



# Working Instruction/, Mechanical

Applicable for W350

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# 1 Introduction

W350



## 1.1 Equipment

### SPECIAL TOOLS

Special tools text:

- NTZ 122 459 Torque screwdriver (or equivalent)
- NTZ 112 1052 Bits (JCIS No.0)
- NTZ 112 478 Torx Bits T5
- NTZ 112 590 Plectrum (guitar pick)
- NTZ 112 302/2 Front opening tool



### STANDARD TOOLS

Standard tools text:

- Dentist Hook
- Tweezers
- Nylon Pointer



### ESD EQUIPMENT

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

- ESD-wristband
- ESD-gloves



### LABEL EQUIPMENT

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

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





## 1.2 General cautions

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

- ***SWITCH OFF THE PHONE AND REMOVE ANY MEMORY STICK BEFORE THE START OF THE DISASSEMBLY!***
- ***KEEP ALL CONTACT SURFACES CLEAN!***
- ***BE CAREFUL WHEN USING TOOLS LIKE THE DENTIST HOOK, TWEEZERS, OPENING TOOLS, GUITAR PICK ETC. TO AVOID SCRATCHES OR DAMAGES TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!***
- ***BE CAREFUL NOT TO DAMAGE ANY CONTACT SPRINGS!***
- ***REMEMBER TO REMOVE THE PROTECTION FOILS ON NEW PARTS SUCH AS THE FRONT COVER AND LCD!***
- ***NEVER TOUCH THE DISPLAY GLASS!***
- ***USE AIR BLOW EQUIPMENT TO KEEP THE FRONT WINDOW AND DISPLAY MODULE DUST FREE!***

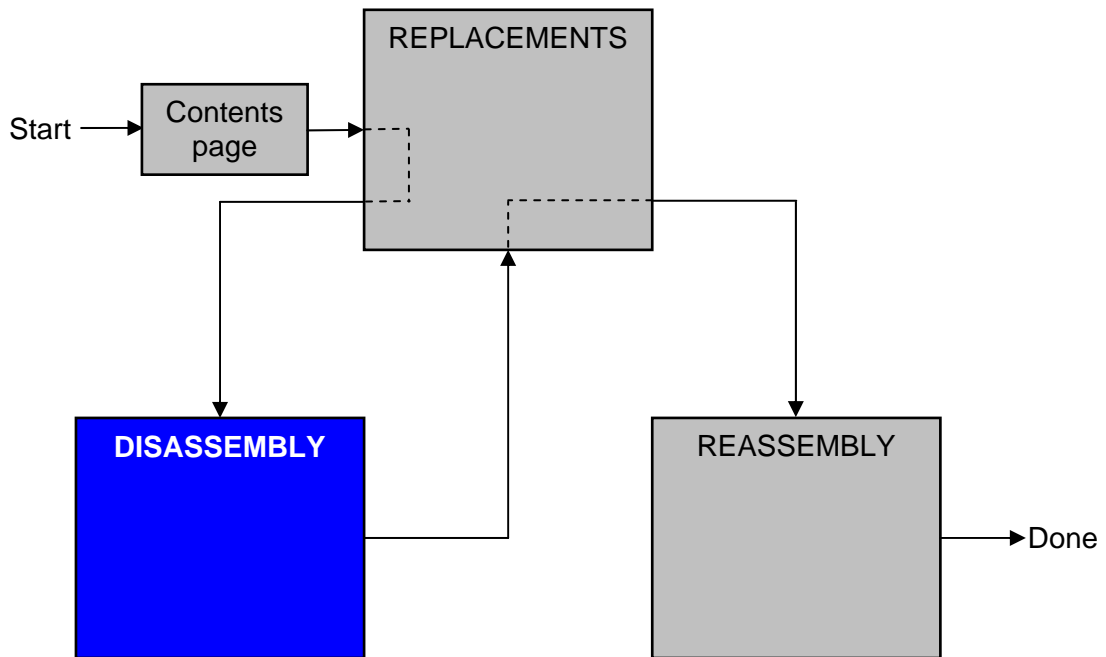
## 1.3 Adhesives

Use a dentist hook and/or the tweezers to remove old adhesives.  
Clean the surface with isopropyl alcohol before attaching new adhesives.



## 2 Disassembly

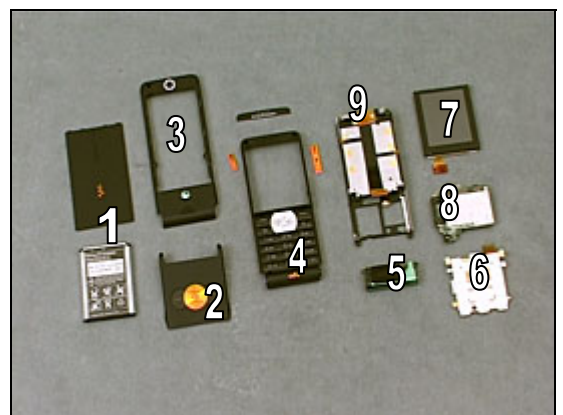
When you are going to replace a part being listed in *Replacements*, the instruction of that section usually begins by directing you to this *Disassembly* section with a specification of the instructions you have to carry out in order to disassemble the phone as far as needed before returning to *Replacements*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



### 2.1 Overview

The disassembly is done in the following sequence:

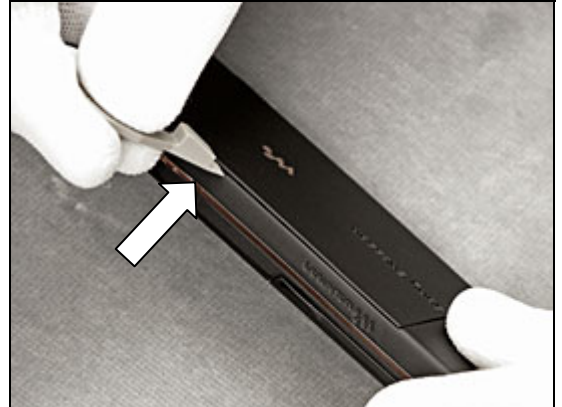
1. Battery Cover & Battery
2. Flip Assembly
3. Rear Cover Assy
4. Front Assembly & Keyboard
5. Speaker Box Assembly
6. Key Foil Assy
7. Display Assy
8. PBA
9. Carrier Inner Frame





## 2.1.1 Battery Cover & Battery

Use a Front Opening Tool to remove the battery Cover



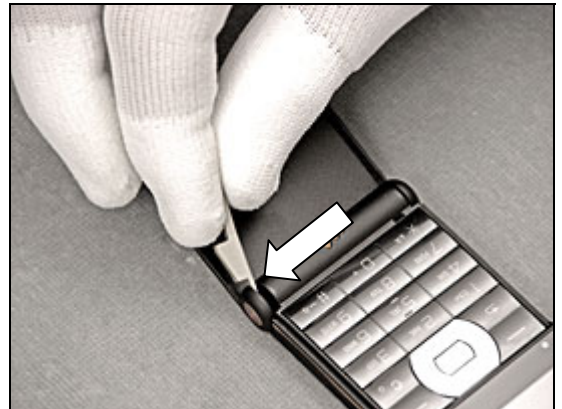
Use your Fingers to remove the Battery



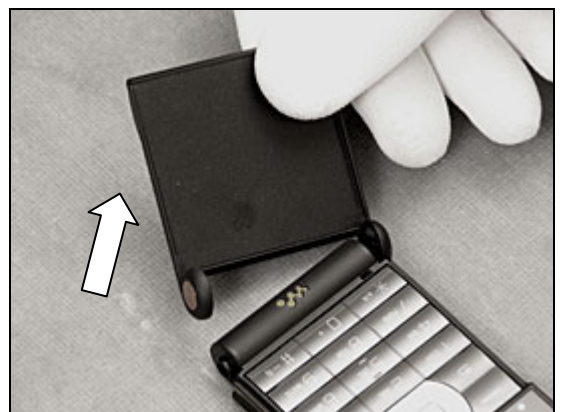
## 2.1.2 Flip Assembly

**THE FLIP MUST BE IN THE NORMAL OPEN POSITION**

Use a Front Opening Tool to loosen the Flip Assembly



Use your fingers to remove the Flip Assembly





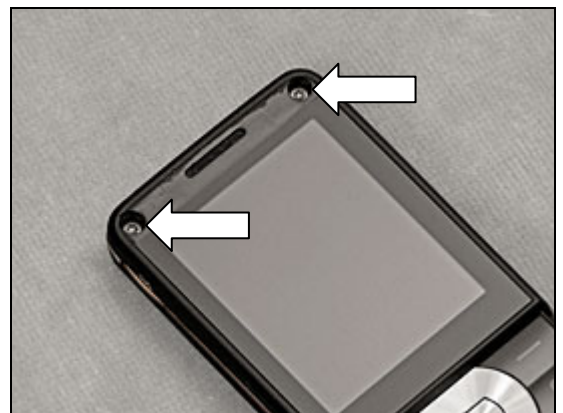
## 2.1.3 Rear Cover Assy

**BE CAREFUL NOT TO DAMAGE THE PLASTIC!**

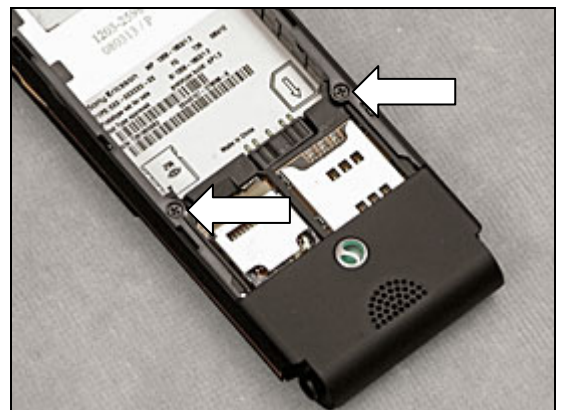
Use a Dentist Hook to remove the Front panel



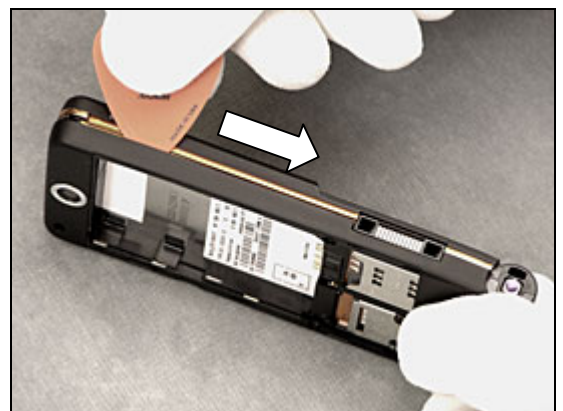
Use a Torx Bits T5 bit to remove the two screws



Use a PH00 bit to remove the two screws

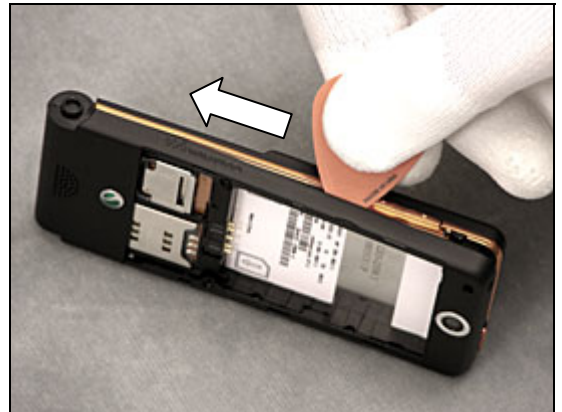


Use a Guitar Pick to loosen the Rear Cover Assy

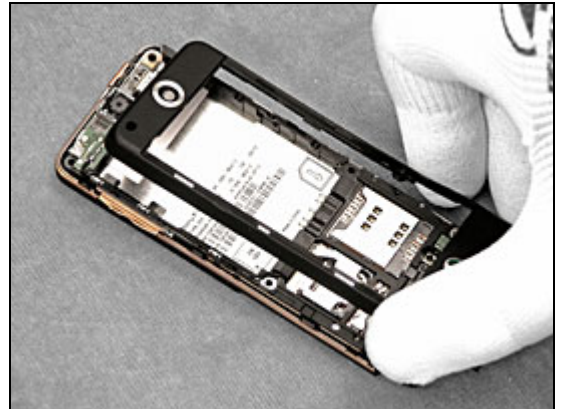




Use a Guitar Pick to loosen the Rear Cover Assy

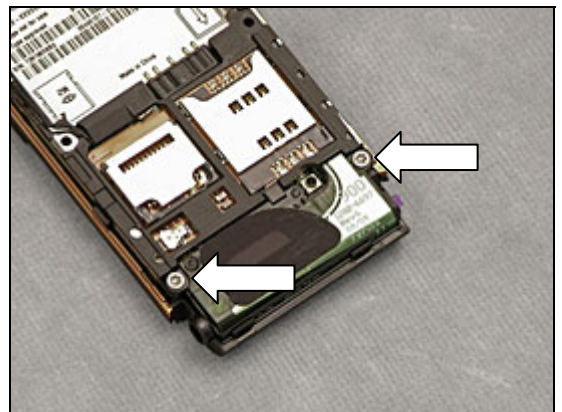


Use your fingers to remove the Rear Cover Assy

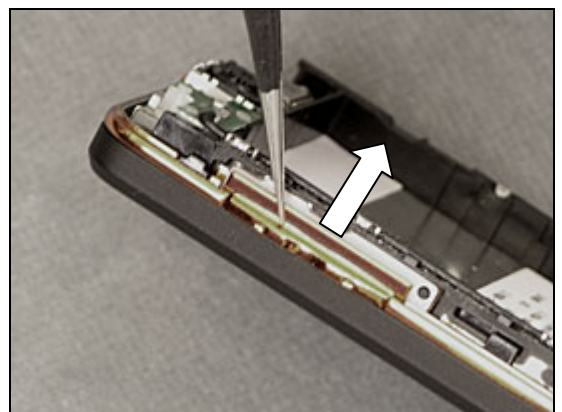


## 2.1.4 Front Assembly

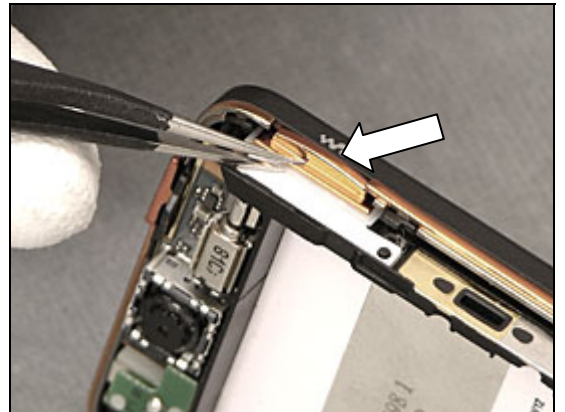
Use a Torx Bits T5 bit to remove the two screws



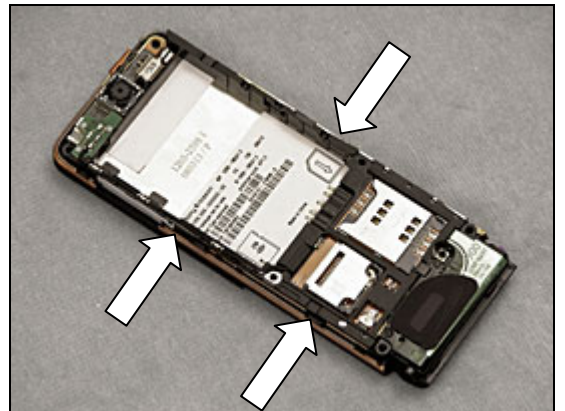
Use a pair of Tweezers to remove the Volume Key



Use a pair of Tweezers to remove the Walkman Key



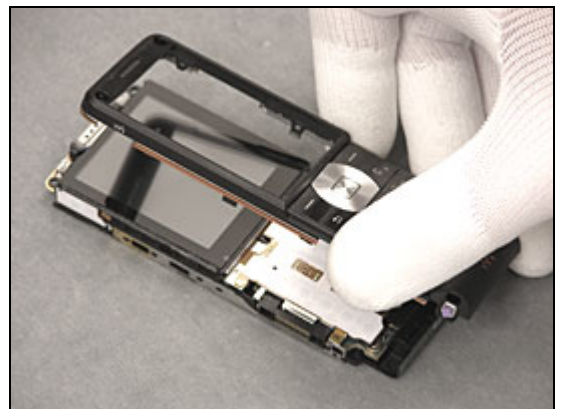
Locate the three snap hooks



Use a Front Opening Tool to loosen the Front Assembly

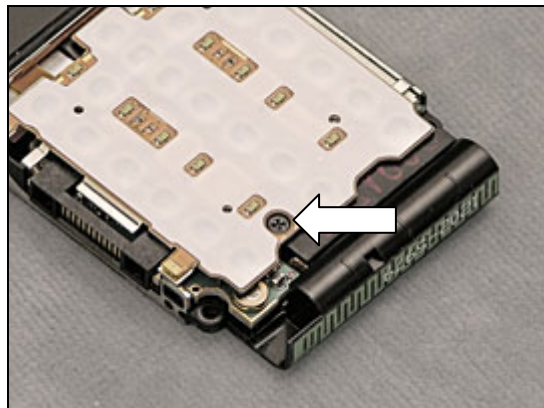


Use your fingers to remove the Front Assembly

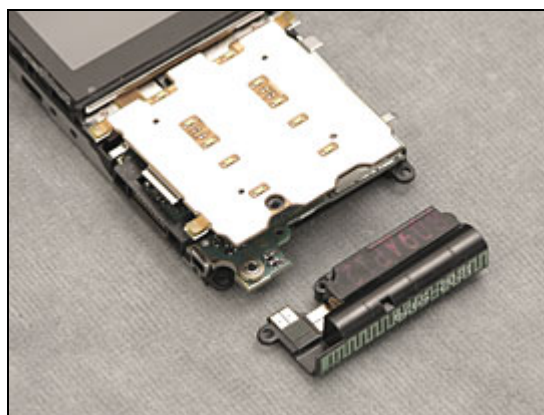


## 2.1.5 Speaker Box Assembly

Use a PH00 bit to remove the screw

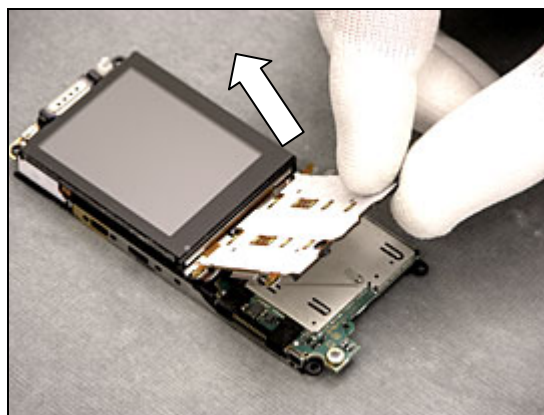


Use your fingers to remove the Speaker Box Assembly



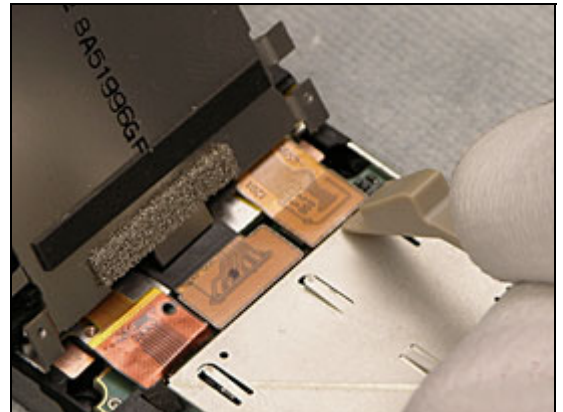
## 2.1.6 Key Foil Assy

Use your fingers to turn over the key Foil Assy





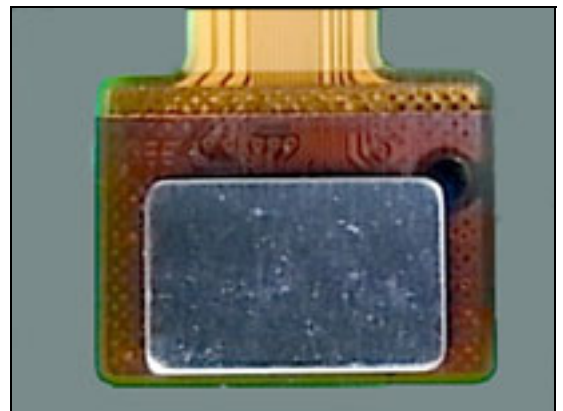
Use a Front Opening Tool to loosen the connector



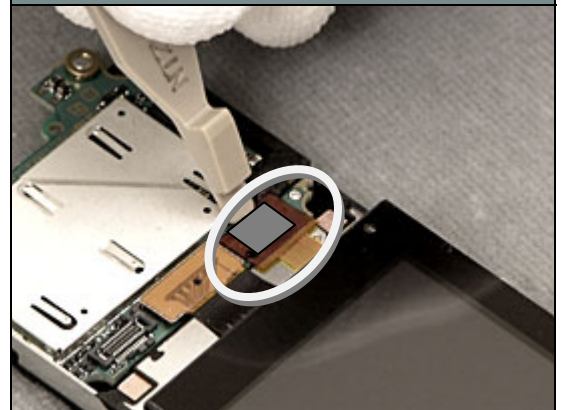
## 2.1.7 Display Assy

### **IMPORTANT**

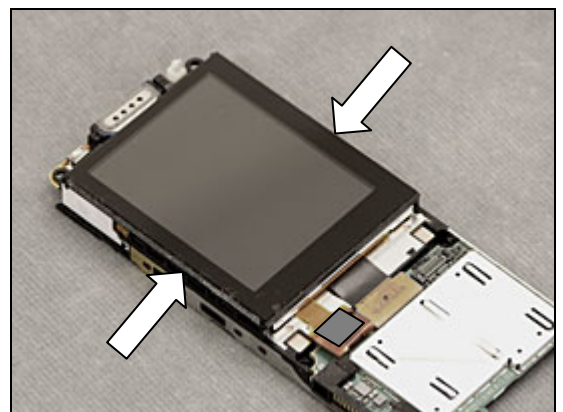
**BEFORE DISCONNECTING THE DISPLAY ASSY CONNECTOR:**  
**MOUNT THE NEW "BTB METAL STIFFENER" ON TOP OF THE**  
**CONNECTOR AS SHOWN IN PICTURE. THE POSITION IS**  
**IMPORTANT.**



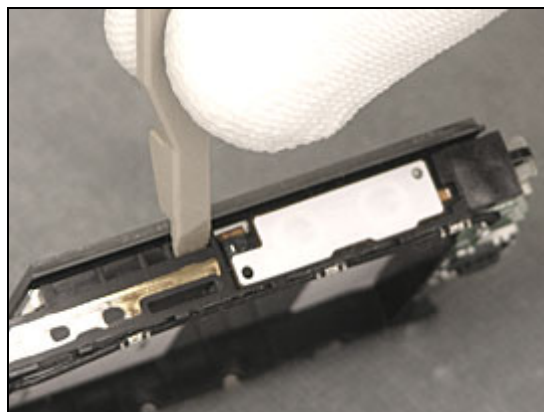
Use a Front Opening Tool to loosen the connector



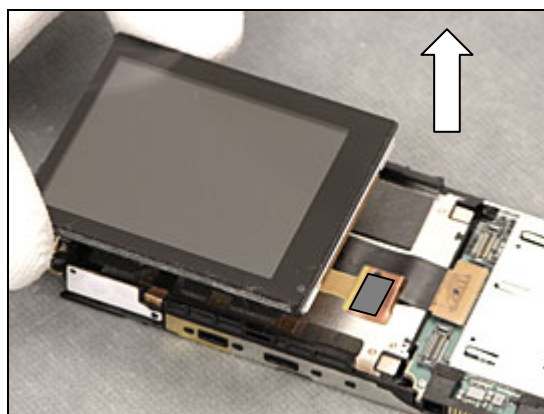
Locate the two snap hooks



Use a Front Opening Tool to unsnap the hooks.

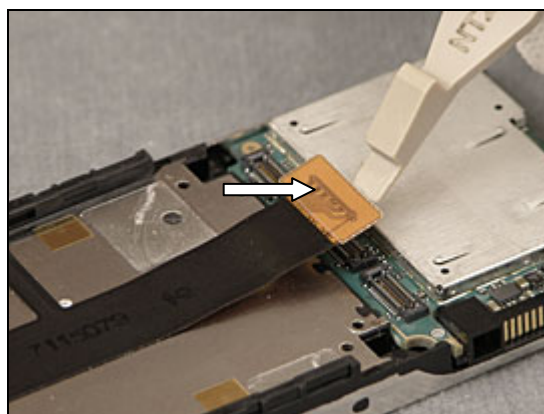


Use your fingers to remove the Display Assy

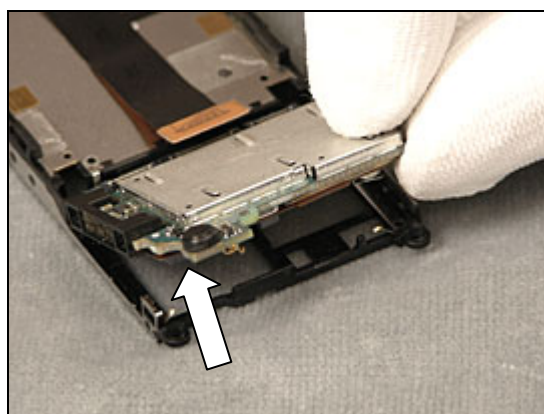


## 2.1.8 PBA

Use a Front Opening Tool to loosen the Camera PBA Assy from the PBA

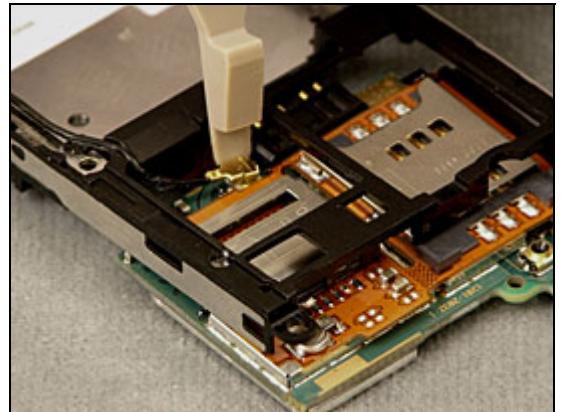


Use your fingers to unsnap the PBA





Use a Front Opening Tool to disconnect the Bluetooth Antenna Assy





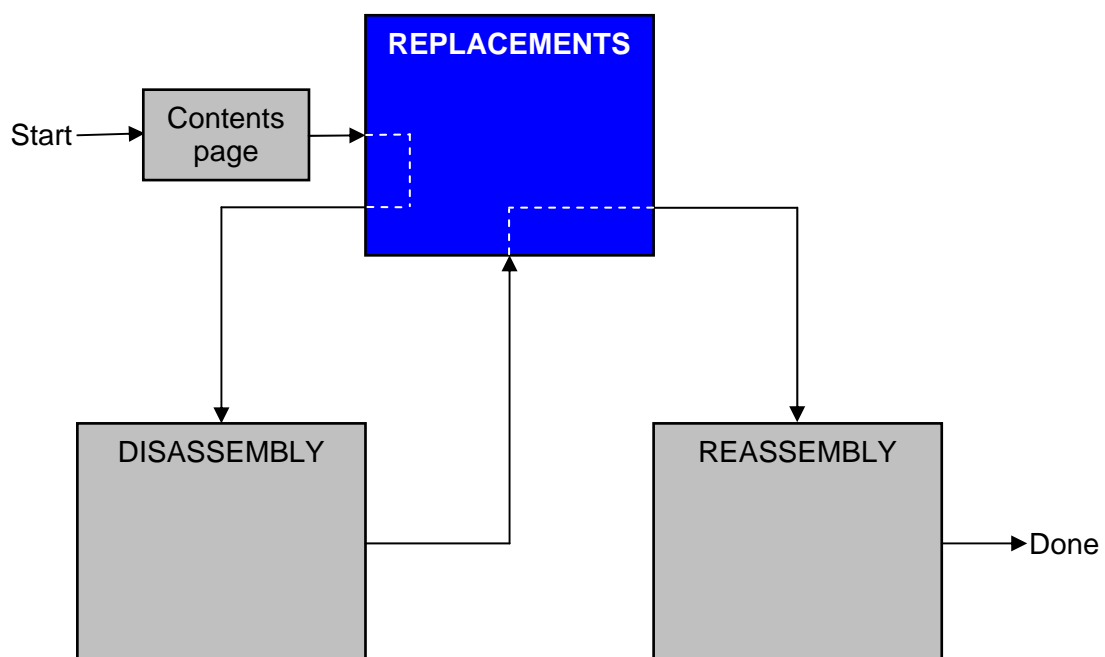
### 3 Replacements

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

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

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

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





### **3.1 Battery Cover & Battery**

*Follow the 2.1.1 Disassembly instructions!*

Replace the battery cover and/or battery

*Follow the 4.1.8 Reassembly instructions!*

### **3.2 Flip Assembly**

*Follow the 2.1.1 – 2.1.2 Disassembly instructions!*

Replace the Flip Assembly

*Follow the 4.1.7 – 4.1.8 Reassembly instructions!*

### **3.3 Rear Cover Assy**

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Replace the Rear Cover Assy

*Follow the 4.1.6 – 4.1.8 Reassembly instructions!*

### **3.4 Front Assembly**

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

Replace the Front Assembly

*Follow the 4.1.5 – 4.1.8 Reassembly instructions!*

### **3.5 Speaker Box Assembly**

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Replace the Speaker Box Assembly

*Follow the 4.1.4 – 4.1.8 Reassembly instructions!*

### **3.6 Key Foil Assy**

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

Replace the Key Foil Assy

*Follow the 4.1.3 – 4.1.8 Reassembly instructions!!*

### **3.7 Display Assy**

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Replace the Display Assy

*Follow the 4.1.2 – 4.1.8 Reassembly instructions!*

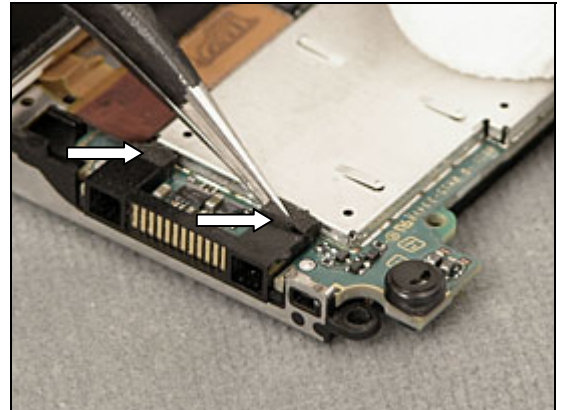


## 3.8 Gasket System Connector

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

### **REMOVAL**

Use a pair of tweezers to remove the Gasket System Connector

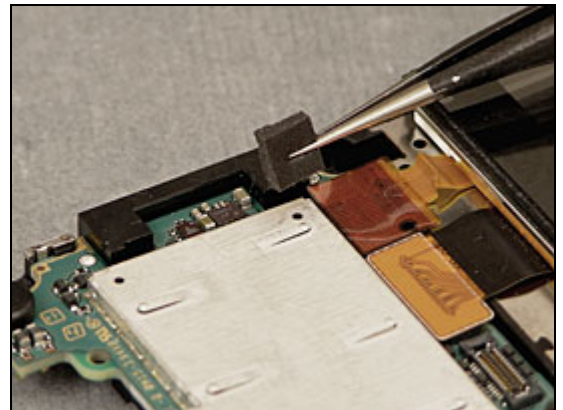


Use a pair of tweezers to remove the Gasket System Connector



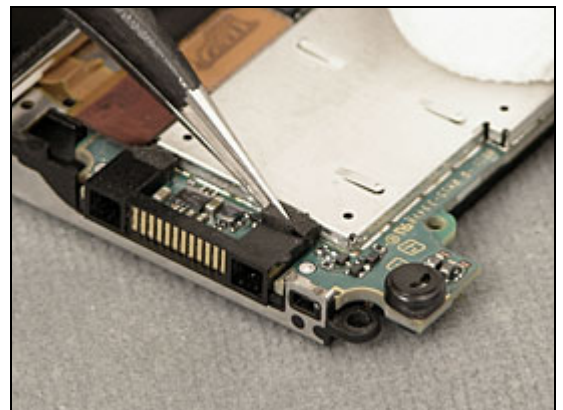
### **INSTALLATION**

Use a pair of tweezers to position the Gasket System Connector. The glossy side of the Gasket System Connector should face the Shield Can of the PBA



Use a pair of tweezers to attach the Gasket System Connectors

*Follow the 4.1.3 – 4.1.8 Reassembly instructions!*

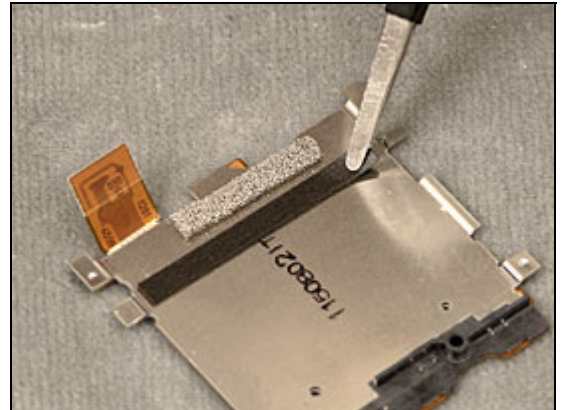


## 3.9 Cushion BtB

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*  
**ONLY APPLICABLE FOR W350I,C 900 MHz**

### REMOVAL

Use a pair of tweezers to remove the Cushion BtB



### INSTALLATION

Use a pair of tweezers to position and press with your fingers to mount the Cushion BtB

Follow the 4.1.3– 4.1.8 Reassembly instructions!

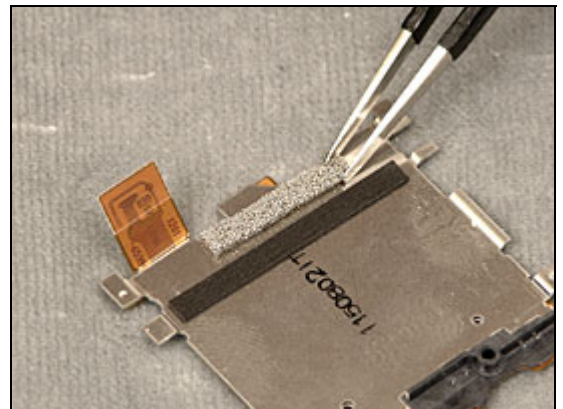


## 3.10 Cushion Conductive Carrier

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*  
**ONLY APPLICABLE FOR W350 I,C 900MHz**

### REMOVAL

Use a pair of tweezers to remove the Cushion Conductive Carrier



### INSTALLATION

Use a pair of tweezers to position and press with your fingers to mount the Cushion Conductive Carrier

Follow the 4.1.3 – 4.1.8 Reassembly instructions!



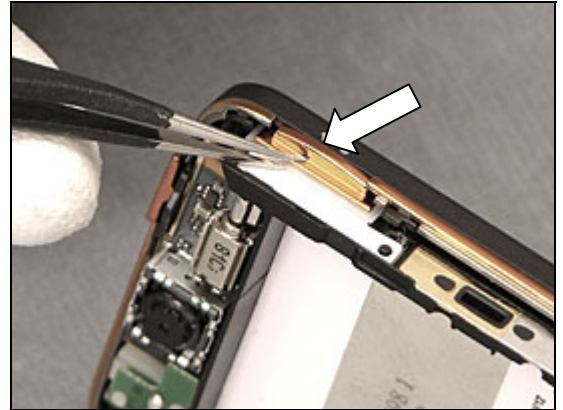


### 3.11 Walkman Key

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Use a pair of tweezers to replace the Walkman Key

*Follow the 4.1.6 – 4.1.8 Reassembly Instructions!*

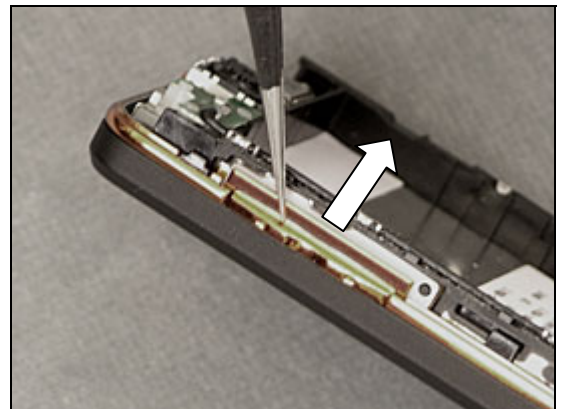


### 3.12 Volume Key

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Use a pair of tweezers to replace the Volume Key

*Follow the 4.1.6 – 4.1.8 Reassembly Instructions!*

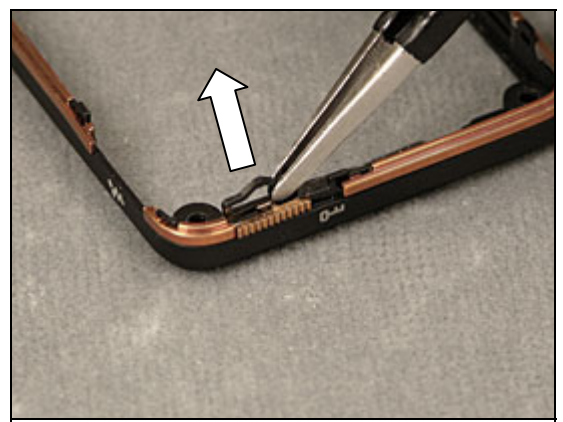


### 3.13 Key Lock Key

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

#### **REMOVAL**

Use a pair of tweezers to loosen the Key Lock Key



Use a pair of tweezers to remove the Key Lock Key



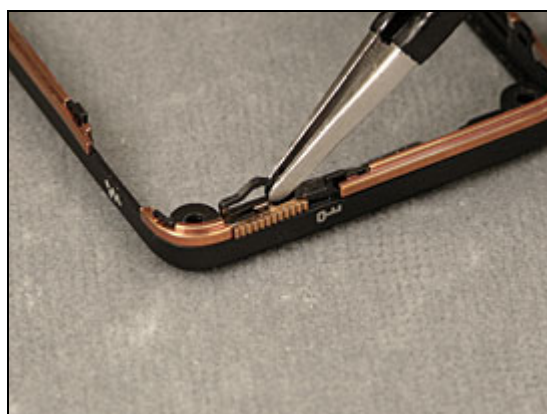
#### **INSTALLATION**

Use a pair of tweezers to position the Key Lock Key



Use a pair of tweezers to mount the Key Lock Key

*Follow the 4.1.6 – 4.1.8 Reassembly Instructions!*



### **3.14 Front Panel**

*NO disassembly necessary!*

Use a Dentist Hook to remove the Front Panel



*Use a pair of tweezers to mount the Front Panel*

*NO Reassembly necessary!*



### 3.15 Label

*Follow the 2.1.1 Disassembly instructions!*

Read the old label and/or write the information into the "Label make" program before removal

Note the position of the label before removal

Heat up the label by using hot air, if needed.

Carefully remove the label without causing scratches

If there still are residues, clean the surface with isopropyl alcohol



Check that the proper label format is loaded in the Zebra printer.

Write a new label by using the program "Label make" and check that the printing is OK.

Take the new label and place it onto the frame as in the adjacent picture.

**ONE LABEL ONLY IS ALLOWED!**

*Follow the 4.1.8 Reassembly Instructions!*

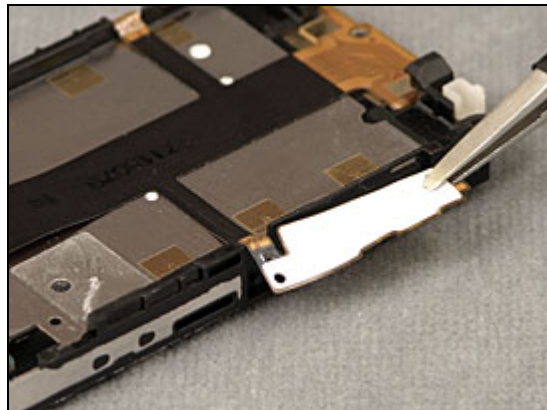


## 3.16 Camera PBA Assy

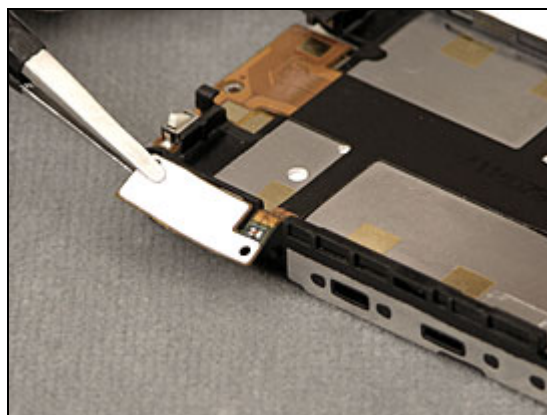
*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

### **REMOVAL**

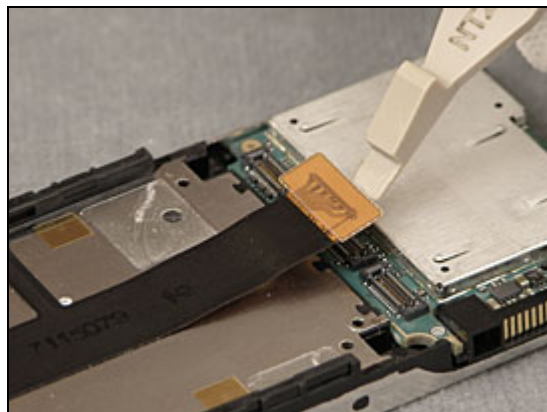
Use a blunt pair of tweezers to loosen the Volume Key Pad part of the Camera PBA Assy



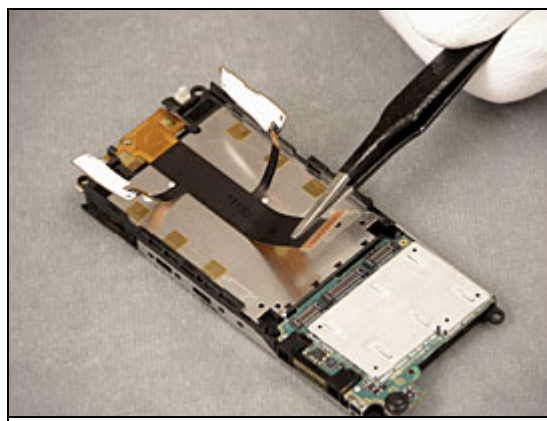
Use a pair of tweezers to loosen the Walkman Key Pad part of the Camera PBA Assy



Use a Front Opening Tool to loosen the BtB connector of the Camera PBA Assy

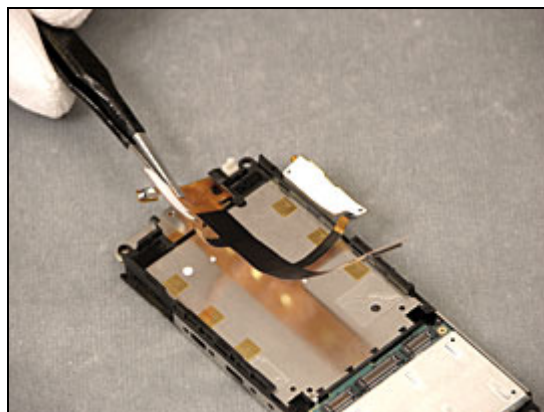


Use a pair of tweezers to loosen the Camera PBA Assy





Use a pair of tweezers to loosen the Camera PBA Assy as shown in picture



Use the Camera Removal Tool to loosen the Camera Module 1.3 MPixel



Use a pair of tweezers to remove the Camera Module 1.3 MPixel



Use a pair of tweezers to loosen the Camera PBA Assy



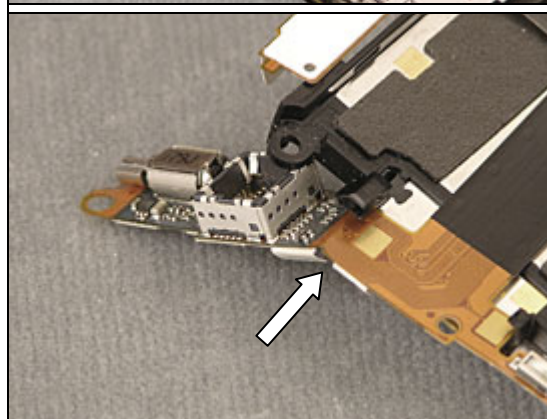


Use a pair of tweezers to remove the Camera PBA Assy



### INSTALLATION

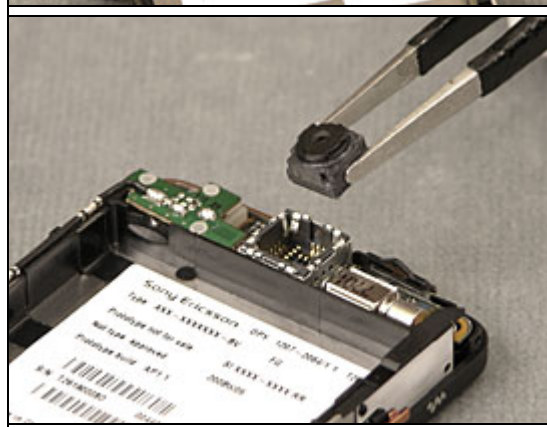
Use your fingers to position the Camera PBA Assy on the Carrier Inner Frame as shown in picture



Use your fingers to mount the Camera PBA Assy



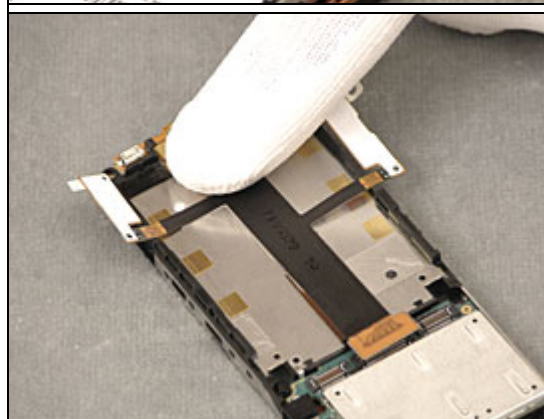
Use a pair of tweezers to position the Camera Module 1.3 MPixel



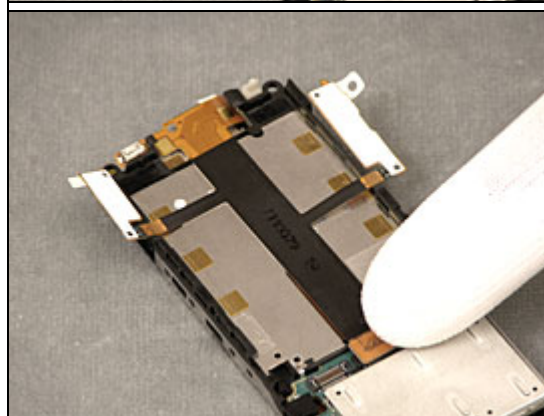
Use your fingers to mount the Camera Module 1.3 MPixel



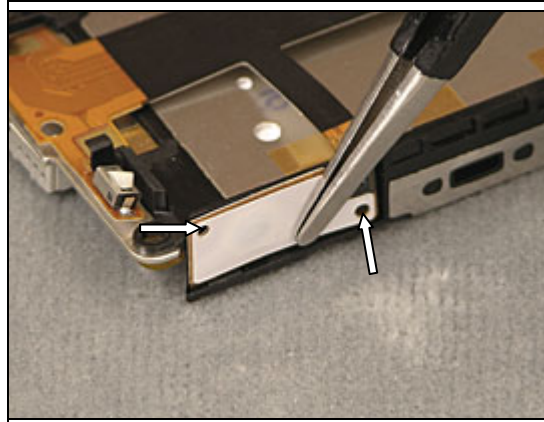
Use your fingers to mount the Flex part of Camera PBA Assy



Use your fingers to attach the Camera PBA Assy connector

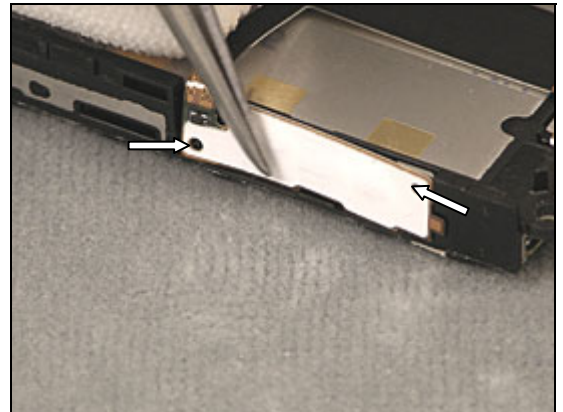


Use a pair of tweezers to attach the Walkman key Pad part of the Camera PBA Assy. Align the Walkman Pad Part correctly (see arrows in the picture)



Use a pair of tweezers to attach the Volume Key Pad part of the Camera PBA Assy. Align the Volume Pad Part correctly (see arrows in the picture)

Follow the 4.1.6 – 4.1.8 Reassembly Instructions!

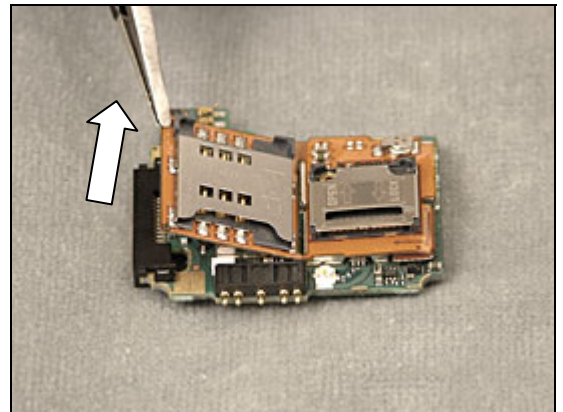


### 3.17 SIM M2 Assy

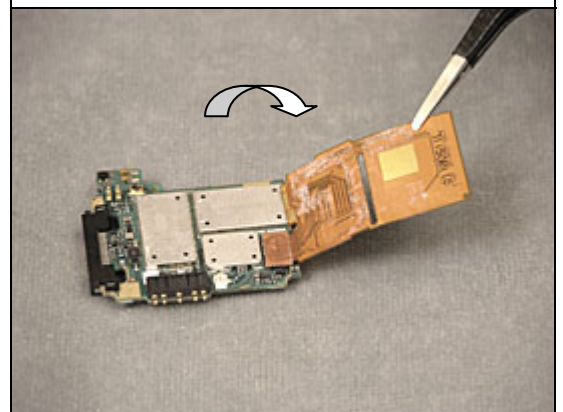
Follow the 2.1.1 – 2.1.8 Disassembly instructions!

#### **REMOVAL**

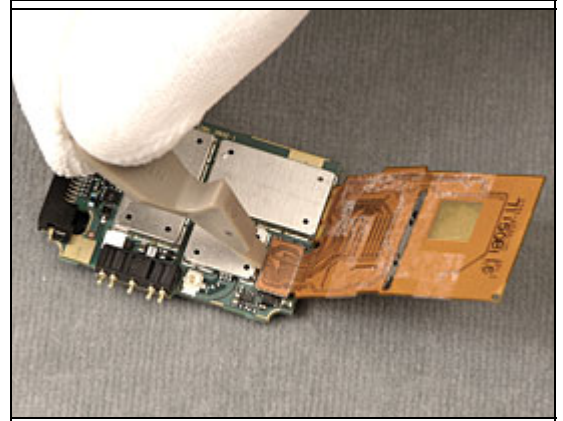
Use a pair of tweezers to remove the SIM M2 from the PCB



Use a pair of tweezers to lift up the SIM M2



Use a Front Opening Tool to disconnect the SIM M2

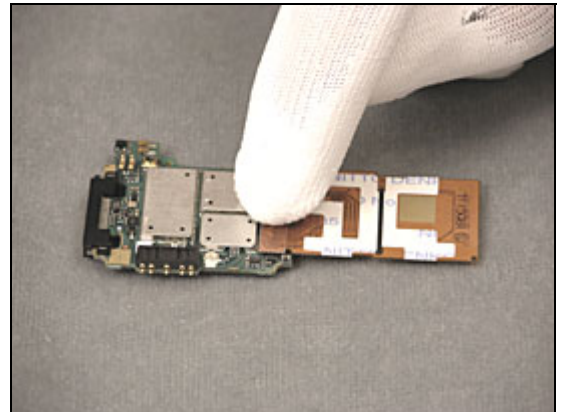




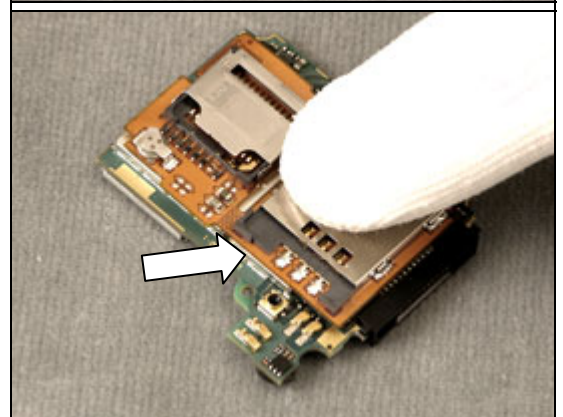
**INSTALLATION**

**NO REUSE OF THE SIM M2 ASSY**

Use your fingers to connect the BtB contact of the SIM M2 assy



Remove the protection tape and use your fingers to attach the SIM M2. Align the SIM M2 perfectly to the Shield Can (see arrow in the picture)



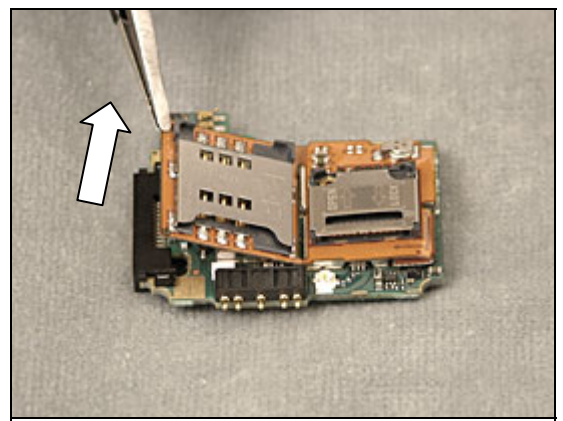
*Follow the 4.1.1 – 4.1.8 Reassembly Instructions!*

## 3.18 Liquid Intrusion Indicator

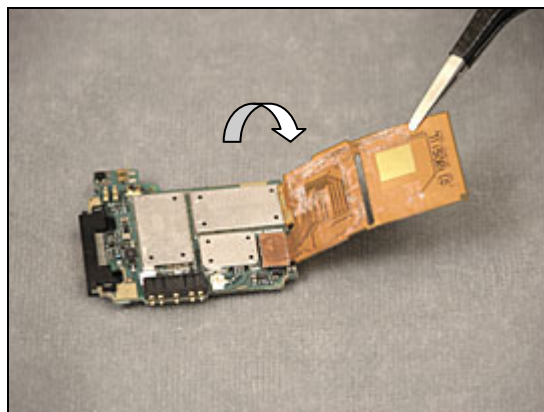
*Follow the 2.1.1 – 2.1.8 Disassembly instructions!*

**REMOVAL**

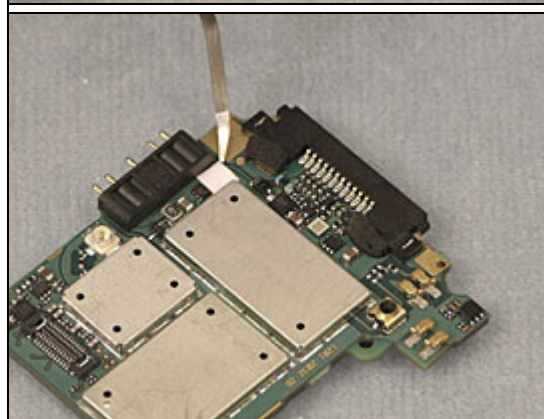
Use a pair of tweezers to loosen the SIM M2 from the PCB



Use a pair of tweezers to loosen the SIM M2

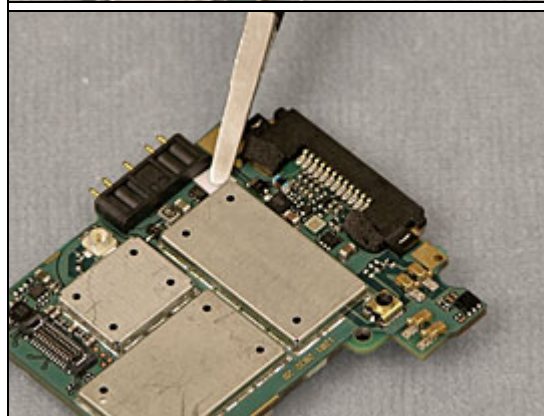


Use a Dentist Hook to remove the Liquid Intrusion Indicator



### **INSTALLATION**

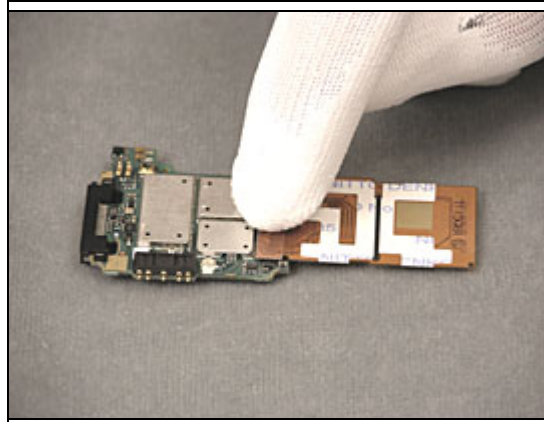
Use a pair of tweezers to mount the Liquid Intrusion Indicator



### **INSTALLATION**

#### **NO REUSE OF THE SIM M2 ASSY**

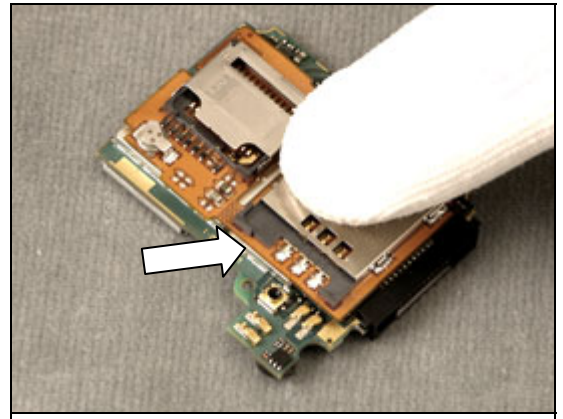
Use your fingers to connect the BtB connector of the SIM M2 assy





Remove the protection tape and use your fingers to attach the SIM M2. Align the SIM M2 perfectly to the Shield Can (see arrow in the picture)

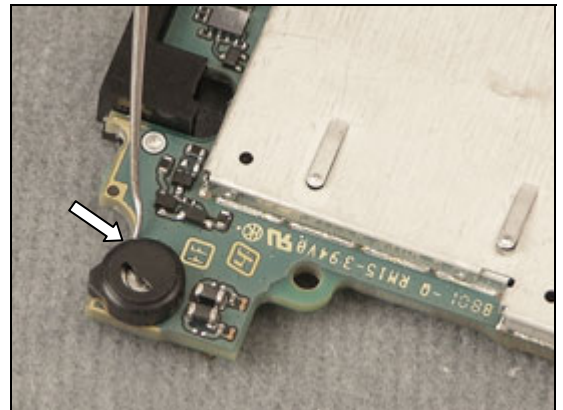
*Follow the 4.1.1 – 4.1.8 Reassembly Instructions!*



### 3.19 Gasket Microphone Grommet

*Follow the 2.1.1 – 2.1.8 Disassembly instructions!*

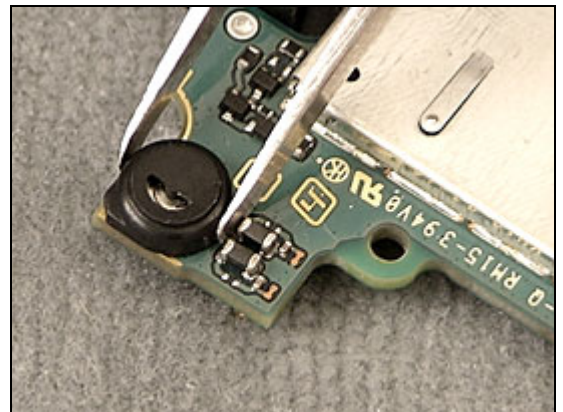
Use a Dentist Hook to remove the Gasket Microphone Grommet



#### **INSTALLATION**

Use a pair of tweezers to mount the Gasket Microphone Grommet

*Follow the 4.1.1- 4.1.8 Reassembly Instructions!*



### 3.20 Screw PH 6.0x1.4 mm

*Follow the 2.1.1 Disassembly instructions!*

Use a PH00 bit to replace the two PH Screws 9 +/- 0.5 Ncm

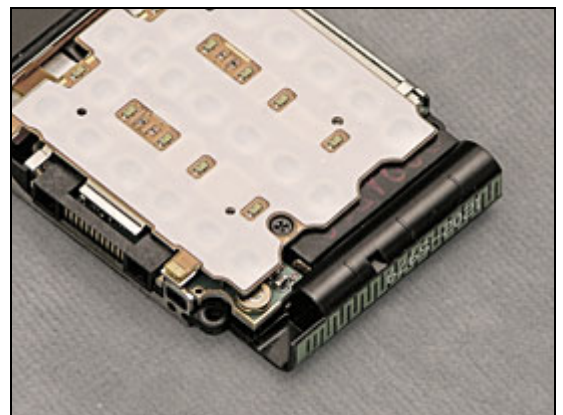
Follow the 4.1.8 Reassembly Instructions!



*Follow the 2.1.1- 2.1.4 Disassembly instructions!*

Use a PH00 bit to replace the PH Screws 9 +/- 0.5 Ncm

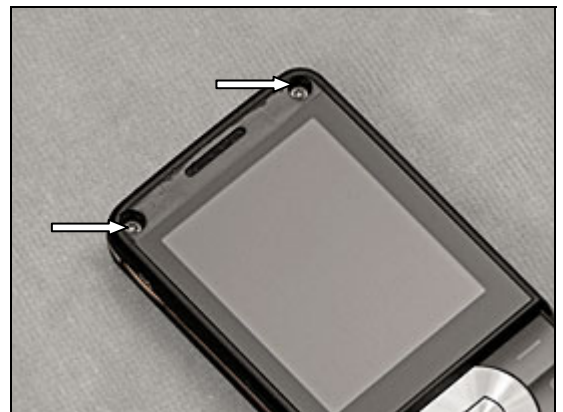
Follow the 4.1.5 – 4.1.8 Reassembly Instructions!



### 3.21 Screw Torx Len:5, Diam:1.6

*Remove the Front Panel (3.14) before continuing*

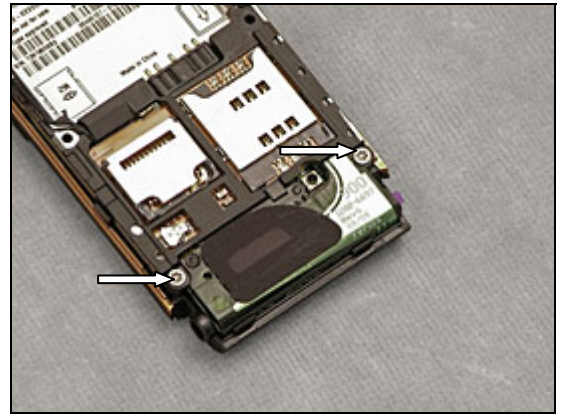
Use a Torx Bits T5 bit to replace the two Torx Screws 18+/- .5 N.cm



*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

Use a Torx Bits T5 bit to replace the two Torx Screws 10+/- .5 n.cm

*Follow the 4.1.6 – 4.1.8 Reassembly Instructions!*



## 3.22 Hinge

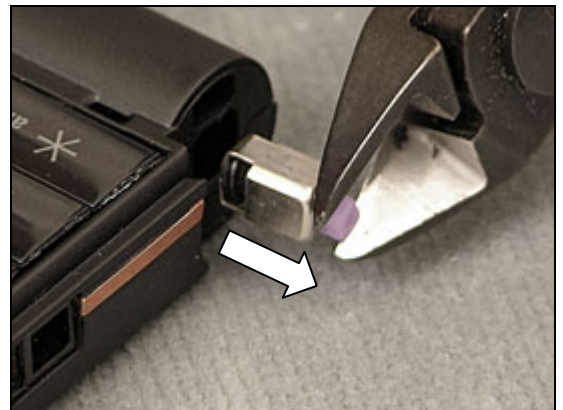
*Follow the 2.1.2 Disassembly instructions!*

### REMOVAL

Use a Cutting Pliers to remove the Hinge



Use a Cutting Plier to pull and remove the Hinge



### INSTALLATION

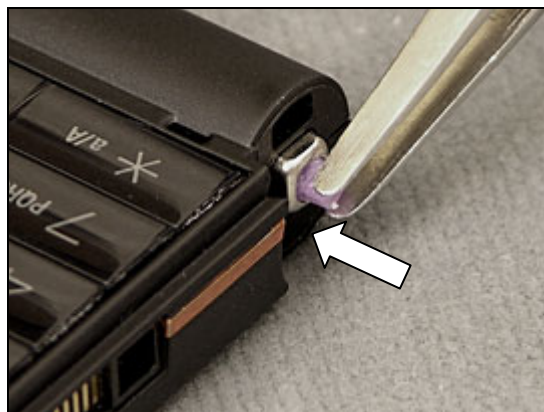
#### NOTE THE ORIENTATION OF THE HINGE

Use a pair of tweezers to position the Hinge



Use a pair of tweezers to position the Hinge

*Follow the 4.1.7 Reassembly Instructions!*



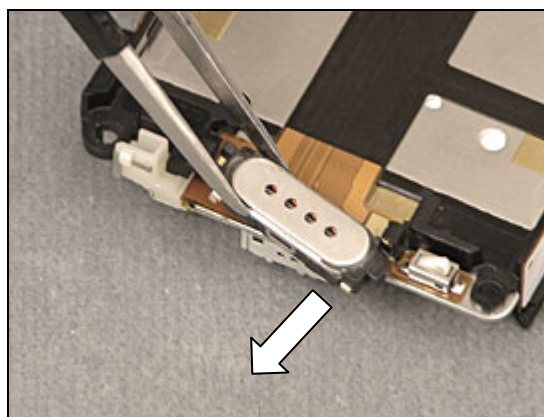
### 3.23 Ear Speaker

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

**REMEMBER TO MOUNT A NEW NET EAR SPEAKER IN THE FRONT ASSY WHEN REPLACING THE EAR SPEAKER**

#### **REMOVAL**

Use a pair of tweezers to remove the Ear Speaker

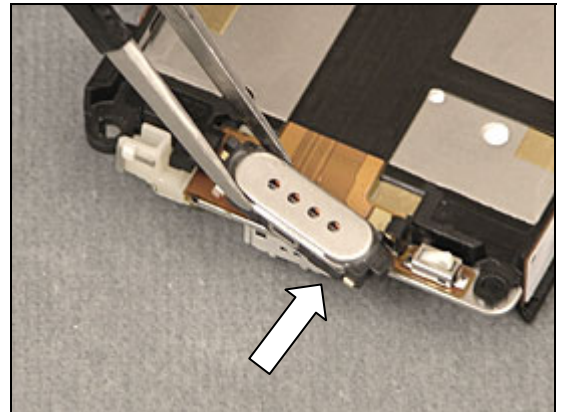




**INSTALLATION**

Use a pair of tweezers to mount the new Ear Speaker

*Follow the 4.1.5 – 4.1.8 Reassembly Instructions!*

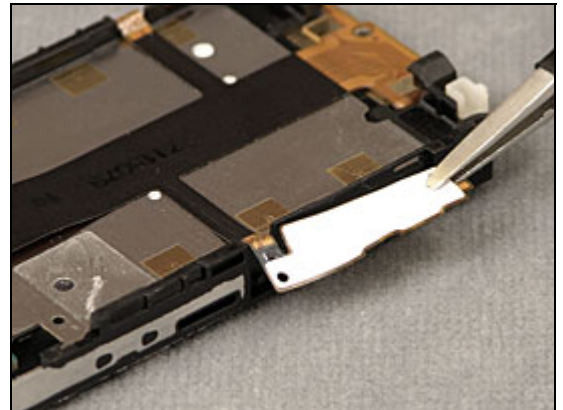


## 3.24 Carrier Inner Frame

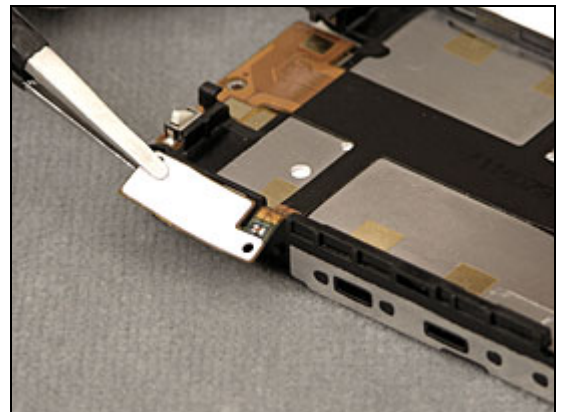
*Follow the 2.1.1 – 2.1.8 Disassembly instructions!*

**REMOVAL**

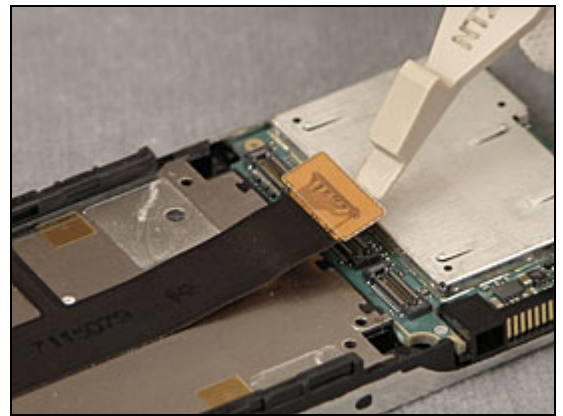
Use a pair of tweezers to loosen Volume Key pad part of the Camera PBA Assy



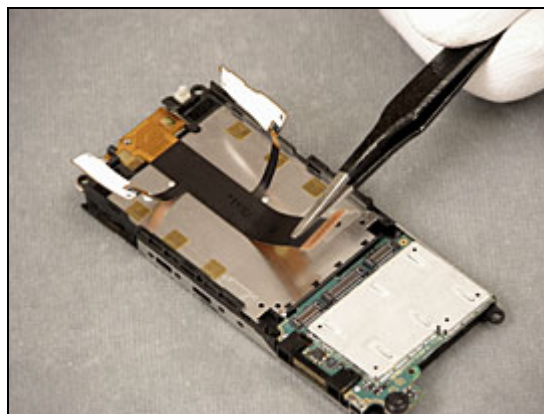
Use a pair of tweezers to loosen the Walkman Key pad part of the Camera PBA Assy



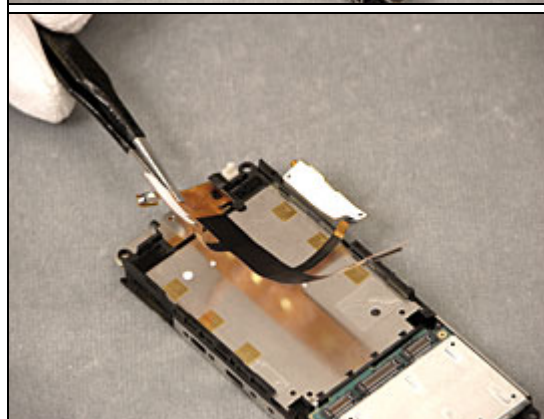
Use a Front Opening Tool to disconnect the BtB connector of the Camera PBA Assy



Use a pair of tweezers to loosen the Camera PBA Assy



Use a pair of tweezers to loosen the Camera PBA Assy



Use a pair of tweezers to loosen the Camera PBA Assy



Use a pair of tweezers to remove the Camera PBA Assy



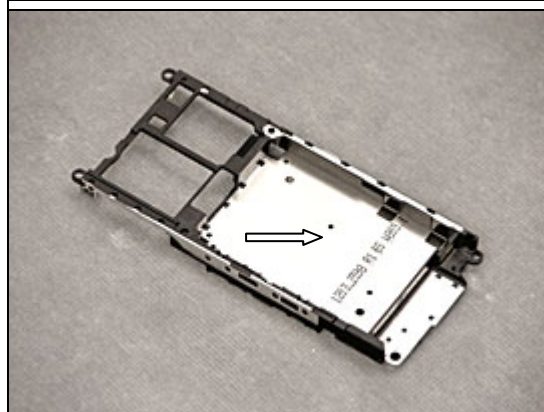
Use a pair of tweezers to loosen the Bluetooth Antenna Assy



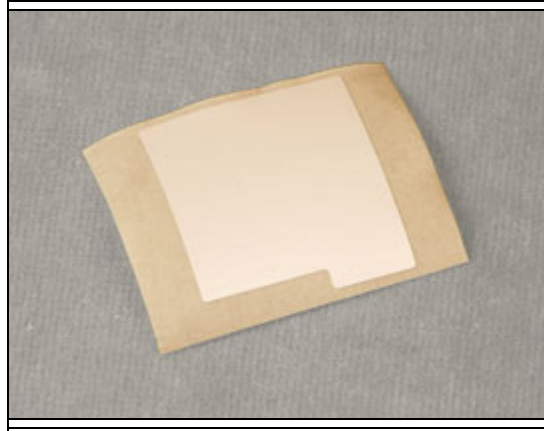
Use a pair of tweezers to remove the Bluetooth Antenna Assy



Replace the Carrier Inner Frame



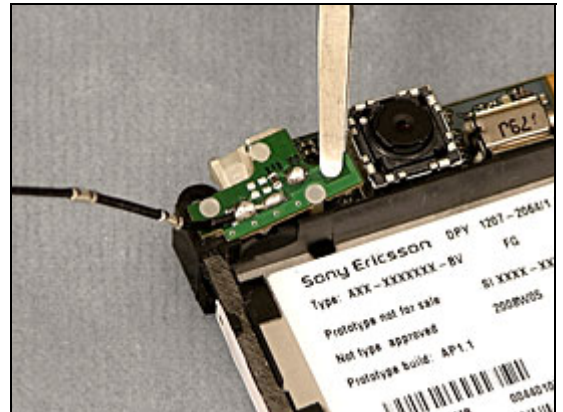
Replace the label according to Replacement Instruction 3.15





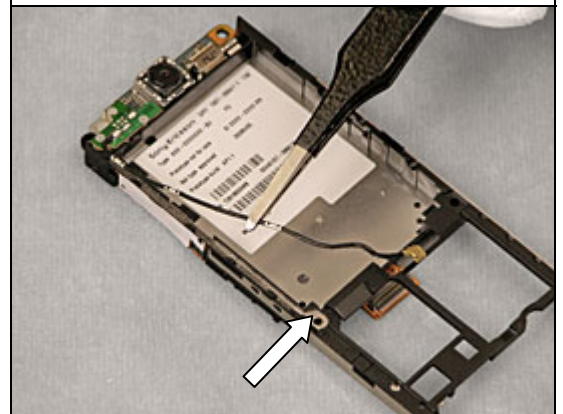
**REMEMBER TO REMOVE THE PROTECTION FOIL OF THE CONDUCTIVE ADHESIVE BT ASSY**

Use a pair of tweezers to mount the Bluetooth Antenna Assy

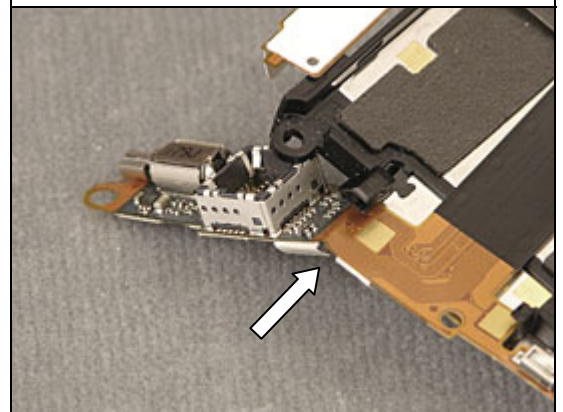


**BE CAREFUL NOT TO SQUEEZE THE BT ANTENNE CABLE WHEN REASSEMBLING THE PHONE (POSITION SHOWN BY ARROW)**

Use a pair of tweezers to mount the Bluetooth Antenna Assy



Use a pair of tweezers to position the Camera PBA Assy

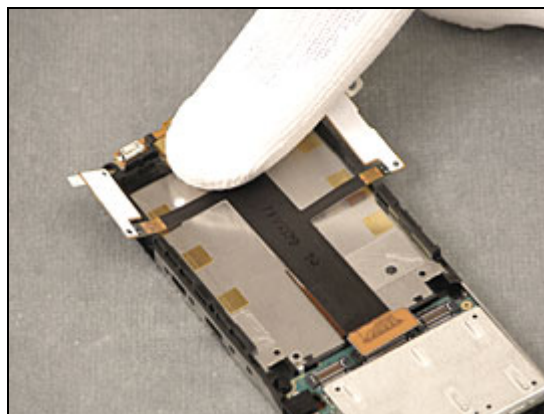


Use your fingers to mount the Camera PBA Assy

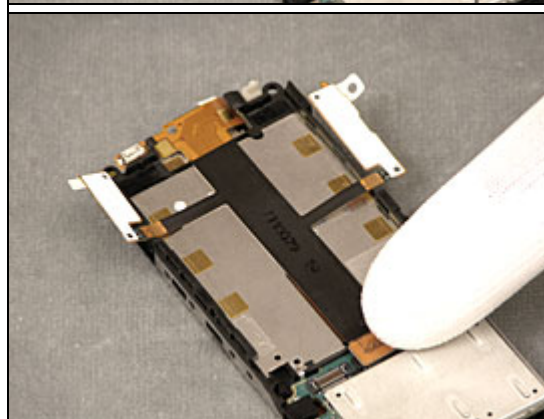




Use your fingers to mount the Camera PBA Assy



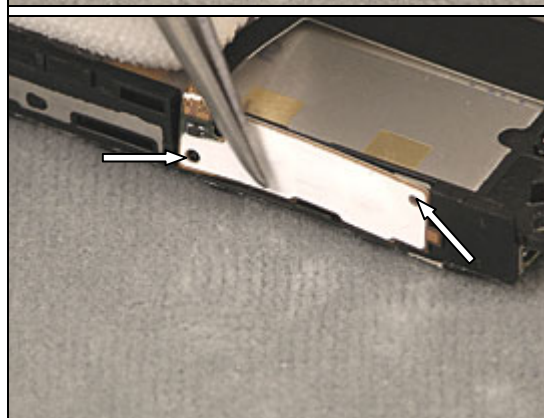
Use your fingers to mount the Camera PBA Assy connector



Use a pair of tweezers to mount the Camera PBA Assy. Align the Walkman Pad Part correctly (see arrows in the picture)



Use a pair of tweezers to mount the Camera PBA Assy. Align the Volume Pad Part correctly (see arrows in the picture)



Follow the 4.1.1 – 4.1.8 Reassembly Instructions!

## 3.25 Camera Window

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

### **REMOVAL**

Use a pair of tweezers to remove the gasket. **No Re-use of Camera Gasket!**

Use your finger to push the Camera window from outside and a pair of tweezers to remove it

### **INSTALLATION**

Use a pair of tweezers to attach the camera Window

Use a pair of tweezers to mount the new Camera Gasket

Follow the 4.1.6 – 4.1.8 Reassembly Instructions!



## 3.26 Camera module 1.3 MPixel

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

### REMOVAL

Use a Camera Removal Tool to remove the Camera Module 1.3 MPixel

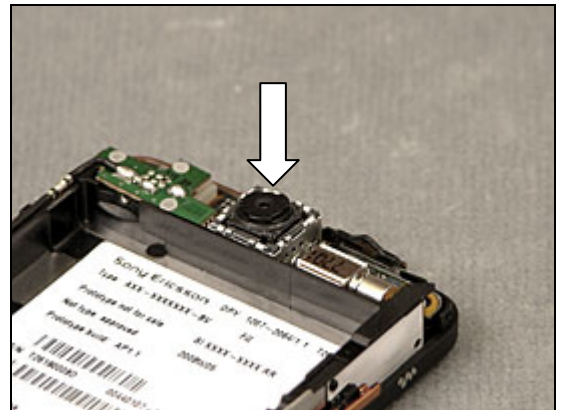


### INSTALLATION

Use a pair of tweezers to position the Camera Module 1.3 MPixel



Use your fingers to press down the Camera module. A weak "click" sound can be heard when the module gets in position



*Follow the 4.1.6 – 4.1.8 Reassembly Instructions!*

## 3.27 Bluetooth Antenna Assy

*Follow the 2.1.1 – 2.1.8 Disassembly instructions!*

### REMOVAL

Use a pair of tweezers to disconnect the Bluetooth Antenna Assy

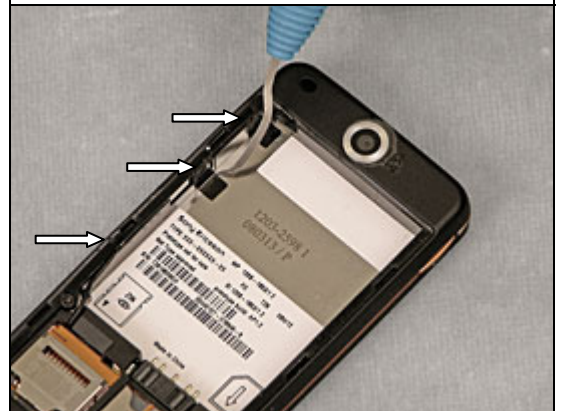




Use a pair of tweezers to remove the Bluetooth Antenna Assy.

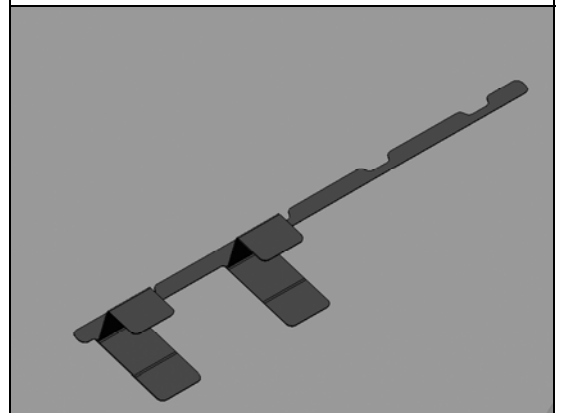


Use a Dentist Hook to remove the Foil Adhesive Conductive BT

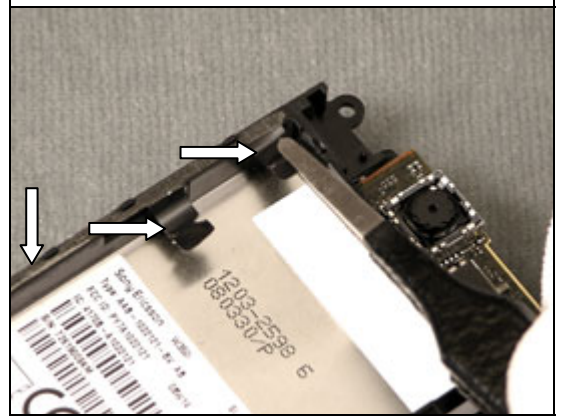


### **INSTALLATION**

This picture shows a 3D drawing of the Foil Adhesive Conductive BT. See next picture for mounting instructions

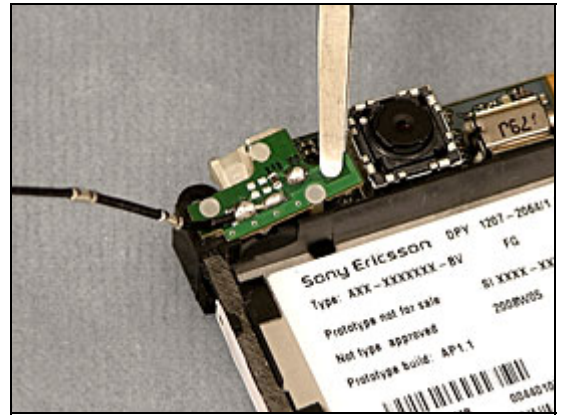


Use a pair of tweezers to mount the Foil Adhesive Conductive BT on the Carrier Inner Frame





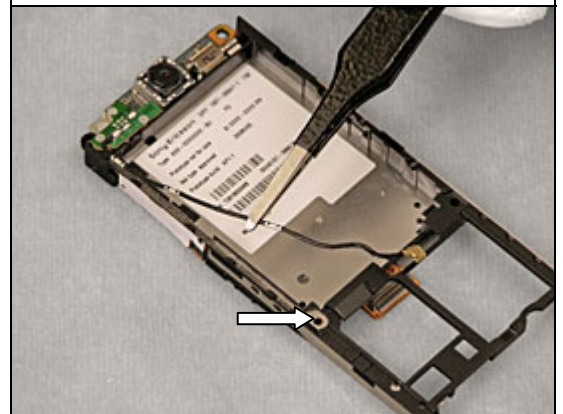
Use a pair of tweezers to mount the Bluetooth Antenna Assy



**BE CAREFUL NOT TO SQUEEZE THE BT ANTENNE CABLE WHEN REASSEMBLING THE PHONE (POSITION SHOWN BY ARROW)**

Use a pair of tweezers to mount the Bluetooth Antenna Assy

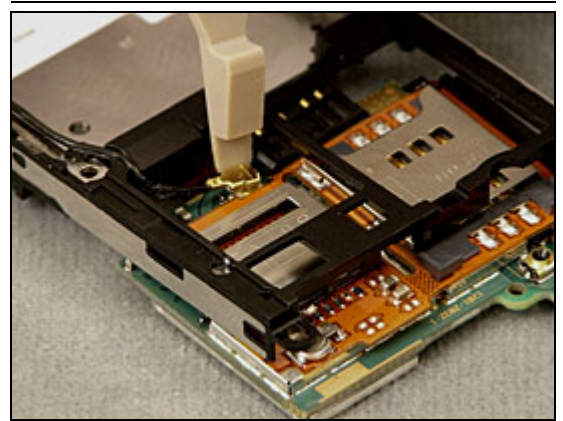
Follow the 4.1.1– 4.1.8 Reassembly Instructions!



## 3.28 Foil Adhesive Conductive BT

Follow the 2.1.1 – 2.1.4 Disassembly instructions!

Use a Front Opening Tool to disconnect Connector of the Bluetooth Antenna Assy



Use a pair of tweezers to disconnect the Bluetooth Antenna Assy



Use a pair of tweezers to remove the Bluetooth Antenna Assy.

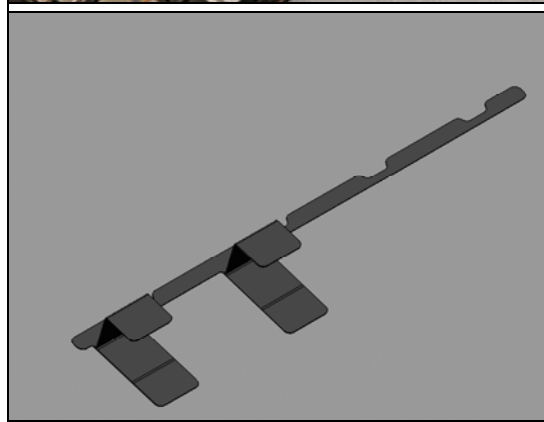


Use a Dentist Hook to remove the Foil Adhesive Conductive BT

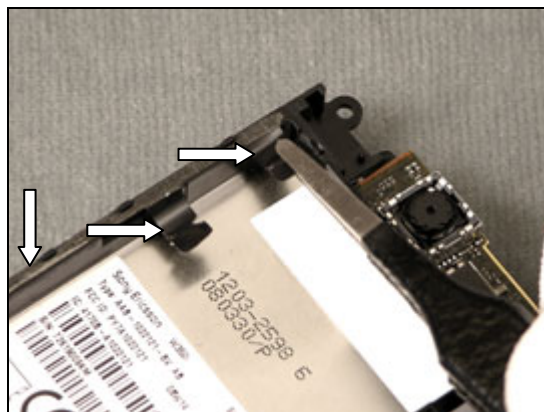


### INSTALLATION

This picture shows a 3D drawing of the Foil Adhesive Conductive BT. See next picture for mounting instructions



Use a pair of tweezers to mount the Foil Adhesive Conductive BT on the Carrier Inner Frame

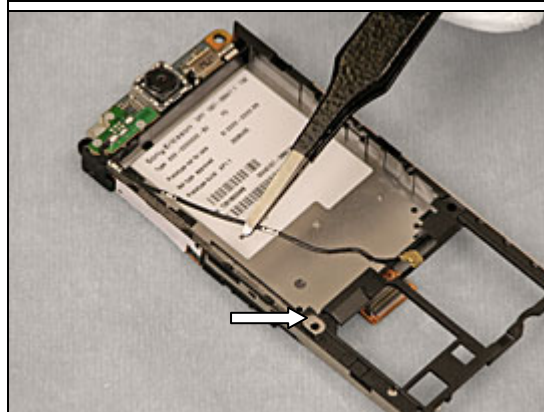


Use a pair of tweezers to mount the Bluetooth Antenna Assy



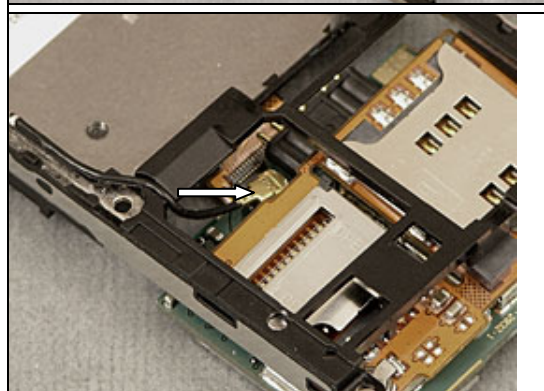
**BE CAREFUL NOT TO SQUEEZE THE BT ANTENNE CABLE WHEN REASSEMBLING THE PHONE (POSITION SHOWN BY ARROW)**

Use a pair of tweezers to mount the Bluetooth Antenna Assy



Use your fingers to attach the Connector of the Bluetooth Antenna Assy

*Follow the 4.1.5– 4.1.8 Reassembly Instructions!*



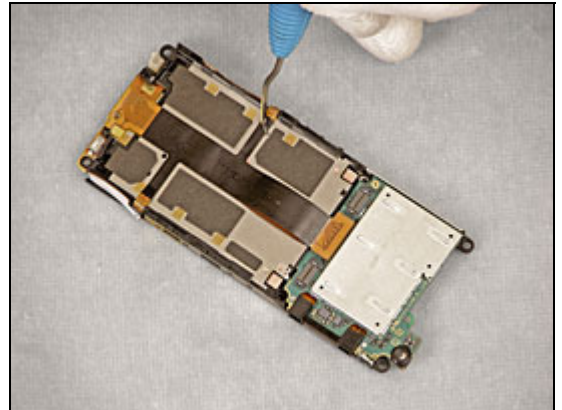


## 3.29 Inner Frame Poron Cushion

*Follow the 2.1.1- 2.1.6 Disassembly instructions!*

### **REMOVAL**

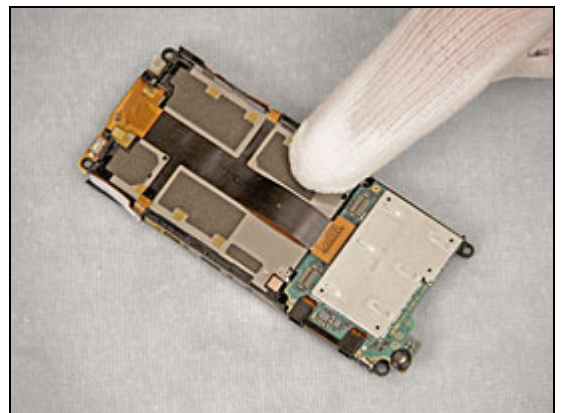
Use a Dentist Hook to remove the Inner Frame Poron Cushions



### **INSTALLATION**

Use a pair of tweezers to position and your fingers to press down the Inner frame poron Cushions

*Follow the 4.1.2– 4.1.8 Reassembly Instructions!*



## 3.30 ESD Shielding Label

*Follow the 2.1.1 Disassembly instructions!*

### **REMOVAL**

Use a Dentist Hook to remove the ESD Shielding Label





### **INSTALLATION**

Use a pair of tweezers to position and your fingers to attach the ESD Shielding Label

*Follow the 4.1.8 Reassembly Instructions!*



## **3.31 Keyboard**

*NO Disassembly necessary!*

### **REMOVAL**

Use a pair of tweezers to loosen the Keyboard



Use a pair of tweezers to remove the Keyboard



### **INSTALLATION**

Use a pair of tweezers to position the Keypad Adhesive Tape



Use a Nylon Pointer to press down the Keypad Adhesive Tape



Use a Dental Hook to remove the protection tape



Use a pair of tweezers to position the Keyboard



Use your fingers to mount and press down the Keyboard

*NO Reassembly necessary!*



### 3.32 Foil Adhesive BtB

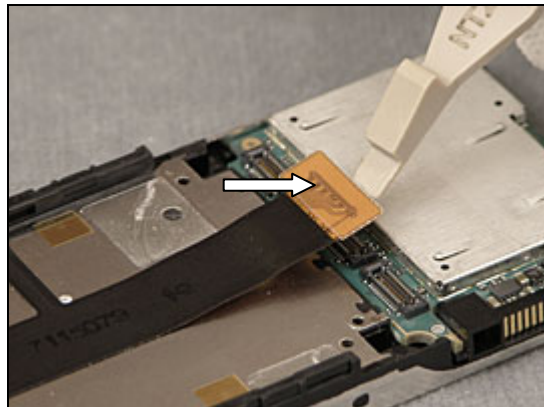
**THIS PART HAS BEEN REMOVED FROM PARTLIST**

**THE ADHESIVE SHOULD BE REMOVED IF THE PHONE IS DISASSEMBLED DURING REPAIR**

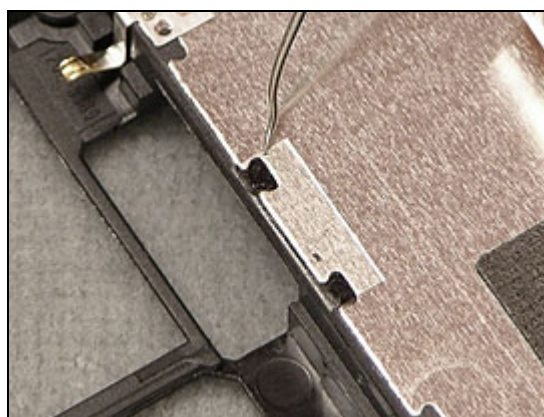
#### REMOVAL

*Follow the 2.1.1 – 2.1.7 Disassembly instructions!*

Use a Front Opening Tool to disconnect the BtB connector from the PBA

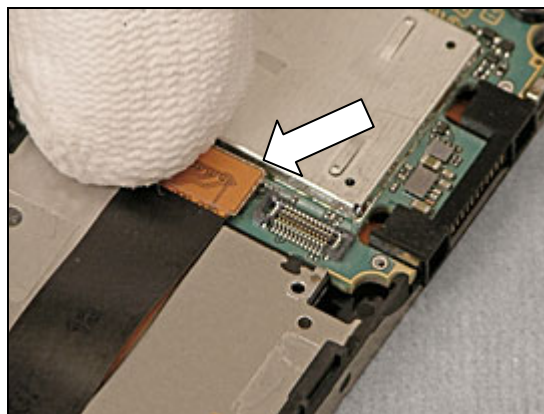


Use a Dentist Hook to remove the Foil Adhesive BtB



Use your fingers to mount the BtB connector to the PBA

*Follow the 4.1.2– 4.1.8 Reassembly Instructions!*



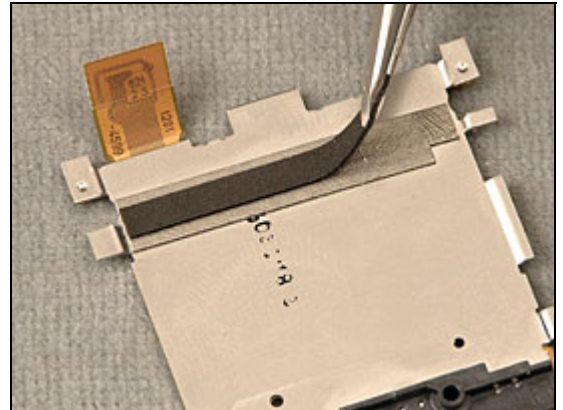
### 3.33 Keyfoil Carrier EFR

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

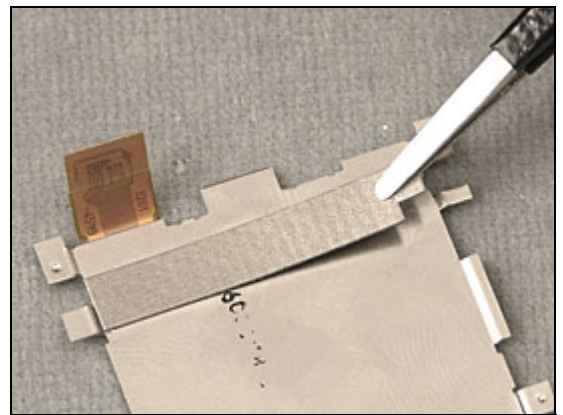
**ONLY APPLICABLE FOR W350A 850MHz**

## REMOVAL

Use a pair of tweezers to remove the Cushion BtB

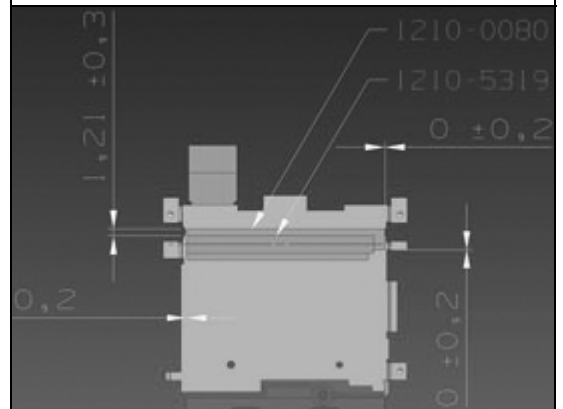


Use a pair of tweezers to remove the Keyfoil Carrier EFR.

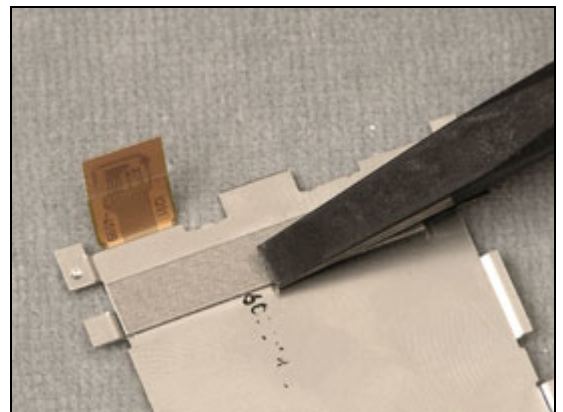


## INSTALLATION

Note the position of the Keyfoil Carrier EFR!

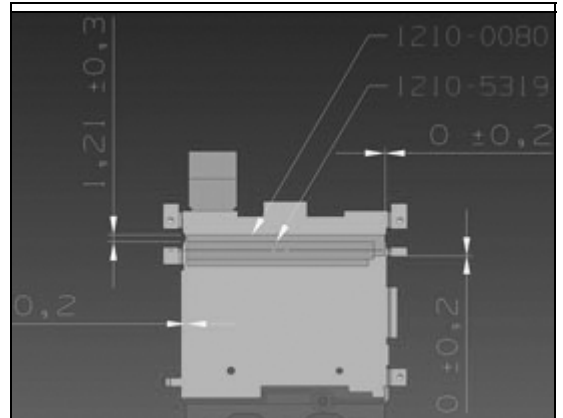


Use a pair of tweezers to position and a nylon pointer to press down the Keyfoil Carrier EFR



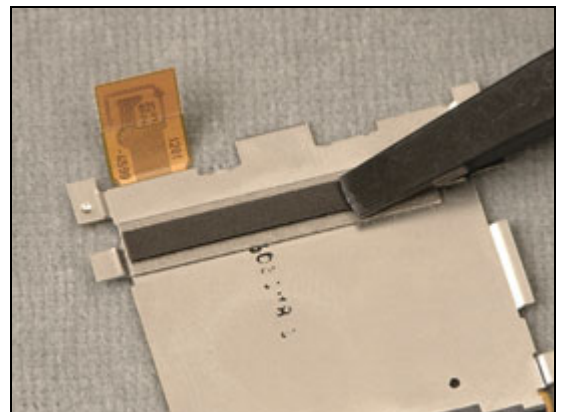


Note the position of the Cushion BtB!



Use a pair of tweezers to position and a nylon pointer to press down the Cushion BtB

*Follow the 4.1.3– 4.1.8 Reassembly Instructions!*



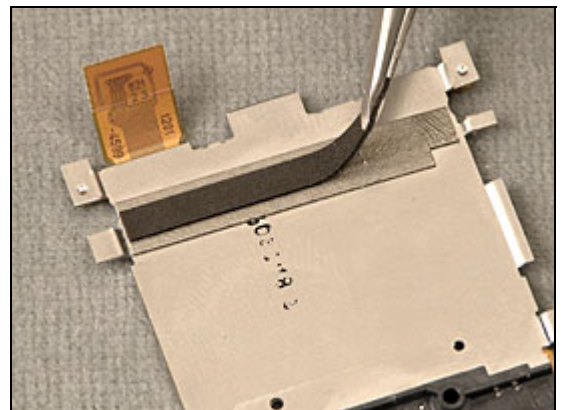
### 3.34 Cushion BtB

*Follow the 2.1.1 – 2.1.6 Disassembly instructions!*

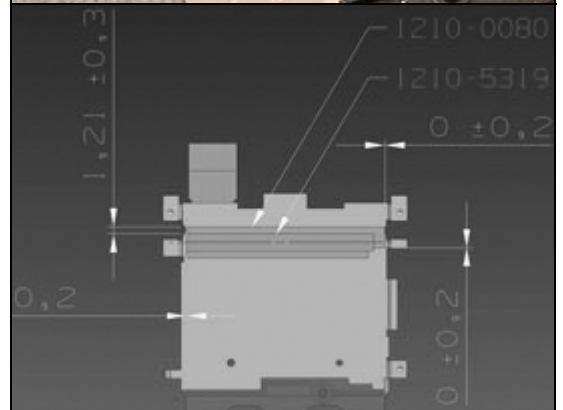
**ONLY APPLICABLE FOR W350A 850MHZ**

#### **REMOVAL**

Use a pair of tweezers to remove the Cushion BtB

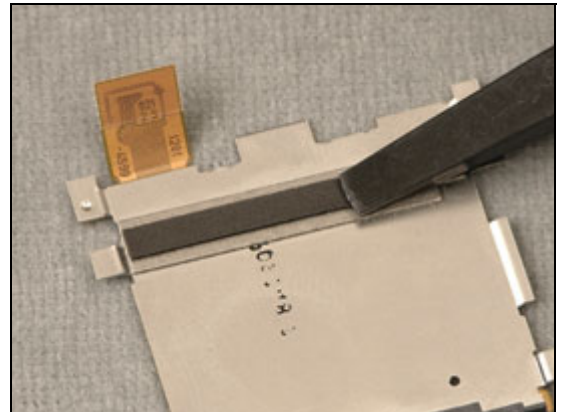


*Note the position of the Cushion BtB!*



Use a pair of tweezers to position and a nylon pointer to press down the Cushion BtB

Follow the 4.1.3– 4.1.8 Reassembly Instructions!



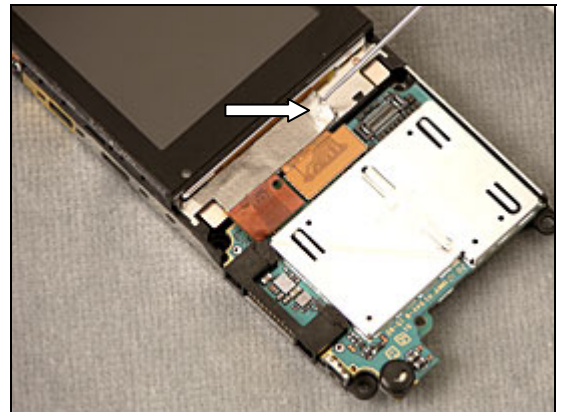
### 3.35 Foil Inner Frame EFR

Follow the 2.1.1 – 2.1.6 Disassembly instructions!

**ONLY APPLICABLE FOR W350A 850MHZ**

#### REMOVAL

Use a dentist hook to loosen the Foil Inner Frame EFR



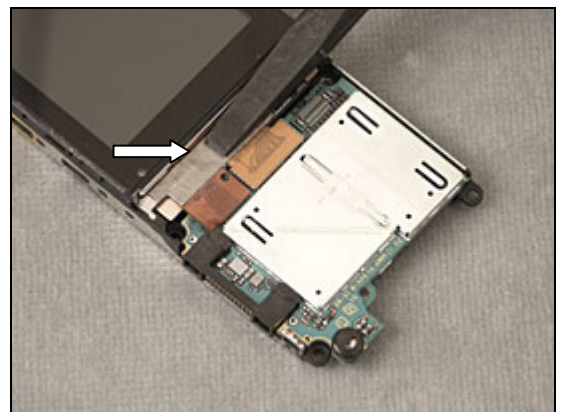
Use a pair of tweezers to remove the Foil Inner Frame EFR



#### INSTALLATION

Use a pair of tweezers to position and a nylon pointer to press down the Foil Inner Frame EFR

Follow the 4.1.3 – 4.1.8 Reassembly Instructions!



### 3.36 Keypad Adhesive Tape

*NO Disassembly necessary!*

#### **REMOVAL**

Use a pair of tweezers to remove the Keyboard



Use a pair of tweezers to remove the Keyboard



#### **INSTALLATION**

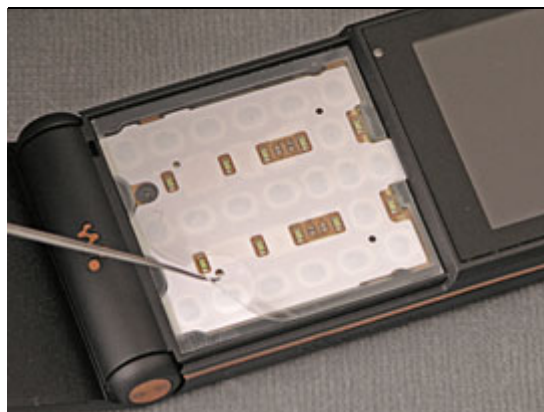
Use a pair of tweezers to position the Keypad Adhesive



Use a Nylon Pointer to press down the Keypad Adhesive Tape



Use a Dental Hook to remove the protection foil



Use a pair of tweezers to position the Keyboard



Use your fingers to mount and press down the Keyboard

*NO Reassembly necessary!*



### 3.37 Net Ear Speaker

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

#### **REMOVAL**

Use a pair of tweezers to remove the Net Ear Speaker





### **INSTALLATION**

Use a pair of tweezers to position the Net Ear Speaker

Use a nylon pointer to gently press down the Net Ear Speaker

*Follow the 4.1.5– 4.1.8 Reassembly Instructions!*



## **3.38 Gasket Ear Speaker**

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

### **REMOVAL**

Use a pair of tweezers to remove the Gasket Ear Speaker

### **INSTALLATION**

Use a pair of tweezers to mount the new Gasket Ear Speaker and remove the protection tape

*Follow the 4.1.5– 4.1.8 Reassembly Instructions!*



### 3.39 Camera Gasket

*Follow the 2.1.1 – 2.1.3 Disassembly instructions!*

**NO REUSE OF THE CAMERA GASKET**

#### **REMOVAL**

Use a pair of tweezers to remove the gasket.



#### **INSTALLATION**

Use a pair of tweezers to mount the new Camera Gasket

Follow the 4.1.6 – 4.1.8 Reassembly Instructions!

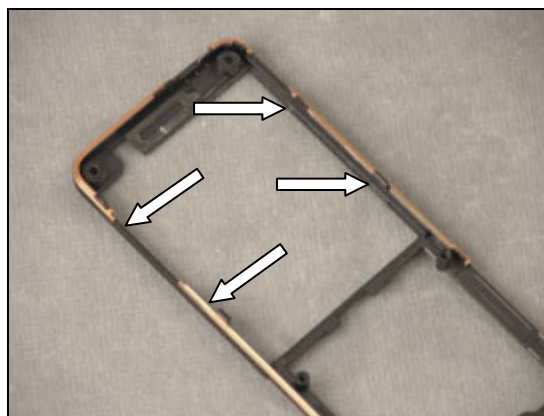


### 3.40 Display Assy Adhesive

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

#### **REMOVAL**

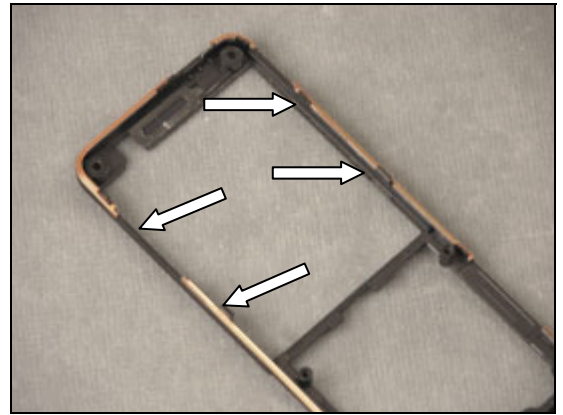
Use a Dentist hook to remove the Display Assy Adhesive



**INSTALLATION****CAREFULLY ALIGN THE ADHESIVE**

Use a pair of tweezers to mount the new Display Assy Adhesive

Follow the 4.1.5 – 4.1.8 Reassembly Instructions!



### 3.41 Protective tape

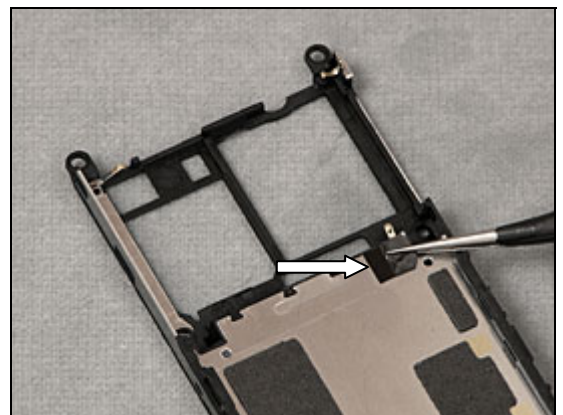
**THIS PART HAS BEEN ADDED IN PRODUCTION**

**IF THE PHONE IS ALREADY DISASSEMBLED YOU SHOULD ALWAYS ADD THIS PART**

**INSTALLATION**

Use a pair of tweezers to replace the Protective tape

Follow the 4.1.5 – 4.1.8 Reassembly Instructions!



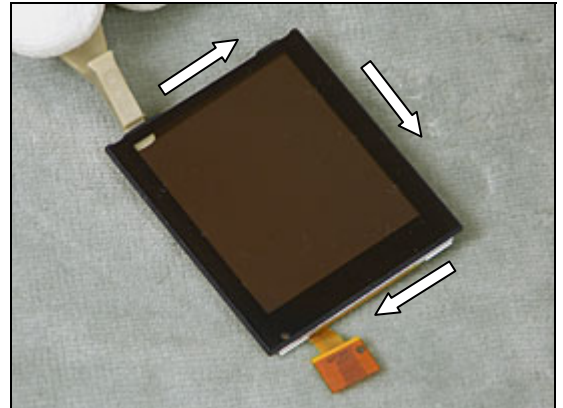
## 3.42 Display Window

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

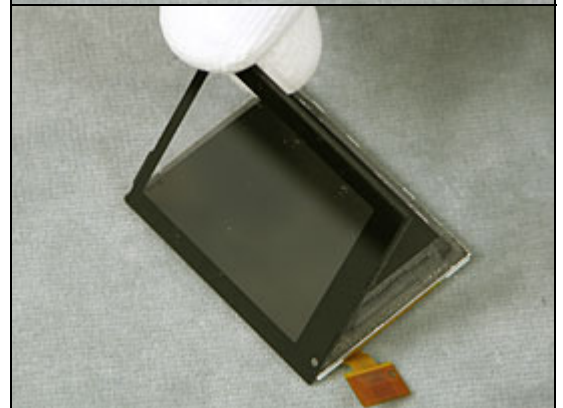
**DISPLAY WINDOW IS NOW RELEASED AS A SEPARATE PART**

### **REMOVAL**

Insert a Front opening tool between the display module and window and slide according to arrows in picture

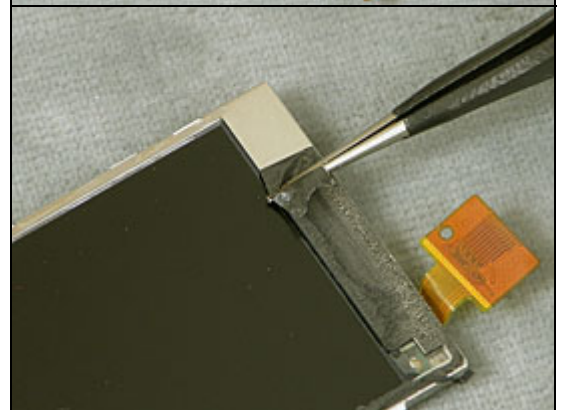


Use your fingers to lift and remove the window.



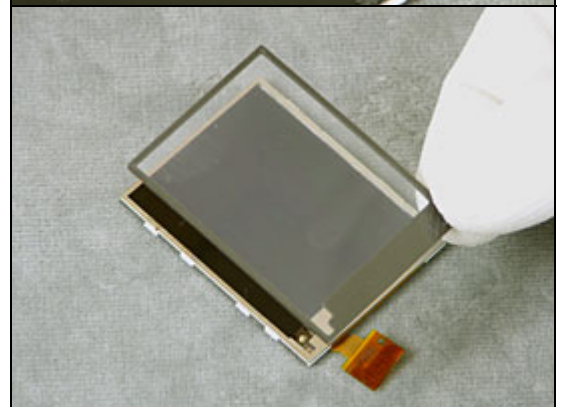
**DO NOT CLEAN THE DISPLAY FRAME WITH ALCOHOL**

Use a pair of tweezers to peel off the adhesive residues



**MAKE SURE THAT THERE IS NO DUST ON THE DISPLAY BEFORE MOUNTING THE NEW GASKET**

Carefully align the poron gasket





*Follow the 3.40 replacement instructions before proceeding*  
*Follow the 3.38 replacement instructions before proceeding*

Use your fingers to mount the new display window

Check that the display window is in the right position

Use your fingers to position the display

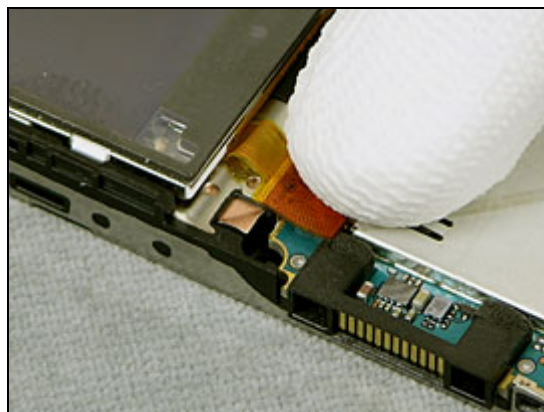
Press with your fingers to mount the display



*Use your fingers to mount the display connector and peel off the display protection tape*

**MAKE SURE THAT THERE IS NO DUST ON THE DISPLAY BEFORE MOUNTING THE CARRIER INNER FRAME ASSY INTO THE FRONT ASSEMBLY**

*Follow the 4.1.3 – 4.1.8 reassembly instructions*



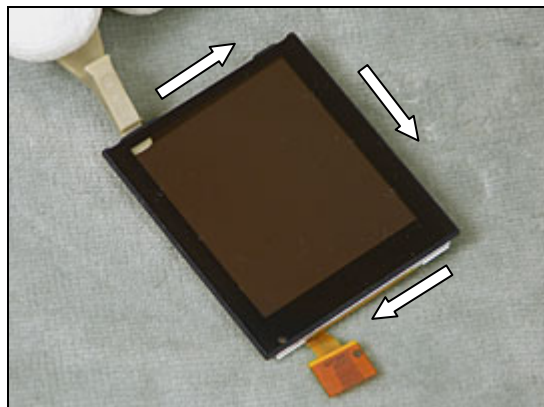
## 3.43 Display

*Follow the 2.1.1 – 2.1.4 Disassembly instructions!*

**THE DISPLAY IS NOW RELEASED AS A SEPARATE PART**

### REMOVAL

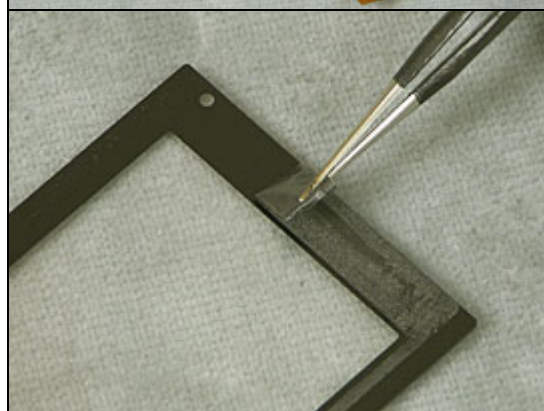
Insert a Front opening tool between the display module and window and slide according to arrows in picture



Use your fingers to lift and remove the window.



Use a pair of tweezers to peel of the adhesive residues



*Follow the 3.40 replacement instructions before proceeding*  
*Follow the 3.38 replacement instructions before proceeding*

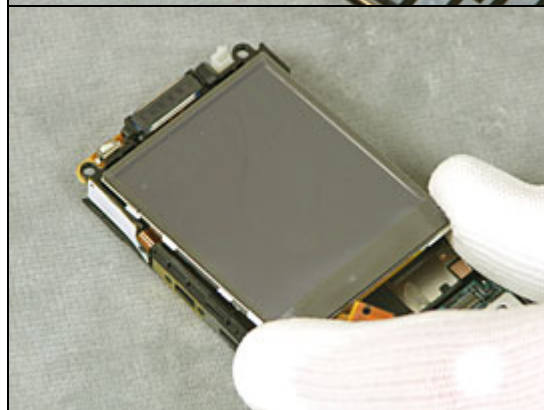
Use your fingers to mount the display window



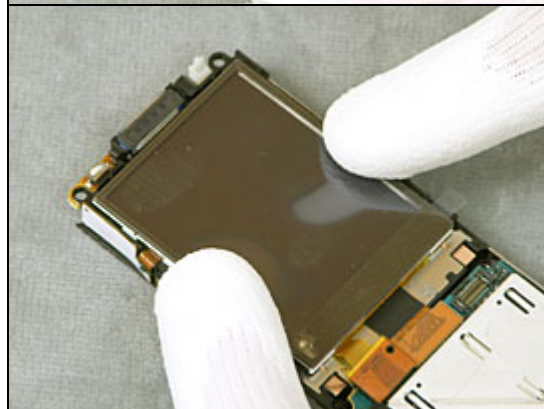
Check that the display window is in the right position



Use your fingers to position the new display



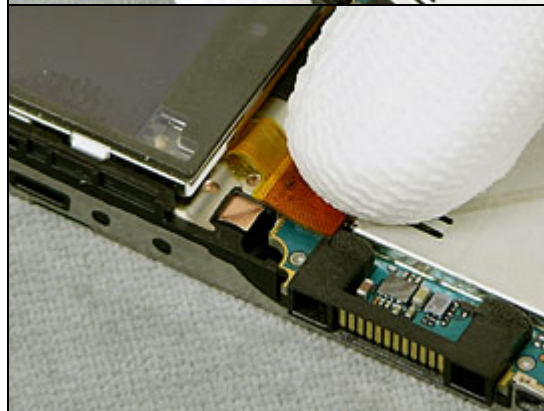
Press with your fingers to mount the display



Use your fingers to mount the display connector and peel off the display protection tape

**MAKE SURE THAT THERE IS NO DUST ON THE DISPLAY BEFORE MOUNTING THE CARRIER INNER FRAME ASSY INTO THE FRONT ASSEMBLY**

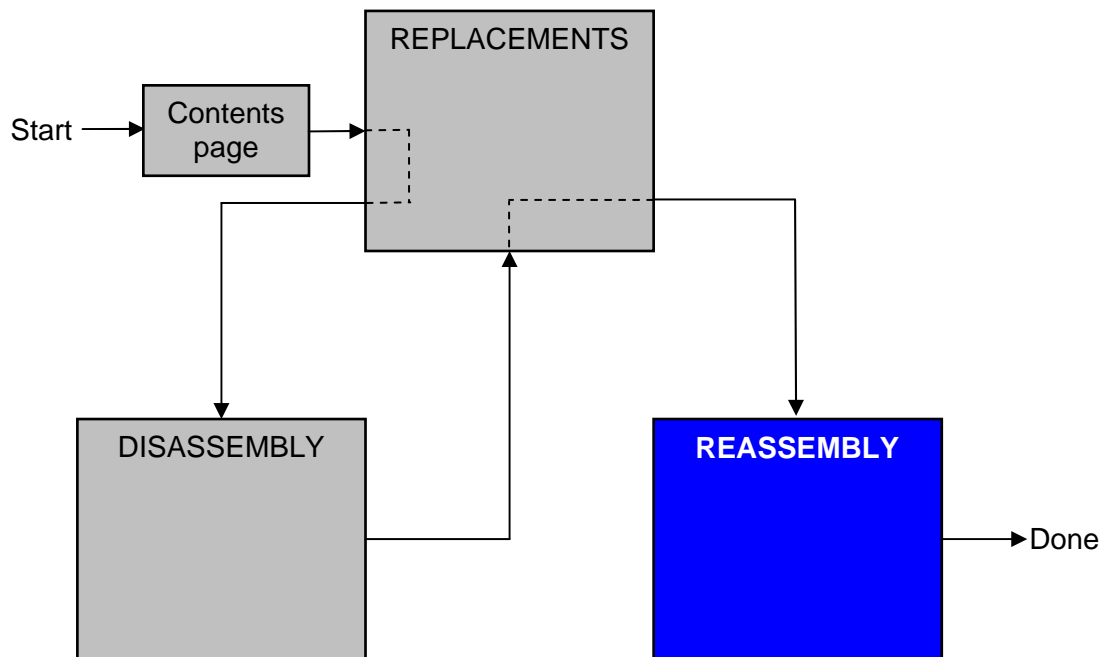
Follow the 4.1.3 – 4.1.8 reassembly instructions





## 4 Reassembly

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



### 4.1 Overview

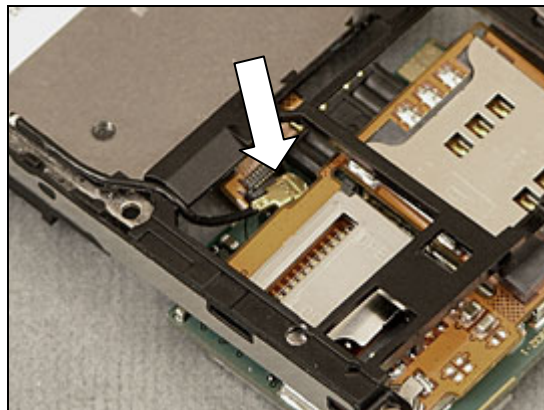
The reassembly is done in the following sequence:

1. Carrier Inner Frame
2. PBA
3. Display Assy
4. Key Foil Assy
5. Speaker Box Assembly
6. Front Assembly & Keyboard
7. Rear Cover Assy
8. Flip Assembly
9. Battery Cover & Battery

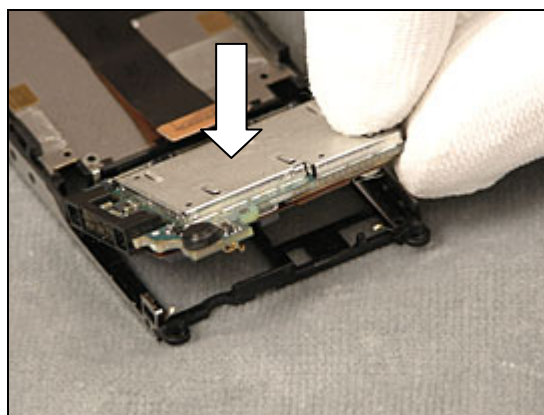


### 4.1.1 PBA

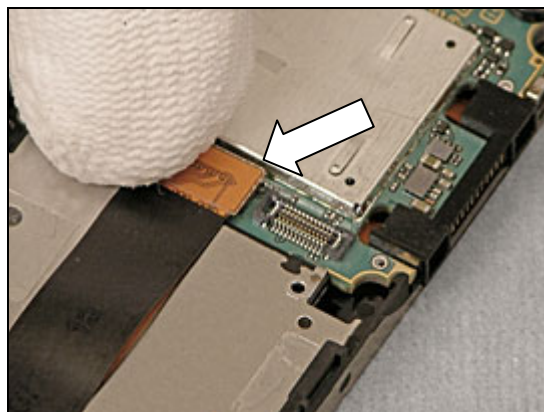
Use your fingers to mount the Bluetooth Antenna Assy



Use your fingers to connect the PBA to the Carrier Inner Frame



Use your fingers to mount the Key Flex connector to the PBA



### 4.1.2 Display Assy

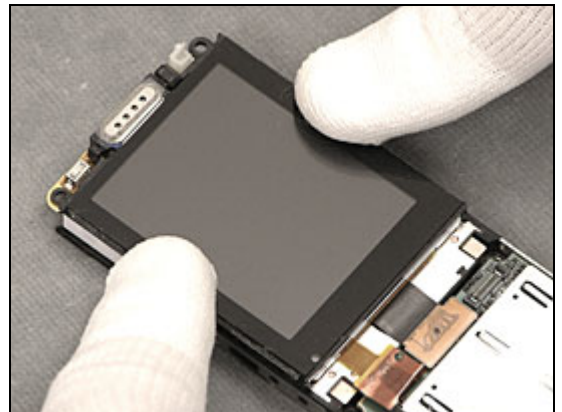
Use your fingers to position the Display Assy



Use your fingers to mount the Display connector to the PBA



Use your fingers to mount the Display Assy



### 4.1.3 Key Foil Assy

Use your fingers to position the Key Foil Assy



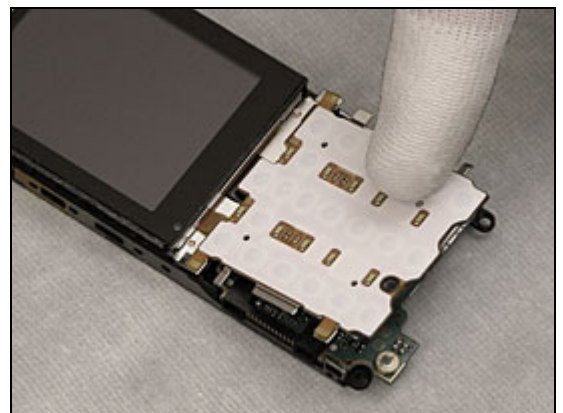


## Reassembly Instruction *continued*

Use your fingers to mount the Key Foil Assy to the PBA

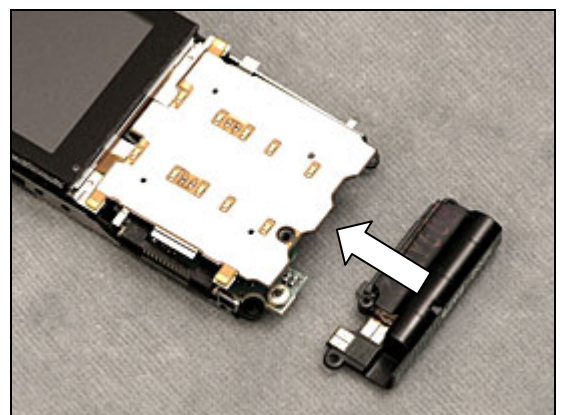


Use your fingers to turn over the Key Foil Assy

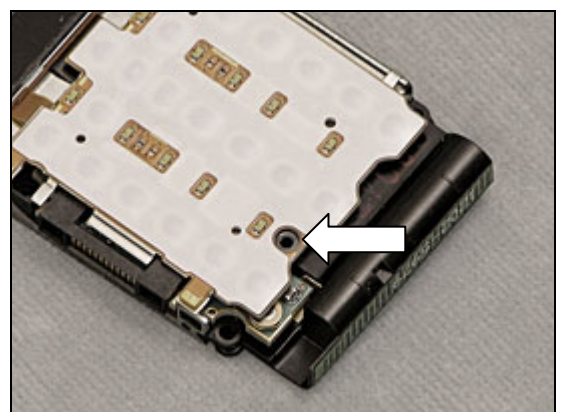


### 4.1.4 Speaker Box Assembly

Use your fingers to position on the Speaker Box Assembly



Use a PH00 bit with 9 +/- 0.5 Ncm torque to mount the screw



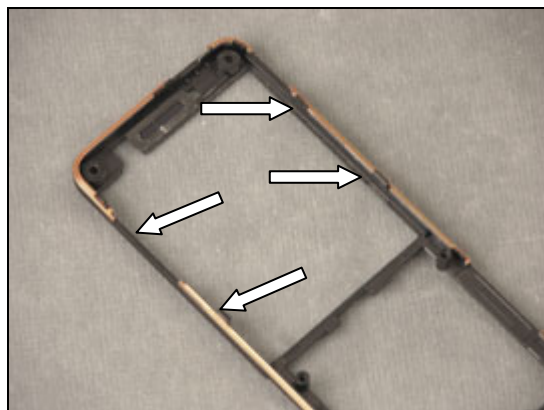


## 4.1.5 Front Assembly

### **INSTALLATION**

**DO NOT FORGET TO MOUNT NEW DISPLAY ASSY ADHESIVE**

Use a pair of tweezers to mount the new Display Assy Adhesive



**MAKE SURE THE KEYLOCK KEY IS IN CORRECT POSITION**



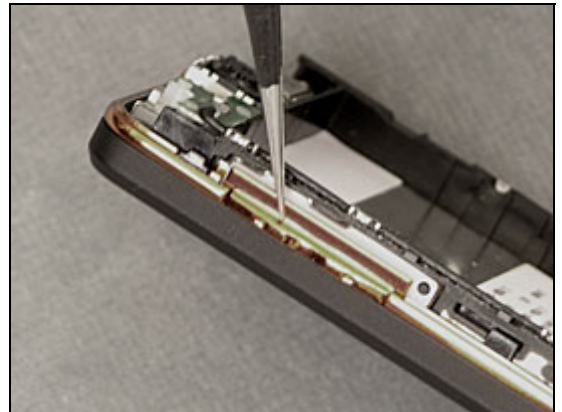
Use your fingers to mount the Carrier Inner Frame Assy to the Front Assembly



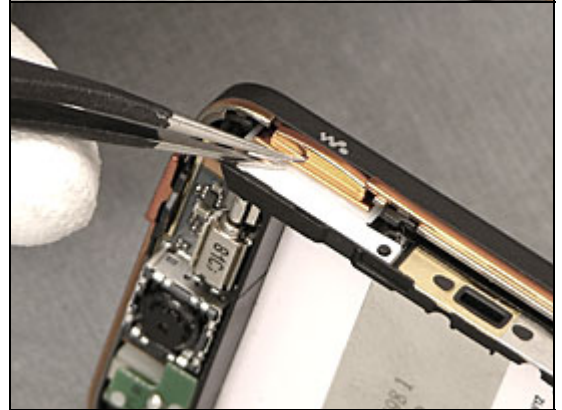
Push the Inner frame Assy into position



Use a pair of tweezers to mount the Volume key



Use a pair of tweezers to mount the Walkman Key



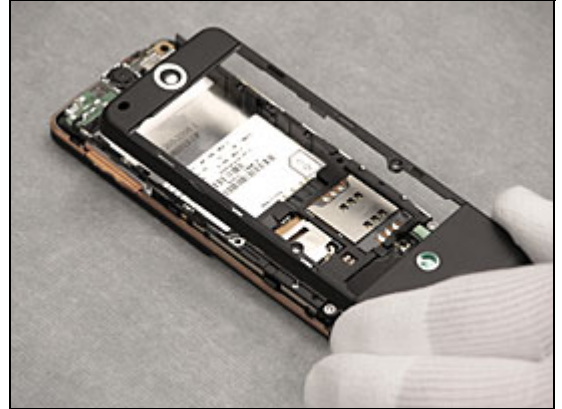
Use a Torx Bits T5 to mount the screws using torque 18+/- .5 n.cm



## Reassembly Instruction *continued*

### 4.1.6 Rear Cover Assy

Use your fingers to position the Rear Cover Assy

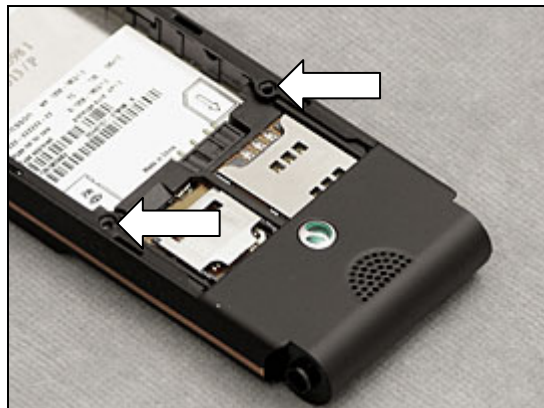


Use your fingers to mount the Rear Cover Assy

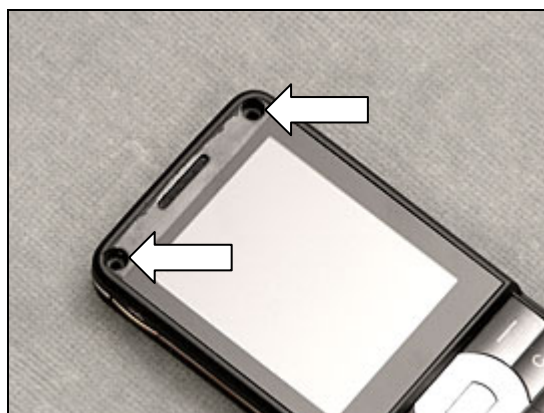


## Reassembly Instruction *continued*

Use a PH00 bit to mount the screws using torque  $9 \pm 0.5$  Ncm



Use a Torx Bits T5 bit to attach the screws using torque  $18 \pm .5$  n.cm



Use a pair of tweezers to mount a new Front Panel





### 4.1.7 Flip Assembly

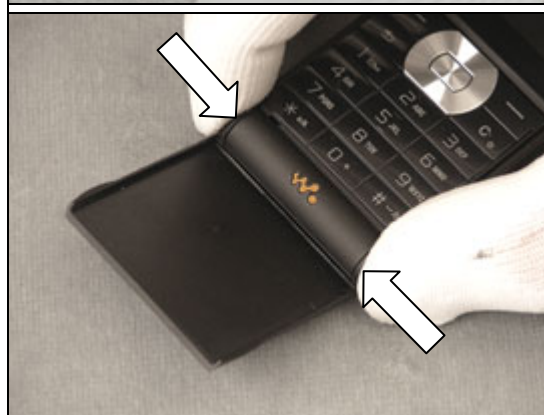
***THE FLIP SHALL BE IN NORMAL OPEN POSITION***

Use your fingers to mount the Flip Assembly



***PRESS AS SHOWN BY ARROWS IN PICTURE***

Use your fingers to mount the Flip Assembly



Use your fingers to close the Flip Assembly



## 4.1.8 Battery Cover & Battery

Use your fingers to position the Battery



Use your fingers to mount the Battery Cover



**CHECK THAT THE SNAP HOOKS ARE SECURED**

Use your fingers to mount the Battery Cover





## 5 Revision history

Rev.	Date	Changes / Comments
1	2008-05-06	First release
2	2008-09-22	Protective tape added , Foil adhesive btb removed
3	2008-10-16	Display and display window added as separate parts
4	2009-02-27	Disassembling LCD section updated (part added)