

Working Instructions

- mechanical -



Xperia™ X Compact
F5321

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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 BtB connector to cut off power supply when the Cover Rear is disassembled.

Always finally connect the Battery BtB connector before the Cover Rear is reassembled.

After reinstall or replace the some specific parts, additional treatment (1289-2983 SMRA (Sony Mobile Repair Application) Calibration, Flashing Customize by Emma, Aged Battery Reset by Emma, or/and label replacement) is required.

Refer to the below table for requiring treatment for part reinstalling/replacing.

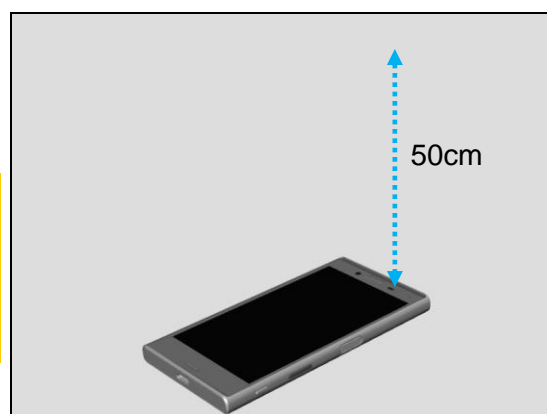
		SMRA Calibration					Emma		Label MOP
		Proximity	Noise Cancelling	Color ID Flashing	RGBC-IR	ToF	Flashing Customize	Aged Battery Reset	Changing
Reassembly	Front Assy	○							
	PBA	○							
Replacement	Front Assy	○							
	PBA	○	○	○	○	○			○
	Key FPC	○							
	Jack FPC Module		○						
	Battery							○	
	Cover Rear				○				
	Sensor FPC				○	○			
	Loudspeaker						○		
	Speaker Box						○		

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

Note!

Remove the protection film if sensor window is covered by the protection film.

The sensor window shouldn't be covered by protection film for proximity sensor calibration.



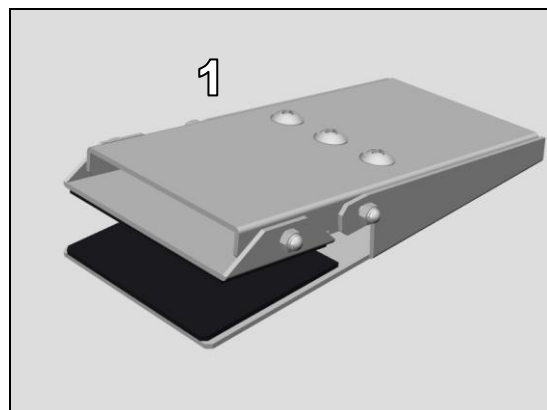
1 Exterior Views



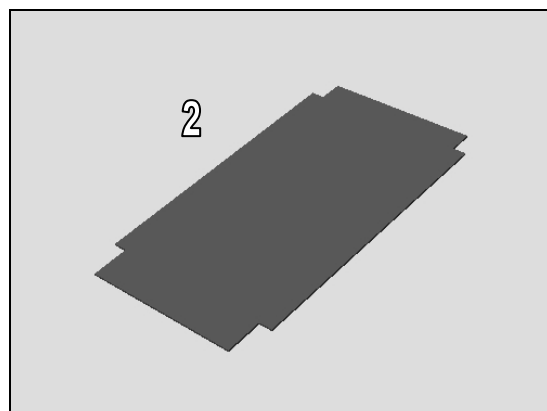
2 Tools

SPECIAL TOOLS

1. Press Clamp (1304-6943)

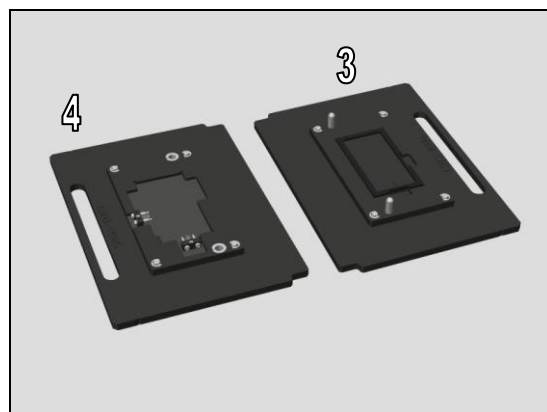


2. Disassembly Sheet (1295-5578)

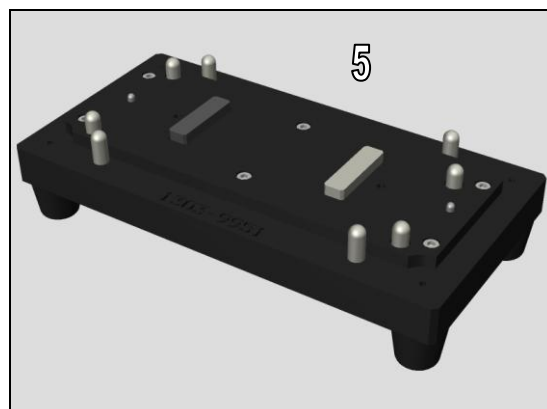


3. Rear Cover Press Top Inlay (1303-9946)

4. Bottom Press Inlay (1303-9945)

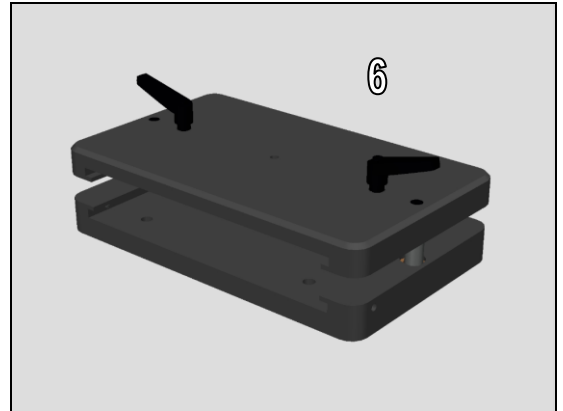


5. Rear Cover Adhesive Fixture (1303-9951)



Tools

6. Generic Fixture for Press tool (1273-4413)



7. Media Cable TyepC Cable (Black) (1302-1935)



Tools

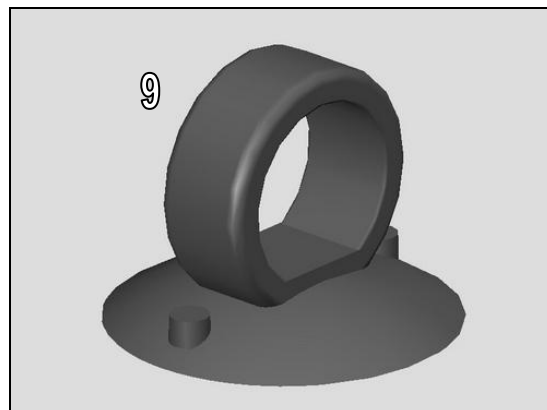
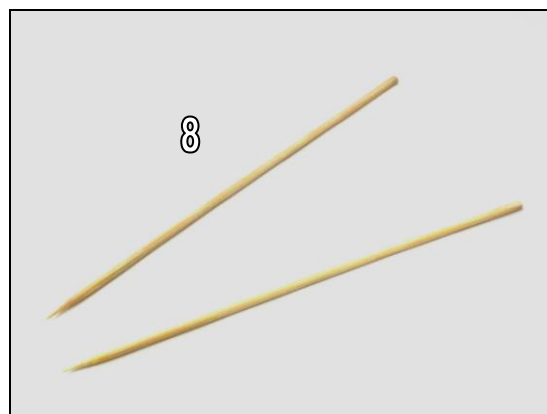
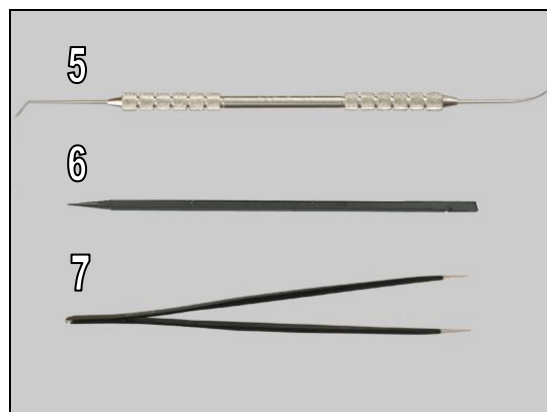
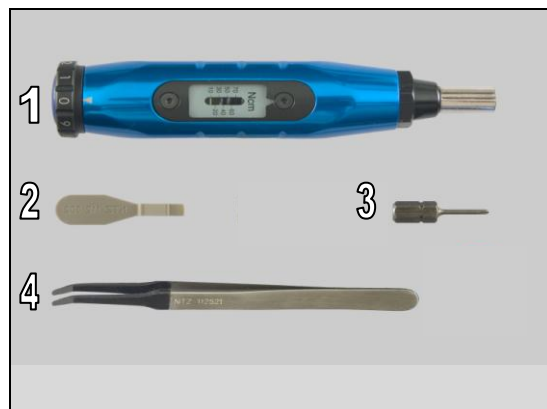
STANDARD TOOLS

1. Torque Screwdriver 2-30Ncm (1233-2284)
2. Front Opening Tool (NTZ 112 302/2)
3. Bits (JCIS No 0) (NTZ 112 1052)
4. Flex film assembly tool (ntz 112 521)

5. Dentist Hook
6. Nylon Pointer
7. Tweezers

8. Bamboo Skewer

9. Suction cup



3 Mandatory Replacement Parts List

The Mandatory Replacement Parts List is embedded.
Click the icon to open the file.



Targeted replacement parts are listed

Mandatory replacement part		SPACE	Refurbish	Target replacement part															
				Cover Rear Sub Assy	Battery	Ant NFC Flex	Sensor FPC Module	Frame Main Sub Assy	Water Indicator	Main Camera	Chat Camera	Speaker Box Sub Assy	Vibrator	PBA	USB FPC Module	Jack FPC Module	Key FPC	Loudspeaker	Front Assy
Adhesive 3LED	1301-7386				1	1									1		1		
Adhesive Battery	1301-7535													1					
Adhesive FPC Key	1301-7394						1	1									1		
Adhesive Holder FPC Sensor	1302-1033																2		
Adhesive RF FPC Key Rect	1302-1644																2		
Adhesive RF FPC Key SQ	1302-1637																		
Adhesive Vib	1302-1032											1	1						
Adhesive WP Audio Jack	1294-6794	1														1			1
Adhesive WR Cover Rear	1301-7579	1		1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
Adhesive WR Mic1	1301-7388	1												1	1	1	1	1	1
Adhesive WR Mic2	1301-7389	1												1	1	1	1	1	1
Adhesive WR Receiver	1301-7431																	1	
Battery 2570mAh	1303-8269				1	1								1					
Cap Mic1 Sub Assy	1303-0140													1					
Cap Tray Assy Black	1304-1918																		
Cap Tray Assy Blue	1304-1920	1																	
Cap Tray Assy White	1304-1919																		
Chat Camera	1303-1631										1								
Cover Rear Sub Assy Black	1301-7541			1															
Cover Rear Sub Assy Blue	1301-8365																		
Cover Rear Sub Assy White	1301-8363																		
FICTIVE Ant NFC Flex	1301-7866				1	1								1					
FICTIVE Main Camera	1301-5925									1									
Fingerprint Sensor Assy	1304-1903	1																	
Frame Main Sub Assy	1301-7530							1											
Front Assy Black	1304-1869																		
Front Assy Blue	1304-1872	1																	1
Front Assy White	1304-1871																		
Holder FPC Sensor	1301-7528						1	1											
Holder NFC Antenna	1301-7537				1	1								1					
Jack FPC Module	1300-8691	1															1		
Key FPC	1300-8693																1		
Label MoP	1301-7586	1																	
Liquid Indicator	1275-3307							1											
Loudspeaker	1287-2024																	1	
PBA														1					
Relay FPC	1301-7435																		
Screw M1.2*4.2	1294-9877	1						8	8	8	8	8	8	8	8	8	8	8	8
Sensor FPC Module Gina	1303-7812						1	1											
Sheet Jack	1301-7430	1														1			
Sheet Protection PBA	1302-1031	1													1	1	1	1	1
Sheet Slider MOP	1302-0113	1													1				
Spacer CN Battery	1301-7581				1	1													
Spacer CN Battery FPC	1303-2138				1	1									1				
Speaker Box Sub Assy	1302-1917											1							
USB FPC Module	1306-1560	1													1				
Vibrator	1264-2341												1						

Mandatory replacement parts for refurbishment.

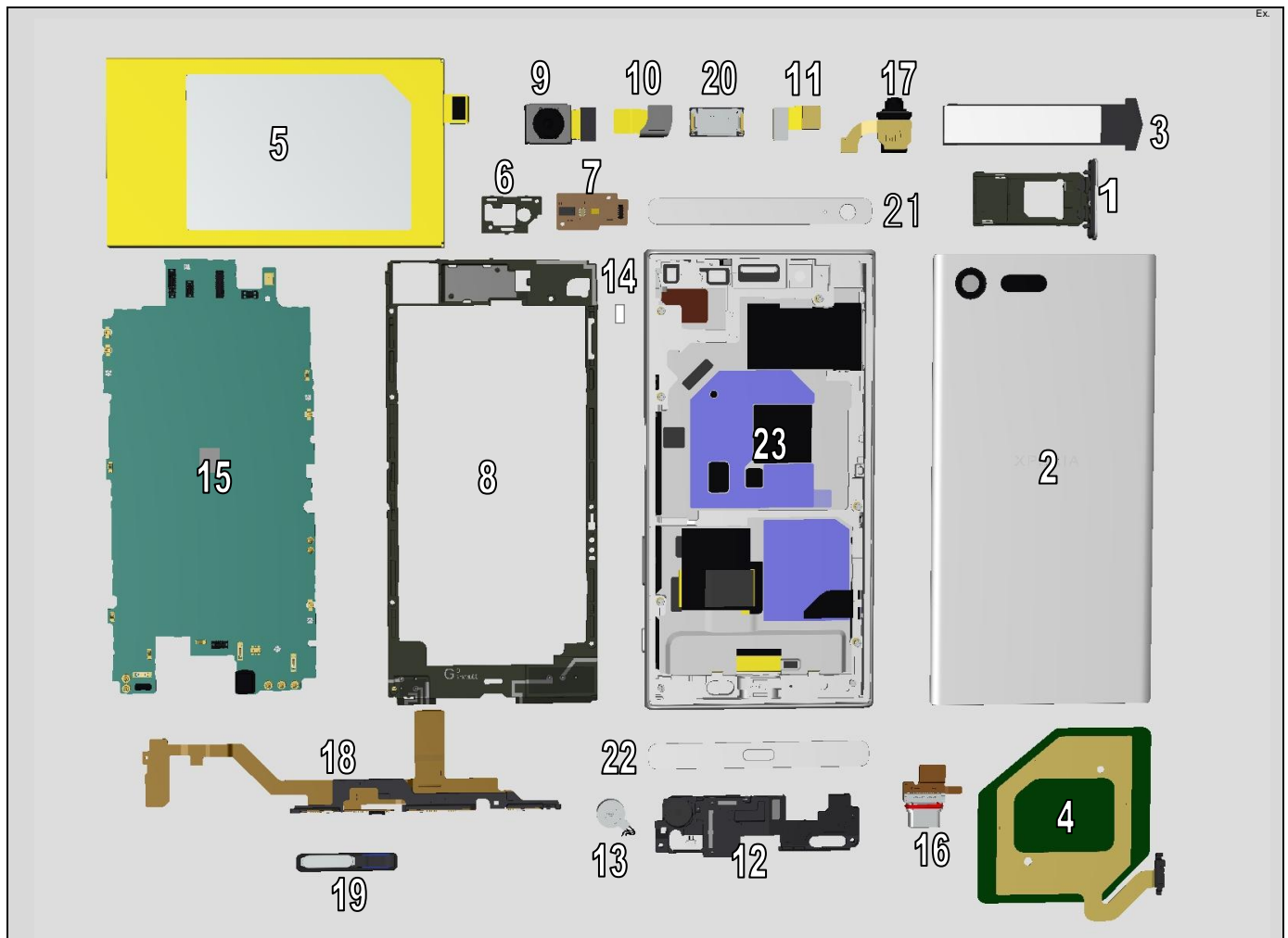
Red Number is replacement target.

Number in the cells indicates parts require replacing for target part.

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

4 Disassembly

The disassembly is done in the following order.



1	Cap Tray Assy	13	Vibrator
2	Cover Rear	14	Liquid Indicator
3	Sheet Slider MOP	15	PBA
4	Ant NFC Flex	16	USB FPC Module
5	Battery	17	Jack FPC Module
6	Holder FPC Sensor	18	Key FPC
7	Sensor FPC	19	Fingerprint Sensor
8	Frame Main	20	Loudspeaker
9	Main Camera	21	Panel Top
10	Relay FPC	22	Panel Bottom
11	Chat Camera	23	Front Assy
12	Speaker Box		

Disassembly

Disassembly Quick Reference Chart is embedded.

Click the icon to open the file.

Required disassembly procedures of specific part removing can be identified by Disassembly Quick Reference Chart.

The following is the sample how to identify the procedures.

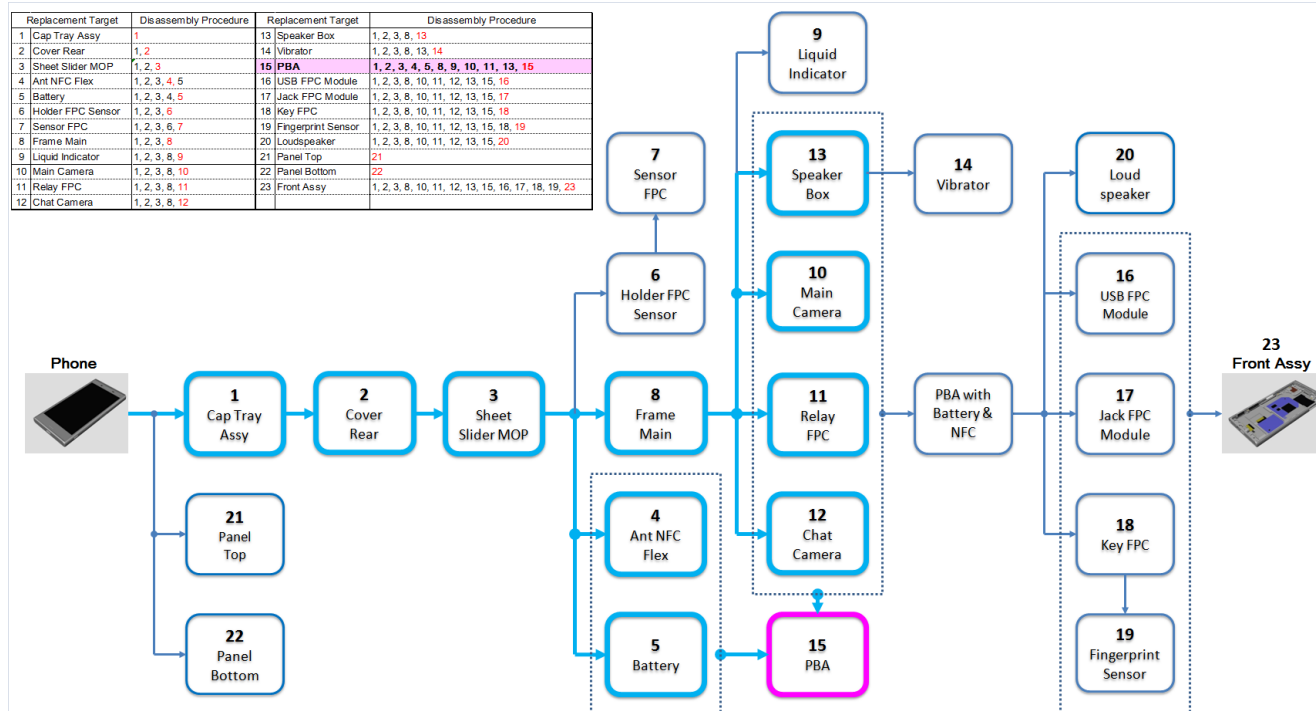
Ex1. In case of PBA replacement



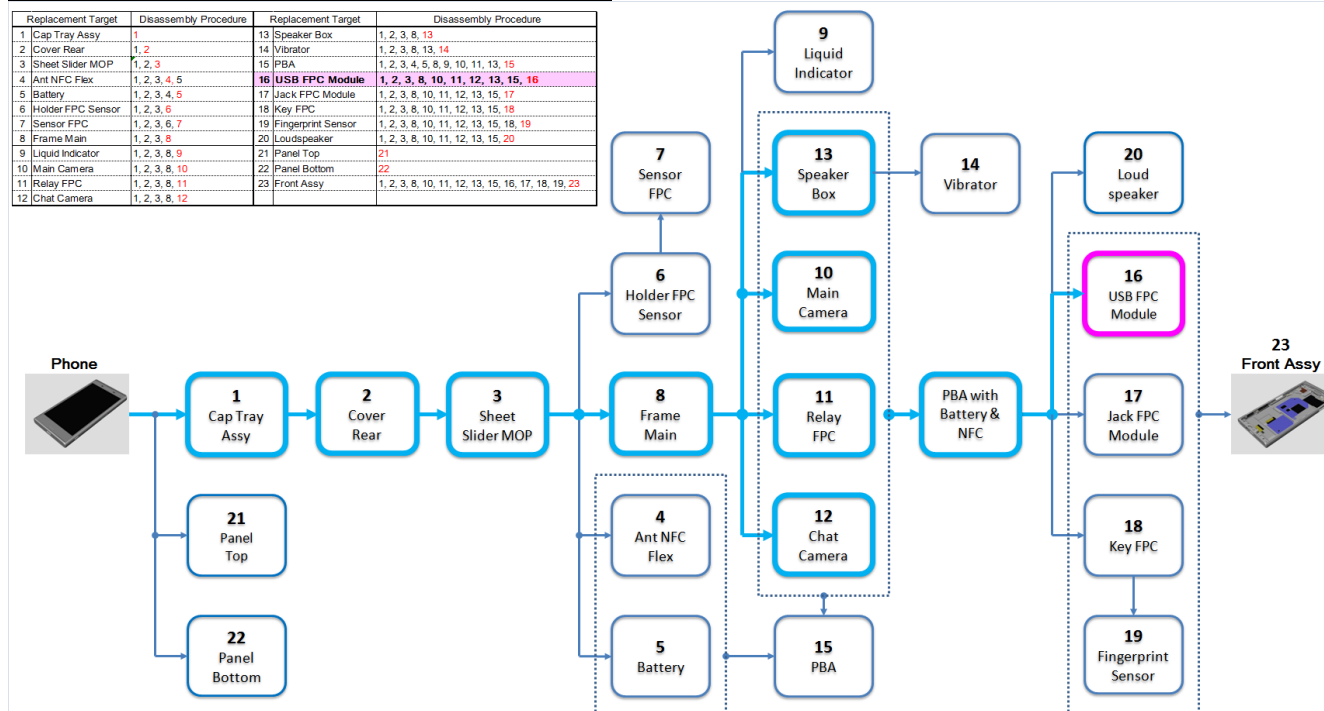
: Replacement Target



: Necessary Procedure



Ex2. In case of USB FPC Module replacement

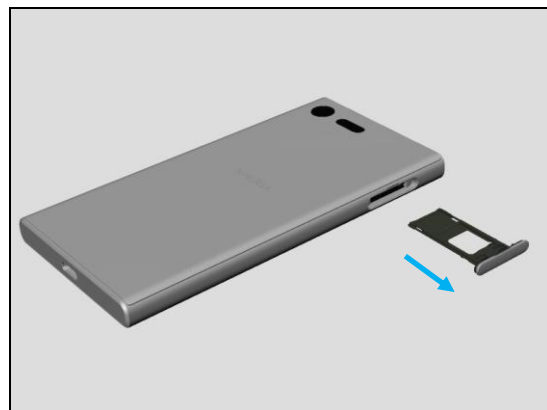


4.1 Cap Tray Assy

Remove the Cap Tray Assy.

Note!

Remove the Cap Tray Assy to keep rear side up. Otherwise, SIM card and (or) micro SD card will be fallen down.



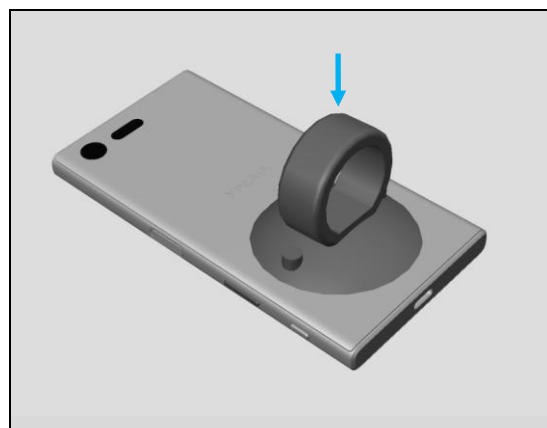
4.2 Cover Rear

Note!

Before removing the Cover Rear, Check if it has any damages such as dimple/dent. Due to dimple/dent of the Cover Rear, the battery might be damaged.

Check the Battery condition to follow the "6 Battery Reuse instruction".

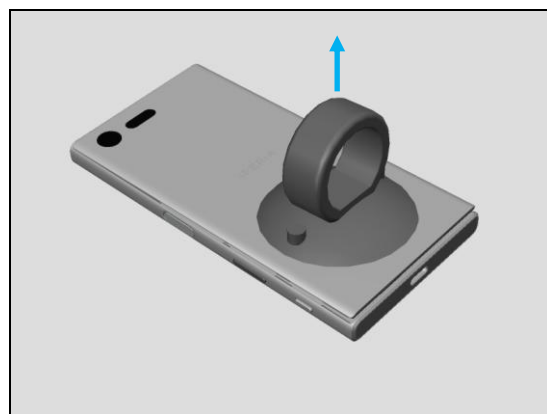
Place the suction cap to bottom side on the Cover Rear.



Pull the suction cap to make the gap between Cover Rear and main body of the unit.

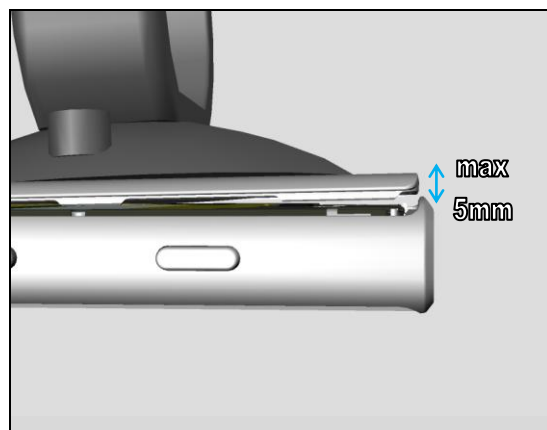
Note!

Picture indicates to make gap at the bottom side. But, if it has difficulty to make gap, try another sides.



Note!

Don't pull the suction cap more than 5mm. Otherwise, Cover Rear will be wound.



Disassembly

Insert the Disassembly Sheet from Key side and Cap Tray Assy side.

Note!

Don't insert the Disassembly Sheet into the unit beyond blue dotted line to prevent damage of the NFC FPC. And Don't use long side of the Disassembly Sheet.

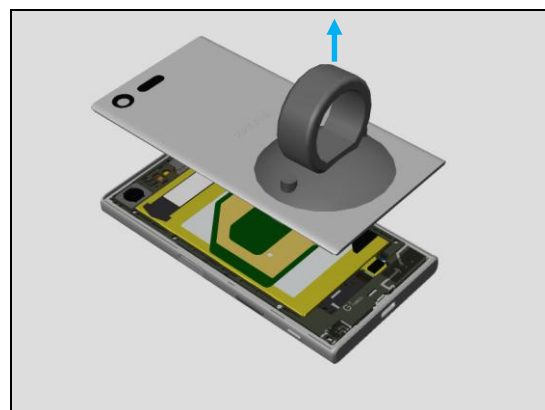
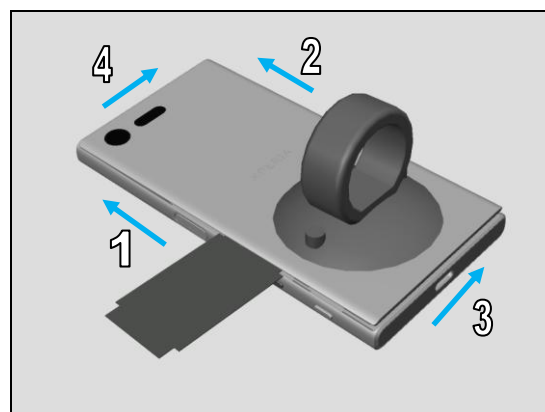
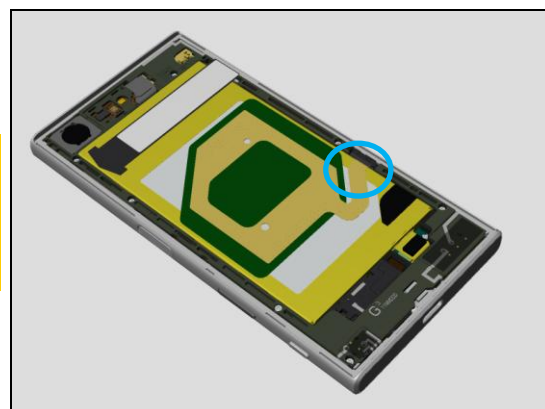
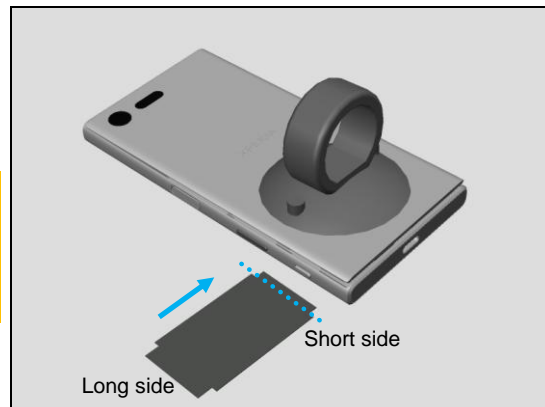
Note!

Be careful about NFC FPC, when removing the Cover Rear.

NFC FPC is located as shown blue circle.

Gently slide the Disassembly Sheet to cut the Adhesive WR Cover Rear as shown order.

Remove the Cover Rear.

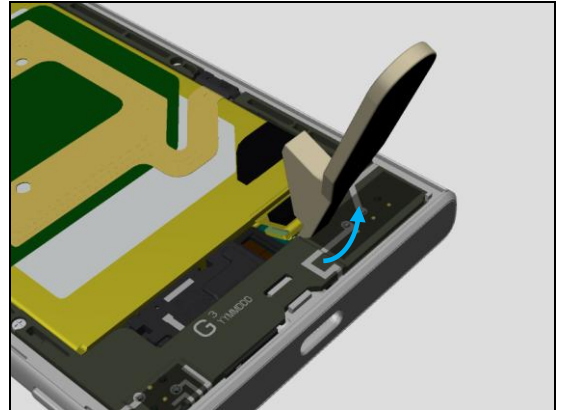


Disassembly

Disconnect the Battery B to B connector by Opening Tool.

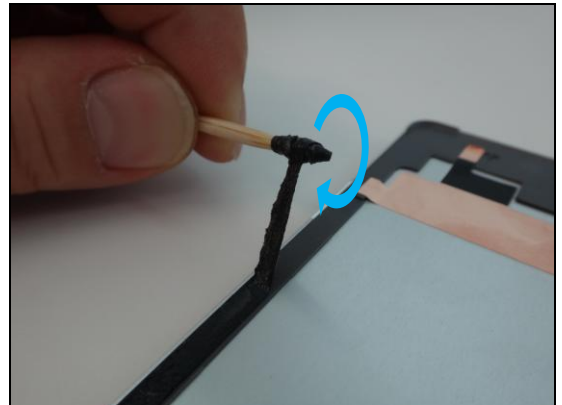
Note!

Make sure to disconnect the battery B to B connector to proceed disassembling beyond this stage to cut the power supply to the unit.



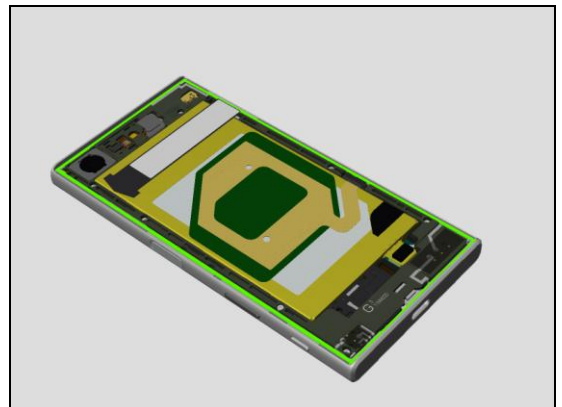
Remove the Adhesive WR Cover Rear to use Bamboo Skewer.

Rotate the Bamboo Skewer to take up the Adhesive WR Cover Rear.



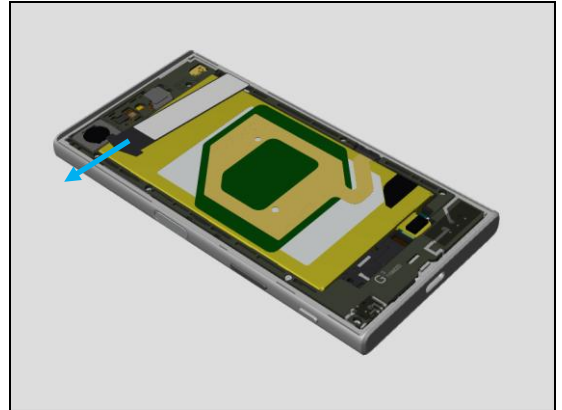
Note!

Make sure to remove all residues of the Adhesive WR Panel Rear completely from both Panel Rear and unit (Green Highlighted Area).



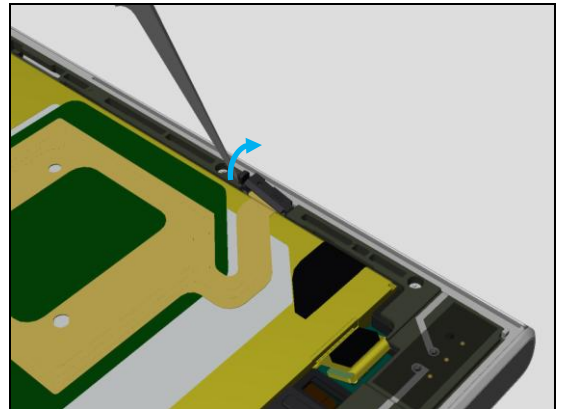
4.3 Sheet Slider MOP

Remove the Sheet Slider MOP as shown.



4.4 Ant NFC Flex

Disconnect the Connector NFC by Nylon Pointer as shown.



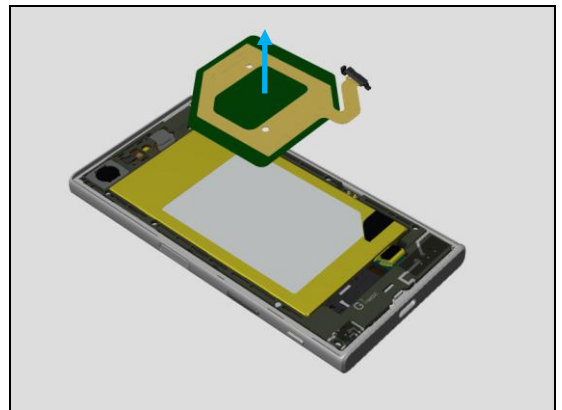
Remove the Ant NFC Flex.

Scrap!

Don't reuse the Ant NFC Flex and the Battery when the Ant NFC Flex is removed!

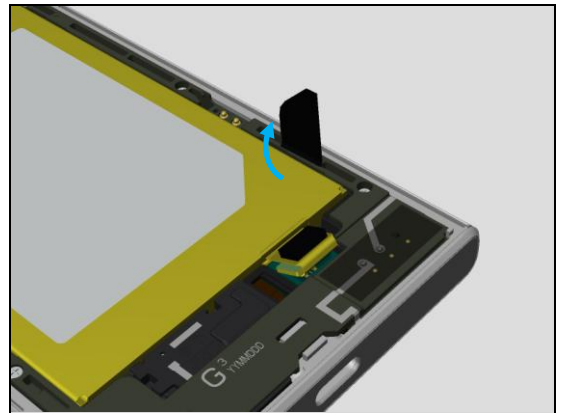
Note!

If the NFC replacement is not needed, you can skip this chapter.



4.5 Battery

Pick up the Battery Adhesive Tab as shown.



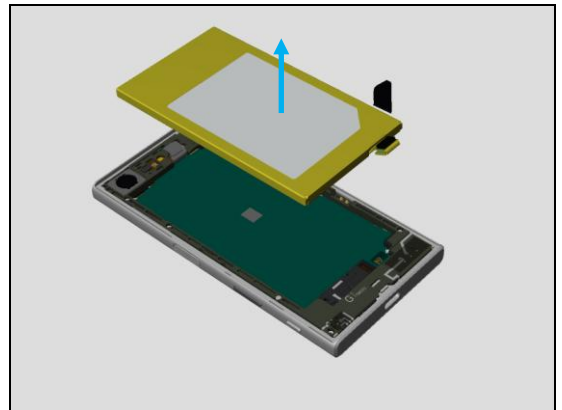
Pull up the Battery Adhesive Tab and remove the Battery.

Scrap!

Don't reuse the Battery and Ant NFC Flex when Battery is removed from PBA!

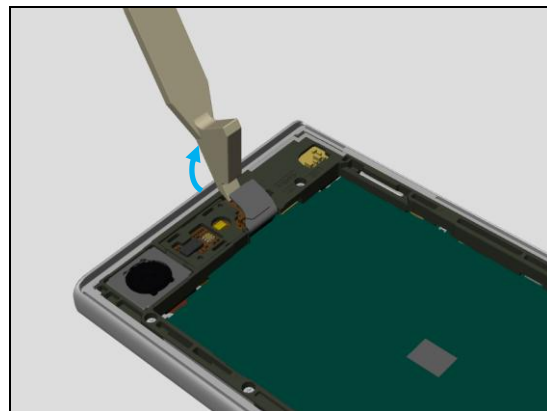
Note!

If the Battery replacement is not needed, you can skip this chapter.



4.6 Holder FPC Sensor

Disconnect the Relay FPC Connector by Opening Tool.



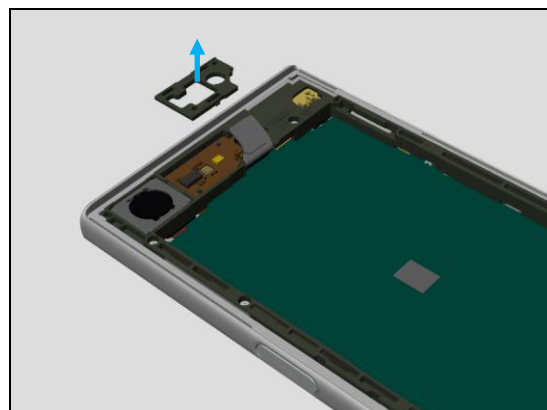
Remove the Holder FPC Sensor.

Scrap!

Don't reuse the Holder FPC Sensor when the Holder FPC Sensor is removed.

Note!

If the Sensor FPC replacement is not needed, you can skip this chapter.



4.7 Sensor FPC

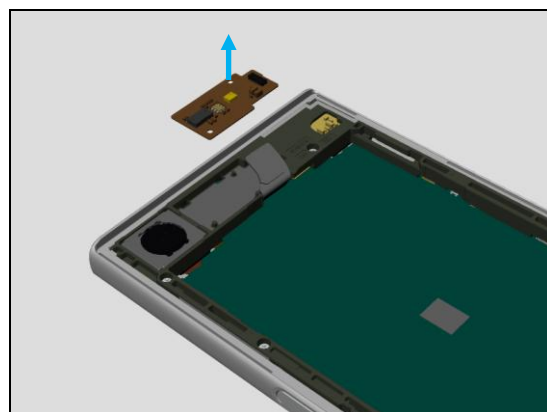
Remove the FPC Sensor.

Scrap!

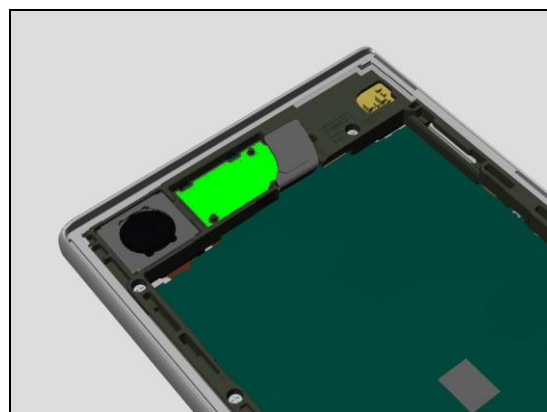
Don't reuse the Sensor FPC when the Sensor FPC is removed!

Note!

If Sensor FPC replacement is not needed, you can skip this chapter.



Remove the ADH of green highlight area.



Disassembly

4.8 Frame Main

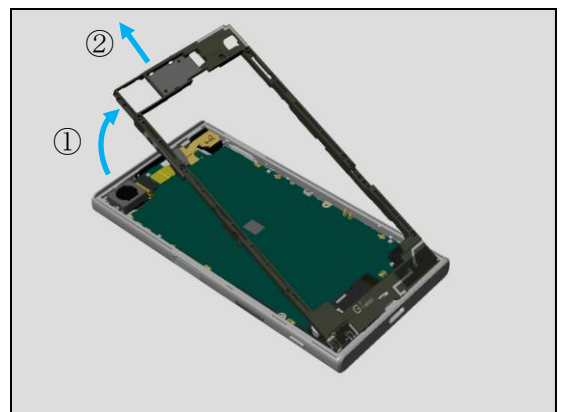
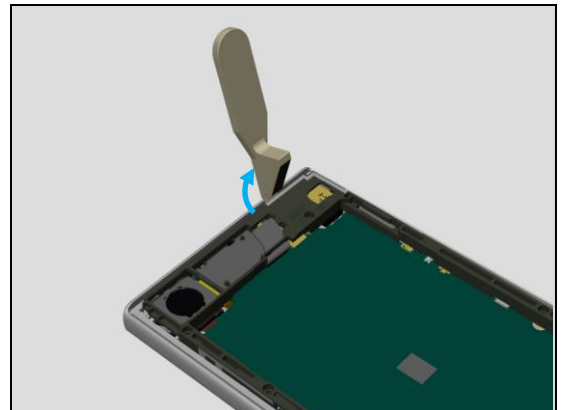
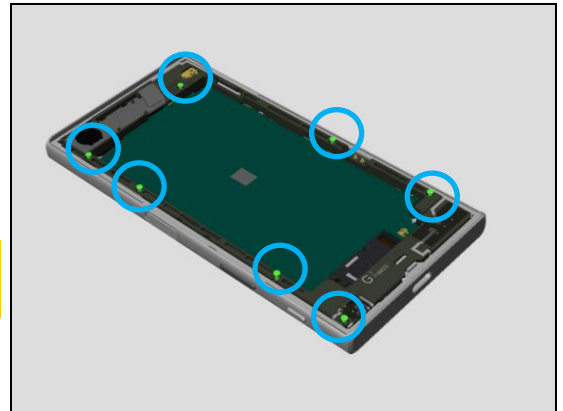
Remove the 7 of Screw by using a screwdriver with Bits (JCIS No.0).

Scrap!

Don't reuse the screws!

Pop up the Frame Main to insert the Opening Tool as shown.

Tilt up the Frame Main as shown.
And Remove the Frame Main.



4.9 Liquid Indicator

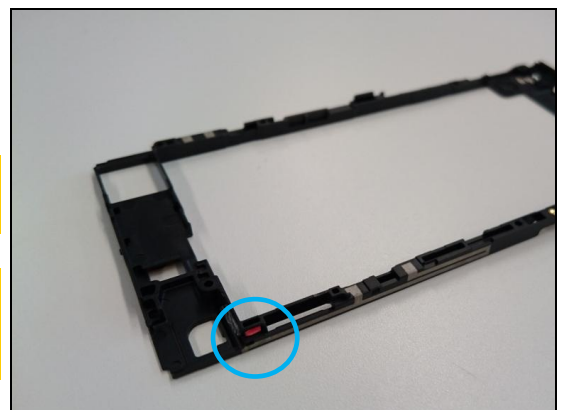
Remove the Liquid Indicator.

Scrap!

Do not reuse the Liquid indicator.

Note!

If Liquid Indicator replacement is not needed, you can skip this chapter.



Disassembly

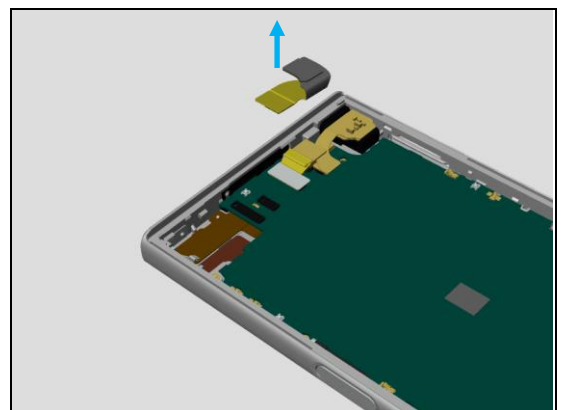
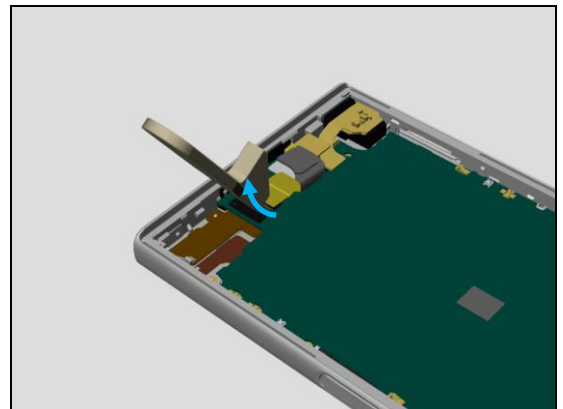
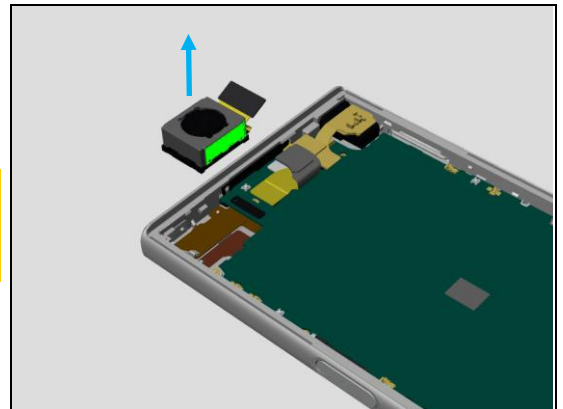
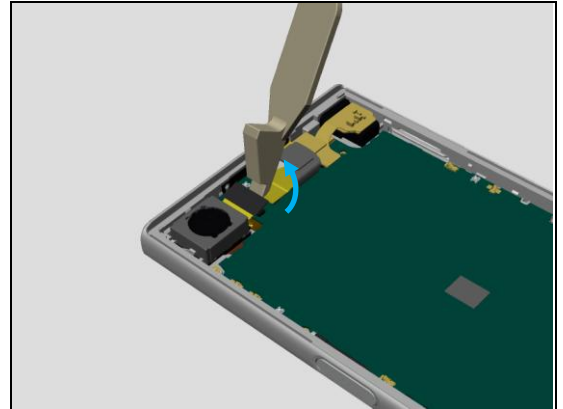
4.10 Main Camera

Disconnect the Main Camera Connector by Opening Tool.

Remove the Main Camera.

Note!

Please touch only green highlight area and opposite side when removing the Camera.



4.11 Relay FPC

Disconnect the Relay FPC Connector by Opening Tool.

Remove the Relay FPC.

Disassembly

4.12 Chat Camera

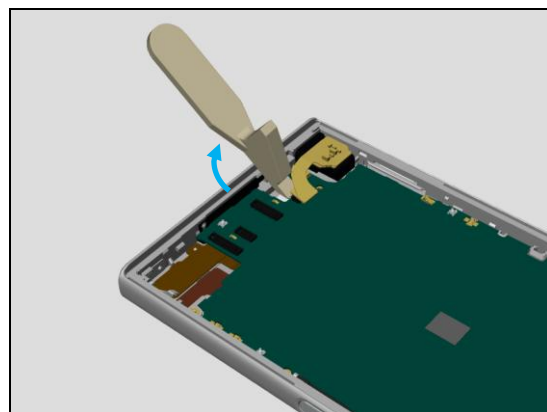
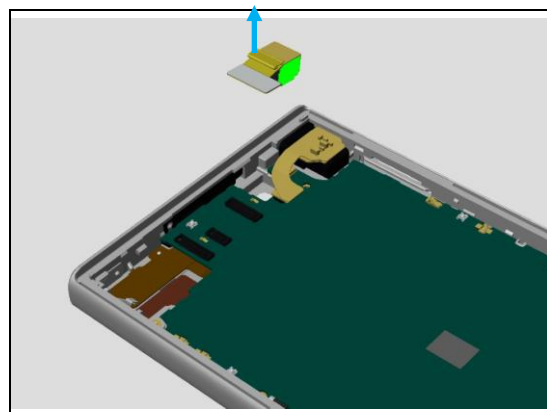
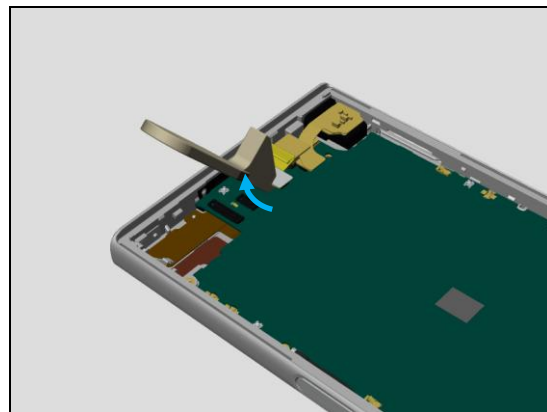
Disconnect the Chat Camera Connector by Opening Tool.

Remove the Chat Camera.

Note!

Please touch only green highlight area and opposite side when removing the Camera.

Disconnect the Audio Jack Connector by Opening Tool.



Disassembly

4.13 Speaker Box

Remove a Screw by using a screwdriver with Bits (JCIS No.0).

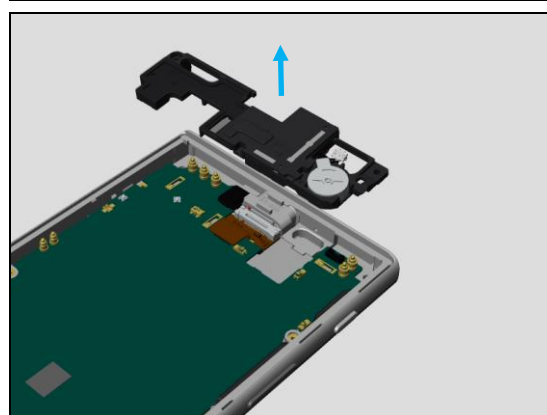
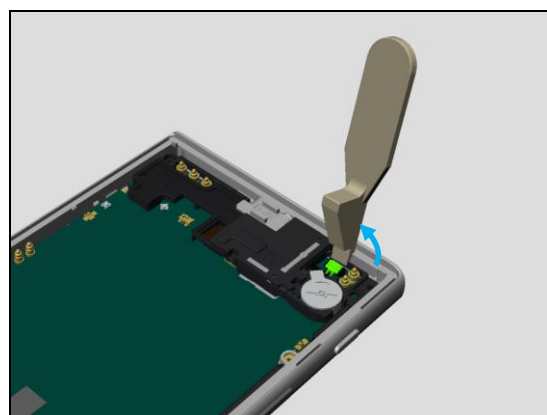
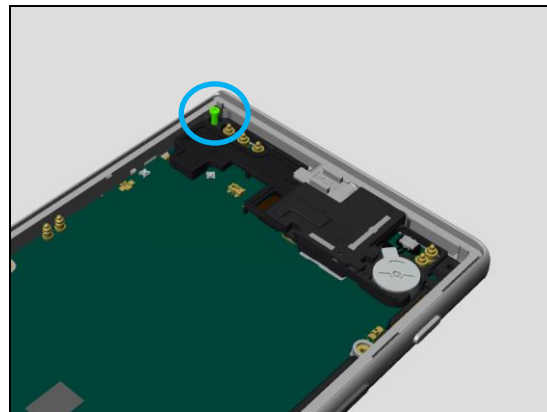
Scrap!

Don't reuse the screw!

Disconnect the Vibrator Connector by Opening Tool.

Pop up the Speaker Box to insert the Opening Tool as shown.

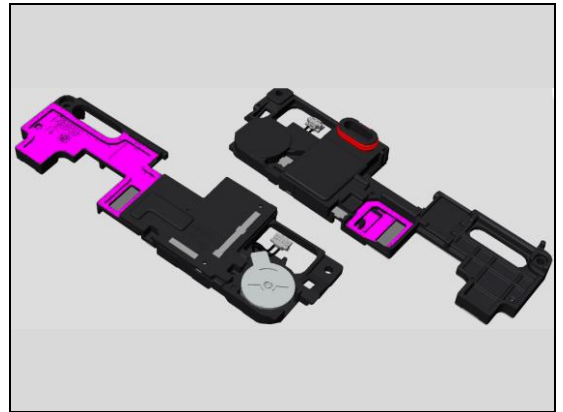
Remove the Speaker Box.



Disassembly

Note!

Don't press the pink highlight area when handling the Speaker Box.

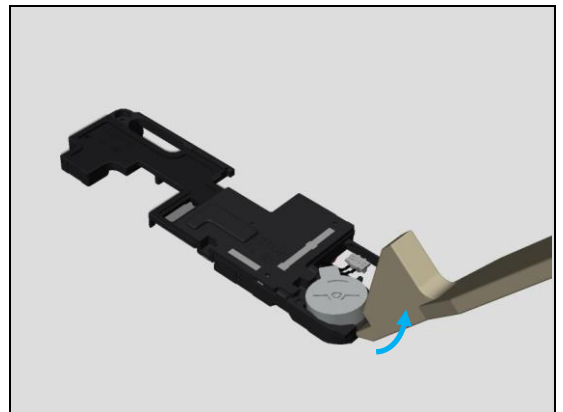


4.14 Vibrator

Pop up the Vibrator by Opening Tool.

Note!

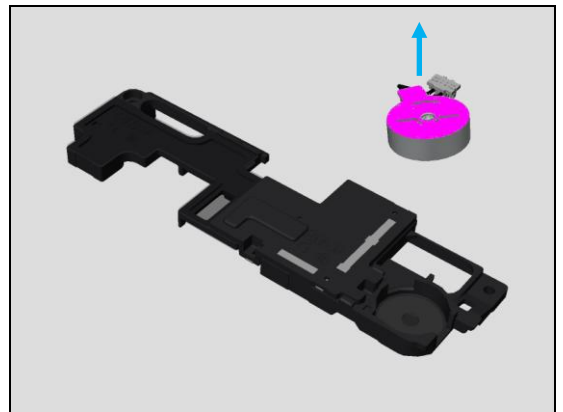
If Vibrator replacement is not needed, you can skip this chapter.



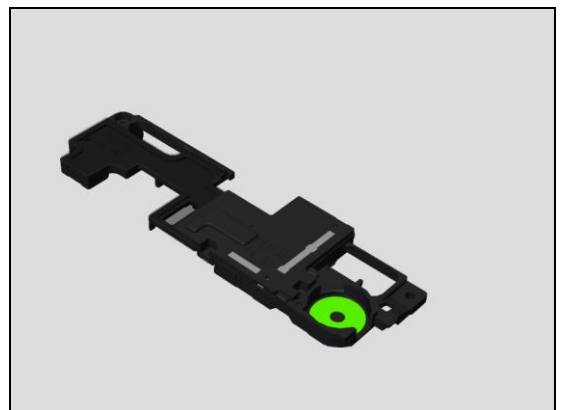
Remove the Vibrator.

Note!

When removing a vibrator, don't press upper area as shown pink area.

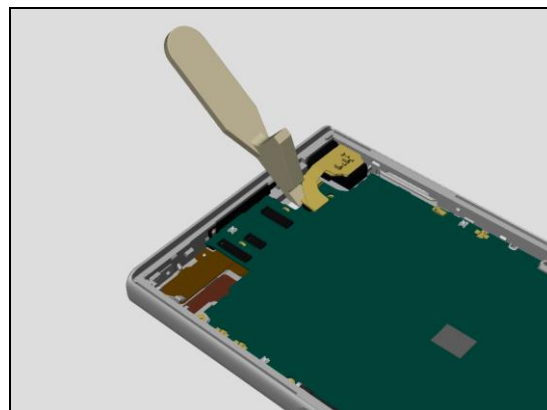


Remove the ADH Vibrator.

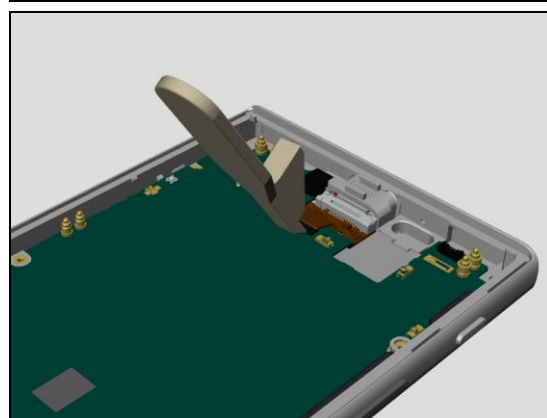


4.15 PBA

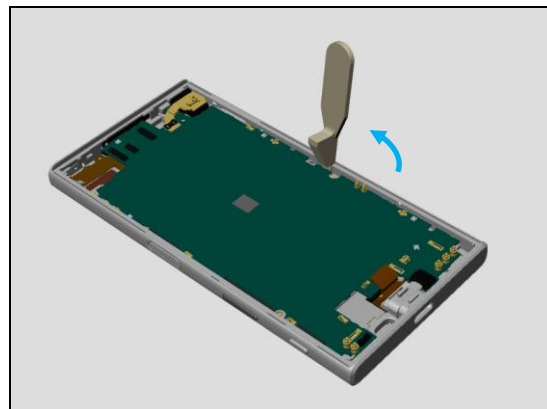
Disconnect the Audio Jack connector.



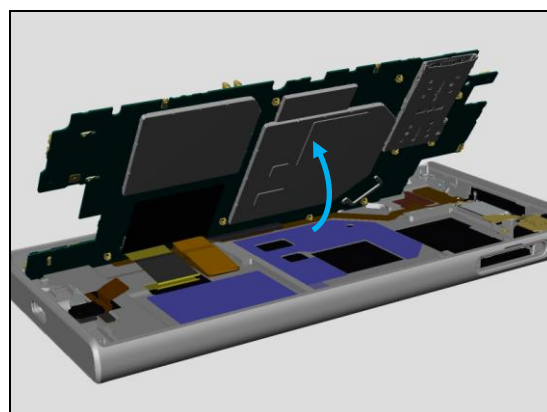
Disconnect the USB connector.



Pop up the PBA by Opening Tool as shown.



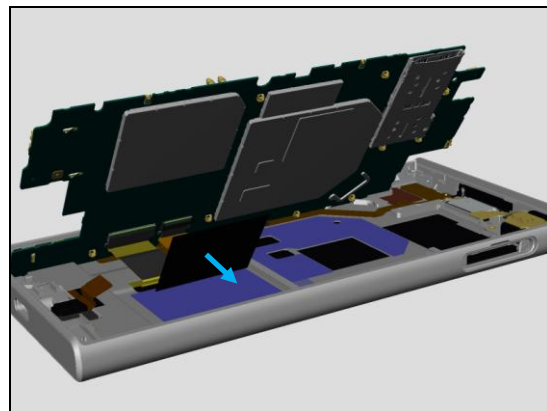
Hold the PBA as shown.



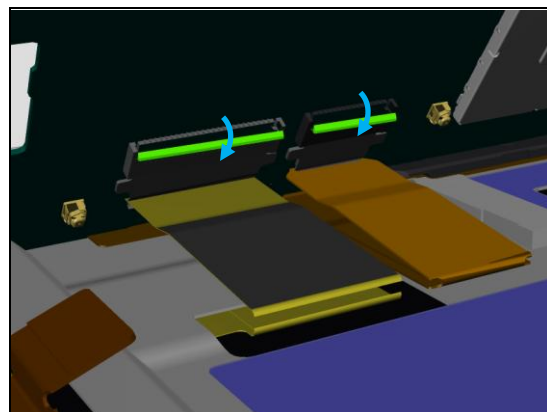
Remove the Sheet Protection PBA.

Scrap!

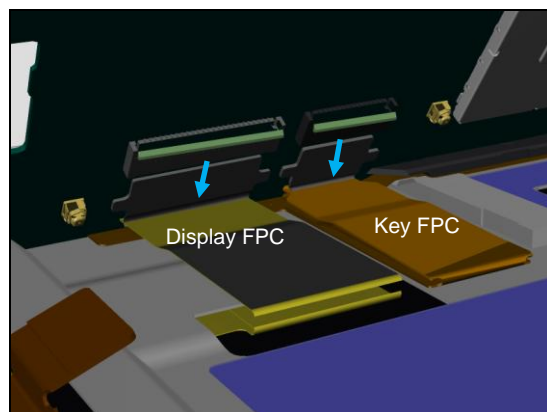
Don't reuse the Sheet Protection PBA.



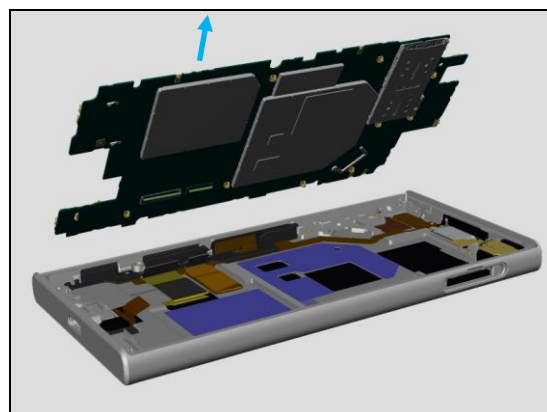
Unlock the 2 of ZIF Connector.



Slide the Display FPC and Key FPC.



Gently remove the PBA with note to spring damage.

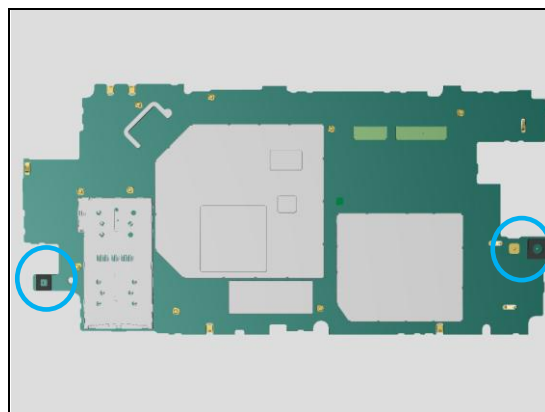
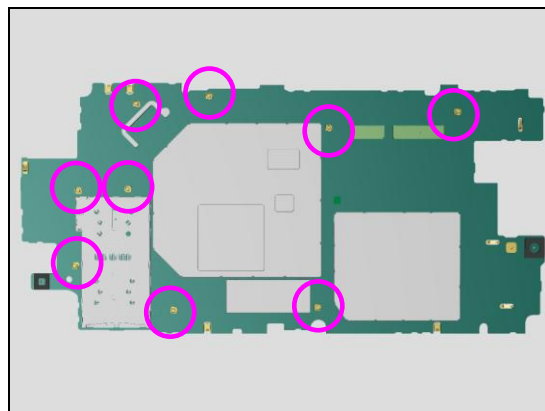


Note!

Be careful the spring damage.

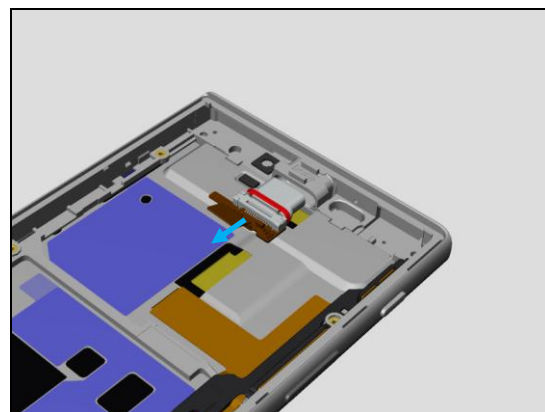
Spring location is as shown.

Remove the ADH WR Mic1, ADH WR Mic2 from PBA or Unit.



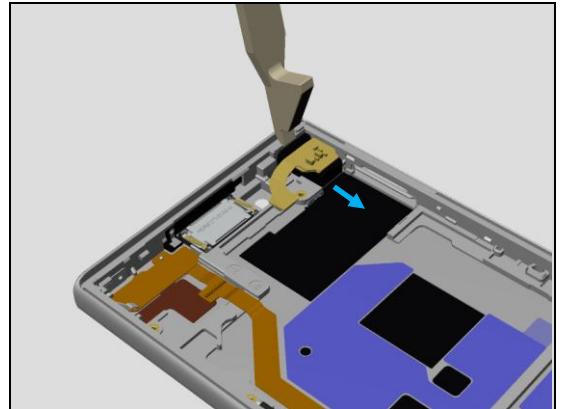
4.16 USB FPC Module

Remove the USB FPC Module.

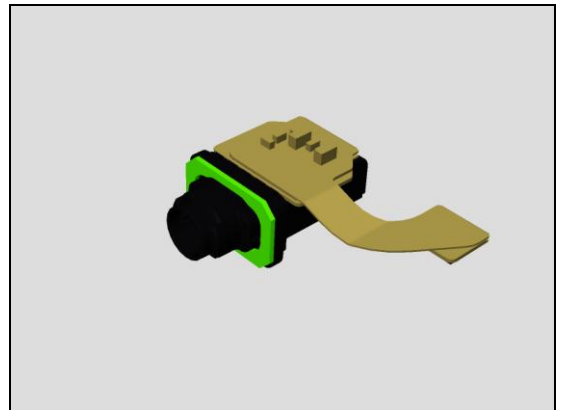


4.17 Jack FPC Module

Remove the USB FPC Module.



Remove the Adhesive WP Audio Jack.

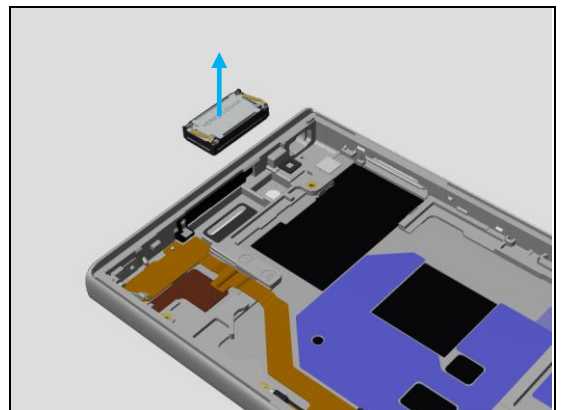


4.18 Loudspeaker

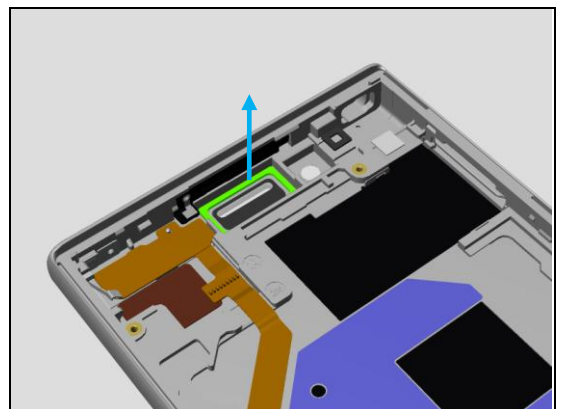
Remove the Loudspeaker.

Scrap!

Don't reuse the Loudspeaker.



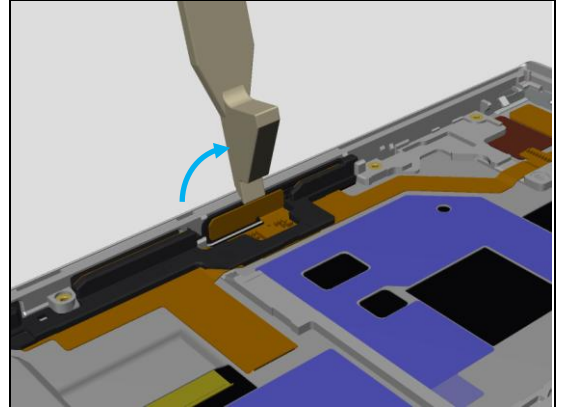
Remove the ADH Loudspeaker by Bamboo Skewer.



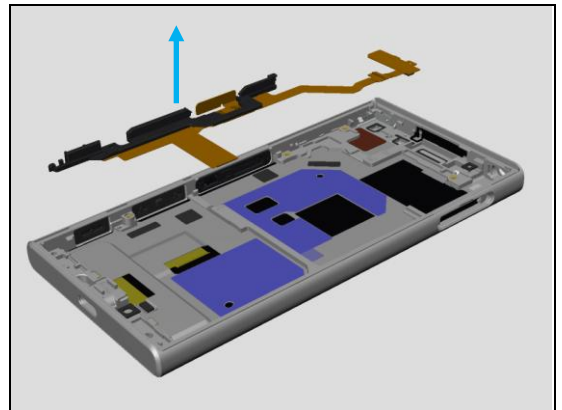
Disassembly

4.19 Key FPC

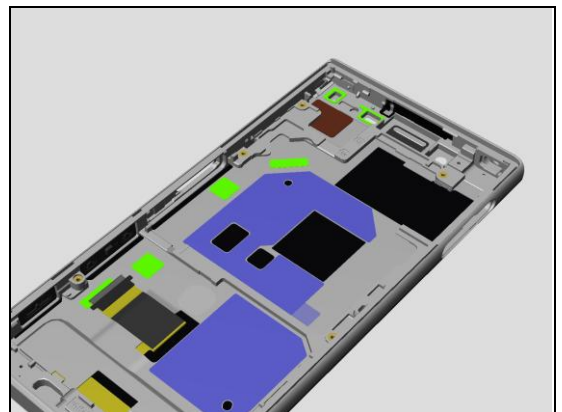
Disconnect the Fingerprint Sensor Connector by Opening Tool.



Gently remove the Key FPC.



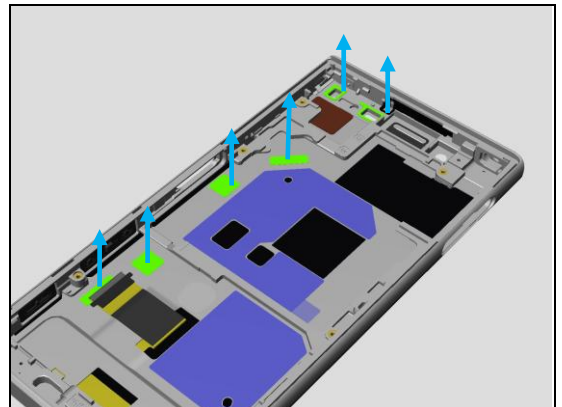
Under the Key FPC, adhesives are located where marked by green.



Remove the adhesives.

Note!

Don't press hard on Plate Display when removing adhesives.



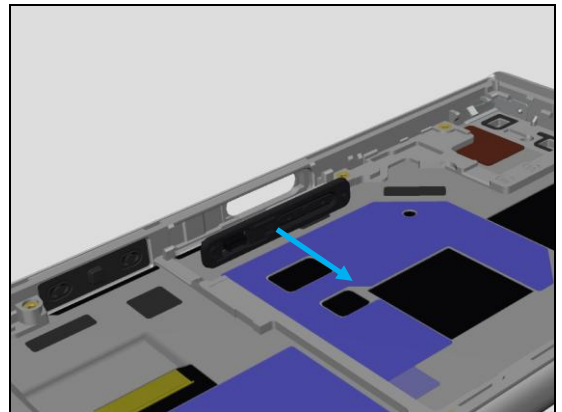
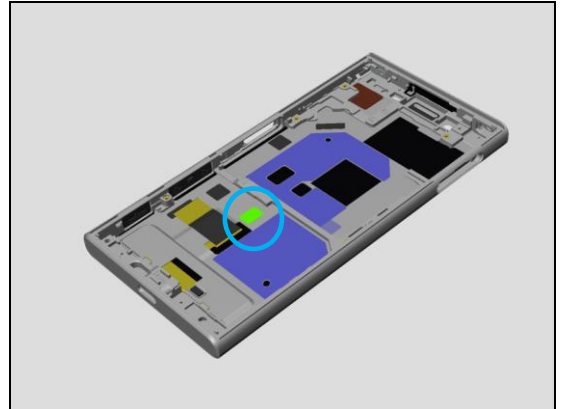
Disassembly

Note!

If Adhesive or Adhesive and sheet is on blue circle, gently remove the Adhesive by Nylon Pointer and Tweezers.

Don't press the Plate Display hard because easy to bend the Plate Display.

Plate Display Material is aluminum and thickness is 0.2mm.



4.20 Fingerprint Sensor

Remove the Fingerprint Sensor.

Disassembly

4.21 Panel Top

Spear the Panel Top to below position by Dentist Hook.

Note!

If Panel Top replacement is not needed, you can skip this chapter.

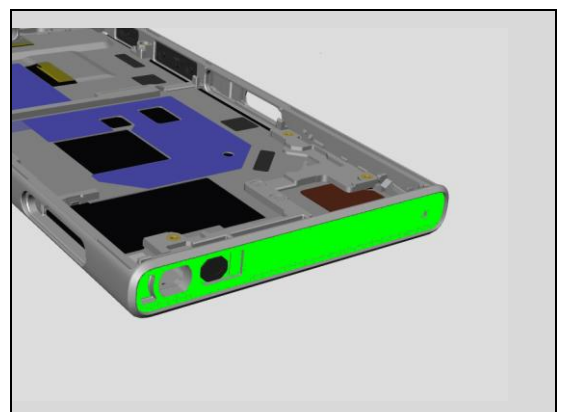
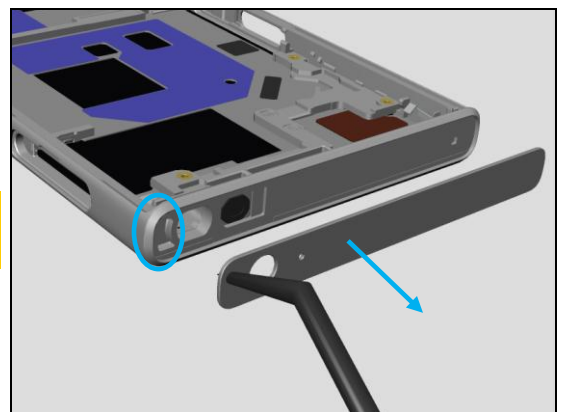
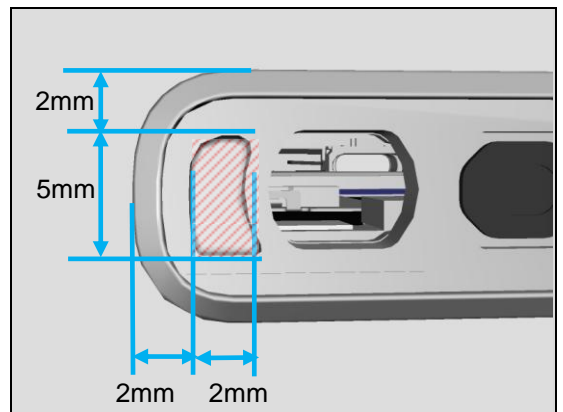
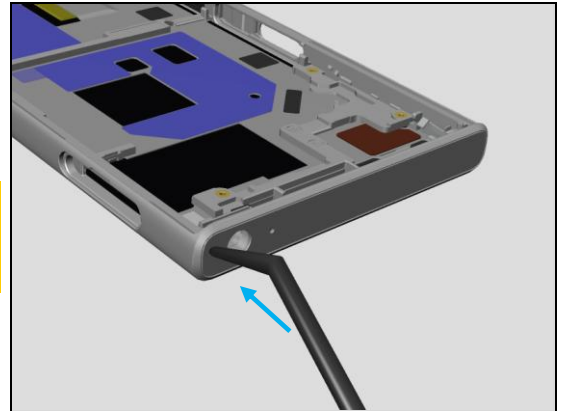
Spearling position is as below red hatching area.

Under the Panel Top, concave shape for spearing is located where marked by blue circle. (Cap Tray Assy side)

Scrap!

Don't reuse the Panel Top!

Remove the ADH Panel Top.



Disassembly

4.22 Panel Bottom

Speare the Panel Bottom to below position by Dentist Hook.

Note!

If Panel Bottom replacement is not needed, you can skip this chapter.

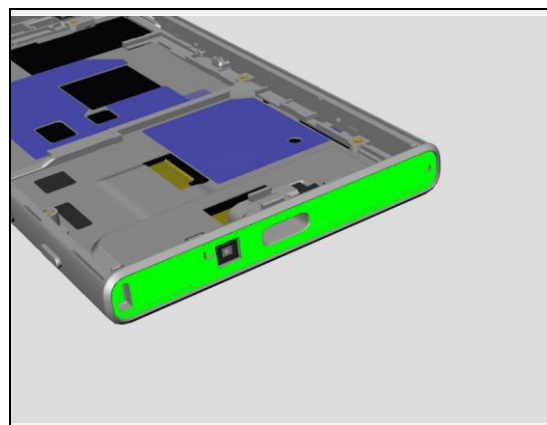
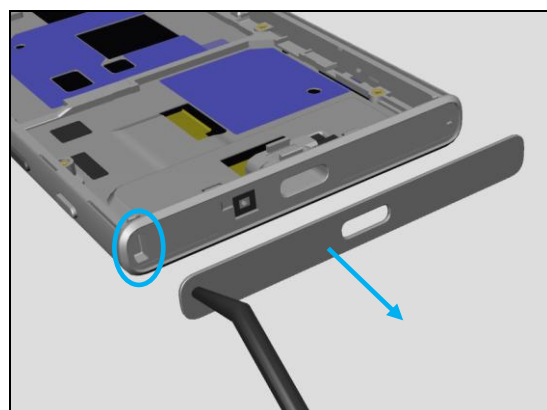
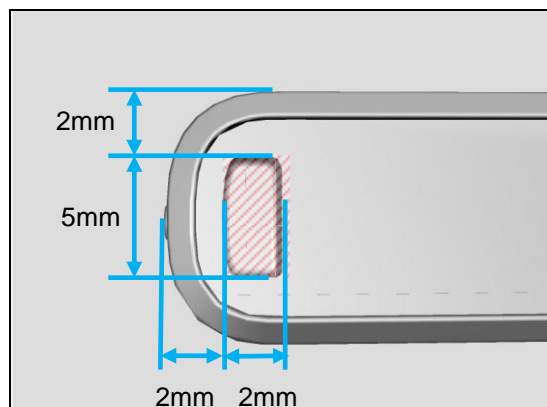
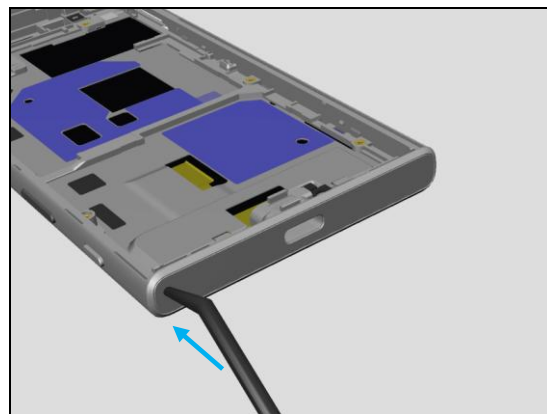
Spearing position is as below red hatching area.

Under the Panel Bottom, concave shape for spearing is located where marked by blue circle. (Camera Key side)

Scrap!

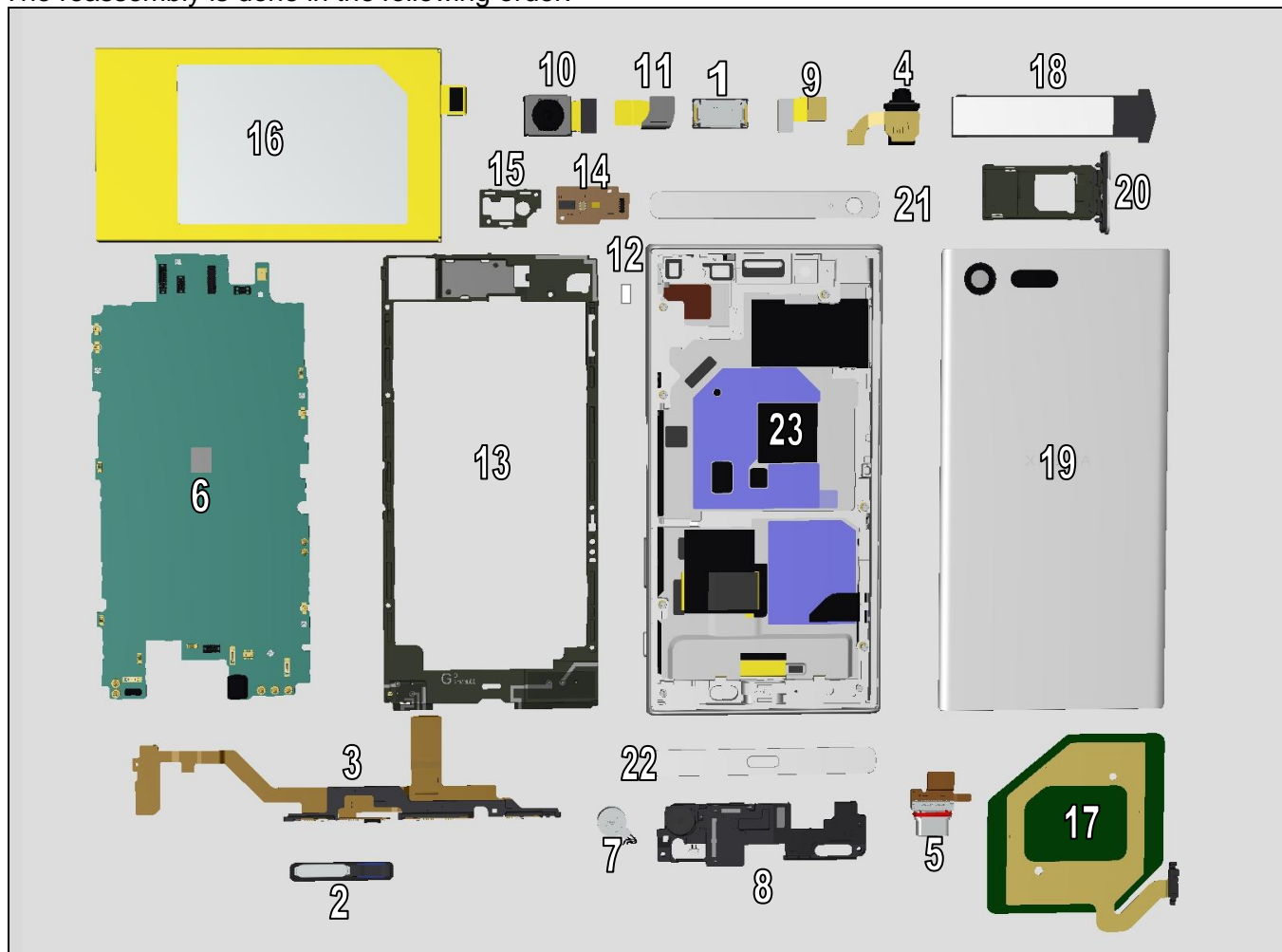
Don't reuse the Panel Bottom!

Remove the ADH Panel Bottom.
There is WRT hole under the Panel Bottom.



5 Reassembly

The reassembly is done in the following order.



1	Loudspeaker	13	Frame Main
2	Fingerprint Sensor	14	Sensor FPC
3	Key FPC	15	Holder FPC Sensor
4	Jack FPC Module	16	Battery
5	USB FPC Module	17	Ant NFC Flex
6	PBA	18	Sheet Slider MOP
7	Vibrator	19	Cover Rear
8	Speaker Box	20	Cap Tray Assy
9	Chat Camera	21	Panel Top
10	Main Camera	22	Panel Bottom
11	Relay FPC	23	Front Assy
12	Liquid Indicator		

Reassembly

Reassembly Quick Reference Chart is embedded.

Click the icon to open the file.

Required reassembly procedures of specific part replacement can be identified by Reassembly Quick Reference Chart.

The following is the sample how to identify the procedures.

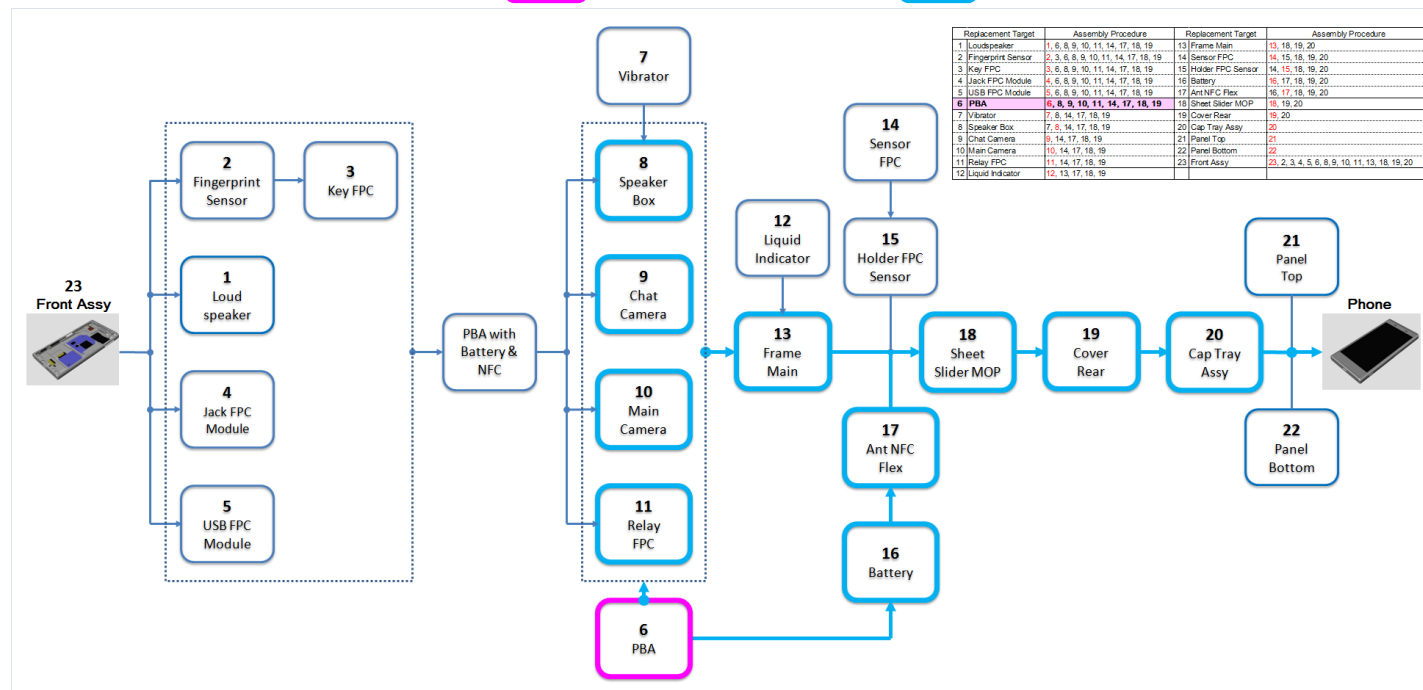
Ex1. In case of PBA replacement



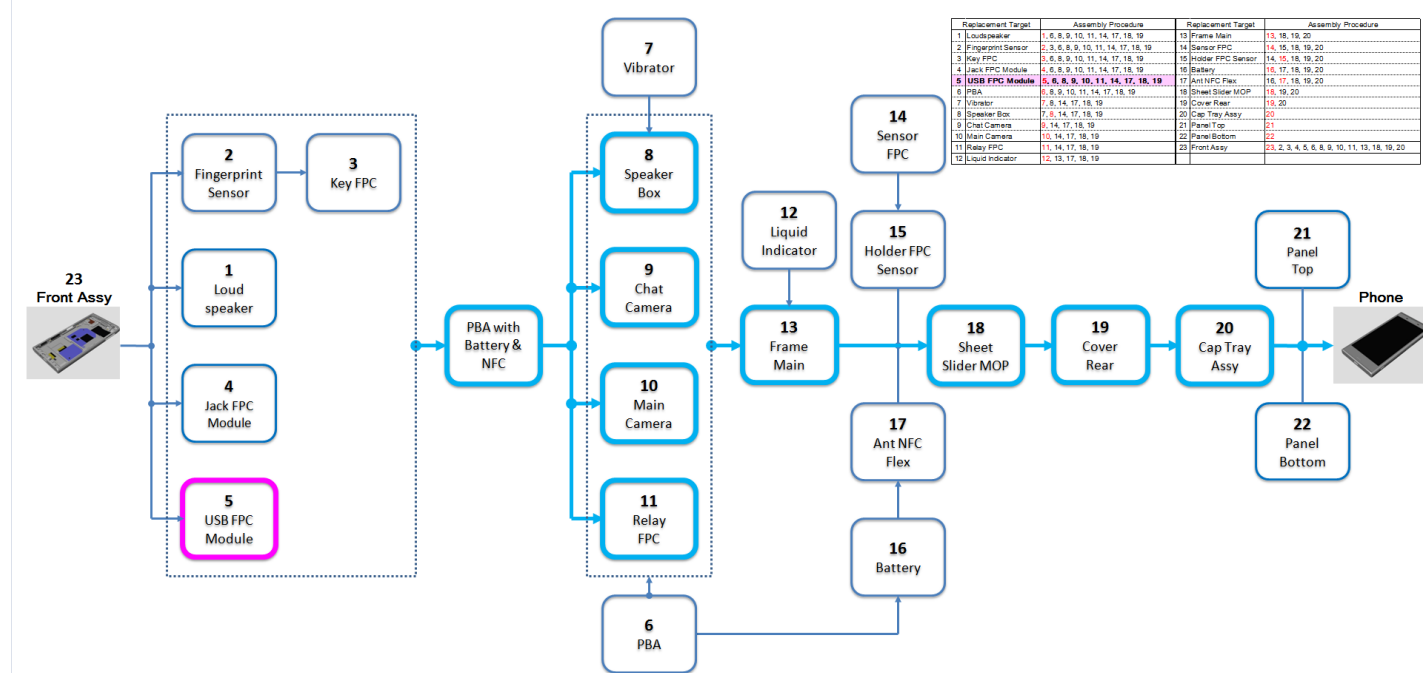
: Replacement Target



: Necessary Procedure



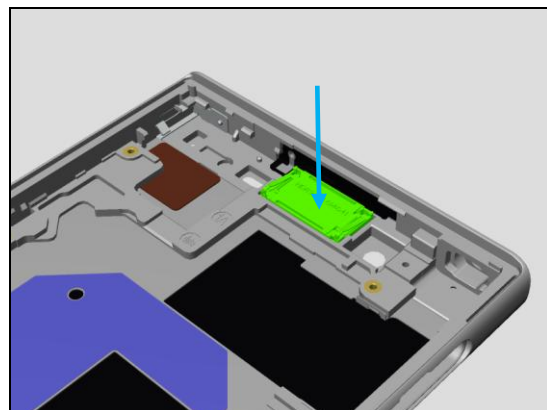
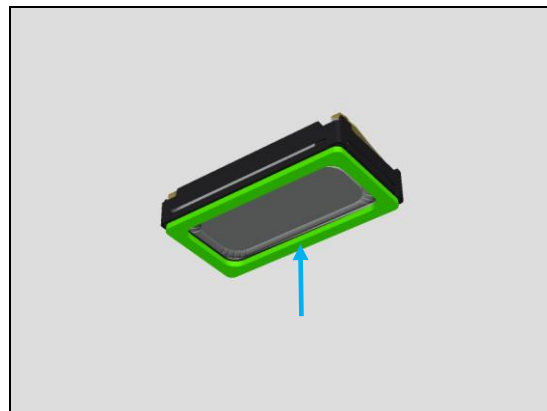
Ex2. In case of USB FPC Module replacement



5.1 Loudspeaker

Paste the Adhesive WR Receiver to Loudspeaker.

Install and press the Loudspeaker to Front Assy.



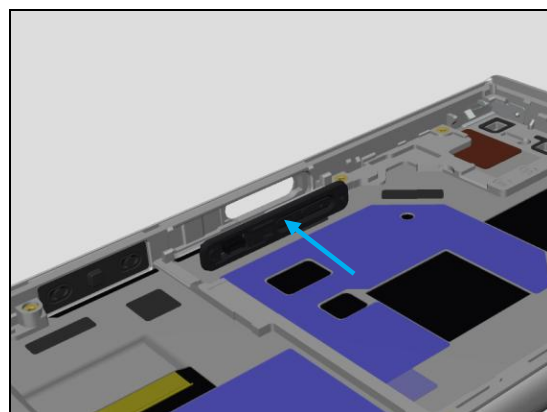
5.2 Fingerprint Sensor

Install the Fingerprint Sensor on the Front Assy.

Note!

Confirm that there are no clearance gaps.

And don't push the Fingerprint Sensor from outside until screwed Frame Main.



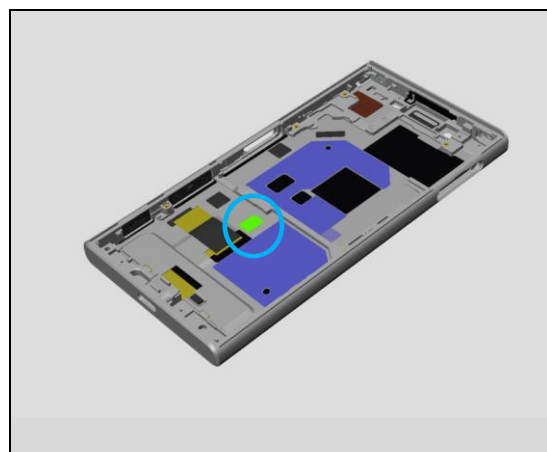
5.3 Key FPC

Note!

If Adhesive or Adhesive and sheet is on blue circle, gently remove the Adhesive by Nylon Pointer and Tweezers before Key FPC assembly.

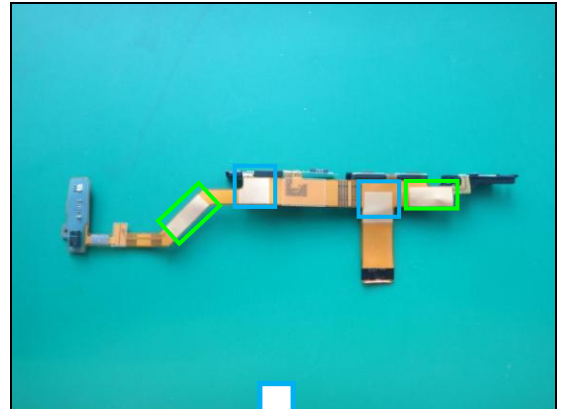
Don't press the Plate Display hard because easy to bend the Plate Display.

Plate Display Material is aluminum and thickness is 0.2mm.



Reassembly

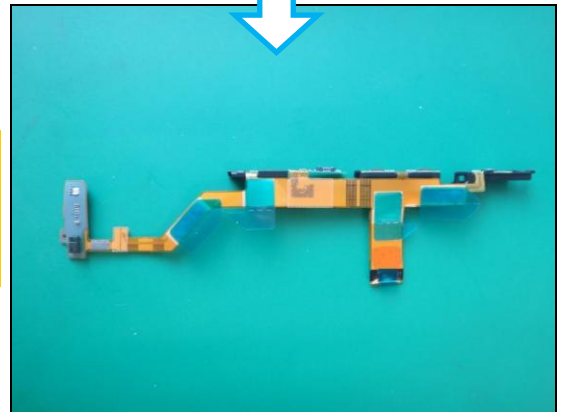
Paste the Adhesive RF FPC Key Rect on metal contact highlighted green areas and Adhesive RF FPC Key SQ on metal contact highlighted blue areas.



Note!

If using a New Front Assy, it is not necessary to paste adhesives on Key FPC.

Because Adhesives are already pasted on Front Assy.

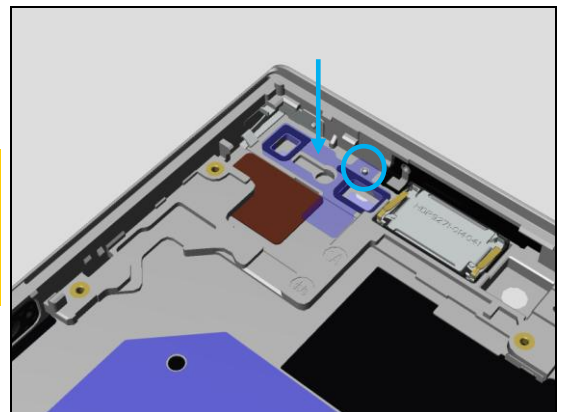


Adjust the Adhesive 3LED position to convex as blue circle and paste the Adhesive.

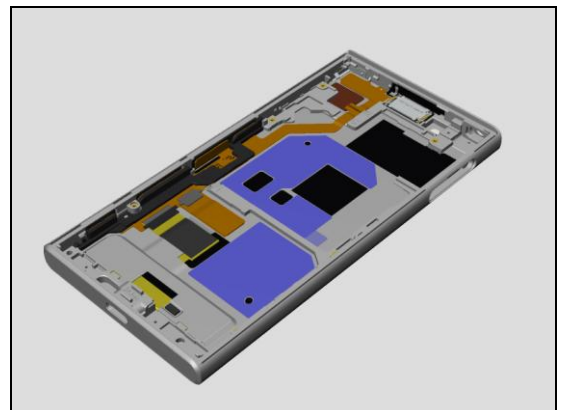
Note!

If using a New Front Assy, it is not necessary to paste adhesive on Front Assy.

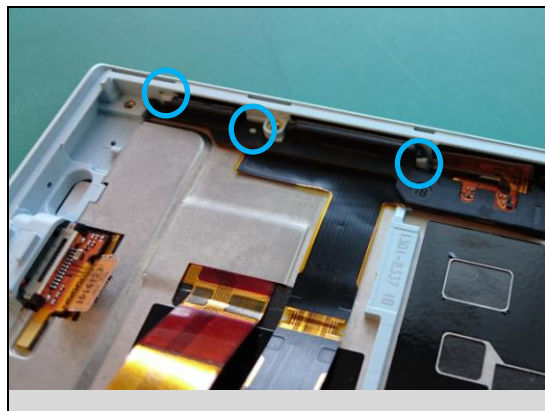
Because Adhesives are already pasted on Front Assy.



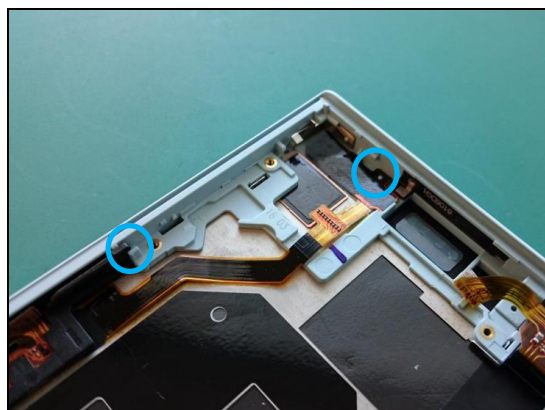
Install the Key FPC with below confirmation.



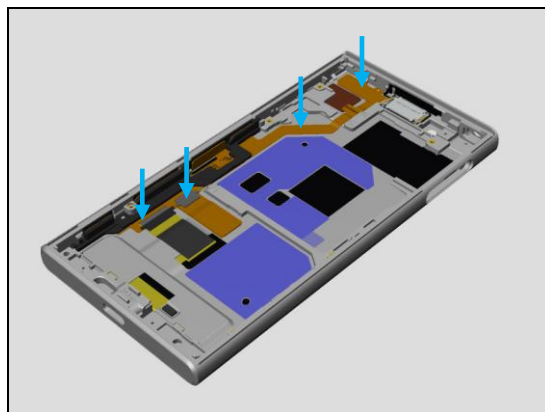
Confirm the right installation of blue circles.



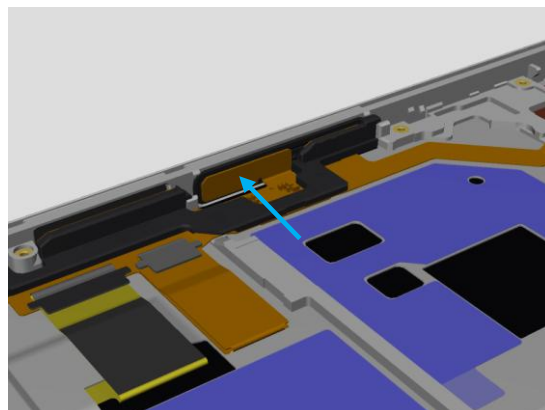
Confirm the right installation of blue circles.



Press the Adhesives areas.

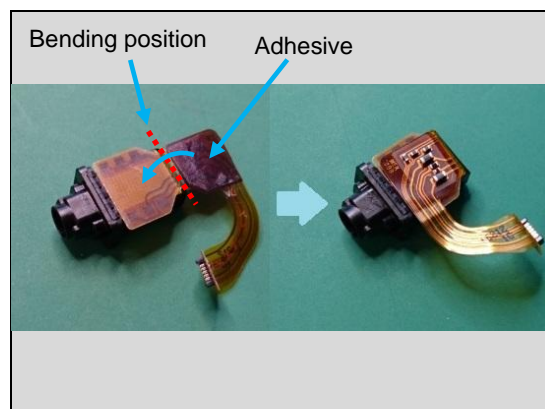


Connect the Fingerprint Sensor Connector to Key FPC.

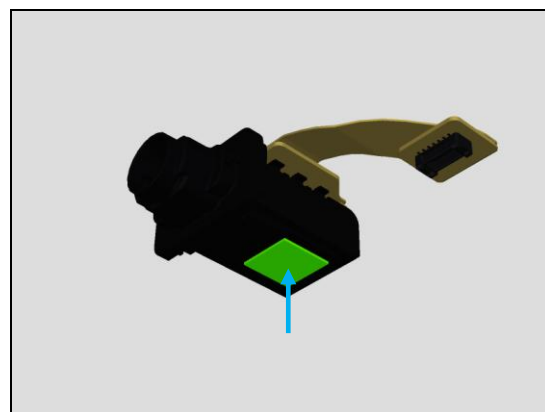


5.4 Jack FPC Module

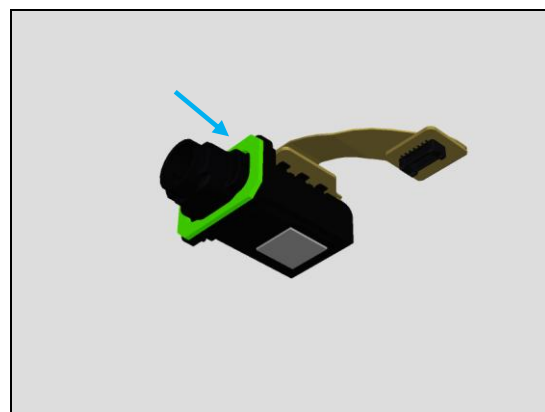
Bend the Jack FPC Module and press the Jack FPC Module.



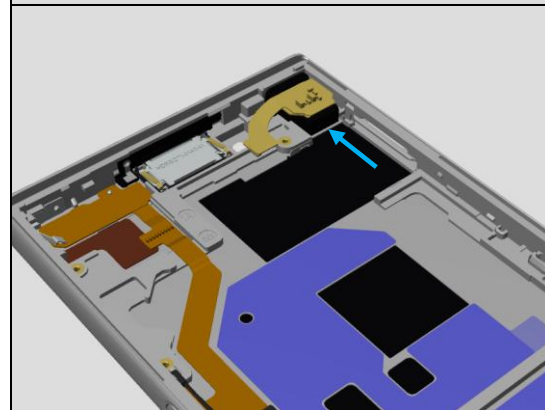
Paste the Sheet Jack.



Paste the Adhesive WR Audio Jack.

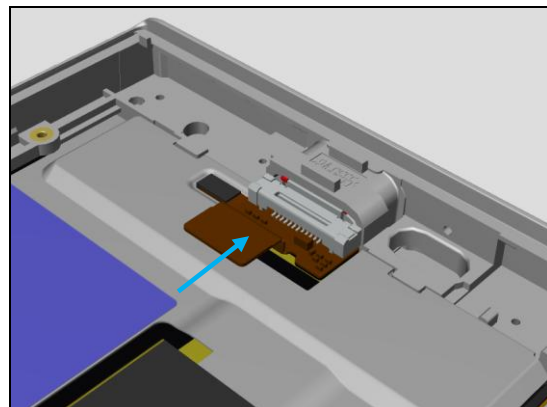


Press 10sec the Jack FPC Module.



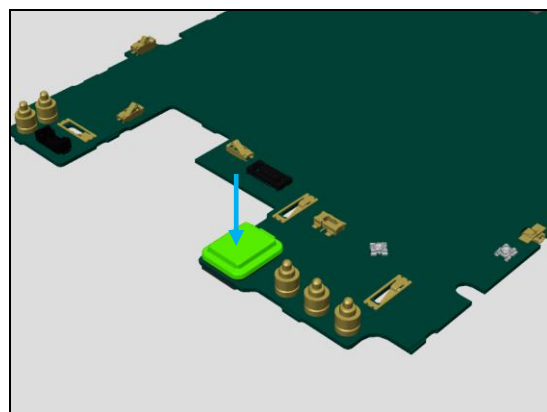
5.5 USB FPC Module

Install the USB FPC Module.



5.6 PBA

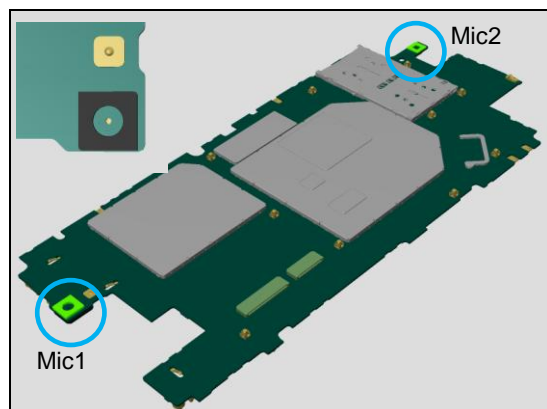
Paste the Cap Mic1 on PBA.



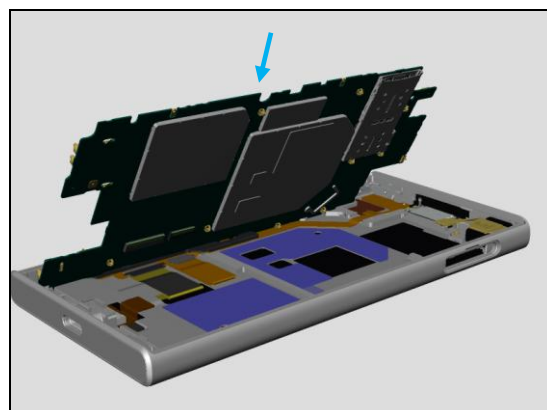
Paste the Adhesive WR Mic1 and Adhesive WR Mic2.

Note!

Don' t close the Mic hole by Adhesive.

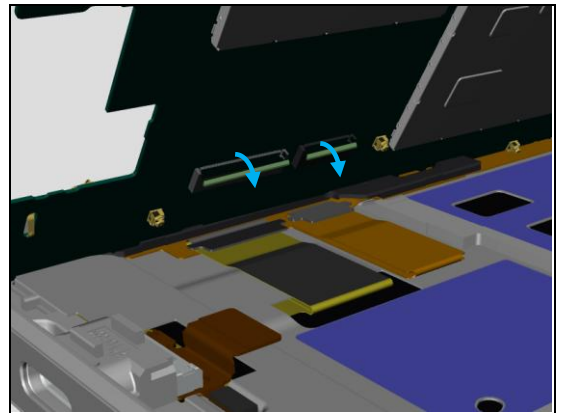


Temporary install the PBA as shown.

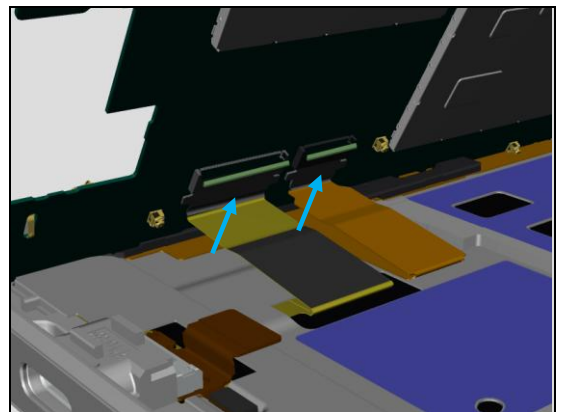


Reassembly

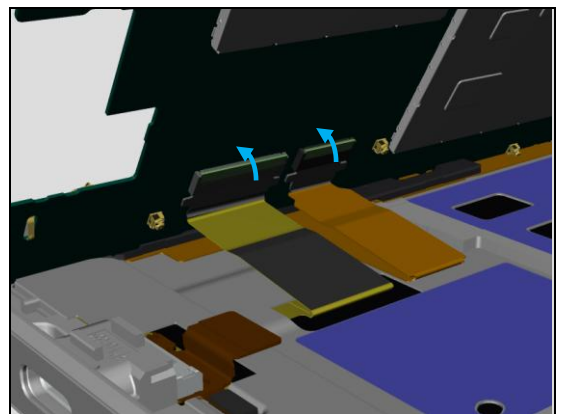
Unlock the ZIF Connectors.



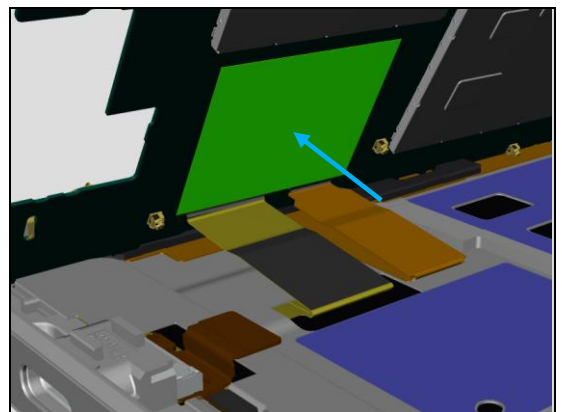
Insert the Display FPC and Key FPC to ZIF Connector.



Lock the ZIF Connectors.



Paste the Sheet Protection PBA as below position.



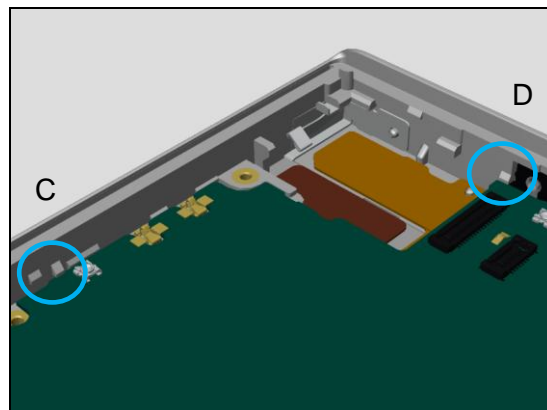
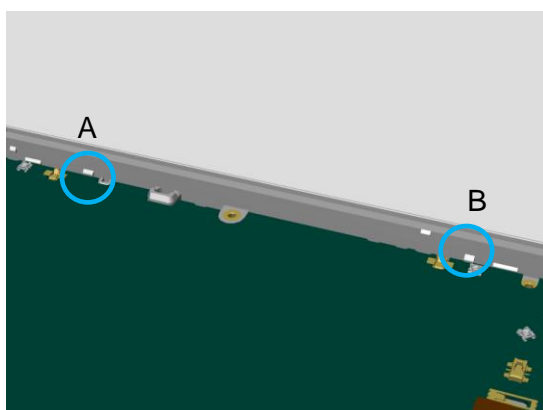
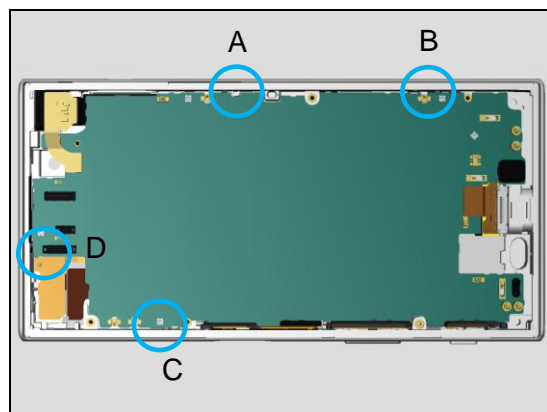
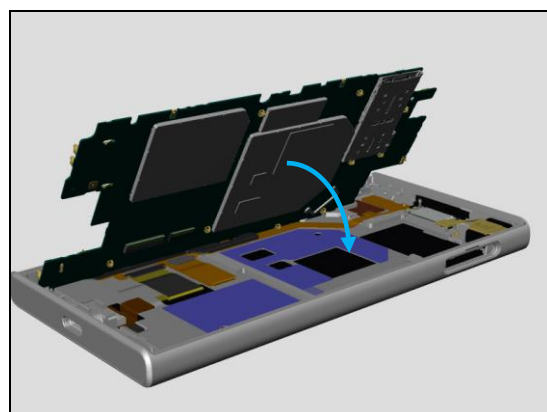
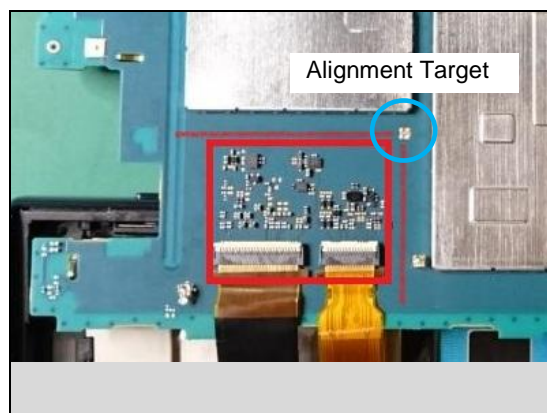
Reassembly

Note!

Cover all components, ZIF Connector and FPC by Sheet Protection PBA.

Install the PBA as shown.

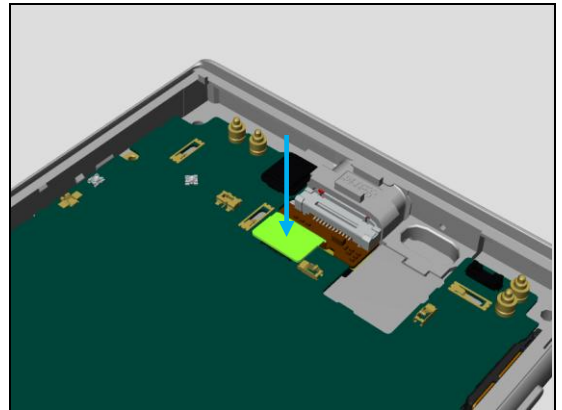
Confirm the 4 hooks of as shown position.



Press the Adhesive WR Mic1 and Adhesive WR Mic2 area.



Connect the USB FPC Module Connector.

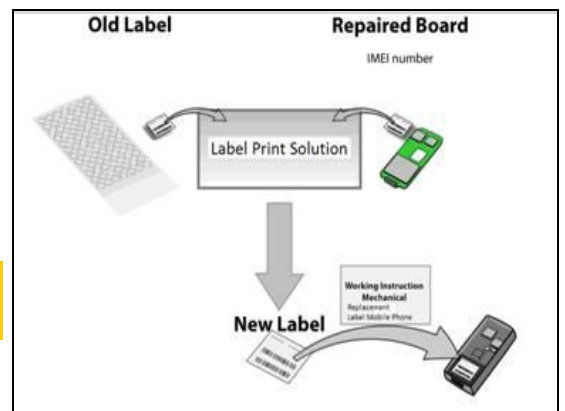


Board Swap – Change Label MOP

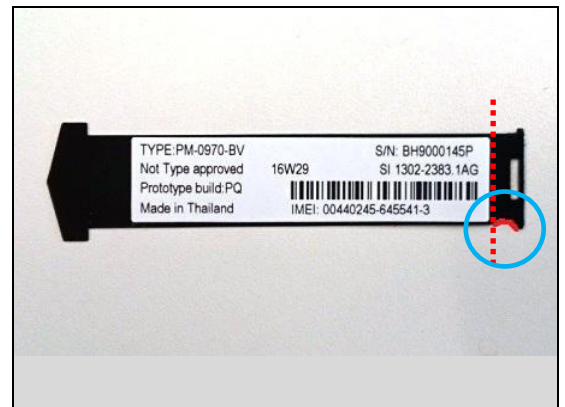
When board swap, follow the instructions in the Generic Repair Manual – Build swap for change of label.

Note!

Label MOP have to be replaced only when board swap.



Paste the Label MOP along cutout.

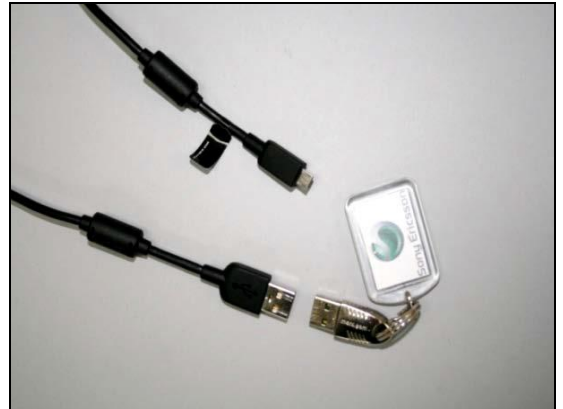


Board Swap – Customize of Software

When board swap, follow the instructions in the Generic Repair Manual – Build swap for customization of the software.

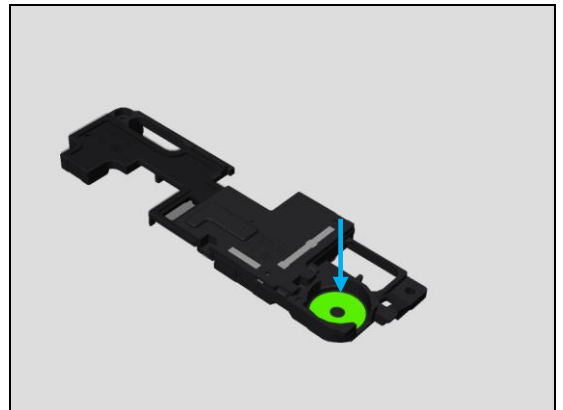
Note!

Customize of Software have to be performed only when board swap.

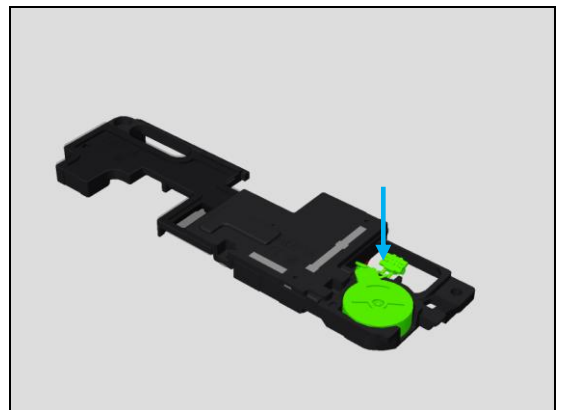


5.7 Vibrator

Paste the Adhesive Vibrator on Speaker Box.



Install the Vibrator on Speaker Box and press.



5.8 Speaker Box

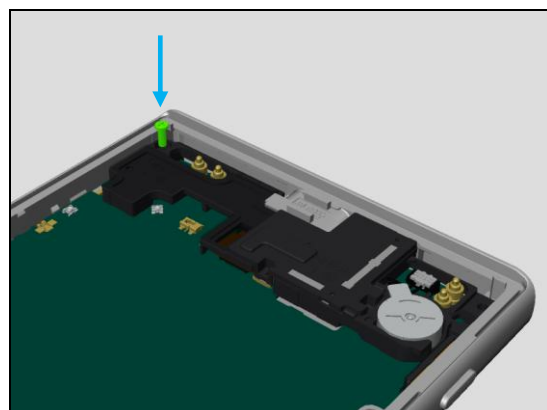
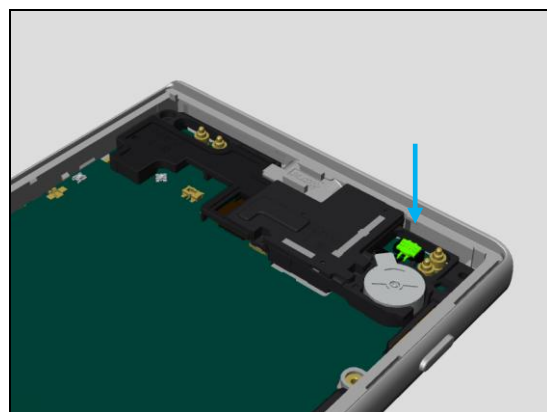
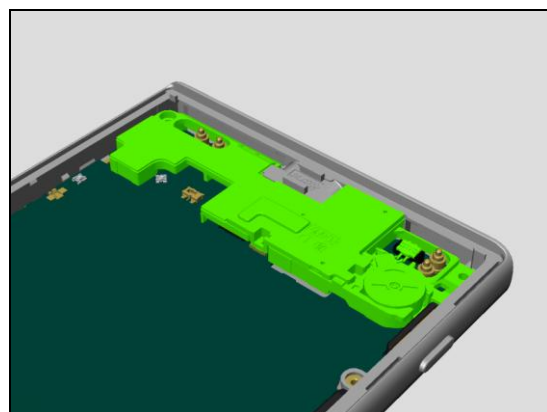
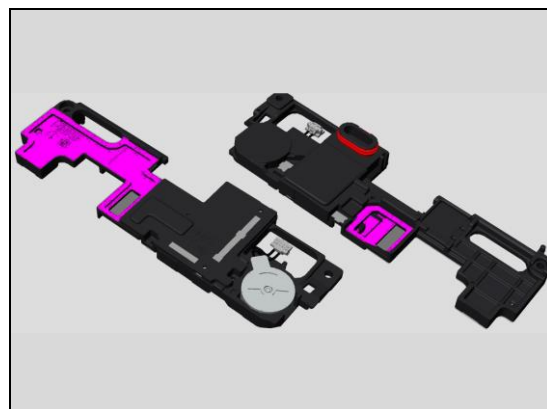
Note!

Don't press the pink highlight area when handling the Speaker Box.

Install the Speaker Box.

Connect the Vibrator Connector.

Tighten Screw by using a screwdriver with Bit (JCIS No.0)
Torque: 8 ± 1 [Ncm]



5.9 Chat Camera

Install the Chat Camera.

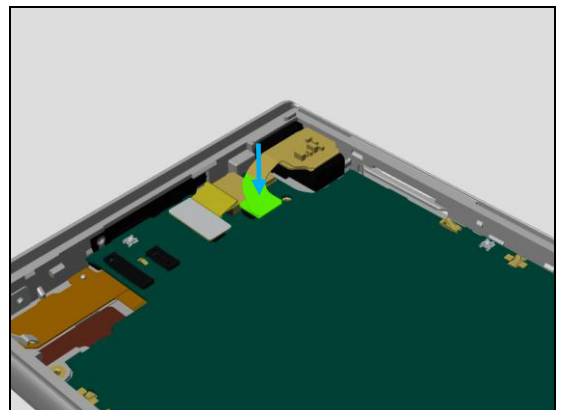
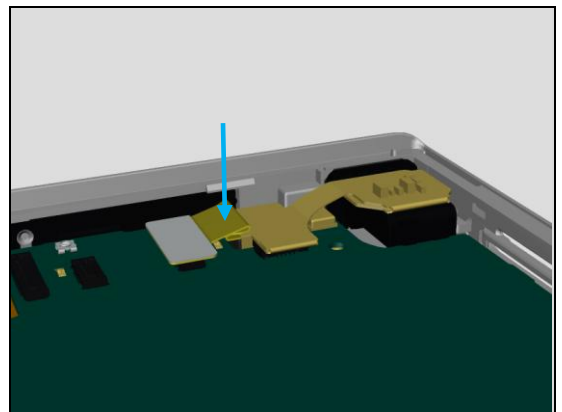
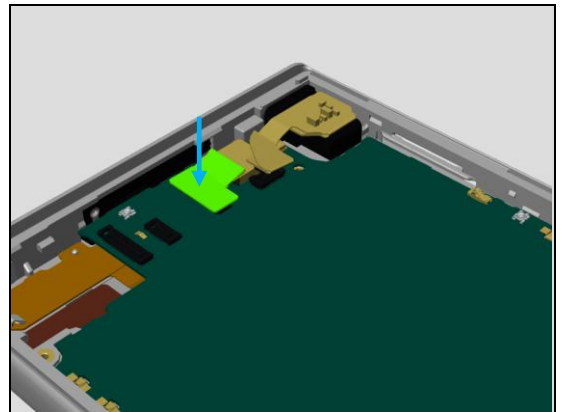
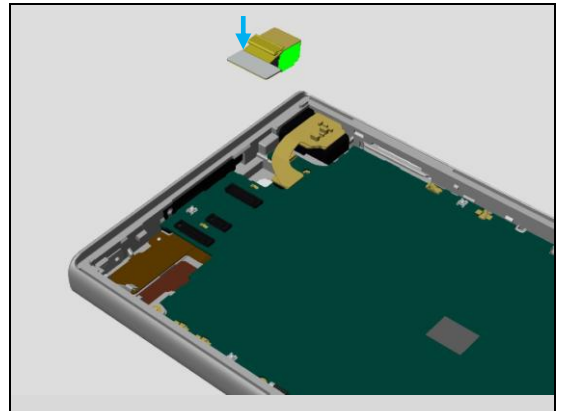
Note!

Please touch only green area and opposite side when assembly the Camera.

Connect the Chat Camera Connector.

Press the FPC for reduce tension of FPC.

Connect the Audio Jack Connector.



5.10 Main Camera

Note!

Please touch only green area and opposite side when assembly the Camera.

Pre-Bend Main Camera FPC for reduce tension of FPC.

Install the Main Camera.

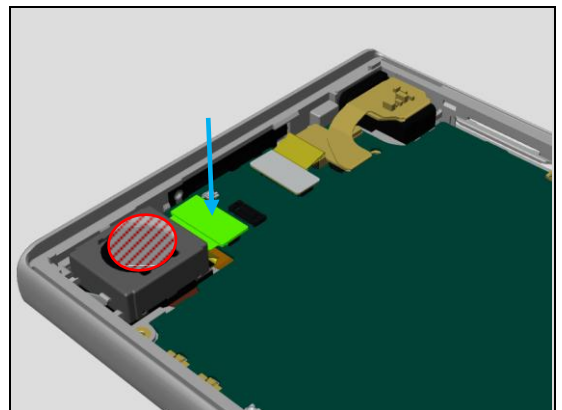
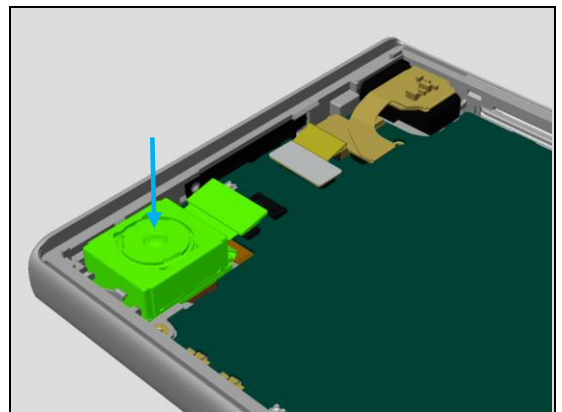
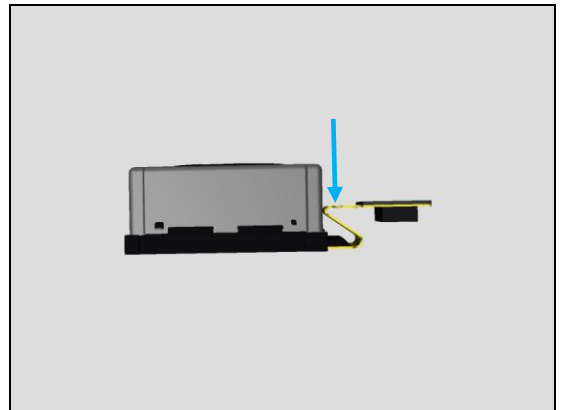
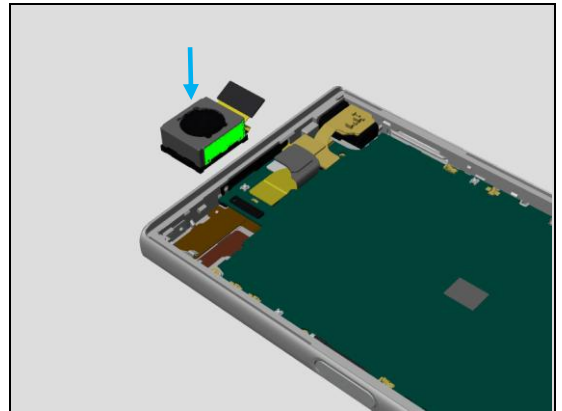
Note!

Make sure no dust, no foreign materials in the camera cavity.

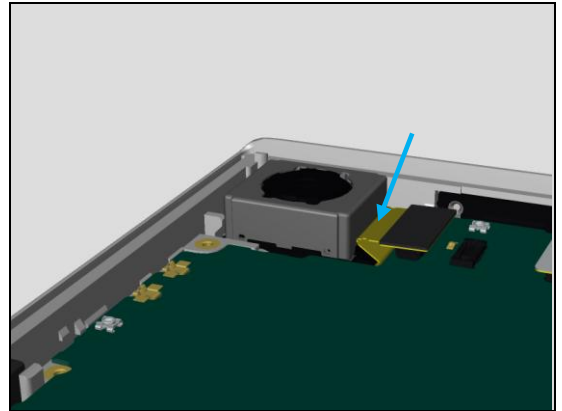
Connect the Main Camera Connector.

Note!

Do not push the lens module of the Main Camera (hatched by red) during installing of the Main Camera on the unit.

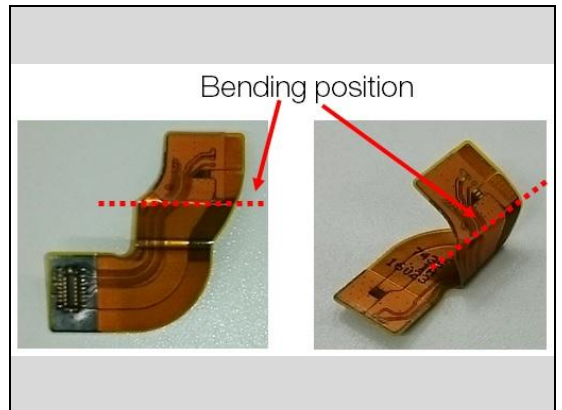


Press the Main Camera FPC for reduce tension of FPC.

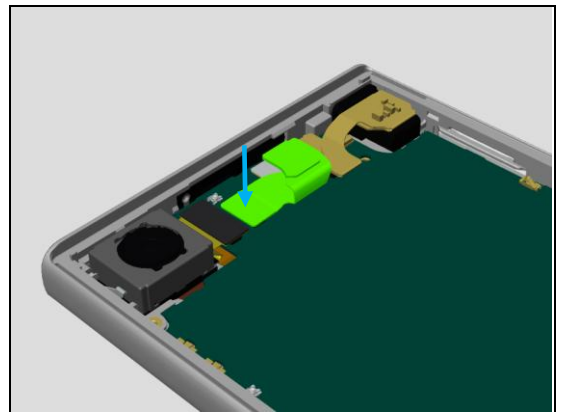


5.11 Relay FPC

Pre-Bend Relay FPC for reduce tension of FPC.



Connect the Relay FPC Connector.



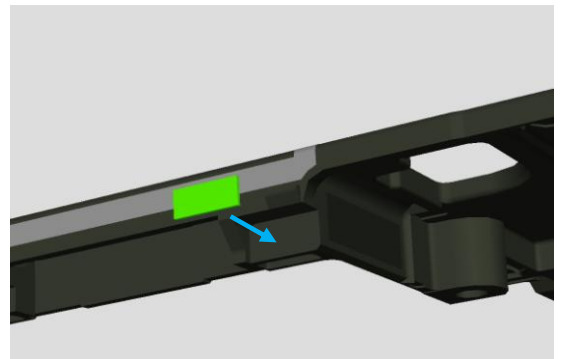
5.12 Liquid Indicator

Paste the Liquid Indicator.

Note!

If Liquid Indicator replacement is not needed, you can skip this chapter.

Liquid Indicator is initially included in Frame Main.

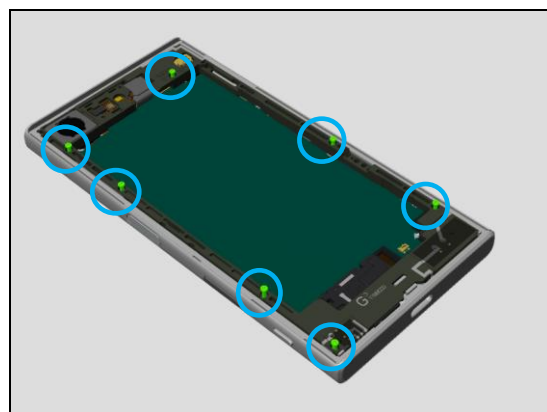
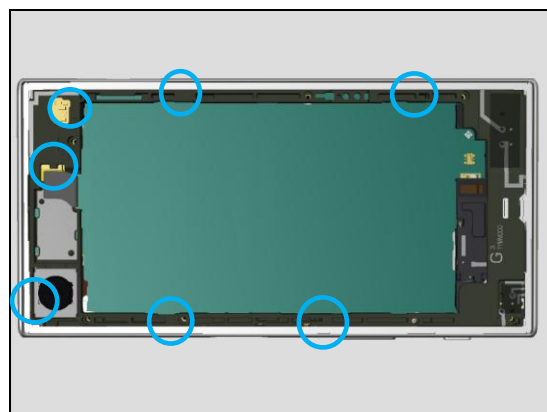
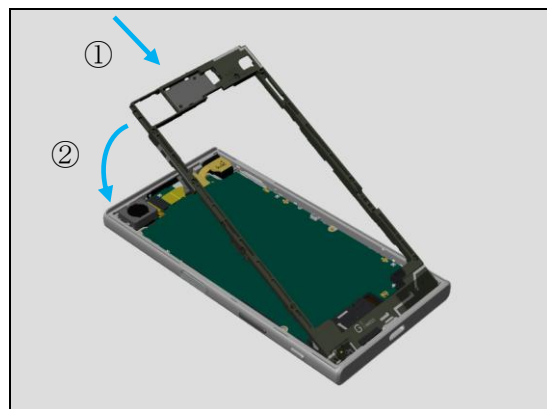


5.13 Frame Main

Install the Frame Main as shown.

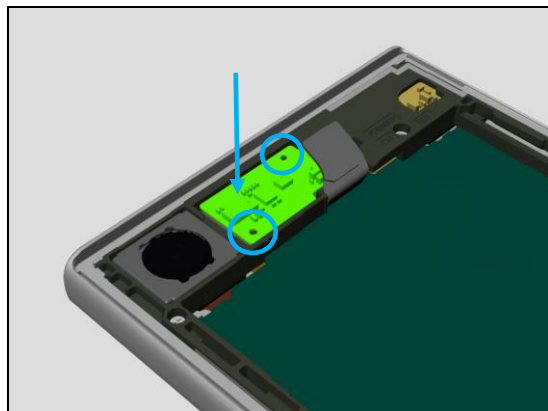
Lock the 7 hooks of Frame Main to unit.

Tighten Screws by using a screwdriver with Bit (JCIS No.0)
Torque: 8 ± 1 [Ncm] $\times 7$ pcs



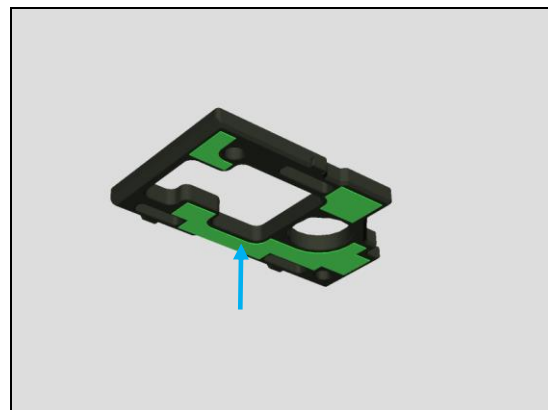
5.14 Sensor FPC

Paste the Sensor FPC to Frame Main.

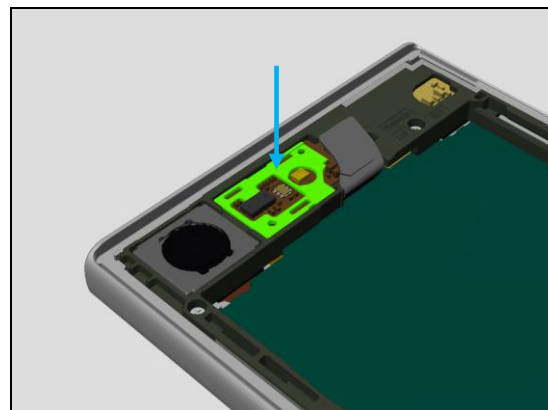


5.15 Holder FPC Sensor

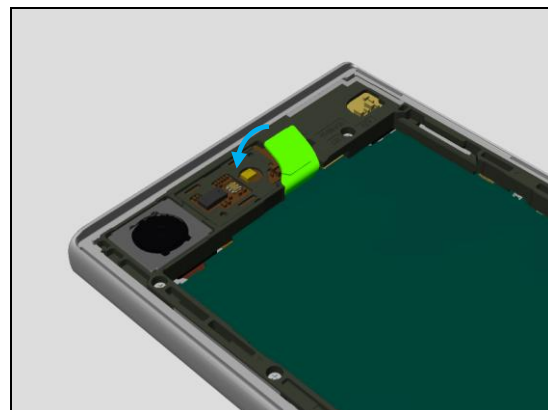
Paste the Adhesive Holder FPC Sensor to Holder FPC Sensor.



Install the Holder FPC Sensor to Sensor FPC.



Connect the Relay FPC Connector to Sensor FPC.



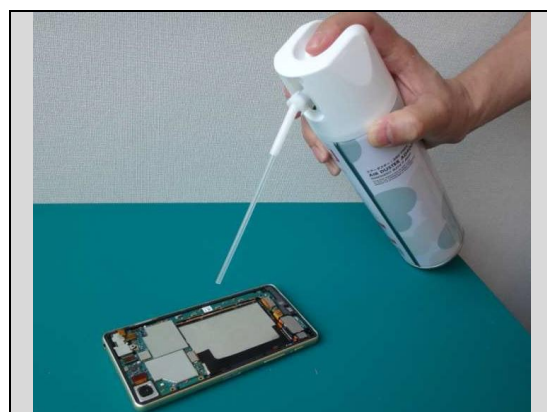
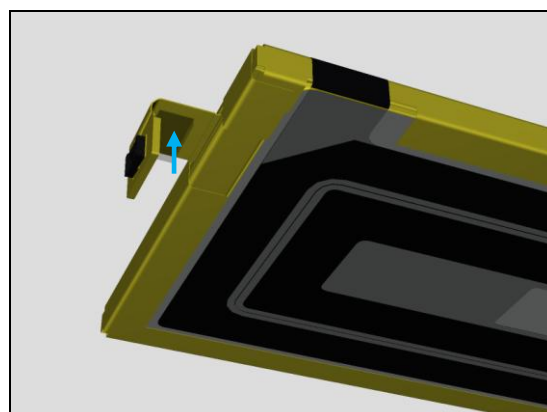
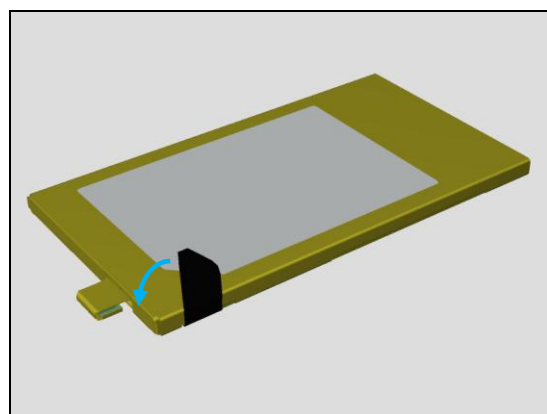
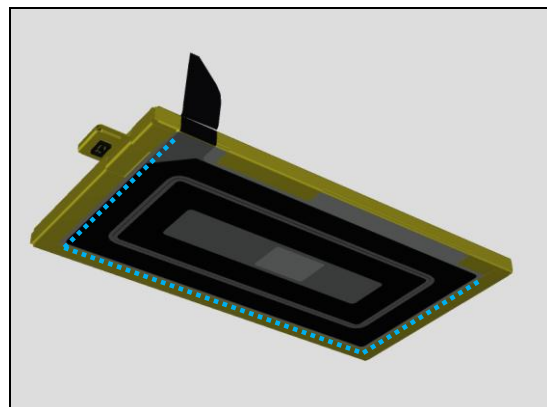
5.16 Adhesive Battery

Paste the Adhesive Battery to Battery along the guide line.

Paste the Tab of Battery Adhesive as shown.

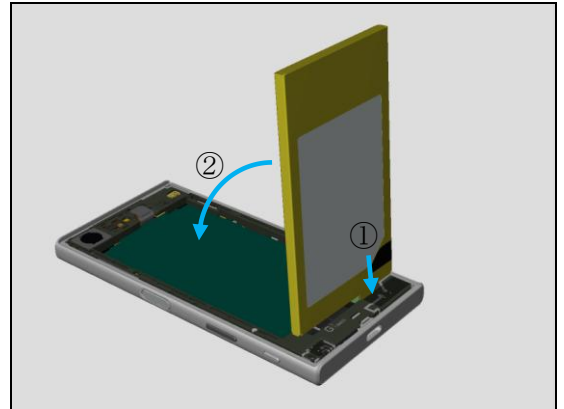
Paste the Spacer CN Battery FPC as shown.

Remove the foreign material by air blow.

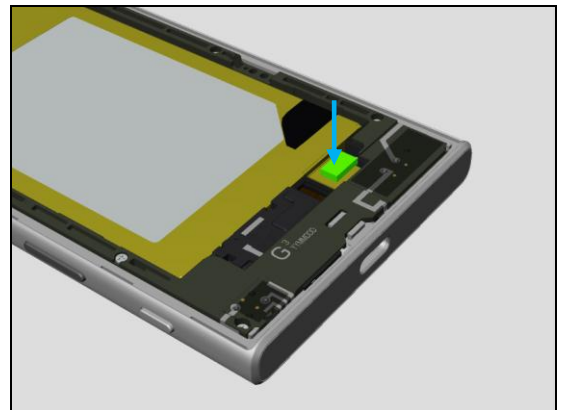


Reassembly

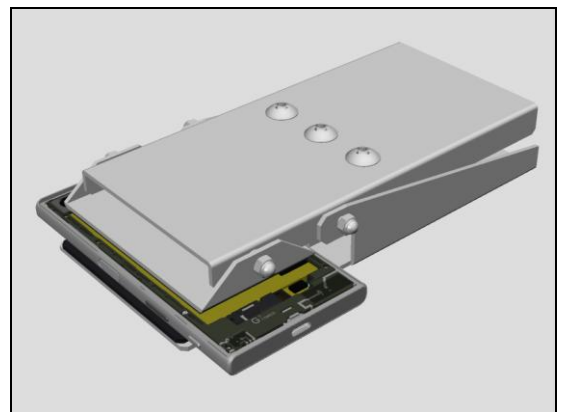
Connect the Battery Connector to PBA as shown.
And gently install the Battery.



Paste the Spacer CN Battery.

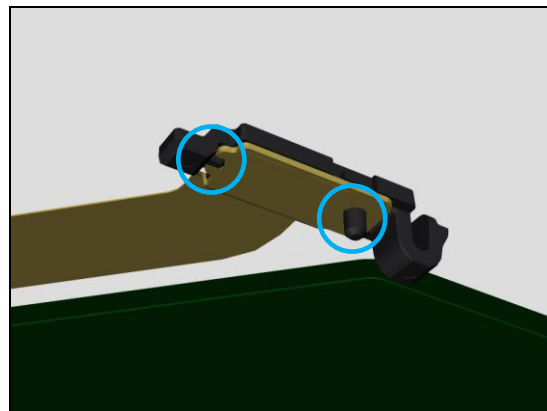


Press the only Battery area by Press Clamp for 5 seconds.

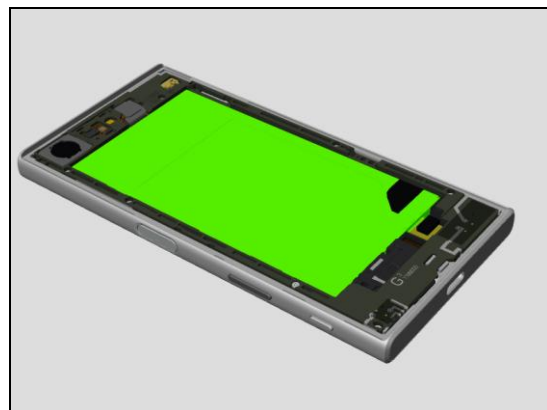


5.17 Ant NFC Flex

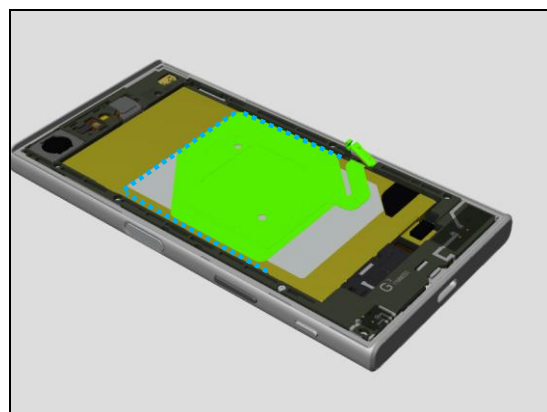
Paste the Holder NFC Antenna to Ant NFC Flex as shown.



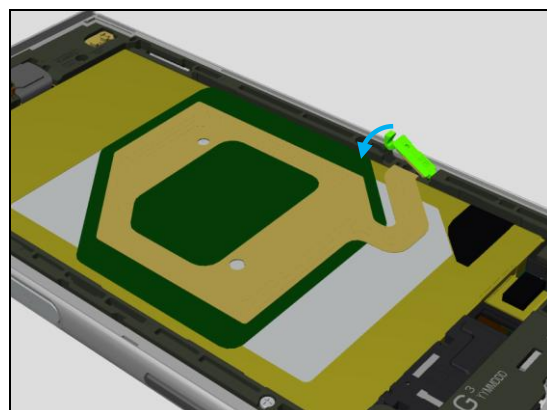
Remove the foreign material on green area by air blow.



Paste the Ant NFC Flex to Battery along label top line and battery edge.

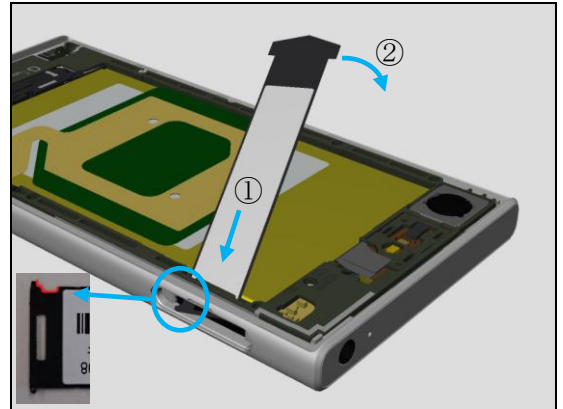


Lock the Holder NFC Antenna.



5.18 Sheet Slider MOP

Install the sheet Slider MOP as shown.

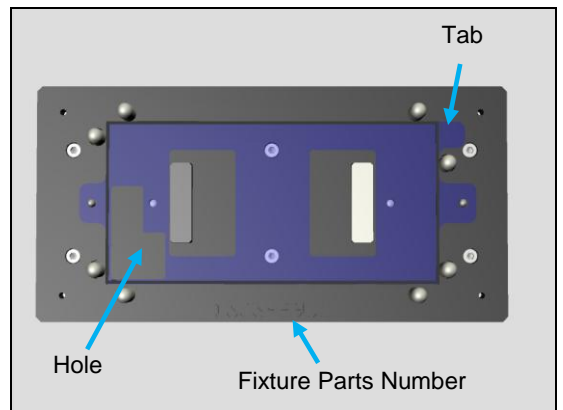


5.19 Cover Rear

Install the Adhesive WR Cover Rear to Rear Cover Adhesive Fixture as below.



Direction of Adhesive WR Cover Rear is as shown.

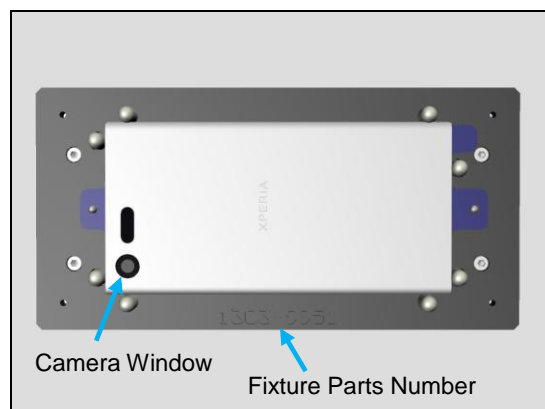


Temporarily install the Cover Rear as below.



Reassembly

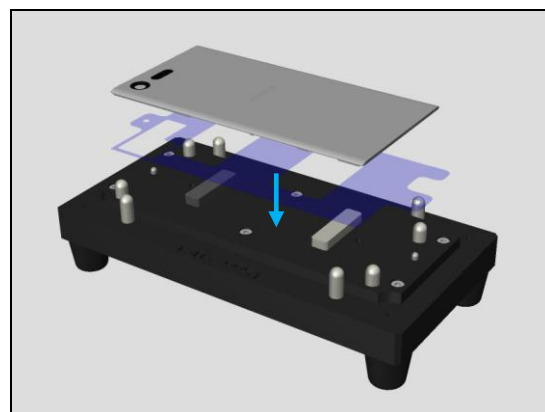
Direction of Cover Rear is as shown.



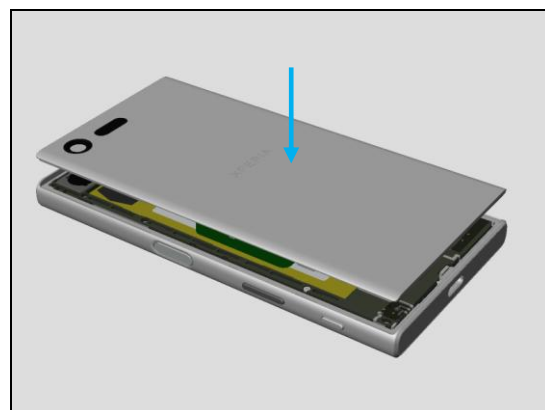
Press the Cover Rear to paste the Rear Cover Adhesive Fixture.



Remove the Liner.

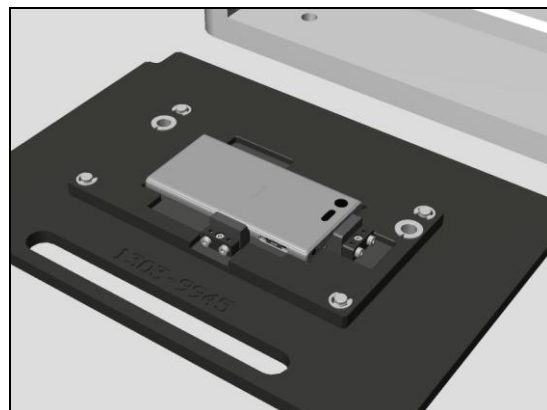


Gently install the Cover Rear to Front Assy.

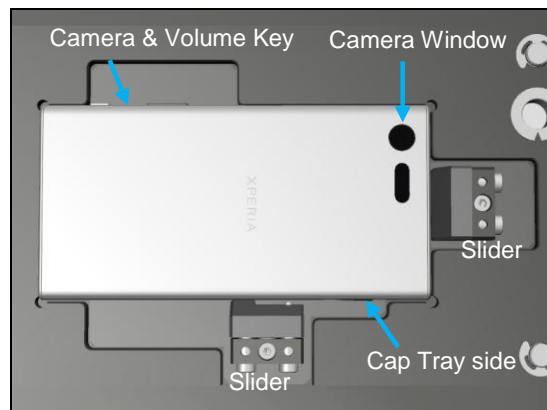


Reassembly

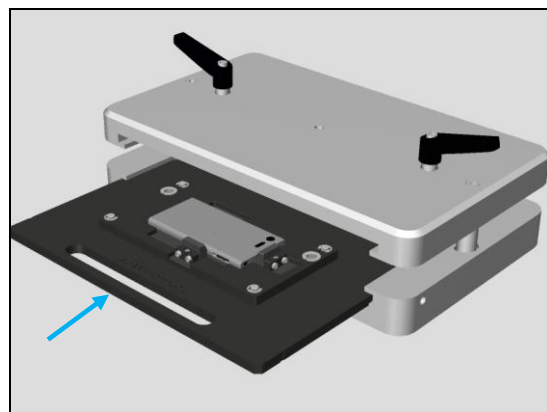
Place the unit on the Bottom Press Inlay as shown.



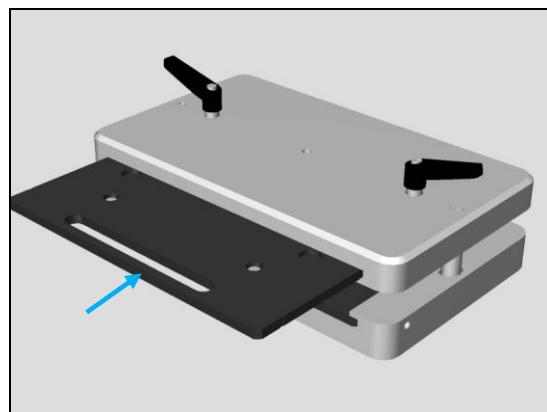
Unit direction is as shown.



Insert the Bottom Press Inlay to the Generic Fixture for Press Tool.



Insert the Rear Cover Press Top Inlay to the Generic Fixture for Press Tool.



Reassembly

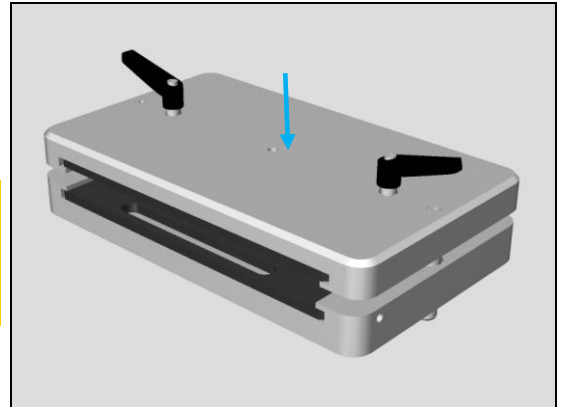
Press with pressure value as below.

1st Press: $600 \pm 50\text{N}$, 10sec

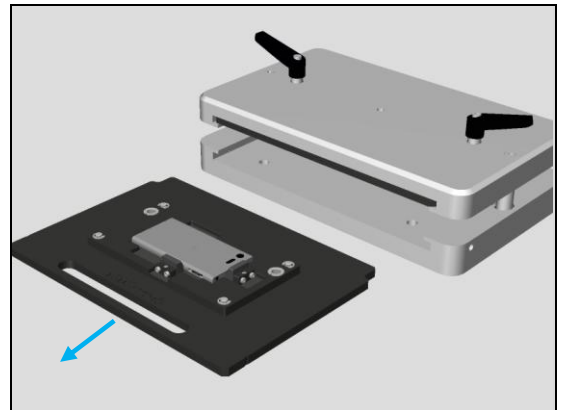
2nd Press: $600 \pm 50\text{N}$, 5sec

Note!

Follow the instruction in 1003-9107 Tool Catalogue mechanical and document Toothed Rack Press Instruction for use.

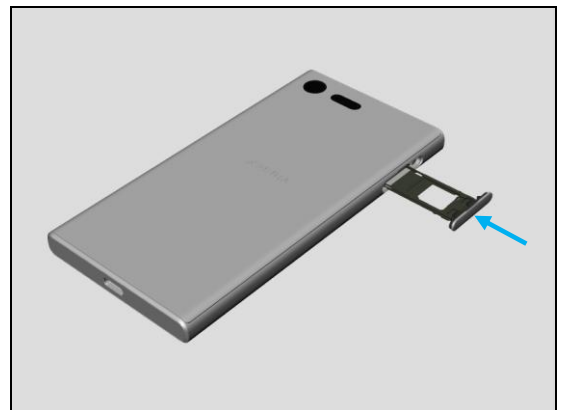


Remove the Rear Cover Press Top Inlay and take out the unit.

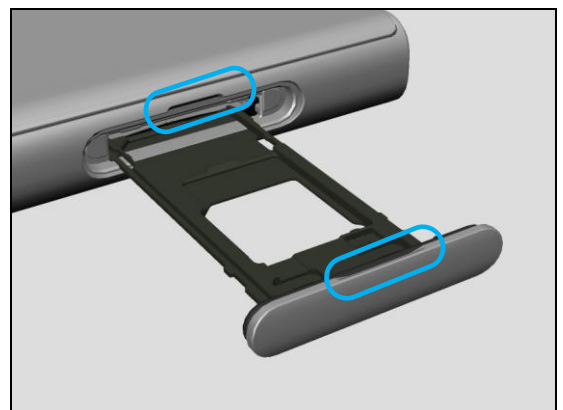


5.20 Cap Tray Assy

Install the Cap Tray Assy to unit as below.

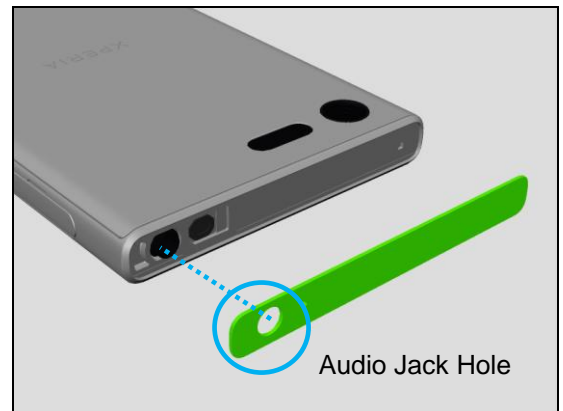


Align the cutout of Cap Tray Assy with Unit.

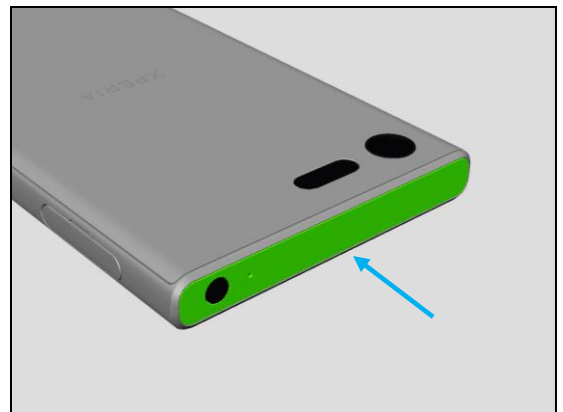


5.21 Panel Top

Confirm the direction by Audio Jack Hole.

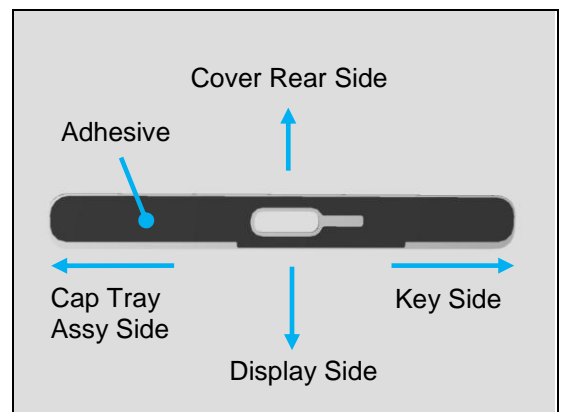


Gently paste the Panel Top to the Unit.

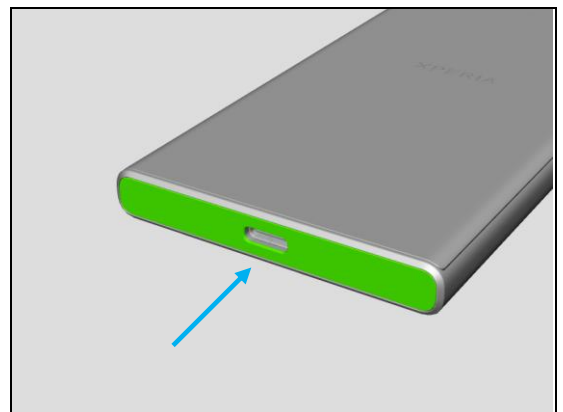


5.22 Panel Bottom

Confirm the direction by Adhesive shape.



Gently paste the Panel Bottom to the Unit.



6 Battery Reuse Instruction

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

6.1 Battery Handling Notices

Don't damage the battery foil with sharp objects.

Don't twist or deform the battery in any way.

If the battery is dropped to floor, should not be used, and scrap.

Reuse conditions

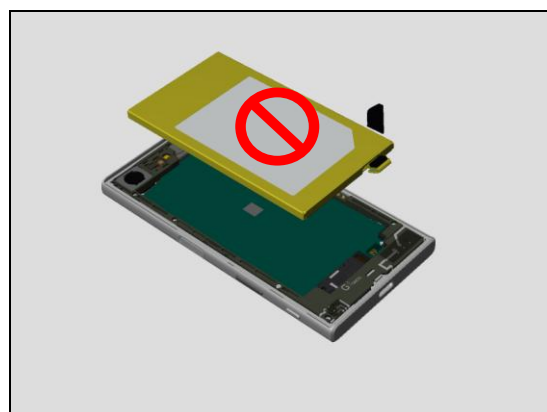
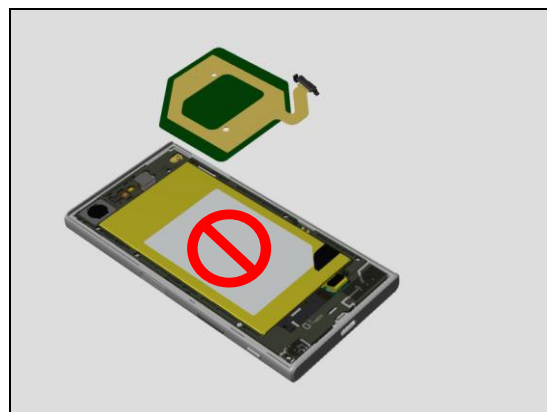
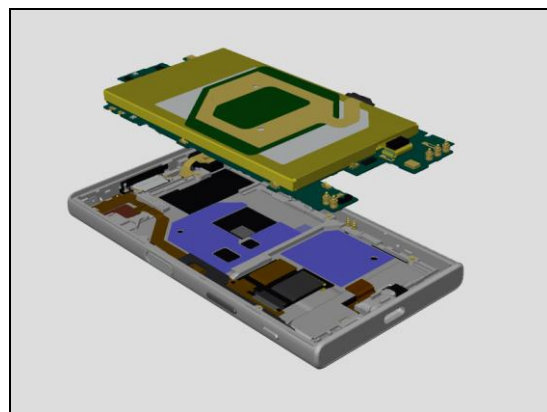
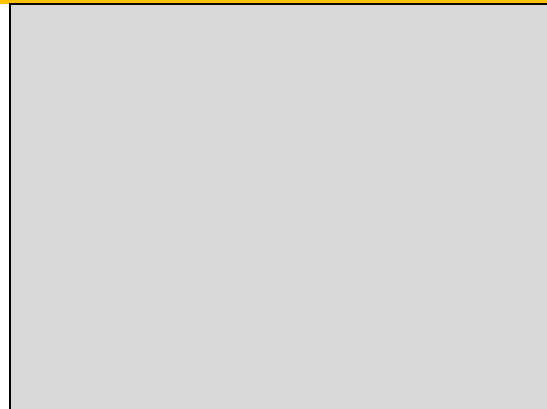
- In case of removing the Battery with PBA and Ant NFC Flex as shown.
- Battery appearance check is OK.

Scrap!

Don't reuse the Battery when Ant NFC Flex is removed from the Battery!

Scrap!

Don't reuse the Battery when Battery is removed from the PBA!



Battery Reuse Instruction

6.2 Appearance Check

Check if any damages on the battery such as Winkle, Mark, Bubble, Dent and / or Scratch.
If it is out of below specification, do not reuse, and scrap the battery.

Item of Damage	Limit of size		Limit of quantity
	Label/Tape surface	Cell surface	
Winkle	Length \leq 5mm	-	1 wrinkle per label or tape
Mark	Length \leq 3mm	-	1 mark per label or tape *
Bubble	Diameter \leq Φ 2mm	-	3 bubbles per label or tape *
Dent	Diameter \leq Φ 2mm		5 dents per surface
Scratch	Width \leq 0.5mm Length \leq 10mm 10mm < Length \leq 15mm 15mm < Length \leq 20mm		5 lines per surface 3 lines per surface 1 line per surface

* Bubble and Mark by air is not defect, and it is OK to use.

Definition of Damages and Sample Pictures

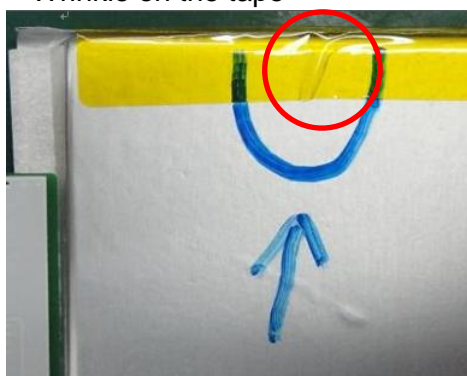
Wrinkle:

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

Wrinkle on the label



Wrinkle on the tape



Mark:

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

Mark on the label



Battery Reuse Instruction

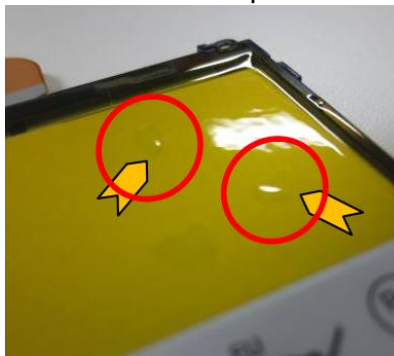
Bubble:

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

Bubble on the label



Bubble on the tape



Dent

It is caused that is stuck by sharp pointed objects.

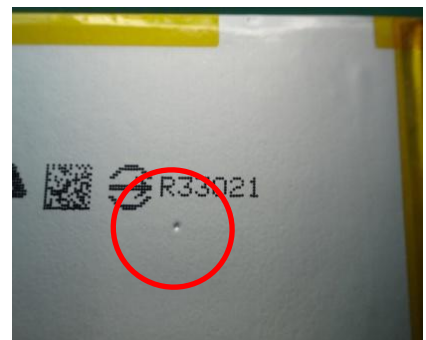
Dent on the label



Dent on the tape



Dent on the Cell surface



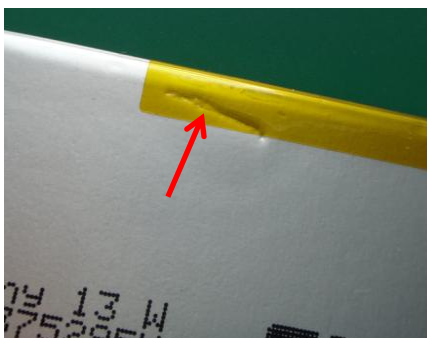
Scratch

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

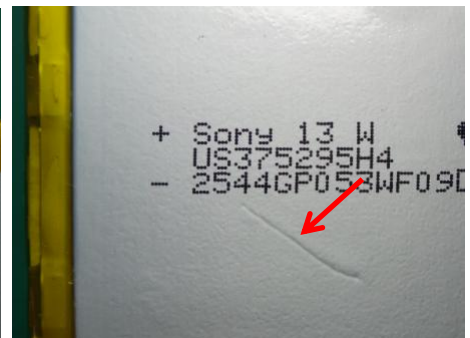
Scratch on the label



Scratch on the tape



Scratch on the Cell surface

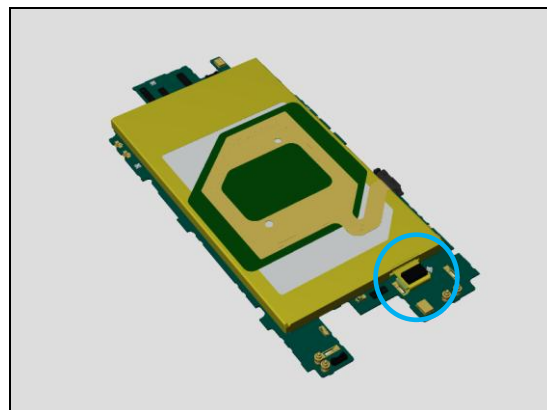


Battery Reuse Instruction

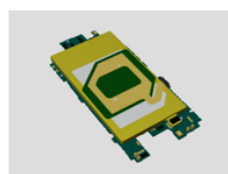
6.3 BtB Connector Check

Check if BtB connector has damages.

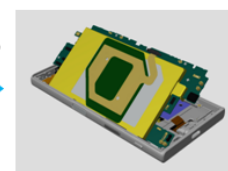
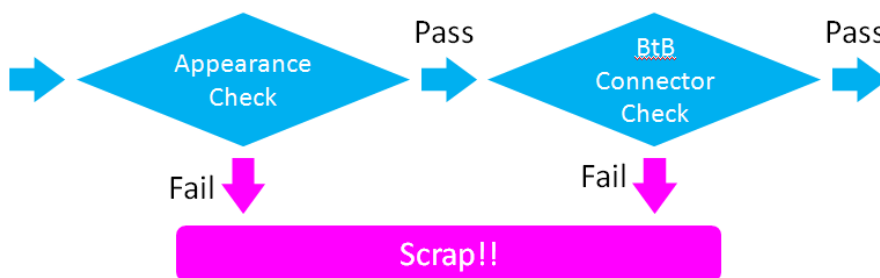
If any damages on the BtB connector, don't reuse, and scrap the Battery and Ant NFC Flex.



6.4 Overall Procedure for Battery Reusing



Removing the
Battery with PBA
& Ant NFC Flex.



Install the Battery
on the unit with
PBA & Ant NFC Flex.

7 Revision History

Rev.	Date	Changes / Comments
1	2016-Sep-01	Initial release
2	2016-Sep-16	Add Mandatory Replacement Parts List in 3.
3	2016-Sep-29	Add column of Label MOP Changing to the table in P4. Add new instruction of Change Label MOP in P40. Add new instruction of Customize of Software in P41.