

SONY

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Working Instructions

- mechanical -



Xperia™ C3 Dual
S55t, S55u, D2502

Xperia™ C3
D2533

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

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

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

1 Exterior Views

1.1 S55t/S55u/D2533/D2502



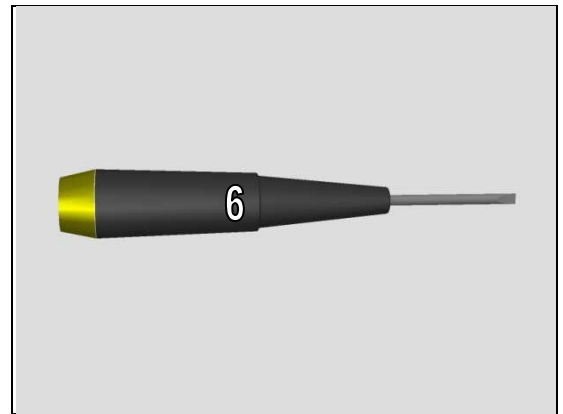
2 Tools

SPECIAL TOOLS

1. Torque Screwdriver
2. Flex Film Assembly Tool
3. Bits JCIS No.0
4. Front Opening Tool
5. Metal Plectrum



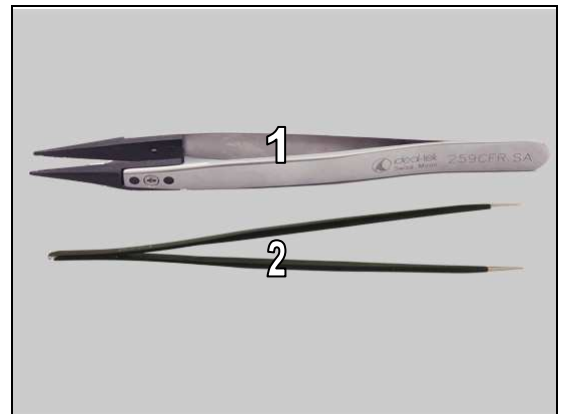
6. Flat Screwdriver (1.5x40)



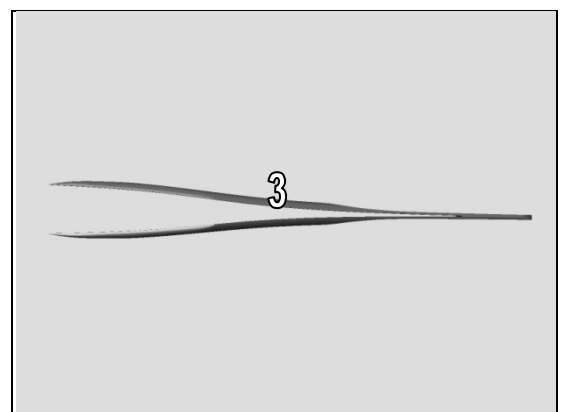
For part no's on the tools above, refer to the 'Tools Catalogue/Matrix'!

STANDARD TOOLS

1. Plastic Tweezers
2. Pointed-tip Tweezers



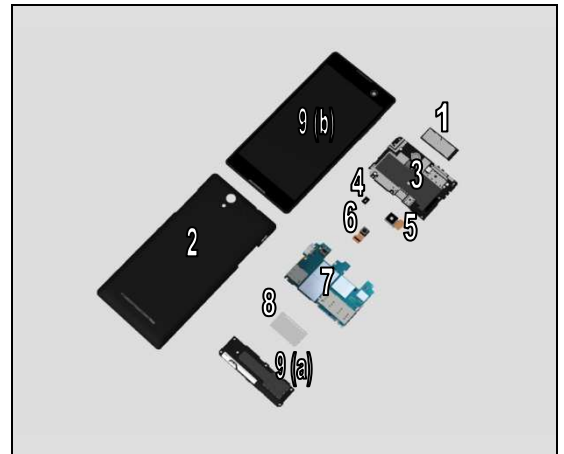
3. Blunt-tip Tweezers



3 Disassembly

The S55t/S55u/D2533/D2502 disassembly is done in the following order:

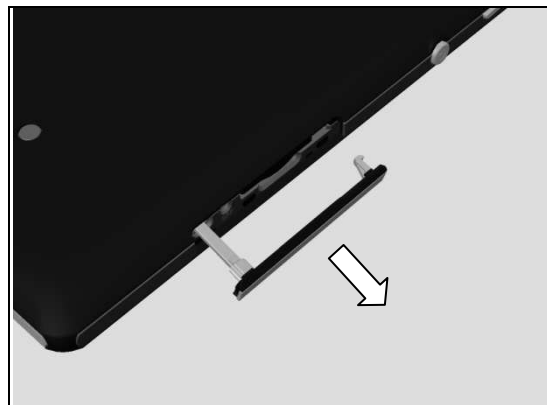
1. SIM Tray
2. Back Cover Assy
3. Ant Top Frame Assy
4. 2nd Mic Rubber
5. Main Camera
6. Chat Camera
7. Main PBA
8. Core Unit label Tray
9. Ant Speaker Bottom Frame Assy (a) and Display Frame Assy (b)



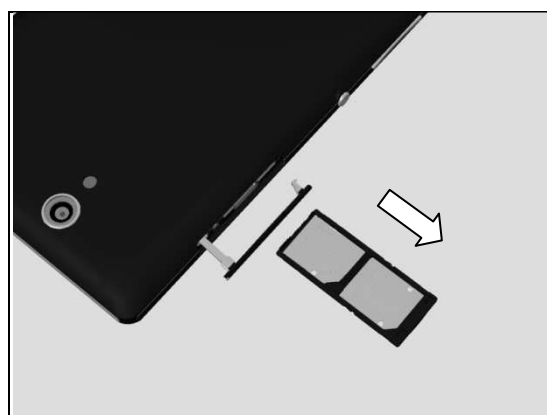
Disassembly

3.1 SIM Tray

Open the SIM Cap.



Remove the SIM Tray with fingers.



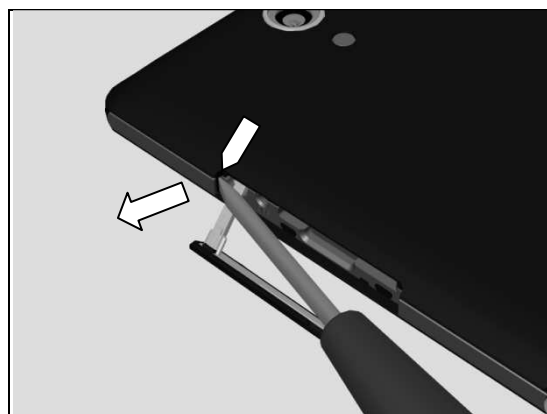
3.2 Back Cover Assy

Open the SD Cap.



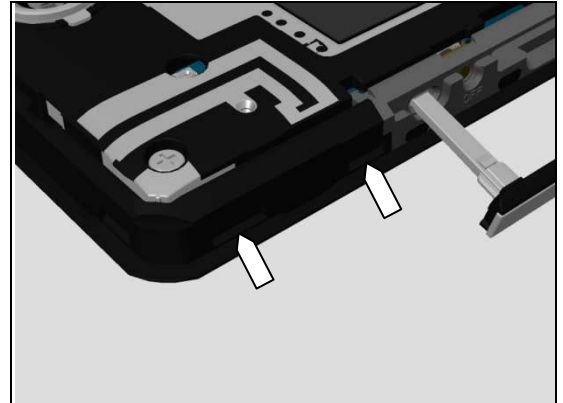
Use the Flat Screwdriver to get space for inserting the Metal Plectrum.

Note! Make sure to insert the Flat Screwdriver between the Back Cover Assy and front frame, and do not detach the Back Cover Panel from the Back Cover Assy.



Disassembly

Note the position of hooks!



Insert the Metal Plectrum between the Back Cover Assy and the front frame.

Note! Do not damage the edge of the front frame and the Back Cover Panels when inserting.

Make sure to insert the Metal Plectrum to the bottom in order to lower the risk of damaging the Back Cover panels when unsnapping the hooks.



Use the Metal Plectrum to unsnap this hook as shown in picture.

Note! Do not damage the edge of the front frame and the Back Cover Panels when unsnapping.

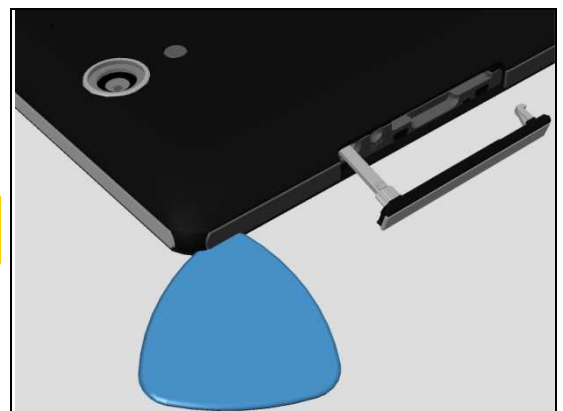
Make sure that the surface of the Metal Plectrum and the edge of the front frame are always parallel to each other when unsnapping, in order to lower the risk of damaging the Back Cover Panels and the front frame.

Repeat this action carefully if the first time unsnapping fails.



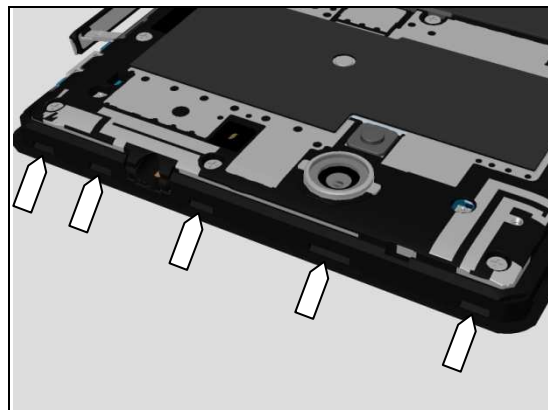
Do the same for this hook.

Note! The hooks near Back Cover Assy corners are tighter, the unsnapping action may repeat some times.



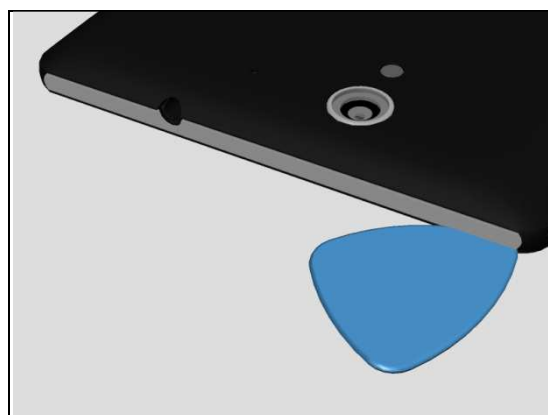
Disassembly

Note the position of hooks!

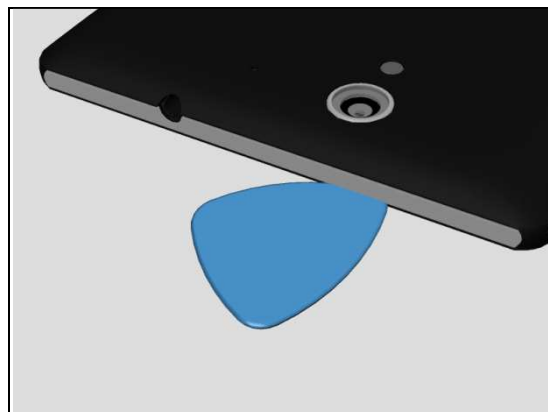


Do the same for this hook.

Note! The hooks near Back Cover Assy corners are tighter, the unsnapping action may repeat some times.

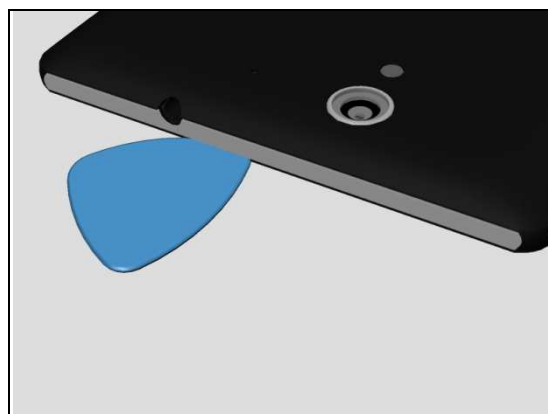


Do the same for this hook.



Do the same for this hook.

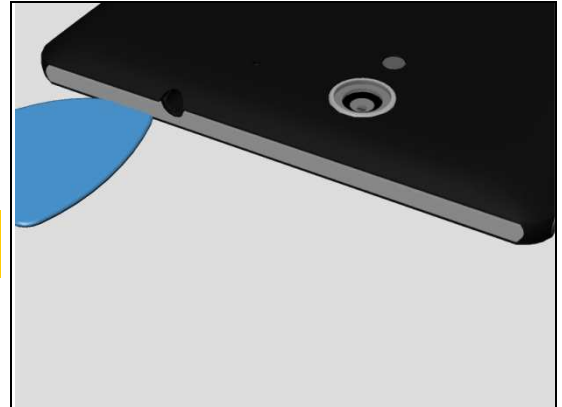
Be careful! Do not deform the Back Cover Assy near the Audio Jack hole.



Disassembly

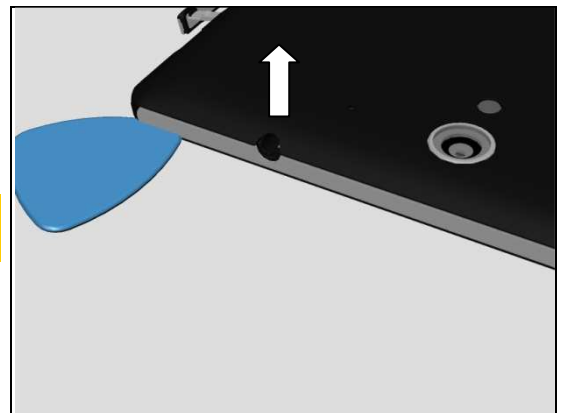
Do the same for this hook.

Be careful! Do not deform the Back Cover Assy near the Audio Jack hole.

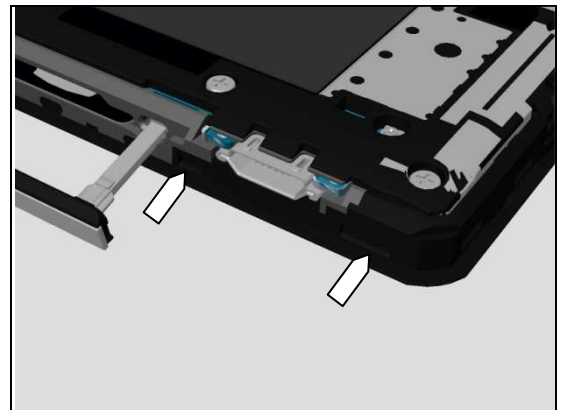


Do the same for this hook.

Note! The hooks near Back Cover Assy corners are tighter, the unsnapping action may repeat some times.

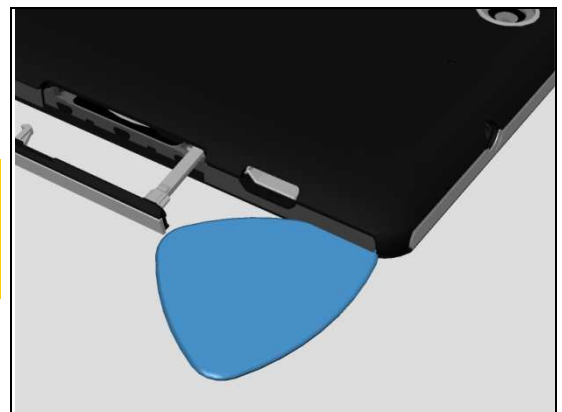


Note the position of hooks!



Do the same for this hook.

Note! The hooks near Back Cover Assy corners are tighter, the unsnapping action may repeat some times.
Be careful! Do not deform the Back Cover Assy near the USB hole.



Disassembly

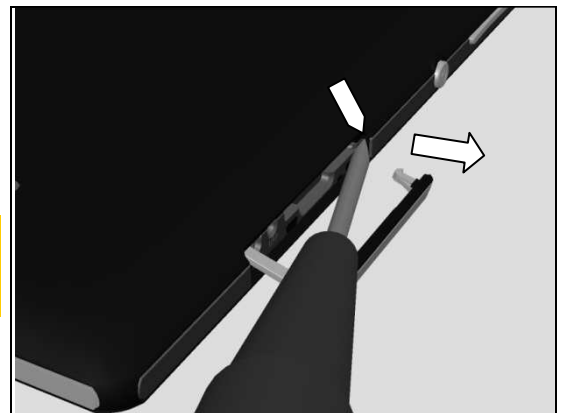
Do the same for this hook.

Be careful! Do not deform the Back Cover Assy near the USB hole.

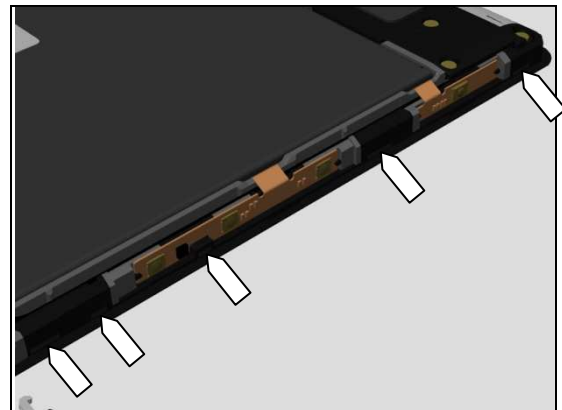


Use the Flat Screwdriver to get space for inserting the Metal Plectrum.

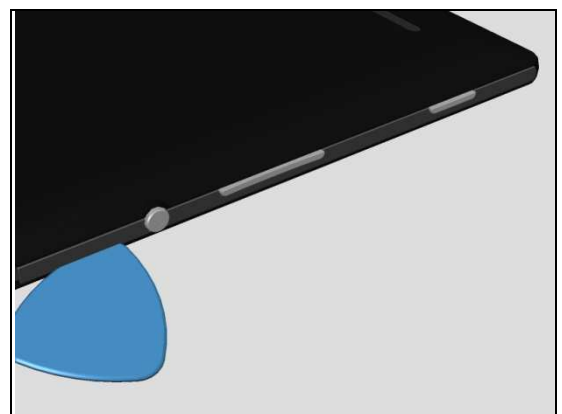
Note! Make sure to insert the Flat Screwdriver between the Back Cover Assy and front frame, and do not detach the Back Cover Panel from the Back Cover Assy.



Note the position of hooks!



Do the same for these 2 hooks.



Disassembly

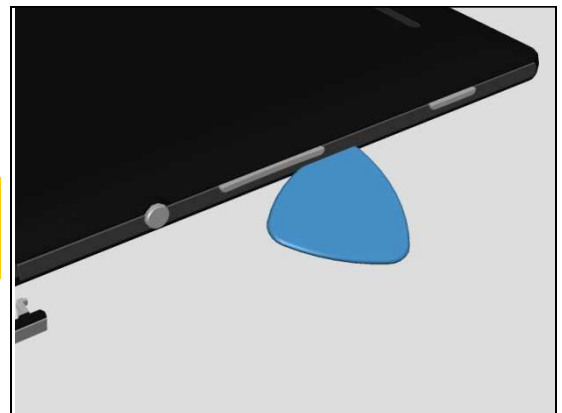
Do the same for this hook.

Note! Do not damage the components on the Power/Side Key FPC when inserting Metal Plectrum and unsnapping the hook.



Do the same for this hook.

Note! Do not damage the components on the Power/Side Key FPC when inserting Metal Plectrum and unsnapping the hook.



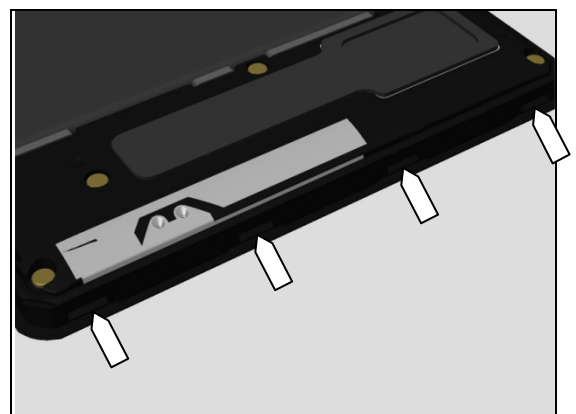
Do the same for this hook.

Note! Do not damage the components on the Camera Key FPC when inserting Metal Plectrum and unsnapping the hook.

Note! The hooks near Back Cover Assy corners are tighter, the unsnapping action may repeat some times.



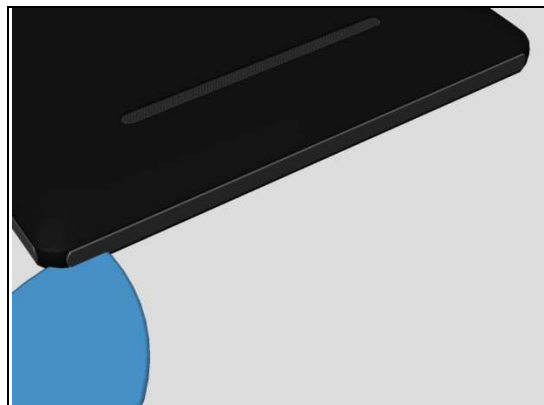
Note the position of hooks!



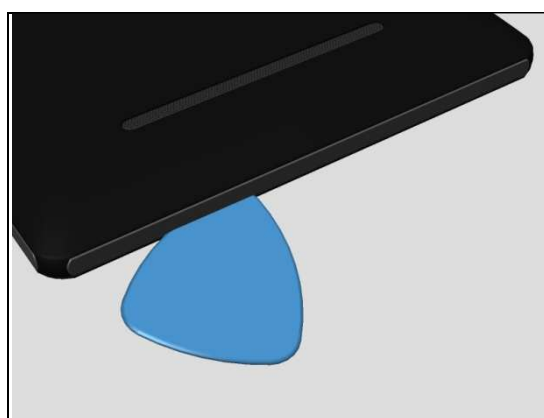
Disassembly

Do the same for this hook.

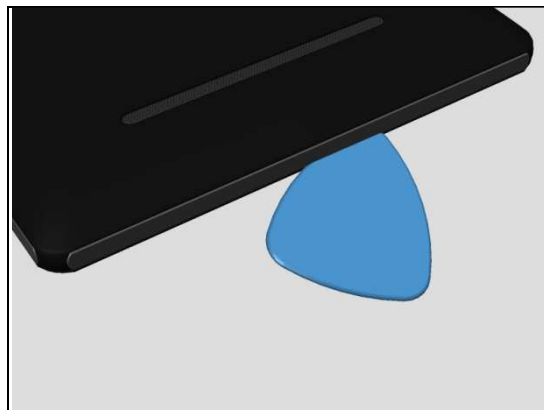
Note! The hooks near Back Cover Assy corners are tighter, the unsnapping action may repeat some times.



Do the same for this hook.

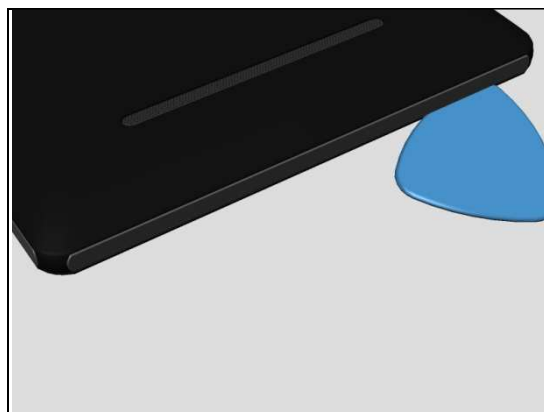


Do the same for this hook.



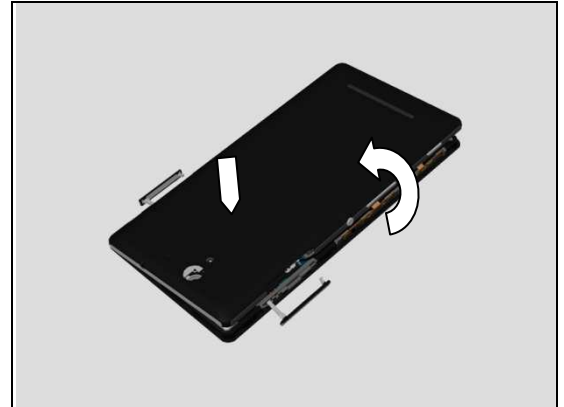
Do the same for this hook.

Note! The hooks near Back Cover Assy corners are tighter, the unsnapping action may repeat some times.



Disassembly

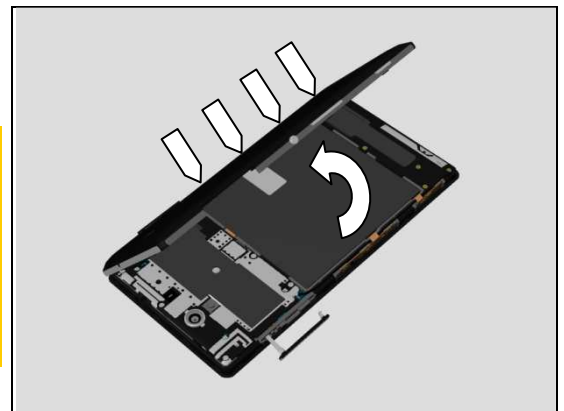
Open the Back Cover Assy as shown in picture to release the hook in the center.



Unsnap the 4 hooks at the side of Back Cover USB Side Lower Panel by rotating the Back Cover Assy.

Note! These 4 hooks are tighter than the others, so this disassembly method has lower possibility of damaging the Back Cover Assy and front frame than unsnapping by Metal Plectrum.

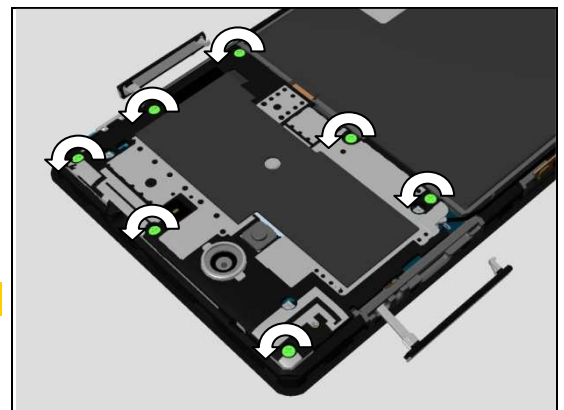
This action should not damage the Back Cover Assy even though it seems the hooks are pretty tight and more force is applied.



3.3 Ant Top Frame Assy

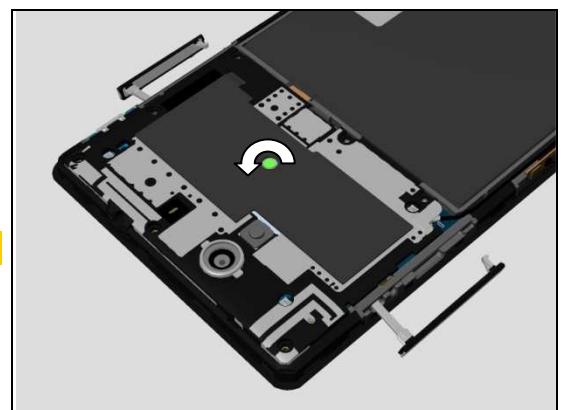
Remove the seven Screw Torx Len:3.1 Diam:1.4 by using a screwdriver with Bits (JCIS No 0).

Scrap! Not to be reused!



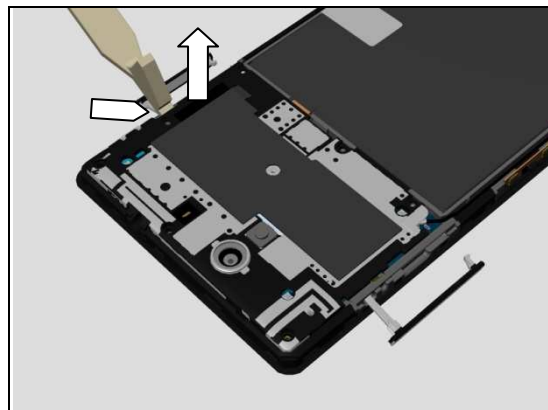
Remove the Screw Other Len:1.1 Diam:1.2 by using a screwdriver with Bits (JCIS No 0).

Scrap! Not to be reused!

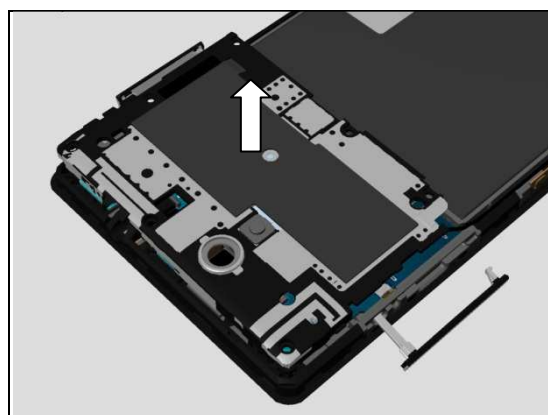


Disassembly

Release the hooks and lift up the Ant Top Frame Assy.



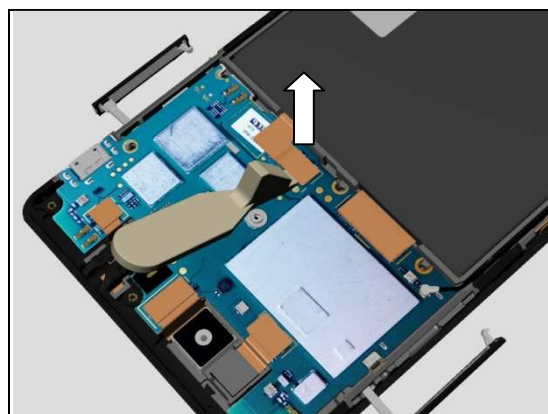
Remove the Ant Top Frame Assy.



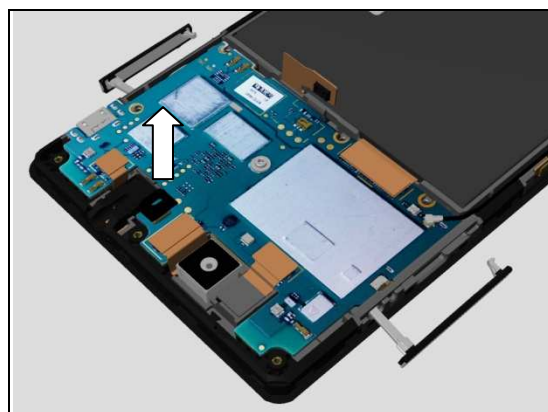
3.4 2nd Mic Rubber

Disconnect the Battery FPC BtB connector.

Do not damage components on the Main PBA!



Remove the 2nd Mic Rubber.



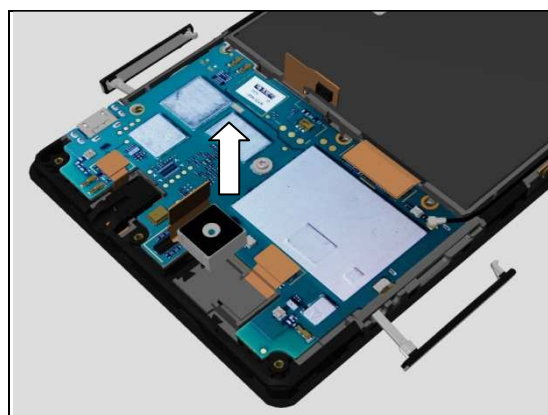
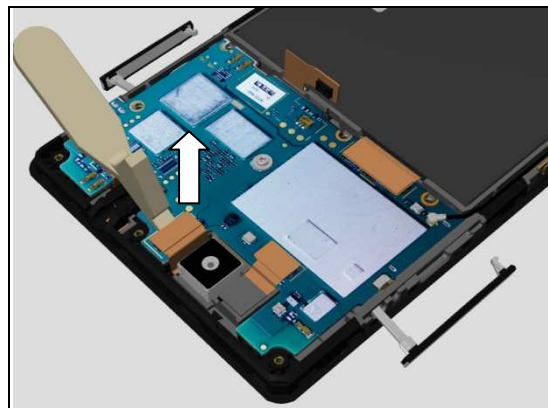
Disassembly

3.5 Main Camera

Disconnect BtB connector of the Main Camera FPC.

Do not damage components on the Main PBA!

Remove the Main Camera.

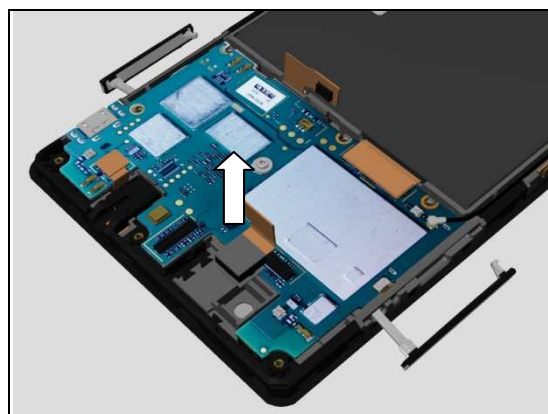
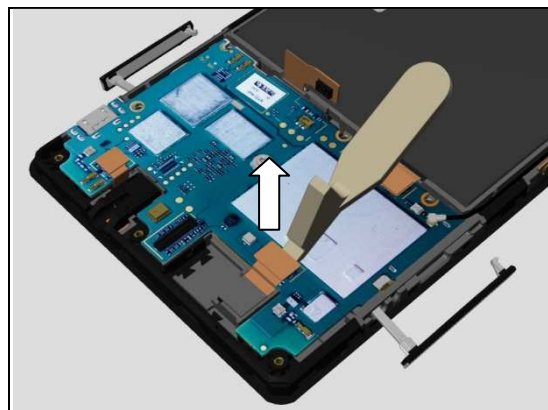


3.6 Chat Camera

Disconnect BtB connector of the Chat Camera FPC.

Do not damage components on the Main PBA!

Remove the Chat Camera.



Disassembly

3.7 Main PBA

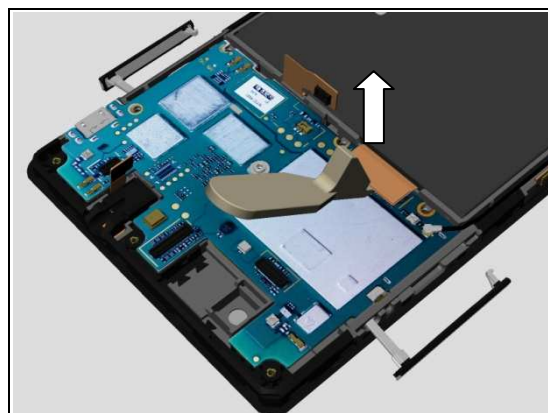
Disconnect BtB connector of the Audio Jack Assy.

Do not damage components on the Main PBA!



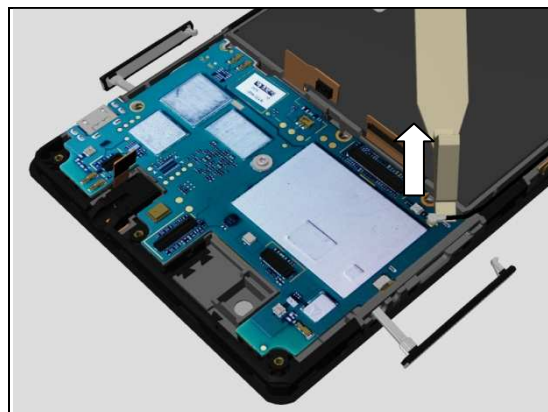
Disconnect BtB connector of the Main FPC Assy.

Do not damage components on the Main PBA!

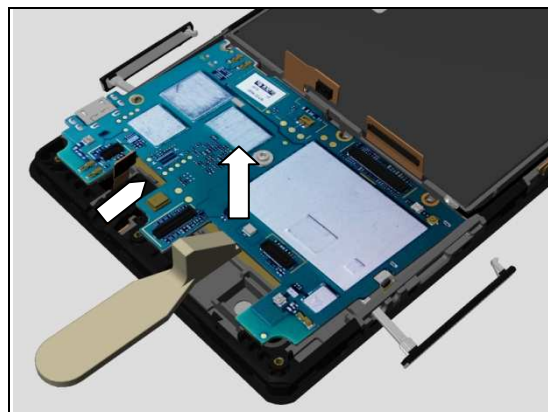


Disconnect RF Cable connector.

Do not damage components on the Main PBA!

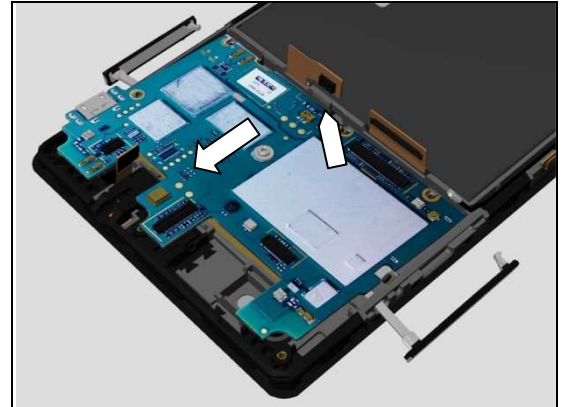


Release the upper side of Main PBA.

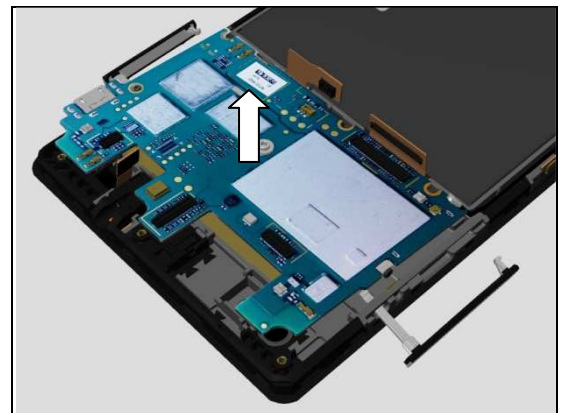


Disassembly

Release the bottom side of Main PBA.

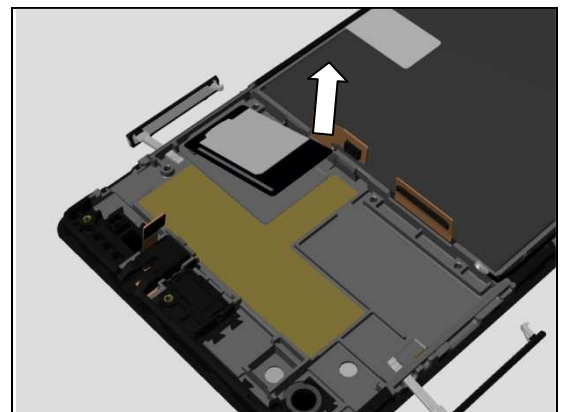


Remove the Main PBA.



3.8 Core Unit label Tray

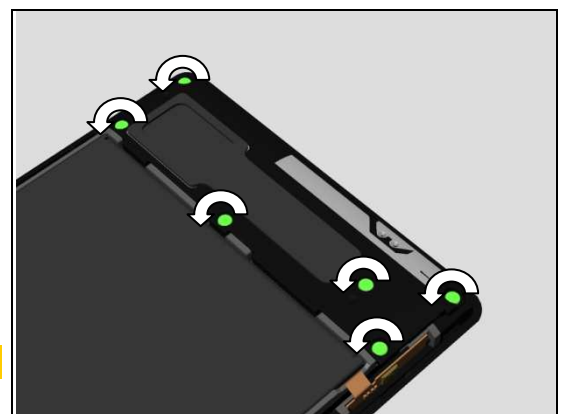
Remove the Core Unit label Tray.



3.9 Ant Speaker Bottom Frame Assy (a) and Display Frame Assy (b)

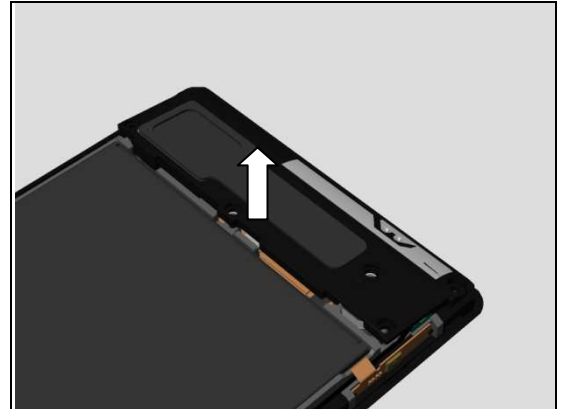
Remove the six Screw M1.4x2.8 by using a screwdriver with Bits (JCIS No 0).

Scrap! Not to be reused!

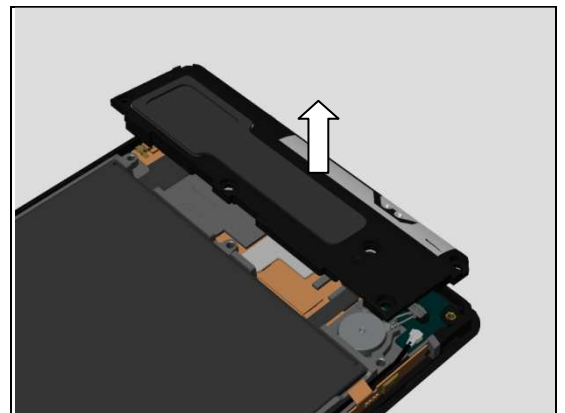


Disassembly

Release the Ant Speaker Bottom Frame Assy.



Remove the Ant Speaker Bottom Frame Assy.



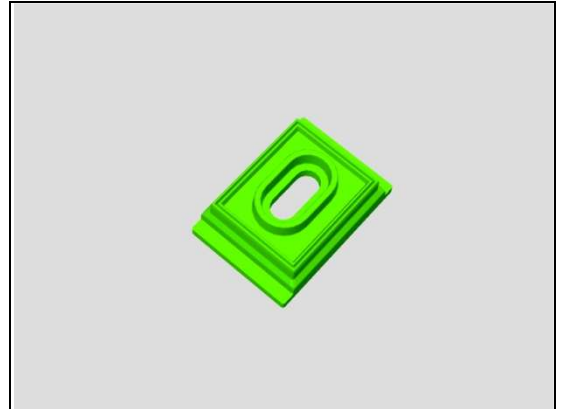
4 Replacement

4.1 2nd Mic Rubber

Follow the 3.2 – 3.4 Disassembly instructions!

Prepare a new 2nd Mic Rubber.

Follow the 5.6 – 5.8 Reassembly instructions!

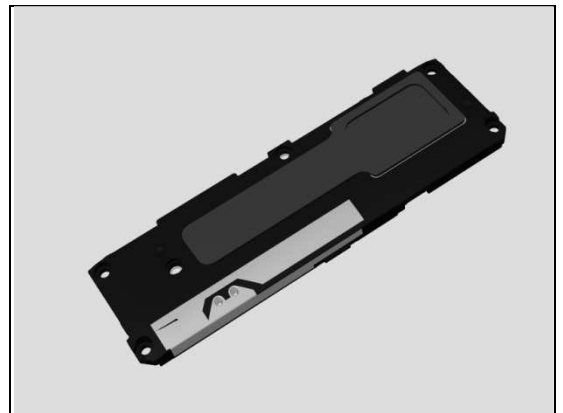


4.2 Ant Speaker Bottom Frame Assy

Follow the 3.2 and 3.9 Disassembly instructions!

Prepare a new Ant Speaker Bottom Frame Assy.

Follow the 5.1 and 5.8 Reassembly instructions!

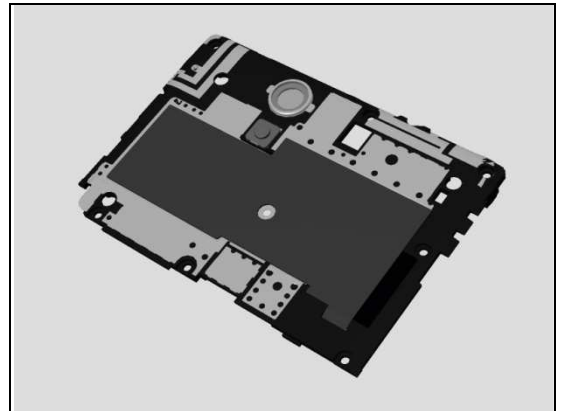


4.3 Ant Top Frame Assy

Follow the 3.2 – 3.3 Disassembly instructions!

Prepare a new Ant Top Frame Assy.

Follow the 5.7 – 5.8 Reassembly instructions!



4.4 Back Cover Assy

Follow the 3.2 Disassembly instructions!

Prepare a new Back Cover Assy.

Follow the 5.8 Reassembly instructions!



Replacement

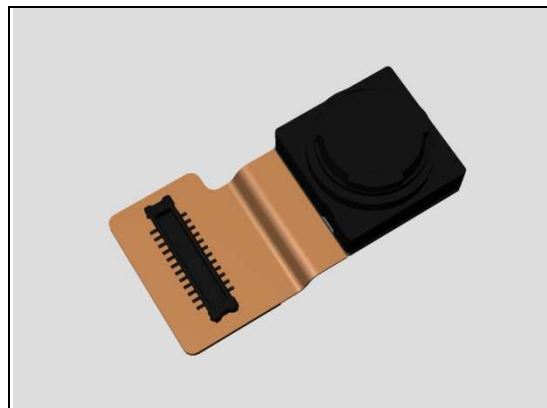
4.5 Chat Camera

Follow the 3.2 – 3.3 and 3.6 Disassembly instructions!

Prepare a new Chat Camera.

Follow the 4.32 Installation instructions!

Follow the 5.4 and 5.7 – 5.8 Reassembly instructions!



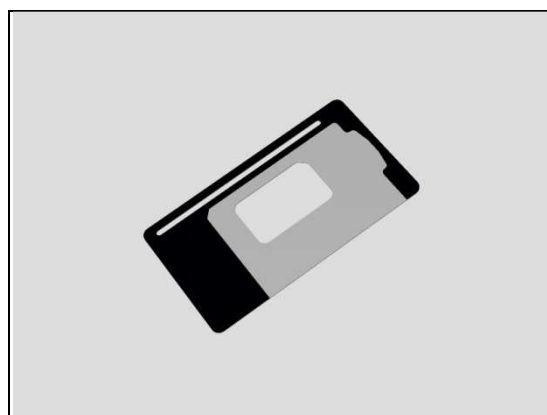
4.6 Core Unit label Tray

Follow the 3.1 – 3.8 Disassembly instructions!

Prepare a new Camera.

Follow the 4.30 Installation instructions!

Follow the 5.2 – 5.9 Reassembly instructions!



4.7 Display Frame Assy

Follow the 3.1 – 3.9 Disassembly instructions!

Follow the 4.17, 4.31, 4.40, 4.41, 4.26, 4.38, 4.45 and 4.44 Removal instructions!

Prepare a new Display Frame Assy.

Follow the 4.16, 4.17, 4.31, 4.40, 4.41, 4.33, 4.44, 4.45, 4.38, 4.35 and 4.26 Installation instructions!

Follow the 5.1 – 5.9 Reassembly instructions!

Touch Panel Calibration must be performed for all replaced units; 1289-2983 Trouble Shooting Application – mechanical.



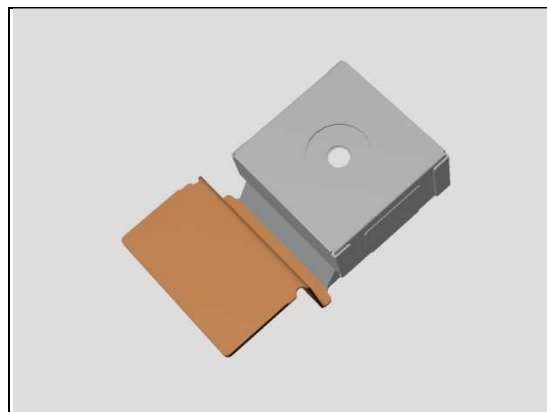
4.8 Main Camera

Follow the 3.2 – 3.3 and 3.5 Disassembly instructions!

Prepare a new Main Camera.

Follow the 4.34 Installation instructions!

Follow the 5.5 and 5.7 – 5.8 Reassembly instructions!



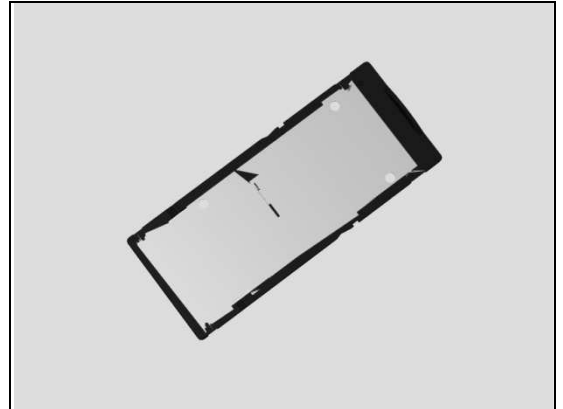
Replacement

4.9 SIM Tray

Follow the 3.1 Disassembly instructions!

Prepare a new SIM Tray.

Follow the 5.9 Reassembly instructions!



Replacement

4.10 2nd Mic Mesh

Follow the 3.2 Disassembly instructions!

Prepare a new 2nd Mic Mesh.

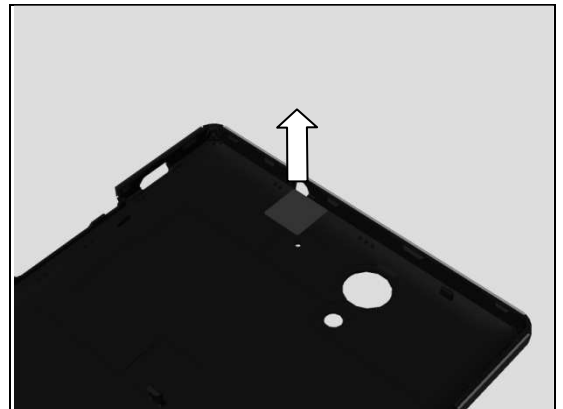
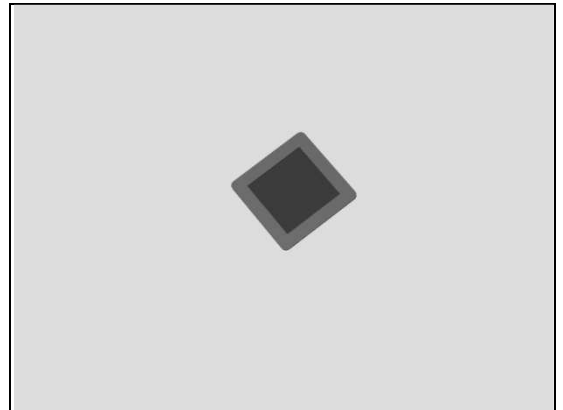
Follow the 5.8 Reassembly instructions!

REMOVAL

Detach the 2nd Mic Mesh and remove it with a pair of Plastic Tweezers.

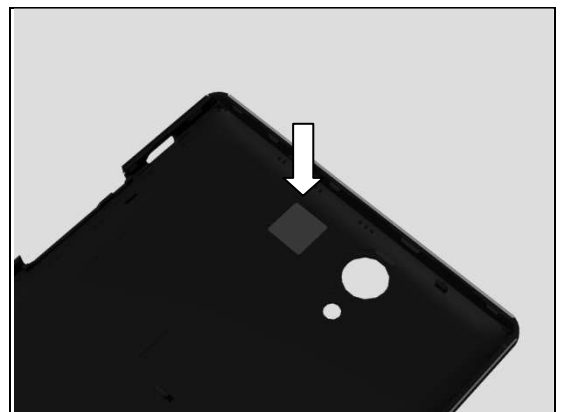
Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!



INSTALLATION

Attach a new 2nd Mic Mesh by using a pair of Plastic Tweezers as shown in picture and press it.



Replacement

4.11 Adhesive Battery

Follow the 3.1 – 3.9 Disassembly instructions!

Follow the 4.26 Removal instructions!

Prepare a new Adhesive Battery.

Follow the 4.26 Installation instructions!

Follow the 5.1 – 5.9 Reassembly instructions!

Adhesive Battery must be replaced when the Battery is disassembled.

REMOVAL

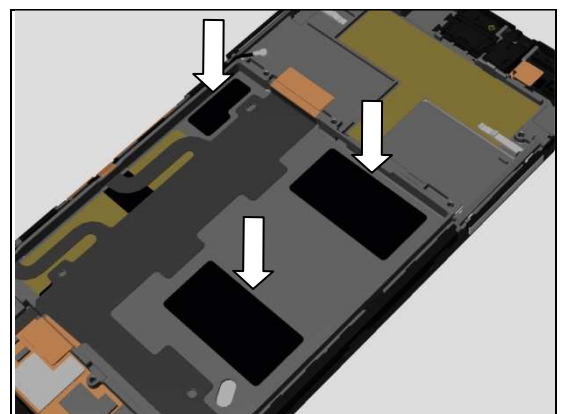
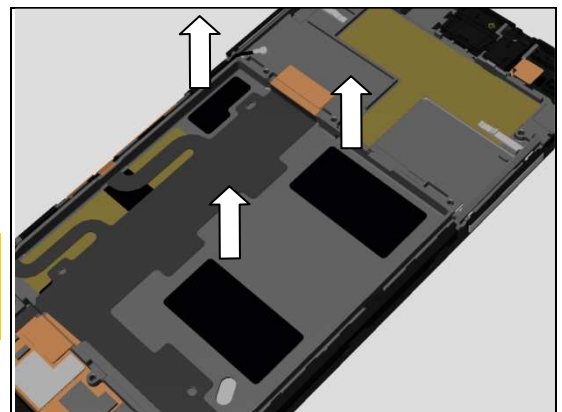
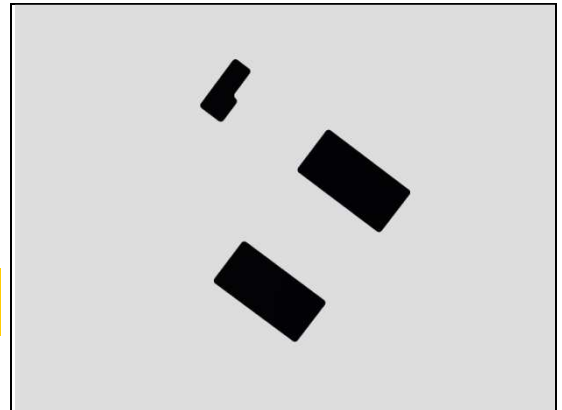
Detach the Adhesive Battery and remove it with a pair of Plastic Tweezers.

Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!

INSTALLATION

Attach a new Adhesive Battery by using a pair of Plastic Tweezers as shown in picture and press it.



Replacement

4.12 Adhesive Conductive Main FPC

Follow the 3.1 – 3.9 Disassembly instructions!

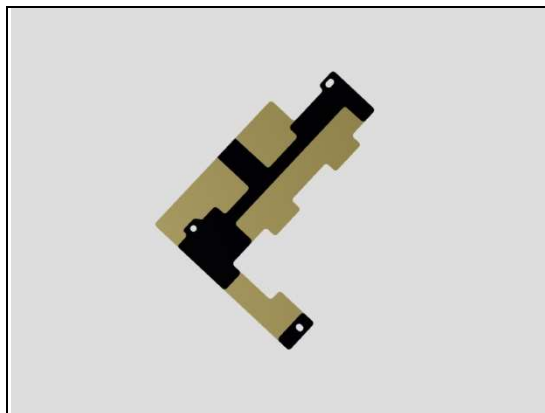
Follow the 4.26 and 4.35 Removal instructions!

Prepare a new Adhesive Conductive Main FPC.

Follow the 4.35 and 4.26 Installation instructions!

Follow the 5.1 – 5.9 Reassembly instructions!

Adhesive Conductive Main FPC must be replaced when the Main FPC Assy is disassembled.

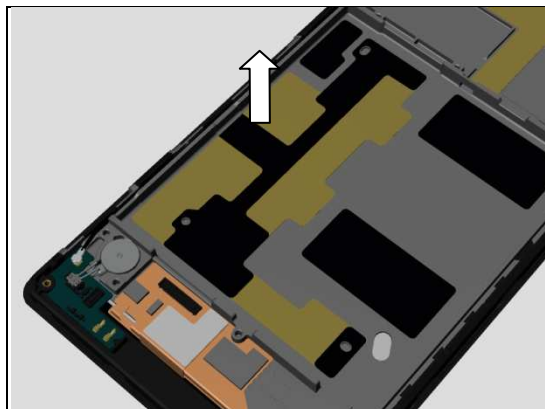


REMOVAL

Detach the Adhesive Conductive Main FPC and remove it with a pair of Plastic Tweezers.

Scrap! Not to be reused!

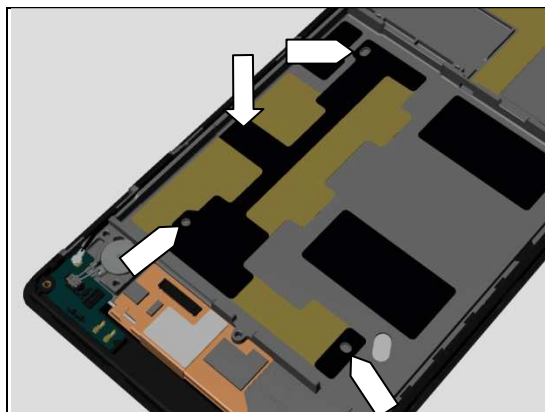
Make sure all remaining adhesive residue have been removed!



INSTALLATION

Attach a new Adhesive Conductive Main FPC by using a pair of Plastic Tweezers as shown in picture and press it.

Note the position of 3 alignment holes!



Replacement

4.13 Adhesive Conductive Sub PBA

Follow the 3.2 and 3.9 Disassembly instructions!

Follow the 4.44 Removal instructions!

Prepare a new Adhesive Conductive Sub PBA.

Follow the 4.44 Installation instructions!

Follow the 5.1 and 5.8 Reassembly instructions!

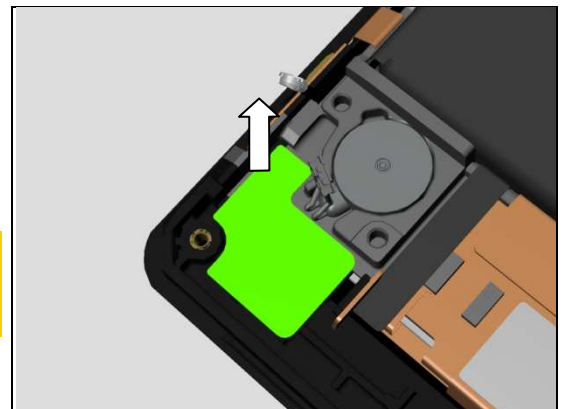
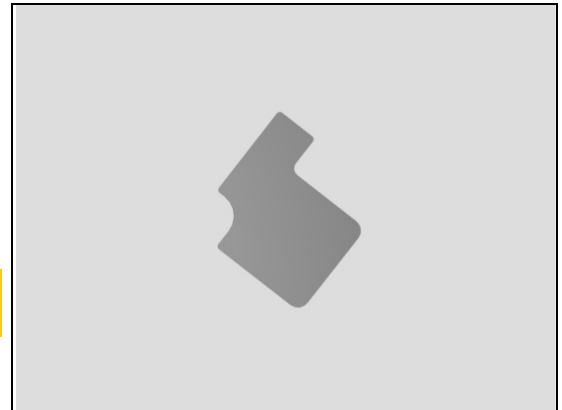
Adhesive Conductive Sub PBA must be replaced when the Sub PBA is disassembled.

REMOVAL

Detach the Adhesive Conductive Sub PBA and remove it with a pair of Plastic Tweezers.

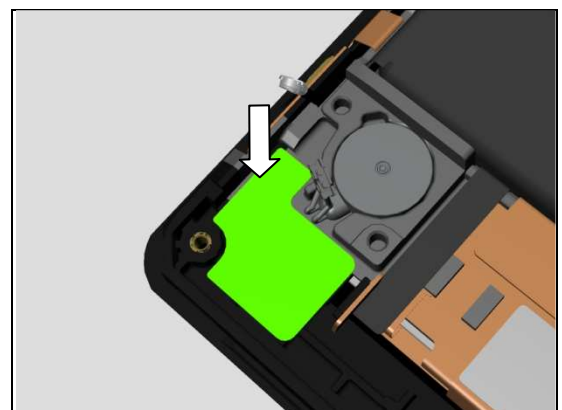
Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!



INSTALLATION

Attach a new Adhesive Conductive Sub PBA by using a pair of Plastic Tweezers as shown in picture and press it.



Replacement

4.14 Adhesive Conductive Vibrator

Follow the 3.2 and 3.9 Disassembly instructions!

Follow the 4.45 Removal instructions!

Prepare a new Adhesive Conductive Vibrator.

Follow the 4.45 Installation instructions!

Follow the 5.1 and 5.8 Reassembly instructions!

Adhesive Conductive Vibrator must be replaced when the Vibrator is disassembled.

REMOVAL

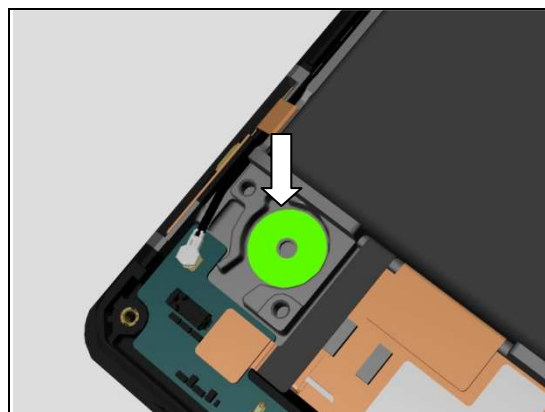
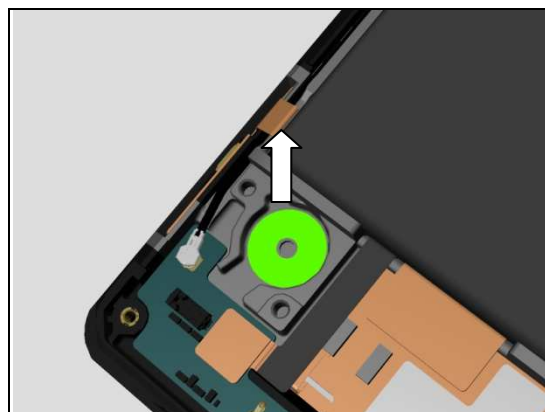
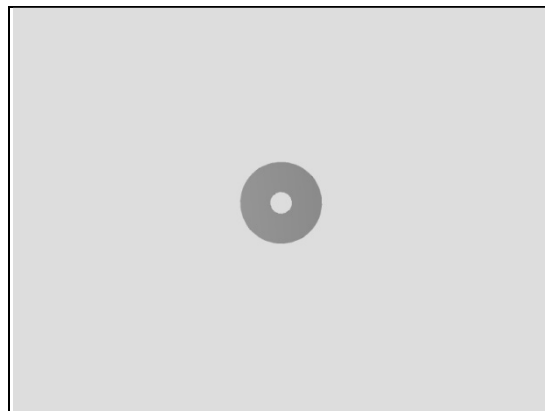
Detach the Adhesive Conductive Vibrator and remove it with a pair of Plastic Tweezers.

Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!

INSTALLATION

Attach a new Adhesive Conductive Vibrator by using a pair of Plastic Tweezers as shown in picture and press it.



Replacement:

4.15 Adhesive Earspeaker

Follow the 3.1 – 3.7 Disassembly instructions!

Follow the 4.31 Removal instructions!

Prepare a new Adhesive Earspeaker.

Follow the 4.31 Installation instructions!

Follow the 5.3 – 5.9 Reassembly instructions!

Adhesive Earspeaker must be replaced when the Earspeaker is disassembled.

REMOVAL

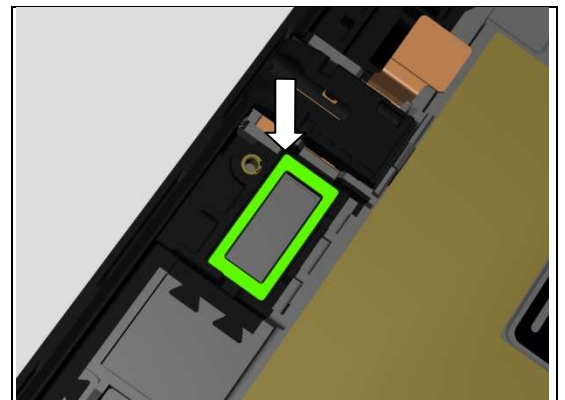
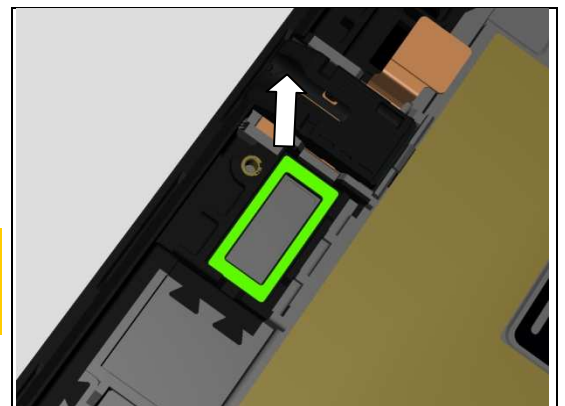
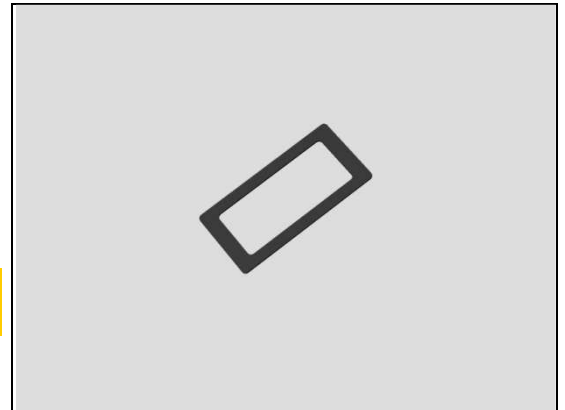
Detach the Adhesive Earspeaker and remove it with a pair of Plastic Tweezers.

Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!

INSTALLATION

Attach a new Adhesive Earspeaker by using a pair of Plastic Tweezers as shown in picture and press it.



Replacement

4.16 Audio Jack Adhesive

Follow the 3.1 – 3.7 Disassembly instructions!

Follow the 4.17 Removal instructions!

Prepare a new Audio Jack Adhesive.

Follow the 4.17 Installation instructions!

Follow the 5.3 – 5.9 Reassembly instructions!

Audio Jack Adhesive must be replaced when the Audio Jack Assy is disassembled.

REMOVAL

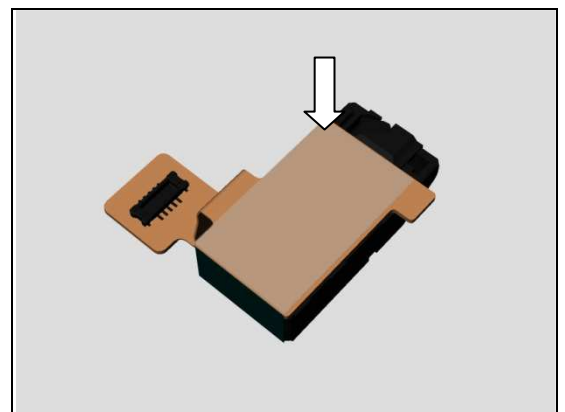
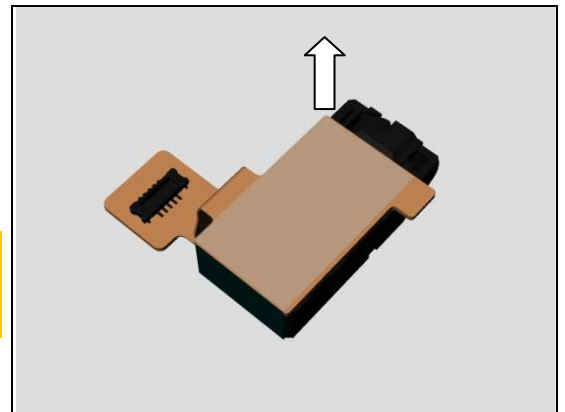
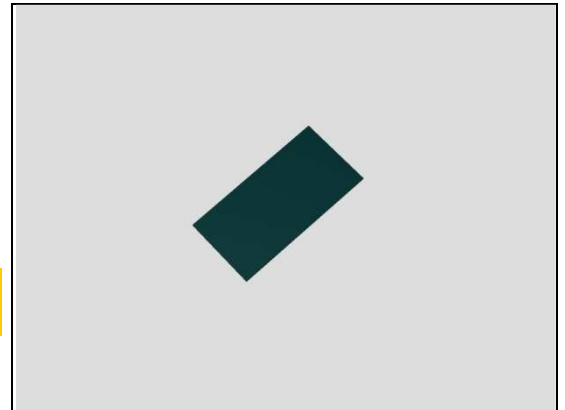
Detach the Audio Jack Adhesive and remove it with a pair of Plastic Tweezers.

Scrap! Not to be reused!

Make sure all remaining adhesive residue on the Audio Jack Assy and front frame have been removed!

INSTALLATION

Attach a new Audio Jack Adhesive by using a pair of Plastic Tweezers as shown in picture and press it.



Replacement

4.17 Audio Jack Assy

Follow the 3.1 – 3.7 Disassembly instructions!

Prepare a new Audio Jack Assy.

Follow the 5.3 – 5.9 Reassembly instructions!

REMOVAL

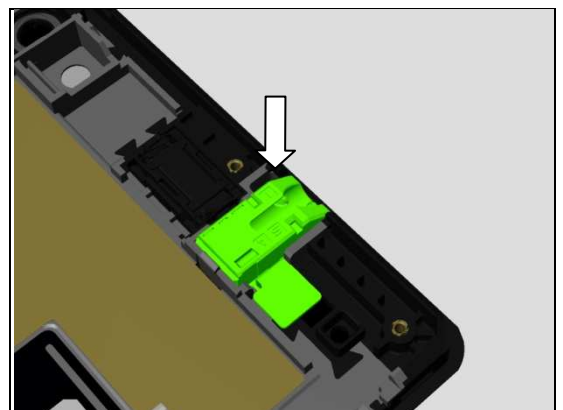
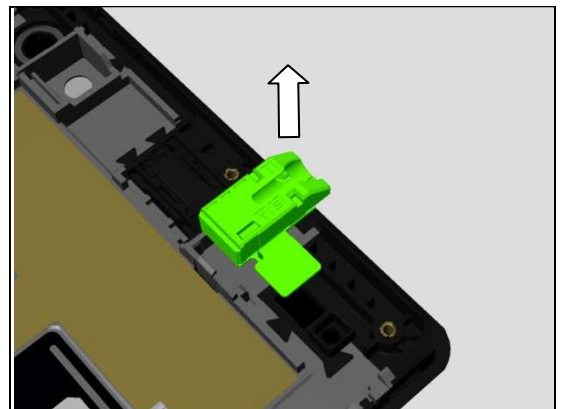
Detach the Audio Jack Assy to remove it.

Make sure all remaining adhesive residue on the front frame have been removed!

INSTALLATION

Follow the 4.18 Removal and Installation instructions to replace a new Audio Jack Film.

Mount the Audio Jack Assy in its cavity and press it.



Replacement

4.18 Audio Jack Film

Follow the 3.1 – 3.7 Disassembly instructions!

Follow the 4.17 Removal instructions!

Prepare a new Audio Jack Film.

Follow the 4.17 Installation instructions!

Follow the 5.3 – 5.9 Reassembly instructions!

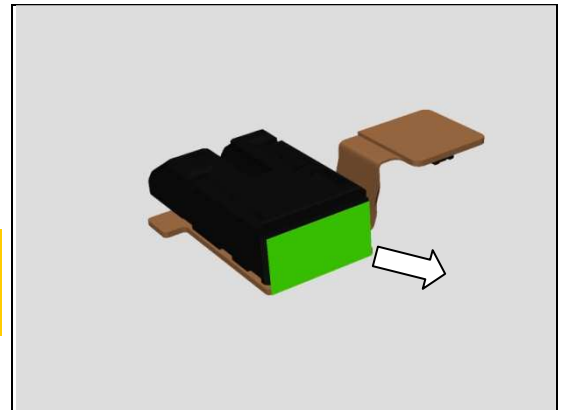
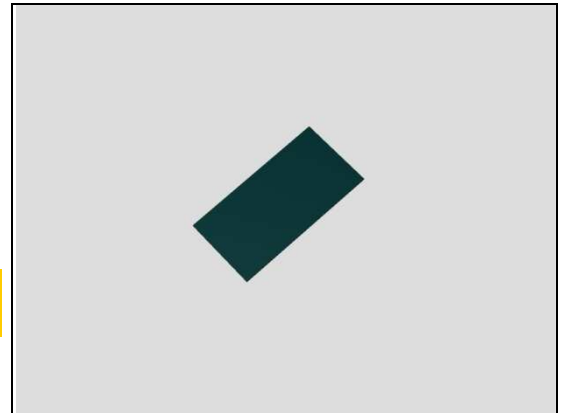
Audio Jack Film must be replaced when the Audio Jack Assy is replaced.

REMOVAL

Detach the Audio Jack Film and remove it with a pair of Plastic Tweezers.

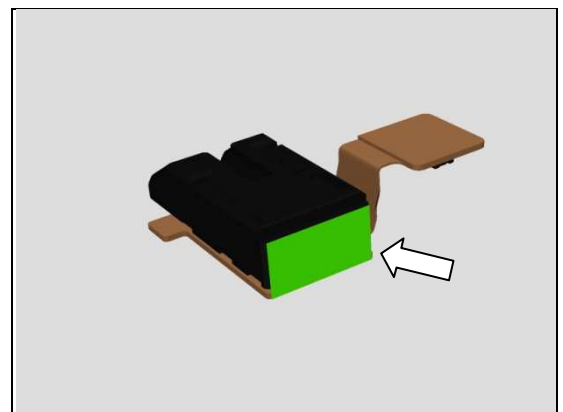
Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!



INSTALLATION

Attach a new Audio Jack Film by using a pair of Plastic Tweezers as shown in picture and press it.



Replacement

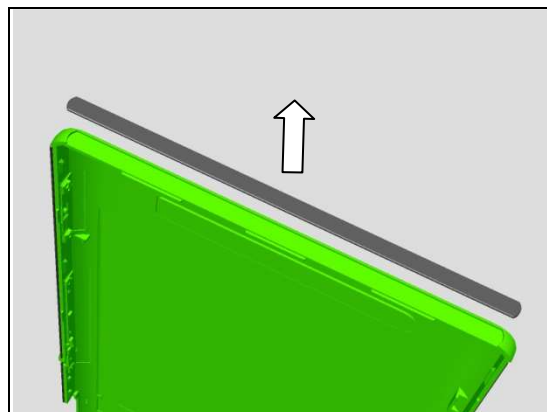
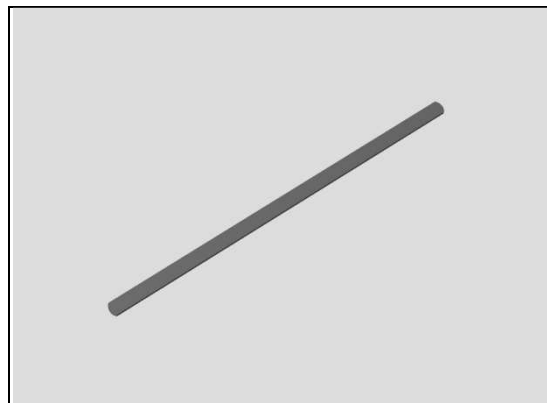
4.19 Back Cover Bottom Panel

Follow the 3.2 Disassembly instructions!
 Prepare a new Back Cover Bottom Panel.
Follow the 5.8 Reassembly instructions!

REMOVAL

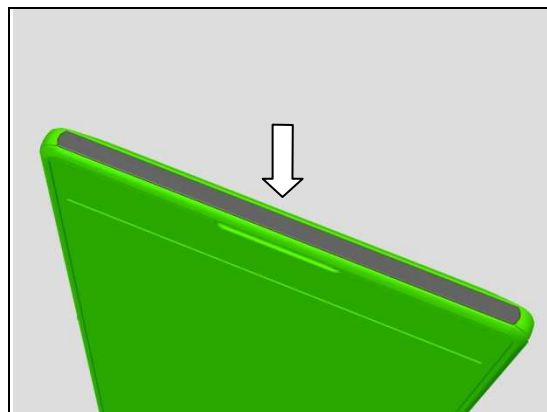
Disassemble the Back Cover Assy.
 Detach the Back Cover Bottom Panel.

Scrap! Not to be reused!
Make sure all remaining adhesive residue have been removed!

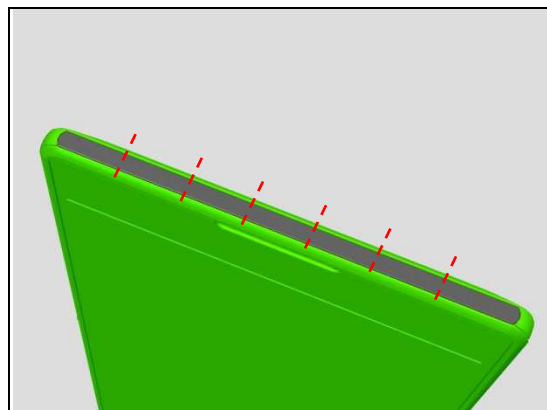


INSTALLATION

Assemble the Back Cover Assy.
 Attach the Back Cover Bottom Panel into its cavity as shown in picture.



Press it hard by finger from one side to the other side part by part, press each part for 5s.
The panel is divided into 7 parts whose length is about 1 centimeter.



Replacement

4.20 Back Cover Sidekey Side Lower Panel

Follow the 3.2 Disassembly instructions!

Prepare a new Back Cover Sidekey Side Lower Panel.

Follow the 5.8 Reassembly instructions!

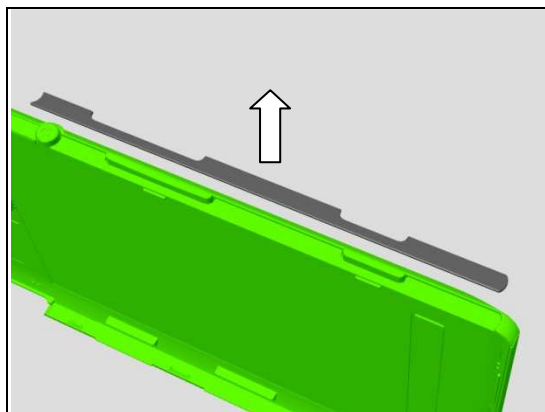
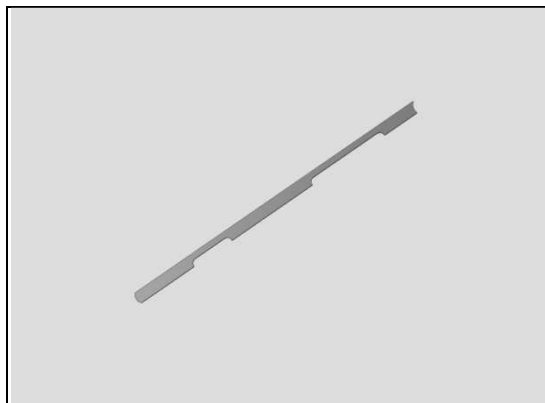
REMOVAL

Disassemble the Back Cover Assy.

Detach the Back Cover Sidekey Side Lower Panel.

Scrap! Not to be reused!

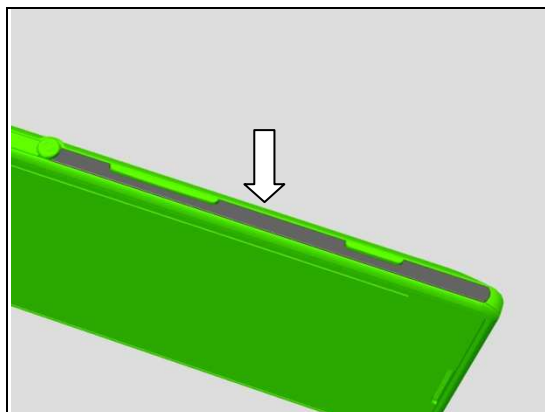
Make sure all remaining adhesive residue have been removed!



INSTALLATION

Assemble the Back Cover Assy.

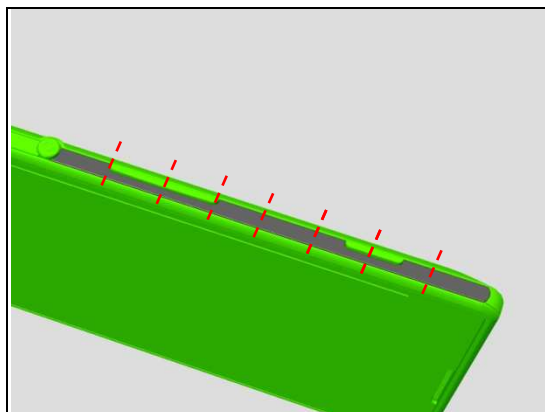
Attach the Back Cover Sidekey Side Lower Panel into its cavity as shown in picture.



Press it hard by finger from one side to the other side part by part, press each part for 5s.

The panel is divided into 8 parts whose length is about 1 centimeter.

Check the function of Power key, Side key and Camera key after pressing.



Replacement

4.21 Back Cover Sidekey Side Middle Panel

Follow the 3.2 Disassembly instructions!

Prepare a new Back Cover Sidekey Side Middle Panel.

Follow the 5.8 Reassembly instructions!

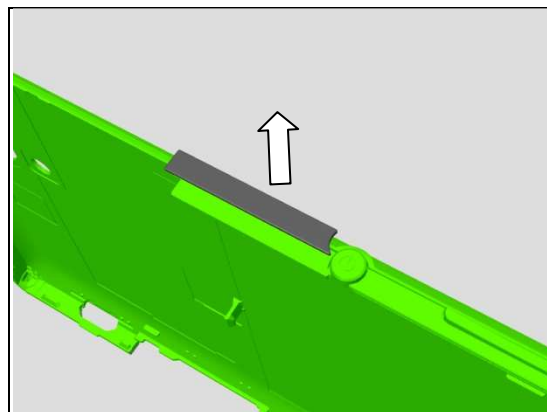
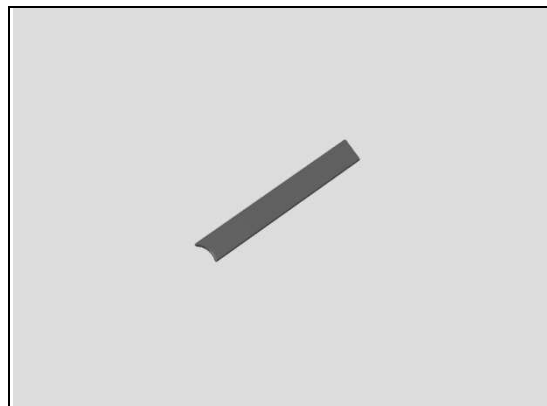
REMOVAL

Disassemble the Back Cover Assy.

Detach the Back Cover Sidekey Side Middle Panel.

Scrap! Not to be reused!

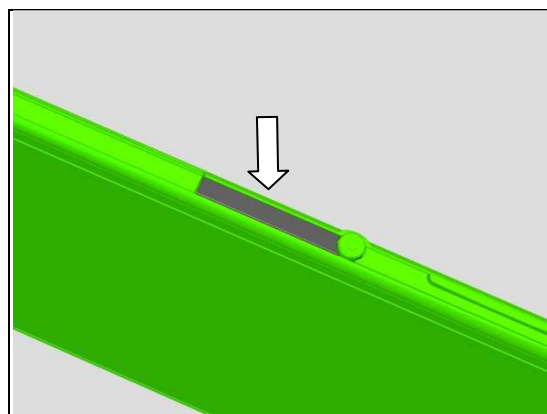
Make sure all remaining adhesive residue have been removed!



INSTALLATION

Assemble the Back Cover Assy.

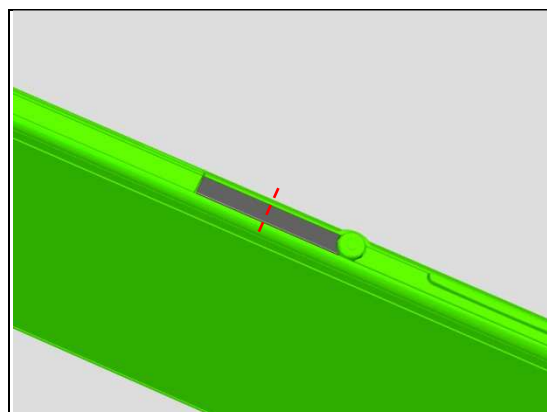
Attach the Back Cover Sidekey Side Middle Panel into its cavity as shown in picture.



Press it hard by finger from one side to the other side part by part, press each part for 5s.

The panel is divided into 2 parts whose length is about 1 centimeter.

Check the function of Power key after pressing.



Replacement

4.22 Back Cover Sidekey Side Upper Panel

Follow the 3.2 Disassembly instructions!

Prepare a new Back Cover Sidekey Side Upper Panel.

Follow the 5.8 Reassembly instructions!

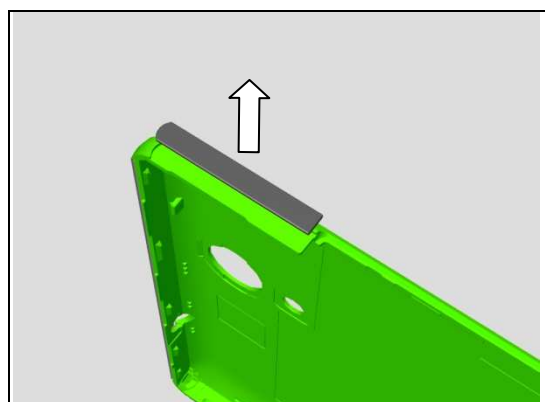
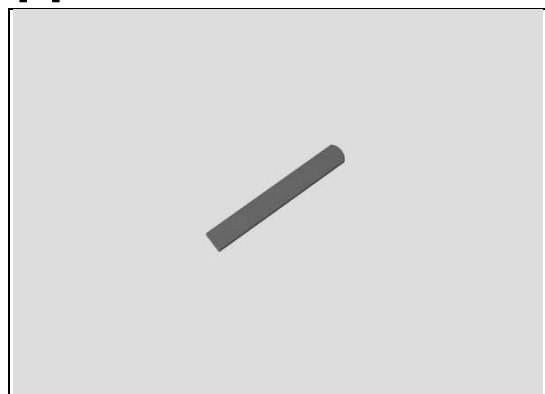
REMOVAL

Disassemble the Back Cover Assy.

Detach the Back Cover Sidekey Side Upper Panel.

Scrap! Not to be reused!

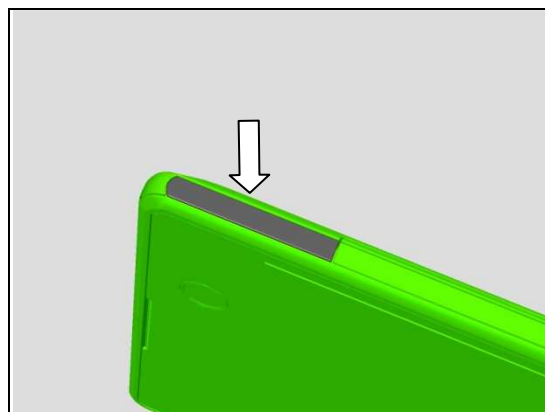
Make sure all remaining adhesive residue have been removed!



INSTALLATION

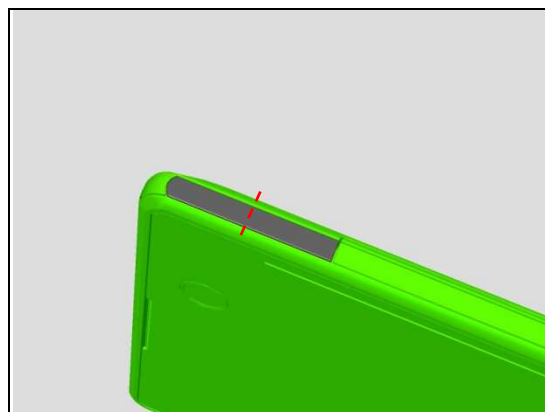
Assemble the Back Cover Assy.

Attach the Back Cover Sidekey Side Upper Panel into its cavity as shown in picture.



Press it hard by finger from one side to the other side part by part, press each part for 5s.

The panel is divided into 2 parts whose length is about 1 centimeter.



Replacement

4.23 Back Cover Top Panel

Follow the 3.2 Disassembly instructions!

Prepare a new Back Cover Top Panel.

Follow the 5.8 Reassembly instructions!

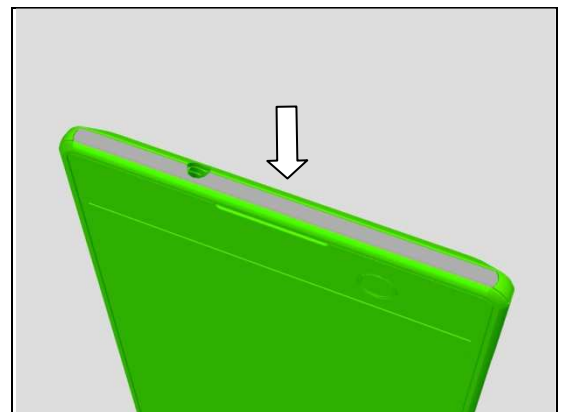
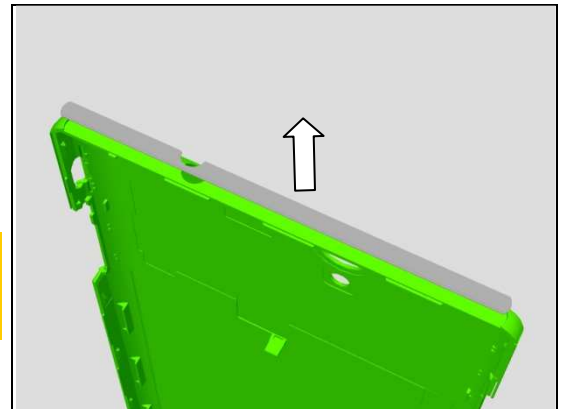
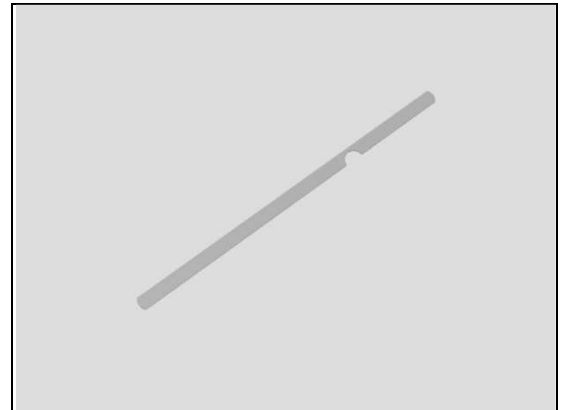
REMOVAL

Disassemble the Back Cover Assy.

Detach the Back Cover Top Panel.

Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!



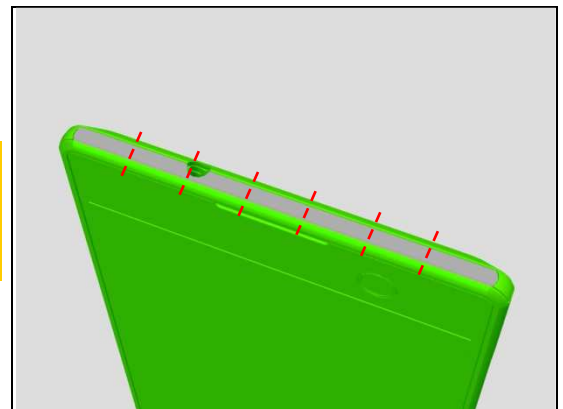
INSTALLATION

Assemble the Back Cover Assy.

Attach the Back Cover Top Panel into its cavity as shown in picture.

Press it hard by finger from one side to the other side part by part, press each part for 5s.

The panel is divided into 7 parts whose length is about 1 centimeter.



Replacement

4.24 Back Cover USB Side Lower Panel

Follow the 3.2 Disassembly instructions!

Prepare a new Back Cover USB Side Lower Panel.

Follow the 5.8 Reassembly instructions!

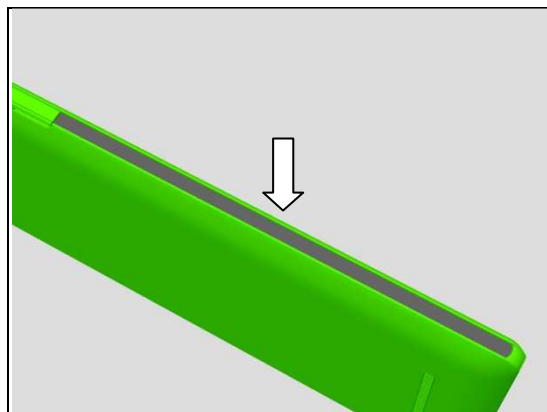
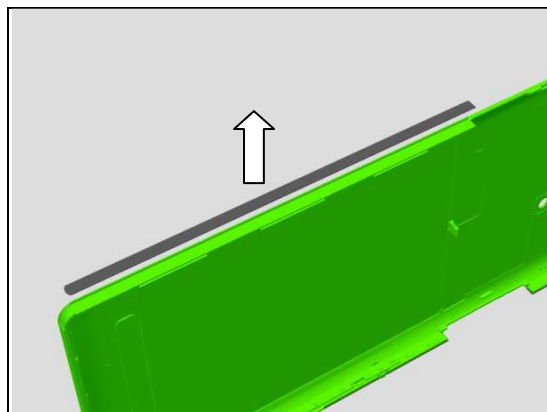
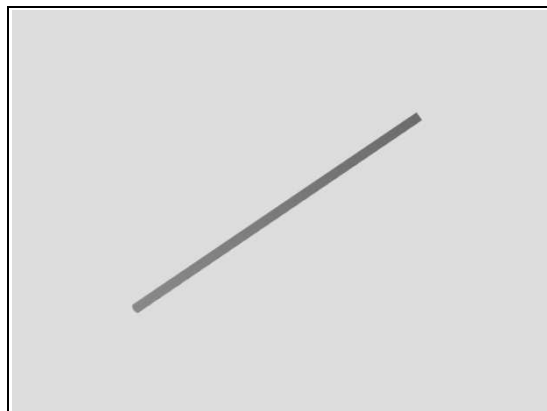
REMOVAL

Disassemble the Back Cover Assy.

Detach the Back Cover USB Side Lower Panel.

Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!



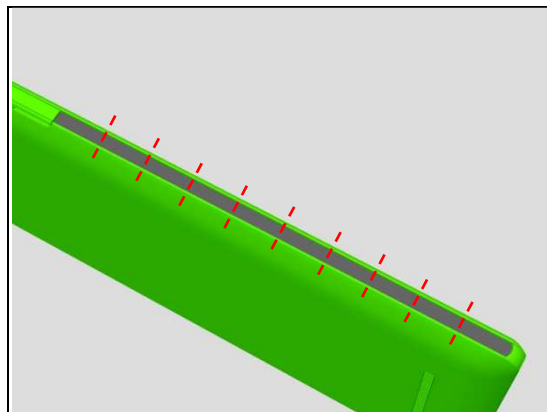
INSTALLATION

Assemble the Back Cover Assy.

Attach the Back Cover USB Side Lower Panel into its cavity as shown in picture.

Press it hard by finger from one side to the other side part by part, press each part for 5s.

The panel is divided into 10 parts whose length is about 1 centimeter.



Replacement

4.25 Back Cover USB Side Upper Panel

Follow the 3.2 Disassembly instructions!

Prepare a new Back Cover USB Side Upper Panel.

Follow the 5.8 Reassembly instructions!

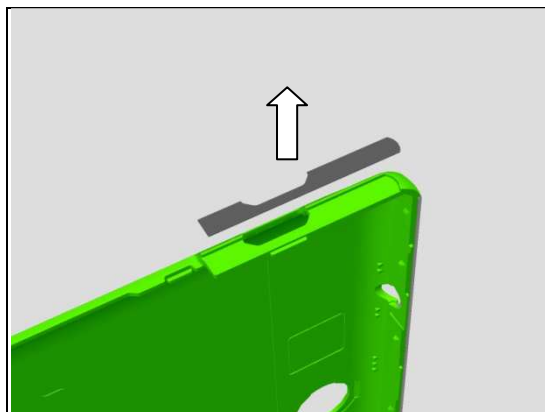
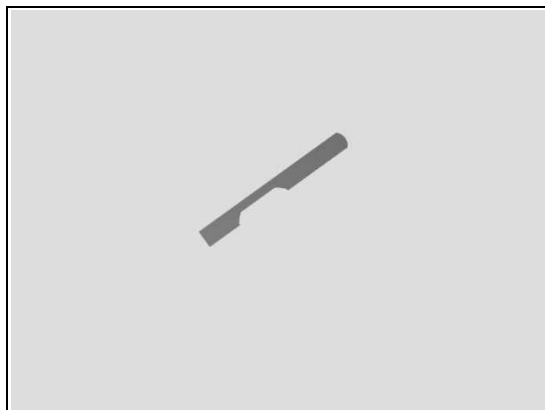
REMOVAL

Disassemble the Back Cover Assy.

Detach the Back Cover USB Side Upper Panel.

Scrap! Not to be reused!

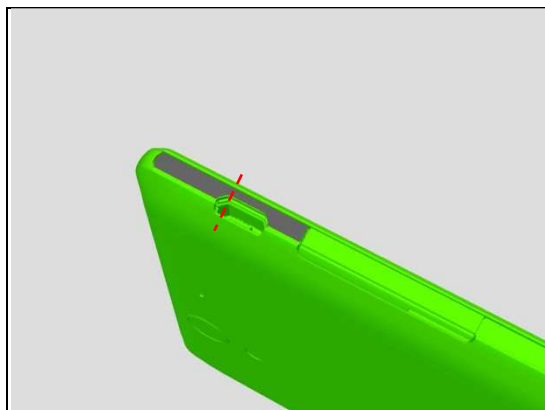
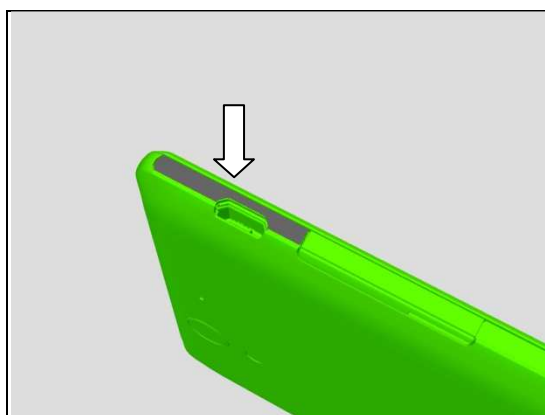
Make sure all remaining adhesive residue have been removed!



INSTALLATION

Assemble the Back Cover Assy.

Attach the Back Cover USB Side Upper Panel into its cavity as shown in picture.



Press it hard by finger from one side to the other side part by part, press each part for 5s.

The panel is divided into 2 parts whose length is about 1 centimeter.

Replacement

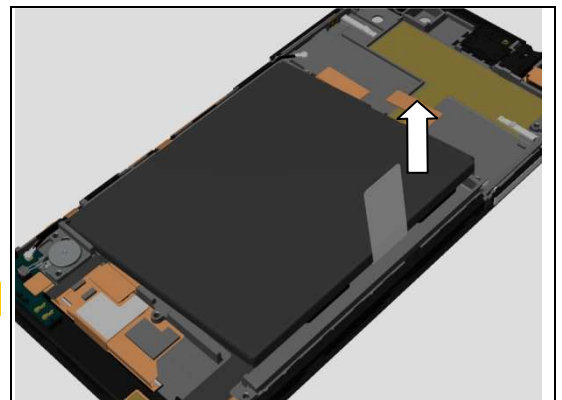
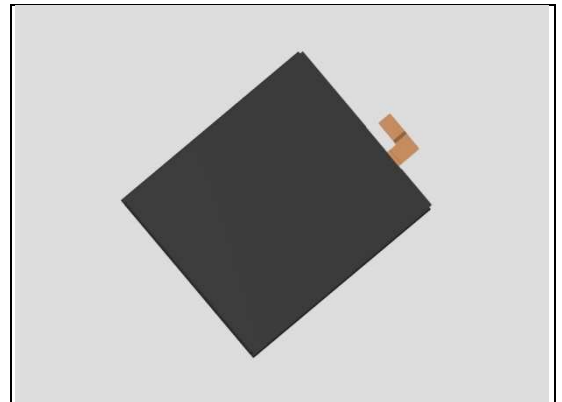
4.26 Battery

Follow the 3.1 – 3.9 Disassembly instructions!
Follow the 4.11 and 4.27 Removal instructions!
 Prepare a new Battery.
Follow the 4.11 and 4.27 Installation instructions!
Follow the 5.1 – 5.9 Reassembly instructions!

REMOVAL

Turn the Battery Release Tape vertically.
 Pull the tape to release the Battery from its adhesive underneath.

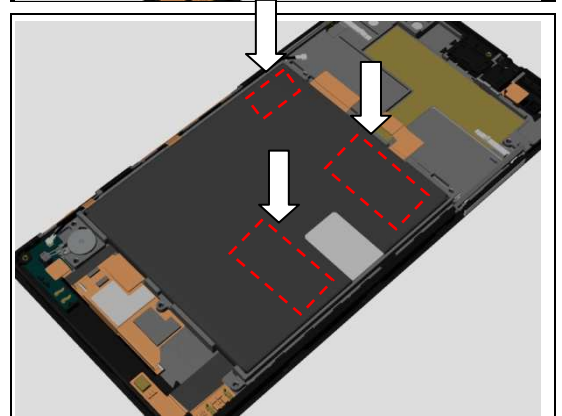
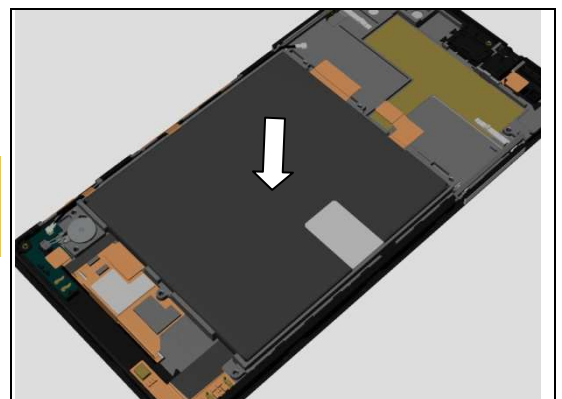
Scrap! Not to be reused!



INSTALLATION

Follow the 4.11 and 4.27 Removal and Installation instructions to replace a new Adhesive Battery and a new Battery Release Tape.

Mount the Battery into its cavity.



Press the Battery hard by fingers onto the adhesive area for 5s separately.

Replacement

4.27 Battery Release Tape

Follow the 3.1 – 3.9 Disassembly instructions!

Follow the 4.26 Removal instructions!

Prepare a new Battery Release Tape.

Follow the 4.26 Installation instructions!

Follow the 5.1 – 5.9 Reassembly instructions!

Battery Release Tape must be replaced when the Battery is disassembled.

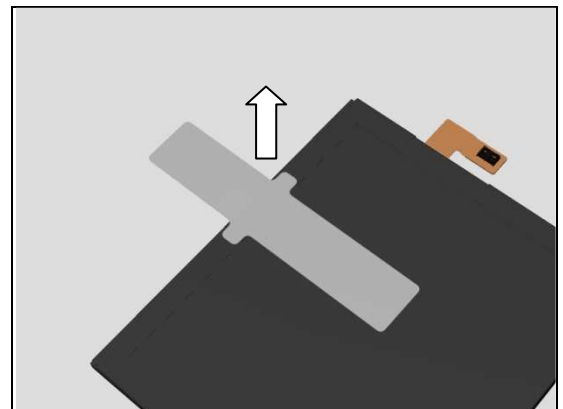
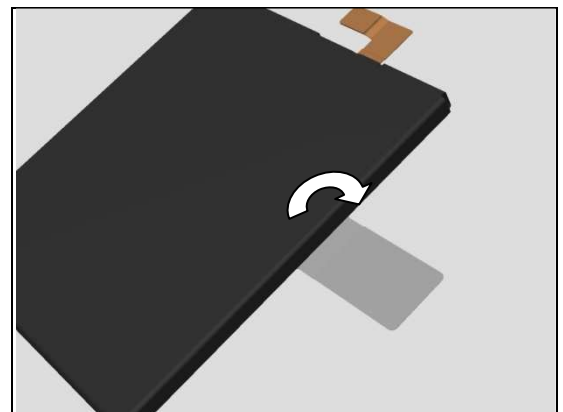
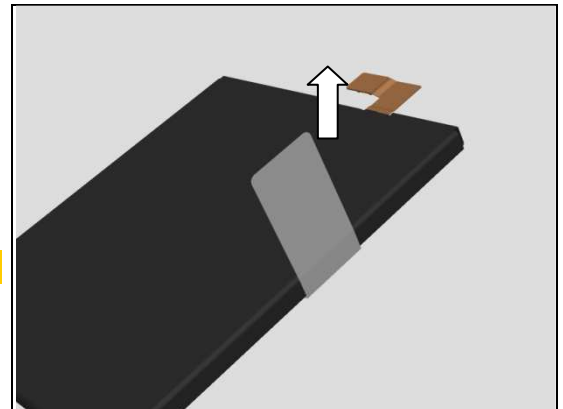
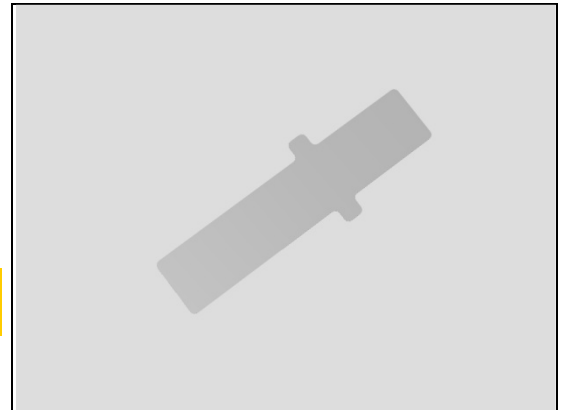
REMOVAL

Detach the Battery Release Tape as shown in picture.

Scrap! Not to be reused!

Do the same.

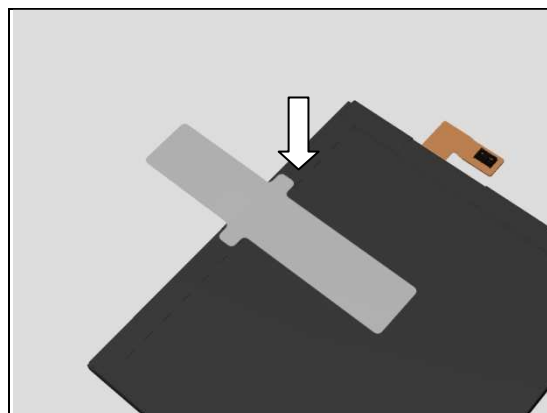
Do the same.



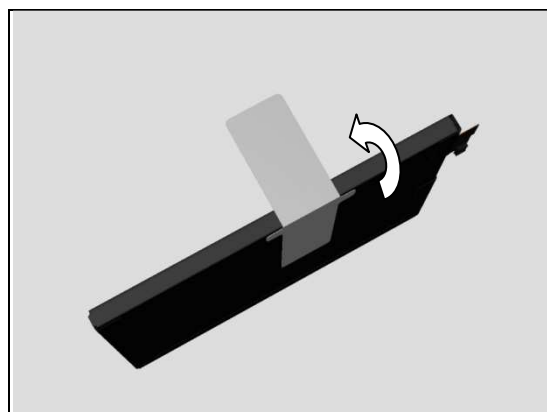
Replacement: Battery Release Tape

INSTALLATION

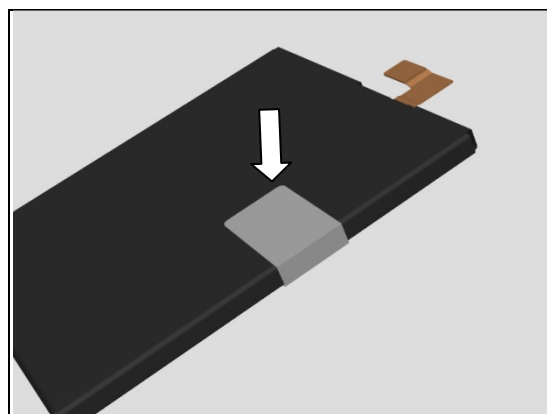
Attach the Battery Release Tape in its proper position as shown in picture.



Attach the rest part of the Battery Release Tape.



Do the same.



Replacement

4.28 Camera Key Assy

Follow the 3.2 Disassembly instructions!

Prepare a new Camera Key Assy.

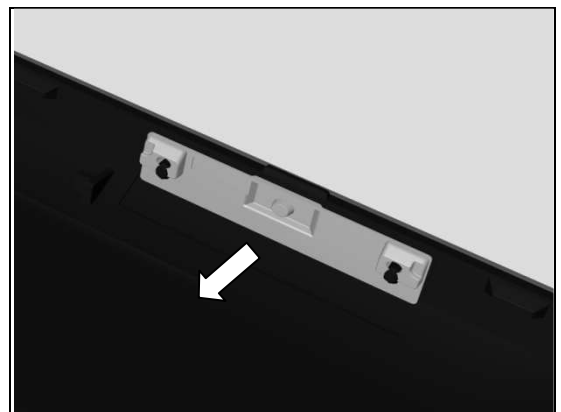
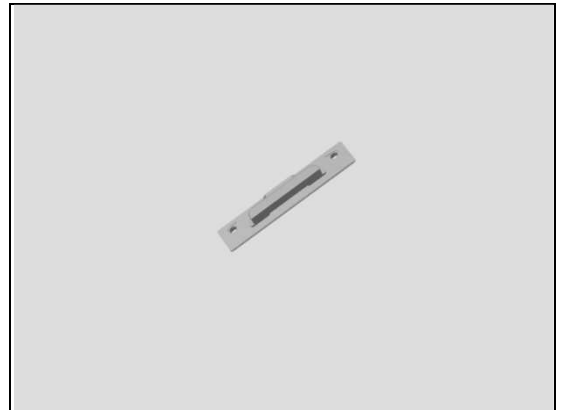
Follow the 5.8 Reassembly instructions!

REMOVAL

Detach the Camera Key Assy.

Scrap! Not to be reused!

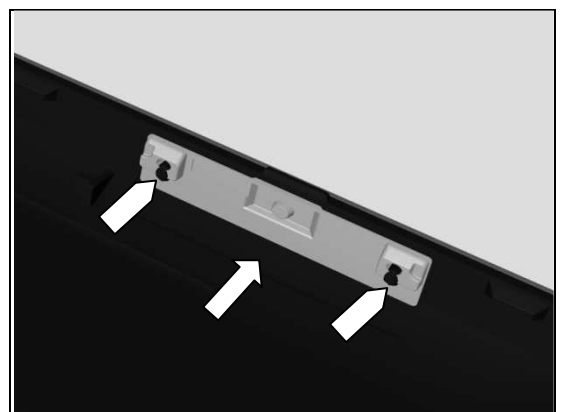
Make sure all remaining adhesive residue have been removed!



INSTALLATION

Attach the Camera Key Assy and press it.

Note the position of alignment pins and holes!



Replacement

4.29 Camera Window

Follow the 3.2 – 3.3 Disassembly instructions!

Prepare a new Camera Window.

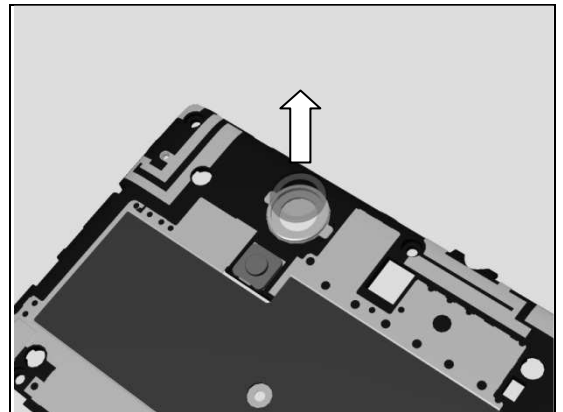
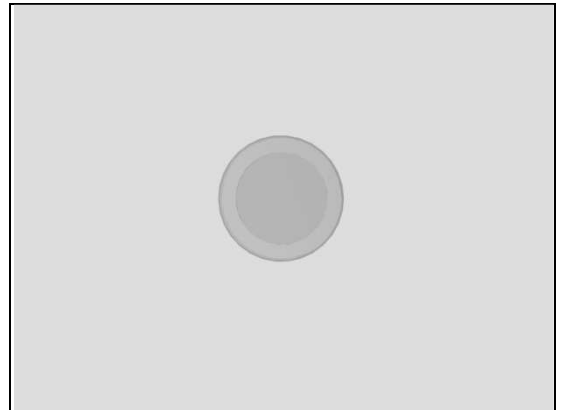
Follow the 5.7 – 5.8 Reassembly instructions!

REMOVAL

Detach the Camera Window.

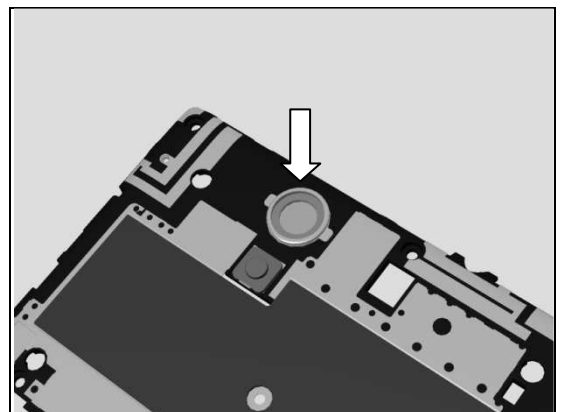
Scrap! Not to be reused!

Make sure all remaining adhesive residue have been removed!



INSTALLATION

Attach the Camera Window and press it.



Replacement

4.30 Core Unit label

Follow the 3.1 – 3.8 Disassembly instructions!

Prepare a new Core Unit label.

Follow the 5.2 – 5.9 Reassembly instructions!

REMOVAL

Read the old Core Unit Label and/or write the information into the 'Label Print Solution' program before removal. Carefully remove the Core Unit Label by using the Flex Film Assembly Tool.

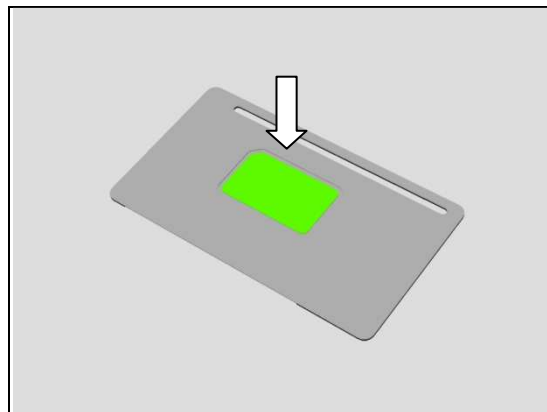
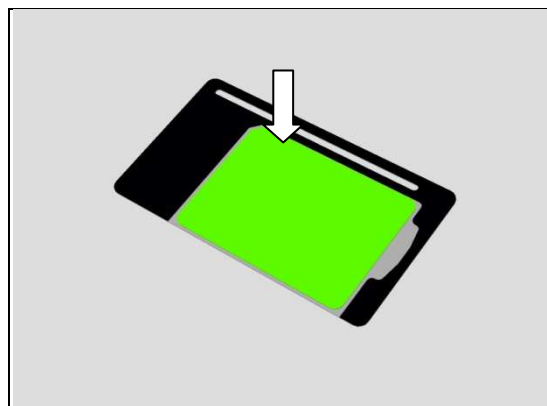
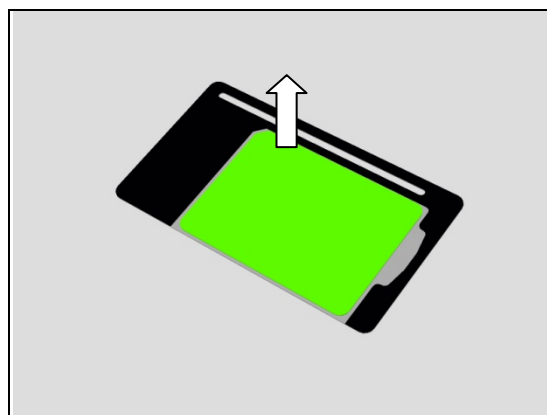
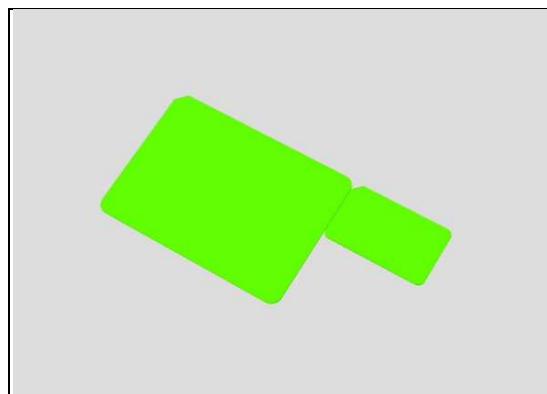
Scrap! Not to be reused!

INSTALLATION

Check that the label format is properly loaded in the Zebra printer and write a new Label using the 'Label Print Solution' software.

Attach a new Core Unit Label in its proper position as shown in picture.

Attach a new Core Unit Label in its proper position as shown in picture.



Replacement

4.31 Earspeaker

Follow the 3.1 – 3.7 Disassembly instructions!

Prepare a new Earspeaker

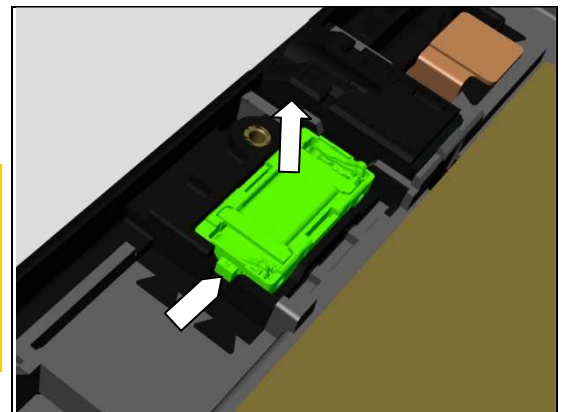
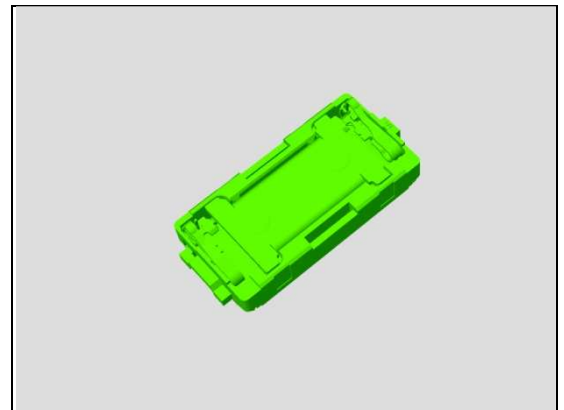
Follow the 5.3 – 5.9 Reassembly instructions!

REMOVAL

Detach the Earspeaker.

Note position of applying a pair of Pointed-tip tweezers as shown in picture!

Be careful! Insert a pair of Pointed-tip tweezers between the Earspeaker and front frame to detach the Earspeaker, otherwise the Earspeaker is easy to be damaged.

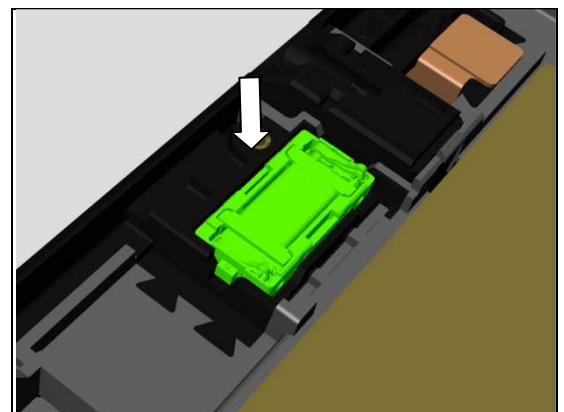
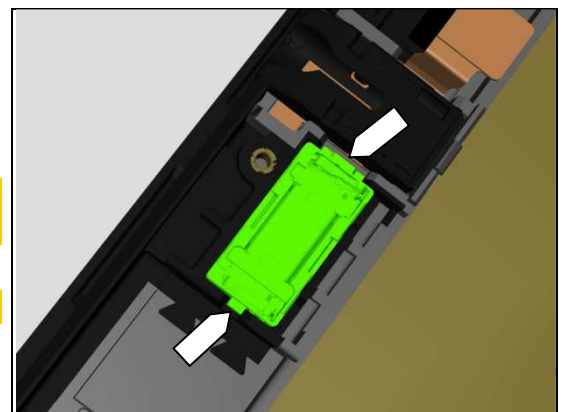


INSTALLATION

Follow the 4.15 Removal and Installation instructions to replace a new Adhesive Earspeaker.

Mount the Earspeaker into its cavity.

Note the direction of the Earspeaker!



Press to secure its solid attachment.

Replacement

4.32 Gasket Chat Camera

Follow the 3.2 – 3.3 and 3.6 Disassembly instructions!

Prepare a new Gasket Chat Camera.

Follow the 5.4 and 5.7 – 5.8 Reassembly instructions!

Gasket Chat Camera must be replaced when the Chat Camera is replaced.

REMOVAL

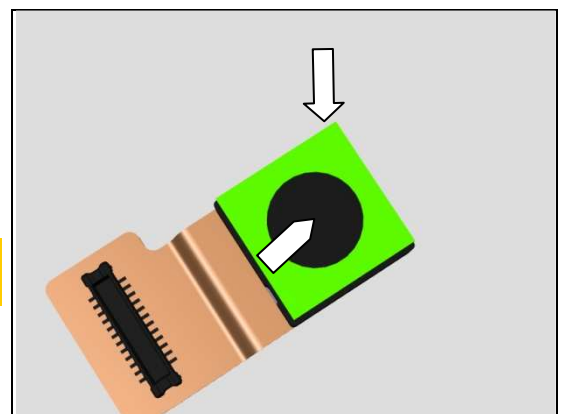
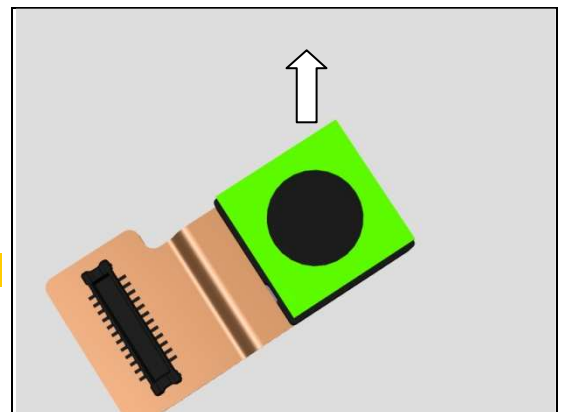
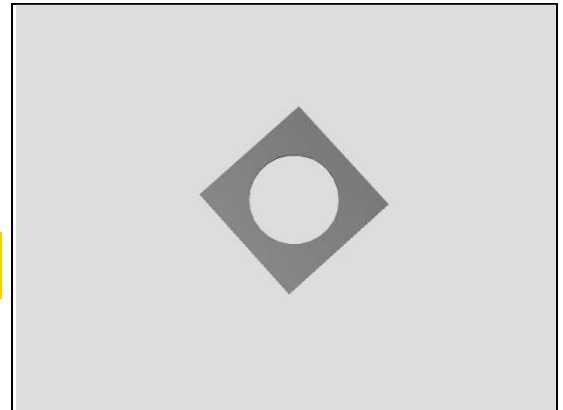
Detach the Gasket Chat Camera.

Scrap! Not to be reused!

INSTALLATION

Attach the Gasket Chat Camera.

Note position of the Gasket Chat Camera! Make sure the camera lens is in the center of the circle.



Replacement

4.33 Liquid Indicator

Follow the 3.1 – 3.8 Disassembly instructions!

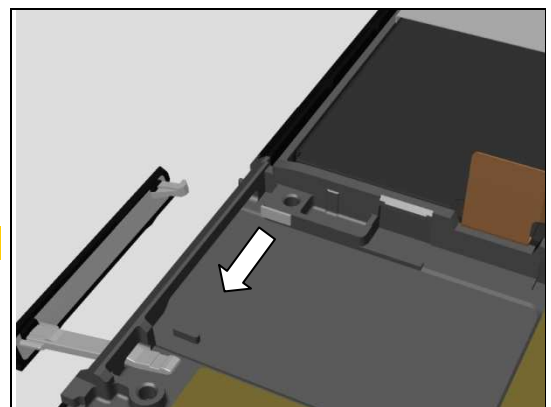
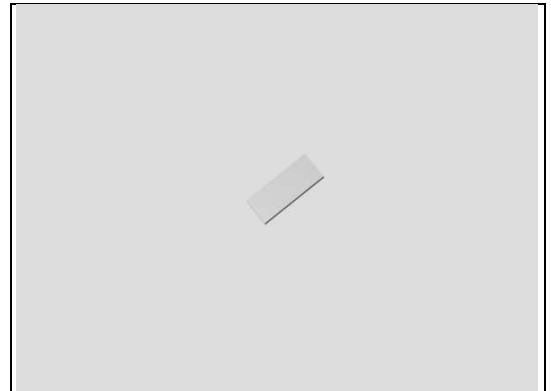
Prepare a new Liquid Indicator.

Follow the 5.2 – 5.9 Reassembly instructions!

REMOVAL

Detach to remove the Liquid Indicator by using a Flex Film Assembly Tool.

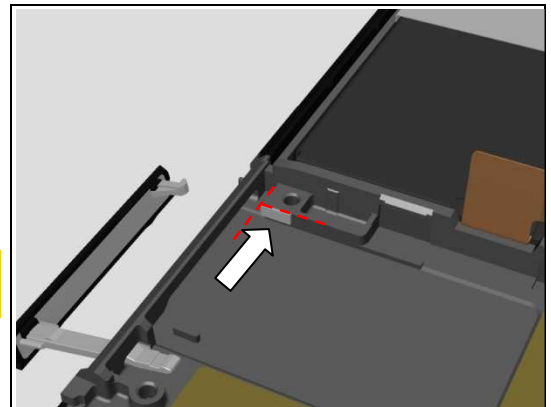
Scrap! Not to be reused!



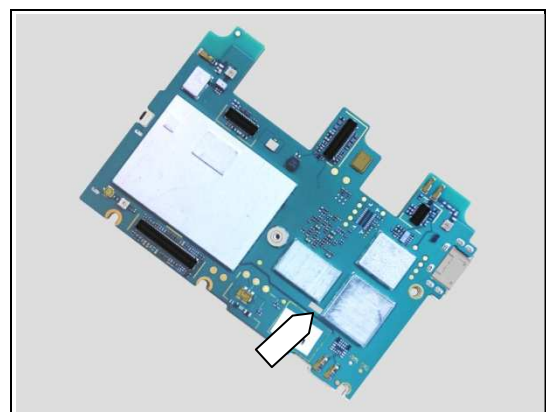
INSTALLATION

Attach a new Liquid Indicator in its proper position by using a Flex Film Assembly Tool as shown in picture.

Note position of the Liquid Indicator! Make sure the Liquid Indicator is aligned to the top left corner of the rib.



Do the same to this Liquid Indicator.



Replacement

4.34 Main Camera Film

Follow the 3.2 – 3.3 and 3.5 Disassembly instructions!

Prepare a new Main Camera Film.

Follow the 5.5 and 5.7 – 5.8 Reassembly instructions!

Main Camera Film must be replaced when the Main Camera is replaced.

REMOVAL

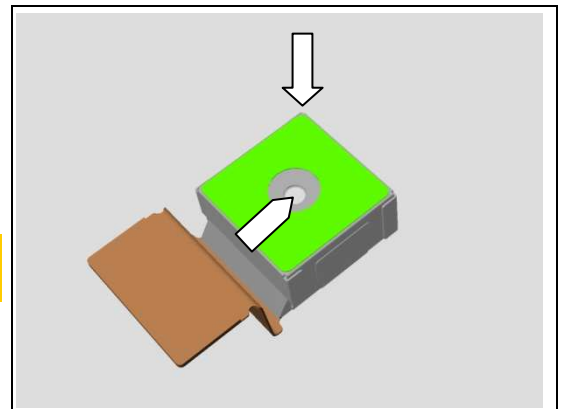
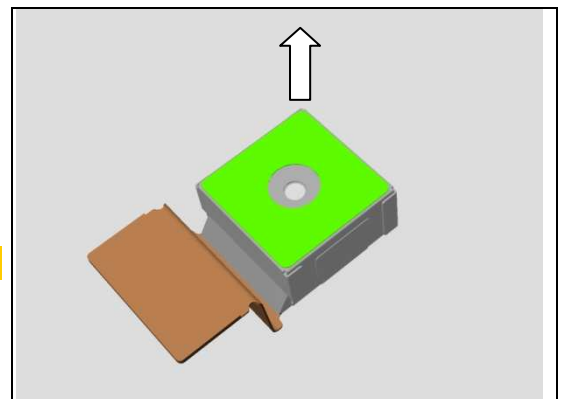
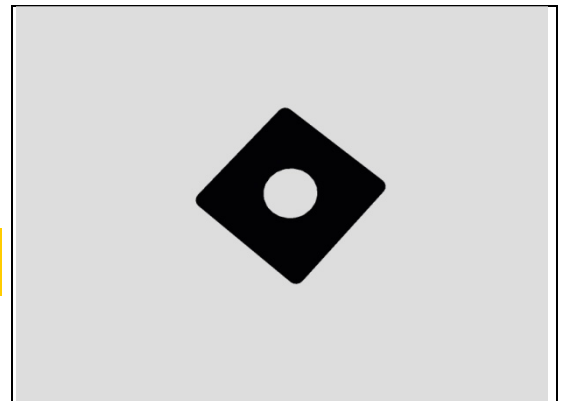
Detach the Main Camera Film.

Scrap! Not to be reused!

INSTALLATION

Attach the Main Camera Film.

Note position of the Main Camera Film! Make sure the camera lens is in the center of the circle.



Replacement

4.35 Main FPC Assy

Follow the 3.1 – 3.9 Disassembly instructions!

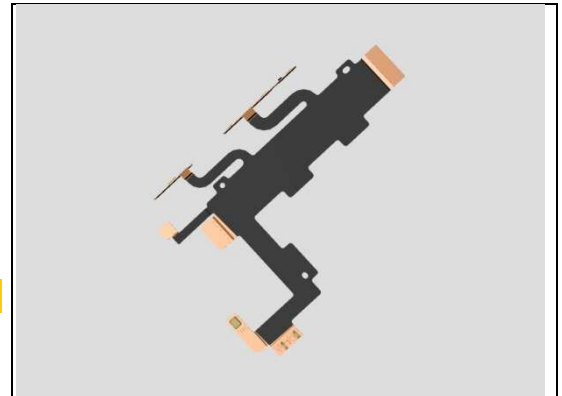
Follow the 4.26 Removal instructions!

Prepare a new Main FPC Assy.

Follow the 4.26 Installation instructions!

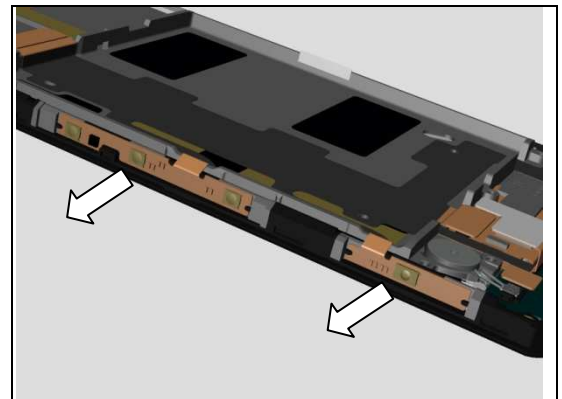
Follow the 5.1 – 5.9 Reassembly instructions!

Scrap! Not to be reused!

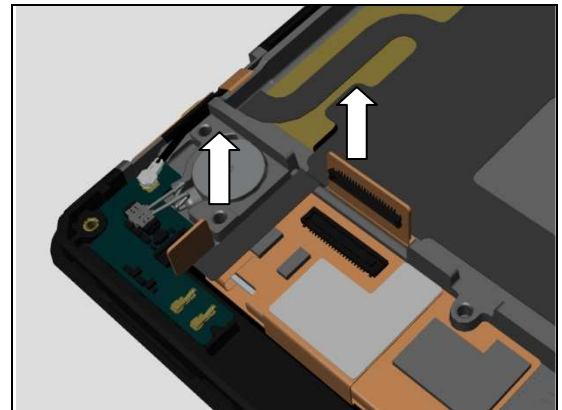


REMOVAL

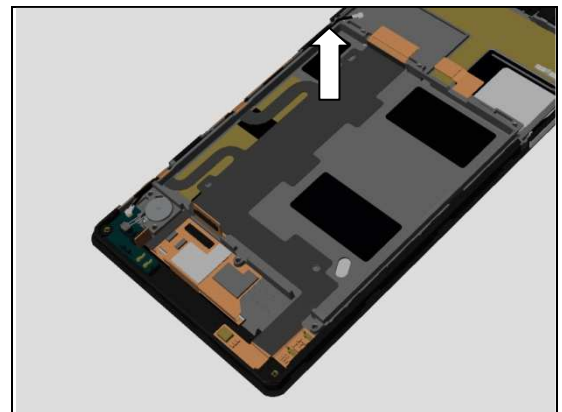
Detach the power/side key FPC and camera key FPC.



Disconnect these 2 BtB connectors.



Detach the Main FPC Assy.



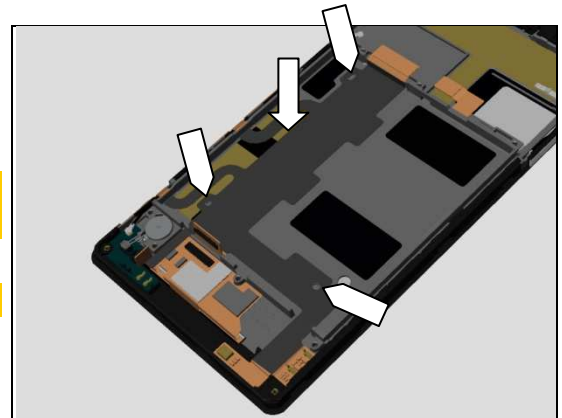
Replacement: Main FPC Assy

INSTALLATION

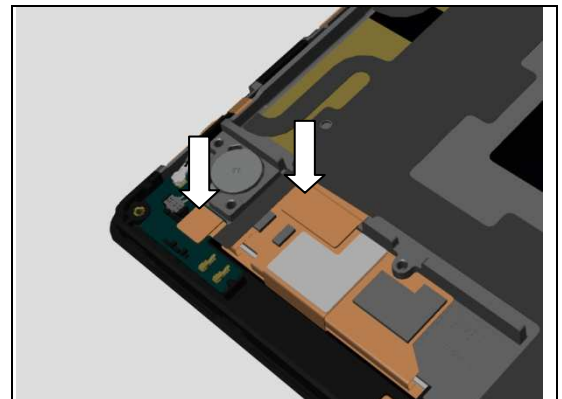
Follow the 4.12 Removal and Installation instructions to replace a new Adhesive Conductive Main FPC.

Attach the Main FPC and press to secure the attachment.

Note position of alignment holes!

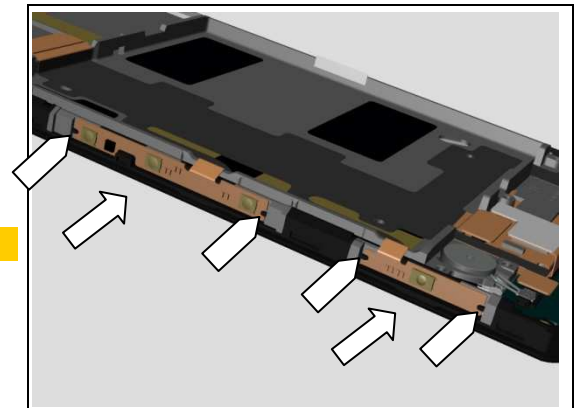


Press to snap these 2 BtB connectors.



Attach the power/side key FPC and camera key FPC and press it.

Note position of alignment pins!



Replacement

4.36 Power/Side Key Assy

Follow the 3.2 Disassembly instructions!

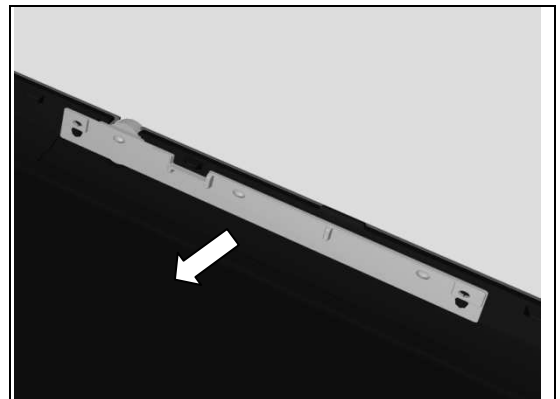
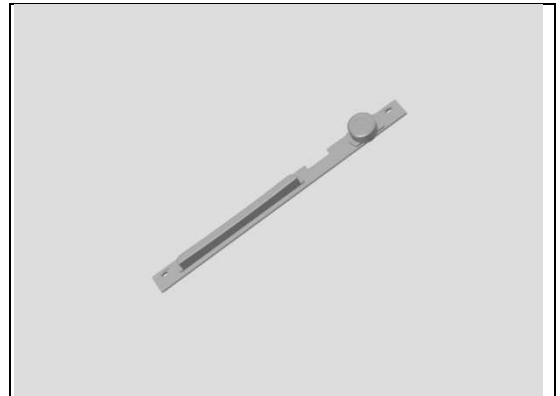
Prepare a new Power/Side Key Assy.

Follow the 5.8 Reassembly instructions!

REMOVAL

Detach the Power/Side Key Assy,

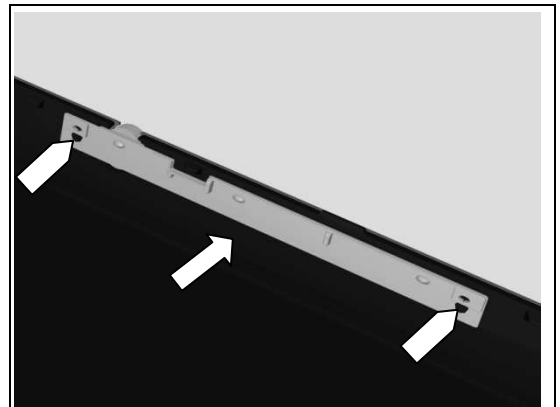
Scrap! Not to be reused!



INSTALLATION

Attach the Power/Side Key Assy and press it.

Note position of alignment pins and holes!



Replacement

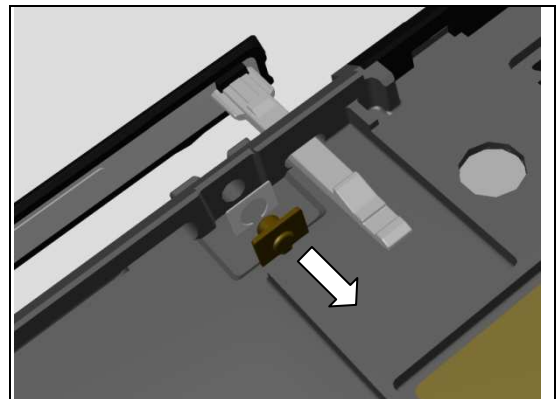
4.37 Reset Key and Tape Reset Key

Follow the 3.1 – 3.7 Disassembly instructions!
 Prepare a new Reset Key and Tape Reset Key.
Follow the 5.3 – 5.9 Reassembly instructions!

REMOVAL

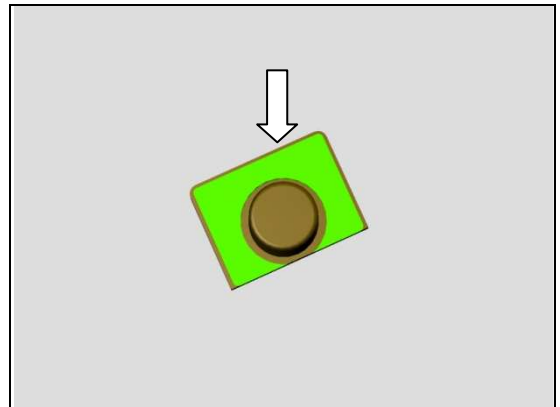
Detach Reset Key and Tape Reset Key.

Scrap! Not to be reused!



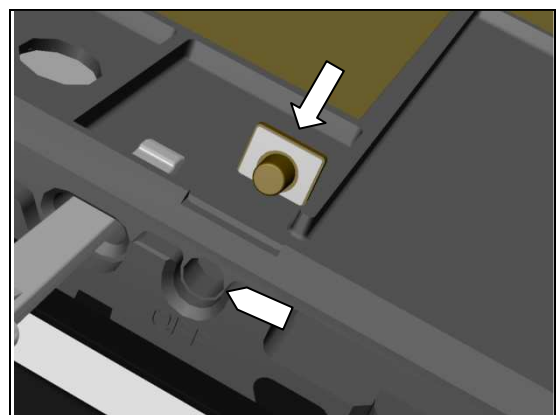
INSTALLATION

Attach the Tape Reset Key onto the Reset Key.



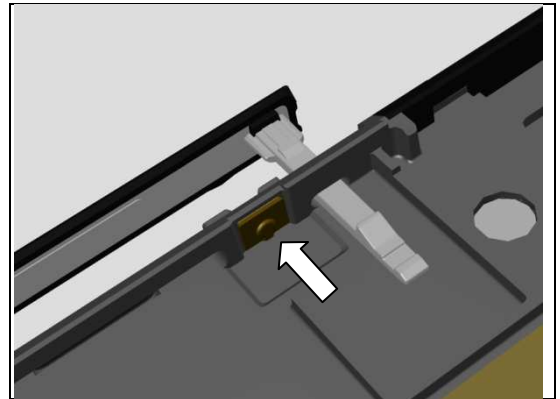
Mount the Reset Key into its hole.

Note direction the Reset Key!



Replacement: Reset Key and Tape Reset Key

Press to secure it attachment.



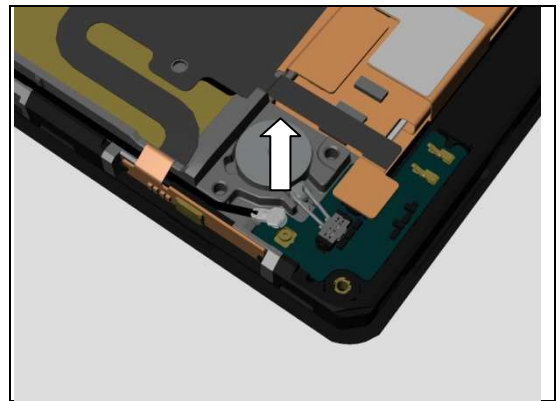
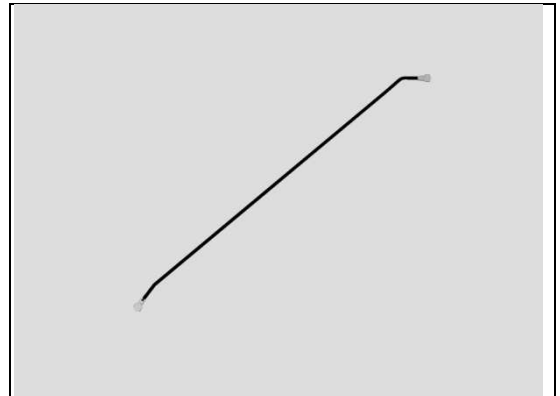
Replacement

4.38 RF cable

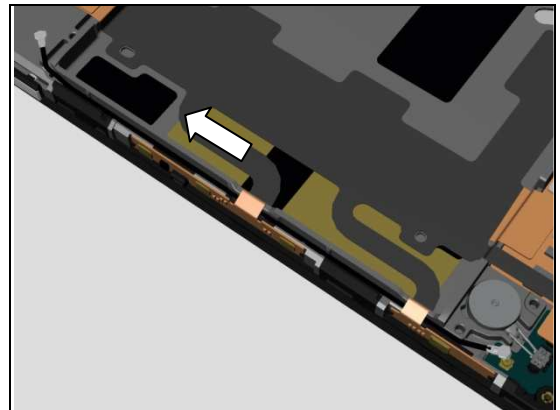
Follow the 3.1 – 3.9 Disassembly instructions!
Follow the 4.26 Removal instructions!
 Prepare a new RF cable.
Follow the 4.26 Installation instructions!
Follow the 5.1 – 5.9 Reassembly instructions!

REMOVAL

Disconnect the RF cable connector.



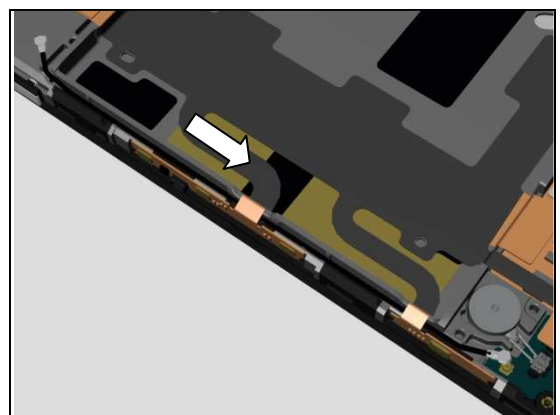
Thread the RF cable through the Main FPC to remove it.



INSTALLATION

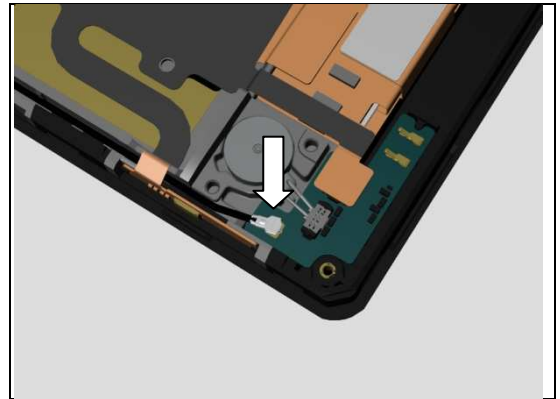
Mount the RF cable by threading it through the Main FPC.

Make sure the RF cable is mounted in its cavity.



Replacement: RF cable

Press to snap RF cable connector.



Replacement

4.39 RGB Gasket

Follow the 3.1 – 3.7 Disassembly instructions!

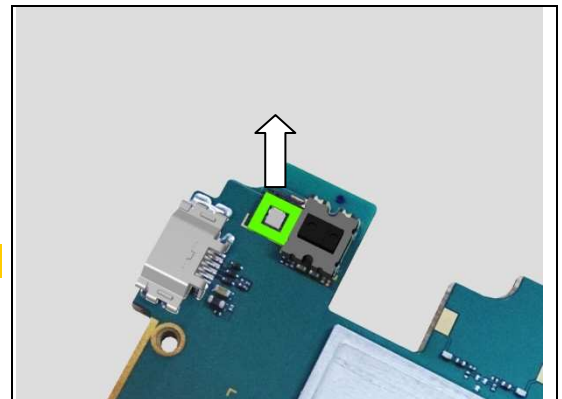
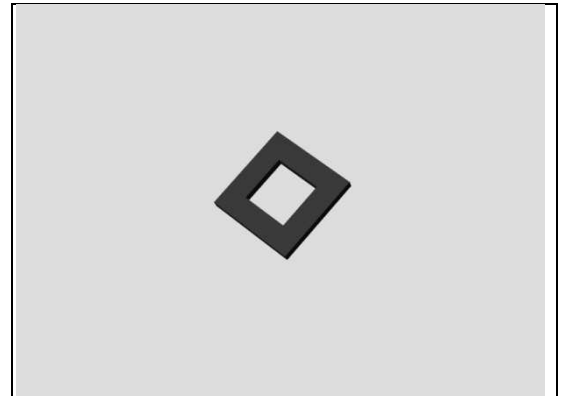
Prepare a new RGB Gasket.

Follow the 5.3 – 5.9 Reassembly instructions!

REMOVAL

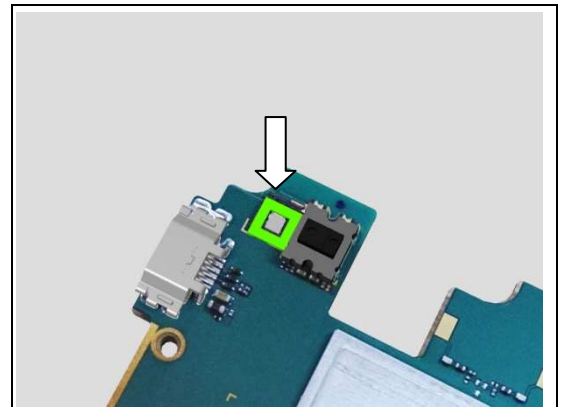
Detach the RGB Gasket.

Scrap! Not to be reused!



INSTALLATION

Attach the RGB Gasket.



Replacement

4.40 SD Cap

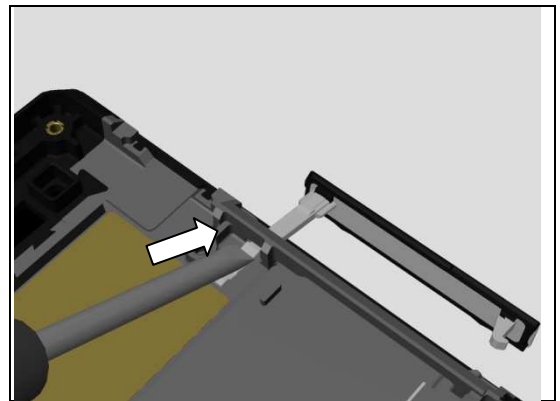
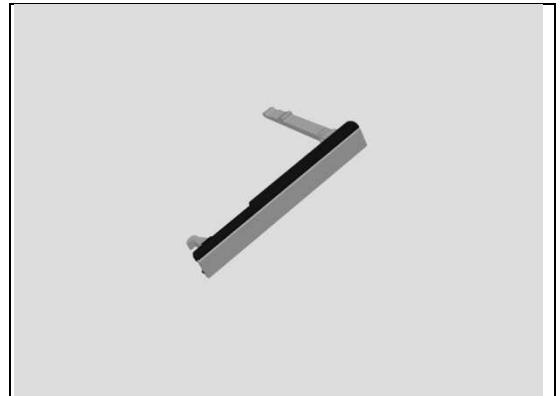
Follow the 3.1 – 3.8 Disassembly instructions!

Prepare a new SD Cap.

Follow the 5.2 – 5.9 Reassembly instructions!

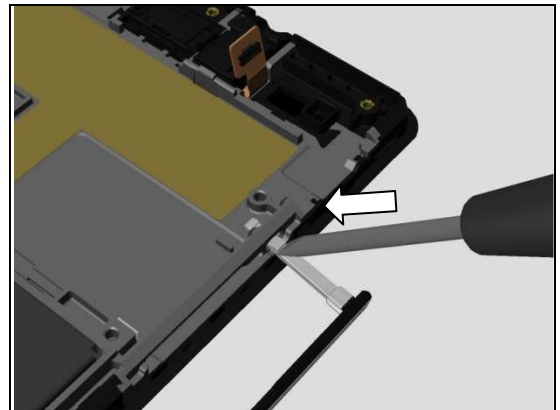
REMOVAL

Push the stopper to release the SD Cap by using Flat Screwdriver.



INSTALLATION

Push the stopper to mount the SD Cap by using Flat Screwdriver.



Replacement

4.41 SIM Cap

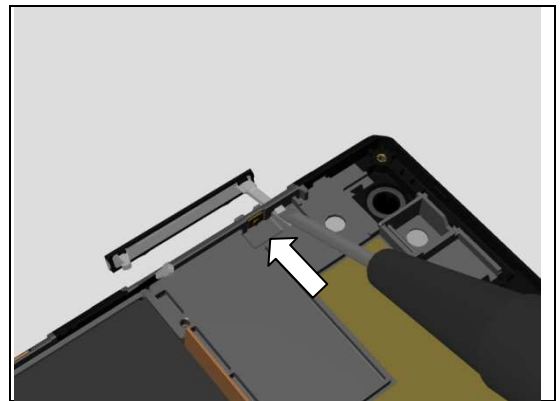
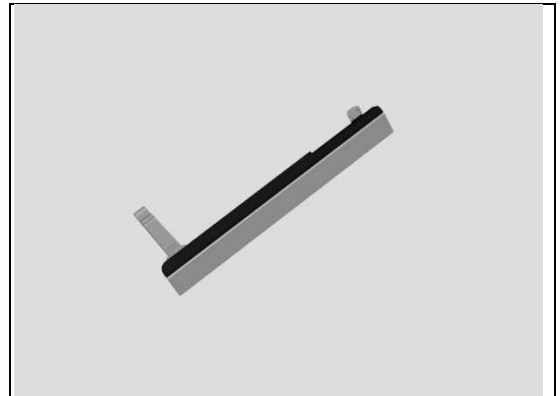
Follow the 3.1 – 3.8 Disassembly instructions!

Prepare a new SIM Cap.

Follow the 5.2 – 5.9 Reassembly instructions!

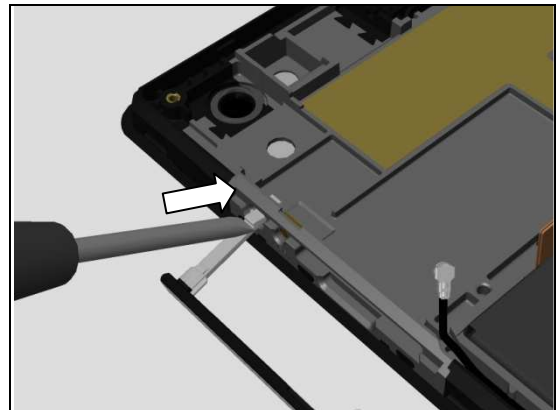
REMOVAL

Push the stopper to release the SIM Cap by using Flat Screwdriver.



INSTALLATION

Push the stopper to mount the SIM Cap by using Flat Screwdriver.



Replacement

4.42 Speaker Mesh

Follow the 3.2 Disassembly instructions!

Prepare a new Speaker Mesh.

Follow the 5.8 Reassembly instructions!

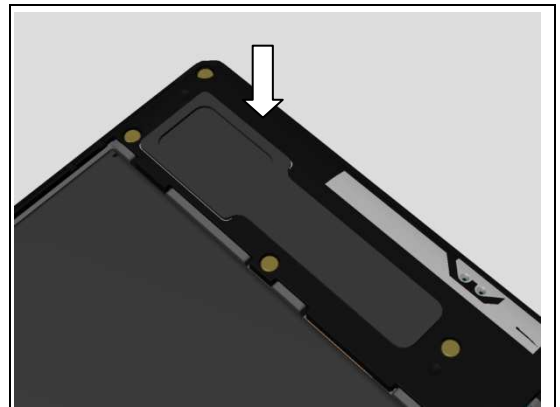
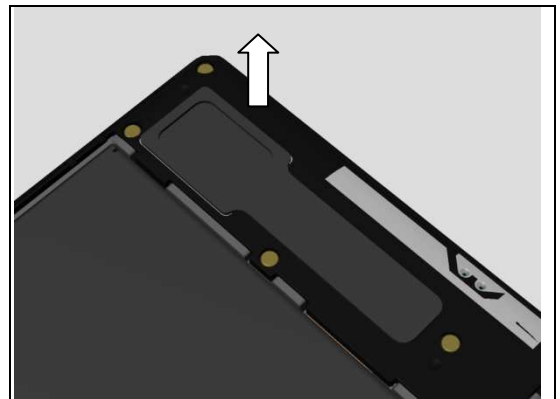
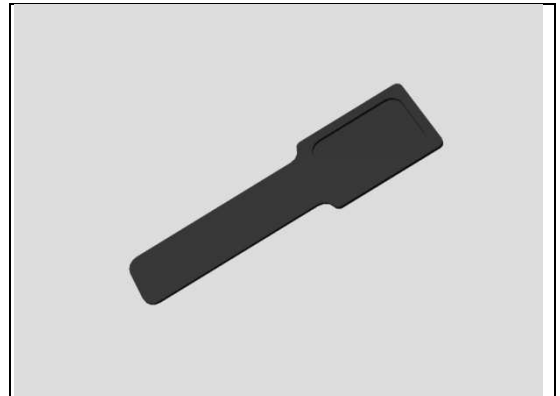
REMOVAL

Detach the Speaker Mesh.

Scrap! Not to be reused!

INSTALLATION

Attach the Speaker Mesh.



Replacement

4.43 Speaker Net

Follow the 3.2 Disassembly instructions!

Prepare a new Speaker Net.

Follow the 5.8 Reassembly instructions!

REMOVAL

Detach the Speaker Net.

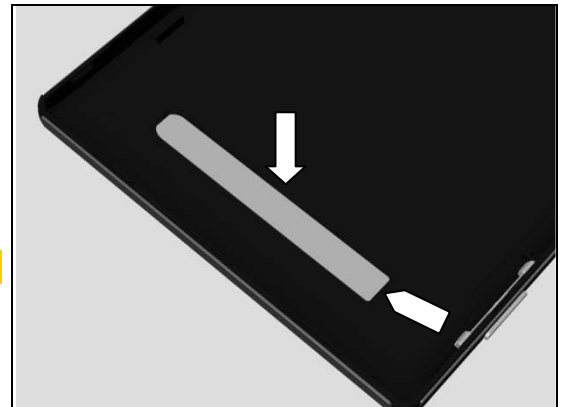
Scrap! Not to be reused!



INSTALLATION

Attach the Speaker Net in its hole.

Note the direction of the Speaker Net!



Make sure the Speaker Net is mounted into its proper position.



Replacement

4.44 Sub PBA

Follow the 3.2 and 3.9 Disassembly instructions!

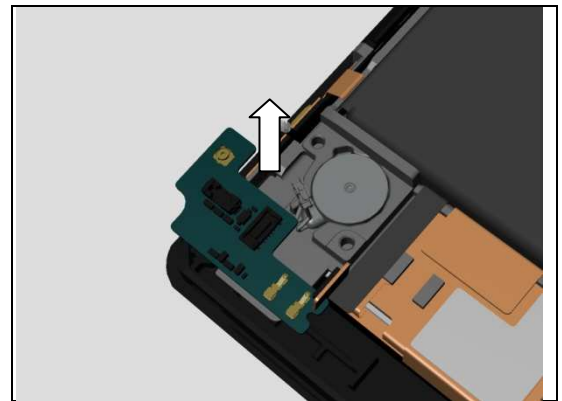
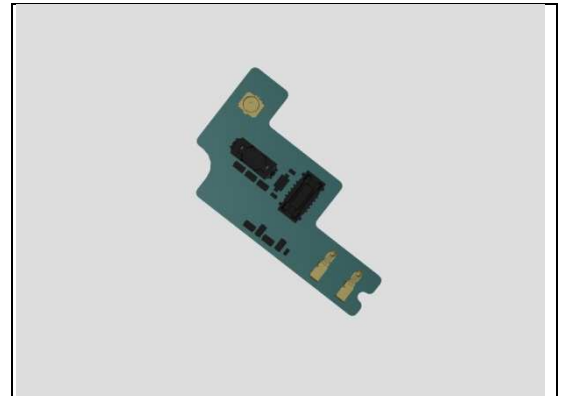
Prepare a new Sub PBA.

Follow the 5.1 and 5.8 Reassembly instructions!

REMOVAL

Disconnect the Main FPC BtB connector, RF Cable connector and Vibrator connector.

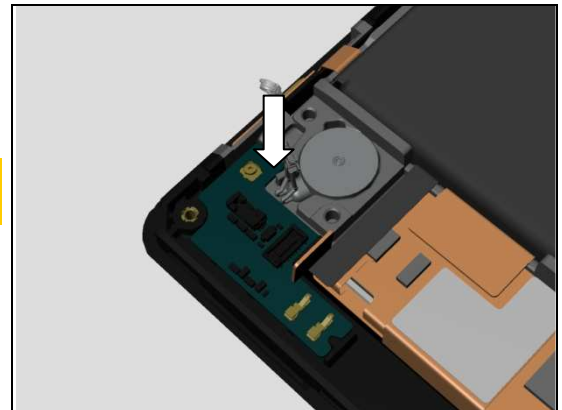
Detach the Sub PBA.



INSTALLATION

Follow the 4.13 Removal and Installation instructions to replace a new Adhesive Conductive Sub PBA.

Attach the Sub PBA in its proper position and press it. Press to snap the Main FPC BtB connector, RF Cable connector and Vibrator connector.



Replacement

4.45 Vibrator

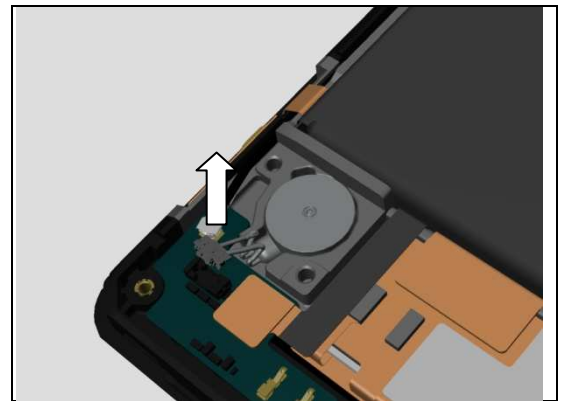
Follow the 3.2 and 3.9 Disassembly instructions!

Prepare a new Vibrator.

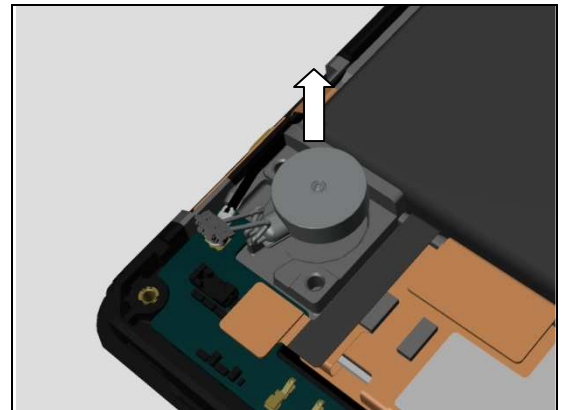
Follow the 5.1 and 5.8 Reassembly instructions!

REMOVAL

Disconnect the Vibrator connector.



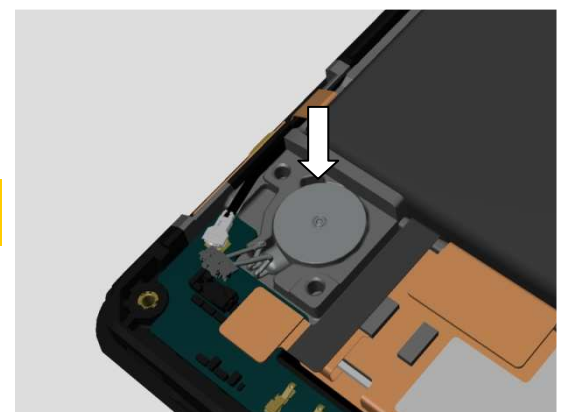
Detach the Vibrator.



INSTALLATION

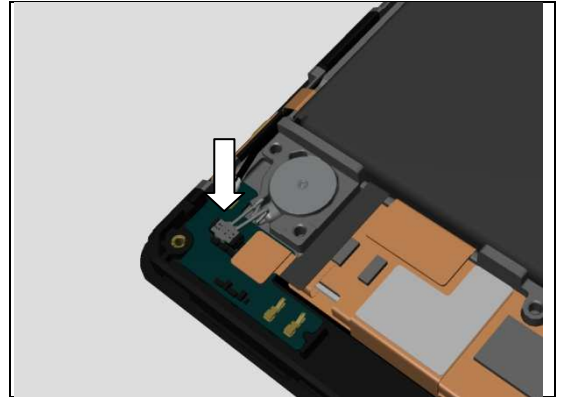
Follow the 4.14 Removal and Installation instructions to replace a new Adhesive Conductive Vibrator.

Attach the Vibrator into its cavity and press it.



Replacement: Vibrator

Press to snap the Vibrator connector.



Replacement

4.46 Board Swap – Replacement

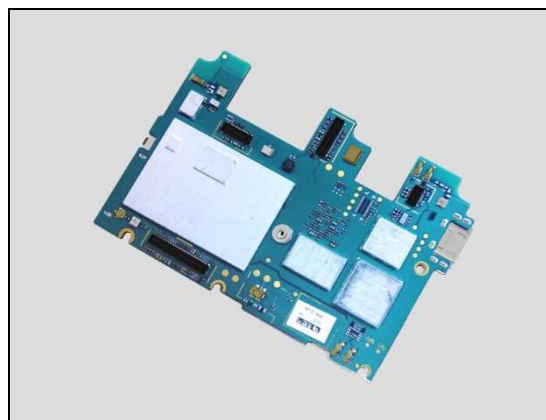
Follow the 3.1 – 3.7 Disassembly instructions!

Prepare a new Main PBA.

Follow the 4.33 and 4.39 Installation instructions!

Follow the 5.3 – 5.9 Reassembly instructions!

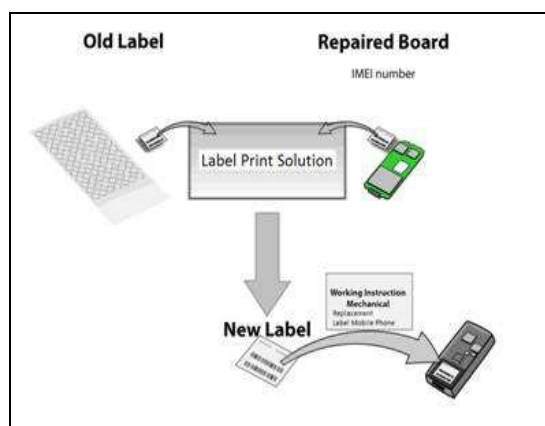
Accelerometer Calibration must be performed for all replaced units; 1289-2983 Trouble Shooting Application – mechanical.



4.47 Board Swap – Change Label

CHANGE LABEL

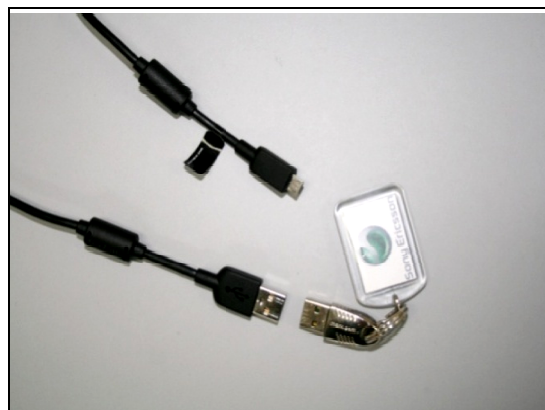
Follow the instructions in the Generic Repair Manual – Build swap for change of label.



4.48 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

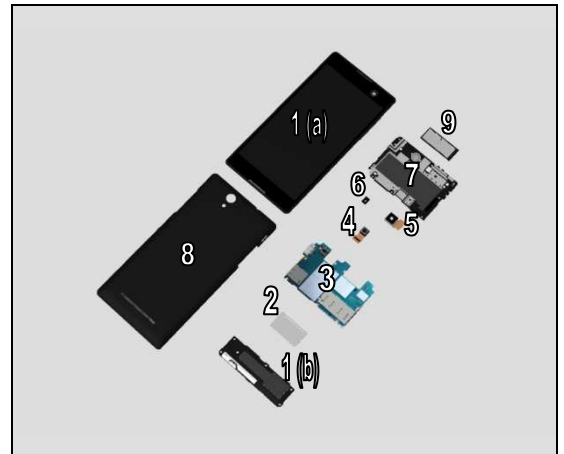
Follow the instructions in the Generic Repair Manual – Build swap for customization of the software.



5 Reassembly

The S55t/S55u/D2533/D2502 reassembly is done in the following order:

1. Display Frame Assy (a) and Ant Speaker Bottom Frame Assy (b)
2. Core Unit label Tray
3. Main PBA
4. Chat Camera
5. Main Camera
6. 2nd Mic Rubber
7. Ant Top Frame Assy
8. Back Cover Assy
9. SIM Tray



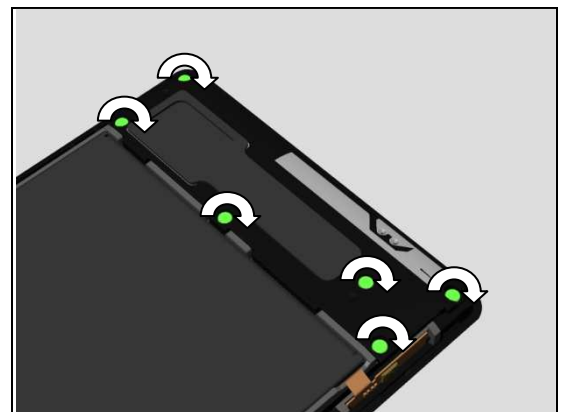
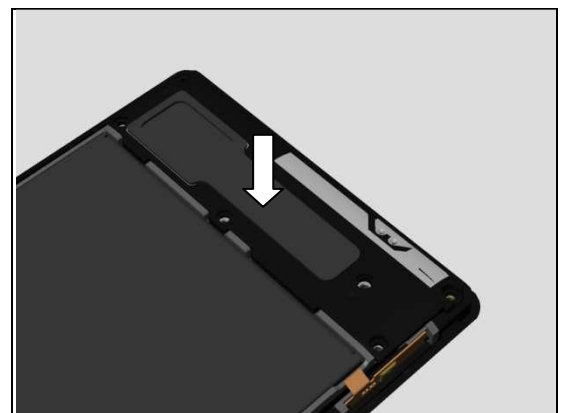
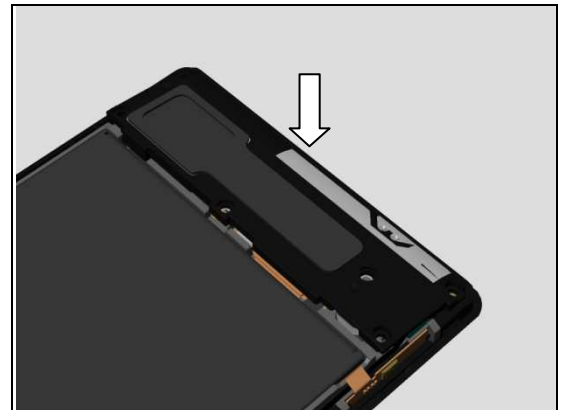
Reassembly

5.1 Display Frame Assy (a) and Ant Speaker Bottom Frame Assy (b)

Mount the bottom side of the Ant Speaker Bottom Frame Assy.

Press to secure its position.

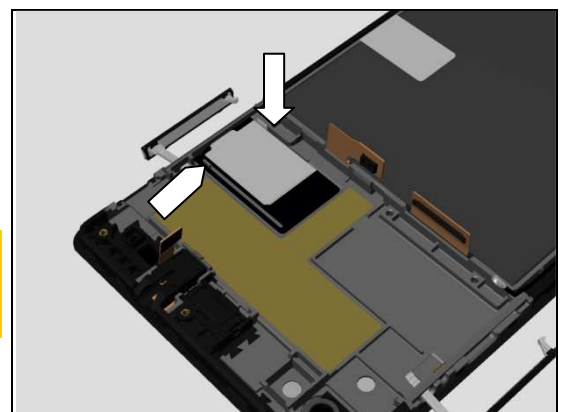
Apply $8\text{Ncm} \pm 1\text{Ncm}$ torque when tightening the six Screw M1.4x2.8 with Bits (JCIS No 0).



5.2 Core Unit label Tray

Mount the Core Unit label Tray in its proper position.

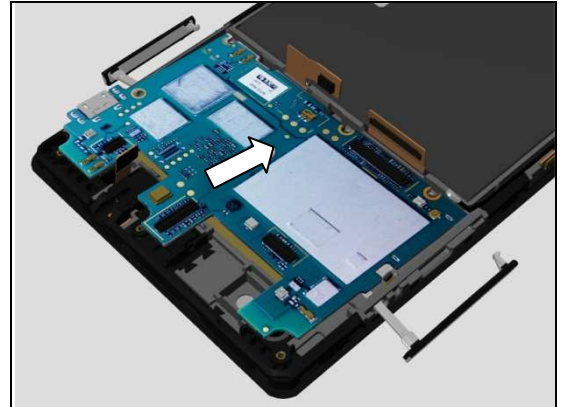
Note the direction of the Core Unit label Tray!
Make sure the stopper rib is mounted into the sliding slot!



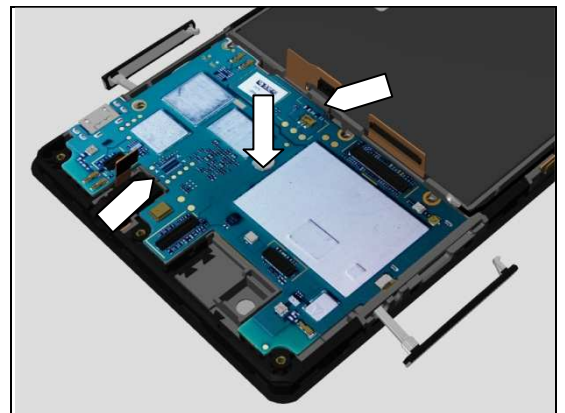
Reassembly

5.3 Main PBA

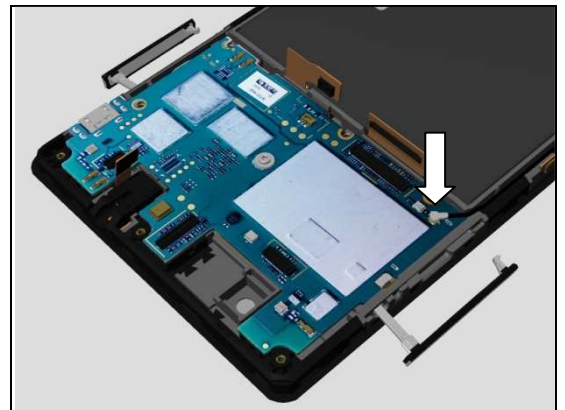
Mount the Main PBA in its cavity.



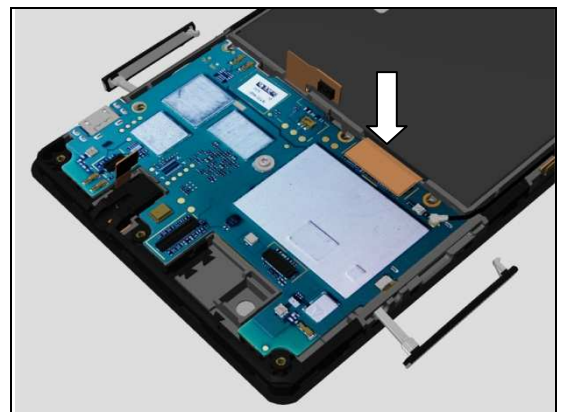
Press to snap the Main PBA.



Press to snap the RF Cable connector.

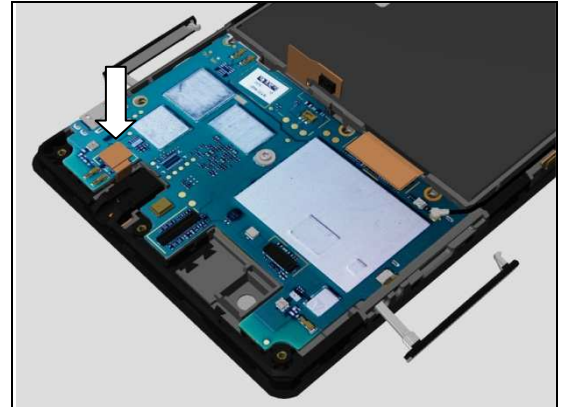


Press to snap the Main FPC BtB connector.



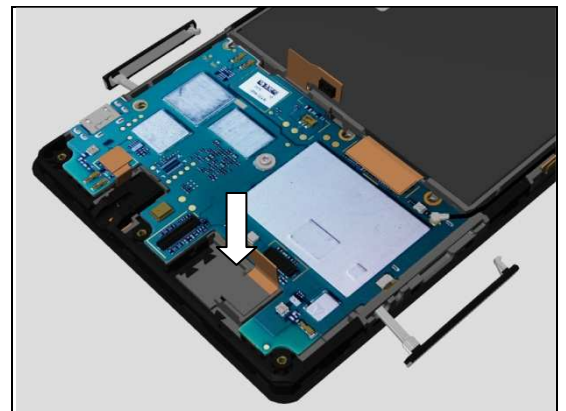
Reassembly

Press to snap the Audio Jack Assy BtB connector.

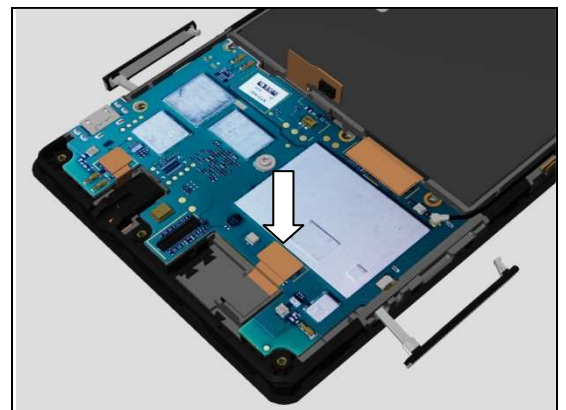


5.4 Chat Camera

Mount the Chat Camera in its cavity.

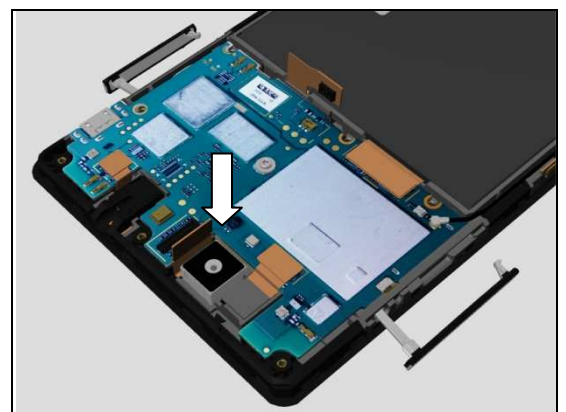


Press to snap the Chat Camera BtB connector.



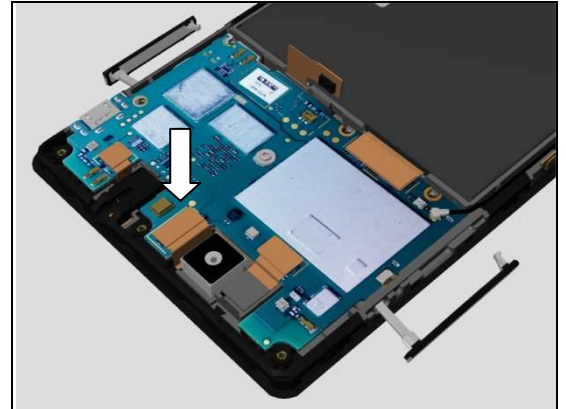
5.5 Main Camera

Mount the Main Camera in its cavity.



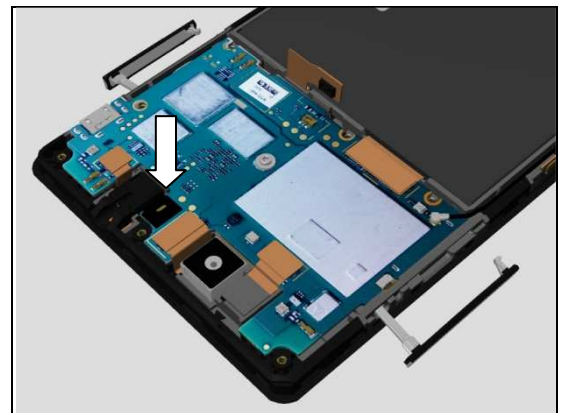
Reassembly

Press to snap the Main Camera BtB connector.

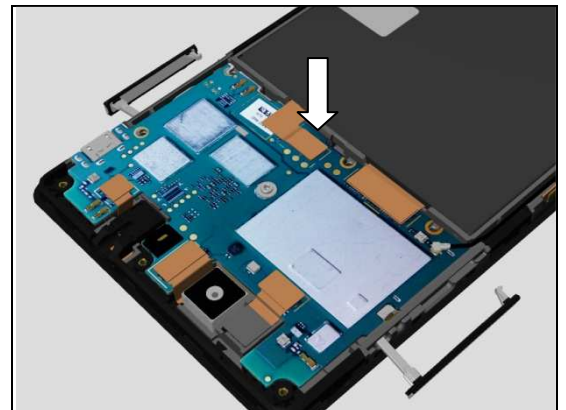


5.6 2nd Mic Rubber

Mount the 2nd Mic Rubber and press it.

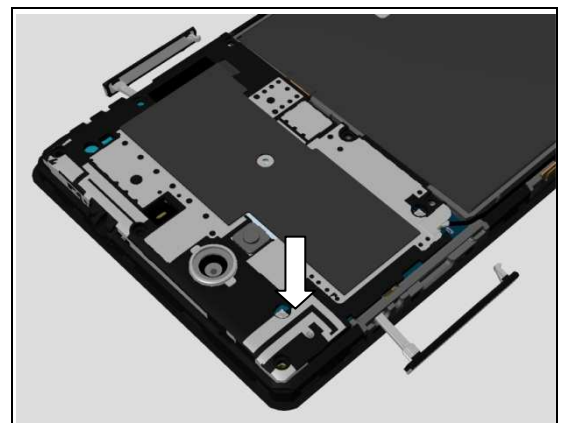


Press to snap the Battery FPC BtB connector.



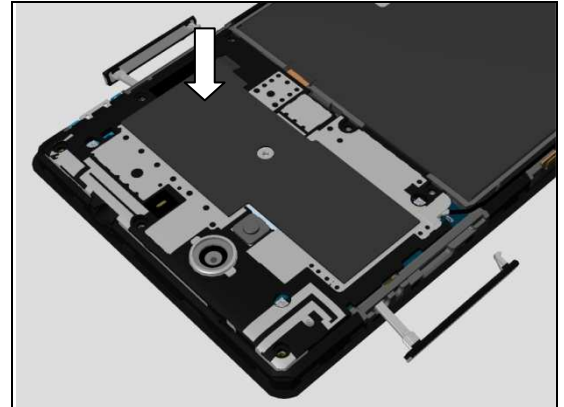
5.7 Ant Top Frame Assy

Mount the top left side of the Ant Top Frame Assy.

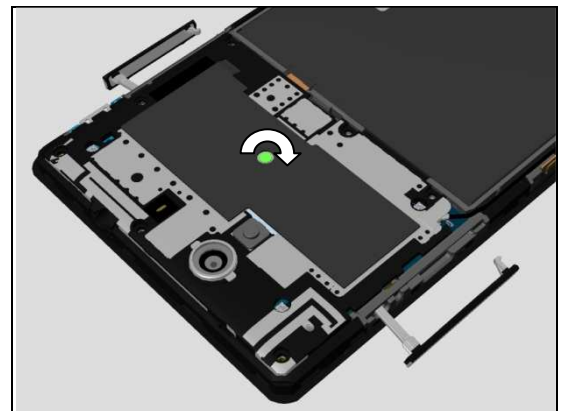


Reassembly

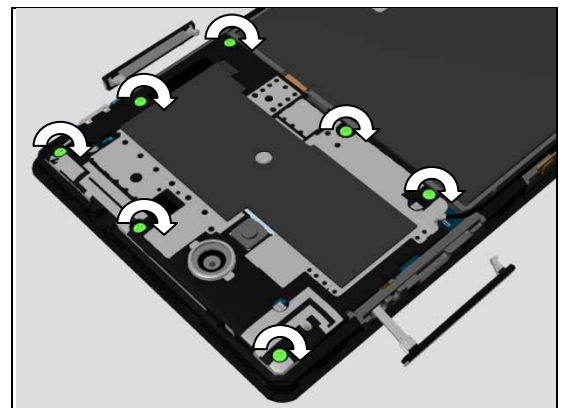
Press to snap the Ant Top Frame Assy.



Apply $3\text{Ncm} \pm 0.5\text{Ncm}$ torque when tightening the Screw
Other Len:1.1 Diam:1.2 with Bits (JCIS No 0).



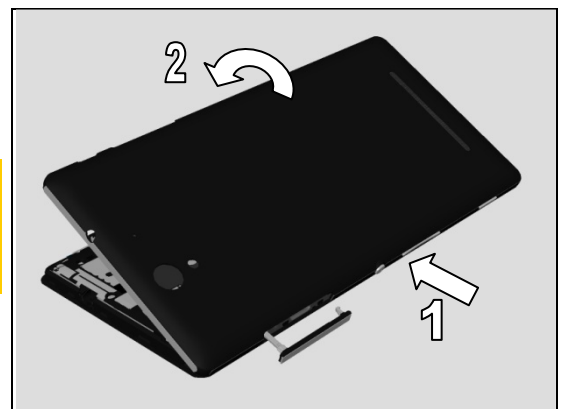
Apply $8\text{Ncm} \pm 1\text{Ncm}$ torque when tightening the seven Screw
Torx Len:3.1 Diam:1.4 with Bits (JCIS No 0).



5.8 Back Cover Assy

Follow the 4.19 or 4.20 or 4.21 or 4.22 or 4.23 or 4.24 or 4.25 Removal and Installation instructions to replace a new certain Back Cover Panel due to it is damaged from Back Cover Assy disassembly.

Mount the power key side of the Back Cover Assy(1), and rotate the Back Cover Assy to mount the other side(2).

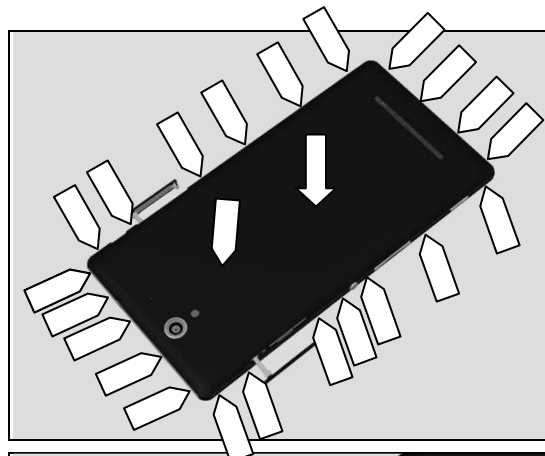


Reassembly

Press to snap hooks of the Back Cover Assy.

Make sure all the hooks are snapped!

Check the function of power key, side key and camera key after assembly.

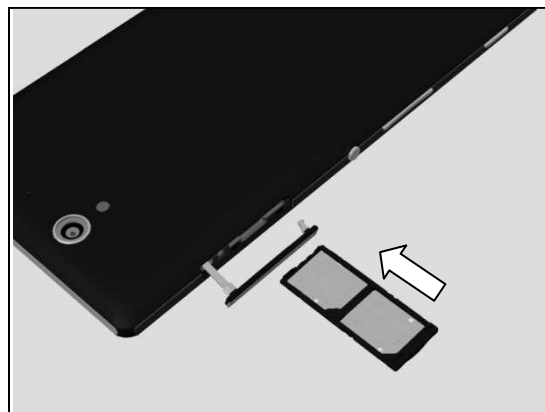


Close the SD Cap.

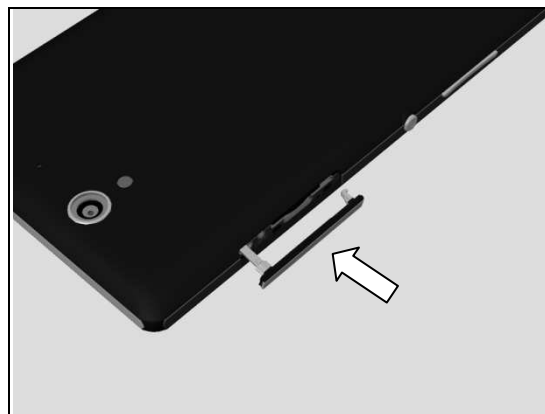


5.9 SIM Tray

Insert the SIM Tray with fingers.



Close the SIM Cap.



6 Revision History

Rev.	Date	Changes / Comments
1	2014-Jul-18	Initial release
2	2014-Jul-24	Update document since no need Proximity Sensor Calibration any more. Update the note of Earspeaker removal.
3	2014-Aug-08	Added D2533/D2502
4	2014-Aug-29	Update chapter 4.26, need to scrap battery once disassembly.