

Working Instructions

- mechanical -



X10i, X10a, SO-01B

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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 X10i, X10a



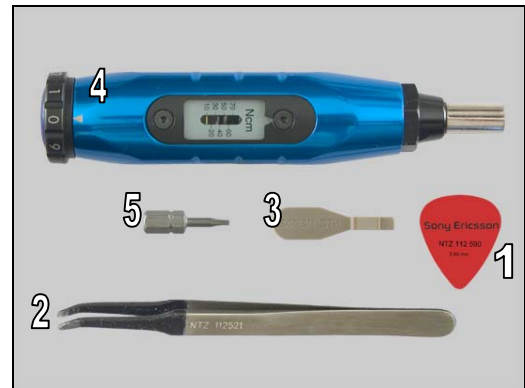
1.2 SO-01B



2 Tools

SPECIAL TOOLS

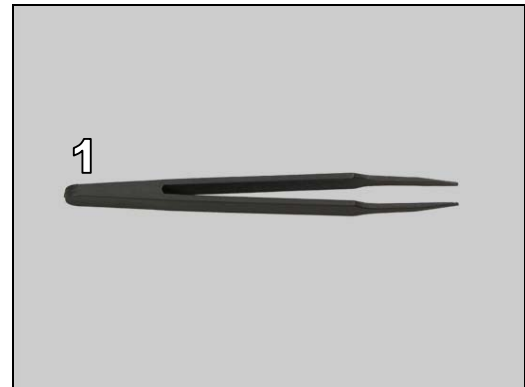
1. Guitar Pick
2. Flex Film Assembly Tool
3. Front Opening Tool
4. Torque Screwdriver
5. Bits(T6)



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

STANDARD TOOLS

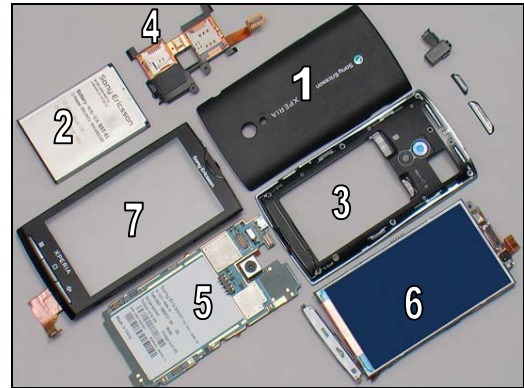
1. Tweezers



3 Disassembly

The disassembly is done in the following order:

1. Battery Cover
2. Battery
3. Rear Cover Assy
4. Non-Celler Antenna Speaker Box
5. Main PBA
6. Frame Sub Assembly
7. Front Cover Assy



3.1 Battery Cover

Insert Front Opening Tool to release the hook of the Battery Cover on the bottom side.



Lift to release the Battery Cover from the bottom side gently.



3.2 Battery

Lift up the Battery from its cavity by using a Front Opening Tool.



Disassembly

Remove the Battery.



3.3 Rear Cover Assy

Remove the eight screws by a screwdriver with T6



There are thirteen securing hooks as shown by the arrows.



Insert the Guitar Pick into the right side of the Rear Cover Assy as shown.

Keep the Guitar Pick downward direction as shown to make sure not to touch the edge of Rear Cover Assy



Disassembly

Push the Guitar Pick along gently to release the hooks of this side.

Keep the Guitar Pick downward direction as shown to make sure not to touch the edge of Rear Cover Assy



Push the Guitar Pick along gently to release the hooks of bottom side.

Keep the Guitar Pick downward direction as shown to make sure not to touch the edge of Rear Cover Assy!

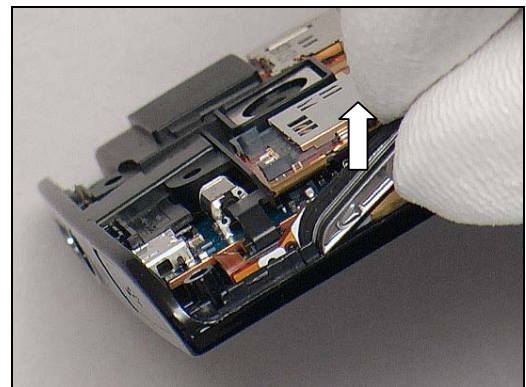


Turn the Rear Cover Assy over from the right side to remove it gently.

Be careful not to damage it! If damaged, scrap it.

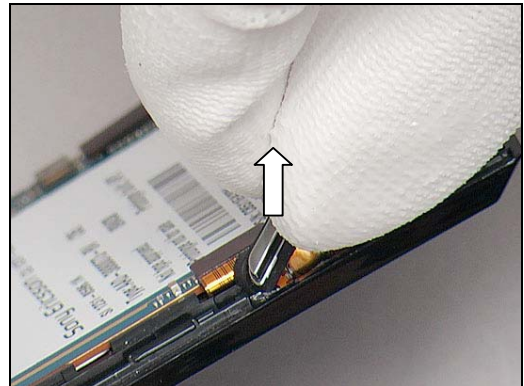


Lift to remove the Key Volume.



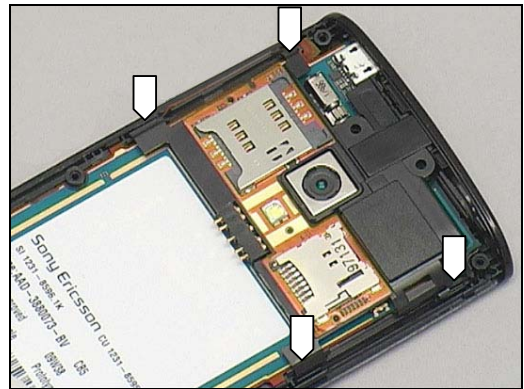
Disassembly

Lift to remove the Key Camera.

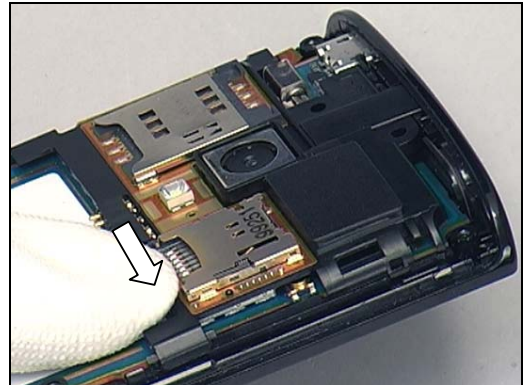


3.4 Non-Celler Antenna Speaker Box

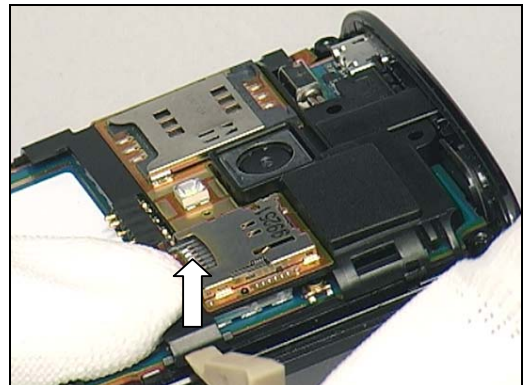
There are four securing hooks on the Non-Celler Antenna Speak Box as shown by arrows.



Push the lower right hook of the Non-Celler Antenna Speak Box by fingers as the arrows shown.

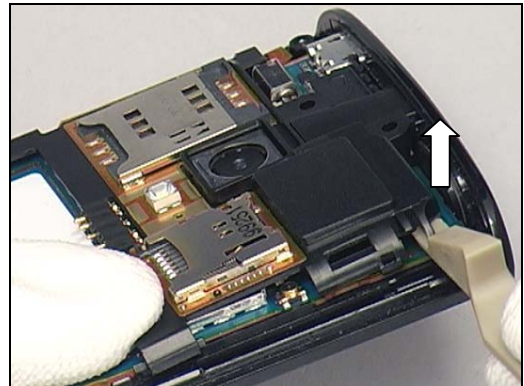


Unsnap the hook by using a Front Opening Tool.

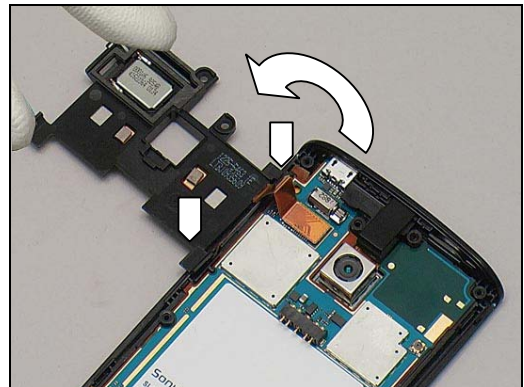


Disassembly

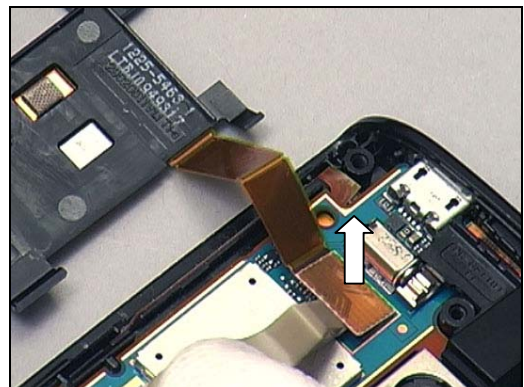
Unsnap another hook on this side as shown.



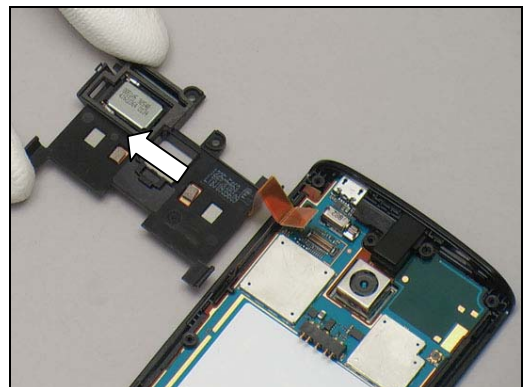
Turn the Non-Celler Antenna Speak Box over to release the other two hooks gently.



Disconnect the BtB connector by using a Front Opening Tool.

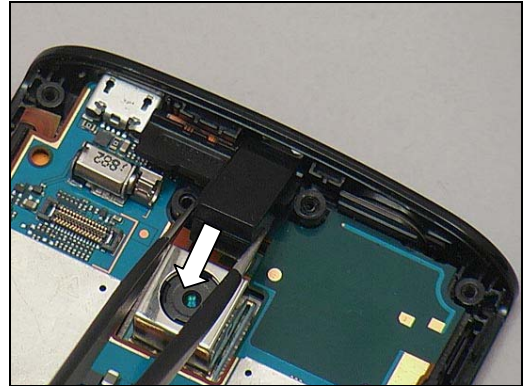


Remove the Non-Celler Antenna Speak Box.



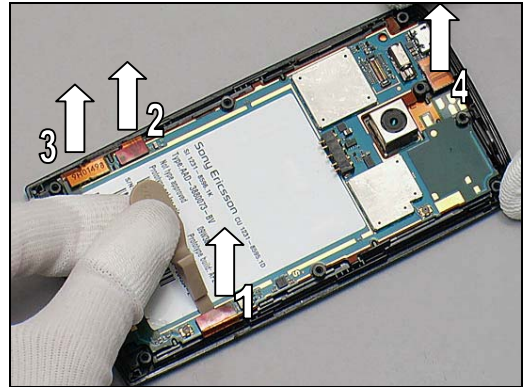
Disassembly

Remove the Audio Jack Holder by using a pair of tweezers.



3.5 Main PBA

Disconnect the four BtB connectors of the Unit by using a Front Opening Tool.



Insert the Front Opening Tool to release the Main PBA from the left side.



Do the same on the opposite side.



Disassembly

Lift up the bottom of the Main PBA gently.

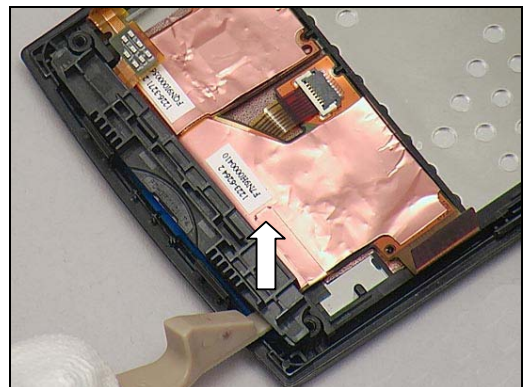


Separate the Main PBA and the Unit carefully.

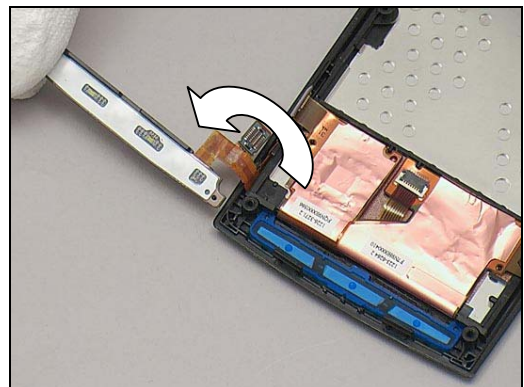


3.6 Frame Sub Assembly

Insert the Front Opening Tool underneath the Main Key Unit to release it.

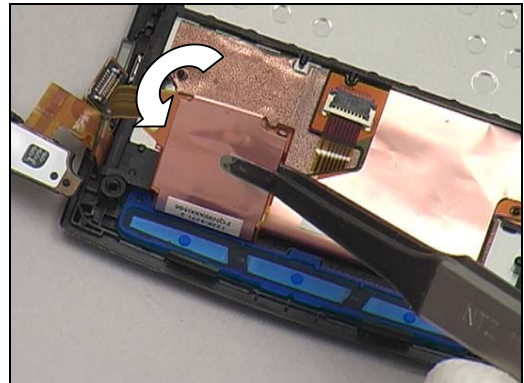


Turn over the Main Key Unit as the arrow shown.

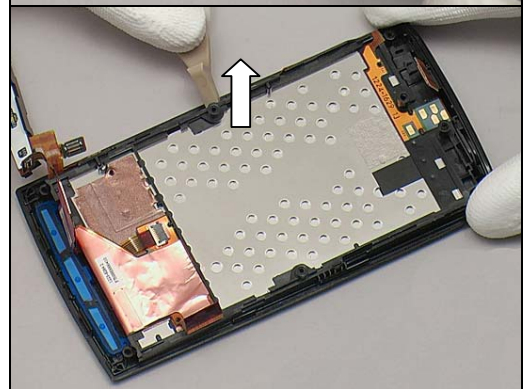


Disassembly

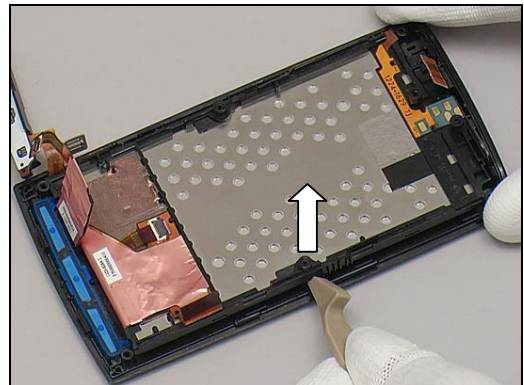
Detach the FPC from the adhesive slightly by using a Flex Film Assembly Tool.



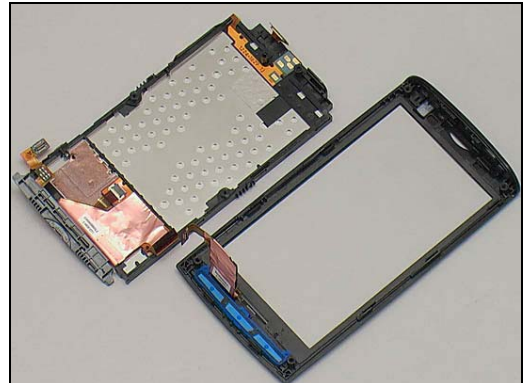
Release the Frame Sub Assembly with a Front Opening Tool on the left side.



Do the same on the opposite side.



Separate the Frame Sub Assembly and the Front Cover Assy.



4 Replacement

4.1 Battery Cover

Follow the 3.1 Disassembly instructions!

Prepare a new Battery Cover.

Follow the 5.6 Reassembly instructions!

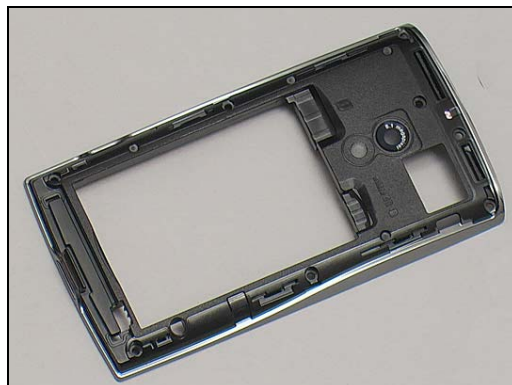


4.2 Rear Cover Assy

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare a new Rear Cover Assy

Follow the 5.4 – 5.6 Reassembly instructions!



4.3 Front Cover Assy

Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Front Cover Assy.

Follow the 5.1 – 5.6 Reassembly instructions!



4.4 Key Camera

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare a new Key Camera.

Follow the 5.4 – 5.6 Reassembly instructions!



Replacement

4.5 Key Volume

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare a new Key Volume.

Follow the 5.4 – 5.6 Reassembly instructions!



Replacement

4.6 Adhesive Frame Sub Assembly

Follow the 3.1 – 3.5 Disassembly instructions!
 Prepare a new Adhesive Frame Sub Assembly.
Follow the 5.2 – 5.6 Reassembly instructions!

REMOVAL

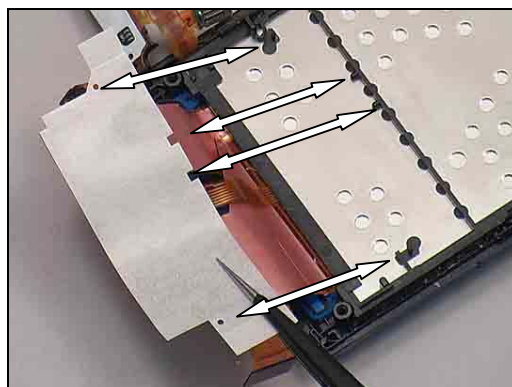
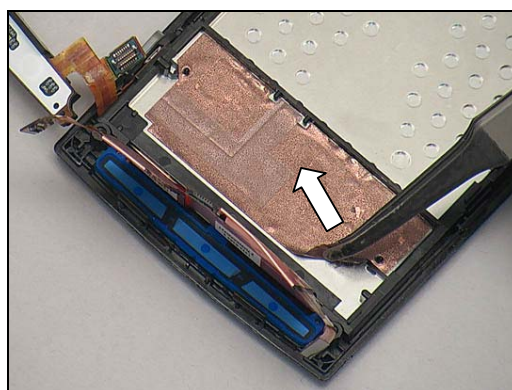
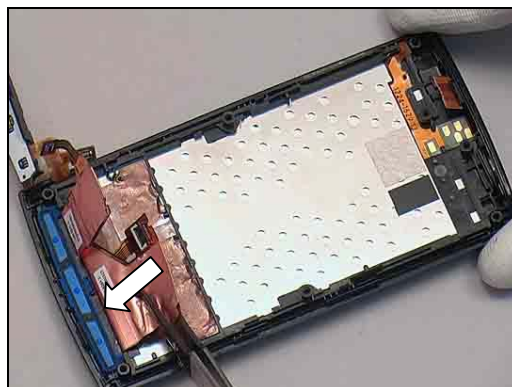
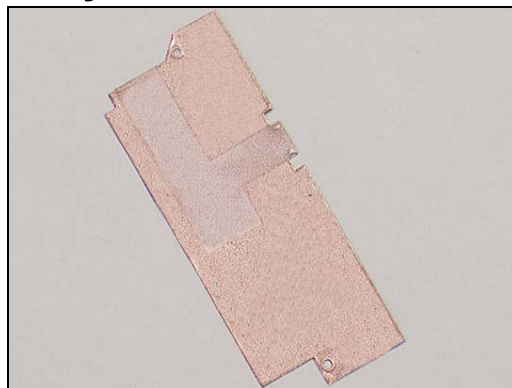
Detach the FPC from the Adhesive Frame Sub Assembly by using a Flex Film Assembly Tool.

Peel off the Adhesive Frame Sub Assembly by using a Flex Film Assembly Tool.

Scrap! Cannot be reused!

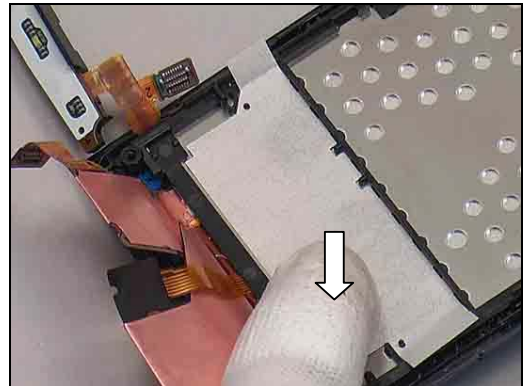
INSTALLATION

Put a new Adhesive Frame Sub Assembly align guiding poles.

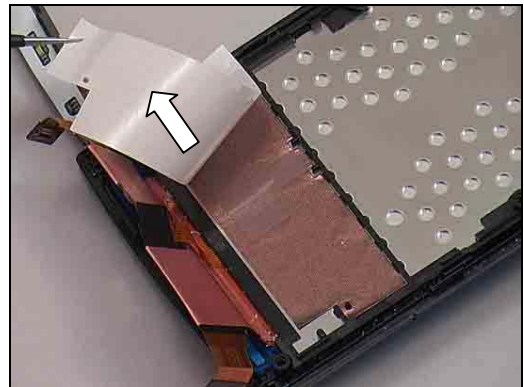


Replacement: Adhesive Frame Sub Assembly

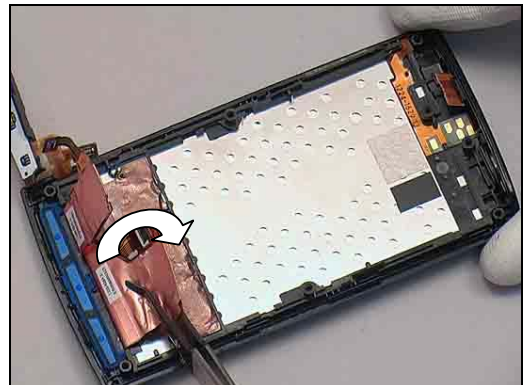
Press to secure its attachment.



Peel off the protect film.



Turn over the FPC aligning guiding poles and press to secure its attachment.



Replacement

4.7 Audio Jack Connector

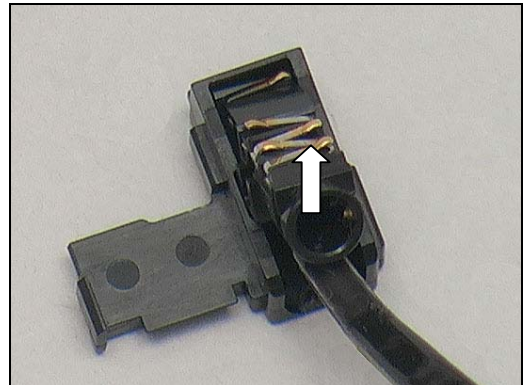
Follow the 3.1 – 3.4 Disassembly instructions!

Prepare a new Audio Jack Connector.

Follow the 5.3 – 5.6 Reassembly instructions!

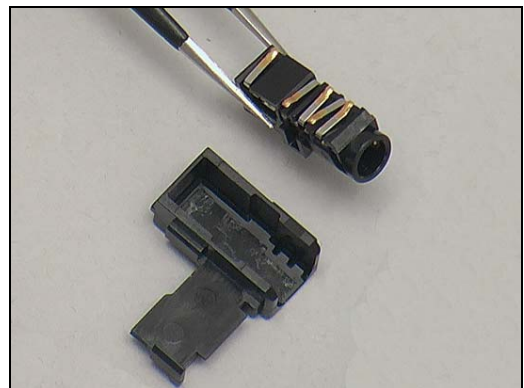
REMOVAL

Detach to remove the Jack Connector from the head by using a Flex Film Assembly Tool.



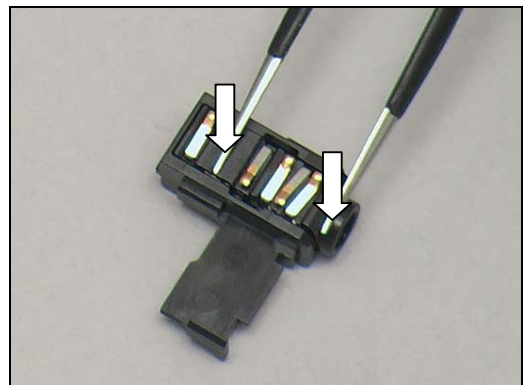
INSTALLATION

Place a new Jack Connector in place by using a pair of tweezers.



Press to secure its attachment by using a pair of tweezers.

Do not touch the spring pins.



Replacement

4.8 Audio Jack Holder

Follow the 3.1 – 3.4 Disassembly instructions!

Follow the 4.7 Removal instructions!

Prepare a new Audio Jack Holder.

Follow the 4.7 Installation instructions!

Follow the 5.3 – 5.6 Reassembly instructions!



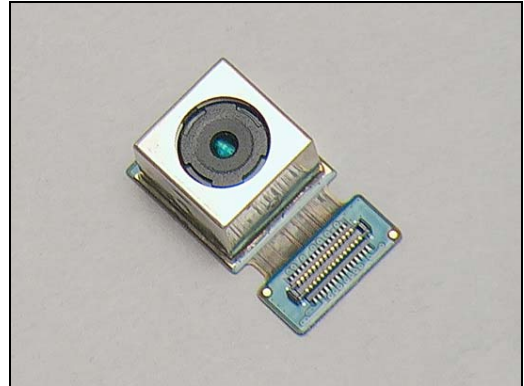
Replacement

4.9 Camera 8 MPixel CMOS

Follow the 3.1 – 3.5 Disassembly instructions!

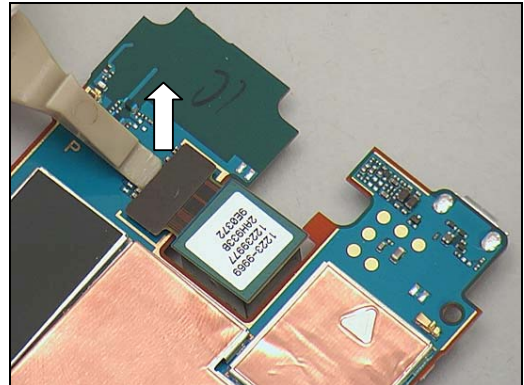
Prepare a new Camera 8 MPixel CMOS.

Follow the 5.2 – 5.6 Reassembly instructions!

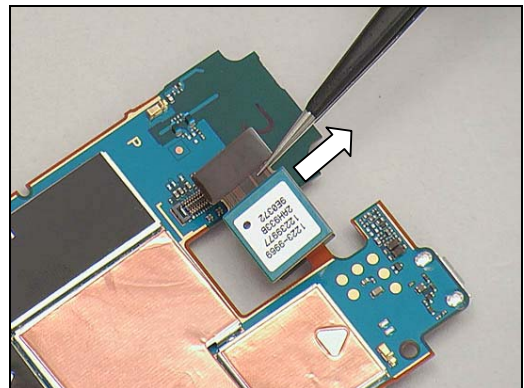


REMOVAL

Unsnap the BtB connector by using a Front Opening Tool.

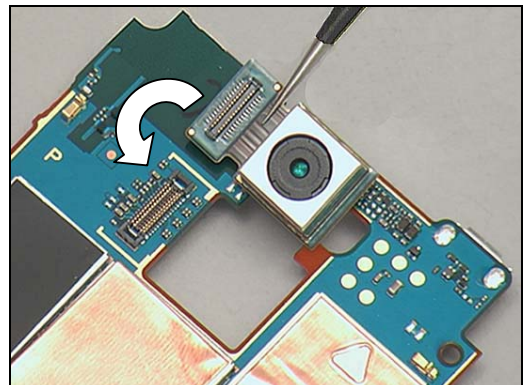


Remove the Camera 8 MPixel CMOS.



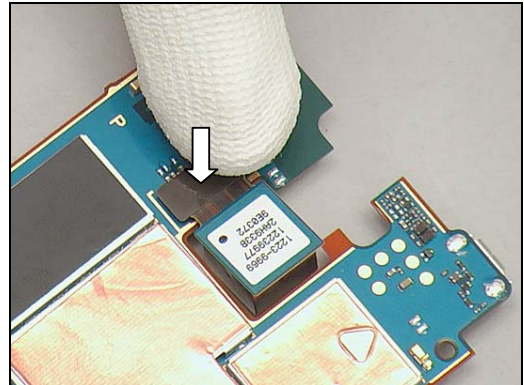
INSTALLATION

Place a new Camera 8 MPixel CMOS in place.



Replacement: Camera 8 MPixel CMOS

Press to snap it.



Replacement

4.10 Co-Brand

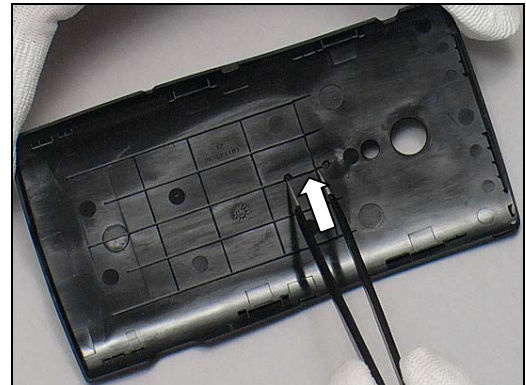
Follow the 3.1 Disassembly instructions!

Prepare a new Co-Brand

Follow the 5.6 Reassembly instructions!

REMOVAL

Push from the hole on the back side of the Battery Cover Co-brand Pocket by using a pair of tweezers.



Detach to remove the Co-Brand from the Battery Cover Co-brand Pocket.



INSTALLATION

Put a new Co-Brand in place.



Replacement: Co-Brand

Press along to secure its attachment.



Replacement

4.11 Conductive Gasket

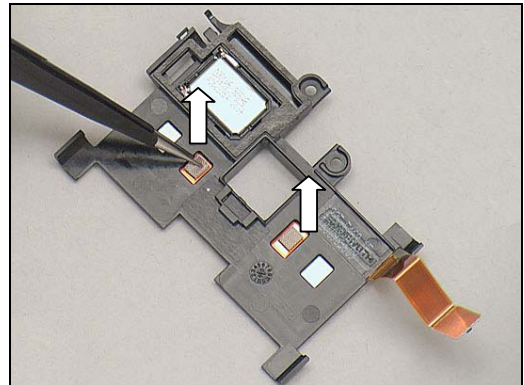
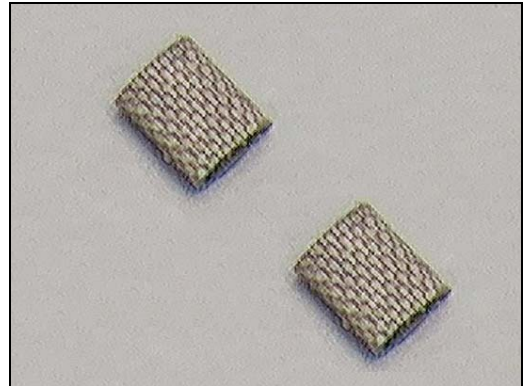
Follow the 3.1 – 3.4 Disassembly instructions!

Prepare the new Conductive Gaskets

Follow the 5.3 – 5.6 Reassembly instructions!

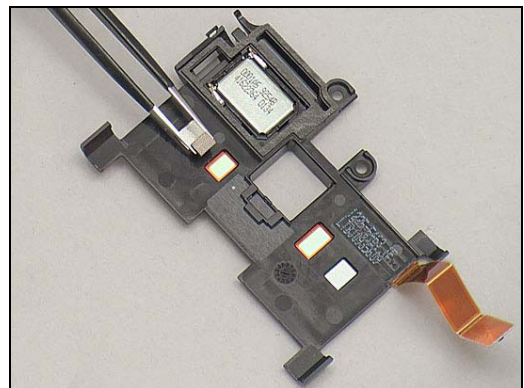
REMOVAL

Detach the two Conductive Gaskets by using a pair of tweezers.

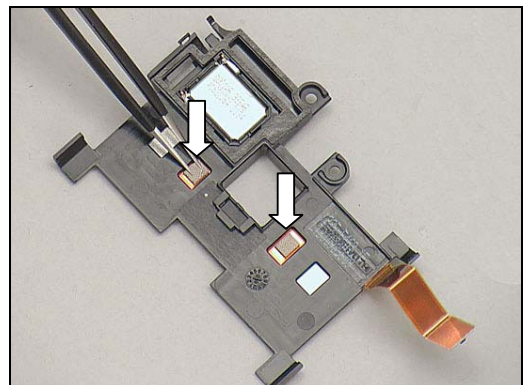


INSTALLATION

Put two new Conductive Gaskets in place.



Press to secure the attachments.



Replacement

4.12 Core Unit Label

Follow the 3.1 – 3.2 Disassembly instructions!

Prepare a new Core Unit Label

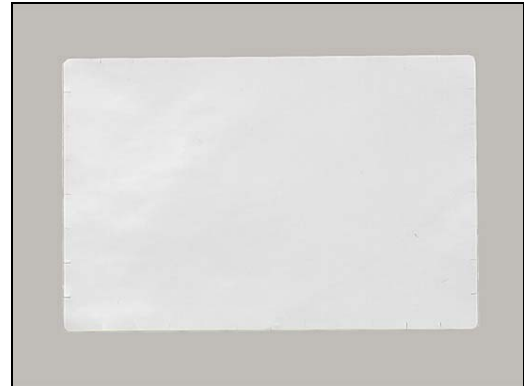
Follow the 5.5 – 5.6 Reassembly instructions!

REMOVAL

Read the old Core Unit Label and write the information into the 'LabelMake' program.

Detach the Label from the corner by using a Front Opening Tool.

Remove the Label carefully by using a pair of tweezers



Replacement: Core Unit Label

INSTALLATION

Check that the label format is properly loaded in the Zebra printer and write a new Label by using the 'Label Make' software.

One label only is allowed!

Press the new Core Unit Label onto the Main PBA.



Replacement

4.13 Cover Micro USB

Prepare a new Cover Micro USB.



REMOVAL

Unsnap the three hooks of the Cover Micro USB with a Front Opening Tool.



Pull the Cover Micro USB out of the Phone gently.



INSTALLATION

Place a new Cover Micro USB with the proper direction.



Replacement: Cover Micro USB

Push the Cover Micro USB Into the Phone into the cavity by using a pair of tweezers



Press to snap the Cover Micro USB.



Replacement

4.14 Cover Sensor

Follow the 3.1 – 3.6 Disassembly instructions!

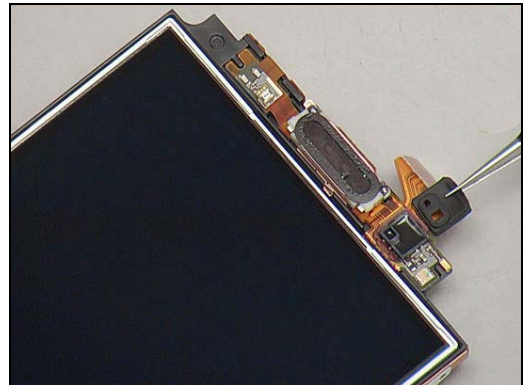
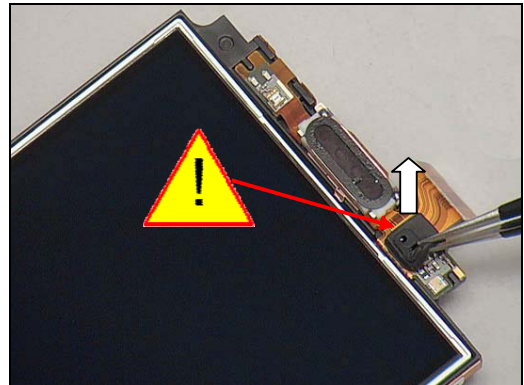
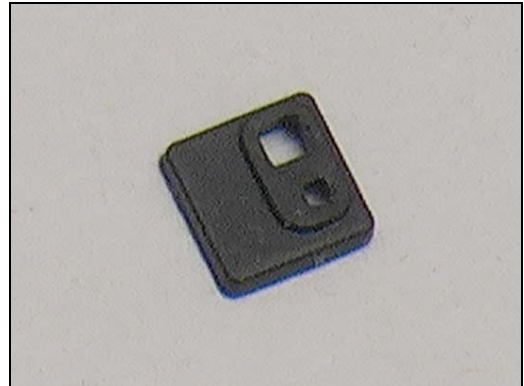
Prepare a new Cover Sensor.

Follow the 5.1 – 5.6 Reassembly instructions!

REMOVAL

Remove it by using a pair of tweezers.

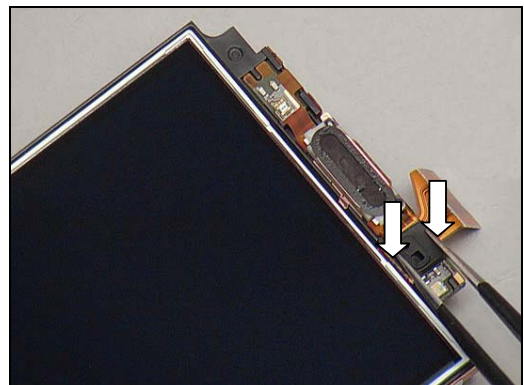
Do not damage the sensor.



INSTALLATION

Place a new Cover Sensor in place.

Press to secure its position.



Replacement

4.15 Cushion for Frame Key

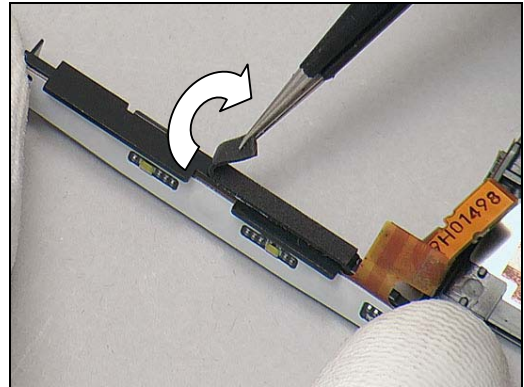
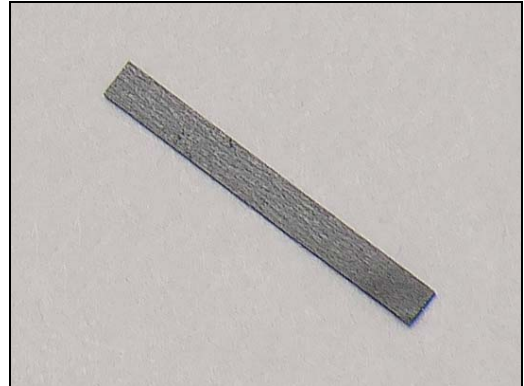
Follow the 3.1 – 3.5 Disassembly instructions!

Prepare a new Cushion for Frame Key

Follow the 5.2 – 5.6 Reassembly instructions!

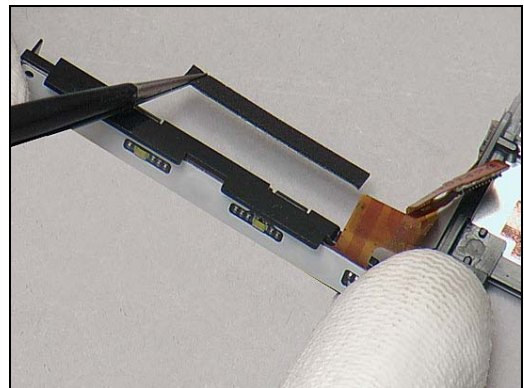
REMOVAL

Detach it by using a pair of tweezers.

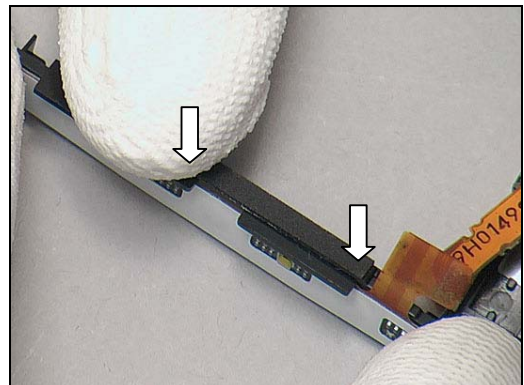


INSTALLATION

Place a new Cushion for Frame Key in place.



Press to secure its position.



Replacement

4.16 Display 4.0 TFT

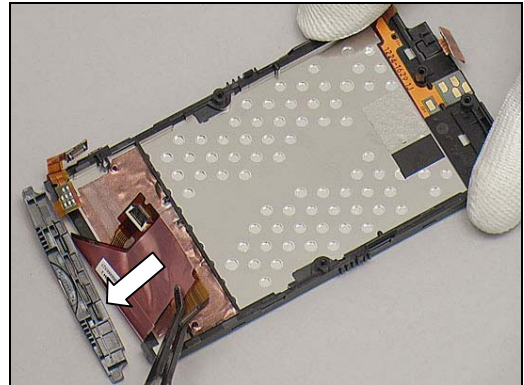
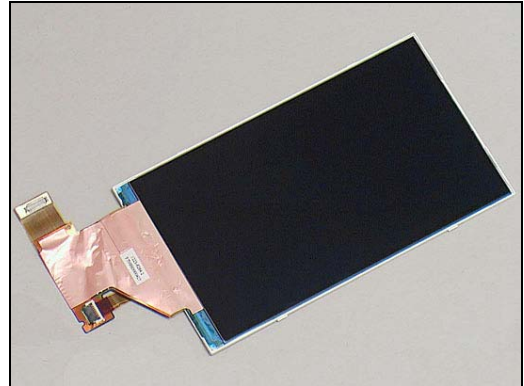
Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Display 4.0 TFT.

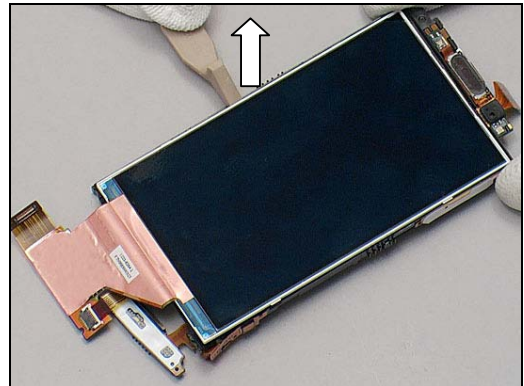
Follow the 5.1 – 5.6 Reassembly instructions!

REMOVAL

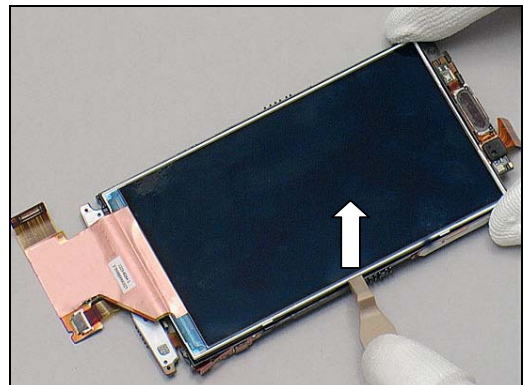
Detach the FPC from the Adhesive Frame Sub Assembly.



Turn over the Unit and release the Display 4.0 TFT with a Front Opening Tool on the left side.

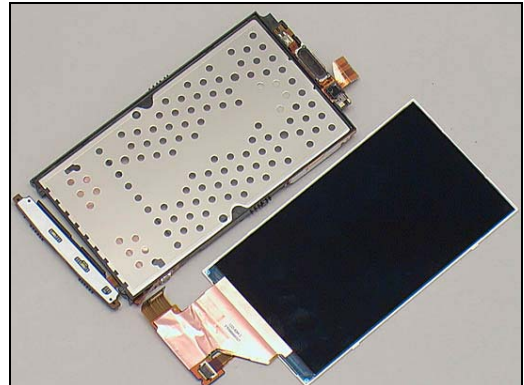


Do the same on the right side.



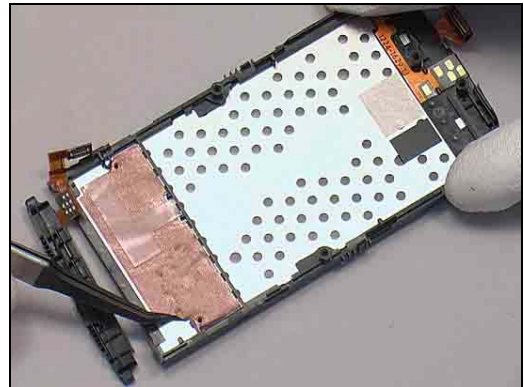
Replacement: Display 4.0 TFT

Separate the Display 4.0 TFT from the Unit.



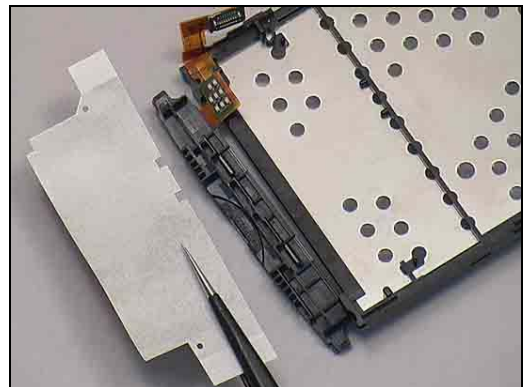
Peel off the Adhesive Frame Sub Assembly by using a Flex Film Assembly Tool.

Scrap! Not to be reused!

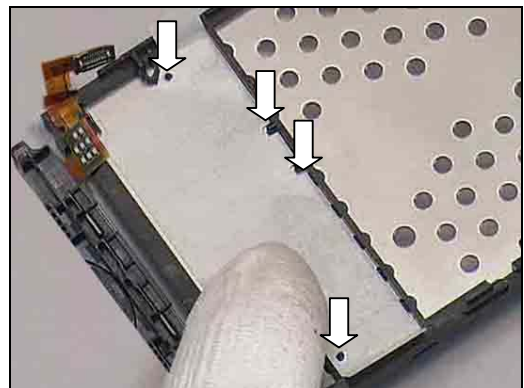


INSTALLATION

Put a new Adhesive Frame Sub Assembly in place.

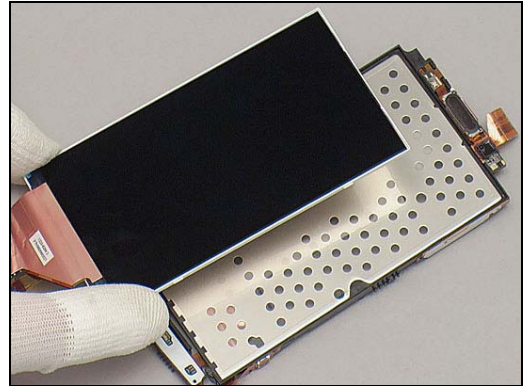


Fix it align with the guiding poles as shown.



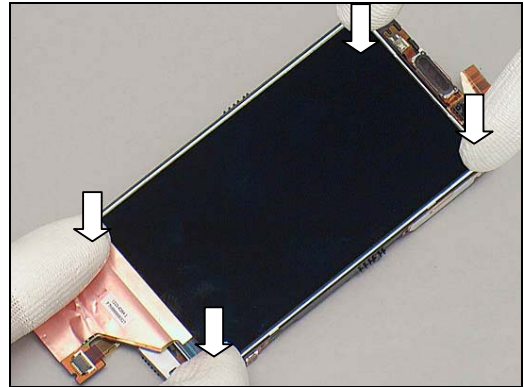
Replacement: Display 4.0 TFT

Place the Display 4.0 TFT in place.

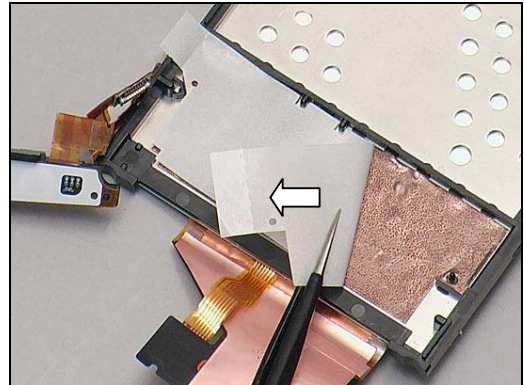


Press to secure its position.

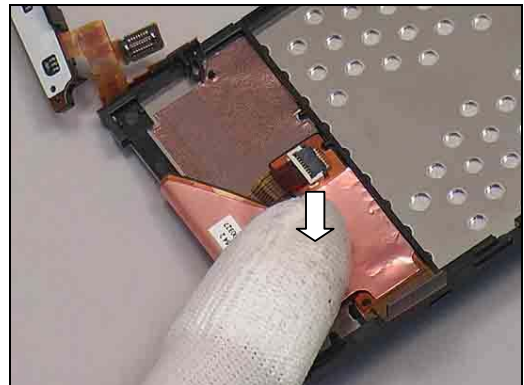
Do not touch the screen.



Peel off the protect film of the Adhesive Frame Sub Assembly.



Fix the FPC on the Adhesive Frame Sub Assembly aligns guiding poles.



Replacement

4.17 Frame Sub Assembly

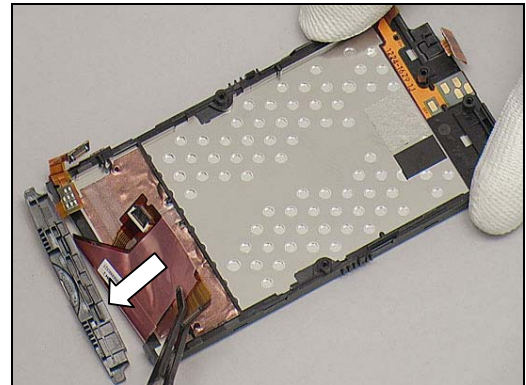
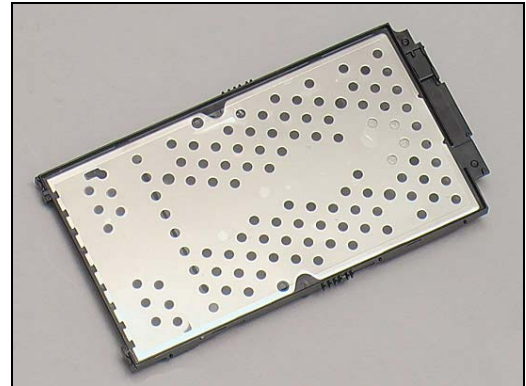
Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Frame Sub Assembly.

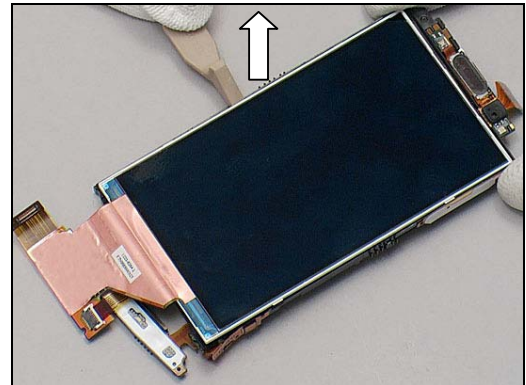
Follow the 5.1 – 5.6 Reassembly instructions!

REMOVAL

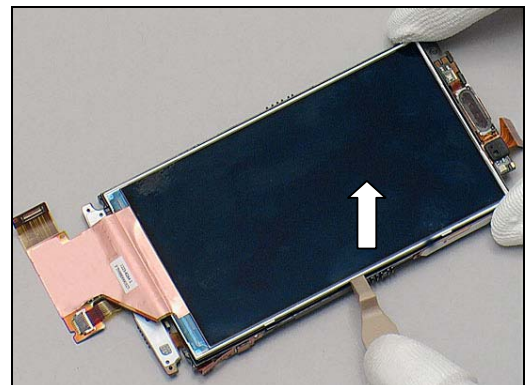
Detach the FPC from the Adhesive Frame Sub Assembly.



Turn it over and release the Display 4.0 TFT with a Front Opening Tool on the left side.

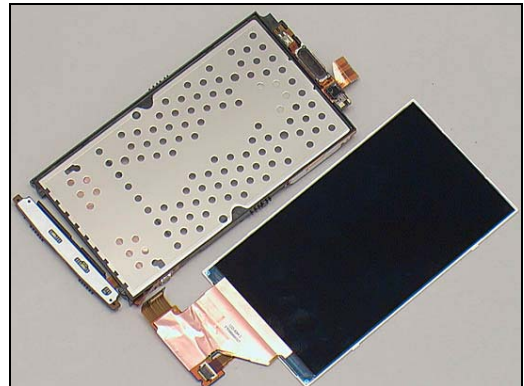


Do the same on the right side.



Replacement: Frame Sub Assembly

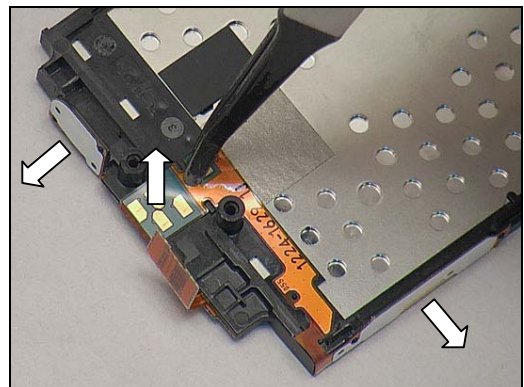
Separate the Display 4.0 TFT from the Frame Sub Assembly.



Peel off the Main Key FPC from the Frame Sub Assembly.

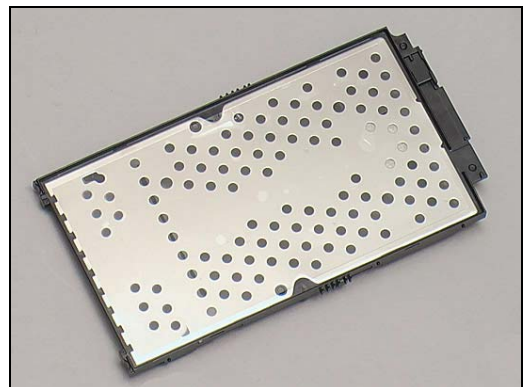


Detach the Receiver FPC from the frame by using a Flex Film Assembly Tool as shown.



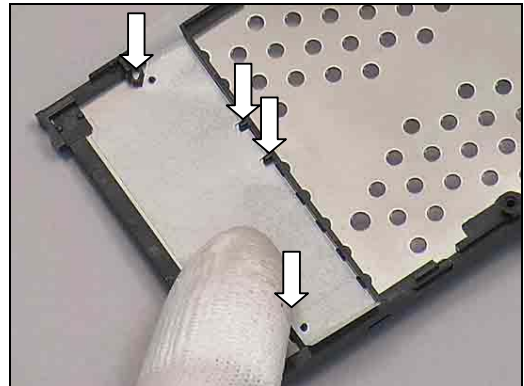
INSTALLATION

Place a new Frame Sub Assembly.

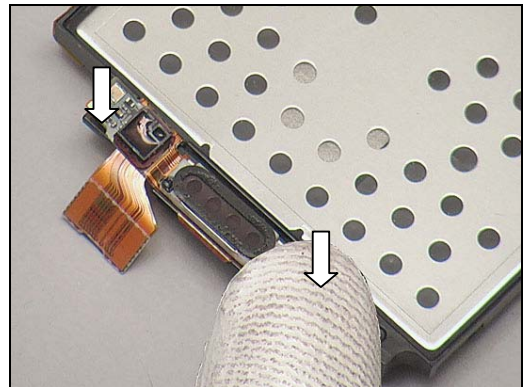


Replacement: Frame Sub Assembly

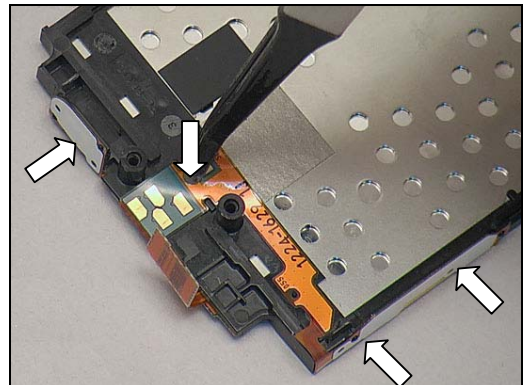
Attach a new Adhesive Frame Sub Assembly onto the Frame Sub Assembly align guiding poles.



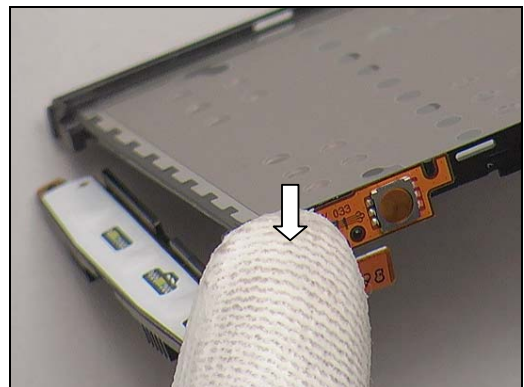
Attach a new Receiver onto the Frame Sub Assembly aligned with the guiding poles.



Turn over the FPC and press the keys/pads aligned with the guiding poles as shown

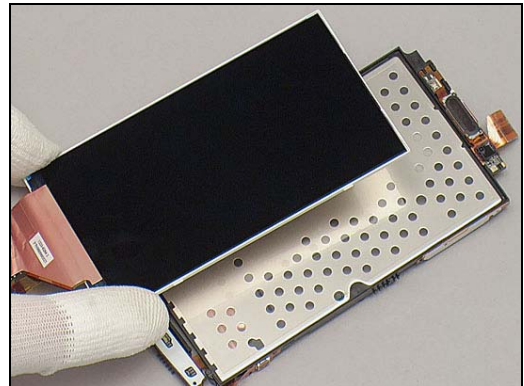


Attach the Main Key FPC Unit onto the Frame Sub Assembly aligned with the guiding poles.



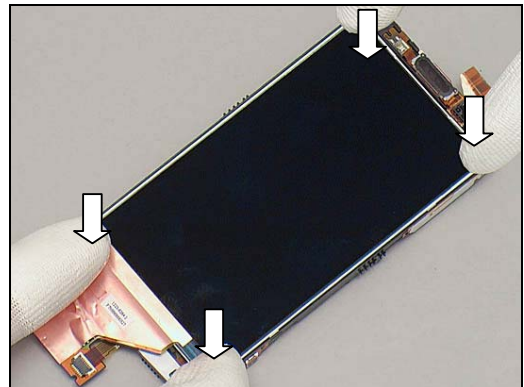
Replacement: Frame Sub Assembly

Place the Display 4.0 TFT in place.

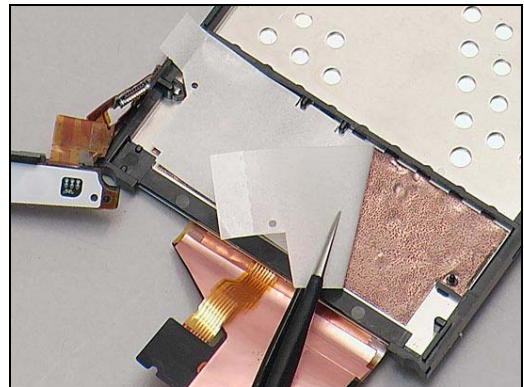


Press to secure its position.

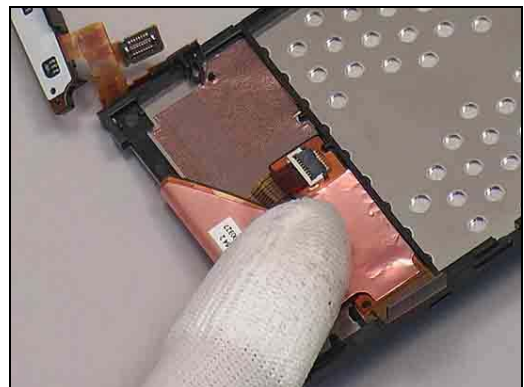
Do not touch the screen.



Turn over the Unit and peel off the protect film of the Adhesive Frame Sub Assembly.



Fix the FPC on the Adhesive Frame Sub Assembly aligns guiding poles.



Replacement

4.18 Key Main

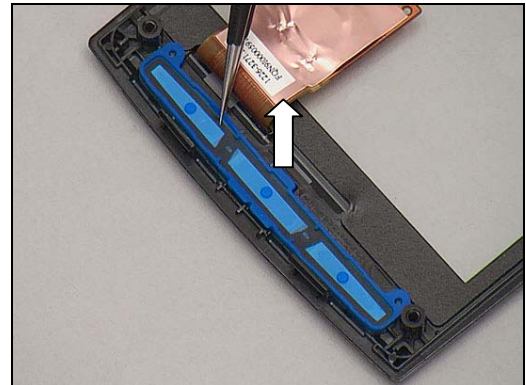
Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Key Main.

Follow the 5.1 – 5.6 Reassembly instructions!

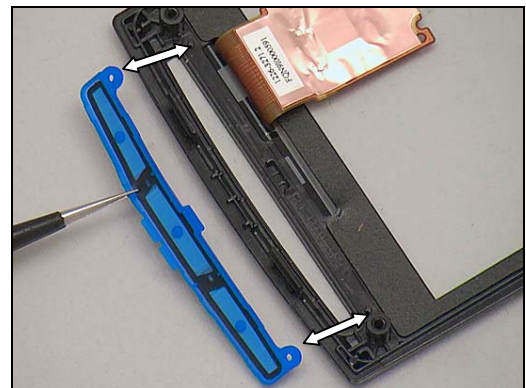
REMOVAL

Lift to remove by using a pair of tweezers.

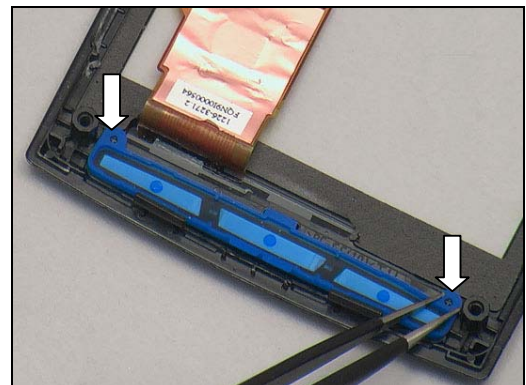


INSTALLATION

Place a new Key Main in the proper direction into the slot.

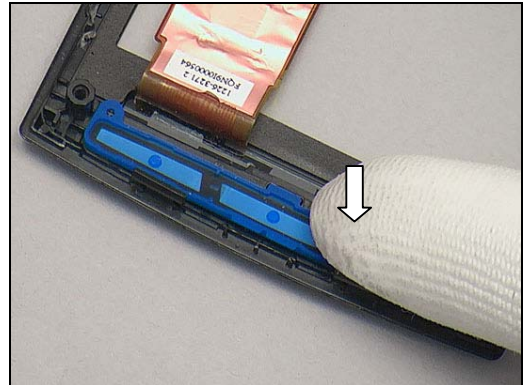


Fix the Key Main on the guiding pole by using a pair of tweezers.



Replacement: Key Main

Press along to secure its position.



Replacement

4.19 Key On/Off

Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Key On/Off.

Follow the 5.1 – 5.6 Reassembly instructions!

REMOVAL

Push from the outside with a pair of tweezers.



Remove the Key On/Off from the inside.



INSTALLATION

Place the Key On/Off with proper direction into the slot.



Replacement: Key On/Off

Fix the Key On/Off to the guiding pole by using a pair of tweezers.



Press to secure its position



Replacement

4.20 Main Antenna

Follow the 3.1 – 3.3 Disassembly instructions!

Prepare a new Main Antenna.

Follow the 5.4– 5.6 Reassembly instructions!

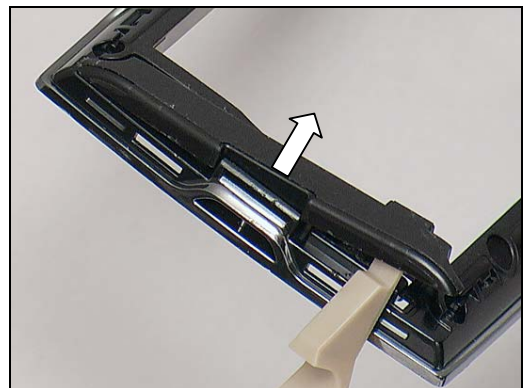
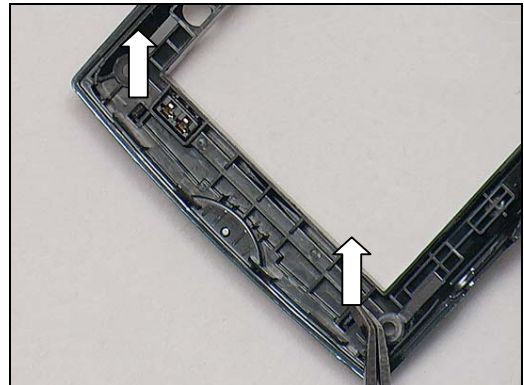
REMOVAL

Push to release the two hooks from inside of the Rear Cover Assy by using a Flex Film Assembly Tool.

Detach carefully and remove it.

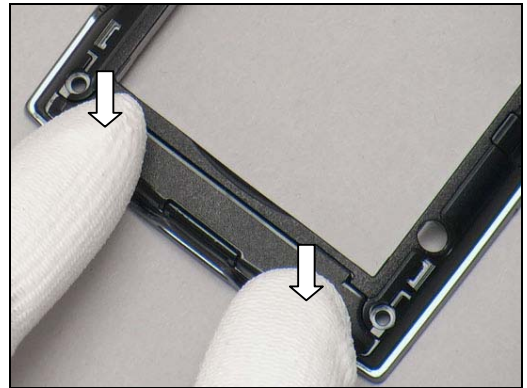
INSTALLATION

Put a new Main Antenna in place.



Replacement: Main Antenna

Press to snap the two hooks of Main Antenna.



Replacement

4.21 Main Key FPC

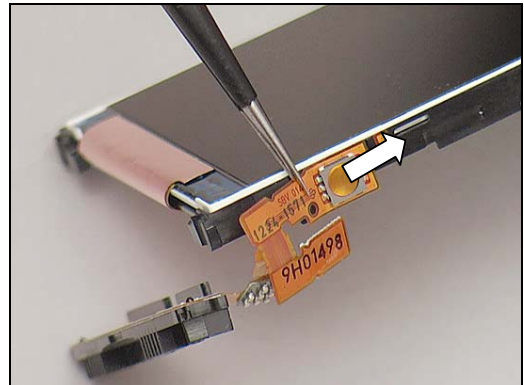
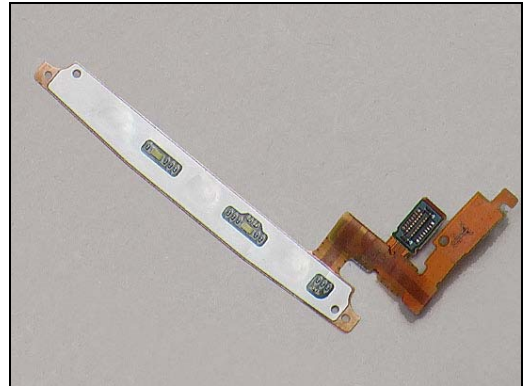
Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Main Key FPC.

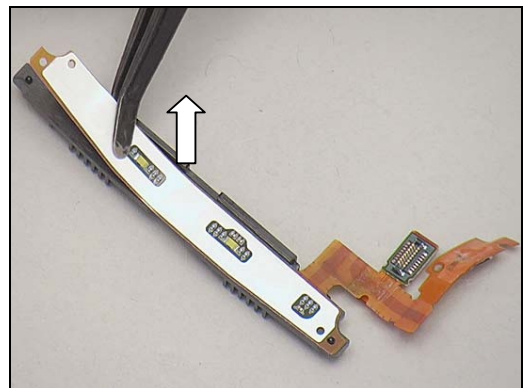
Follow the 5.1 – 5.6 Reassembly instructions!

REMOVAL

Peel off the Main Key Unit from the Frame Sub Assembly.

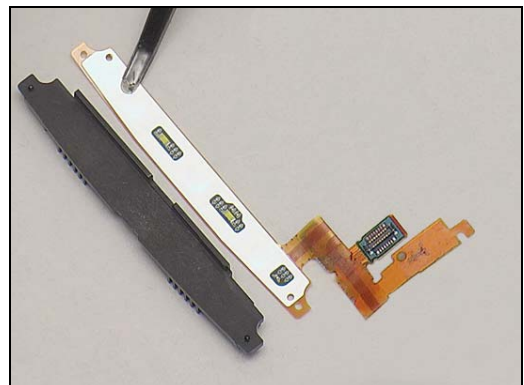


Detach the Main Key FPC from the Main Key Frame.



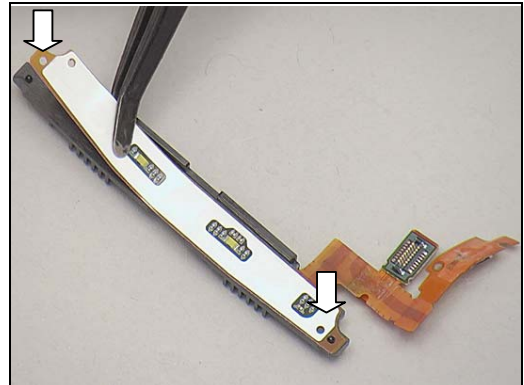
INSTALLATION

Place a new Main Key FPC in place.

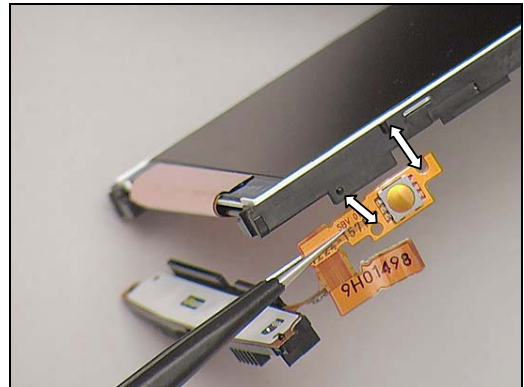


Replacement: Main Key FPC

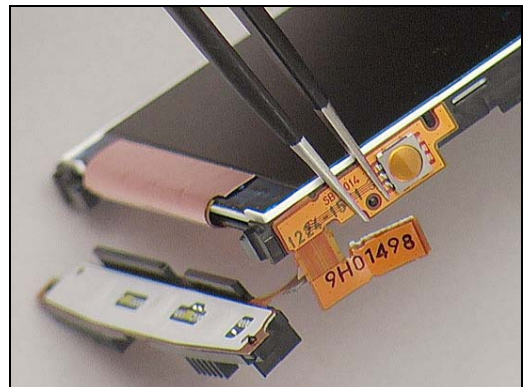
Attach the Main Key FPC onto the Main Key Frame aligns two guiding poles.



Attach it onto the Frame Sub Assembly aligned with two guiding poles as shown.



Press to secure its attachment.



Replacement

4.22 Main Key Frame

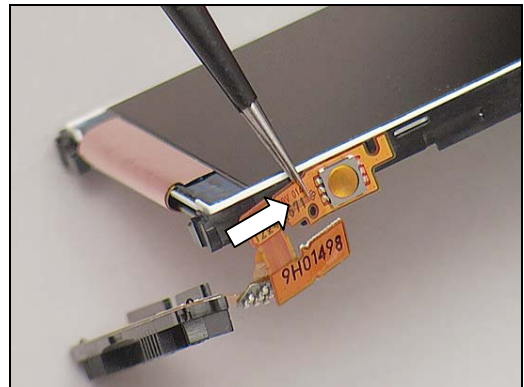
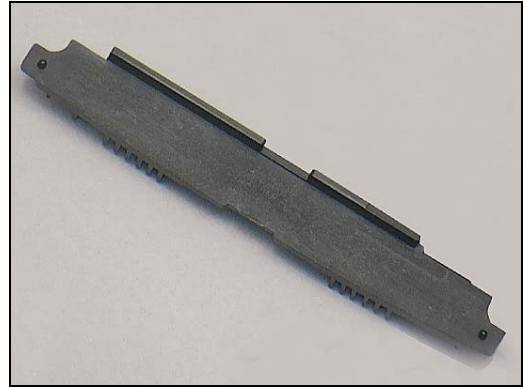
Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Main Key Frame and a new Main Key FPC.

Follow the 5.1 – 5.6 Reassembly instructions!

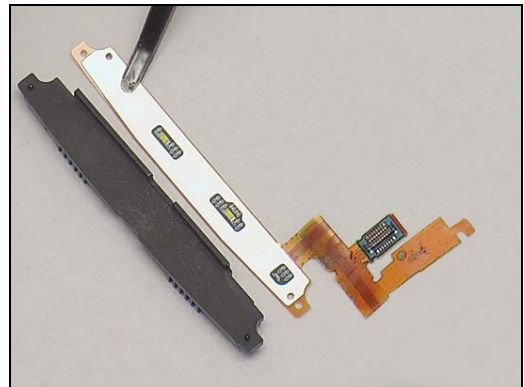
REMOVAL

Peel it off the Main Key FPC from the Frame Sub Assembly.

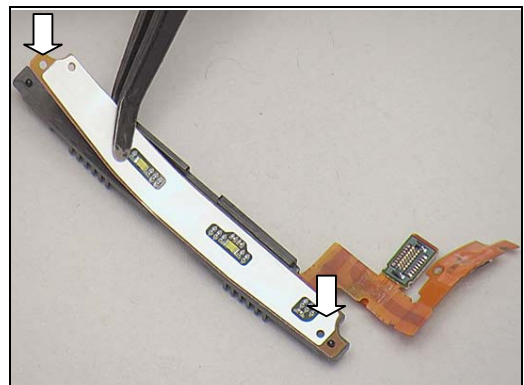


INSTALLATION

Place the a new Main Key Frame and a new Main Key FPC in place.

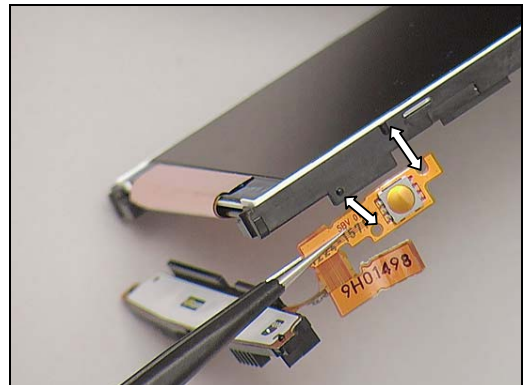


Attach the Main Key FPC onto the Main Key Frame aligns two guiding poles.

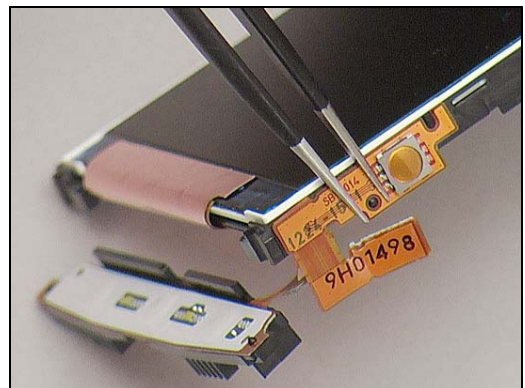


Replacement: Main Key Frame

Attach it onto the Frame Sub Assembly aligned with two guiding poles as shown.



Press to secure its attachment.



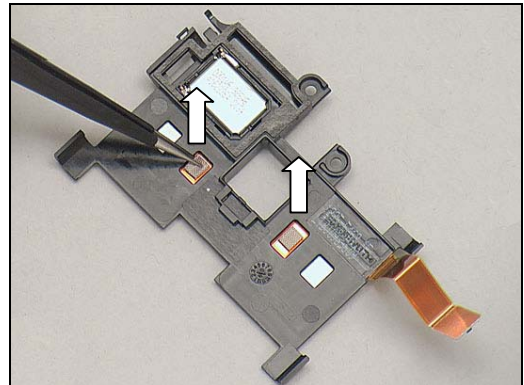
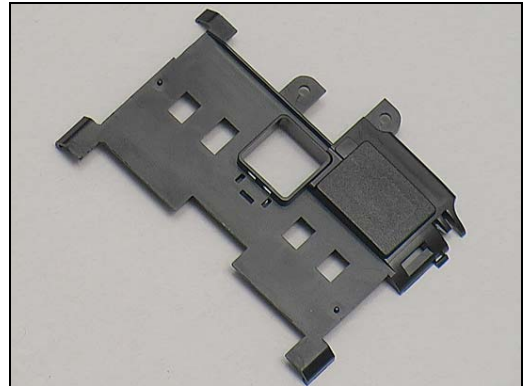
Replacement

4.23 Non-Celler Antenna Speaker Box

Follow the 3.1 – 3.4 Disassembly instructions!
 Prepare a new Non-Celler Antenna Speaker Box
Follow the 5.3 – 5.6 Reassembly instructions!

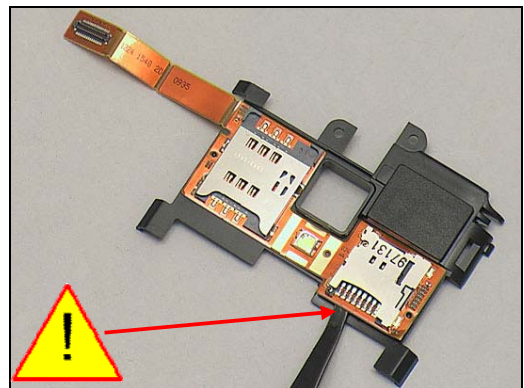
REMOVAL

Remove the two Conductive Gaskets.



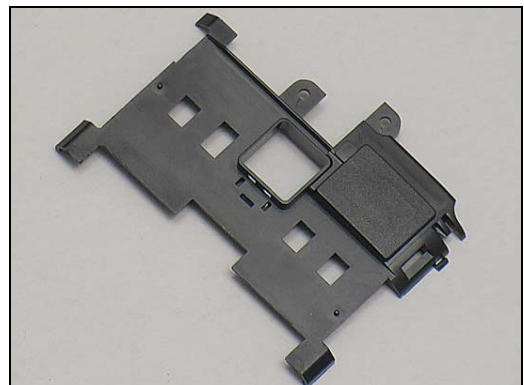
Detach and remove the SIM and MicroSD FPC gently.

Be careful not to damage the SIM and MicroSD FPC



INSTALLATION

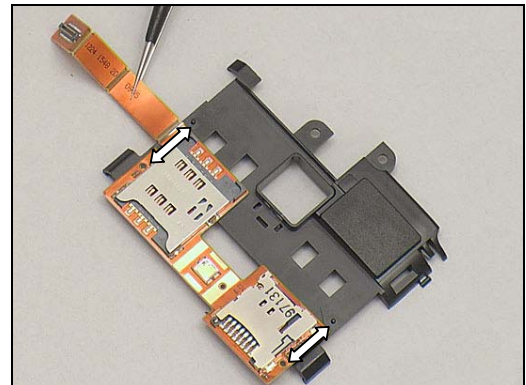
Put a new Non-Celler Antenna Speaker Box in place.



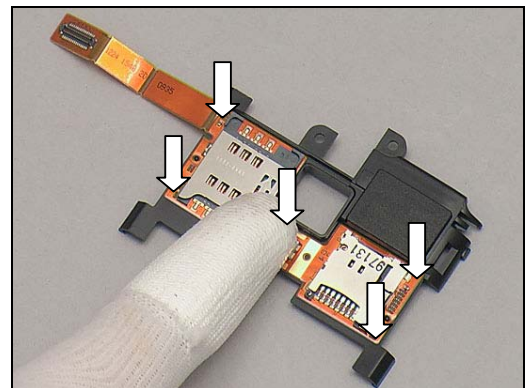
Replacement: Non-Celler Antenna Speaker Box

INSTALLATION

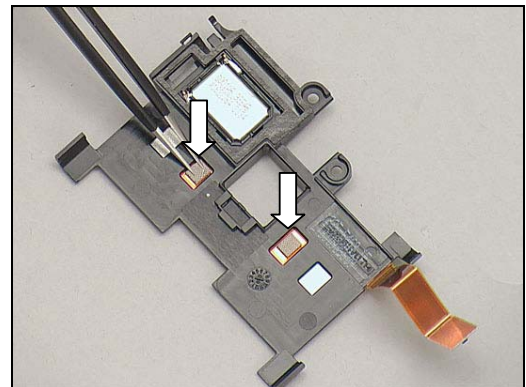
Put the SIM and MicroSD FPC align with the two guiding poles of the Non-Celler Antenna Speaker Box.



Attach the SIM and MicroSD FPC aligns guiding poles.



Attach two new Conductive Gaskets onto the Unit.



Replacement

4.24 Receiver FPC

Follow the 3.1 – 3.6 Disassembly instructions!

Prepare a new Receiver FPC.

Follow the 5.1 – 5.6 Reassembly instructions!

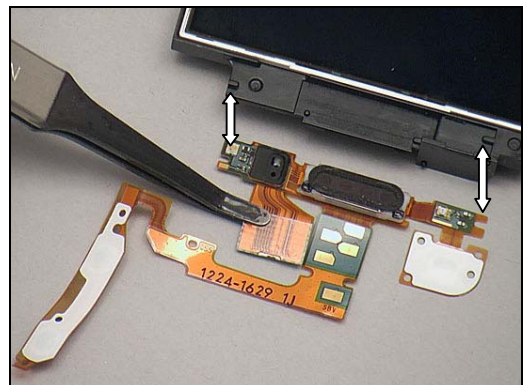
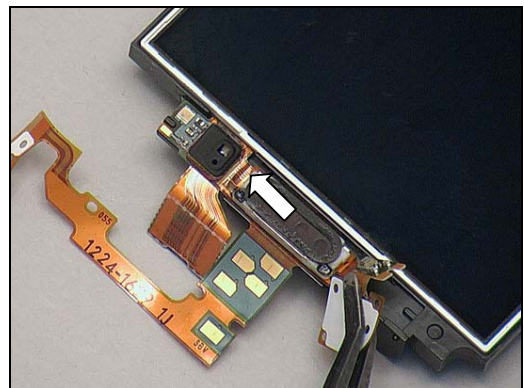
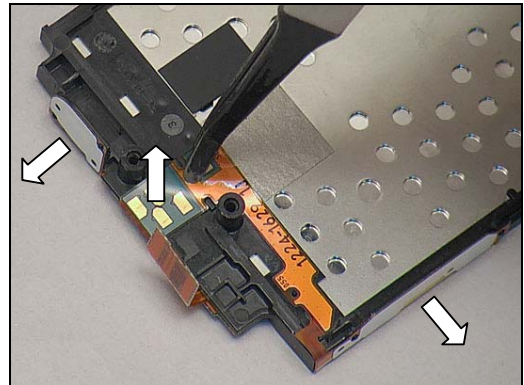
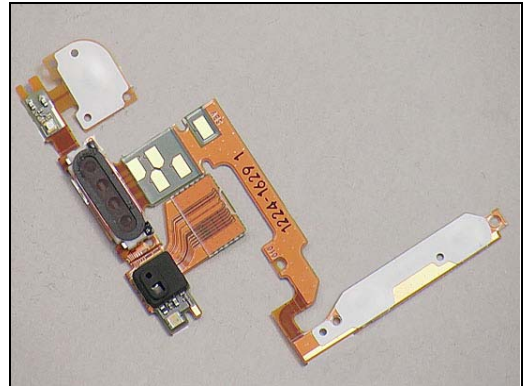
REMOVAL

Detach the keys/pads from the frame by using a Flex Film Assembly Tool as shown.

Detach the speaker carefully.

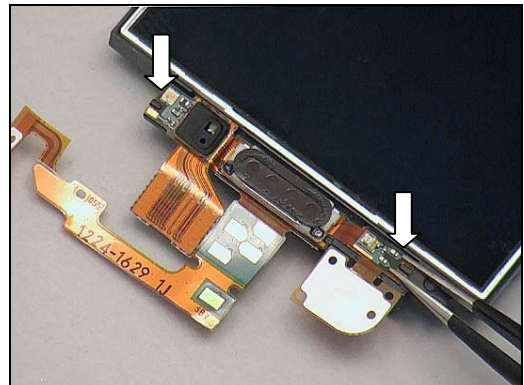
INSTALLATION

Place the Receiver FPC in place

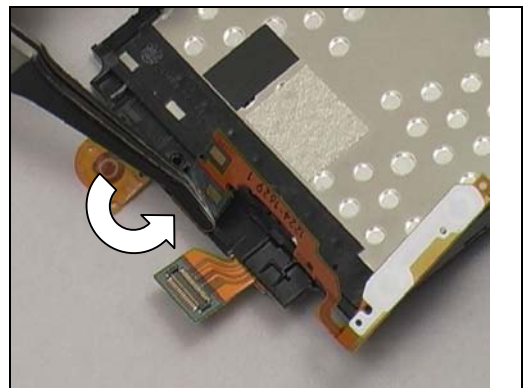


Replacement: Receiver FPC

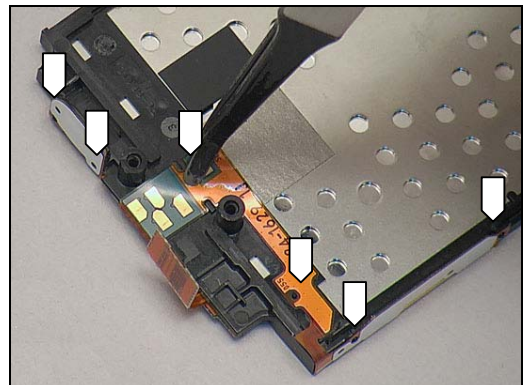
Attach the Receiver FPC aligned with the two guiding poles.



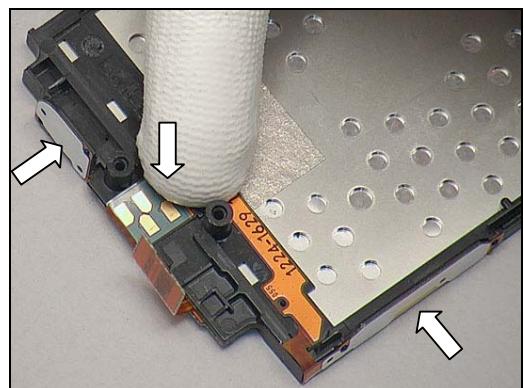
Turn over the FPC.



Put the keys/pads aligned with the guiding poles as shown.



Press to secure attachment.



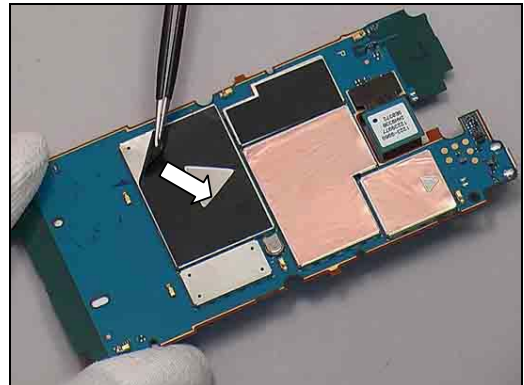
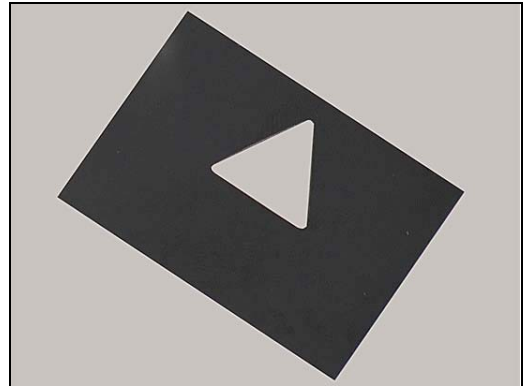
Replacement

4.25 Shield Can MComp Sheet Lid A1

Follow the 3.1 – 3.5 Disassembly instructions!
Prepare a new Shield Can MComp Sheet Lid A1.
Follow the 5.2 – 5.6 Reassembly instructions!

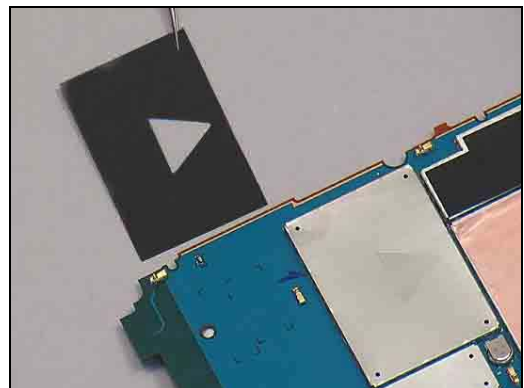
REMOVAL

Detach the Shield Can MComp Sheet Lid A1 from Main PBA

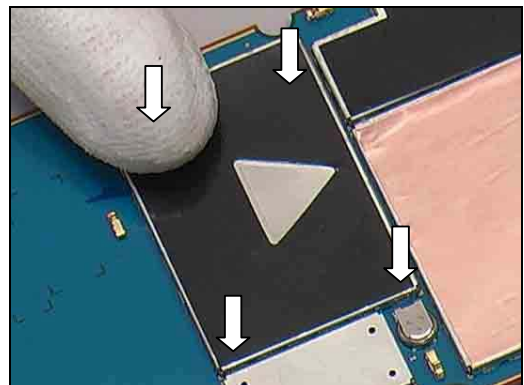


INSTALLATION

Put a new Shield Can MComp Sheet Lid A1 in place.



Press to secure its attachment.



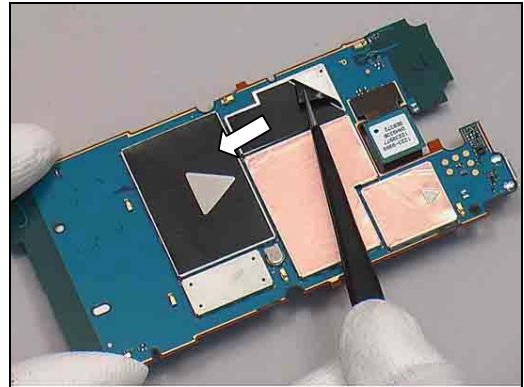
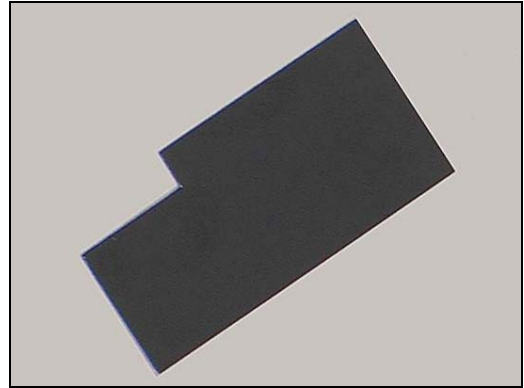
Replacement

4.26 Shield Can MComp Sheet Lid A3

Follow the 3.1 – 3.5 Disassembly instructions!
Prepare a new Shield Can MComp Sheet Lid A3.
Follow the 5.2 – 5.6 Reassembly instructions!

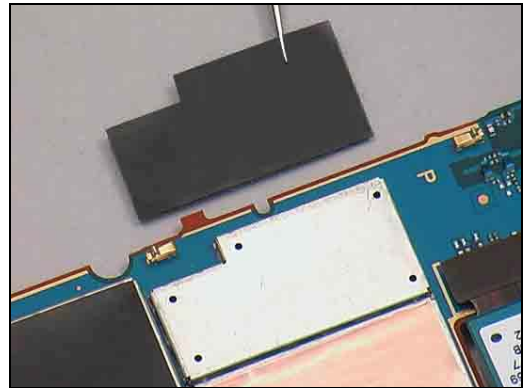
REMOVAL

Detach the Shield Can MComp Sheet Lid A3 from Main PBA

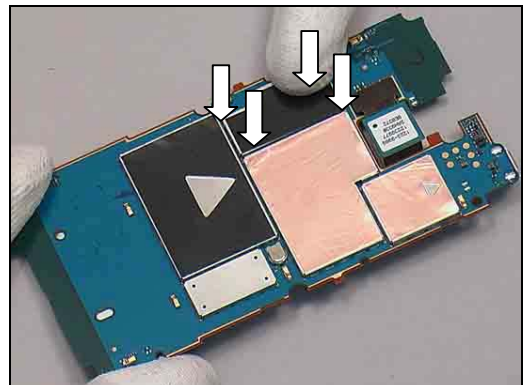


INSTALLATION

Put a new Shield Can MComp Sheet Lid A3 in place.



Press to secure its attachment.



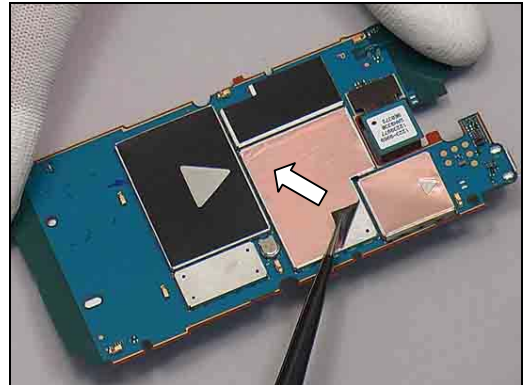
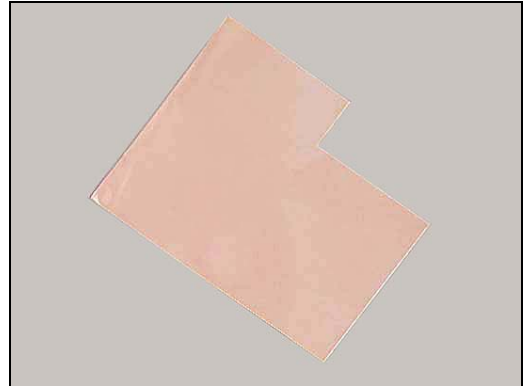
Replacement

4.27 Shield Can MComp Sheet Lid A4

Follow the 3.1 – 3.5 Disassembly instructions!
 Prepare a new Shield Can MComp Sheet Lid A4.
Follow the 5.2 – 5.6 Reassembly instructions!

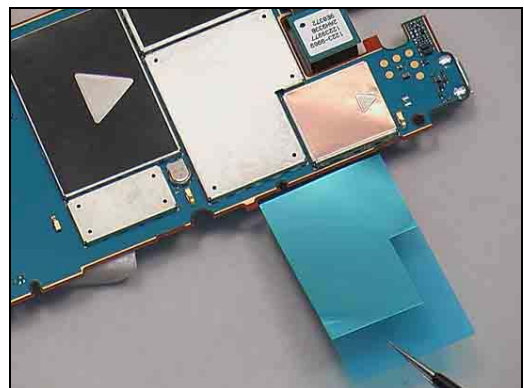
REMOVAL

Detach the Shield Can MComp Sheet Lid A4 from Main PBA

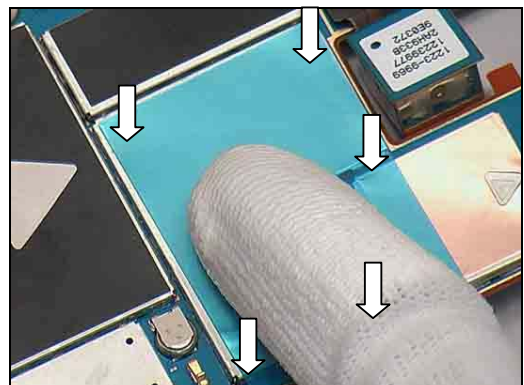


INSTALLATION

Put a new Shield Can MComp Sheet Lid A4 in place.

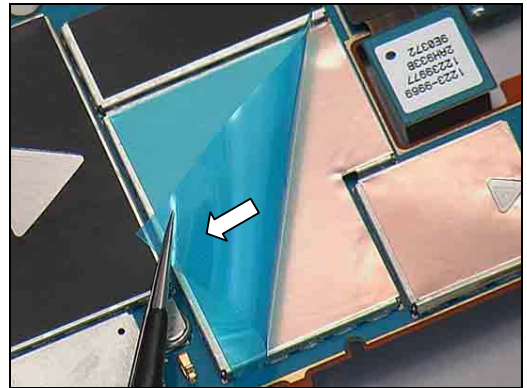


Press to secure its attachment.



Replacement: Shield Can MComp Sheet Lid A4

Peel off the protect film.



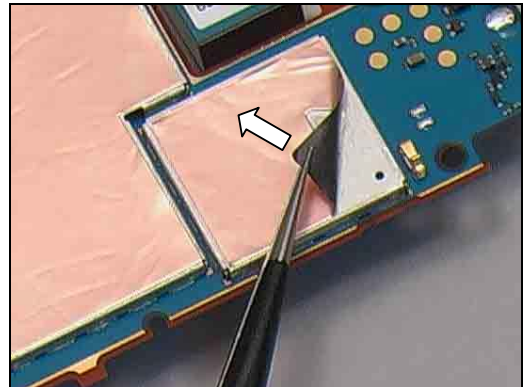
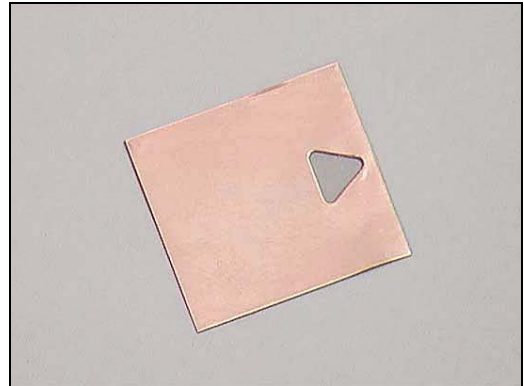
Replacement

4.28 Shield Can MComp Sheet Lid A5

Follow the 3.1 – 3.5 Disassembly instructions!
Prepare a new Shield Can MComp Sheet Lid A5.
Follow the 5.2 – 5.6 Reassembly instructions!

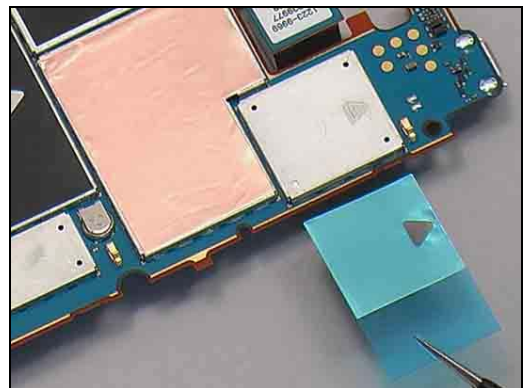
REMOVAL

Detach the Shield Can MComp Sheet Lid A5 from Main PBA

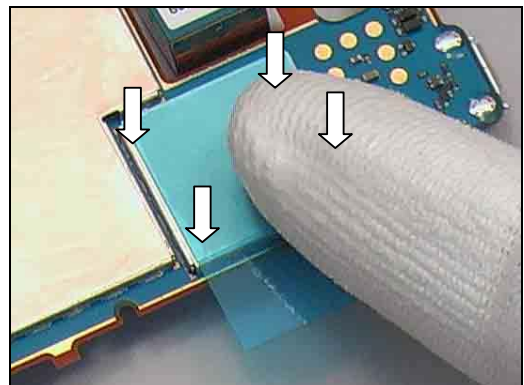


INSTALLATION

Put a new Shield Can MComp Sheet Lid A5 in place.

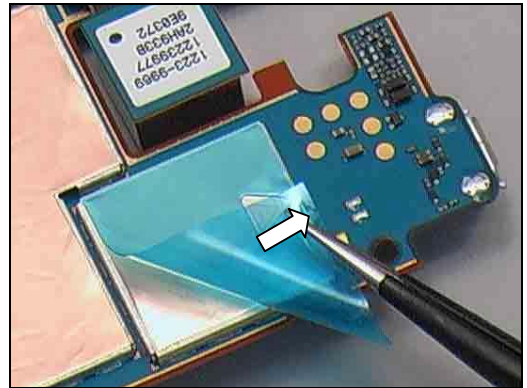


Press to secure its attachment.



Replacement: Shield Can MComp Sheet Lid A5

Peel off the protect film.



Replacement

4.29 Shield Can Lid A1

Follow the 3.1 – 3.5 Disassembly instructions!

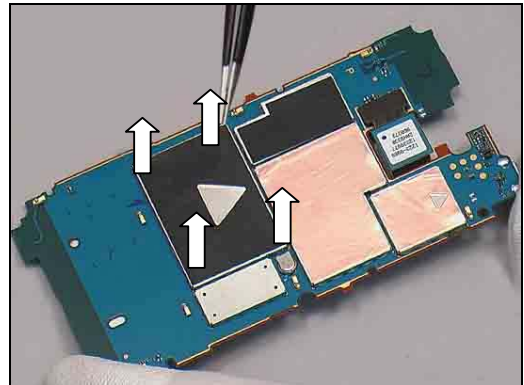
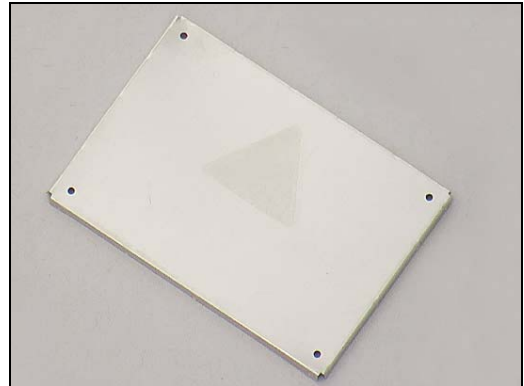
Prepare a new Shield Can Lid A1.

Follow the 5.2 – 5.6 Reassembly instructions!

REMOVAL

Unsnap the corners of the Shield Can Lid A1 with a pair of tweezers and remove it.

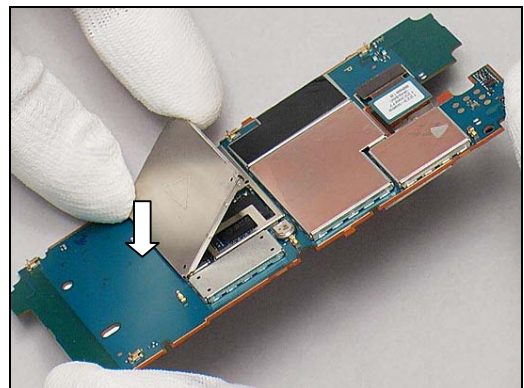
Scrap! Cannot be reused!



INSTALLATION

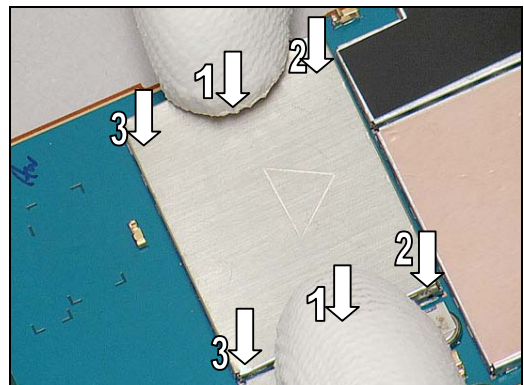
Place a new Shield Can Lid A1 from lower side as shown.

Follow the assembly steps firmly!



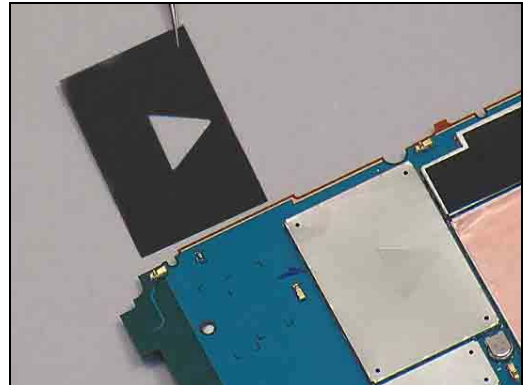
Press to snap on both sides with fingers following the order as the arrows shown.

Follow the assembly steps firmly!

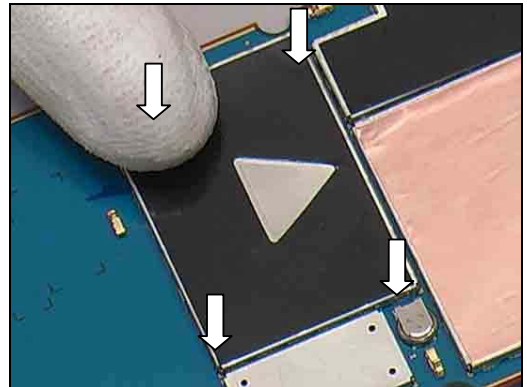


Replacement: Shield Can Lid A1

Put a new Shield Can MComp Sheet Lid A1 in place.



Press to secure its attachment.



Replacement

4.30 Shield Can Lid A2

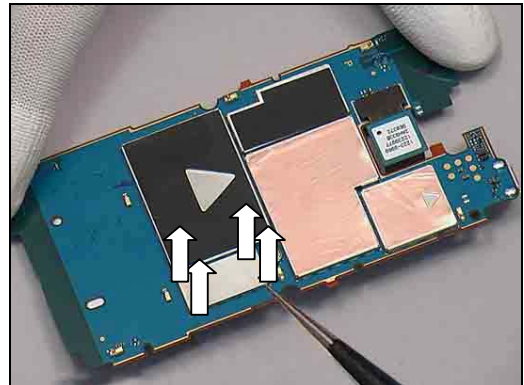
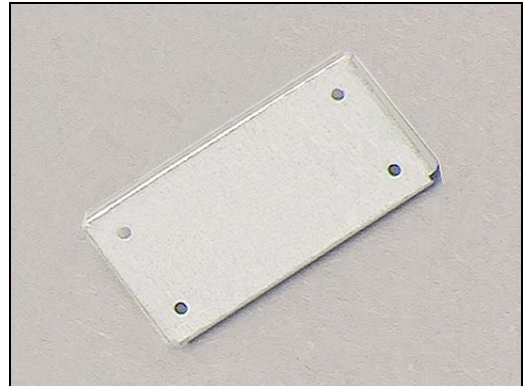
Follow the 3.1 – 3.5 Disassembly instructions!

Prepare a new Shield Can Lid A2.

Follow the 5.2 – 5.6 Reassembly instructions!

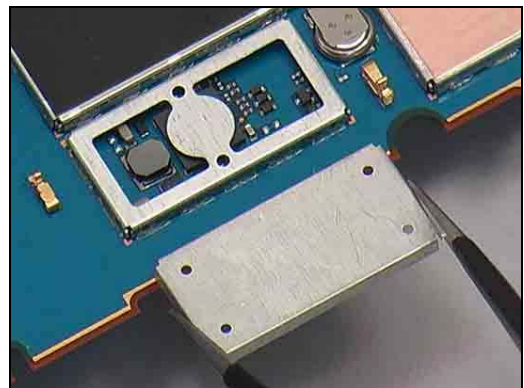
REMOVAL

Unsnap the corners of the Shield Can Lid A2 with a pair of tweezers and remove it.

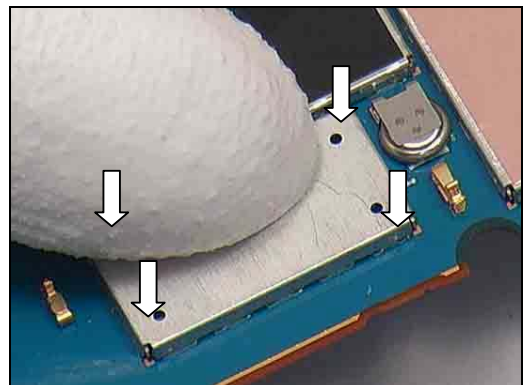


INSTALLATION

Put a new Shield Can Lid A2 in place.



Press to snap it.



Replacement

4.31 Shield Can Lid A3

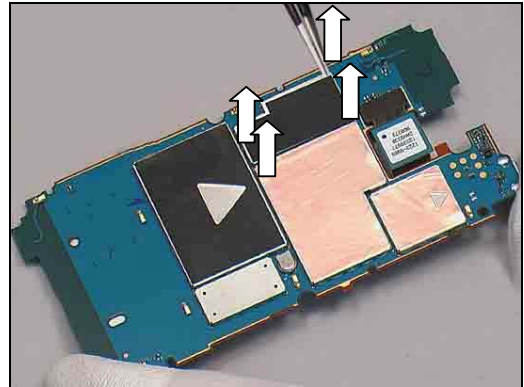
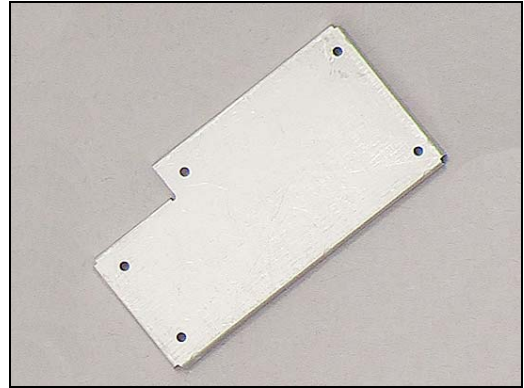
Follow the 3.1 – 3.5 Disassembly instructions!

Prepare a new Shield Can Lid A3.

Follow the 5.2 – 5.6 Reassembly instructions!

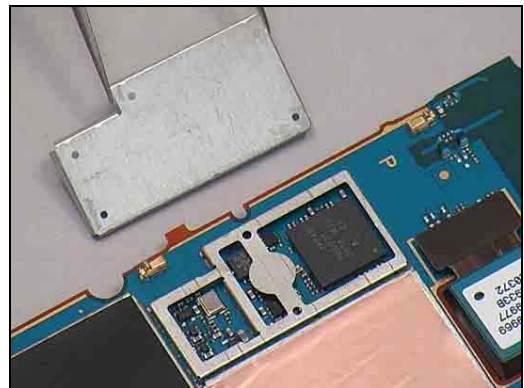
REMOVAL

Unsnap the corners of the Shield Can Lid A3 with a pair of tweezers and remove it.

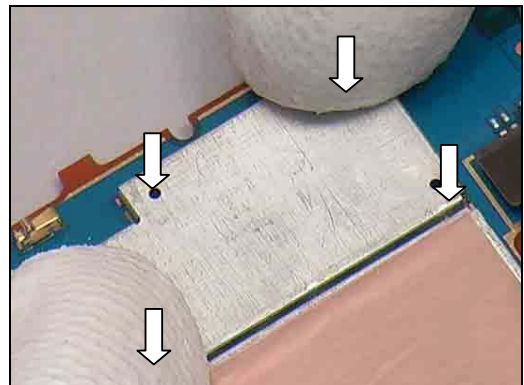


INSTALLATION

Put a new Shield Can Lid A3 in place.

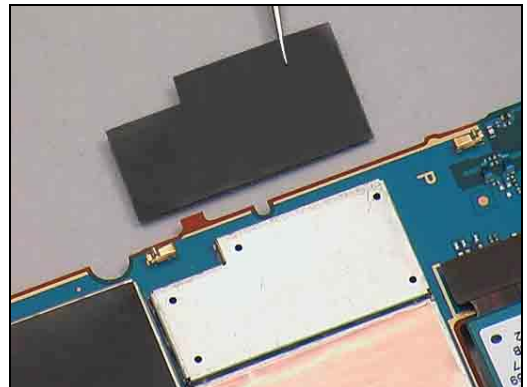


Press to snap it.

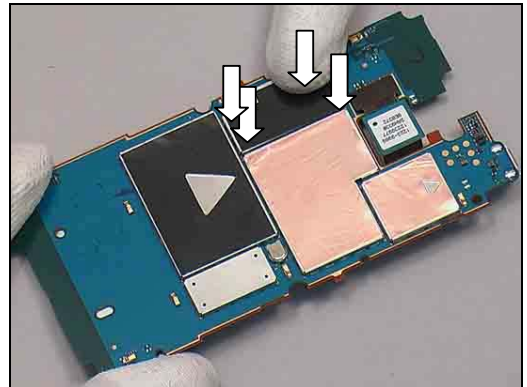


Replacement: Shield Can Lid A3

Put a new Shield Can MComp Sheet Lid A3 in place.



Press to secure its attachment.



Replacement

4.32 Shield Can Lid A4

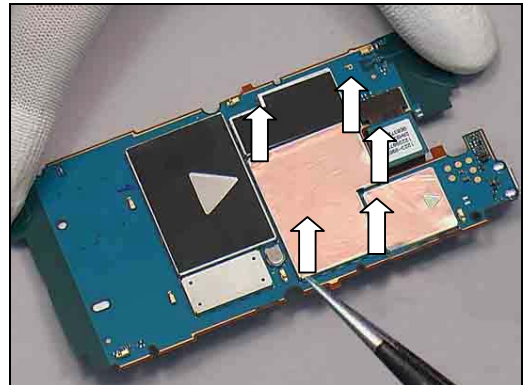
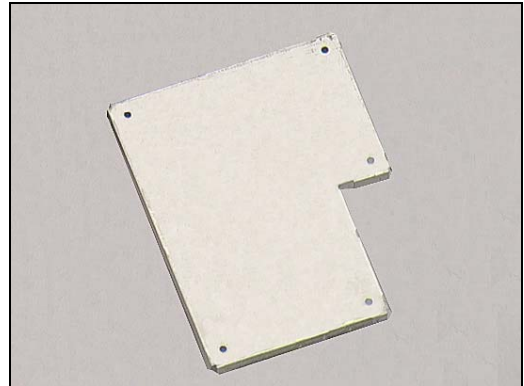
Follow the 3.1 – 3.5 Disassembly instructions!

Prepare a new Shield Can Lid A4.

Follow the 5.2 – 5.6 Reassembly instructions!

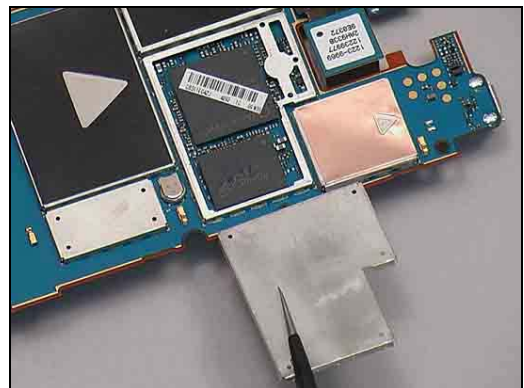
REMOVAL

Unsnap the corners of the Shield Can Lid A4 with a pair of tweezers and remove it.

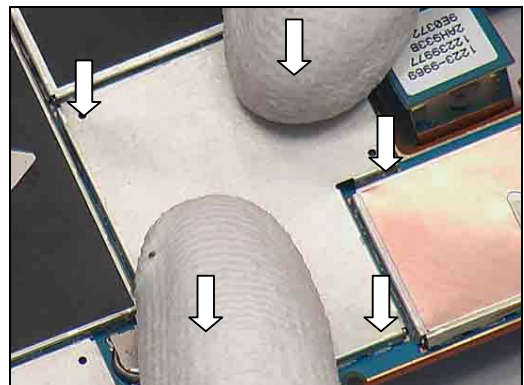


INSTALLATION

Put a new Shield Can Lid A4 in place.

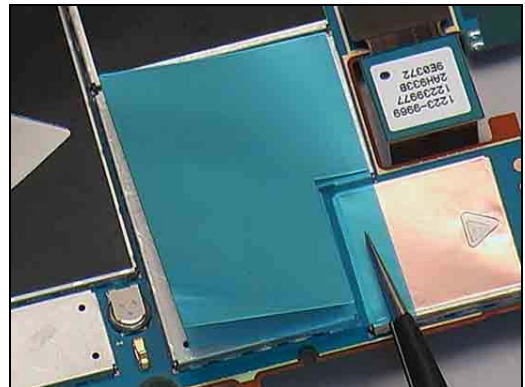


Press to snap it.

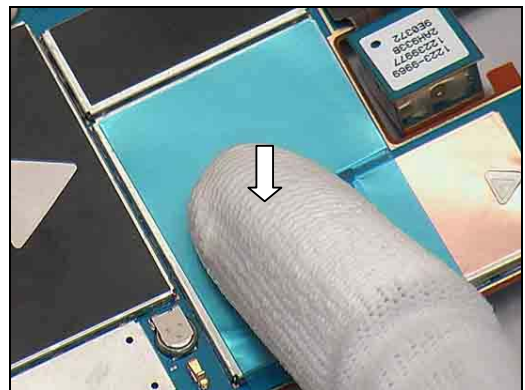


Replacement: Shield Can Lid A4

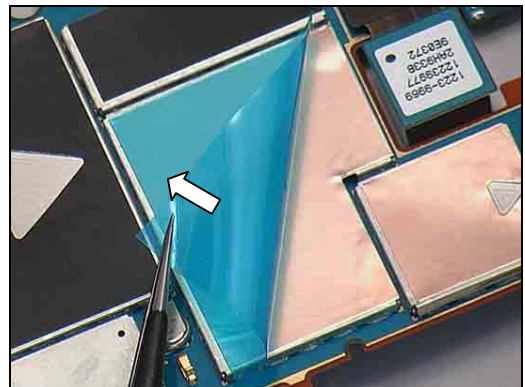
Put a new Shield Can MComp Sheet Lid A4 in place.



Press to secure its attachment.



Peel off the protect film.



Replacement

4.33 Shield Can Lid A5

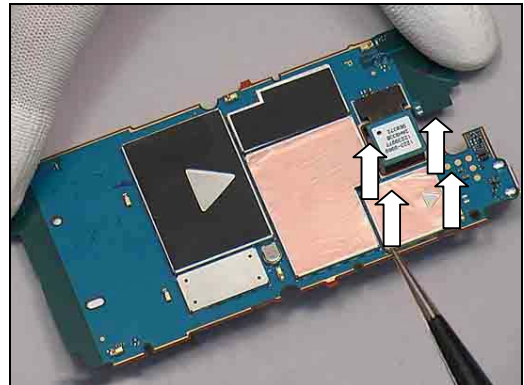
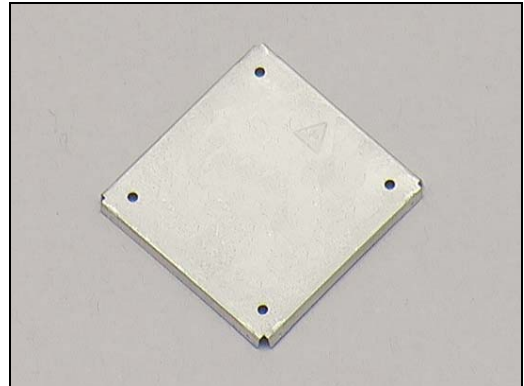
Follow the 3.1 – 3.5 Disassembly instructions!

Prepare a new Shield Can Lid A5.

Follow the 5.2 – 5.6 Reassembly instructions!

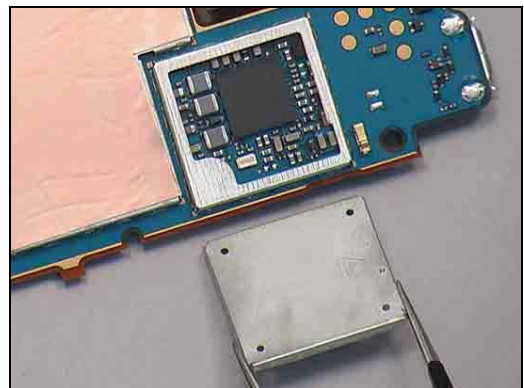
REMOVAL

Unsnap the corners of the Shield Can Lid A5 with a pair of tweezers and remove it.

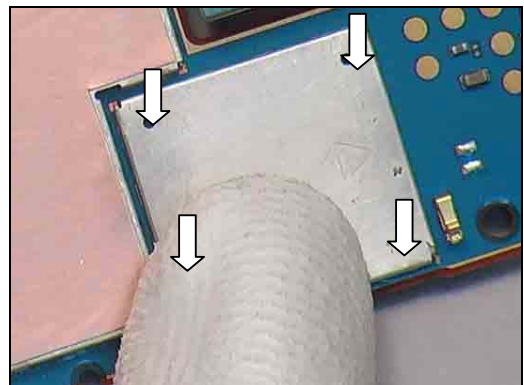


INSTALLATION

Put a new Shield Can Lid A5 in place.

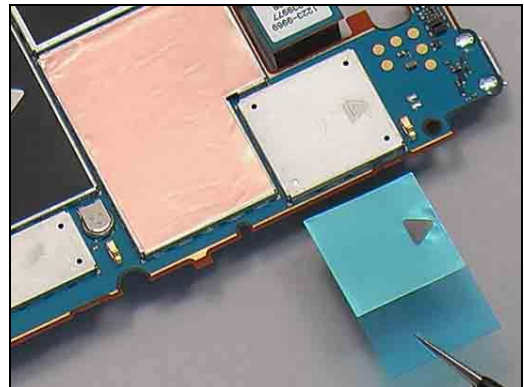


Press to snap it.

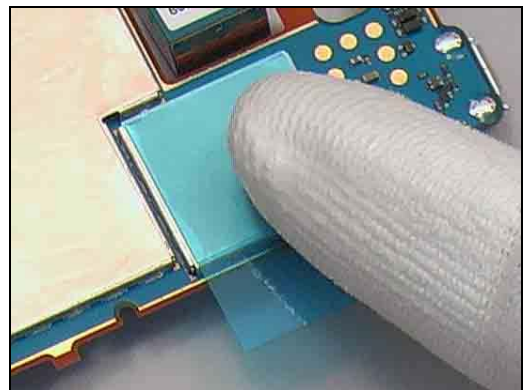


Replacement: Shield Can Lid A5

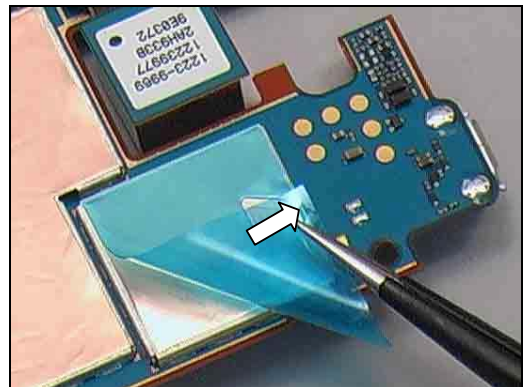
Put a new Shield Can MComp Sheet Lid A5 in place.



Press to secure its attachment.



Peel off the protect film.



Replacement

4.34 Shield Can Lid B1

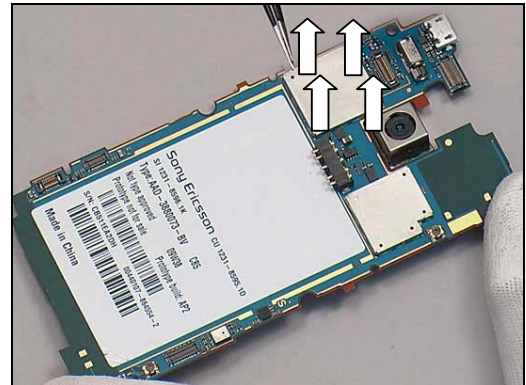
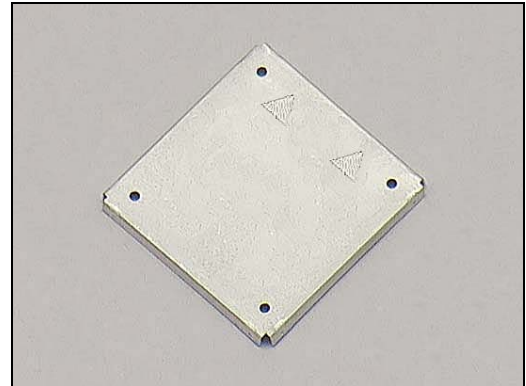
Follow the 3.1 – 3.5 Disassembly instructions!

Prepare a new Shield Can Lid B1.

Follow the 5.2 – 5.6 Reassembly instructions!

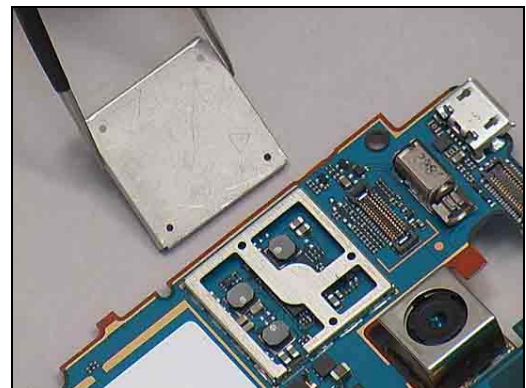
REMOVAL

Unsnap the corners of the Shield Can Lid B1 with a pair of tweezers and remove it.

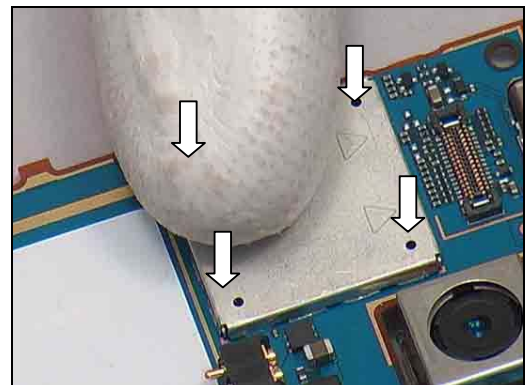


INSTALLATION

Put a new Shield Can Lid B1 in place.



Press to snap it.



Replacement

4.35 Shield Can Lid B2

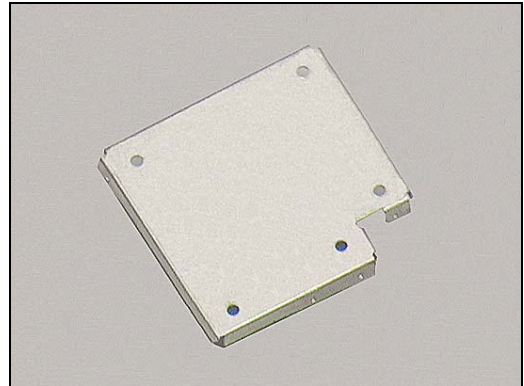
Follow the 3.1 – 3.5 Disassembly instructions!

Prepare a new Shield Can Lid B2.

Follow the 5.2 – 5.6 Reassembly instructions!

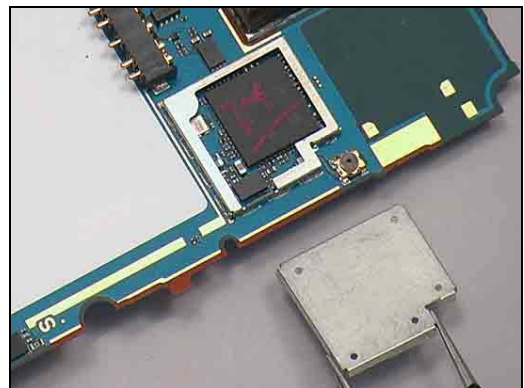
REMOVAL

Unsnap the corners of the Shield Can Lid B2 with a pair of tweezers and remove it.

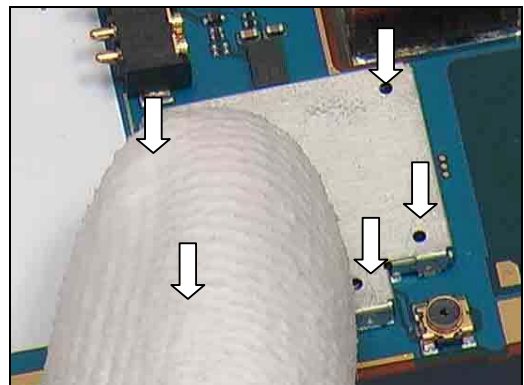


INSTALLATION

Put a new Shield Can Lid B2 in place.



Press to snap it.



Replacement

4.36 SIM and MicroSD FPC

Follow the 3.1 – 3.4 Disassembly instructions!

Prepare a new SIM and MicroSD FPC.

Follow the 5.3 – 5.6 Reassembly instructions!

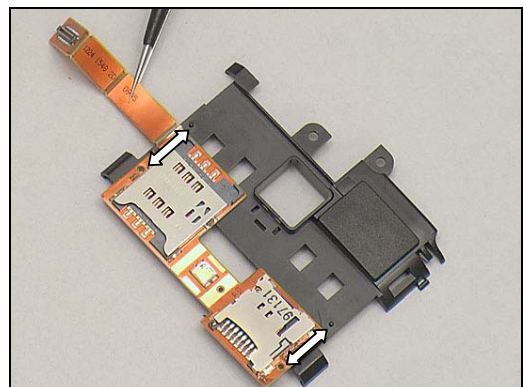
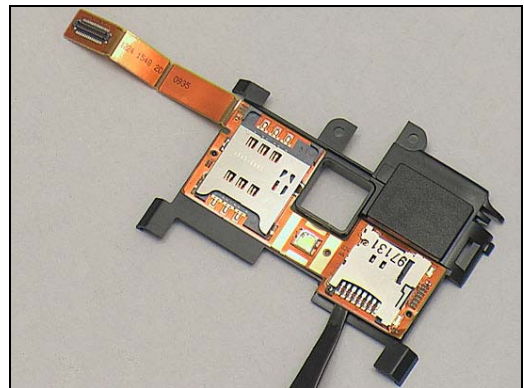
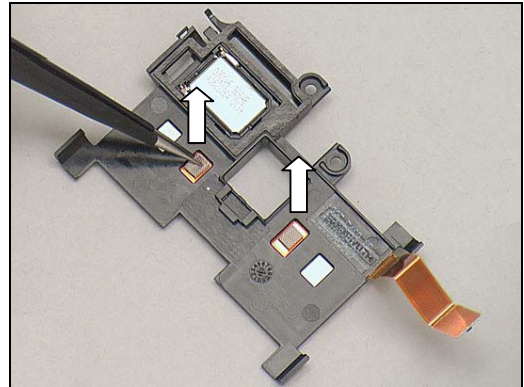
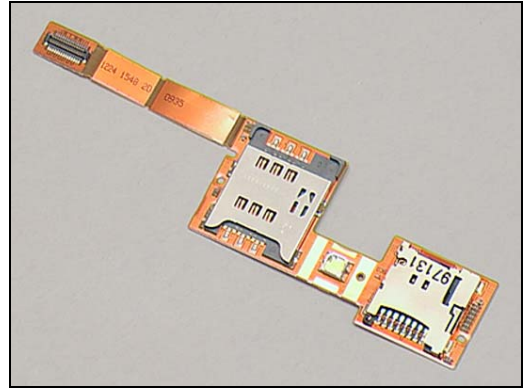
REMOVAL

Remove the two Conductive Gaskets.

Detach and remove the SIM and MicroSD FPC gently.

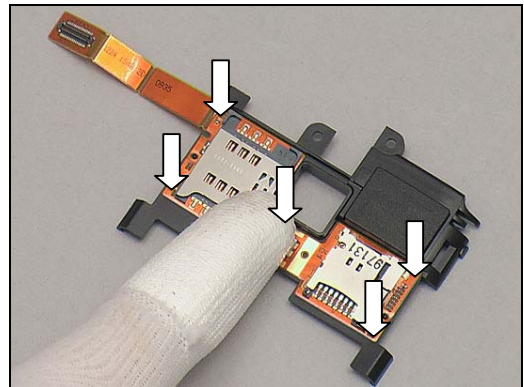
INSTALLATION

Put a new SIM and MicroSD FPC and align it with the two guiding poles of the Non-Celler Antenna Speaker Box.

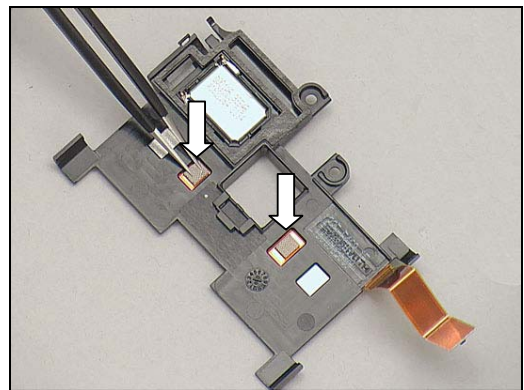


Replacement: SIM and MicroSD FPC

Press to secure its attachment.



Put the two new Conductive Gaskets onto the Unit.



Replacement

4.37 Board Swap—Replace Swap Board

Follow the 3.1 – 3.5 Disassembly instructions!

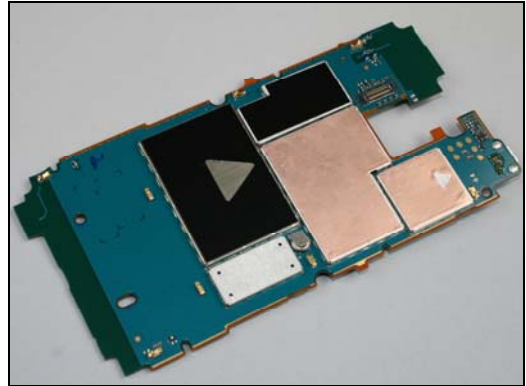
Follow the 4.9 Removal instructions!

Prepare a new swap board.

Follow the 4.9 Installation instructions!

Follow the 5.2 - 5.2 Reassembly instructions!

NOTE: Startup the unit to initialize settings, before perform Customize Phone in Emma



4.38 Board Swap – Change Label

Change Label

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

4.39 Board Swap – Customize Software

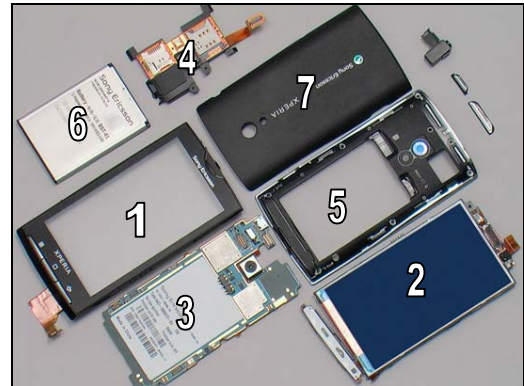
Customization of software

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

5 Reassembly

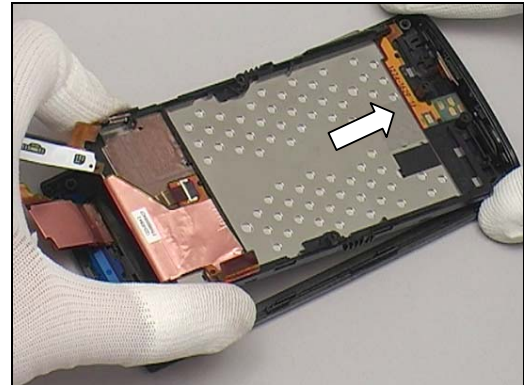
The reassembly is done in the following order:

1. Front Cover Assy
2. Frame Sub Assembly
3. Main PBA
4. Non-Celler Antenna Speaker Box
5. Rear Cover Assy
6. Battery
7. Battery Cover

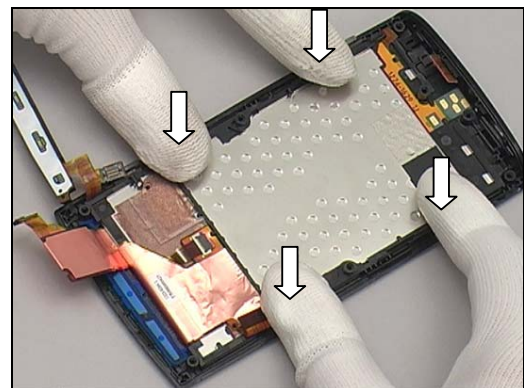


5.1 Front Cover Assy & Frame Sub Assembly

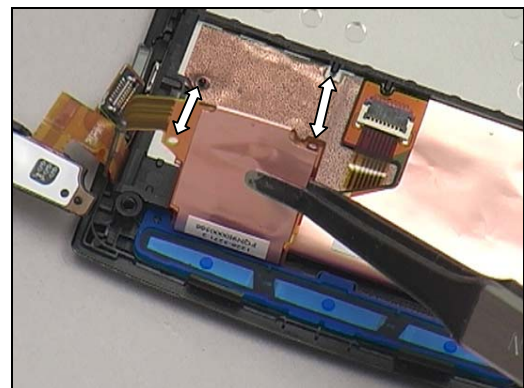
Place Frame Sub Assembly at approximately 30° onto the Front Cover Assy.



Press the Frame Sub Assembly to snap it.

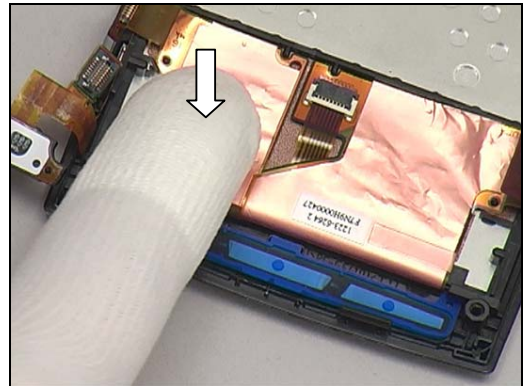


Attach the FPC aligned with the two guiding poles.

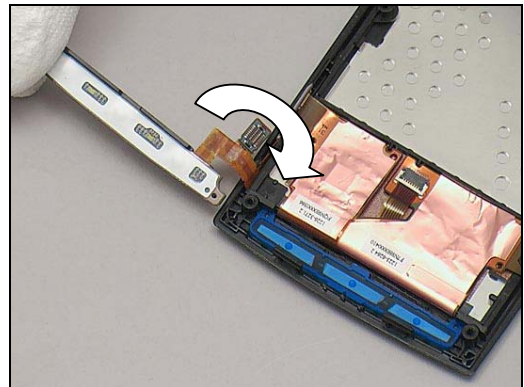


Reassembly

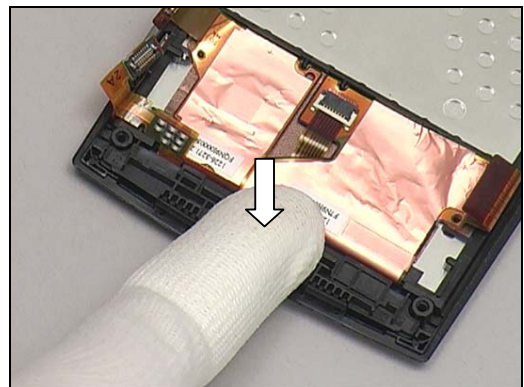
Press to secure its attachment.



Lift and gently turn over the Main Key Unit into its cavity.



Press the Main Key Unit to snap.



5.2 Main PBA

Place the Main PBA at approximately 30°.

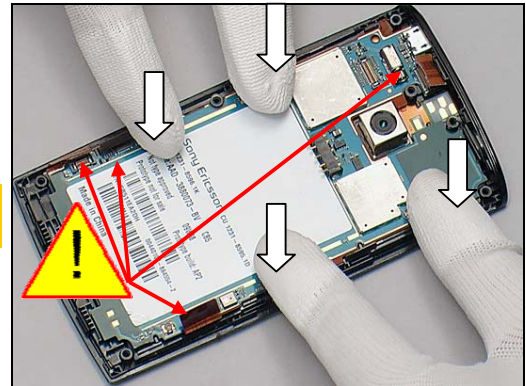
Insert the Micro USB connector first!



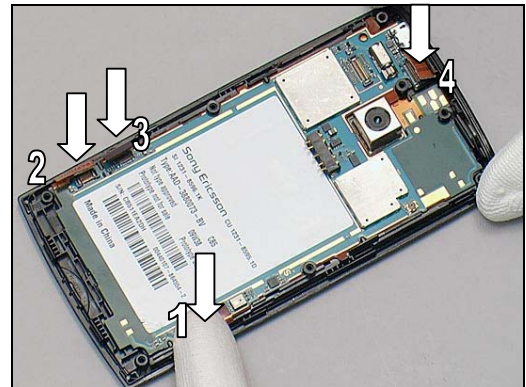
Reassembly

Press to snap the Unit.

Make sure all the BtB connectors are above the Main PBA before press!



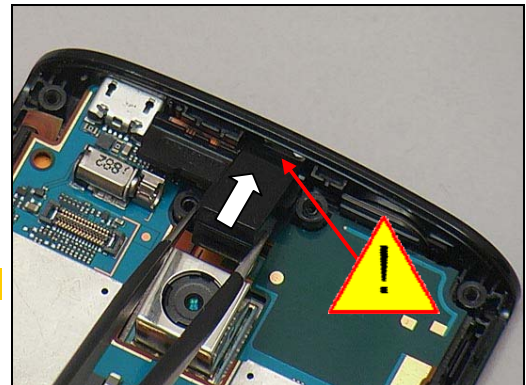
Snap the four BtB connectors as indicated



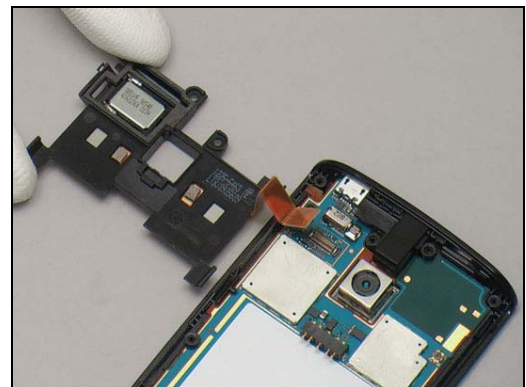
5.3 Non-Celler Antenna Speaker Box

Put the Audio Jack Unit in place.

Make sure the Audio Jack head is inserted into the hole!

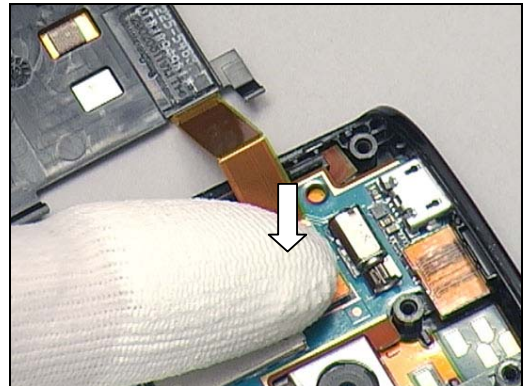


Put the Non-Celler Antenna Speaker Box in place.

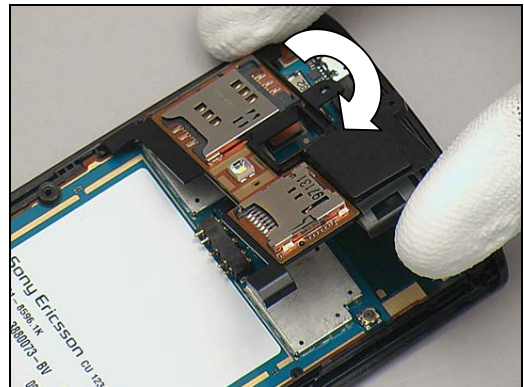


Reassembly

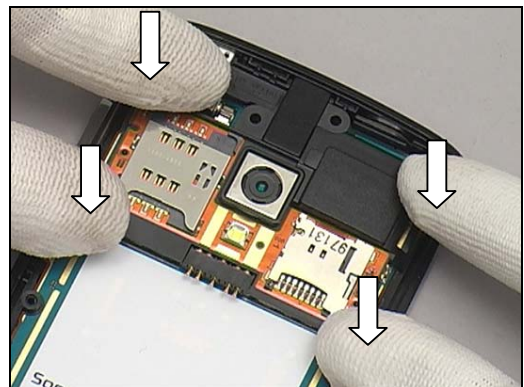
Press to snap the BtB connector by fingers.



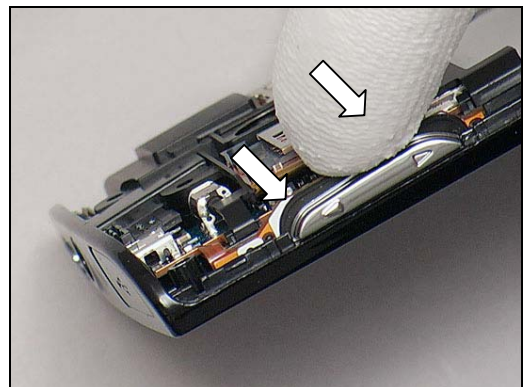
Turn over the Non-Celler Antenna Speaker Box.



Press the four hooks to snap.

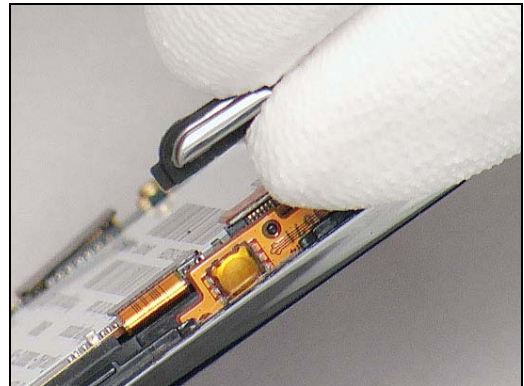


Put the Key Volume into its cavity.

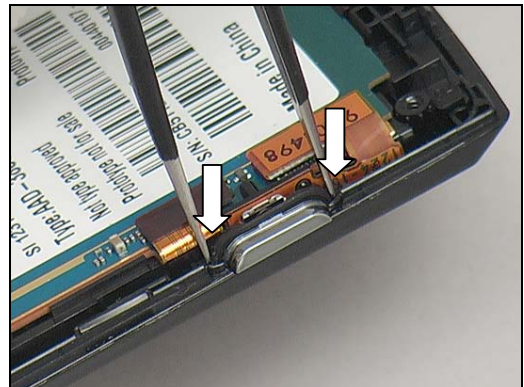


Reassembly

Put the Key Camera in place.



Fix the Key Camera by using a pair of tweezers.

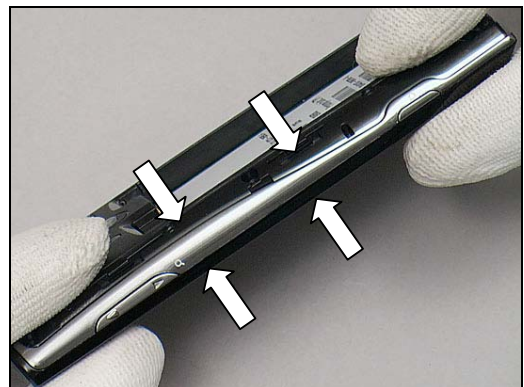


5.4 Rear Cover Assy

Put the Rear Cover Assy in place.

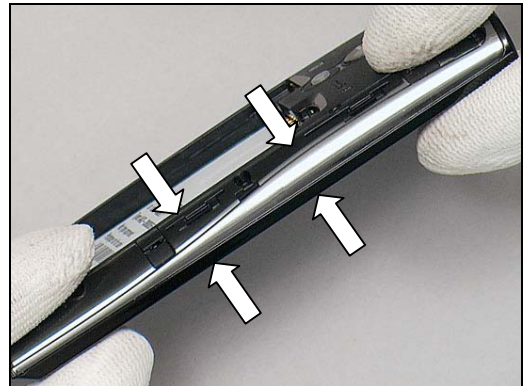


Press to snap the four hooks in the direction of the arrows.

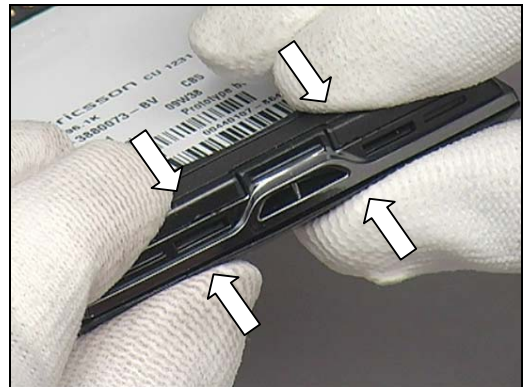


Reassembly

Press to snap the three hooks on the opposite side.



Press to snap the four hooks on the bottom side.



Press to snap the two hooks on the top side



Apply 20 Ncm torque when tightening eight Screw Other
Len:4.5 Diam:1.7 with T6.



Reassembly

5.5 Battery

Put the Battery in place.



Press the Battery into its cavity.

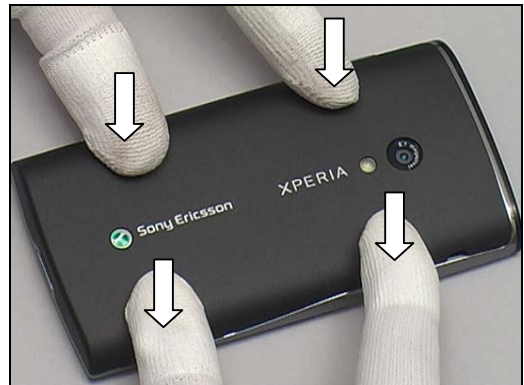


5.6 Battery Cover

Put the Battery Cover in place.



Press to snap it.



6 Country of origin Barcodes for Brazil/VIVO Labels

Below is a link to a list of countries of origin. If you are printing a Brazil or VIVO label, scan the barcode corresponding to the correct country of origin for the “Fabricado” field.



7 Revision History

Rev.	Date	Changes / Comments
1	2010-Mar-11	Initial release
2	2010-05-10	Add Board Swap Chapter
3	2010-05-10	Update one photo one page8
4	2010-07-16	Update one sequence on page 20.
5	2010-07-29	Add chapter 6 about Brazil/VIVO label content
6	2010-09-16	Add info in chapter 4.37, for startup of unit