



Working Instruction, Mechanical

Applicable for M600i

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1 Introduction

M600i (crystal white)



M600i (granite black)



1.1 Equipment

SPECIAL TOOLS

- NTZ 122 459 Torque screwdriver (or equivalent)
- NTZ 122 288 Torx bit no 6
- NTZ 112 1052 JCIS bit
- NTZ 122 521 Flex film assembly tool
- NTZ 122 302/2 Front opening tool



STANDARD TOOLS

- Dentist hook
- Blunt pair of tweezers
- Guitar pick



ESD EQUIPMENT

Protect the phone from ESD damages whenever it has been opened by using:

- ESD-wristband
- ESD-gloves



LABEL EQUIPMENT

The following special equipment is required when replacing or installing a new label:

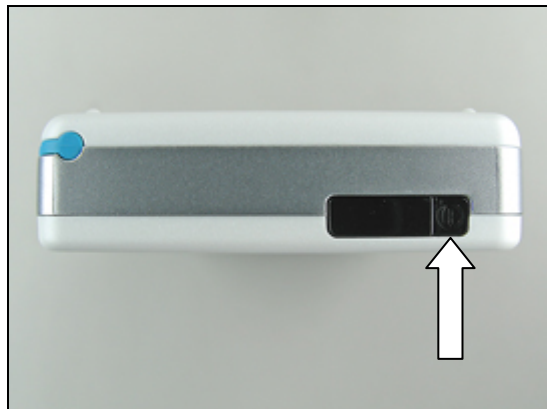
- Hot air flow solder station
- Zebra printer connected to computer



1.2 General cautions

The following cautions are considered to be generic for all phone models and will not be repeated in the Disassembly, Replacements and Reassembly sections:

SWITCH OFF THE PHONE BEFORE THE START OF THE DISASSEMBLY!



REMOVE ANY MEMORY STICK BEFORE THE START OF THE DISASSEMBLY!

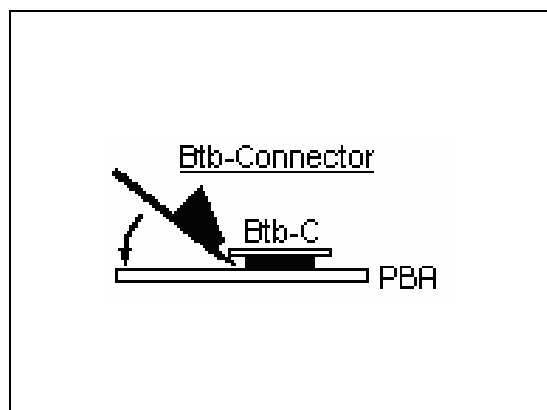


KEEP ALL CONTACT SURFACES CLEAN!

BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, OPENING TOOLS, GUITAR PICK ETC. TO AVOID SCRATCHES OR DAMAGES TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!

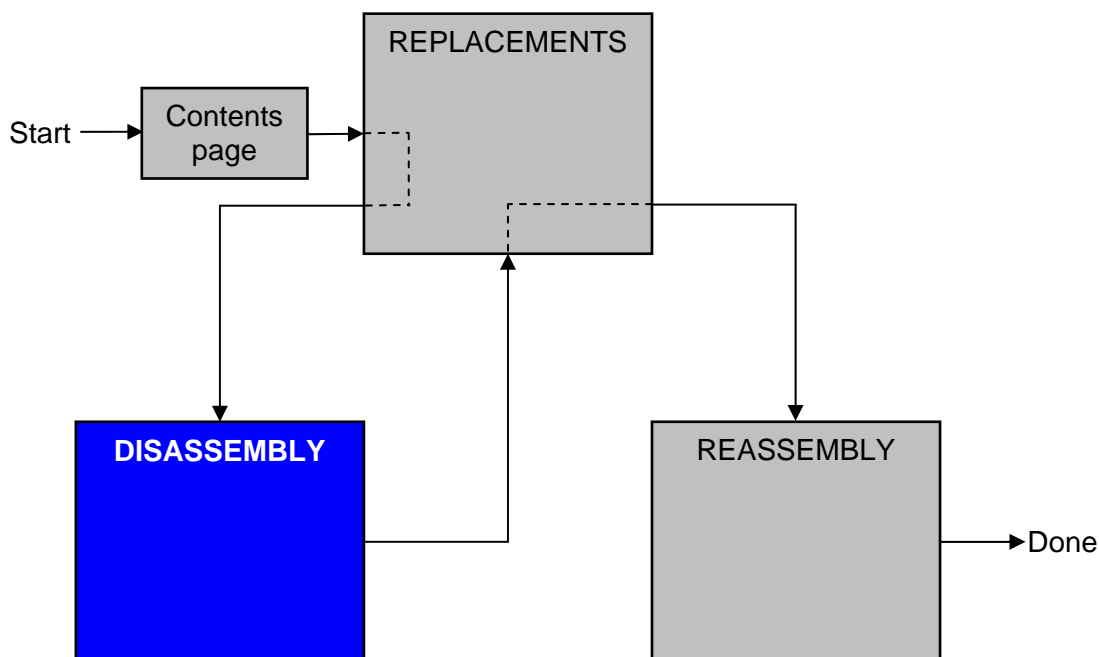
1.3 Recurrent repair actions

Use the front open tool to open the board-to-board connectors like this.



2 Disassembly

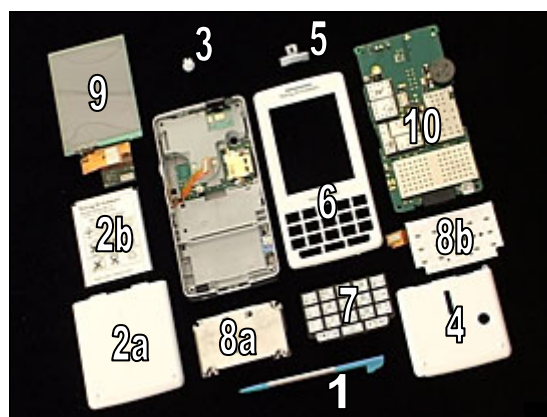
When you are going to replace a part being listed in *Replacements*, the instruction of that section usually begins by directing you to this *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before returning to *Replacements* for the actual replacement.



2.1 Overview

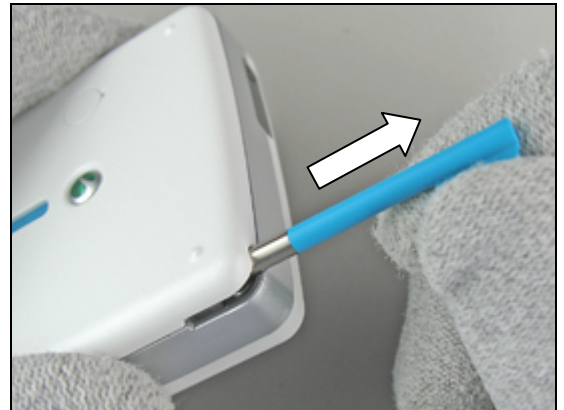
The disassembly is done in the following sequence:

1. Pen Stylus
2. Battery Lid (a) & Battery (b)
3. External Antenna Cap
4. Antenna Lid
5. Cap MS
6. Front Sub
7. Keyboard QWERTY
8. Keyboard Support (a) & Flex Film, Keyboard (b)
9. LCD
10. PBA



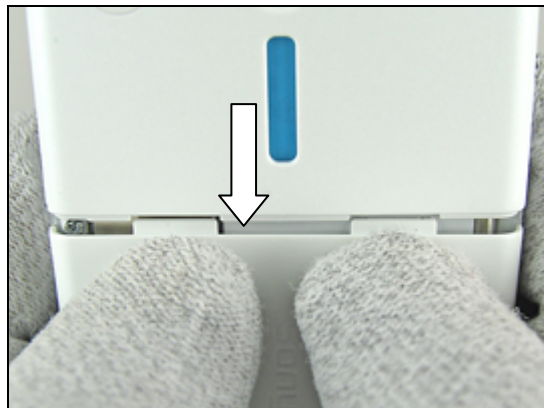
2.1.1 Pen Stylus asm

Remove the *pen stylus* with your fingers.

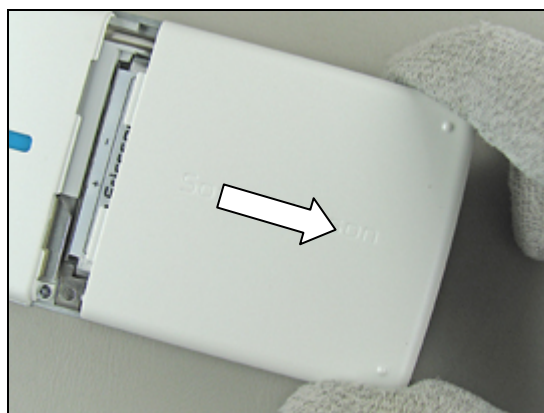


2.1.2 Battery Lid & Battery

Press on the *battery lid* until you get a gap.



Slide the *battery lid* towards the bottom of the phone and remove it.



Release the *battery* from the phone by lifting it up at the bottom.

If not released, turning the phone around at the same time will make it become released.

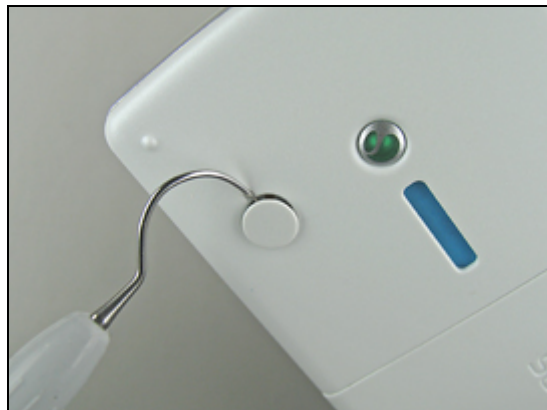


Remove the *battery*.



2.1.3 External Antenna Cap

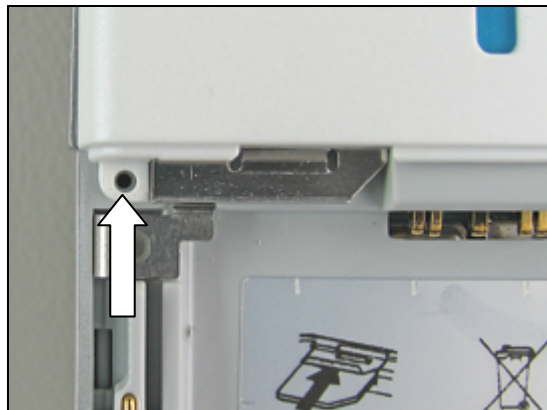
Remove the *external antenna cap* with a dentist hook.



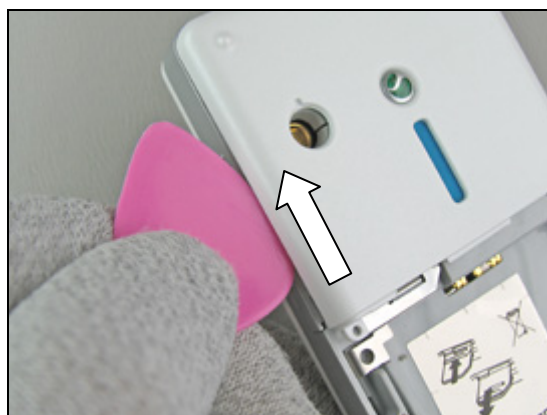
2.1.4 Antenna Lid asm

Remove the screw from the *antenna lid* by using the JCIS bit.

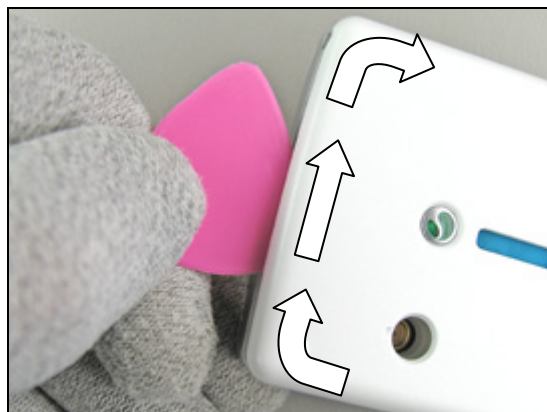
THE SCREW CAN BE REUSED ONLY IF IT IS NOT DAMAGED!



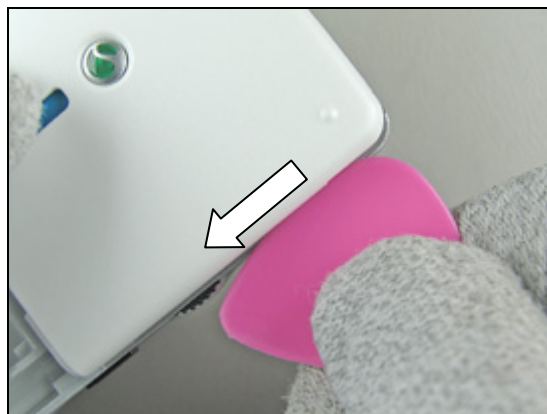
Gently but firmly move the guitar pick up and along the gap (starting at the screw hole) until the *antenna lid* is released on this side.



Continue up and around the corner and forward on until the top is released as well.

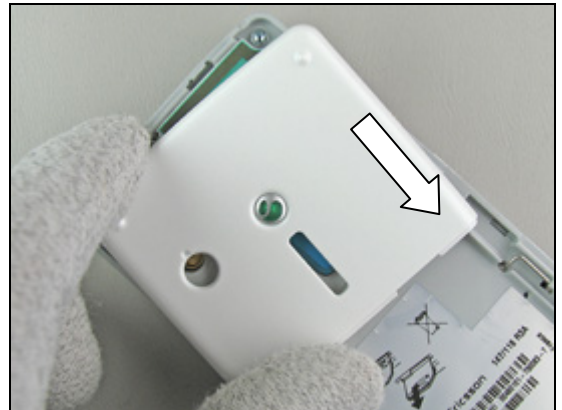


Continue down this side until the *antenna lid* is released on all three sides.

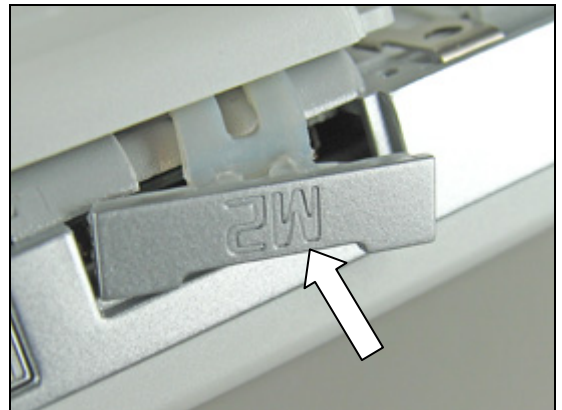


Antenna Lid asm *continued*

Start to slide down the corner where the arrow is located, and then remove the *antenna lid*.



When the *antenna lid* is removed, the *cap MS* may fall out of the phone.



Antenna lid removed.



2.1.5 Cap MS

Remove the *cap MS* with the tweezers or your fingers.



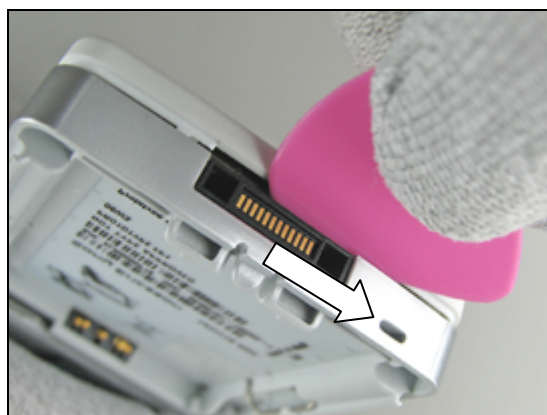
2.1.6 Front Sub asm

Remove the four inside screws from the *frame* by using torx bit no. 6.

REMOVED SCREWS CANNOT BE REUSED AND MUST BE SCRAPPED!



Gently but firmly move the guitar pick along the gap (starting at the system connector) until the *front sub* is released on this side.



Continue around the corner and along this side.



Continue forward (the next snap hook to be released is placed right in the middle of the phone).



Front Sub asm *continued*

Unhook the snap hook on the top right side of the phone.
The right hand side of the *front sub* is now released.

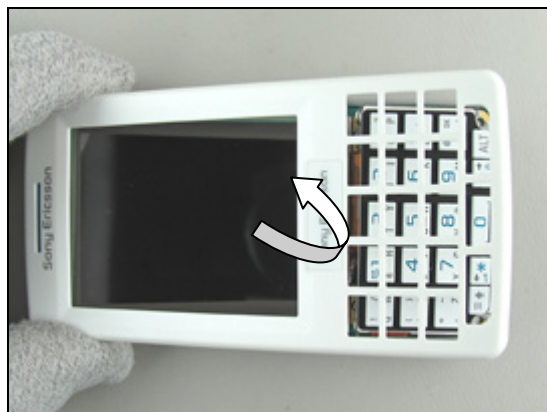


Do the same thing on the left hand side (starting at the *system connector*) and repeat all steps above.



**DO NOT BEND THE FRONT SUB TO MUCH UPWARDS AS THIS
CAN CAUSE SERIOUS DAMAGE TO THE FRONT SUB!**

Gently lift the *front sub* (starting the lift at the *keyboard qwerty*) and remove it.



Front sub removed.



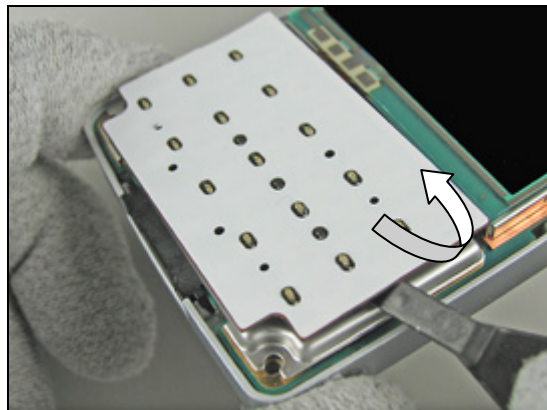
2.1.7 Keyboard QWERTY

Remove the *keyboard qwerty* by hand.

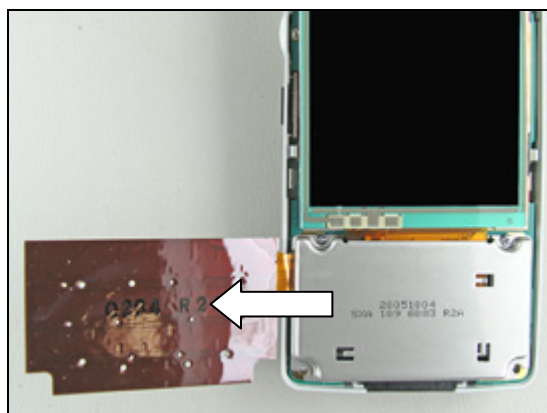


2.1.8 Keyboard Support asm & Flex Film asm, Keyboard

Gently bend under the *flex film, keyboard* with the front opening tool until it becomes released.

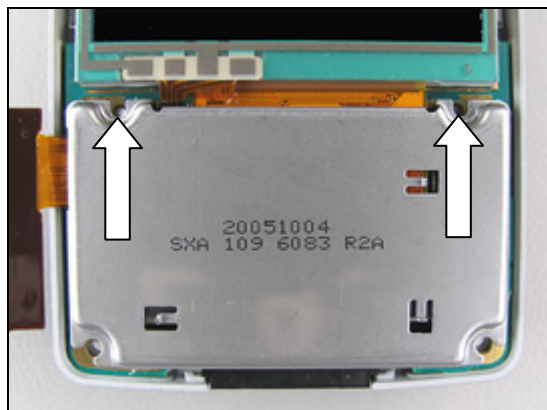


Turn the *flex film, keyboard* to the left.



Remove the two screws from the *keyboard support* by using the JCIS bit.

REMOVED SCREWS CAN BE REUSED ONLY IF THEY ARE NOT DAMAGED!

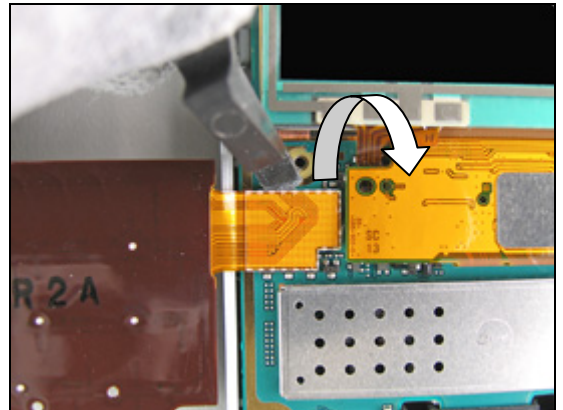


Remove the *keyboard support* with the tweezers or by hand.

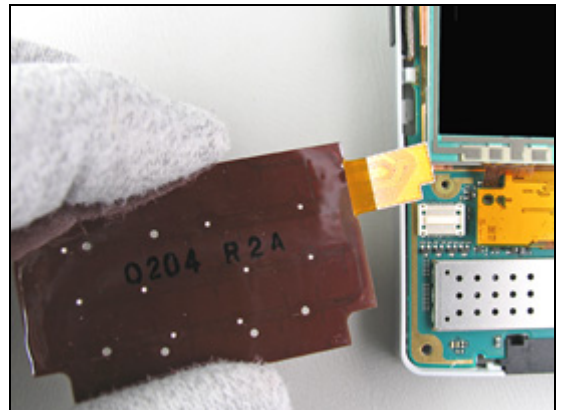


Keyboard Support asm & Flex Film asm, Keyboard *continued*

Use the front opening tool to disconnect the *flex film*, *keyboard* from the *PBA*.

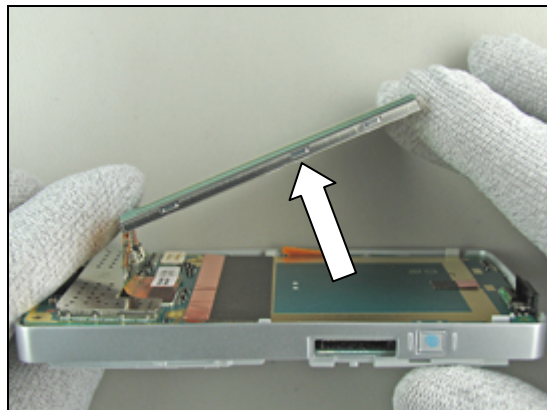


Remove the *flex film*, *keyboard*.



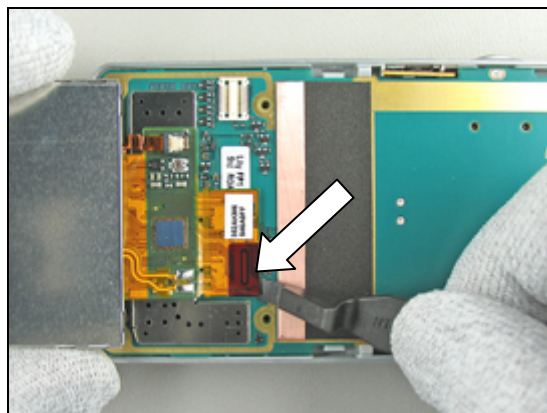
2.1.9 LCD

Turn the *LCD* 180° from the *PBA* by hand.

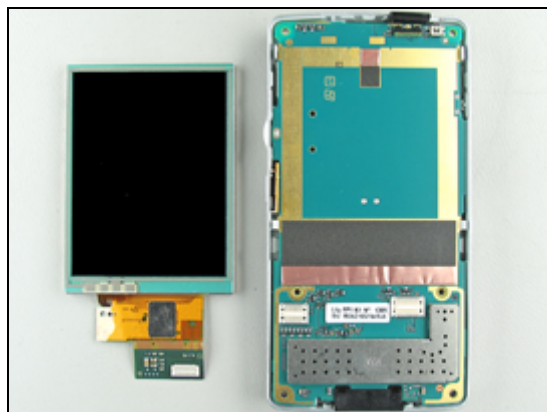


HANDLE THE LCD FLEX FILM WITH CARE!

Gently bend with the front opening tool under the *LCD*'s board-to-board connector until the *LCD* becomes disconnected from the *PBA*.

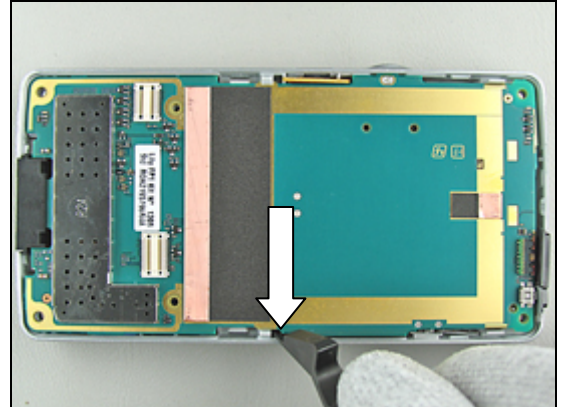


LCD removed.

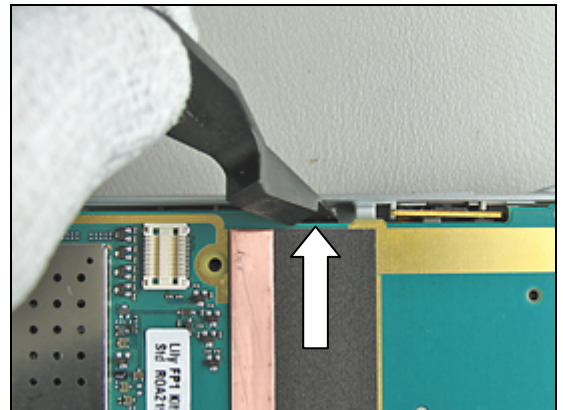


2.1.10 PBA

Gently bend with the front opening tool under the *PBA* until it is released on this side of the phone.



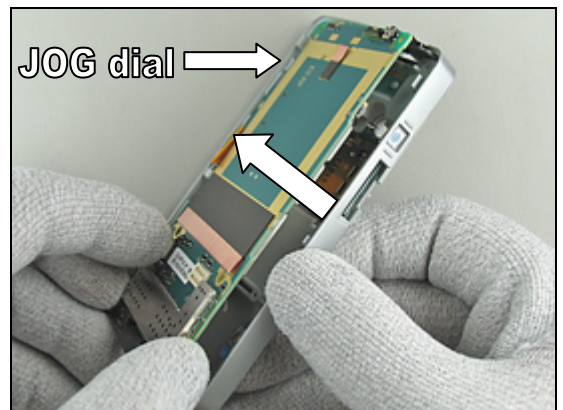
Bend under the *PBA* on the opposite side until it is released from the *frame* on this side as well.



BE MOST CAREFUL WITH THE JOG DIAL WHEEL WHEN THE PBA SEPARATES FROM THE FRAME!

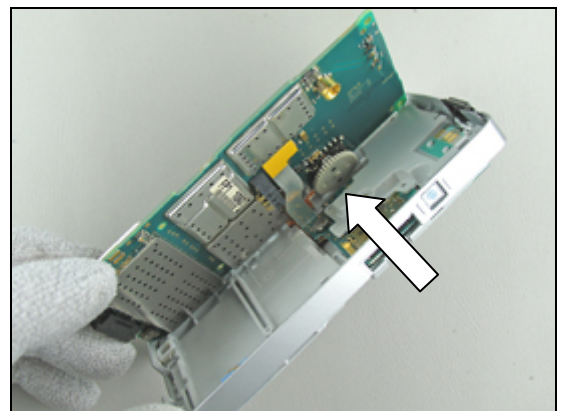
DON'T BEND THE PBA TOO MUCH UPWARDS SINCE THE WHEEL EASILY BREAKS APART!

Gently start to remove the *PBA*.
If necessary, gently wiggle the *PBA* side to side while turning it away from the *frame*.



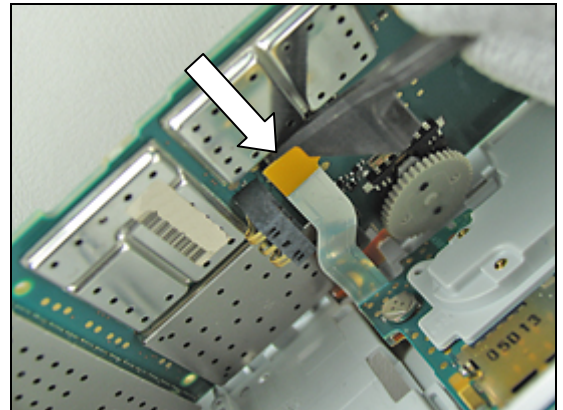
BE CAREFUL WITH THE JOG DIAL WHEEL!

Continue turning the *PBA* and stop at an angle of approx. 40 °.

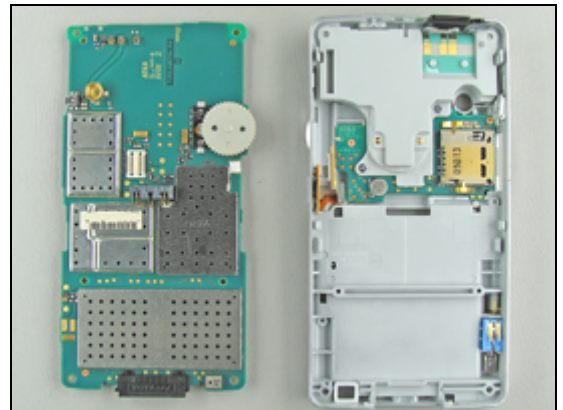


PBA continued

Start to bend with the front opening tool under the *SIM PWB* board-to-board connector until it becomes disconnected from the *PBA*.



PBA removed.



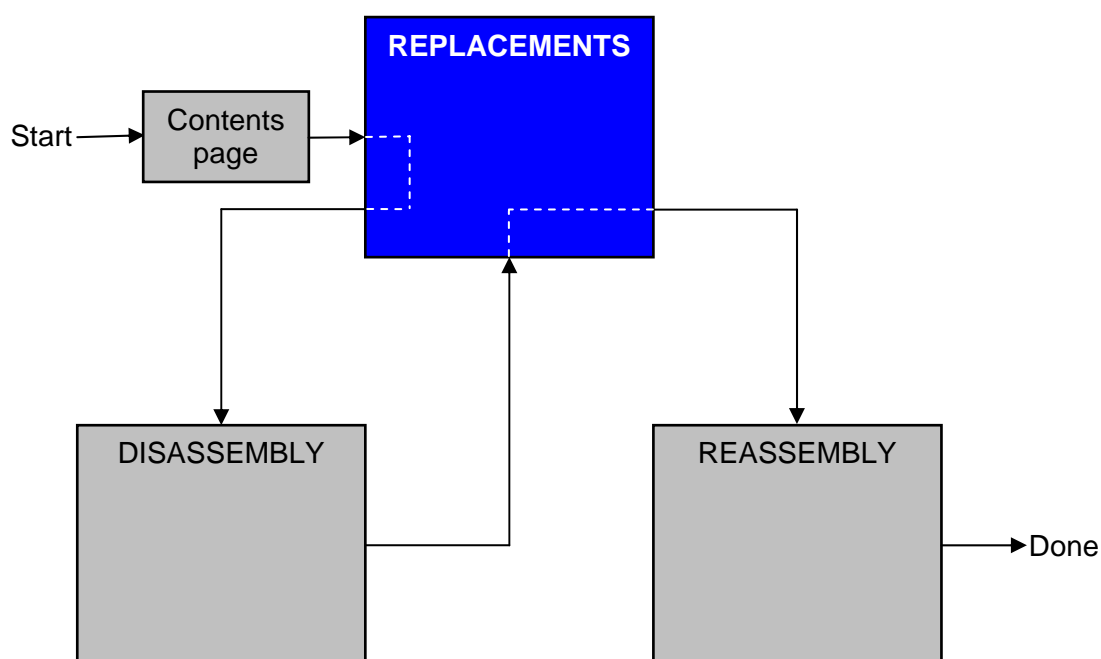
3 Replacements

Search for the part to be replaced on the Contents page and go to that instruction to be found in this *Replacements* section.

The instruction usually begins by directing you to the *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before the actual replacement.

Go back to this *Replacements* section and carry out the instruction.

The instruction usually ends by directing you to the *Reassembly* section with a specification of the instructions you have to carry out in order to reassemble the phone.



3.1 Pen Stylus asm

Follow the 2.1.1 Disassembly instructions!

Prepare the new *pen stylus*.

Follow the 4.1.10 Reassembly instructions!

3.2 Battery Lid

Follow the 2.1.2 Disassembly instructions!

Prepare the new *battery lid*.

Follow the 4.1.9 Reassembly instructions!

3.3 External Antenna Cap

Follow the 2.1.3 Disassembly instructions!

Prepare the new *external antenna cap*.

Follow the 4.1.8 Reassembly instructions!

3.4 Antenna Lid asm

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

Prepare the new *antenna lid*.

Follow the 4.1.7 – 4.1.10 Reassembly instructions!

3.5 Cap MS

Follow the 2.1.1 – 2.1.5 Disassembly instructions!

Prepare the new *cap MS*.

Follow the 4.1.6 – 4.1.10 Reassembly instructions!

3.6 Front Sub asm

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

Prepare the new *front sub*.

Follow the 4.1.5 – 4.1.10 Reassembly instructions!!

3.7 Keyboard QWERTY

Follow the 2.1.1 – 2.1.7 Disassembly instructions!

Prepare the new *keyboard*.

Follow the 4.1.4 – 4.1.10 Reassembly instructions!

3.8 Keyboard Support asm

Follow the 2.1.1 – 2.1.8 Disassembly instructions!

Prepare the new keyboard support.

Follow the 4.1.3 – 4.1.10 Reassembly instructions!

3.9 Flex Film asm, Keyboard

Follow the 2.1.1 – 2.1.8 Disassembly instructions!

Prepare the new flex film, keyboard.

Follow the 4.1.3 – 4.1.10 Reassembly instructions!

3.10 LCD

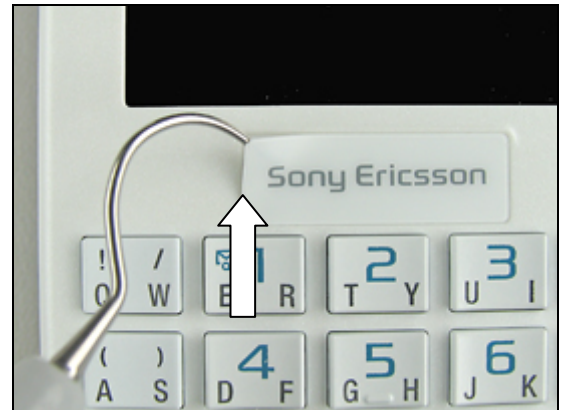
Follow the 2.1.1 – 2.1.9 Disassembly instructions!

Prepare the new LCD.

Follow the 4.1.2 – 4.1.10 Reassembly instructions!

3.11 Co-Brand Label

Gently remove the old *co-brand label* with a dentist hook.

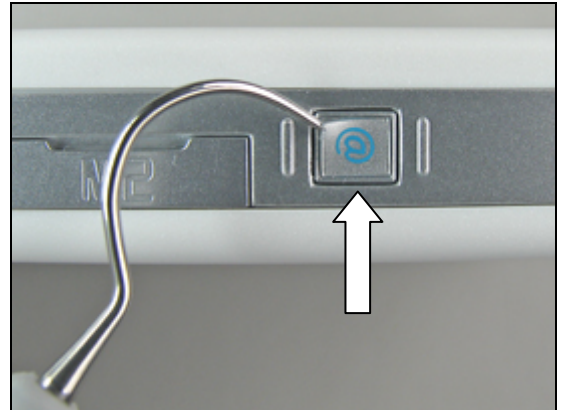


Attach a new *co-brand label* with the tweezers or by hand. Keep the pressure on for a few seconds to secure a good attachment.



3.12 Co-Brand Sticker

Gently remove the old *co-brand sticker* with a dentist hook.



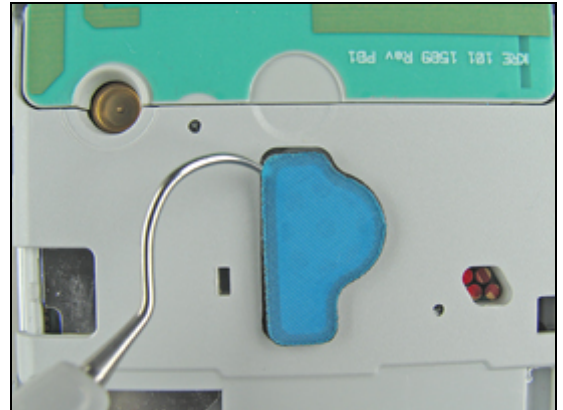
Attach a new *co-brand sticker* with the tweezers or by hand. Keep the pressure on for a few seconds to secure a good attachment.



3.13 Net, Loudspeaker

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

Remove the old *net, loudspeaker* with a dentist hook.



Attach a new *net, loudspeaker* with the tweezers.

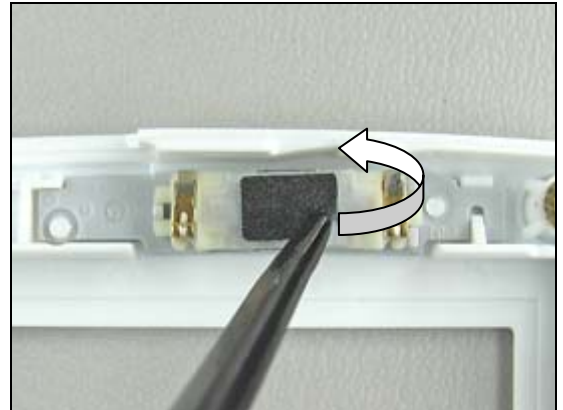
Follow the 4.1.7 – 4.1.10 Reassembly instructions!



3.14 Earspeaker Cushion

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

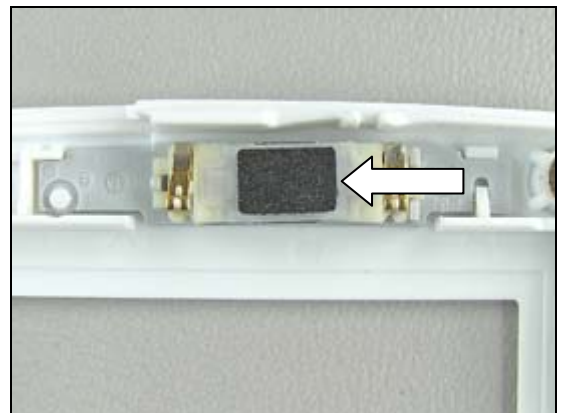
Remove the *earspeaker cushion* with the tweezers.



DO NOT TOUCH OR BEND THE CONTACT SPRINGS!

Attach a new *earspeaker cushion* with the tweezers.

Follow the 4.1.5 – 4.1.10 Reassembly instructions!

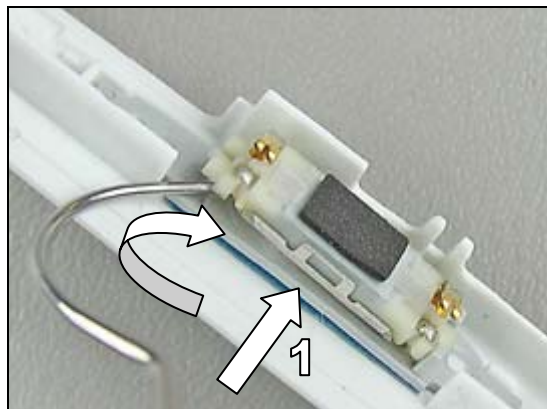


3.15 Earspeaker

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

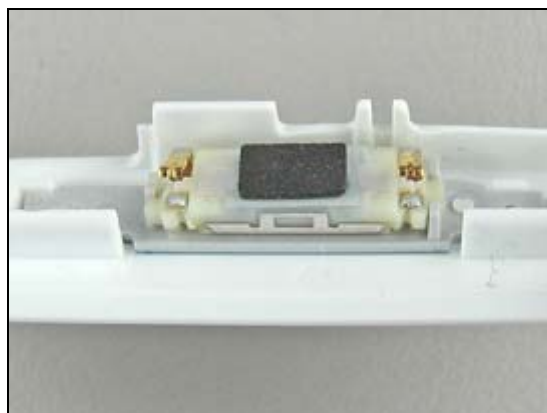
DO NOT REMOVE THE EARSPEAKER HOLDER (1)!

Start to bend the old *earspeaker* upwards with the dentist hook and remove it with your fingers.



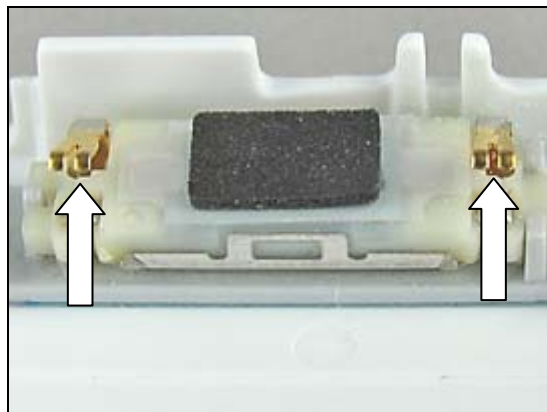
DO NOT TOUCH OR BEND THE CONTACT SPRINGS!

Press gently on each side of the new *earspeaker* with the tweezers and hold it for a few seconds to secure a good attachment.



Check that the contact springs are not bent or damaged but look like in the picture.

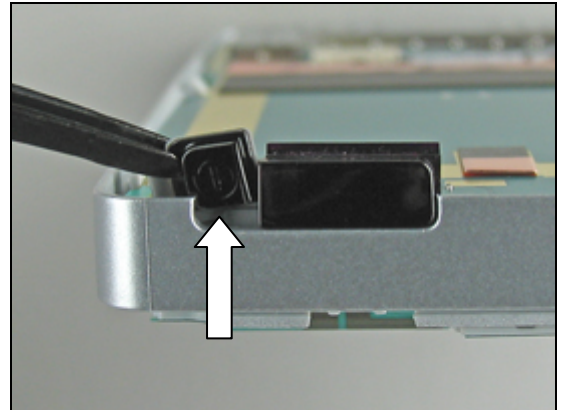
Follow the 4.1.5 – 4.1.10 Reassembly instructions!



3.16 On/Off Key

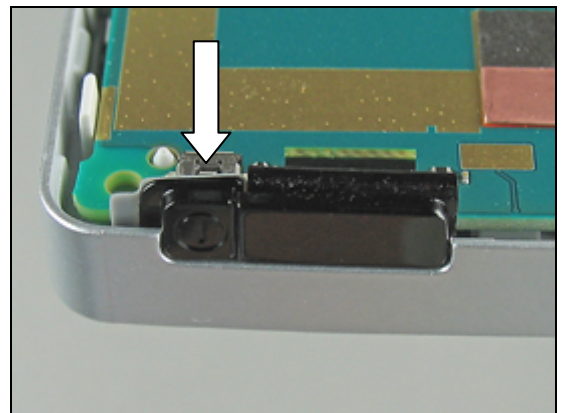
Follow the 2.1.1 – 2.1.6 Disassembly instructions!

Remove the old *on/off* key with the tweezers.



Insert a new *on/off* key into the *frame* with the tweezers.

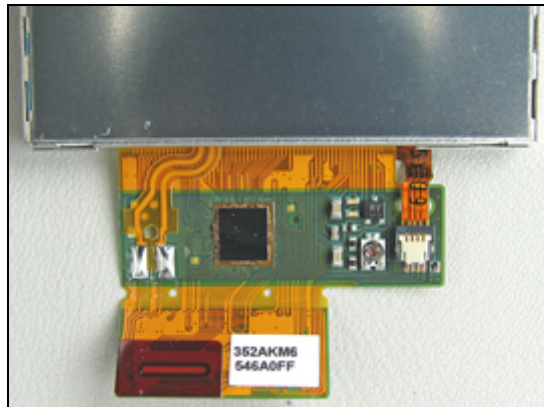
Follow the 4.1.5 – 4.1.10 Reassembly instructions!



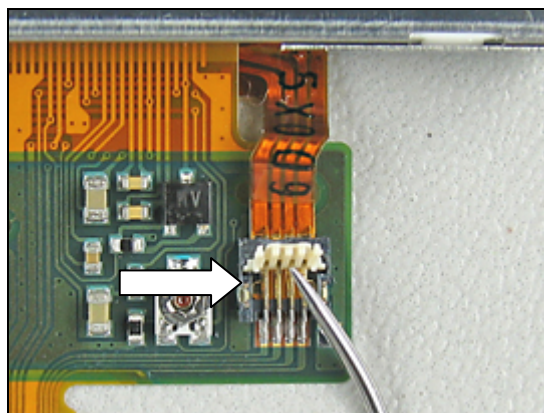
3.17 Touch Panel with Frame

Follow the 2.1.1 – 2.1.9 Disassembly instructions!

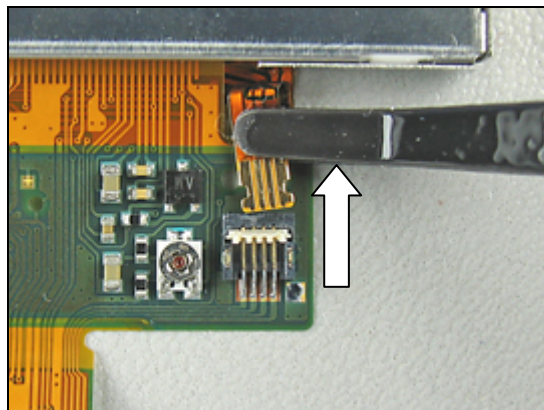
Place the *LCD* like this.



Open the FPC connector with the dentist hook.



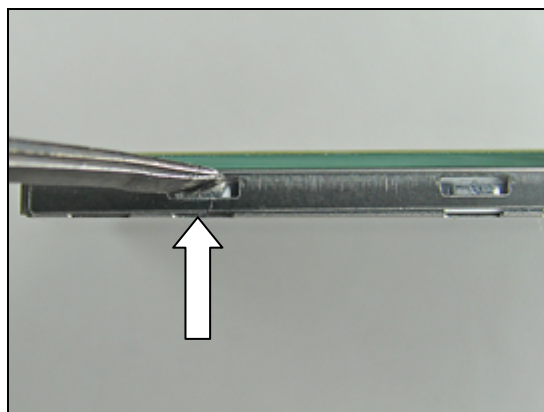
Disconnect the *touch panel* flex film with the flex film assembly tool.



Use the tweezers, or a small screwdriver, to detach the *touch panel* from the *LCD*.

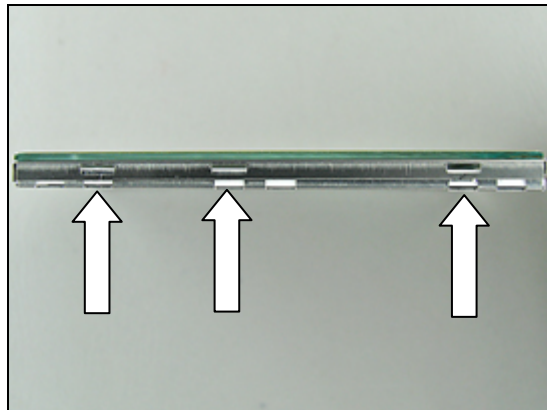
Start by pressing on one of the three small hooks that secures the *touch panel* to the *LCD*.

Continue until all three become released on this side.

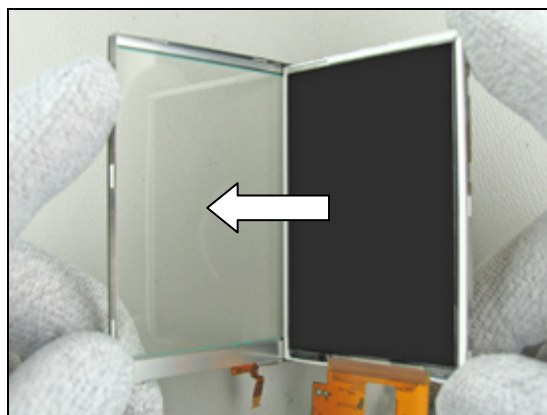


Touch Panel with Frame *continued*

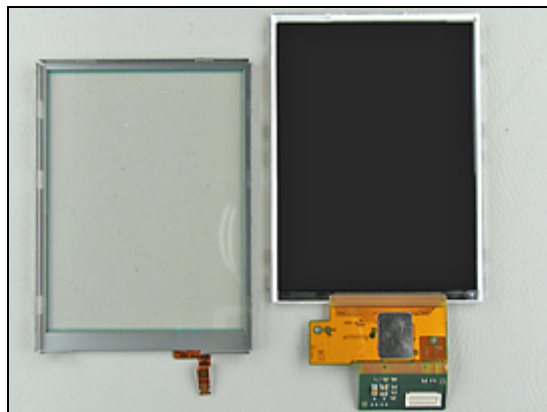
Continue to detach the other three hooks on the opposite side (six hooks in total on the *LCD* unit) until the *touch panel* is released on all sides.



Remove the *touch panel* by hand.



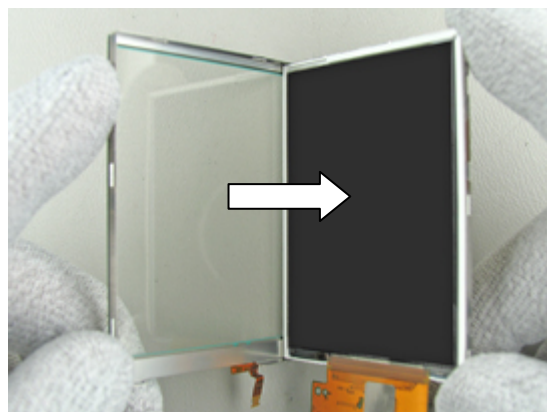
Touch panel removed.



Turn the new *touch panel* onto the *LCD* screen.

DO NOT TOUCH THE INSIDE OF THE TOUCH PANEL OR THE LCD SURFACE!

REMOVE ANY DUST WITH AN IONIZED AIRGUN OR A BLOWER!



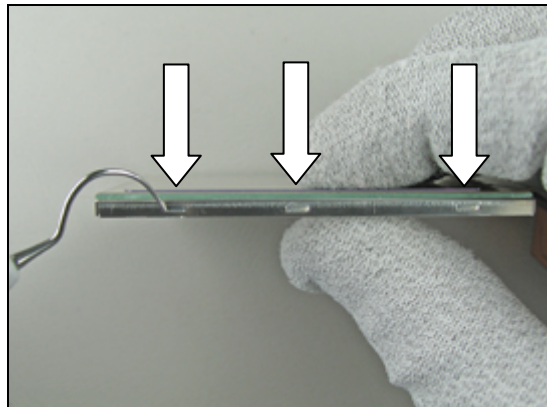
Touch Panel with Frame *continued*

Mount the new *touch panel* on the *LCD*.

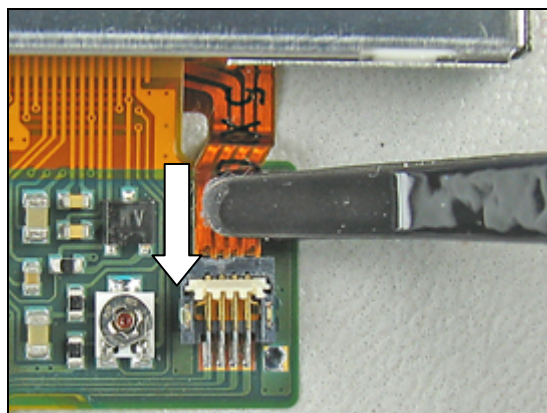
If it doesn't fit right on, it might help to press on one of the hooks with the dentist hook.

DO NOT USE EXCESSIVE FORCE!

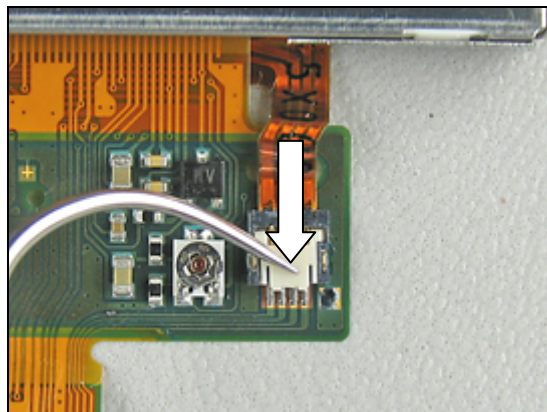
Make sure that the *touch panel* is properly mounted on the *LCD*.



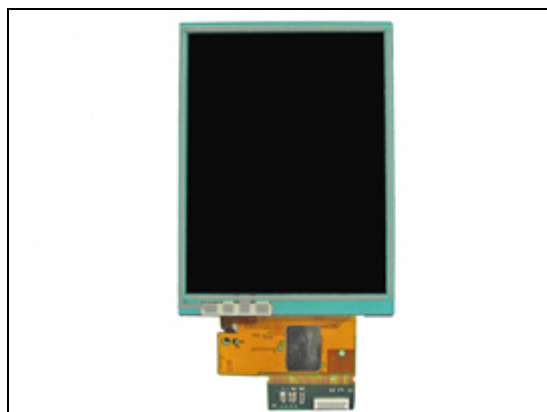
Connect the *touch panel* flex film with the flex film assembly tool.



Close the FPC connector with the dentist hook.



Properly assembled *touch panel* and *LCD*.



Touch Panel with Frame *continued*

Don't forget to remove the protective tape from the new LCD before the *front sub* is installed.

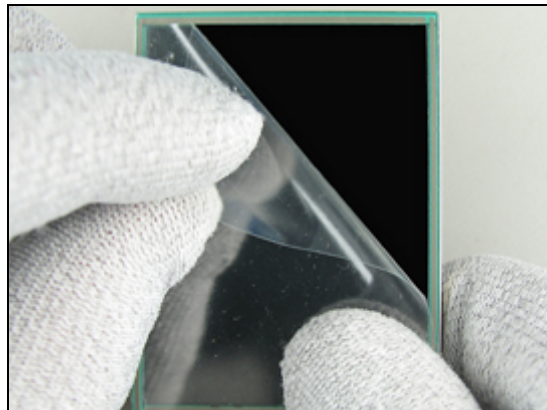
DO NOT TOUCH THE LCD GLASS SURFACE!
REMOVE ANY DUST WITH AN IONIZED AIRGUN OR BLOWER!

Follow the 4.1.2 – 4.1.10 Reassembly instructions!

Do these seven tests when the phone is reassembled to check that the LCD assembly works properly.

(2_00021-1_FEA209544_101 Test instruction mechanical):

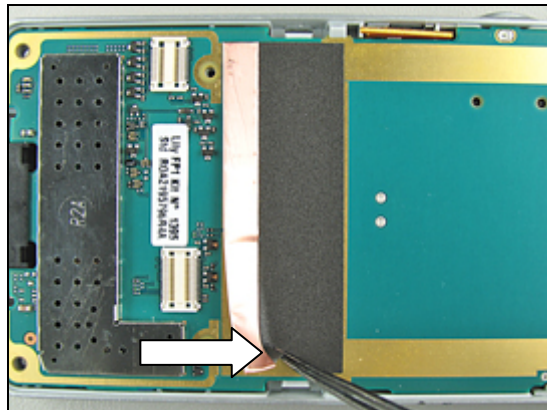
- Touch screen test
- Backlight brightness uniformity
- Contrast
- Display position to check correctly aligned
- Dust inspection
- Dot inspection
- Color check



3.18 Gasket, LCD Big

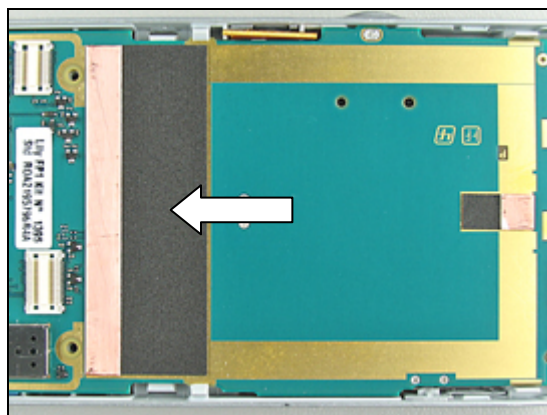
Follow the 2.1.1 – 2.1.9 Disassembly instructions!

Remove the *gasket, LCD big* with the dentist hook.



Attach a new *gasket, LCD big* with the tweezers.

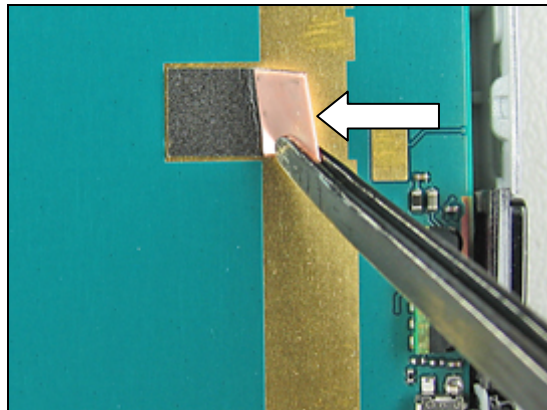
Follow 4.1.2 – 4.1.10 Reassembly instructions!



3.19 Gasket, LCD Small

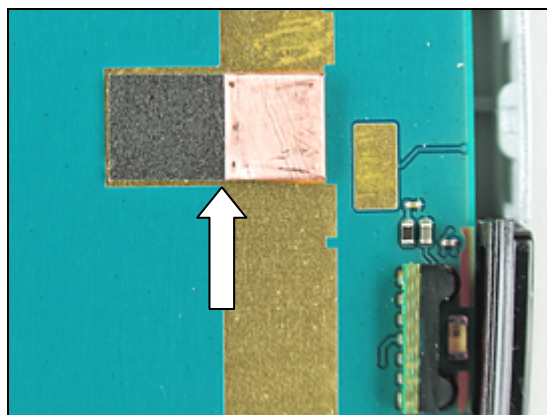
Follow the 2.1.1 – 2.1.9 Disassembly instructions!

Remove the *gasket, LCD small* with the tweezers.



Attach a new *gasket, LCD small* with the tweezers.

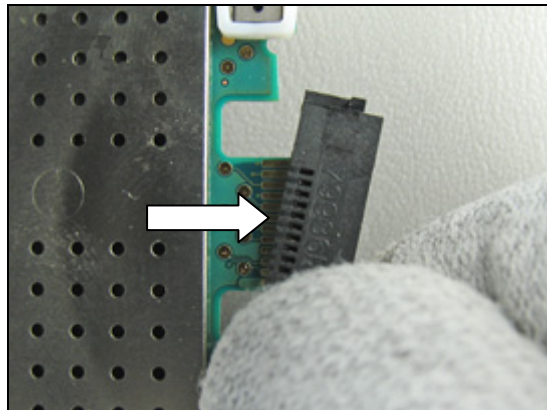
Follow 4.1.2 – 4.1.10 Reassembly instructions!



3.20 System Connector

Follow 2.1.1 – 2.1.10 Reassembly instructions!

Remove the old *system connector* by hand.



Mount a new *system connector* with your fingers.
Press the *system connector* firmly to the bottom.

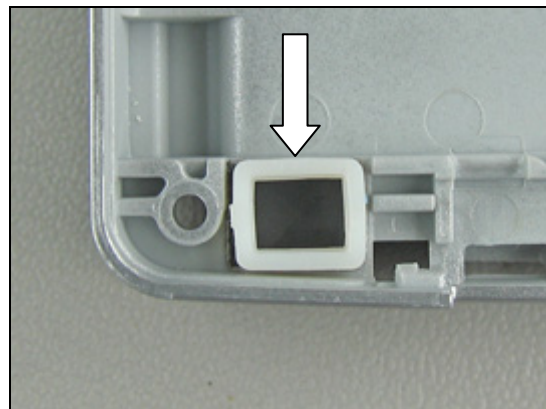
Follow 4.1.1 – 4.1.10 Reassembly instructions!



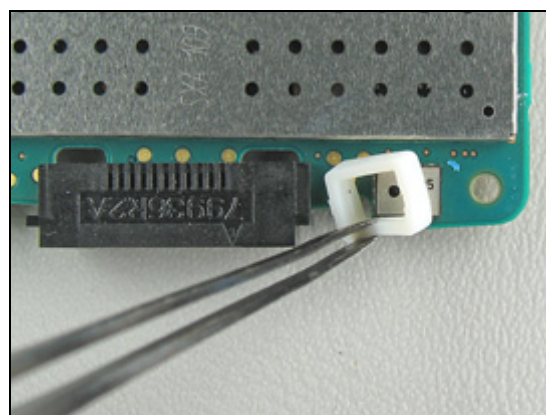
3.21 Gasket, Microphone

Follow 2.1.1 – 2.1.10 Disassembly instructions!

In some cases the *gasket, microphone* might get stuck on the *frame*.

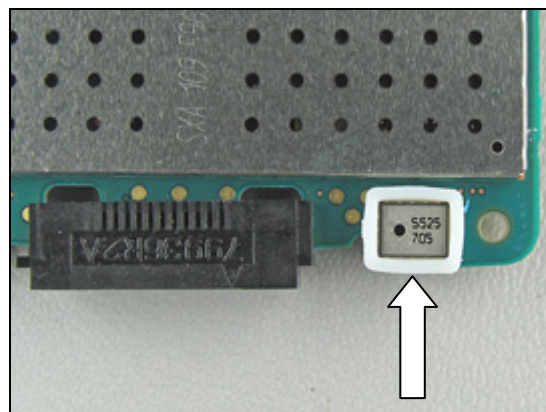


Remove the old *gasket, microphone* with the tweezers.



Mount a new *gasket, microphone* with the tweezers.

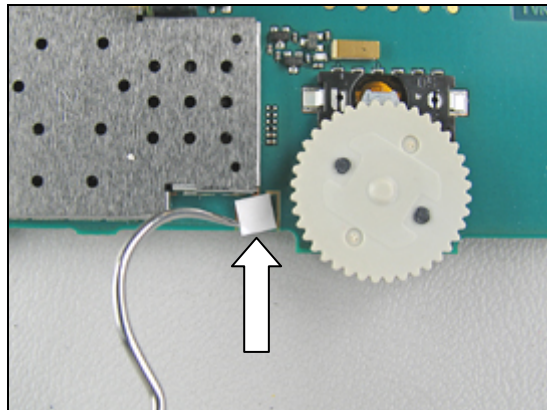
Follow 4.1.1 – 4.1.10 Reassembly instructions!



3.22 Liquid Intrusion Indicator

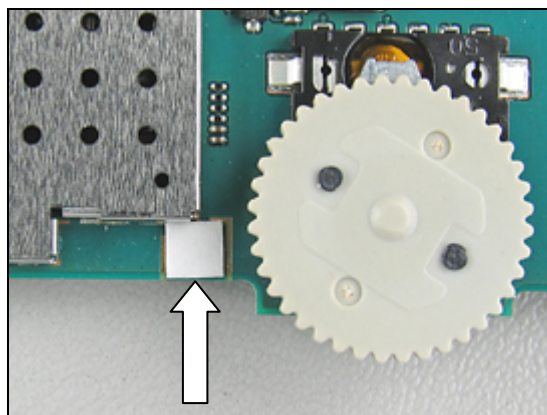
Follow 2.1.1 – 2.1.10 Disassembly instructions!

Remove the old *liquid intrusion indicator* with the dentist hook.



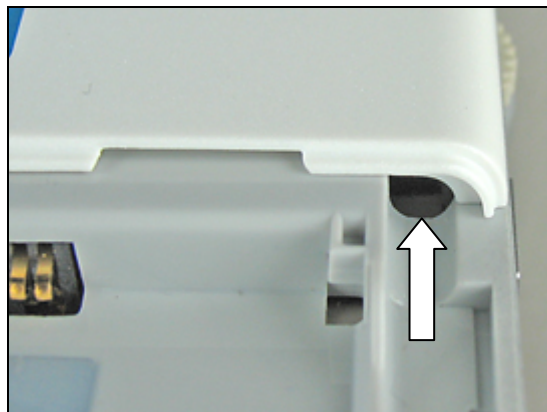
Attach a new *liquid intrusion indicator* with the dentist hook.

Follow 4.1.1 – 4.1.10 Reassembly instructions!

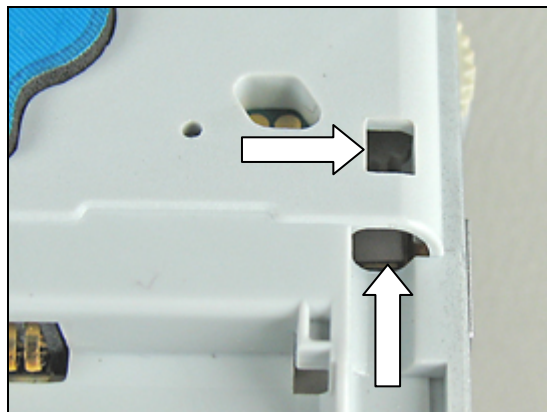


INSPECTION

Check for water damage on the *liquid intrusion indicator* with the *antenna lid* mounted.



Check for water damage on the *liquid intrusion indicator* with the *antenna lid* removed.

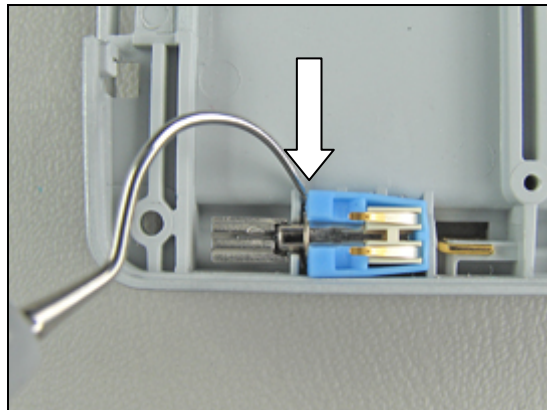


3.23 Motor Unit, Vibrator

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

DO NOT TOUCH THE VIBRATOR CONTACT SPRINGS OR DAMAGE THE FLYWHEEL!

Lift the *motor unit, vibrator* straight up with a dentist hook.

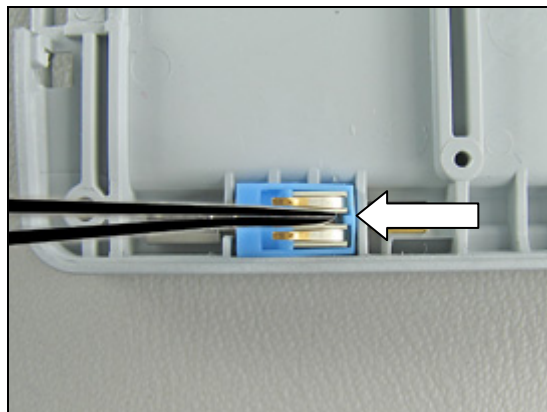


Remove the *motor unit, vibrator* with the tweezers.



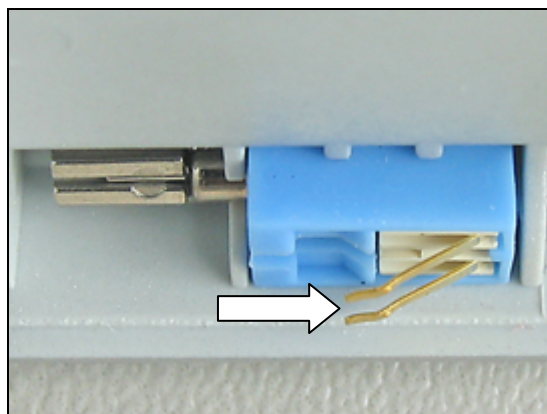
Gently press the *motor unit, vibrator* to the bottom of the cavity with the tweezers.

DO NOT PRESS ON THE CONTACT SPRINGS!



Check that the contact springs are not bent or damaged, but look like in the picture.

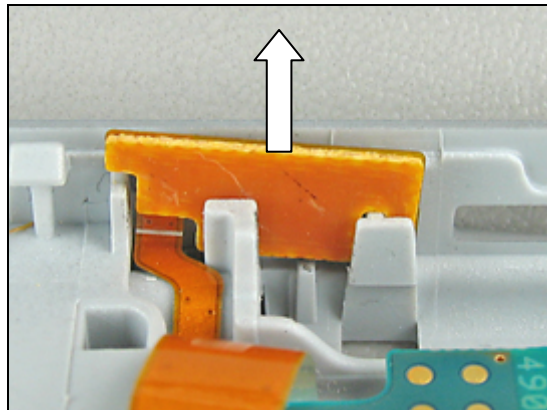
Follow the 4.1.1 – 4.1.10 Reassembly instructions!



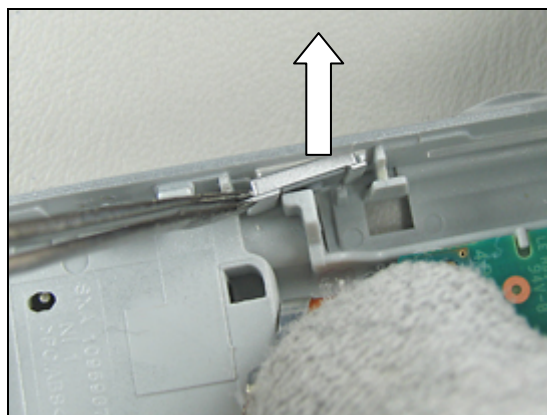
3.24 Key Back

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

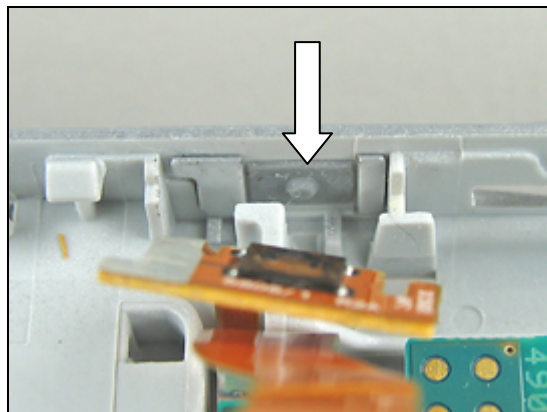
Lift this portion of the SIM PWB straight up to release it so that the key back becomes accessible.



Remove the old *key back* by lifting it straight up from the inside with the tweezers.

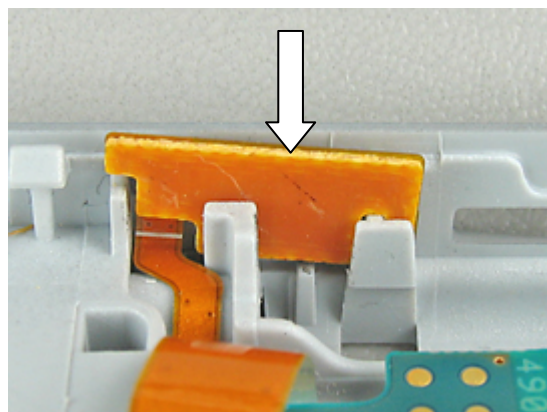


Insert a new *key back* from above by using tweezers.



Insert this portion of the *SIM PWB* into its original position.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!



3.25 Antenna asm

Follow the 2.1.1 – 2.1.10 Disassembly instructions!

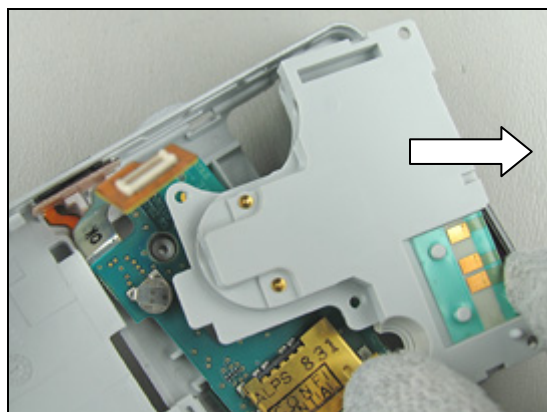
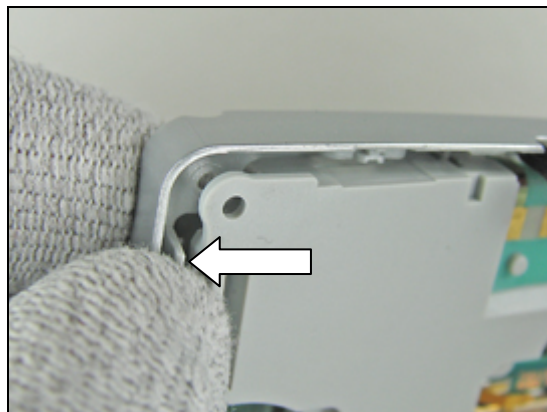
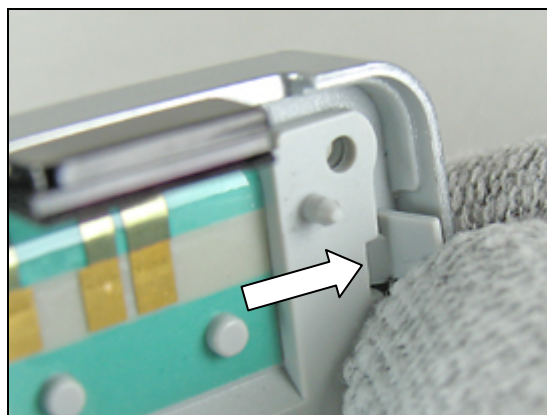
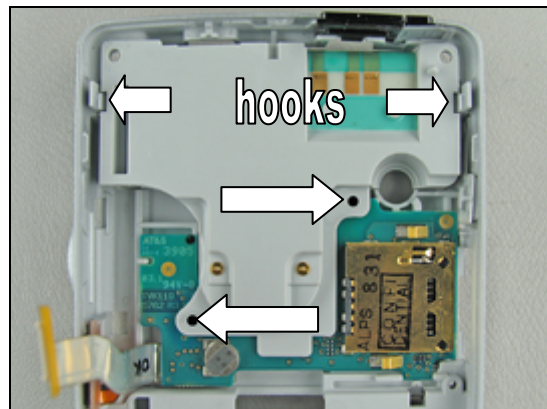
Remove the two screws from the *antenna* by using the JCIS bit.

REMOVED SCREWS CAN BE REUSED ONLY IF THEY ARE NOT DAMAGED!

Release the two hooks (see picture above) that secure the *antenna* and at the same time push from the back with your finger until it gets unhooked.

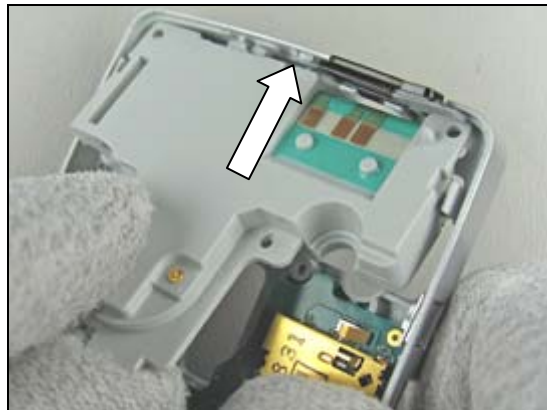
Do the same on the opposite side to make the *antenna* become released from the *frame*.

Remove the *antenna*.

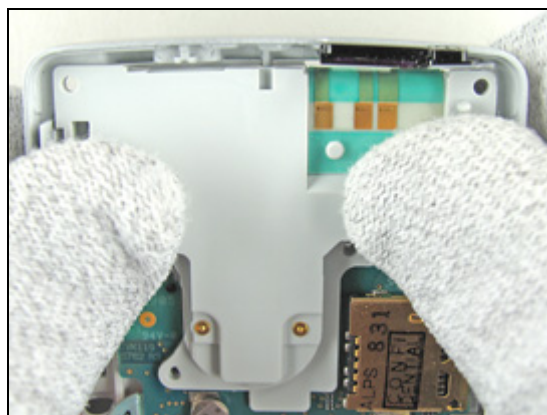


Antenna asm *continued*

Start the installation of the *antenna* by putting it against the top of the *frame*.



Lower the *antenna* towards the bottom of the *frame* until it becomes latched by the hooks.

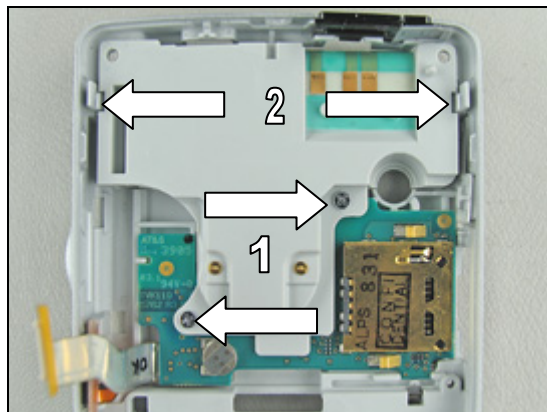


Apply **9 Ncm** \pm 2 Ncm torque to tighten the two screws (1) using the JCIS bit.

REPLACE THE SCREWS IN CASE THEY ARE DAMAGED.

Make sure the *antenna* is properly mounted inside the *frame* and that the two hooks (2) are latched.

Follow the 4.1.1 – 4.1.10 Reassembly instructions!

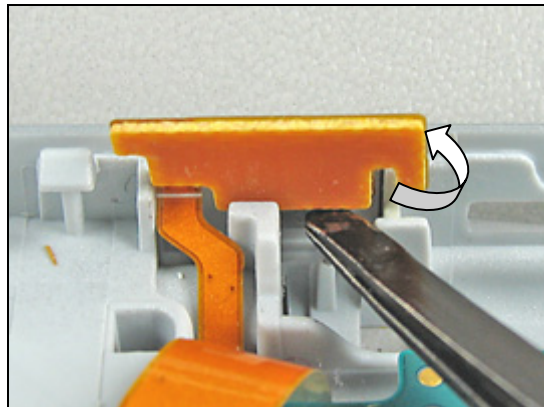


3.26 SIM PWB asm

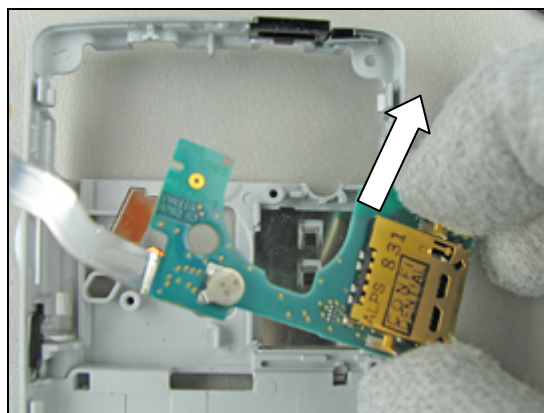
Follow the 2.1.1 – 2.1.10 Disassembly instructions!

Follow the 3.25 Replacements removal instruction!

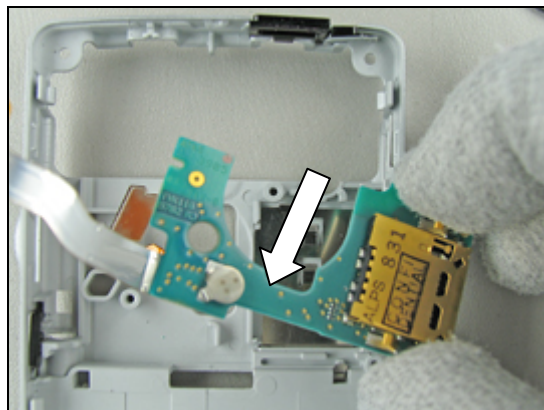
Gently release the *SIM PWB* flex film with the tweezers or the dentist hook.



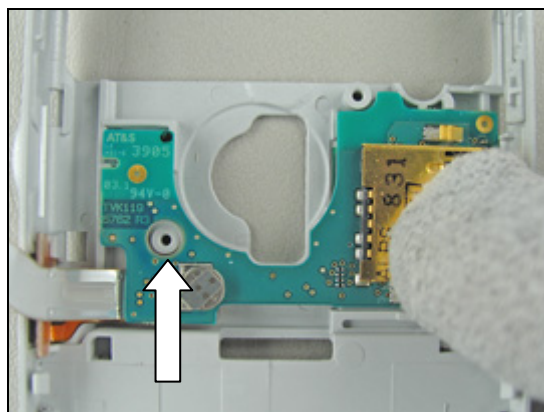
Remove the *SIM PWB*.



Use your fingers to install the *SIM PWB* into the *frame*.



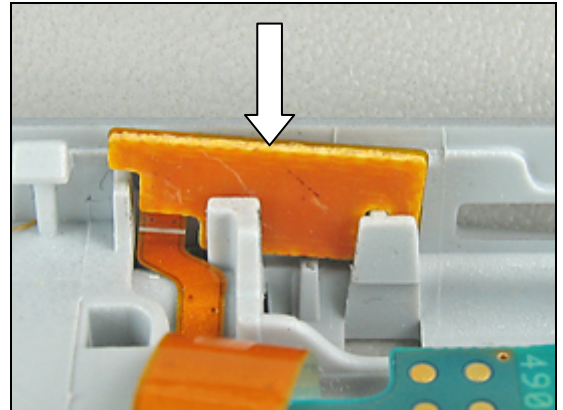
Put the *SIM PWB* into the bottom of the *frame* and align the *SIM PWB* hole to the circular protrusion of the *frame*.



SIM PWB asm *continued*

Insert this portion of the *SIM PWB* flex film into its original position by hand or with the tweezers.

Follow the 3.25 Replacements installation instruction!
Follow the 4.1.1 – 4.1.10 Reassembly instructions!



3.27 SIM Ejector

Follow the 2.1.1 – 2.1.10 Disassembly instructions!
Follow the 3.25 & 3.26 Replacements removal instruction!

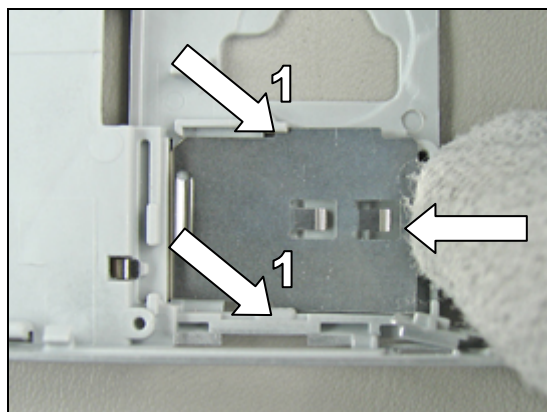
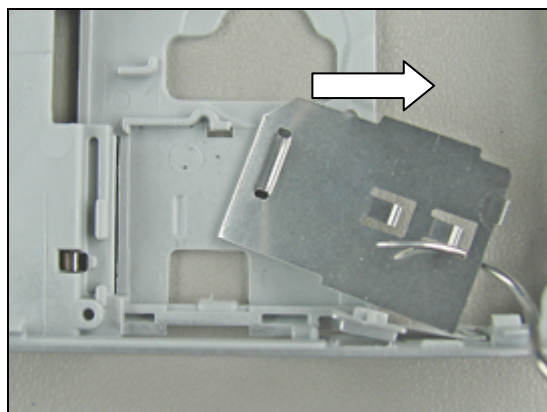
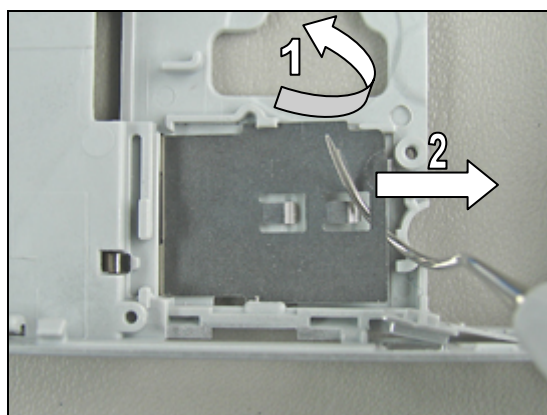
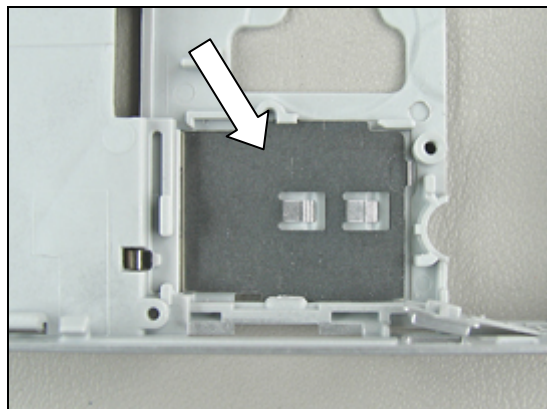
The *SIM ejector*.

Use the dentist hook to lift the *SIM ejector* slightly up (1) and simultaneously out of its position (2) away from the frame to release it.

Remove the *SIM ejector*.

Push the new *SIM ejector* underneath the two supports with your finger.

Sometimes it helps to press with a finger in the middle of the *SIM ejector* to make it slide into its normal position.



SIM Ejector *continued*

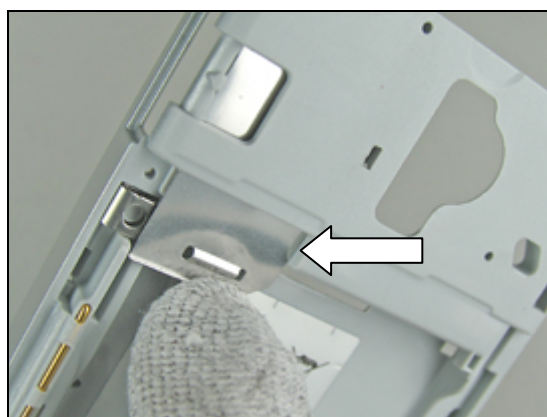
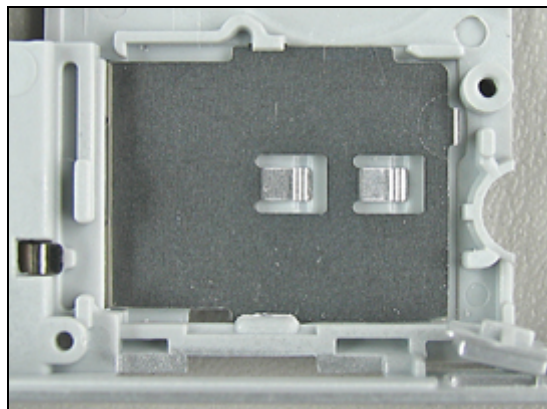
SIM ejector installed.

Make sure that the *SIM ejector* is properly mounted in the frame.

Check the function of the *SIM ejector*.

Follow the 3.26 & 3.25 Replacements installation instructions!

Follow the 4.1.1 – 4.1.10 Reassembly instructions!



3.28 Label

Follow the 2.1.2 Disassembly instructions!

- Read the old label and/or write the information into the "Label make" program before removal
 - Note the position of the label before removal
 - Heat up the label by using hot air, if needed.
 - Carefully remove the label without causing scratches
 - If there still are residues, clean the surface with isopropyl alcohol
-
- Check that the proper label format is loaded in the Zebra printer.
 - Write a new label by using the program "Label make" and check that the printing is OK.
 - Take the new label and place it onto the *frame* as in the adjacent picture.
 - **ONE LABEL ONLY IS ALLOWED!**

Follow the 4.1.9 Reassembly instructions!



3.29 Frame asm

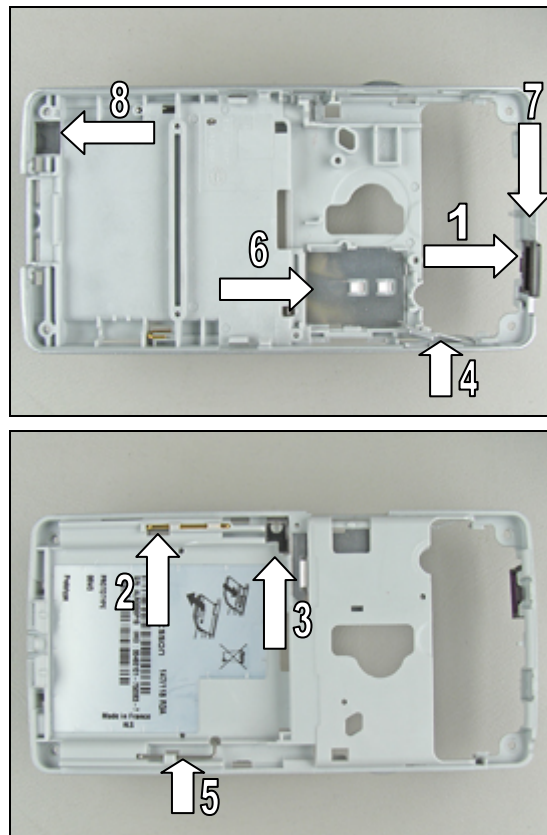
Follow the 2.1.1 – 2.1.10 Disassembly instructions!
Follow the 3.16 & 3.23 – 3.26 Replacements removal instructions!

A new *frame assembly* contains the following components:

- Window IRDA (1) • Antenna BT (2) • Hook, battery (3)
- Key, operator (4) • Stylus spring (5) • SIM ejector (6)
- Protection tape, IRDA (7) • Net, microphone (8)

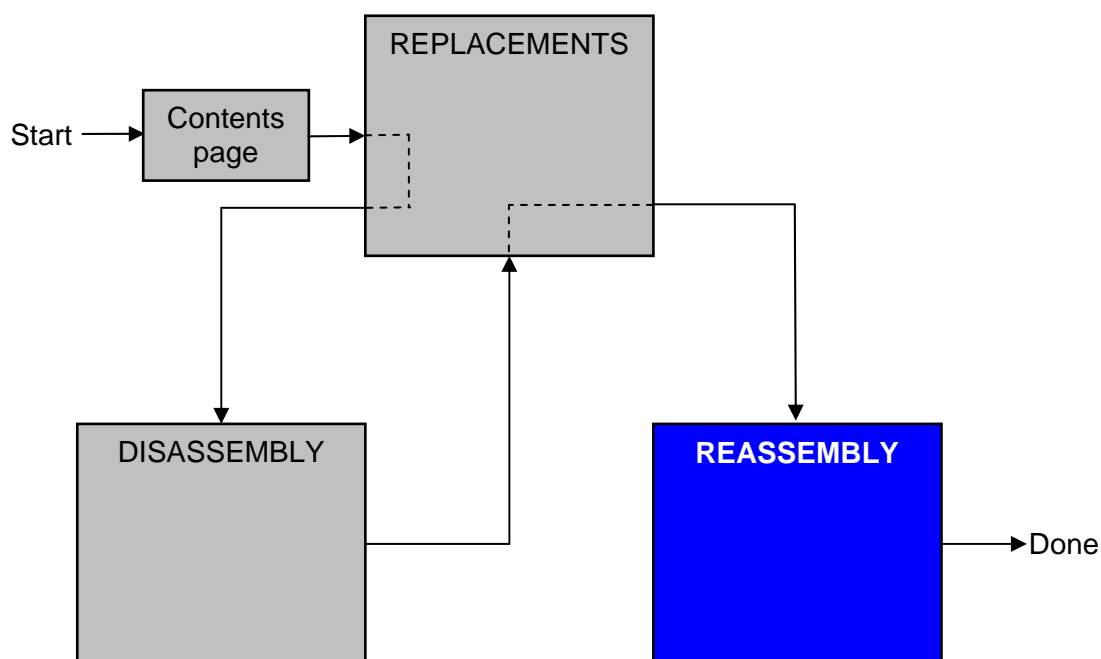
Make sure that all components mentioned above are properly mounted in the *frame assembly*.

Follow the 3.28, 3.26 – 3.23, 3.16 & 3.13 Replacements installation instructions!
Follow the 4.1.1 – 4.1.10 Reassembly instructions!



4 Reassembly

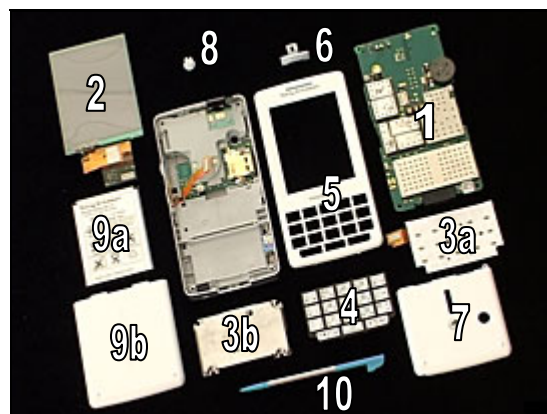
After replacing a part being listed in Replacements, the instruction of that section usually ends by directing you to this Reassembly section with a specification of the instructions you have to carry out in order to reassemble the phone.



4.1 Overview

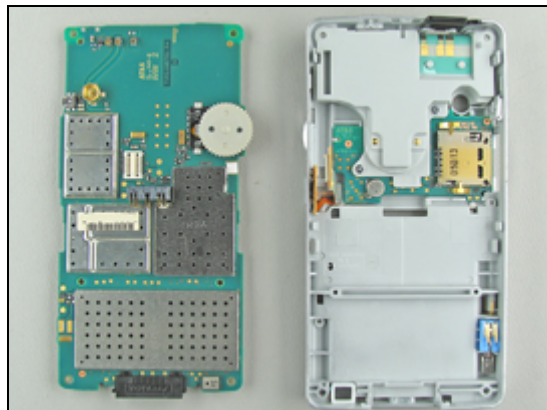
The reassembly is done in the following sequence:

1. PBA
2. LCD
3. Flex Film, keyboard (a) & Keyboard Support (b)
4. Keyboard QWERTY
5. Front Sub
6. Cap MS
7. Antenna Lid
8. External Antenna Cap
9. Battery (a) & Battery Lid (b)
10. Pen Stylus

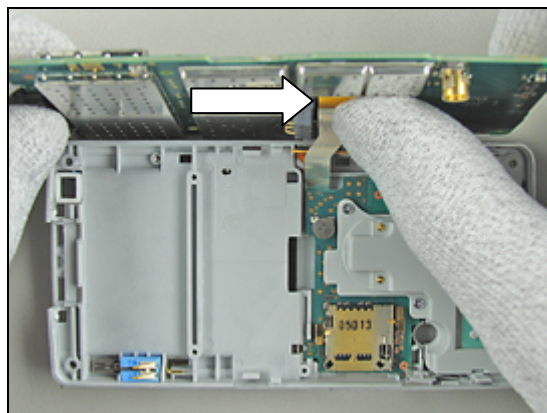


4.1.1 PBA

PBA to be installed into the *frame*.



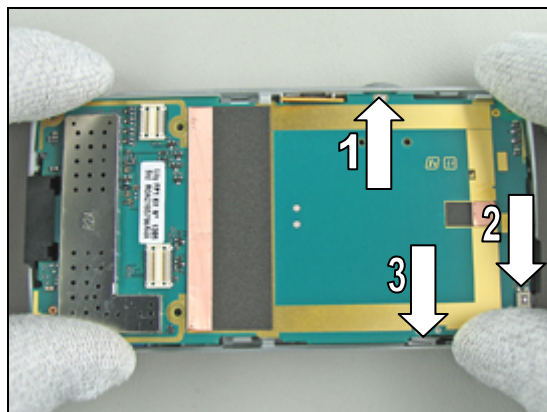
Place the *PBA* close to the *frame* and connect the *SIM PWB* board-to-board connector with your fingers.



BE MOST CAREFUL WITH THE JOG DIAL WHEEL (1), ON/OFF KEY (2), AND THE OPERATOR KEY (3) WHEN THE PBA IS INSTALLED INTO THE FRAME!

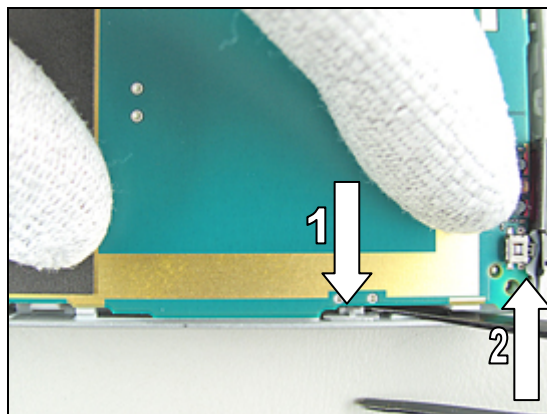
DON'T BEND THE PBA TOO MUCH UPWARDS, SINCE THE JOG DIAL WHEEL EASILY BREAKS APART!

Start the installation by placing the *PBA*'s jog dial wheel into the narrow opening (1) of the *frame*.



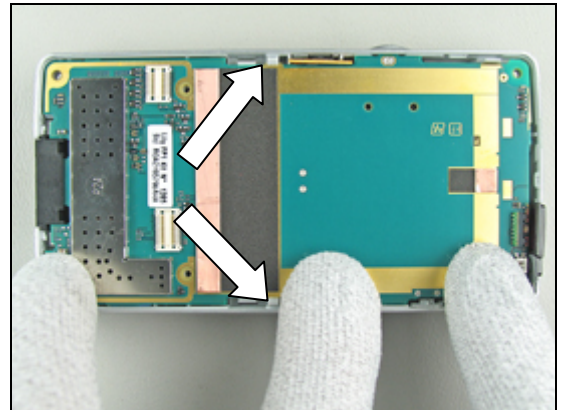
Sometimes the operator (1) and on/off (2) keys obstruct the passage for the *PBA*.

In that case gently push the operator and on/off keys into place by using the tweezers.

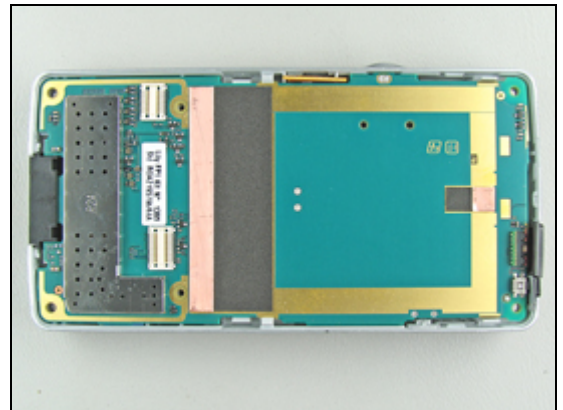


PBA continued

Push the *PBA* all the way to the bottom of the *frame*.
Make sure that the *PBA* is properly installed in the *frame*
and that the *PBA* is latched by the two *frame* snap hooks.

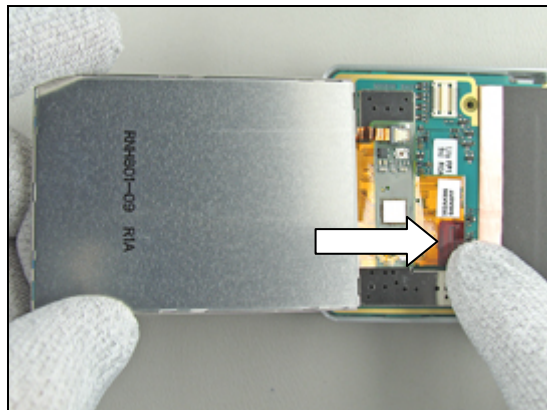


PBA installed.

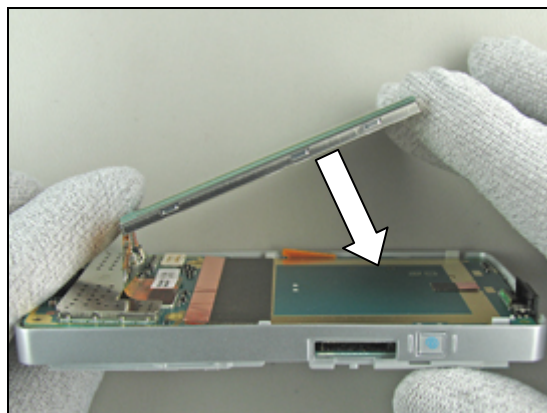


4.1.2 LCD

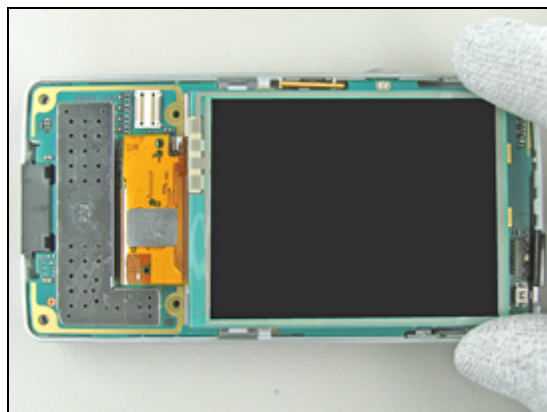
Connect the *LCD* board-to-board connector to the *PBA* using your fingers.



Gently turn the *LCD* on top of the *PBA* until it is in its proper position.

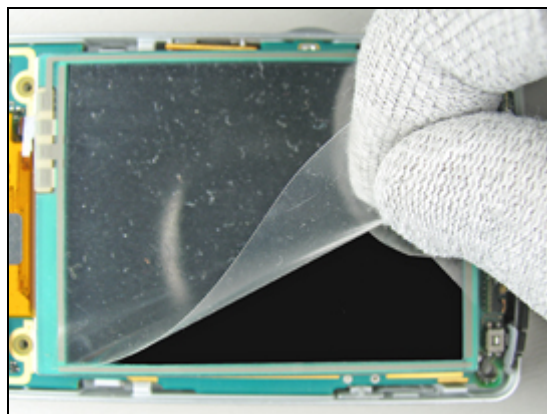


LCD installed on the *PBA*.



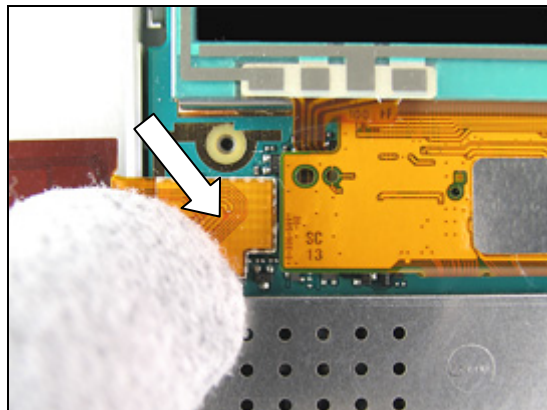
Don't forget to remove the protective tape from a new *LCD* before the installation of the *front sub*.

DO NOT TOUCH THE LCD GLASS SURFACE!
REMOVE ANY DUST WITH AN IONIZED AIRGUN OR BLOWER!



4.1.3 Flex Film asm, Keyboard & Keyboard Support asm

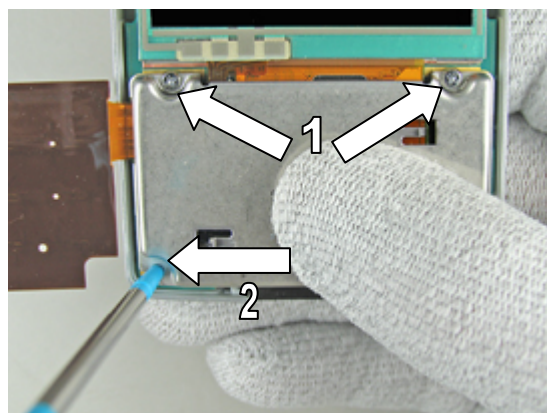
Connect the *flex film, keyboard* to the *PBA* by hand.



DO NOT TIGHTEN THE TWO SCREWS!

Insert the two screws (1) in the *PBA*.

Use the *stylus pen* (2) to guide the *keyboard support* into its proper position.

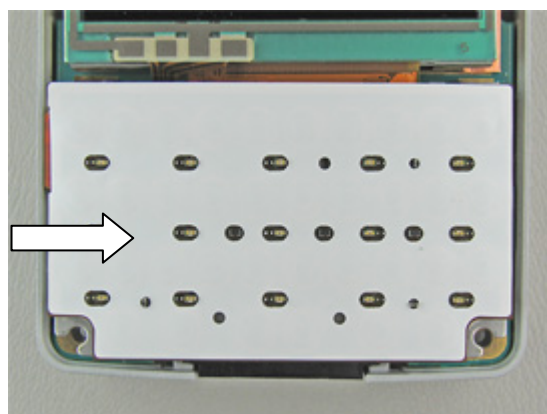


REPLACE THE SCREWS IN CASE THEY ARE DAMAGED!

Apply **9 Ncm** \pm 2 Ncm torque to tighten the two screws using the JCIS bit.



Gently turn the *flex film, keyboard* to the right over the *keyboard support*.



4.1.4 Keyboard QWERTY

Place the *keyboard qwerty* on top of the *flex film*, keyboard by hand.



4.1.5 Front Sub asm

Front sub to be installed.



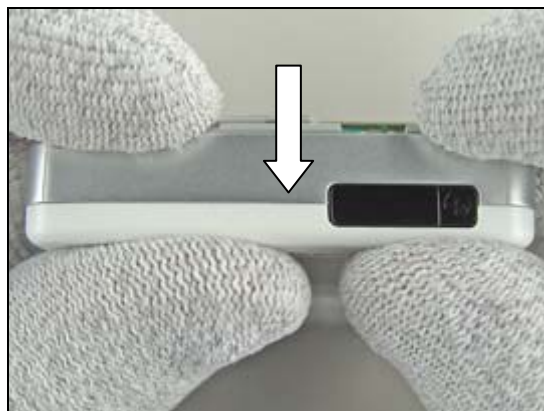
Start the installation of the front sub from the bottom of the phone.



Snap the *front sub* to the phone.



Continue to snap the *front sub* to the phone.
Check that there are no gaps along the sides.
If there still is a gap somewhere, gently press the two halves together with your fingers.



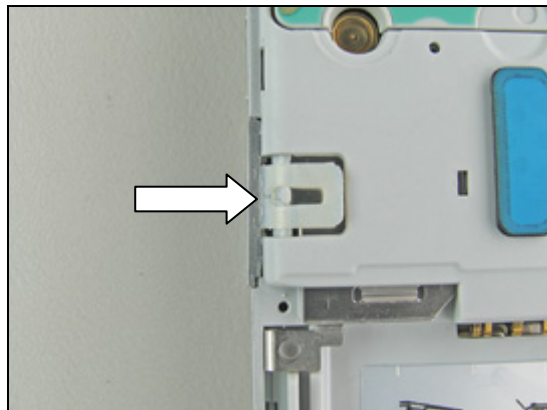
Front Sub asm *continued*

Apply **15 Ncm** \pm 2 Ncm torque to tighten four **new** screws using torx bit no. 6.



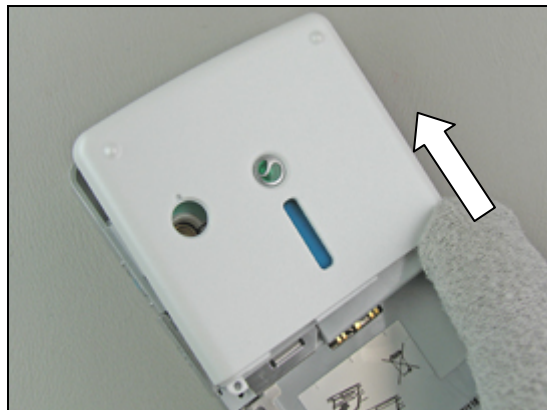
4.1.6 Cap MS

Put the *cap MS* over the guiding pin.

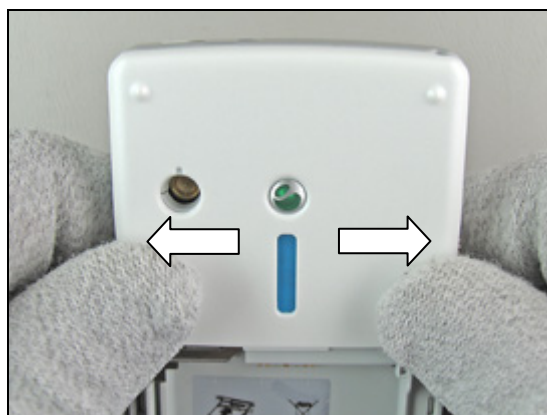


4.1.7 Antenna Lid asm

MOST IMPORTANT TO START THE INSTALLATION OF THE ANTENNA LID IN THE LOWER RIGHT CORNER!

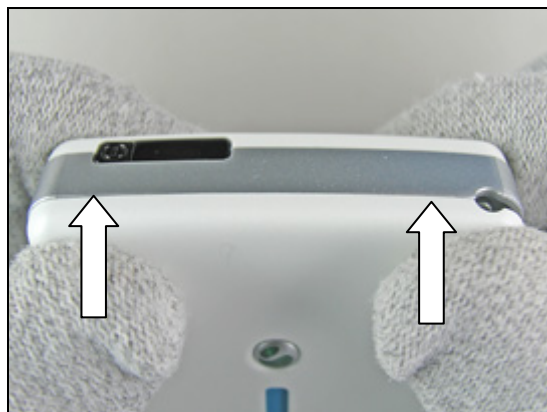


Continue to snap the *antenna lid* onto the phone, first at the bottom.



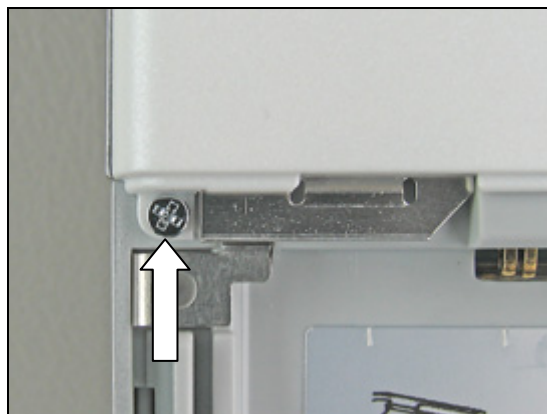
And then on the top of the phone.

Check that there are no gaps along the sides.
If there still is a gap somewhere, gently press the two halves together with your fingers.



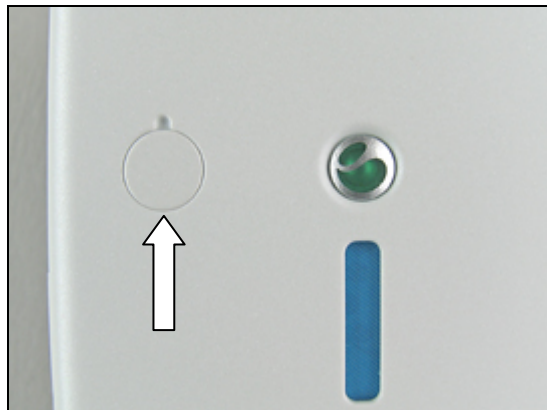
Apply **9 Ncm** \pm 2 Ncm torque by tightening the screw using the JCIS bit.

REPLACE THE SCREW IN CASE IT IS DAMAGED.



4.1.8 External Antenna Cap

Press the *external antenna cap* into its position with your fingers.



4.1.9 Battery & Battery Lid

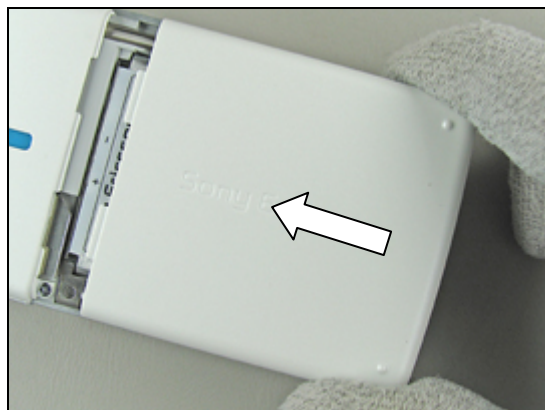
Put the top of the *battery* into the battery compartment.



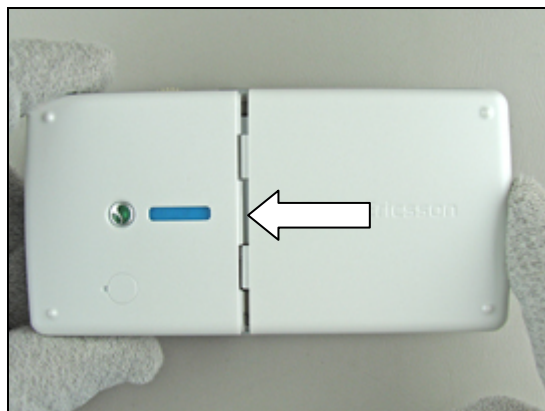
Slide the *battery* forward and press at the bottom until it is secured in its proper position.



Slide the *battery lid* onto the phone.

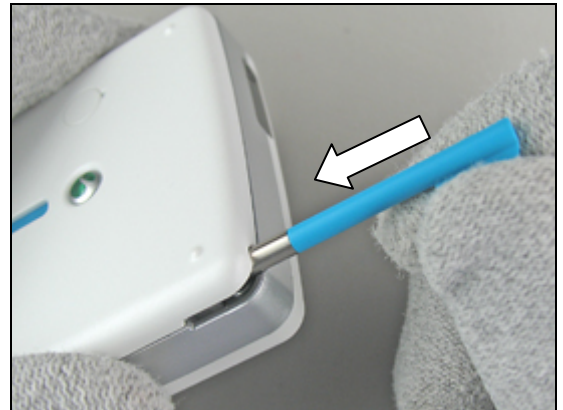


Push on the *battery lid* until it is closed without any gap.



4.1.10 Pen Stylus asm

Insert the *pen stylus* with your fingers.



Pen stylus inserted.



5 Revision history

Rev.	Date	Changes / Comments
A	2006-05-19	1 st release