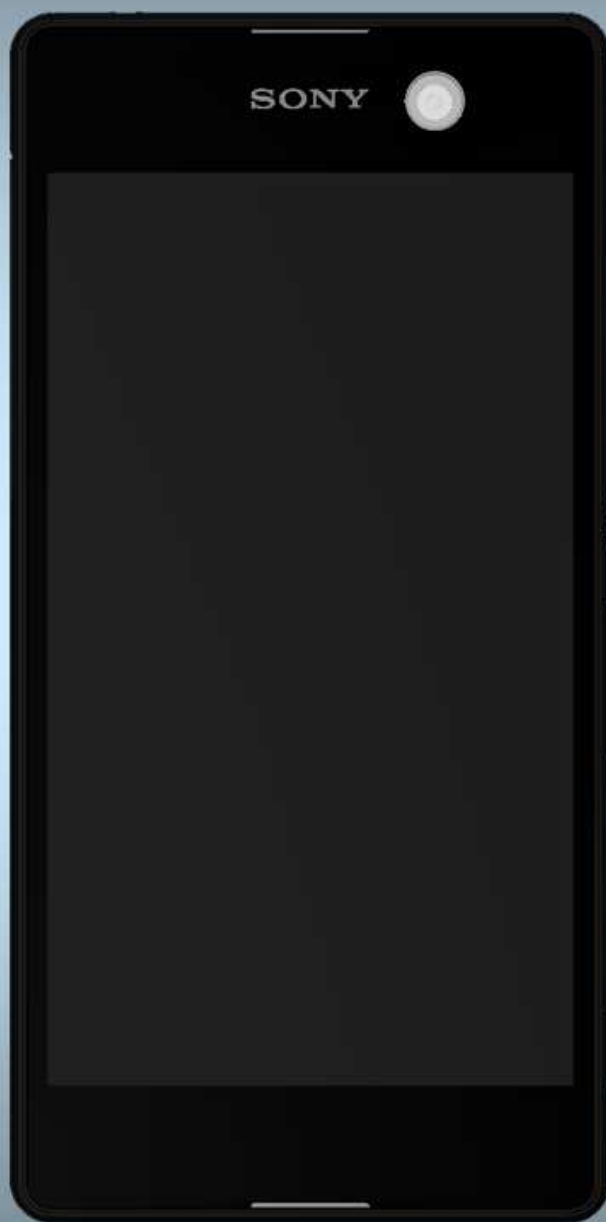


## Working Instructions

- mechanical -



*Xperia™ M5*

*E5603, E5606, E5633, E5643, E5653, E5663*

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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  
Conductive Tape Battery Connector is disassembled.**

**Always finally connect the Battery FPC BtB connector before the Conductive Tape Battery  
Connector is reassembled.**

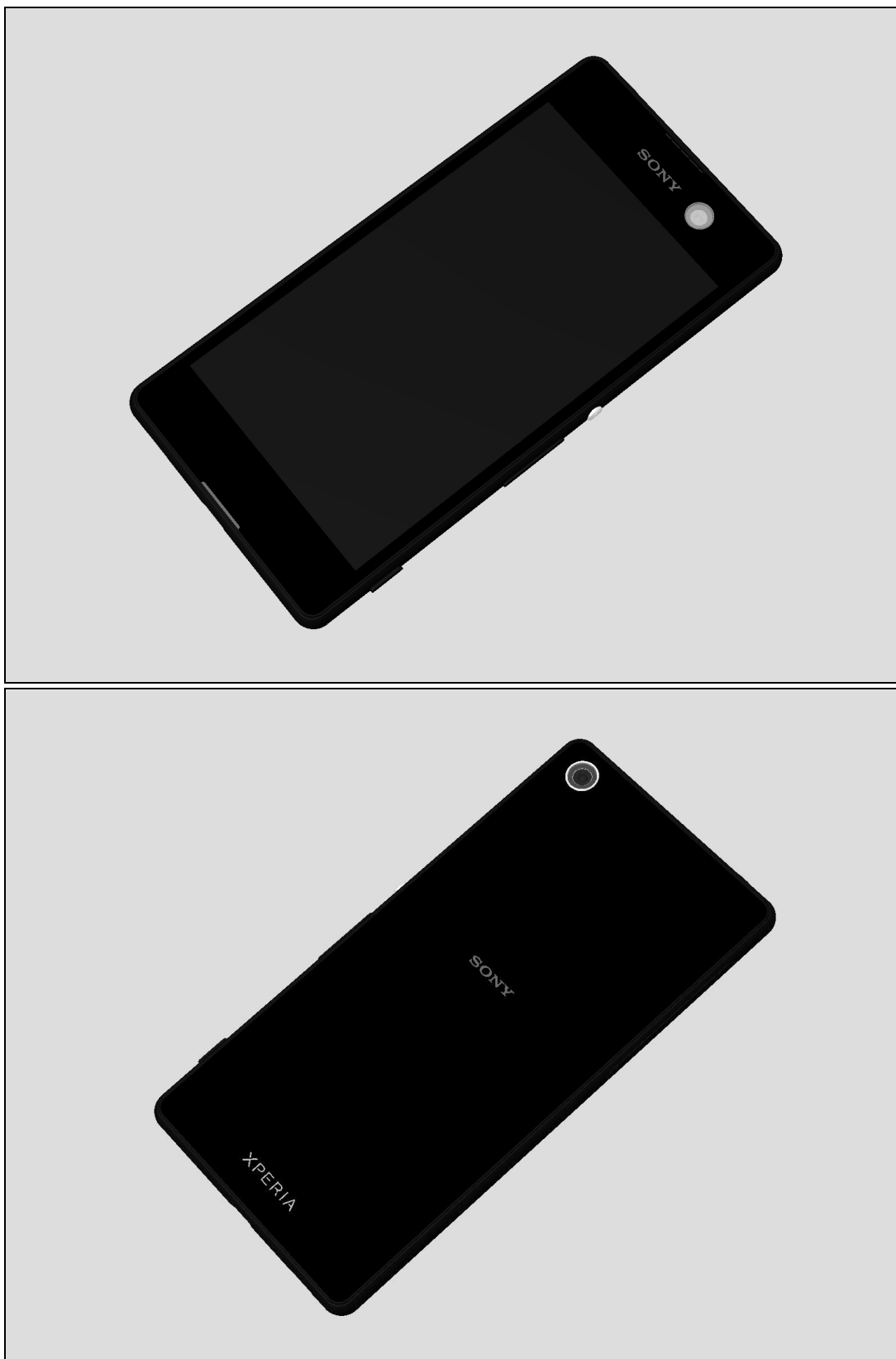
**If there are no special indications of 'E5603, E5606, E5633, E5643, E5653 or E5663', E5603, E5606,  
E5633, E5643, E5653 and E5663 share the same repair method as common sections, whose  
pictures are used with E5603.**

**Always Do not damage the Battery Assy and Do not damage the copper sheet attached on the  
top side of the Battery Assy and Do not damage the Battery Copper Sheet 1 when operation!**



## 1 Exterior Views

### 1.1 E5603/E5606/E5633/E5643/E5653/E5663



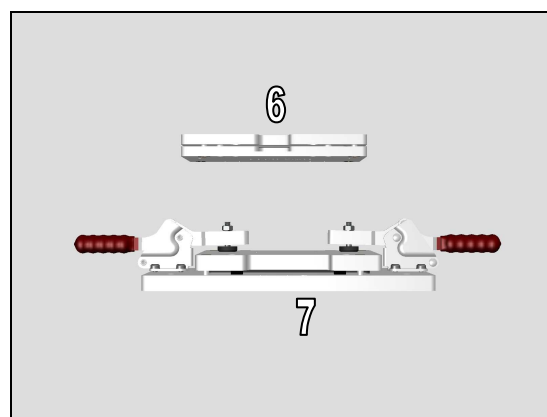
## 2 Tools

### SPECIAL TOOLS

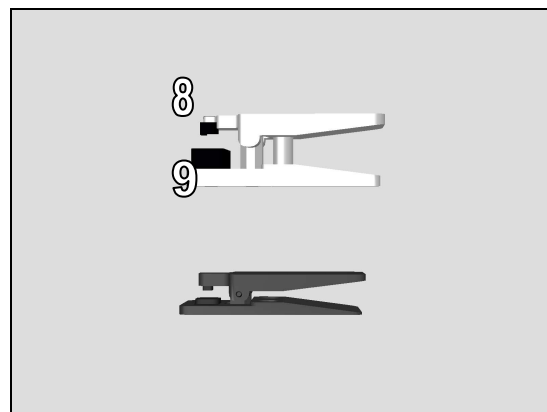
1. Torque Screwdriver
2. Flex Film Assembly Tool
3. Bits JCIS No.0
4. Bits T5
5. Front Opening Tool
6. Guitar Pick



6. Back Panel Adhesive Alignment Fixture
7. Back Panel Press



8. Audio Jack Press Clamp
9. Press Tool (for Earspeaker)



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

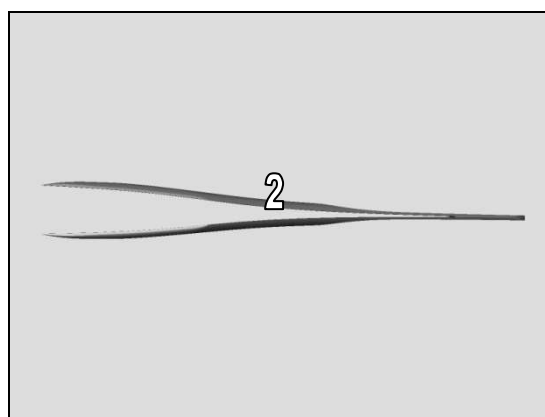
## Tools

### STANDARD TOOLS

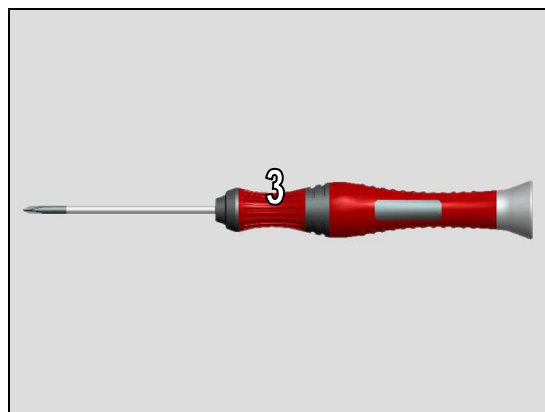
1. Pointed Plastic Tweezers



2. Blunt-tip Metal Tweezers



3. Cross Screwdriver



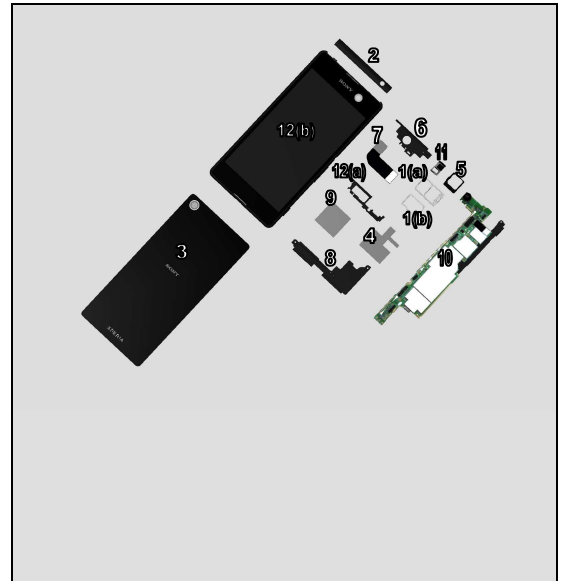
4. Suction cup



## 3 Disassembly

The E5603/E5606/E5633/E5643/E5653/E5663 disassembly is done in the following order:

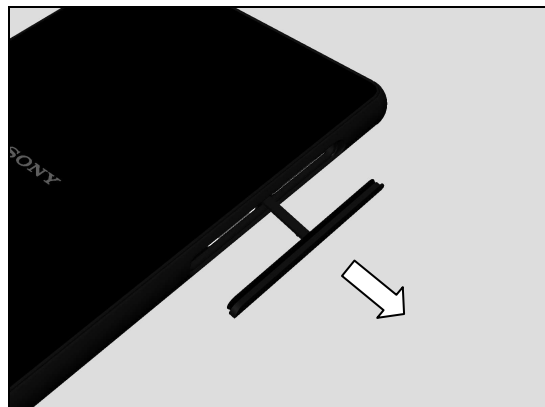
1. Tray Single SIM (E5603/E5606/E5653)/Tray Dual SIM (E5633/E5643/E5663) (a) and Tray SD (b)
2. Panel Deco Top
3. Back Panel
4. Conductive Tape Battery Connector
5. Main Camera Rubber
6. Holder Diversity Ant Assy
7. Chat Camera
8. Holder Speaker Main Ant Assy
9. Kapton Film LCM Connector
10. Main PBA and Holder GPS/WiFi Ant Assy
11. Second Mic Rubber
12. Holder Earspeaker (a) and Display Cover Assy (b)



## Disassembly

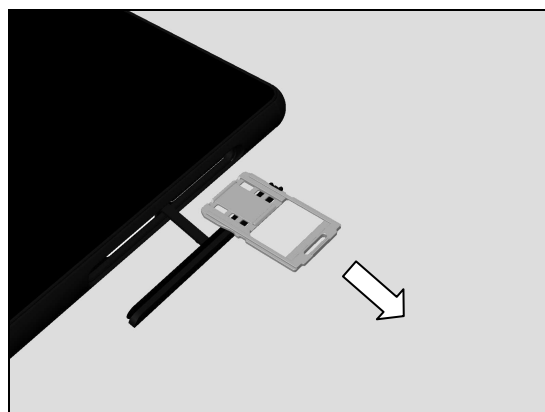
### 3.1 Tray Single SIM (E5603/E5606/E5653)/ Tray Dual SIM (E5633/E5643/E5663) and Tray SD

Open the Cap SIM/SD.



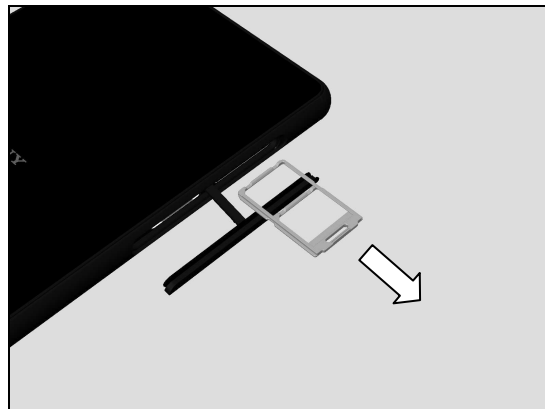
Remove the Tray Single SIM with fingers.

***This is only for E5603/E5606/E5653!***

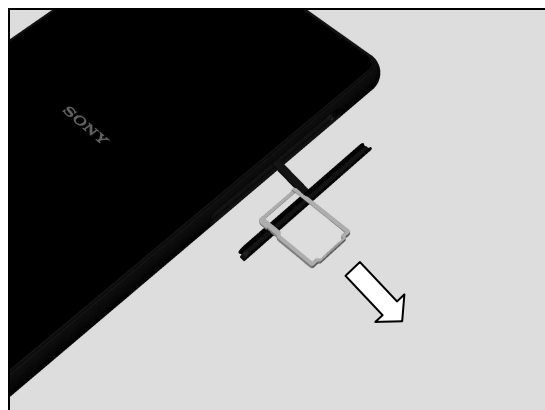


Remove the Tray Dual SIM with fingers.

***This is only for E5633/E5643/E5663!***

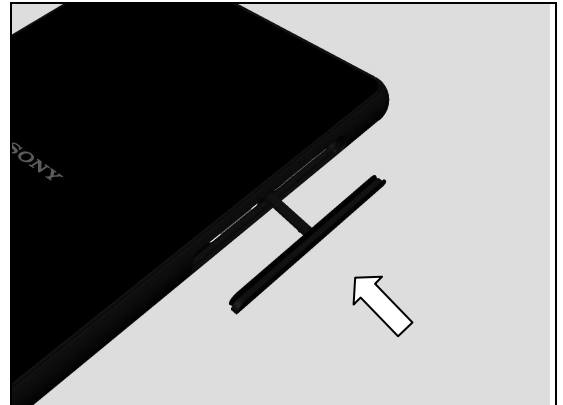


Remove the Tray SD with fingers.



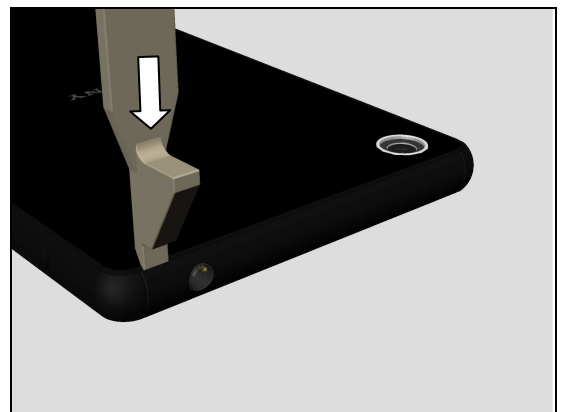
## Disassembly

Close the Cap SIM/SD.

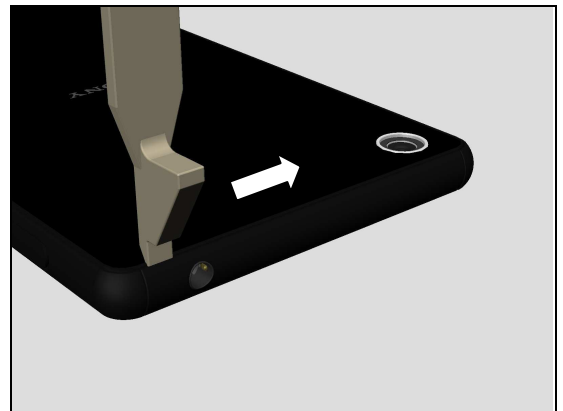


### 3.2 Panel Deco Top

Insert the Front Opening Tool between Panel Deco Top and Display Cover Assy.

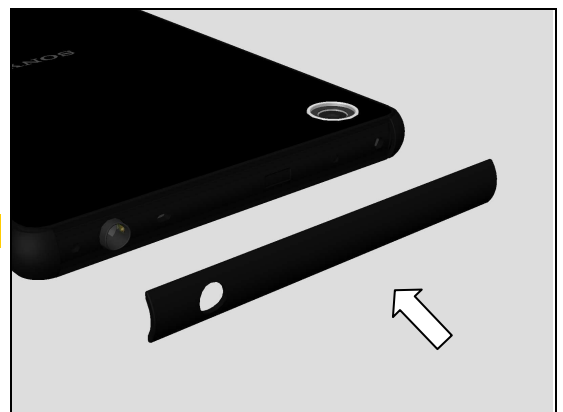


Slide to detach the Panel Deco Top.



Remove the Panel Deco Top.

**Scrap! Not to be reused!**



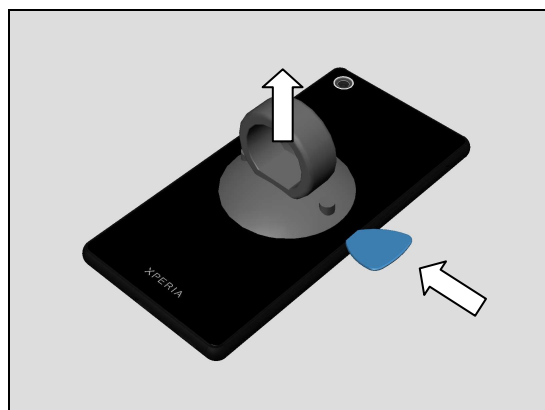
## Disassembly

### 3.3 Back Panel

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

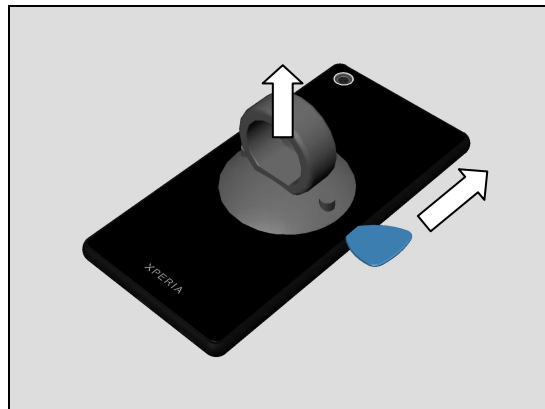


Insert the Guitar Pick.

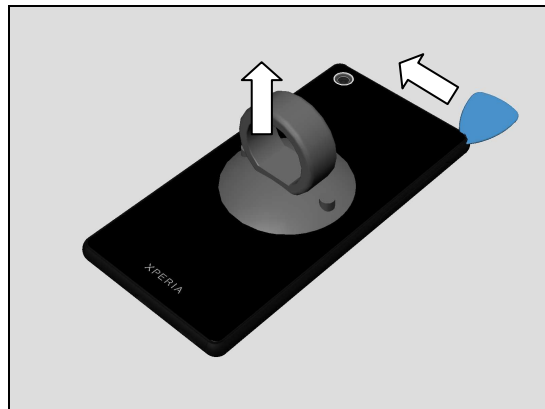


Gently slide the Guitar Pick along to release the sides of the Back Panel as shown in picture.

**Note! Start in the middle of the right long side!**



Slide this side.



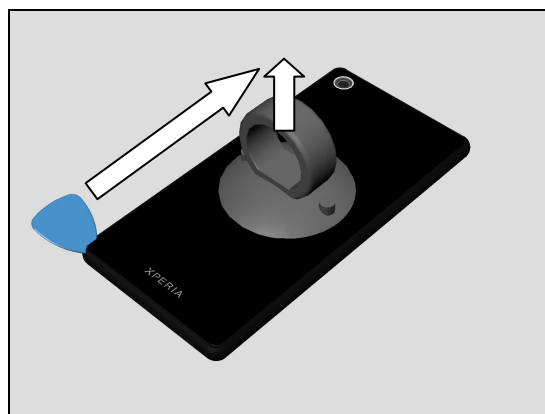
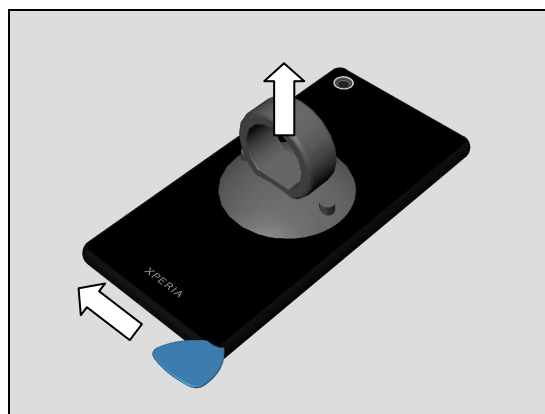
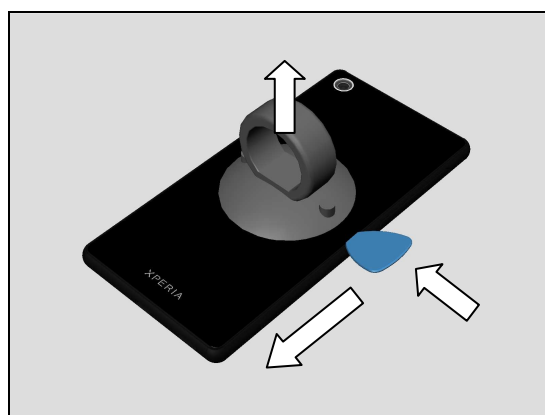
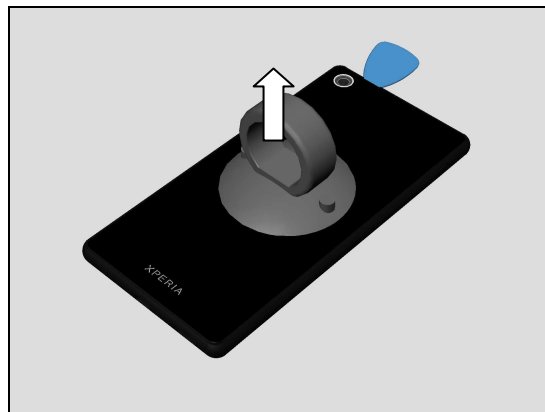
## Disassembly

**Note! Stop Sliding to this position for not to damage the main camera cushion on the Back Panel.**

Insert the Guitar Pick again and slide this side.

Slide this side.

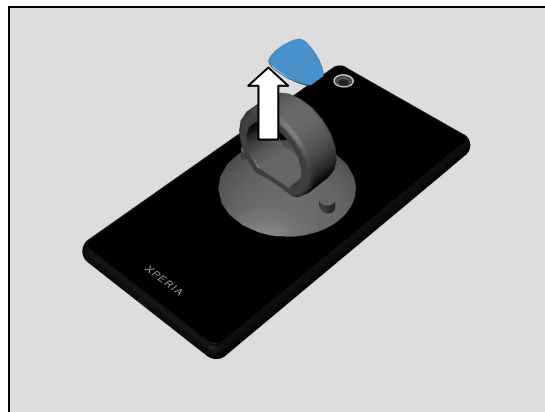
Slide this side.



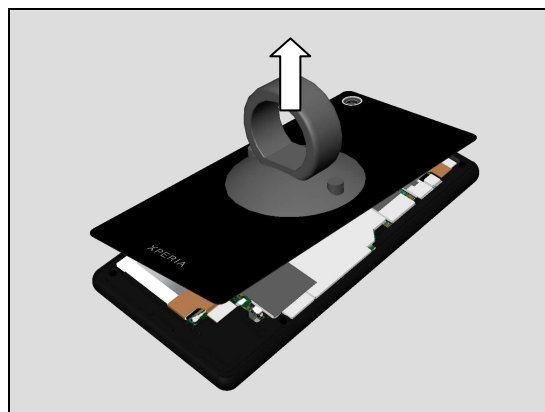


## Disassembly

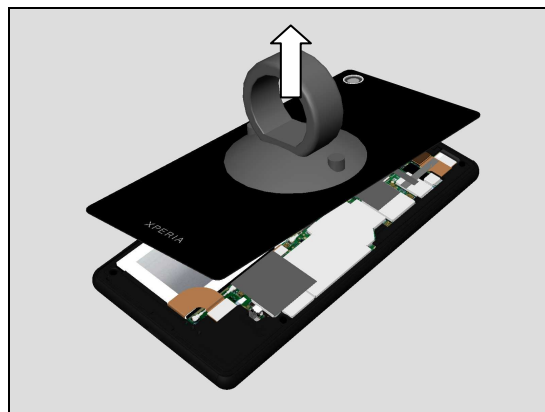
**Note! Stop Sliding to this position for not to damage the main camera cushion on the Back Panel.**



Detach the left top corner of the Back Panel.



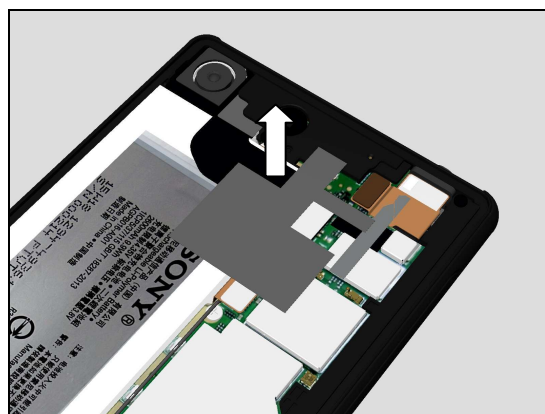
Remove the Back Panel.



### 3.4 Conductive Tape Battery Connector

Detach the Conductive Tape Battery Connector.

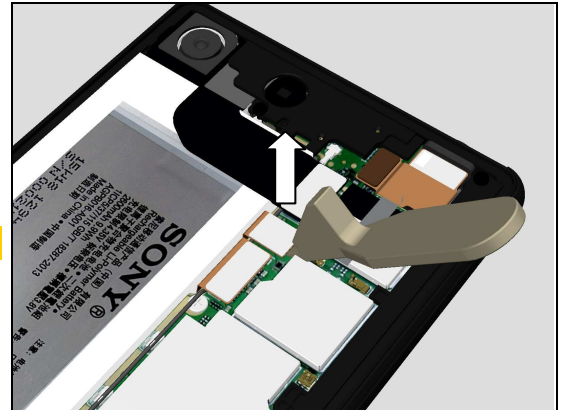
**Scrap! Not to be reused!**



## Disassembly

Disconnect the Battery connector by using the Front Opening Tool.

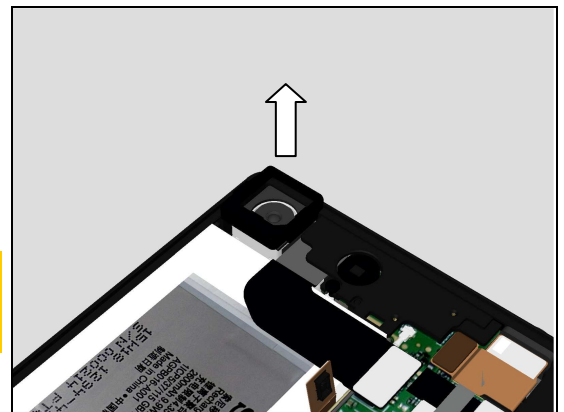
**Do not damage components on the Main PBA!**



### 3.5 Main Camera Rubber

Remove the Main Camera Rubber.

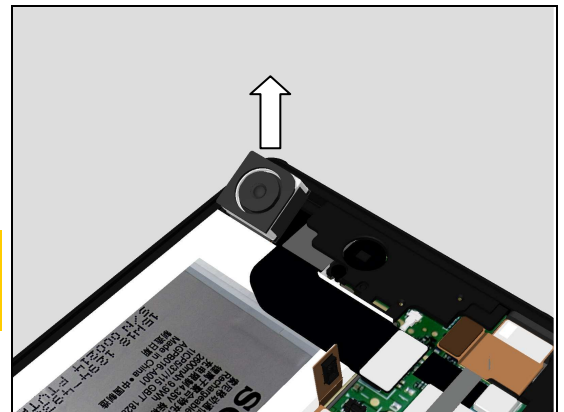
**Do not damage the Battery Assy and Do not damage the copper sheet attached on the top side of the Battery Assy!**



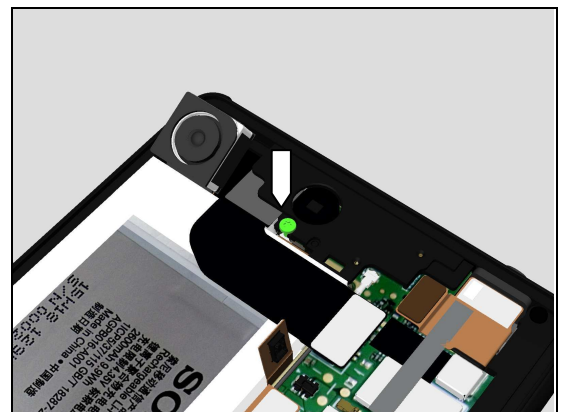
### 3.6 Holder Diversity Ant Assy

Rotate to lift the Main Camera.

**Do not damage the Battery Assy and Do not damage the copper sheet attached on the top side of the Battery Assy!**



Remove the Screw M1.2\_L3.5 by using a screwdriver with Bits T5.

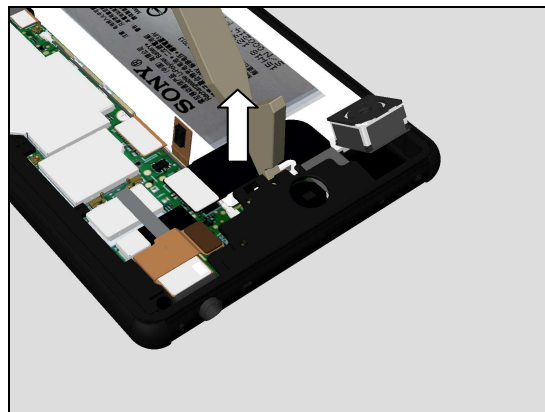


## Disassembly

Unsnap the hook of the Holder Diversity Ant Assy by using the Front Opening Tool.

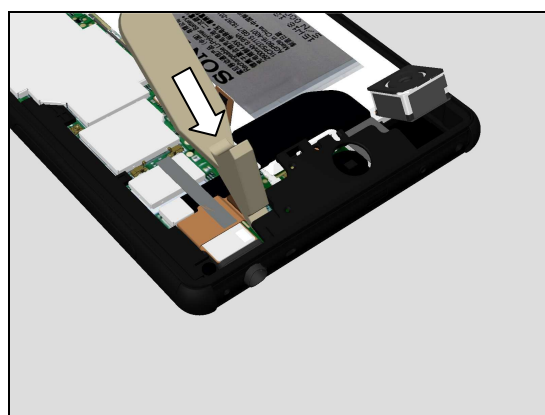
**Do not damage the Battery Assy and the components on the Main PBA!**

**Do not damage the copper sheet attached on the top side of the Battery Assy!**

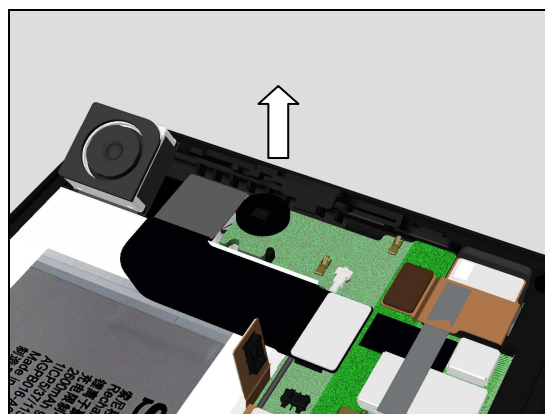


Detach the Holder Diversity Ant Assy from the Main PBA.

**Do not damage the components on the Main PBA!**

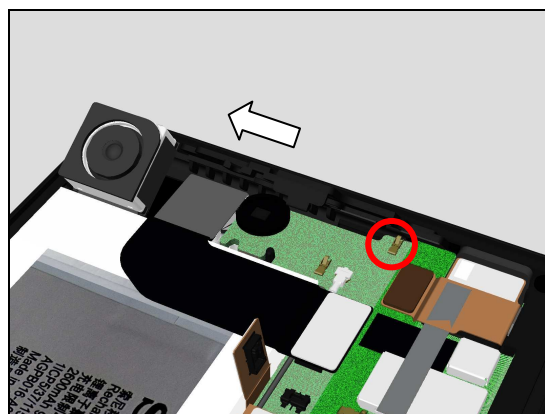


Lift the Holder Diversity Ant Assy.



Move the Holder Diversity Ant Assy a little as shown in picture.

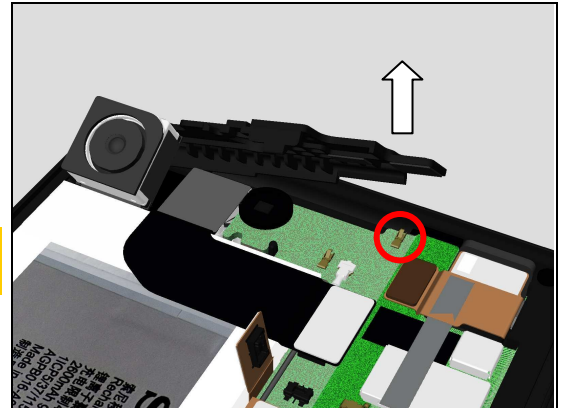
**Note! Do not damage the contact spring of the Diversity Antenna!**



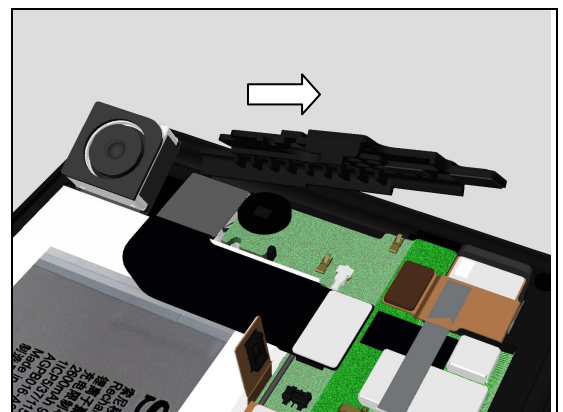
## Disassembly

Release this side of the Holder Diversity Ant Assy as shown in picture.

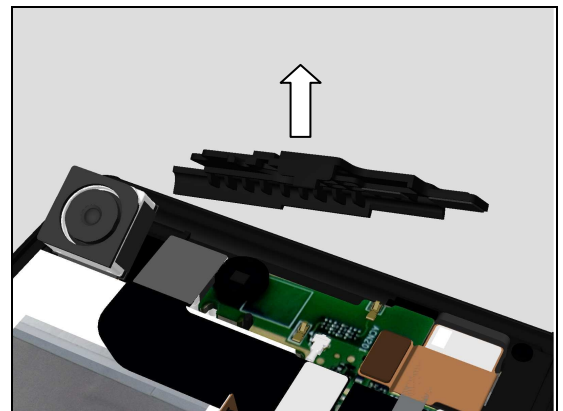
**Note! Do not damage the contact spring of the Diversity Antenna!**



Release the other side of the Holder Diversity Ant Assy as shown in picture.



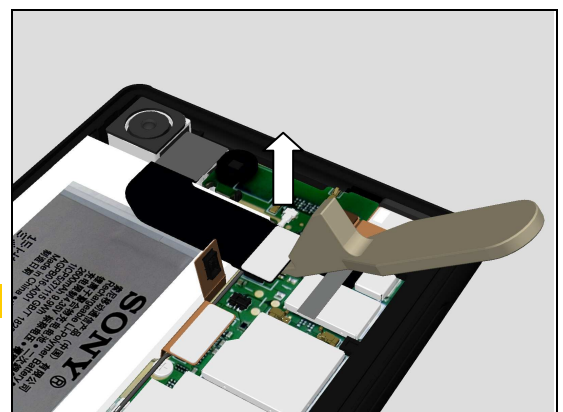
Remove the Holder Diversity Ant Assy.



### 3.7 Chat Camera

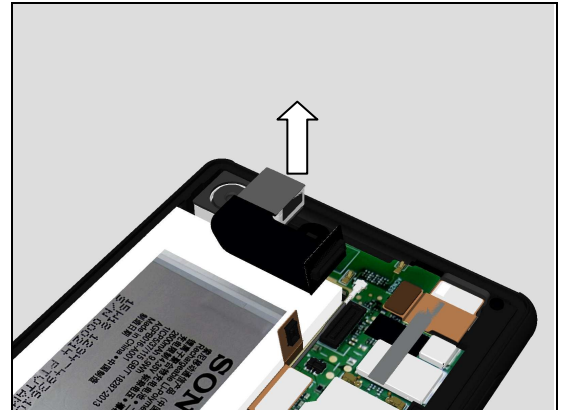
Disconnect the Chat Camera connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**



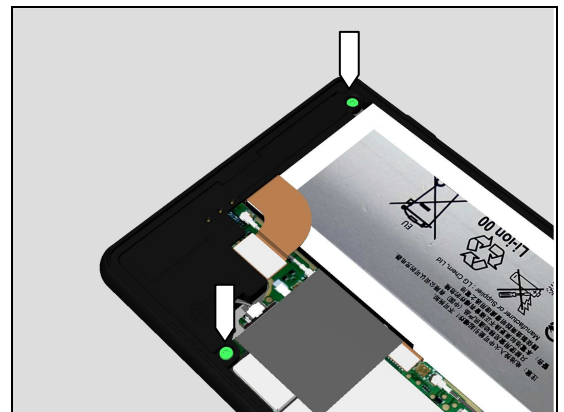
## Disassembly

Remove the Chat Camera.

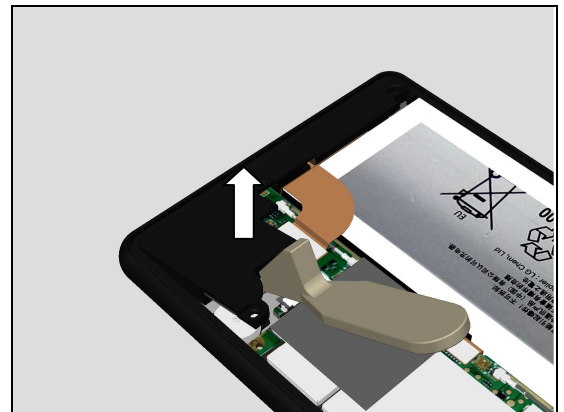


### 3.8 Holder Speaker Main Ant Assy

Remove the two Screw M1.2\_L3.5 by using a screwdriver with Bits T5.

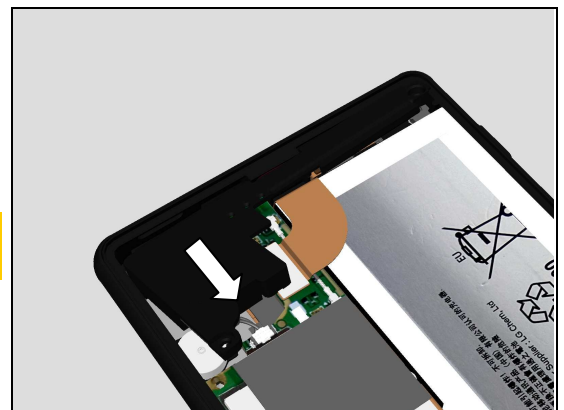


Lift the Holder Speaker Main Ant Assy by the Front Opening Tool as shown in picture.



Slowly move the Holder Speaker Main Ant Assy a little to detach it from the Display Cover Assy.

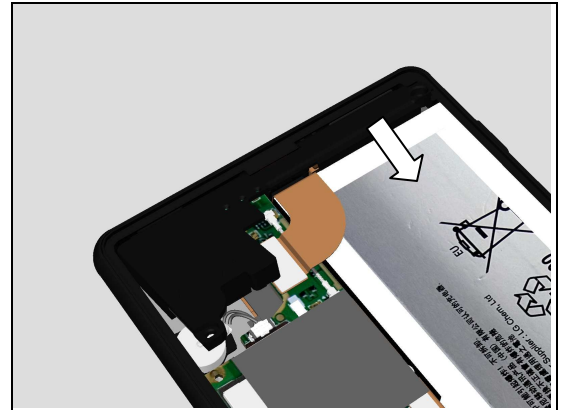
**Do not move the Holder Speaker Main Ant Assy too much!**



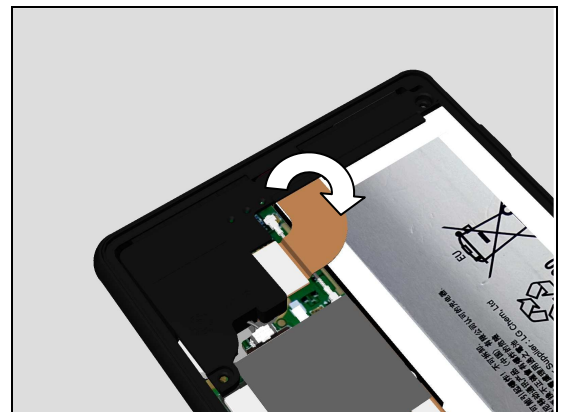


## Disassembly

Slowly move the other side of the Holder Speaker Main Ant Assy a little as shown in picture.

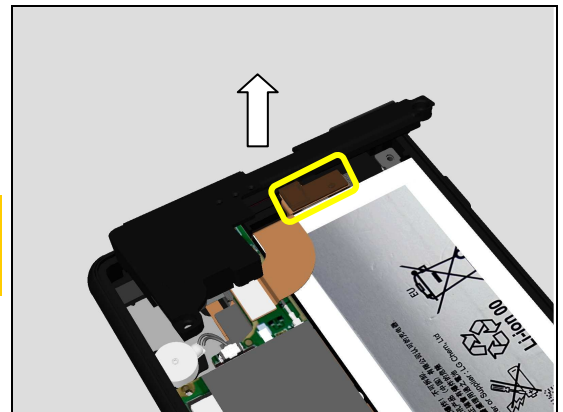


Rotate the Holder Speaker Main Ant Assy a little to get proper release angle as shown in picture.



Release the Holder Speaker Main Ant Assy as shown in picture.

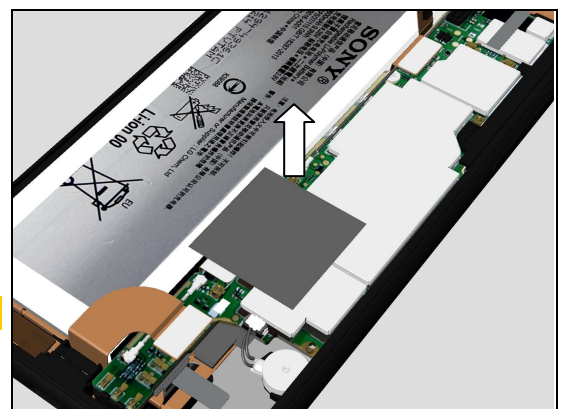
**Do not detach the USB FPC Assy from the Main Mic Rubber since it is WRT purpose! If detached, replace new Adhesive Main Mic and new Main Mic Rubber.**



### 3.9 Kapton Film LCM Connector

Detach the Kapton Film LCM Connector.

**Scrap! Not to be reused!**

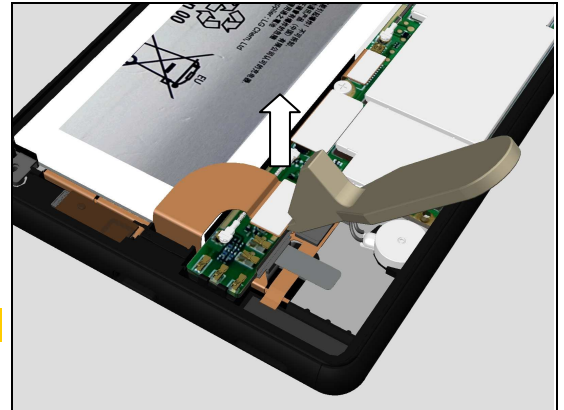


## Disassembly

### 3.10 Main PBA and Holder GPS/WiFi Ant Assy

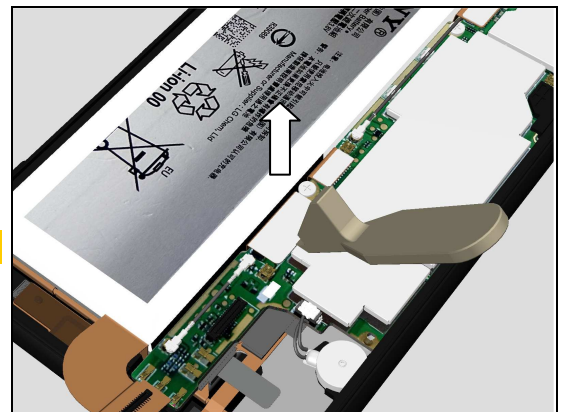
Disconnect USB FPC Assy connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**



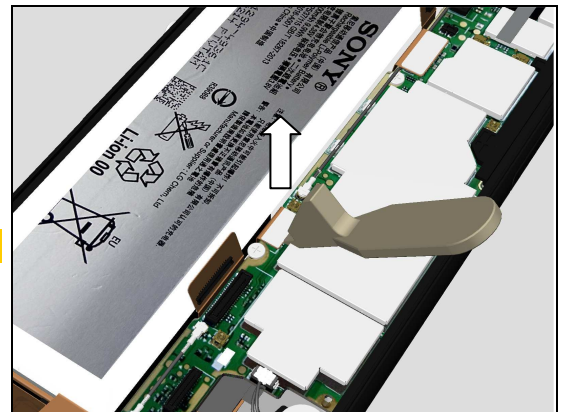
Disconnect LCM FPC Connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**



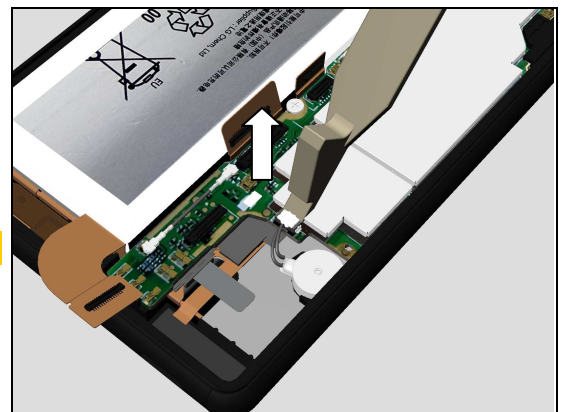
Disconnect Sidekey FPC Assy Connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**



Disconnect Vibrator Connector by using the Front Opening Tool.

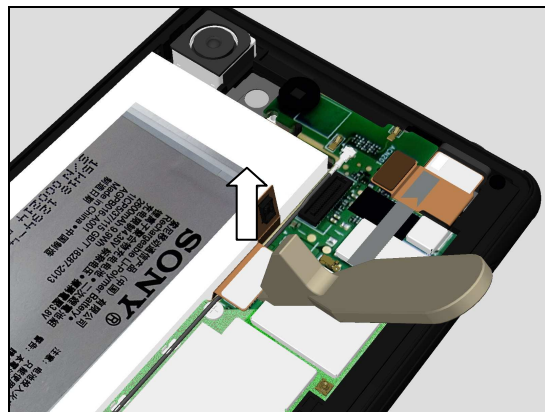
**Do not damage components on the Main PBA!**



## Disassembly

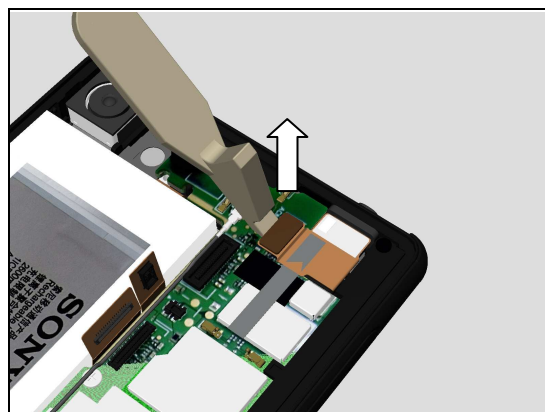
Disconnect Main Camera FPC Connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**

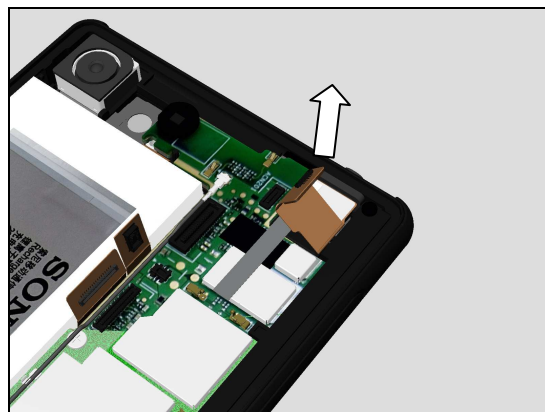


Disconnect Audio Jack FPC Assy Connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**

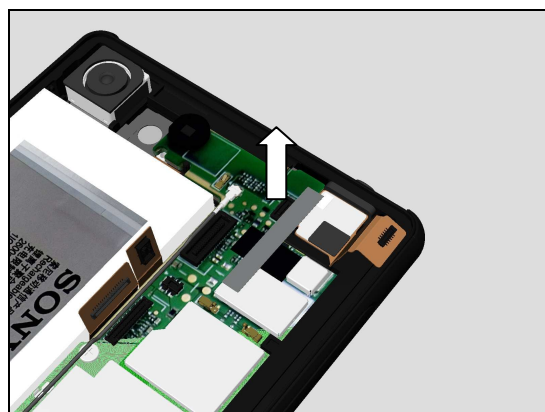


Detach the FPC of the Audio Jack FPC Assy.



Detach the Conductive Tape Audio Jack.

**Scrap! Not to be reused!**

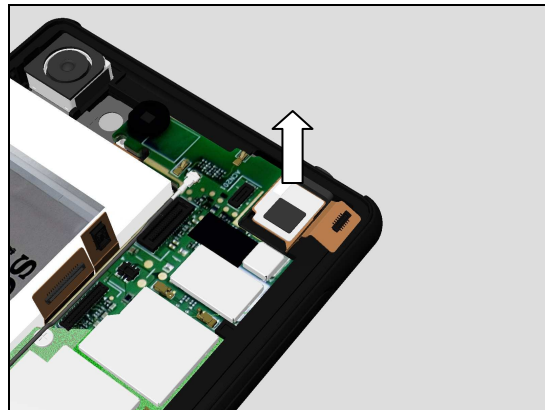




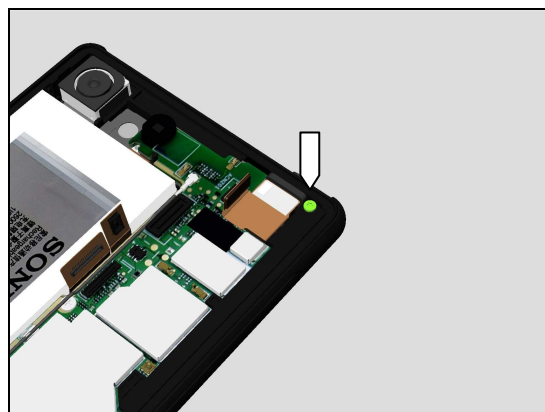
## Disassembly

Detach the Adhesive Diversity Ant/Audio Jack.

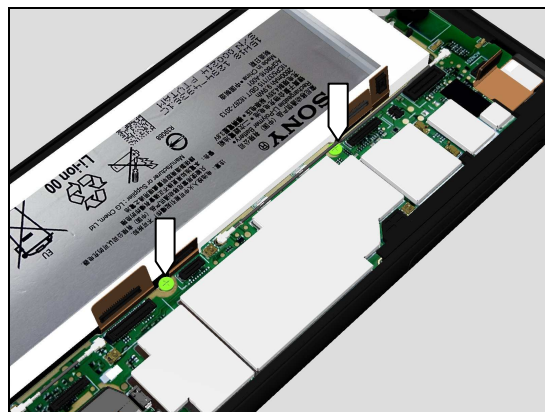
**Scrap! Not to be reused!**



Remove the Screw M1.2\_L3.5 by using a screwdriver with Bits T5.

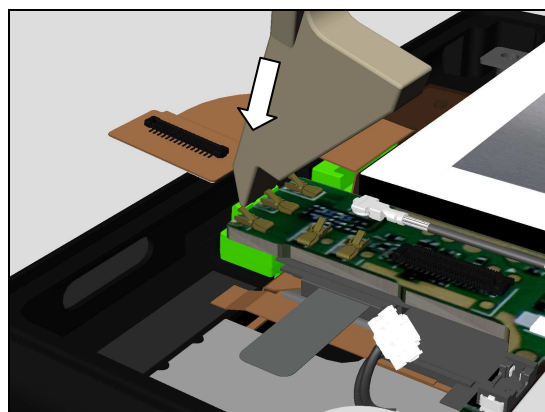


Remove the two Screw M1.2\_L2.5 by using a screwdriver with Bits JCIS No.0.



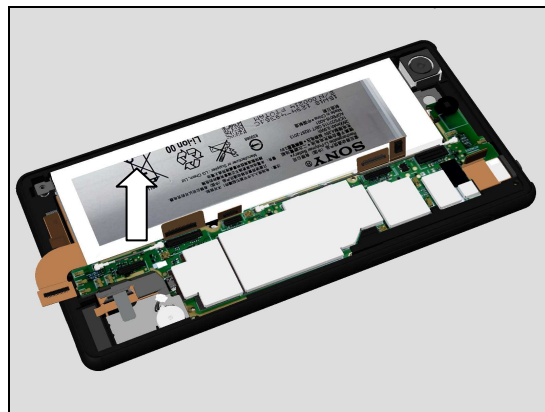
Unsnap the hooks as shown in picture.

**Note! Do not touch the contact springs!**

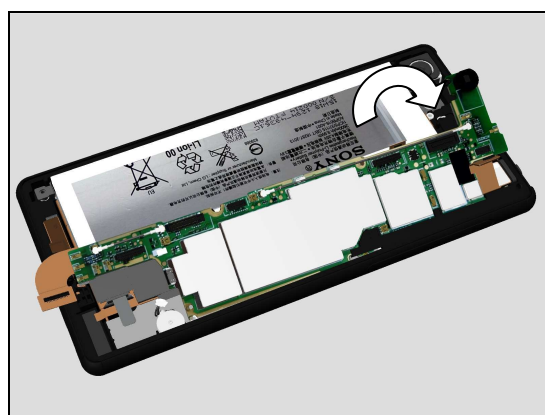


## Disassembly

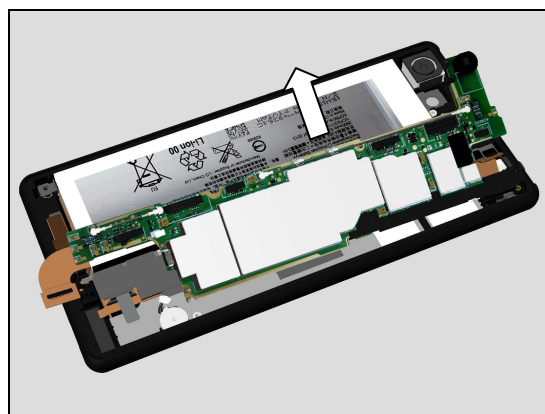
Release the bottom side of the Main PBA.



Rotate to release the top side of the Main PBA.



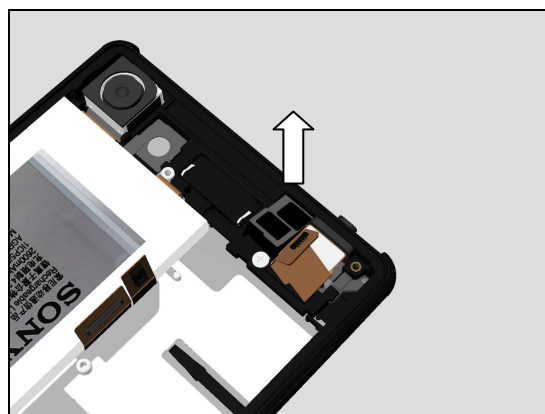
Remove the Main PBA.



### 3.11 Second Mic Rubber

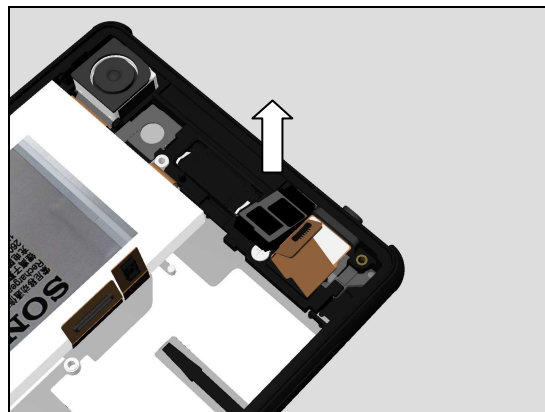
Detach the Second Mic Rubber.

**Scrap! Not to be reused!**



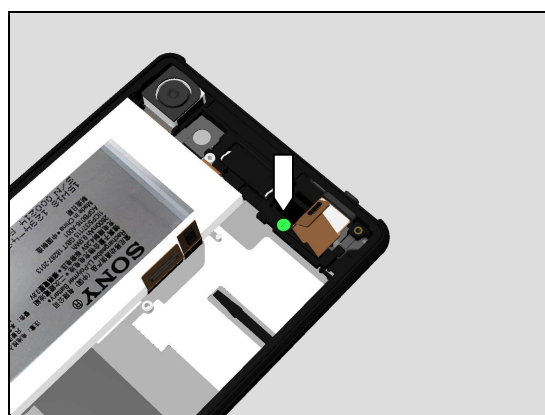
## Disassembly

Remove it.

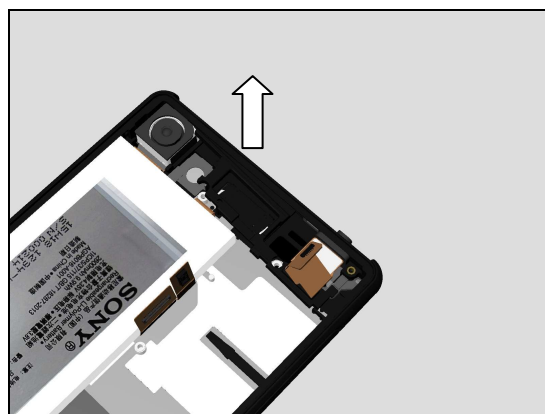


### 3.12 Holder Earspeaker and Display Cover Assy

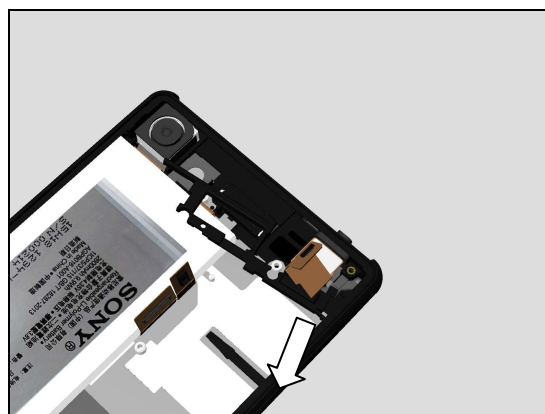
Remove the Screw M1.2\_L2.5 by using a screwdriver with Bits JCIS No.0.



Lift the Holder Earspeaker.

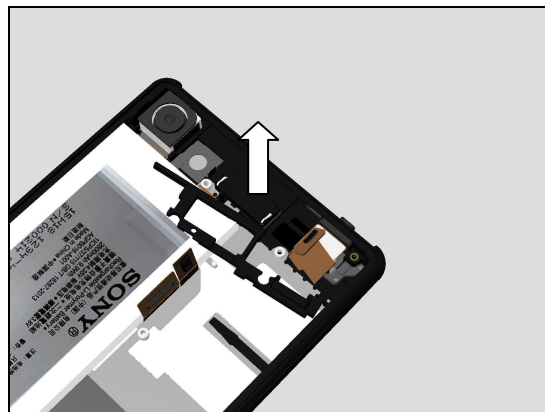


Release the Holder Earspeaker.



## Disassembly

Remove it.



## 4 Replacement

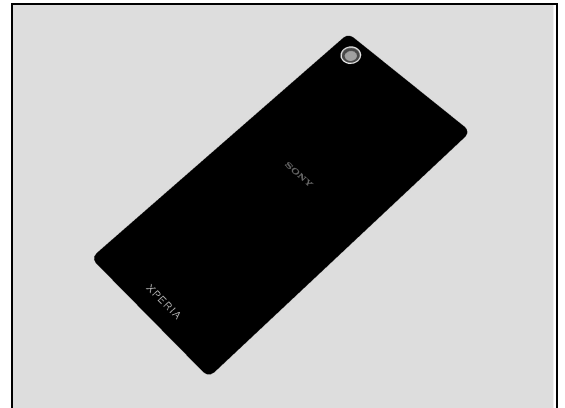
### 4.1 Back Panel

*Follow the 3.1 – 3.3 Disassembly instructions!*

Prepare a new Back Panel.

*Follow the 4.20 Installation instructions!*

*Follow the 5.10 – 5.12 Reassembly instructions!*



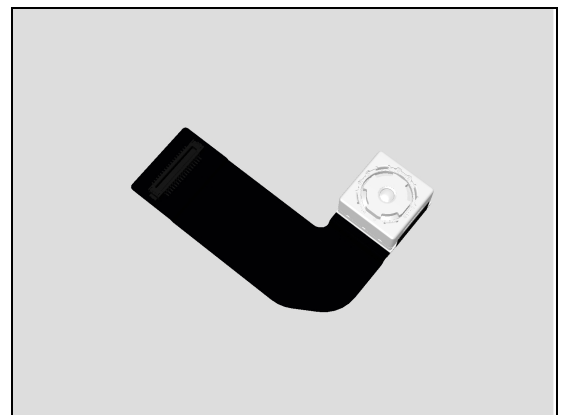
### 4.2 Chat Camera

*Follow the 3.1 – 3.7 Disassembly instructions!*

Prepare a new Chat Camera.

*Follow the 4.26 Installation instructions!*

*Follow the 5.6 – 5.12 Reassembly instructions!*



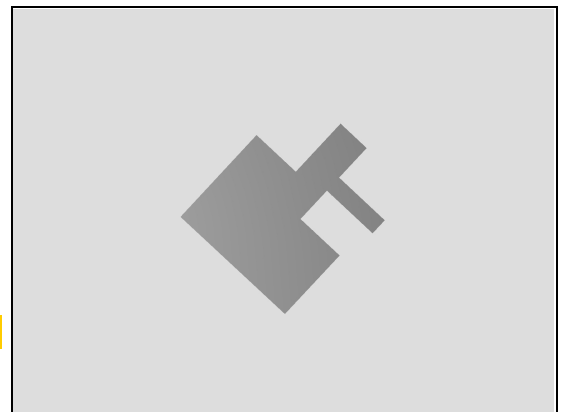
### 4.3 Conductive Tape Battery Connector

*Follow the 3.1 – 3.4 Disassembly instructions!*

Prepare a new Conductive Tape Battery Connector.

*Follow the 5.9 – 5.12 Reassembly instructions!*

**Scrap! Not to be reused!**

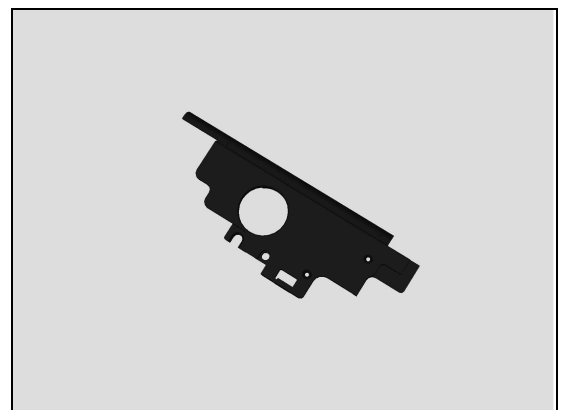


### 4.4 Holder Diversity Ant Assy

*Follow the 3.1 – 3.6 Disassembly instructions!*

Prepare a new Holder Diversity Ant Assy.

*Follow the 5.7 – 5.12 Reassembly instructions!*



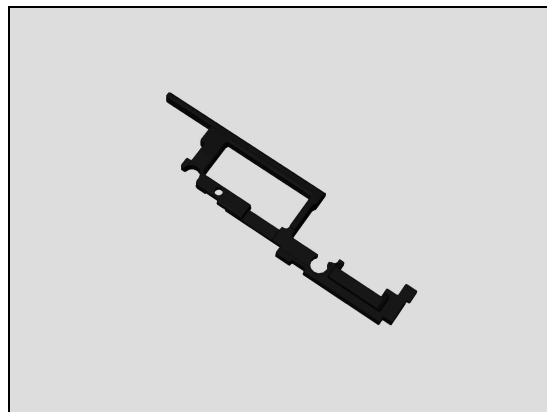
## Replacement

### 4.5 Holder Earspeaker

*Follow the 3.1 – 3.12 Disassembly instructions!*

Prepare a new Holder Earspeaker.

*Follow the 5.1 – 5.12 Reassembly instructions!*



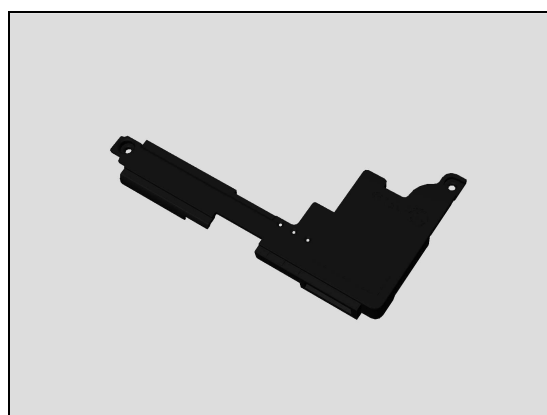
### 4.6 Holder Speaker Main Ant Assy

*Follow the 3.1 – 3.8 Disassembly instructions!*

Prepare a new Holder Speaker Main Ant Assy.

*Follow the 4.21 and 4.58 Installation instructions!*

*Follow the 5.5 – 5.12 Reassembly instructions!*



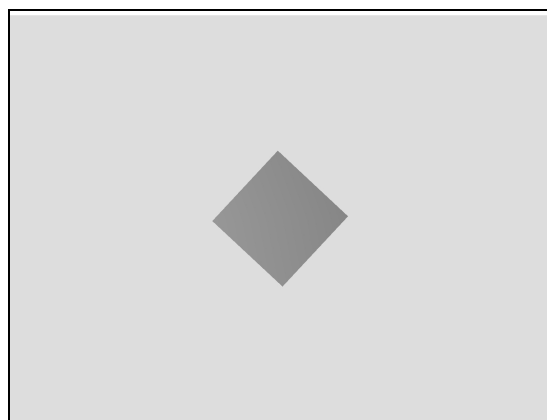
### 4.7 Kapton Film LCM Connector

*Follow the 3.1 – 3.9 Disassembly instructions!*

Prepare a new Kapton Film LCM Connector.

*Follow the 5.4 – 5.12 Reassembly instructions!*

**Scrap! Not to be reused!**

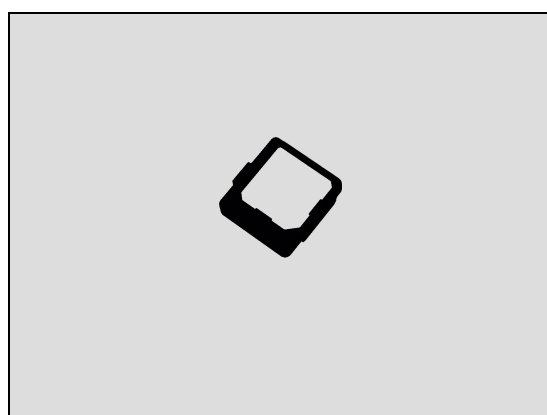


### 4.8 Main Camera Rubber

*Follow the 3.1 – 3.5 Disassembly instructions!*

Prepare a new Main Camera Rubber.

*Follow the 5.8 – 5.12 Reassembly instructions!*



## Replacement

### 4.9 Panel Deco Top

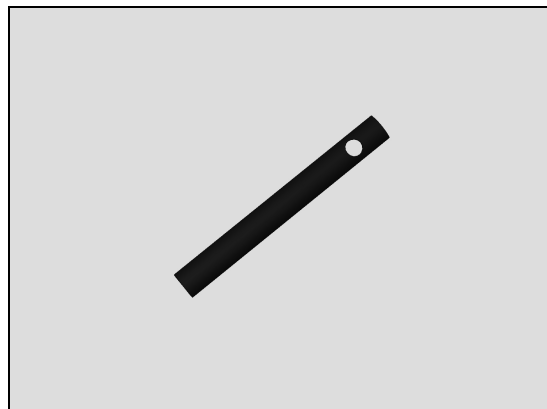
*Follow the 3.1 – 3.2 Disassembly instructions!*

Prepare a new Panel Deco Top.

*Follow the 5.11 – 5.12 Reassembly instructions!*

**Scrap! Not to be reused!**

**Note! Clean the adhesive residues on the Display Cover Assy before assembly.**



### 4.10 Second Mic Rubber

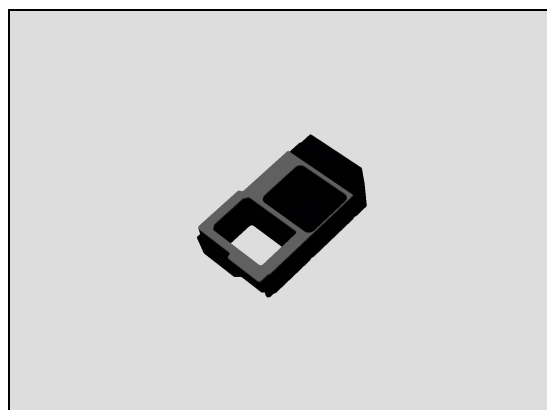
*Follow the 3.1 – 3.11 Disassembly instructions!*

Prepare a new Second Mic Rubber.

*Follow the 5.2 – 5.12 Reassembly instructions!*

**Scrap! Not to be reused!**

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

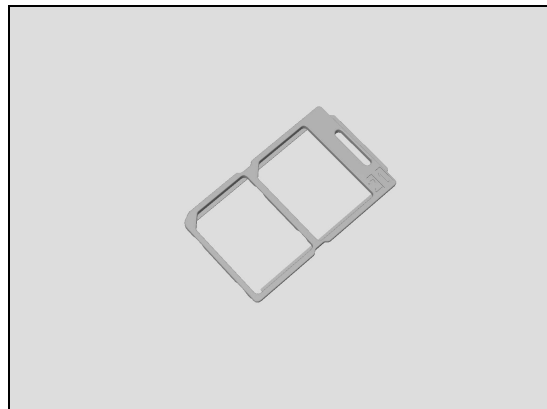


### 4.11 Tray Dual SIM

*Follow the 3.1 Disassembly instructions!*

Prepare a new Tray Dual SIM.

*Follow the 5.12 Reassembly instructions!*

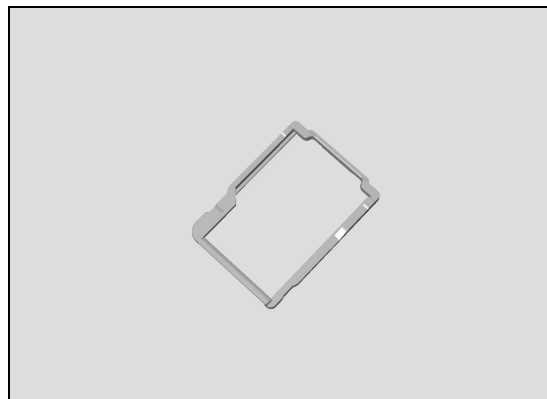


### 4.12 Tray SD

*Follow the 3.1 Disassembly instructions!*

Prepare a new Tray SD.

*Follow the 5.12 Reassembly instructions!*



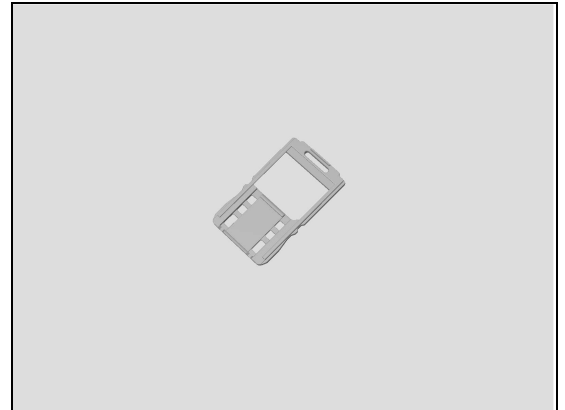
## Replacement

### 4.13 Tray Single SIM

*Follow the 3.1 Disassembly instructions!*

Prepare a new Tray Single SIM.

*Follow the 5.12 Reassembly instructions!*



### 4.14 Display Cover Assy

*Follow the 3.1 – 3.12 Disassembly instructions!*

*Follow the 4.18, 4.22, 4.23, 4.41, 4.44, 4.54, 4.55, 4.56 and 4.57 Removal instructions!*

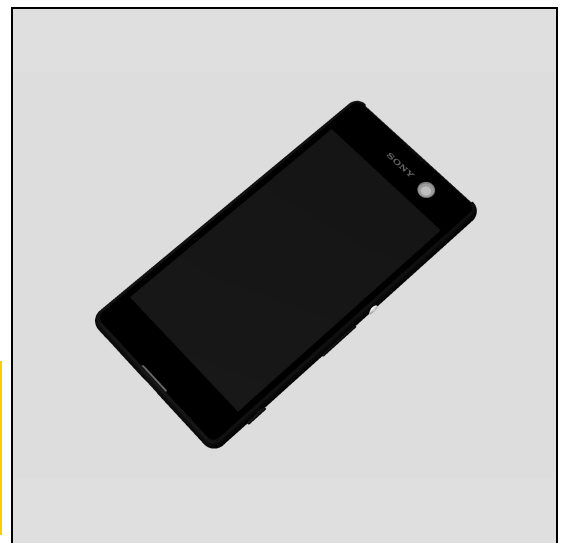
Prepare a new Display Cover Assy.

*Follow the 4.18, 4.22, 4.23, 4.24, 4.30, 4.31, 4.37, 4.38, 4.41, 4.44, 4.45, 4.54, 4.55, 4.56, 4.57 and 4.60 Installation instructions!*

*Follow the 5.1 – 5.12 Reassembly instructions!*

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

**Note! When replace new Display Cover Assy, Battery Copper Sheet 1 must be attached.**





## Replacement

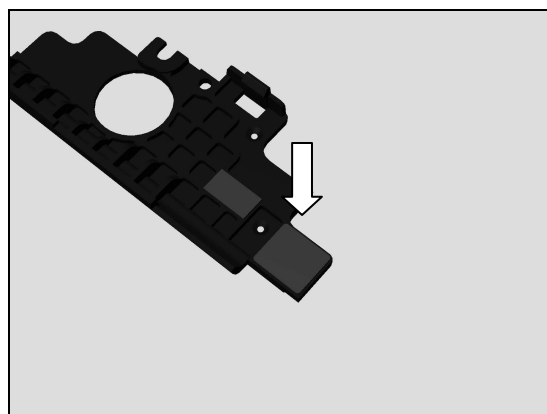
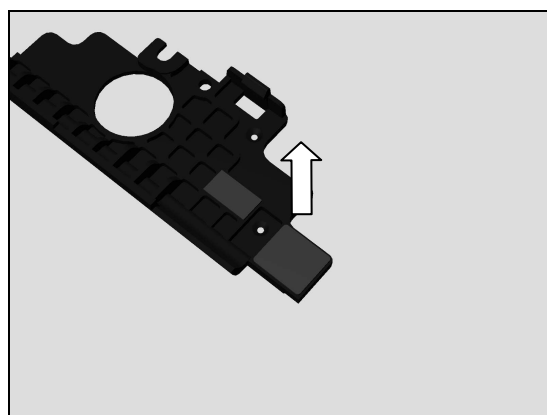
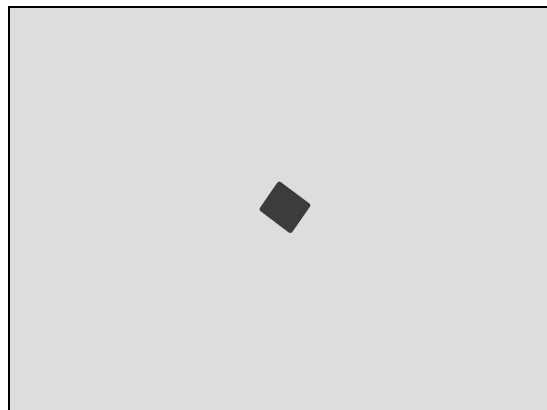
### 4.15 Adhesive Diversity Ant/Audio Jack

*Follow the 3.1 – 3.6 Disassembly instructions!*  
 Prepare a new Adhesive Diversity Ant/Audio Jack.  
*Follow the 5.7 – 5.12 Reassembly instructions!*

#### REMOVAL

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

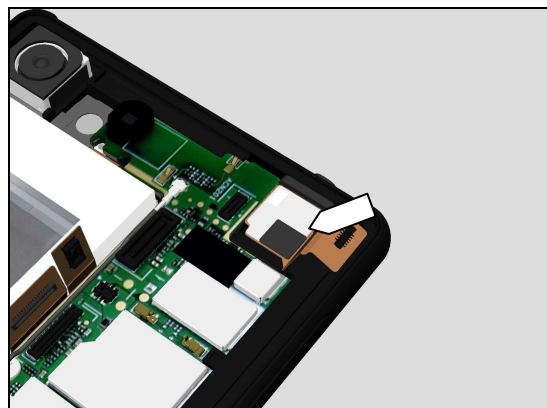
**Scrap! Not to be reused!**  
**Make sure all remaining adhesive residue have been removed!**



#### INSTALLATION

Attach a new Adhesive Diversity Ant/Audio Jack by using a pair of Plastic Tweezers as shown in picture.

Do the same to this Adhesive Diversity Ant/Audio Jack.



## Replacement

### 4.16 Adhesive Holder Diversity Ant Assy

*Follow the 3.1 – 3.6 Disassembly instructions!*

Prepare a new Adhesive Holder Diversity Ant Assy.

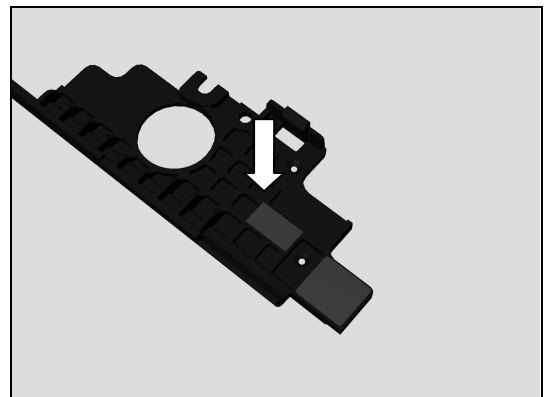
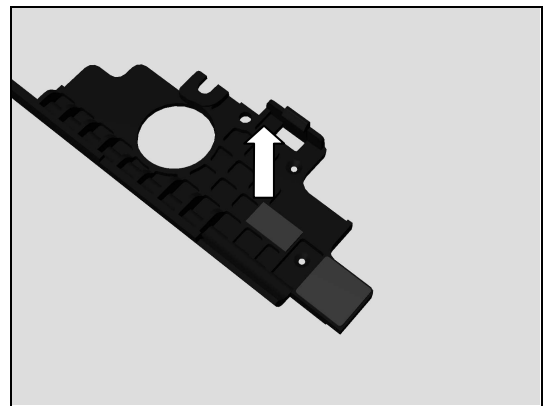
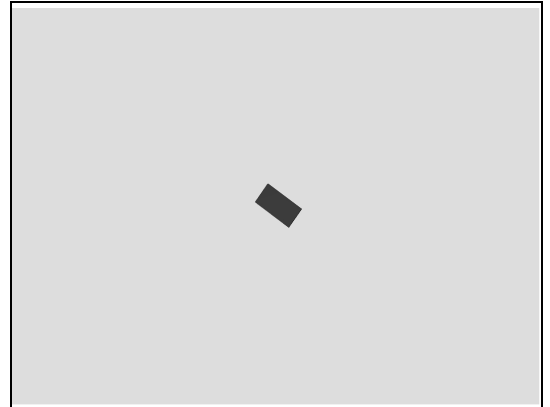
*Follow the 5.7 – 5.12 Reassembly instructions!*

#### REMOVAL

Detach the Adhesive Holder Diversity Ant Assy 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 Holder Diversity Ant Assy by using a pair of Plastic Tweezers as shown in picture.

## Replacement

### 4.17 Adhesive Holder GPS/WiFi Ant Assy 1&2&3

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Follow the 4.40 Removal instructions!*  
*Prepare a new Adhesive Holder GPS/WiFi Ant Assy 1&2&3.*  
*Follow the 4.40 Installation instructions!*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

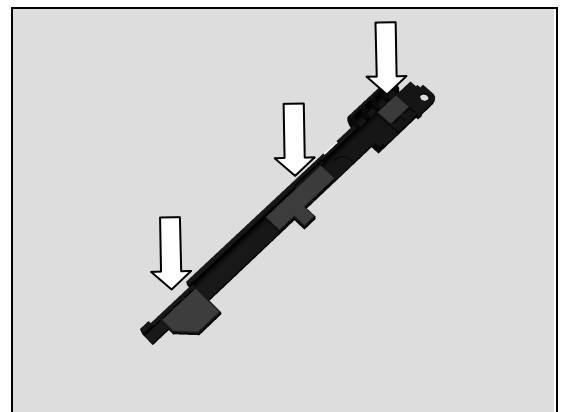
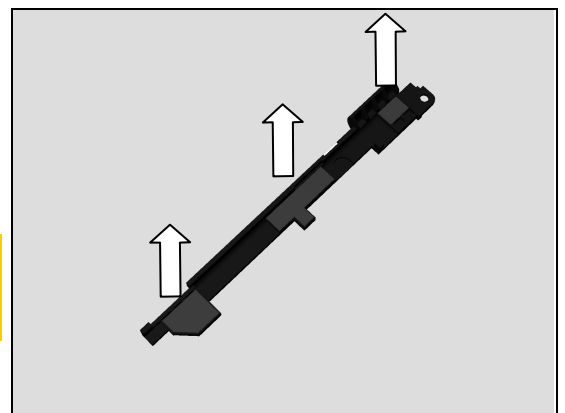
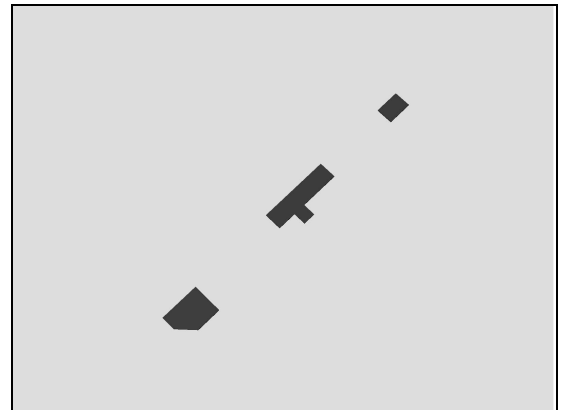
#### REMOVAL

Detach the Adhesive Holder GPS/WiFi Ant Assy 1&2&3 and remove them with a pair of Plastic Tweezers.

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

#### INSTALLATION

Attach new Adhesive Holder GPS/WiFi Ant Assy 1&2&3 by using a pair of Plastic Tweezers as shown in picture.



## Replacement

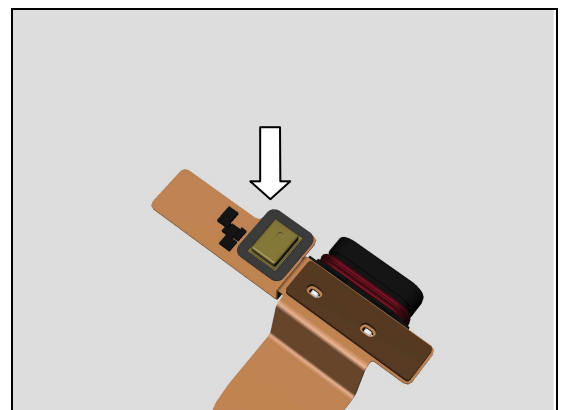
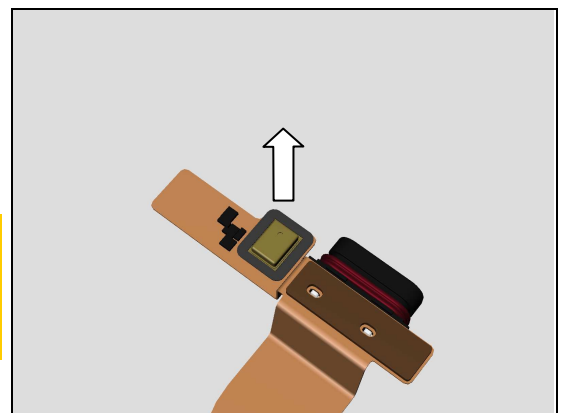
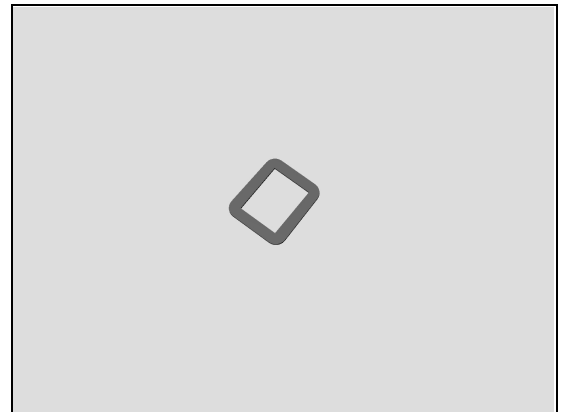
### 4.18 Adhesive Main Mic

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23, 4.41, 4.55, 4.56 and 4.45 Removal instructions!*  
*Prepare a new Adhesive Main Mic.*

#### REMOVAL

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

**Scrap! Not to be reused!**  
**Be careful! Do not damage the Main Mic.**  
**Make sure all remaining adhesive residue on the FPC have been removed!**



#### INSTALLATION

Attach a new Adhesive Main Mic in its proper position as shown in picture.

*Follow the 4.45, 4.56, 4.55, 4.41, 4.24 and 4.23 Installation instructions!*

## Replacement

### 4.19 Adhesive Vibrator

*Follow the 3.1 – 3.8 Disassembly instructions!*  
*Follow the 4.57 Removal instructions!*  
*Prepare a new Adhesive Vibrator.*  
*Follow the 4.57 Installation instructions!*  
*Follow the 5.5 – 5.12 Reassembly instructions!*

#### REMOVAL

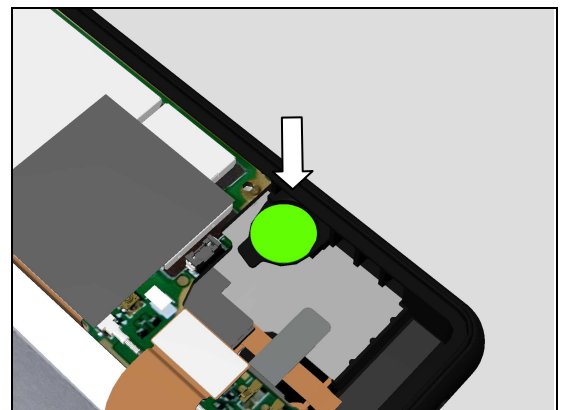
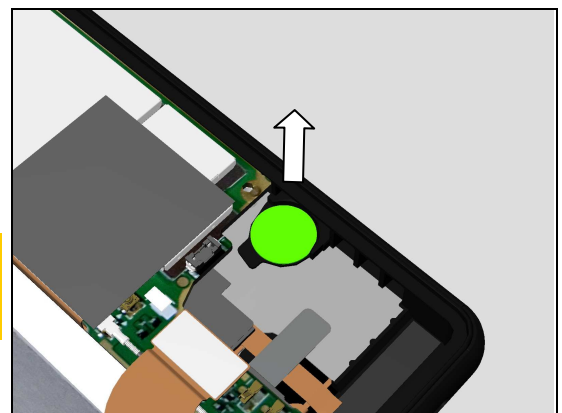
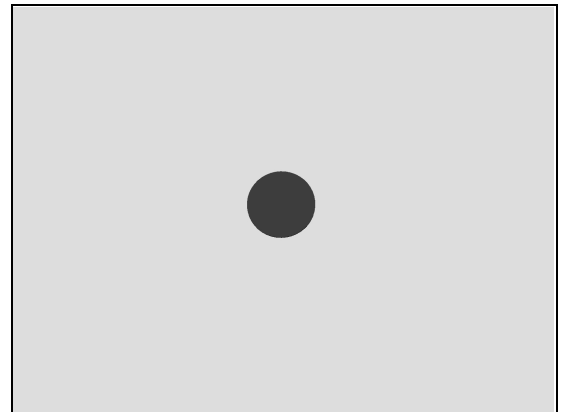
Detach the Adhesive Vibrator and remove it with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

**Make sure all remaining adhesive residue have been removed!**

#### INSTALLATION

Attach a new Adhesive Vibrator in its proper position as shown in picture.



## Replacement

### 4.20 Adhesive WR Back Panel

Follow the 3.1 – 3.3 Disassembly instructions!  
 Prepare a new Adhesive WR Back Panel.  
 Follow the 5.10 – 5.12 Reassembly instructions!

#### REMOVAL

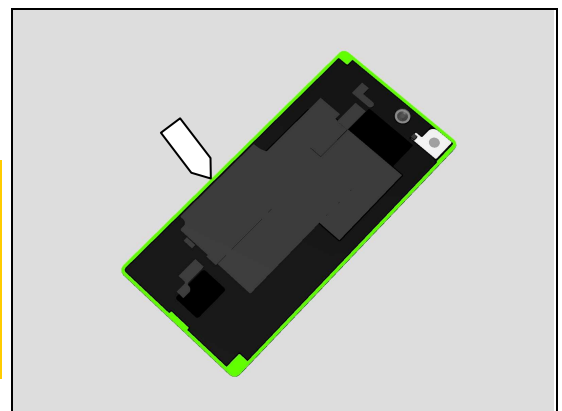
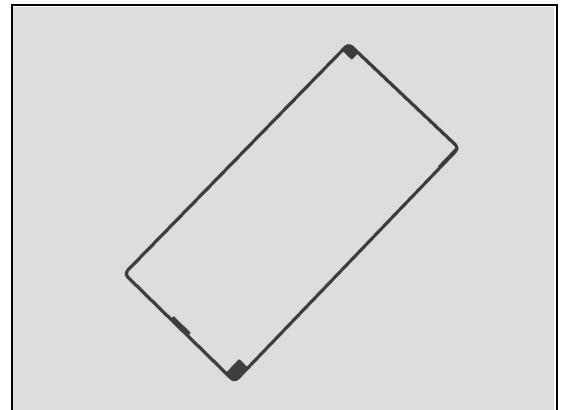
Detach to remove the Adhesive WR Back Panel with fingers.

**Scrap! Not to be reused!**

**Note! Do not damage or scratch the Back Panel.**

**Note! Do not damage the main camera cushion on the Back Panel.**

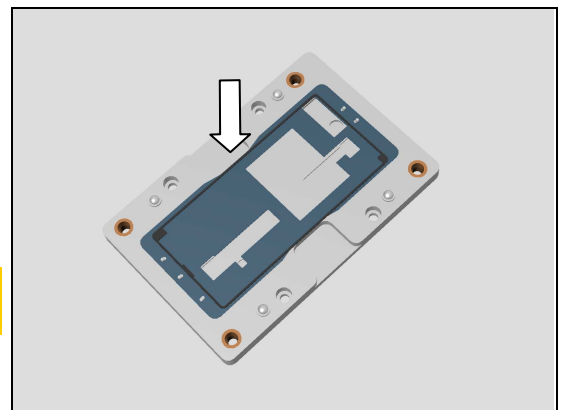
**Make sure all remaining adhesive residue have been removed!**



#### INSTALLATION

Place a new Adhesive WR Back Panel with protection film onto the Back Panel Adhesive Alignment Fixture (Bottom Part).

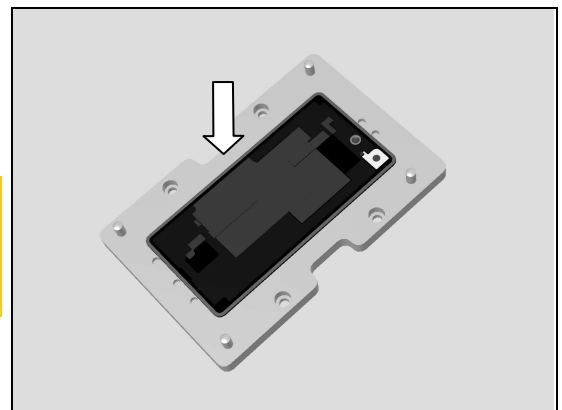
**Note the correct orientation to be installed as shown in picture!**



Place the Back Panel onto the Back Panel Adhesive Alignment Fixture (Upper Part).

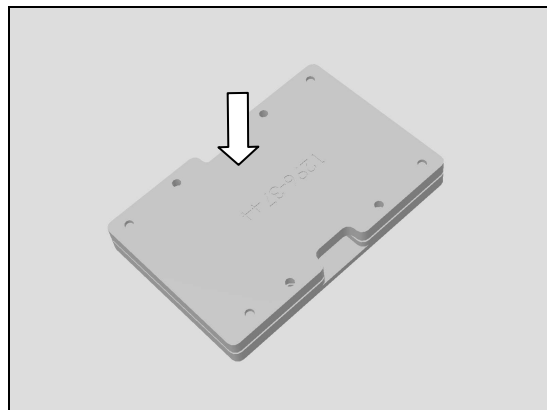
**Note the correct orientation to be installed as shown in picture!**

**Important to make sure that old adhesive is removed before installation because of WRT requirement!**



## Replacement: Adhesive WR Back Panel

Place the Upper Part of the fixture and press it.



## Replacement

### 4.21 Adhesive WR Speaker Holder

*Follow the 3.1 – 3.8 Disassembly instructions!*  
*Prepare a new Adhesive WR Speaker Holder.*  
*Follow the 5.5 – 5.12 Reassembly instructions!*

#### REMOVAL

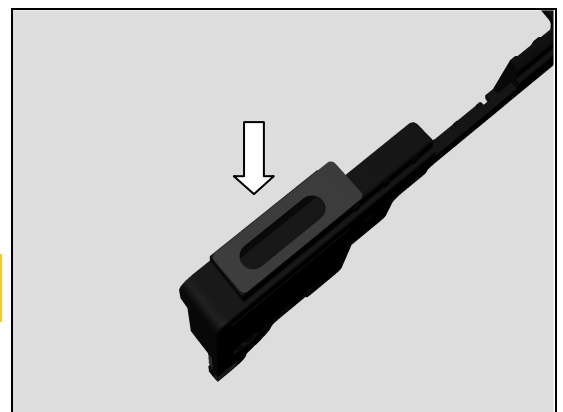
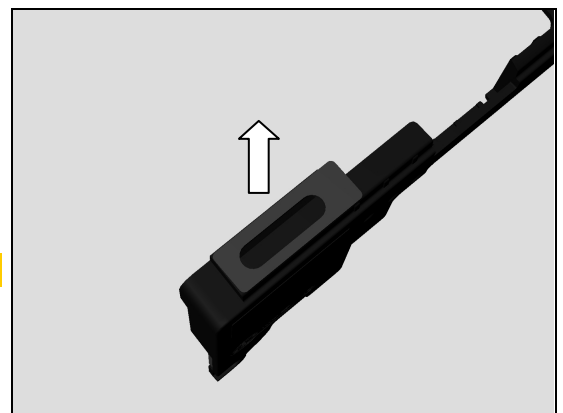
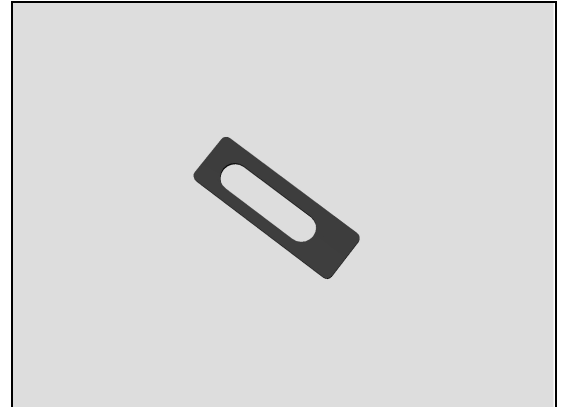
Detach the Adhesive WR Speaker Holder.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Adhesive WR Speaker Holder in its proper position as shown in picture.

**Important to make sure that old adhesive is removed before installation because of WRT requirement!**





## Replacement

### 4.22 Audio Jack FPC Assy and Adhesive WR Audio Jack

*Follow the 3.1 – 3.12 Disassembly instructions!*

*Prepare a new Audio Jack FPC Assy and Adhesive WR Audio Jack.*

*Follow the 4.59 Installation instructions!*

*Follow the 5.1 – 5.12 Reassembly instructions!*

**E5603, E5606, E5633, E5643, E5653, E5663 share the same disassembly and reassembly method.**

#### REMOVAL

Insert the Front Opening Tool between Audio Jack FPC Assy and Display Cover Assy and slide to detach the Audio Jack FPC Assy.

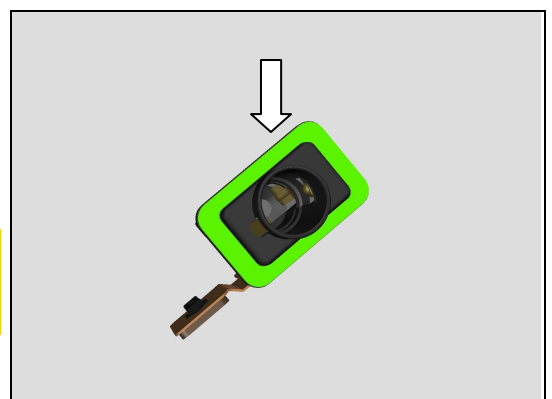
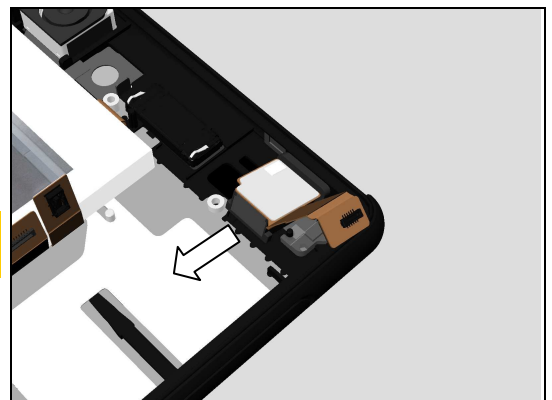
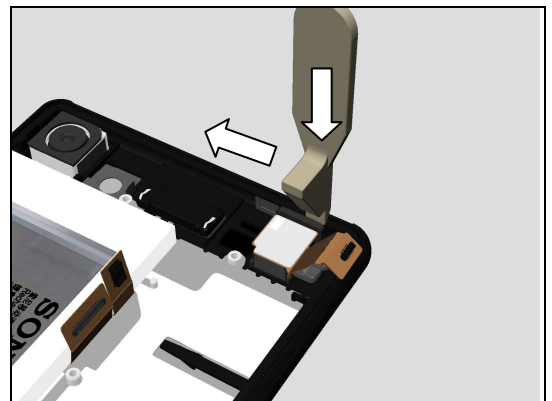
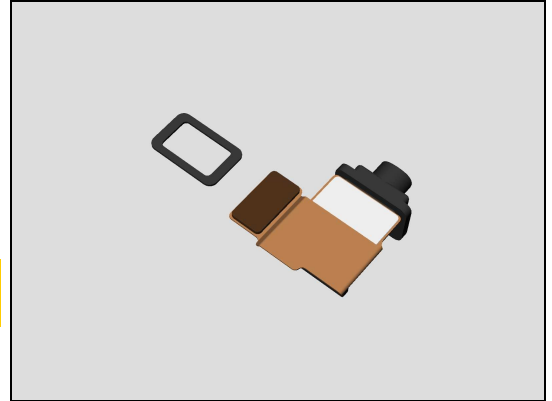
Remove the Audio Jack FPC Assy.

**Note! Lift the Audio Jack FPC Assy a little to avoid metal plate blocking it.**

#### INSTALLATION

Attach a new Adhesive WR Audio Jack in its proper position as shown in picture.

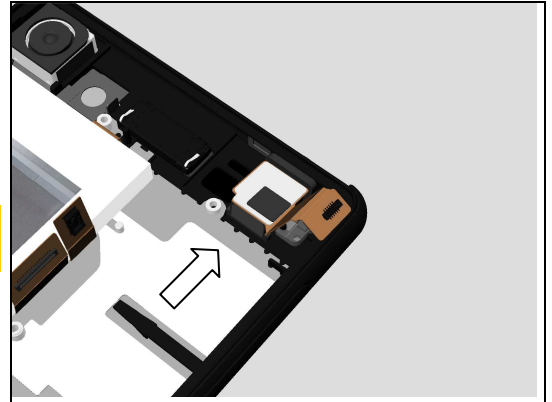
**Scrap the old Adhesive WR Audio Jack!  
Make sure all remaining adhesive residue have been removed before installation!**



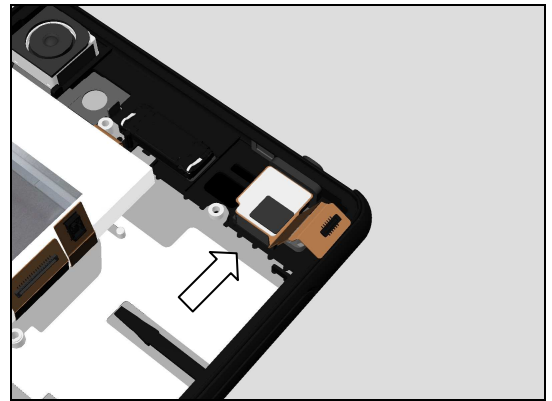
## Replacement: Audio Jack FPC Assy and Adhesive WR Audio Jack

Insert to mount a new Audio Jack FPC Assy into its hole as shown in picture.

***Make sure all remaining adhesive residue on the Display Cover Assy have been removed!***

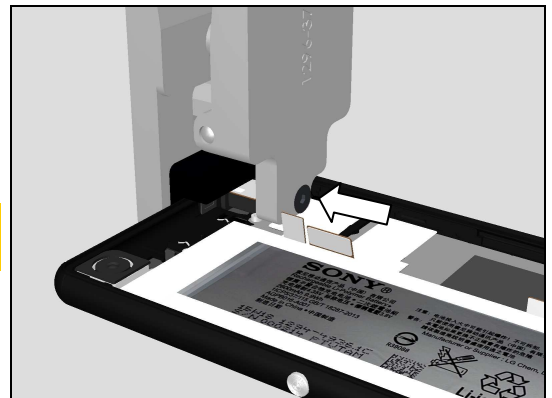


Secure the Audio Jack FPC Assy onto its proper position.



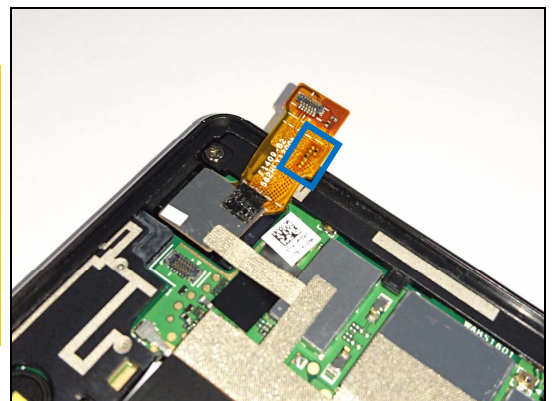
Press it by using the Audio Jack Press Clamp for 10 seconds.

***Note! Do not damage the Audio Jack FPC when pressing.***



***The protection film attached above the electrical components as shown in picture is to avoid shortcut. The stickiness of this film might be lost and peel off, but the possibility is very low, so this film is not defined as spare part.***

***If it peels off, transparent adhesive tape can be used instead, cut the tape to the same shape and attach it at same position.***



## Replacement

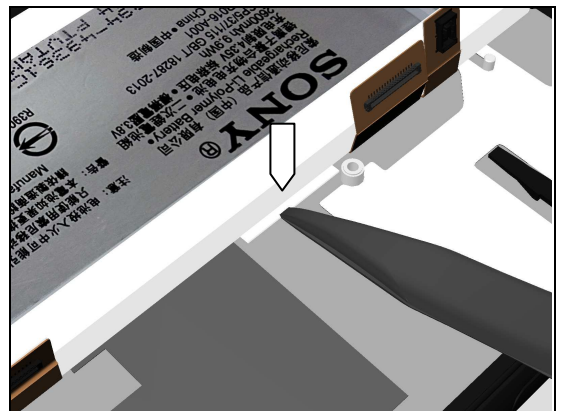
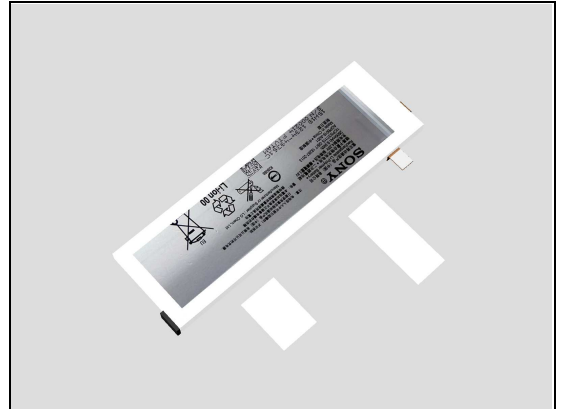
### 4.23 Battery Assy and Adhesive Battery 1&2

Follow the 3.1 – 3.12 Disassembly instructions!  
Prepare a new Battery Assy and Adhesive Battery 1&2.

#### REMOVAL

Hold the Adhesive Battery 1 by using the Blunt-tip Metal Tweezers.

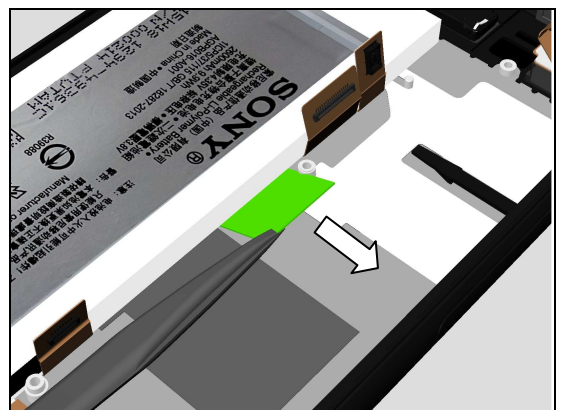
**Be careful not to damage the Battery Assy!**



Pull to remove the Adhesive Battery 1.

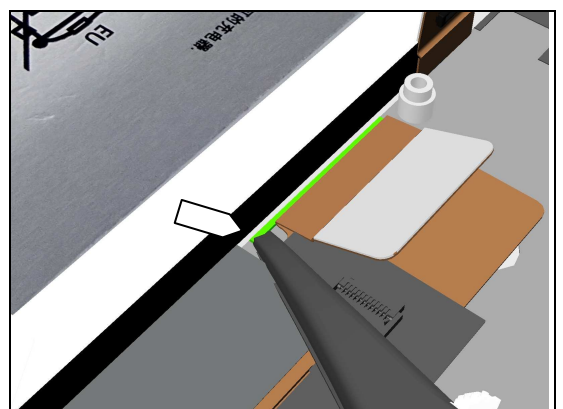
**Scrap! Not to be reused.**

**To avoid the adhesive break, hold the adhesive and roll the tweezers while pulling!**



Hold the Adhesive Battery 2 by using the Blunt-tip Metal Tweezers.

**Be careful not to damage the Battery Assy!**

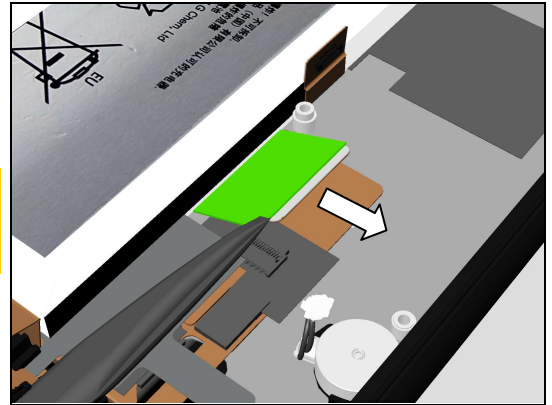


## Replacement: Battery Assy and Adhesive Battery 1&2

Pull to remove the Adhesive Battery 2.

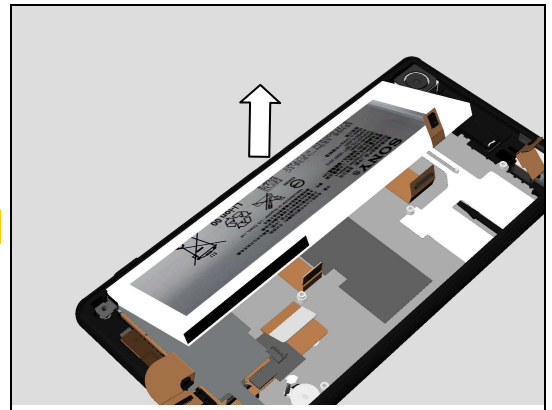
**Scrap! Not to be reused.**

**To avoid the adhesive break, hold the adhesive and roll the tweezers while pulling!**



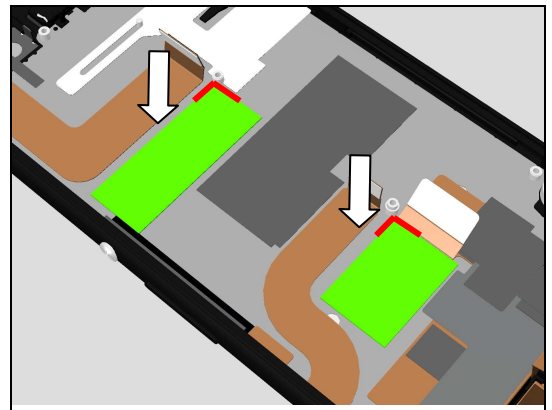
Remove the Battery Assy.

**Scrap! Not to be reused.**



### INSTALLATION

Attach a new Adhesive Battery 1 and Adhesive Battery 2 aligning with the guiding lines as shown in picture.

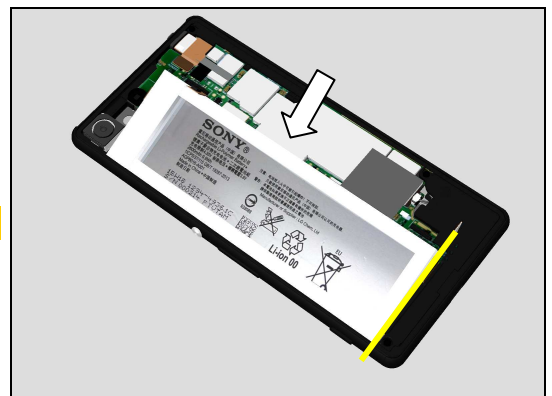


Follow the 5.1 – 5.5 Reassembly instructions to assemble Main PBA!

Open the USB FPC Assy connector.

**Attach a new Battery Mylar onto new Battery Assy.**

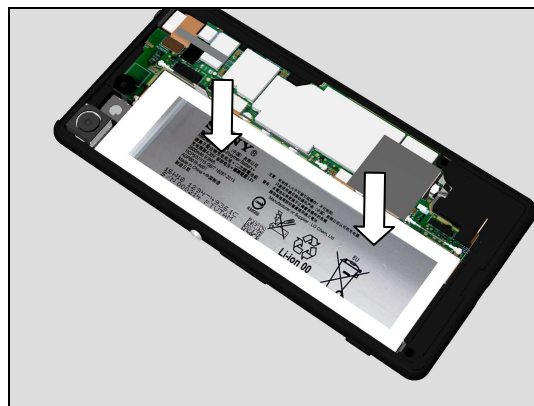
Insert to mount the Battery Assy aligning with bottom side as shown in picture.



## Replacement: Battery Assy and Adhesive Battery 1&2

Press the adhesive area for 5 seconds by fingers.  
Connect the USB FPC Assy connector.

*Follow the 5.6 – 5.12 Reassembly instructions!*



## Replacement

### 4.24 Battery Mylar

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23 Removal instructions!*  
*Prepare a new Battery Mylar.*  
*Follow the 4.23 Installation instructions!*

#### REMOVAL

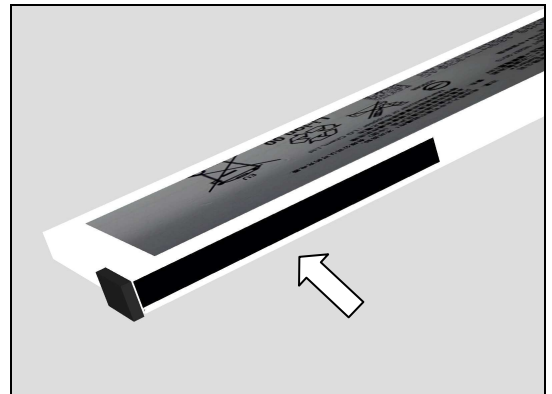
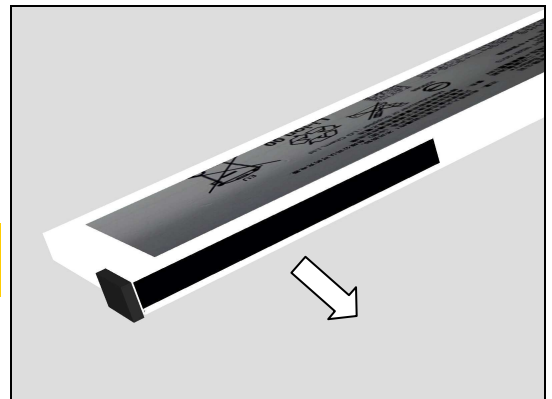
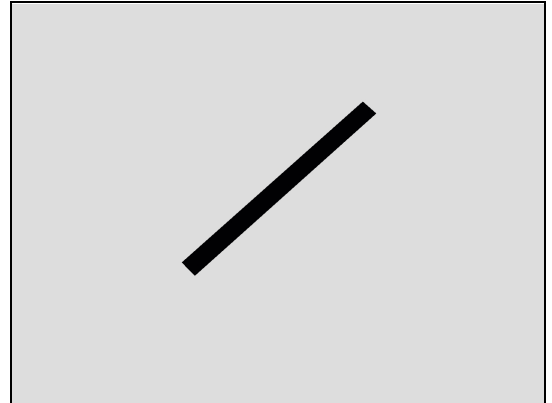
Detach the Battery Mylar and remove it.

**Scrap! Not to be reused!**

**Be careful not to damage the Battery Assy!**

#### INSTALLATION

Attach a new Battery Mylar in its proper position as shown in picture.



## Replacement

### 4.25 Cap SIM/SD

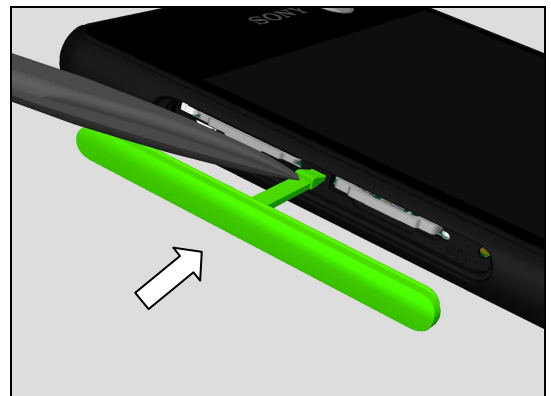
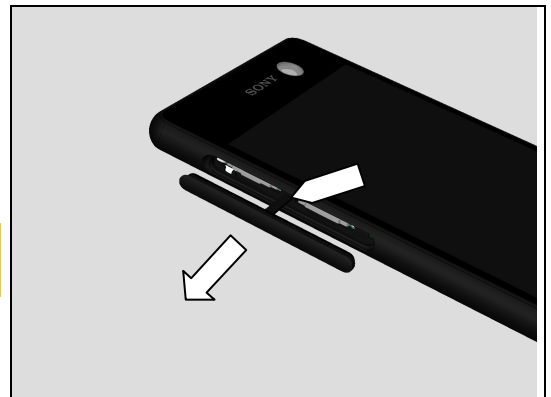
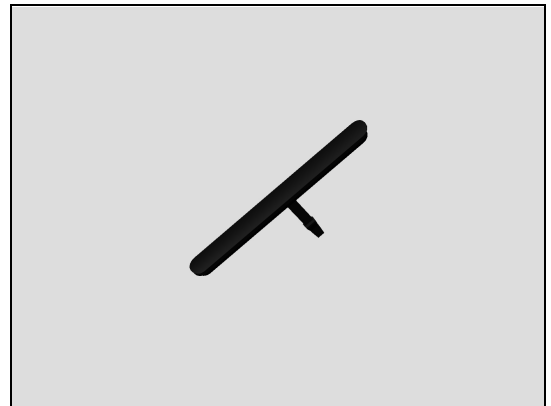
Prepare a new Cap SIM/SD.

#### REMOVAL

Open the Cap SIM/SD and pull to remove it.

**Scrap! Not to be reused!**

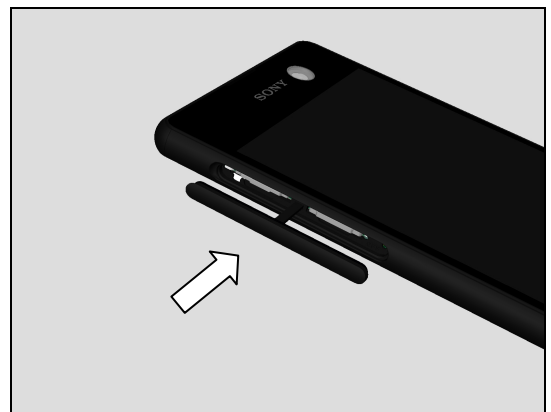
**Note! Hold the cap tail to pull out as the arrow shown.**



#### INSTALLATION

Push by using a pair of pointed plastic tweezers to insert the Cap SIM/SD into its hole as shown in picture.

Close the Cap SIM/SD.



## Replacement

### 4.26 Chat Camera Cushion

*Follow the 3.1 – 3.7 Disassembly instructions!*  
*Prepare a new Chat Camera Cushion.*  
*Follow the 5.6 – 5.12 Reassembly instructions!*

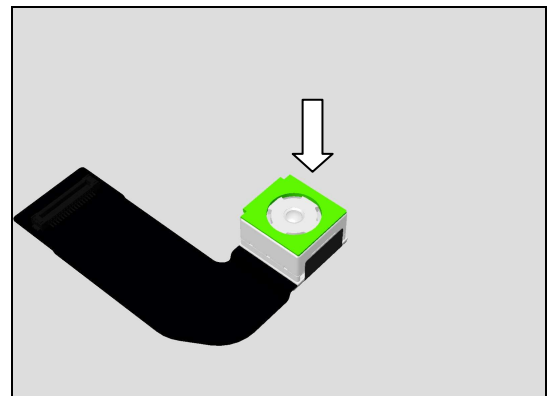
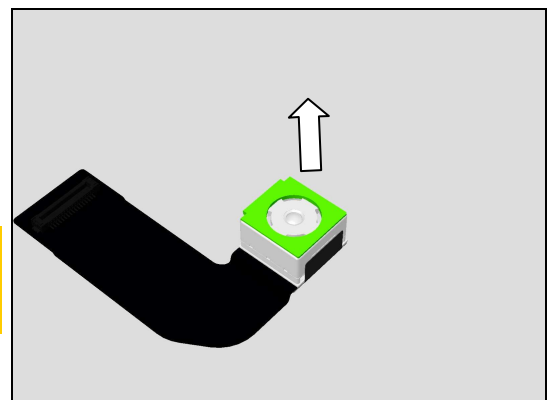
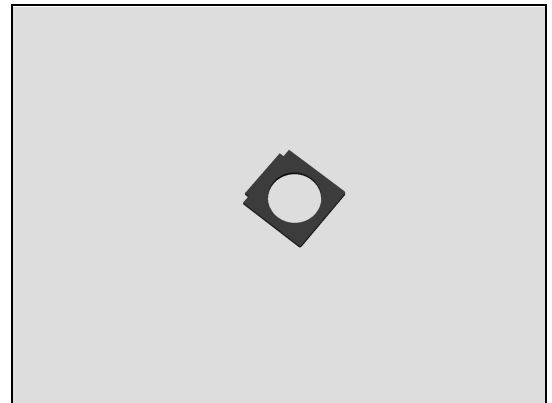
#### REMOVAL

Detach the Chat Camera Cushion and remove it with a pair of Plastic Tweezers.

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

#### INSTALLATION

Attach a new Chat Camera Cushion by using a pair of Plastic Tweezers as shown in picture.





## Replacement

### 4.27 Conductive Adhesive Sidekey FPC 1

*Follow the 3.1 – 3.12 Disassembly instructions!*

*Follow the 4.23, 4.50, 4.51, 4.49 and 4.52 Removal instructions!*

*Prepare a new Conductive Adhesive Sidekey FPC 1.*

*Follow the 4.52, 4.49, 4.51, 4.50, 4.24 and 4.23 Installation instructions!*

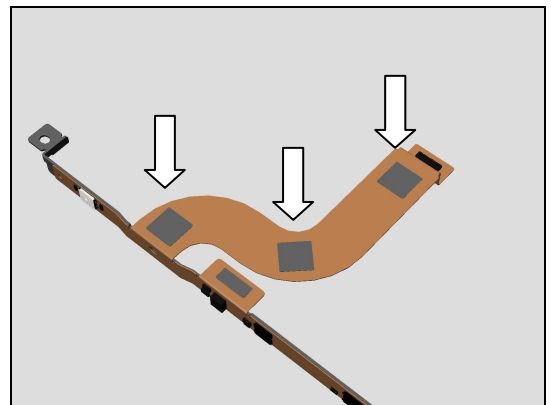
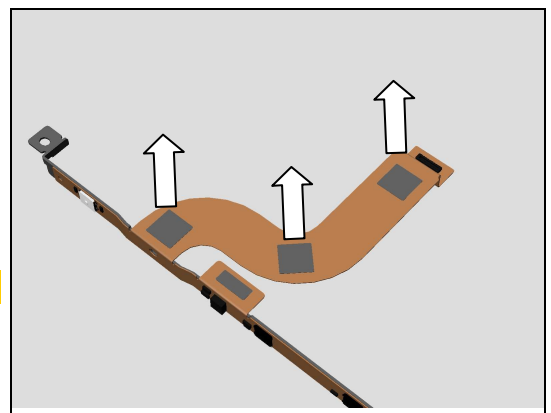
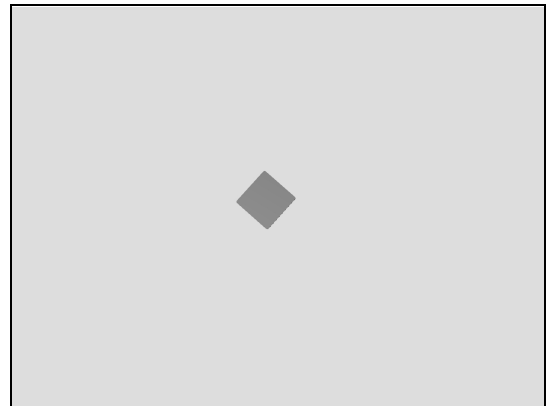
#### REMOVAL

Detach the Conductive Adhesive Sidekey FPC 1 and remove them with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Conductive Adhesive Sidekey FPC 1 aligning with the guiding lines on the FPC as shown in picture.



## Replacement

### 4.28 Conductive Adhesive Sidekey FPC 2

*Follow the 3.1 – 3.12 Disassembly instructions!*

*Follow the 4.23, 4.50, 4.51, 4.49 and 4.52 Removal instructions!*

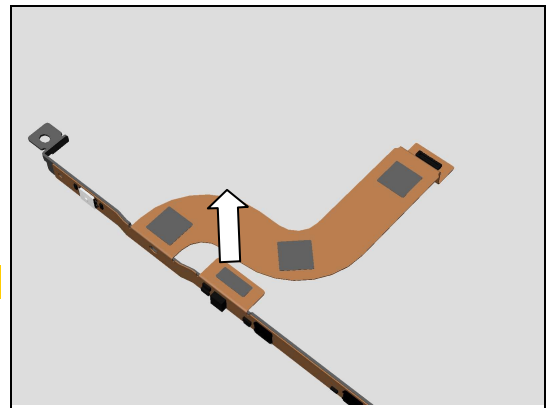
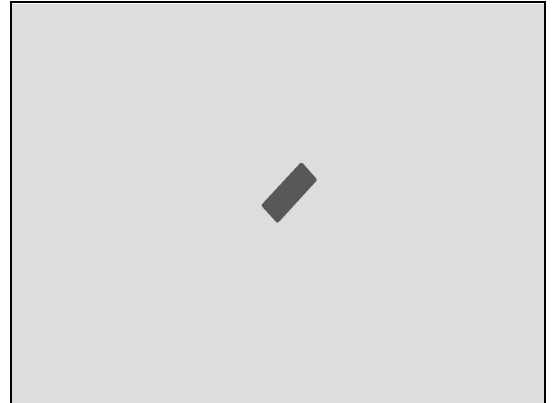
*Prepare a new Conductive Adhesive Sidekey FPC 2.*

*Follow the 4.52, 4.49, 4.51, 4.50, 4.24 and 4.23 Installation instructions!*

#### REMOVAL

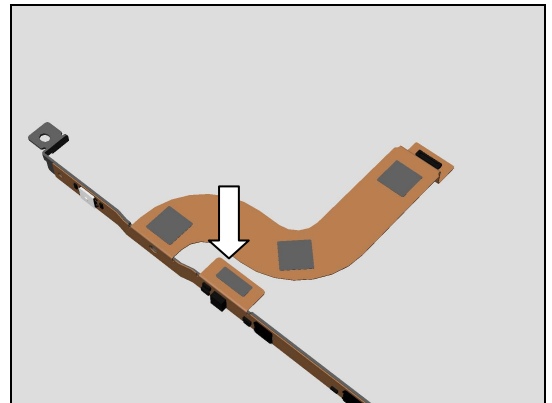
Detach the Conductive Adhesive Sidekey FPC 2 and remove it with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**



#### INSTALLATION

Attach a new Conductive Adhesive Sidekey FPC 2 by using a pair of Plastic Tweezers as shown in picture.



## Replacement

### 4.29 Conductive Tape Audio Jack

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Conductive Tape Audio Jack.*  
*Follow the 5.3– 5.12 Reassembly instructions!*

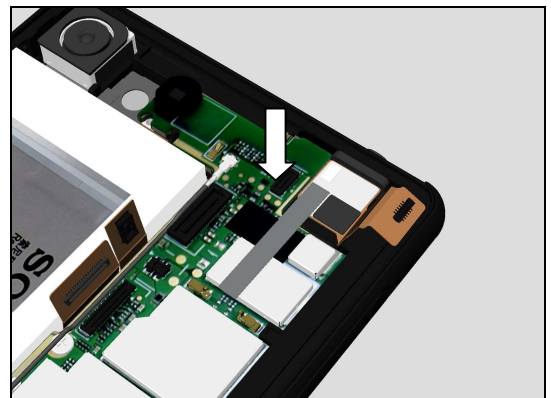
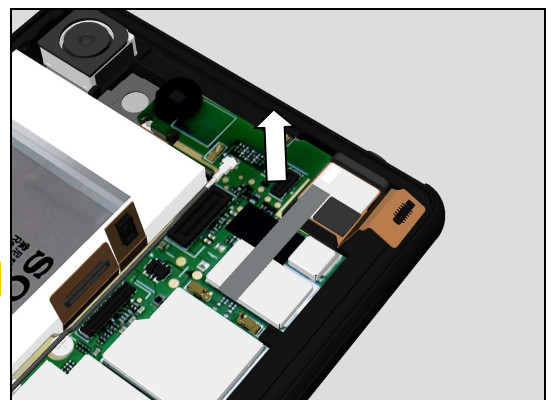
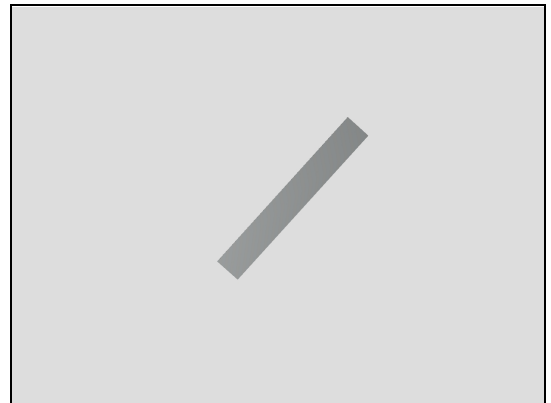
#### REMOVAL

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

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Conductive Tape Audio Jack by using a pair of Plastic Tweezers as shown in picture.



## Replacement

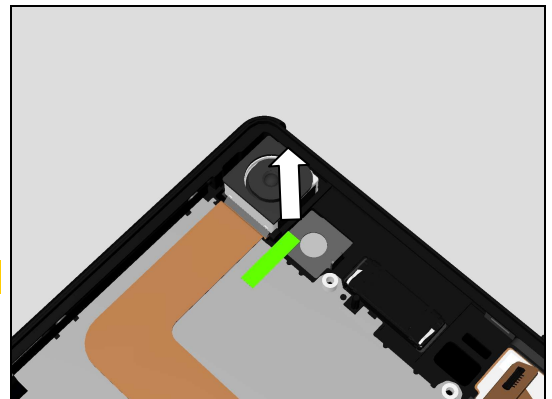
### 4.30 Conductive Tape Front Ring

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23 and 4.60 Removal instructions!*  
*Prepare a new Conductive Tape Front Ring.*  
*Follow the 4.60, 4.24 and 4.23 Installation instructions!*

#### REMOVAL

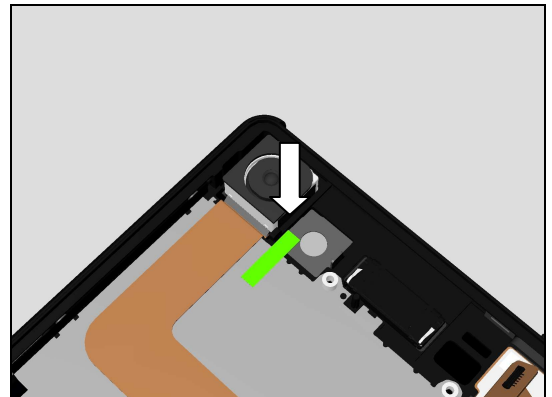
Detach the Conductive Tape Front Ring and remove it with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**



#### INSTALLATION

Attach a new Conductive Tape Front Ring by using a pair of Plastic Tweezers as shown in picture.



## Replacement

### 4.31 Conductive Tape LCM FPC

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23 Removal instructions!*  
*Prepare a new Conductive Tape LCM FPC.*  
*Follow the 4.24 and 4.23 Installation instructions!*

#### REMOVAL

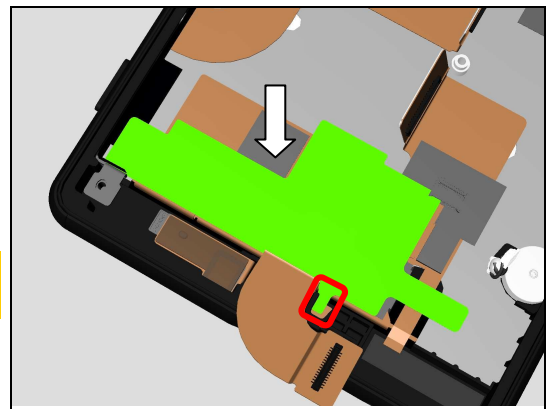
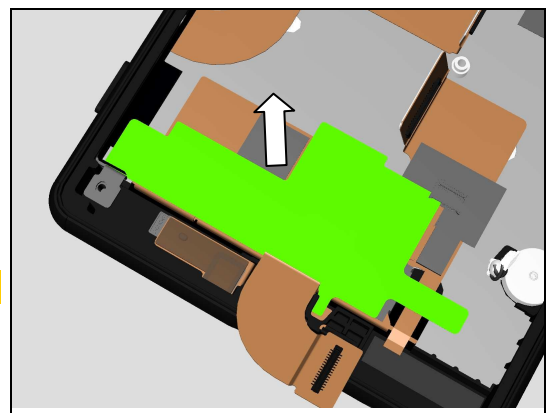
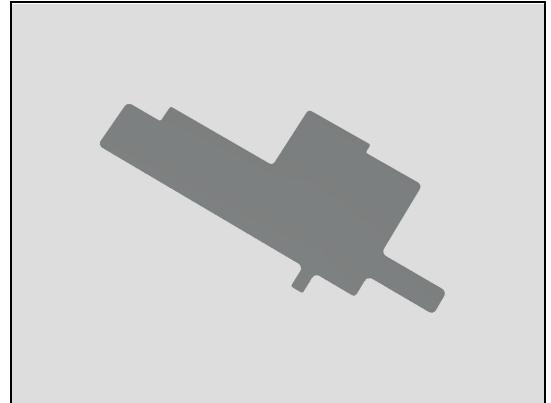
Detach the Conductive Tape LCM FPC and remove it with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Conductive Tape LCM FPC by using a pair of Plastic Tweezers as shown in picture.

**Note! The area indicated as shown must be pasted onto the USB FPC Assy.**



## Replacement

### 4.32 Conductive Tape SD

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Follow the 4.53 Removal instructions!*  
 Prepare a new Conductive Tape SD.  
*Follow the 4.53 Installation instructions!*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

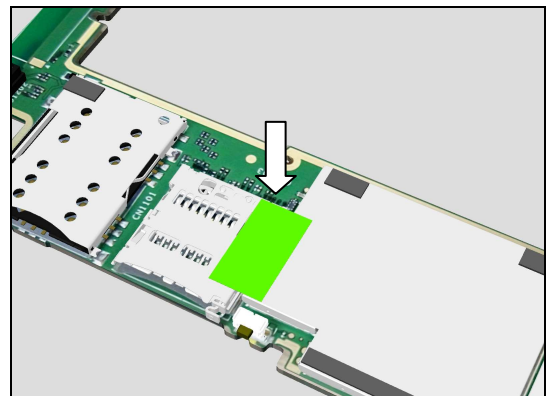
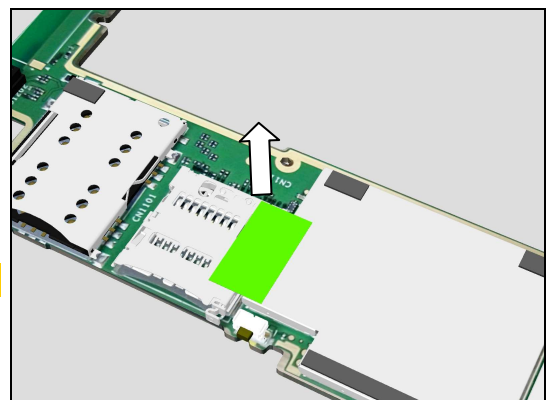
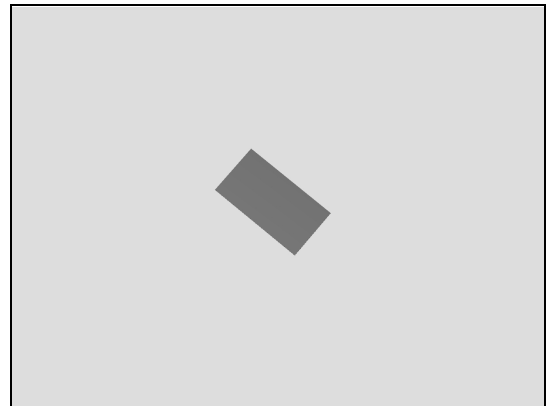
#### REMOVAL

Detach the Conductive Tape SD and remove it with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Conductive Tape SD by using a pair of Plastic Tweezers as shown in picture.



## Replacement

### 4.33 Conductive Tape Shield CPU 1

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Conductive Tape Shield CPU 1.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

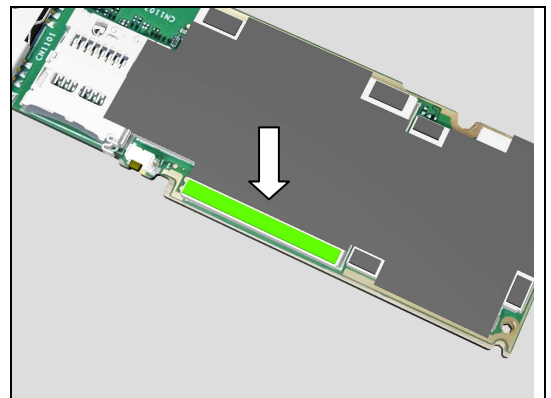
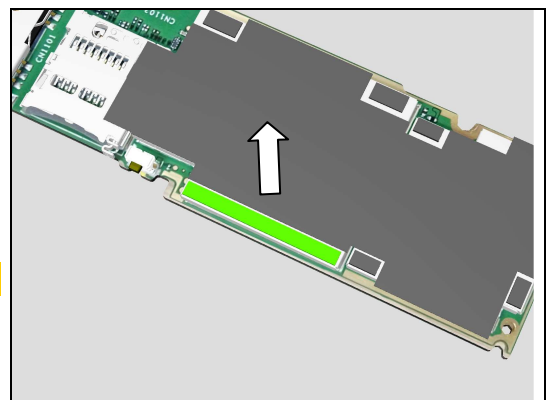
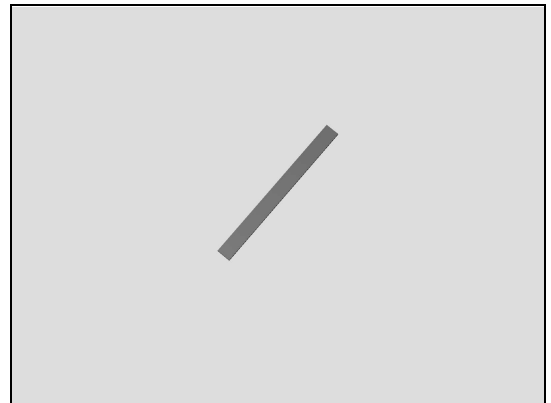
#### REMOVAL

Detach the Conductive Tape Shield CPU 1 and remove it with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Conductive Tape Shield CPU 1 by using a pair of Plastic Tweezers as shown in picture.



## Replacement

### 4.34 Conductive Tape Shield CPU 2

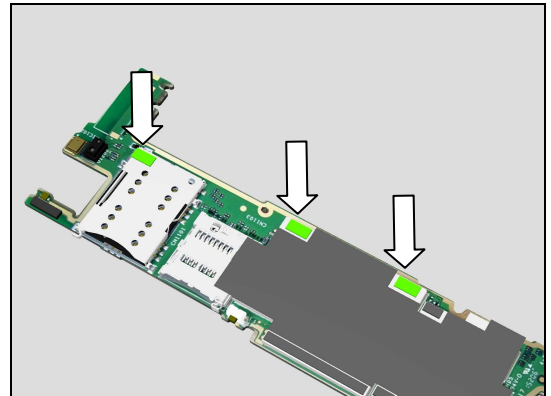
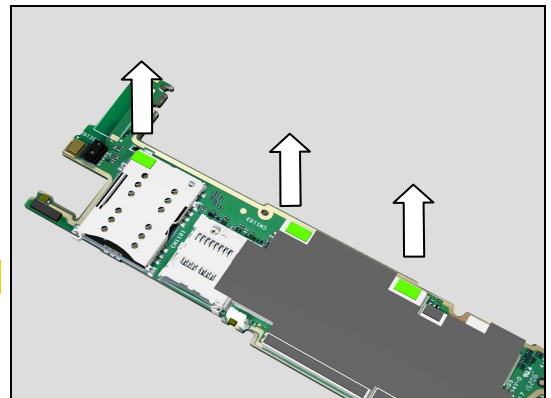
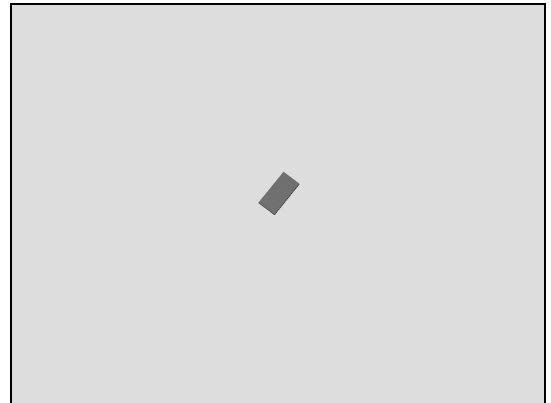
*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Conductive Tape Shield CPU 2.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

Detach the Conductive Tape Shield CPU 2 and remove them with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

Attach a new Conductive Tape Shield CPU 2 by using a pair of Plastic Tweezers as shown in picture.





## Replacement

### 4.35 Conductive Tape Shield Phone 1

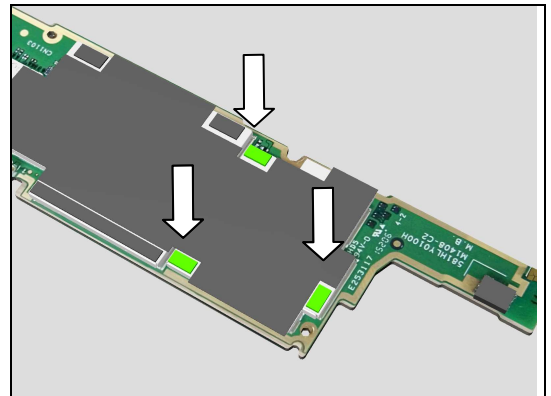
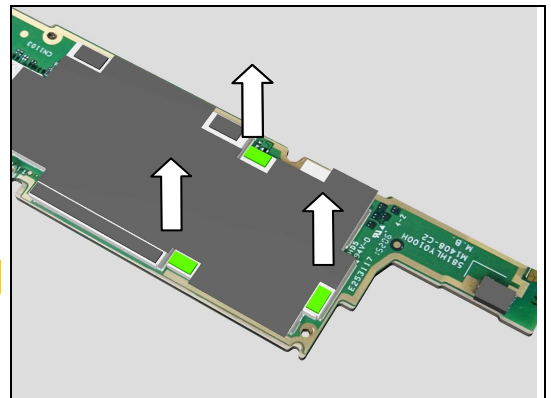
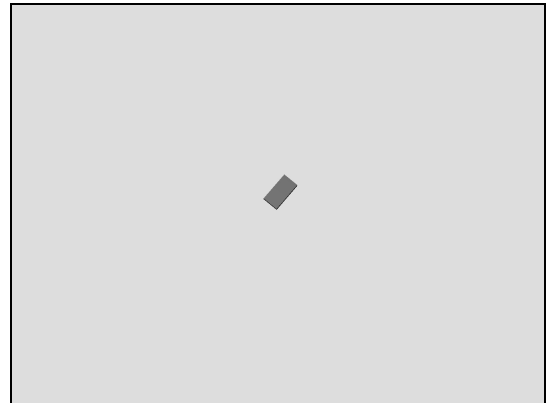
*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Conductive Tape Shield Phone 1.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

Detach the Conductive Tape Shield Phone 1 and remove them with a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

Attach a new Conductive Tape Shield Phone 1 by using a pair of Plastic Tweezers as shown in picture.



## Replacement

### 4.36 Core Unit Label

*Prepare a new Core Unit Label.*

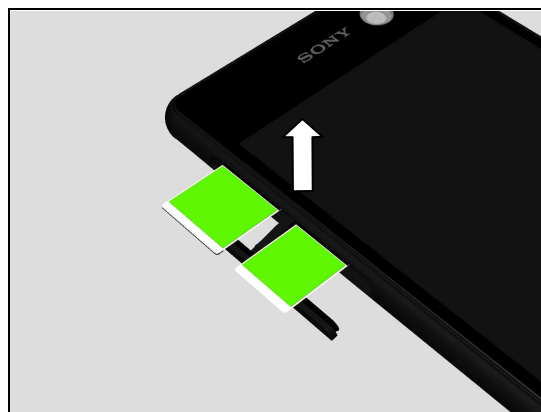
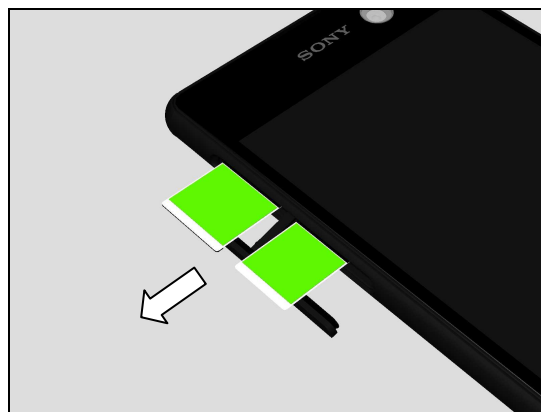
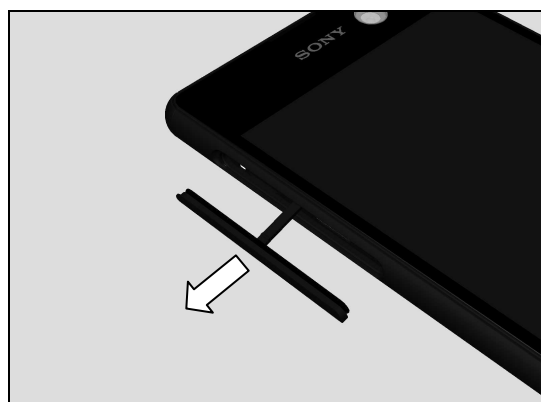
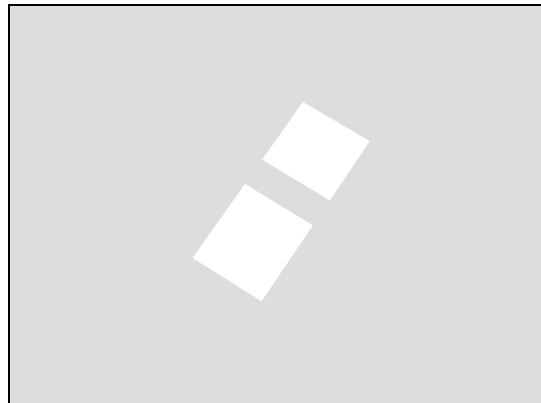
#### REMOVAL

Open the Cap SIM/SD.

Pull out the Tray Core Unit Label with fingers.

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.**



## Replacement: Core Unit Label

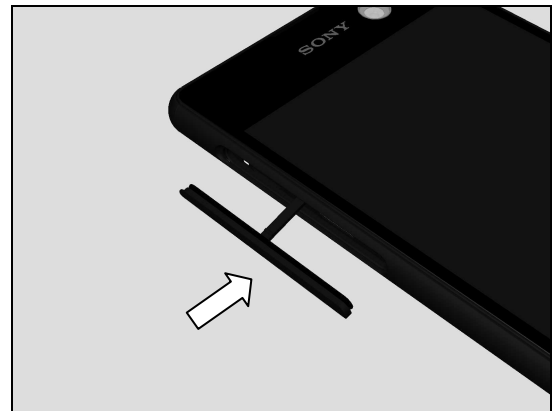
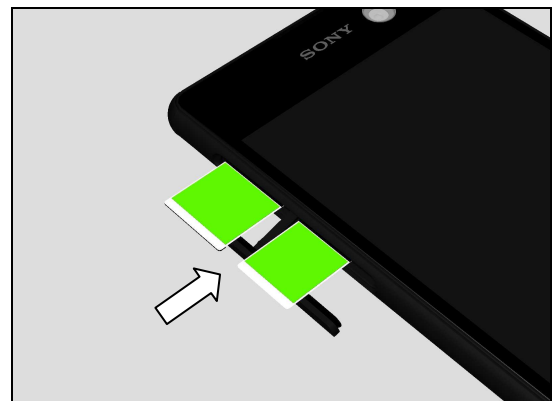
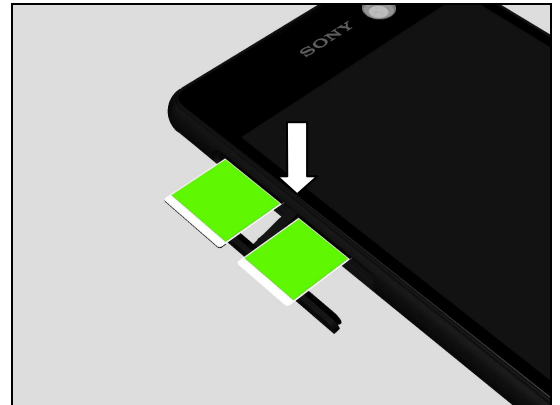
### INSTALLATION

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 Core Unit Label in its proper position as shown in picture.

Push the Tray Core Unit Label into the slot.

Close the Cap SIM/SD.



## Replacement

### 4.37 Cushion Holder Speaker Main Ant Assy

*Follow the 3.1 – 3.8 Disassembly instructions!*

Prepare a new Cushion Holder Speaker Main Ant Assy.

*Follow the 5.5 – 5.12 Reassembly instructions!*

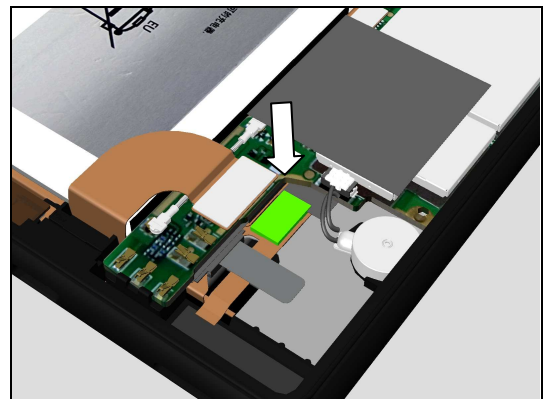
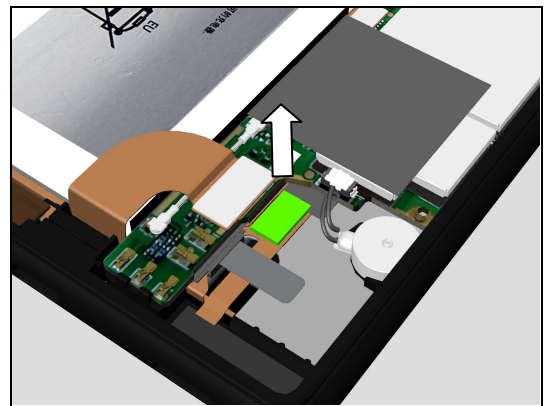
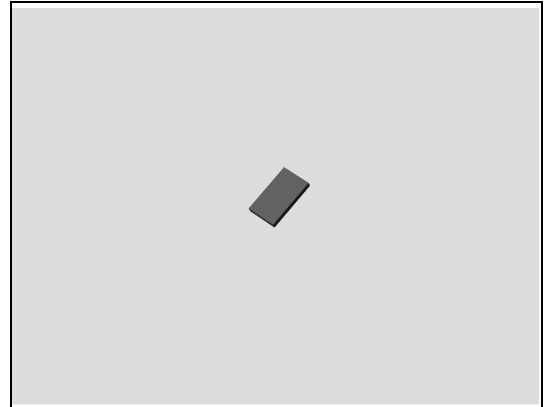
#### REMOVAL

Detach to remove the Cushion Holder Speaker Main Ant Assy.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Cushion Holder Speaker Main Ant Assy in its proper position as shown in picture.



## Replacement

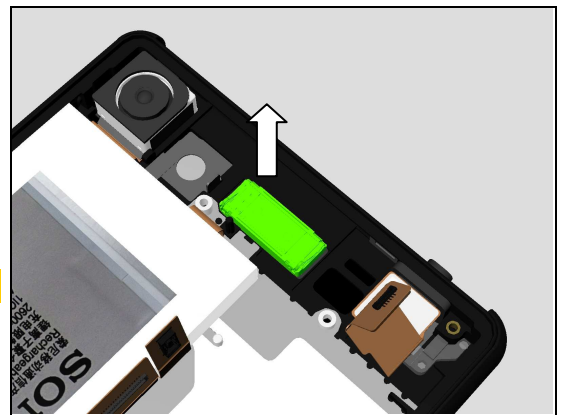
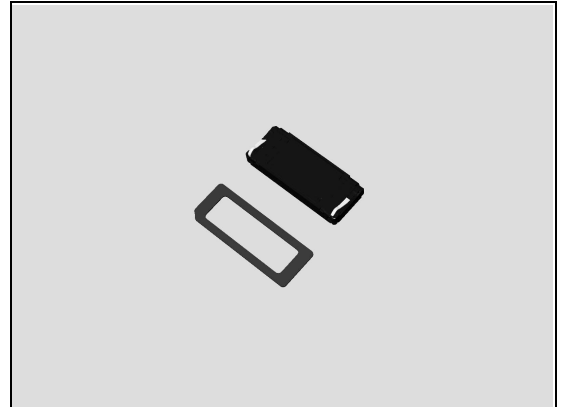
### 4.38 Earspeaker and Adhesive WR Earspeaker

Follow the 3.1 – 3.12 Disassembly instructions!  
Prepare a new Earspeaker and Adhesive WR Earspeaker.

#### REMOVAL

Detach to remove the Earspeaker by using the Front Opening Tool.

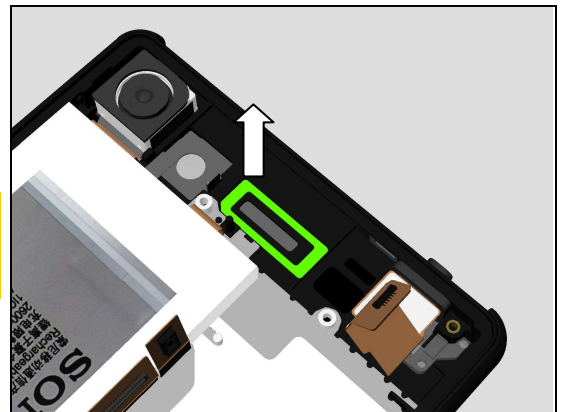
**Scrap! Not to be reused!**



Detach to remove the Adhesive WR Earspeaker by using the Front Opening Tool.

**Scrap! Not to be reused!**

**Make sure all remaining adhesive residue have been removed!**

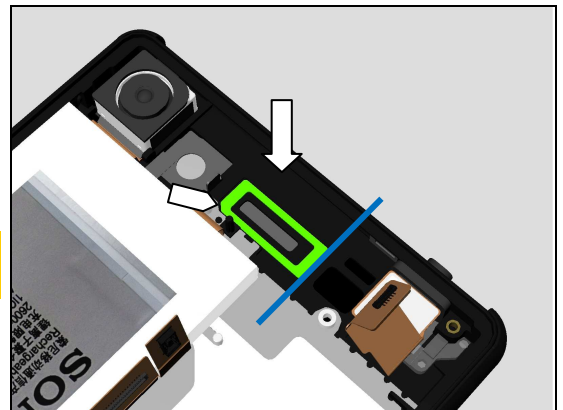


#### INSTALLATION

Attach a new Adhesive WR Earspeaker aligning with the right side as shown in picture.

**Note the correct orientation of the Adhesive WR Earspeaker to be installed as shown in picture!**

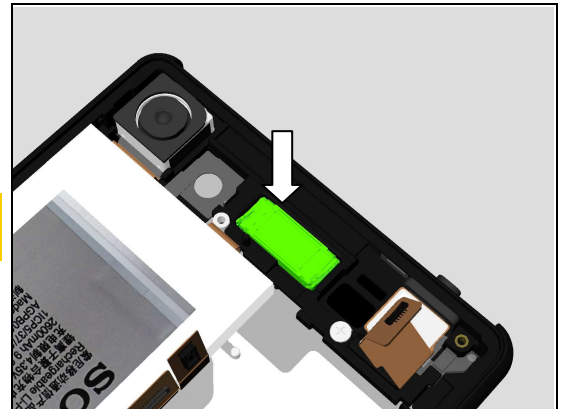
Follow the 5.1 Reassembly instructions!



## Replacement: Earspeaker and Adhesive WR Earspeaker

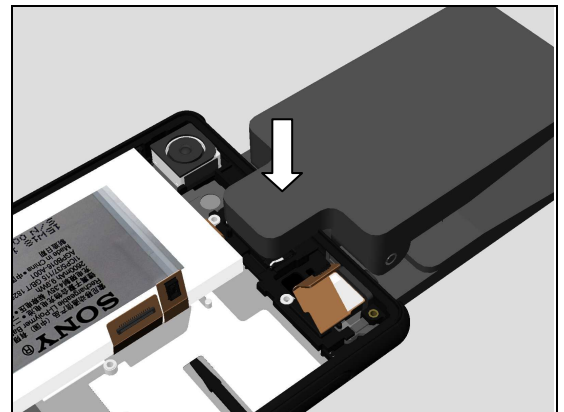
Mount a new Earspeaker in its cavity.

**Note the correct orientation of the Earspeaker contact spring to be installed as shown in picture!**



Press it by using the Press Tool (for Earspeaker) for 10 seconds.

Follow the 5.2 – 5.12 Reassembly instructions!



## Replacement

### 4.39 Flash Lens Rubber

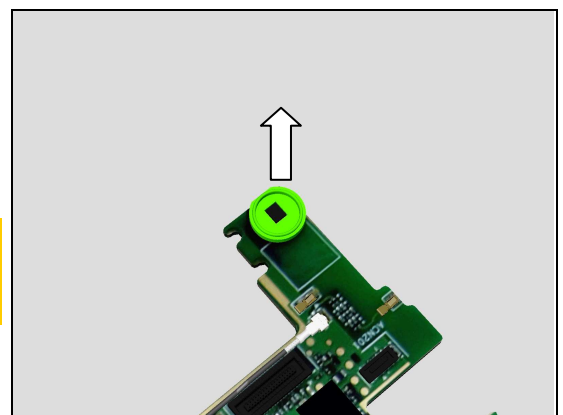
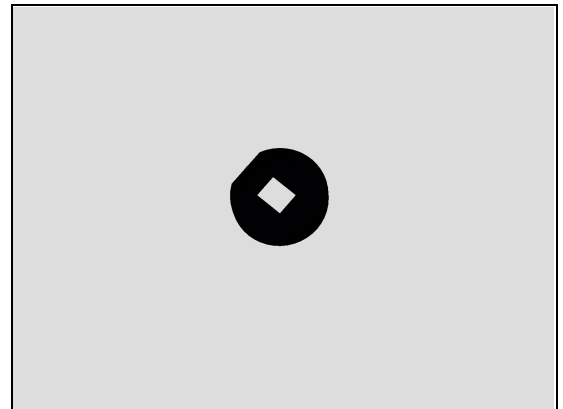
*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Flash Lens Rubber.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

Detach to remove the Flash Lens Rubber.

***Scrap! Not to be reused!***

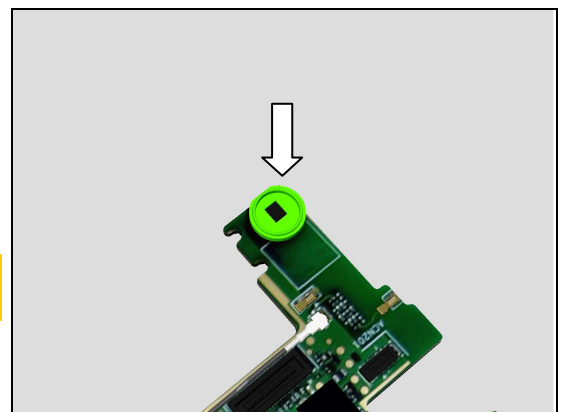
***Make sure all remaining adhesive residue have been removed!***



#### INSTALLATION

Attach a new Flash Lens Rubber in its proper position as shown in picture.

***Note the correct orientation of the Flash Lens Rubber to be installed as shown in picture!***



## Replacement

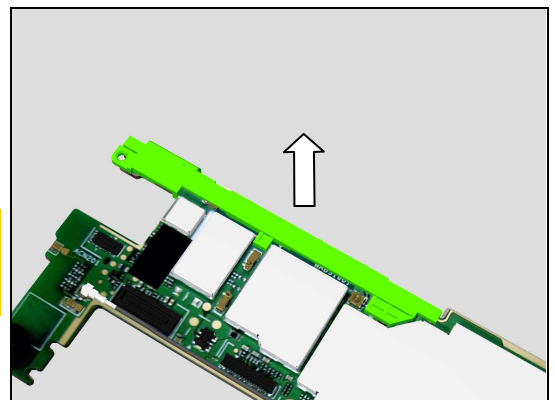
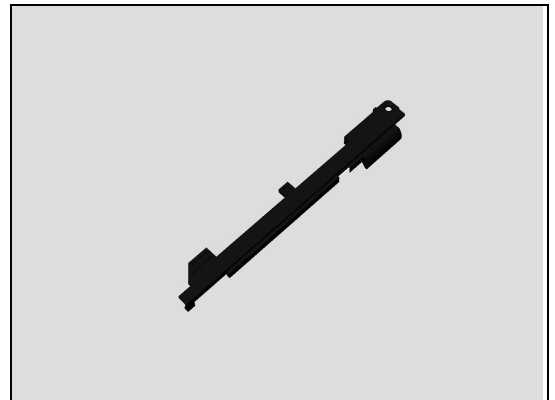
### 4.40 Holder GPS/WiFi Ant Assy

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Holder GPS/WiFi Ant Assy.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

Detach the Holder GPS/WiFi Ant Assy.

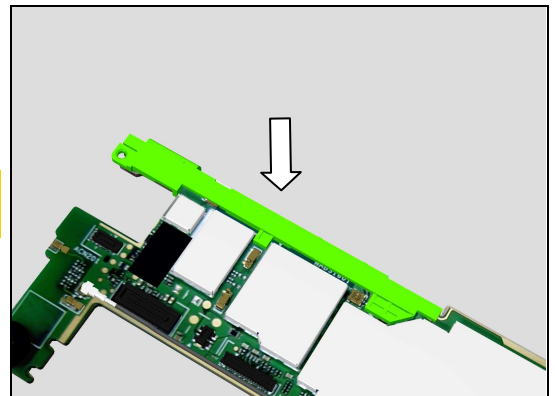
**Do not damage components on the Main PBA!**  
**Make sure all remaining adhesive residue on the Main PBA have been removed!**



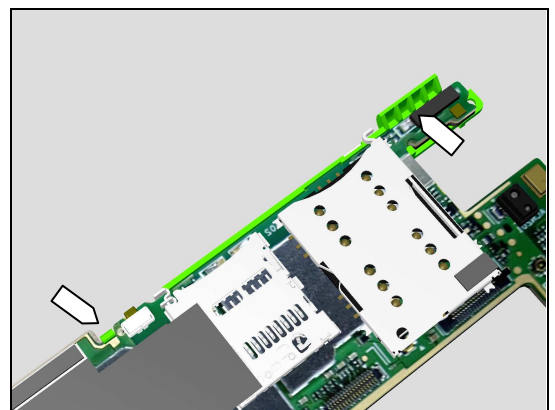
#### INSTALLATION

**Replace new Adhesive Holder GPS/WiFi Ant Assy 1&2&3 if Holder GPS/WiFi Ant Assy is reused**

Attach a new Holder GPS/WiFi Ant Assy in its proper position as shown in picture.



Secure the correct position of the Holder GPS/WiFi Ant Assy.





## Replacement

### 4.41 Holder USB

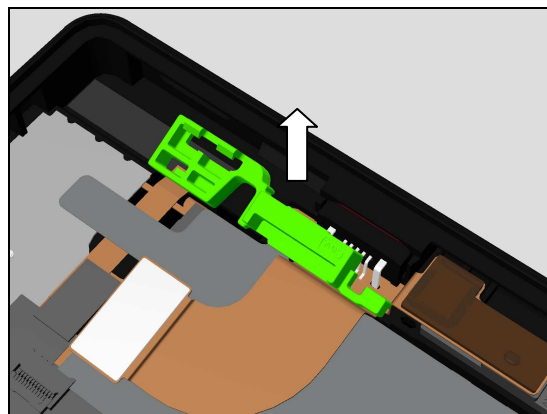
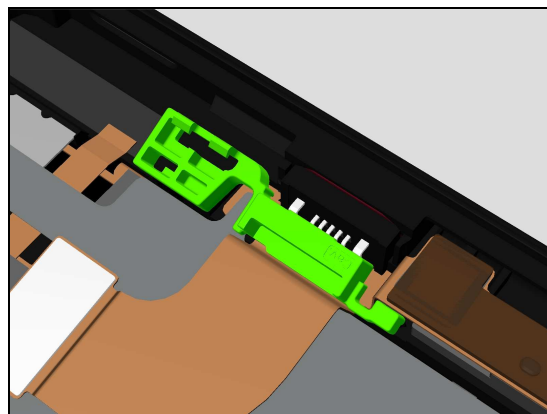
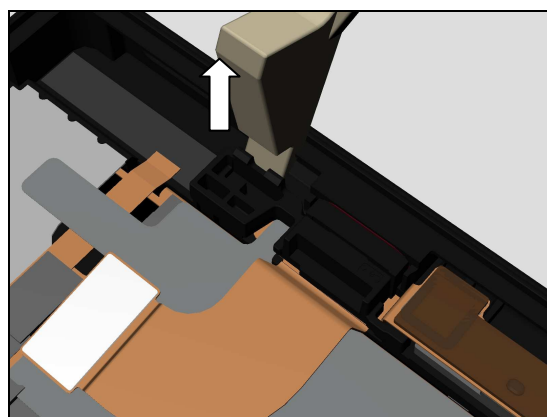
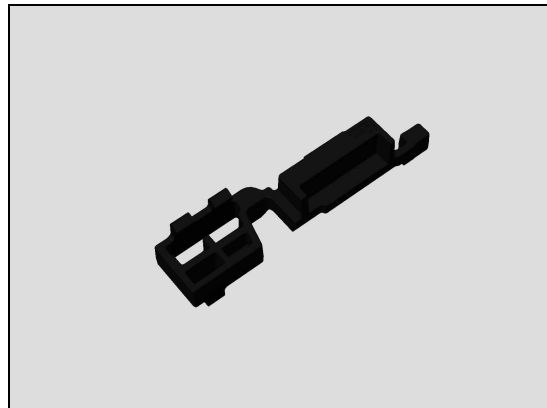
*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23 Removal instructions!*  
*Prepare a new Holder USB.*  
*Follow the 4.24 and 4.23 Installation instructions!*

#### REMOVAL

Unsnap the Holder USB by using the Front Opening Tool.

Release the Holder USB.

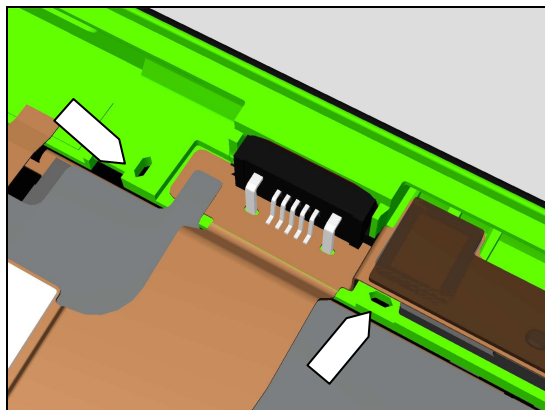
Remove it.



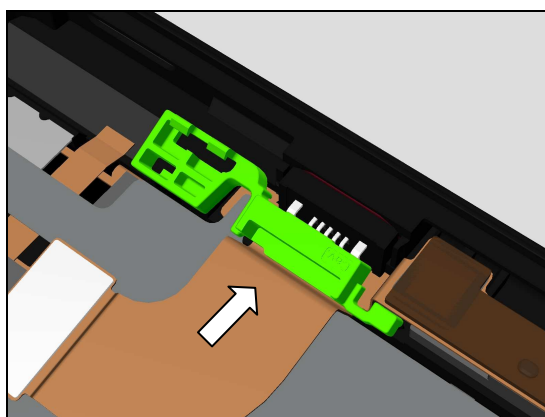
## Replacement: Holder USB

### INSTALLATION

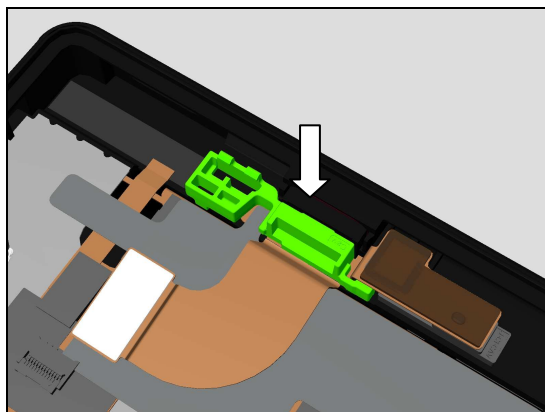
Identify the two guiding holes as shown in picture.



Insert to mount the Holder USB.



Press to snap the Holder USB.



## Replacement

### 4.42 LCM Gasket

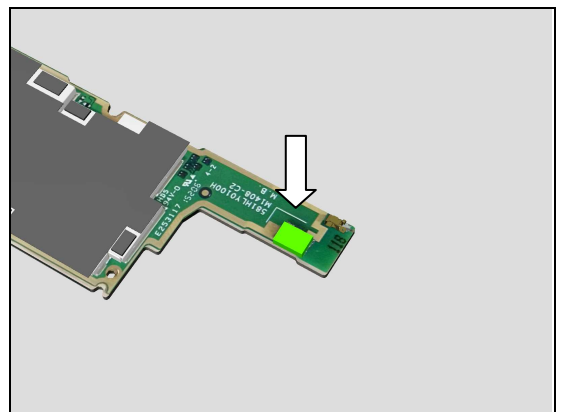
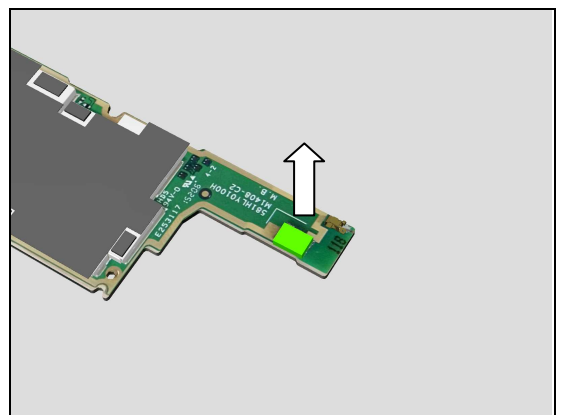
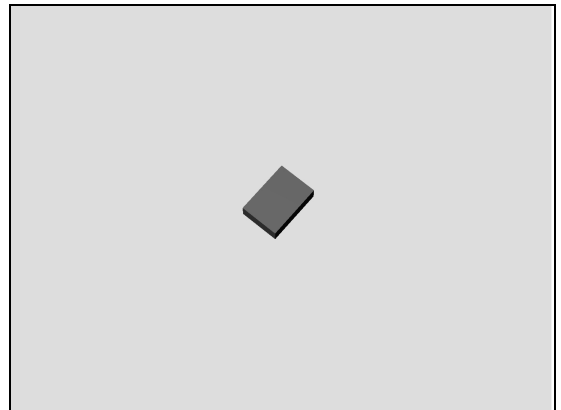
*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new LCM Gasket.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

Detach the LCM Gasket by using a pair of Plastic Tweezers.

**Scrap! Not to be reused!**

**Make sure all remaining adhesive residue have been removed!**



#### INSTALLATION

Attach a new LCM Gasket in its proper position as shown in picture.

## Replacement

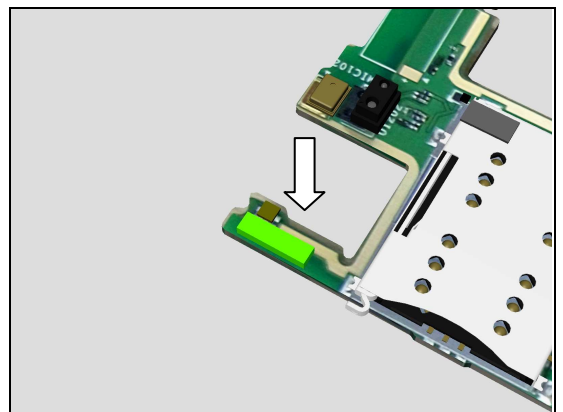
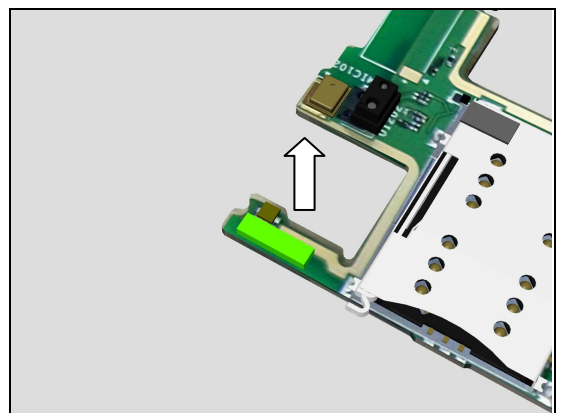
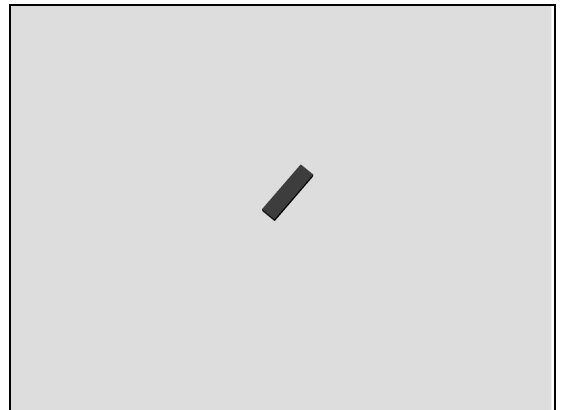
### 4.43 LED Cushion

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new LED Cushion.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

Detach the LED Cushion.

**Scrap! Not to be used.**



#### INSTALLATION

Attach a new LED Cushion in its proper position as shown in picture.

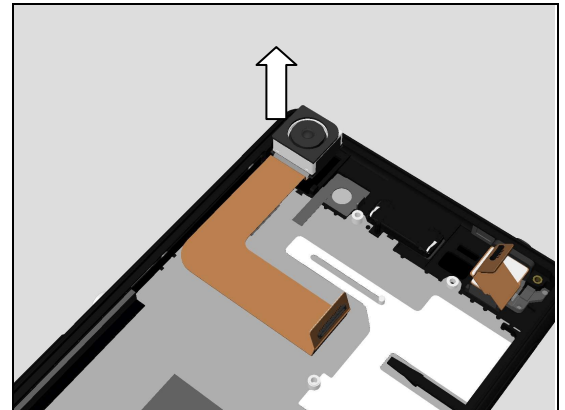
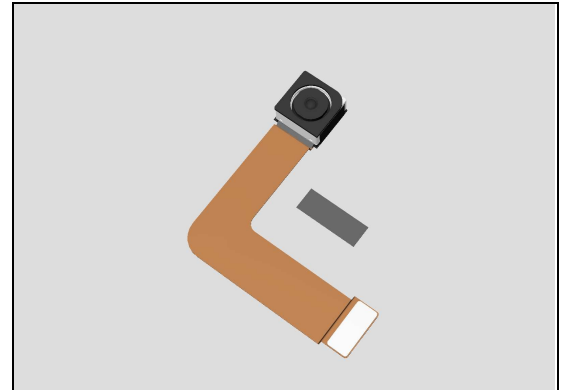
## Replacement

### 4.44 Main Camera and Conductive Adhesive Main Camera FPC

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23 Removal instructions!*  
 Prepare a new Main Camera and Conductive Adhesive Main Camera FPC.

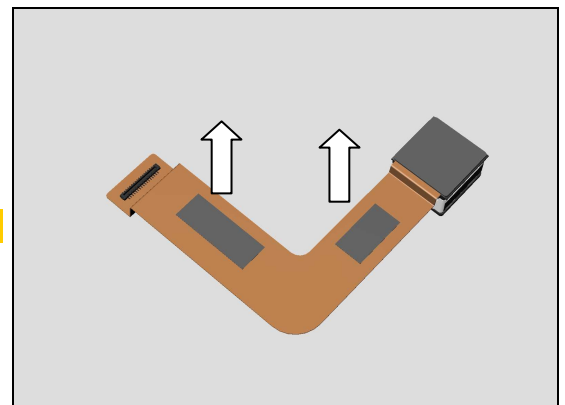
#### REMOVAL

Detach the Main Camera.



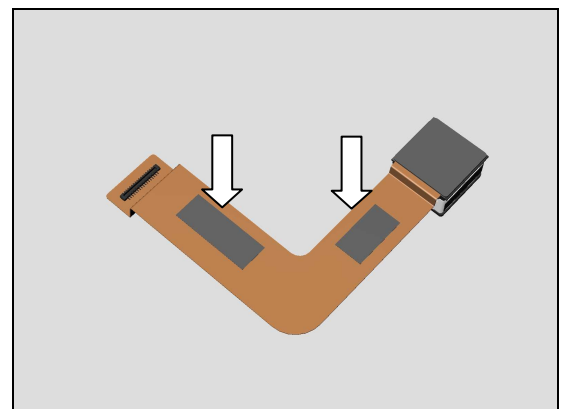
Detach the Conductive Adhesive Main Camera FPC.

**Scrap! Not to be reused!**



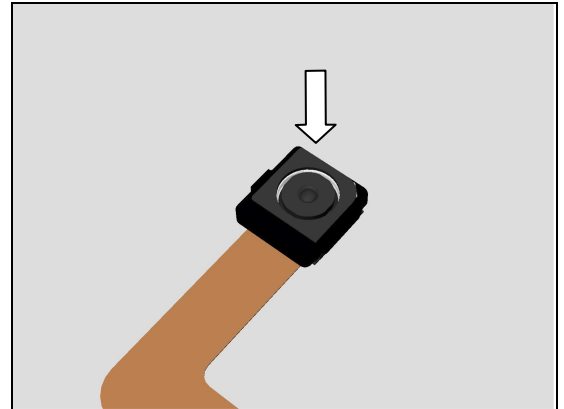
#### INSTALLATION

Attach new Conductive Adhesive Main Camera FPC in alignment with the guiding lines on the FPC.



## Replacement: Main Camera and Conductive Adhesive Main Camera FPC

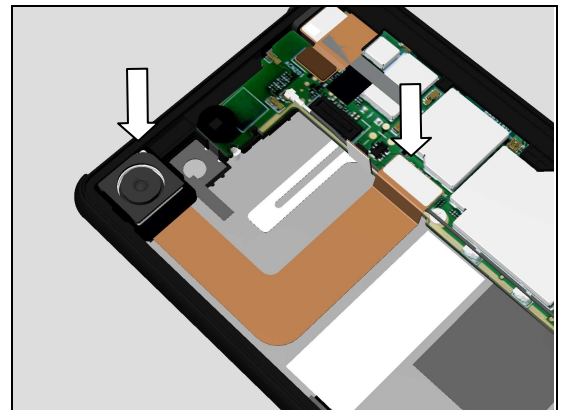
Mount the Main Camera Rubber.



Attach a new Adhesive Battery 1 and Adhesive Battery 2.

Follow the 5.1 – 5.3 Reassembly instructions to assemble Main PBA!

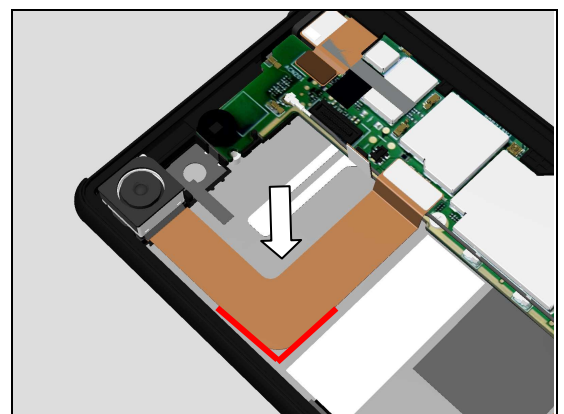
Mount the Main Camera into its cavity and Press to snap the BtB connector of the Main Camera FPC.



Attach the Main Camera FPC aligning with the guiding lines as shown in picture.

Remove the Main Camera Rubber.

*Follow the 4.24 and 4.23 Installation instructions!*



## Replacement

### 4.45 Main Mic Rubber

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23, 4.41, 4.55 and 4.56 Removal instructions!*  
 Prepare a new Main Mic Rubber.

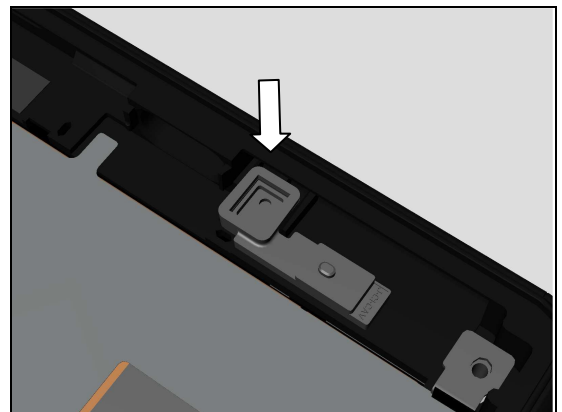
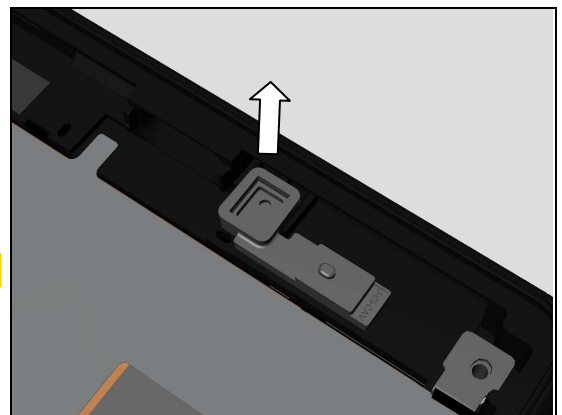
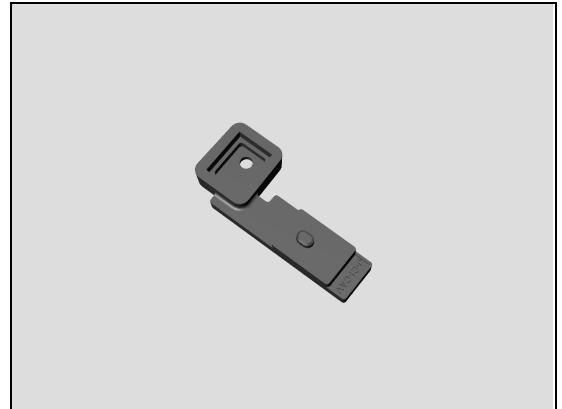
#### REMOVAL

Detach the Main Mic Rubber.

**Scrap! Not to be reused!**

Attach a new Main Mic Rubber in its proper position as shown in picture.

*Follow the 4.56, 4.18, 4.55, 4.41, 4.24 and 4.23 Installation instructions!*



## Replacement

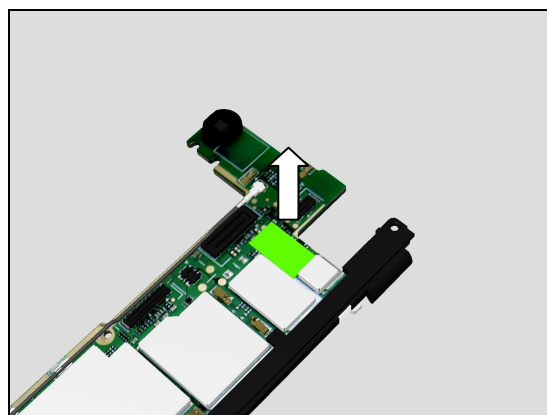
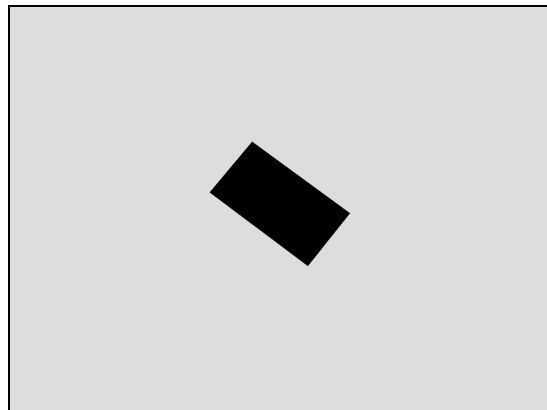
### 4.46 Mylar PCB Front

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Mylar PCB Front.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

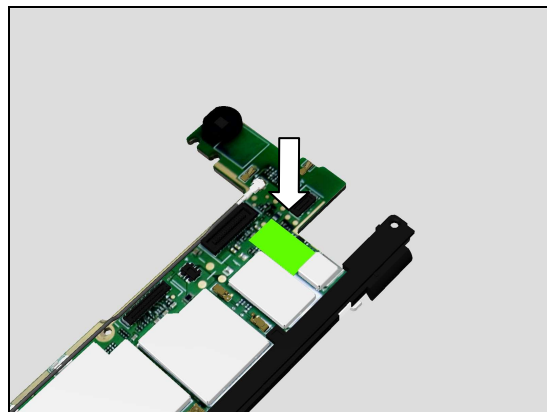
Detach Mylar PCB Front.

**Scrap! Not to be reused!**



#### INSTALLATION

Attach a new Mylar PCB Front as shown in picture.





## Replacement

### 4.47 RF Cable Lower

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new RF Cable Lower.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

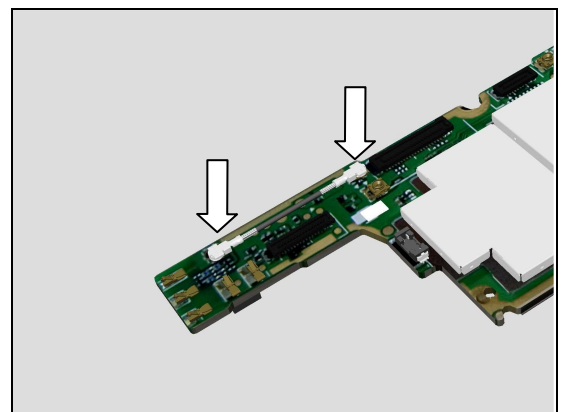
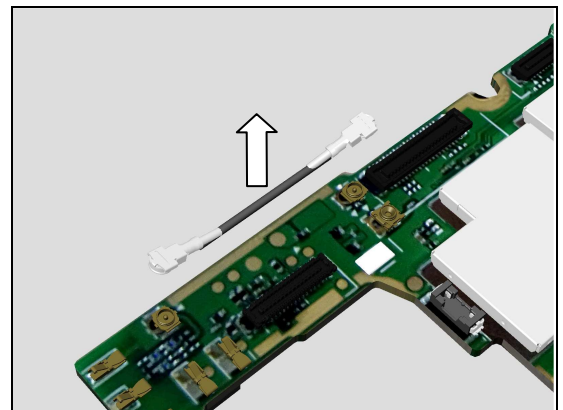
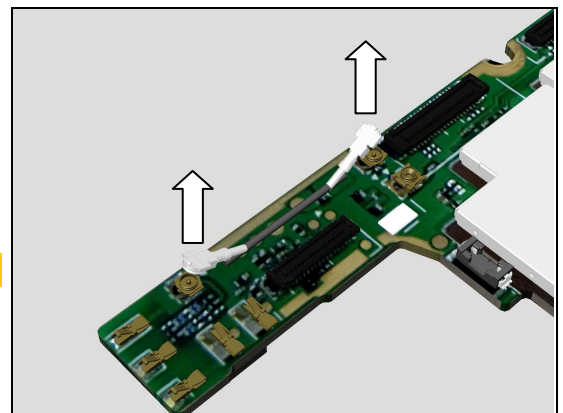
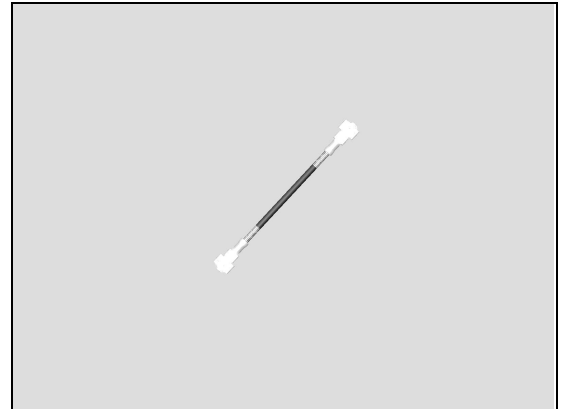
Disconnect RF Cable Lower connectors.

**Do not damage components on the Main PBA!**

Remove the RF Cable Lower.

#### INSTALLATION

Press to snap the RF cable Lower connectors.



## Replacement

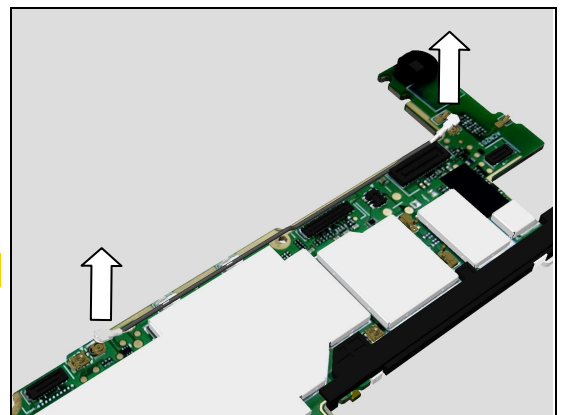
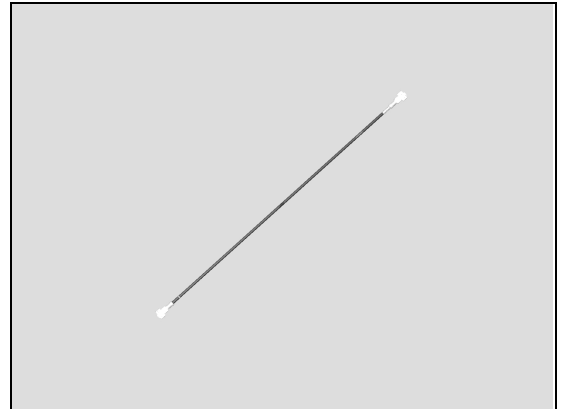
### 4.48 RF Cable Upper

Follow the 3.1 – 3.10 Disassembly instructions!  
Prepare a new RF Cable Upper.  
Follow the 5.3 – 5.12 Reassembly instructions!

#### REMOVAL

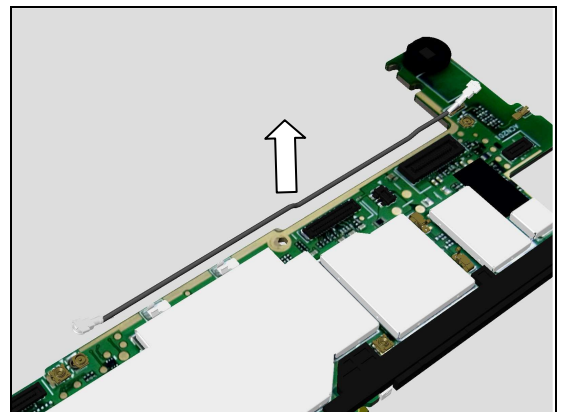
Disconnect RF Cable Upper connectors.

**Do not damage components on the Main PBA!**



#### INSTALLATION

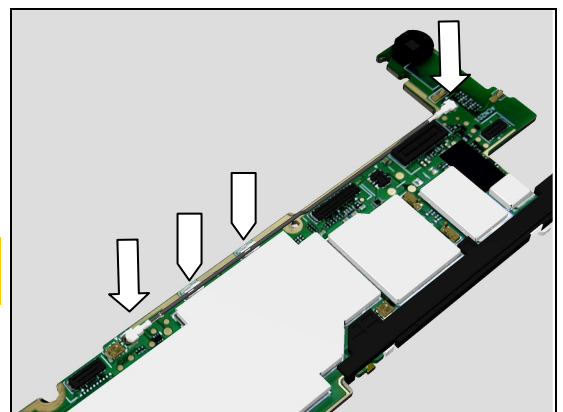
Remove the RF Cable Upper.



#### INSTALLATION

Press to snap the RF cable Upper connectors.

**Note! Make sure the two metal parts of the RF Cable Upper are mounted into the clips.**



## Replacement

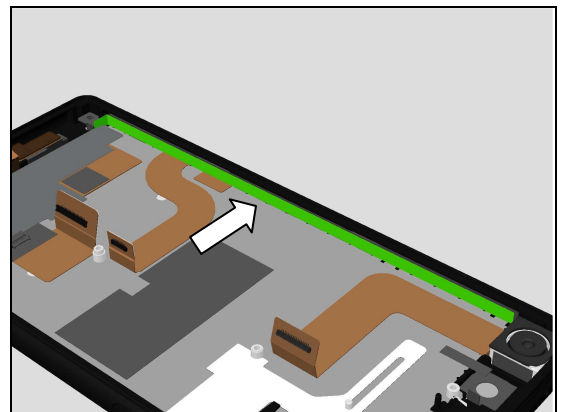
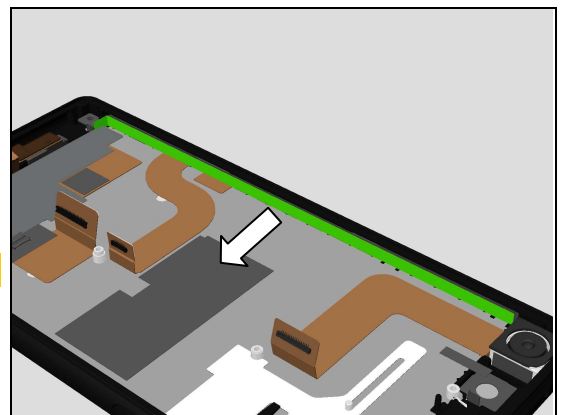
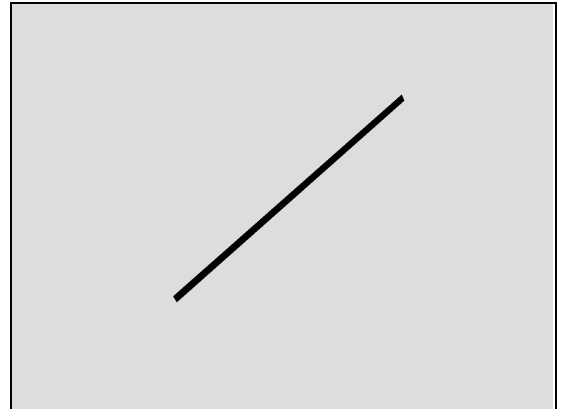
### 4.49 Sidekey Bracket Mylar

Follow the 3.1 – 3.12 Disassembly instructions!  
 Follow the 4.23, 4.50 and 4.51 Removal instructions!  
 Prepare a new Sidekey Bracket Mylar.  
 Follow the 4.51, 4.50, 4.24 and 4.23 Installation instructions!

#### REMOVAL

Detach the Sidekey Bracket Mylar.

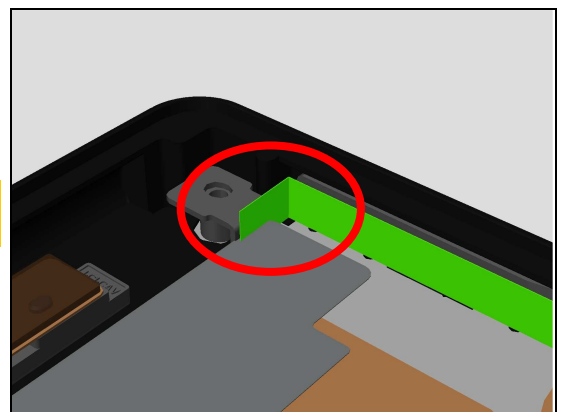
**Scrap! Not to be reused!**



#### INSTALLATION

Attach a new Sidekey Bracket Mylar as shown in picture.

**Note! The Sidekey Bracket Mylar is attached along the sidekey FPC bracket.**



## Replacement

### 4.50 Sidekey Cushion 1

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23 Removal instructions!*  
*Prepare a new Sidekey Cushion 1.*  
*Follow the 4.24 and 4.23 Installation instructions!*

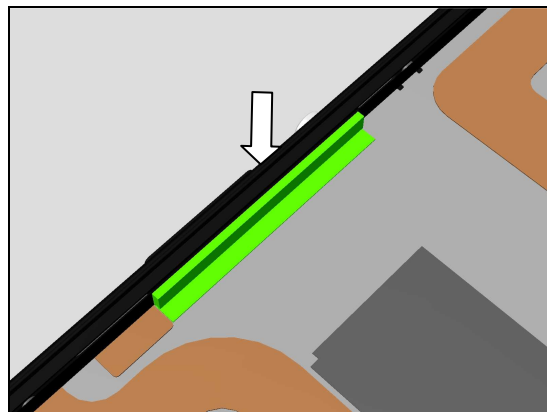
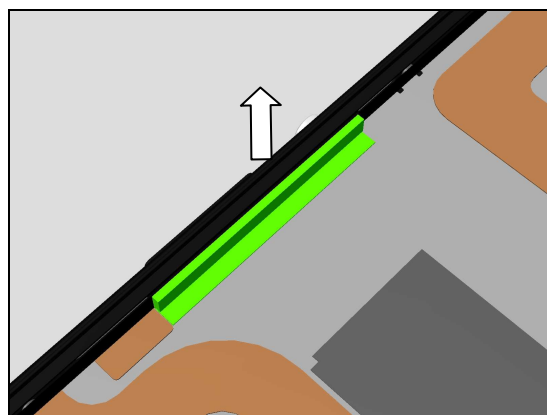
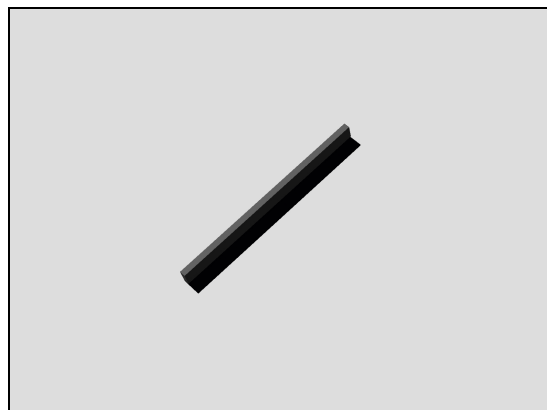
#### REMOVAL

Detach the Sidekey Cushion 1.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Sidekey Cushion 1 as shown in picture.



## Replacement

### 4.51 Sidekey Cushion 2

Follow the 3.1 – 3.12 Disassembly instructions!  
 Follow the 4.23 Removal instructions!  
 Prepare a new Sidekey Cushion 2.  
 Follow the 4.24 and 4.23 Installation instructions!

#### REMOVAL

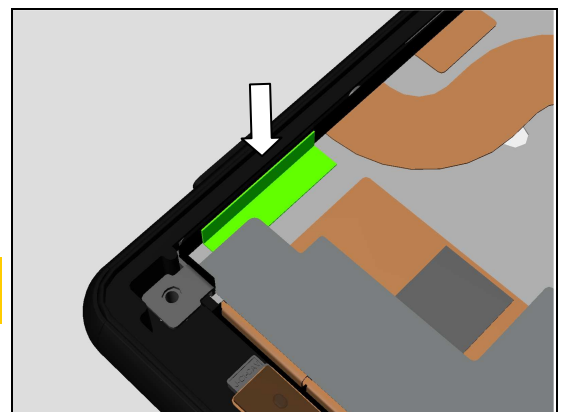
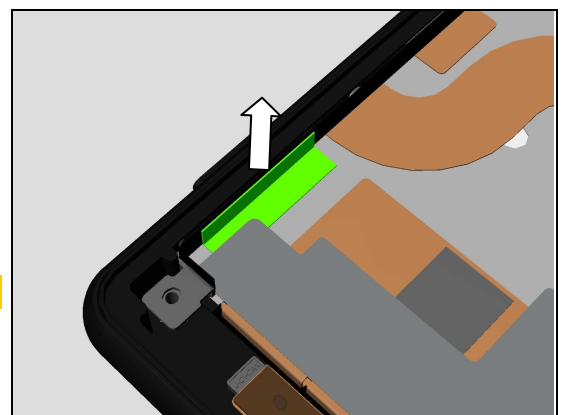
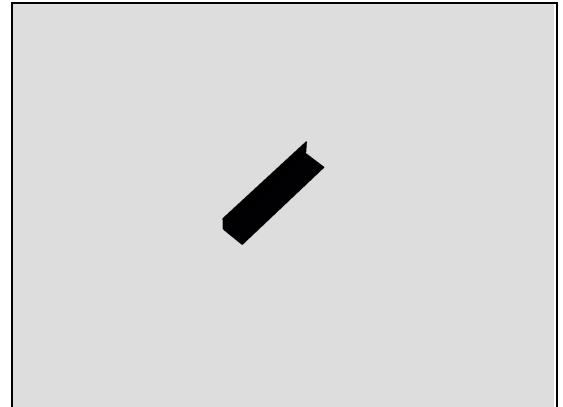
Peel off Conductive Tape LCM FPC.  
 Detach the Sidekey Cushion 2.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Sidekey Cushion 2 in its proper position.  
 Re-attach the Conductive Tape LCM FPC.

**If Conductive Tape LCM FPC lose its stickiness replace a new one.**



## Replacement

### 4.52 Sidekey FPC Assy

*Follow the 3.1 – 3.12 Disassembly instructions!*

*Follow the 4.23, 4.50, 4.51 and 4.49 Removal instructions!*

*Prepare a new Sidekey FPC Assy.*

*Follow the 4.49, 4.51, 4.50, 4.24 and 4.23 Installation instructions!*

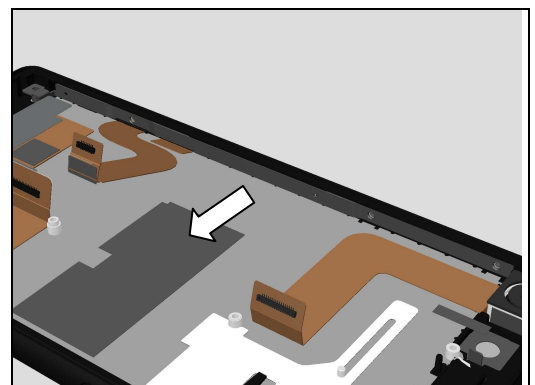
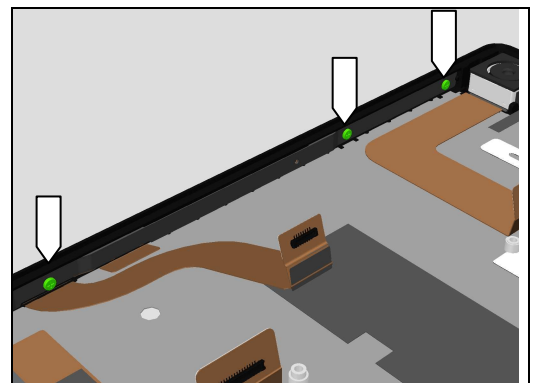
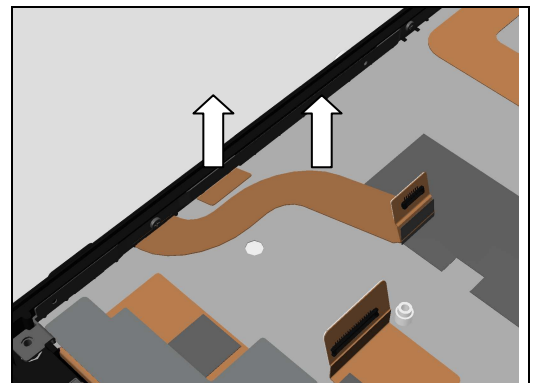
**Accelerometer Calibration must be performed for all replaced units; 1289-2983 Trouble Shooting Application – mechanical.**

#### REMOVAL

Detach the Sidekey FPC Assy as show in picture.

Remove the three Screw M1.2\_L1.5 by using a Cross Screwdriver.

Remove the Sidekey FPC Assy.

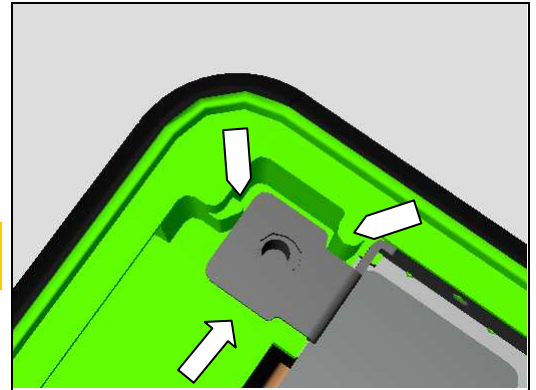


## Replacement: Sidekey FPC Assy

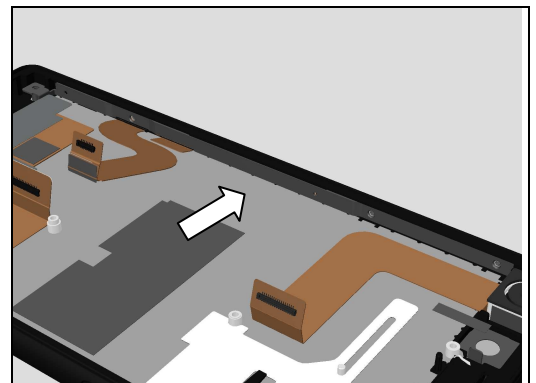
### INSTALLATION

Mount a new Sidekey FPC Assy from this side firstly.

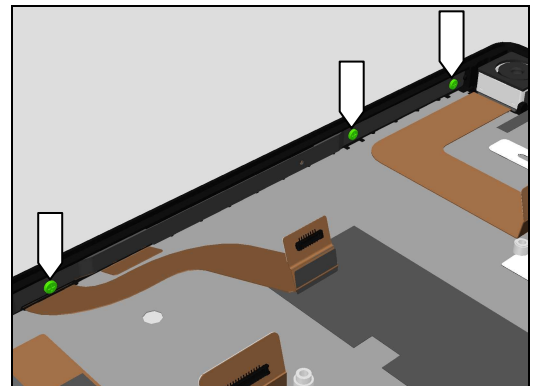
***Make sure the correct position of the Sidekey FPC Assy as shown in picture.***



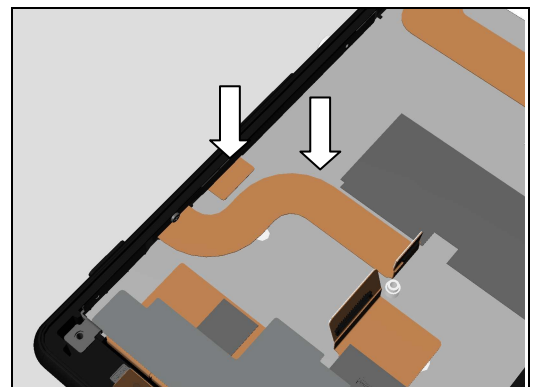
Then mount the other part of the Sidekey FPC Assy as shown in picture.



Tightening the three Screw M1.2\_L1.5 with Cross Screwdriver.



Attach the Sidekey FPC Assy as shown in picture.



## Replacement

### 4.53 Thermal Graphite Sheet Front

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Thermal Graphite Sheet Front.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

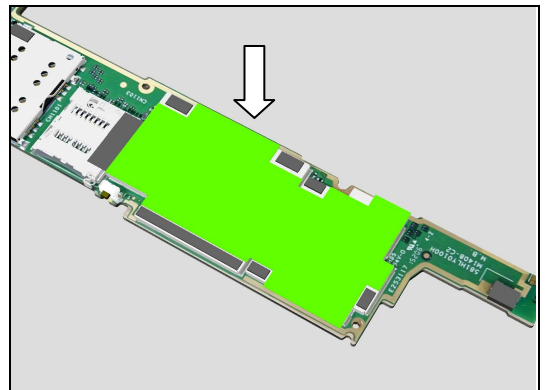
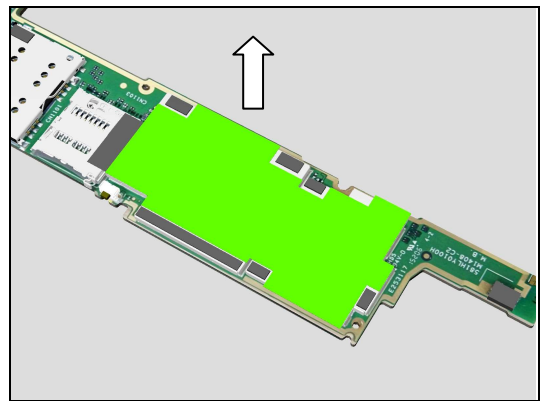
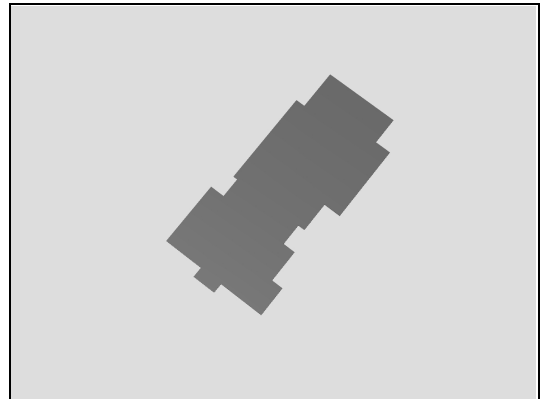
#### REMOVAL

Detach the Thermal Graphite Sheet Front.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Thermal Graphite Sheet Front in alignment with the shielding can lids as shown in picture.





## Replacement

### 4.54 Tray Core Unit Label

*Follow the 3.1 – 3.11 Disassembly instructions!*  
*Prepare a new Tray Core Unit Label.*  
*Follow the 5.2 – 5.12 Reassembly instructions!*

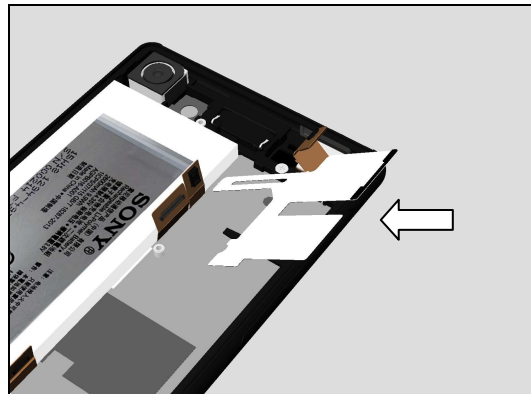
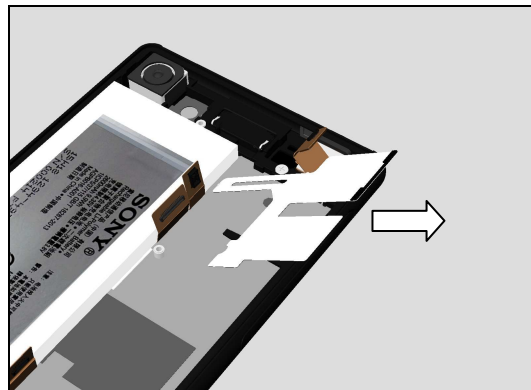
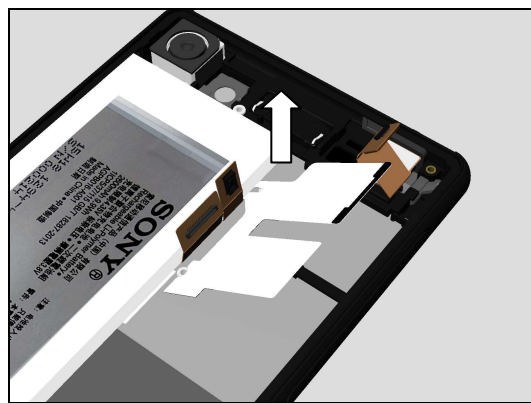
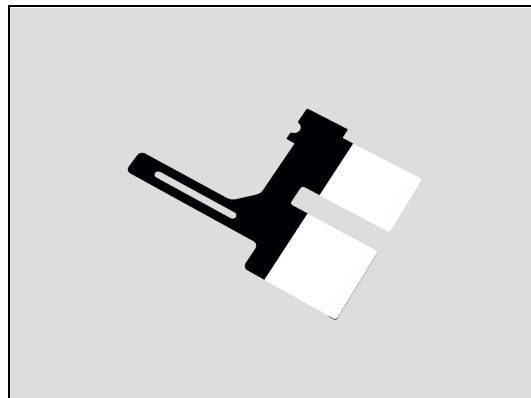
#### REMOVAL

Lift the Tray Core Unit Label.

Remove the Tray Core Unit Label.

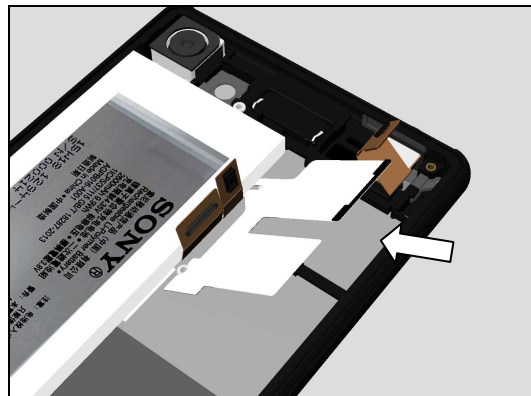
#### INSTALLATION

Insert to mount the Tray Core Unit Label.

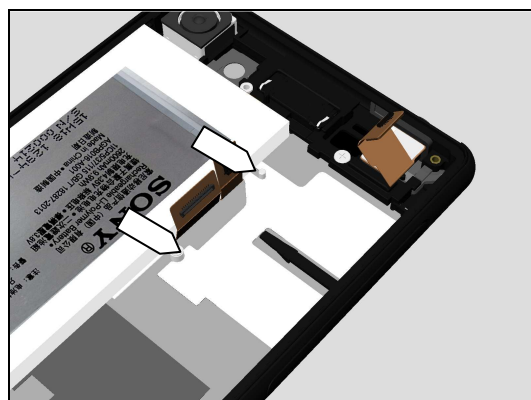


## Replacement: Tray Core Unit Label

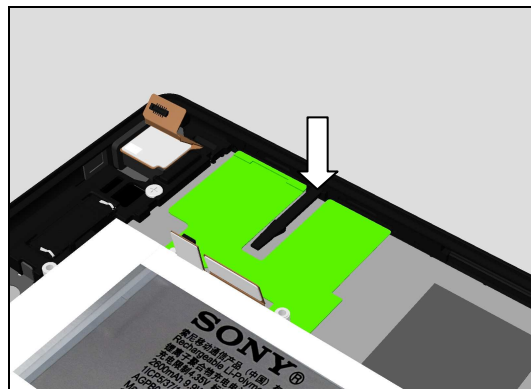
Mount the Tray Core Unit Label to its proper position.



Secure the correct position of the Tray Core Unit Label.



Press the Tray Core Unit Label Attach to its proper position.



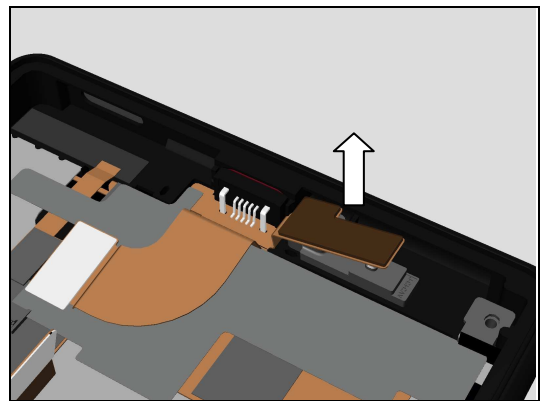
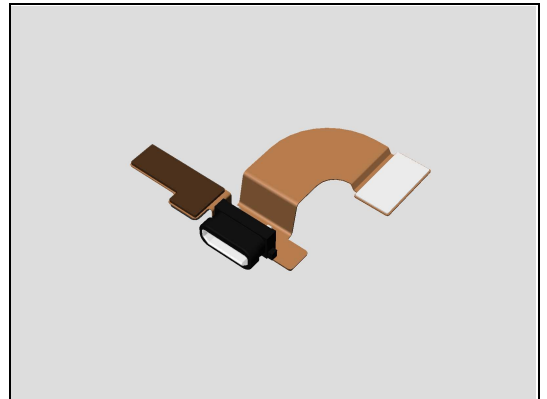
## Replacement

### 4.55 USB FPC Assy

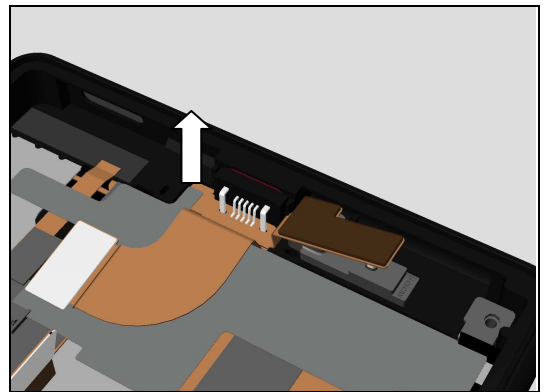
*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23, 4.41, 4.56 and 4.45 Removal instructions!*  
*Prepare a new USB FPC Assy.*  
 Follow the 4.45, 4.56 and 4.18 installation instructions!

#### REMOVAL

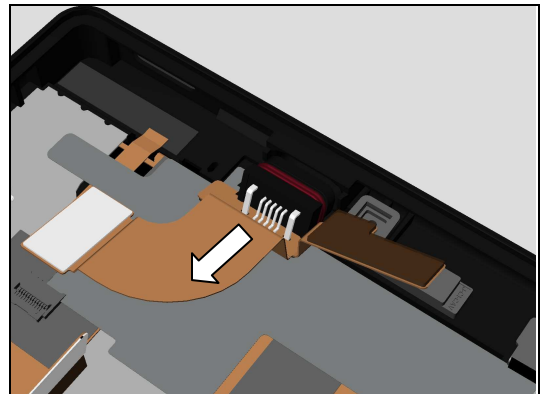
Detach the USB FPC Assy as shown in picture.



Detach the Conductive Tape LCM FPC.



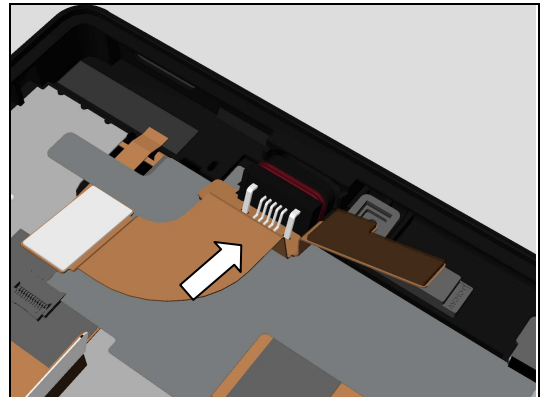
Remove the USB FPC Assy.



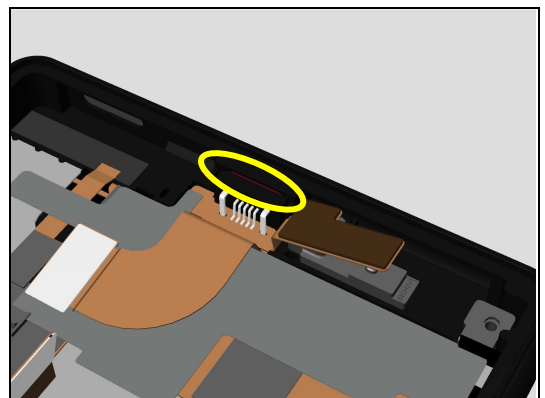
## Replacement: USB FPC Assy

### INSTALLATION

Insert to mount the USB FPC Assy.

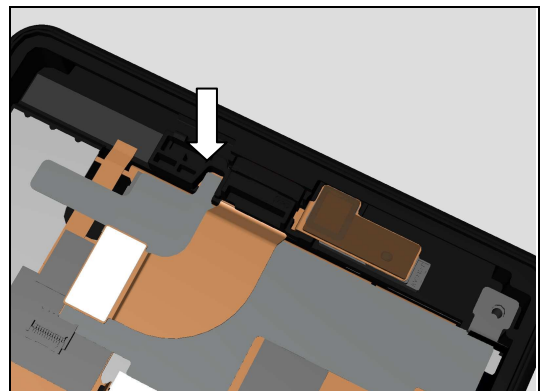


**Make sure the USB O-Ring is mounted into its hole and not twisted since it is for WR purpose!**



Re-attach the Conductive Tape LCM FPC.

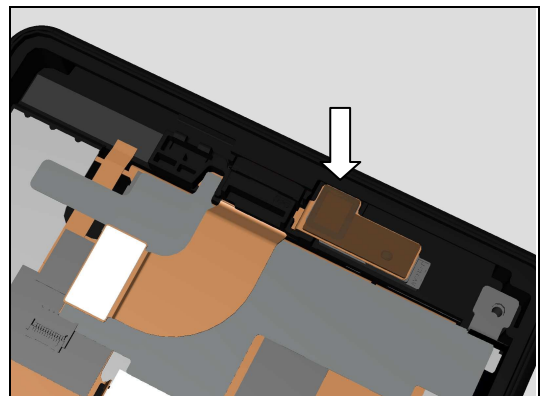
**If Conductive Tape LCM FPC lose its stickiness replace a new one.**



Attache the USB FPC Assy.

**Make sure to secure the good attachment of the USB FPC Assy since it is for WRT purpose!**

Follow the 4.41, 4.24 and 4.23 Installation instructions!



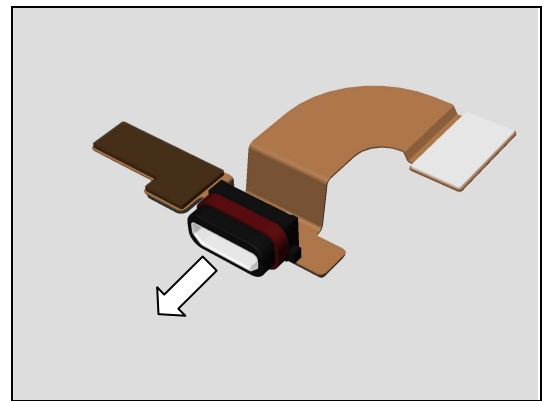
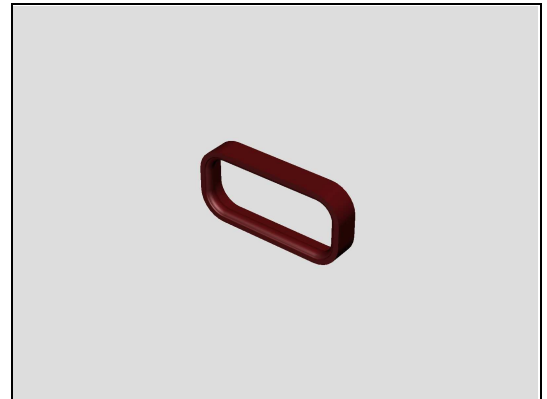
## Replacement

### 4.56 USB O-Ring

*Follow the 3.1 – 3.12 Disassembly instructions!*  
*Follow the 4.23, 4.41, 4.55 and 4.45 Removal instructions!*  
*Prepare a new USB O-Ring.*

#### REMOVAL

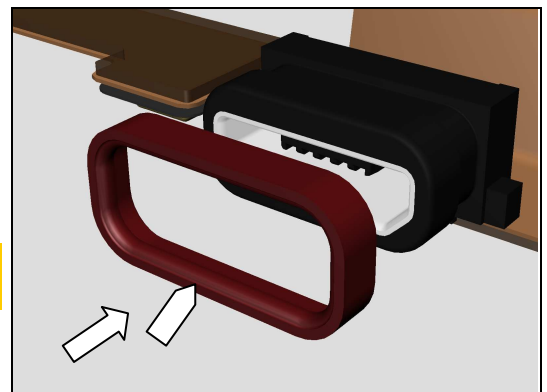
Remove the USB O-Ring.



#### INSTALLATION

Prepare the USB O-Ring and USB FPC Assy as shown in picture.

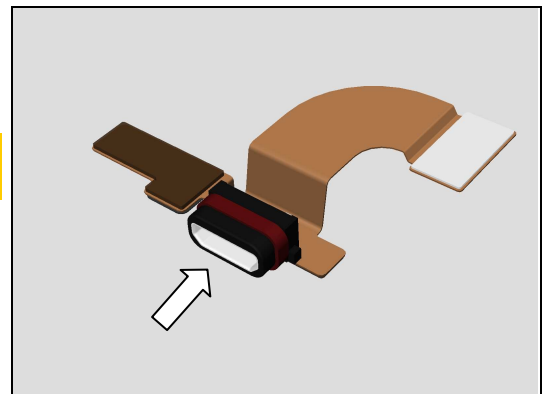
**Note the correct orientation of the USB O-Ring thicker end to be installed as the arrow indicated in picture!**



Mount a new USB O-Ring as show in picture.

**Make sure the USB O-Ring is not twisted after installation.**

Follow the 4.45, 4.18, 4.55, 4.41, 4.24 and 4.23 Installation instructions!



## Replacement

### 4.57 Vibrator

*Follow the 3.1 – 3.8 Disassembly instructions!*  
*Prepare a new Vibrator.*  
*Follow the 5.5 – 5.12 Reassembly instructions!*

#### REMOVAL

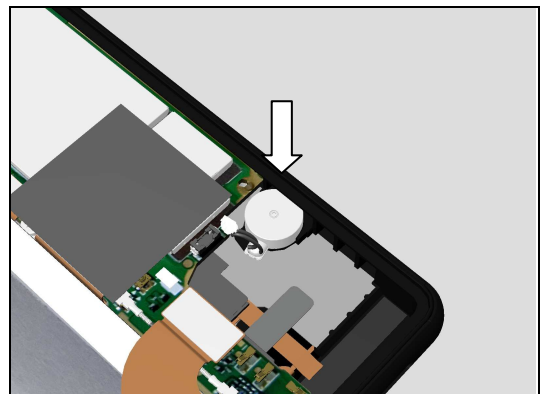
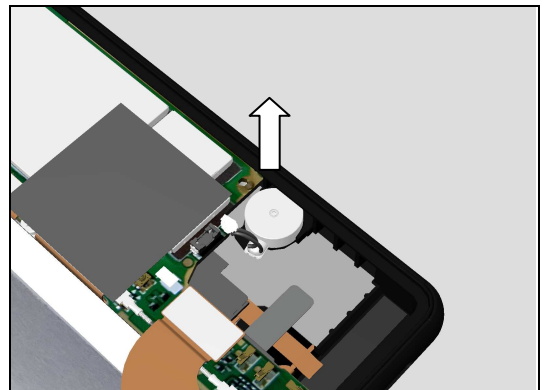
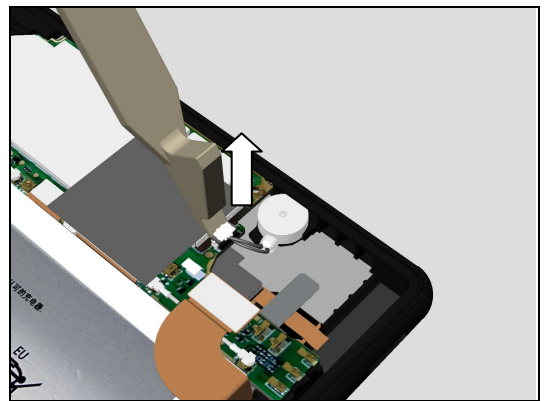
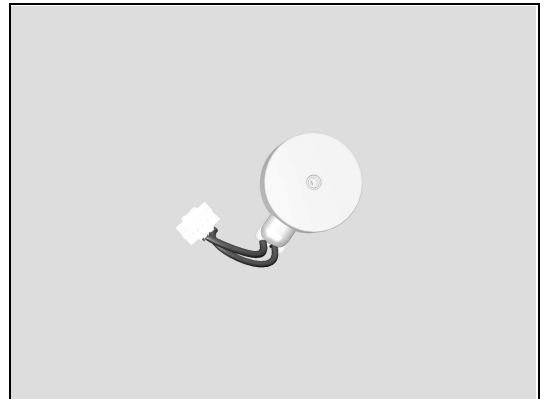
Disconnect Vibrator Connector by using the Front Opening Tool.

**Do not damage components on the Main PBA!**

Detach the Vibrator.

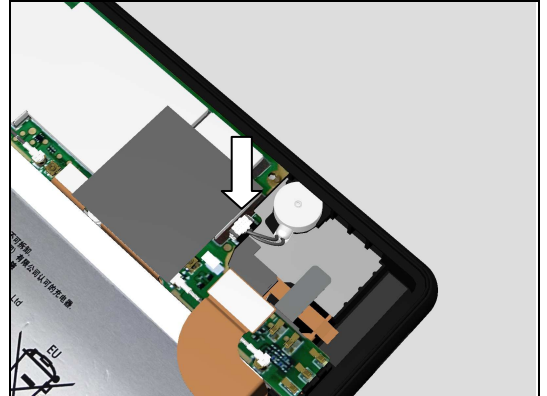
#### INSTALLATION

Attach a new Vibrator as shown in picture.



## Replacement: Vibrator

Press to snap the Vibrator connector.



## Replacement

### 4.58 Vibrator Cushion

*Follow the 3.1 – 3.8 Disassembly instructions!*  
*Prepare a new Vibrator Cushion.*  
*Follow the 5.5 – 5.12 Reassembly instructions!*

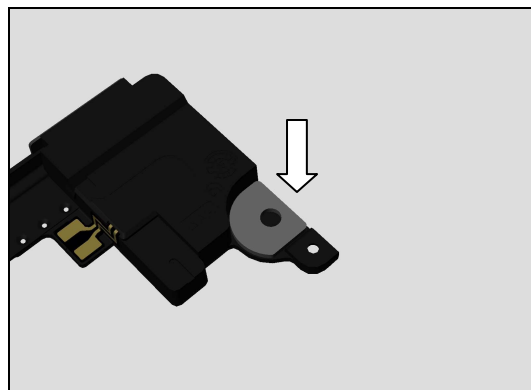
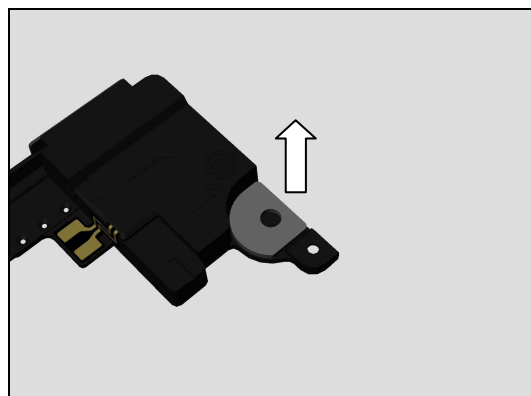
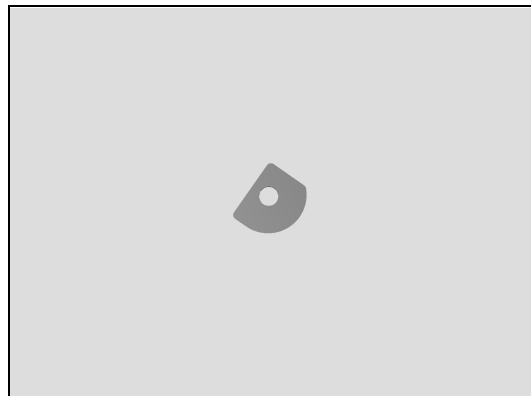
#### REMOVAL

Detach the Vibrator Cushion.

**Scrap! Not to be reused!**

#### INSTALLATION

Attach a new Vibrator Cushion as shown in picture.





## Replacement

### 4.59 Water Indicator

*Follow the 3.1 – 3.10 Disassembly instructions!*  
*Prepare a new Water Indicator.*  
*Follow the 5.3 – 5.12 Reassembly instructions!*

#### REMOVAL

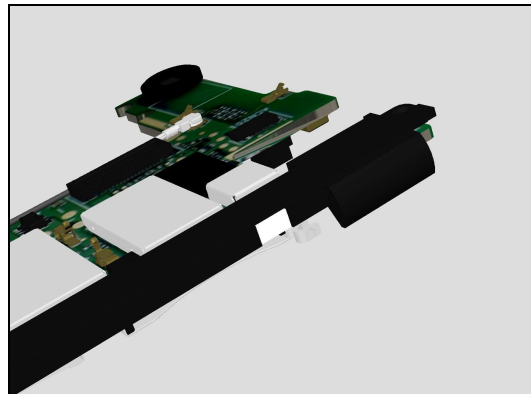
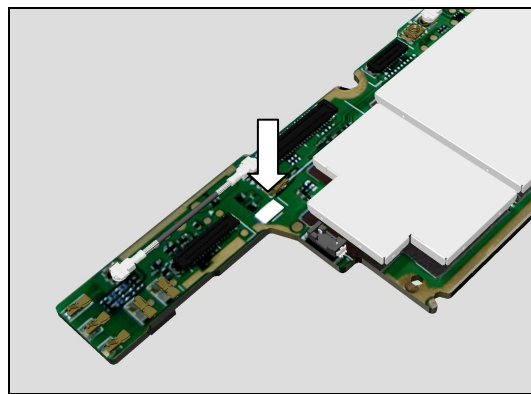
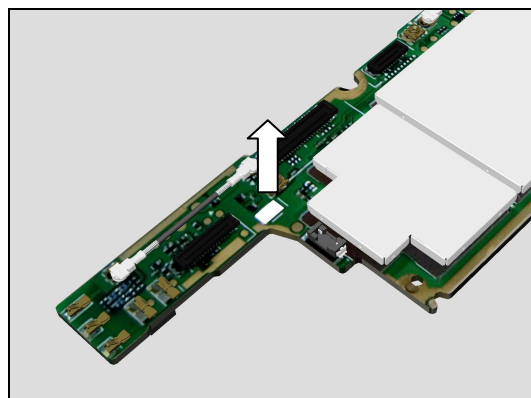
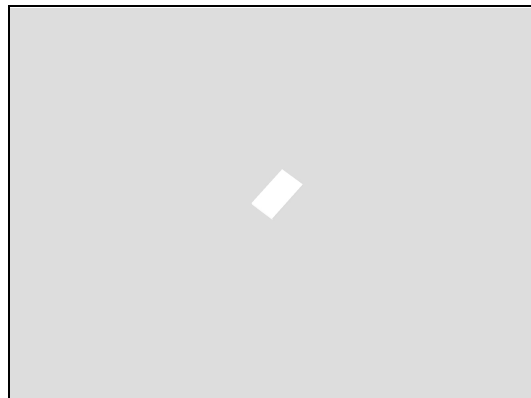
Detach the Water Indicator.

**Scrap! Not to be reused!**

#### INSTALLATION

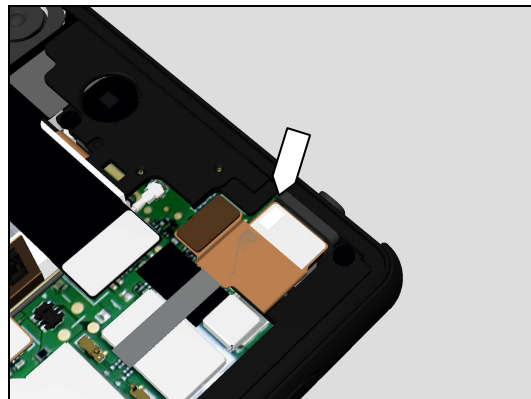
Attach a new Water Indicator in alignment with the guiding lines on the Main PBA.

Do the same to this Water Indicator.



## Replacement: Water Indicator

Do the same to this Water Indicator.



## Replacement

### 4.60 Battery Copper Sheet 1

*Follow the 3.1 – 3.12 Disassembly instructions!*

*Follow the 4.23 Removal instructions!*

*Prepare a new Battery Copper Sheet 1.*

*Follow the 4.24 and 4.23 Installation instructions!*

**Note! When replace new Display Cover Assy, Battery Copper Sheet 1 must be attached.**

#### REMOVAL

Detach the Battery Copper Sheet 1.

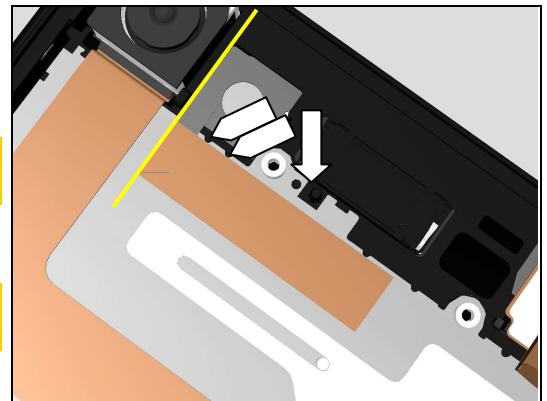
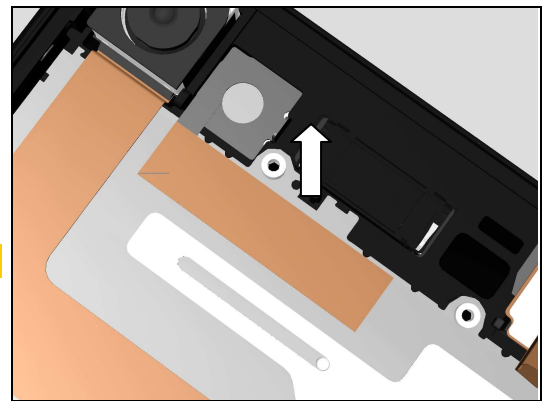
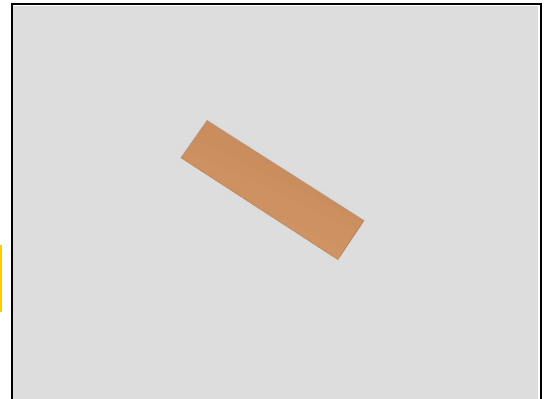
**Scrap! Not to be reused!**

#### INSTALLATION

**Replace new Conductive Tape Front Ring if damaged before installation.**

Attach a new Battery Copper Sheet 1 in its proper position as shown in picture.

**Make sure the correct position of the Battery Copper Sheet 1 as shown in picture.**

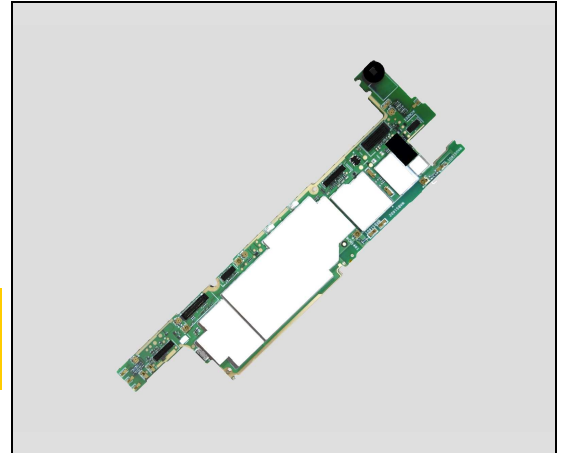


## Replacement

### 4.61 Board Swap – Replacement

Follow the 3.1 – 3.10 Disassembly instructions!  
 Follow the 4.48, 4.47 and 4.40 Removal instructions!  
 Replace the Swap Board.  
 Follow the 4.46, 4.48, 4.47, 4.40, 4.17, 4.59 and 4.43  
 Installation instructions!  
 Follow the 5.3 – 5.12 Reassembly instructions!

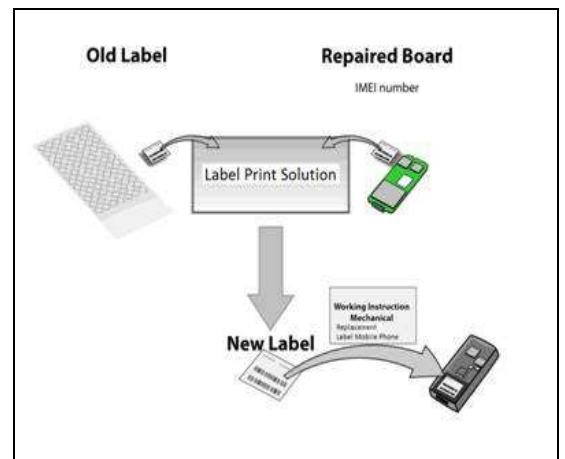
**Proximity, Light Sensor and Accelerometer Calibration  
 must be performed for all replaced units; 1289-2983  
 Trouble Shooting Application – mechanical.**



### 4.62 Board Swap – Change Label

#### CHANGE LABEL

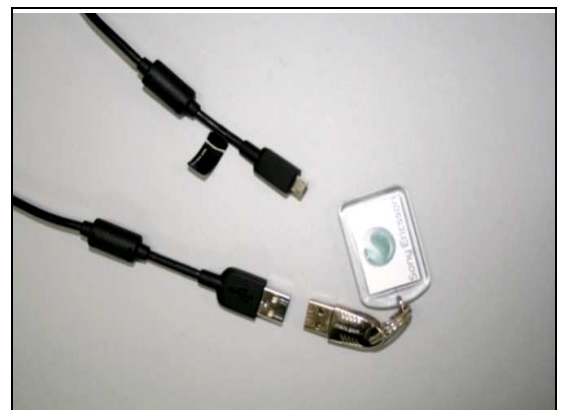
Follow the instructions in the Generic Repair Manual –  
 Build swap for change of label.



### 4.63 Board Swap – Customize of Software

#### CUSTOMIZE OF SOFTWARE

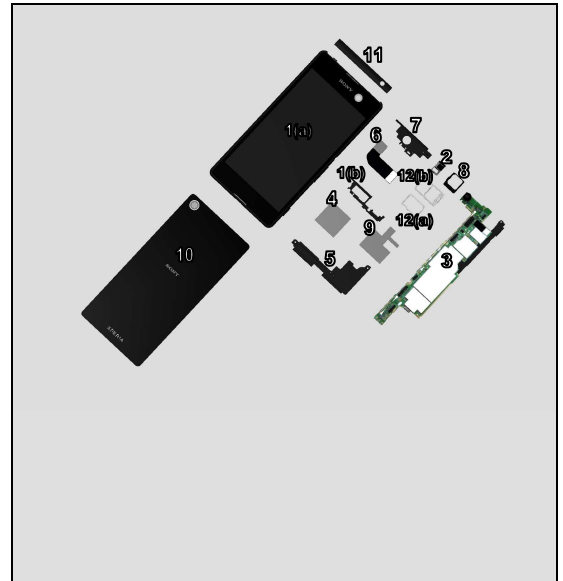
Follow the instructions in the Generic Repair Manual –  
 Build swap for customization of the software.



## 5 Reassembly

The E5603/E5606/E5633/E5643/E5653/E5663 reassembly is done in the following order:

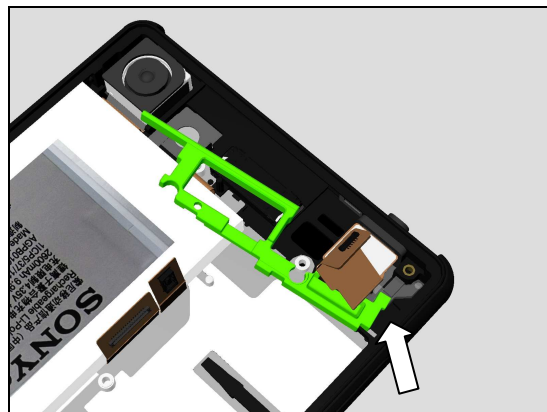
1. Display Cover Assy (a) and Holder Earspeaker (b)
2. Second Mic Rubber
3. Main PBA and Holder GPS/WiFi Ant Assy
4. Kapton Film LCM Connector
5. Holder Speaker Main Ant Assy
6. Chat Camera
7. Holder Diversity Ant Assy
8. Main Camera Rubber
9. Conductive Tape Battery Connector
10. Back Panel
11. Panel Deco Top
12. Tray SD (a) and Tray Single SIM (E5603/E5606/E5653)/  
Tray Dual SIM (E5633/E5643/E5663) (b)



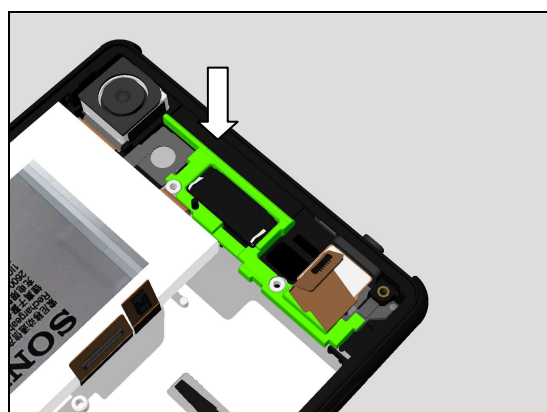
## Reassembly

### 5.1 Display Cover Assy (a) and Holder Earspeaker (b)

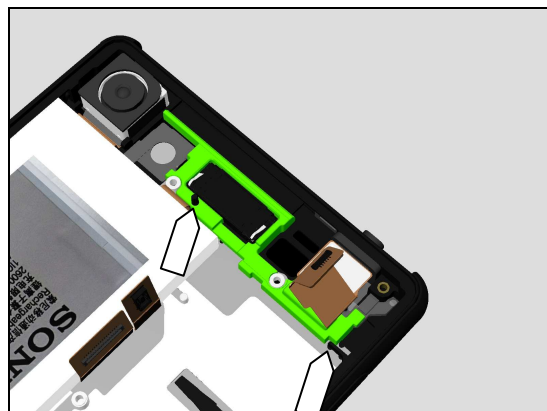
Mount the Holder Earspeaker from this side as shown in picture.



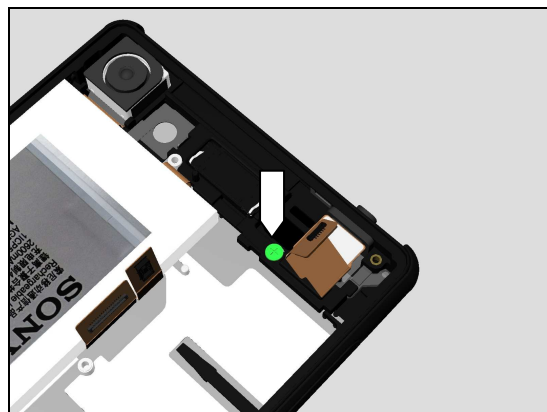
Mount the other side of the Holder Earspeaker.



**Make sure the correct position of the Holder Earspeaker as shown in picture.**



Apply 4Ncm torque when tightening the Screw M1.2\_L2.5 with Bits JCIS No.0.

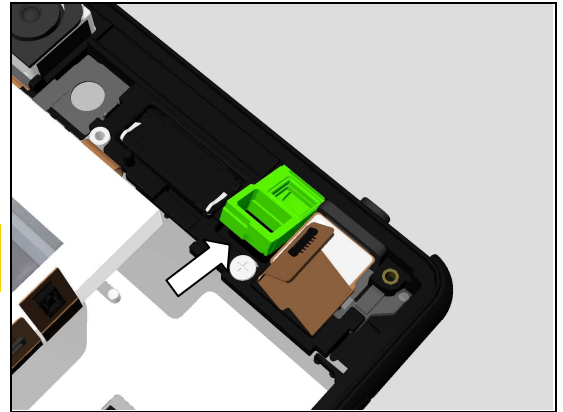


## Reassembly

### 5.2 Second Mic Rubber

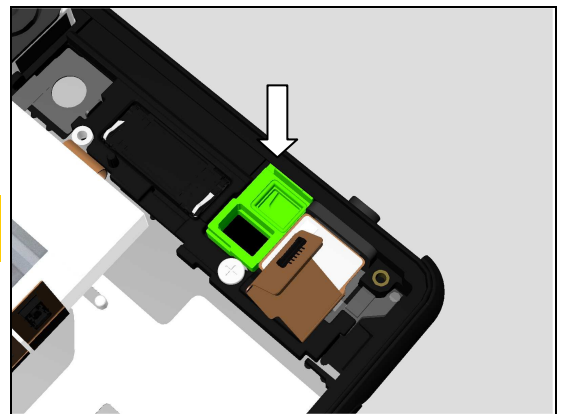
Insert to mount a new Second Mic Rubber.

***Make sure all remaining adhesive residue on the Display Cover Assy have been removed before installation!***



Press to attach the Second Mic Rubber into its cavity.

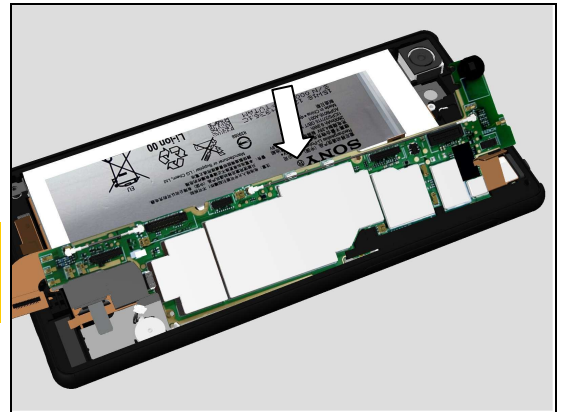
***Make sure the Second Mic Rubber is mounted into its cavity and is flat after mounting.***



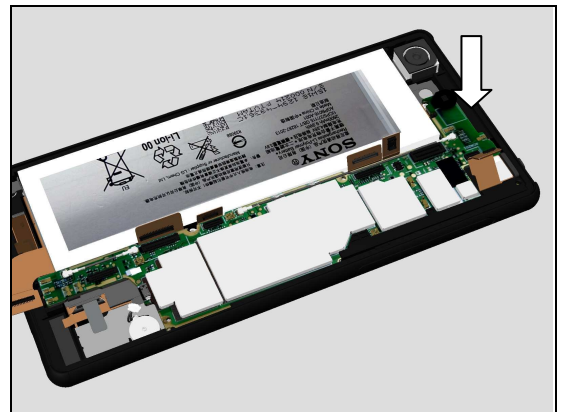
### 5.3 Main PBA and Holder GPS/WiFi Ant Assy

Insert to mount the Main PBA as shown in picture.

***Make sure all remaining adhesive residue of the Second Mic Rubber on the Main PBA have been removed before installation!***



Press to attach the top side of Main PBA onto the Second Mic Rubber.

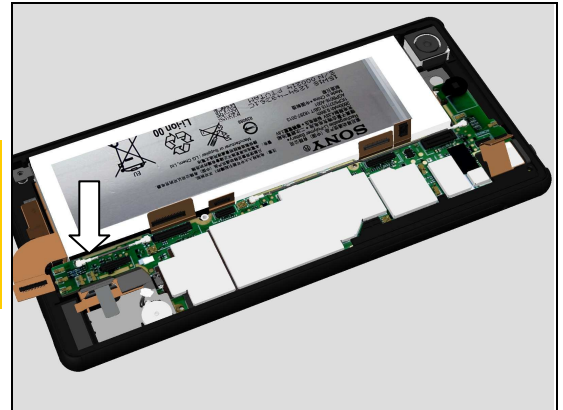




## Reassembly

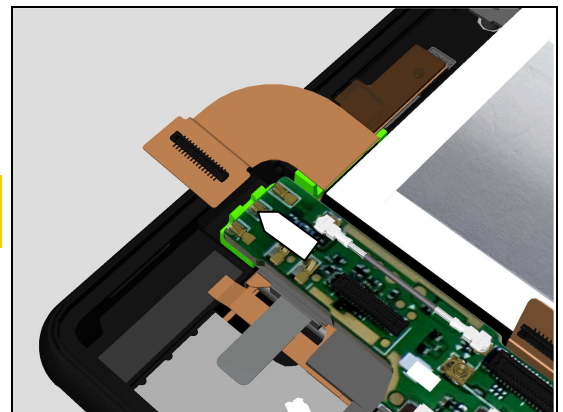
Press to snap the bottom side of the Main PBA.

**Make sure Main Camera FPC connector, Audio Jack FPC Assy connector, Vibrator connector, Sidekey FPC Assy Connector, LCM FPC connector, USB FPC Assy connector and Battery connector are not under the Main PBA when assembly!**

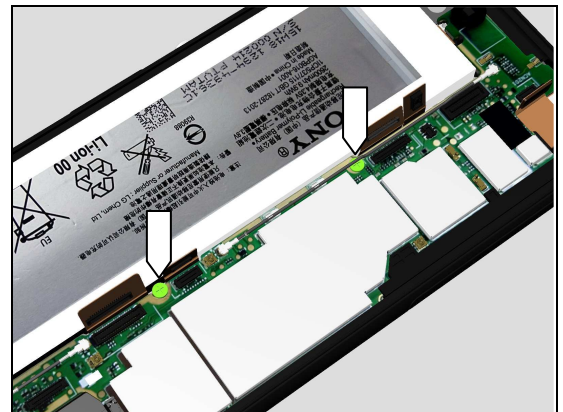


**Make sure the Main PBA is snapped.**

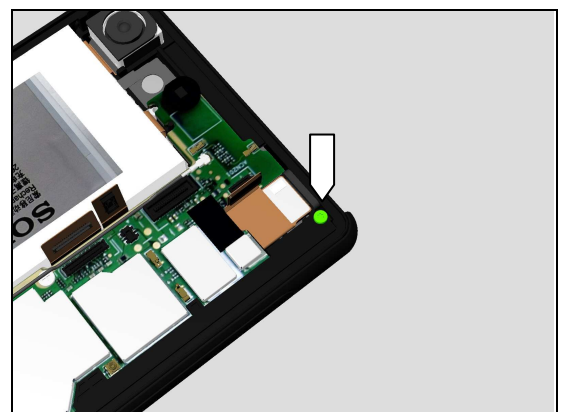
**Note! Do not touch the contact springs when snapping!**



Apply 4Ncm torque when tightening the two Screw M1.2\_L2.5 with Bits JCIS No.0.



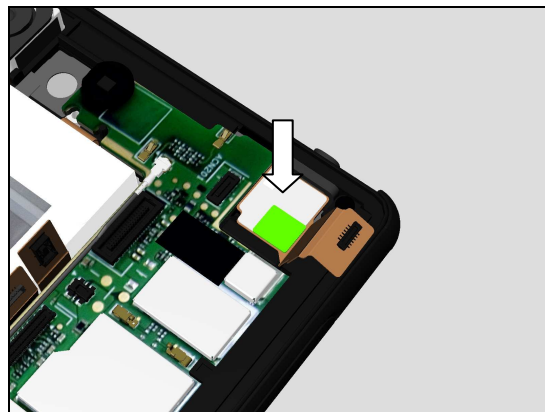
Apply 4Ncm torque when tightening the Screw M1.2\_L3.5 with Bits T5.





## Reassembly

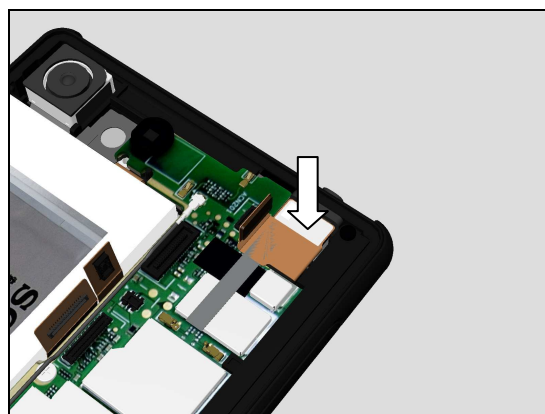
Attach a new Adhesive Diversity Ant/Audio Jack as shown in picture.



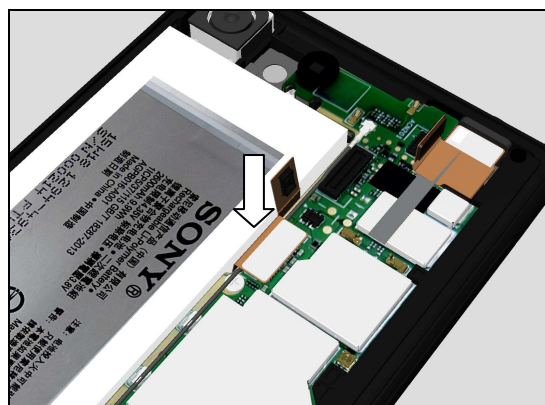
Attach a new Conductive Tape Audio Jack as shown in picture.



Press the Adhesive Diversity Ant/Audio Jack area to secure Audio Jack FPC good attachment.

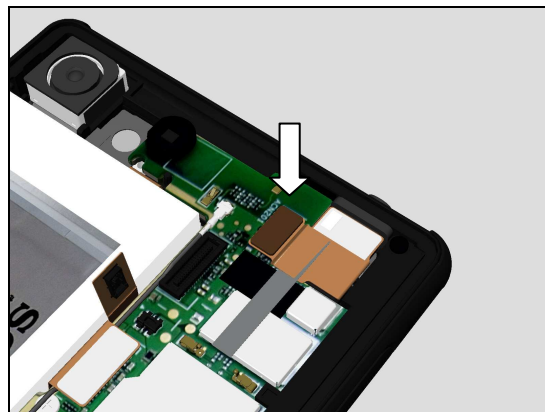


Press to snap the Main Camera FPC connector.

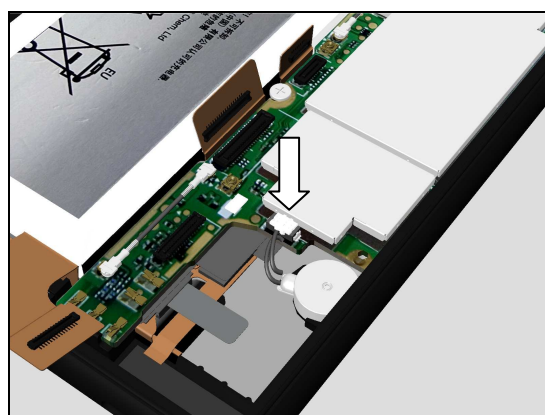


## Reassembly

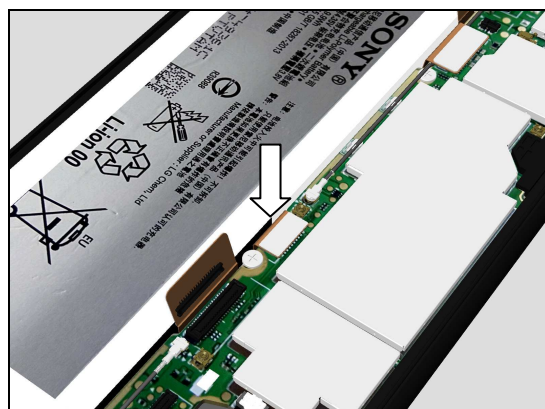
Press to snap the Audio Jack FPC Assy connector.



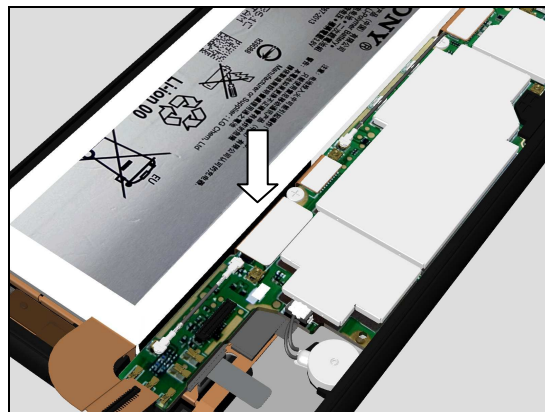
Press to snap the Vibrator connector.



Press to snap the Sidekey FPC Assy Connector.

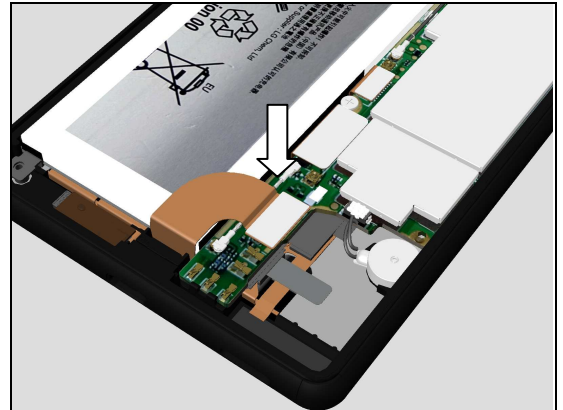


Press to snap the LCM FPC connector.



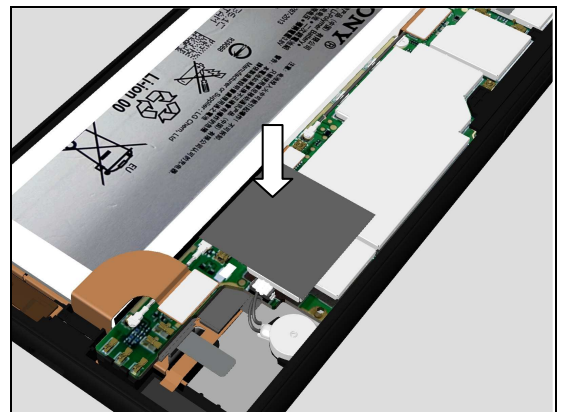
## Reassembly

Press to snap the USB FPC Assy connector.



### 5.4 Kapton Film LCM Connector

Attach a new Kapton Film LCM Connector.



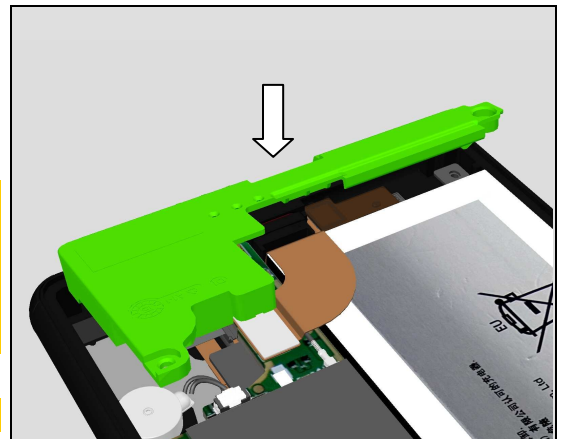
### 5.5 Holder Speaker Main Ant Assy

**Make sure all remaining adhesive residue on the Holder Speaker Main Ant Assy and Display Cover Assy have been removed before installation!**

**Replace new Adhesive WR Speaker Holder before installation.**

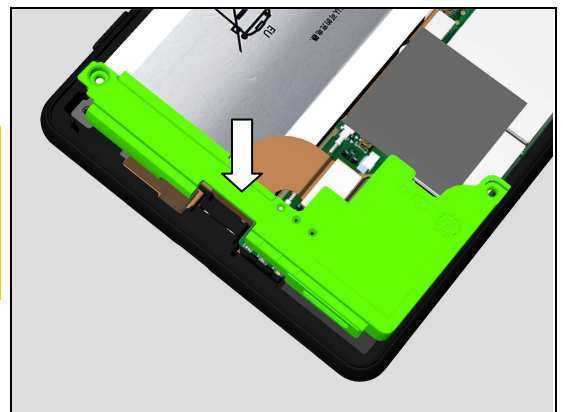
Insert to mount the Holder Speaker Main Ant Assy.

**Be careful to adjust proper angle to insert!**



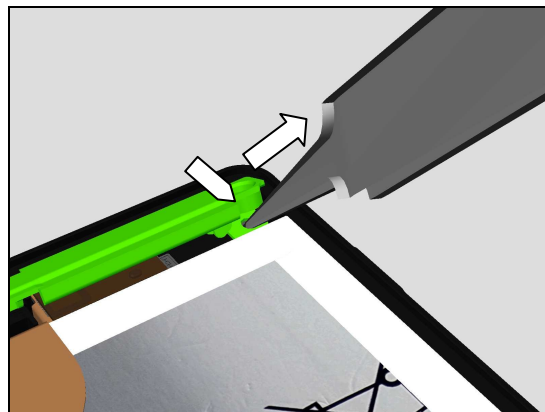
**Make sure insert the left side between USB FPC Assy and Display Cover Assy.**

**Make sure insert the right side between Holder USB and Display Cover Assy. Do not damage the contact springs on the Main PBA.**

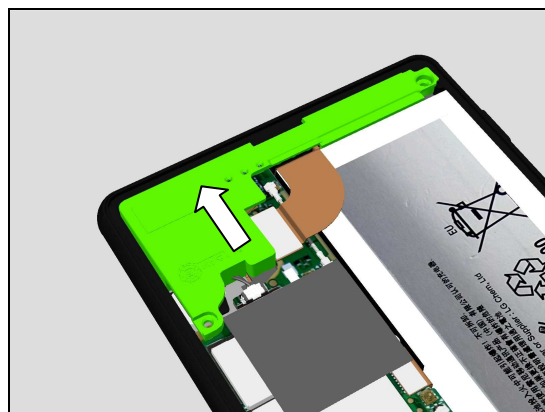


## Reassembly

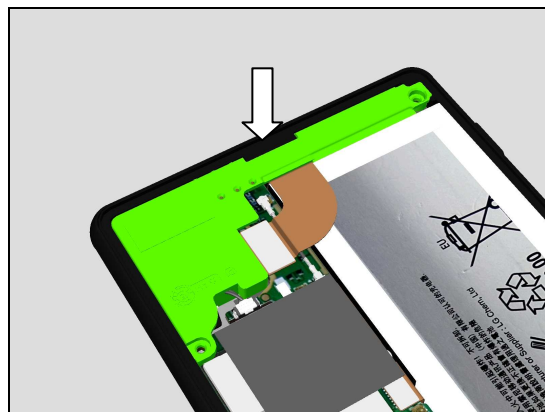
**If the Sidekey FPC Bracket block the mounting of the Holder Speaker Main Ant Assy use the tweezers to move the Bracket to its proper position.**



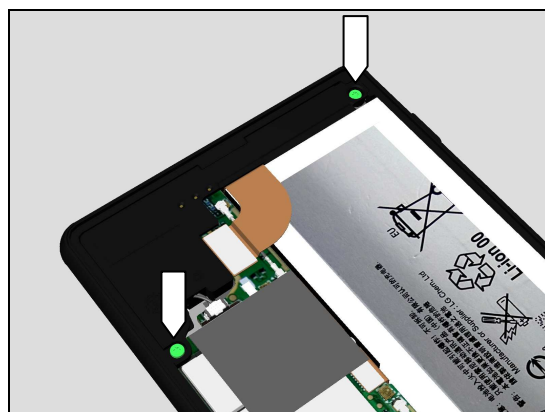
Press to secure the good attachment of the Adhesive WR Speaker Holder.



Press the Holder Speaker Main Ant Assy to its proper position.



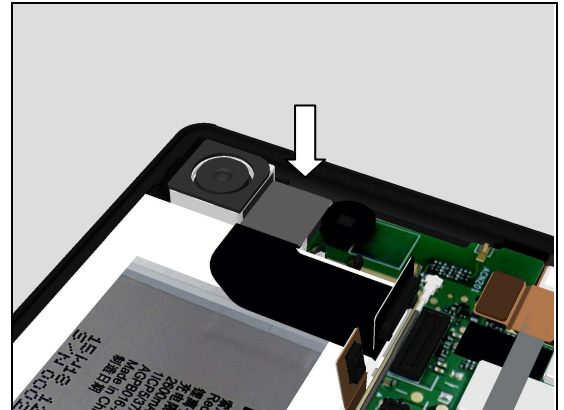
Apply 4Ncm torque when tightening the two Screw M1.2\_L3.5 with Bits T5.



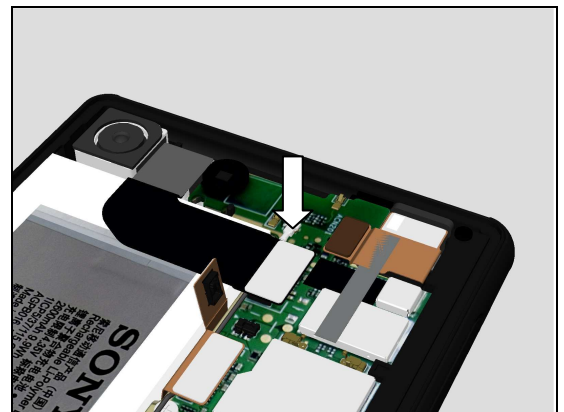
## Reassembly

### 5.6 Chat Camera

Mount the Chat Camera into its cavity.



Press to snap the Chat Camera FPC connector.

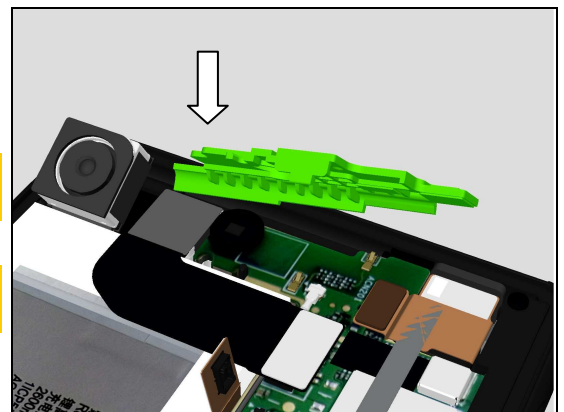


### 5.7 Holder Diversity Ant Assy

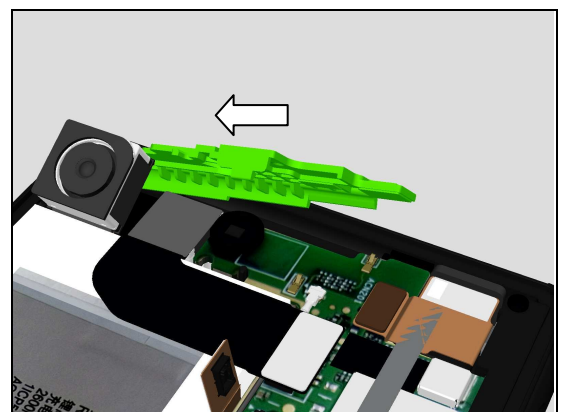
**Replace new Adhesive Diversity Ant/Audio Jack and Adhesive Holder Diversity Ant Assy before installation.**

Insert this side to mount the Holder Diversity Ant Assy.

**Make sure all remaining adhesive residue on the Main PBA have been removed before installation!**



Move the Holder Diversity Ant Assy a little as shown in picture.

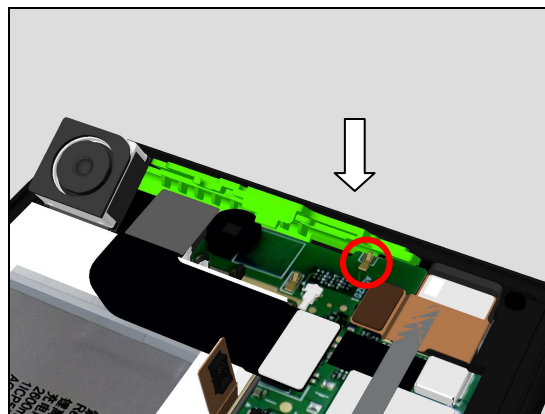




## Reassembly

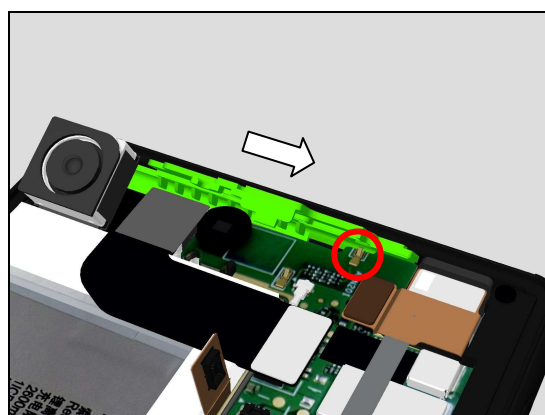
Insert the other side of the Holder Diversity Ant Assy.

**Note! Do not damage the contact spring of the Diversity Antenna!**



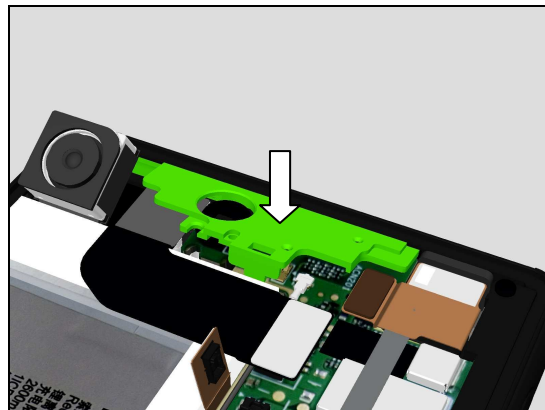
Move the Holder Diversity Ant Assy a little as shown in picture.

**Note! Do not damage the contact spring of the Diversity Antenna!**



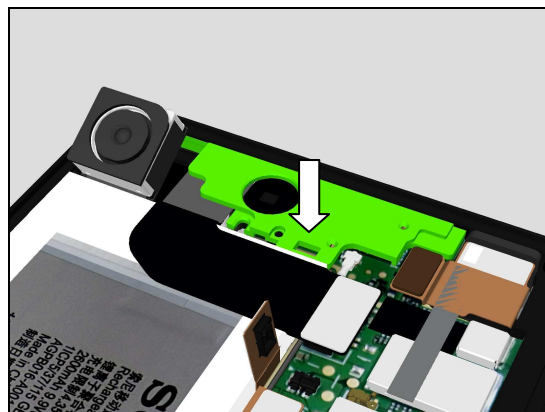
Rotate to press the Holder Diversity Ant Assy.

**Do not damage the copper sheet attached on the top side of the Battery Assy!**



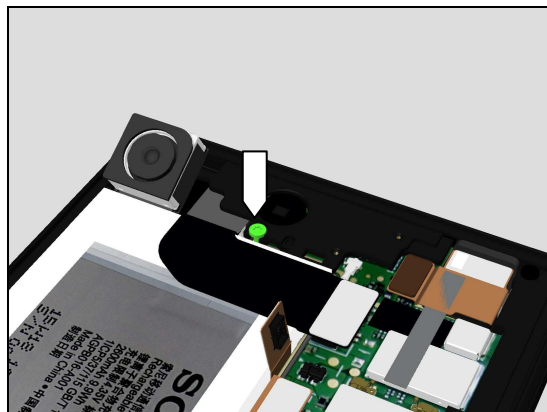
Press to snap the hook.

**Do not damage the copper sheet attached on the top side of the Battery Assy!**



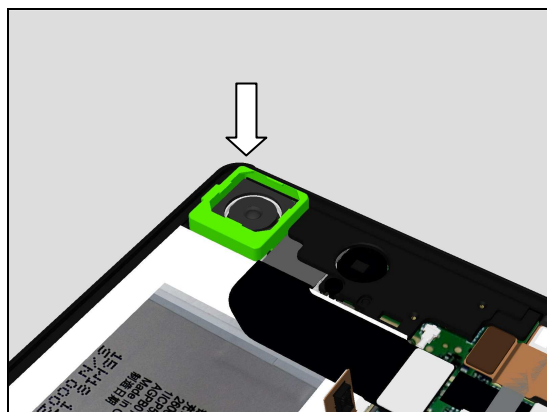
## Reassembly

Apply 3Ncm torque when tightening the Screw M1.2\_L3.5 with Bits T5.

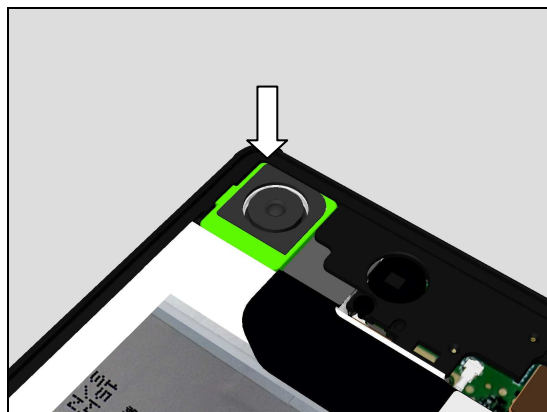


### 5.8 Main Camera Rubber

Mount the Main Camera Rubber.

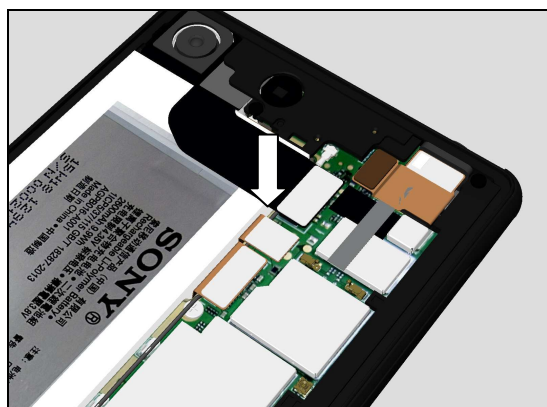


Secure its correct position as shown in picture.



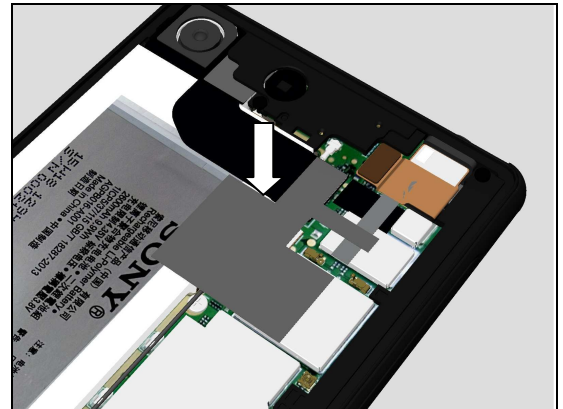
### 5.9 Conductive Tape Battery Connector

Press to snap the Battery connector.



## Reassembly

Attach a new Conductive Tape Battery Connector.



### 5.10 Back Panel

**Make sure all remaining adhesive residue on the Display Cover Assy have been removed before installation!**

Use Isopropyl Alcohol – 99 % to clean around the Adhesive WR Back Panel attaching area on the Display Cover Assy before assembly of the Back Panel.



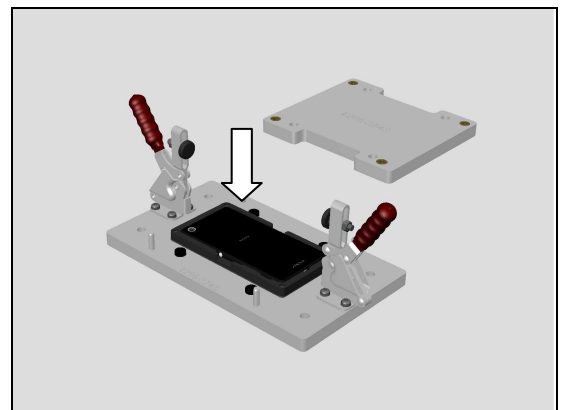
**Replace a new Adhesive WR Back Panel before installation.**

Place the Back Panel onto the Display Cover Assy.

**Make sure of a good alignment so the Back Panel is centered.**



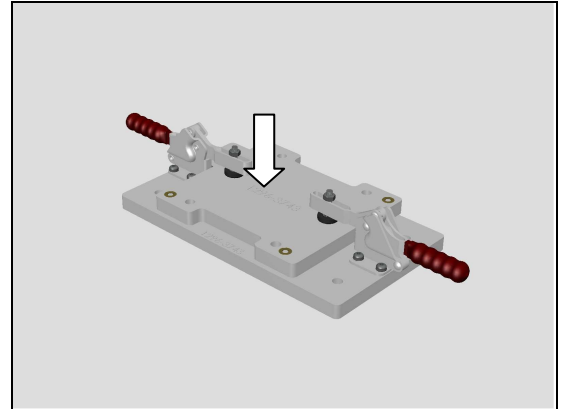
Place the phone (with the Back panel upwards) in the bottom inlay of the Back Panel Press.





## Reassembly

Place the top inlay of the Back Panel Press as shown in picture and then press for 2 minutes.



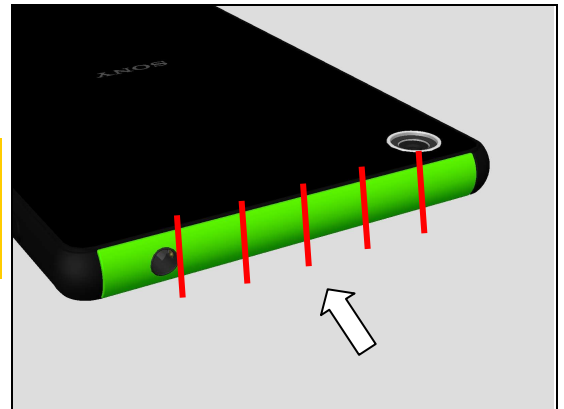
### 5.11 Panel Deco Top

Attach a new Panel Deco Top.

***Make sure all remaining adhesive residue have been removed before installation!***

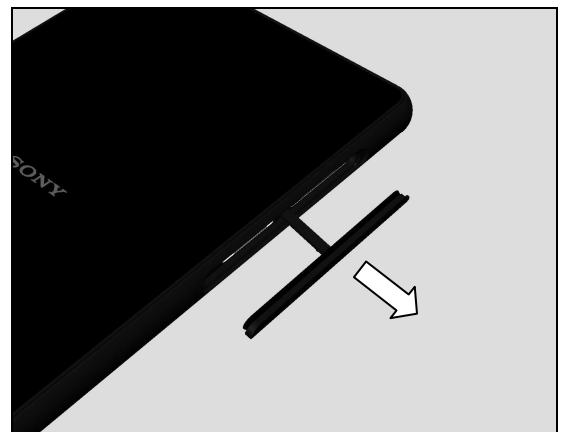


***Press it hard by finger from one side to the other side part by part, press each part for 15s.  
The panel is divided into 6 parts, the length of each part is about 1 centimeter.***



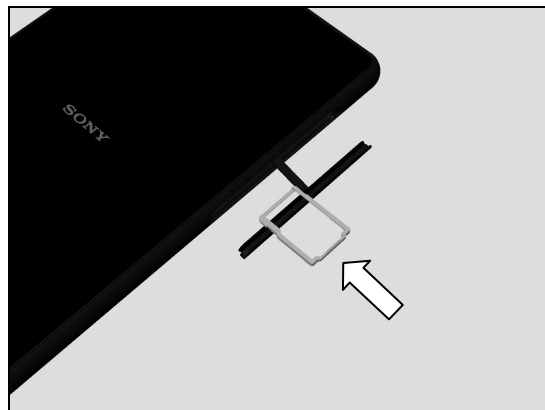
### 5.12 Tray SD (a) and Tray Single SIM (E5603/E5606/E5653)/ Tray Dual SIM (E5633/E5643/E5663) (b)

Open the Cap SIM/SD.



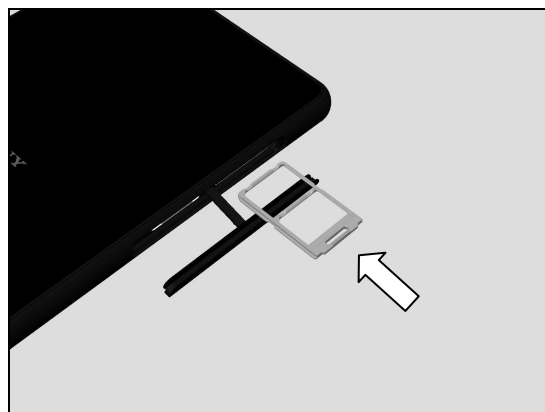
## Reassembly

Insert Tray SD.



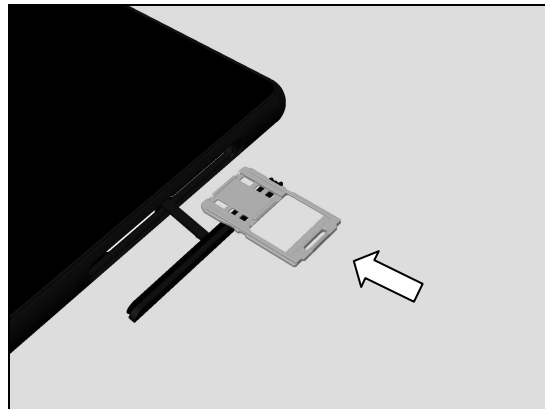
Insert the Tray Dual SIM.

***This is only for E5633/E5643/E5663!***



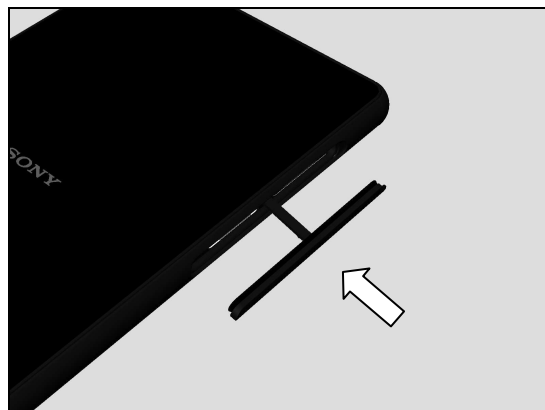
Insert the Tray Single SIM.

***This is only for E5603/E5606/E5653!***



Close the Cap SIM/SD.

***Proximity and Accelerometer Calibration must be performed after reassembly; 1289-2983 Trouble Shooting Application – mechanical.***



## 6 Revision History

Rev.	Date	Changes / Comments
1	2015-Aug-16	Initial release
2	2015-Sept-16	<ol style="list-style-type: none"> <li>Added note "Always Do not damage the Battery Assy and Do not damage the copper sheet attached on the top side of the Battery Assy and Do not damage the Battery Copper Sheet 1 when operation!" after table of contents</li> <li>Updated previous note like this "Note! Stop Sliding to this position for not to damage the main camera cushion on the Back Panel." in chapter 3.3</li> <li>Added note "Do not damage the Battery Assy and Do not damage the copper sheet attached on the top side of the Battery Assy!" in chapter 3.5 and 3.6</li> <li>Added note "Do not damage the copper sheet attached on the top side of the Battery Assy!" in chapter 3.6</li> <li>Added note "Note! Do not touch the contact springs!" in chapter 3.10</li> <li>Updated chapter 4.14 disassembly and reassembly process since new chapter 4.60 added</li> <li>Added note "Note! When replace new Display Cover Assy, Battery Copper Sheet 1 must be attached." in chapter 4.14</li> <li>Added note "Note! Do not damage the main camera cushion on the Back Panel." in chapter 4.20</li> <li>Updated previous instruction like this "Place the Upper Part of the fixture and press it", delete "by hand for 10 seconds." In chapter 4.20</li> <li>Added note "Note! Do not damage the Audio Jack FPC when pressing." in chapter 4.22</li> <li>Added note and picture about the protection film on the Audio Jack FPC in chapter 4.22</li> <li>Updated chapter 4.23 installation that Holder Speaker Main Ant Assy should be assembled before Battery Assy installation.</li> <li>Added note "Note! Hold the cap tail to pull out as the arrow shown." in chapter 4.25</li> <li>Updated chapter 4.30 disassembly and reassembly process since new chapter 4.60 added</li> <li>Updated Adhesive WR Earspeaker installation instruction with "aligning with the right side as shown in picture" in chapter 4.38</li> <li>Updated first step of installation in chapter 4.52 since design running change</li> <li>Updated previous note like this "Make sure the USB O-Ring is mounted into its hole and not twisted since it is for WR purpose!" in chapter 4.55</li> <li>Updated whole chapter 4.56 since USB O-ring assembly method change</li> <li>Added new chapter 4.60</li> <li>Updated chapter 4.61 disassembly and reassembly process since there is running change that Mylar PCB Front will not be attached on new exchange PBA</li> <li>Added note "Make sure all remaining adhesive residue on the Display Cover Assy have been removed before installation!" in chapter 5.2</li> <li>Added note "Make sure the Second Mic Rubber is mounted into its cavity and is flat after mounting." in chapter 5.2</li> <li>Added note "Make sure all remaining adhesive residue of the Second Mic Rubber on the Main PBA have been removed before installation!" in</li> </ol>

Rev.	Date	Changes / Comments
		chapter 5.3
		24. Added note "Make sure Main Camera FPC connector, Audio Jack FPC Assy connector, Vibrator connector, Sidekey FPC Assy Connector, LCM FPC connector, USB FPC Assy connector and Battery connector are not under the Main PBA when assembly!" in chapter 5.3
		25. Added note "Note! Do not touch the contact springs when snapping!" in chapter 5.3
		26. Added note "Make sure all remaining adhesive residue on the Holder Speaker Main Ant Assy and Display Cover Assy have been removed before installation! Replace new Adhesive WR Speaker Holder before installation." in chapter 5.5
		27. Updated previous note like this "Make sure insert the left side between USB FPC Assy and Display Cover Assy. Make sure insert the right side between Holder USB and Display Cover Assy. Do not damage the contact springs on the Main PBA." in chapter 5.5
		28. Changed screw torque from 4Ncm to 3Ncm in chapter 5.7
		29. Added note "Make sure all remaining adhesive residue on the Main PBA have been removed before installation!" in chapter 5.7
		30. Added note "Do not damage the copper sheet attached on the top side of the Battery Assy!" in chapter 5.7
		31. Added note "Make sure all remaining adhesive residue on the Display Cover Assy have been removed before installation!" in chapter 5.10
		32. Added note "Make sure all remaining adhesive residue have been removed before installation!" in chapter 5.11