

Working Instructions

- mechanical -



Xperia™ C4 & C4 Dual
E5303, E5333, E5353, E5343, E5306, E5363

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SONY

Working Instruction Repair Instruction Mechanical/

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

Exterior Views

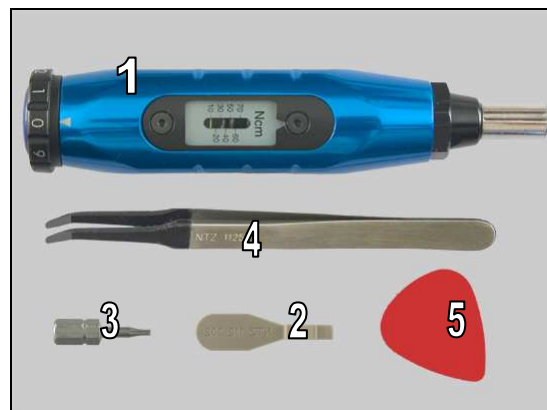
1.1 E5303, E5333, E5353, E5343, E5306, E5363



2 Tools

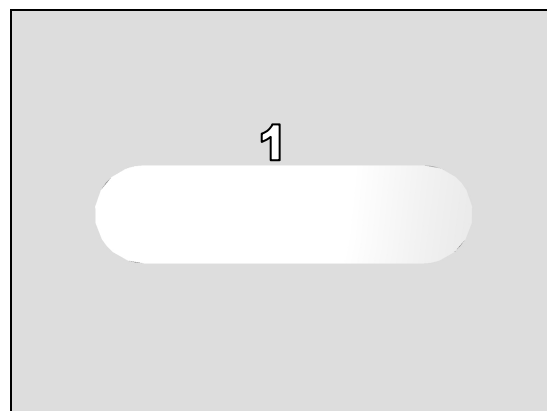
SPECIAL TOOLS

1. Torque Screwdriver
2. Front Opening Tool
3. Torx Bit T5
4. Flex Film Assembly Tool
5. Guitar Pick



SPECIAL TOOLS

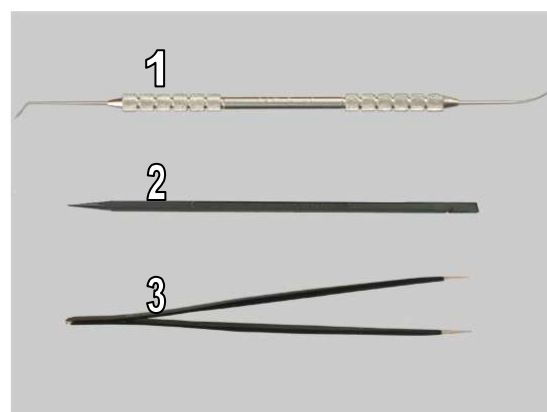
1. Flexible Disassembly tool



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

STANDARD TOOLS

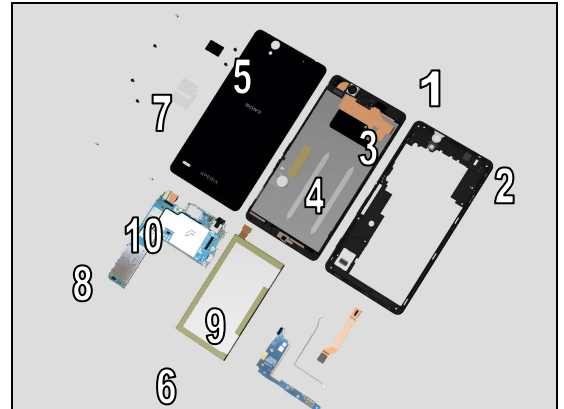
1. Dentist Hook
2. Nylon Pointer
3. Tweezers



3 Disassembly

The disassembly is done in the following order:

1. Battery Cover
2. Battery Mylar
3. Screws
4. Rear Cover Ass'y
5. Main PBA
6. CU Label Tray
7. Link FPC
8. Coaxial Cable
9. SUB PBA
10. Battery 2600mAh & Front Cover Ass'y

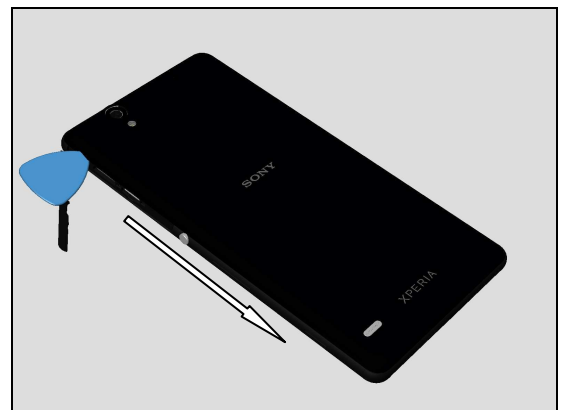


3.1 Battery Cover

Open Micro SD/SIM door.



Insert Guitar Pick then slide Guitar Pick along side of phone loosening snap hooks as shown in picture.

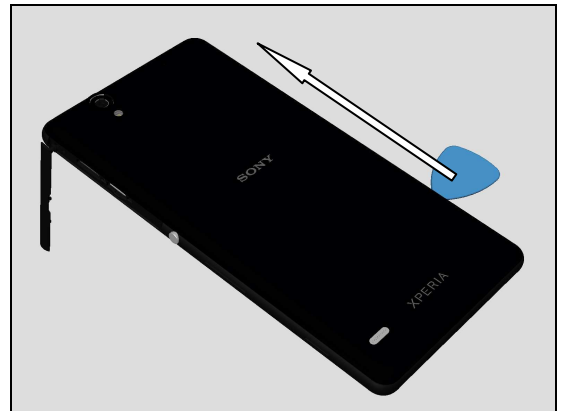


Repeat same action for bottom side.

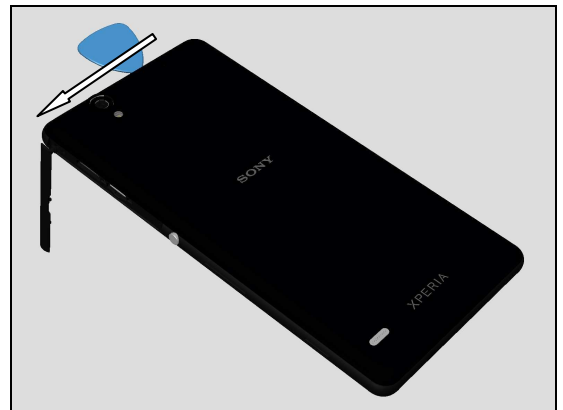


Disassembly

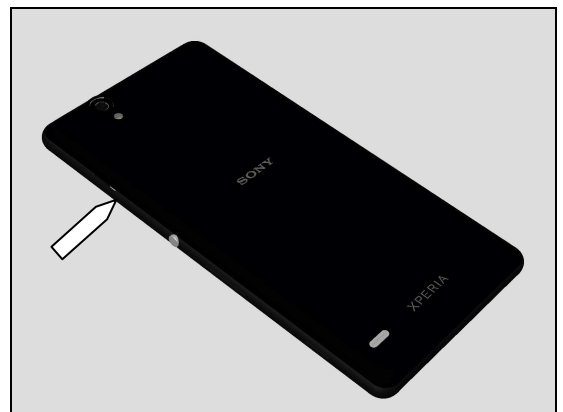
Repeat same action for other side.



Repeat same action for topside.



Close Micro SD/SIM door.



Lift up battery Cover from topside and remove.

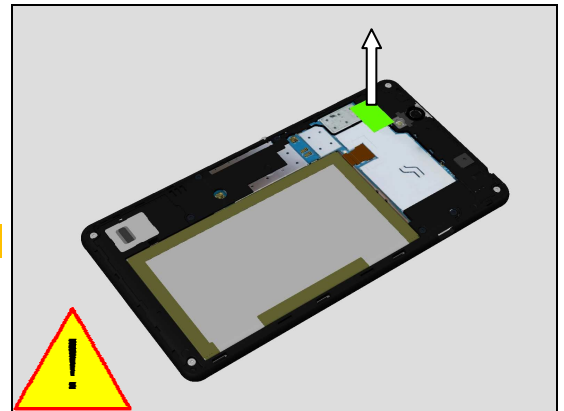
Scrap: Do not reuse, during removal operation of Battery Cover snap hooks will be damaged!



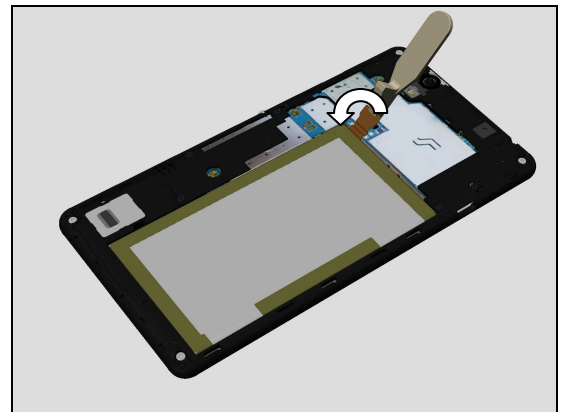
3.2 Battery Conn Mylar

Remove Battery Conn Mylar.

Scrap: Do not reuse!

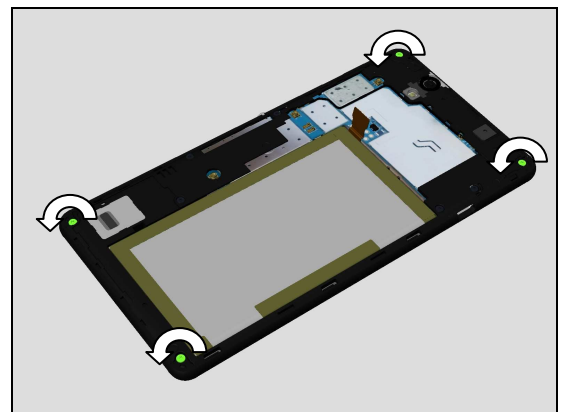


Use Front Opening Tool to disconnect Battery 2600mAh board-to-board (BtB) connector to cut to power to Main PBA.

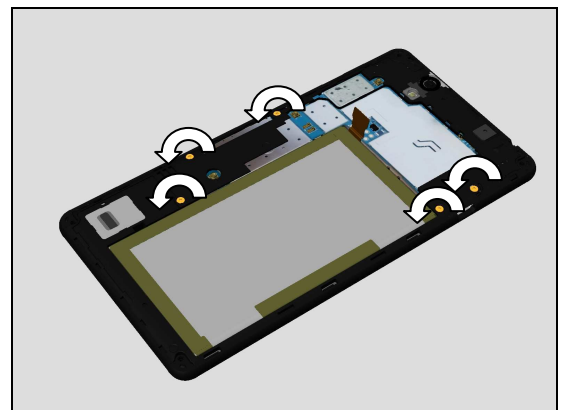


3.3 Screws

Remove 4 outer Screw 1.6mm x 4mm_SILVER_T5 using torx T5.

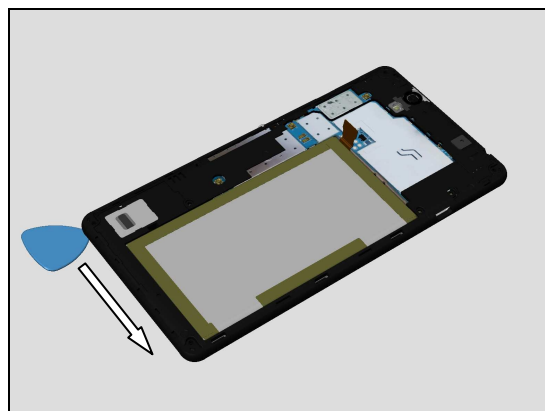


Remove 5 inner Screw 1.6mm x 3mm_BLACK_T5 using Torx T5.

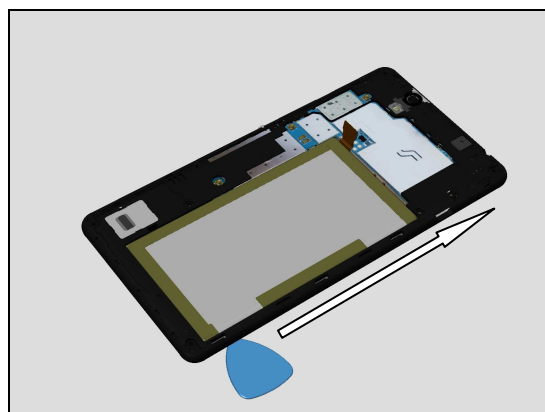


3.4 Rear Cover Ass'y

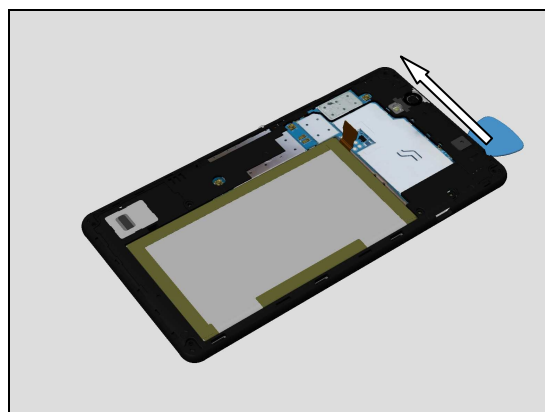
Insert Guitar Pick then slide Guitar Pick along side of phone loosening snap hooks as shown in picture.



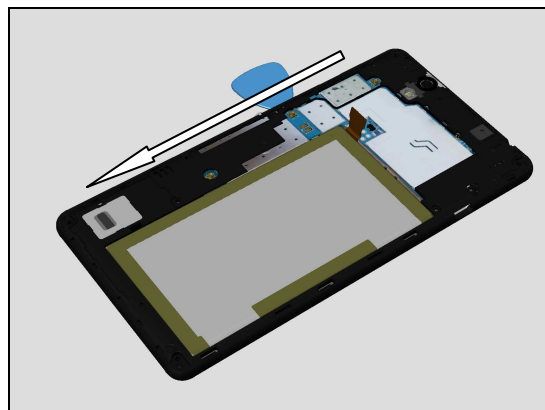
Repeat same action for the side of the phone.



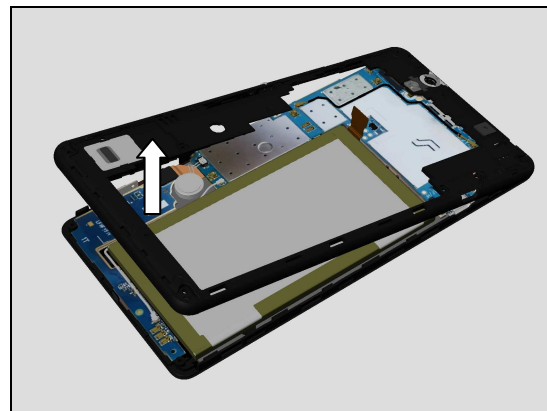
Repeat same action for topside.



Repeat same action for other side.

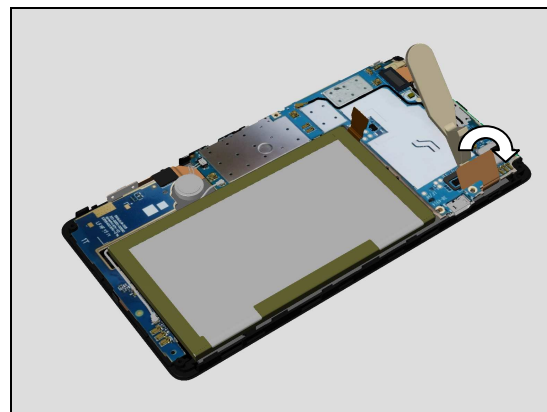


Lift up Rear Cover Ass'y from bottom side and remove as shown in picture.

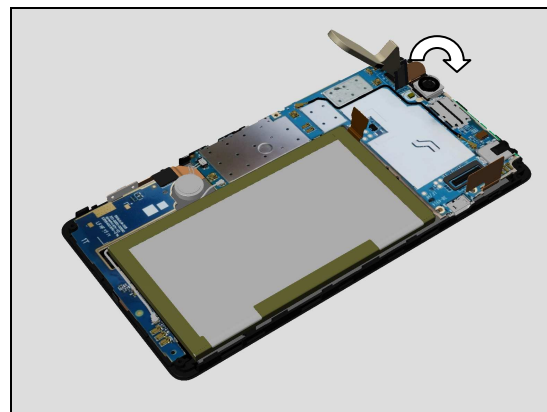


3.5 Main PBA

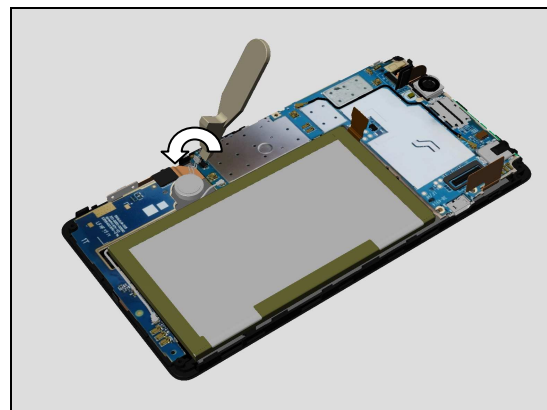
Use Front Opening Tool to disconnect LCM board-to-board (BtB) connector.



Use Front Opening Tool to disconnect Main Camera board-to-board (BtB) connector.

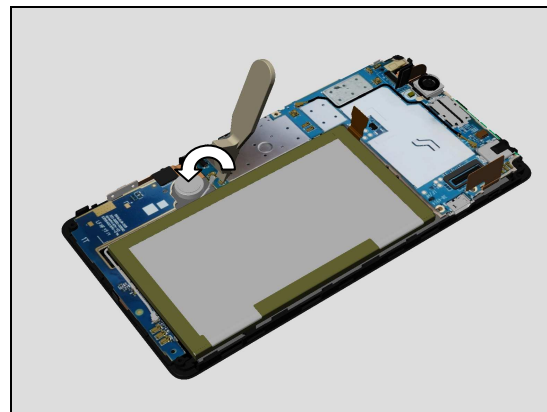


Use Front Opening Tool to disconnect Vibrator connector.

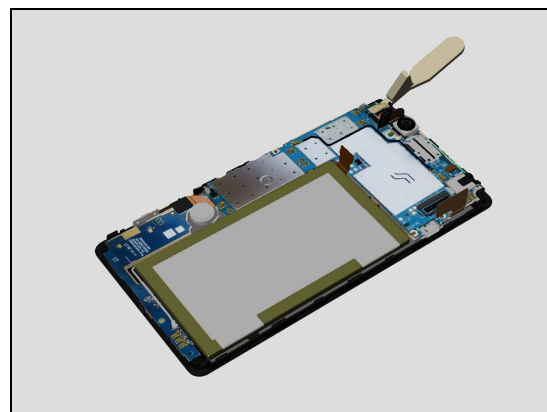


Disassembly

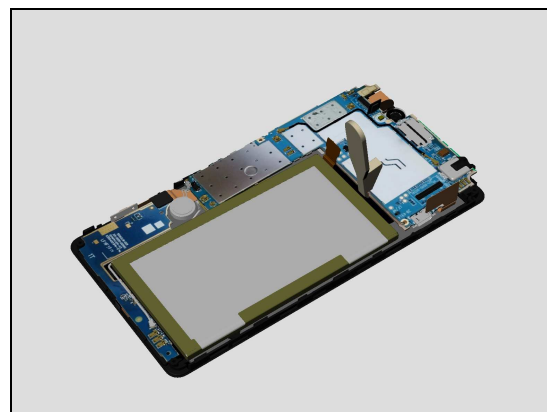
Use Front Opening Tool to disconnect Coaxial Cable connector.



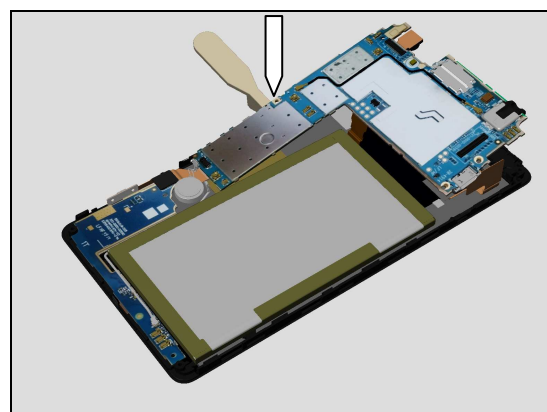
Use Front Opening Tool to release snap hook at side of Main PBA.



Use Front Opening Tool to rise up Main PBA releasing snap hook as shown in picture.

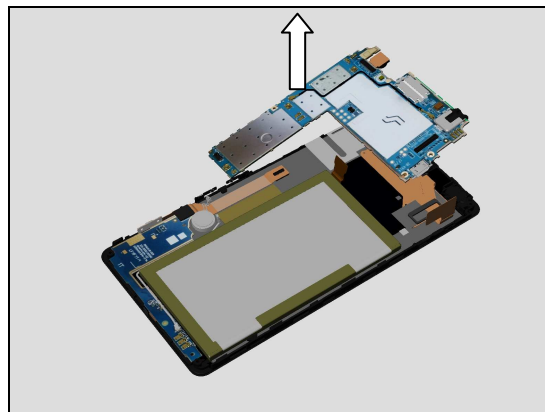


Gently lift up Main PBA then use Front Opening Tool to disconnect Link FPC board-to-board (BtB) connector underneath Main PBA.



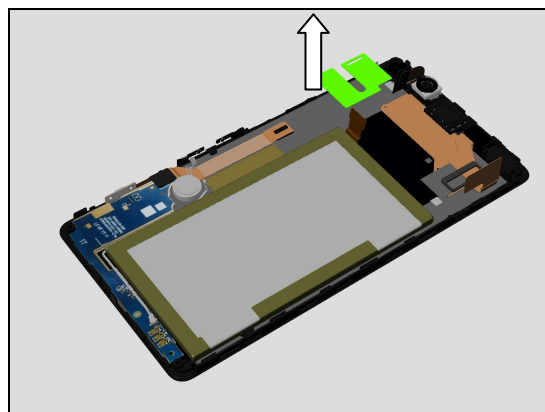
Disassembly

Remove Main PBA.



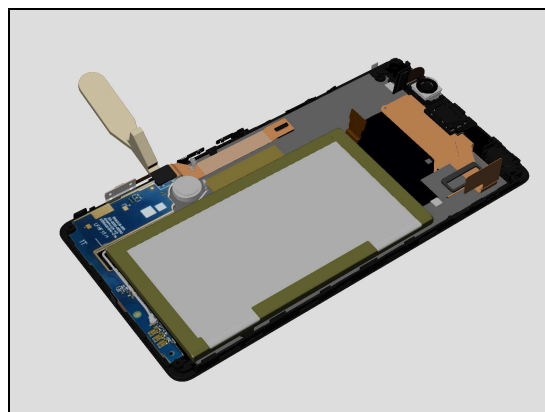
3.6 CU Label Tray

Remove CU label Tray.



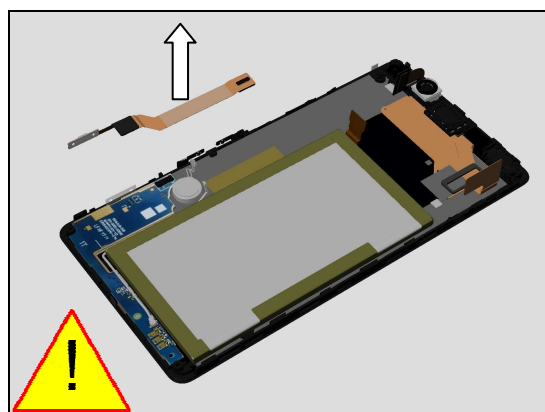
3.7 Link FPC

Use Front Opening Tool to disconnect Link FPC board-to-board (BtB) connector Sub PBA.



Remove Link FPC.

Scrap: Do not reuse!



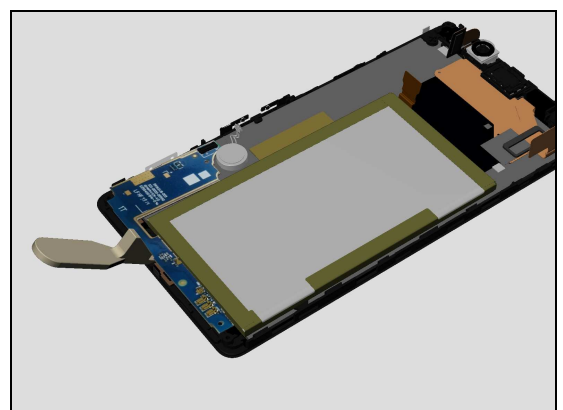
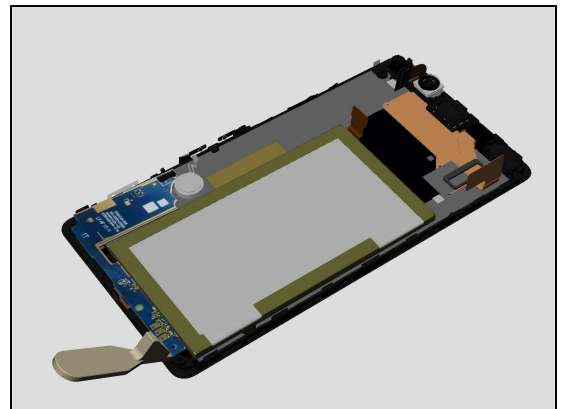
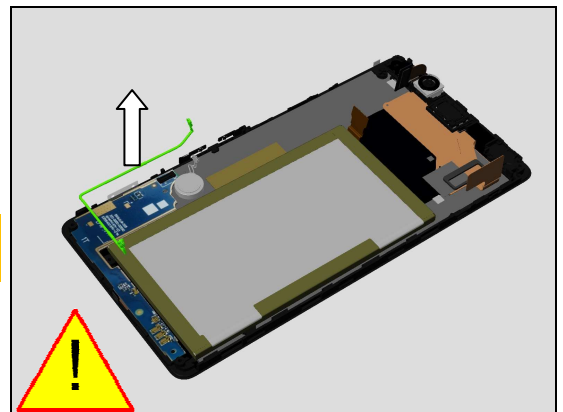
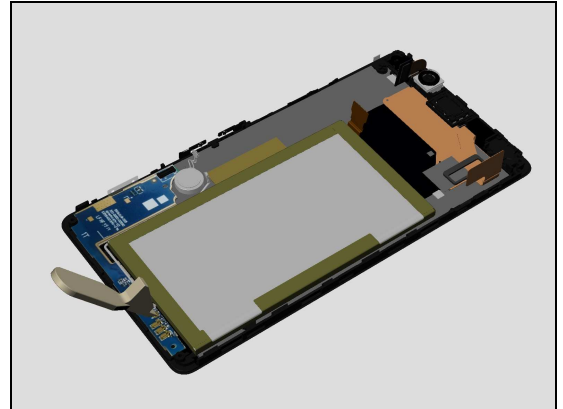
Disassembly

3.8 Coaxial Cable

Use Front Opening Tool to disconnect Coaxial Cable board-to-board (BtB) connector Sub PBA.

Carefully detach Coaxial Cable from Front Cover Assy cavity using Front Open Tool and fingers.

Inspect Coaxial Cable for any physical damage after disassembly! Scrap if damaged!



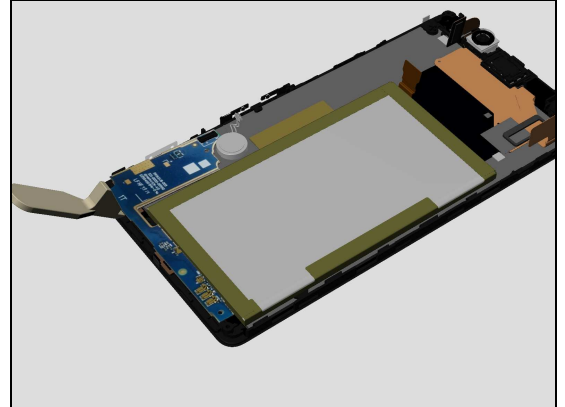
3.9 Sub PBA

Insert Front Opening Tool, tilt to loosen Sub PBA.

Repeat action again as shown on picture.

Disassembly

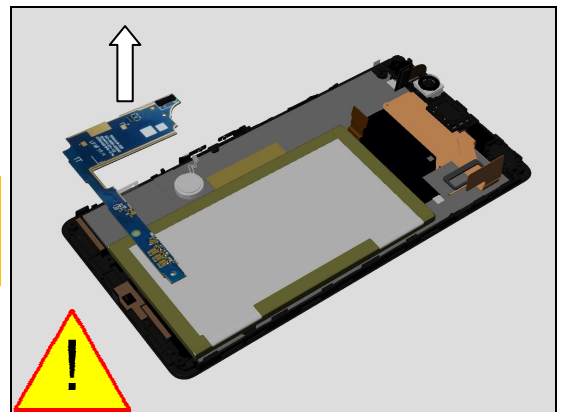
Repeat action again as shown on picture.



Remove Sub PBA.

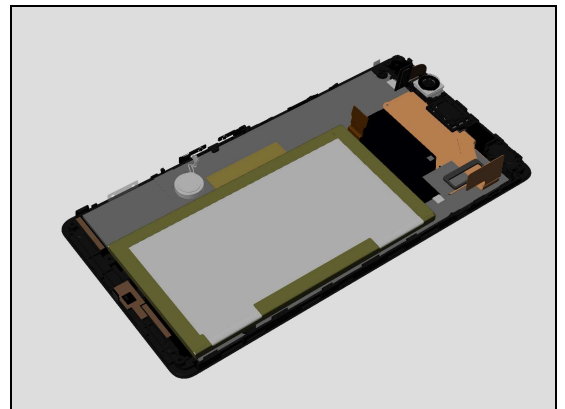
Scrap: Do Not Reuse!

Due to adhesive fixation impossible to avoid warp damage to Sub PBA!



3.10 Battery 2600mAh & Front Cover Ass'y

Place the Front Assy with Battery 2600mAh into ESD safe bag.



Place the Front Assy unit into the fridge.

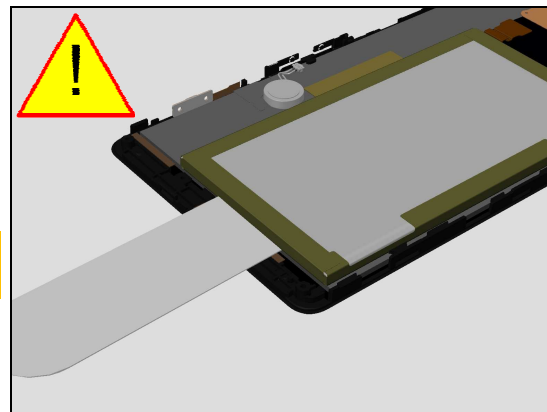
Set the fridge temperature at -20°C, and set the time at 30 minutes.



Disassembly

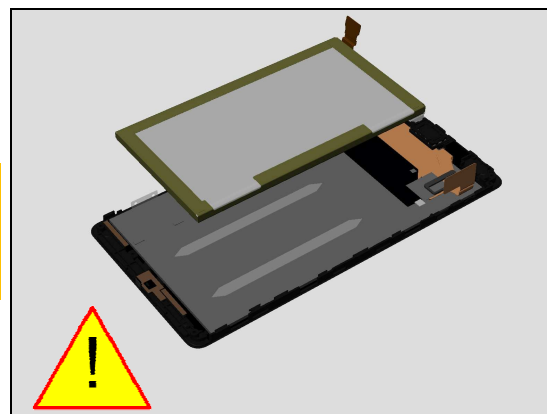
Remove from freezer, then immediately Insert Flexible Disassembly Tool at the bottom end to loosen adhesive located under battery.

Attention: If Front Cover Assy with Battery 2600mAh returns to room temperature, adhesive will bond again!



Remove Battery 2600mAh using fingers

Carefully inspect the Battery after removing it. Battery with visual signs of been punctured etc must be scraped after removal and disposed of in accordance with local policies!



4 Replacement

4.1 Battery Cover

Follow the 3.1 Disassembly instruction!

Prepare the new part Battery Cover.

Follow the 5.10 Reassembly instruction!

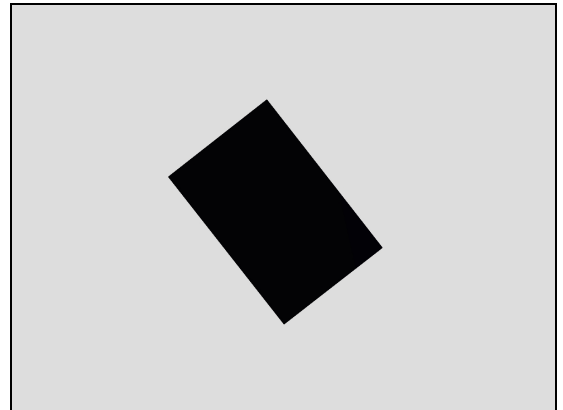


4.2 Battery Conn Mylar

Follow the 3.1 – 3.2 Disassembly instructions!

Prepare the new part Battery Conn Mylar.

Follow the 5.9 – 5.10 Reassembly instructions!

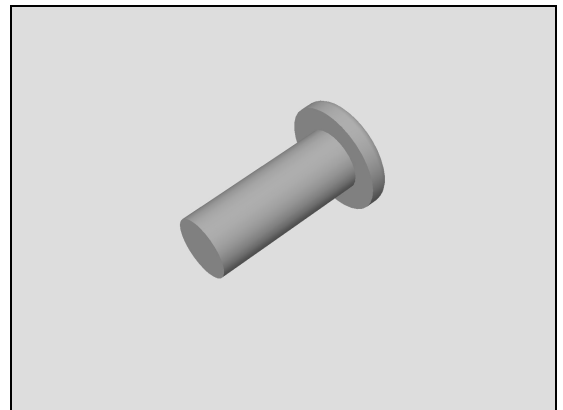


4.3 Screw 1.6mm x 4mm_SILVER_T5

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new part Screw 1.6mm x 4mm_SILVER_T5.

Follow the 5.8 – 5.10 Reassembly instructions!

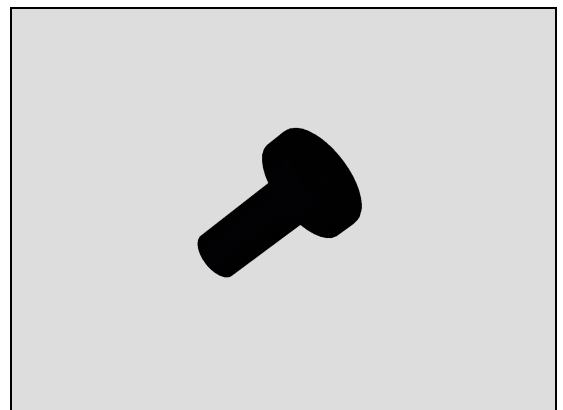


4.4 Screw 1.6mm x 3mm_BLACK_T5

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare the new Part Screw 1.6mm x 3mm_BLACK_T5.

Follow the 5.8 – 5.10 Reassembly instructions!

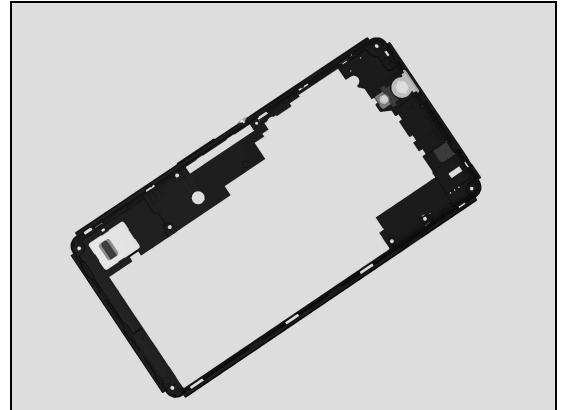


4.5 Rear Cover Ass'y

Follow the 3.1 – 3.4 Disassembly instructions!

Prepare the new Part Rear Cover Ass'y.

Follow the 5.7 – 5.10 Reassembly instructions!

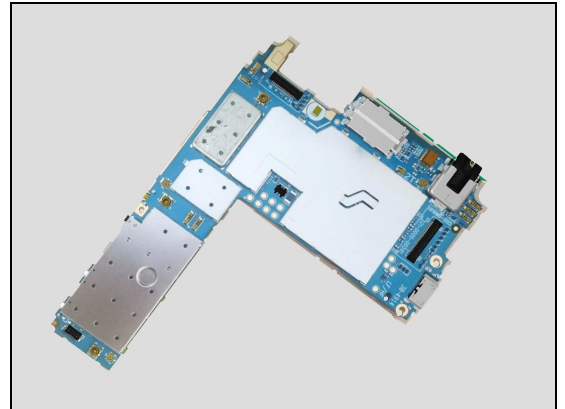


4.6 Main PBA

Follow the 3.1 – 3.5 Disassembly instructions!

Prepare the new Part Main PBA.

Follow the 5.6 – 5.10 Reassembly instructions!



4.7 CU Label Tray

Follow the 3.1 – 3.6 Disassembly instructions!

Prepare the new Part CU Label Tray.

Follow the 5.5 – 5.10 Reassembly instructions!

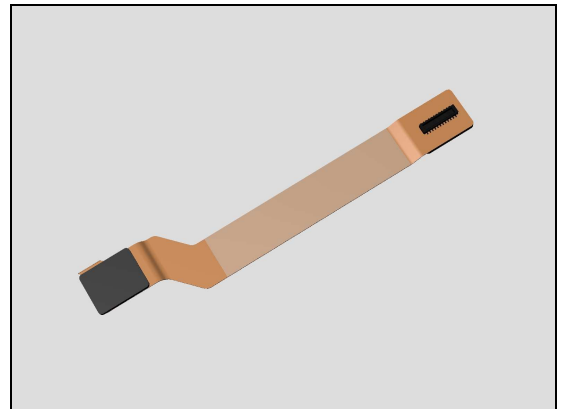


4.8 Link FPC

Follow the 3.1 – 3.7 Disassembly instructions!

Prepare the new Part Link FPC.

Follow the 5.4 – 5.10 Reassembly instructions!



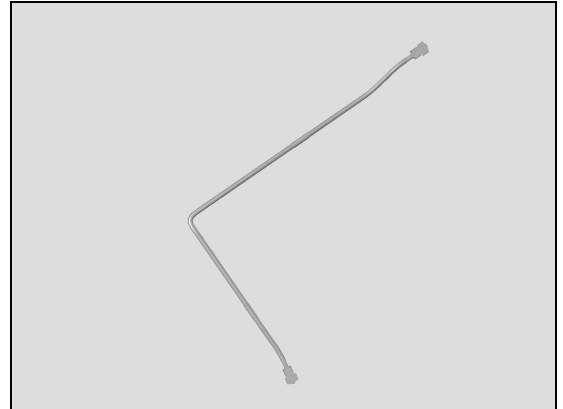
Replacement

4.9 Coaxial Cable

Follow the 3.1 – 3.8 Disassembly instructions!

Prepare the new Part Coaxial Cable.

Follow the 5.3 – 5.10 Reassembly instructions!

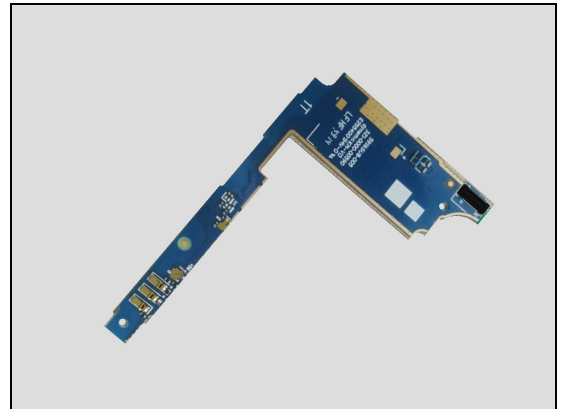


4.10 Sub PBA

Follow the 3.1 – 3.9 Disassembly instructions!

Prepare the new Part Sub PBA.

Follow the 5.2 – 5.10 Reassembly instructions!

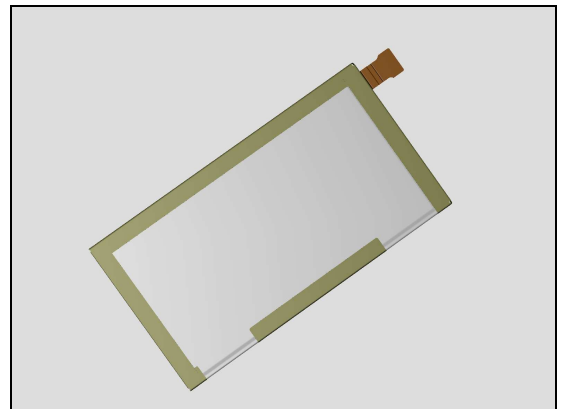


4.11 Battery 2600mAh

Follow the 3.1 – 3.10 Disassembly instructions!

Prepare the new Part Battery 2600mAh.

Follow the 5.1 – 5.10 Reassembly instructions!



4.12 Front Cover Ass'y

Follow the 3.1 – 3.10 Disassembly instructions!

Prepare the new Part Front Cover Ass'y

Follow the 5.1 – 5.10 Reassembly instructions!



Replacement

4.13 Battery Adhesive

Follow the 3.1 – 3.10 Disassembly instructions!

Carry out the Removal as described below!

Prepare the new Part Battery Adhesive.

Carry out the Removal as described below!

Follow the 5.10 – 5.1 Reassembly instructions!

REMOVAL

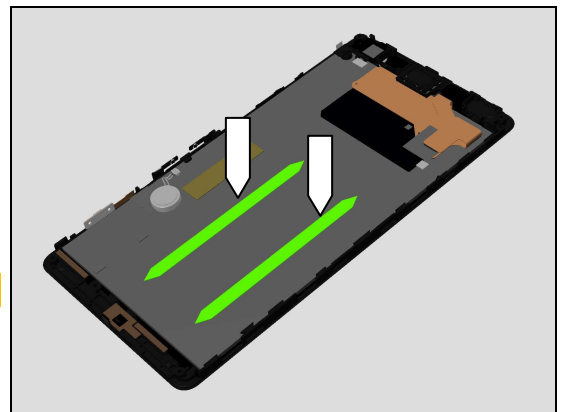
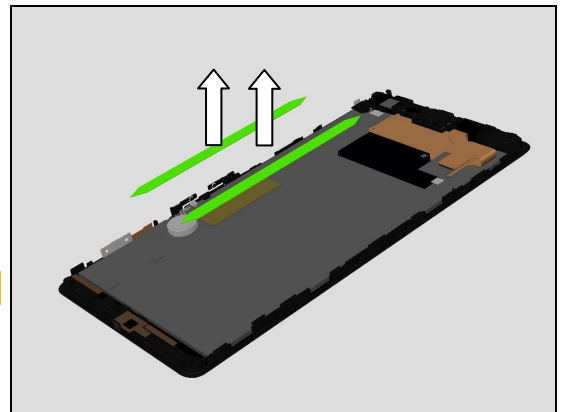
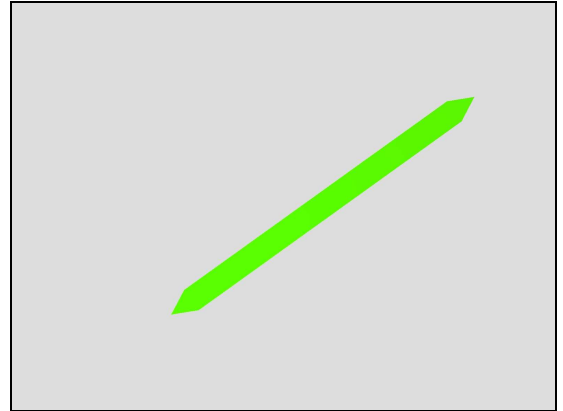
Remove both Battery Adhesives using Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place new Battery Adhesive using Flex Film Assembly Tool onto its proper position.

Use etched marking on Front Cover Ass'y for alignment!



Replacement

4.14 Chat Camera

Follow the 3.1 – 3.5 Disassembly instructions!

Carry out the Removal as described below!

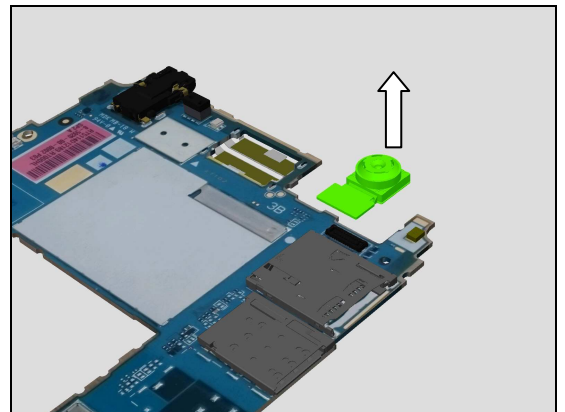
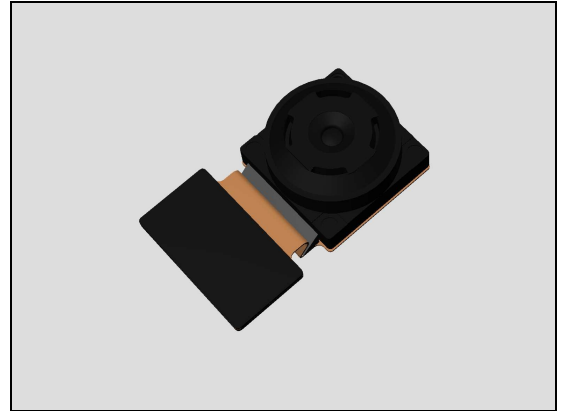
Prepare the new Part Chat Camera.

Carry out the Removal as described below!

Follow the 5.10 – 5.6 Reassembly instructions!

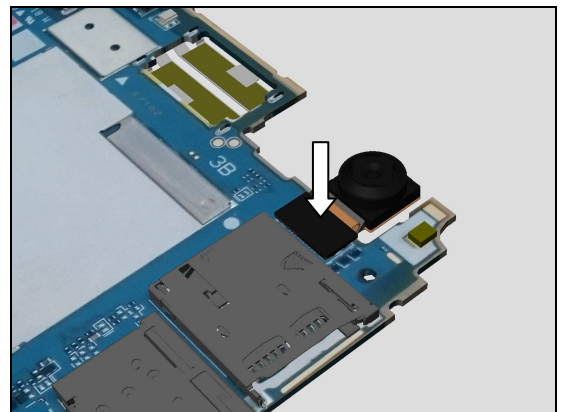
REMOVAL

Use Front Opening Tool to disconnect Chat Camera board-to-board (BtB) connector and remove Chat Camera



INSTALLATION

Attach Chat Camera BtB connector to Main PBA, press directly on top of connector using Nylon Pointer for 5sec to fully secure board-to-board (BtB) connector attachment!



Replacement

4.15 Conductive Adhesive 1

Follow the 3.1 – 3.9 Disassembly instructions!

Carry out the Removal as described below!

Prepare the new Part Conductive Adhesive 1.

Carry out the Removal as described below!

Follow the 5.9 – 5.1 Reassembly instructions!

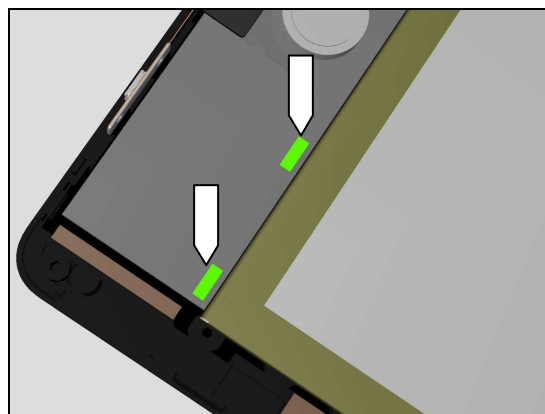
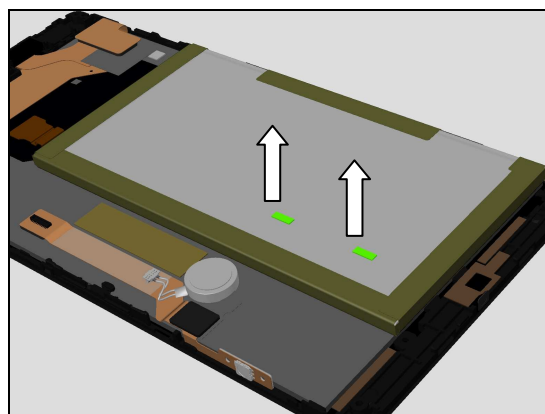
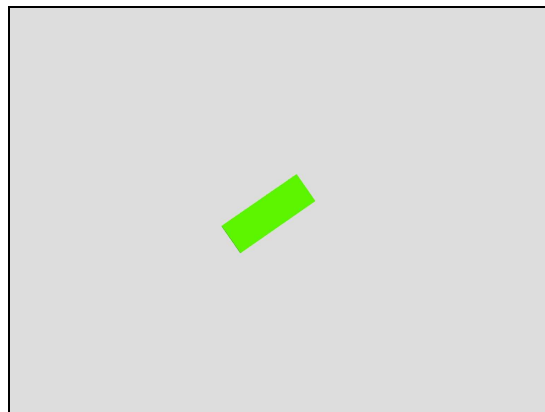
REMOVAL

Remove both Conductive Adhesive 1's, using Dentist Hook.

Scrap! Not to be reused!

INSTALLATION

Place new Conductive Adhesive 1 using Flex Film Assembly Tool onto its proper position.



Replacement

4.16 Conductive Adhesive 2

Follow the 3.1 – 3.9 Disassembly instructions!
Carry out the Removal as described below!
Prepare the new Part Conductive Adhesive 2.
Carry out the Removal as described below!
Follow the 5.9 – 5.1 Reassembly instructions!

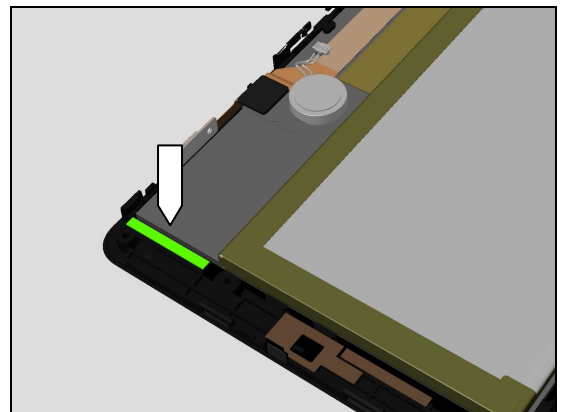
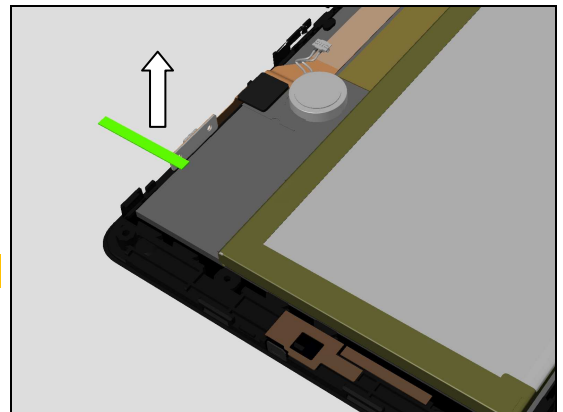
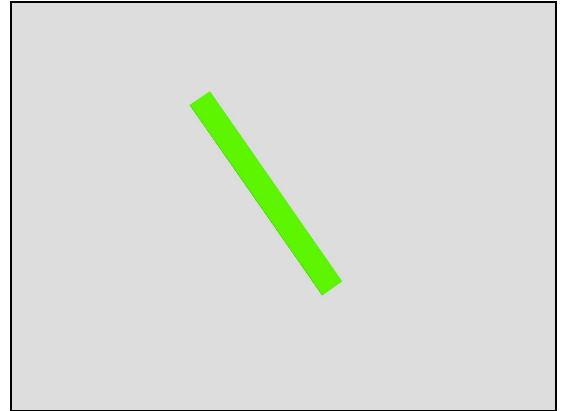
REMOVAL

Remove Conductive Adhesive 2 using Tweezers.

Scrap! Not to be reused!

INSTALLATION

Place new Conductive Adhesive 2 using Flex Film Assembly Tool onto its proper position.



Replacement

4.17 Conductive Adhesive 3

Follow the 3.1 – 3.9 Disassembly instructions!
Carry out the Removal as described below!
Prepare the new Part Conductive Adhesive 3.
Carry out the Removal as described below!
Follow the 5.9 – 5.1 Reassembly instructions!

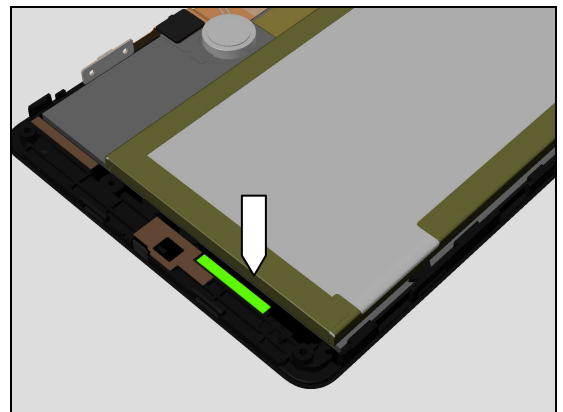
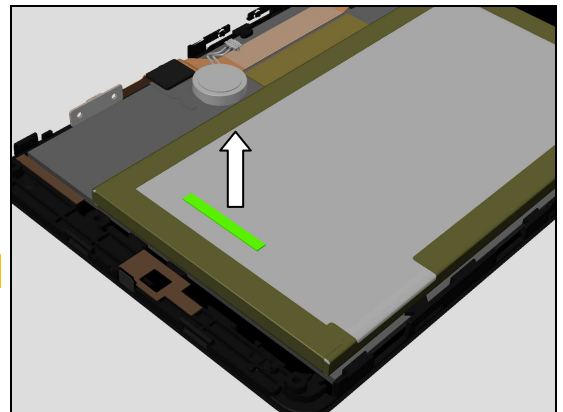
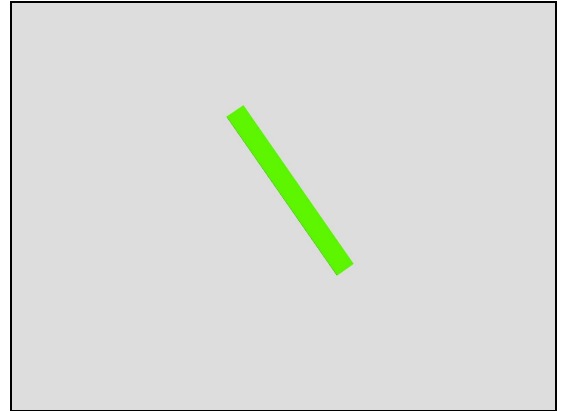
REMOVAL

Remove Conductive Adhesive 3 using Tweezers.

Scrap! Not to be reused!

INSTALLATION

Place new Conductive Adhesive 3 using Flex Film Assembly Tool onto its proper position.



Replacement

4.18 CU Label

Carry out the Removal as described below!
Carry out the Removal as described below!
Prepare the new Part CU Label.
Carry out the Removal as described below!
Carry out the Installation as described below!

REMOVAL

Open SIM-SD Cap, then pull out the CU Label Tray with fingers, gripping only top-sided label as shown in picture.

Caution: gripping bottom label can cause damage to CU Label Tray!

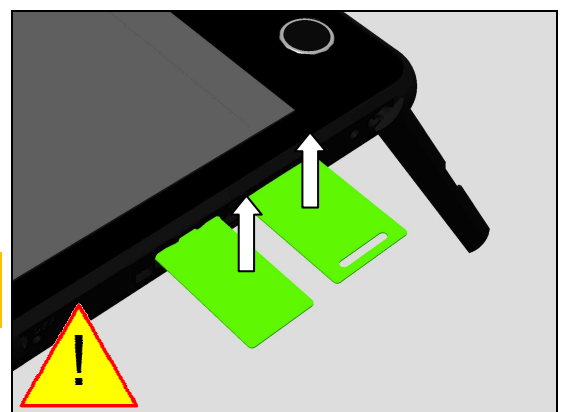
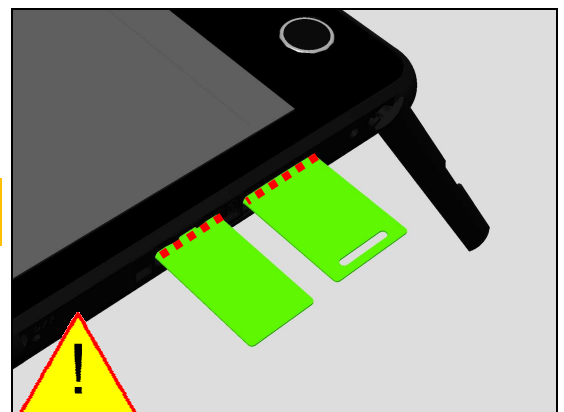
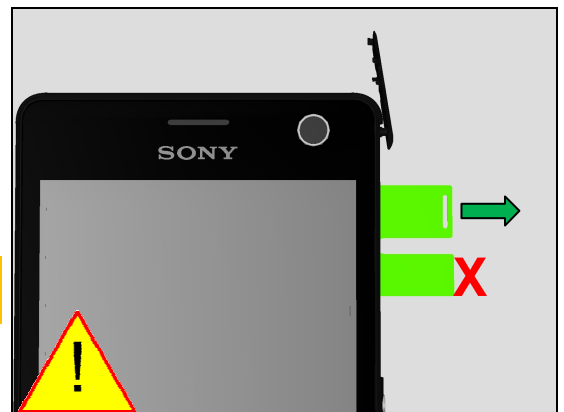
Caution: Do not pullout CU Label Tray further than indicated by red dotted line shown in picture!

Read the old CU Label and/or write the information into the 'Label Print Solution' program before removal.

Carefully remove the CU Label by using the Flex Film Assembly Tool and fingers from CU Label Tray.

Scrap! Not to be reused!

Be careful not to damage CU Label Tray!



Replacement: CU Label

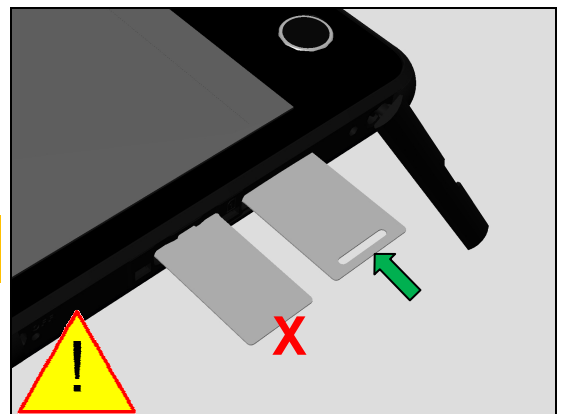
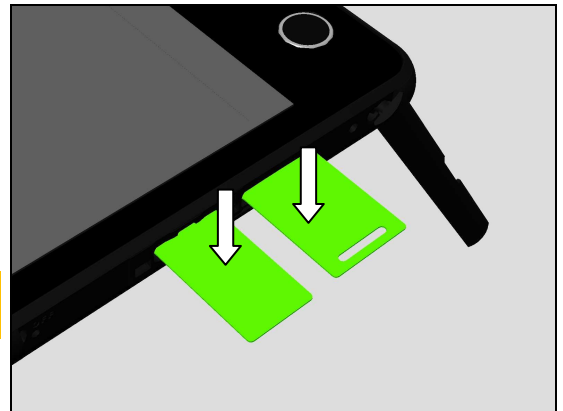
INSTALLATION

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 CU Label onto CU Label Tray in its proper position!

Insert CU Label Tray pushing only top-sided label as shown in picture, then close SIM-SD Cap.

Caution: gripping bottom label can cause damage to CU Label Tray!



Replacement

4.19 Liquid Intrusion Label

Follow the 3.1 Disassembly instruction!
Carry out the Removal as described below!
Prepare the new Part Liquid Intrusion Label.
Carry out the Installation as described below!
Follow the 5.10 Reassembly instructions!

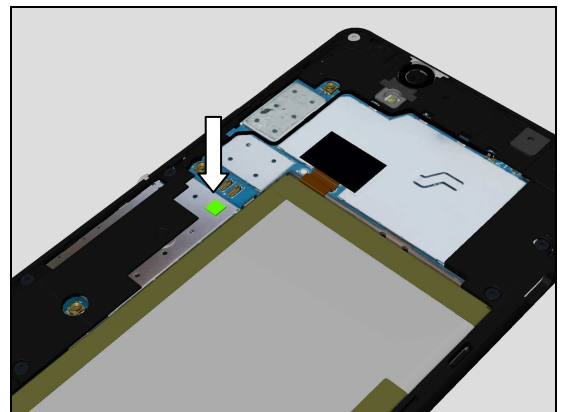
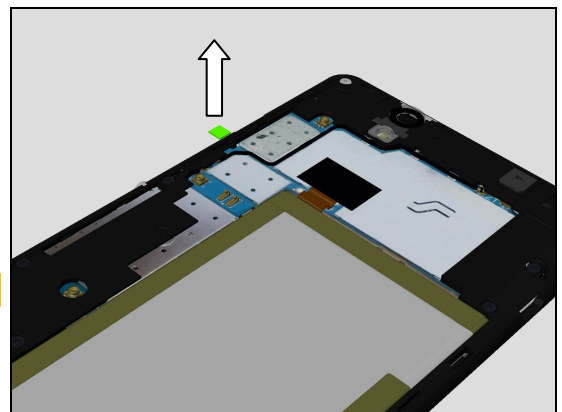
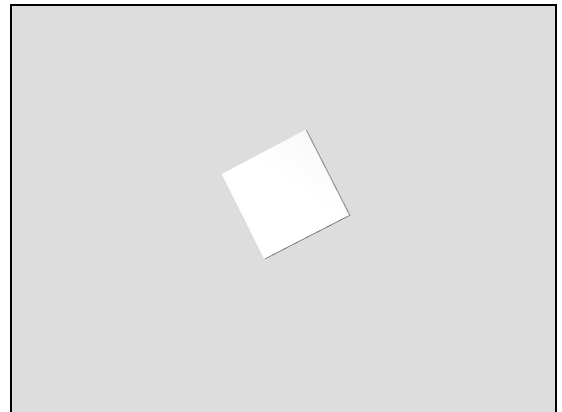
REMOVAL

Remove the Liquid Intrusion Label using Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place new Liquid Intrusion Label using Flex Film Assembly Tool onto Main PBA in its proper position.



Replacement

4.20 Loudspeaker & SPK Mesh Adhesive

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below!

Prepare the new Part Loudspeaker & SPK Mesh Adhesive.

Carry out the Removal as described below!

Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

1. Remove the Loudspeaker using Front Opening Tool

Scrap! Not to be reused!

2. Remove the SPK Mesh Adhesive using Flex Film Assembly Tool and then clean any remaining adhesive from Rear Cover Ass'y cavity.

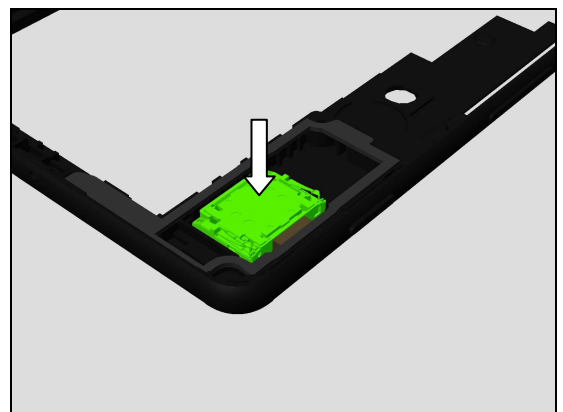
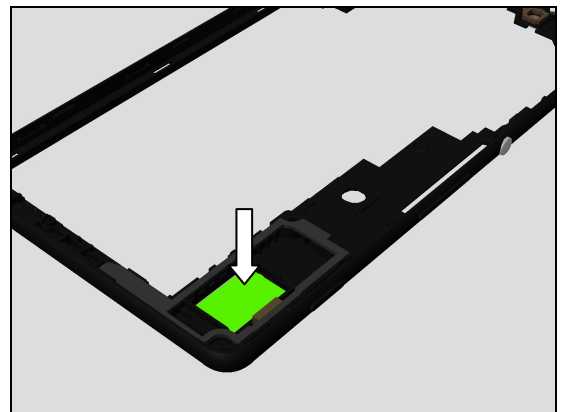
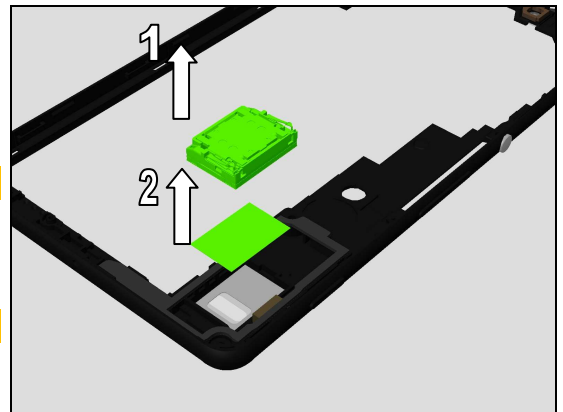
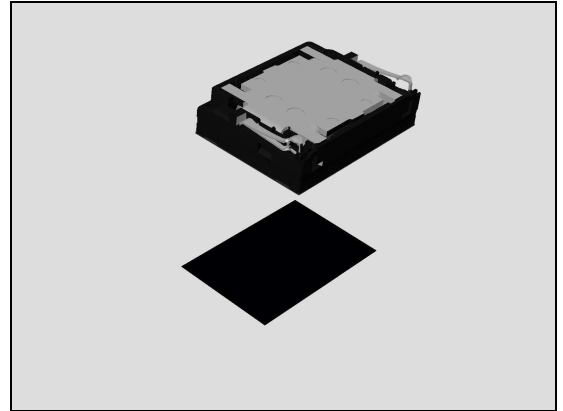
Scrap! Not to be reused!

INSTALLATION

Place new SPK Mesh Adhesive using Flex Film Assembly Tool into its proper position.

Place new Loudspeaker using fingers into its proper position.

Press directly on top of Loudspeaker using Nylon Pointer for five seconds to secure attachment.



Replacement

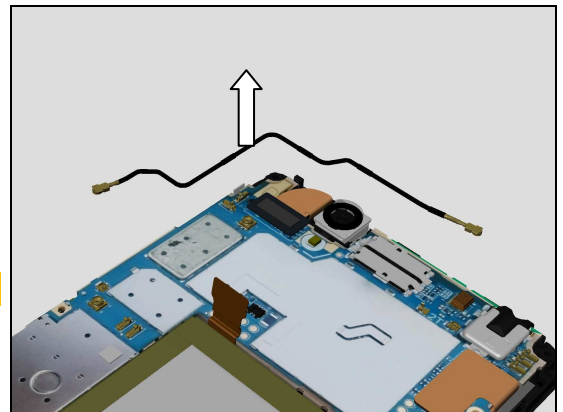
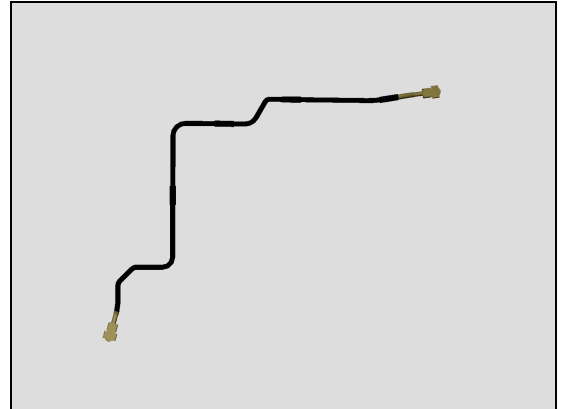
4.21 Low Loss Coaxial Cable

Follow the 3.1 – 3.4 Disassembly instructions!
Carry out the Removal as described below!
Prepare the new Part Low Loss Coaxial Cable.
Carry out the Removal as described below!
Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

Carefully detach Low Loss Coaxial Cable from Main PBA cavity using Front Open Tool and fingers.

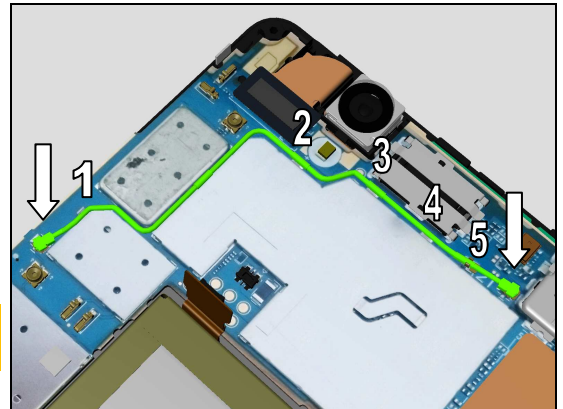
Scrap if damaged!



INSTALLATION

Place new Low Loss Coaxial Cable using fingers into its proper position aligning the cable rings to five conductive clips within Main PBA then use Nylon Pointer to secularly connect both ends of Low Loss Coaxial Cable connector as shown in picture.

Inspect Low Loss Coaxial Cable for any physical damage after assembly!



Replacement

4.22 Main Camera

Follow the 3.1 – 3.5 Disassembly instructions!

Carry out the Removal as described below!

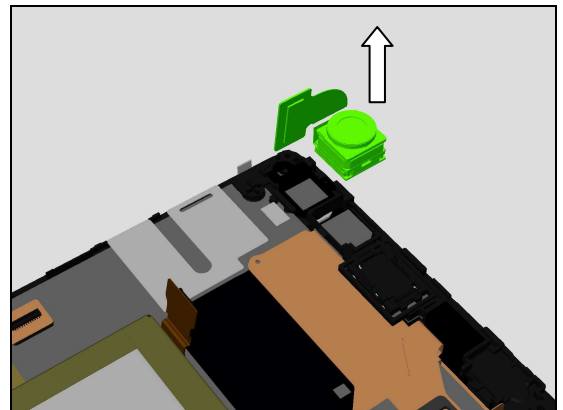
Prepare the new Part Main Camera.

Carry out the Removal as described below!

Follow the 5.6 – 5.10 Reassembly instructions!

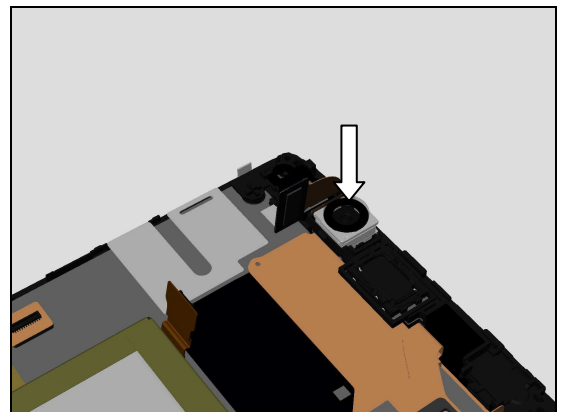
REMOVAL

Remove Camera Main using fingers gripping at the sides.



INSTALLATION

Place Main Camera into Front Ass'y cavity as shown in picture.



Replacement

4.23 Receiver & Receiver Carrier & Receiver Carrier Adhesive

Follow the 3.1 – 3.5 Disassembly instructions!

Carry out the Removal as described below!

Prepare the new Part Receiver & Receiver Carrier & Receiver Carrier Adhesive.

Carry out the Removal as described below!

Follow the 5.6 – 5.10 Reassembly instructions!

REMOVAL

1. Remove the Receiver & Receiver Carrier using Front Opening Tool
2. Remove the Receiver Carrier Adhesive using Flex Film Assembly Tool and then clean any remaining adhesive from Front Cover Ass'y cavity.

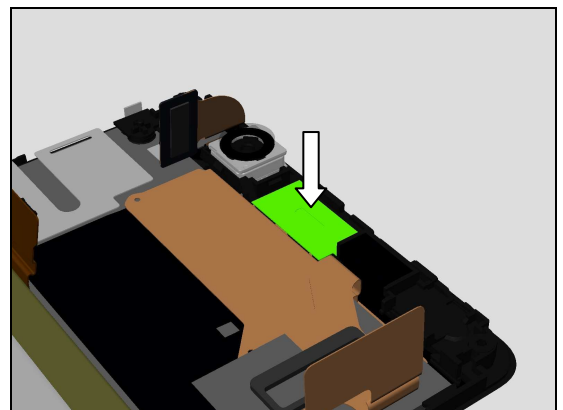
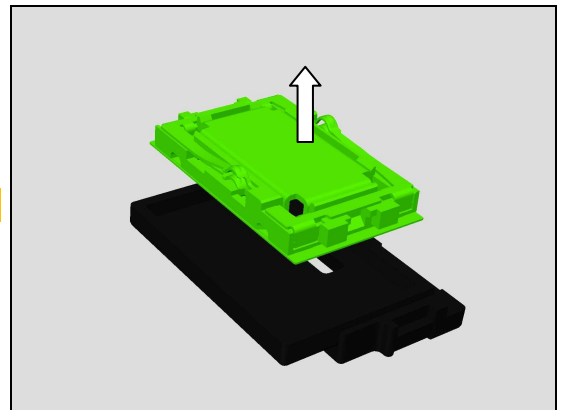
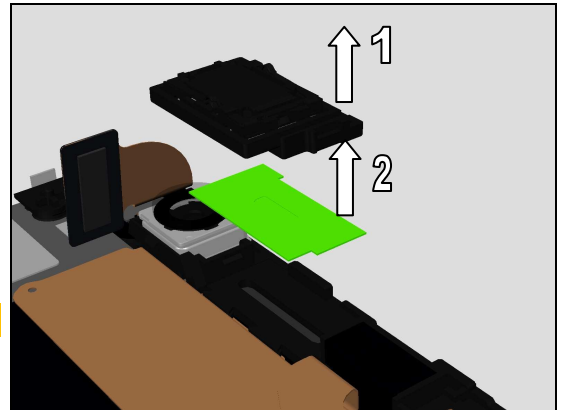
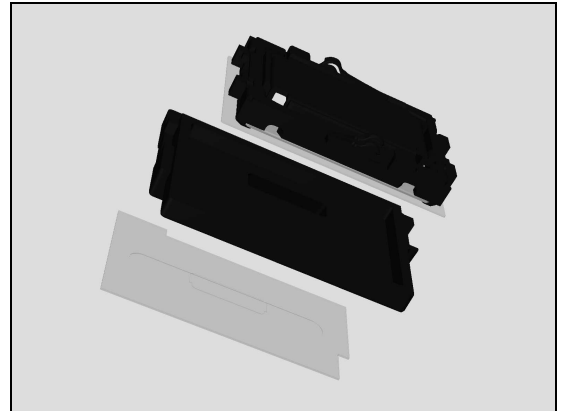
Scrap! Not to be reused!

Remove the Receiver from Receiver Carrier using Front Opening Tool.

Scrap! Receiver not to be reused!

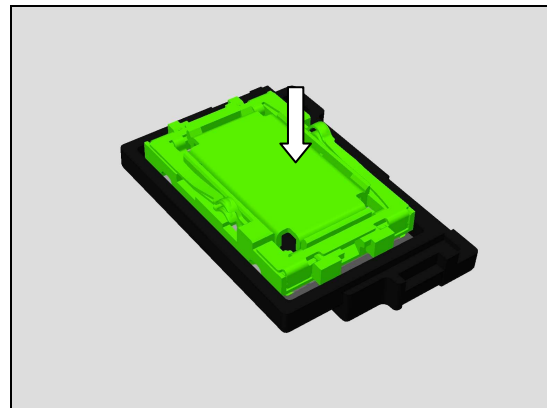
INSTALLATION

Place new Receiver Carrier Adhesive using Flex Film Assembly Tool into its proper position.



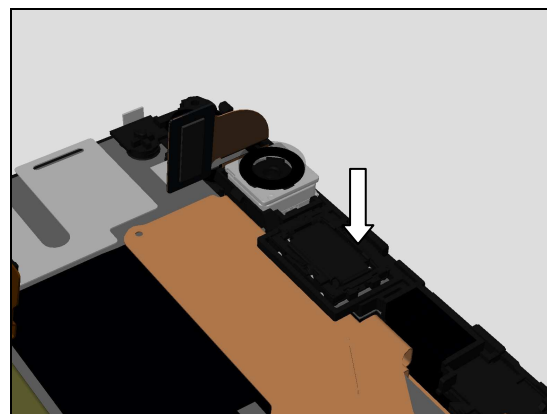
Replacement: Receiver & Receiver Carrier & Receiver Carrier Adhesive.

Place new Receiver into the cavity of Receiver Carrier using fingers as shown in picture.



Place new Receiver & Receiver Carrier using fingers into its proper position located on Front Cover Ass'y.

Press directly on top of Receiver & Receiver Carrier using Nylon Pointer for five seconds to secure attachment.



Replacement

4.24 SUB PBA Adhesive

Follow the 3.1 – 3.9 Disassembly instructions!
Carry out the Removal as described below!
Prepare the new Part SUB PBA Adhesive.
Carry out the Removal as described below!
Follow the 5.2 – 5.10 Reassembly instructions!

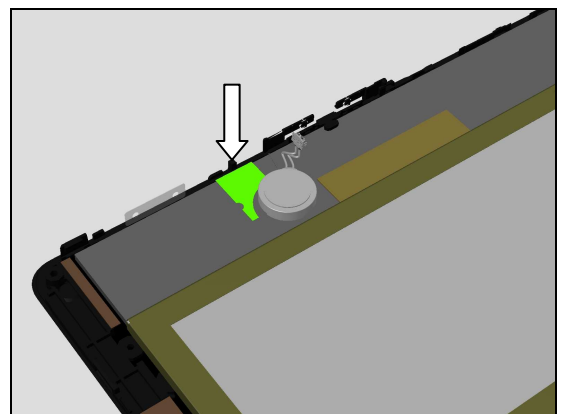
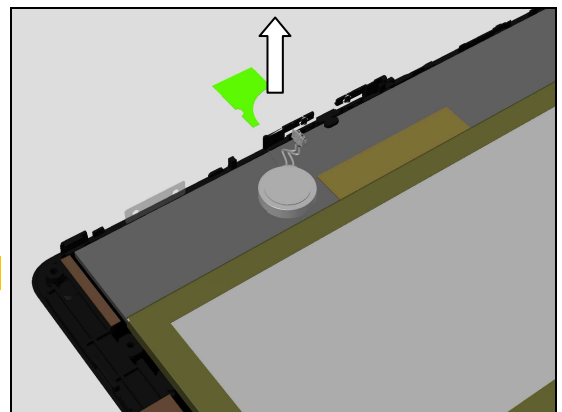
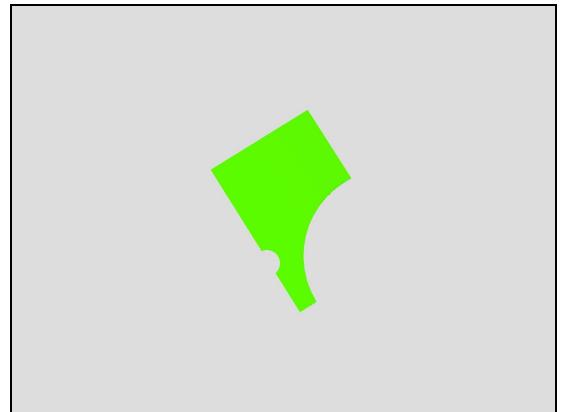
REMOVAL

Remove SUB PBA Adhesive using Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place new SUB PBA Adhesive using Flex Film Assembly Tool onto its proper position.



Replacement

4.25 TP ZIF Conn. Mylar

Follow the 3.X – 3.Y Disassembly instructions!

Carry out the Removal as described below!

Prepare the new Part TP ZIF Conn. Mylar.

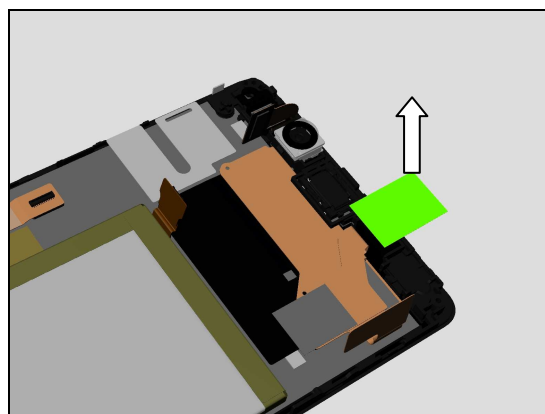
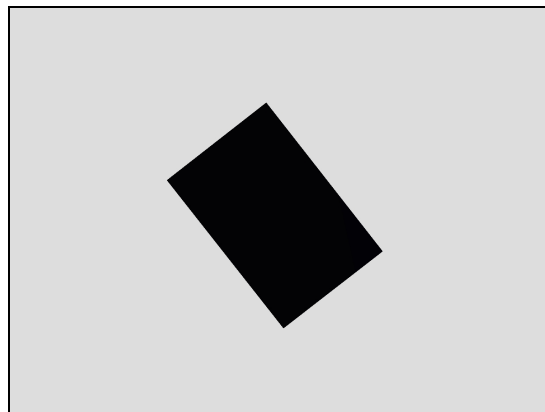
Carry out the Removal as described below!

Follow the 5.X – 5.Y Reassembly instructions!

REMOVAL

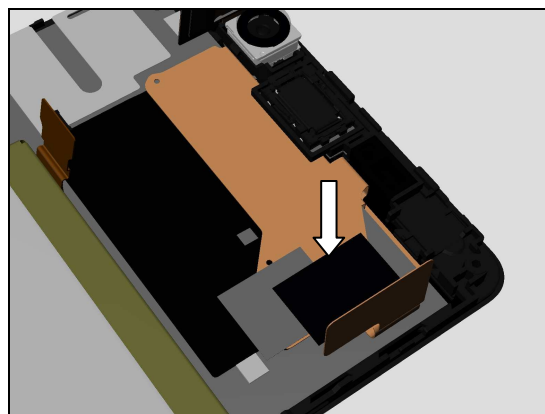
Remove TP ZIF Conn. Mylar using Flex Film Assembly Tool.

Scrap! Not to be reused!



INSTALLATION

Place new TP ZIF Conn. Mylar using Flex Film Assembly Tool onto its proper position.



Replacement

4.26 Vibrator & Vibrator Adhesive

Follow the 3.1 – 3.4 Disassembly instructions!

Carry out the Removal as described below!

Prepare the new Part Vibrator & Vibrator Adhesive.

Carry out the Removal as described below!

Follow the 5.7 – 5.10 Reassembly instructions!

REMOVAL

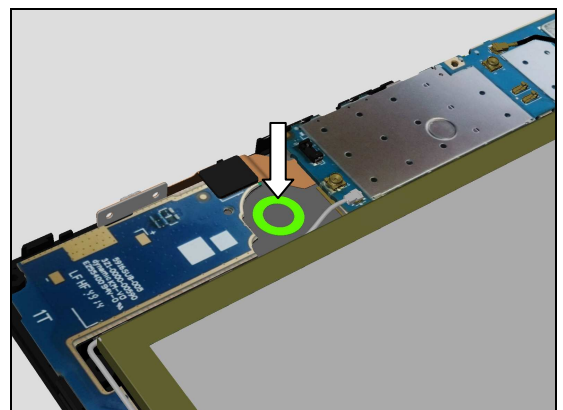
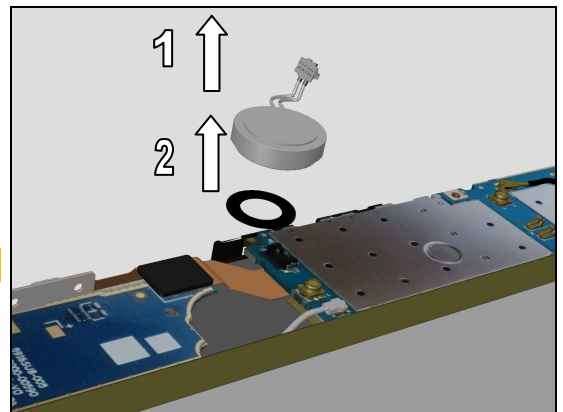
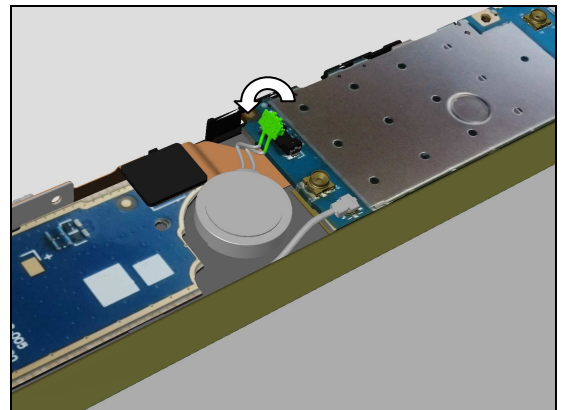
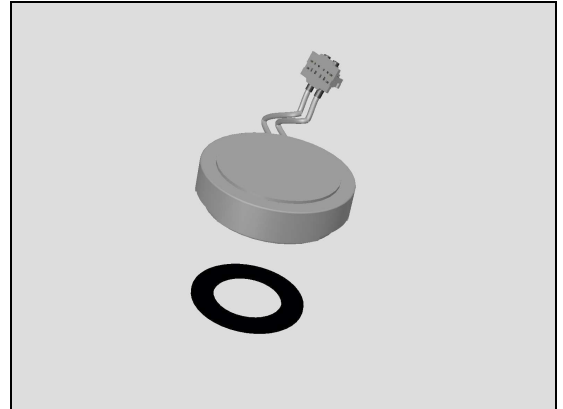
Use Front Opening Tool to disconnect Vibrator connector.

1. Remove the Vibrator using Front Opening Tool
2. Remove the Vibrator Adhesive using Flex Film Assembly Tool and then clean any remaining adhesive from Front Cover Ass'y cavity.

Scrap! Not to be reused!

INSTALLATION

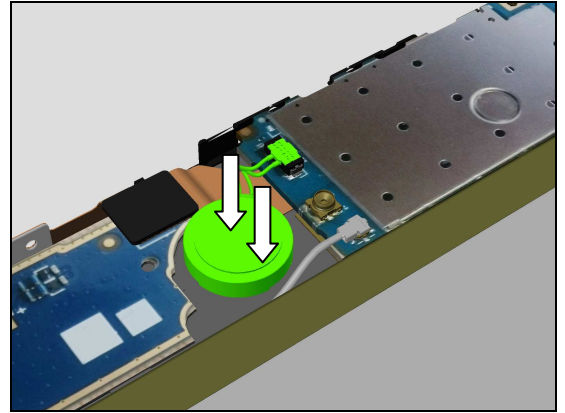
Place new Vibrator Adhesive using Flex Film Assembly Tool onto its proper position.



Replacement: Vibrator & Vibrator Adhesive

Place new Vibrator using fingers onto its proper position and then connect the Vibrator connector to Main PBA.

Press directly on top of Vibrator using Nylon Pointer for five seconds to secure attachment.



Replacement

4.27 Board Swap – Replacement

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.14 and 4.21 Removal instructions!

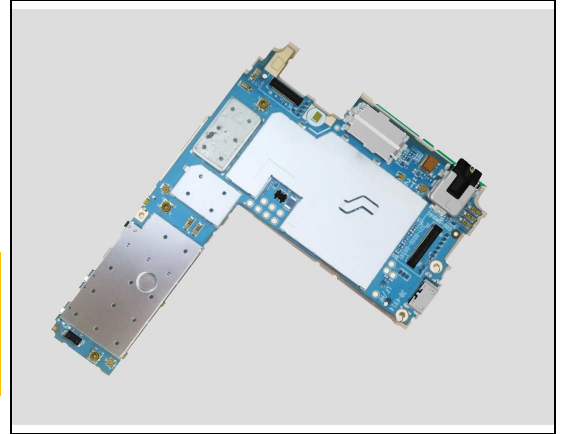
Replace the Swap Board.

Follow the 4.14, 4.19 and 4.21 Installation instructions! !

Follow the 5.4 – 5.6 Reassembly instructions!

Reuse the Chat Camera and Low Loss Coaxial Cable!

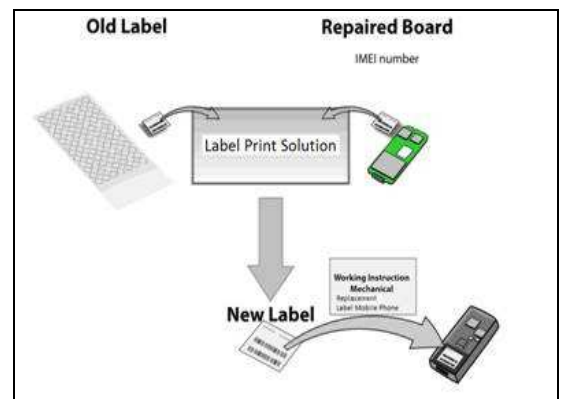
Please refer to: Trouble Shooting Application 1257-2706 for applicable E5303, E5333, E5353, E5343, E5306, & E5363 calibrations!



4.28 Board Swap – Change Label

CHANGE LABEL

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

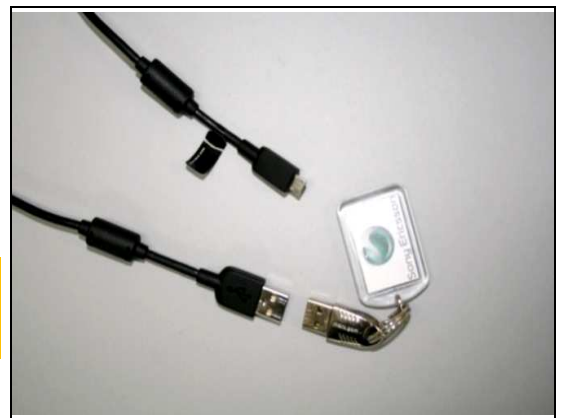


4.29 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

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

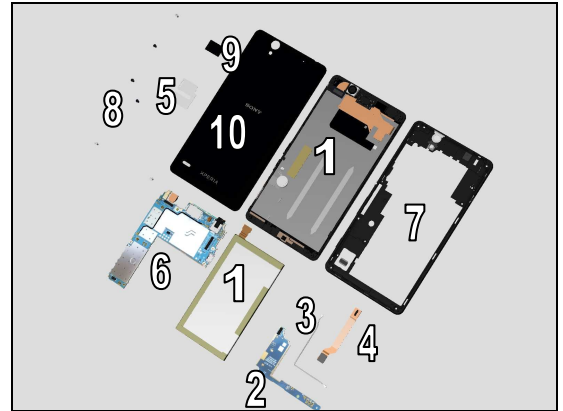
After SW Flash press the Key On/Off to power on the phone, place unit on flat desk and wait 4 minutes until system boot up has been completed!



5 Reassembly

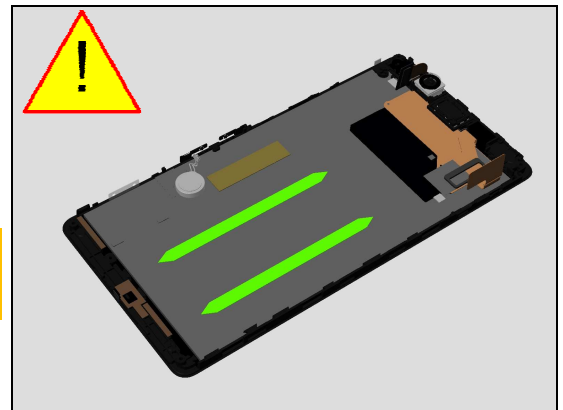
The reassembly is done in the following order:

1. Front Ass'y & Battery 2600mAh
2. SUB PBA
3. Coaxial Cable
4. Link FPC
5. CU Label Tray
6. Main PBA
7. Rear Cover Ass'y
8. Screws
9. Battery Conn Mylar
10. Battery Cover



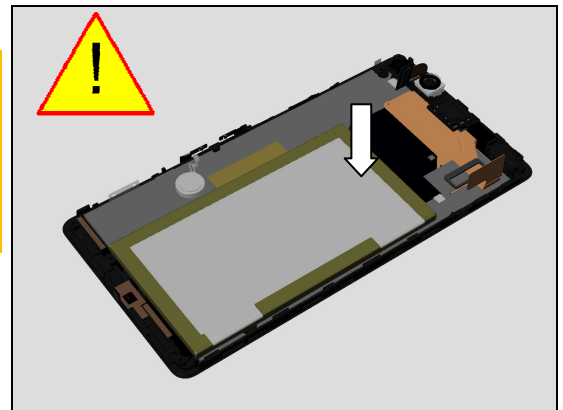
5.1 Front Cover Ass'y & Battery 2600mAh

Scrap! Battery Adhesive, not to be reused!
Follow the 4.13 removal and installation instructions to replace a new Battery Adhesive.



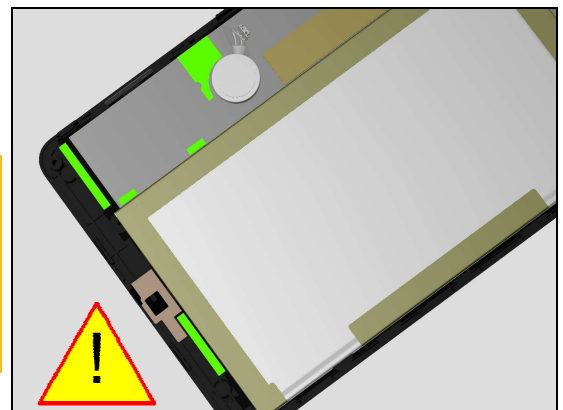
If reusing the Battery 2600mAh carefully inspect the Battery before assembly. Batteries with visual signs of being bent, having been punctured, bubbles etc. should be scraped after removal!
Follow chapter 4.11 replacement instructions to replace a new Battery 2600mAh!

Place the Battery 2600mAh in its proper position into the Front Cover Ass'y connector side first as shown in picture.



5.2 Sub PBA

Scrap! Conductive Adhesive 1, Conductive Adhesive2, Conductive Adhesive 3 and SUB PBA Adhesive, not to be reused!
Follow the 4.15, 4.16, 4.17 and 4.25 removal and installation instructions to replace a new parts Conductive Adhesive 1, Conductive Adhesive2, Conductive Adhesive 3 and SUB PBA Adhesive!



Place the Sub PBA onto its proper position and then press to secure its attachment.

5.3 Coaxial Cable

Carefully attach Coaxial Cable using fingers into its proper position aligning the cable rings to conductive clip on Sub PBA and cavities within Front Cover Ass'y.

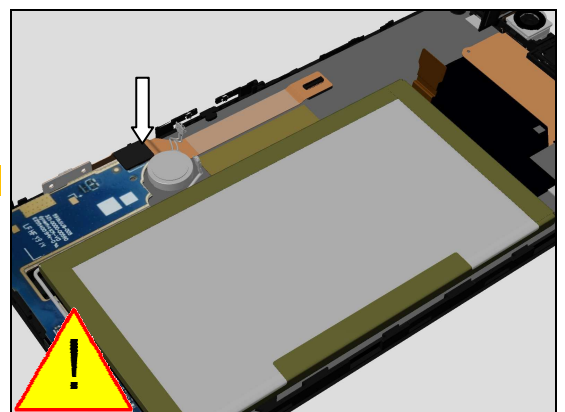
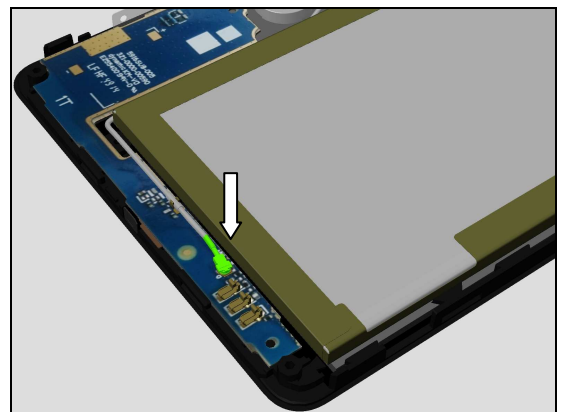
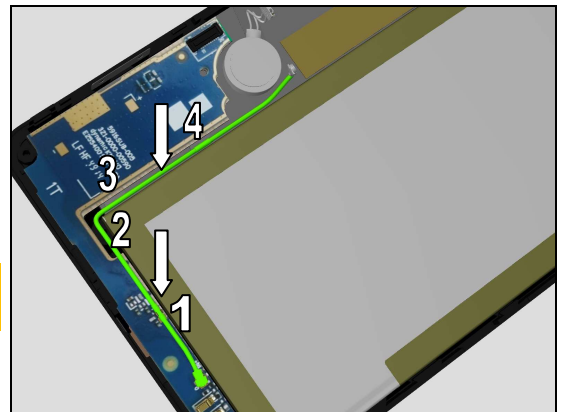
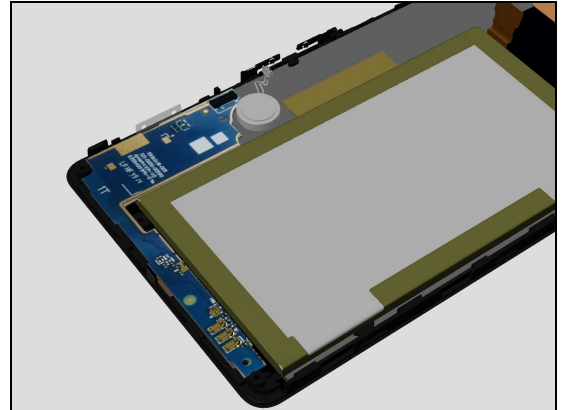
Inspect Coaxial Cable for any physical damage after assembly!

Use Nylon Pointer to securely connect Sub PBA end of Coaxial Cable connector as shown in picture.

5.4 Link FPC

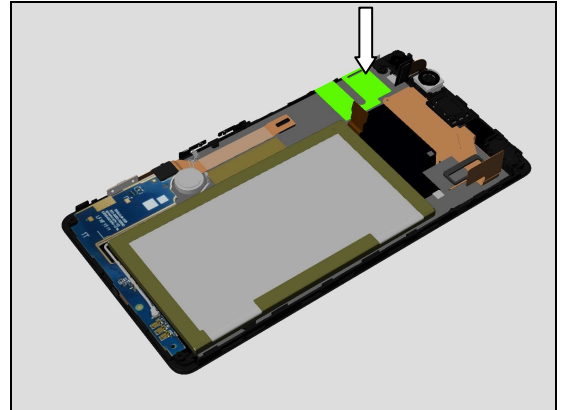
Scrap! Link FPC, not to be reused!

Place new Link FPC using fingers onto its proper position and then attach Link FPC BtB connector to Sub PBA, press directly on top of connector using Nylon Pointer for 5sec to fully secure board-to-board (BtB) connector attachment!



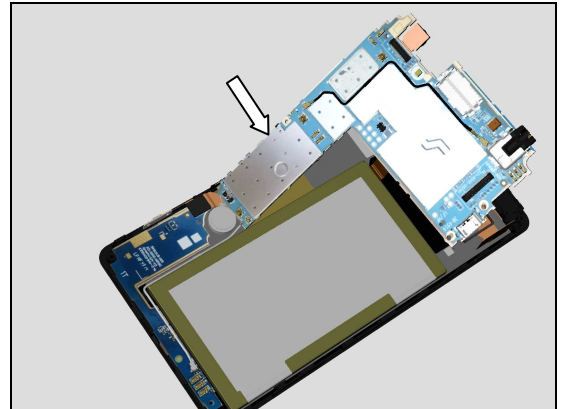
5.5 CU Label Tray

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

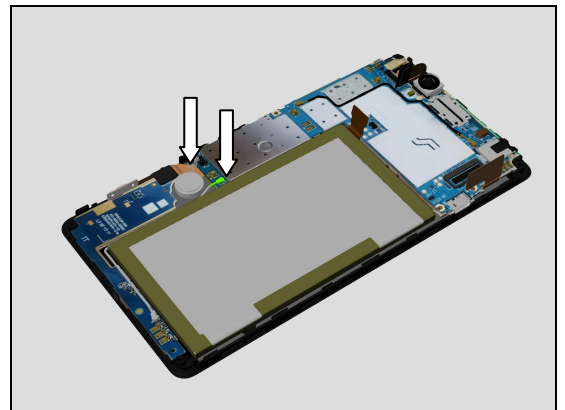


5.6 Main PBA

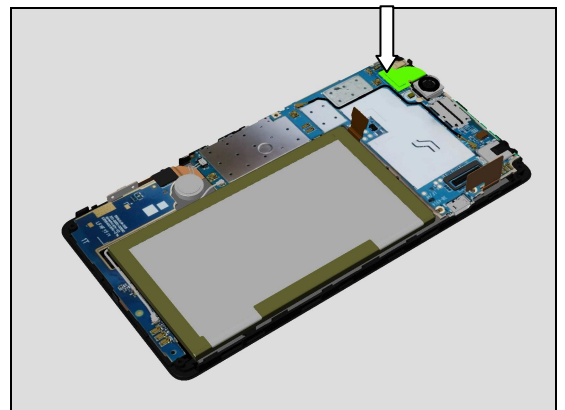
Peel off Adhesive tab from Link FPC then carefully bent upwards to Main PBA and attach board-to-board (BtB) using fingers and then lower Main PBA into position.



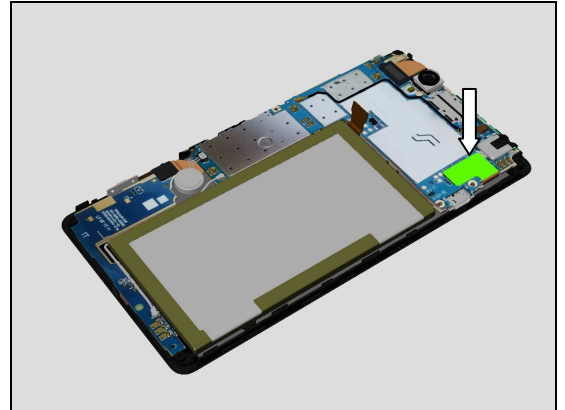
Attach Coaxial Cable and Vibrator connector, press directly on top of connector using Nylon Pointer for 5sec to fully secure both connectors attachment!



Attach Main camera BtB connector, press directly on top of connector using Nylon Pointer for 5sec to fully secure board-to-board (BtB) connector attachment!

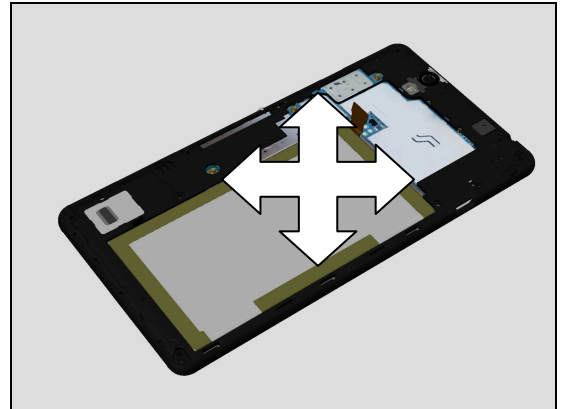


Attach LCM BtB connector, press directly on top of connector using Nylon Pointer for 5sec to fully secure board-to-board (BtB) connector attachment!



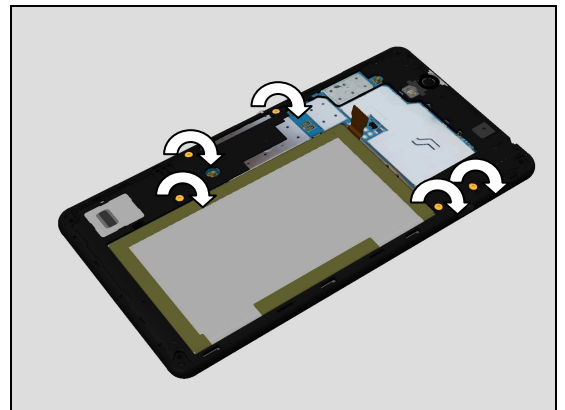
5.7 Rear Cover Ass'y

Attach Rear Cover Ass'y and then press down on all sides of Rear Cover Ass'y make it snap securely on to Front Cover Ass'y.

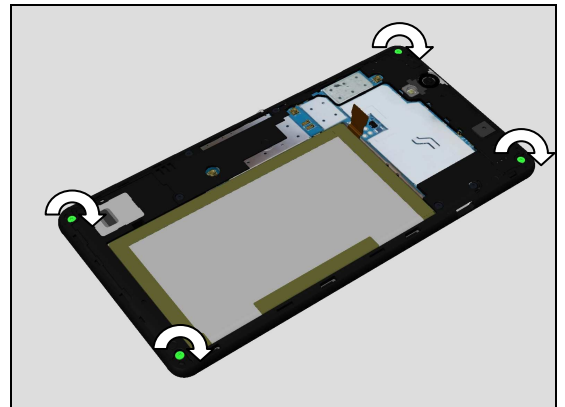


5.8 Screws

Apply 9 NCM torque when tightening all five Screw 1.6mm x 3mm_BLACK_T5 using T5 Torx Bit.



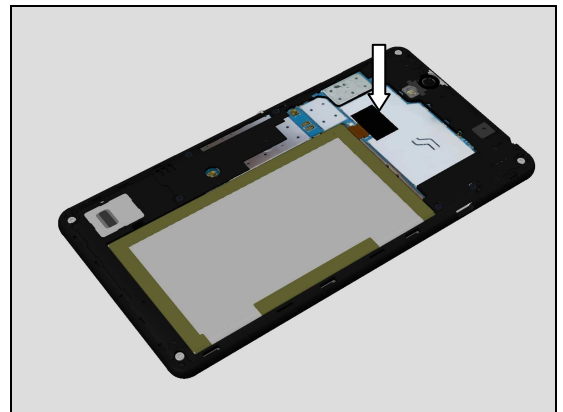
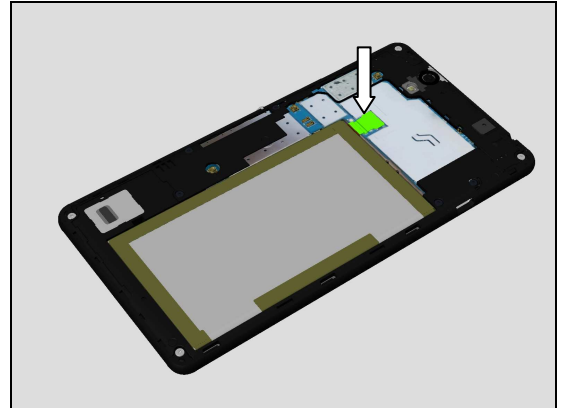
Apply 10 NCM torque when tightening all ten Screw 1.6mm x 4mm_SILVER_T5 using T5 Torx Bit.



5.9 Battery Conn Mylar

Attach Battery 2600mAh BtB connector, press directly on top of connector using Nylon Pointer for 5sec to fully secure board-to-board (BtB) connector attachment!

Place the Battery Conn Mylar onto its proper position as shown in picture.



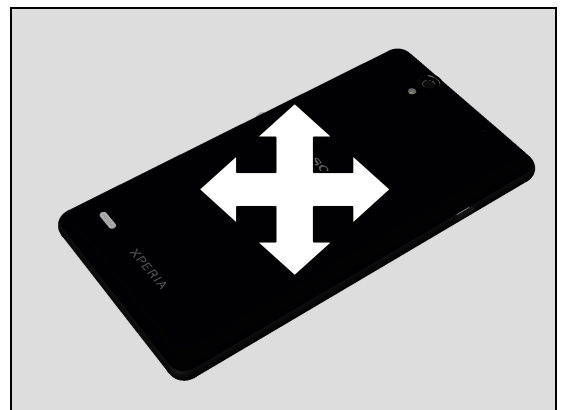
5.10 Battery Cover

Scrap! Battery Cover, not to be reused due to hook damage from disassembly!

Peel off Adhesives tabs underneath Battery Cover then hold Battery Cover at an angle and insert the hooks of the Battery Cover onto topside of Front Cover Ass'y cavity,

Then press down on topside and then press down on all sides of Battery Cover make it snap securely on to Front Cover Ass'y.

Lastly press down on all sides for 15 seconds to activate the Battery Cover adhesive to ensure secure attachment.



6 Revision History

Rev.	Date	Changes / Comments
1	2015-May-18	Released