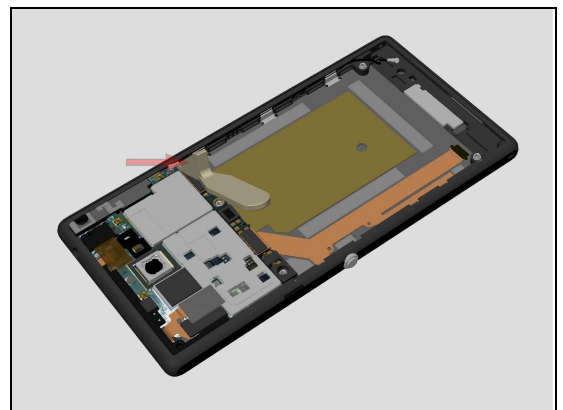
Open the RF Cable connector on Sub Board Assy.



Remove the Sub Board Assy.

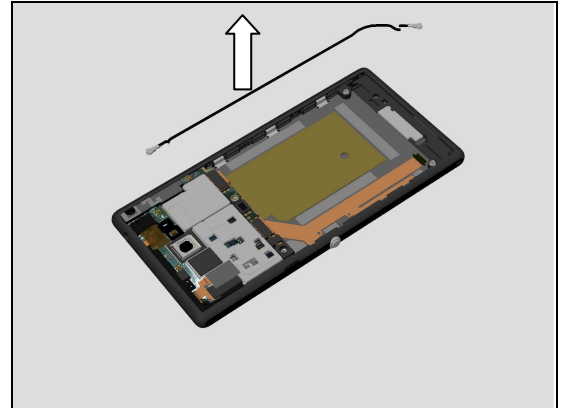


Open the RF Cable connector on Main PBA.



Disassembly

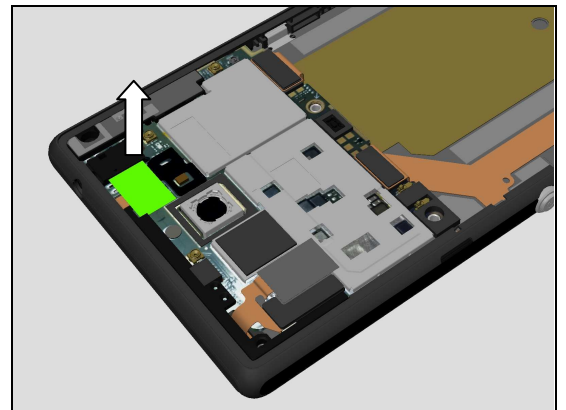
Remove the RF Cable.



3.5 Main PBA

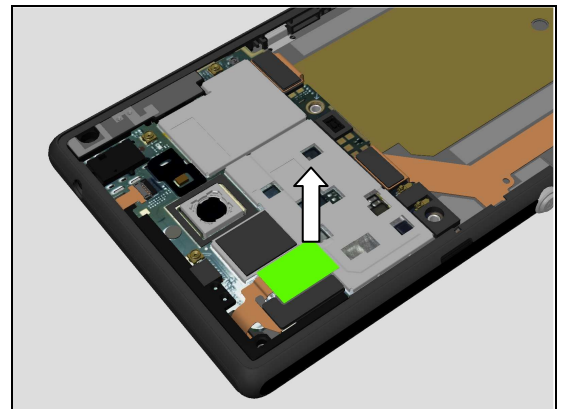
Remove the Yellow film on PL ZIF connector as shown in Picture.

Scrap! Not to be reused!

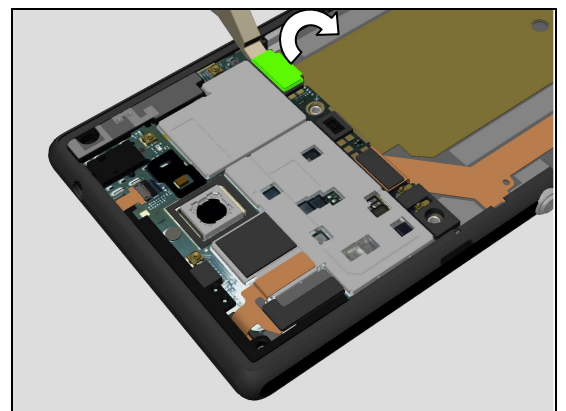


Remove the ESD Cloth TP BTB as shown in Picture.

Scrap! Not to be reused!

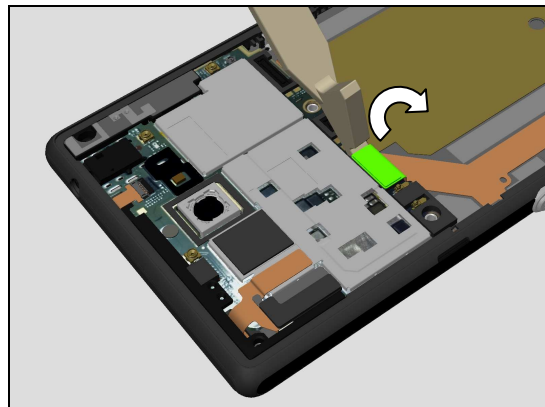


Open the SIM FPC Assy BtB connector on Main PBA.

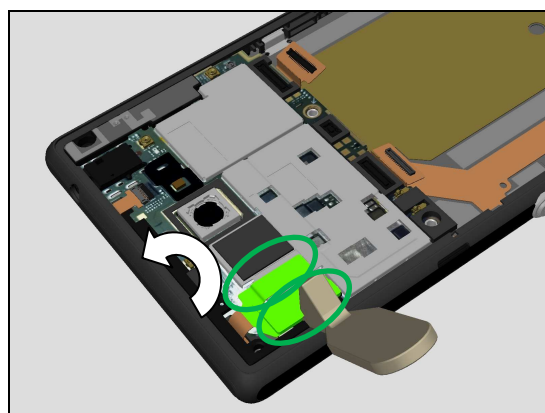


Disassembly

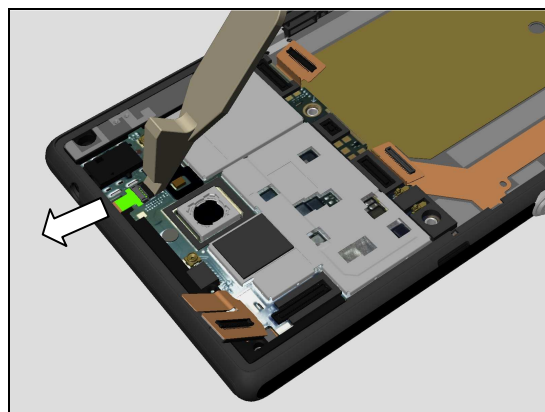
Open the Side Key FPC BtB connector on Main PBA.



Open the Touch Panel FPC BtB connector on Main PBA.
Release the adhesive FPC from Main PBA.

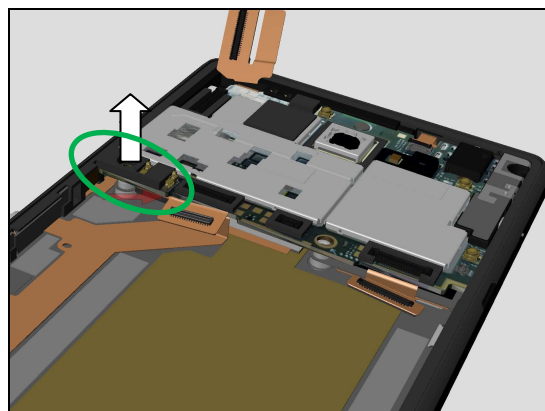


Open the PL Sensor FPC ZIF connector using Front Opening Tool and pull FPC out.



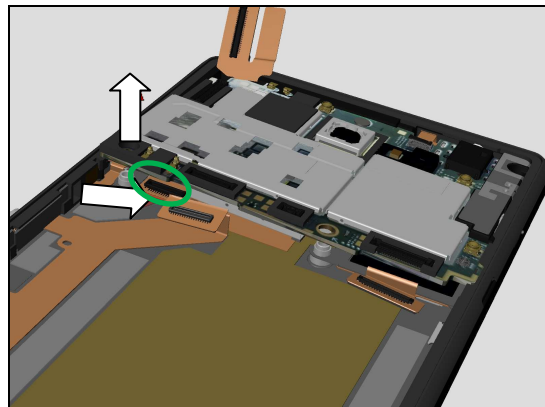
Lift up Left bottom corner of Main PBA carefully by hand about 5mm to show LCM BtB connector under Main PBA.

Be careful! Not to damage Main PBA.



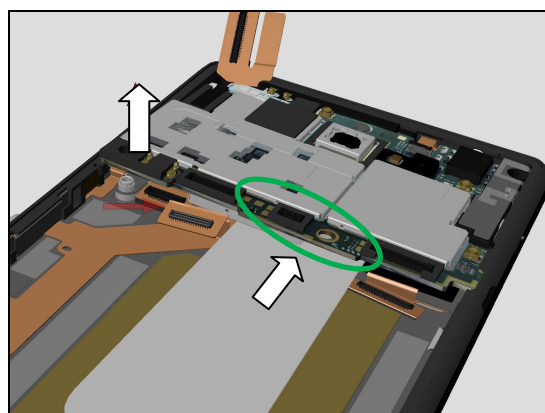
Disassembly

Open the LCM BtB connector under Main PBA.

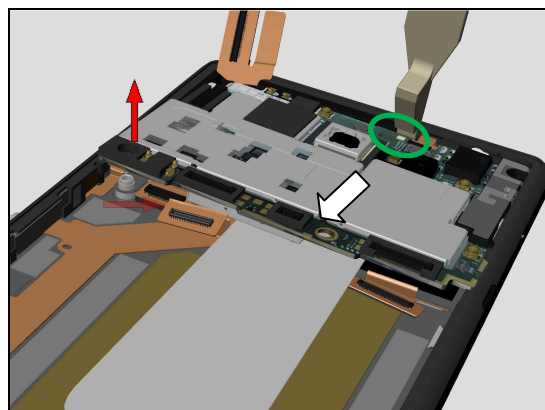


Insert the Flexible Disassembly tool between screw pillar and Main PBA.

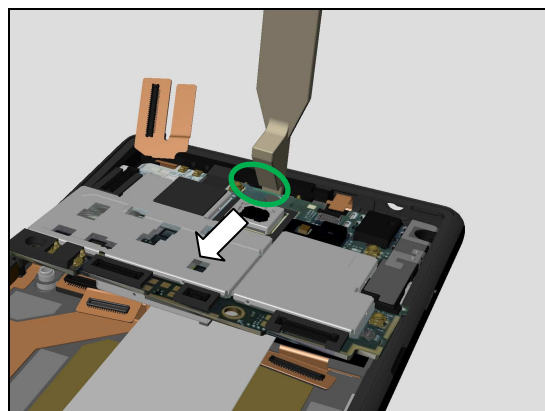
Be careful! Not to damage FPC inside.



Insert Front Opening Tool as shown to release Main PBA from Antenna DIV.

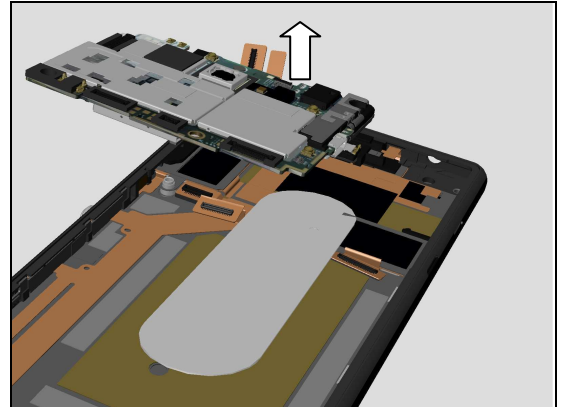


Insert Front Opening Tool as shown to release Main PBA from Antenna DIV.

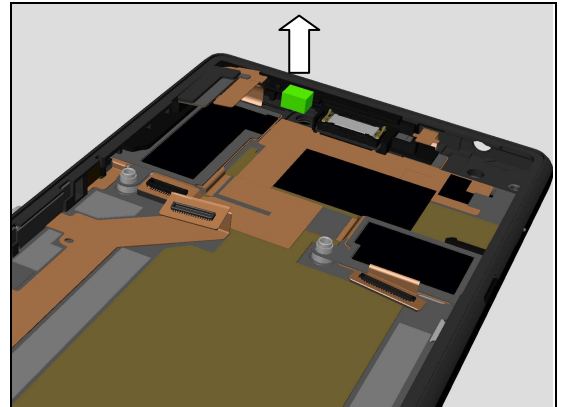


Disassembly

Remove the Main PBA.

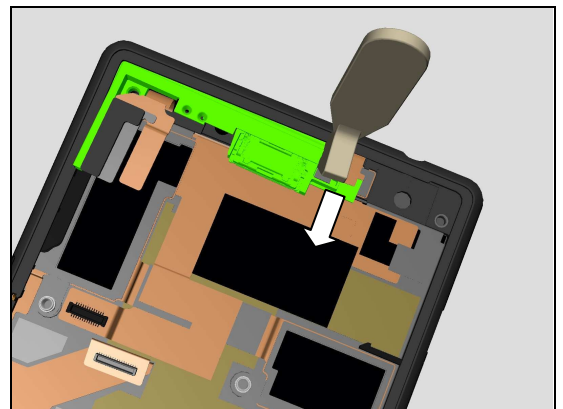


Remove the Foam Front Camera.

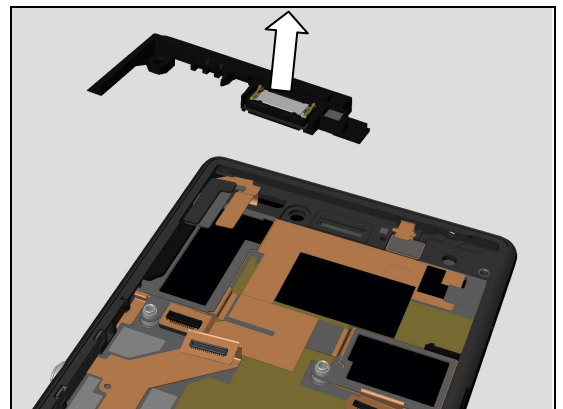


3.6 Antenna DIV

Insert Front Opening Tool as shown to release Antenna DIV from Front Cover LCM TP Assy.



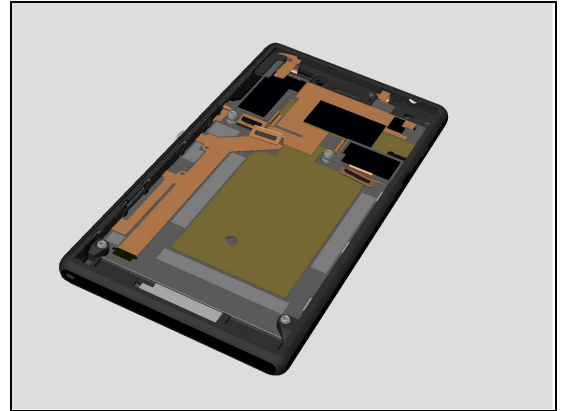
Remove the Antenna DIV.



Disassembly

3.7 Front Cover LCM TP Assy

Front Cover LCM TP Assy as shown.



4 Replacement

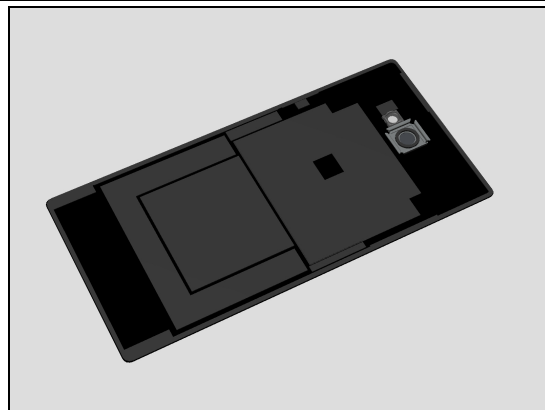
4.1 Battery Cover Assy

Follow the 3.1 Disassembly instructions!

Prepare a new Battery Cover Assy.

Follow the 5.6 Reassembly instructions!

Note: New Battery Cover Assy already have BC Adhesive1 Battery Cover and BC Adhesive5 Camera Sponge.

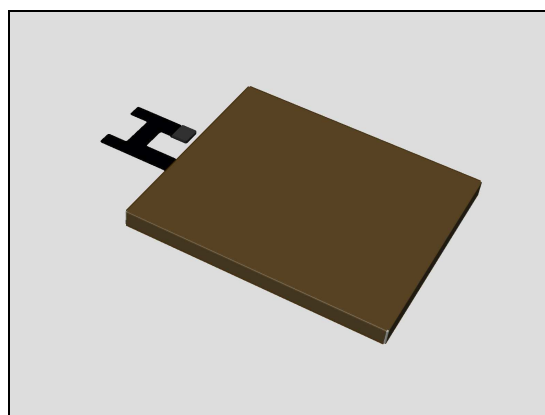


4.2 Embedded Battery Assy

Follow the 3.1 – 3.2 Disassembly instructions!

Prepare a new Embedded Battery Assy.

Follow the 5.6 -- 5.7 Reassembly instructions!



4.3 Main ANT Assy

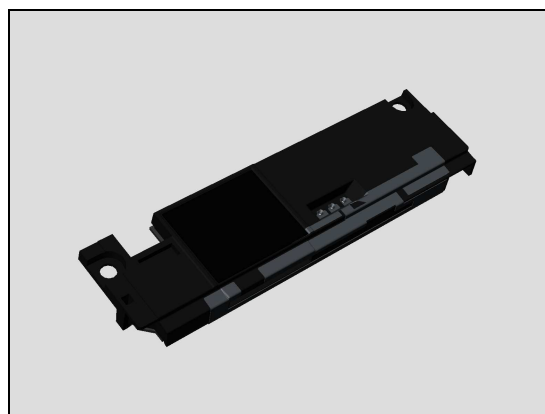
Follow the 3.1 – 3.3 Disassembly instructions!

Follow 4.39 Removal instructions.

Prepare a new Main ANT Assy.

Follow 4.39 Installation instructions.

Follow the 5.5 – 5.7 Reassembly instructions!



4.4 Sub Board Assy

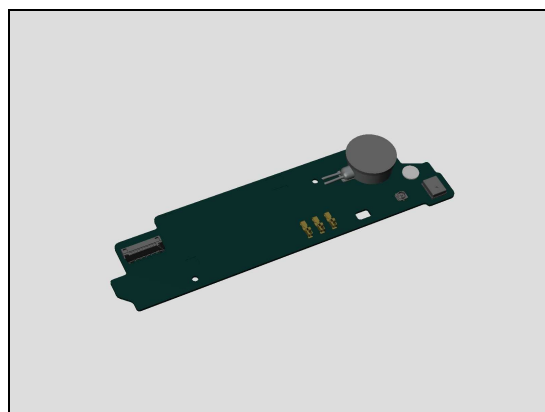
Follow the 3.1 – 3.4 Disassembly instructions!

Follow 4.33 Removal instructions.

Prepare new Sub Board Assy.

Follow 4.33 Installation instructions.

Follow the 5.4 – 5.7 Reassembly instructions!



Replacement

4.5 Front Cover LCM TP Assy

Follow the 3.1 – 3.7 Disassembly instructions!

Follow 4.30, 4.31 Removal instructions.

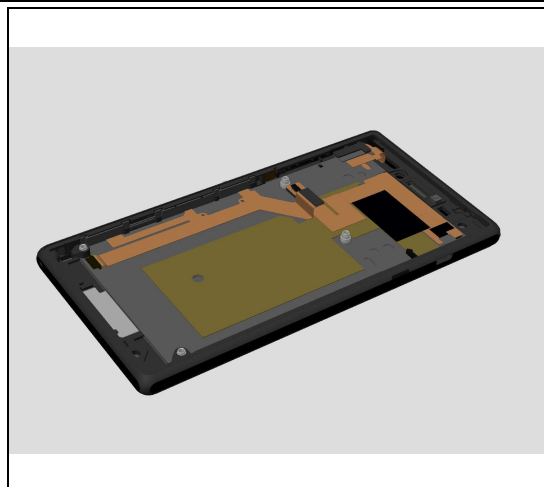
Prepare a new Front Cover LCM TP Assy.

Follow 4.43 Installation instructions.

Follow the 5.1 – 5.7 Reassembly instructions!

Follow 4.30, 4.31 Installation instructions.

When replacing Front Cover LCM TP Assy or board swap, must do the Calibration for P-sensor, light sensor, accelerometer: 1287-2411 Trouble Shooting Application – mechanical.



4.6 Antenna DIV

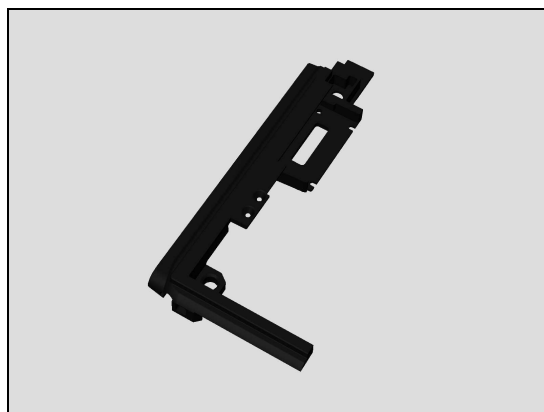
Follow the 3.1 – 3.6 Disassembly instructions!

Follow 4.39 Removal instructions.

Prepare new Antenna DIV.

Follow 4.39 Installation instructions.

Follow the 5.2 – 5.7 Reassembly instructions!

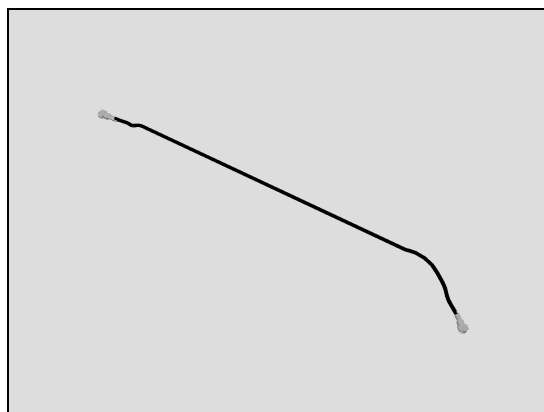


4.7 RF Cable

Follow the 3.1 – 3.4 Disassembly instructions!

Prepare new RF Cable.

Follow the 5.4 – 5.7 Reassembly instructions!



4.8 Foam Front Camera

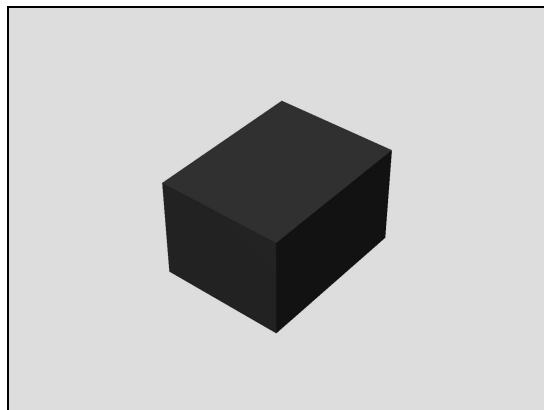
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Foam Front Camera.

Carry out the Installation as described below.

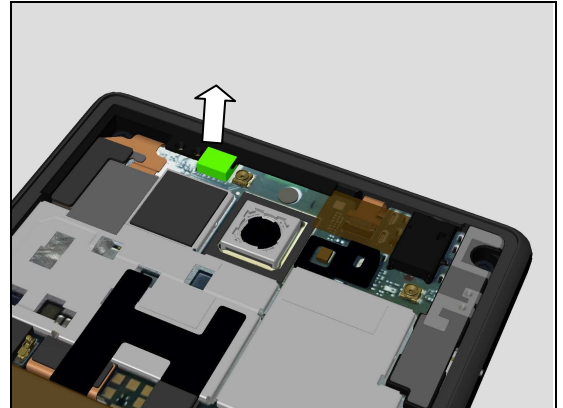
Follow the 5.7 Reassembly instructions!



Replacement

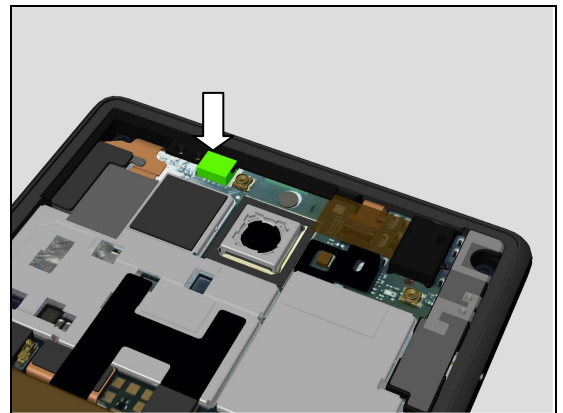
Removal

Remove the Foam Front Camera.



Installation

Place a new Foam Front Camera into its cavity.



4.9 ESD Cloth TP BTB

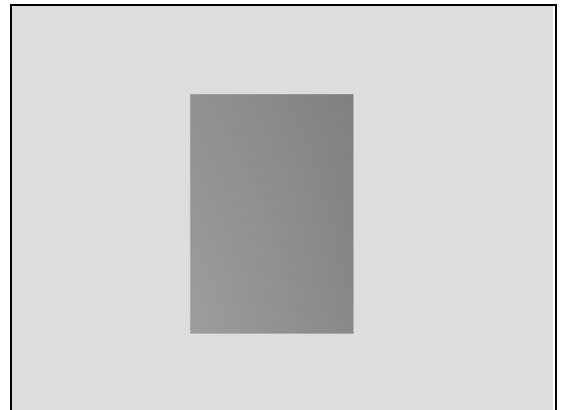
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new ESD Cloth TP BTB.

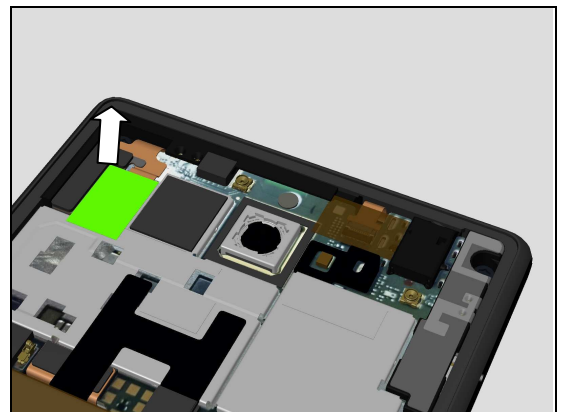
Carry out the Installation as described below.

Follow the 5.7 Reassembly instructions!



Removal

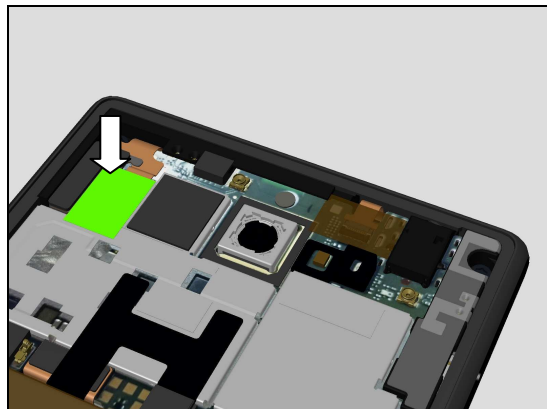
Remove the ESD Cloth TP BTB.



Replacement

Installation

Place a new ESD Cloth TP BTB.



4.10 Yellow film on PL ZIF

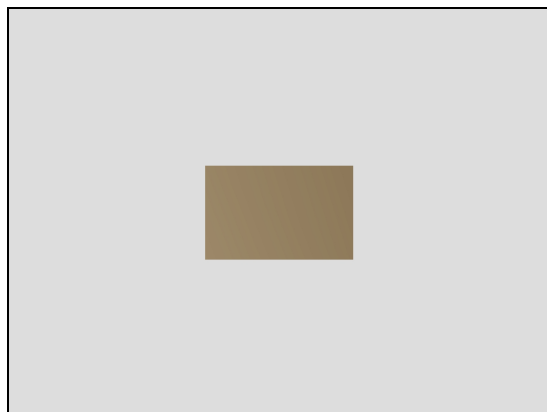
Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Yellow film on PL ZIF.

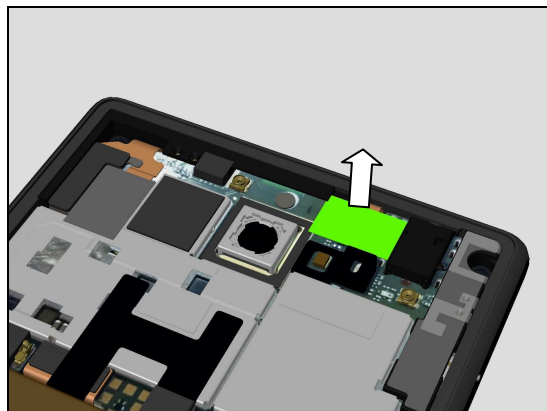
Carry out the Installation as described below

Follow the 5.7 Reassembly instructions!



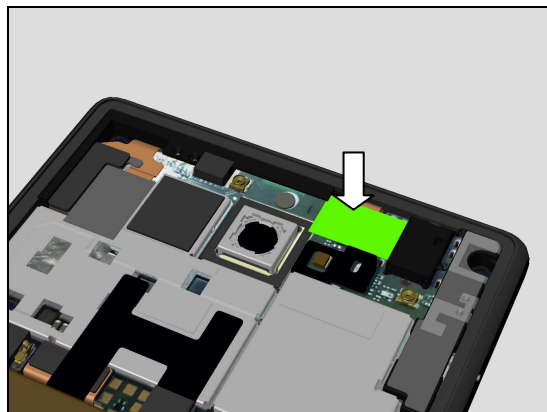
Removal

Remove the Yellow film on PL ZIF.



Installation

Place a new Yellow film on PL ZIF.



Replacement

4.11 Screw TORX L3.3

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Screw TORX L3.3.

Carry out the Installation as described below

Follow the 5.7 Reassembly instructions!

Removal

Remove these six Screws by using a screwdriver with Bits (T5).

Scrap! Not to be reused!

Installation

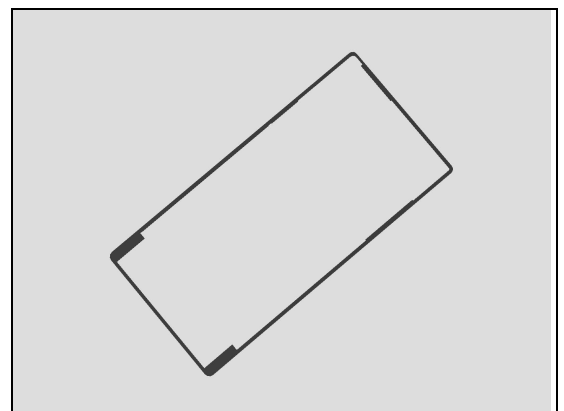
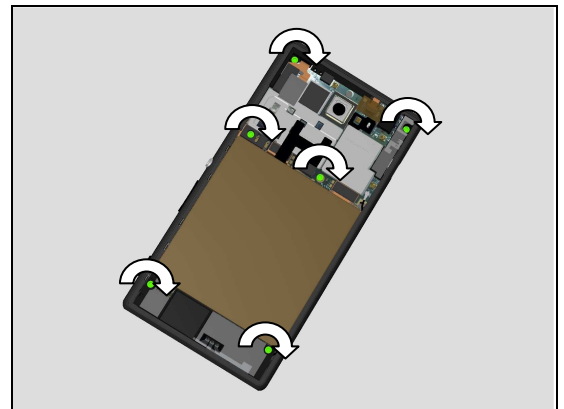
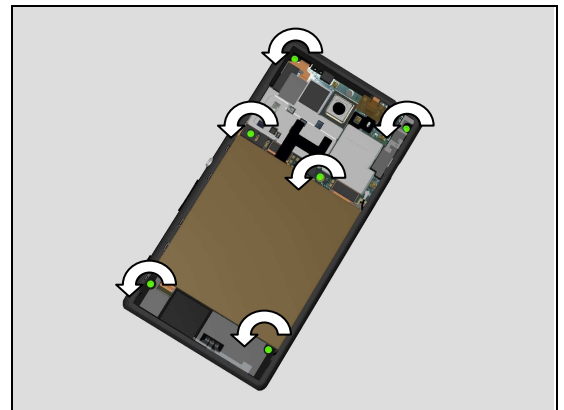
Apply 9.8 N.cm torque when tightening these six Screws with Bits (T5) as shown.

4.12 BC Adhesive1 Battery Cover

Follow the 3.1 Disassembly instructions!

Prepare a new BC Adhesive1 Battery Cover.

Follow the 5.7 Reassembly instructions!



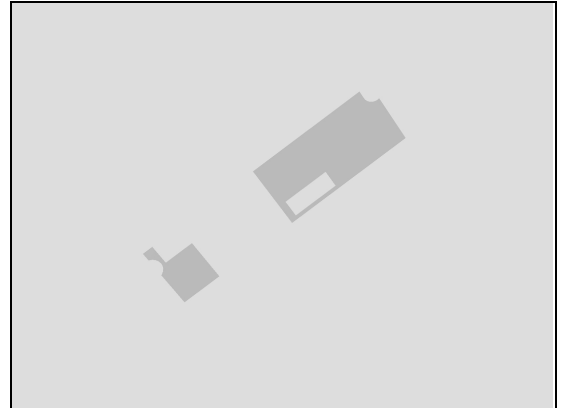
Replacement

4.13 BC Adhesive2.3 Main ANT

Follow the 3.1 Disassembly instructions!

Prepare a new BC Adhesive2.3 Main ANT.

Follow the 5.7 Reassembly instructions!

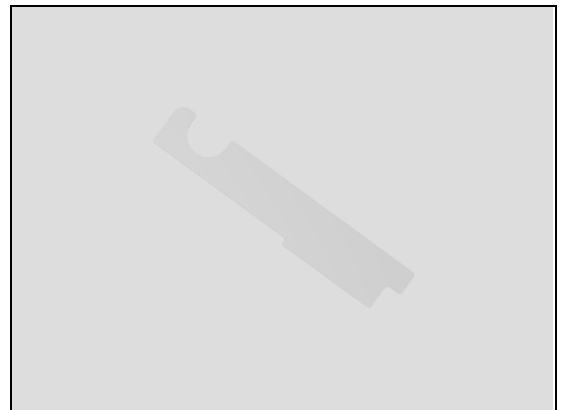


4.14 BC Adhesive4 GPS ANT

Follow the 3.1 Disassembly instructions!

Prepare a new BC Adhesive4 GPS ANT.

Follow the 5.7 Reassembly instructions!

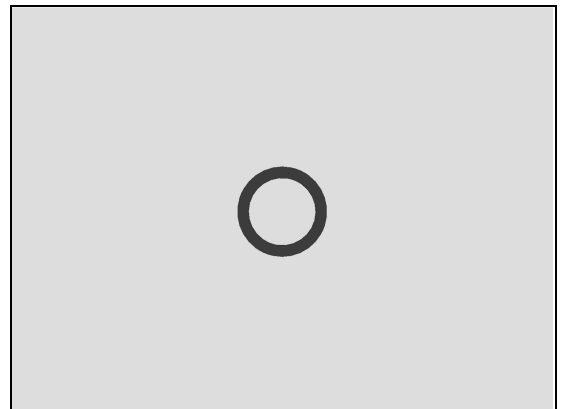


4.15 BC Adhesive5 Camera Sponge

Follow the 3.1 Disassembly instructions!

Prepare a new BC Adhesive5 Camera Sponge.

Follow the 5.7 Reassembly instructions!

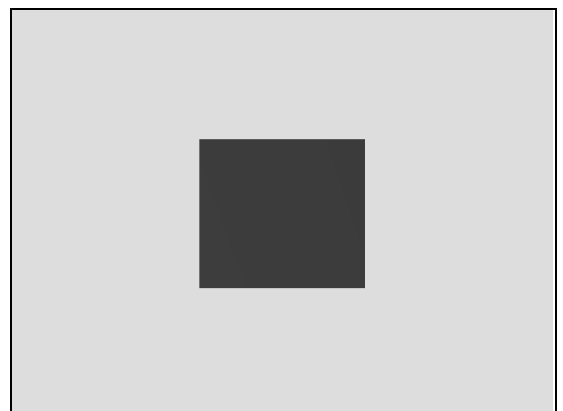


4.16 BC Adhesive6 Shield Cover

Follow the 3.1 Disassembly instructions!

Prepare a new BC Adhesive6 Shield Cover.

Follow the 5.7 Reassembly instructions!



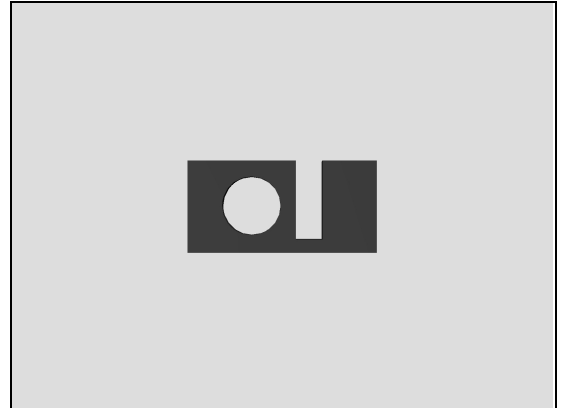
Replacement

4.17 BC Adhesive7 NFC Spring

Follow the 3.1 Disassembly instructions!

Prepare a new BC Adhesive7 NFC Spring.

Follow the 5.7 Reassembly instructions!

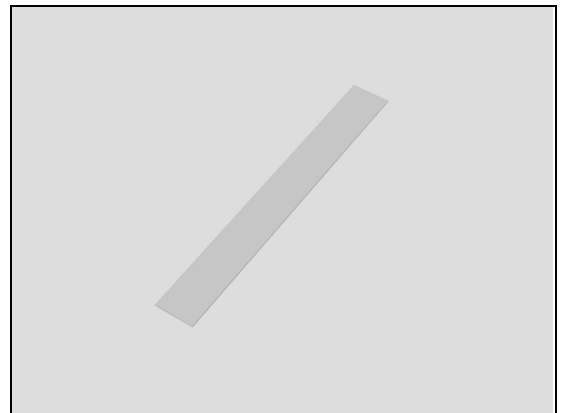


4.18 BAT Adhesive1.2.3 Battery

Follow the 3.1-3.2 Disassembly instructions!

Prepare a new BAT Adhesive1.2.3 Battery.

Follow the 5.6-5.7 Reassembly instructions!

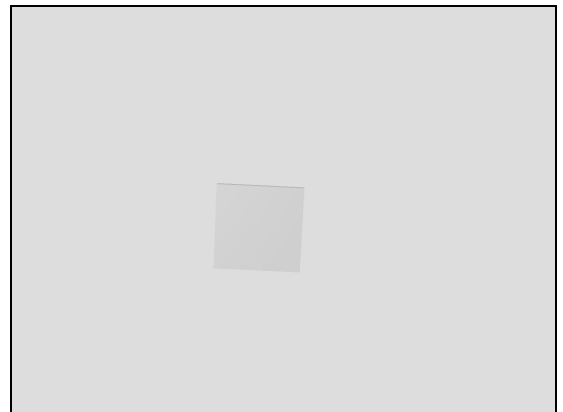


4.19 BAT Adhesive4 Camera key

Follow the 3.1-3.2 Disassembly instructions!

Prepare a new BAT Adhesive4 Camera key.

Follow the 5.6-5.7 Reassembly instructions!



4.20 BAT Adhesive5 Power key

Follow the 3.1-3.2 Disassembly instructions!

Prepare a new BAT Adhesive5 Power key.

Follow the 5.6-5.7 Reassembly instructions!



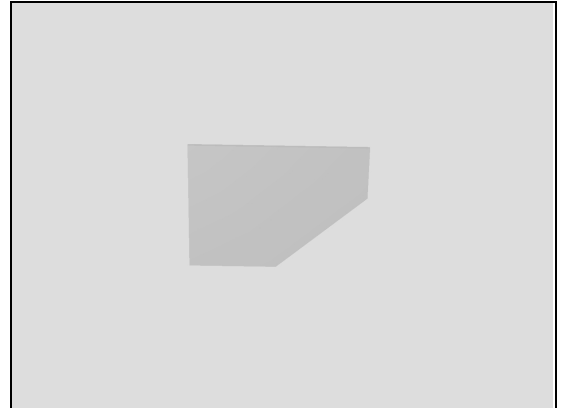
Replacement

4.21 BAT Adhesive6 Reset key

Follow the 3.1-3.2 Disassembly instructions!

Prepare a new BAT Adhesive1.2.3 Battery.

Follow the 5.6-5.7 Reassembly instructions!



4.22 Front Camera Assy

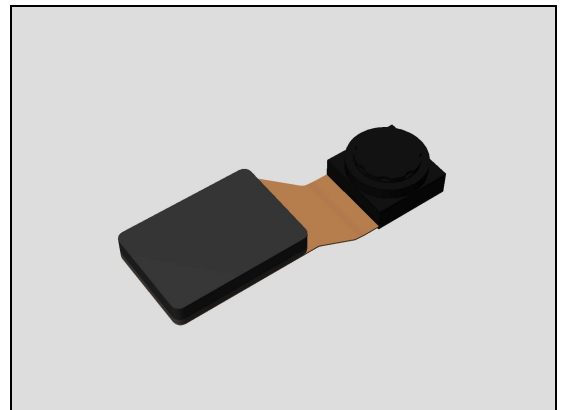
Follow the 3.1-3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Front Camera Assy.

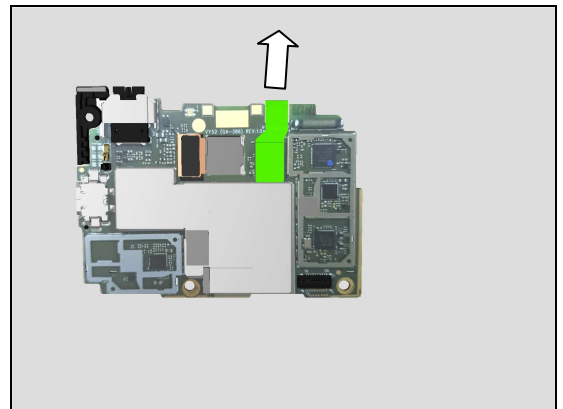
Carry out the Installation as described below.

Follow the 5.1-5.7 Reassembly instructions!



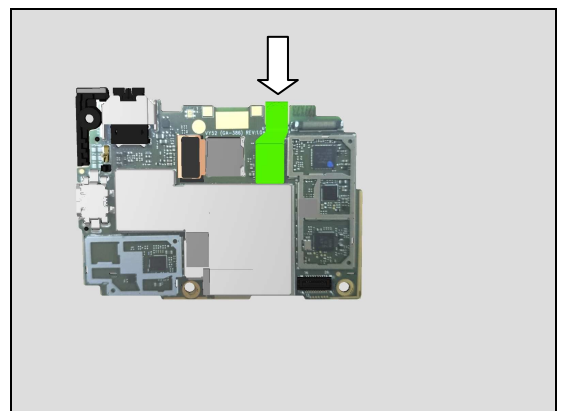
Removal

Open its BtB connector and remove Front Camera Assy.



Installation

Place a new Front Camera Assy in the correct position as shown in the picture; ensure its BtB connector well assembled.



Replacement

4.23 Main Camera

Follow the 3.1-3.7 Disassembly instructions!

Carry out the Removal as described below.

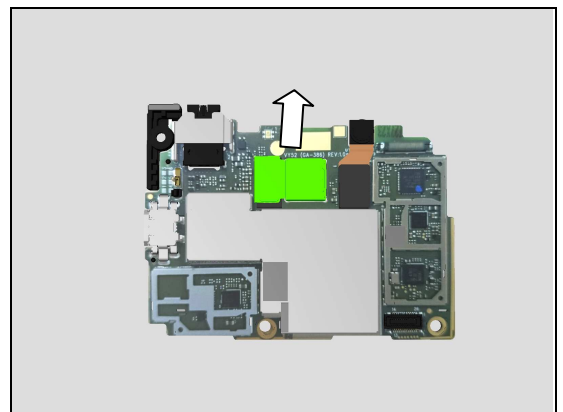
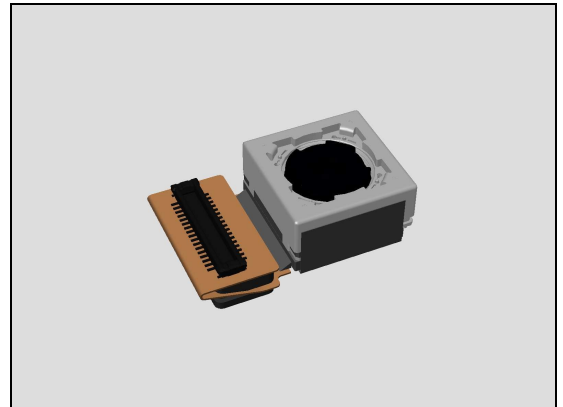
Prepare a new Main Camera.

Carry out the Installation as described below.

Follow the 5.1-5.7 Reassembly instructions!

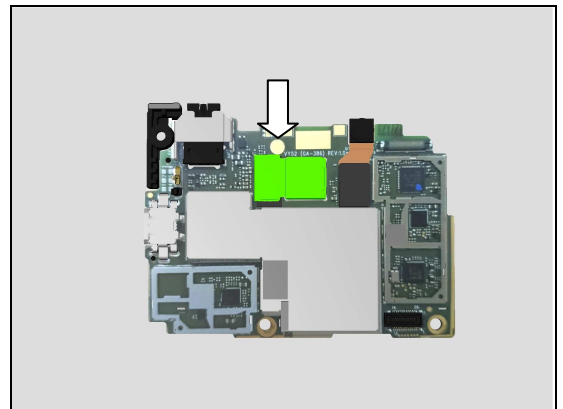
Removal

Open its BtB connector and remove Main Camera.



Installation

Place a new Main Camera in the correct position as shown in the picture; ensure its BtB connector well assembled.



4.24 Antenna BT WIFI GPS

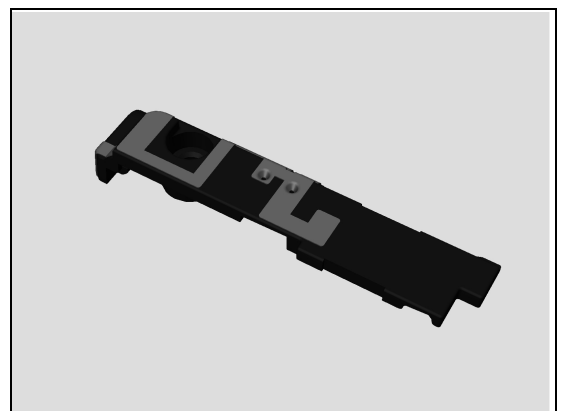
Follow the 3.1-3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Antenna BT WIFI GPS.

Carry out the Installation as described below.

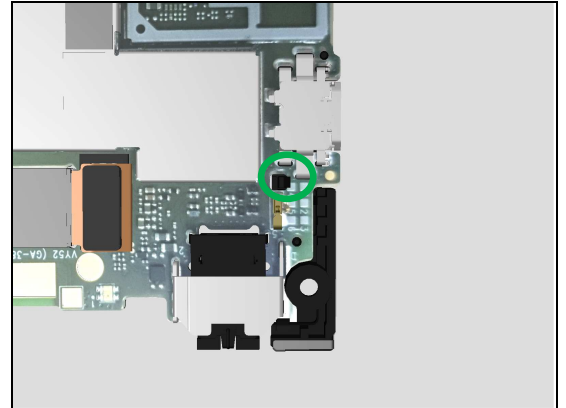
Follow the 5.1-5.7 Reassembly instructions!



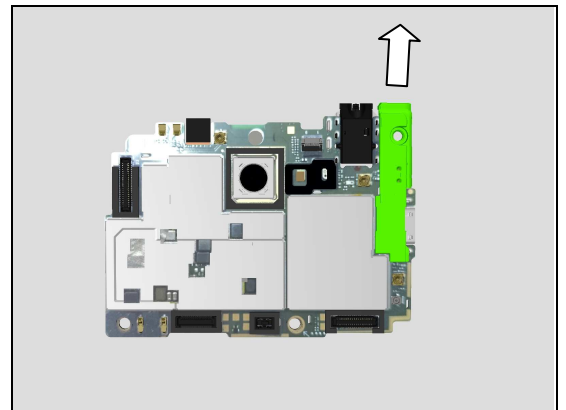
Replacement

Removal

Push the hook of the Antenna BT WIFI GPS from Main PBA.

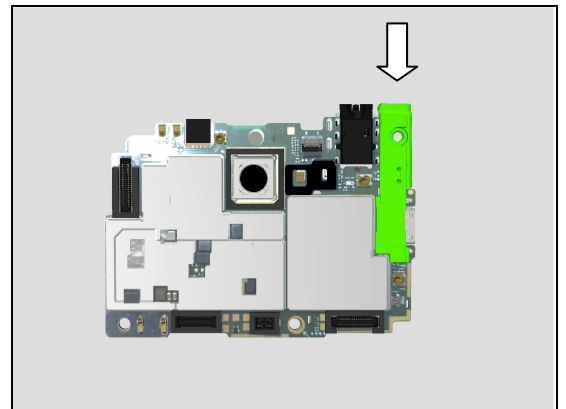


Remove the Antenna BT WIFI GPS from Main PBA.

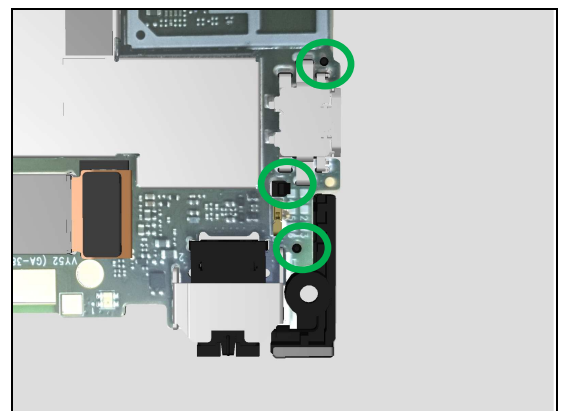


Installation

Place a new Antenna BT WIFI GPS in the correct position as shown in the picture;



Ensure the its hook and position pillar as shown in the picture are well assembled;



Replacement

4.25 Side Panel Top

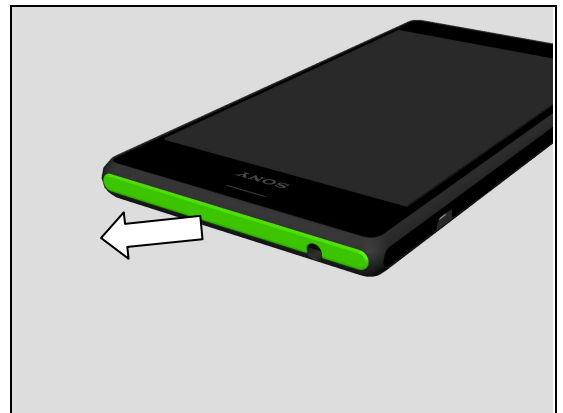
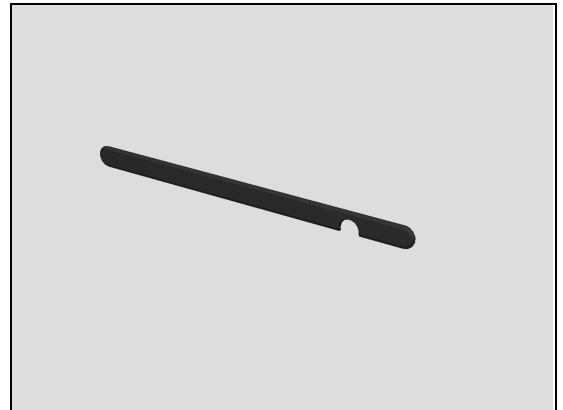
Carry out the Removal as described below.

Prepare a new Side Panel Top.

Carry out the Installation as described below.

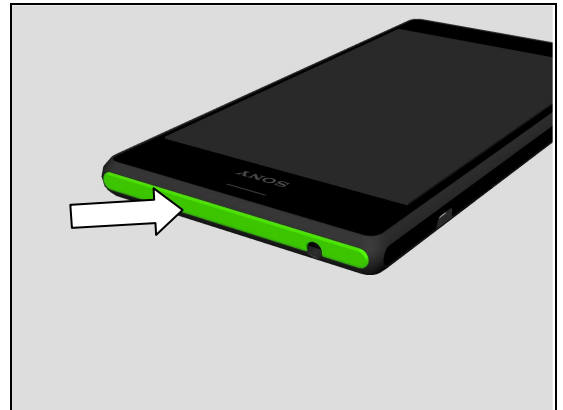
Removal

Remove the Side Panel Top.



Installation

Place the new Side Panel Top in the correct position as shown and press it by hand to secure its attachment.

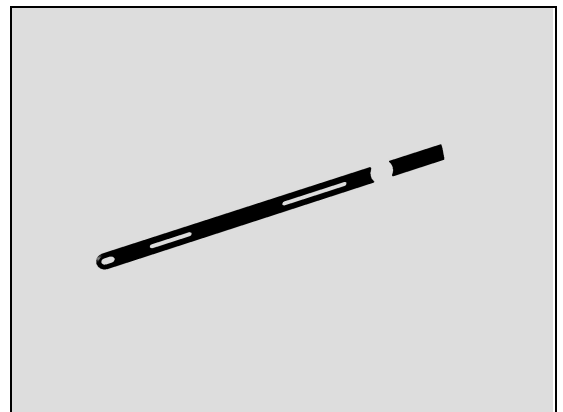


4.26 Side Pane Right

Carry out the Removal as described below.

Prepare a new Side Pane Right.

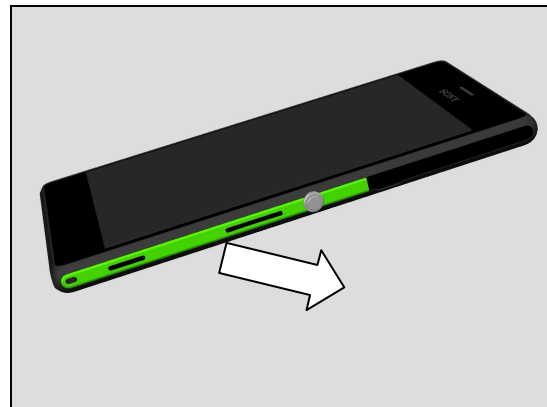
Carry out the Installation as described below.



Replacement

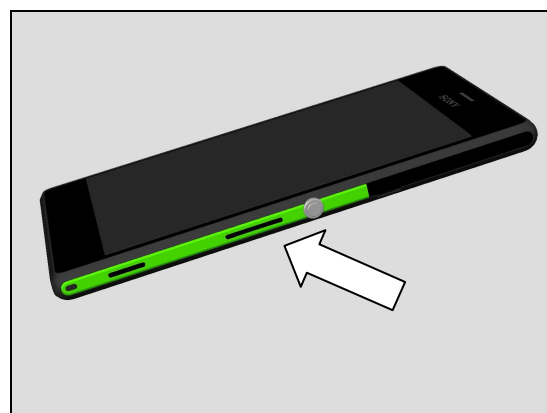
Removal

Remove the Side Pane Right.



Installation

Place the new Side Pane Right in the correct position as shown and press it by hand to secure its attachment.

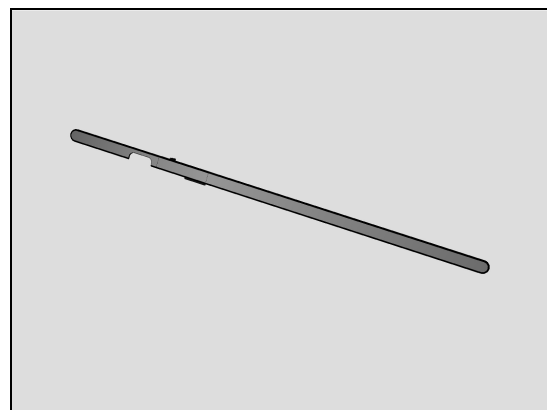


4.27 Side Panel Left (D2303, D2305, D2306)

Carry out the Removal as described below.

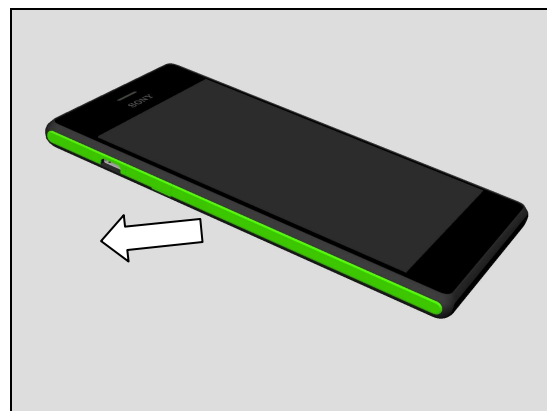
Prepare a new Side Panel Left.

Carry out the Installation as described below.



Removal

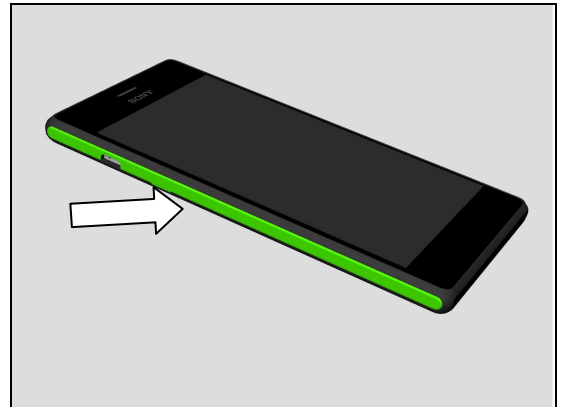
Remove the Side Panel Left.



Replacement

Installation

Place the new Side Panel Left in the correct position as shown and press it by hand to secure its attachment.

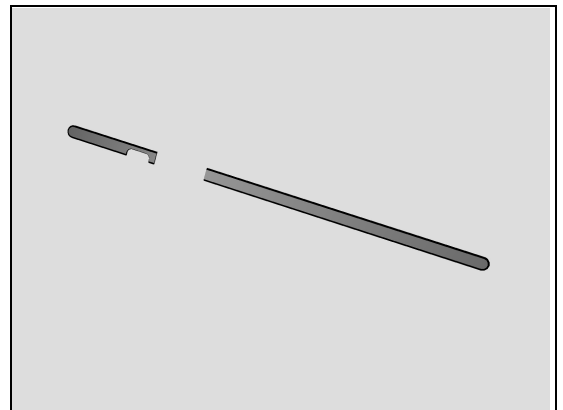


4.28 Side Panel Left (D2302, S50h)

Carry out the Removal as described below.

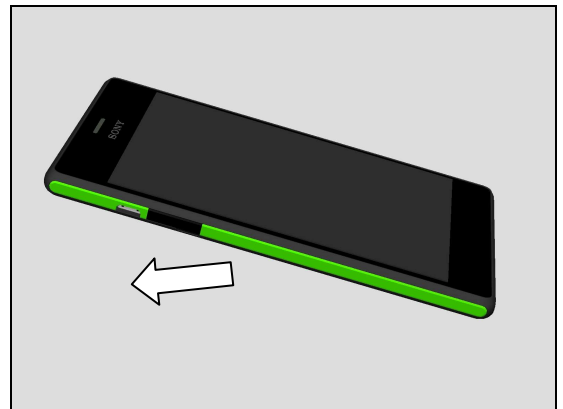
Prepare a new Side Panel Left.

Carry out the Installation as described below.



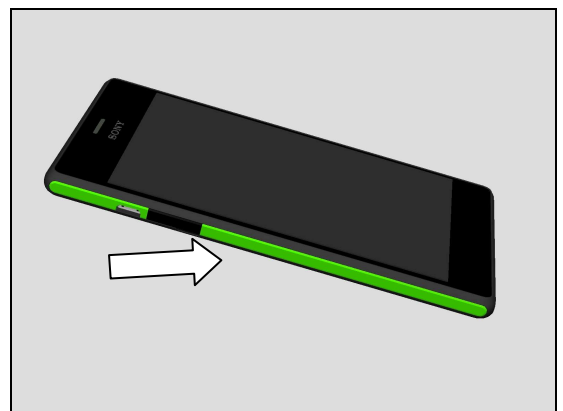
Removal

Remove the Side Panel Left.



Installation

Place the new Side Panel Left in the correct position as shown and press it by hand to secure its attachment.



Replacement

4.29 Micro SD Door (D2302, S50h)

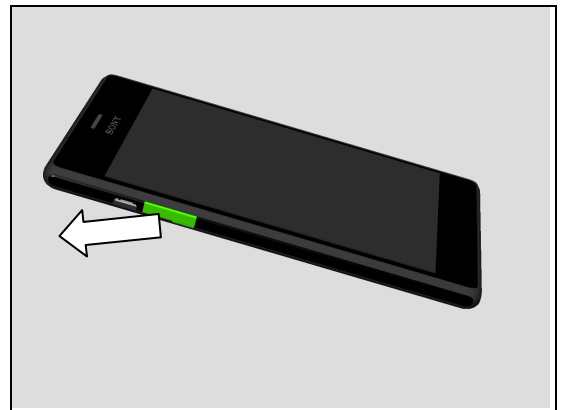
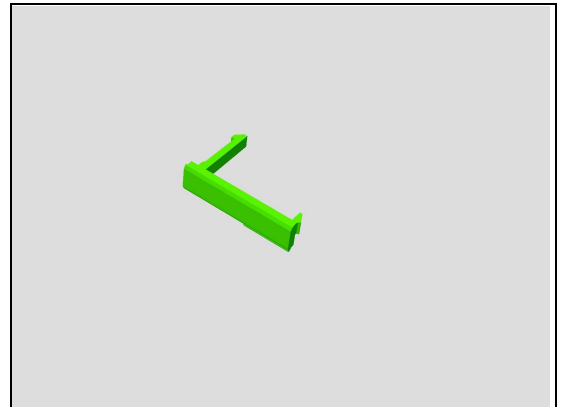
Carry out the Removal as described below.

Prepare a new Micro SD Door.

Carry out the Installation as described below.

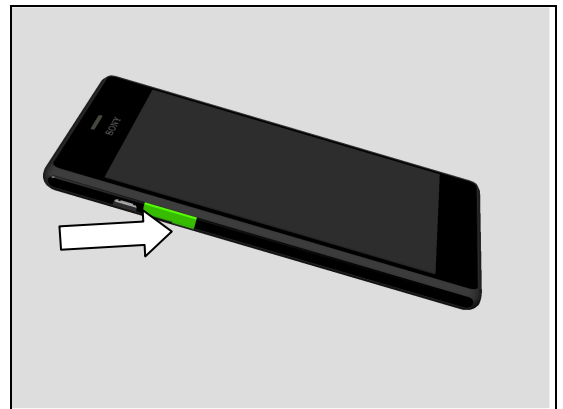
Removal

Remove the Micro SD Door.



Installation

Place the new Micro SD Door in the correct position as shown and press it by hand to secure its attachment.

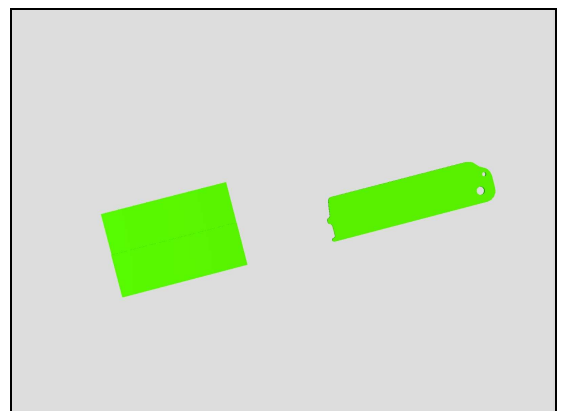


4.30 Core Unit Label & Tray A thick Blank

Carry out the Removal as described below.

Prepare a new Core Unit Label & Tray A thick Blank.

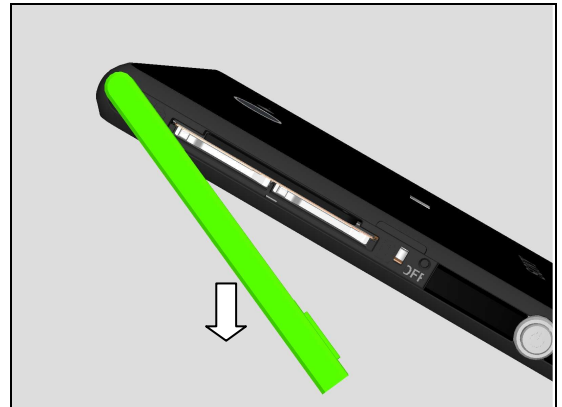
Carry out the Installation as described below.



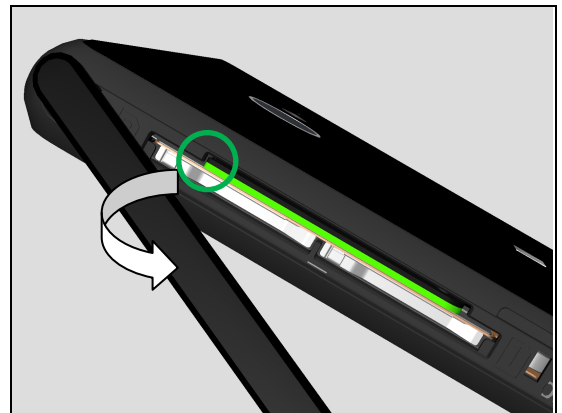
Replacement

Removal

Open the SIM Door first to show Tray A.

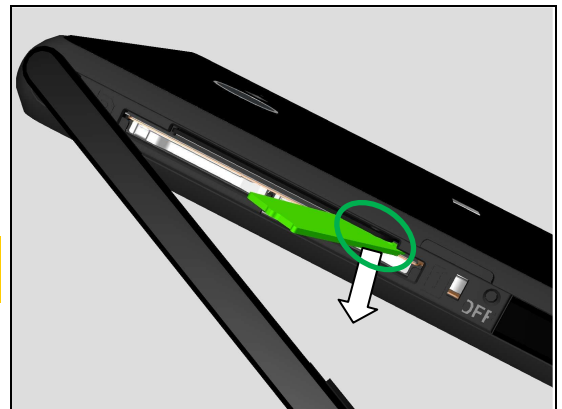


Pull out Tray A from top side as shown.



Hold Tray A by hand and press its bottom side down about 1mm as shown to release its bottom side from its Pillar.

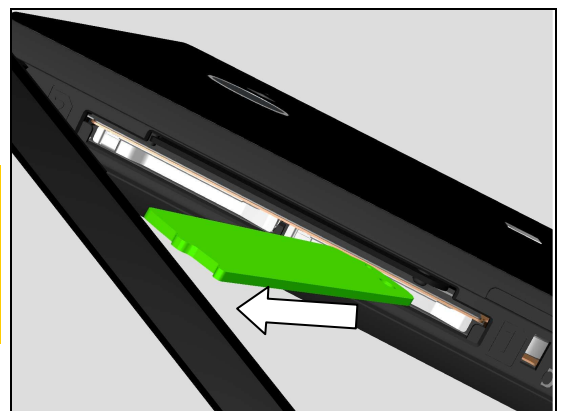
Note: SIM Connector will be pressed deformed down about 1mm to release Tray A from its pillar.



Remove the Tray A.

Note: Tray A from production line is laser Print Label content.

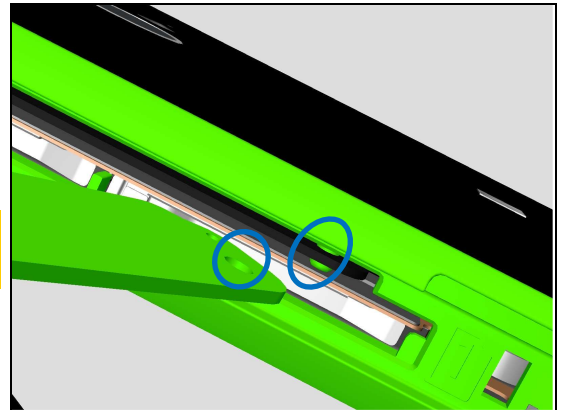
For Repaired phones, use Tray A thick Blank and CU Label White Paper 19x12mm with Label content printed (Paper, Zebra printer).



Replacement

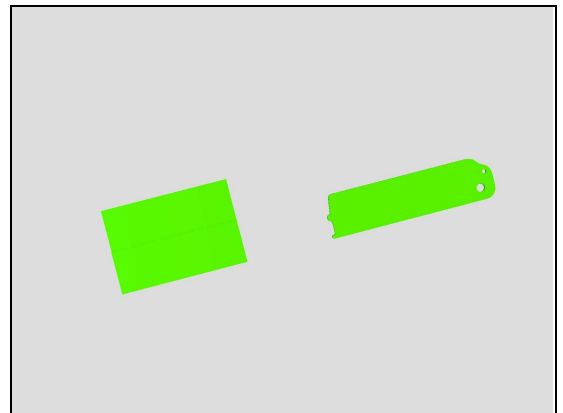
Tray A hole and its Pillar as shown in picture.

**Note: Tray A has two holes on its bottom side.
The bigger size hole is its position hole.**



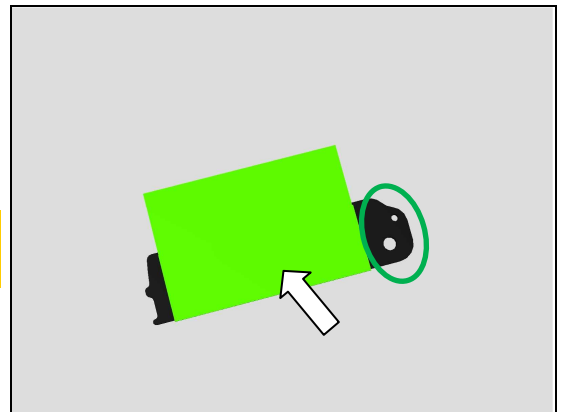
Installation

Prepare the Core Unit Label and Tray A thick Blank.



Attach a new Core Unit Label carefully as shown on front side of Tray A thick Blank first.

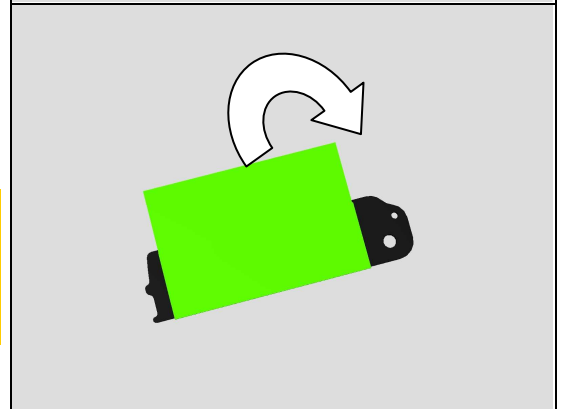
**Only one Label is attached.
Pay attention that the part is in its proper position!**



Attach Core Unit Label carefully as shown on back side of Tray A thick Blank then.

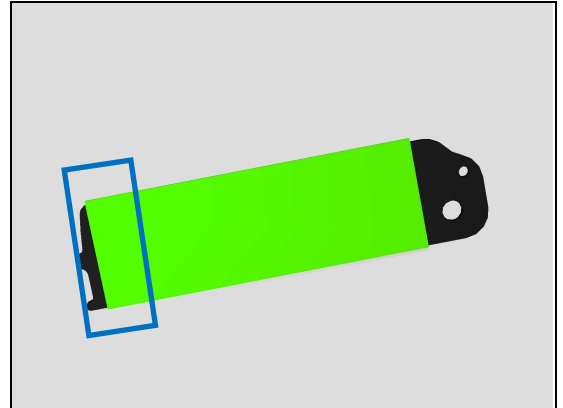
Pay attention about Tray A blank direction as shown!

**Core Unit Label can only be rotated up direction to
paste it on back side of Tray A blank.**



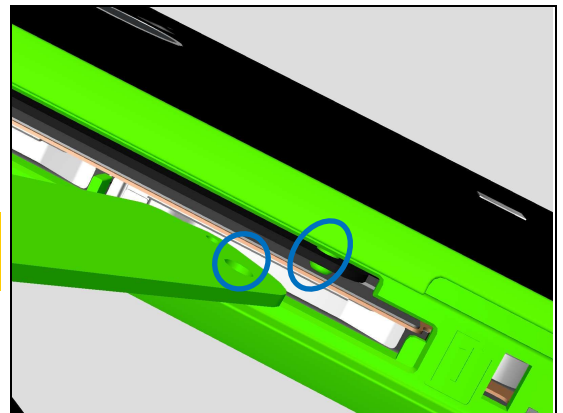
Replacement

Try to align Core Unit Label with the Left side of Tray A thick Blank as shown.



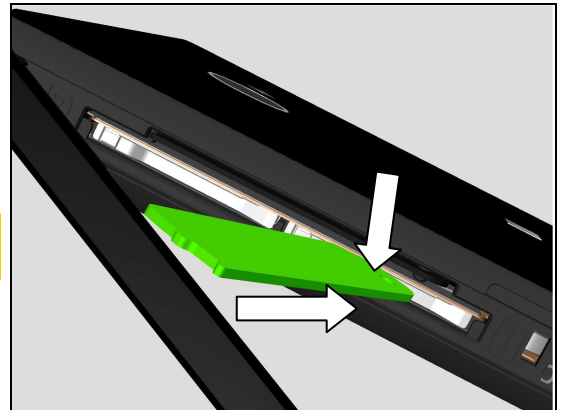
Tray A hole and its Pillar as shown in picture.

**Note: Tray A has two holes on its bottom side.
The bigger size hole is its position hole.**



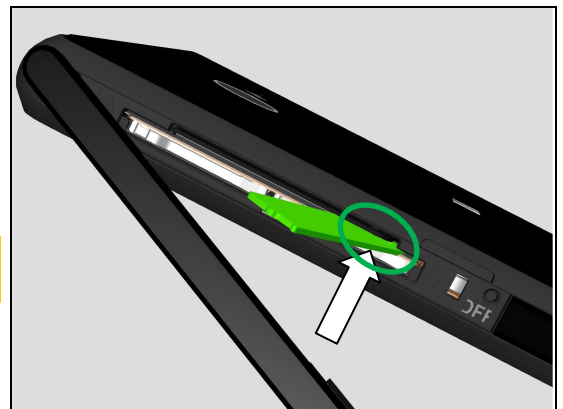
Insert Tray A thick Blank with Core Unit Label above SIM connector and press its bottom side down about 1mm.

Note: SIM Connector will be pressed deformed down about 1mm to insert Tray A under its pillar.



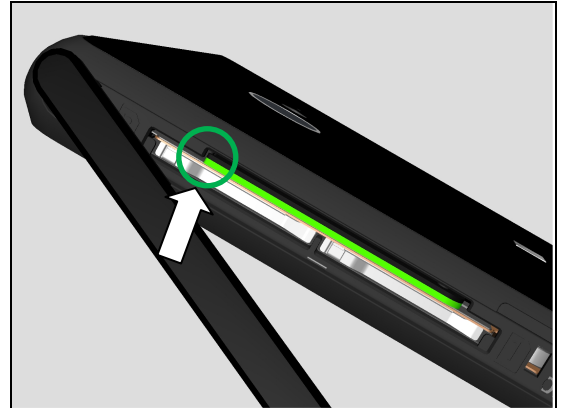
Assemble the hole of Tray A thick Blank with Core Unit Label onto its pillar.

Note: Rotate this part several times to ensure its hole through its pillar correctly.

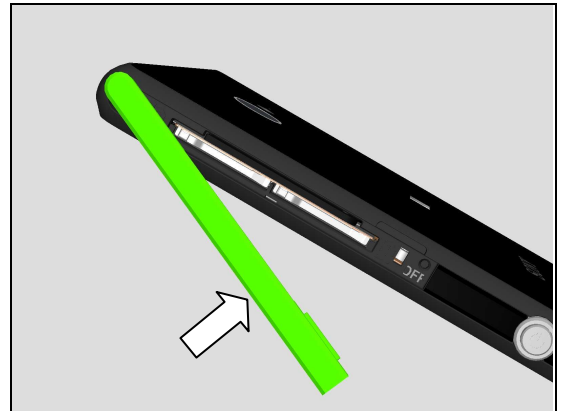


Replacement

Close Tray A thick Blank with Core Unit Label into its position as shown.



Close the SIM Door.



Replacement

4.31 Tray B thin Laser Print

Follow the 4.30 Removal instructions!

Carry out the Removal as described below.

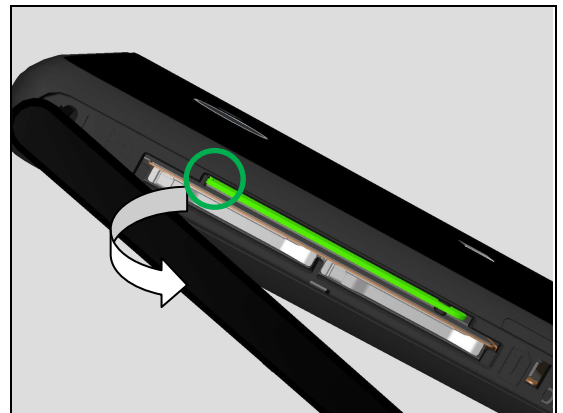
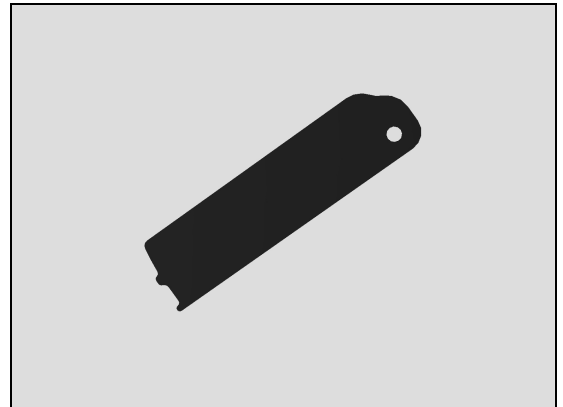
Prepare a new Tray B thin Laser Print.

Carry out the Installation as described below.

Follow the 4.30 Installation instructions!

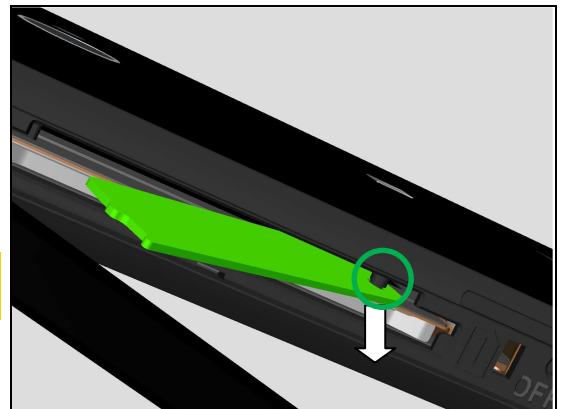
Removal

Pull out Tray B from top side as shown.



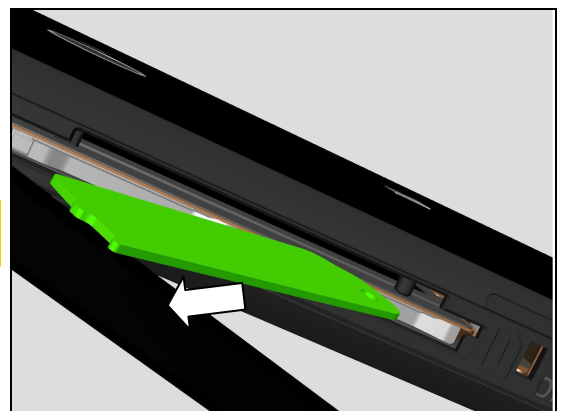
Hold Tray B thin Laser Print by hand and press its bottom side down about 1mm as shown to release its bottom side from its Pillar.

Note: SIM Connector will be pressed deformed down about 1mm to release Tray A from its pillar.



Remove the Tray B thin Laser Print.

Note: There is only one position hole for Tray B thin Laser Print.

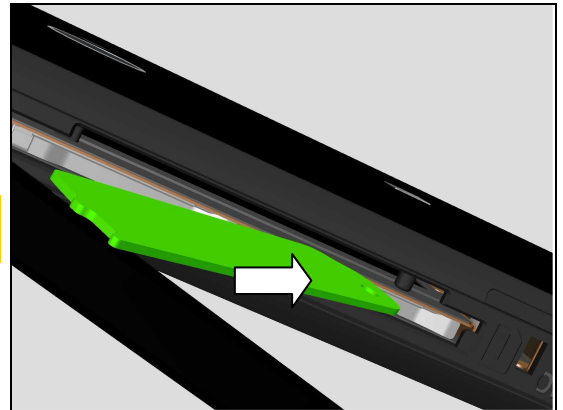


Replacement

Installation

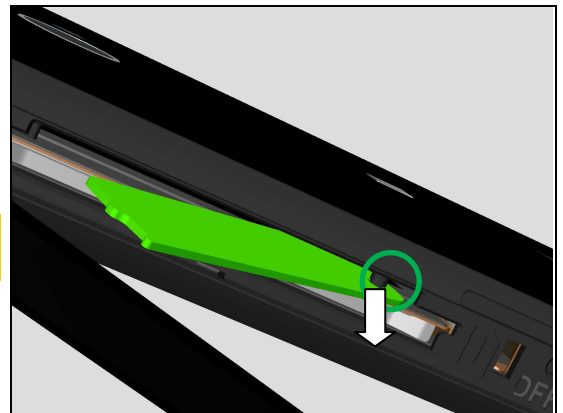
Prepare new Tray B thin Laser Print.

Note: There are 5 variants of Tray B thin Laser Print for common Label content according to model name.



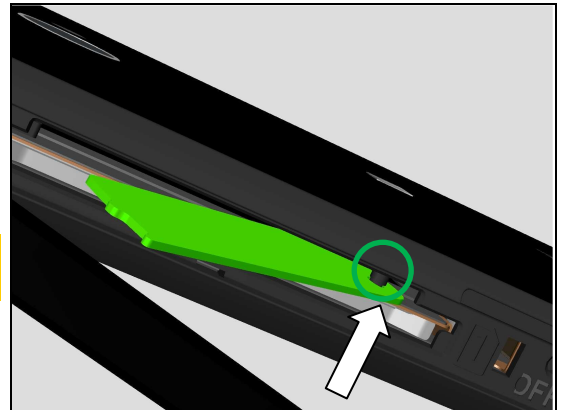
Insert Tray B thin Laser Print above SIM connector and press its bottom side down about 1mm.

Note: SIM Connector will be pressed deformed down about 1mm to insert Tray A under its pillar.

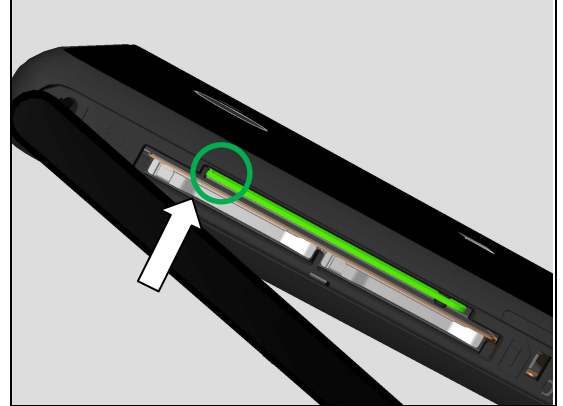


Assemble the hole of Tray A thick Blank with Core Unit Label onto its pillar.

Note: Rotate this part several times to ensure its hole through its pillar correctly.



Close Tray B thin Laser Print into its position as shown.



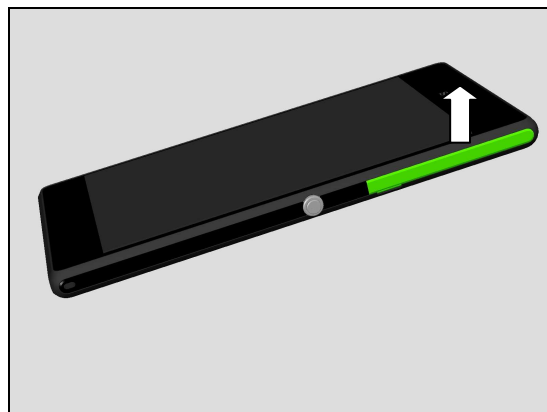
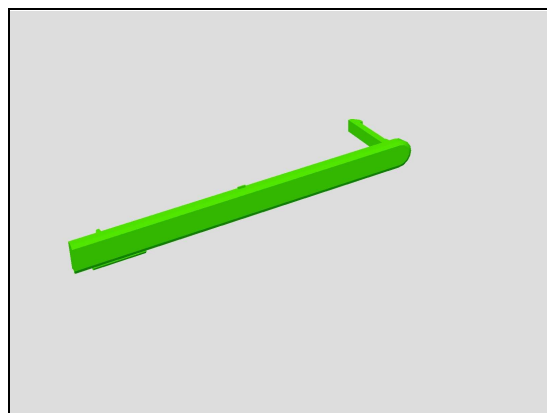
Replacement

4.32 SIM Door

Carry out the Removal as described below.
Prepare a new SIM Door.
Carry out the Installation as described below.

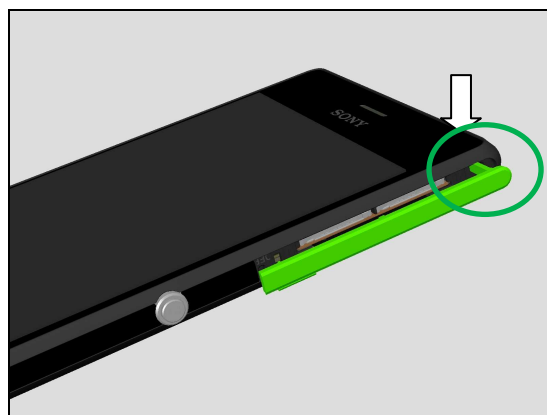
REMOVAL

Remove the SIM Door as shown.

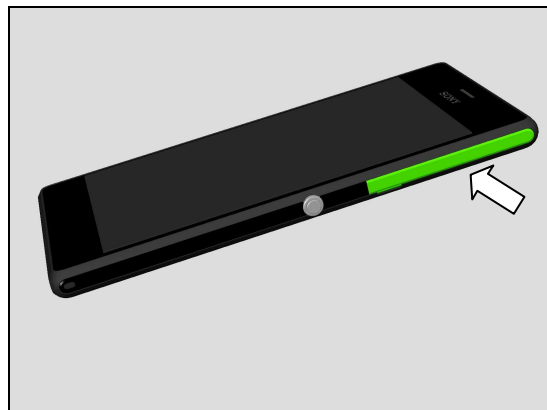


INSTALLATION

Place a new SIM Door in the correct position as shown.
Insert the tail of SIM Door first using Tweezers.



Close the SIM Door



Replacement

4.33 Rubber MIC1

Follow the 3.1-3.4 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Rubber MIC1.

Carry out the Installation as described below.

Follow the 5.4-5.7 Reassembly instructions!

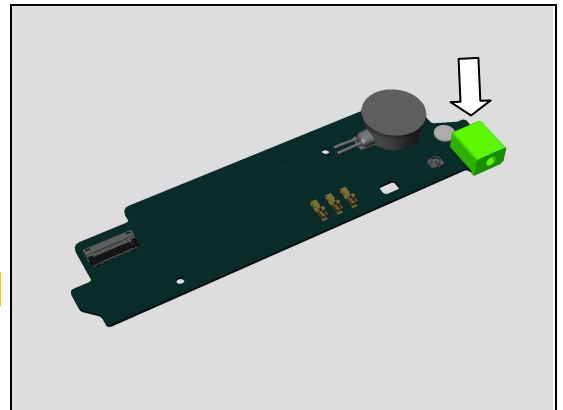
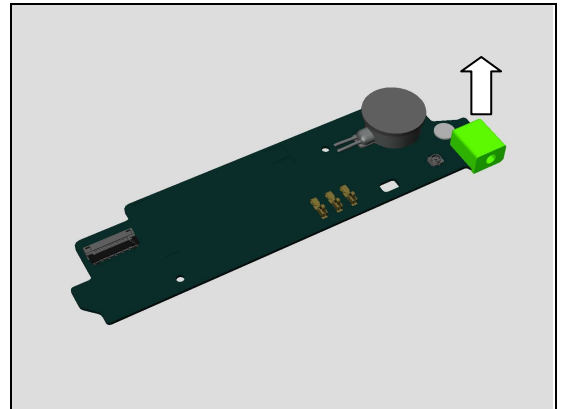
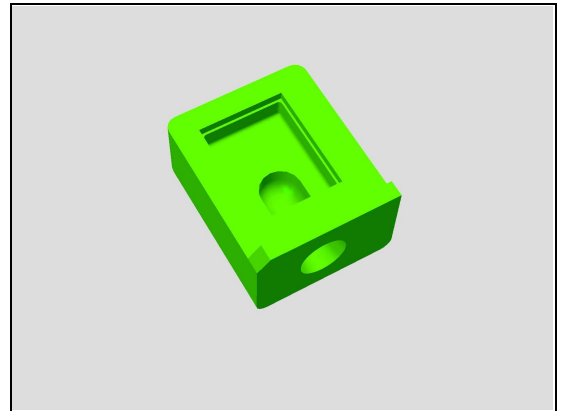
REMOVAL

Remove the Rubber MIC1 from Sub Board Assy.

INSTALLATION

Place a new Rubber MIC1 in the correct position as shown in the picture.

Pay attention about its direction!



Replacement

4.34 Rubber MIC2

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Rubber MIC2.

Carry out the Installation as described below.

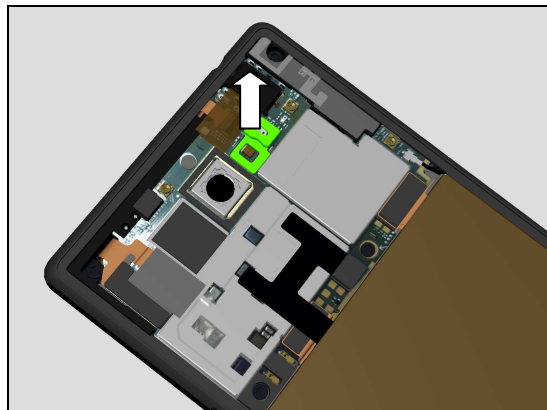
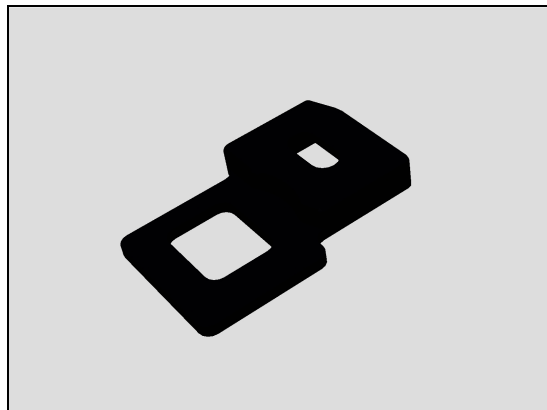
Follow the 5.7 Reassembly instructions!

REMOVAL

Peel off the Rubber MIC2.

INSTALLATION

Place a new Rubber MIC2 in the correct position as shown in the picture.



Replacement

4.35 Water Intrusion Label

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Water Intrusion Label.

Carry out the Installation as described below.

Follow the 5.7 Reassembly instructions!

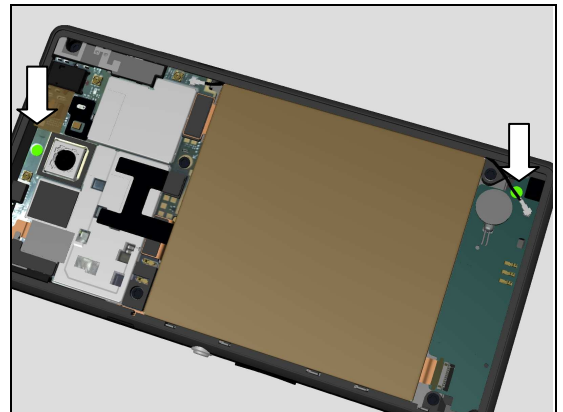
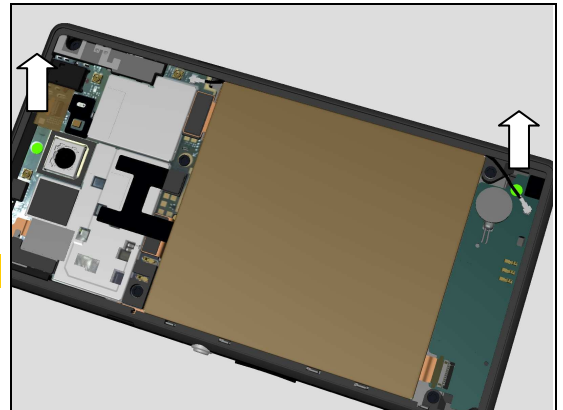
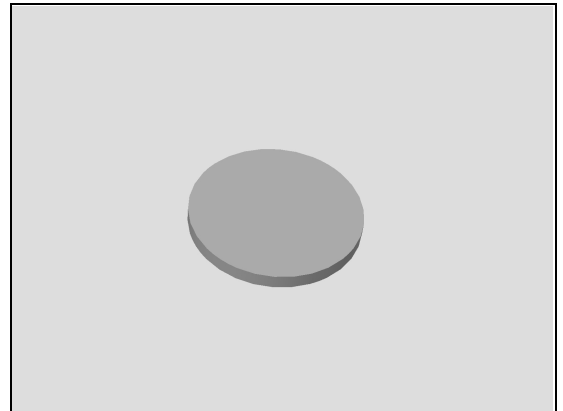
REMOVAL

Peel off the Water Intrusion Label.

Scrap! Not to be reused!

INSTALLATION

Place a new Water Intrusion Label in the correct position as shown in the picture.



Replacement

4.36 Speaker & Speaker Adhesive

Follow the 3.1 – 3.3 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Speaker and Speaker Sponge Adhesive.

Carry out the Installation as described below.

Follow the 5.5 – 5.7 Reassembly instructions!

REMOVAL

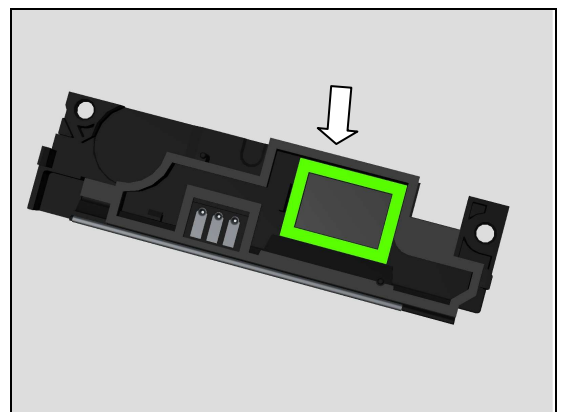
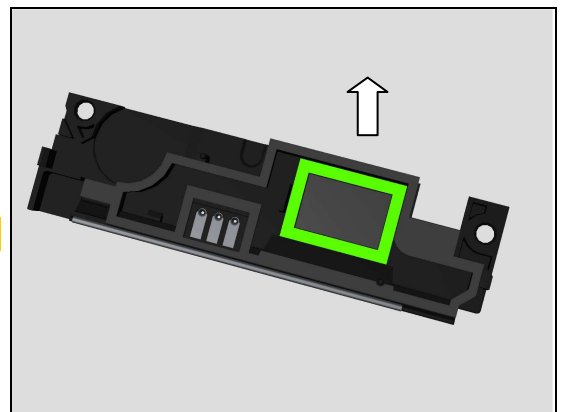
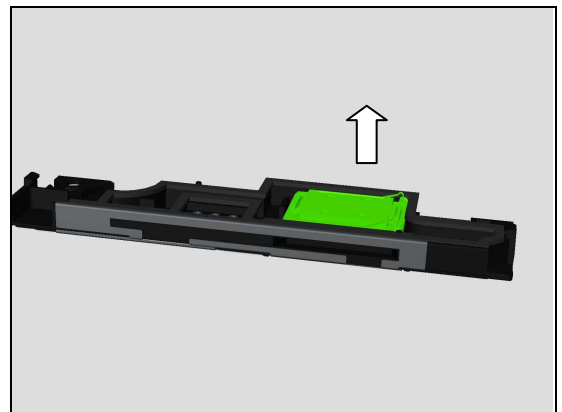
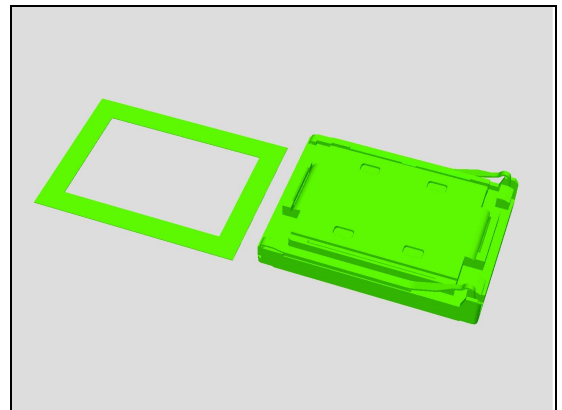
Detach the Speaker by using a pair of tweezers.

Peel off the Speaker Sponge Adhesive.

Scrap! Not to be reused!

INSTALLATION

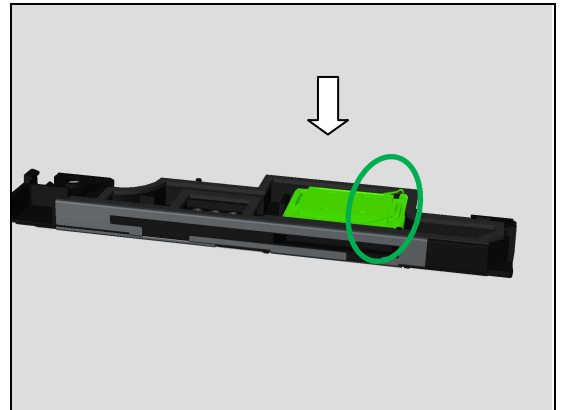
Place a new Speaker Sponge Adhesive in the correct position as shown in the picture.



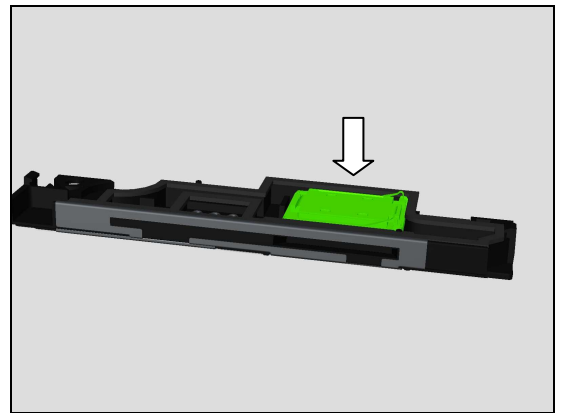
Replacement

Place a new Speaker in the correct position.

Make sure the Pin direction is correct!



Press to secure its attachment.



Replacement

4.37 Water Intrusion Label Rectangle 2.5*1.3m

Carry out the Removal as described below.

Prepare a new Water Intrusion Label Rectangle 2.5*1.3m.

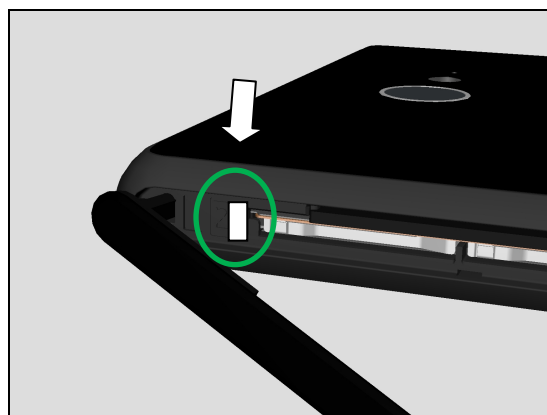
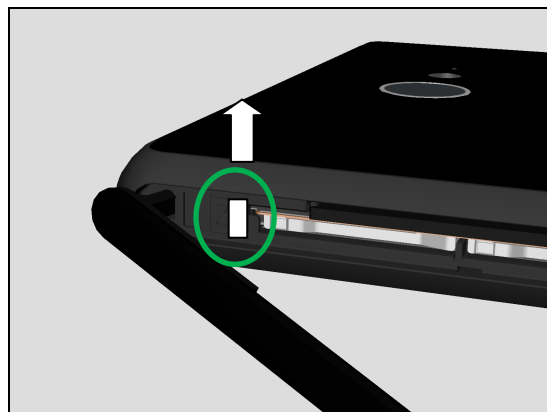
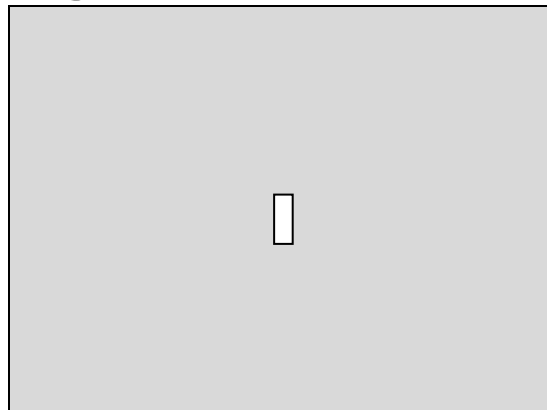
Carry out the Installation as described below.

REMOVAL

Open SIM Door and remove the Water Intrusion Label Rectangle 2.5*1.3m.

INSTALLATION

Assemble the new Water Intrusion Label Rectangle 2.5*1.3m and close SIM Door.



Replacement

4.38 PL Sensor FPC

Follow the 3.1 – 3.7 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new PL Sensor FPC.

Carry out the Installation as described below.

Follow the 5.1 – 5.7 Reassembly instructions!

Must do the Calibration for P-sensor, light sensor after PL Sensor FPC replacement: 1287-2411 Trouble Shooting Application – mechanical.

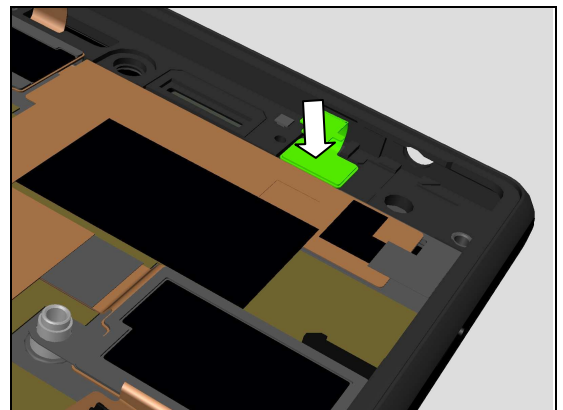
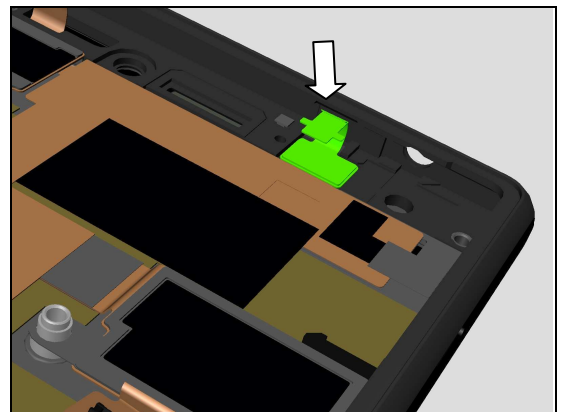
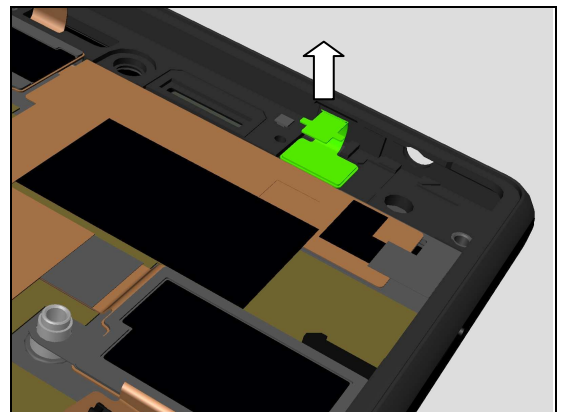
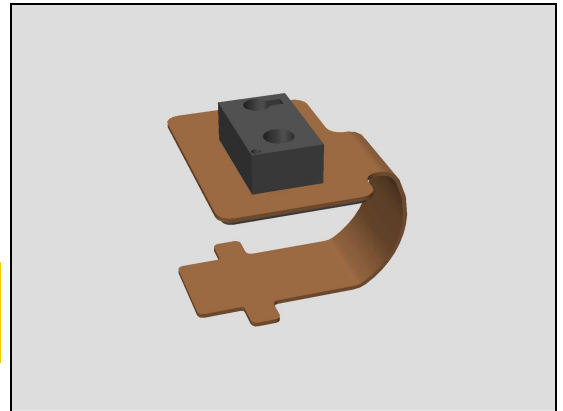
REMOVAL

Remove the PL Sensor FPC from its cavity.

INSTALLATION

Place a new PL Sensor FPC into its cavity.

Press to secure its attachment.



Replacement

4.39 Receiver & Receiver Adhesive

Follow the 3.1 – 3.7 Disassembly instructions!

Carry out the Removal as described below.

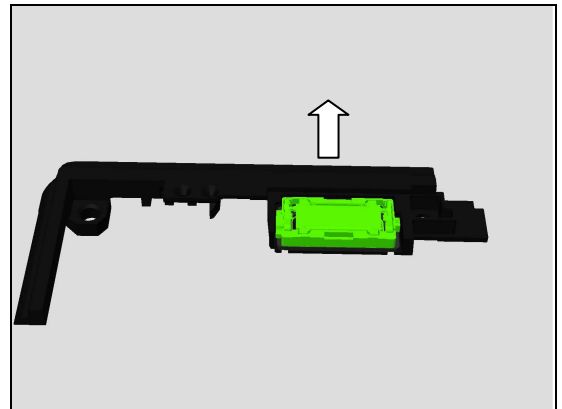
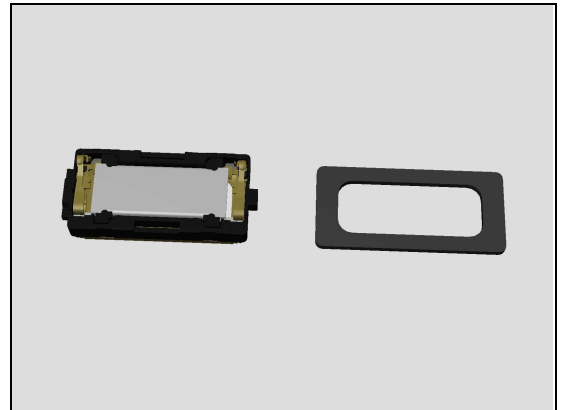
Prepare a new Receiver and Receiver Adhesive.

Carry out the Installation as described below.

Follow the 5.1 – 5.7 Reassembly instructions!

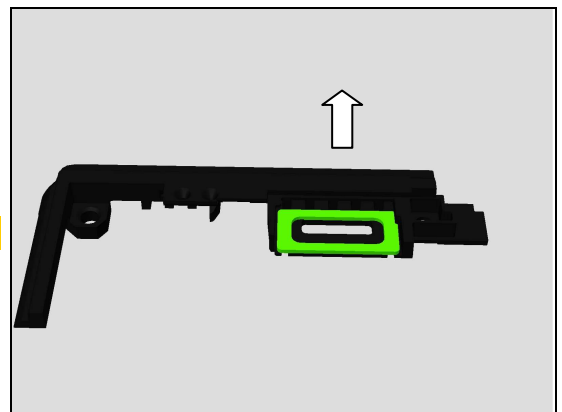
REMOVAL

Detach the Receiver by using a pair of tweezers.



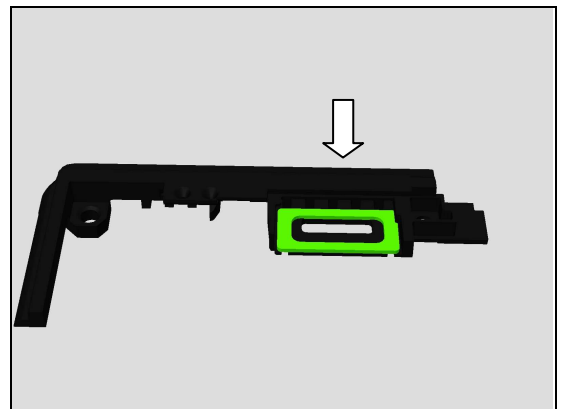
Clean the Receiver Adhesive on Front Cover LCM TP Assy.

Scrap! The Receiver Adhesive can't be reused!



INSTALLATION

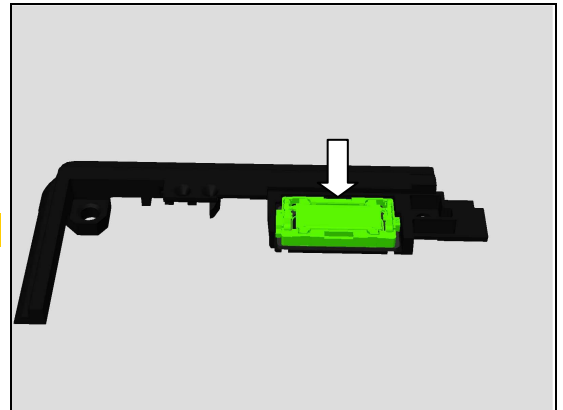
Place a new Receiver Adhesive in the correct position.



Replacement

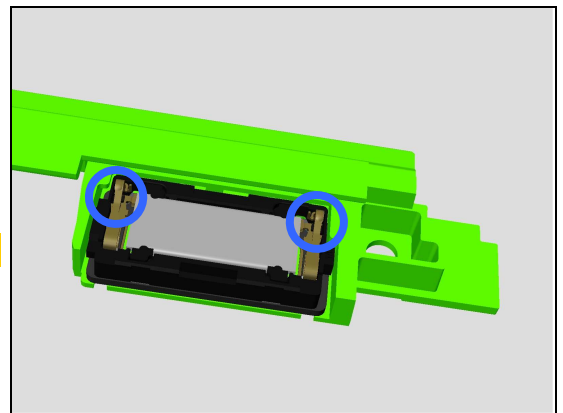
Place a new Receiver in the correct position.

Don't touch the Receiver pins!



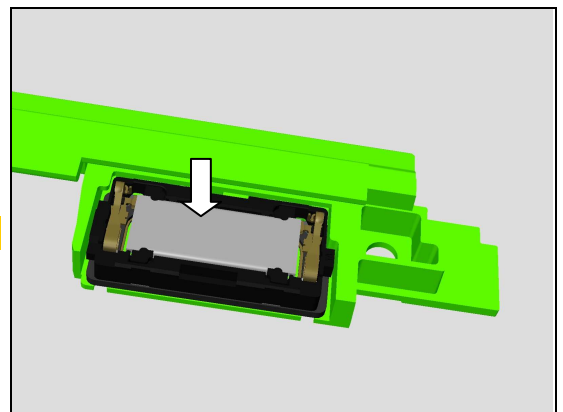
Check Receiver's pin correct direction as shown in the picture!

Don't touch the Receiver pins!



Press to secure its attachment.

Do not touch the Receiver pins!



Replacement

4.40 Power Key Ring

Follow the 4.26 Removal instructions!

Carry out the Removal as described below.

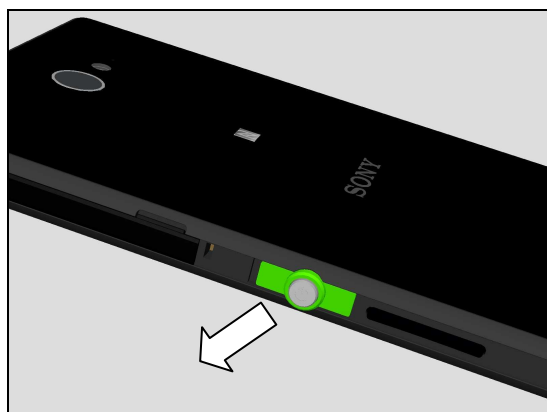
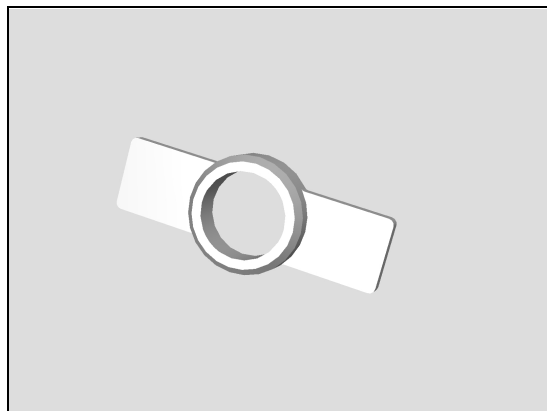
Prepare a new Power Key Ring.

Carry out the Installation as described below.

Follow the 4.26 Installation instructions!

REMOVAL

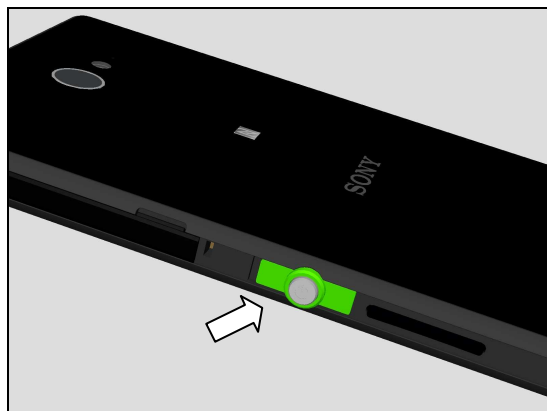
Remove the Power Key Ring from its cavity.



INSTALLATION

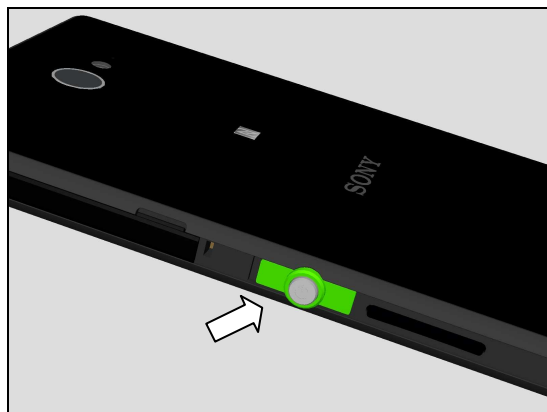
Place the Power Key Ring in the correct position.

Note: pay attention about its direction.



Press to secure its attachment.

Note: pay attention about its direction.



Replacement

4.41 Power Key

Follow the 4.26, 4.41 Removal instructions!

Carry out the Removal as described below.

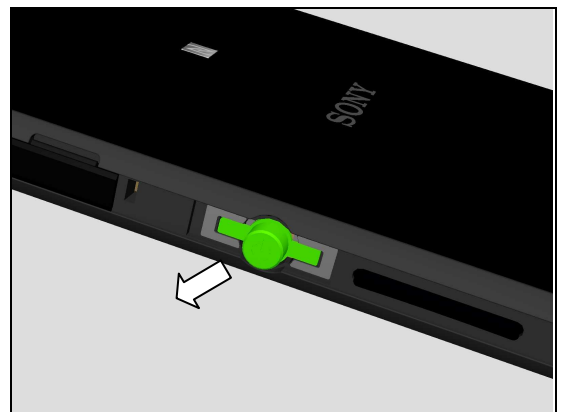
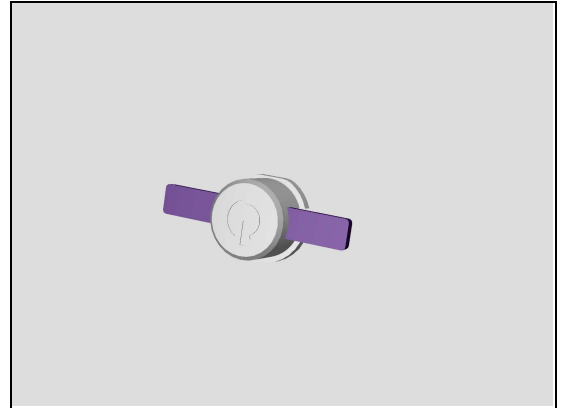
Prepare a new Power Key.

Carry out the Installation as described below.

Follow the 4.26, 4.41 Installation instructions!

REMOVAL

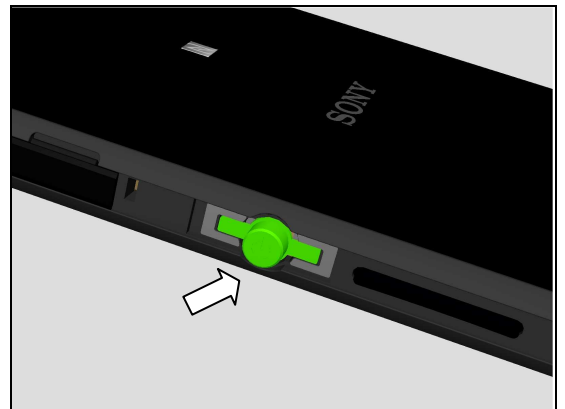
Remove the Power Key from its cavity.



INSTALLATION

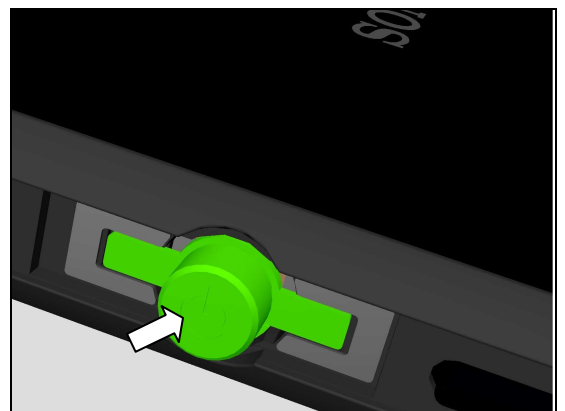
Place the Power Key in the correct position.

Note: pay attention about its direction.



Press to secure its attachment.

Note: pay attention about its direction.



Replacement

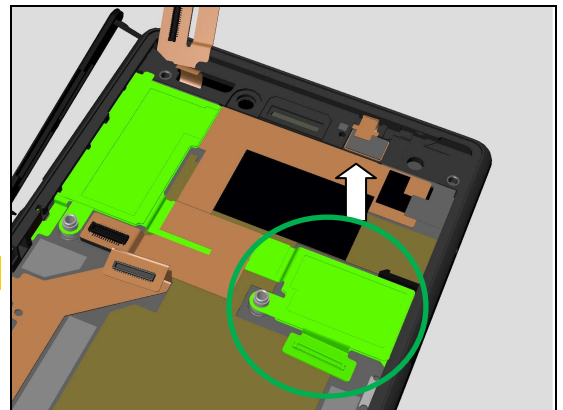
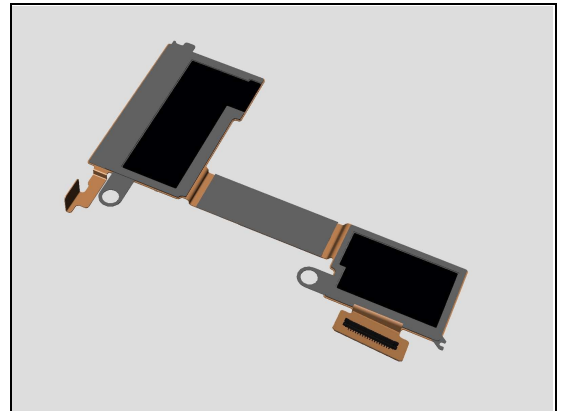
4.42 SIM FPC Assy

Follow the 3.1 – 3.7 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the new SIM FPC Assy.
 Carry out the Installation as described below.
Follow the 5.1 – 5.7 Reassembly instructions!

REMOVAL

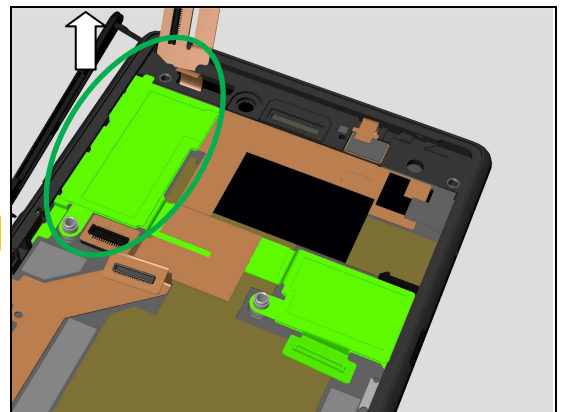
Remove right side of SIM FPC Assy first.

Scrap! Not to be reused!



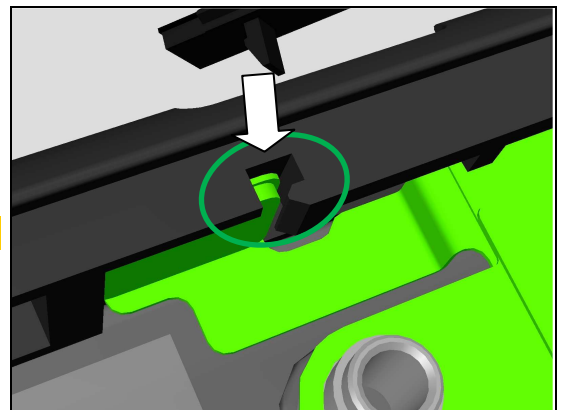
Remove left side of SIM FPC Assy then.

Scrap! Not to be reused!



Insert tweezers at shown gap to remove Reset key FPC.

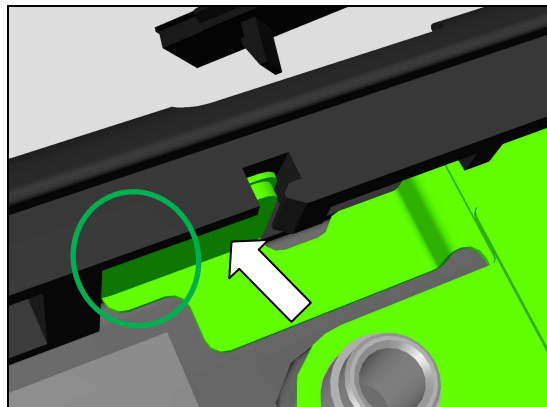
Scrap! Not to be reused!



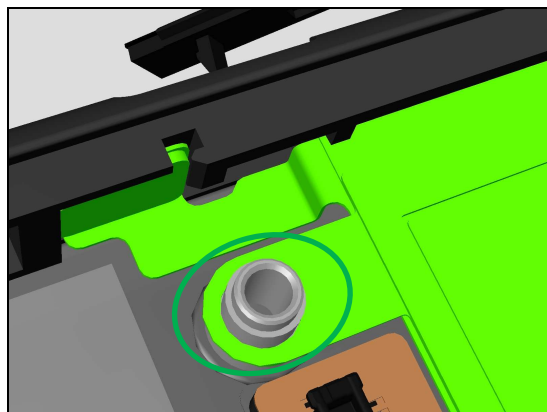
Replacement

INSTALLATION

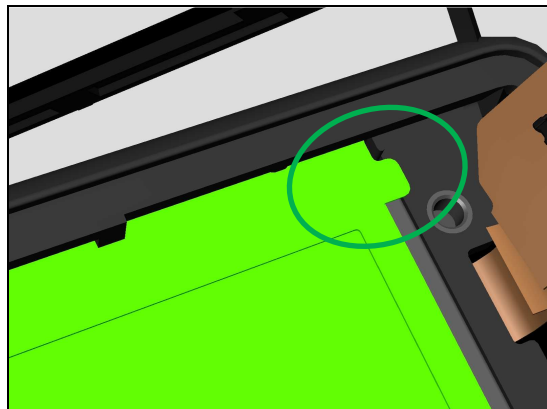
Insert the Reset Key FPC into its cavity first.
Press to secure its attachment.



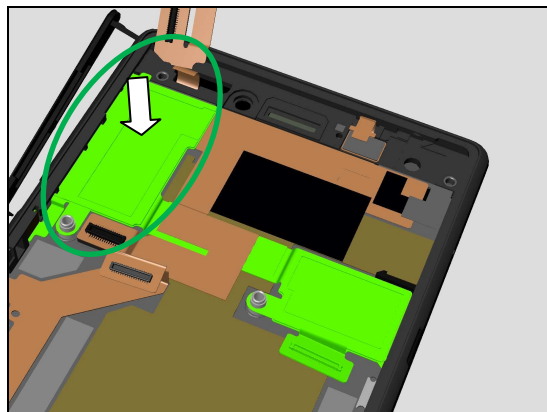
Assemble the screw metal hole onto its pillar then.



Assemble the left top corner onto its correct position.

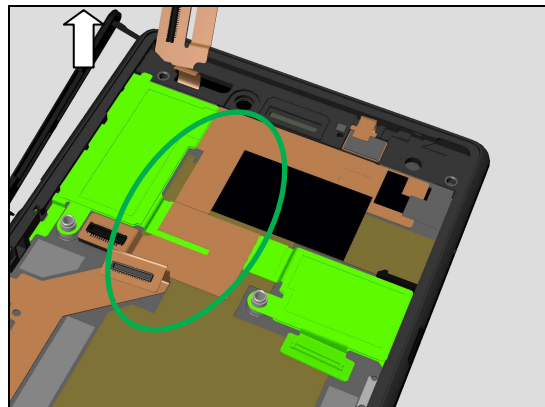


Press the left side to secure its attachment.

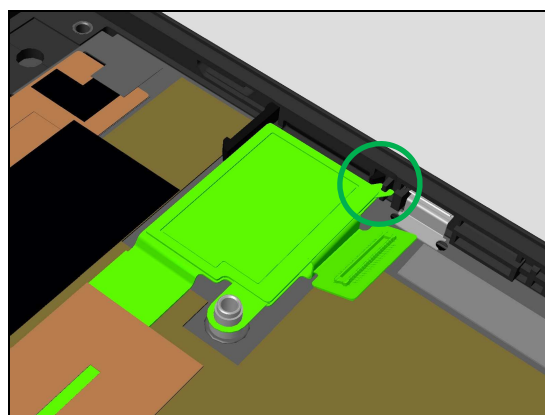


Replacement

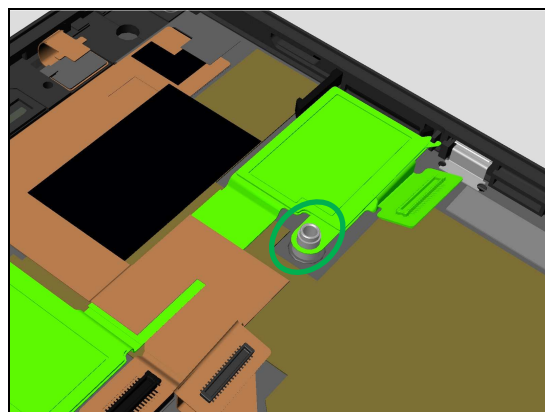
Put the middle FPC of SIM FPC Assy under LCM FPC.



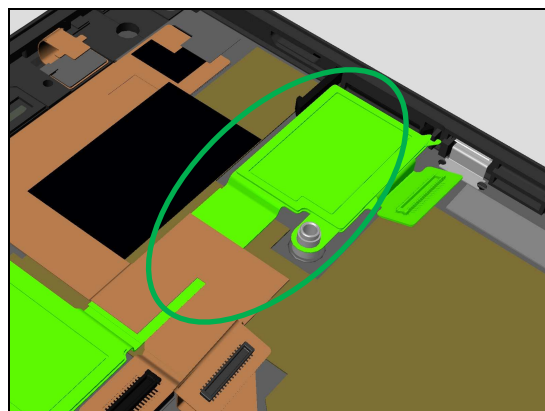
Assemble the right down corner into its correct position first.



Assemble the screw metal hole onto its pillar then.



Press the right side and middle FPC to secure its attachment.



Replacement

4.43 Sponge BAT BTB

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Sponge BAT BTB.

Carry out the Installation as described below.

Follow the 5.6 – 5.7 Reassembly instructions!

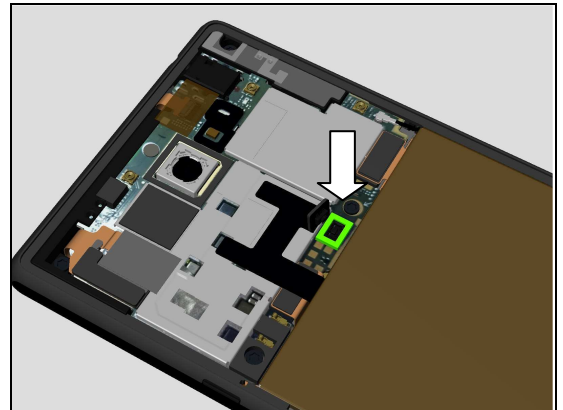
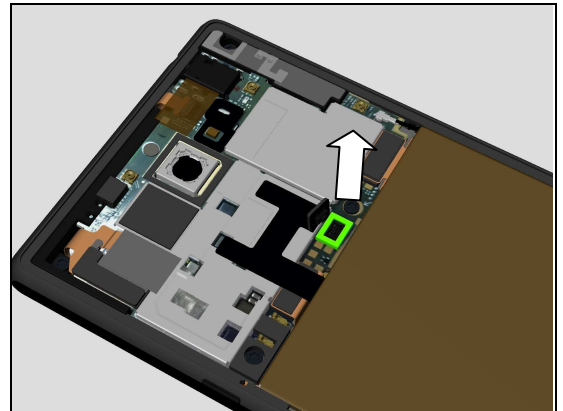
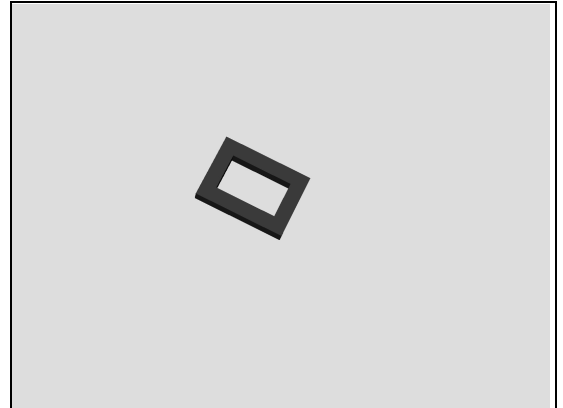
REMOVAL

Remove the Sponge BAT BTB from its connector.

Note: Scrap, not to be reused!

INSTALLATION

Place the Sponge BAT BTB onto its connector.



Replacement

4.44 Sponge KEY BTB

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Sponge KEY BTB.

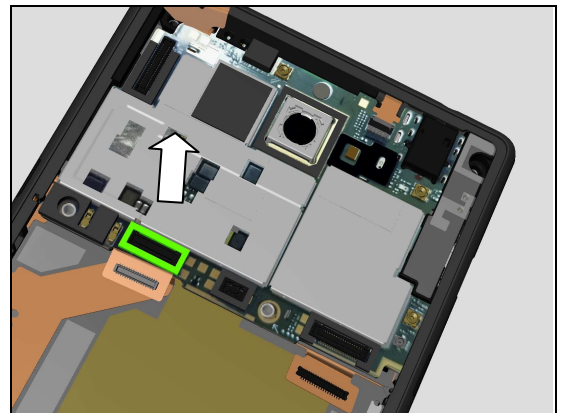
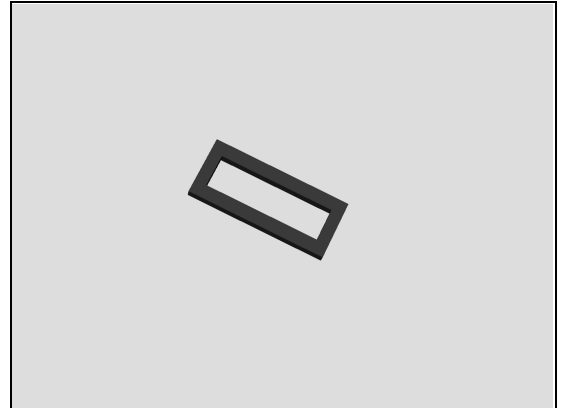
Carry out the Installation as described below.

Follow the 5.6 – 5.7 Reassembly instructions!

REMOVAL

Remove the Sponge KEY BTB from its connector.

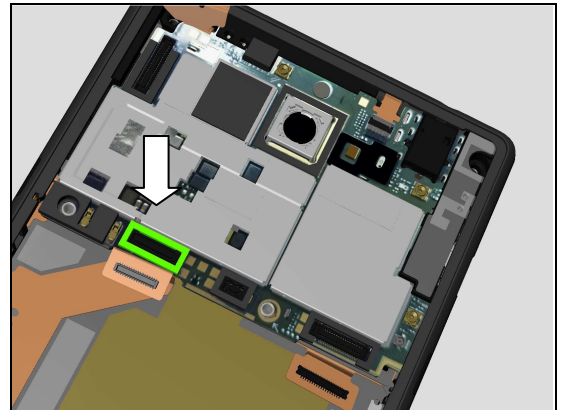
Note: Scrap, not to be reused!



INSTALLATION

Place the Sponge KEY BTB in the correct position.

Note: pay attention about its direction.



Replacement

4.45 Sponge SIM BTB

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Sponge SIM BTB.

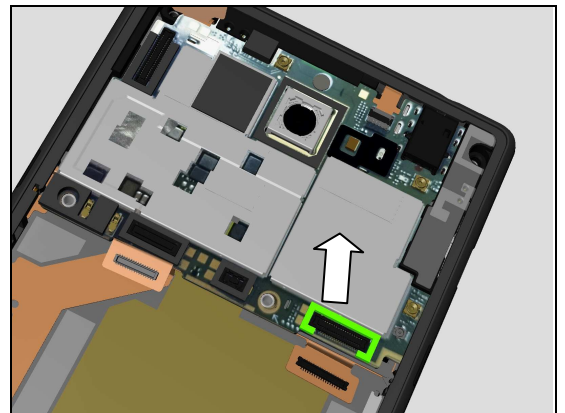
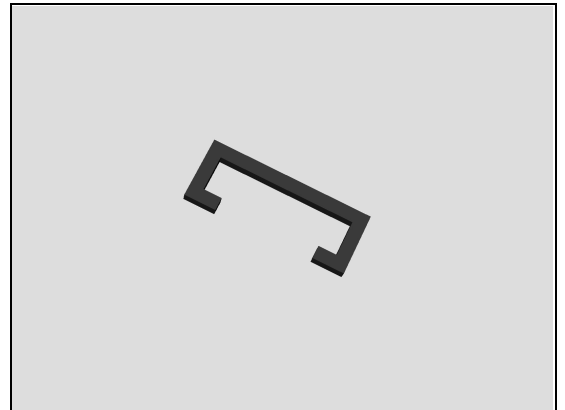
Carry out the Installation as described below.

Follow the 5.6 – 5.7 Reassembly instructions!

REMOVAL

Remove the Sponge SIM BTB from its connector.

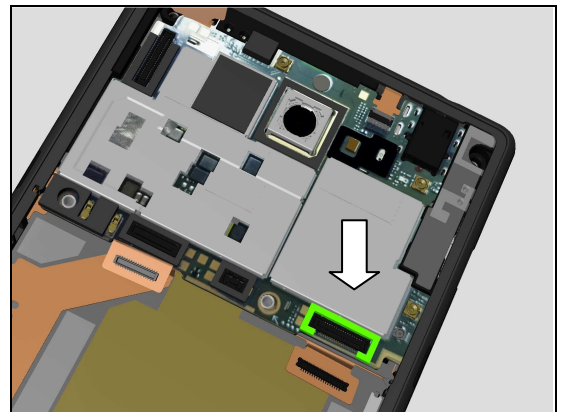
Note: Scrap, not to be reused!



INSTALLATION

Place the Sponge SIM BTB in the correct position.

Note: pay attention about its direction.



Replacement

4.46 Sponge TP BTB

Follow the 3.1 – 3.2 Disassembly instructions!

Carry out the Removal as described below.

Prepare a new Sponge TP BTB.

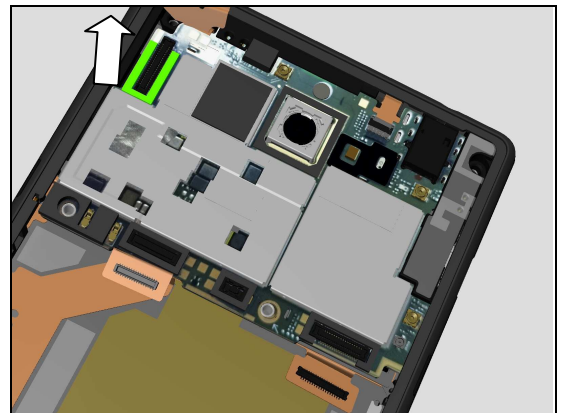
Carry out the Installation as described below.

Follow the 5.6 – 5.7 Reassembly instructions!

REMOVAL

Remove the Sponge TP BTB from its connector.

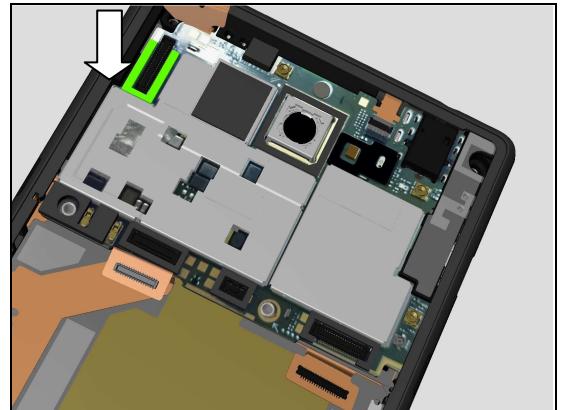
Note: Scrap, not to be reused!



INSTALLATION

Place the Sponge TP BTB in the correct position.

Note: pay attention about its direction.



Replacement

4.47 Sponge Front Camera BTB

Follow the 3.1 – 3.7 Disassembly instructions!

Follow 4.22 Removal instructions.

Carry out the Removal as described below.

Prepare a new Sponge Front Camera BTB.

Carry out the Installation as described below.

Follow 4.22 Installation instructions.

Follow the 5.1 – 5.7 Reassembly instructions!

REMOVAL

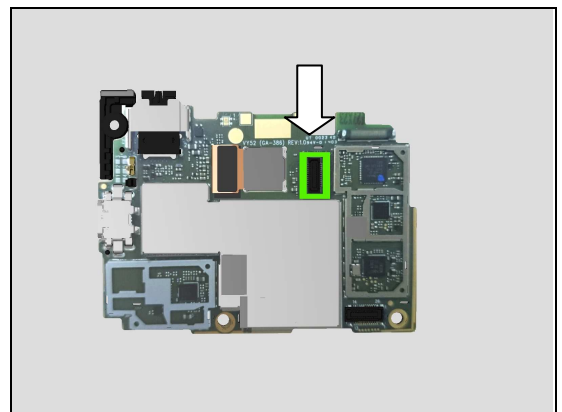
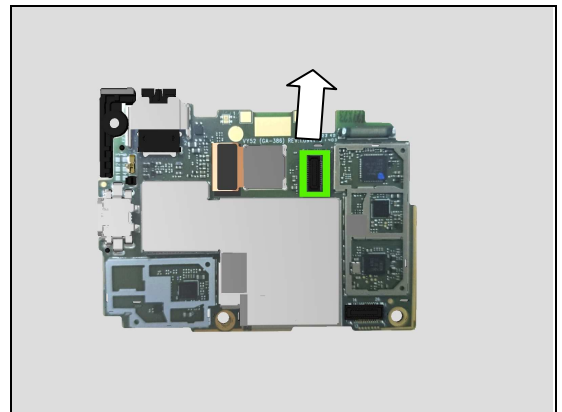
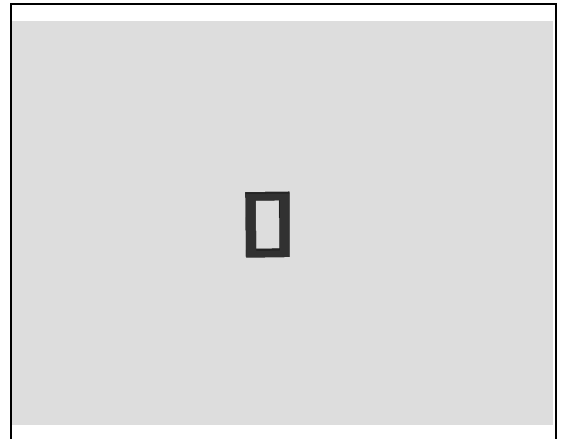
Remove the Sponge Front Camera BTB from its connector.

Note: Scrap, not to be reused!

INSTALLATION

Place the Sponge Front Camera BTB in the correct position.

Note: pay attention about its direction.



Replacement

4.48 Sponge Main Camera BTB

Follow the 3.1 – 3.7 Disassembly instructions!

Follow 4.23 Removal instructions.

Carry out the Removal as described below.

Prepare a new Sponge Main Camera BTB.

Carry out the Installation as described below.

Follow 4.23 Installation instructions.

Follow the 5.1 – 5.7 Reassembly instructions!

REMOVAL

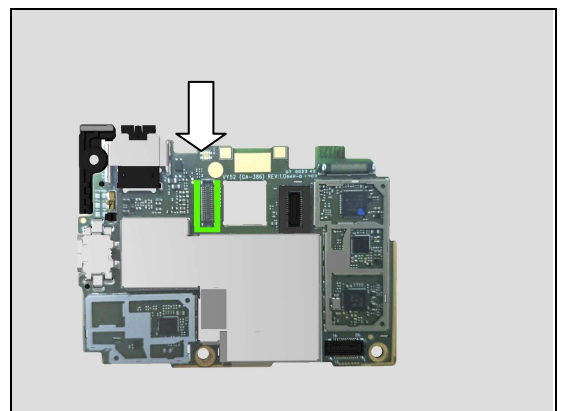
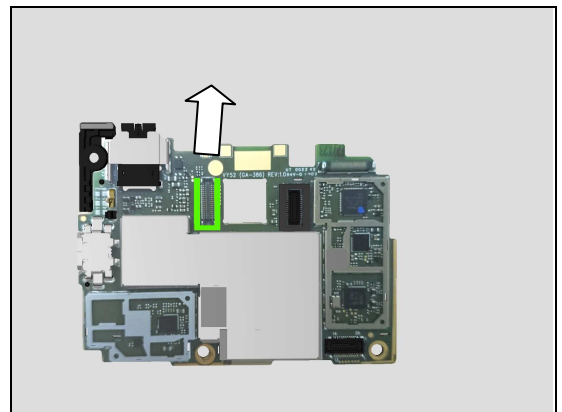
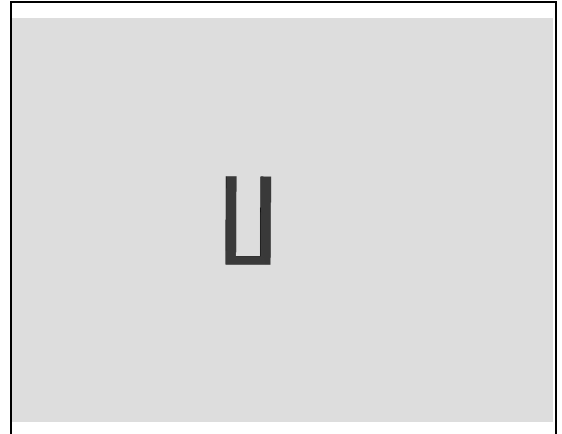
Remove the Sponge Main Camera BTB from its connector.

Note: Scrap, not to be reused!

INSTALLATION

Place the Sponge Main Camera BTB in the correct position.

Note: pay attention about its direction.



Replacement

4.49 Board Swap – Replacement

Follow the 3.1 – 3.7 Disassembly instructions!

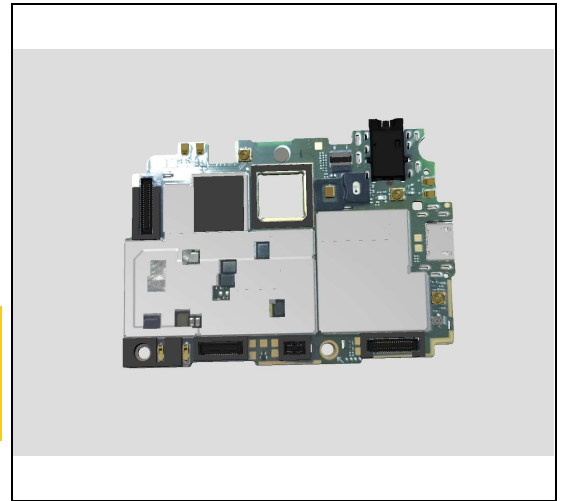
Follow the 4.22, 4.23, 4.48, 4.49, 4.34 Removal instructions!

Replace the Swap Board.

Follow the 4.22, 4.23, 4.48, 4.49, 4.34 Installation instructions!

Follow the 5.1 – 5.7 Reassembly instructions!

When replacing Front Cover LCM TP Assy or board swap, must do the Calibration for P-sensor, light sensor, accelerometer: 1287-2411 Trouble Shooting Application – mechanical.

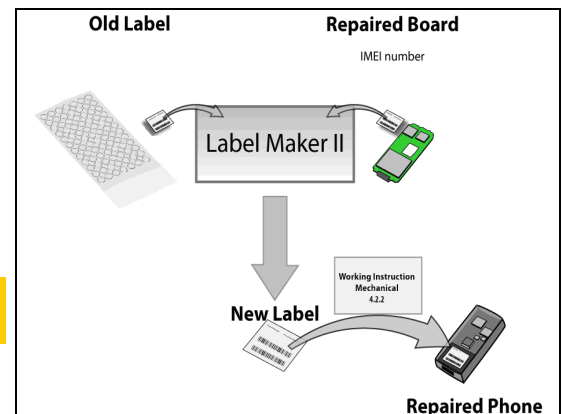


4.50 Board Swap – Change Label

CHANGE LABEL

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

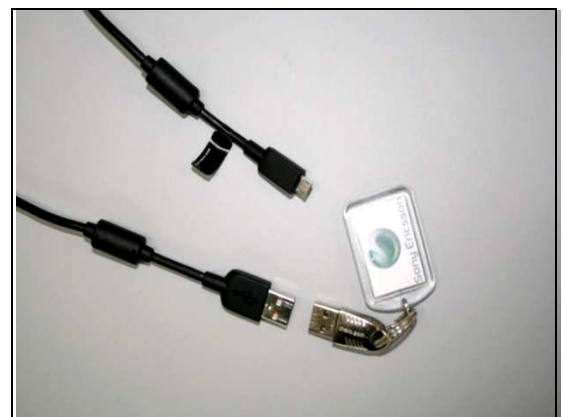
Note: Follow 4.30 Core Unit Label & Tray A thick Blank to change Label instead of Tray A(Laser Print).



4.51 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

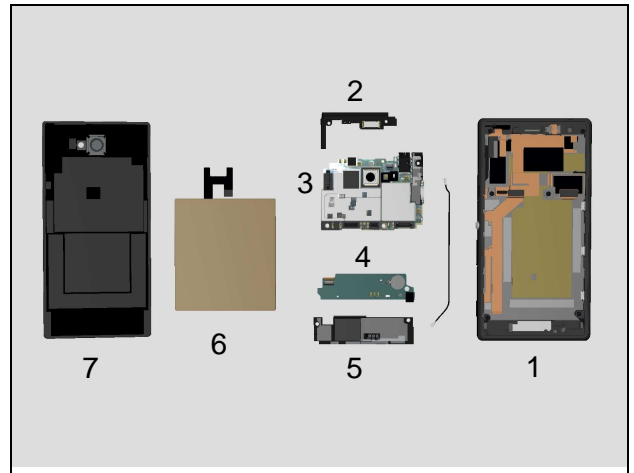
Follow the instructions in the Generic Repair Manual – Build swap for customization of the software.



5 Reassembly

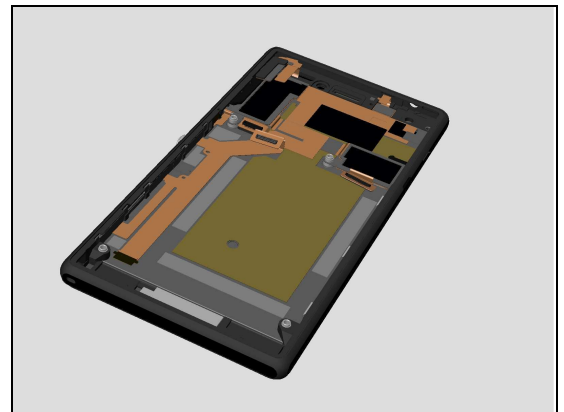
The reassembly is done in the following order:

1. Front Cover LCM TP Assy
2. Antenna DIV
3. Main PBA
4. Sub Board Assy
5. Main ANT Assy
6. Embedded Battery Assy
7. Battery Cover Assy

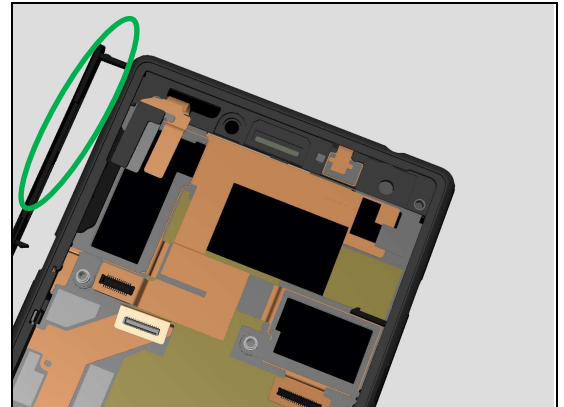


5.1 Front Cover LCM TP Assy

Prepare the Front Cover LCM TP Assy.



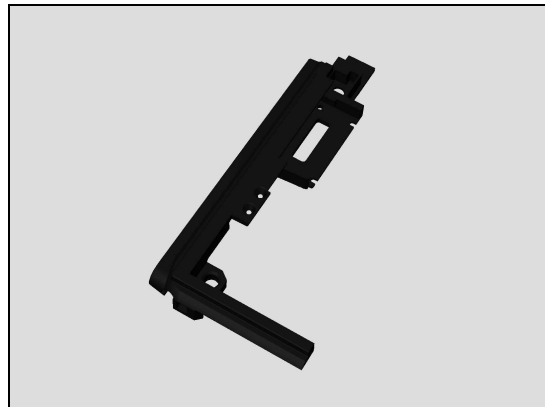
Open the SIM Door.



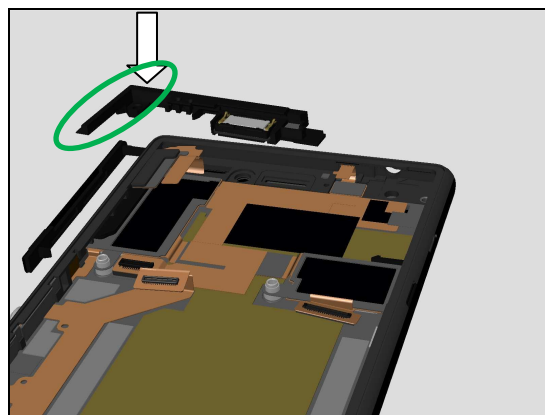
Reassembly

5.2 Antenna DIV

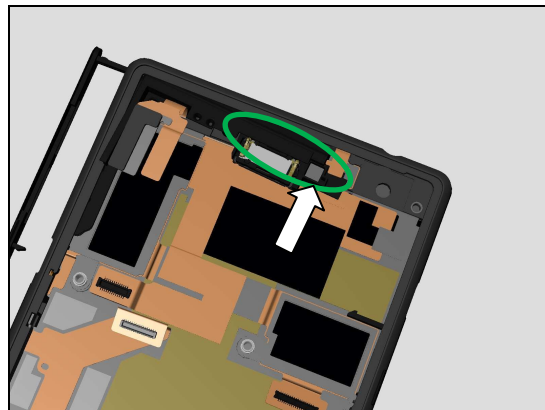
Prepare the Antenna DIV.



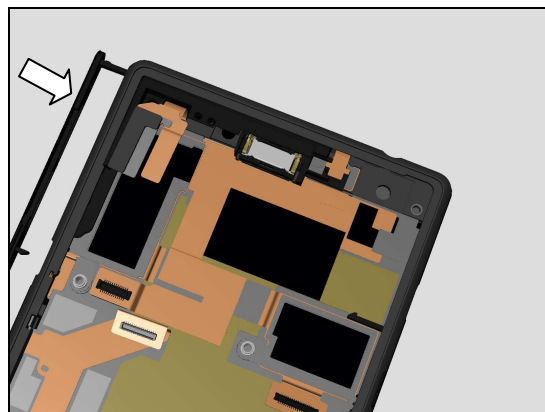
Place Left side of Antenna DIV onto Front Cover LCM TP Assy first.



Push back right side of Antenna DIV onto Front Cover LCM TP Assy.



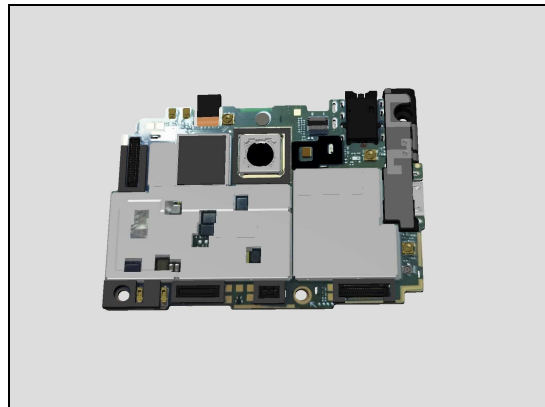
Close the SIM Door.



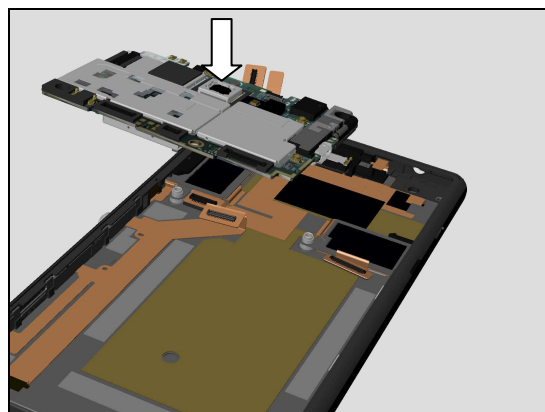
Reassembly

5.3 Main PBA

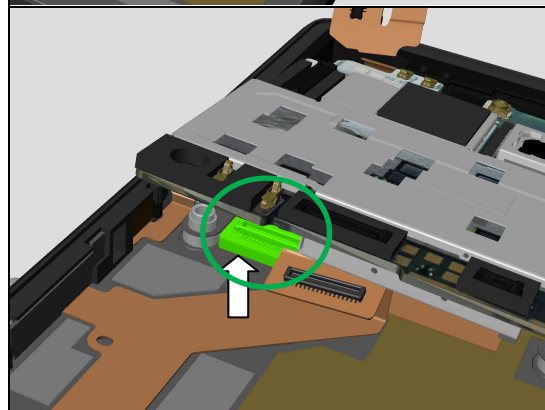
Prepare the Main PBA.



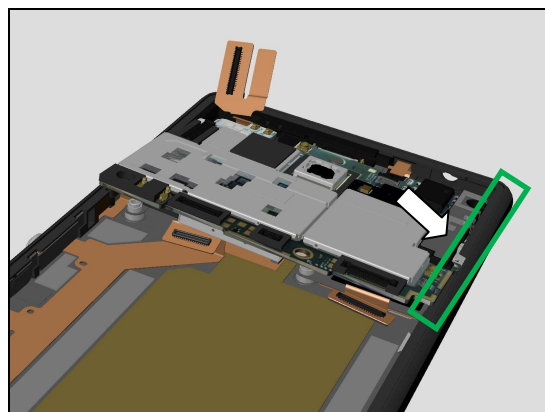
Place the Main PBA onto Front Cover LCM TP Assy.



Assemble the LCM BtB connector under Main PBA first.

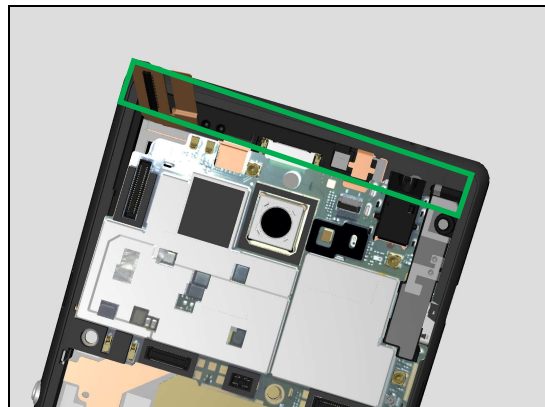


Insert right side of Main PBA onto Front Cover LCM TP Assy as shown then.

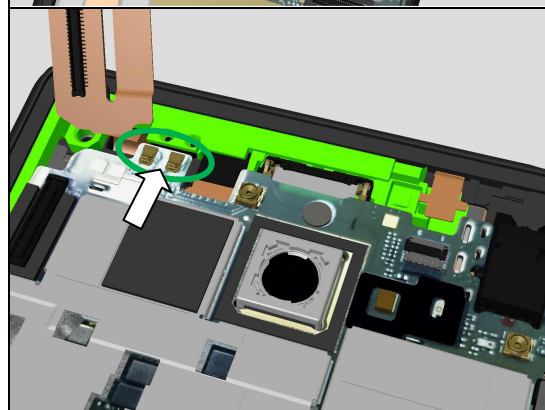


Reassembly

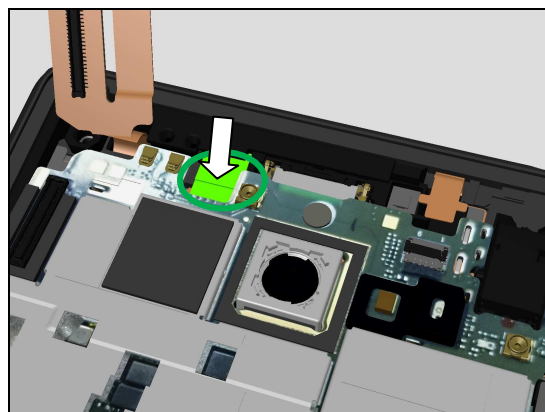
There is about 5mm distance between Main PBA and Front Cover LCM TP Assy.



Insert Main PBA spring pins under Antenna DIV first.

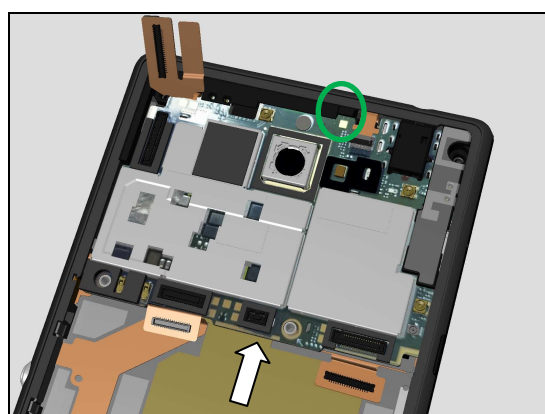


Press Front Camera Assy down onto its correct cavity then.



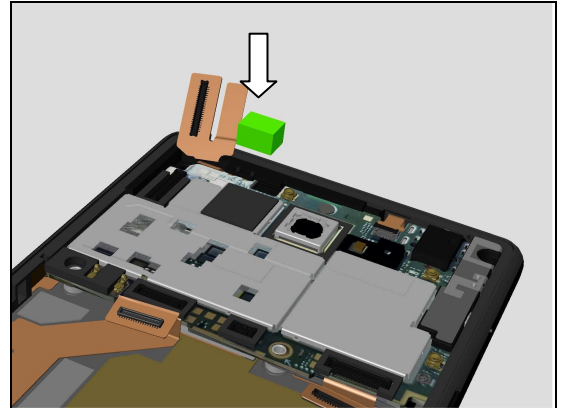
Push bottom side of Main PBA until it is on correct position.
Press down Main PBA around to ensure its correct position.

Note: Make sure there is no gap between Main PBA and Antenna DIV as shown.

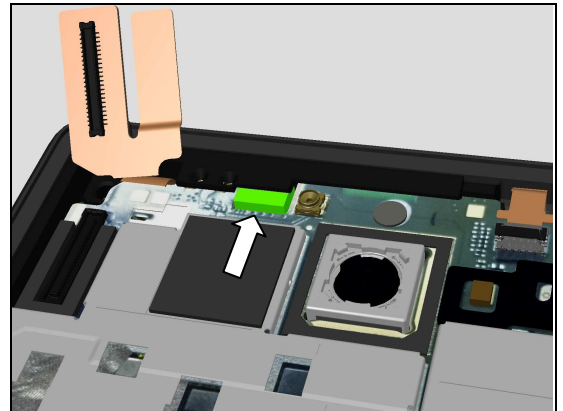


Reassembly

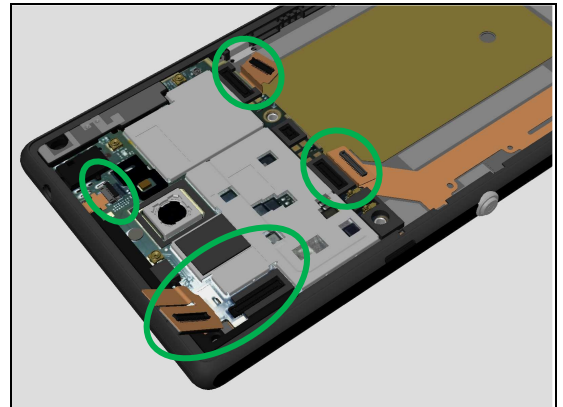
Assemble the Foam Front Camera.



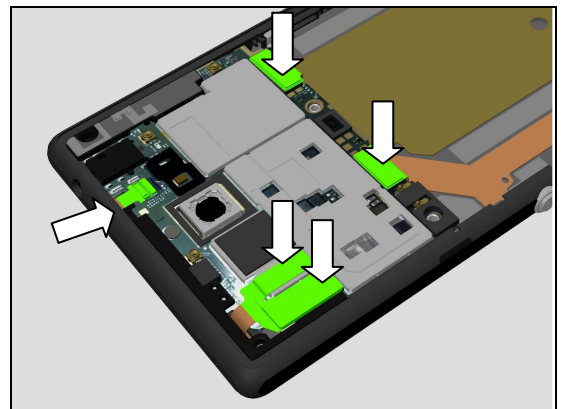
Insert the Foam Front Camera under Antenna DIV at its Cavity to press Front Camera Assy.



Assemble three BtB connectors and one ZIF connector on Main PBA.

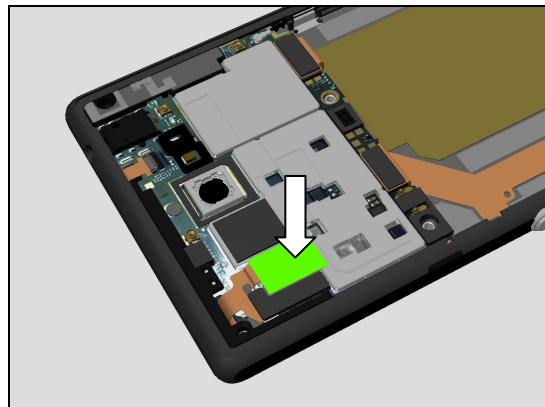


Press to secure its correct connection.

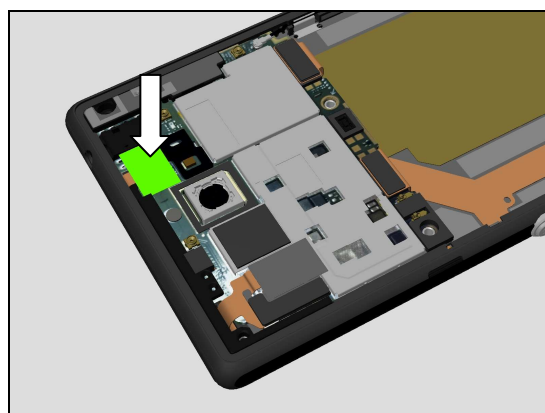


Reassembly

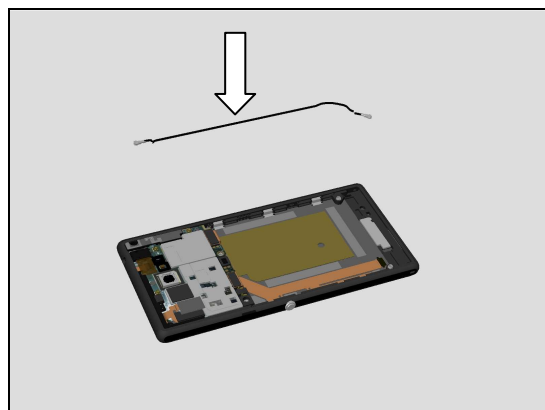
Assemble the ESD Cloth TP BTB on LCM BtB connector.



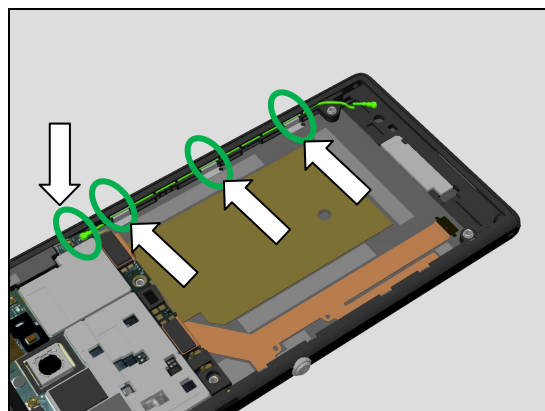
Assemble the Yellow film on PL ZIF connector.



Assemble the RF Cable onto Core unit.



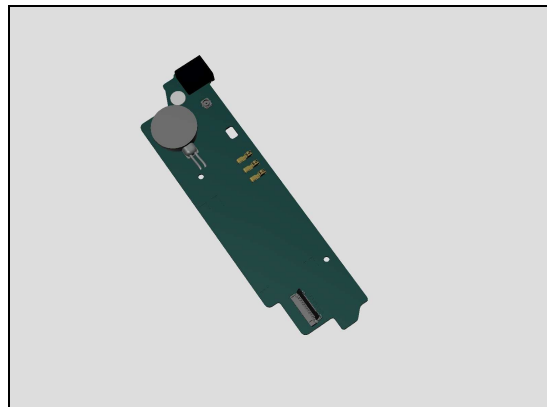
Close the RF Cable connector on Main PBA.
Insert the RF Cable into its cavity on Front Cover LCM TP Assy as shown.



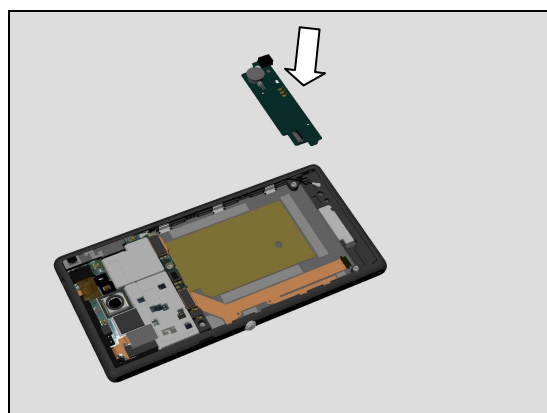
Reassembly

5.4 Sub Board Assy

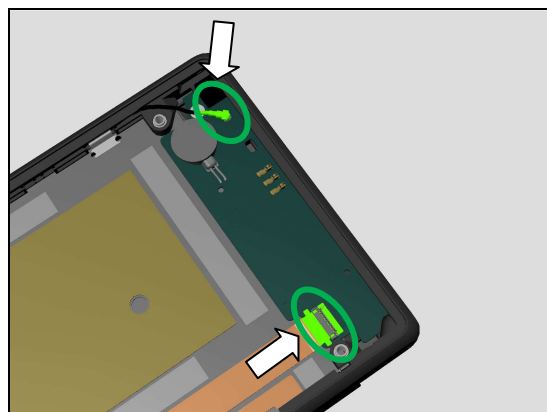
Prepare the Sub Board Assy.



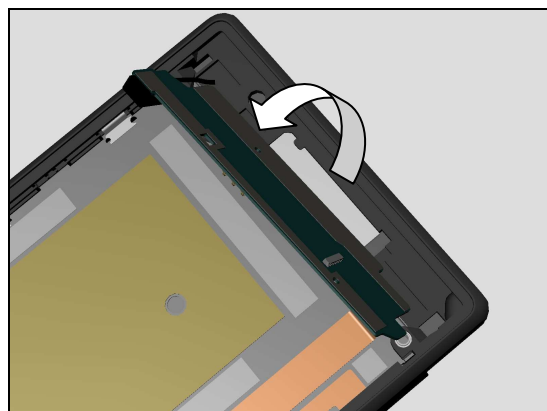
Place the Sub Board Assy onto Front Cover LCM TP Assy.



Close the RF Cable connector on Sub Board Assy.
Insert Side Key FPC into its ZIF connector on Sub Board Assy and close it.



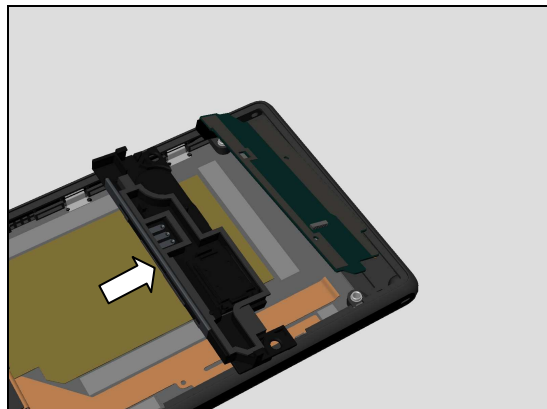
Turn over the Sub Board Assy.



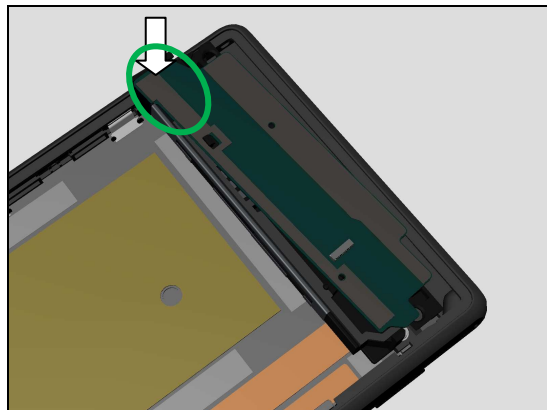
Reassembly

5.5 Main ANT Assy

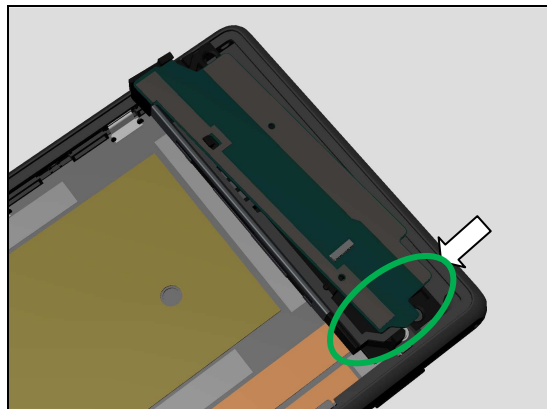
Prepare the Main ANT Assy.



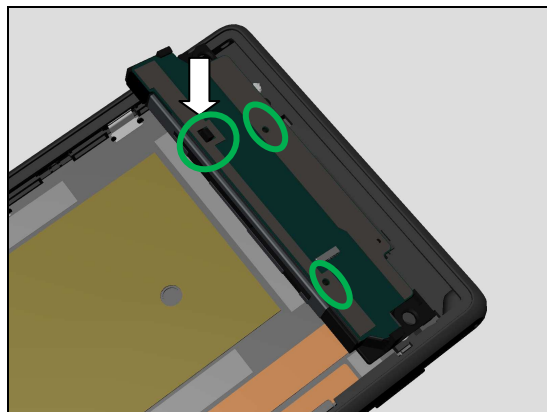
Insert Left side of Sub Board Assy onto Main ANT Assy first.



Push back right side of Sub Board Assy onto Main ANT Assy then.

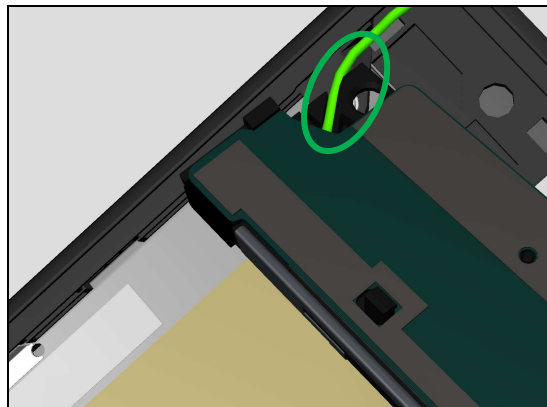


Assemble the middle hook of Main ANT Assy and its two position pillars.

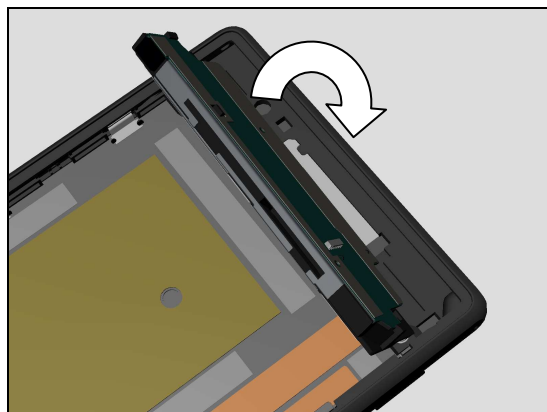


Reassembly

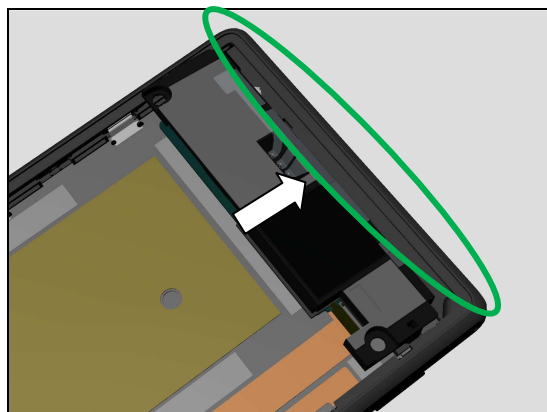
Assemble the RF Cable inside its cavity on Main ANT Assy.



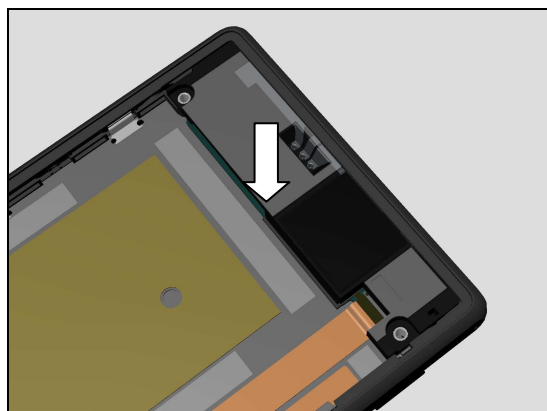
Turn over the Main ANT Assy back on Front Cover LCM TP Assy.



Insert top side of Main ANT Assy into Front Cover LCM TP Assy first.

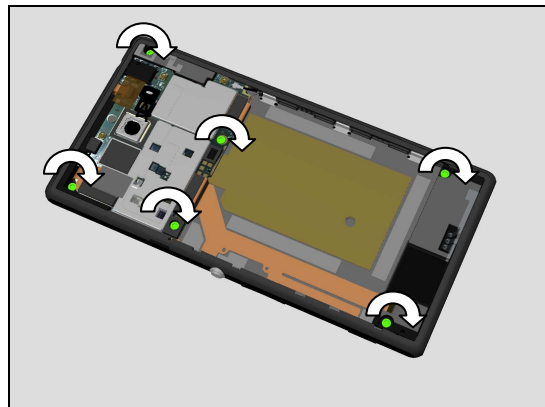


Put down Main ANT Assy then and press it to secure its position.



Reassembly

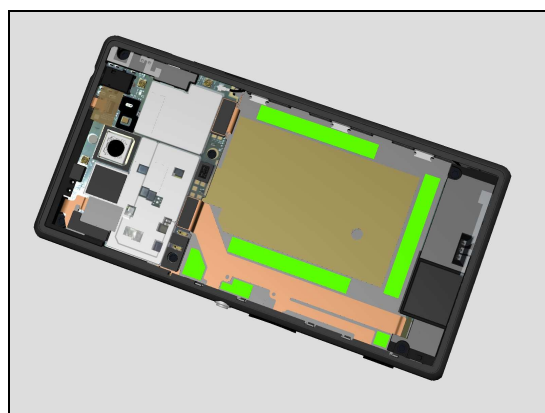
Apply 9.8 N.cm torque when tightening these six Screws with Bits (T5) as shown.



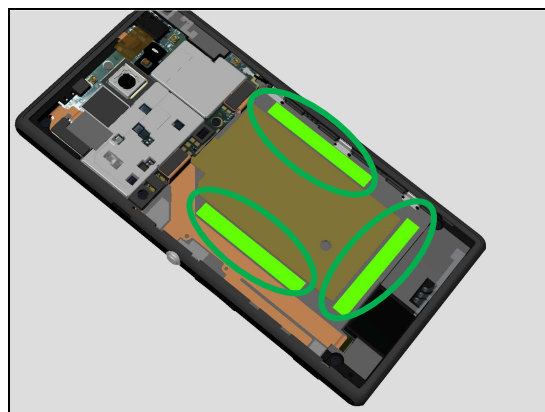
5.6 Embedded Battery Assy

Clean all the old surplus adhesives as shown first.

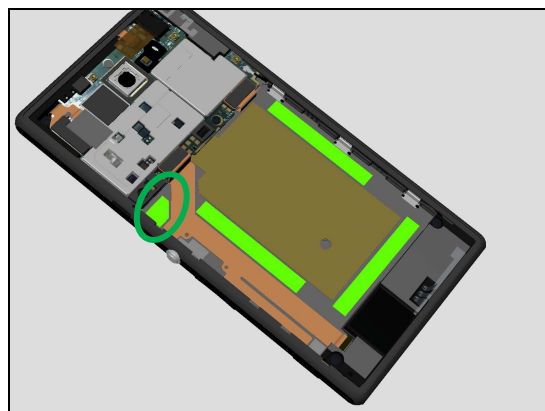
Note: Scrap, old surplus adhesives can not to be reused!



Assemble the new BAT Adhesive1.2.3 Battery as shown.

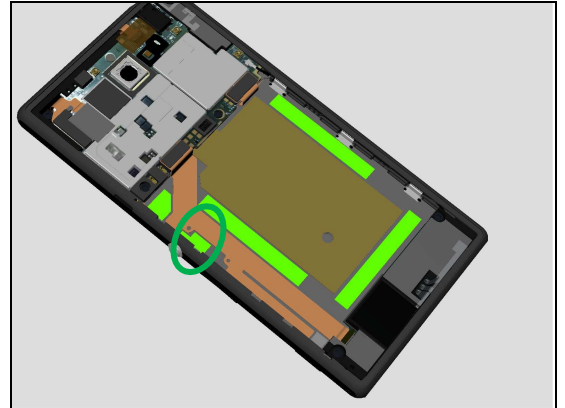


Assemble the new BAT Adhesive6 Reset key as shown.

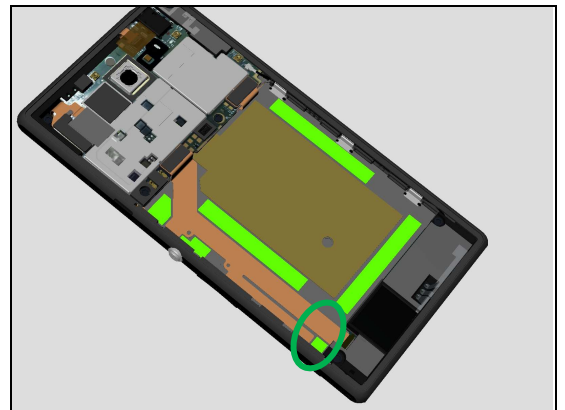


Reassembly

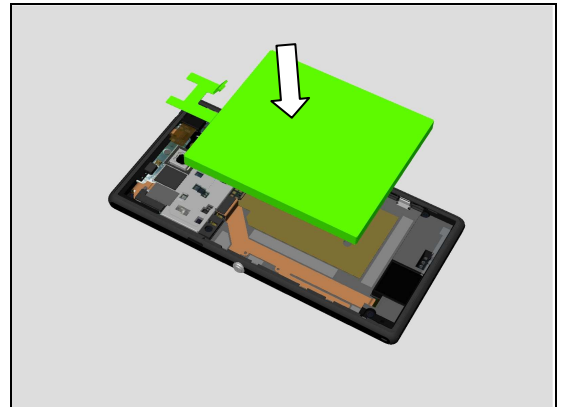
Assemble the new BAT Adhesive5 Power key as shown.



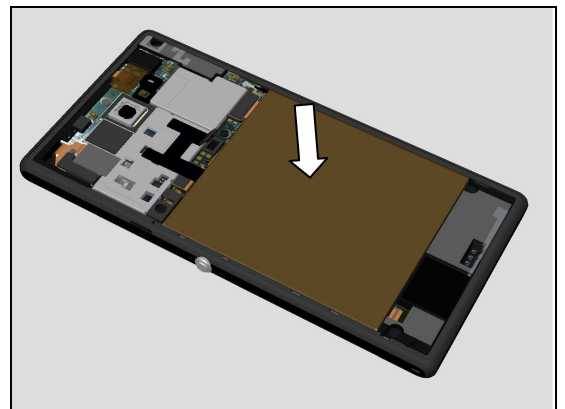
Assemble the new BAT Adhesive4 Camera key as shown.



Insert Battery into its position.

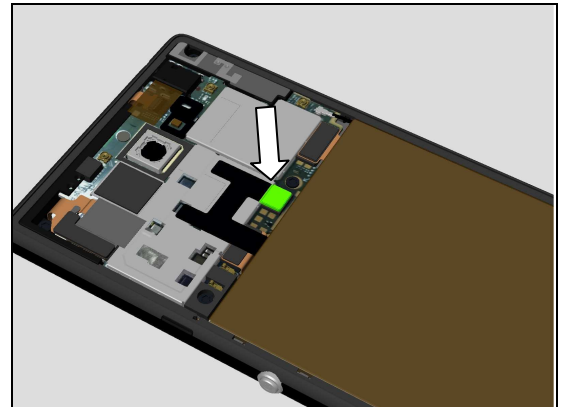


Press down the Battery to secure its position.



Reassembly

Close the BtB connector of Embedded Battery Assy.



5.7 Battery Cover Assy

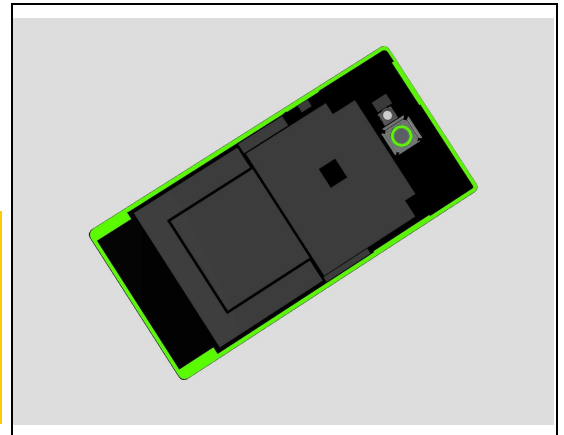
Prepare the Battery Cover Assy.

Clean all the old surplus adhesives as shown.

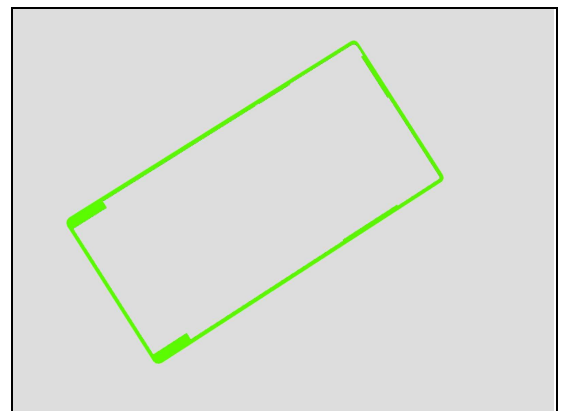
Note: Scrap, old surplus adhesives can not to be reused!

Note: Use Isopropyl Alcohol – 99 % for cleaning around the Battery Cover Assy.

Note: no need of cleaning for new Battery Cover Assy because new Battery Cover Assy already have new BC Adhesive1 Battery Cover and new BC Adhesive5 Camera Sponge.

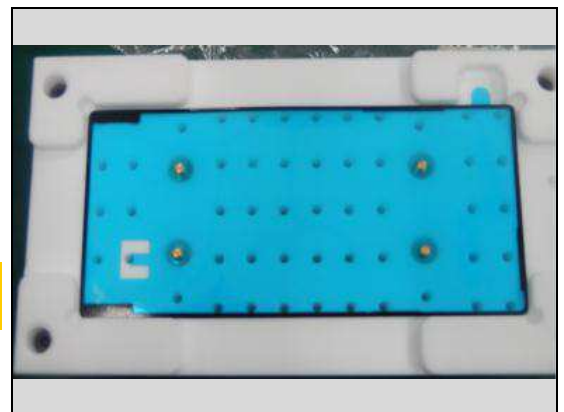


Prepare the new BC Adhesive1 Battery Cover.



Place the new BC Adhesive1 Battery Cover on Assembly fixture for BC Adhesive1 Batter first, ensuring it is flat enough.

Note: Make sure the new BC Adhesive1 Battery Cover on fixture is flat enough, no turn up.

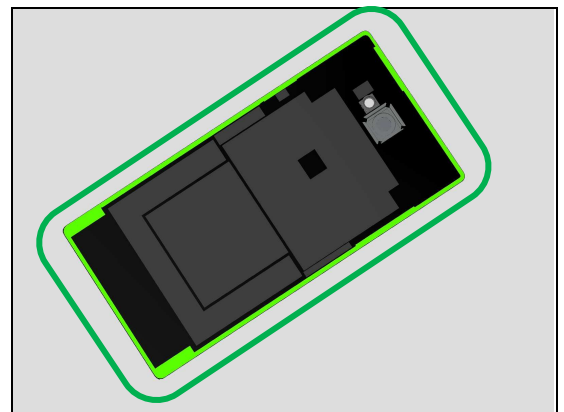


Reassembly

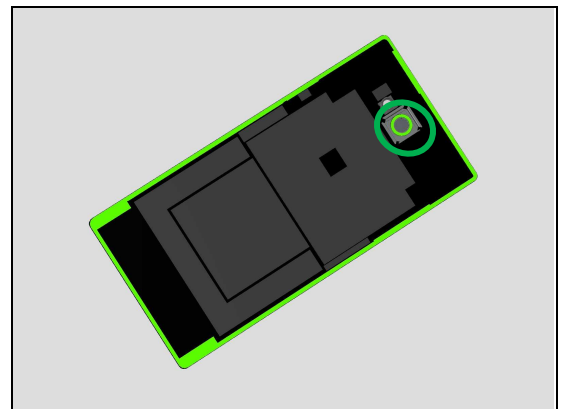
Place the Battery Cover Assy on fixture then and press it carefully.



The new BC Adhesive1 Battery Cover is attached on Battery Cover Assy.



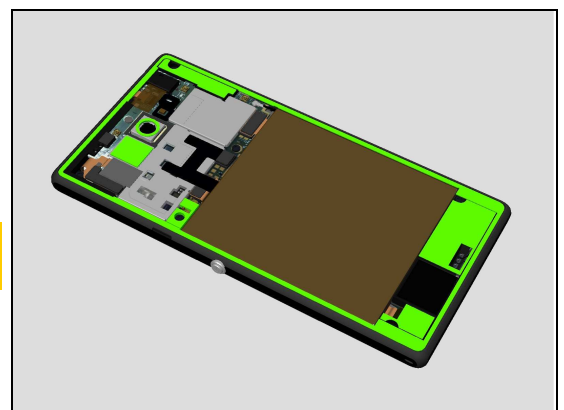
Attach new BC Adhesive5 Camera Sponge on Battery Cover Assy.



Clean all the old surplus adhesives on Core units as shown:

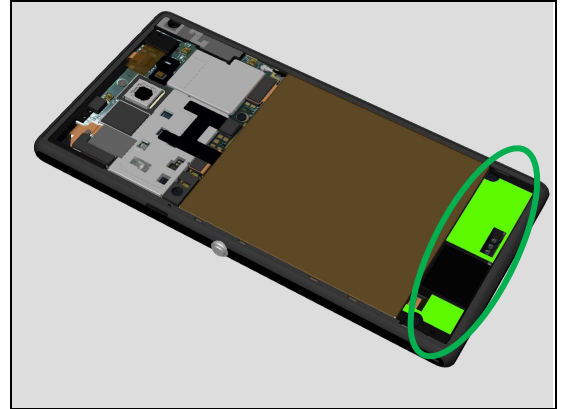
Note: Scrap, old surplus adhesives can not to be reused!

Note: Use Isopropyl Alcohol – 99 % for clean around the Front Cover LCM TP Assy.

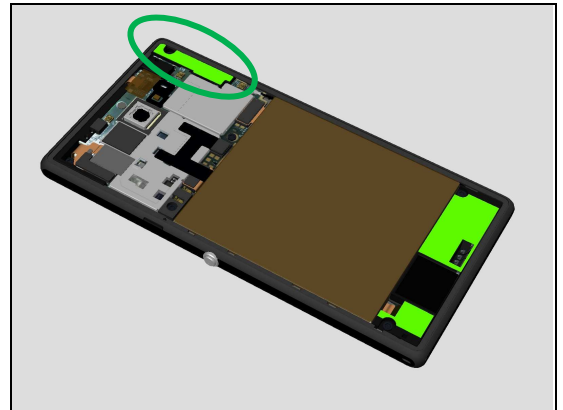


Reassembly

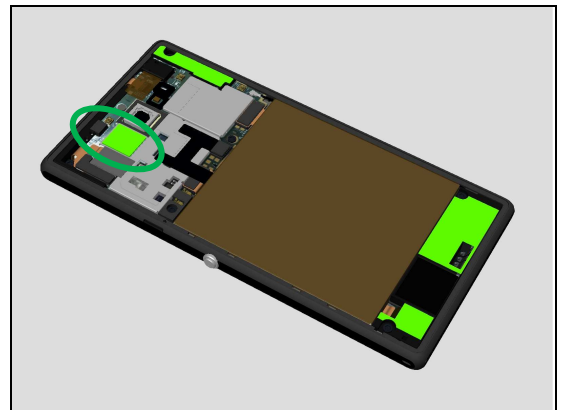
Attach the new BC Adhesive2.3 Main ANT on Core unit.



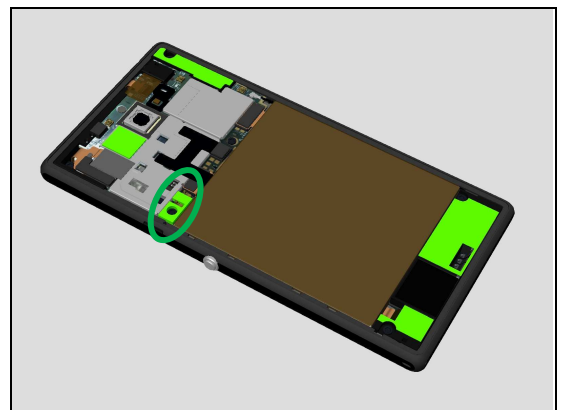
Attach the new BC Adhesive4 GPS ANT on Core unit.



Attach the new BC Adhesive6 Shield Cover on Core unit.

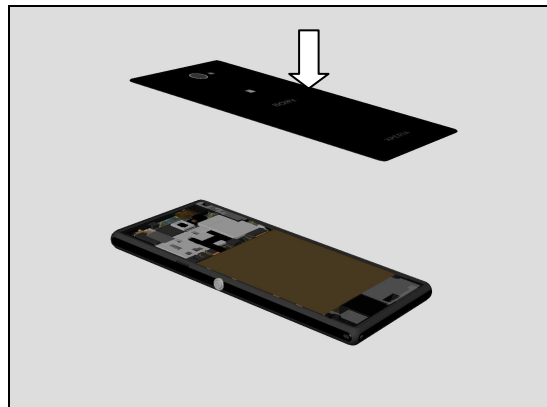


Attach the new BC Adhesive7 NFC Spring on Core unit.



Reassembly

Assemble the Battery Cover Assy onto Core Unit.

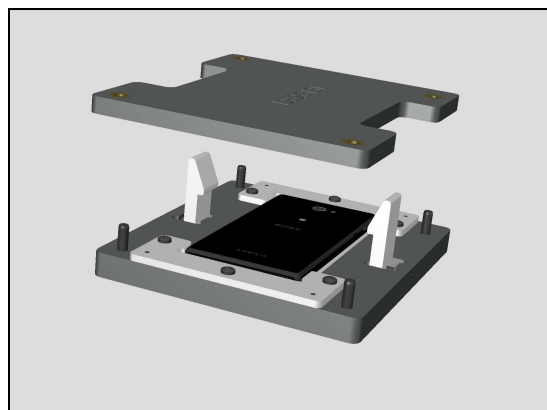


Press the Battery Cover Assy around carefully on Core Unit.

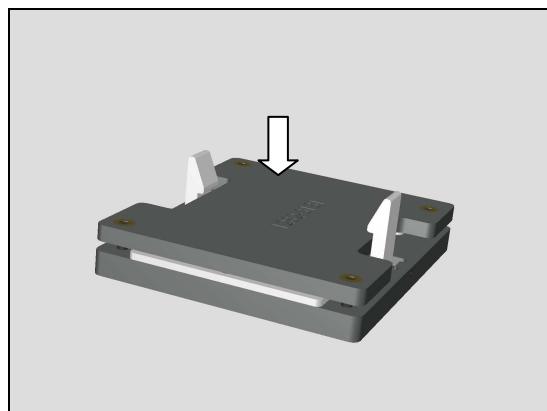


Place phone onto the Battery Cover Press Fixture.

Note: Battery Cover Assy is up;
Pay attention about the phone's direction.



Close the Battery Cover Press Fixture and keep 180 seconds for pressing.



6 Revision History

Rev.	Date	Changes / Comments
1	2014-04-16	Initial release
2	2014-06-12	Update the 4.30 chapter