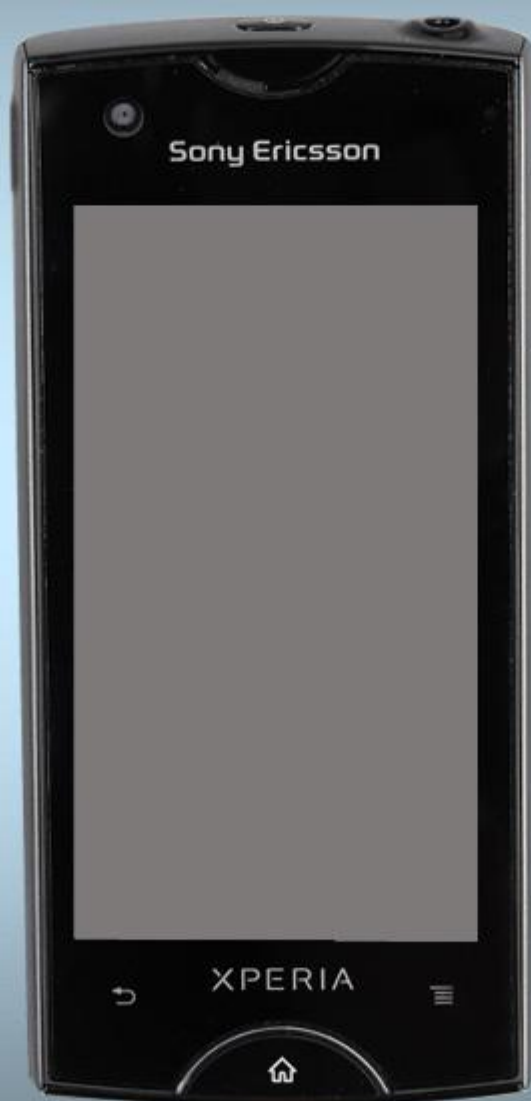




Sony Ericsson

Working Instructions

- mechanical -



ST18i, ST18a, SO-03C,
Xperia™ Ray



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



1 Exterior Views

1.1 Ray, ST18, ST18i, ST18a



2 Tools

SPECIAL TOOLS

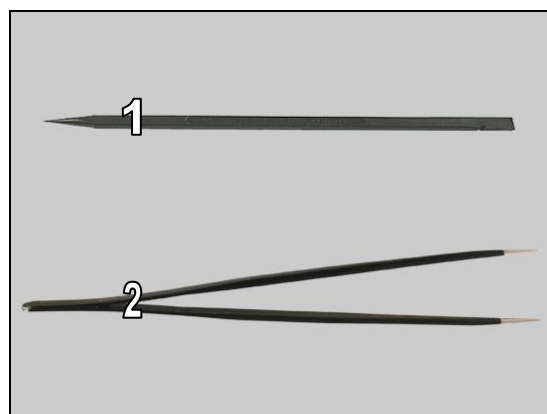
1. Torque Screwdriver
2. Flex Film Assembly Tool
3. Front Opening Tool
4. Bits(T4)
5. Guitar Pick



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

STANDARD TOOLS

1. Nylon Pointer
2. Tweezers

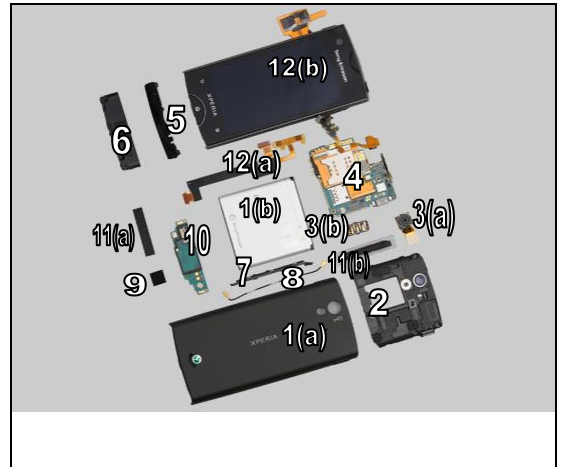




3 Disassembly

The disassembly is done in the following order:

1. Cover Battery (a) & Battery (b)
2. Cover Rear Assembly
3. Main Camera (a) & Audio Jack (b)
4. Main PBA
5. Cover Panel Bottom
6. Main Antenna Assy
7. Cable Cover Insert
8. RF Cable
9. MComp Sheet Relay CON
10. Sub PBA
11. Cushion Batt Conn (a) & Key Volume (b)
12. Relav FPC (a) & Cover Front Assv (b)

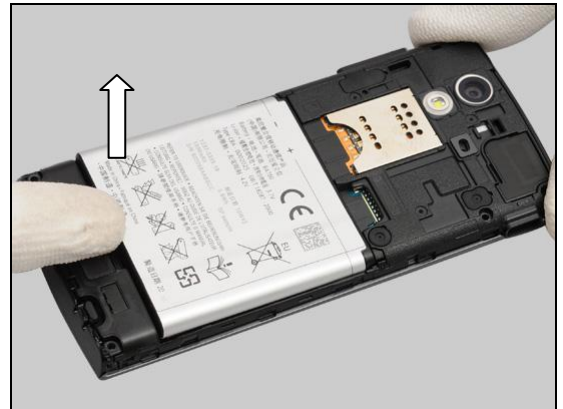


3.1 Cover Battery

Lift up to unsnap the hooks of the Cover Battery from the bottom gently and remove it.



Lift up the Battery from its cavity by finger.



Remove the Battery.



Disassembly

3.2 Cover Rear Assembly

Remove the five Screw Len:4.0 Diam:1.4 by a screwdriver with Bits (T4).

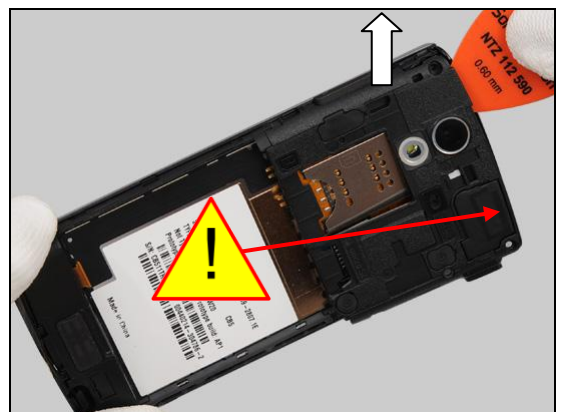


Insert guitar pick from the USB position in right side and slide along right side.



Insert guitar pick from the upper left corner and release the hook.

Note: Do not insert guitar pick too much, because there is antenna spring in this area proximity!



Slide along left side to release the hooks.



Disassembly

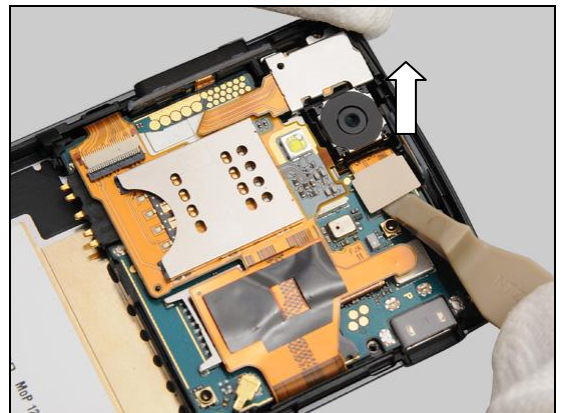
Remove the Cover Rear Assembly gently.



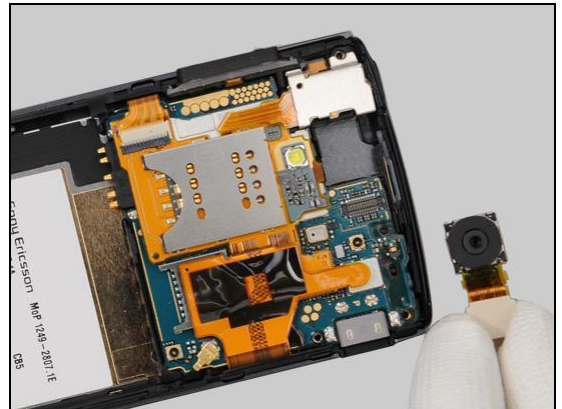
3.3 Main Camera

Unsnap the BtB connector by using a Front Opening Tool.

Note: Do not bend top panel!

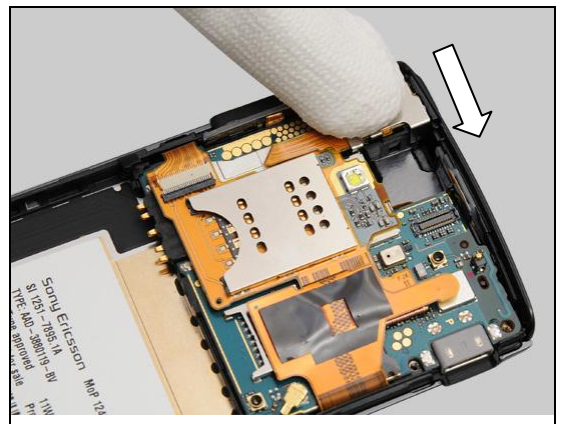


Remove the Main Camera.



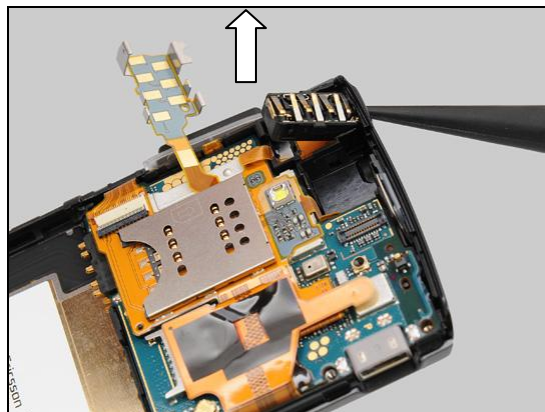
3.4 Audio Jack

Push the Audio Jack Plate from left to right to unlock the hook by finger.



Disassembly

Lift up the Audio Jack by using a Nylon Pointer.

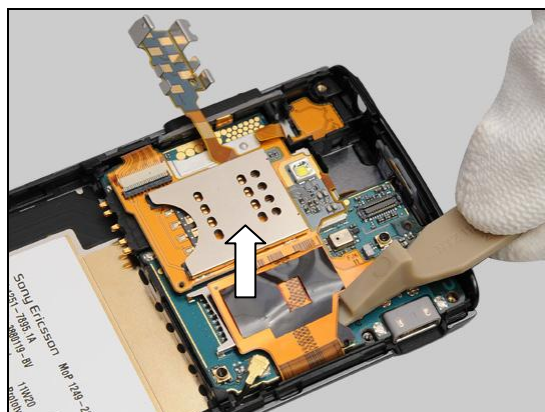


Remove the Audio Jack.

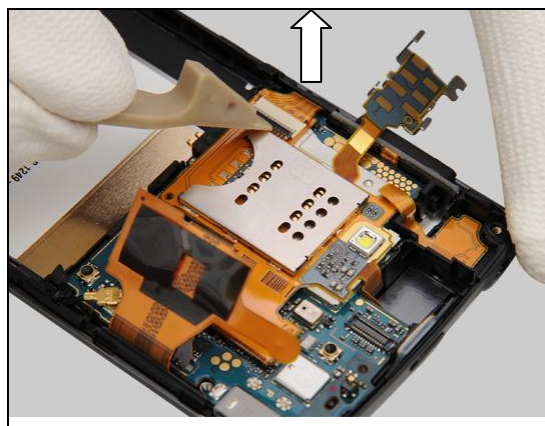


3.5 Main PBA

Unsnap the BtB connector by using a Front Opening Tool.

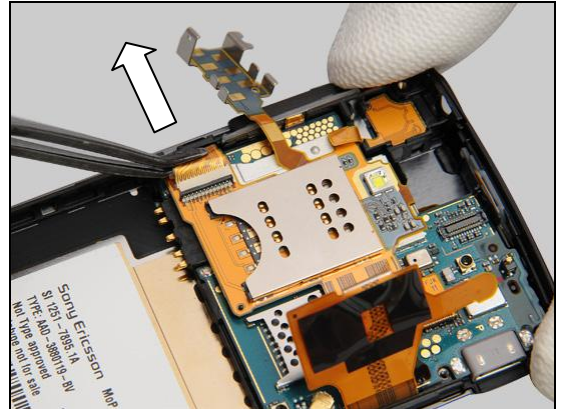


Unsnap the ZIF connector by using a Front Opening Tool.

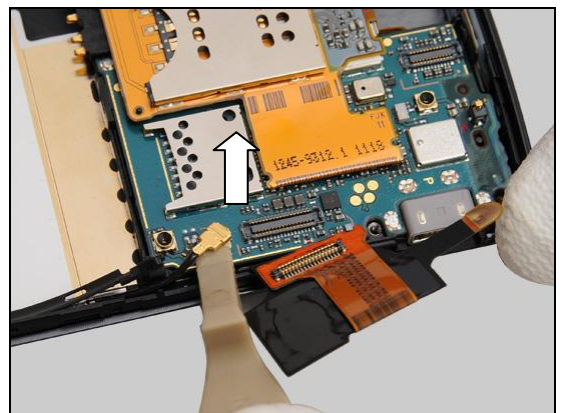


Disassembly

Lift up the FPC by using a Flex Film Assembly Tool.

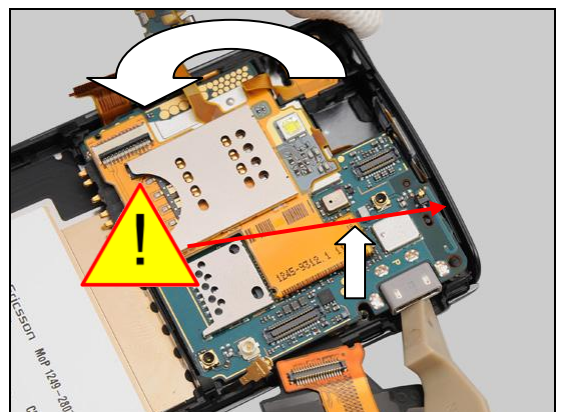


Unsnap the connector by using a Front Opening Tool.



Insert the Front Opening Tool to lift up the Main PBA under the Micro USB connector gently.

Note: Lift up the Main PBA gently and don't bend the cover panel upper.



Lift up and separate the Main PBA.



Disassembly

3.6 Cover Panel Bottom

Slide the Guitar Pick to release the hooks of Cover Panel Bottom from left to right.

Remove the Cover Panel Bottom.



3.7 Main Antenna Assy

Insert the Front Opening Tool from upper left to push the Main Antenna Assy gently.

Slide along upper side.





Disassembly

Remove the Main Antenna Assy.



3.8 Cable Cover Insert

Lift up the Cable Cover Insert from bottom side.



Slide along to release the hook by using a Front Opening Tool.



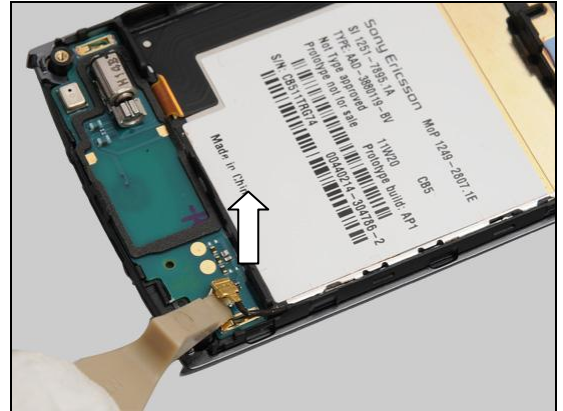
Remove the Cable Cover Insert.



Disassembly

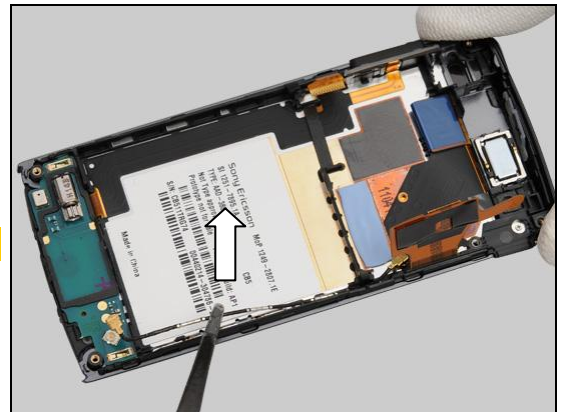
3.9 RF Cable

Unsnap the connector by using a Front Opening Tool.



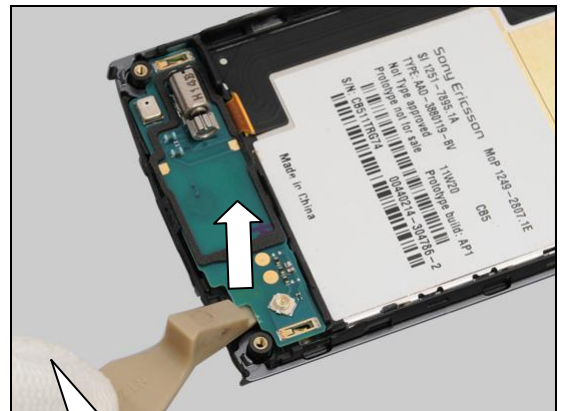
Remove the RF Cable by using a Flex Film Assembly Tool gently.

Note: Carefully remove the RF cable from the groove.

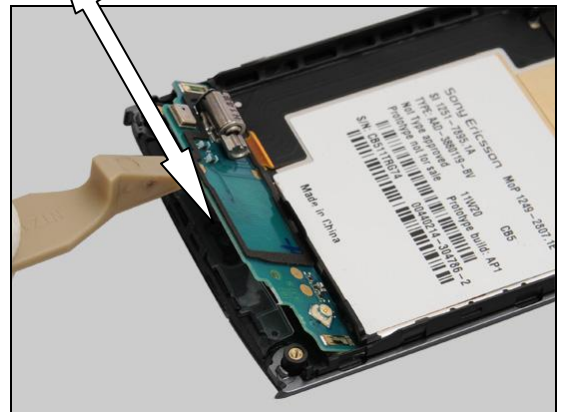


3.10 MComp Sheet Relay CON

Insert the Front Opening Tool from right to lift up the Sub PBA gently.



Slide along the bottom side.



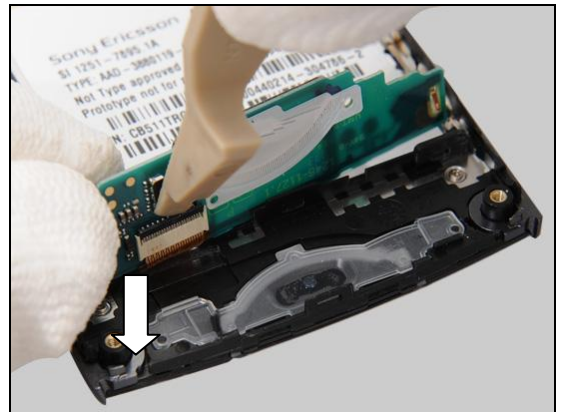
Disassembly

Peel off the MComp Sheet Relay CON.

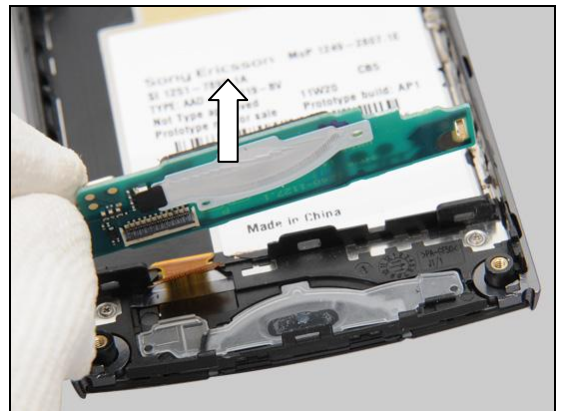


3.11 Sub PBA

Unsnap the ZIF connector by using a Front Opening Tool.

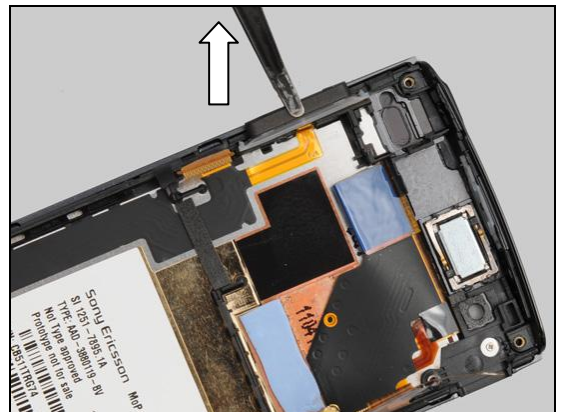


Lift up the Sub PBA and remove it.



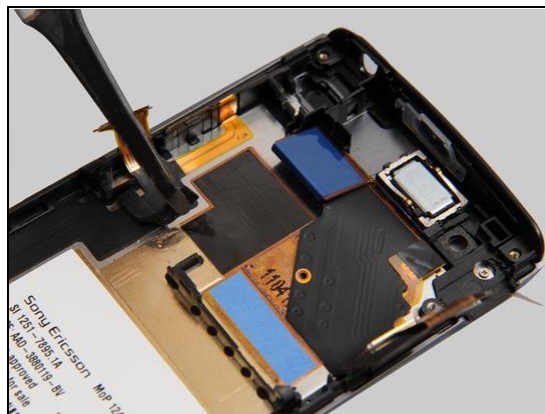
3.12 Relay FPC & Cover Front Assy

Remove the Volume Key

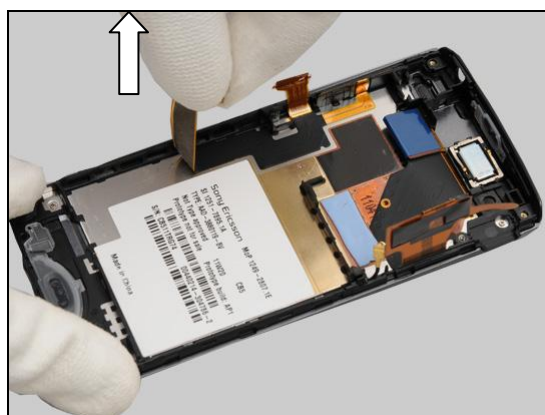


Disassembly

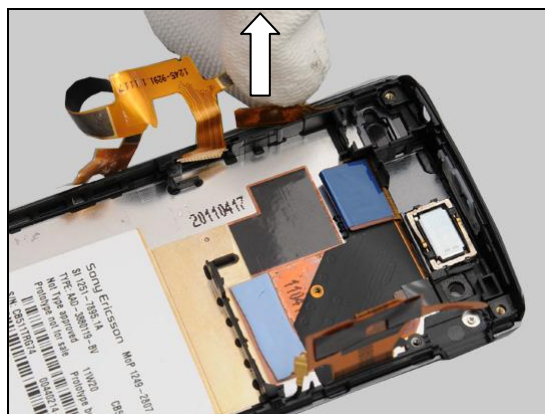
Peel off the Cushion Batt Conn by using a Flex Film Assembly Tool.



Peel off the Relay FPC gently from bottom side.



Peel off the key dome and remove the Relay FPC.





4 Replacement

4.1 Cover Battery

Follow the 3.1 Disassembly instructions!

Prepare a new Cover Battery.

Follow the 5.12 Reassembly instructions!



4.2 Cover Rear Assembly

Follow the 3.1 – 3.2 Disassembly instructions!

Follow the 4.10, 4.11, 4.12, 4.19 Removal instructions!

Prepare a new Cover Rear Assembly.

Follow the 4.10, 4.11, 4.12, 4.19 Installation instructions!

Follow the 5.11 – 5.12 Reassembly instructions!

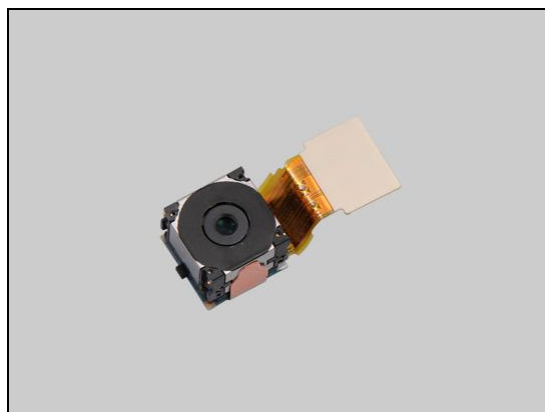


4.3 Main Camera

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare a new Main Camera.

Follow the 5.6, 5.11– 5.12 Reassembly instructions!



4.4 Audio Jack

Follow the 3.1 – 3.4 Disassembly instructions!

Prepare a new Audio Jack.

Follow the 5.5 – 5.6, 5.11 – 5.12 Reassembly instructions!





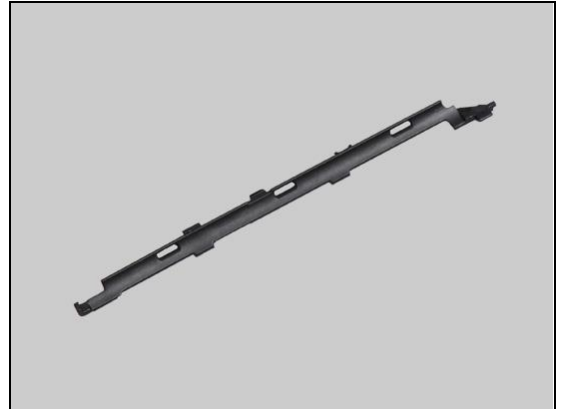
Replacement

4.5 Cable Cover Insert

Follow the 3.1 – 3.8 Disassembly instructions!

Prepare a new Cable Cover Insert.

Follow the 5.4 – 5.12 Reassembly instructions!

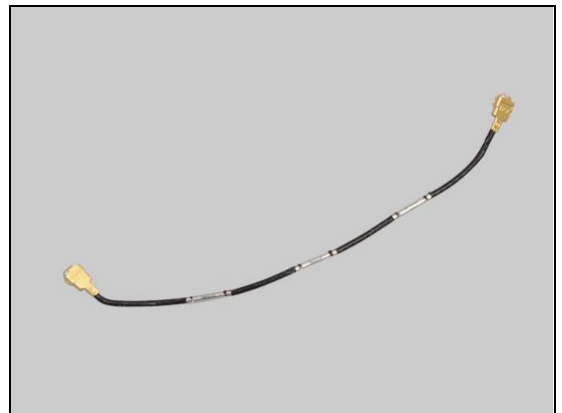


4.6 RF Cable

Follow the 3.1 – 3.9 Disassembly instructions!

Prepare a new RF Cable.

Follow the 5.4 – 5.12 Reassembly instructions!

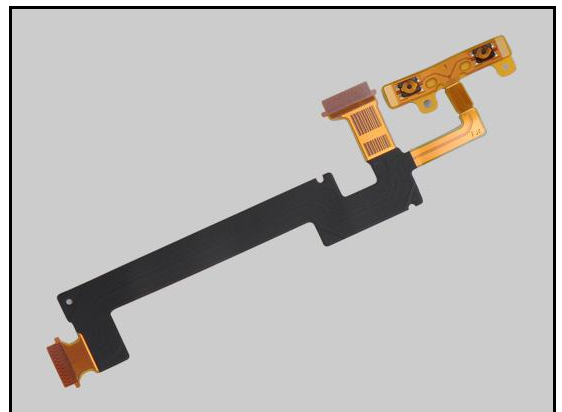


4.7 Relay FPC

Follow the 3.1 – 3.12 Disassembly instructions!

Prepare a new Relay FPC.

Follow the 5.1 – 5.12 Reassembly instructions!



4.8 Cover Front Assy

Follow the 3.1 – 3.12 Disassembly instructions!

Follow the 4.17, 4.18, 4.20, 4.21, 4.23 Removal instructions!

Prepare a new Cover Front Assy.

Follow the 4.17, 4.18, 4.20, 4.21, 4.23 Installation instructions!

Follow the 5.1 – 5.12 Reassembly instructions!

If tearing in camera view finder after reassembly, please perform Main Display V-Sync Calibration;

1269-2060 Trouble Shooting Application-mechanical.



Replacement

4.9 Audio Jack Plate

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.32 Removal instructions!

Prepare the new Audio Jack Plate.

Follow the 4.32 Installation instructions!

Follow the 5.4 – 5.12 Reassembly instructions!





Replacement

4.10 Cap RF

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

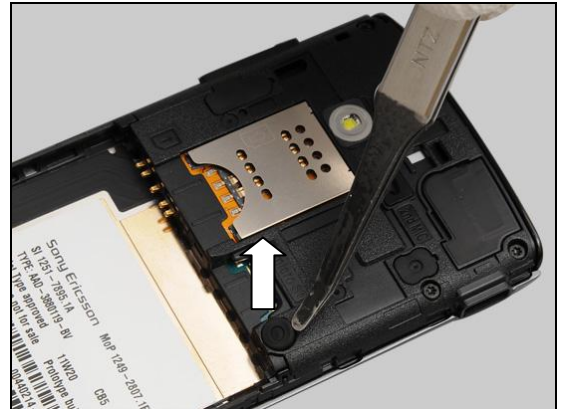
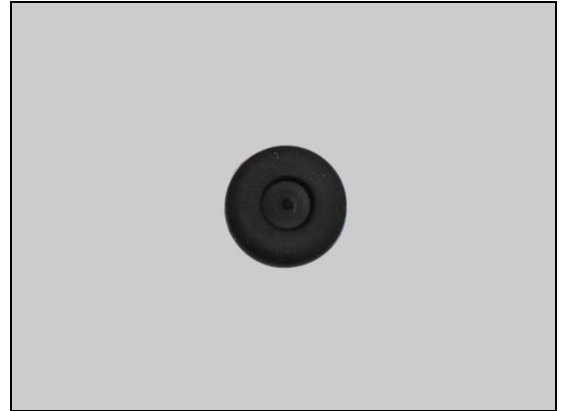
Prepare the new Cap RF.

Carry out the Installation as described below.

Follow the 5.12 Reassembly instructions!

REMOVAL

Lift up Cap RF by using a Flex Film Assembly Tool and remove it.

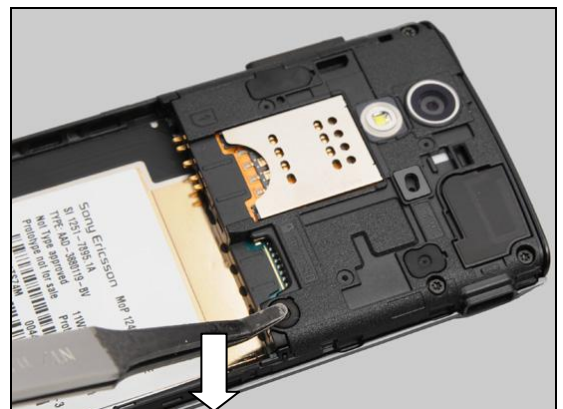


INSTALLATION

Place the new Cap RF in the correct position.



Press to secure its position.



Replacement

4.11 Cap TP A

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

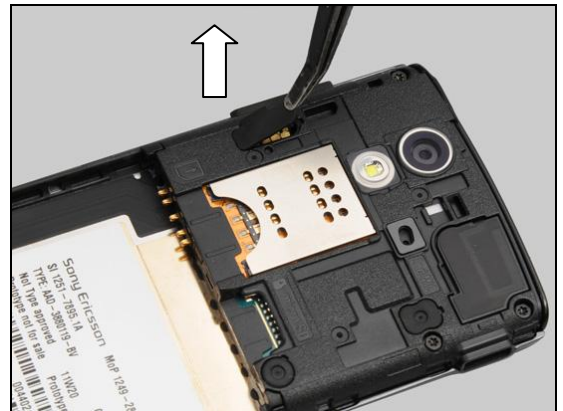
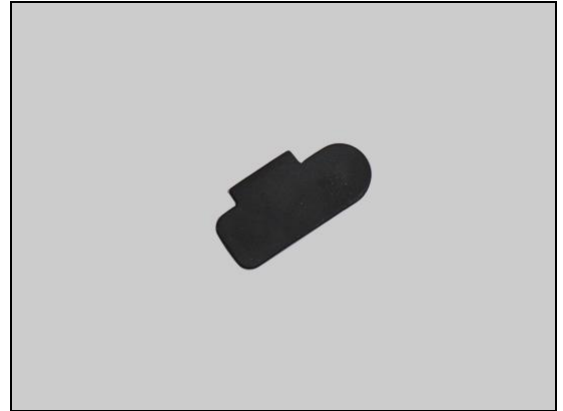
Prepare the new Cap TP A.

Carry out the Installation as described below.

Follow the 5.12 Reassembly instructions!

REMOVAL

Lift up Cap TP A by using a Flex Film Assembly Tool and remove it.

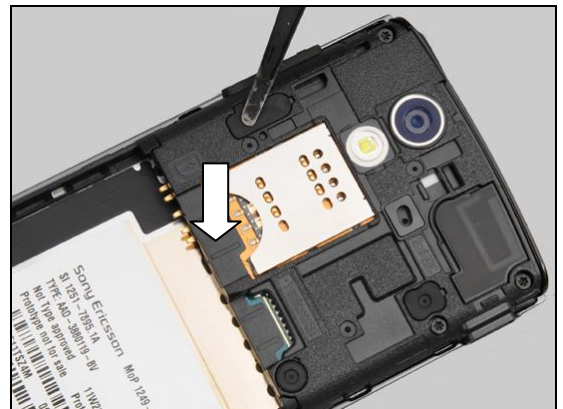


INSTALLATION

Place the new Cap TP A in the correct position.



Press to secure its position.



Replacement

4.12 Cap TP B

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

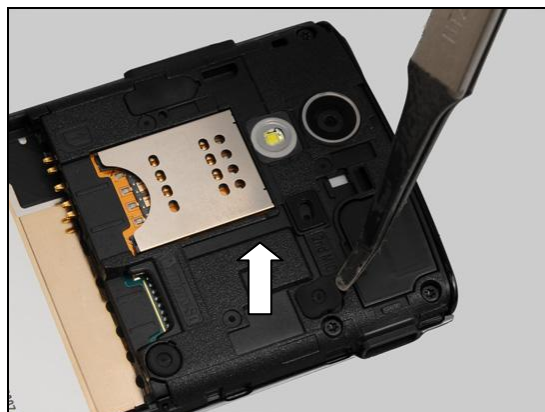
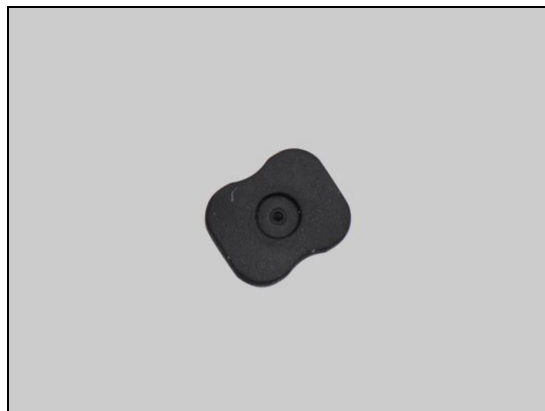
Prepare the new Cap TP B.

Carry out the Installation as described below.

Follow the 5.12 Reassembly instructions!

REMOVAL

Lift up Cap TP B by using a Flex Film Assembly Tool and remove it.

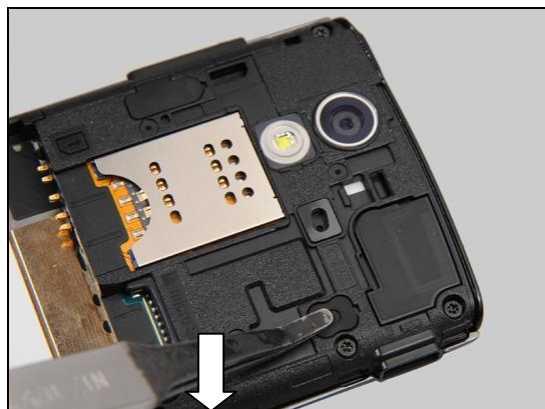


INSTALLATION

Place the new Cap TP B in the correct position.



Press to secure its position.



Replacement

4.13 Carrier Holder Receiver Sub Assembly

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.32 Removal instructions!

Carry out the Removal as described below.

Prepare a new Carrier Holder Receiver Sub Assembly.

Carry out the Installation as described below.

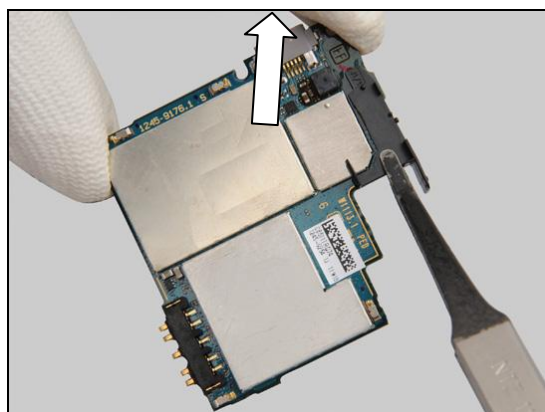
Follow the 4.32 Installation instructions!

Follow the 5.4 – 5.12 Reassembly instructions!

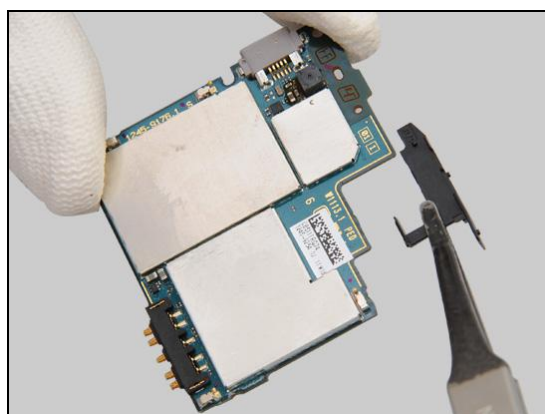


REMOVAL

Detach the foil by using a Flex Film Assembly Tool.

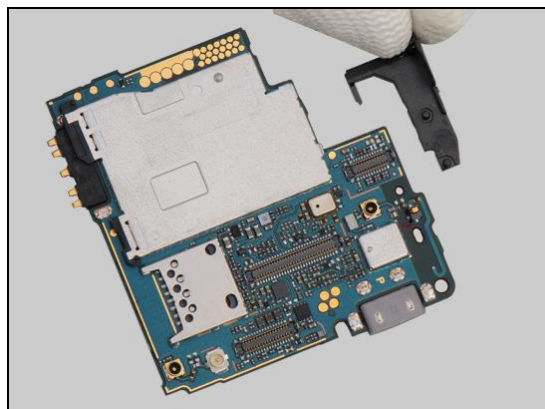


Remove the Carrier Holder Receiver Sub Assembly.



INSTALLATION

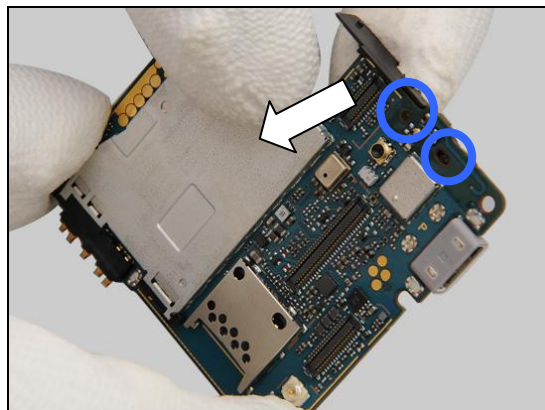
Place the new Carrier Holder Receiver Sub Assembly in the correct position.



Replacement: Carrier Holder Receiver Sub Assembly

Press to secure its position and attachment.

Note the two guiding holes.



Replacement

4.14 Cover Panel Bottom

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Cover Panel Bottom.

Carry out the Installation as described below.

Follow the 5.12 Reassembly instructions!

REMOVAL

Remove the two Screw Len:4.0 Diam:1.4 by a screwdriver with Bits (T4).



Slide the Guitar Pick to release the hooks of Cover Panel Bottom from left to right and remove it gently.



INSTALLATION

Place the Cover Panel Bottom in the correct position.



Replacement: Cover Panel Bottom

Press to secure its position.



Apply 10 ± 1 Ncm torque when tightening the two Screw
Len:4.0 Diam:1.4 with T4.

Take new screws!



Replacement

4.15 Cushion 0.0 mmSub PBA

Follow the 3.1 Disassembly instructions!

Follow the 4.14, 4.24 Removal instructions!

Carry out the Removal as described below.

Prepare a new Cushion 0.0 mmSub PBA.

Carry out the Installation as described below.

Follow the 4.14, 4.24 Installation instructions!

Follow the 5.12 Reassembly instructions!

REMOVAL

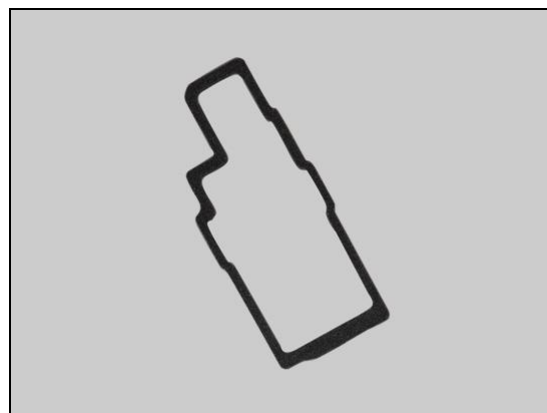
Peel off Cushion 0.0 mmSub PBA by using a Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place the new Cushion 0.0 mmSub PBA in the correct position.

Press to secure its attachment.



Replacement

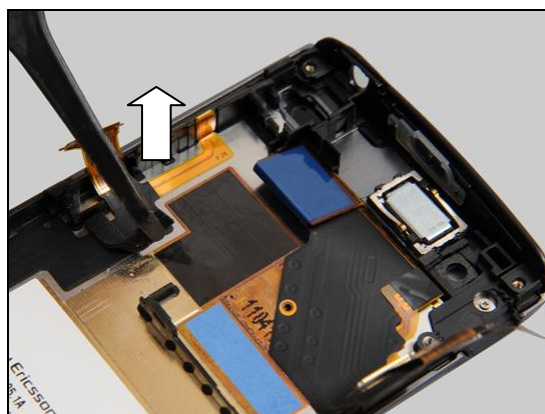
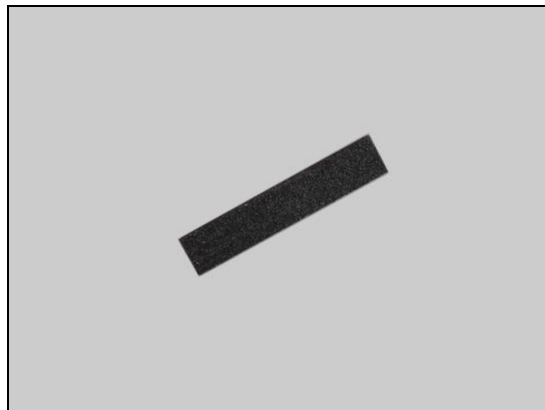
4.16 Cushion Batt Conn

Follow the 3.1 – 3.5 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare a new Cushion Batt Conn.
 Carry out the Installation as described below.
 Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

Peel off the Cushion Batt Conn by using a Flex Film Assembly Tool.

Scrap! Not to be reused!

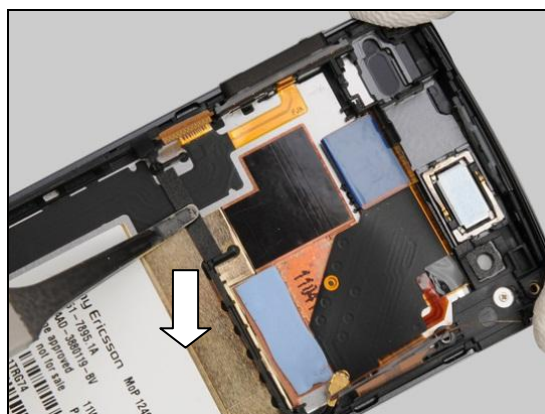


INSTALLATION

Place the new Cushion Batt Conn in the correct position.



Press to secure its attachment.



Replacement

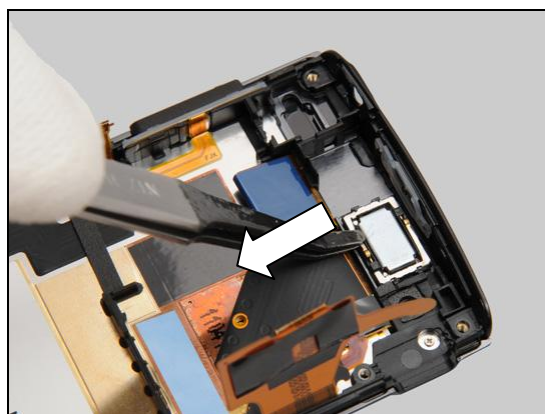
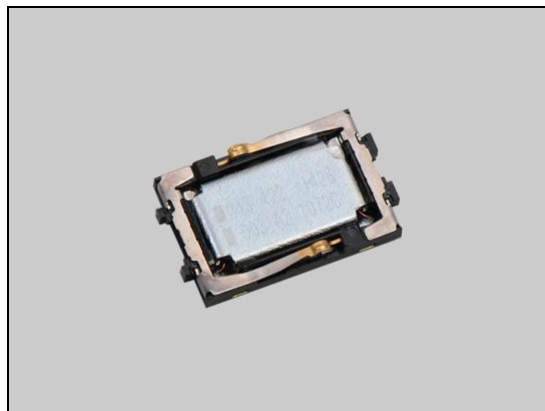
4.17 Ear Speaker

Follow the 3.1 – 3.5 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare a new Ear Speaker.
 Carry out the Installation as described below.
Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

Remove the Ear Speaker by using a Flex Film Assembly Tool.

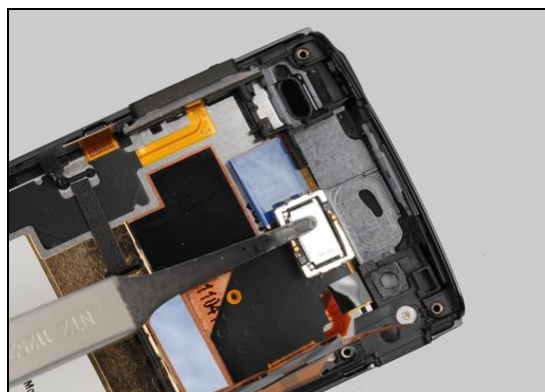
Do not touch the pins!



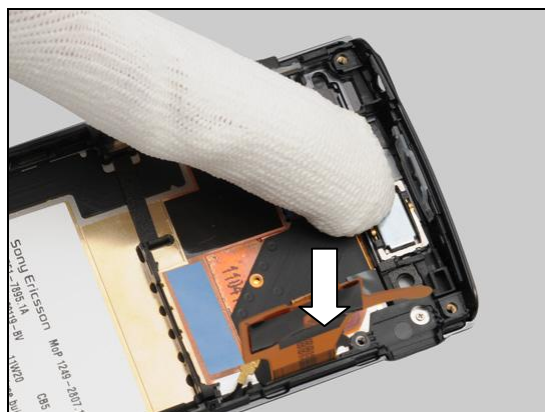
INSTALLATION

Place the new Ear Speaker in the correct position.

Note the correct direction of the Ear Speaker.



Press to secure its position and attachment.



Replacement

4.18 Foil Adhesive Double Side Receiver

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.17 Removal instructions!

Carry out the Removal as described below.

Prepare the new Foil Adhesive Double Side Receiver.

Carry out the Installation as described below.

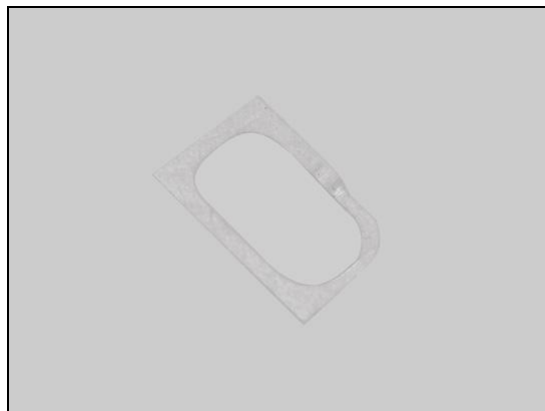
Follow the 4.17 Installation instructions!

Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

Peel off the Foil Adhesive Double Side Receiver by using a Flex Film Assembly Tool.

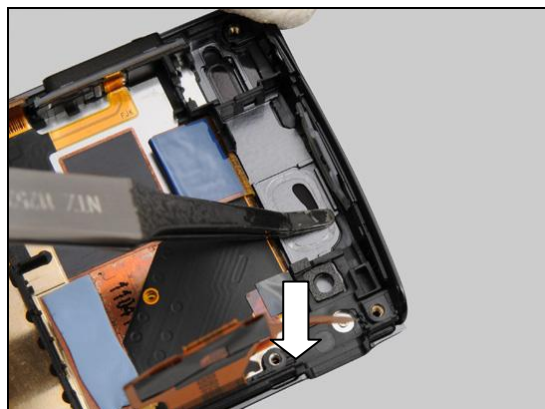
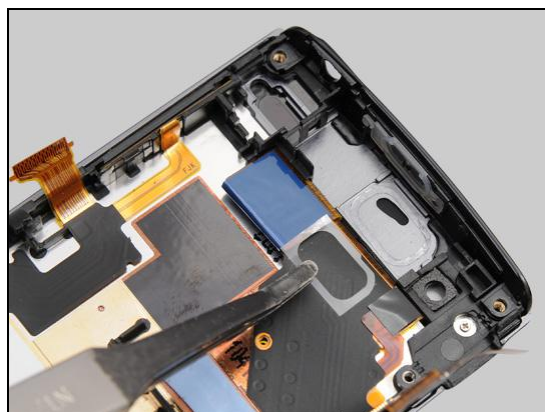
Scrap! Not to be reused!



INSTALLATION

Place the new Foil Adhesive Double Side Receiver in the correct position.

Press to secure its attachment.



Replacement

4.19 GPS Non-Cellular Antenna

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new GPS Non-Cellular Antenna.

Carry out the Installation as described below.

Follow the 5.12 Reassembly instructions!

REMOVAL

Detach the foil from the bottom by using a Flex Film Assembly Tool and remove it.



INSTALLATION

Place the new GPS Non-Cellular Antenna in the correct position.



Press to secure its position and attachment.





Replacement

4.20 Key Home

Follow the 3.1 Disassembly instructions!

Follow the 4.14, 4.24, 4.25, 4.33 Removal instructions!

Carry out the Removal as described below.

Prepare a new Key Home.

Carry out the Installation as described below.

Follow the 4.14, 4.24, 4.25, 4.33 Installation instructions!

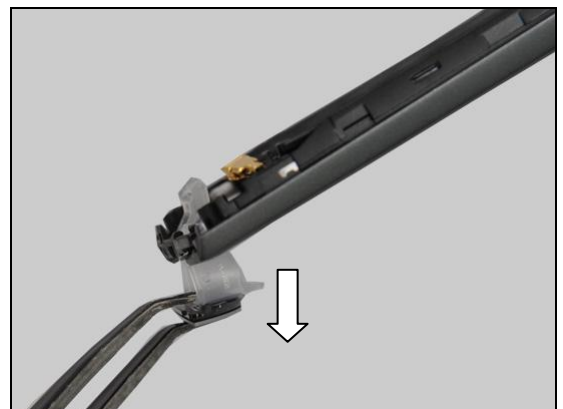
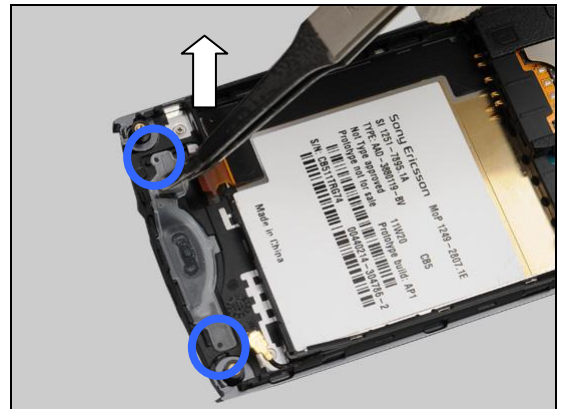
Follow the 5.12 Reassembly instructions!

REMOVAL

Lift up the rubber from the two holes.

Press the Key Home from inside to make it out of the cavity by using a Flex Film Assembly Tool.

Remove the Key Home from outside.





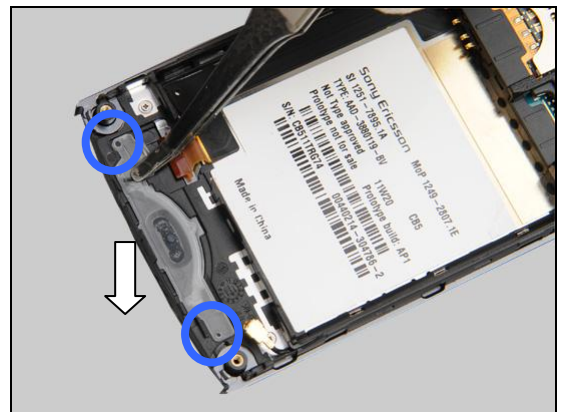
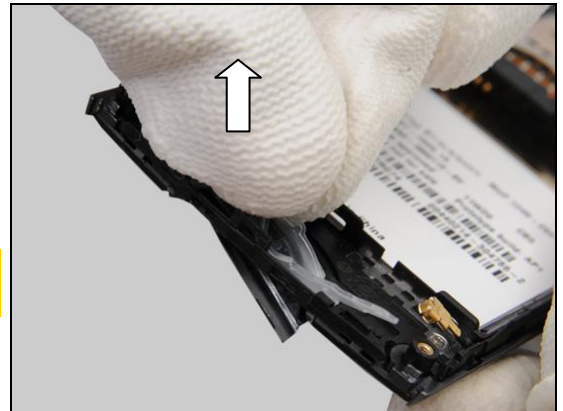
Replacement: Key Home

INSTALLATION

Move the Key Home into the cavity and secure its correct position.

Note: Make sure the rubber is completely out of the cavity.

Align the Key Home into the two guiding hole.



Replacement

4.21 Key On/Off

Follow the 3.1 – 3.5 Disassembly instructions!

Carry out the Removal as described below:

Prepare the new Key On/Off.

Carry out the Installation as described below.

Follow the 5.4– 5.12 Reassembly instructions!

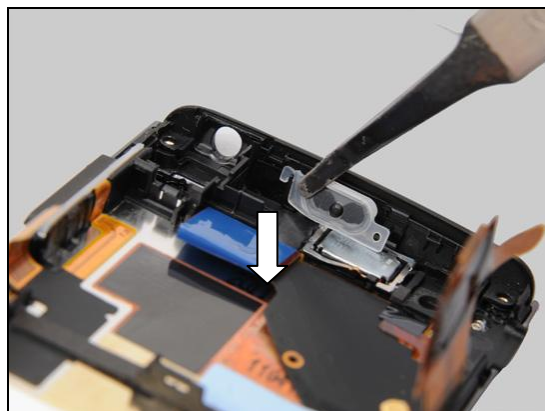
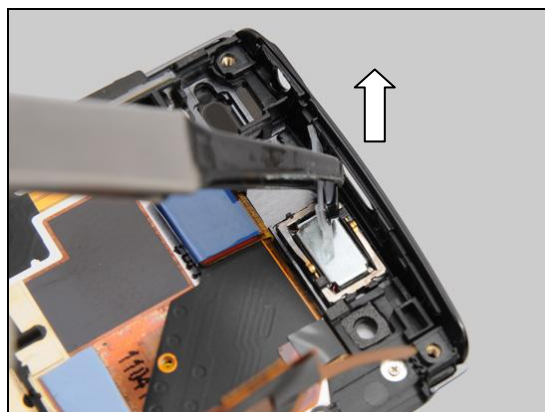
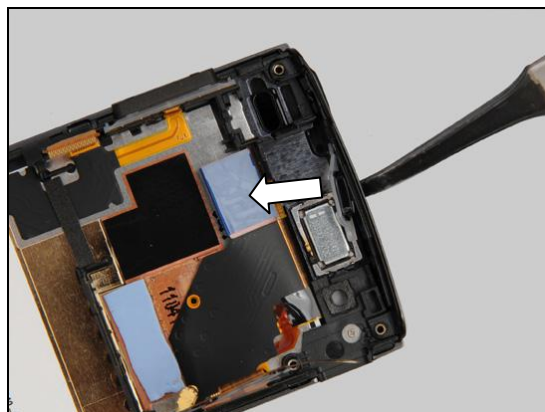
REMOVAL

Press the Key On/Off from outside by using a Flex Film Assembly Tool.

Remove the Key On/Off.

INSTALLATION

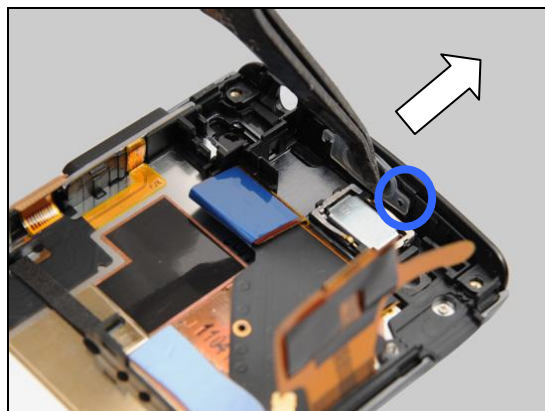
Insert the Key On/Off into the cavity in the left side.



Replacement: Key On/Off

Press to secure its position.

Note: Align the Key On/Off into the guiding hole.



Replacement

4.22 Key Volume

Follow the 3.1– 3.2 Disassembly instructions!

Carry out the Removal as described below.

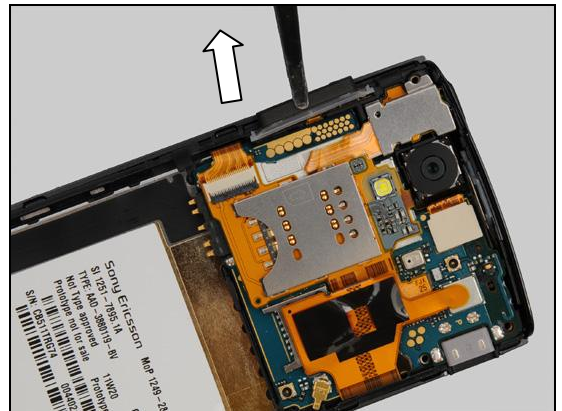
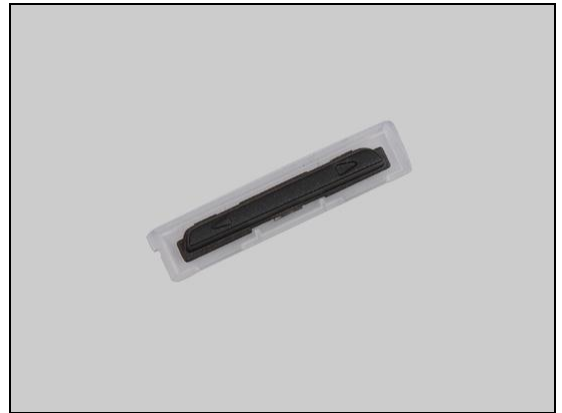
Prepare the new Key Volume.

Carry out the Installation as described below.

Follow the 5.11 – 5.12 Reassembly instructions!

REMOVAL

Remove the Key Volume.

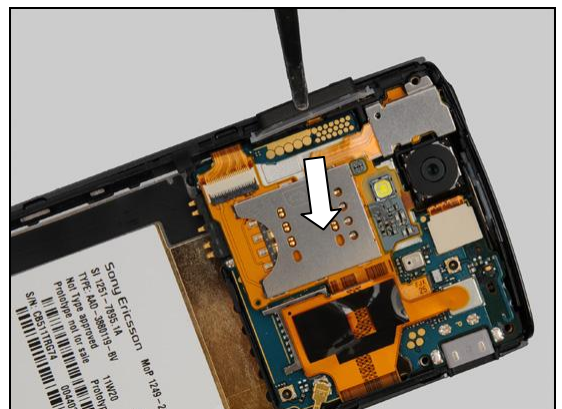


INSTALLATION

Place the Key Volume in the correct position.



Press to secure its position.





Replacement

4.23 Label Core Unit

Follow the 3.1 Disassembly instructions!

Carry out the Removal as described below.

Prepare the new Label Core Unit.

Carry out the Installation as described below.

Follow the 5.12 Reassembly instructions!

REMOVAL

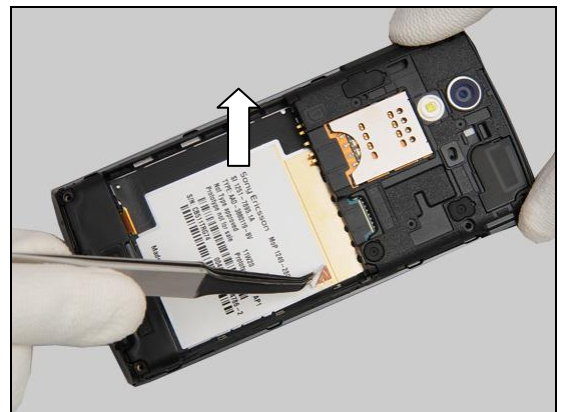
Copy old Core Unit Label information into the 'LabelMake' program.

Carefully remove the Label with Flex Film Assembly Tool.

INSTALLATION

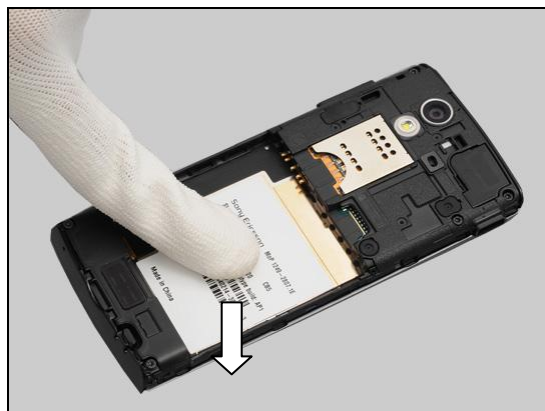
Check that the proper label format is loaded in the Zebra printer and print a new Label by using the 'LabelMake' software.

One label only is allowed!



Replacement: Label Core Unit

Press along the surface to make sure Label securely attached.



Replacement

4.24 Main Antenna Assy

Follow the 3.1 Disassembly instructions!

Follow the 4.14 Removal instructions!

Carry out the Removal as described below.

Prepare the new Main Antenna Assy.

Carry out the Installation as described below.

Follow the 4.14 Installation instructions!

Follow the 5.12 Reassembly instructions!

REMOVAL

Insert the Front Opening Tool from upper left to push the Main Antenna Assy gently.

Slide along upper side.

Remove the Main Antenna Assy.



Replacement: Main Antenna Assy

INSTALLATION

Place the Main Antenna Assy in the correct position.



Press to secure its position.



Replacement

4.25 MComp Sheet Relay CON

Follow the 3.1 Disassembly instructions!

Follow the 4.14, 4.24 Removal instructions!

Carry out the Removal as described below.

Prepare the new MComp Sheet Relay CON.

Carry out the Installation as described below.

Follow the 4.14, 4.24 Installation instructions!

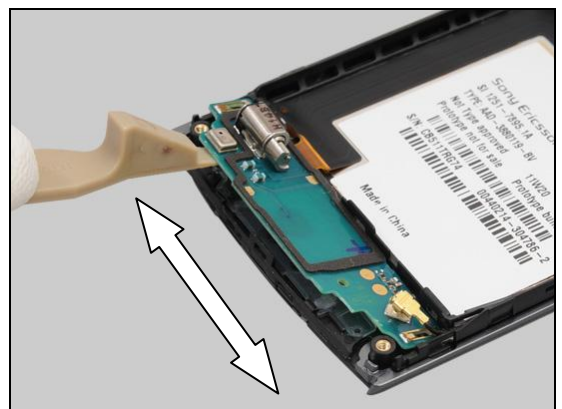
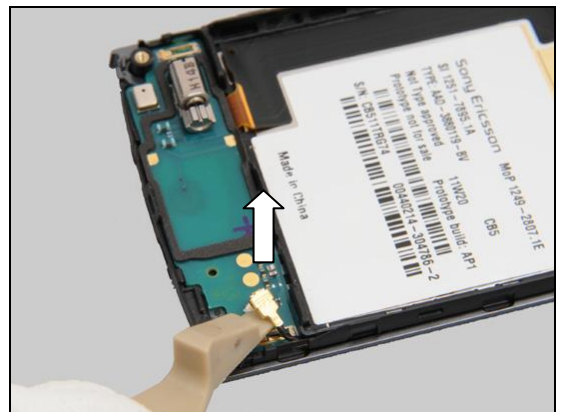
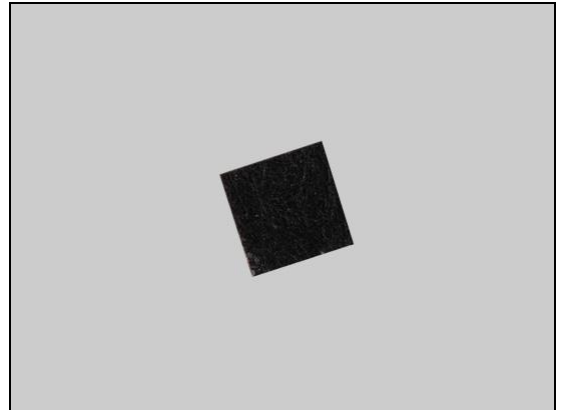
Follow the 5.12 Reassembly instructions!

REMOVAL

Unsnap the connector by using a Front Opening Tool.

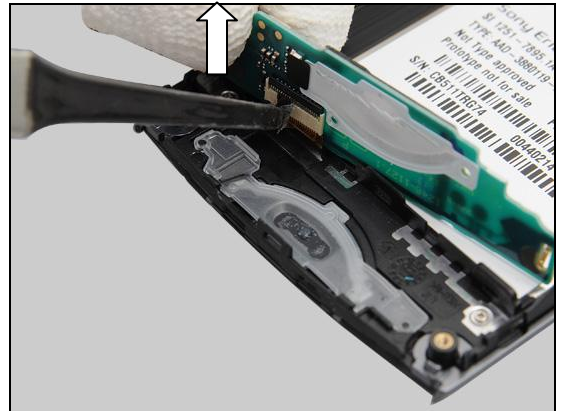
Insert the Front Opening Tool from right to lift up the Sub PBA gently.

Slide along the bottom side.



Replacement: MComp Sheet Relay CON

Peel off the MComp Sheet Relay CON.

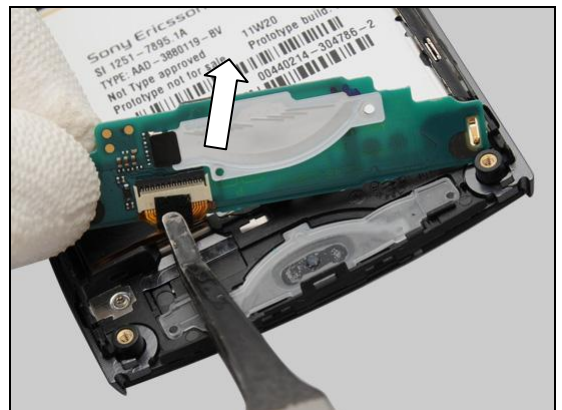


INSTALLATION

Place the new MComp Sheet Relay CON in the correct position.



Press to secure its attachment.



Turn over the Sub PBA and press to secure its position.



Replacement: MComp Sheet Relay CON

Snap the connector of RF Cable with finger.

Listen to the click sound.





Replacement

4.26 RF Radiator Sheet

Follow the 3.1 – 3.5 Disassembly instructions!
Carry out the Removal as described below.
Prepare a new RF Radiator Sheet.
Carry out the Installation as described below.
Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

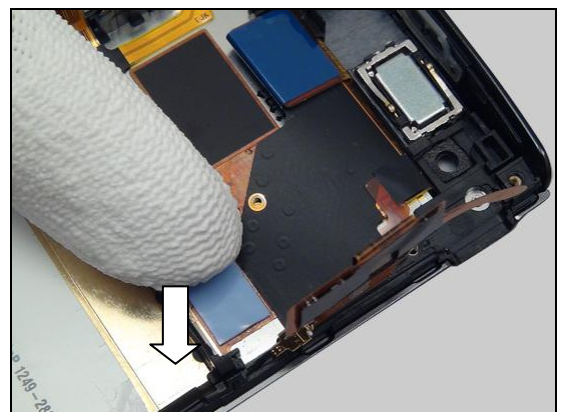
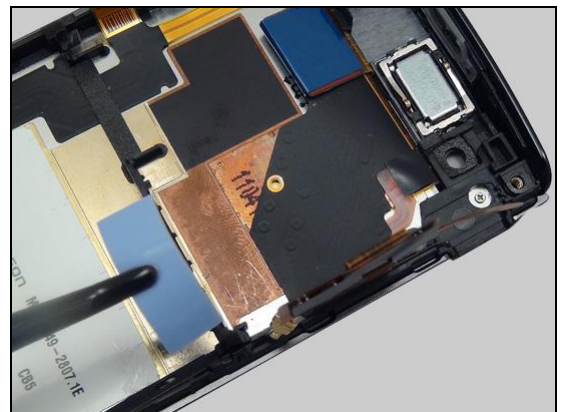
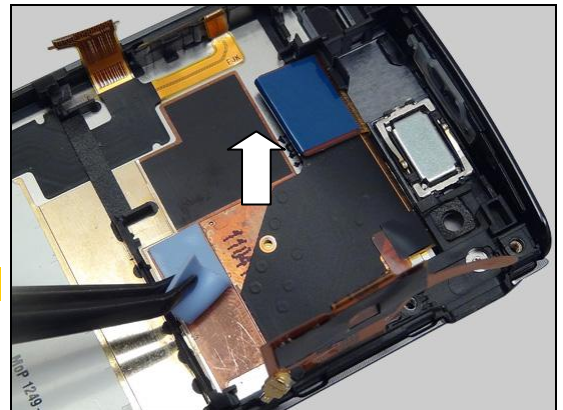
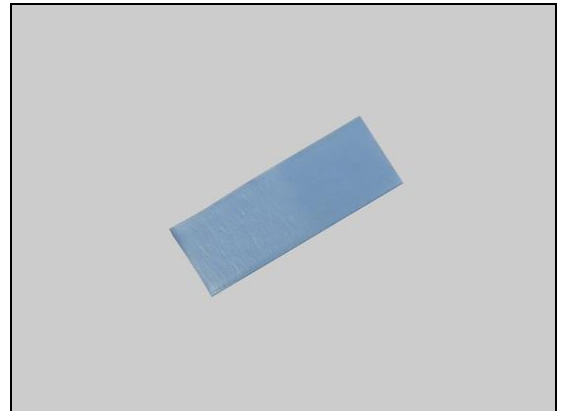
Peel off the RF Radiator Sheet by using a Flex Film Assembly Tool.

Scrap! Not to be reused!

INSTALLATION

Place the new RF Radiator Sheet in the correct position.

Press to secure its attachment.



Replacement

4.27 Sheet LCD BtoB

Follow the 3.1 – 3.5 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare a new Sheet LCD BtoB.
 Carry out the Installation as described below.
Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

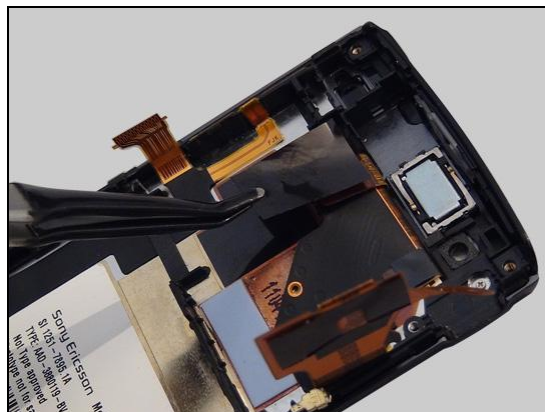
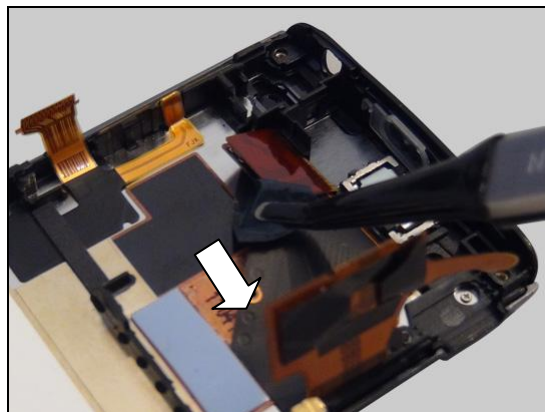
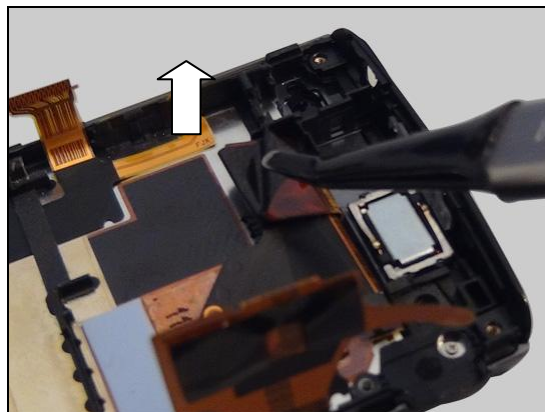
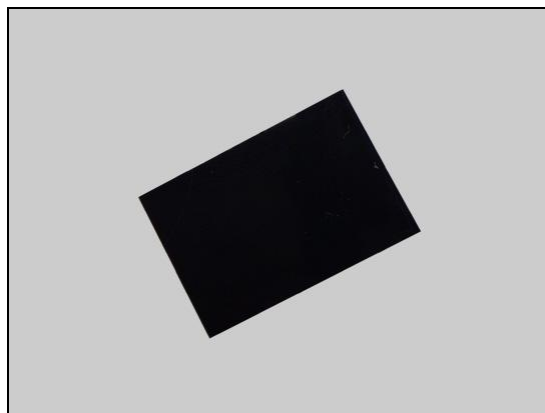
Peel off the Sheet LCD BtoB by using a Flex Film Assembly Tool.

Peel off the back side of Sheet LCD BtoB.

Scrap! Not to be reused!

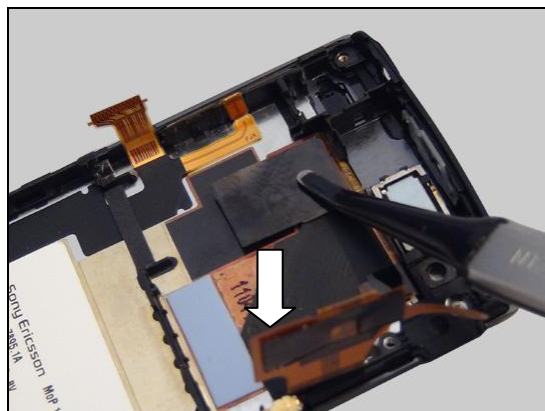
INSTALLATION

Place the new Sheet LCD BtoB in the correct position.

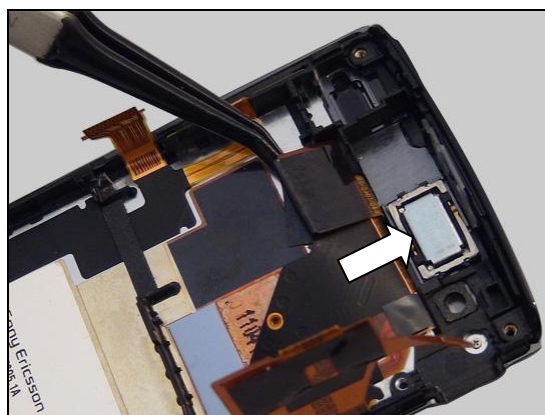


Replacement: Sheet LCD BtoB

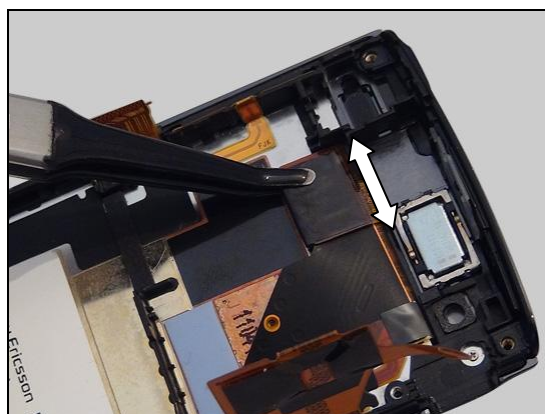
Press to secure its attachment.



Put the Sheet LCD BtoB to the back side along the bottom edge.



Press along to secure its attachment.





Replacement

4.28 Shield Can Lid MSM

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.32 Removal instructions!

Carry out the Removal as described below.

Prepare the Shield Can Lid MSM.

Carry out the Installation as described below.

Follow the 4.32 Installation instructions!

Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

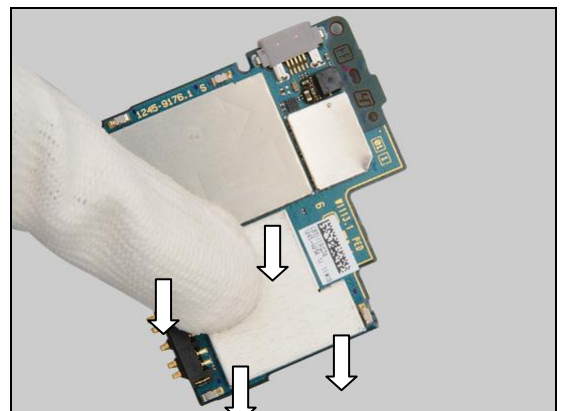
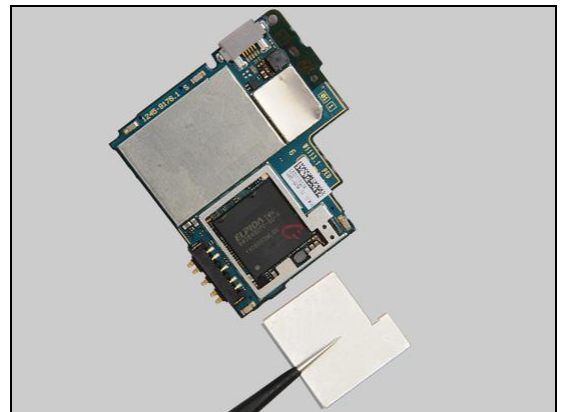
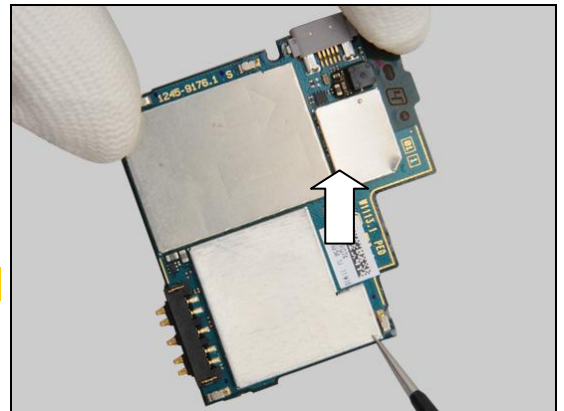
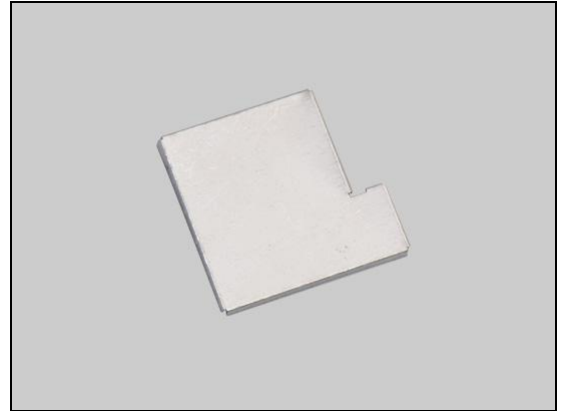
Unsnap the corners of the Shield Can Lid MSM with a pair of tweezers and remove it.

Scrap! Not to be reused!

INSTALLATION

Place a new Shield Can Lid MSM in the correct position.

Press to secure its position.



Replacement

4.29 Shield Can Lid Non-Cell

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.32 Removal instructions!

Carry out the Removal as described below.

Prepare the Shield Can Lid Non-Cell.

Carry out the Installation as described below.

Follow the 4.32 Installation instructions!

Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

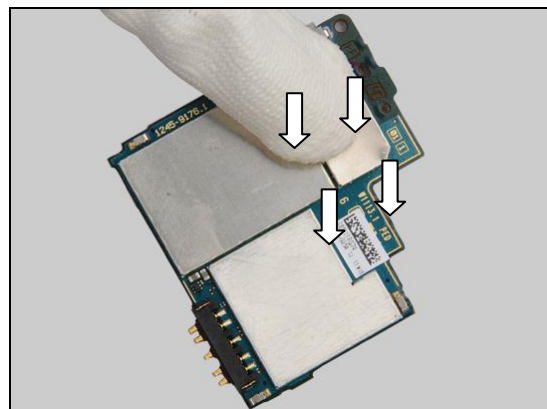
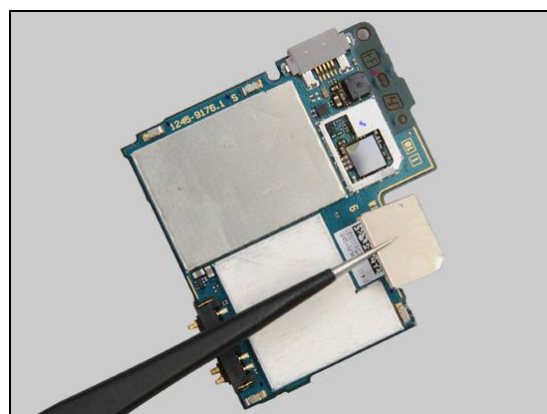
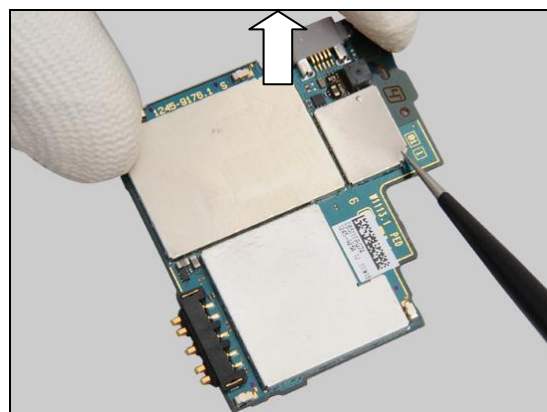
Unsnap the corners of the Shield Can Lid Non-Cell with a pair of tweezers and remove it.

Scrap! Not to be reused!

INSTALLATION

Place a new Shield Can Lid Non-Cell in the correct position.

Press to secure its position.



Replacement

4.30 Shield Can Lid PMIC

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.32 Removal instructions!

Carry out the Removal as described below.

Prepare the Shield Can Lid PMIC.

Carry out the Installation as described below.

Follow the 4.32 Installation instructions!

Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

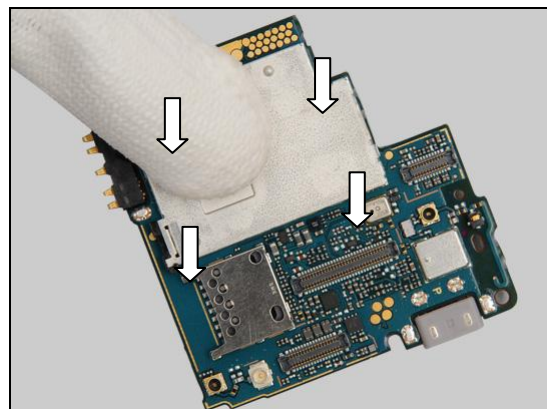
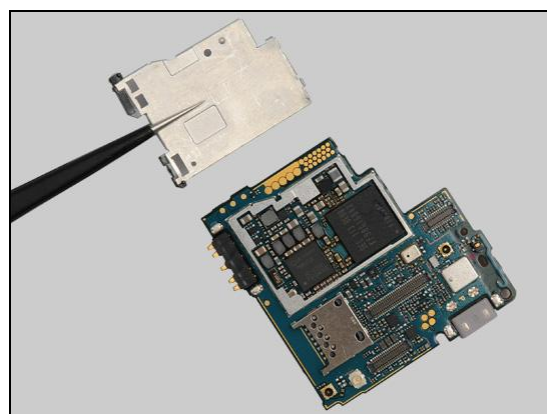
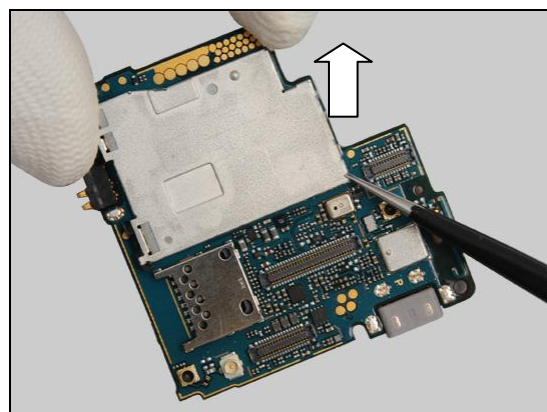
Unsnap the corners of the Shield Can Lid PMIC with a pair of tweezers and remove it.

Scrap! Not to be reused!

INSTALLATION

Place a new Shield Can Lid PMIC in the correct position.

Press to secure its position.



Replacement

4.31 Shield Can Lid RF

Follow the 3.1 – 3.5 Disassembly instructions!

Follow the 4.32 Removal instructions!

Carry out the Removal as described below.

Prepare the Shield Can Lid RF.

Carry out the Installation as described below.

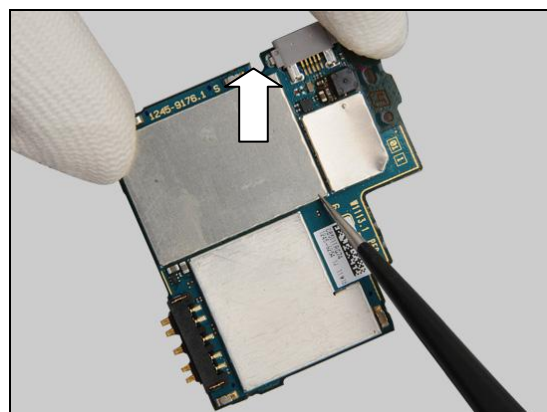
Follow the 4.32 Installation instructions!

Follow the 5.7 – 5.11 Reassembly instructions!

REMOVAL

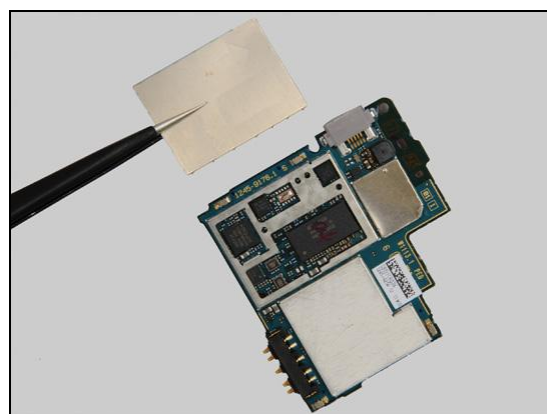
Unsnap the corners of the Shield Can Lid RF with a pair of tweezers and remove it.

Scrap! Not to be reused!

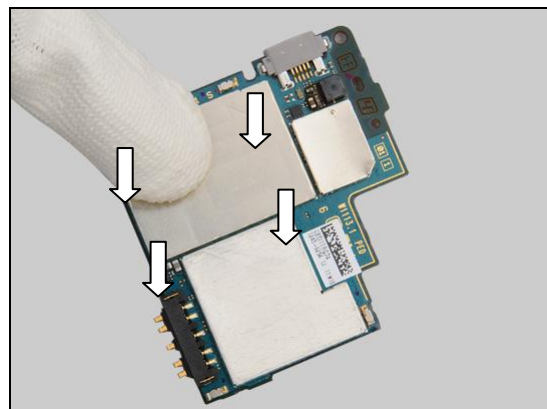


INSTALLATION

Place a new Shield Can Lid RF in the correct position.



Press to secure its position.



Replacement

4.32 SIM FPC Module

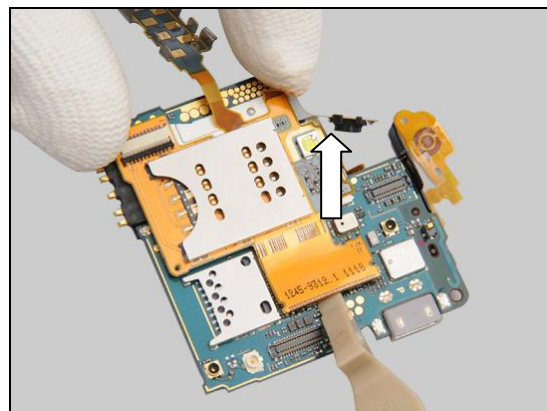
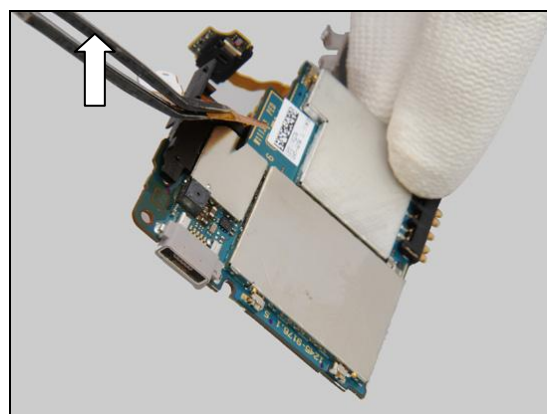
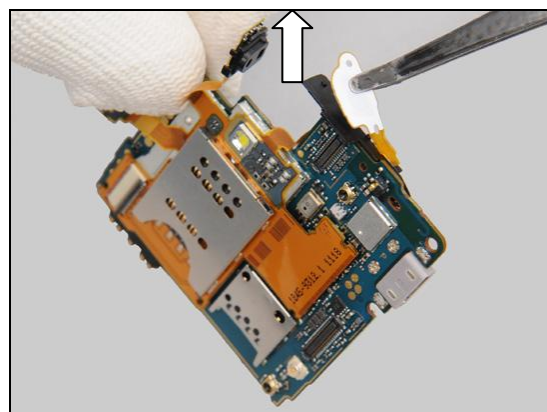
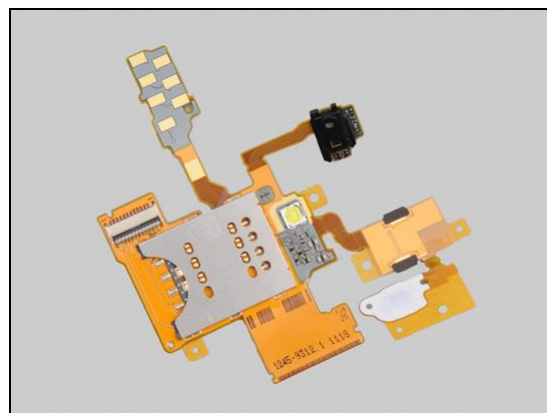
Follow the 3.1 – 3.5 Disassembly instructions!
 Carry out the Removal as described below.
 Prepare the SIM FPC Module.
 Carry out the Installation as described below.
Follow the 5.4 – 5.12 Reassembly instructions!

REMOVAL

Detach the foil of the dome.

Peel off the FPC gently.

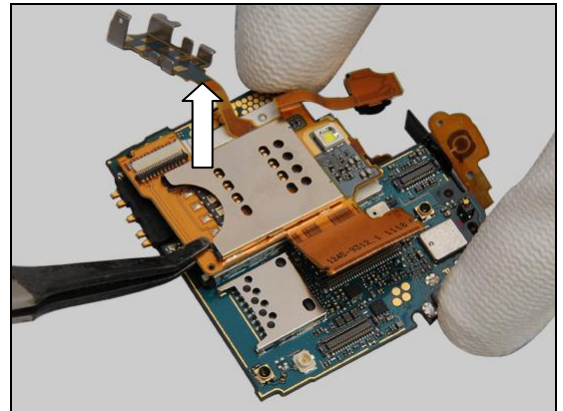
Unsnap the BtB connector by using a Front Opening Tool.



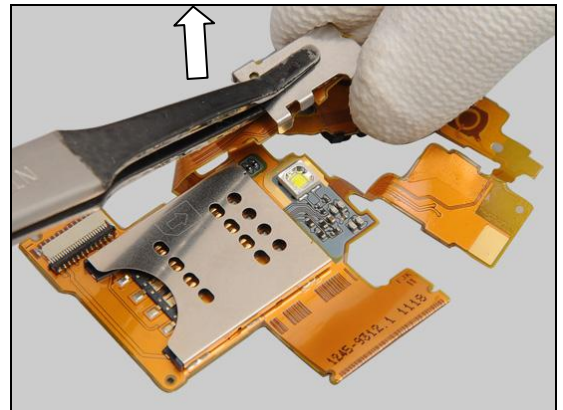


Replacement: SIM FPC Module

Lift up SIM FPC Module at lower right corner by using a Flex Film Assembly Tool.

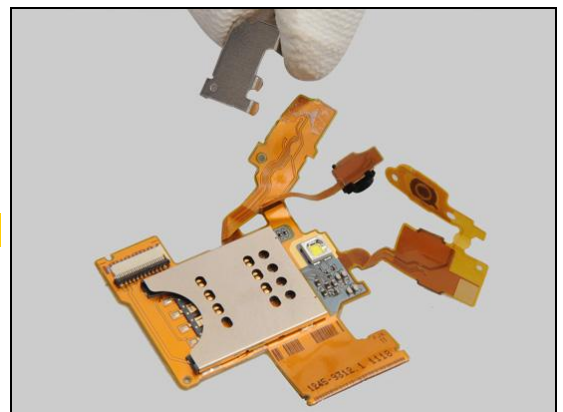


Detach the foil of Audio Jack Plate by using a Flex Film Assembly Tool.



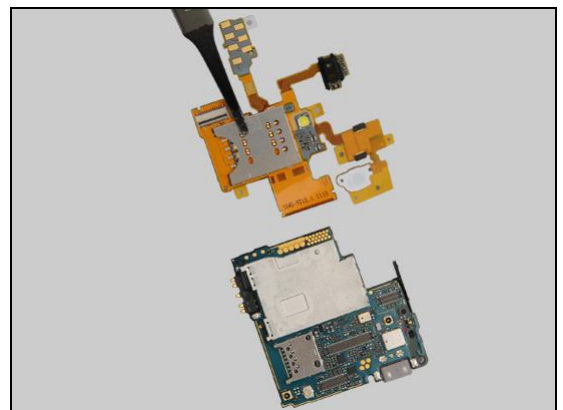
Remove the Audio Jack Plate.

Scrap! Not to be reused!



INSTALLATION

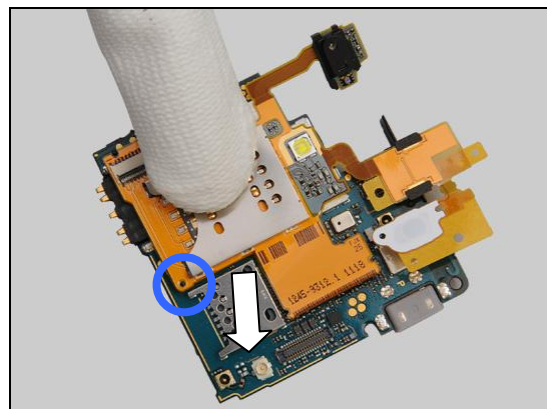
Place a new SIM FPC Module in the correct position.



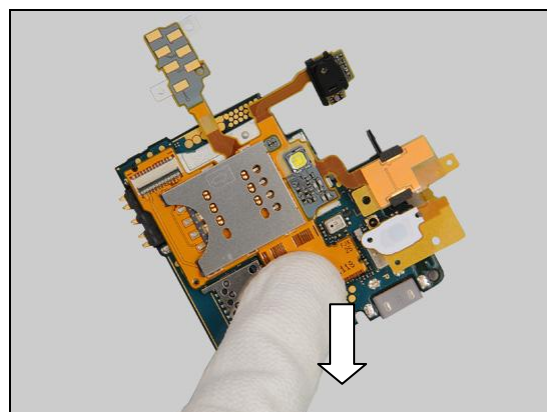
Replacement: SIM FPC Module

Press to secure its attachment.

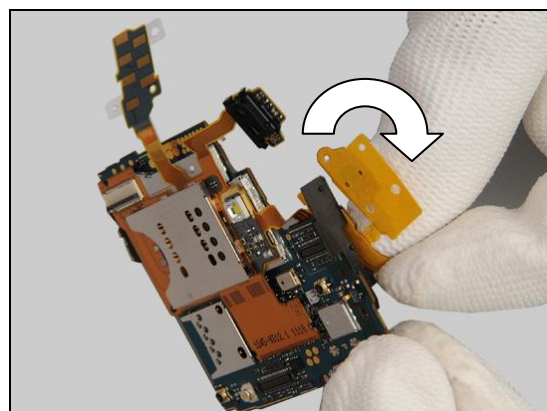
Note the guiding hole.



Snap the BtB connector.

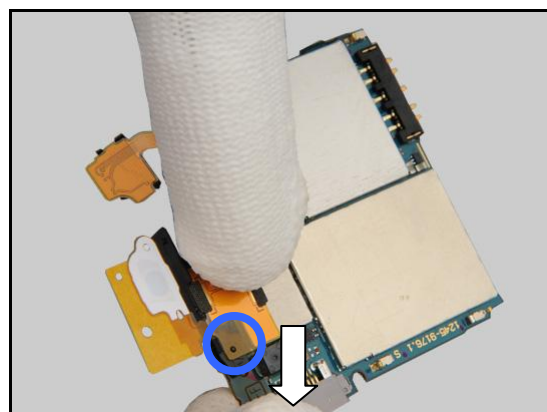


Turn the FPC to the back side.



Press to secure its attachment.

Note the guiding hole.

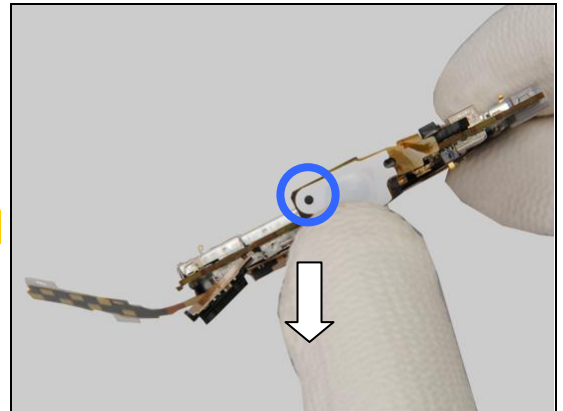




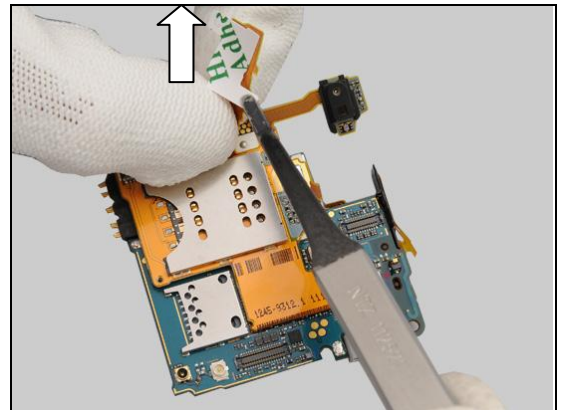
Replacement: SIM FPC Module

Press to key dome to secure its attachment.

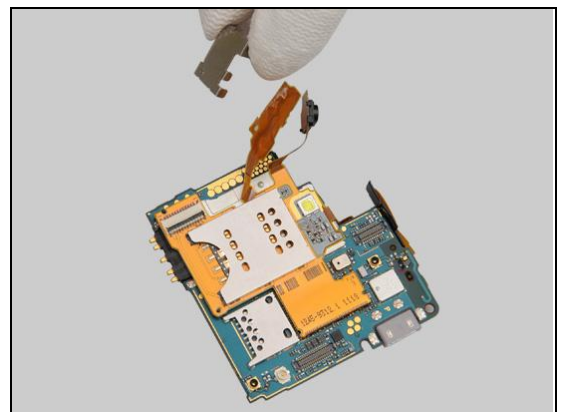
Note the guiding hole.



Peel off the protection tape.

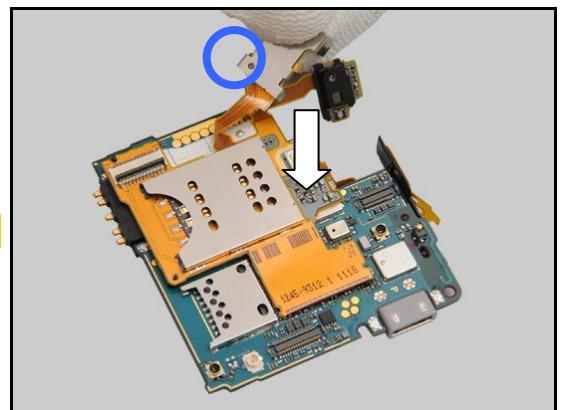


Place the new Audio Jack Plate in the correct position.



Press to secure its attachment.

Note the guiding hole.



Replacement

4.33 Sub PBA

Follow the 3.1 Disassembly instructions!

Follow the 4.14, 4.24, 4.25 Removal instructions!

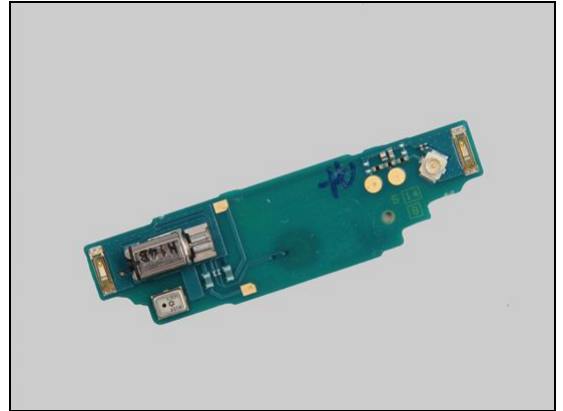
Carry out the Removal as described below.

Prepare the new Sub PBA.

Carry out the Installation as described below.

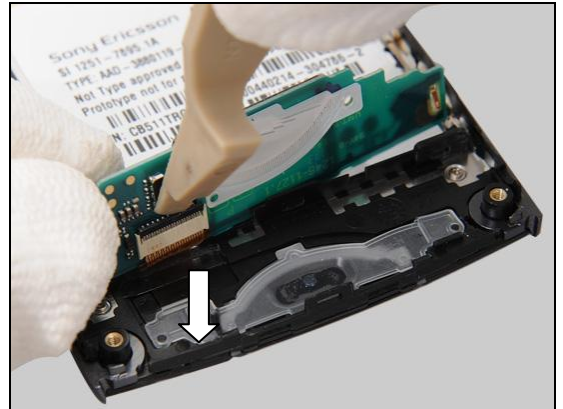
Follow the 4.14, 4.15, 4.24, 4.25, 4.34 Installation instructions!

Follow the 5.12 Reassembly instructions!

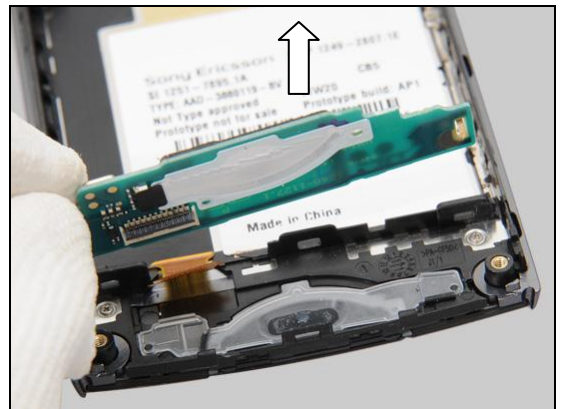


REMOVAL

Unsnap the ZIF connector by using a Front Opening Tool.

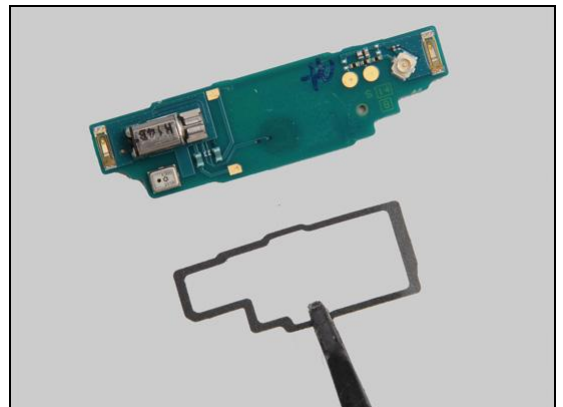


Pull out the Sub PBA.



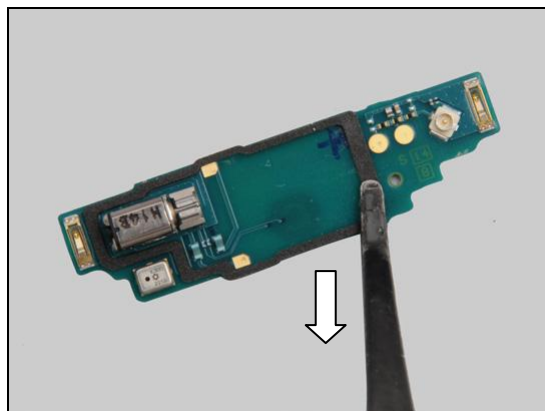
INSTALLATION

Place the new Cushion 0.0 mm Sub PBA in the correct position.

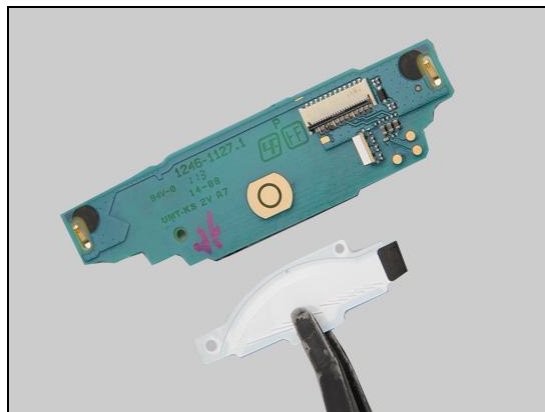


Replacement: Sub PBA

Press to secure its attachment.

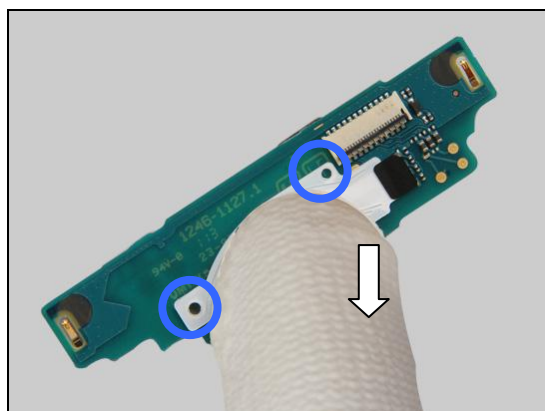


Place the new Sub PBA Dome Switch in the correct position.



Press to secure its attachment.

Note the two guiding holes!



Connect the ZIF connector.



Replacement: Sub PBA

Snap the ZIF connector by using a Front Opening Tool.





Replacement

4.34 Sub PBA Dome Switch

Follow the 3.1 Disassembly instructions!

Follow the 4.14, 4.24, 4.25, 4.33 Removal instructions!

Carry out the Removal as described below.

Prepare the new Sub PBA Dome Switch.

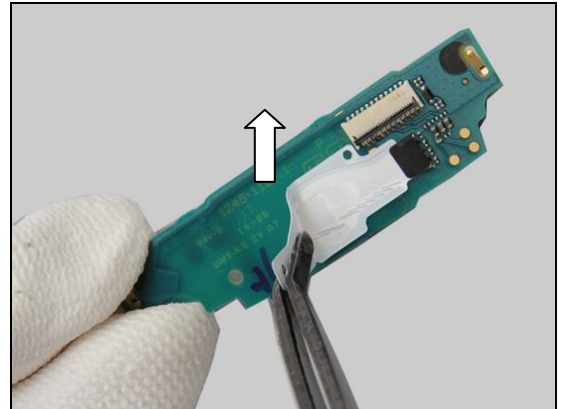
Carry out the Installation as described below.

Follow the 4.14, 4.24, 4.25, 4.33 Installation instructions!

Follow the 5.12 Reassembly instructions!

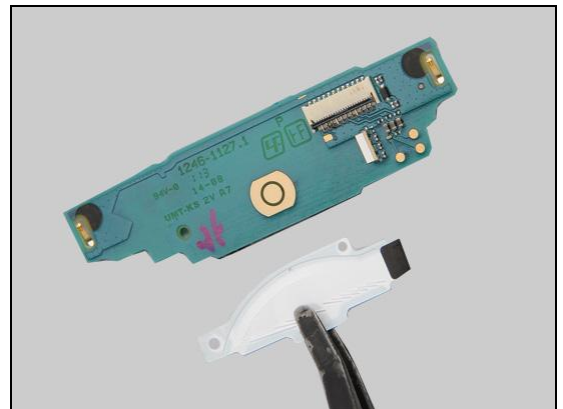
REMOVAL

Peel off the Sub PBA Dome Switch from left side.



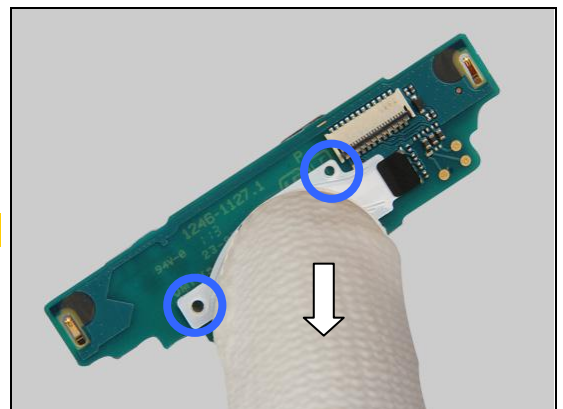
INSTALLATION

Place the new Sub PBA Dome Switch in the correct position.



Press to secure its attachment.

Note the two guiding holes.



Replacement

4.35 Board Swap - Replacement

Follow the 3.1 – 3.5 Disassembly instructions.

Follow the 4.13, and 4.32 Removal instructions.

Replace the Swap Board.

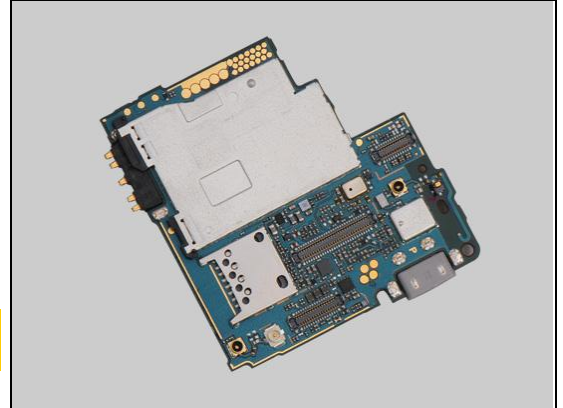
Reuse Camera.

NOTE: Remove protection cover from chat camera

Follow the 4.13, and 4.32 Installation instructions.

Follow the 5.4 – 5.12 Reassembly instructions.

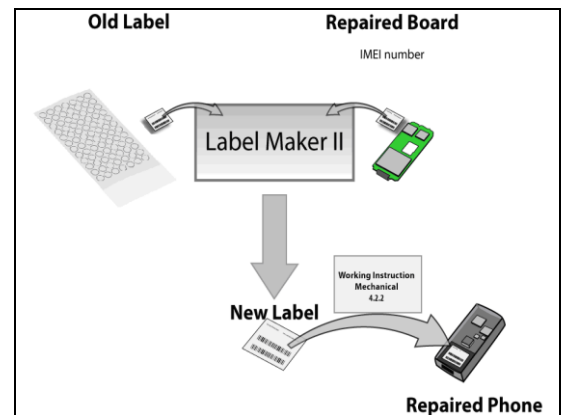
**Startup the unit to initialize settings, before performing
Customize Phone in Emma.**



4.36 Board Swap – Change Label

CHANGE LABEL

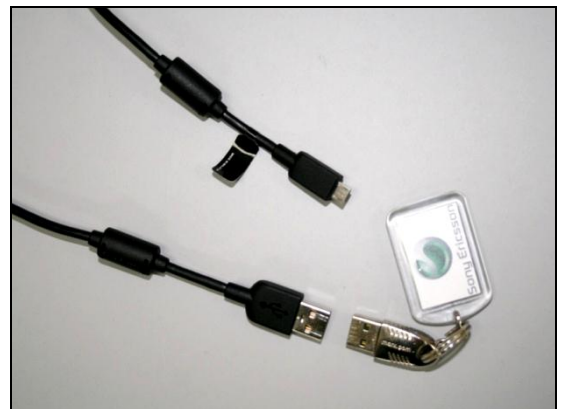
Follow the instructions in the Generic Repair Manual –
Build swap for change of label.



4.37 Board Swap – Customize of Software

CUSTOMIZE OF SOFTWARE

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

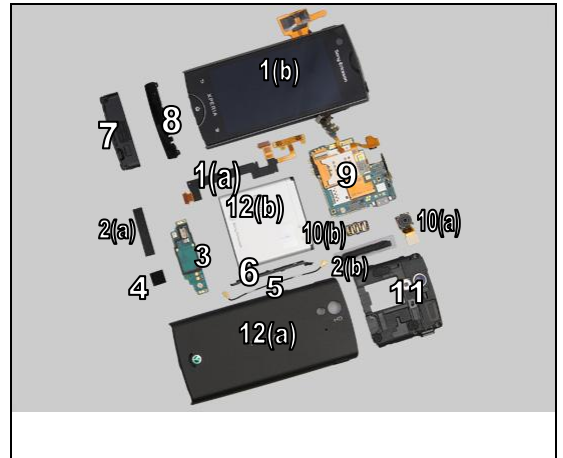




5 Reassembly

The reassembly is done in the following order:

1. Relay FPC (a) & Cover Front Assy (b)
2. Cushion Batt Conn (a) & Key Volume (b)
3. Sub PBA
4. MComp Sheet Relay CON
5. RF Cable
6. Cable Cover Insert
7. Main Antenna Assy
8. Cover Panel Bottom
9. Main PBA
10. Main Camera (a) & Audio Jack (b)
11. Cover Rear Assembly
12. Cover Battery (a) & Battery (b)
11. Cover Battery & Battery



5.1 Relay FPC & Cover Front Assy

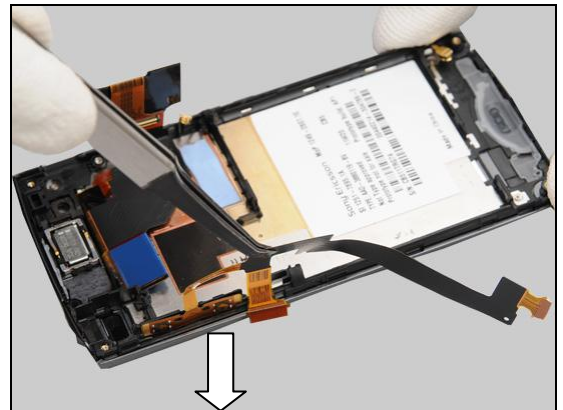
Place the Relay FPC and Cover Front Assy.

On Cover Front Assy, check that no damage to following;

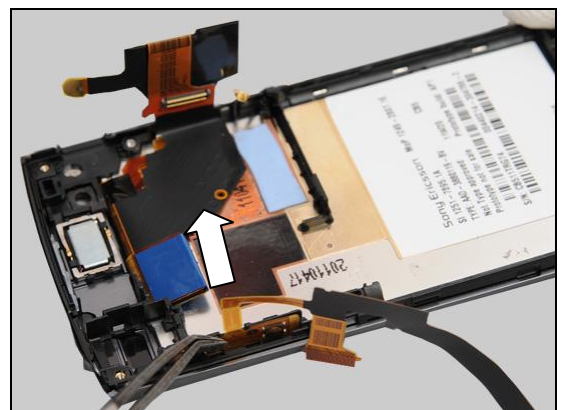
1. RF Radiator Sheet "Refer to page 43".
2. Sheet LCD BtoB before continuing with assembly! "Refer to page 44".



Place the key dome with proper direction into the slot.

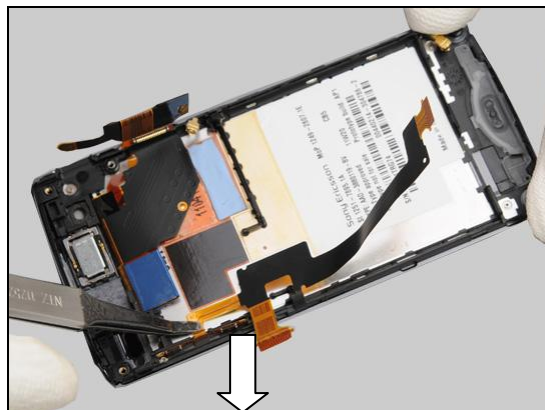


Press to secure its attachment.

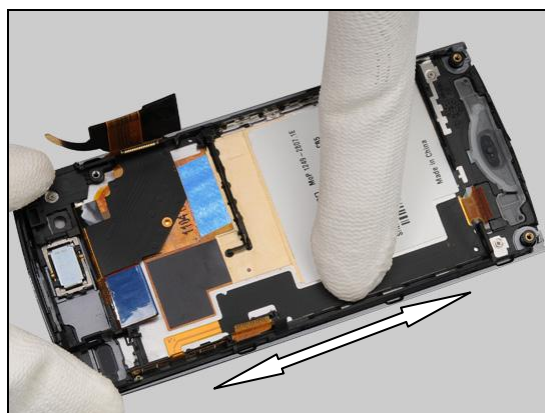


Reassembly

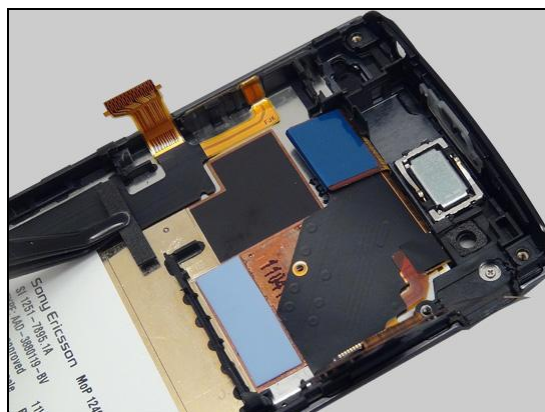
Kink the FPC and secure its attachment.



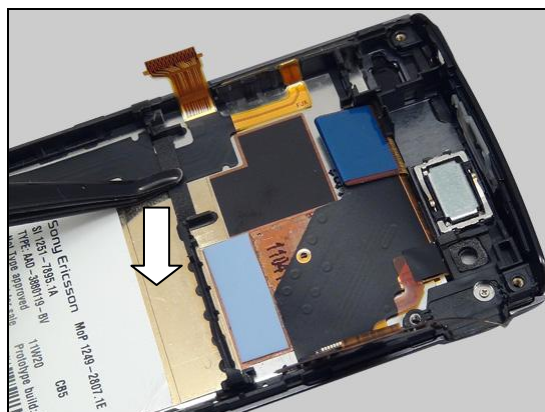
Press along the Relay FPC to secure its attachment.



Place the new Cushion Batt Conn in the correct position.



Press to secure its attachment.

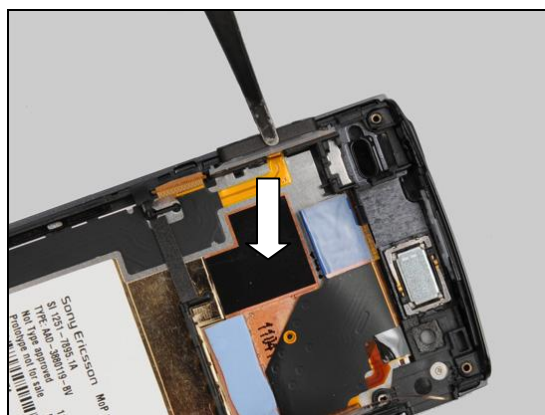


Reassembly

Place the Key Volume in the correct position.



Press to secure its position.



5.2 Sub PBA

Place the Sub PBA and Cover Front Assy.

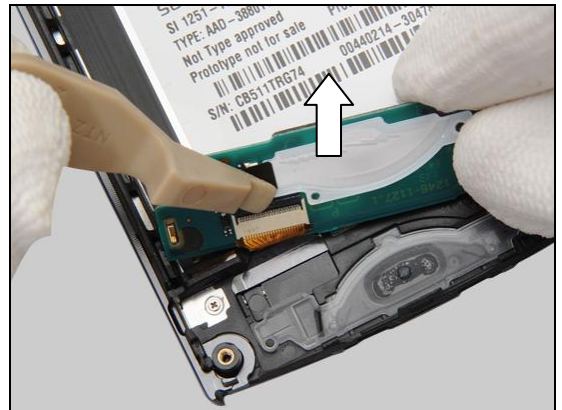


Connect the ZIF connector by using a Flex Film Assembly Tool.



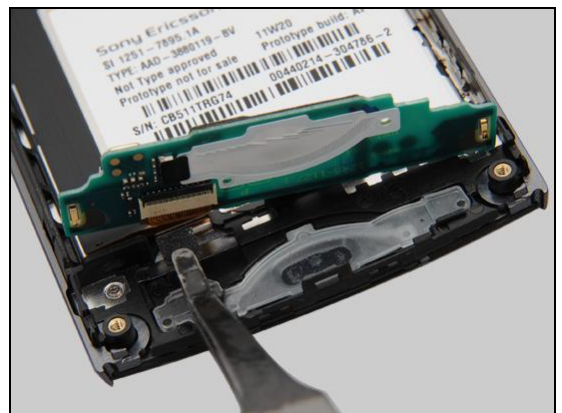
Reassembly

Snap the ZIF connector by using a Front Opening Tool.

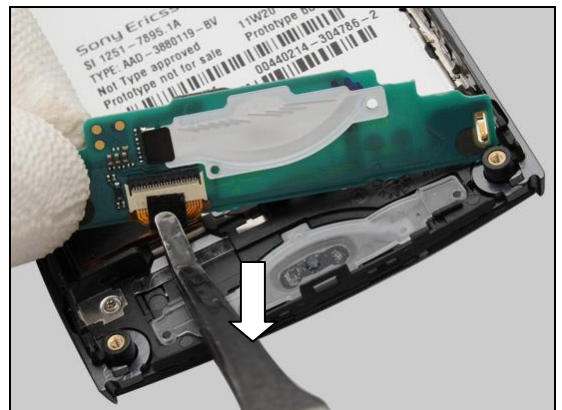


5.3 MComp Sheet Relay CON

Place the new MComp Sheet Relay CON in the correct position.



Press to secure its attachment.



Turn over the Sub PBA and press to secure its position.

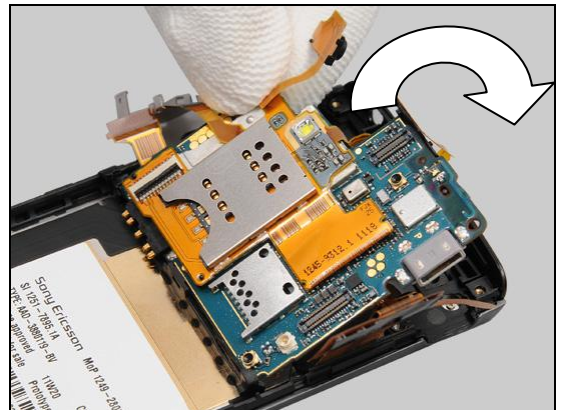


Reassembly

5.4 Main PBA

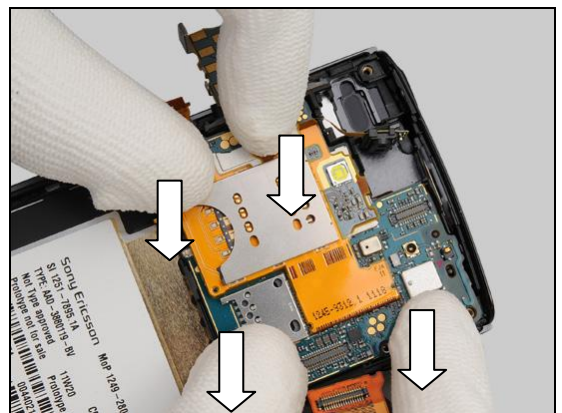
Place the Main PBA into the socket from bottom side.

Note: On PBA top spring connector, check that no damage to spring before continuing with assembly!

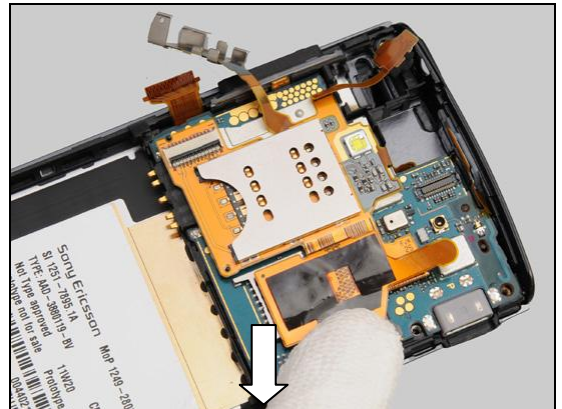


Press the Main PBA to secure its position.

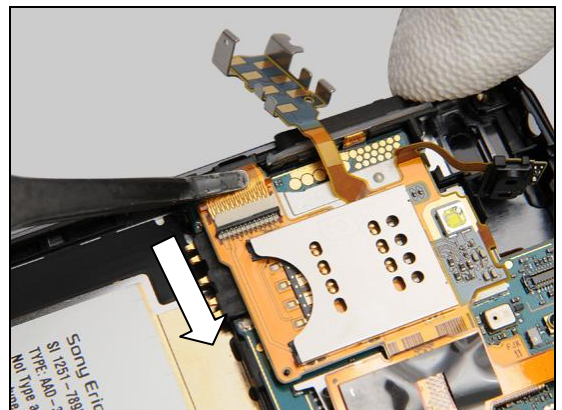
Note: Do not bend top panel! And make the FPC outside.



Snap the BtB connector.

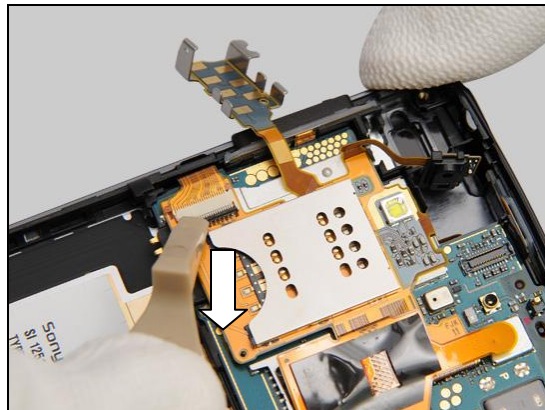


Connect the ZIF connector by using a Flex Film Assembly Tool.

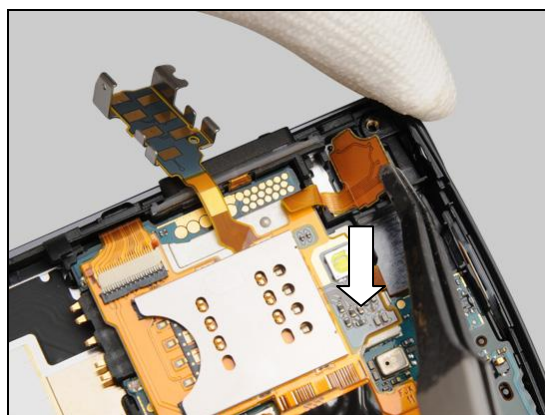


Reassembly

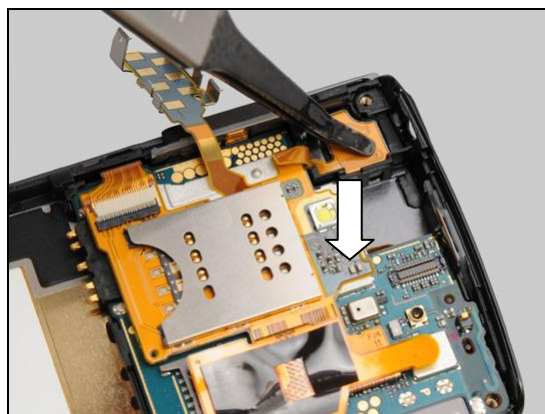
Snap the ZIF connector by using a Front Opening Tool.



Place the FPC into the socket.

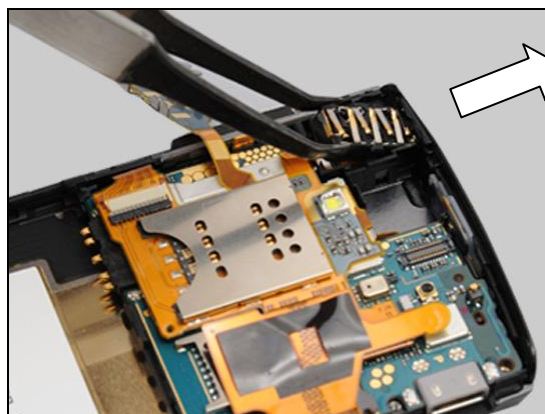


Press to secure its position.



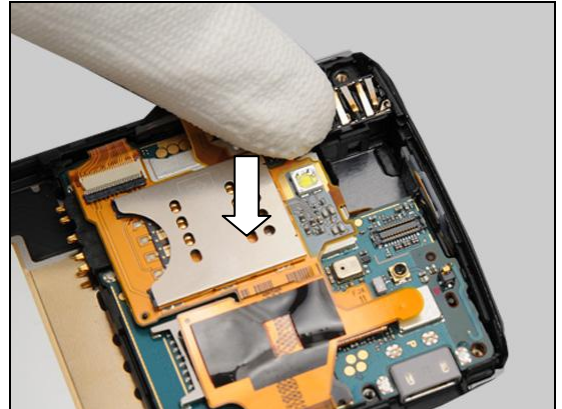
5.5 Audio Jack

Place the Audio Jack into the socket.

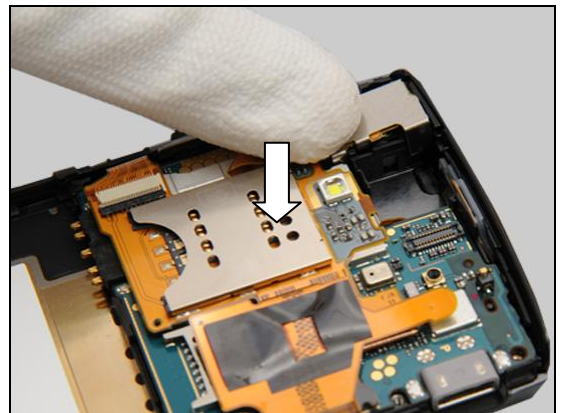


Reassembly

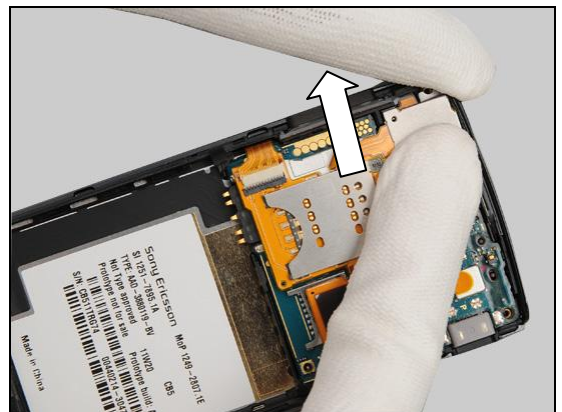
Press to secure its position.



Place the Audio Jack Plate in the correct position.

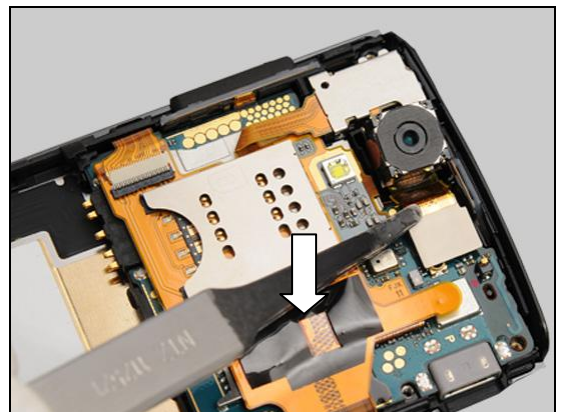


Press and push from right to left to lock it.



5.6 Main Camera

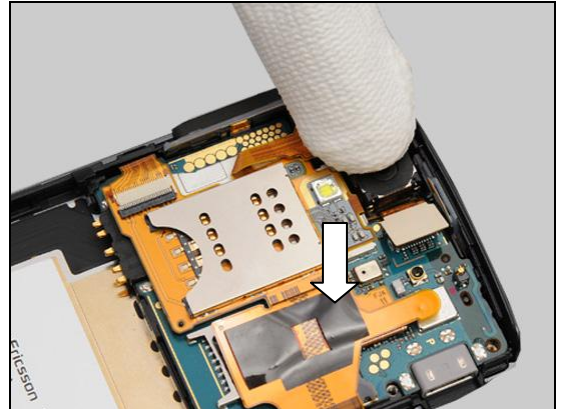
Place the Main Camera into socket with 30 degree tilt with fingers.



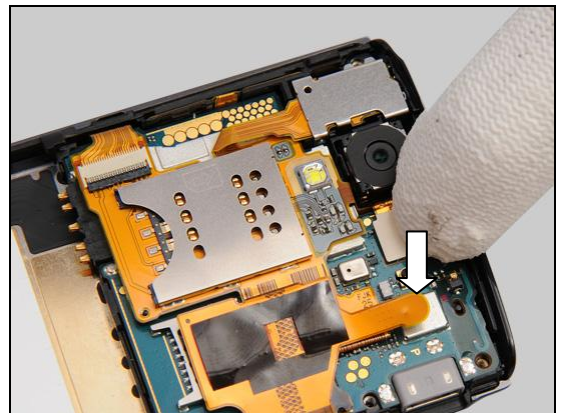
Reassembly

Press to secure its position gently.

Note: Be careful of FPC when press.



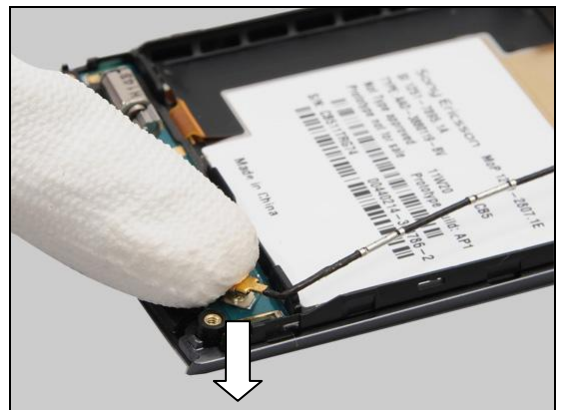
Snap the BtB connector with fingers.



5.7 RF Cable

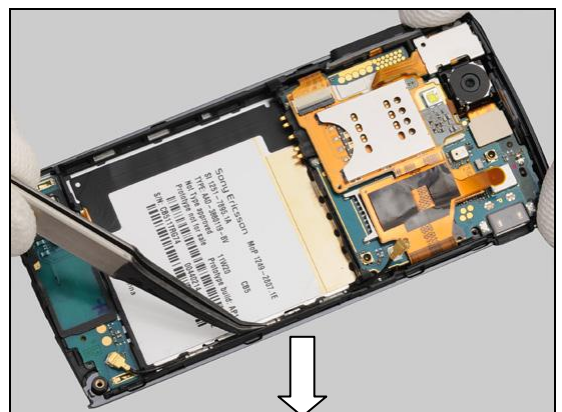
Snap the connector of RF Cable with fingers.

Listen to the click sound.



Place the RF Cable in the fixing sockets by using a Flex Film Assembly Tool.

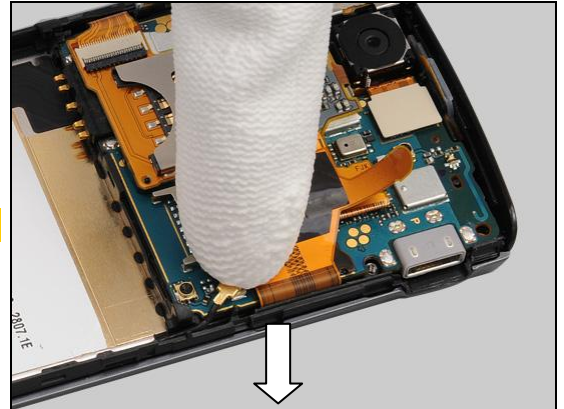
Note: Gently secure the cable without causing damage.



Reassembly

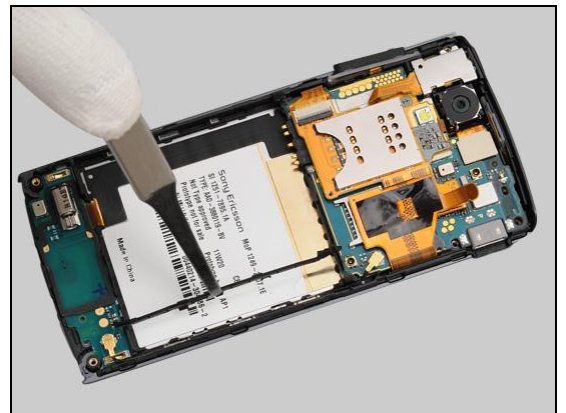
Snap the connector of RF Cable with fingers.

Listen to the click sound.

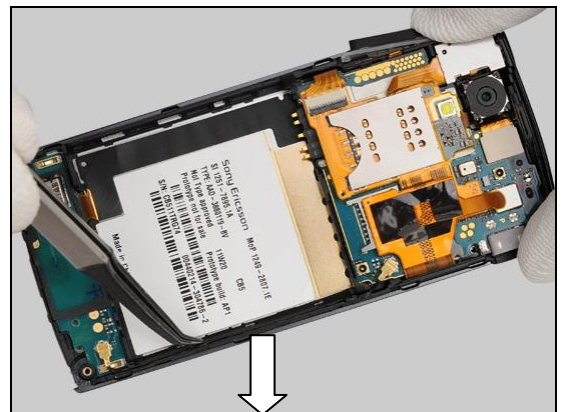


5.8 Cable Cover Insert

Place the Cable Cover Insert in the correct position.



Push to snap the hooks with Flex Film Assembly Tool.



5.9 Main Antenna Assy

Place the Main Antenna Assy in the correct position.



Reassembly

Press to secure its position.



5.10 Cover Panel Bottom

Place the Cover Panel Bottom in the correct position.

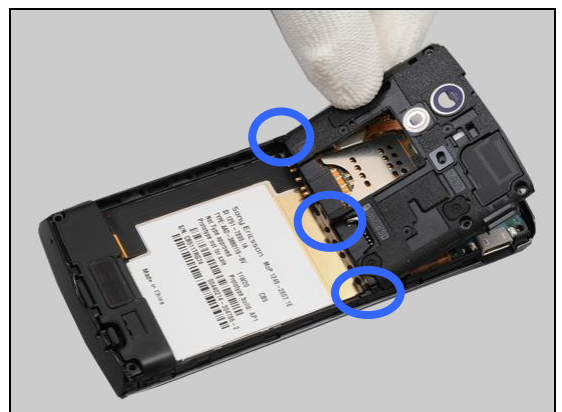


Press to secure its position.



5.11 Cover Rear Assembly

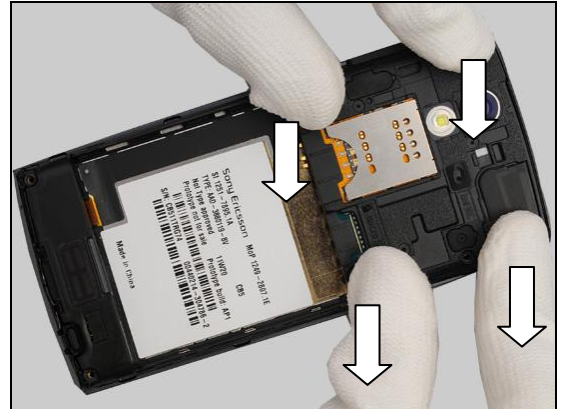
Place the Cover Rear Assembly from bottom side to secure the three hooks position.





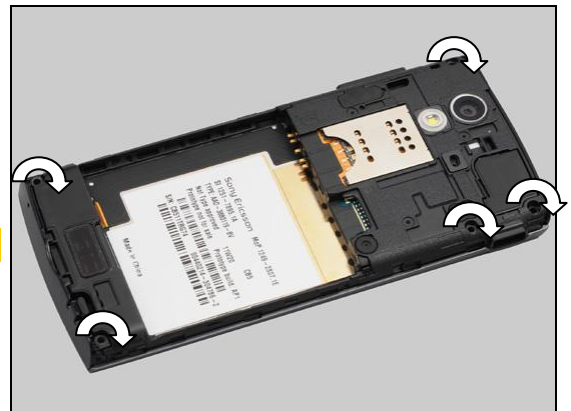
Reassembly

Press the corner, the middle of Cover Lower Rear to snap it, securing the cover.



Apply 10 ± 1 Ncm torque when tightening the five Screw
Len:4.0 Diam:1.4 with T4.

Take new screws!



5.12 Cover Battery

Place the Battery in the correct position.



Press the Battery into its cavity.

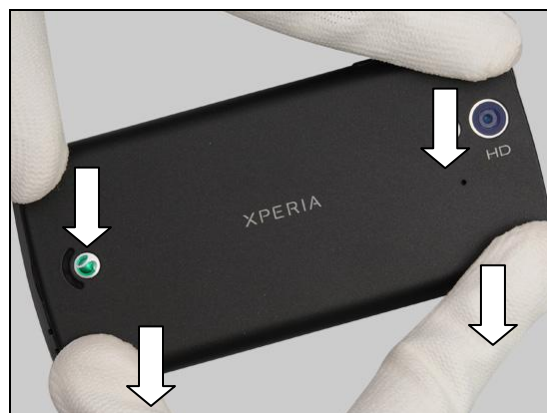


Reassembly

Place the Cover Battery in the correct position.



Press to snap it.





6 Revision History

Rev.	Date	Changes / Comments
1	2011-Aug-10	Released
2	2011-Sep-02	Add new part RF Radiator Sheet
3	2011-Sep-13	Torx Bit changed
4	2011-Sep-16	Chapters Added 4.33, 4.34 & 4.35
5	2011-Sep-16	Java System Error (No Change)
6	2011-Sep-16	Java System Error (No Change)
7	2011-Sep-16	4.33 Picture updated
8	2011-Sep-16	Chapter 4.33 Text update
9	2011-Sep-16	Java System Error (No Change)
10	2011-Dec-20	Java System Error (No Change)
11	2011-Dec-20	Add new part 1251-8844
12	2011-Dec-21	Section 5.1 updated
13	2012-Okt-05	Main display V-sync calibration added to 4.8