



# Working Instruction, Mechanical

Applicable for W600i, W600c, W550i, and W550c

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# 1 General

## 1.1 Phone Portions - Base and Flip

This document uses the hinge of the phone to divide the phone into two identifiable portions. The portion of the phone that contains the keypad will be referred to throughout this document as the base portion of the phone. The other portion of the phone is the part that contains the display. This will be referred to as the flip portion of the phone. The basic disassembly and reassembly procedures will be structured based on these two distinct portions.



## 1.2 Using Hand and ESD Protection

When handling this product, keep all surfaces clean of dirt, dust, debris, and hand oil. Use appropriate ESD precautions when working on this product. The use of finger cots or gloves, an ESD mat, and an ESD wrist strap are required at minimum.

## 1.3 Protection of LCDs, Lenses, and Windows

Any time the screen portion of a display assembly, the windows of a display cover, or a camera lens is unprotected and will be exposed for an extended period of time, add a protective film over the exposed part to reduce the amount of dust, finger prints, debris, and/or damage that the part may obtain.

## 1.4 Acceptable Pry Tools

Whenever the phrase “pry tool” is used, a nylon pointer, an orangewood stick, or a front opening tool may be used, depending on the user’s preference.

## 1.5 When an “\*” appears beside a Tool in “Tools Needed:”

A “\*” beside a tool in a procedure’s list of tools indicates that the tool is not specifically called out in those instructions, but an operator may find it helpful to use that tool when performing some steps of that procedure.

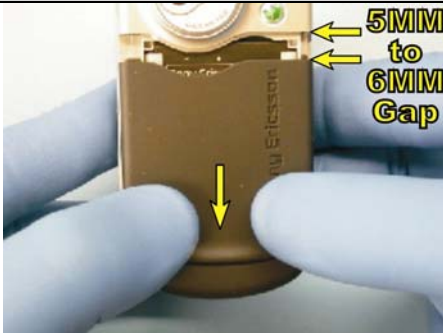

## 2 Base

### 2.1 Base Disassembly

The disassembly of the base portion of this product is broken down into sections by the components that need to be removed to perform the disassembly. The sections that make up the “Base Disassembly” procedure are arranged in the order that they must be performed to properly disassemble the base portion of this product. If your task is to replace one of the components that is removed during the base disassembly, just perform the sections of the base disassembly through to the point that the part you are trying to replace is removed.

#### 2.1.1 Battery Cover Removal

**Tools needed:** None




Step-by-Step Instructions	
<p>1. Using your thumbs, slide the battery cover towards the system connector until a 5 to 6 MM gap forms between the battery cover and the edge of the battery opening adjacent the camera.</p> <p><b>NOTE!</b> The battery cover will not slide more than 5 or 6 MM.</p>	
<p>2. Once battery cover has been slide 5 to 6 MM towards the system connector, lift the battery cover away from the phone.</p>	

## 2.1.2 Battery Removal

All of the sections of the Base Disassembly preceding this section must be performed in sequential order before the disassembly steps listed below can be performed.

### Tools needed:

- Pry Tool

Step-by-Step Instructions	
1. At the end of the battery closest to the system connector, catch the flat end of a pry tool on the accessible portion of the battery that is adjacent to the system connector.	
2. Using the pry tool, push the battery towards the camera while simultaneously lifting the end of the battery. The end being lifted should come free from the battery cavity.	
3. Once one end of the battery is free from the battery cavity, lift the battery away from the phone.  <b>NOTE!</b> Do not tap the phone against a hard surface in an attempt to get the battery out. Damage to the phone may result!	









### 2.1.3 Outer Base Cover Removal



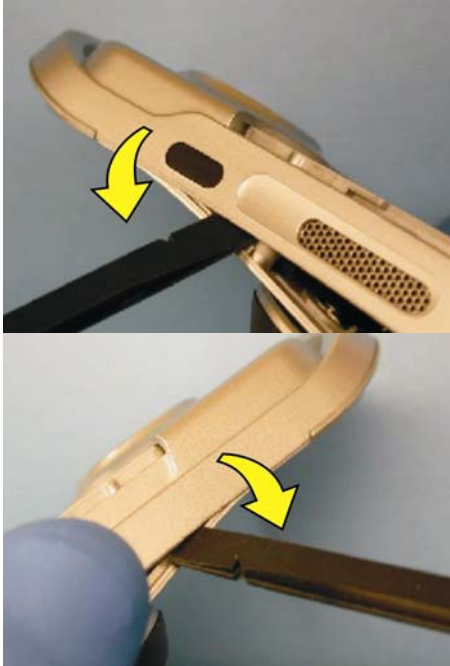

All of the sections of the Base Disassembly preceding this section must be performed in sequential order before the disassembly steps listed below can be performed.

**Tools needed:**

- Pry Tool
- Torque screwdriver
- Front opening tool
- Style 2A ESD tweezers (Blunt tip)
- Torx Plus size 5 bit

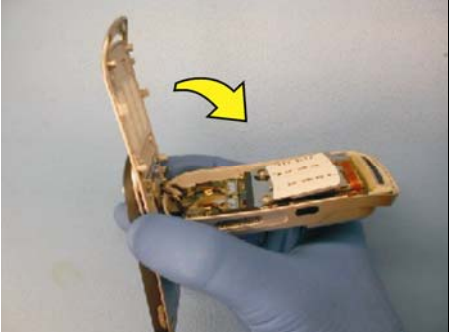
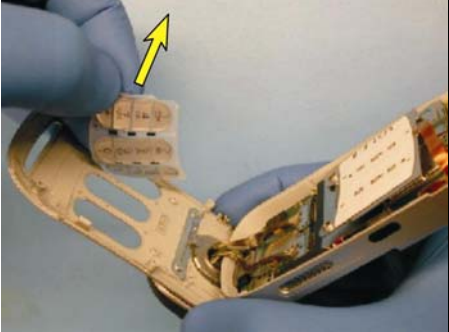

Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to scratch the inner base cover when removing the base's screw cover panel.</p> <p>1. Open the phone so that the main keypad is accessible and locate the screw cover panel on the inner base cover.</p>	
<p>2. Begin lifting the screw cover panel away from the inner base cover by using the tip of one side of a pair of style 2A tweezers or a front opening tool at one of the two locations indicated.</p>	
<p>3. Once a portion of the screw cover panel is slightly lifted, grip the lifted portion of the panel and peel it off of the base.</p> <p><b>NOTE!</b> The screw cover panel cannot be reused.</p>	
<p>4. Carefully clean off any remaining adhesive residue from the area on the inner base cover where the screw cover panel mounts using the style 2A tweezers, alcohol, and a lint free wipe.</p> <p>5. Remove the two screws that were concealed by the base's screw cover panel using a torque driver and a Torx Plus size 5 bit.</p>	

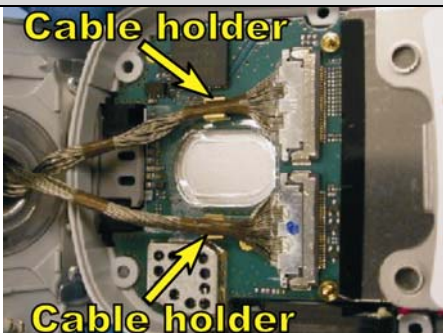
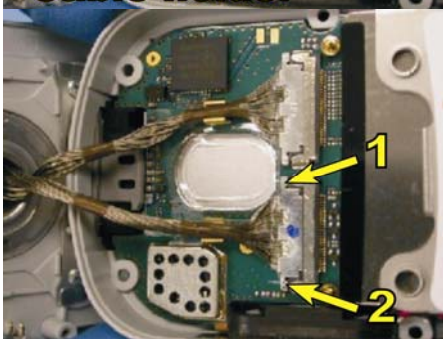
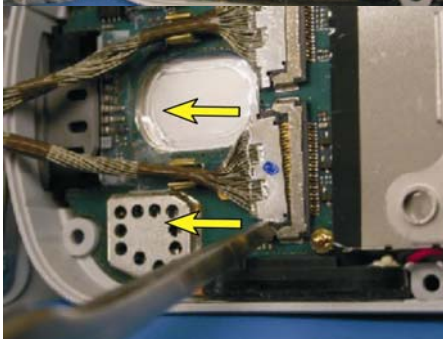
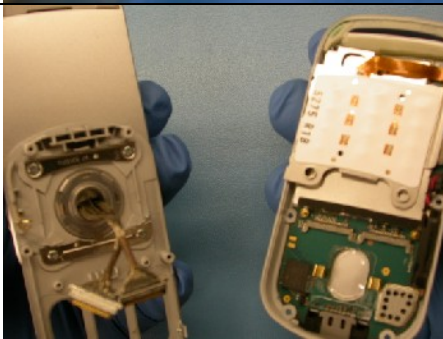


Step-by-Step Instructions	
6. Remove the four screws indicated from the battery cavity side of the base using a torque driver and a Torx Plus size 5 bit.	
7. Lift the system connector end of the base assembly away from the flip portion of the phone as high as it will easily move.	
8. With a pry tool, gently pry at the two locations indicated to release catches that hold the outer base cover assembly to the inner base cover. When prying, make sure to rotate the pry tool towards the keypad.	
9. With the latch along each side of the outer base cover assembly released, gently wiggle the outer base cover assembly side to side so that the antenna loop portion of the outer base cover releases from the inner base cover.	





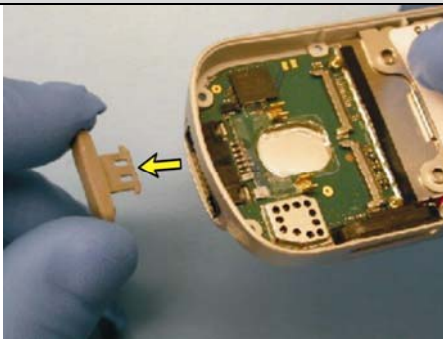
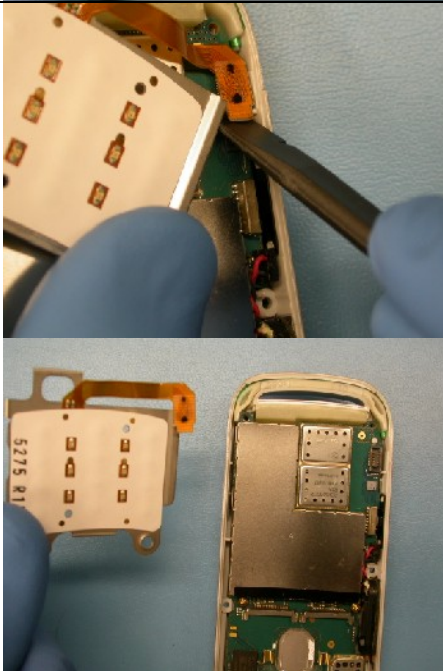
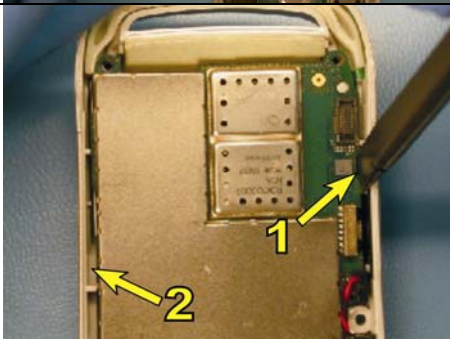
Step-by-Step Instructions	
<p>10. Once the two halves of the base are free from each other, rotate the outer base cover so that it is perpendicular to the rest of the phone.</p> <p><b>NOTE!</b> Use one hand to hold the phone in this current orientation.</p>	
<p>11. Remove the keypad from the inner base cover and set the keypad aside.</p>	
<p>12. Rotate the outer base cover assembly so that it is still perpendicular to the rest of the phone, but the battery cavity is adjacent to the keypad area on the inner base cover.</p> <p><b>NOTE!</b> Continue to use one hand to hold the phone in this current orientation.</p>	

Step-by-Step Instructions	
<p>13. Select one of the cable assemblies and lift it out of its holder on the circuit board.</p> <p><b>NOTE!</b> Do not attempt to unplug the cable assemblies by pulling on the mass of cables.</p> <p>14. At the board connection of the cable being disconnected, use the tip of a pair of style 2A tweezers to unplug the cable connection from the board. There are two locations that the connector must be alternately pulled at to disconnect the cable from the connector on the circuit board. The two pulling locations are labelled location 1 and location 2.</p> <p>15. Repeat the previous two steps to disconnect the other cable/board connection.</p>	  
<p>16. Once the cable assemblies are disconnected, the outer base cover assembly is free from the rest of the phone.</p>	

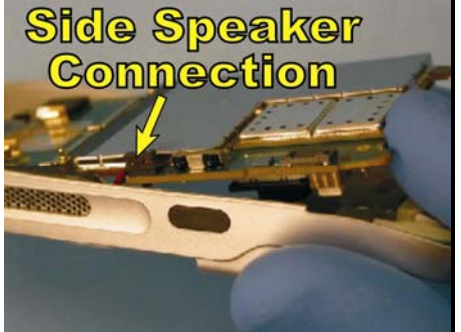
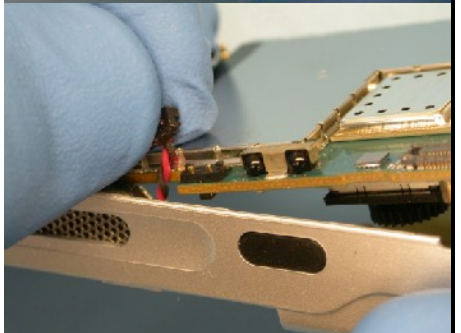

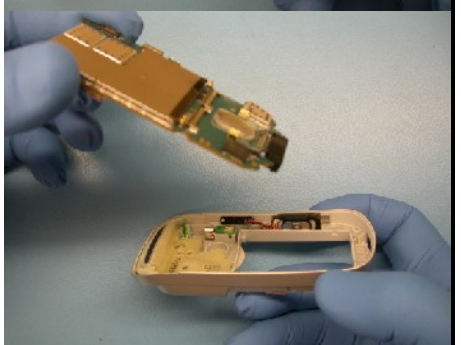
## 2.1.4 Circuit Board Removal

### Tools needed:

- Pry Tool

Step-by-Step Instructions	
1. Unplug the system connector cover from the system connector and set the system connector cover aside.	
2. Unplug the keypad switch assembly's flex film from its connection on the circuit board using a pry tool and set the keypad switch assembly aside.	
3. Using a pry tool, gently pry in the two locations indicated to release the catches that hold the circuit board in the outer base cover.	



Step-by-Step Instructions	
<p>4. Once the catches holding the circuit board have been released, lift the end of the circuit board that is adjacent to the antenna just far enough away from the outer base cover that the side speaker's connector is clear of the outer base cover's side wall.</p>	 <p><b>Side Speaker Connection</b></p> 
<p>5. While holding the circuit board in this lifted position, unplug the side speaker from the circuit board.</p>	
<p>6. Once the side speaker is disconnected, continue to rotate the circuit board away from the end of the outer base cover containing the antenna. Once the angle between the circuit board and the outer base cover has exceeded 45 degrees, the circuit board can be easily lifted from the outer base cover.</p>	 



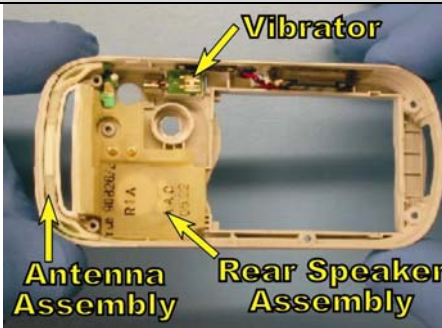
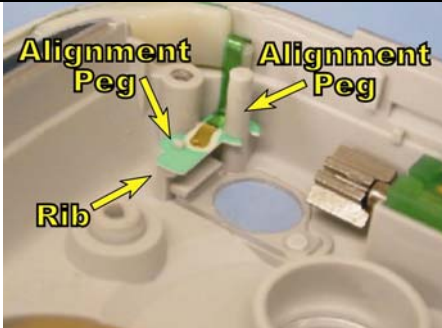

## 2.2 Base Reassembly

The reassembly of the base portion of this product is broken down into sections by the components that need to be installed to perform the reassembly of the base portion. The sections that make up the “Base Reassembly” procedure are arranged in the order that they must be performed to properly reassemble the base portion of this product. If only a partial disassembly of the base has been performed, perform the only necessary reassembly sections.

### 2.2.1 Circuit Board Installation

**Tools needed:**

- Pry Tool
- Style 2A ESD tweezers (Blunt tip)

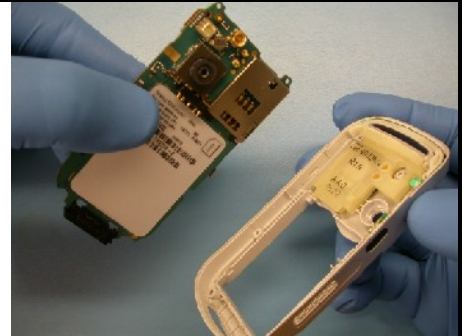
Step-by-Step Instructions	
<ol style="list-style-type: none"> <li>1. Obtain the outer base cover and orient it so that its inner surface is towards you.</li> <li>2. Verify that the antenna assembly, the rear speaker assembly, and the vibrator are in their correct positions.</li> </ol>	
<ol style="list-style-type: none"> <li>3. Verify that the antenna contact is correctly mounted on top of the rib that protrudes up from the inner surface of the outer base cover.</li> </ol> <p><b>NOTE!</b> There are two alignment pegs that position the contact portion of the antenna. Make sure that the two alignment pegs protrude through their corresponding holes in the contact portion of the antenna.</p>	
<ol style="list-style-type: none"> <li>4. Remove the side speaker from its cavity that is along the inner wall of the outer base cover by prying the end of the speaker nearest the system connector opening up out of the outer base cover. Then lift the speaker from its cavity using your fingers.</li> </ol>	





### Step-by-Step Instructions

5. Orient the circuit board relative to the outer base cover so that the camera is towards the inner surface of the outer base cover and the end of the circuit board with the system connector corresponds to the outer base cover's system connector opening.



6. Rotate the circuit board so that it is at a 45 degree angle to the outer base cover



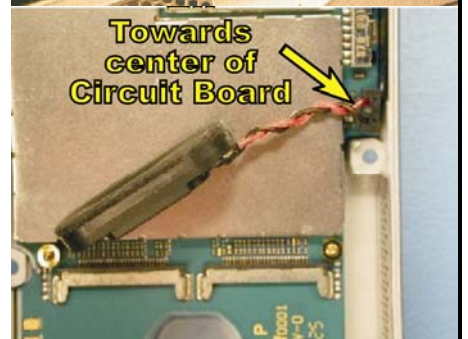
7. Insert the end of circuit board, in which the system connector is attached, into the outer base cover so that the system connector inserts into its opening in the outer base cover.



8. Hold the circuit board and the outer base cover in this configuration using one hand and reconnect the side speaker to the circuit board using the other hand.

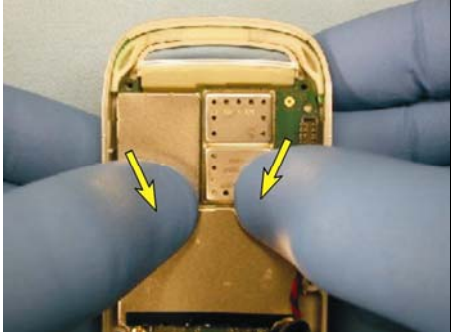
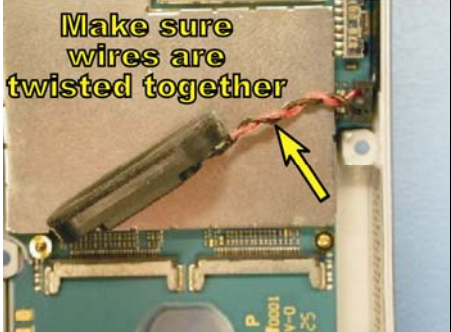

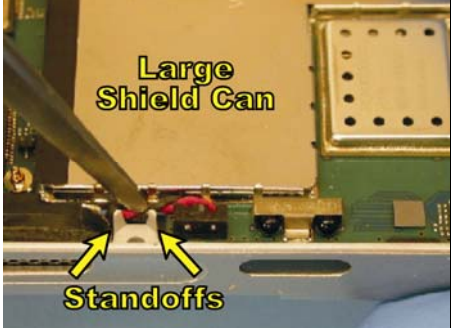


**NOTE!** When the side speaker's board connector is correctly connected, the wires coming off of the side speaker's connector extend towards the center of the circuit board.



9. Rotate the circuit board down into the outer base cover.



Step-by-Step Instructions	
10. To lock the circuit board in the outer base cover, press the circuit board down into the outer base cover in the two locations indicated.	
<b>NOTE!</b> Make sure the two wires of the side speaker are twisted together before inserting the speaker in its cavity, but be careful not to over twist the wires.	
11. With the side of the speaker containing the dust cloth oriented towards the speaker port, insert the side speaker into its cavity in the outer base cover.	
12. Work the wires of the side speaker down into the gap between the large shield can and the standoffs protruding up from the outer base cover.	



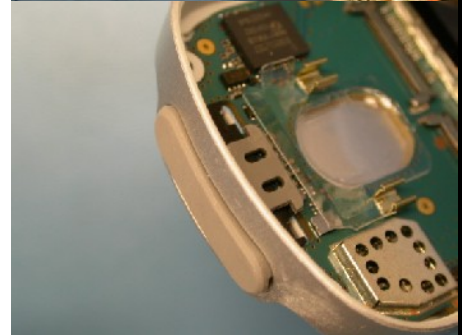
### Step-by-Step Instructions

13. Insert the large tab portion of the system connector cover into the opening between the system connector and the outer base cover.



14. Plug the system connector cover into the system connector.

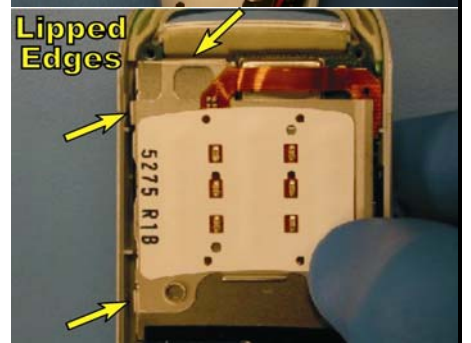
**NOTE!** If the system connector cover has been installed correctly, the large tab portion of the system connector cover can be seen lying on top of the system connector.



15. With the keypad switch assembly held directly over the circuit board and the dome foil side of the assembly away from the circuit board, plug the keypad switch assembly's flex film into its connection on the circuit board.



16. Then position the keypad switch assembly over the exposed shield cans so that the lipped edges of the keypad switch assembly's metal plate catch on the corresponding edges of the large shield can.



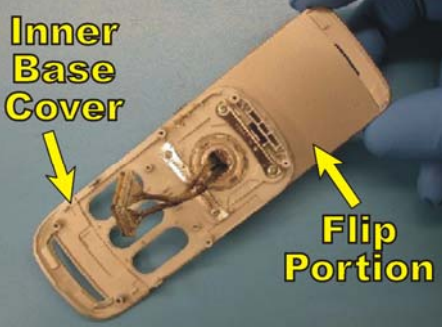
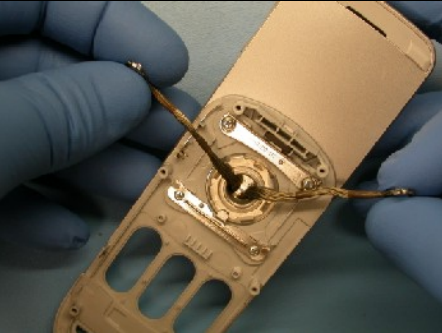

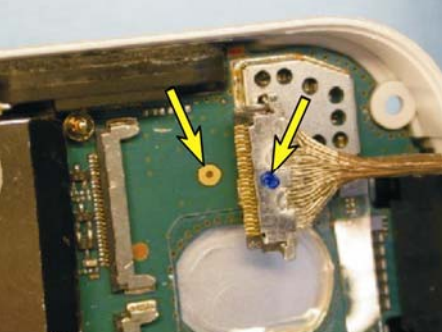


## 2.2.2 Outer Base Cover Installation

If this part is being replaced, refer to the “Outer Base Cover” subsection under the “Parts Replacement” portion of this document for detailed instructions on how to replace this part.

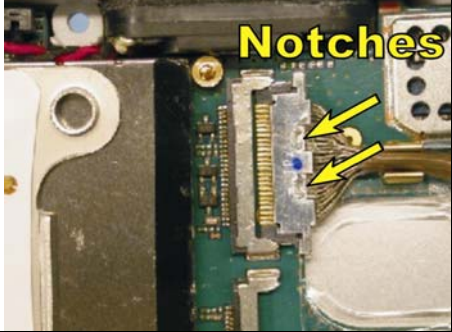
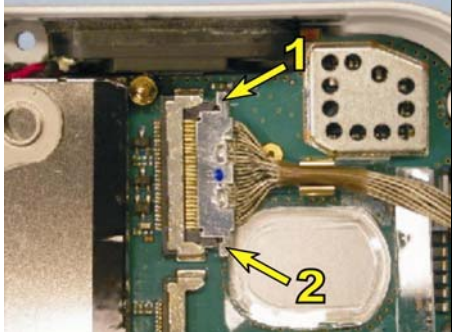
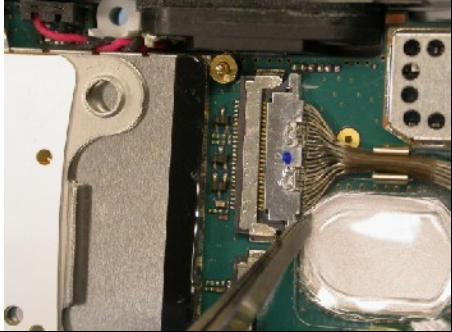
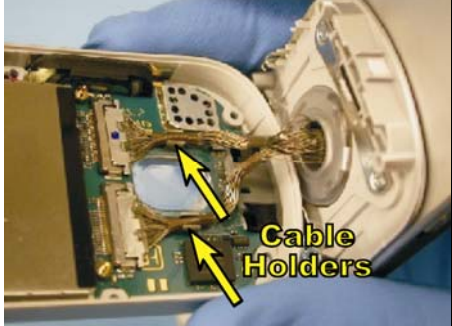
**Tools needed:**

- Torque screwdriver
- Torx Plus size 5 bit
- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
1. Rotate the inner base cover relative to the flip portion of the phone so that the phone is in the open position as shown.	
<b>NOTE!</b> Verify that the two cables are not twisted together.	
2. Orient the outer base cover so that it is perpendicular to the flip assembly with the system connector end of the outer base cover towards the inner base cover and the battery cavity adjacent to the inner base cover's keypad area.	
<b>NOTE!</b> The cable assembly with the color mark matches to the board connection that has the large gold dot below it.	





Step-by-Step Instructions	
<p>3. Select the cable you are going to connect and orient the connector end of the cable so that the side of the connector with the two notches is oriented away from the board.</p>	
<p><b>NOTE!</b> Be careful not to damage the cable assemblies when reconnecting them to the circuit board.</p> <p><b>NOTE!</b> Do NOT attempt to plug the cable assemblies in by using the cable assembly itself to push the cable connection into the board connection. Damage to the cable assembly most likely will result.</p>	
<p>4. Place the end of the cable assembly into the opening of its board connection.</p>	
<p>5. Using the tip of a pair of style 2A tweezers, work the end of the cable into its board connector. There are two locations that the connection on the end of the cable must be alternately pushed at to get the cable connection completely seated into its board connector. The pushing locations are labelled location 1 and location 2.</p>	
<p>6. Repeat the previous three steps to connect the other cable/board connection.</p>	
<p>7. Once the cables are connected to the circuit board, insert each of the cables into their corresponding cable holders on the circuit board.</p>	



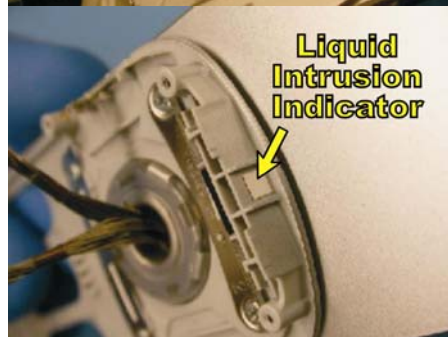
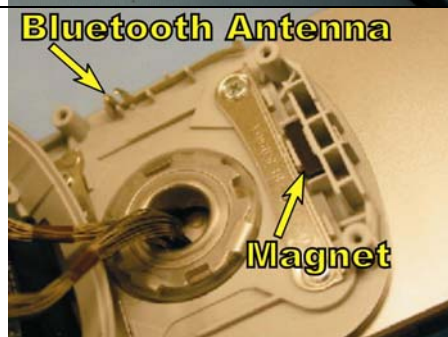
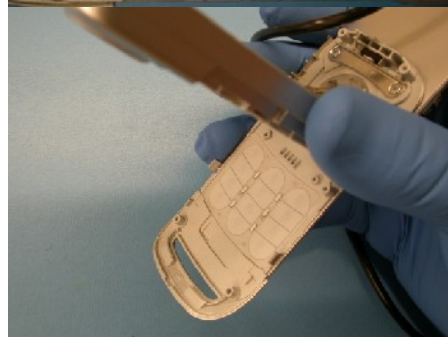
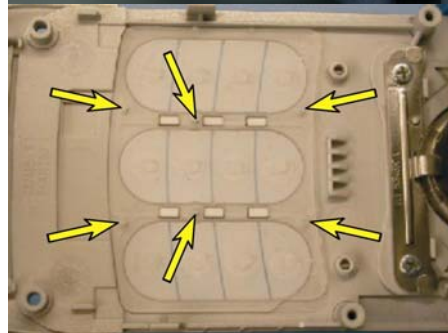
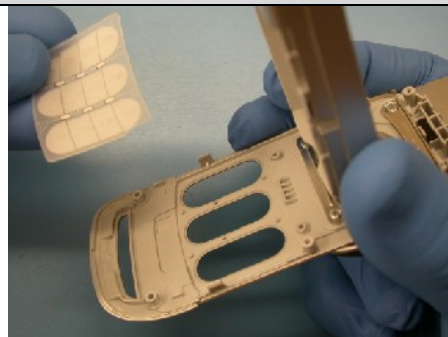


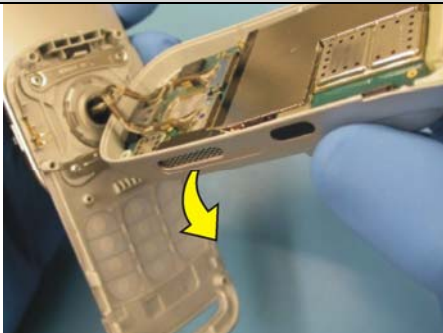

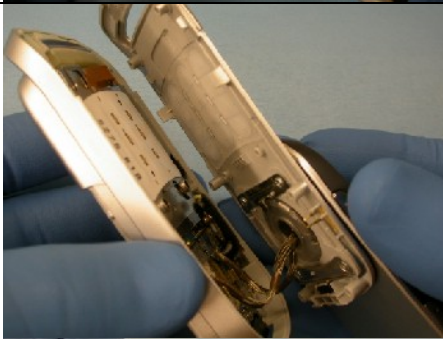

### Step-by-Step Instructions

8. Obtain a keypad and orient it so that the keys are towards the inner base cover and the curved edges of the keypad correspond to the curved edges of the recess in the inner base cover.

9. Insert the keypad into its recessed area in the inner base cover and press the keypad into place so that it is seated down onto the 6 positioning pegs that extend up from the inner base cover.

10. Verify that the magnet, the Bluetooth antenna, and the liquid intrusion indicator are in place on the inner base cover before installing the outer base cover assembly.



Step-by-Step Instructions	
<p>11. Rotate the outer base cover assembly so that its side speaker moves towards the keypad.</p>	 
<p>12. Continue to rotate the outer base cover assembly until the inner surfaces of the two base covers are towards each other.</p>	
<p><b>NOTE!</b> Make sure the cables are still mounted in their cable holders and the keypad switch assembly is still correctly positioned before performing the next step.</p>	 
<p>13. Hold the two halves of the phone so that the side of the base with the IR window is downward and the upper edges of the two halves are slightly rotated away from each other so that the keypad switch assembly and the keypad do not fall out of place during the assembly of the two halves of the base.</p>	
<p>14. Mate the two halves of the base and gently snap the two halves together.</p>	
<p>15. Check that there is no gap along the seam where the two portions of the base assemble.</p>	



### Step-by-Step Instructions

16. Using a torque screwdriver set to 15 N·cm and a Torx Plus size 5 bit, install a 1.6 X 5mm screw into each of the four screw locations in the outer base cover.

**NOTE!** When installing these screws, if the torque bit starts repeatedly slipping in a screw before the screw is completely seated, that screw must be replaced with a new screw and the bit tip must be cleaned of any metal shavings before proceeding.



17. Using a torque screwdriver set to 15 N·cm and a Torx Plus size 5 bit, install a 1.6 X 8mm screw into each of the two screw locations in the inner base cover.

**NOTE!** When installing these screws, if the torque bit starts repeatedly slipping in a screw before the screw is completely seated, that screw must be replaced with a new screw and the bit tip must be cleaned of any metal shavings before proceeding.



**NOTE!** Make sure there is no adhesive residue in the area where the screw cover panel mounts onto the inner base cover. Carefully clean off any residue in this area using alcohol and a lint free wipe.

18. Obtain a new screw cover panel assembly and orient the assembly so that the side of the screw panel with adhesive is towards the inner base cover.

19. Insert the screw cover panel assembly in the screw cover's cavity and apply pressure to it for 3 seconds so that a good bond forms between the parts.


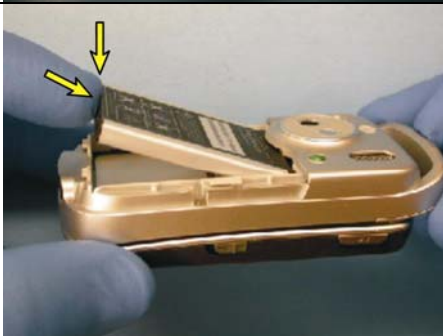


All of the sections of the Base Reassembly following this section must be performed in sequential order to reassemble the base portion of the phone.

### 2.2.3 Battery Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:** None

Step-by-Step Instructions	
1. With the label side of the battery oriented away from the phone, insert the end of the battery with connection pads into the end of the battery cavity nearest the camera.	
2. While pushing the battery towards the camera, simultaneously press the other end of the battery down into the battery cavity.	

All of the sections of the Base Reassembly following this section must be performed in sequential order to reassemble the base portion of the phone.








## 2.2.4 Battery Cover Installation

**Tools needed:** None

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

Step-by-Step Instructions	
<p><b>NOTE!</b> The positioning mark, referred to in the next step, consists of a line with an arrow pointing towards it that is molded in the edge of the outer base cover's battery cavity.</p>	
<p>1. Place the battery cover over the battery cavity so that the extension off of the battery cover that is directly below the camera flash is lined up with the positioning mark on that edge of the battery cavity and the side edges of the battery cover are flush against the adjacent edges of the outer base cover.</p>	
<p>2. Slide the battery cover towards the camera until the battery cover snaps into place.</p>	





## 3 Flip

### 3.1 Flip Disassembly


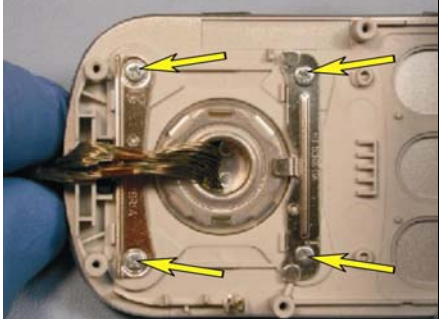

The disassembly of the flip portion of this product is broken down into sections by the components that need to be removed to perform the disassembly. The sections that make up the “Flip Disassembly” procedure are arranged in the order that they must be performed to properly disassemble the flip portion. If your task is to replace one of the components that are removed during the flip disassembly, just perform the sections of the flip disassembly through to the point that the part you are trying to replace is removed.

#### 3.1.1 Inner Base Cover Removal

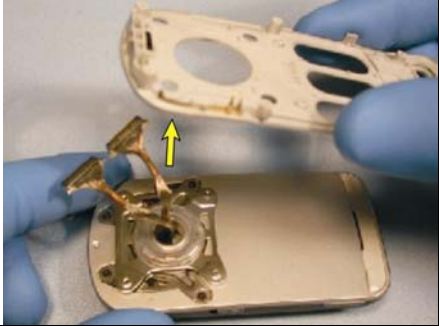
- Perform the sections 2.1.1 – 2.1.3 of the Base Disassembly before proceeding.

**Tools needed:**

- Torque screwdriver
- JCIS No. 0 bit
- \* Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful when handling the inner base cover. The spring finger portion of the Bluetooth antenna can easily become damaged.</p> <p>1. Rotate the inner base cover so that the phone is in the closed position as shown.</p>	
<p>2. Remove the four screws that mount the inner base cover to the hinge assembly using a torque screwdriver and a JCIS No. 0 bit.</p> <p><b>NOTE!</b> Do not reuse these screws.</p>	
<p>3. Lift the hinge braces from the inner base cover and set them aside.</p>	

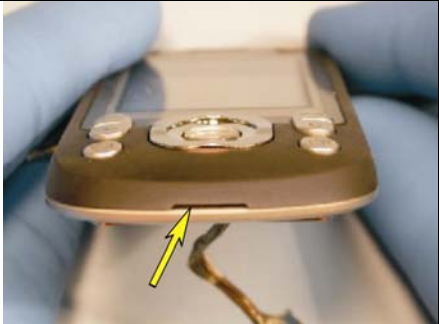







Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to damage the two cable assemblies when removing the inner base cover.</p> <p>4. Lift the inner base cover from the rest of the phone. When removing the inner base cover, work both of the cable assemblies through the hole in the inner base cover to make sure they do not get damaged.</p>	

### 3.1.2 Style-Up Cover Removal

Tools needed:

- Pry Tool

Step-by-Step Instructions	
<p>1. Locate the notch in the seam where the style-up cover and the inner flip cover come together. The notch is at the end of the flip that is adjacent to the navigation keypad.</p>	
<p><b>NOTE!</b> Be careful not to scratch the external plastics that cover the flip when using a pry tool to separate the two covers.</p> <p>2. Slide the flat end of the pry tool in the notch in the seam between the two external flip covers and gently twist the pry tool to start the separation of the two covers.</p>	 

Step-by-Step Instructions	
<p>3. Continue the separation of the two covers by sliding and twisting the pry tool along the seam in both directions until you reach a key in each direction.</p>	
<p>4. Keep the freed portion of the seam between the style-up cover and the rest of the flip separated.</p> <p>5. On one side of the phone, insert the flat end of the pry tool in the seam behind the key where the seam has not been separated and twist the pry tool until the latch on that side of the style-up cover disengages.</p>	
<p>6. Repeat the previous step on the other side of the flip assembly.</p>	



### Step-by-Step Instructions

7. Once the side latches that were holding the style-up cover in place have been released, rotate the style-up cover up off of the flip assembly until the edge of the style-up cover will clear the music player and volume buttons.
8. Then push the lifted end of the style-up towards the end of the flip assembly where the power button is located until the style-up cover separates from the flip assembly.
9. Once free, set the style-up cover aside.



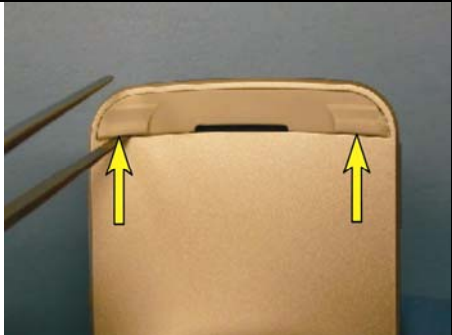


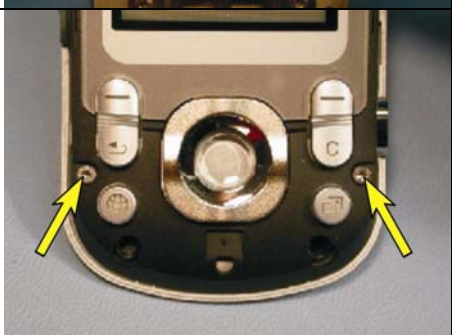


### 3.1.3 Display Cover Removal

The sections of the Flip Disassembly preceding this section must be performed in sequential order before the disassembly steps listed below can be performed.

**Tools needed:**

- Torque screwdriver
- Torx Plus size 5 bit
- Style 2A ESD tweezers (Blunt tip)
- Front opening tool

Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to scratch the inner flip cover when removing the flip's screw cover panel.</p> <ol style="list-style-type: none"><li>1. Begin lifting the screw cover panel away from the inner flip cover by using the tip of one side of a pair of style 2A tweezers or a front opening tool at one of the two locations indicated.</li></ol>	
<ol style="list-style-type: none"><li>2. Once a portion of the screw cover panel is slightly lifted, grip the lifted portion of the panel and peel it off of the flip.</li></ol> <p><b>NOTE!</b> The screw cover panel cannot be reused.</p>	
<ol style="list-style-type: none"><li>3. Carefully clean off any remaining adhesive residue from the area where the screw cover panel mounts using the style 2A tweezers, alcohol, and a lint free wipe.</li><li>4. Using a torque driver with a Torx Plus size 5 bit, remove the two screws that were concealed by the flip's screw cover panel.</li></ol>	
<ol style="list-style-type: none"><li>5. Using a torque driver with a Torx Plus size 5 bit, remove the two screws indicated from the display cover side of the flip assembly.</li></ol>	





6. Lift the display cover from the phone, and set it aside.

**NOTE!** Occasionally, the navigation keypad comes off with the display cover when it is removed. If that is the case just set the navigation keypad aside.



### 3.1.4 Display Carrier Assembly's Disassembly from Inner Flip Cover

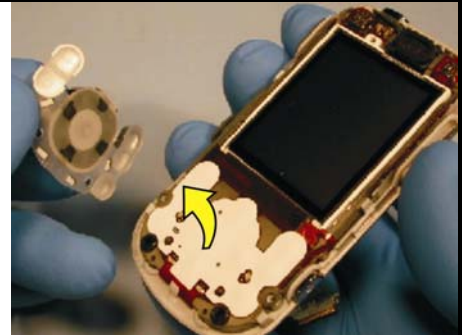
The sections of the Flip Disassembly preceding this section must be performed in sequential order before the disassembly steps listed below can be performed.

**Tools needed:**

- Torque screwdriver
- JCIS No. 0 bit
- Style 2A ESD tweezers (Blunt tip)

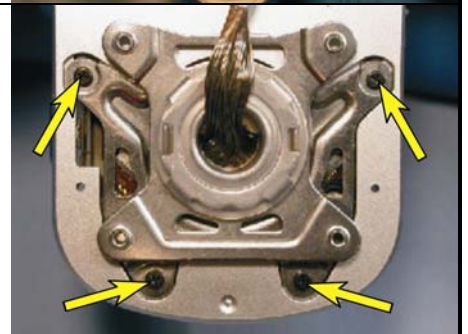
#### Step-by-Step Instructions

1. If the navigation keypad is lying on the display carrier, remove the navigation keypad and set it aside.



2. Remove the four screws that attach the hinge to the flip assembly using a torque screwdriver and a JCIS No. 0 bit.

**NOTE!** Do not reuse these screws.



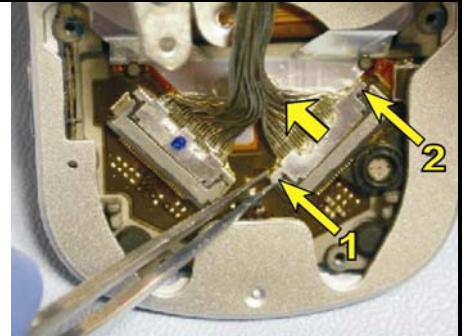
3. Lift the hinge assembly from the flip and hold it out of the way.





### Step-by-Step Instructions

- NOTE!** Do not attempt to unplug the cable assemblies by pulling on the cable assembly's mass of cables.
- NOTE!** There are two locations that the cable connector must be alternately pulled at to free the cable from its mating connector. The pulling locations are labelled location 1 and location 2.
4. Using the tip of a pair of style 2A tweezers, unplug one of the cable connections from the display flex film by pulling the cable connector alternately at the two locations indicated in the direction shown.
  5. Repeat the previous step to disconnect the other cable connection from the display flex film.
  6. Once the two cables have been unplugged, set the hinge/cable assembly aside.



7. With one hand, hold the inner flip cover by its side edges and press with one finger in the middle of the hinge opening in the inner flip cover.

**NOTE!** Only a small amount of pressure should be applied to the display carrier assembly. The pressure is only being applied to keep the latches on the inner base cover from re-latching to the display carrier once they have been unhooked.



### Step-by-Step Instructions

**NOTE!** Be aware that the camera key may fall out when performing the next step.

8. With the LCD carrier is being pressed away from the inner flip cover, release the four side latches that are holding the display carrier and the inner flip cover together by flexing the portion of the inner flip cover that is adjacent to each of the four latches away from the display carrier. Start with the two latches that are on each side of the navigation keypad.

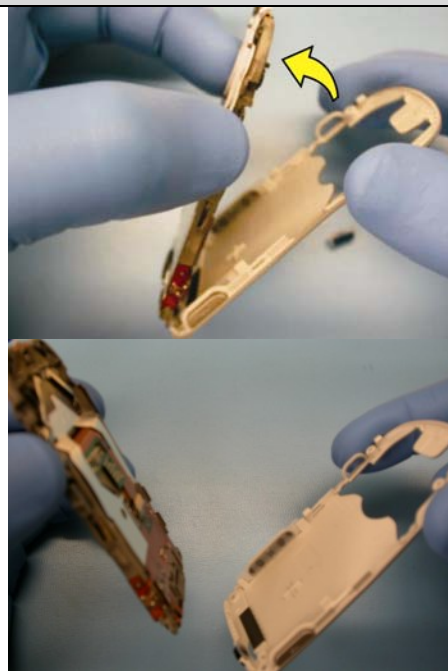




### Step-by-Step Instructions

**NOTE!** Be aware that the power key may fall out when performing the next step.

9. Once the four latches are unlatched, rotate the dome foil end of the display carrier assembly away from the inner flip cover until the two parts have separated.





## 3.2 Flip Reassembly

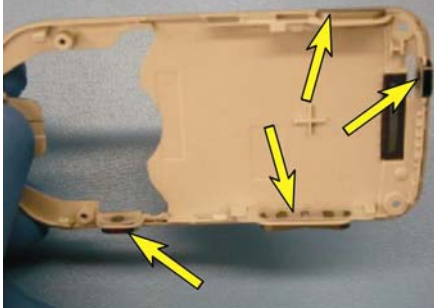
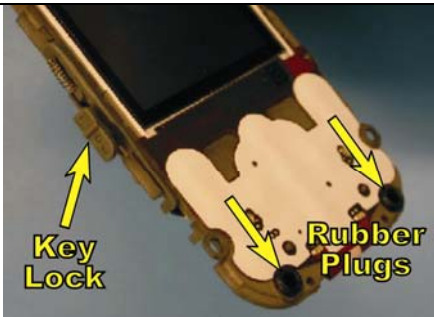
The reassembly of the flip portion of this product is broken into sections by the components that need to be installed to perform the reassembly of the flip portion. The sections that make up the “Flip Reassembly” procedure are arranged in the order that they must be performed to properly reassemble the flip portion. If you have only performed a partial disassembly of the flip, perform only the reassembly sections necessary.


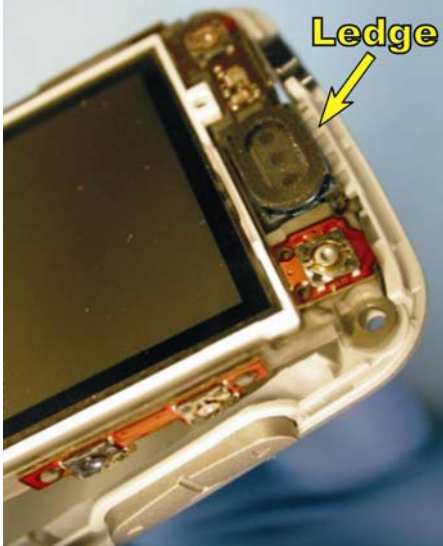
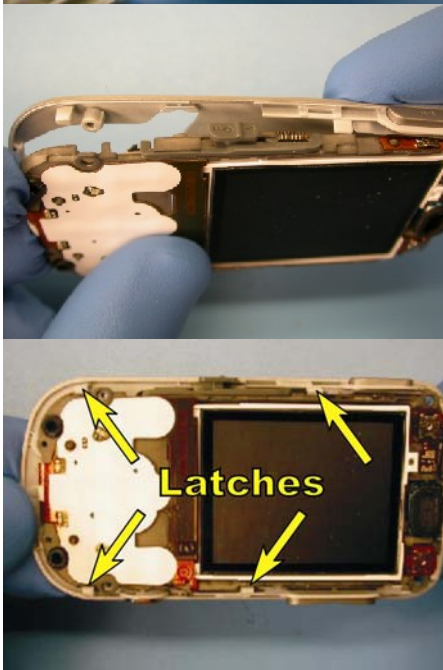
### 3.2.1 Display Carrier Assembly’s Reassembly to Inner Flip Cover

If the inner flip cover is being replaced, a new part should be used in the place of the old part when performing the following procedure. Note that the power key, the camera key, the volume key, and the music player key must be transferred from the old inner flip cover to the new one before proceeding. For more details regarding the steps that must be performed on a new inner flip cover before you can perform the following procedure, refer to the “Inner Flip Cover” section under the “Part Replacement” portion of this document.

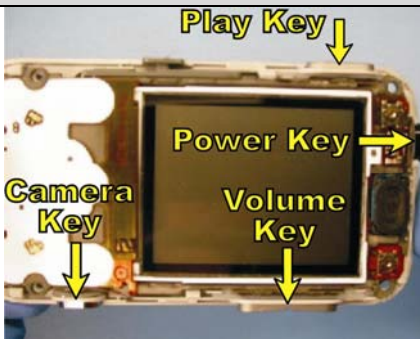
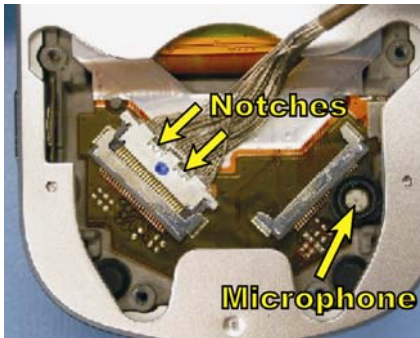
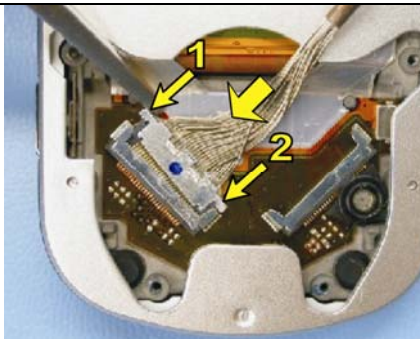
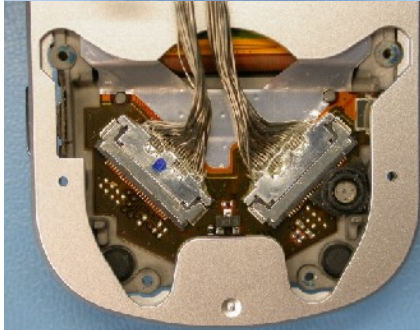
**Tools needed:**

- Torque screwdriver
- JCIS No. 0 bit
- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<ol style="list-style-type: none"> <li>1. Obtain the inner flip cover and verify that the power key, the camera key, the volume key, and the music player key are in their correct positions.</li> <li>2. Orient the inner flip cover so that the inner surface is upward and the side with the camera key is towards you.</li> <li>3. Rotate the inner flip cover so that the inner surface is slightly towards you to help keep the camera key in place.</li> </ol>	
<ol style="list-style-type: none"> <li>4. Obtain the display carrier and verify that the keypad lock key and the rubber plugs are in their correct positions</li> <li>5. If there is not a protective covering over the display, place one there at this time.</li> </ol>	

<b>Step-by-Step Instructions</b>	
<p>6. Orient the display carrier so that the cable connections are adjacent to the hinge opening in the inner flip cover.</p>	
<p>7. Slide the edge of the display carrier that is adjacent to the receiver under the corresponding ledge on the inner flip cover.</p>	
<p>8. Then rotate the display carrier down onto the inner flip cover and snap the four latches in place that hold the display carrier to the inner flip cover.</p>	

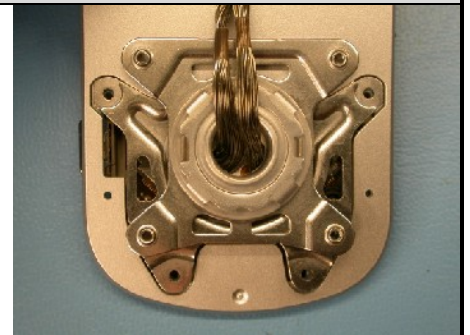


Step-by-Step Instructions	
<p>9. Verify that the power key, the camera key, the volume key, and the music player key are correctly positioned after the display carrier has been installed.</p> <p><b>NOTE!</b> When the display carrier and the inner flip cover are correctly mated, the four screw holes in the two components should be aligned.</p>	
<p>10. Obtain the hinge/cable assembly.</p> <p><b>NOTE!</b> The cable with the color mark connects to the display flex film connection that is not adjacent to the microphone.</p>	
<p>11. Select the cable you are going to connect and orient the connector end of the cable so that the side of the connector with the two notches is oriented away from the flex film.</p> <p><b>NOTE!</b> Do NOT attempt to plug the cable assemblies in by using their mass of wires to push the cable connections together. Damage to the cable assemblies are likely to result.</p>	
<p>12. Position the end of the cable assembly adjacent to its corresponding connection slot on the flex film so that all the connection needs is to be pressed together.</p>	
<p><b>NOTE!</b> Be careful not to damage the cable assemblies when connecting them to the display flex film.</p> <p>13. Using the tip of a pair of style 2A tweezers, work the end of the cable into its connector. There are two locations that the connection on the end of the cable must be alternately pushed to get the cable connection completely seated into its connector. The pushing locations are labeled location 1 and location 2.</p> <p>14. Repeat the previous three steps to connect the other cable to the display flex film.</p>	 



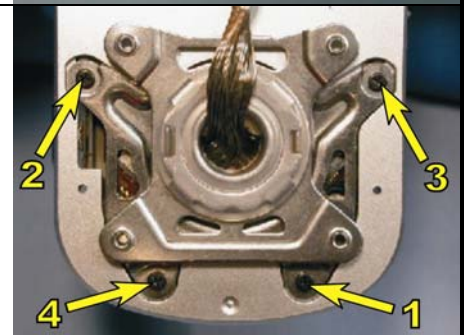
### Step-by-Step Instructions

15. Once both cables are connected, position the hinge assembly in the inner flip cover's hinge opening so that the four screw holes in the hinge are aligned with their corresponding screw holes in the display carrier and the two alignment pegs extending from the display carrier are within their corresponding notches in the hinge assembly.



Alignment  
Peg  
and Notch

16. Using a torque screwdriver set to 11 N·cm and a JCIS No. 0 bit; install in the sequence shown, a **new** flip hinge screw in each of the four screw locations that hold the hinge assembly to the flip.



The sections of the Flip Reassembly following this section must be performed in sequential order to reassemble the base portion of the phone.



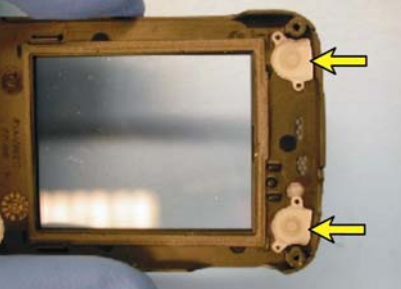




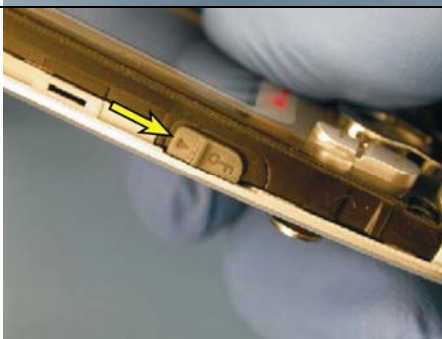

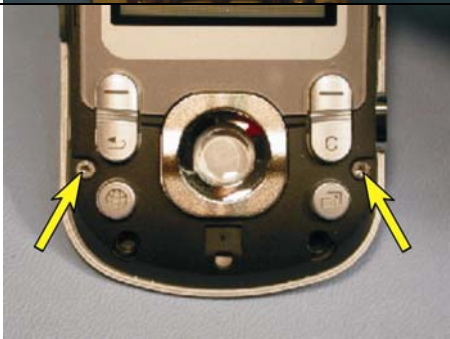
### 3.2.2 Display Cover Installation

If this part is being replaced, a new part should be used in the place of the old part when performing the following procedure. Note that the two gaming keys must be transferred from the old display cover to the new one.

**Tools needed:**

- Torque screwdriver
- Torx Plus size 5 bit
- \* Style 2A ESD tweezers (Blunt tip)
- Lint free wipes

Step-by-Step Instructions	
<ol style="list-style-type: none"> <li>1. Obtain the display cover being installed and place a protective film over the outer surface of the display cover's display window if one is not already present.</li> <li>2. Orient the display cover so that the inner surface of the cover is pointing upward.</li> </ol>	
<ol style="list-style-type: none"> <li>3. Insert the navigation keypad into its openings in the display cover.</li> </ol>	
<ol style="list-style-type: none"> <li>4. Verify that the two gaming keys are in their correct positions within the display cover.</li> </ol> <p><b>NOTE!</b> If a new display cover is being installed, the two gaming keys must be transferred from the old cover to the new one before proceeding. Make sure to press the keys down around their placement pegs.</p>	

<b>Step-by-Step Instructions</b>	
<p><b>NOTE!</b> If there is a protective covering over the display or on the inner surface of the window portion of the display cover, remove them at this time.</p> <p>5. Check for dust on the display and on the inner surface of the display cover's window. Use ionized air, alcohol, and lint-free wipes to remove any dust from these surfaces.</p> <p>6. Place the display carrier/inner flip cover assembly into the display cover so that the display is aligned to the display window in the display cover.</p> <p><b>NOTE!</b> When the display cover and the display carrier/inner flip cover assembly are correctly aligned, you can see through the screw holes that are located on each side of the navigation keypad.</p>	 
<p>7. Hold the display cover in place and slide the keypad lock key to make sure that the keypad lock key does not hang. The keypad lock key is spring loaded and should return to its original position when released.</p>	
<p>8. Using a torque screwdriver set to 15 N-cm and a Torx Plus size 5 bit, install a 1.6 X 5mm screw in each of the two screw locations.</p>	
<p>9. Using a torque screwdriver set to 11 N-cm and a Torx Plus size 5 bit, install a 1.6 X 5mm screw in each of the two screw locations.</p>	



### Step-by-Step Instructions

**NOTE!** Make sure there is no adhesive residue in the area where the screw cover panel mounts onto the inner flip cover. Carefully clean off any residue in this area using alcohol and a lint free wipe.

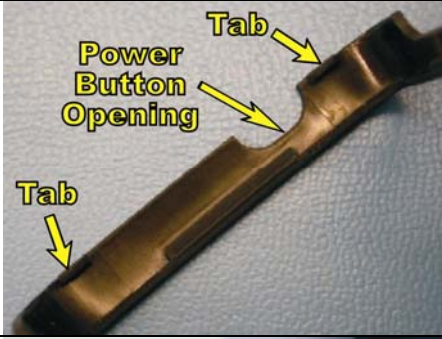
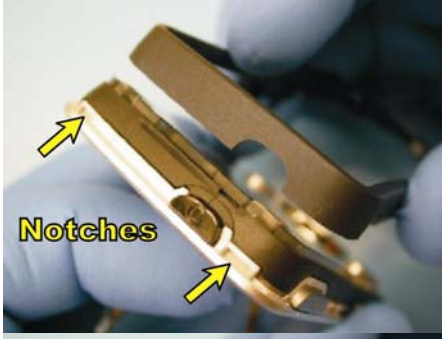


10. Obtain a new screw cover panel assembly and orient the assembly so that the side of the screw panel with adhesive is towards the inner flip cover.
11. Insert the screw cover panel/adhesive assembly in the screw cover's cavity and apply pressure to it for 3 seconds so that a good bond forms between the parts.



### 3.2.3 Style-Up Flip Cover Installation

If this part is being replaced, a new part should be used in the place of the old part when performing the following procedure.

**Tools needed:** None

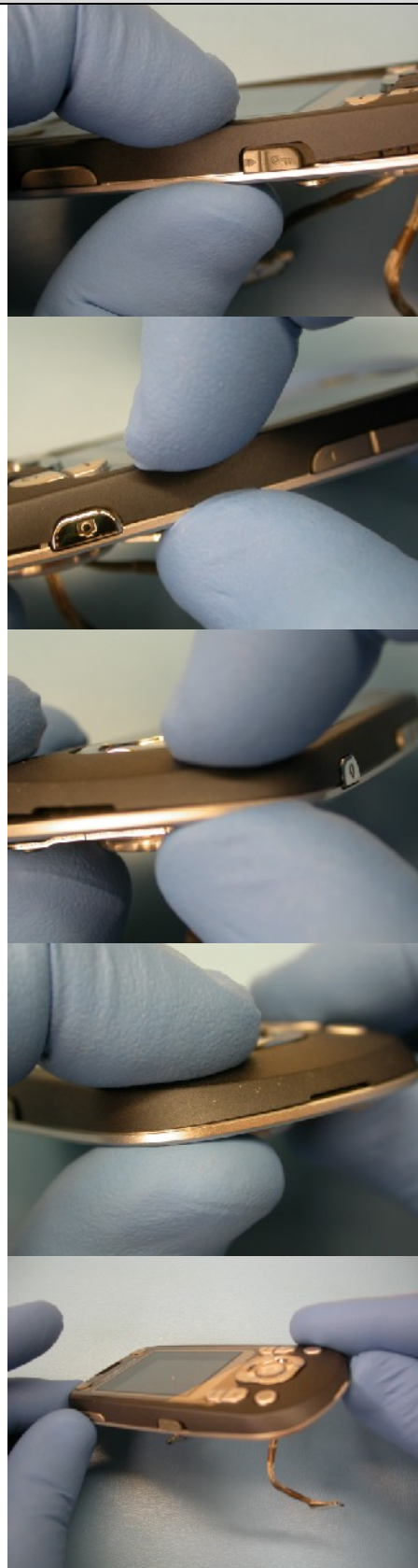
Step-by-Step Instructions	
1. Locate the two tabs on the edge of the style-up cover where the power button cut out is located.	 <p>This image shows a close-up of the style-up cover. Two yellow arrows point to the tabs on the edge, labeled 'Tab'. Another yellow arrow points to the power button cutout, labeled 'Power Button Opening'.</p>
2. Insert the two tabs in the corresponding notches in the end of the flip assembly and rotate the style-up cover onto the flip portion of the phone.	   <p>This section contains three images illustrating the installation process. The first image shows the flip assembly with two notches indicated by yellow arrows and labeled 'Notches'. The second image shows the style-up cover being rotated onto the flip portion. The third image shows the style-up cover fully installed on the flip portion, with a yellow arrow indicating the rotation point.</p>





### Step-by-Step Instructions

3. Snap the style-up cover onto the display cover by pressing the style-up cover in the locations indicated until the style-up cover is completely snapped into place.



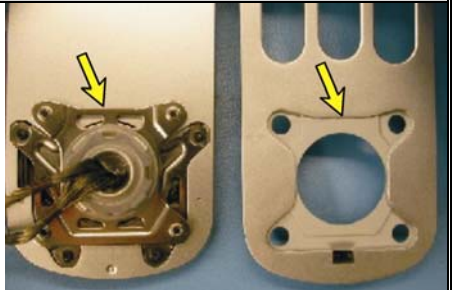
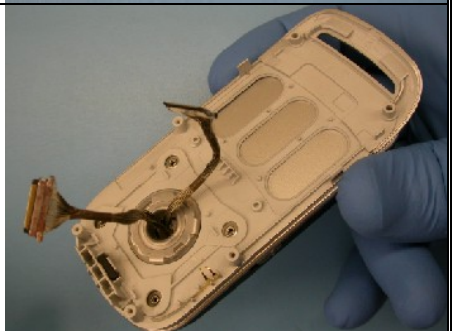
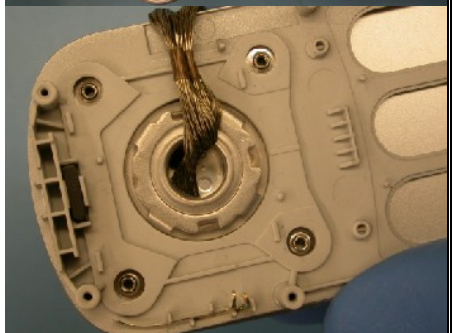



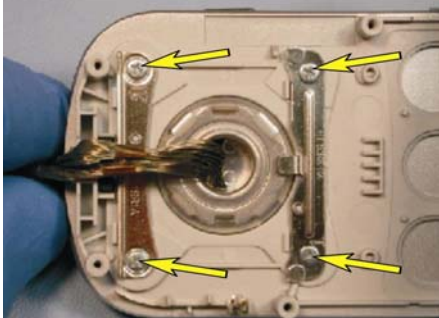
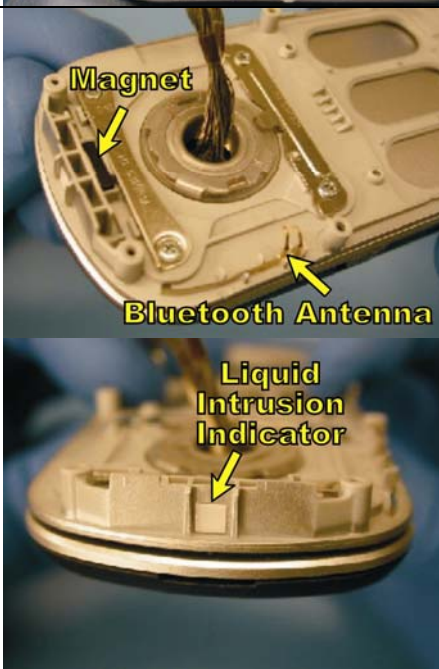
### 3.2.4 Inner Base Cover Installation

If the inner base cover is being replaced, a new part should be used in the place of the old part when reassembling. Using a new inner base cover requires that a new Bluetooth antenna, a new magnet, and a liquid intrusion indicator be installed on the new inner base cover. Refer to the installation sections for the Bluetooth antenna, the magnet, and the liquid intrusion indicator for instructions on how to install these components.

**Tools needed:**

- Torque screwdriver
- JCIS No. 0 bit

Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to damage the two cable assemblies when installing the inner base cover.</p> <p>1. Orient the inner base cover so that the outer surface of the inner base cover is toward the flip and the curved edge in the hinge cavity will align with the curved edge of the hinge assembly.</p>	
<p>2. Slide the two cable assemblies through the hole in the inner base cover and position the inner base cover down onto the hinge.</p>	
<p><b>NOTE!</b> If the inner base cover is mated correctly with the hinge assembly, then all four threaded screw holes should be visible through the four holes in the inner base cover and there should not be any visible gap between where the hinge and the screw holes in the inner base cover come together.</p>	
<p>3. Place the two hinge braces on the inner surface of the inner base cover as shown. An alignment peg extending from the inner base cover should pass through the corresponding alignment hole in each the hinge braces.</p> <p><b>NOTE!</b> The screw holes in each of the hinge braces will line up with a screw holes in the hinge when the braces are correctly positioned.</p>	

Step-by-Step Instructions	
<p>4. Using a torque screwdriver set to 11 N-cm and a JCIS No. 0 bit, install a <b>new</b> hinge brace screw into each of the hinge brace screw locations.</p>	
<p><b>NOTE!</b> If a new inner base cover was installed, verify that a Bluetooth antenna, a magnet, and a liquid intrusion indicator have been installed on the new inner base cover. If any of these components are not present, refer to the installation section of the missing component(s) for instructions on how to install the missing part(s).</p>	

- Starting with the “Outer Base Cover Installation” section, perform the remaining base reassembly sections to complete the reassembly of this phone.

## 4 Part Replacements

### 4.1 Battery Cover

The removal and installation of this part is covered in the base disassembly and reassembly procedures. To remove this part, perform section 2.1.1 of the base disassembly. To install this part, perform section 2.2.4 of the base reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions.

### 4.2 Battery

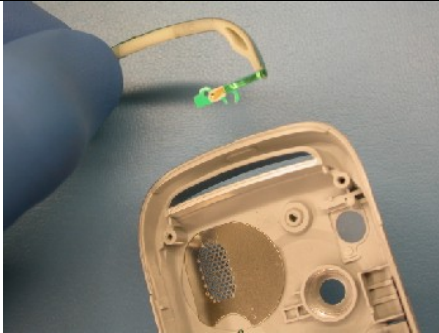

The removal and installation of this part is covered in the base disassembly and reassembly procedures. To remove this part, perform sections 2.1.1 - 2.1.2 of the base disassembly. To install this part, perform sections 2.2.3 - 2.2.4 of the base reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions.

### 4.3 Outer Base Cover

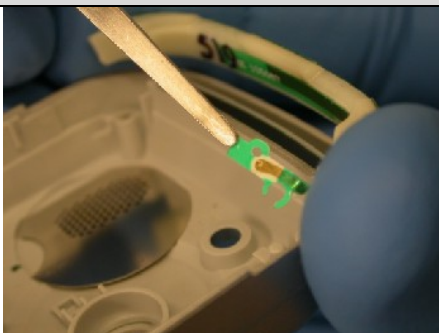


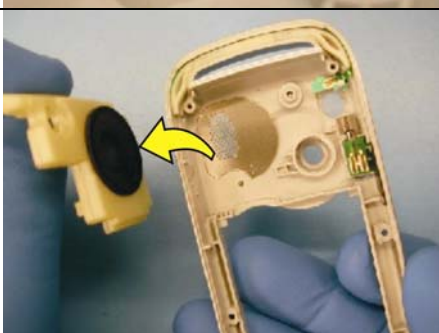

#### Replacement Procedure



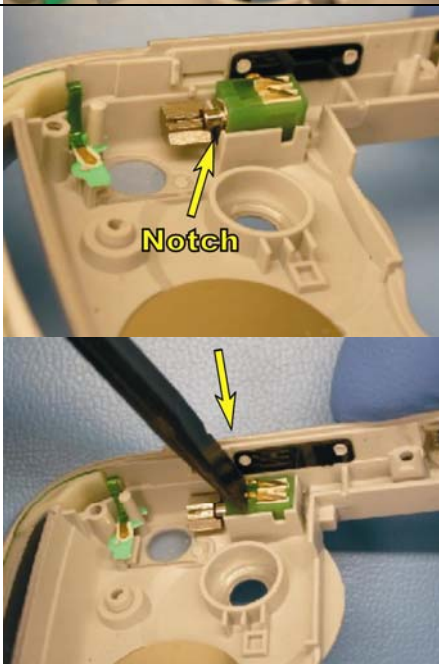
**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)
- Style 3 ESD tweezers
- Pry tool
- Lint-free wipes
- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure.

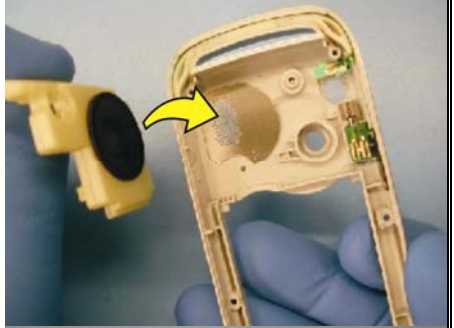



<b>Step-by-Step Instructions</b>	
1. Obtain a new outer base cover and new antenna assembly.	
2. Remove the protective covering from the portion of the antenna assembly that adheres to the outer base cover.	
3. Position the antenna assembly over the antenna loop portion of the outer base cover so that end of the antenna with the flex film extending from it is adjacent to the camera flash window in the outer base cover.	



<b>Step-by-Step Instructions</b>	
<p>4. While holding the new antenna over the new outer base cover, use a pair of style 2A tweezers and position the flex film portion of the antenna around the two alignment standoffs that are part of the ledge that the antenna's flex film extension attaches too.</p>	
<p>5. Once the antenna flex film extension is seated onto its ledge, insert the new antenna into the antenna loop portion of the outer base cover.</p>	
<p>6. Use the flat end of a pry tool to apply pressure over the area where the antenna flex film mates to the ledge in the outer base cover so that a good bond is formed between the two.</p>	
<p>7. Lift the rear speaker module from the old outer base cover and set it aside.</p>	
<p>8. Remove the RF port plug from the old outer base cover by pressing it out from the inside surface of the outer base cover.</p>	

Step-by-Step Instructions	
<p>9. Orient the RF port plug so that its small end goes down into the RF hole in the new outer base cover and press the RF port plug into place.</p>	
<p>10. Using style 3 tweezers, grip the rubber bushing portion of the vibrator and remove the vibrator from the old outer base cover.</p> <p><b>NOTE!</b> The vibrator may separate from its rubber bushing when being removed. If it does, just reassemble the two parts.</p>	
<p><b>NOTE!</b> Be careful not to damage the vibrator contacts when handling the vibrator.</p> <p>11. Position the vibrator in its cavity in the new outer base cover so that the contacts are oriented away from the outer base cover and the neck on the vibrator is aligned with the notch in the wall of the vibrator cavity.</p> <p><b>NOTE!</b> Do not press on the vibrator contacts when inserting the vibrator in its cavity.</p> <p>12. Press the vibrator into its cavity so that it is completely seated.</p>	



Step-by-Step Instructions	
13. Insert the rear speaker module into the new outer base cover so that the speaker cloth on the speaker module is towards the outer base cover's rear speaker grill and the RF port plug is centered in the circular opening in the speaker module.	 
14. Remove the side speaker from its cavity in the old outer base cover by prying the end of the speaker nearest the system connector opening up out of the outer base cover.	
15. Then lift the speaker from its cavity using your fingers and set it aside. The side speaker will be reinstalled when performing the reassembly procedure.	

- Perform sections 2.2.1 - 2.2.4 of the Base Reassembly procedure to complete the reassembly of this unit.

## 4.4 Camera Panel

This component comes as part of the outer base cover. Therefore to replace this component, you must replace the phone's outer base cover. Refer to the "Outer Base Cover" section of this document for instructions on replacing the outer base cover.



## 4.5 Mirror

This component comes as part of the outer base cover. Therefore to replace this component, you must replace the phone's outer base cover. Refer to the "Outer Base Cover" section of this document for instructions on replacing the outer base cover.

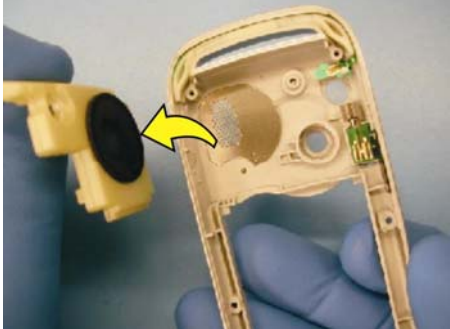


## 4.6 Antenna Assembly

### 4.6.1 Antenna Assembly Removal

- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure

**Tools Needed:**

- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
1. Lift the rear speaker module from the inside surface of the outer base cover and set it aside.	
2. Locate the flex film portion of the antenna assembly that is adhered to the outer base cover. 3. Using style 2A tweezers, peel loose the part of the antenna assembly that is adhered to the outer base cover.	
4. Lift the antenna assembly out of the outer base cover.	






## 4.6.2 Antenna Assembly Installation

A new part must be used when the following steps are being performed.

### Tools Needed:

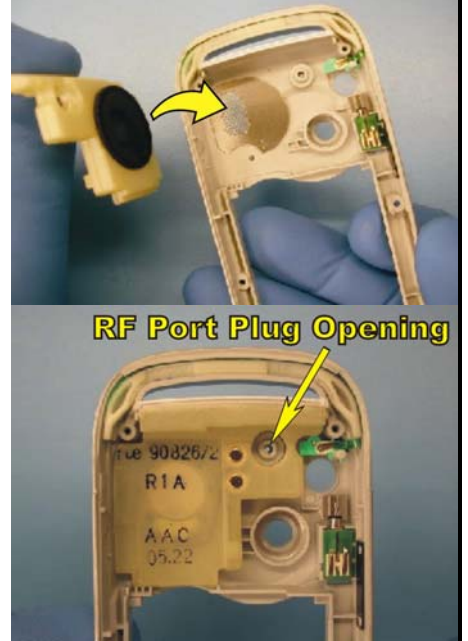
- Style 2A ESD tweezers (Blunt tip)
- Pry tool

Step-by-Step Instructions	
1. Remove the protective covering from the portion of the antenna assembly that adheres to the outer base cover.	
2. Position the antenna assembly over the antenna loop portion of the outer base cover so that end of the antenna with the flex film extending from it is adjacent to the camera flash window in the outer base cover.	
3. While holding the new antenna over the outer base cover, use a pair of style 2A tweezers and position the flex film portion of the antenna around the two alignment standoffs that are part of the ledge that the antenna's flex film extension attaches too.	
4. Once the antenna flex film extension is seated onto its ledge, insert the antenna into the antenna loop portion of the outer base cover.	
5. Use the flat end of a pry tool to apply pressure over the area where the antenna flex film mates to the ledge in the outer base cover so that a good bond is formed between the two.	



### Step-by-Step Instructions

6. Insert the rear speaker module back into the outer base cover so that the speaker cloth on the speaker module is towards the outer base cover's rear speaker grill and the RF port plug is centered in the circular opening in the speaker module.



- Perform sections 2.2.1 - 2.2.4 the Base Reassembly procedure.



## 4.7 RF Port Plug



### 4.7.1 RF Port Plug Removal

**If the outer base cover is removed from the phone,** the easiest way to remove the RF port plug by pushing the portion of the plug that protrudes into the outer base cover's inner area back through the hole in which it protrudes. To remove the RF port plug in this way, removing the rear speaker module from outer base cover is recommended, if it is present.

**If the outer base cover is not removed from the phone,** perform the following procedure to remove the RF port plug.



**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)
- No disassembly required

Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to scratch or damage the outer base cover when removing the RF port plug.</p> <p>1. Insert the tip of one side of a pair of style 2A tweezers between the RF port plug and the outer base cover.</p>	
<p>2. Press the tweezer tip towards the hole in the center of the RF port plug while lifting up on the plug. The RF port plug should come free from its hole in the outer base cover and can then be set aside.</p>	

## 4.7.2 RF Port Plug Installation

**Tools needed:** None

Step-by-Step Instructions	
<ol style="list-style-type: none"> <li>1. If replacing the RF port plug, obtain a new one at this point.</li> <li>2. Insert the RF port plug so that the smaller diameter end of the plug inserts into the base's RF hole first.</li> </ol>	
<ol style="list-style-type: none"> <li>3. Apply pressure to the accessible surface of RF port plug so that the plug completely seats into the RF access hole in the base.</li> </ol>	

- No reassembly required




## 4.8 Vibrator

### 4.8.1 Vibrator Removal

- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure

**Tools needed:**

- Style 3 ESD tweezers



Step-by-Step Instructions	
<p>1. Using style 3 tweezers, grip the rubber bushing portion of the vibrator and remove the vibrator from the outer base cover.</p> <p><b>NOTE!</b> The vibrator may separate from its rubber bushing when being removed. If it does, just reassemble the two parts.</p>	

### 4.8.2 Vibrator Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:**

- \* Pry tool

Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to damage the vibrator contacts when handling the vibrator.</p> <p>1. Position the vibrator in its cavity in the outer base cover so that the contacts are oriented away from the outer base cover and the neck on the vibrator is aligned with the notch in the wall of the vibrator cavity.</p>	
<p><b>NOTE!</b> Do not press on the vibrator contacts when inserting the vibrator in its cavity.</p> <p>2. Press the vibrator into its cavity so that it is completely seated.</p>	

- Perform sections 2.2.1 - 2.2.4 the Base Reassembly procedure.



## 4.9 Rear Speaker Module

### 4.9.1 Rear Speaker Module Removal

- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure

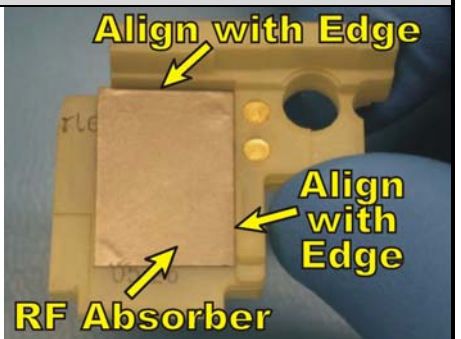
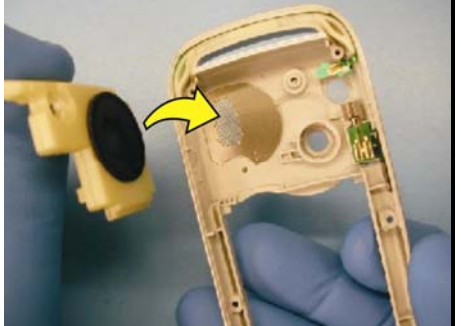
**Tools needed:** None

Step-by-Step Instructions	
1. Locate the rear speaker module and lift it from the outer base cover.	


### 4.9.2 Rear Speaker Module Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:** None

Step-by-Step Instructions	
<p><b>W600 series only:</b></p> <p>If a new rear speaker module is being installed in a W600 series phone, obtain an RF absorber, remove its adhesive protection, and install it on the new rear speaker module in the location shown.</p>	
1. Orient the rear speaker module relative to the interior surface of the outer base cover so that the speaker cloth on the speaker module is towards the outer base cover's rear speaker grill.	



Step-by-Step Instructions	
<p>2. Insert the rear speaker module into the outer base cover so that it is seated down against the interior surface of the outer base cover.</p> <p><b>NOTE!</b> When the rear speaker module is correctly seated, the RF port plug opening in the outer base cover is centered in the circular opening in the speaker module.</p>	<p><b>RF Port Plug Opening</b></p> 

- Perform sections 2.2.1 - 2.2.4 the Base Reassembly procedure.

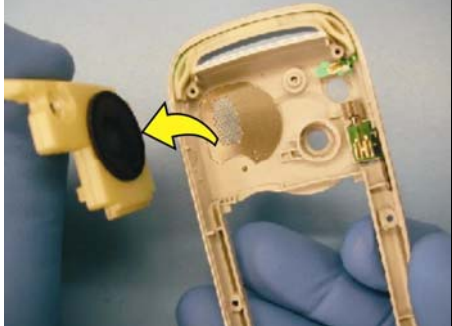

## 4.10 Rear Speaker Cloth

### Replacement Procedure

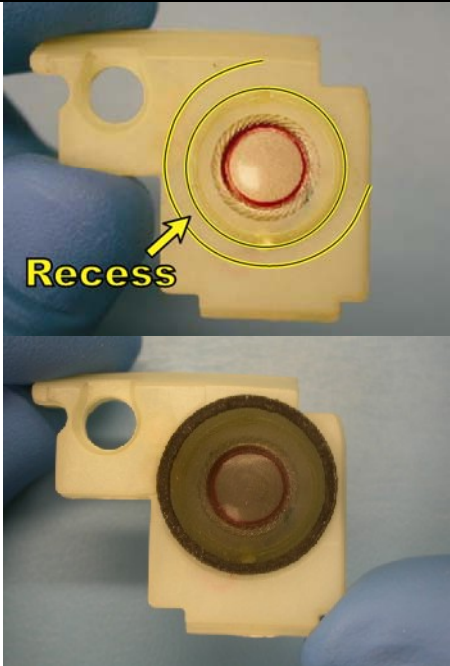
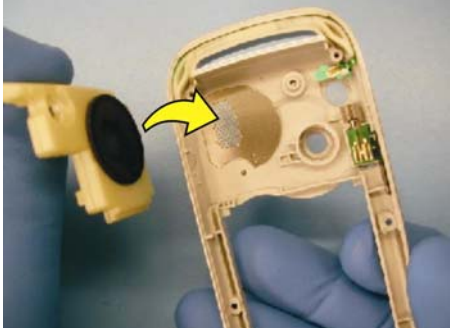

- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure

**Tools needed:**

- Pry tool

Step-by-Step Instructions	
<p>1. Locate the rear speaker module and lift it from the outer base cover.</p>	
<p>2. Remove the rear speaker cloth from the rear speaker module using a pry tool.</p>	



Step-by-Step Instructions	
<p>3. Obtain a new rear speaker cloth and place it in the recess around the rear speaker as shown.</p>	
<p>4. Orient the rear speaker module relative to the interior surface of the outer base cover so that the speaker cloth on the speaker module is towards the outer base cover's rear speaker grill.</p>	
<p>5. Insert the rear speaker module into the outer base cover so that it is seated down against the interior surface of the outer base cover.</p> <p><b>NOTE!</b> When the rear speaker module is correctly seated, the RF port plug opening in the outer base cover is centered in the circular opening in the speaker module.</p>	

- Perform sections 2.2.1 - 2.2.4 the Base Reassembly procedure.





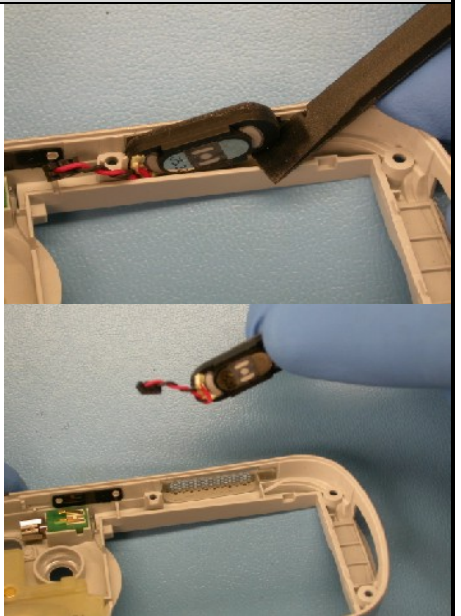
## 4.11 Side Speaker

### 4.11.1 Side Speaker Removal

- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure

**Tools needed:**

- Pry tool

Step-by-Step Instructions	
<ol style="list-style-type: none"><li>1. Remove the side speaker from its cavity in the outer base cover by prying the end of the speaker nearest the system connector opening up out of the outer base cover.</li><li>2. Then lift the speaker from its cavity using your fingers.</li></ol>	

### 4.11.2 Side Speaker Installation

The installation of this part is covered in the base reassembly procedure. To install this part, perform sections 2.2.1 - 2.2.4 of the base reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions.



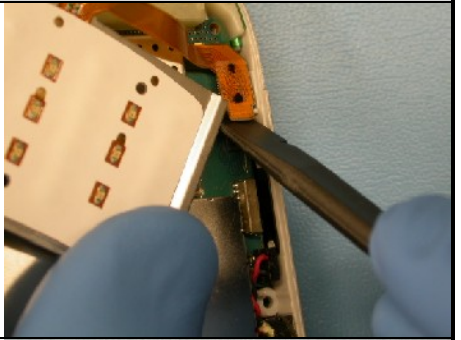

## 4.12 Keypad Switch Assembly – Main Keypad

### 4.12.1 Keypad Switch Assembly Removal

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure

**Tools needed:**

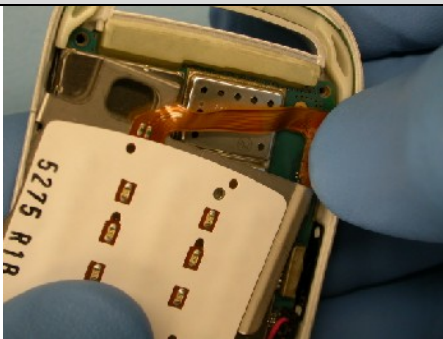
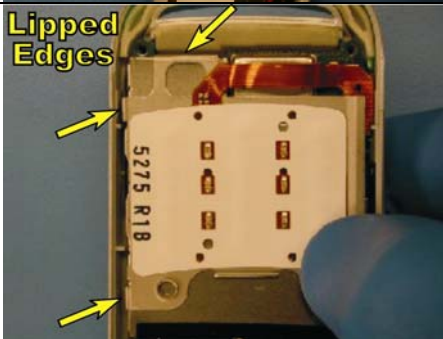
- Pry tool

Step-by-Step Instructions	
1. Unplug the keypad switch assembly from its connection on the circuit board using a pry tool.	
2. Lift the keypad switch assembly off of the circuit board.	

## 4.12.2 Keypad Switch Assembly Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:** None

Step-by-Step Instructions	
1. Plug the keypad switch assembly's flex film extension into its connection on the circuit board.	
2. Position the keypad switch assembly over the circuit board's exposed shield cans so that the lipped edges of the switch assembly's metal plate catch on the corresponding edges of the large shield can.	

- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.

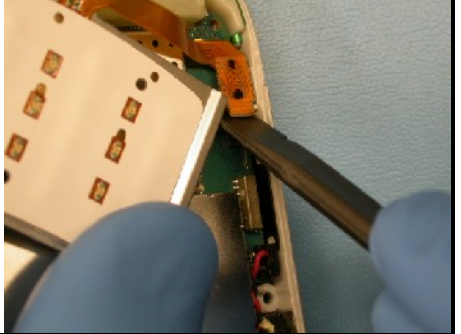
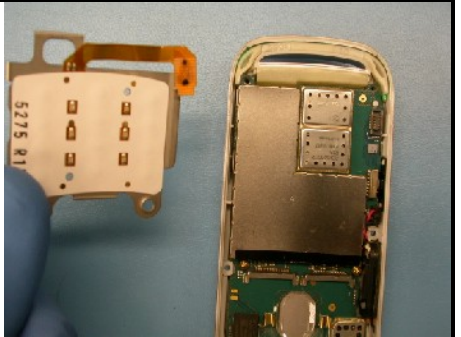
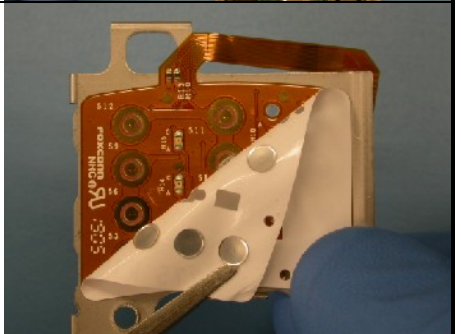
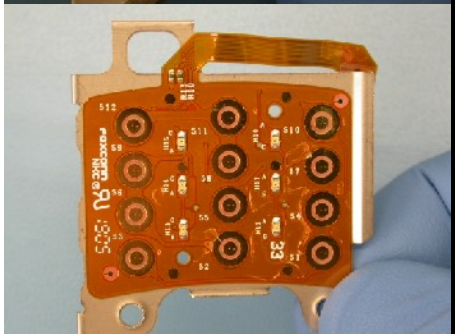
## 4.13 Dome Foil – Main Keypad

### 4.13.1 Keypad Dome Foil Removal

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure

**Tools needed:**

- Pry tool
- Lint-free wipes
- \* Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
1. Unplug the keypad switch assembly from its connection on the circuit board using a pry tool.	
2. Lift the keypad switch assembly off of the circuit board.	
3. Carefully peel off the dome foil from the keypad switch assembly  <b>NOTE!</b> Be careful not to damage the flex film to which the dome foil is adhered.	
4. Clean off any adhesive residue remaining on flex film portion of the keypad switch assembly using isopropyl alcohol and a lint-free wipe.	



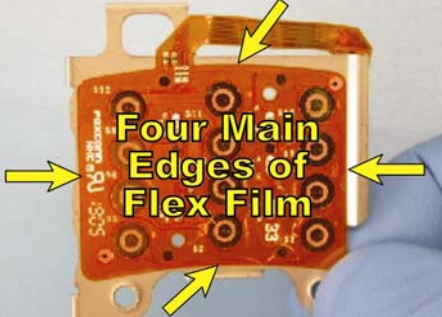

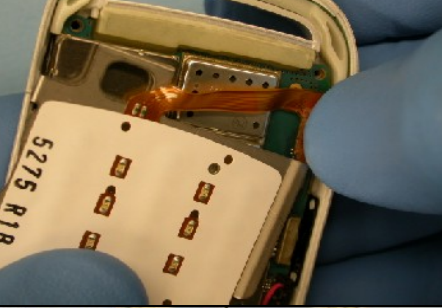
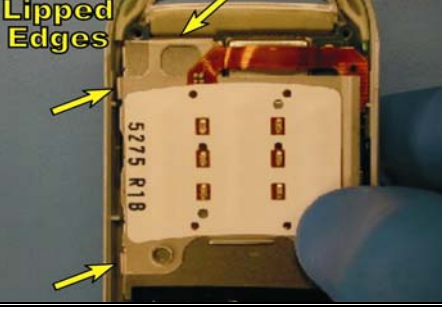


### 4.13.2 Keypad Dome Foil Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<p>1. Obtain a new keypad dome foil and remove the protective backing from it.</p> <p><b>NOTE!</b> Use a pair a tweezers to assist with handling and the positioning of the dome foil.</p>	
<p>2. Align the dome foil to the keypad switch assembly's flex film using the four main edges of the flex film and the two through holes in the flex film as positioning features.</p> <p><b>NOTE!</b> When the dome foil is correctly installed, you should be able to see completely through both through holes. Also, components should be visible in all of the rectangular holes in the dome foil.</p>	
<p>3. Carefully smooth the dome foil into place.</p> <p><b>NOTE!</b> Make sure that no air bubbles are trapped under the dome foil.</p>	
<p>4. Plug the keypad switch assembly's flex film extension into its connection on the circuit board.</p>	
<p>5. Position the keypad switch assembly over the circuit board's exposed shield cans so that the lipped edges of the keypad switch assembly's metal plate catch on the corresponding edges of the large shield can.</p>	

- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.



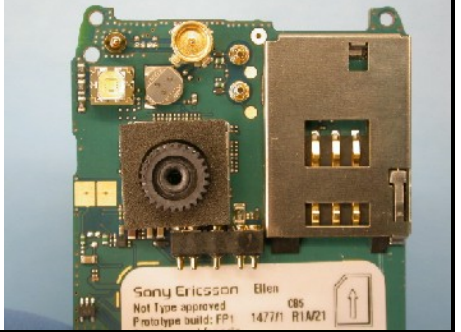

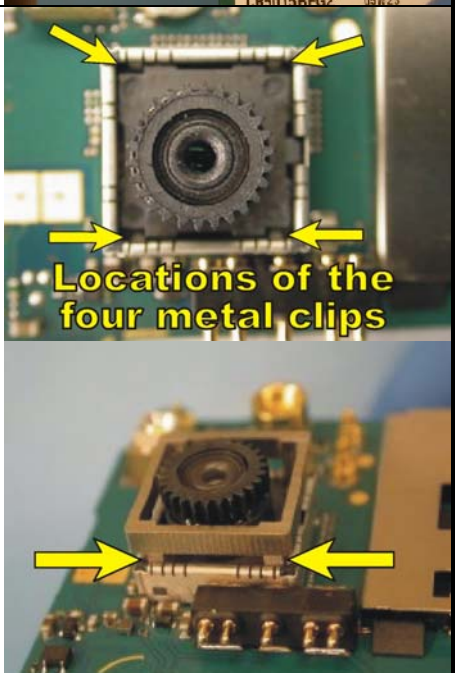
## 4.14 Camera Module

### 4.14.1 Camera Module Removal

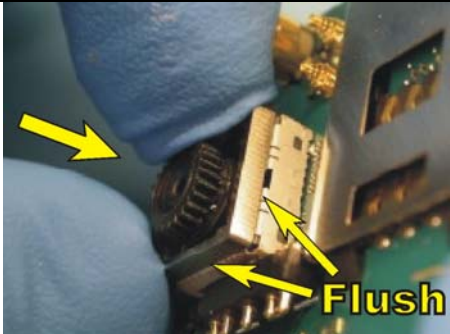
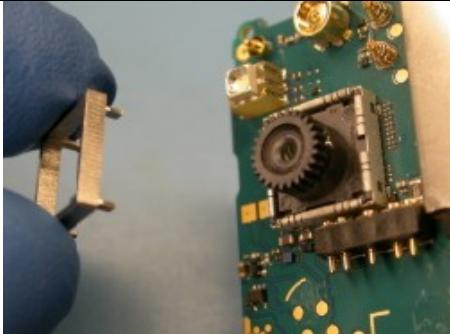
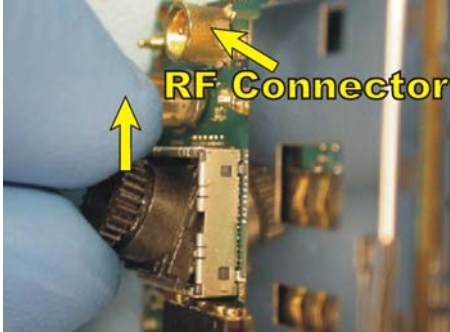
- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure

**Tools needed :**

- Style 2A ESD tweezers (Blunt tip)
- Camera extraction tool

Step-by-Step Instructions	
1. Orient the circuit board so that the camera module is towards you.	
2. Using tweezers, remove the foam gasket that is on top of the camera's circuit board connection.	
3. Obtain the camera extraction tool and orient it so that its four feet are aligned to the four openings where the metal clips that hold the camera module in position are located.	



Step-by-Step Instructions	
4. Press the camera extraction tool down against the camera socket so that the bottom surface of the camera tool is flush against the top surface of the camera socket all the way around.	
5. Lift the camera extraction tool from the camera module and set it aside.	
6. Gently rotate the camera module in the direction of the RF connector until the camera module separates from the camera socket.	

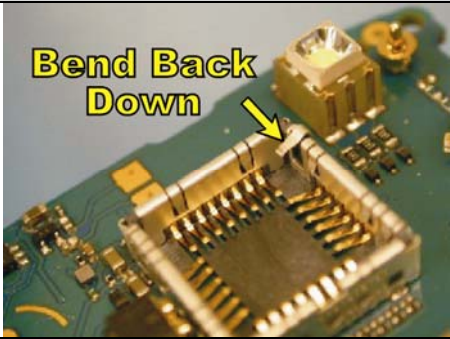
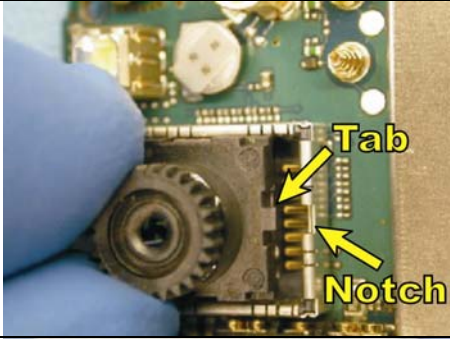
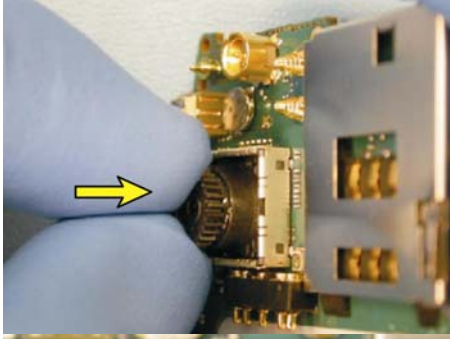
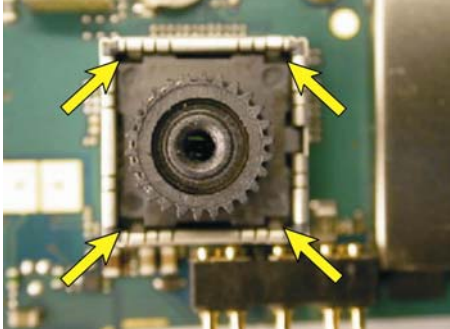


## 4.14.2 Camera Module Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:**

- \* Style 2A ESD tweezers (Blunt tip)
- \* Pry tool

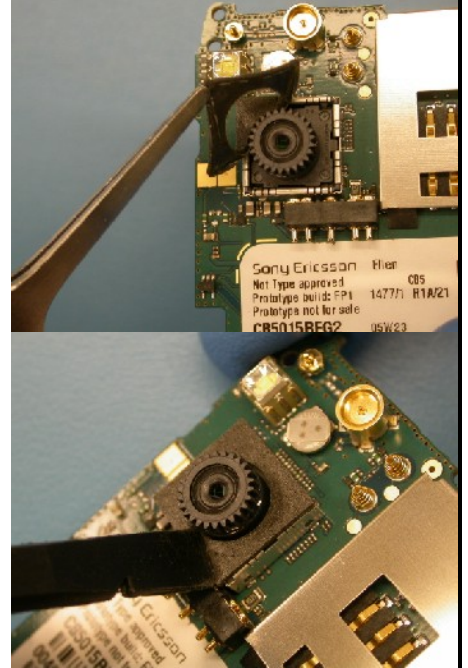
Step-by-Step Instructions	
<p><b>NOTE!</b> If any clips were bent up away from the walls of the camera socket during the removal of the camera module, bend those clips back down against the wall before proceeding.</p>	
<ol style="list-style-type: none"><li>1. Obtain the camera module and make sure there is a protective film over the camera lens.</li><li>2. Orient the camera module so that that tab located on one side of the square portion of the camera module corresponds to the notch in the camera socket.</li></ol>	
<ol style="list-style-type: none"><li>3. Gently press the camera module into its camera socket.</li></ol> <p><b>NOTE!</b> "Clicks" are normally heard when the clips engage.</p>	
<ol style="list-style-type: none"><li>4. Visually check whether each of the four clips has engaged before proceeding.</li></ol>	





### Step-by-Step Instructions

5. Remove the protective film from the camera lens if present.
6. Obtain a new camera gasket and slide it down around the camera lens until it is on top of the camera module's circuit board connection.
7. Align the camera gasket with the camera socket and apply pressure over the surface of the gasket so that it bonds in place.



- Perform sections 2.2.1 - 2.2.4 the Base Reassembly procedure.

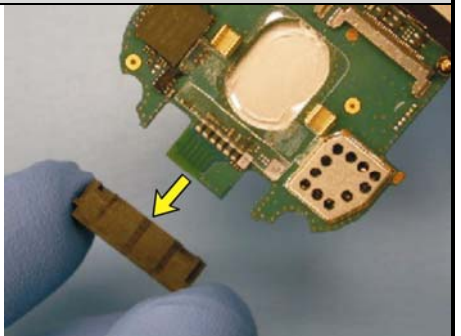


## 4.15 System Connector

### 4.15.1 System Connector Removal

- Perform sections 2.1.1 - 2.1.4 of the Base Disassembly Procedure

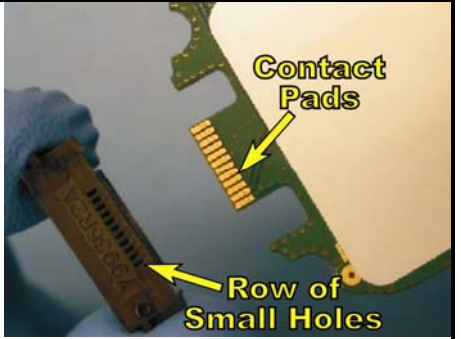
**Tools needed:** None

Step-by-Step Instructions	
1. Pull the system connector off of the circuit board.	

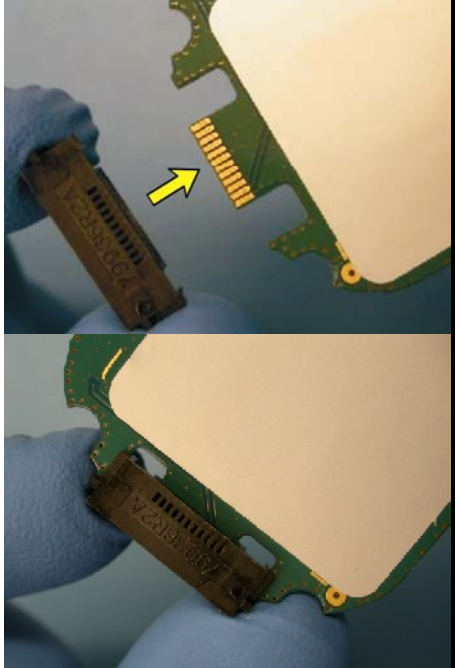
### 4.15.2 System Connector Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:** None

Step-by-Step Instructions	
1. Orient the circuit board so the contact pads for the system connector are towards you.	
2. Orient the system connector so that side of the connector with the row of small holes is towards you and the side of the connector with the long slot is towards the circuit board.	
<p><b>NOTE!</b> The user accessible portion of the system connector will oriented away from the circuit board when the system connector is correctly oriented.</p>	



Step-by-Step Instructions	
<p>3. Align the system connector contact pad portion of the circuit board with the slot in the side of the system connector that is adjacent to it.</p> <p>4. Then slide the system connector onto the circuit board until it is completely seated.</p>	

- Perform sections 2.2.1 - 2.2.4 the Base Reassembly procedure.


## 4.16 System Connector Cover






### Replacement Procedure

- Perform sections 2.1.1 - 2.1.2 of the Base Disassembly Procedure

#### Tools needed:

- Torque screwdriver
- Torx Plus size 5 bit

Step-by-Step Instructions	
<p>1. Unplug the system connector cover from the system connector.</p>	

<b>Step-by-Step Instructions</b>	
<p>2. Remove the four screws indicated from the battery cavity side of the base using a torque driver and a Torx Plus size 5 bit.</p>	
<p>3. Slightly separate the loose end of the inner and outer bases and remove the tab portion of the system connector cover from its slot.</p>	
<p>4. Obtain a new system connector cover.</p> <p>5. Install the system connector cover by sliding its tab portion into the slot adjacent to the system connector and plugging the cover into the system connector.</p>	 
<p>6. Press the two halves of the base back together and install a 1.6 X 5mm screw into each of the four screw locations shown using a torque screwdriver set to 15 N·cm and a Torx Plus size 5 bit.</p> <p>7. Unplug and reinstall the system connector cover in the system connector to verify the cover moves in and out of place correctly.</p>	

- Perform sections 2.2.3 - 2.2.4 the Base Reassembly procedure.







## 4.17 Label

### 4.17.1 Label Removal

- Perform sections 2.1.1 – 2.1.2 of the Base Disassembly Procedure

**Tools needed:**

- \* Pry tool
- \* Style 2A ESD-safe tweezers (Blunt Tip)
- Lint-free wipes

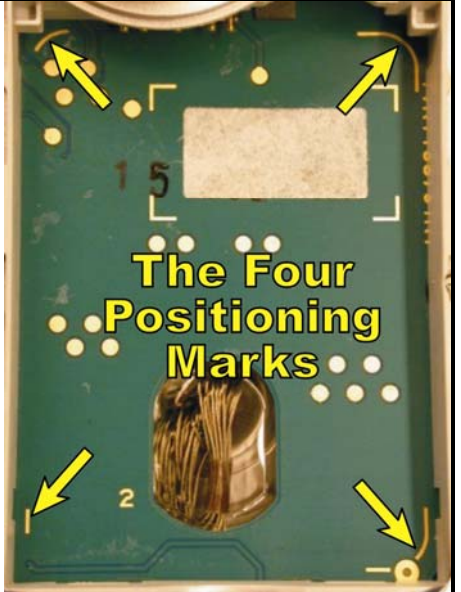
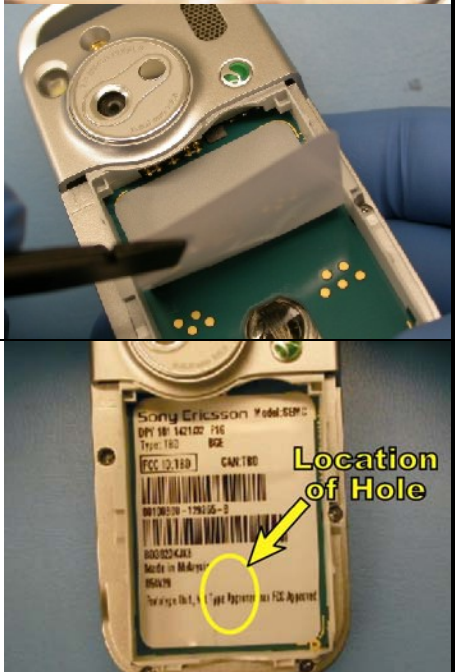
Step-by-Step Instructions	
<p>1. Before removing the label from a phone, print a new label.</p> <p><b>NOTE!</b> The text on the new label must be fully readable and the barcodes must be scannable.</p>	
<p><b>NOTE!</b> Labels only have to be removed from the phone, if there are already two or more labels on the phone.</p> <p><b>NOTE!</b> Heating up the old label(s) with a hot air device may make removing the labels easier.</p> <p>2. Carefully peel the old labels from the circuit board.</p> <p><b>NOTE!</b> Avoid damaging the circuit board when removing the labels.</p> <p><b>NOTE!</b> Make sure that all adhesive residue is removed. Carefully clean off any residue in the label area with alcohol and lint-free wipes.</p>	



## 4.17.2 Label Installation

**Tools needed:**

- \* Pry tool

Step-by-Step Instructions	
<p><b>NOTE!</b> No more than two labels are allowed stacked on top of each other in the battery cavity. If there are already two labels present, perform the label removal procedure before continuing.</p> <p>1. If a new label has not been created yet, then do so at this time.</p> <p>2. Use the four positioning marks on the circuit board to place the label. Place the end of the label that mounts adjacent to the battery connector first. Then roll the rest of the label down onto the circuit board.</p>	
<p>3. Once the label is correctly positioned, carefully smooth the label into place.</p> <p><b>NOTE!</b> Do not apply pressure in the area indicated due to the presence of a hole in the circuit board at this location.</p>	

- Perform sections 2.2.3 – 2.2.4 of the Base Reassembly Procedure



## 4.18 Inner Base Cover

The removal and installation of this part is covered in the flip disassembly and reassembly procedures. To remove this part, perform sections 2.1.1 - 2.1.3 of the base disassembly and then perform section 3.1.1 of the flip disassembly. To install this part, perform section 3.2.4 of the flip reassembly and then perform sections 2.2.2 - 2.2.4 of the base reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions. Using a new inner base cover requires that a new Bluetooth antenna, a new magnet, and a new liquid intrusion indicator be installed on the new inner base cover. Refer to the installation sections for the Bluetooth antenna, the magnet, and the liquid intrusion indicator for instructions on how to install these components.


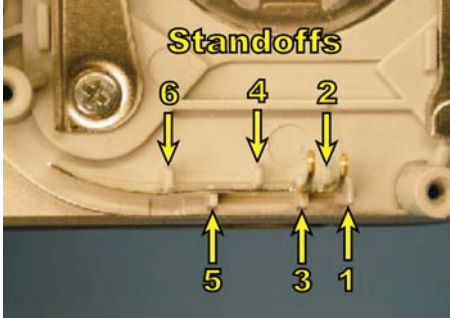
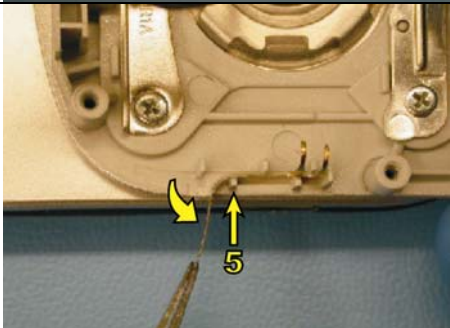
## 4.19 Bluetooth Antenna

### 4.19.1 Bluetooth Antenna Removal

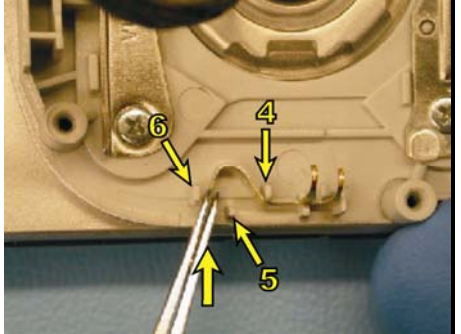
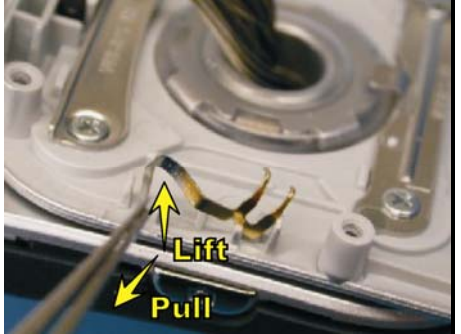
- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure

**Tools needed:**

- \* Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<p>1. Locate the Bluetooth antenna on the inner base cover.</p>	
<p><b>NOTE!</b> The Bluetooth antenna is held in place by six standoffs. Each of the six standoffs has been assigned a number to make identification of specific standoffs easier.</p>	
<p><b>NOTE!</b> The bending of the Bluetooth antenna done in the next few steps is necessary to prevent damage to the features that hold the Bluetooth antenna in place.</p>	
<p>2. Using tweezers, grip the free end of the Bluetooth antenna and bend it around standoff #5 so that the end of the antenna extends off of the inner base cover and is at approximately a 90 degree angle to the rest of the antenna.</p>	



Step-by-Step Instructions	
3. Then push the bent portion of the Bluetooth antenna in between standoff #6 and standoff #5 so that that antenna bends around standoff #4.	
4. Pull the free end of the Bluetooth antenna away from the hinge while simultaneously lifting the antenna away from the inner base cover so that the antenna separates from the inner base cover.	

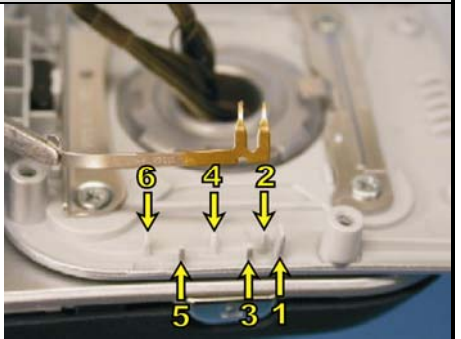
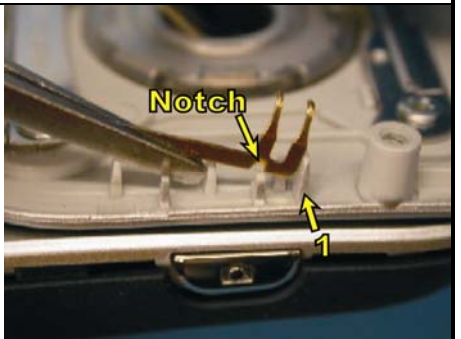
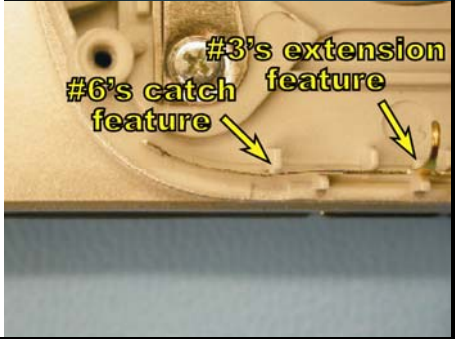
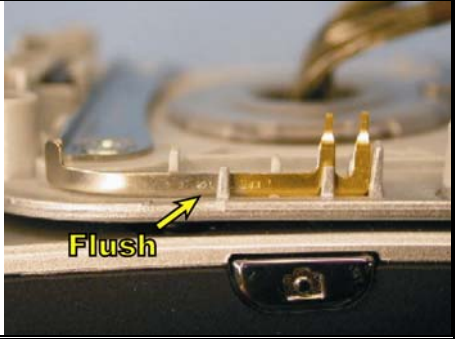


## 4.19.2 Bluetooth Antenna Installation

A new part should be used when the performing the following steps.

### Tools needed:

- \* Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<ol style="list-style-type: none"><li>1. Locate the group of six standoffs on the interior surface of the inner base cover that hold the Bluetooth antenna.</li></ol> <p><b>NOTE!</b> Each of the six standoffs has been assigned a number to make identification of specific standoffs easier.</p> <ol style="list-style-type: none"><li>2. Obtain a new Bluetooth antenna and position it over the group of standoffs so that the tips of its contact fingers are pointing toward the hinge and the fingers themselves extend away from the inner base cover.</li></ol>	
<ol style="list-style-type: none"><li>3. Place the end of the Bluetooth antenna with the spring fingers against and perpendicular to the tallest of the six standoffs, standoff #1.</li><li>4. Starting at the end of the Bluetooth antenna with the spring fingers, work the antenna between the standoffs so that the notch in the antenna fits over the corresponding feature that extends from the standoff #3 and the antenna is under the catch feature that is at the top of standoff #6.</li></ol>	 
<p><b>NOTE!</b> When the antenna is installed correctly, the edge of the antenna that is adjacent to the inner base cover should be flush against the inner base cover.</p>	

- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.






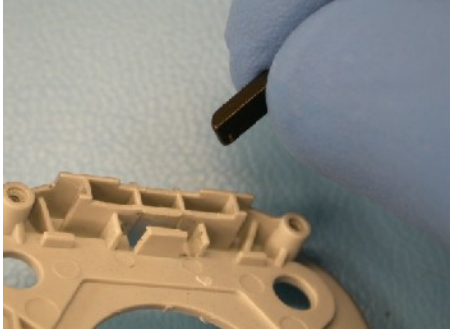
## 4.20 Magnet

### 4.20.1 Magnet Removal

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform section 3.1.1 of the Flip Disassembly Procedure

**Tools needed:**

- Nylon pointer




Step-by-Step Instructions	
1. Orient the inner base cover so that its outer surface is towards you and locate the magnet's access hole that is adjacent to the hinge cavity.	
2. Using the pointed end of a nylon pointer, push on the magnet through the access hole until a portion of the magnet is lifted out of its mounting features.	 
3. Once a portion of the magnet is lifted from the inner base cover enough that a hold on the magnet can be obtained, grip the magnet and remove it from the inner base cover.	

## 4.20.2 Magnet Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:**

- \* Style 2A ESD tweezers (Blunt Tip)

Step-by-Step Instructions	
1. Orient the inner base cover so that its interior surface is towards you and locate the features on the inner base cover that make up the magnet cavity.	
2. Obtain a magnet and orient it so that its rounded corner is aligned to the rounded corner of the magnet cavity.	
3. Insert the magnet in the magnet cavity and press on the magnet so that it seats all the way down in its cavity.	

- Perform section 3.2.4 the Flip Reassembly procedure.
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.



## 4.21 Liquid Intrusion Indicator

### 4.21.1 Liquid Intrusion Indicator Removal

If a liquid intrusion indicator is activated, handle the unit according to the instructions of your Sony Ericsson representative.

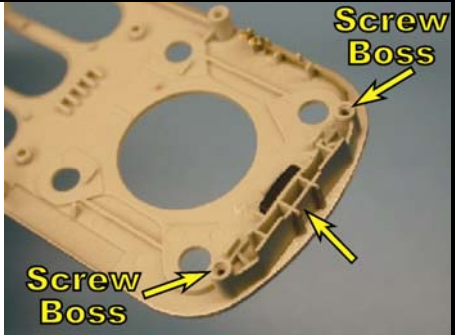

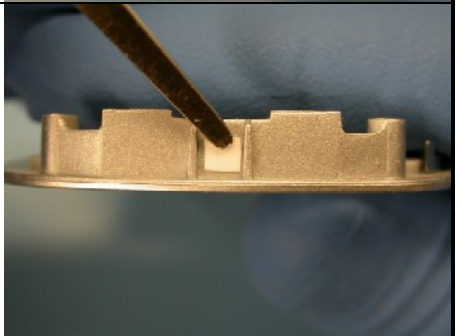
### 4.21.2 Liquid Intrusion Indicator Installation

There are two liquid intrusion indicators on this product. One is located on the inner base cover. The other is located on the display flex film assembly. Use the set of instructions that applies to the location the indicator is being installed.

#### Liquid Intrusion Indicator on Inner Base Cover

**Tools needed:**

- Pry tool
- Style 2A ESD tweezers (Blunt Tip)

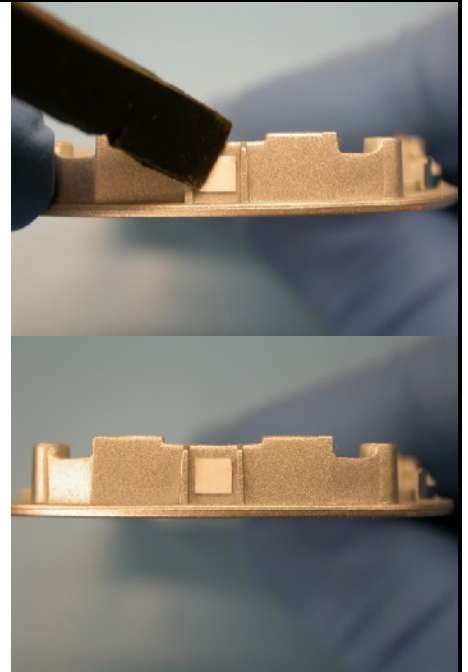
Step-by-Step Instructions	
1. Locate the portion of the inner base cover that extends between the two screw bosses near the hinge opening.	
2. Orient the flip assembly so that the external side of the extension that is between the two screw bosses is towards you.	
3. Using tweezers, place a new liquid intrusion indicator in the center of the channel that is midway the external side of the extension.	



### Step-by-Step Instructions

**NOTE!** Do not use your finger to apply pressure to the liquid intrusion indicator. Using a finger to apply pressure may cause partial activation of the indicator.

4. Using the flat end of a pry tool, apply gentle pressure to the liquid intrusion indicator to ensure a good adhesive bond the inner base cover.



- Perform section 3.2.4 the Flip Reassembly procedure.
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.

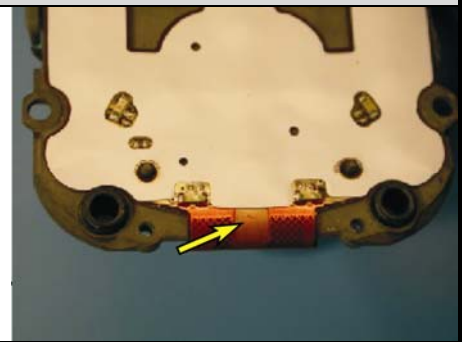
### Liquid Intrusion Indicator on Display Flex Film Assembly

#### Tools needed:

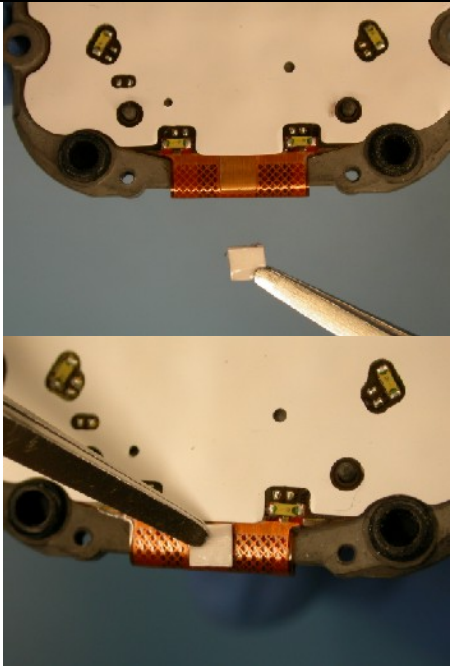
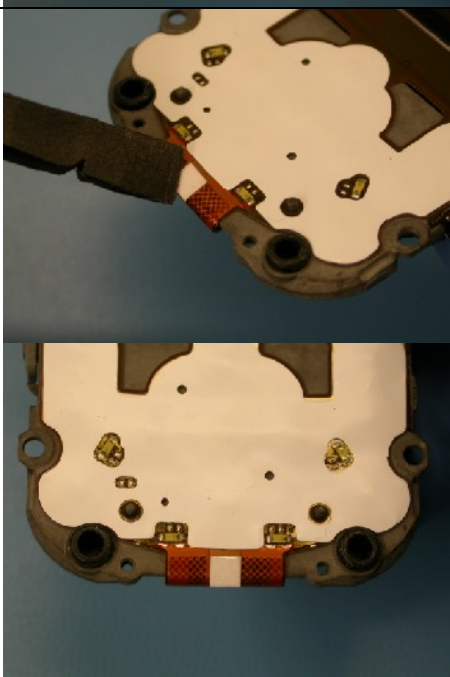
- Pry tool
- Style 2A ESD tweezers (Blunt Tip)

### Step-by-Step Instructions

1. Locate the square pad on the display flex film assembly that is directly below the navigation keypad's dome foil.





Step-by-Step Instructions	
<p>2. Using tweezers, place a new liquid intrusion indicator over the square pad on the display flex film assembly as shown.</p>	
<p><b>NOTE!</b> Do not use your finger to apply pressure to the liquid intrusion indicator. Using a finger to apply pressure may cause partial activation of the indicator.</p> <p>3. Using the flat end of a pry tool, apply gentle pressure to the liquid intrusion indicator to ensure a good adhesive bond to display flex film assembly.</p>	

- Perform sections 3.2.1 - 3.2.4 the Flip Reassembly procedure.
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.



## 4.22 Keypad

The removal and installation of this part is covered in the base disassembly and reassembly procedures. To remove this part, perform sections 2.1.1 - 2.1.3 of the base disassembly, but limit the amount of steps of section 2.1.3 performed to only that which is needed to remove the keypad. To install this part, perform the portion of section 2.2.2 of the base reassembly that is needed and sections 2.2.3 - 2.2.4 of the base reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions.

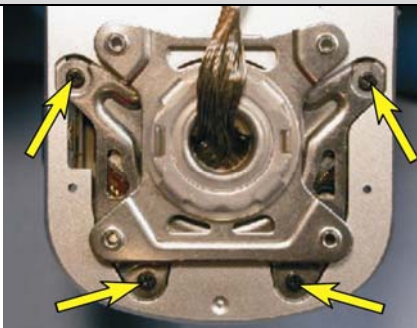

## 4.23 Cable Assemblies

### 4.23.1 Removal of Cable Assemblies

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform section 3.1.1 of the Flip Disassembly Procedure

**Tools needed:**

- Torque screwdriver
- JCIS No. 0 bit
- Style 2A ESD tweezers (Blunt tip)

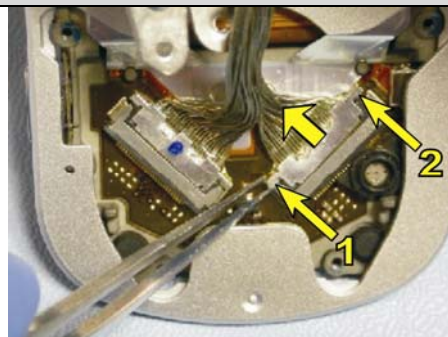
Step-by-Step Instructions	
<p>1. Remove the four screws that mount the hinge assembly to the display carrier using a torque screwdriver and a JCIS No. 0 bit.</p> <p><b>NOTE!</b> Do not reuse these screws.</p>	
<p>2. Lift the hinge assembly from the flip and hold it out of the way.</p>	



### Step-by-Step Instructions

**NOTE!** Be careful not to damage the cable connections on the display flex film when unplugging the cables.

**NOTE!** Do not attempt to unplug the cable assemblies by pulling on the mass of cables that make up them up.



3. Select one of the cable/display flex film connections and use the tip of a pair of style 2A tweezers to unplug the connection. There are two locations that the cable's portion of the connection must be alternately pulled at to disconnect the cable. The two pulling locations are labelled location 1 and location 2. The cable should be pulled in the direction shown.

4. Repeat the previous step to disconnect the other cable/display flex film connection.

5. Work the end of each cable assembly that was just disconnected from the display flex film one at a time through the hole in the hinge assembly.



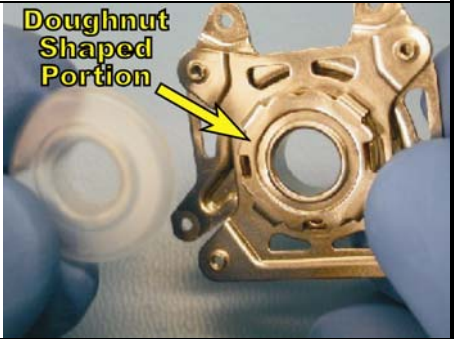
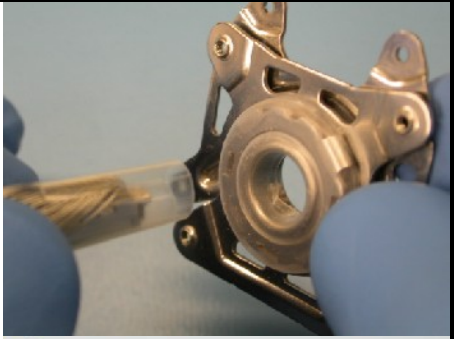
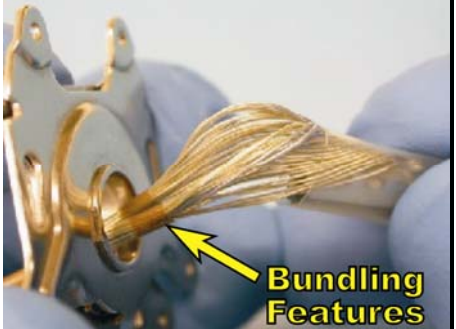


## 4.23.2 Installation of Cable Assemblies

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

### Tools needed:

- Torque screwdriver
- JCIS No. 0 bit
- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<b>NOTE!</b> If this procedure is only being performed to replace the cable assemblies, skip to the note following step 3. If the hinge and/or the hinge sleeve are being replaced, obtain the new parts that are needed and proceed.	
<ol style="list-style-type: none"><li>1. If the hinge sleeve is being replaced but the hinge assembly is not, remove the old hinge sleeve from that hinge assembly at is time.</li><li>2. If there is not a hinge sleeve on the hinge, place a hinge sleeve over the “doughnut” shaped portion of the hinge as shown.</li></ol>	
<b>NOTE!</b> Be careful not to damage the cable assemblies when inserting them through the center hole in the hinge assembly.  <b>NOTE!</b> The end of the cable assemblies that has the bundling feature furthest from the connectors is the end of the cable assemblies that should be passed through the hinge.	
<ol style="list-style-type: none"><li>3. Obtain a new set of cables and do not separate the two cables or remove the plastic sleeves that hold the ends of the two cables together.</li><li>4. From the side of the hinge in which hinge sleeve is mounted, carefully slide the sleeved end of the set of cables that have the bundling features furthest from the connectors through the center hole of the hinge assembly.</li><li>5. Remove the plastic sleeves that hold the cable assemblies together.</li></ol>	



### Step-by-Step Instructions

**NOTE!** The cable assembly with the color mark connects to the display flex film connection that **is not** adjacent to the microphone.

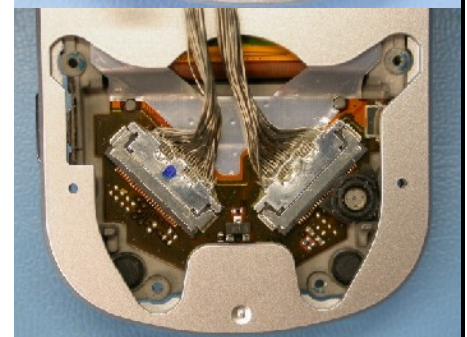
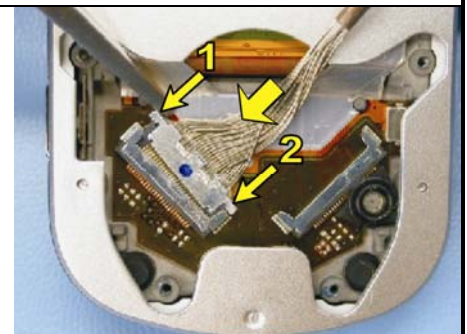
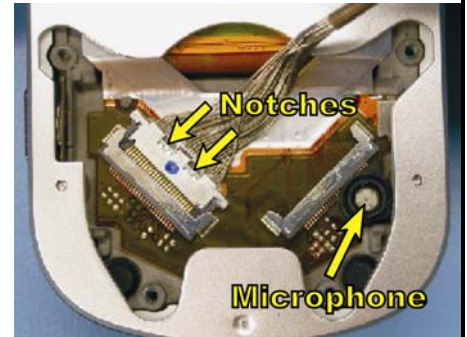
6. Select the cable you are going to connect and orient the connector end of the cable so that the side of the connector with the two notches is oriented away from the flex film.

**NOTE!** Do NOT attempt to plug the cable assemblies in by using their mass of wires to push the cable connection into its mating connector on the flex film. Damage to the cable assembly most likely will result.

7. Position the end of the cable assembly adjacent to its corresponding connection slot on the flex film so that all the connection needs is to be pressed together.


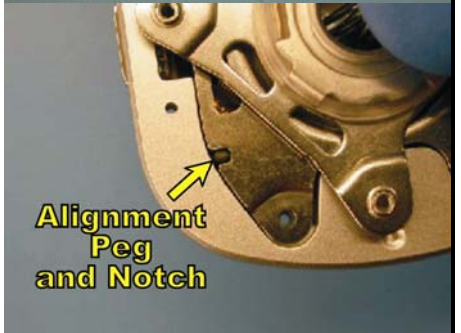
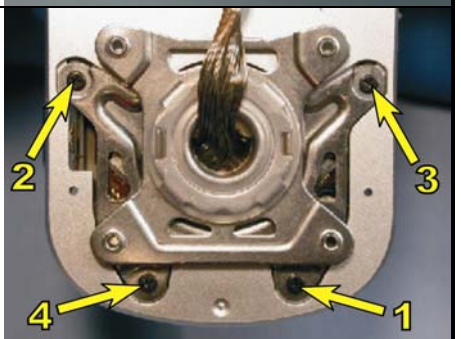
8. Using the tip of a pair of style 2A tweezers, work the end of the cable into its mating connector. There are two locations that the connection on the end of the cable must be alternately pushed at to get the cable connection completely seated into its connector. The two pushing locations are labeled location 1 and location 2.

9. Repeat the previous three steps to connect the other cable/flex film connection.







Step-by-Step Instructions	
10. Once both cables are connected, position the hinge assembly in the inner flip cover's hinge opening so that the four screw holes in the hinge assembly are aligned with their corresponding screw holes in the display carrier and the two alignment pegs extending from the display carrier are within their corresponding notches in the hinge assembly.	  <b>Alignment Peg and Notch</b>
11. Using a torque screwdriver set to 11 N-cm and a JCIS No. 0 bit, install <b>a new</b> display carrier hinge screw in each of the four screw locations shown in the sequence indicated.	

- Perform section 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.

## 4.24 Hinge and Hinge Sleeve

The removal and installation of these parts are covered in the “Cable Assemblies” section. To remove the hinge and/or the hinge sleeve, perform the “Removal of Cable Assemblies” section. To replace the hinge and/or the hinge sleeve, replace the desired part(s) along with both cable assemblies when performing the reassembly portion of “Cable Assemblies” section.

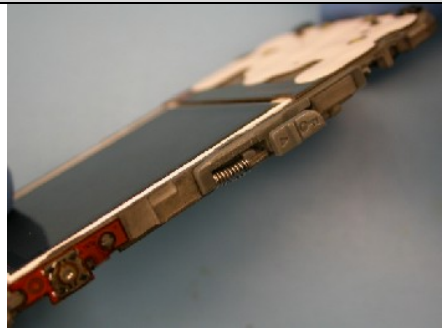
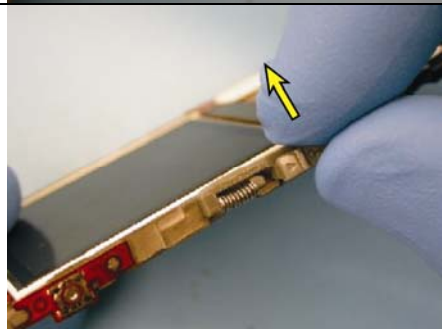



## 4.25 Keypad Lock Key

### 4.25.1 Keypad Lock Key Removal

**Tools needed:** None

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1-3.1.4 of the Flip Disassembly Procedure

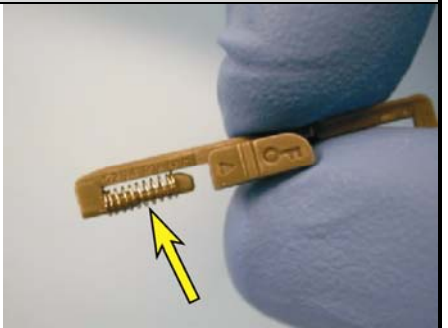



Step-by-Step Instructions	
1. Orient the display carrier so that the display is facing upwards and the keypad lock key is towards you.	
2. Lift the external portion of the keypad lock key in an upward direction. This should cause the keypad lock key to separate from the display carrier.	 

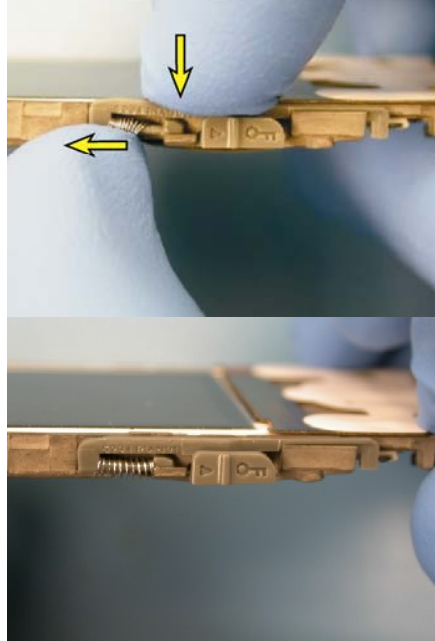
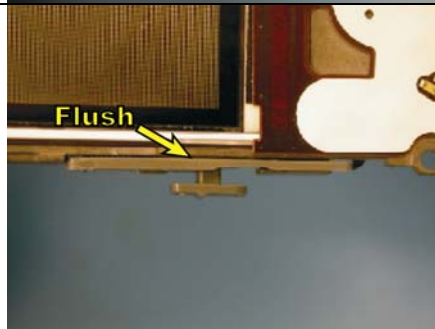


## 4.25.2 Keypad Lock Key Installation

If this part is being replaced, a new part should be used in the place of the old part when the following steps are being performed.

**Tools needed:** None

Step-by-Step Instructions	
1. If a new keypad lock key is being installed, obtain a new keypad lock key and a new keypad lock spring and install the spring on the keypad lock key as shown.	
2. Orient the display carrier so that the display is upward and the music player key's switch is towards you.	
3. Position the keypad lock key so that the external portion of the key is aligned with the indicated opening in the edge of the display carrier and the arm of the keypad lock key with the spring is towards the music player key switch.	
4. Install the keypad lock key in the edge of the display carrier so that the "L" shaped arm of the keypad lock key is within its corresponding slot on the display carrier.	

Step-by-Step Instructions	
<p>5. Compress the spring and press down on the upper edge of the keypad lock key so that the keypad lock key finishes inserting into its correct position.</p>	
<p><b>NOTE!</b> When the keypad lock key is correctly mounted, it should be flush against the side and the upper surface of the display carrier.</p>	

- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.






## 4.26 Screw Cover Panel – Base

### 4.26.1 Base Screw Cover Panel Removal

**Tools needed:**



- Style 2A ESD tweezers (Blunt tip)
- Lint free wipes
- No Disassembly required
- Front opening tool

Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to scratch the inner base cover when removing the base's screw cover panel.</p> <p>1. Begin lifting the screw cover panel away from the inner base cover by using the tip of one side of a pair of style 2A tweezers or a front opening tool at one of the two locations indicated.</p>	
<p>2. Once a portion of the screw cover panel is slightly lifted, grip the lifted portion of the panel and peel it off of the base.</p> <p><b>NOTE!</b> The screw cover panel cannot be reused.</p>	
<p>3. Carefully clean off any remaining adhesive residue from the screw cover panel mounting area on the inner base cover using the style 2A tweezers, alcohol, and a lint free wipe.</p>	



## 4.26.2 Base Screw Cover Panel Installation

Tools needed: • None

Step-by-Step Instructions	
<ol style="list-style-type: none"> <li>1. Obtain a new base screw cover panel and remove the protective backing from its adhesive film.</li> <li>2. Orient the new screw cover panel so that the side of the screw cover panel with adhesive is towards the inner base cover.</li> </ol>	
<ol style="list-style-type: none"> <li>3. Insert the screw cover panel in its cavity on the inner base cover and apply pressure to it for 3 seconds so that a good bond forms between the parts.</li> </ol>	

- No other reassembly required

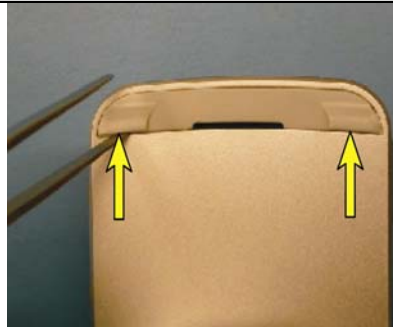




## 4.27 Screw Cover Panel - Flip

### 4.27.1 Flip Screw Cover Panel Removal

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)
- Lint free wipes
- Front opening tool
- No Disassembly required



Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to scratch the inner flip cover when removing the flip's screw cover panel.</p> <p>1. Begin lifting the screw cover panel away from the inner flip cover by using the tip of one side of a pair of style 2A tweezers or a front opening tool at one of the two locations indicated.</p>	
<p>2. Once a portion of the screw cover panel is slightly lifted, grip the lifted portion of the panel and peel it off of the flip.</p> <p><b>NOTE!</b> The screw cover panel cannot be reused.</p>	
<p>3. Carefully clean off any remaining adhesive residue from the screw cover panel mounting area on the inner flip cover using the style 2A tweezers, alcohol, and a lint free wipe.</p>	



## 4.27.2 Flip Screw Cover Panel Installation

Tools needed:

- None

Step-by-Step Instructions	
<ol style="list-style-type: none"><li>1. Obtain a new flip screw cover panel and remove the protective backing from its adhesive film.</li><li>2. Orient the new screw cover panel so that the side of the screw panel with adhesive is towards the inner flip cover.</li></ol>	
<ol style="list-style-type: none"><li>3. Insert the screw cover panel in its cavity on the inner flip cover and apply pressure to it for 3 seconds so that a good bond forms between the parts.</li></ol>	

- No other reassembly required







## 4.28 Co-Brand Label

### 4.28.1 Co-Brand Label Removal

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)
- Front opening tool
- Lint free wipes


Step-by-Step Instructions	
<p><b>NOTE!</b> Be careful not to scratch the inner base cover when removing the base's screw cover panel.</p> <p>1. Begin lifting the screw cover panel away from the inner base cover by using the tip of one side of a pair of style 2A tweezers or a front opening tool at one of the two locations indicated.</p>	
<p>2. Once a portion of the screw cover panel is slightly lifted, grip the lifted portion of the panel and peel it off of the base.</p> <p><b>NOTE!</b> The screw cover panel cannot be reused.</p>	
<p>3. Carefully clean off any remaining adhesive residue from the screw cover panel mounting area on the inner base cover using the style 2A tweezers, alcohol, and a lint free wipe.</p>	

<b>Step-by-Step Instructions</b>	
<p>4. Along one of the edges of the co-brand label that is adjacent to the base's screw cover cavity, slide the tip of one side of a pair of style 2A tweezers between the co-brand label and the ledge portion of the inner base cover to which the co-brand label is adhered.</p>	
<p>5. Grip the co-brand label with the tweezers and peel it from the inner base cover.</p>	
<p>6. Using alcohol and lint free wipes, clean the co-brand label area.</p>	

#### 4.28.2 Co-Brand Label Installation

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)

<b>Step-by-Step Instructions</b>	
<p>1. Obtain a new base screw cover panel and remove the protective backing from its adhesive film.</p>	
<p>2. Orient the new screw cover panel so that the side of the screw panel with adhesive is towards the inner base cover.</p>	
<p>3. Insert the screw cover panel in its cavity on the inner base cover and apply pressure to it for 3 seconds so that a good bond forms between the parts.</p>	



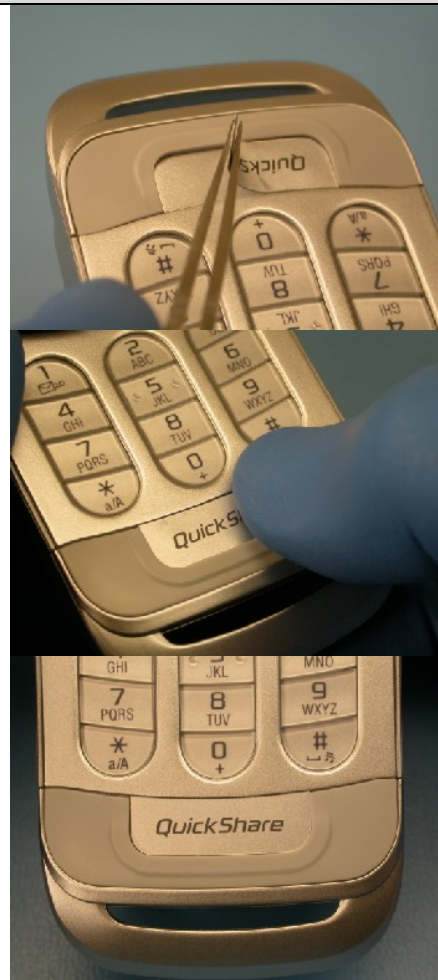
### Step-by-Step Instructions

**NOTE!** Use tweezers to handle the new co-brand label once it has been separated from its protective backing so that contamination of its adhesive is avoided.

4. Using tweezers, position the new co-brand label in its designated area on the inner base cover.

**NOTE!** Make sure that all edges of the co-brand label are within the recessed area designated for it.

5. Once the co-brand label is correctly positioned, carefully smooth the label into place.



- No further reassembly required



## 4.29 Dome Foil Assembly – Navigation Keypad

### 4.29.1 Navigation Keypad Dome Foil Assembly Removal

**Tools needed:**

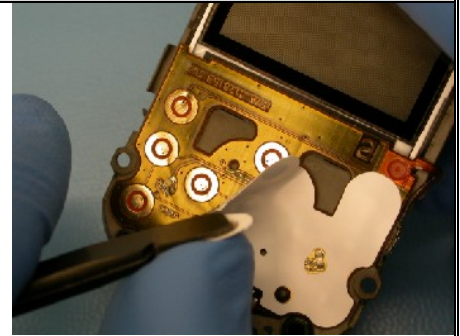
- Nylon pointer
- Lint-free wipes
- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1-3.1.4 of the Flip Disassembly Procedure

#### Step-by-Step Instructions

1. Using the flat end of a nylon pointer, catch a hold of the edge of the dome foil and peel the navigation keypad dome foil from the display flex film assembly.

**NOTE!** The navigation keypad dome foil cannot be reused once removed.

2. Remove any adhesive residue from the navigation keypad dome foil area on the display flex film assembly using alcohol and a lint-free wipe.



### 4.29.2 Navigation Keypad Dome Foil Assembly Installation

**Tools needed:** None

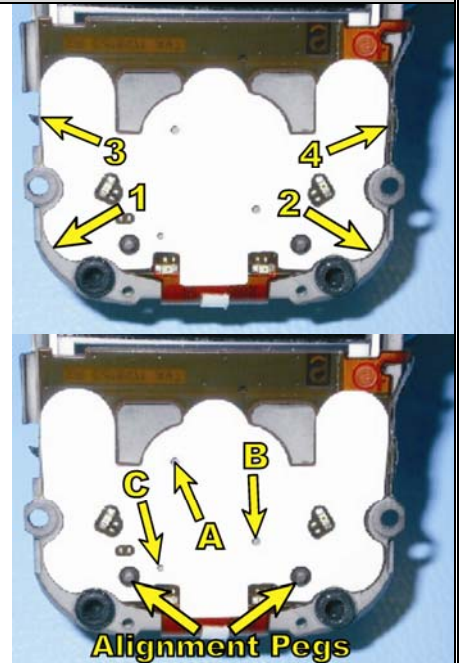
#### Step-by-Step Instructions

1. Position a new navigation keypad dome foil on top of the flex film assembly by aligning the two curved edges of the dome foil, labeled 1 and 2, and the two side edges of the dome foil, labeled 3 and 4, with their corresponding features of the display flex film.

**NOTE!** When the navigational keypad dome foil is correctly positioned, the two alignment pegs that protrude through the dome foil should be centered in their dome foil openings and the display carrier should be visible through the three holes labeled A, B, and C.

2. Once you are sure the navigation keypad dome foil is correctly positioned, carefully smooth the dome foil into place.

**NOTE!** Make sure that no air bubbles are trapped under the dome foil.



- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.

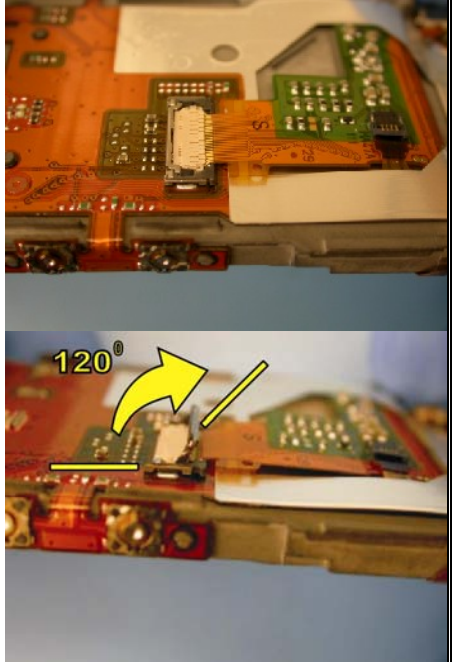
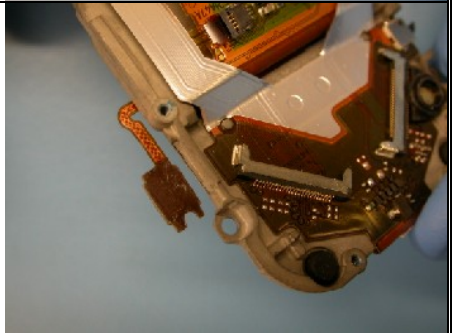
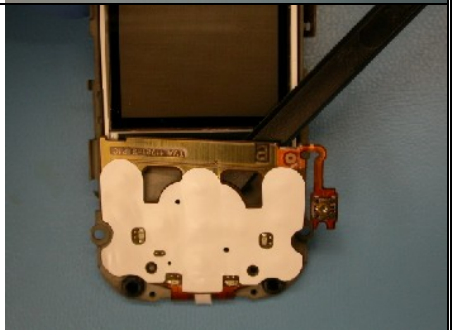


## 4.30 Display Flex Film Assembly and Display Carrier

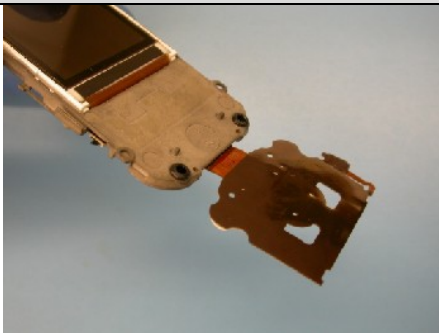
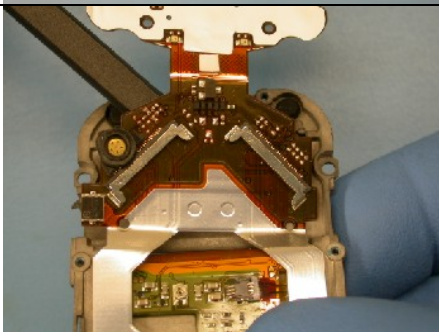

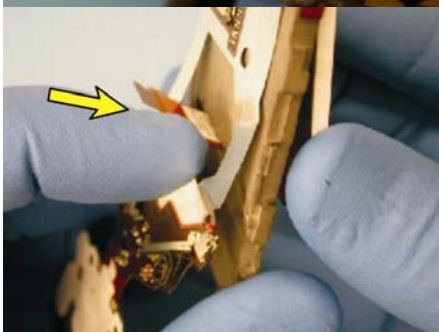
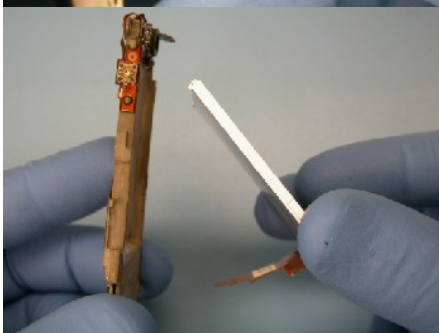
### 4.30.1 Display Flex Film and Display Carrier Disassembly

**Tools needed:**

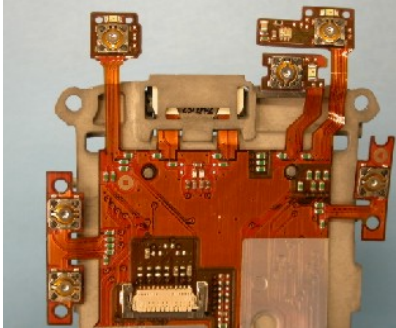
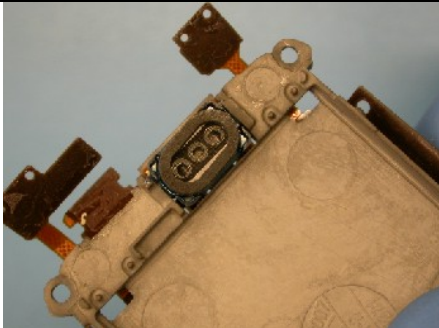
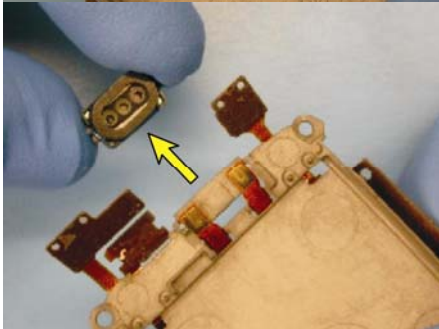
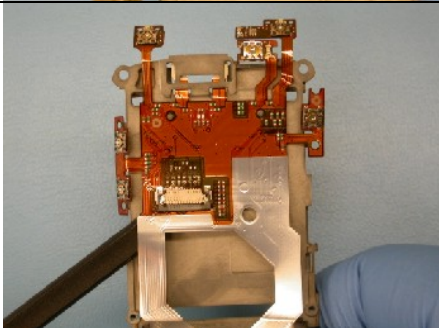

- Pry tool
- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure

Step-by-Step Instructions	
<ol style="list-style-type: none"><li>1. Locate the LCD assembly's connection to the display flex film assembly.</li><li>2. Rotate the edge of the connector that is closest to the receiver towards the LCD's flex film using a pry tool so that the rotated edge is 120 degrees from its original position.</li></ol>	
<ol style="list-style-type: none"><li>3. Using a pry tool, detach the camera key portion of the display flex film from the display carrier.</li></ol>	
<ol style="list-style-type: none"><li>4. Using a pry tool, detach the portion of the display flex film that contains the navigation keypad dome foil.</li></ol>	



Step-by-Step Instructions	
5. Rotate the portion of the display flex film that was just detached so that it is planar with the rest of the display flex film as shown.	
6. Using a pry tool, detach from the display carrier the portion of the display flex film that contains the cable connections.	
7. While holding the loose portion of the display flex film away from the display carrier, dislodge the LCD assembly's flex film from its connector on the display flex film.	
8. Push the LCD assembly's flex film through its slot in the display carrier until the sides of the LCD assembly are accessible enough so that the LCD assembly can be gripped along its sides.	
9. Pull the LCD assembly away from the display carrier until the two assemblies are completely separated.	



<b>Step-by-Step Instructions</b>	
10. Using a pry tool, detach the music player key switch, the two gaming key switches, the volume key switches, and the power key switch from the display carrier.	
11. Slide the receiver out of its slot in the display carrier by sliding it directly away from the display carrier's LCD cavity.	 
12. Using a pry tool, detach the portion of the display flex film containing the LCD connector from the display carrier.	
13. Slide the speaker contact portion of the display flex film from their slots in the carrier. This completes the separation of the display flex film assembly from the display carrier.	

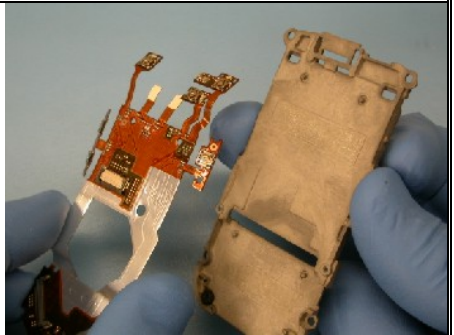
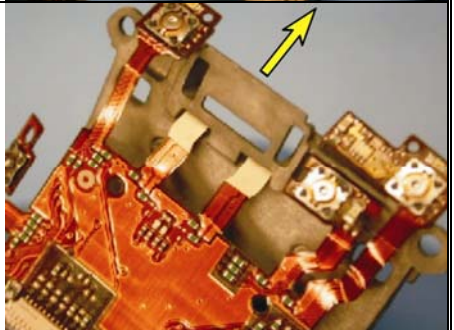
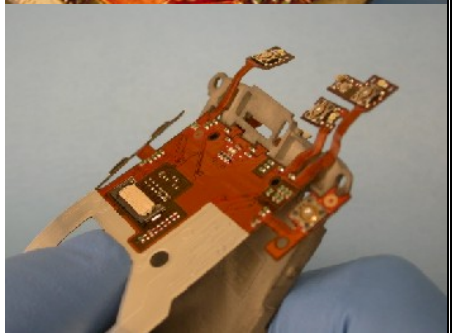
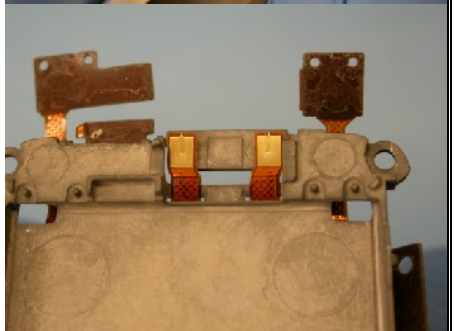


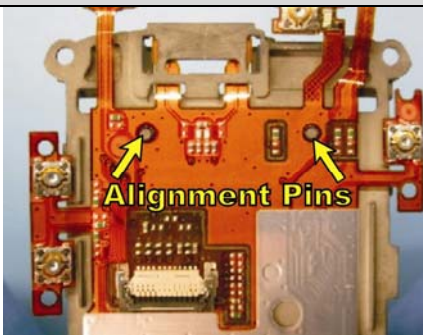
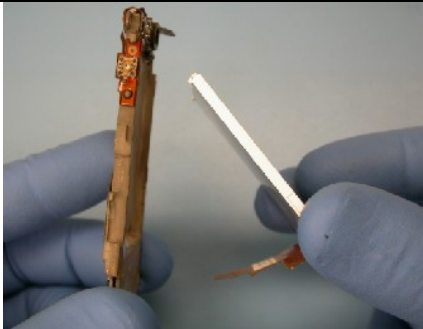
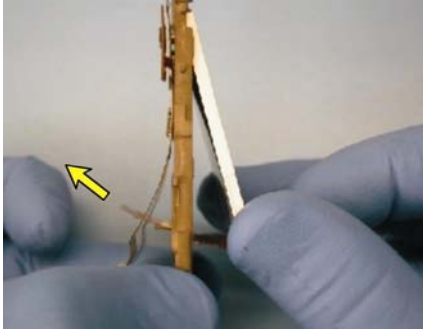



## 4.30.2 Display Flex Film and Display Carrier Reassembly

### Tools needed:

- \* Pry tool

Step-by-Step Instructions	
<b>NOTE!</b> The display carrier can normally be reused. Replacement is only required when one or more of the display carrier's adhesive films will no longer hold the display flex film assembly in place.	
<ol style="list-style-type: none"><li>1. If new carrier is being used, remove the protective coverings from the adhesive films before proceeding.</li><li>2. Orient the display flex film relative to the display carrier so that the side of the display flex film without components is towards the non-display cavity side of the display carrier and the end of the display flex film with the 7 extensions extending from it is towards the receiver cavity end of the display carrier.</li></ol>	
<ol style="list-style-type: none"><li>3. Insert the display flex film's two extensions that contain the receiver contacts into the corresponding slots in the edge of the display carrier's receiver cavity.</li></ol>	  
<b>NOTE!</b> If the display flex film and the display carrier have been oriented correctly, the receiver contact pads should be visible in the display carrier's receiver cavity.	

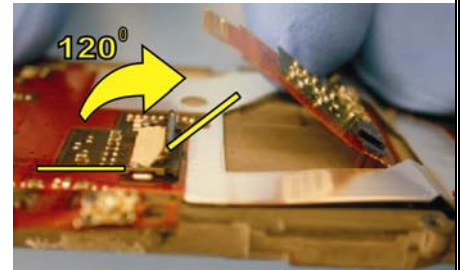
<b>Step-by-Step Instructions</b>	
<p>4. Work the portion of the display flex film that contains the LCD connector down onto the display carrier so that the two carrier alignment pins protrude through their corresponding holes in the display flex film assembly.</p>	
<p>5. Insert the top edge of the LCD into the display carrier's LCD cavity.</p>	
<p>6. While holding the loose portion of the display flex film away from the display carrier and the top edge of the LCD in place, slide the LCD's flex film through the slot at the bottom of the display carrier's LCD cavity and through the opening in the display flex film until the bottom edge of the LCD assembly is seated in the LCD cavity.</p>	 



### Step-by-Step Instructions

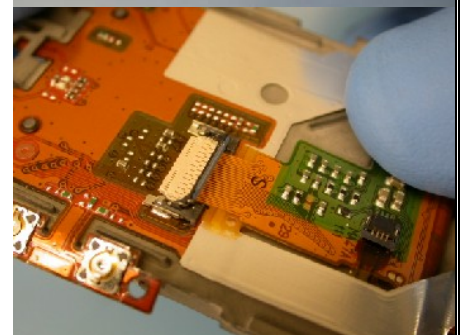
7. Use one hand to hold the LCD in its cavity while performing the following two steps.

**NOTE!** Before trying to insert the LCD assembly's flex film into its connector on the display flex film, make sure that the retaining bar on the display flex film's LCD connection is rotated towards the LCD assembly's flex film so that a 120 degree angle is formed between the retaining bar and the top of the connector.



8. Carefully insert the connection portion of the LCD assembly into the slot between the tan and black portions of connector on the display flex film. Push the LCD's connection into the connector until it will not insert any further.

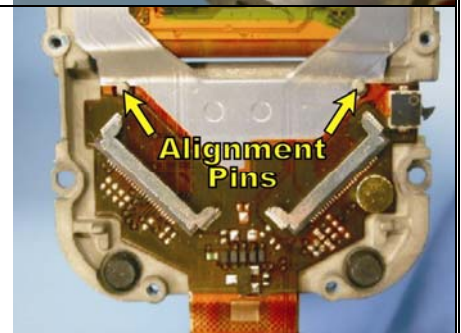
**NOTE!** Approximately 0.75MM of the gold contact portion of the LCD connection will be outside of the connector when the LCD's connection to the display flex film is properly assembled.



9. Rotate the retaining bar away from the LCD assembly's flex film and press it down against the display flex film until the retaining bar is flush with the rest of the connector.



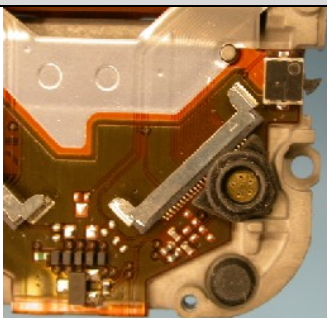
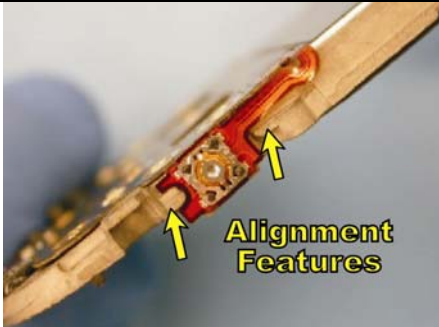
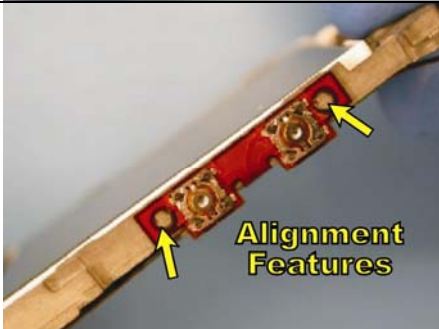
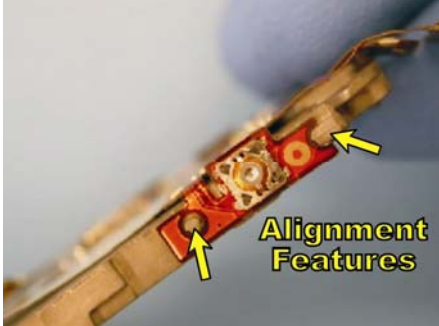
10. Work the portion of the display flex film that contains the cable connections down onto the display carrier so that the two carrier alignment pins protrude through their corresponding holes in the display flex film assembly.



11. Rotate the portion of the display flex film where the navigation keypad dome foil attaches down onto the LCD side of the display carrier so that the two carrier alignment pins protrude through their corresponding holes in the display flex film assembly.





<b>Step-by-Step Instructions</b>	
<p>12. Mount a microphone grommet over the microphone by using the features in the microphone grommet and the features around the microphone to correctly position the grommet on the microphone.</p>	
<p>13. If present, remove the protective backing from the camera switch portion of the display flex film.</p> <p>14. Using the two alignment features associated with this switch, place the camera switch portion of the display flex film into its position on the side of the display carrier.</p>	 <p><b>Alignment Features</b></p>
<p>15. If present, remove the protective backing from the volume switch portion of the display flex film.</p> <p>16. Using the two alignment features associated with this switch, place the volume switch portion of the display flex film into its position on the side of the display carrier.</p>	 <p><b>Alignment Features</b></p>
<p>17. If present, remove the protective backing from the music player switch portion of the display flex film.</p> <p>18. Using the two alignment features associated with this switch, place the music player switch portion of the display flex film into its position on the side of the display carrier.</p>	 <p><b>Alignment Features</b></p>



### Step-by-Step Instructions

19. If present, remove the protective backing from one of the two gaming key switch portions of the display flex film.

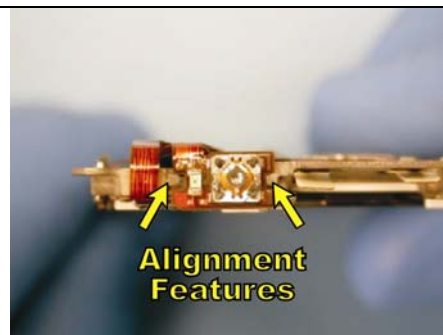
20. Using the two alignment features associated with this switch, place the gaming key switch portion of the display flex film into its position on the display carrier just above the LCD.

21. Repeat the previous two steps to mount the other gaming key switch.



22. If present, remove the protective backing from the power switch portion of the display flex film.

23. Using the two alignment features associated with this switch, place the power switch portion of the display flex film into its position on the top edge of the display carrier.

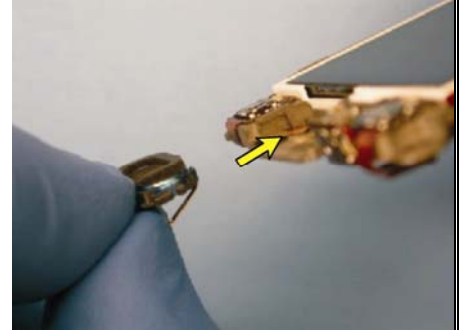




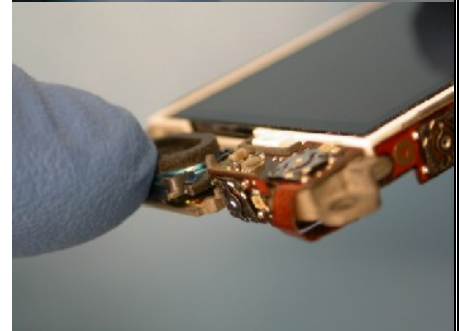


### Step-by-Step Instructions

24. Orient the receiver relative to the receiver cavity on the display carrier so that the side of the receiver with the dust gasket is away from the display carrier and receiver springs point away from the LCD assembly.



25. From the top edge of the display carrier, slide the receiver into the receiver cavity so that the side edges of the receiver are under the ledges the run along each side of the receiver cavity.



**NOTE!** There should not be a significant gap between the receiver and the LCD when the receiver is completely slid into its slot.



- If a navigation keypad dome foil is not present, install one by performing the steps of the “Navigation Keypad Dome Foil Installation” section.
- If a liquid intrusion indicator is not present, install one by performing the display flex film assembly’s portion of the “Liquid Intrusion Indicator Installation” section.
- If a keypad lock key is not present, install one by performing the steps of the “Keypad Lock Key Installation” section.
- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.

## 4.31 Display Carrier

The procedure for removing and reinstalling the *display carrier assembly* (*this consists of the display carrier and the display flex film*) is addressed by the flip disassembly and reassembly procedures. The procedure for replacing the *display carrier* is covered in the Display Flex Film and Display Carrier disassembly and reassembly procedures.

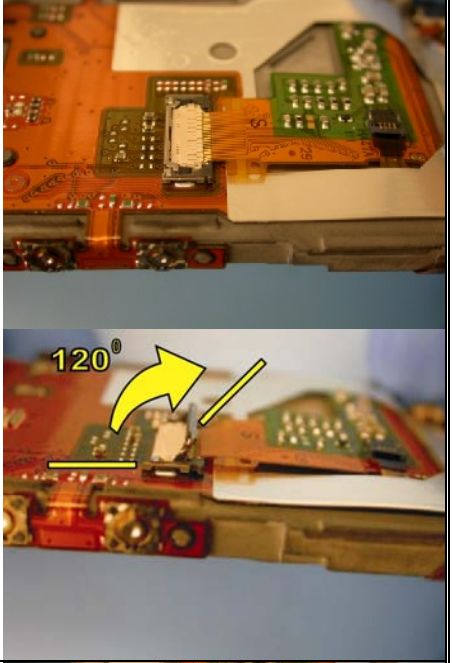
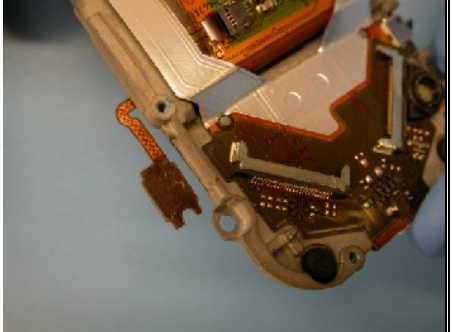
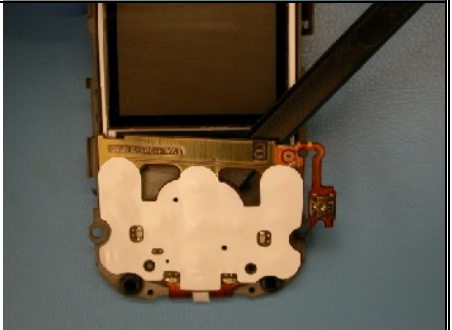


## 4.32 LCD Assembly

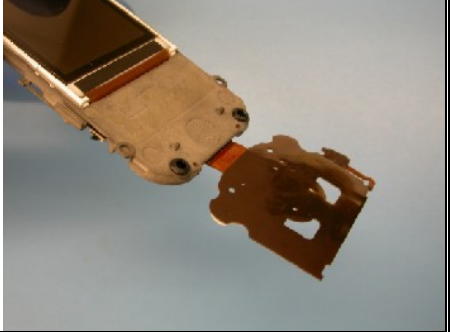
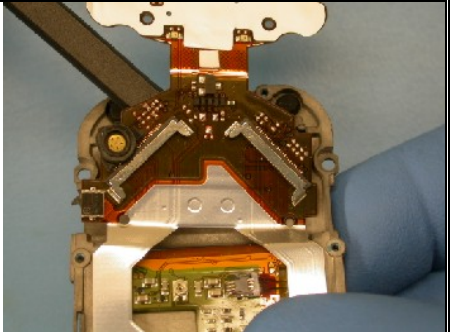
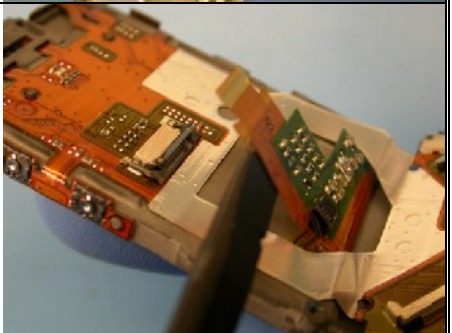
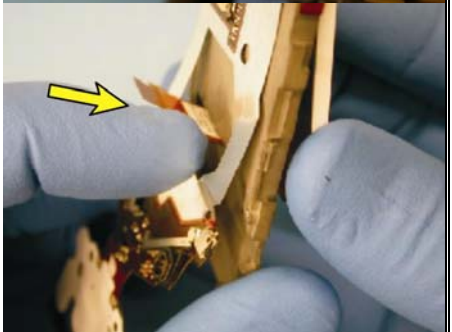

### 4.32.1 LCD Assembly Removal

**Tools needed:**

- Pry tool
- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure

Step-by-Step Instructions	
<ol style="list-style-type: none"><li>1. Locate the LCD assembly's connection to the display flex film assembly.</li><li>2. Rotate the edge of the connector that is closest to the receiver towards the LCD's flex film using a pry tool so that the rotated edge is 120 degrees from its original position.</li></ol>	
<ol style="list-style-type: none"><li>3. Using a pry tool, detach the camera key portion of the display flex film from the display carrier.</li></ol>	
<ol style="list-style-type: none"><li>4. Using a pry tool, detach the portion of the display flex film that contains the navigation keypad dome foil.</li></ol>	




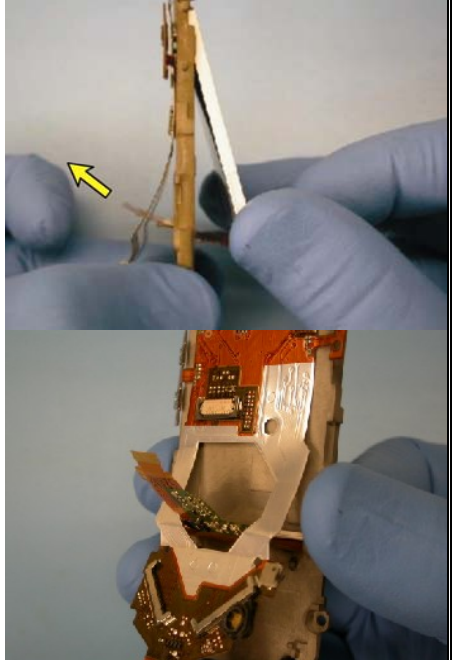
Step-by-Step Instructions	
5. Rotate the portion of the display flex film that was just detached so that it is planar with the rest of the display flex film as shown.	
6. Using a pry tool, detach the portion of the display flex film that contains the cable connections from the display carrier.	
7. While holding the loose portion of the display flex film away from the display carrier, dislodge the LCD assembly's flex film from its connector on the display flex film.	
8. Push the LCD assembly's flex film through its slot in the display carrier until the sides of the LCD assembly are accessible enough so that the LCD assembly can be gripped along its sides.	
9. Pull the LCD assembly free from display carrier.	



#### 4.32.2 LCD Assembly Installation

**Tools needed:**

- Pry tool

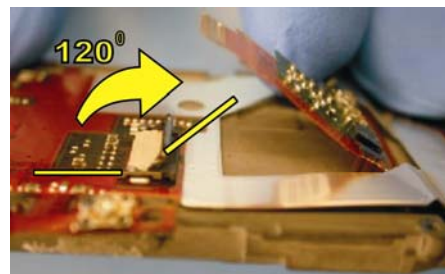
Step-by-Step Instructions	
1. Insert the top edge of the LCD assembly into the display carrier's LCD cavity.	
2. While holding the loose portion of the display flex film away from the display carrier and the top edge of the LCD in place, slide the LCD's flex film through the slot at the bottom of the display carrier's LCD cavity and through the opening in the display flex film until the bottom edge of the LCD assembly is seated in the LCD cavity.	



### Step-by-Step Instructions

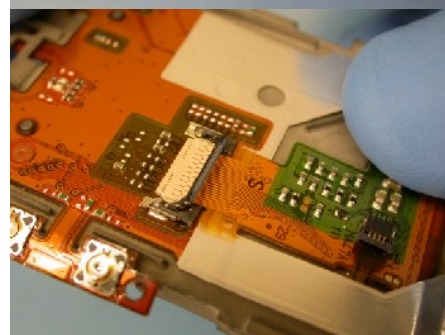
3. Use one hand to hold the LCD in its cavity while performing the following two steps.

**NOTE!** Before trying to insert the LCD assembly's flex film into its connector on the display flex film, make sure that the retaining bar on the display flex film's LCD connection is rotated towards the LCD assembly's flex film so that a 120 degree angle is formed between the retaining bar and the top of the connector.



4. Carefully insert the connection portion of the LCD assembly into the slot between the tan and black portions of connector on the display flex film. Push the LCD's connection into the connector until it will not insert any further.

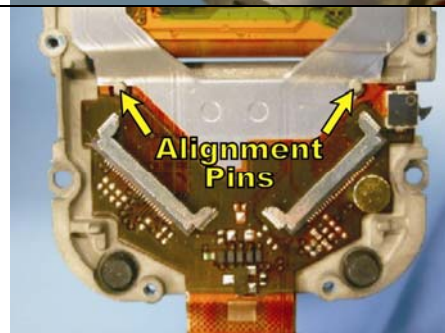
**NOTE!** Approximately 0.75MM of the gold contact portion of the LCD connection will be outside of the connector when the LCD's connection to the display flex film is properly assembled.



5. Rotate the retaining bar away from the LCD assembly's flex film and press it down against the display flex film until the retaining bar is flush with the rest of the connector.



6. Work the portion of the display flex film that contains the cable connections down onto the display carrier so that the two carrier alignment pins protrude through their corresponding holes in the display flex film assembly.

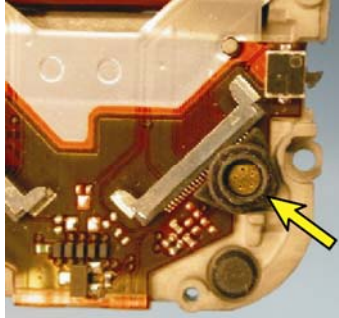
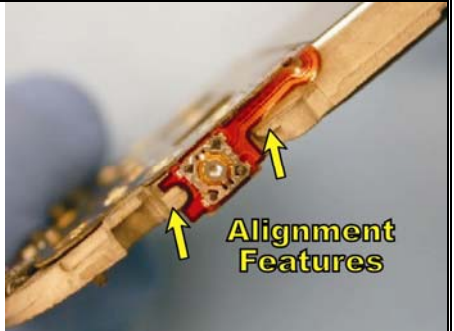


7. Rotate the portion of the display flex film where the navigation key dome foil attaches down onto the LCD side of the display carrier so that the two carrier alignment pins protrude through their corresponding holes in the display flex film assembly.







Step-by-Step Instructions	
8. Verify that the microphone grommet is installed over the microphone.	
9. Using the two alignment features associated with this switch, place the camera switch portion of the display flex film into its position on the side of the display carrier.	

- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.

## 4.33 Microphone

This part comes as part of the display flex film assembly. Therefore to replace this part, the entire display flex film assembly must be replaced. Refer to the “Display Flex Film Assembly and the Display Carrier” section for the instructions on replacing the display flex film assembly.



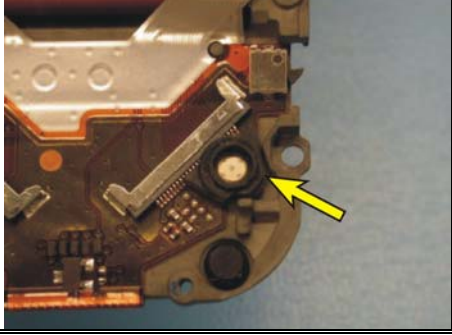


## 4.34 Microphone Grommet Replacement Procedure

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
1. Orient the display carrier assembly so that the display is away from you and locate the microphone assembly on the display flex film.	 A photograph showing the back of a display carrier assembly held by blue gloves. A yellow arrow points to a small component labeled 'Microphone Assembly' on the display flex film.
2. Using style 2A tweezers, remove the microphone grommet from the microphone assembly.	 A close-up photograph of the microphone assembly. A pair of tweezers is shown pulling a small, dark, circular grommet away from the assembly.
3. Obtain a new microphone grommet and mount it over the microphone by using the features in the microphone grommet and the features around the microphone to correctly position the grommet on the microphone.	 A close-up photograph of the microphone assembly. A yellow arrow points to a new, light-colored circular grommet being positioned over the microphone component.

- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 - 2.2.4 the Base Reassembly procedure.

## 4.35 Display Cover


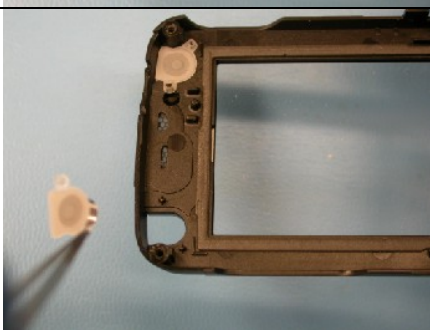
The removal and installation of this part is covered in the flip disassembly and reassembly procedures. If the display cover is the only part being replaced, only a portion of the disassembly and reassembly instructions needs to be performed. When replacing this part only, perform sections 3.1.2 - 3.1.3 of the flip disassembly to remove this part and perform sections 3.2.2 – 3.2.3 of the flip reassembly to install a new part. Before installing the new display cover, transfer the two gaming keys from the old part to the new one. Refer to the “Gaming Keys” section for detailed instructions on removing and reinstalling the gaming keys.

## 4.36 Gaming Keys

### 4.36.1 Gaming Key Removal

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)
- Perform sections 3.1.2 - 3.1.3 of the flip disassembly


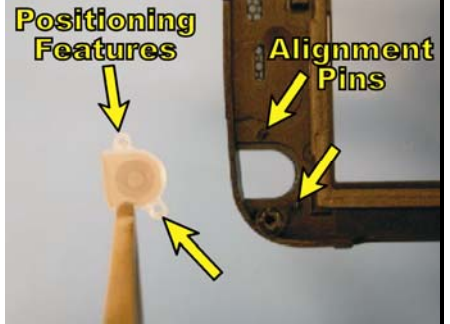

Step-by-Step Instructions	
1. Orient the display cover so that its inner surface is towards you.	
2. Using style 2A tweezers, catch a hold of the soft rubber portion of the gaming key that is being removed and lift the key from its opening in the display cover.	



## 4.36.2 Gaming Key Installation

### Tools needed:

- \* Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<ol style="list-style-type: none"><li>1. Make sure the display cover is oriented so that its inner surface is towards you.</li></ol>	
<p><b>NOTE!</b> The two gaming keys are different and thus a specific gaming key must be used depending on the location a gaming key is being installed.</p> <ol style="list-style-type: none"><li>2. Orient the key that is being installed so that the shape of the key corresponds to the shape of the key hole and make sure that the two positioning features in the soft rubber portion of the key corresponds to the two alignment pins around the key hole.</li></ol> <p><b>NOTE!</b> If the alignment features between the key and the display cover do not line up, you either have the wrong key or you are trying to insert the key in the wrong hole.</p>	
<ol style="list-style-type: none"><li>3. Insert the key into its key hole and press two positioning features of the key down onto their alignment pins.</li></ol>	

- Perform sections 3.2.2 – 3.2.3 of the flip reassembly

## 4.37 Navigation Keypad

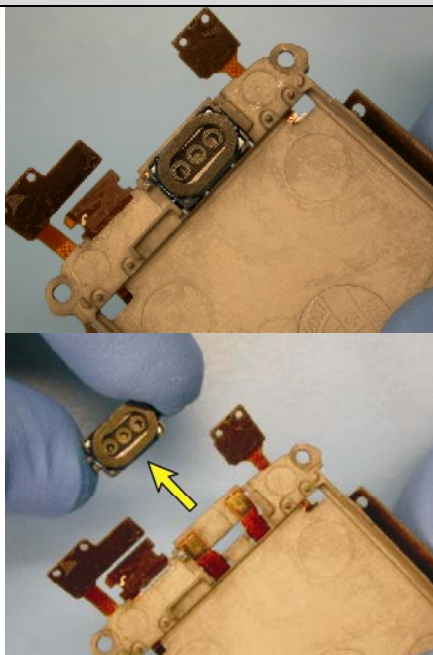
The navigation key and the keys surrounding the navigation key are all part of the navigation keypad. To remove the navigation keypad, perform sections 3.1.2 - 3.1.3 of the flip disassembly and remove the navigation keypad from the display carrier. To install this part, perform sections 3.2.2 – 3.2.3 of the flip reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions.

## 4.38 Receiver

### 4.38.1 Receiver Removal

**Tools needed:** None

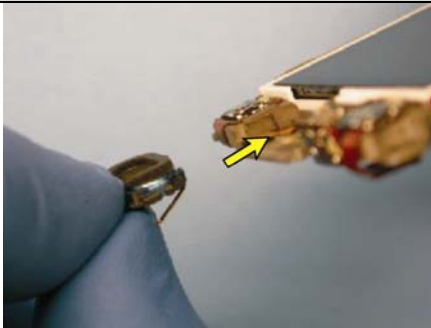
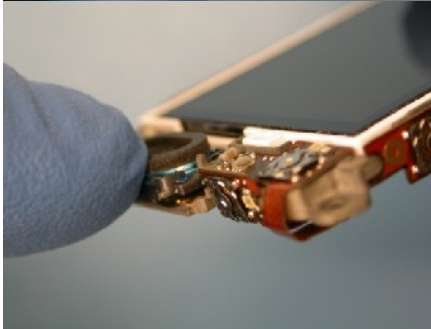

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure

<b>Step-by-Step Instructions</b>	
<ol style="list-style-type: none"> <li>1. Slide the receiver out of its slot in the display carrier by sliding it directly away from the LCD.</li> </ol>	



## 4.38.2 Receiver Installation

Tools needed:                      None

Step-by-Step Instructions	
<p>1. Orient the receiver relative to the display carrier's receiver cavity so that the side of the receiver with the dust gasket is away from the display carrier and receiver springs point away from the LCD assembly.</p>	
<p>2. From the top edge of the display carrier, slide the receiver into the receiver cavity so that the side edges of the receiver are under the ledges that run along each side of the receiver cavity.</p>	
<p><b>NOTE!</b>      There should not be a significant gap between the receiver and the LCD when the receiver is completely slid into its slot.</p>	

- Perform sections 3.2.1 – 3.2.4 of the flip reassembly.
- Perform sections 2.2.2 - 2.2.4 of the base reassembly.

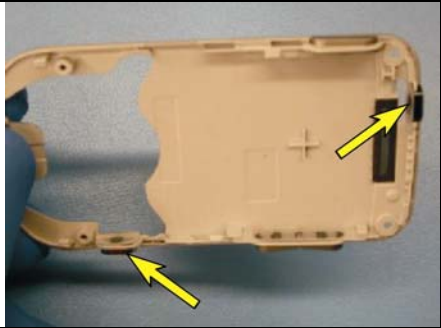
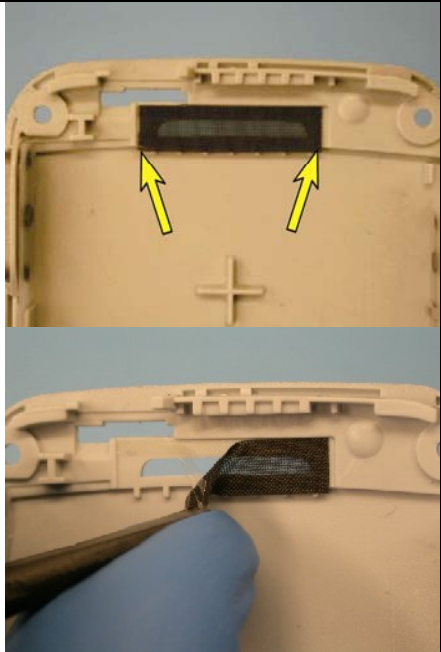
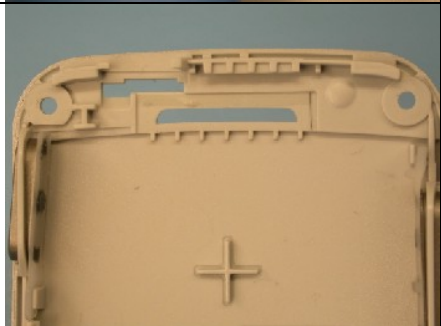


## 4.39 Receiver Dust Cloth on Inner Flip Cover



### Replacement Procedure

**Tools needed:**

- ESD Style 2A tweezers (Blunt tipped)
- Nylon pointer
- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure

Step-by-Step Instructions	
1. Due to the tendency for the power and camera key to fall out, remove them from the inner flip cover before proceeding.	
2. Using a nylon pointer, grip one of the two corners of the dust cloth indicated and peel the dust cloth from the inner flip cover.	
3. Carefully clean off any remaining adhesive residue from the area where the dust cloth mounts onto the inner flip cover using a pair of style 2A tweezers, alcohol, and a lint free wipe.	



Step-by-Step Instructions	
<p><b>NOTE!</b> Use tweezers to handle the new dust cloth once it has been separated from its protective backing so that contamination of its adhesive is avoided.</p> <p>4. Using tweezers, position the dust cloth in its recessed area so that the entire external opening is covered.</p>	
<p>5. Once the dust cloth is correctly positioned, carefully smooth it into place using the flat end of a nylon pointer.</p>	

- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 – 2.2.4 of the Base Reassembly Procedure



## 4.40 Style-Up Cover

The removal and installation of this part is covered in the flip disassembly and reassembly procedures. To remove this part, perform section 3.1.2 of the flip disassembly. To install this part, perform section 3.2.3 of the flip reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions.

## 4.41 Inner Flip Cover


The removal and installation of this part is covered in the flip disassembly and reassembly procedures. To remove this part, perform sections 2.1.1 - 2.1.3 of the base disassembly and then perform sections 3.1.1 – 3.1.4 of the flip disassembly. To install this part, perform sections 3.2.1 - 3.2.4 of the flip reassembly and then perform sections 2.2.2 - 2.2.4 of the base reassembly. If this part is being replaced, a new part should be used in the place of the old part when performing the reassembly instructions. Using a new inner flip cover requires that the power key, the camera key, the volume key, and the music player key be transferred from the old inner flip cover to the new one before performing the reassembly procedure. If there is any question as to how to transfer any of the keys that have to be moved, refer to the section for the specific key in question.

## 4.42 Camera Key

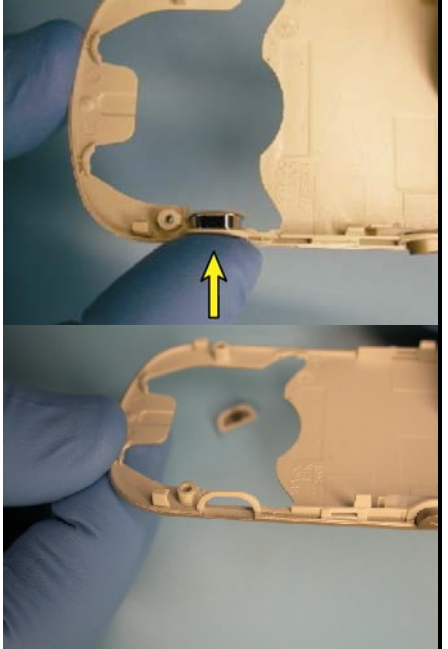
### 4.42.1 Camera Key Removal

**Tools needed:** None

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure


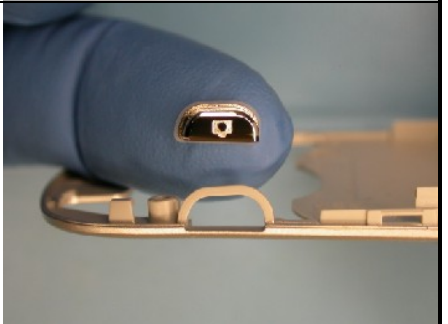
Step-by-Step Instructions	
<p><b>NOTE!</b> The camera key and the power key fall out very easily and may have fallen out of place during the removal of the display carrier assembly.</p> <p>1. Orient the inner flip cover so that its inner surface is towards you and locate the camera key.</p>	



Step-by-Step Instructions	
2. Push on the camera key's exterior surface until the key separates from the inner flip cover.	

#### 4.42.2 Camera Key Installation

Tools needed: None

Step-by-Step Instructions	
<p><b>NOTE!</b> Due to the ease in which these keys fall out, the camera key and the power key should be installed just before the display carrier assembly and the inner flip cover are reassembled.</p>	
1. Locate the camera key opening on the edge of the inner flip cover.	
2. Orient the camera key so that the shape of the key corresponds to the shape of its opening in the inner flip cover.	

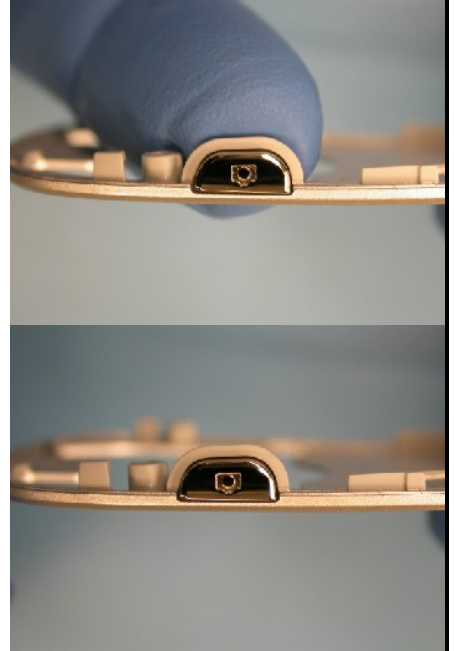




### Step-by-Step Instructions

3. Insert the key into its opening so that the external surface of the key is towards the outer edge of the inner flip cover.

**NOTE!** Make sure camera key does not fall out before the display carrier assembly and the inner flip cover can be reassembled.



- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 – 2.2.4 of the Base Reassembly Procedure


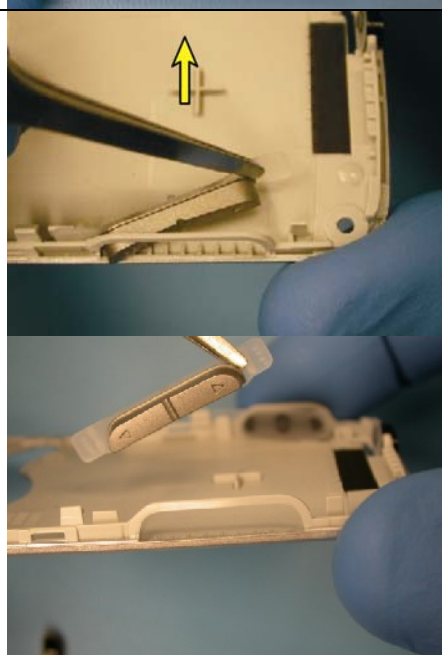


## 4.43 Volume Key

### 4.43.1 Volume Key Removal

**Tools needed:**


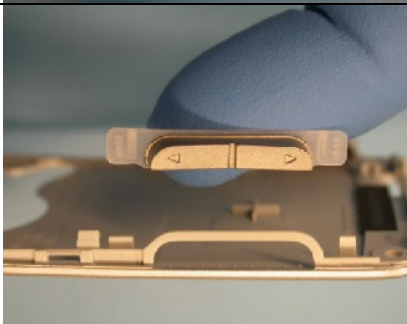
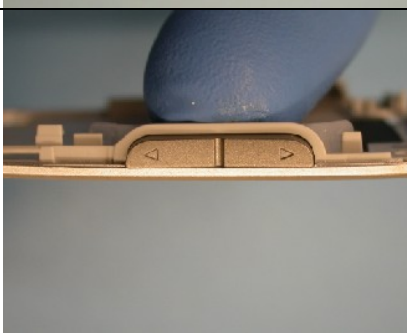
- Style 2A ESD tweezers (Blunt tip)
- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure

Step-by-Step Instructions	
1. Orient the inner flip cover so that its inner surface is towards you and locate the volume key.	
2. Using style 2A tweezers, grab one of the soft rubber portions that extend from each end of the key and pull the key towards the middle of the inner flip cover until the key comes free for the inner flip cover.	

## 4.43.2 Volume Key Installation

### Tools needed:

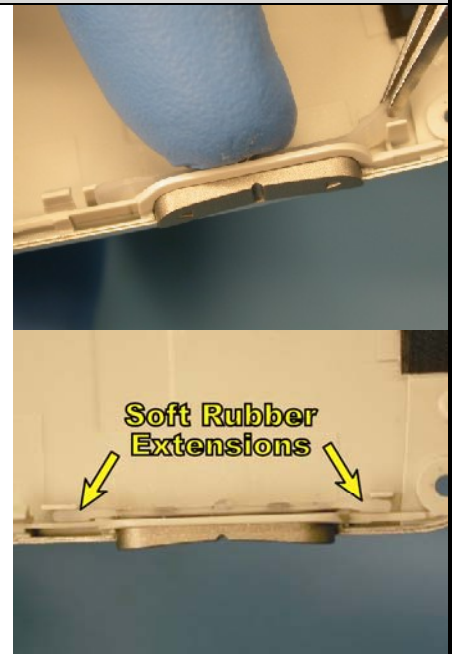
- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
1. Locate the volume key opening on the edge of the inner flip cover.	
2. Orient the volume key so that the shape of the key corresponds to the shape of its opening in the inner flip cover.	
3. Insert the key into its opening so that the external surface of the key is towards the outer edge of the inner flip cover and hold the key in place using a finger.	



### Step-by-Step Instructions

4. While holding the volume key in place, use a pair of style 2A tweezers and work the soft rubber portion that extend from each end of the volume key between the standoff and the side wall at each end of the volume key.



- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 – 2.2.4 of the Base Reassembly Procedure


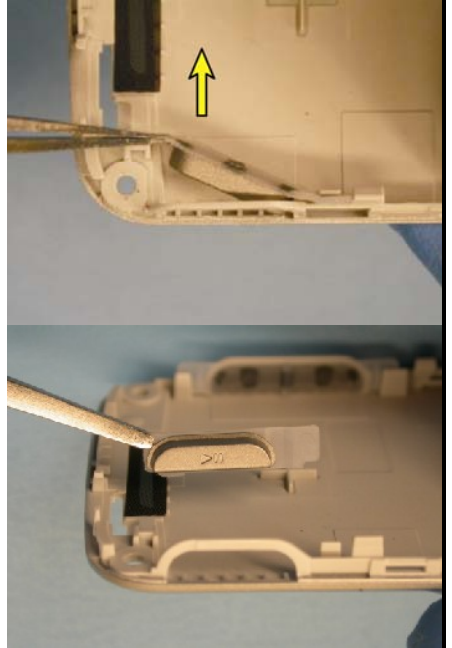


## 4.44 Music Player Key

### 4.44.1 Music Player Key Removal

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)
- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure


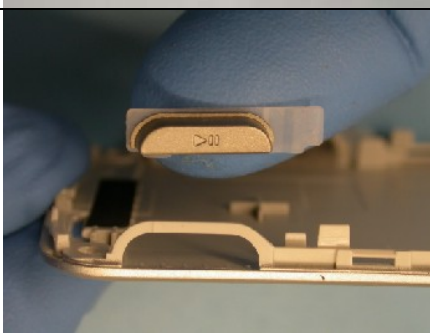

Step-by-Step Instructions	
1. Orient the inner flip cover so that its inner surface is towards you and locate the music player key.	
2. Using style 2A tweezers, grab the soft rubber portion of the key and pull the key towards the middle of the inner flip cover until the key comes free for the inner flip cover.	



#### 4.44.2 Music Player Key Installation

**Tools needed:**

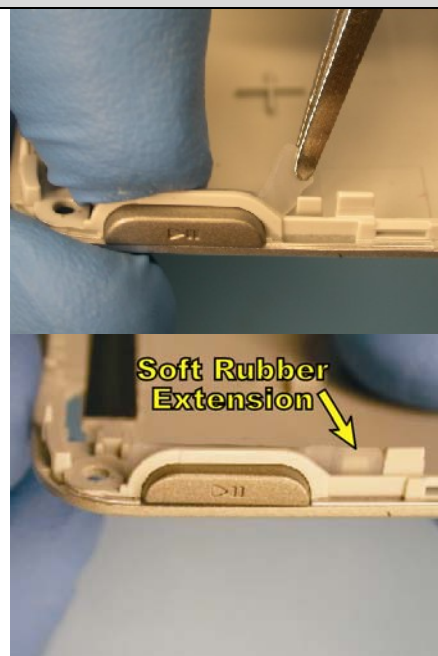
- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
1. Locate the music player key opening on the edge of the inner flip cover.	
2. Orient the music player key so that the shape of the key corresponds to the shape of its opening in the inner flip cover.	
3. Insert the key into its opening so that the external surface of the key is towards the outer edge of the inner flip cover and hold the key in place using a finger.	



### Step-by-Step Instructions

4. While holding the music player key in place, use a pair of style 2A tweezers and work the soft rubber portion that extends from one end of the key between the standoff and the side wall at that end of the key.



- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 – 2.2.4 of the Base Reassembly Procedure


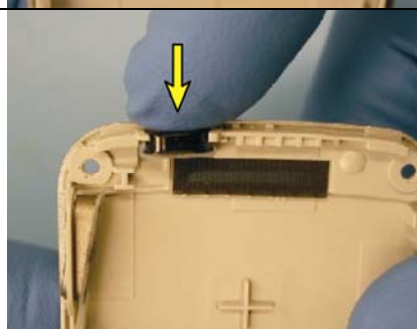



## 4.45 Power Key

### 4.45.1 Power Key Removal

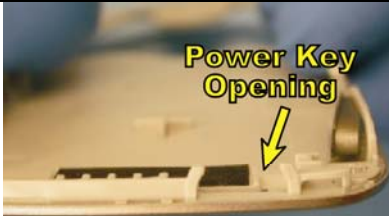
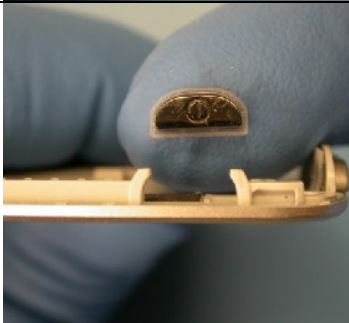


**Tools needed:** None

- Perform sections 2.1.1 - 2.1.3 of the Base Disassembly Procedure
- Perform sections 3.1.1 - 3.1.4 of the Flip Disassembly Procedure

Step-by-Step Instructions	
<p><b>NOTE!</b> The camera key and the power key fall out very easily and may have fallen out of place during the removal of the display carrier assembly.</p> <ol style="list-style-type: none"><li>1. Orient the inner flip cover so that its inner surface is towards you and locate the power key.</li></ol>	
<ol style="list-style-type: none"><li>2. Push the exterior portion of the power key towards the middle of the inner flip cover until the key separates from the inner flip cover.</li></ol>	 

## 4.45.2 Power Key Installation

**Tools needed:** None

Step-by-Step Instructions	
<p><b>NOTE!</b> Due to the ease in which these keys fall out, the camera key and the power key should be installed just before the display carrier assembly and the inner flip cover are reassembled.</p> <p>1. Locate the power key opening on the top edge of the inner flip cover.</p>	
<p>2. Orient the power key so that the shape of the key corresponds to the shape of its opening in the inner flip cover.</p>	
<p>3. Insert the key into its opening so that the external surface of the key is towards the outer edge of the inner flip cover.</p> <p><b>NOTE!</b> Make sure power key does not fall out before the display carrier assembly and the inner flip cover can be reassembled.</p>	 

- Perform sections 3.2.1 - 3.2.4 of the Flip Reassembly Procedure
- Perform sections 2.2.2 – 2.2.4 of the Base Reassembly Procedure

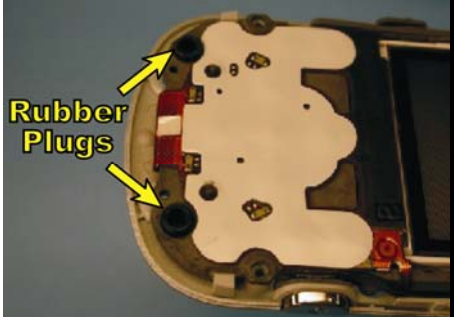
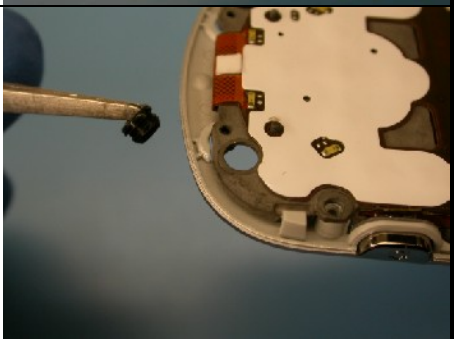

## 4.46 Rubber Plug

### Replacement Procedure

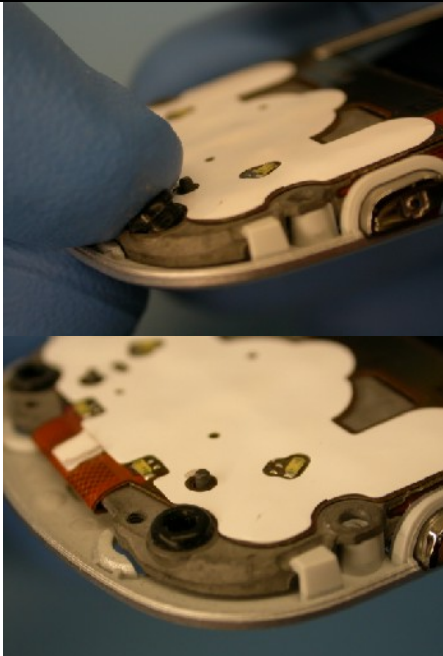
- Perform sections 3.1.2 - 3.1.3 of the Flip Disassembly Procedure.

**Tools needed:**

- Style 2A ESD tweezers (Blunt tip)

Step-by-Step Instructions	
<ol style="list-style-type: none"> <li>1. Orient the phone so that the display is towards you.</li> <li>2. Locate the two round rubber plugs at the bottom of the display carrier.</li> </ol>	
<ol style="list-style-type: none"> <li>3. Using style 2A tweezers, remove the rubber plug(s) that needs replacement.</li> </ol>	
<ol style="list-style-type: none"> <li>4. Obtain a new rubber plug and orient it so that the end of the plug with the hole in it is pointed away from the display carrier.</li> </ol>	



Step-by-Step Instructions	
<p>5. Insert the rubber plug in display carrier's unoccupied plug hole and press the plug down into the hole.</p> <p><b>NOTE!</b> When the plug is installed correctly, the visible portion of the plug should appear round in shape.</p> <p>6. If both rubber plugs are being replaced, repeat the previous two steps to install the other rubber plug.</p>	

- Perform sections 3.2.2 - 3.2.3 of the Flip Reassembly Procedure

## 5 Revision History

Rev.	Date	Changes / Comments
A	2005-Sept. 13	<ul style="list-style-type: none"> <li>• Initial Release</li> </ul>
B	2005-Oct. 5	<ul style="list-style-type: none"> <li>• Added a comment to the rear speaker module installation section regarding the need to install an RF absorber when installing a new rear speaker module in a W600 product.</li> </ul>