



Working Instruction, Mechanical

Applicable for W380

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1 Introduction

1.1 View of W380



1.2 Tools and Equipment

The following tools and equipment should be available while performing the procedures.

STANDARD TOOLS

- Style 2A Tweezers – Rounded Tip
- Nylon Pointer
- Torque Driver
- Dental Hook
- Plectrum



PRODUCT SPECIFIC TOOLS

- JCIS No. 0 Screw Bit
- T6 screw bit
- Pliers





ESD EQUIPMENT

Protect the phone from ESD damage whenever it has been opened:

Minimum requirements are:

- ESD wristband
- ESD gloves
- ESD mat



LABEL EQUIPMENT

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

- Zebra printer connected to computer



1.3 General Cautions

The following cautions are considered to be generic for all products and will not be repeated in the Disassembly, Reassembly, and Replacements 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, PRY TOOLS, ETC. TO AVOID SCRATCHES OR DAMAGE TO THE EXTERIOR AND INTERIOR PARTS OF THE PHONE!**
- **BE CAREFUL NOT TO DAMAGE ANY CONTACT SPRINGS!**
- **REMEMBER TO REMOVE THE PROTECTION FILMS ON NEW PARTS SUCH AS THE FRONT COVER AND LCD!**
- **NEVER TOUCH THE DISPLAY GLASS!**

1.4 Adhesives

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

1.5 Using Hand and ESD Protection

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



1.6 Protection of Displays, Lenses, and Windows

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

1.7 Acceptable Pry Tools

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

2 Disassembly

2.1 Overview

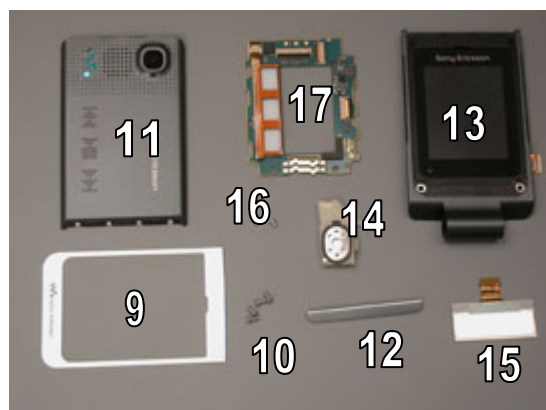
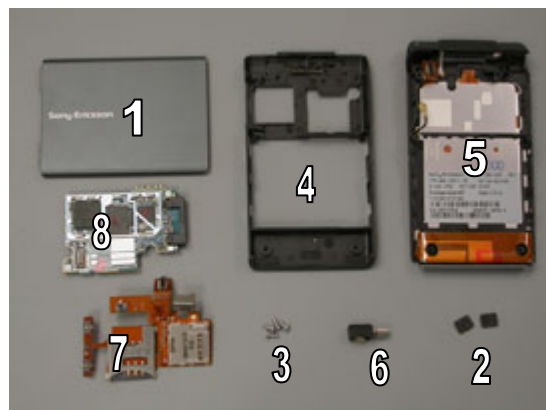
Disassemble in the following order:

Lower Half

- Battery Cover (1)
- Battery
- Screw covers (2)
- Lower back screws (3)
- Lower back cover (4) from lower front (5)
- Vibrator (6)
- SIM/M2 Flex (7)
- Lower PCB (8)

Upper Half

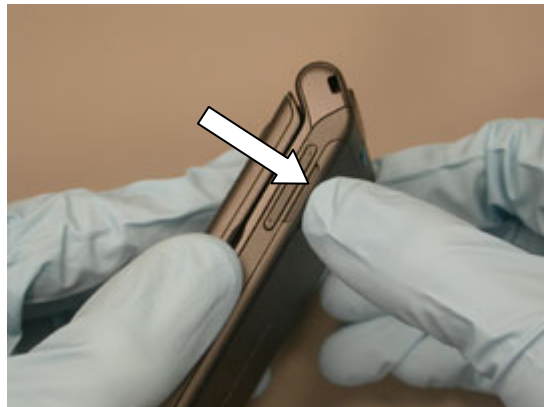
- Main window label (9)
- Upper front screws (10)
- Upper back cover (11) and cover light panel assembly (12) from upper front (13)
- Loudspeaker (14)
- Outer display (15)
- Upper PBA screws (16) and upper PBA (17) from upper front (13)



Lower Half

2.1.1 Battery Cover Removal

Lift up on the battery cover at its notch.

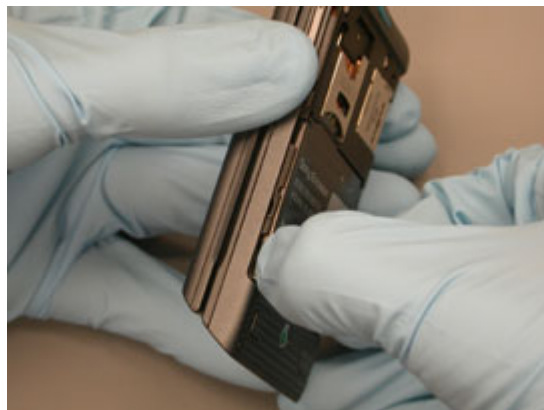


Remove battery cover.



2.1.2 Battery Removal

Lift up on the lower sides of the battery from the notches.



Remove battery.



2.1.3 Screw Cover Removal

Pry the screw cover off from the short side using the round tipped tweezers.

NOTE: DO NOT REUSE SCREW COVERS



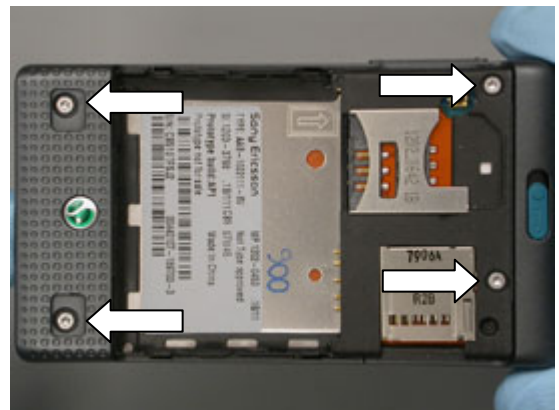
Pry the other screw cover off using round tipped tweezers.

NOTE: ENSURE NO ADHESIVE RESIDUE REMAINS IN THE SCREW RECESS.



2.1.4 Lower Back Screw Removal

Remove the 4 screws using a T5 bit.



2.1.5 Lower Back Cover Removal

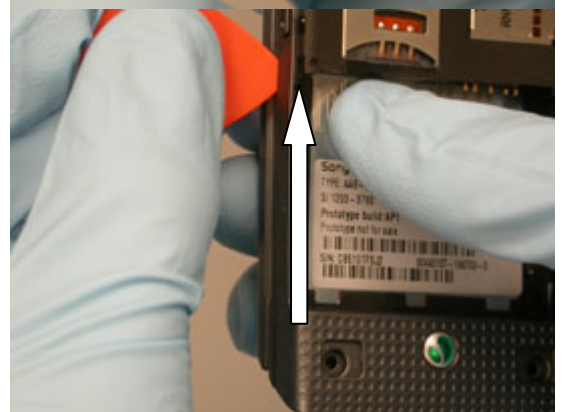
Insert the plectrum between the lower rear cover and the lower front cover just below the battery cavity.



Slide the plectrum along the seam up to the system connector or volume key to release the latches.



Repeat for the other side.



Insert the plectrum between the lower rear cover and the SIM card reader as shown and unlatch the tabs.



Use the plectrum to separate the lower rear cover from the antenna.



Lift up on the lower end of the lower rear cover.

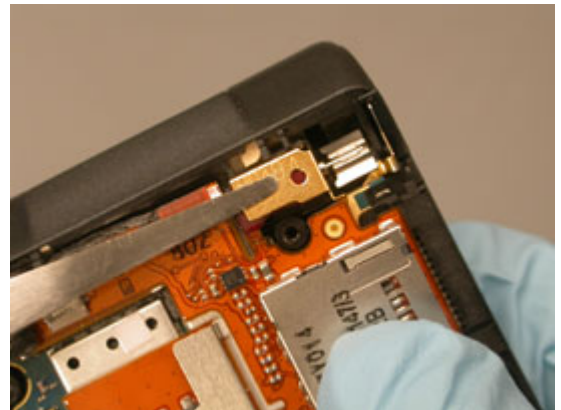


Remove the lower rear cover.

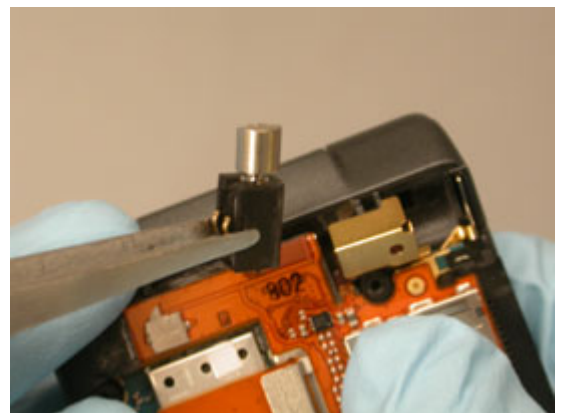


2.1.6 Vibrator Removal

Lift up on the vibrator cap by inserting the round tipped tweezers between the flex and the vibrator.



Pull the vibrator out of its housing.



2.1.7 SIM/M2 Flex Removal

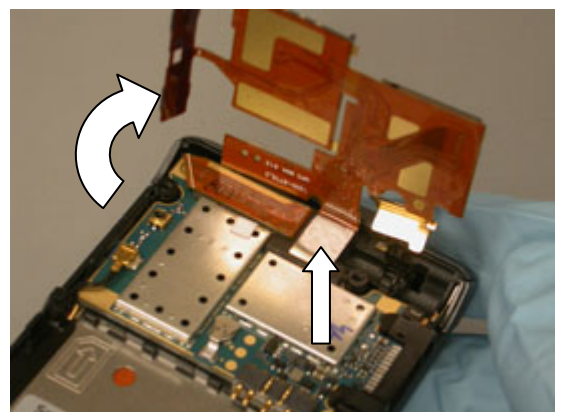
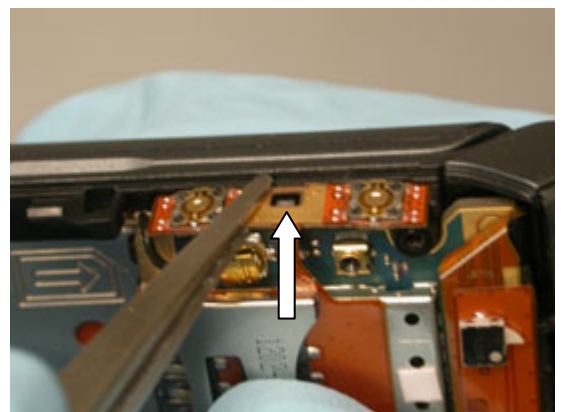
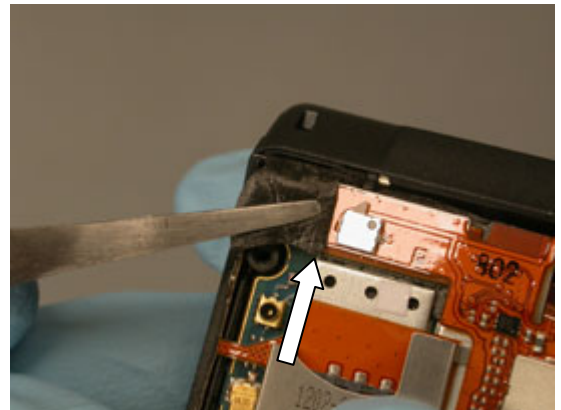
Carefully detach the ESD Cushion from the PCB by wedging up on the edge shown using round tipped tweezers.

NOTE: THE ESD CUSHION ADHESIVE MAY TEAR OFF IF NOT REMOVED PROPERLY

Remove the ESD cushion.

Using the round tipped tweezers, release the side key portion of the SIM/M2 flex from its positioning latch and lift it from the lower front cover.

Rotate the SIM/M2 flex up from the circuit board as shown to expose the flex connector.

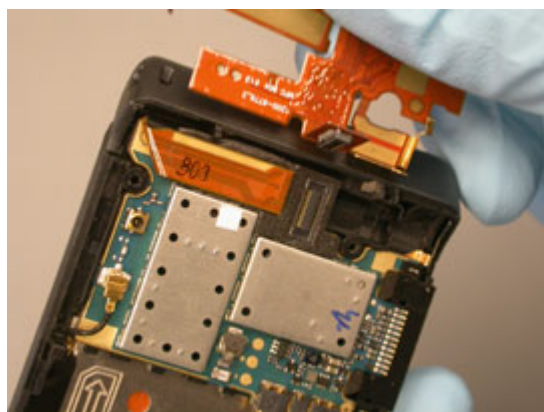


Separate the flex connector from the PCB by prying with the pry tool.

NOTE: DO NOT DAMAGE THE ESD GASKET AND NEARBY COMPONENTS WHEN DISCONNECTING THE BTB CONTACT



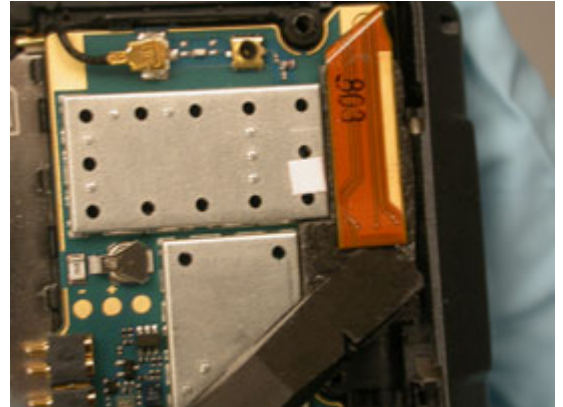
Remove the SIM/M2 flex.



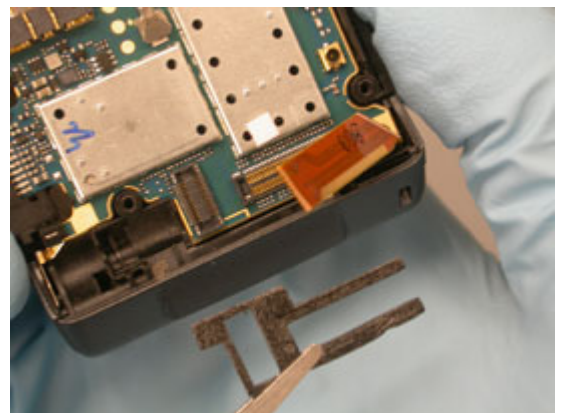
2.1.8 Lower PCB Removal

Pry the flex connector off of the lower PCB using a pry tool.

NOTE: DO NOT DAMAGE THE ESD GASKET AND NEARBY COMPONENTS WHEN DISCONNECTING THE BTB CONTACT



Remove the ESD gasket using round tipped tweezers.



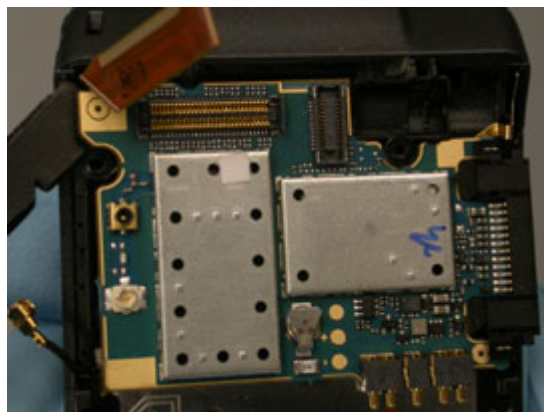
Disconnect the coax cable.



Pry in the location shown to release the first latch.



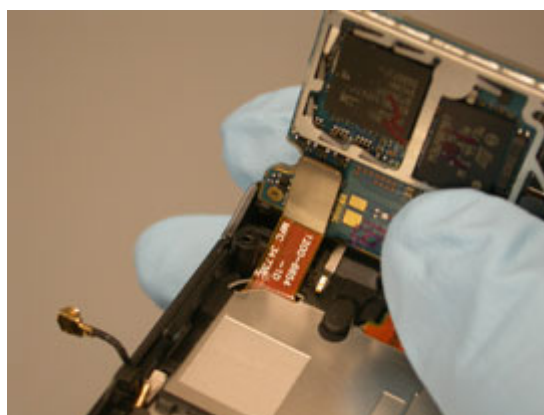
Pry in the location shown to lift the PCB.



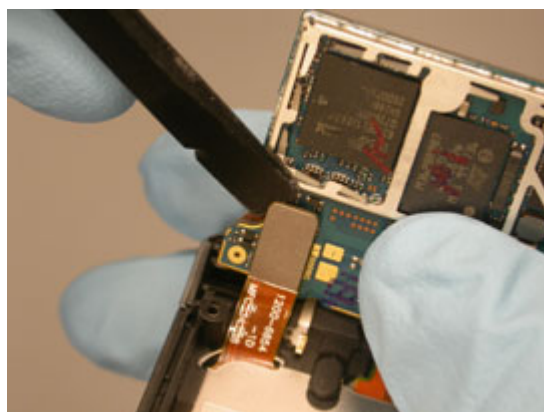
Pull the PCB away as shown.



Rotate the PCB away from the lower inner cover so that you can see the underside.



Unplug the keyboard flex from the PCB using a pry tool.



Upper Half

2.1.9 Main Window Label Removal

Open the phone.



Pry the edge of the gasket up with the round tipped tweezers as shown.



Peel the gasket off the upper front cover.





2.1.10 Upper Front Screw Removal

Remove the 4 screws shown using a T5 bit.



2.1.11 Upper Back Cover Removal

Insert the plectrum between the upper back and upper front covers at the top of the phone. Angle the plectrum and push it into the seam.



Slide the plectrum along the seam to release the three side latches.



Repeat for the other side.

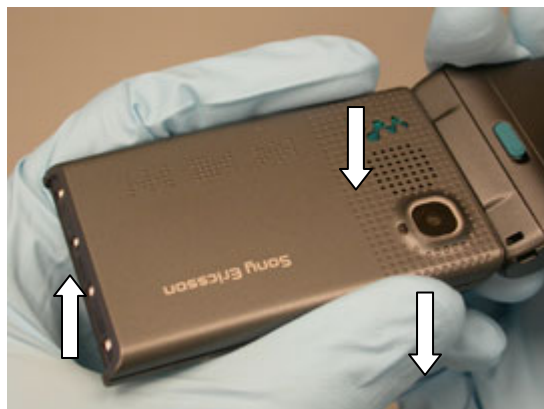
Pry one end of the cover light panel assembly free using round tipped tweezers.

Grip the free end of the cover light panel assembly and pull it off the phone.

NOTE: DO NOT REUSE COVER LIGHT PANEL



Hold the phone as shown. Pull down with your index finger and thumb while pushing up with your hand to release the end latch.



Remove upper rear cover.



2.1.12 Loudspeaker Removal

Pry the loudspeaker up in the location shown using round tipped tweezers.



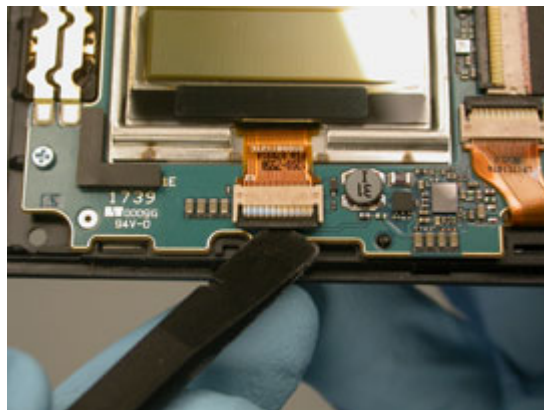
Pry the loudspeaker out in the location shown using round tipped tweezers.

NOTE: BE CAREFUL NOT TO DAMAGE METAL HOLDER FEATURES

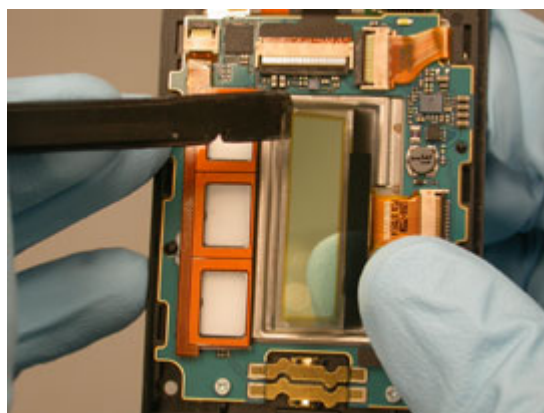


2.1.13 Outer Display Removal

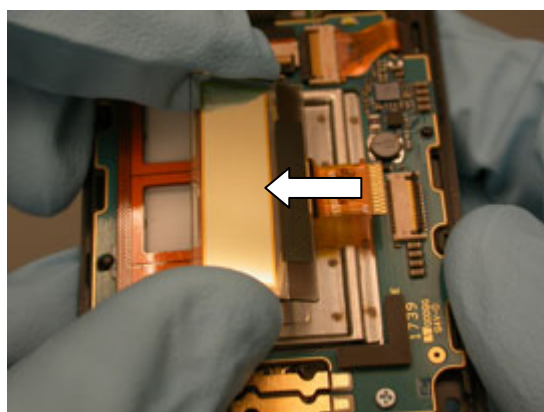
Flip the bar of the ZIF connector up using a pry tool.



Lift up on the display with a pry tool so that you can grab the sides.



Remove the display.



2.1.14 Upper PBA Removal

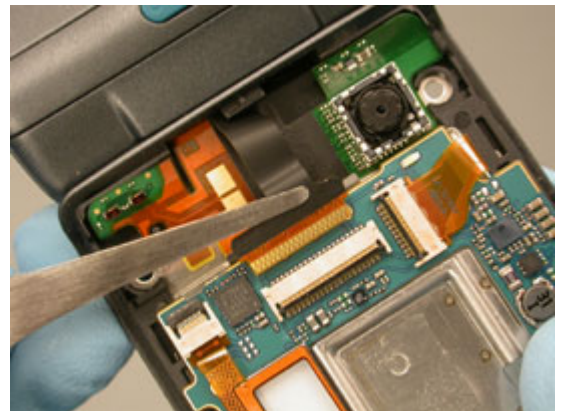
Open the hinge flex ZIF connector.



Open the display ZIF connector.



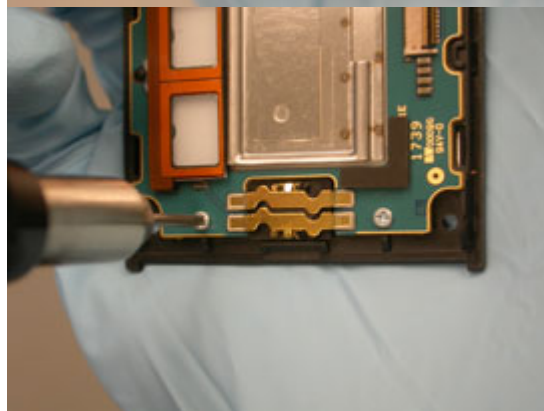
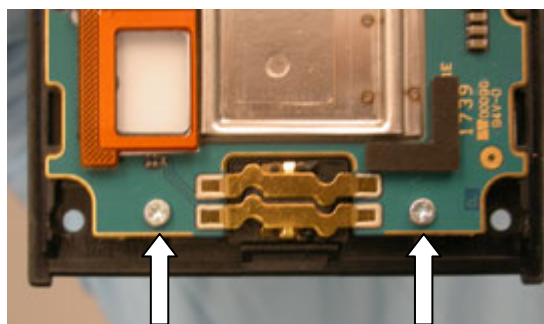
Carefully pull the flex out of the hinge ZIF connector using round tipped tweezers.



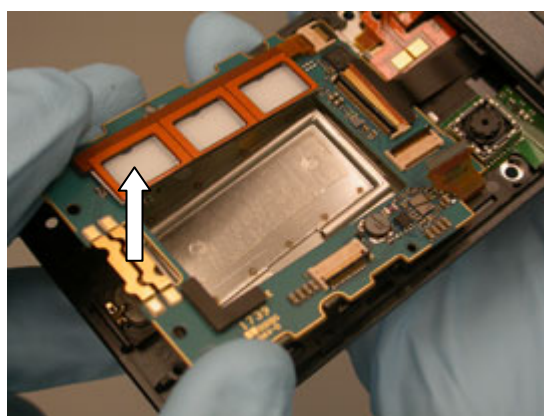
Carefully pull the flex out of the display ZIF connector using round tipped tweezers.



Remove the two upper PBA screws using a JCIS No. 0 bit.



Lift on the lower end of the PBA and remove it from the upper front cover.



3 Replacement

3.1 Antenna Assembly Replacement

Complete 2.1.1-2.1.5 of the disassembly instructions.

Remove the ESD cushion.

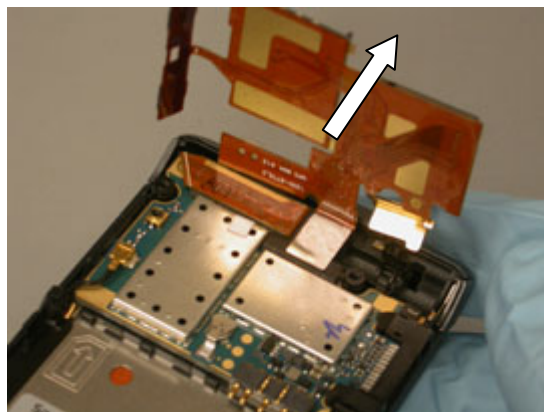
Removal

Using the round tipped tweezers, release the side key portion of the SIM/M2 flex from its positioning latch and lift it from the lower front cover.

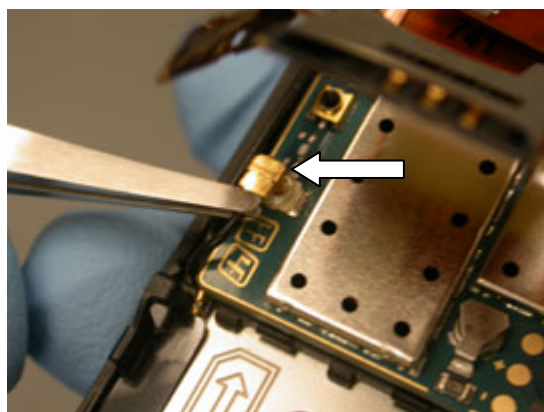
Lift up on the vibrator clip.



Lift up on the flex to expose the lower PCB.



Disconnect the coax cable from the lower PCB



Remove the coax cable gasket.



Pry the antenna off the lower front cover.





Installation

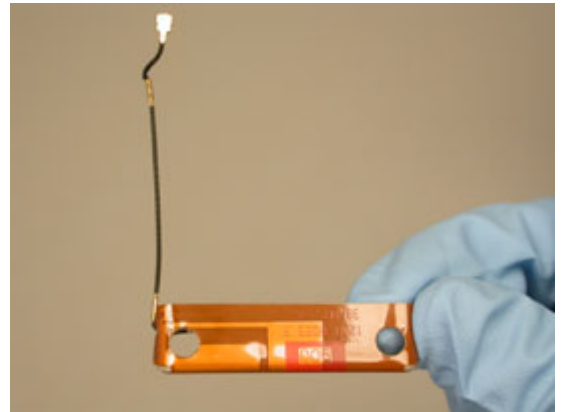
Obtain a new antenna assembly.

If you are reusing the old lower front assembly, inspect the coax cable conductive cushion to ensure it is the latest version (Gold in color). If it is not gold colored, replace it according to the Coax Cable Conductive Cushion Replacement section 3.4 before proceeding.

Snap the new antenna into position.

Lay the coax cable into the groove.

NOTE: THE METAL SHEATH OF THE CABLE SHOULD REST ON THE COAX CABLE CONDUCTIVE CUSHIONS.



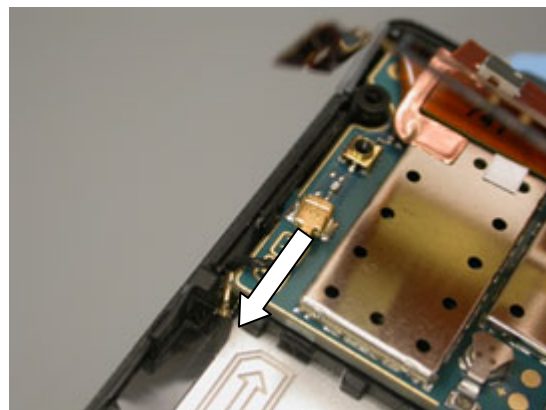


NOTE: DO NOT REUSE THE COAX CABLE GASKET

Position the coax cable gasket over the cable so that the notches on the gasket align with the features along the edge of the lower front cover.

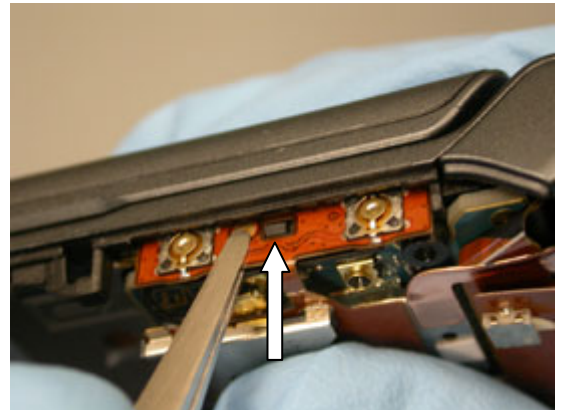


Connect the coax cable to the PCB and position the connection so that it oriented as shown.





Position the volume key flex around the tab shown using the round tipped tweezers.



Complete 4.1.10-4.1.14 of the reassembly procedure.

3.2 Battery Cover Replacement

Removal

Complete 2.1.1 of the disassembly procedure.

Installation

Obtain a new battery cover.

Complete 4.1.14 of the reassembly procedure.

3.3 Camera Replacement

See 3.10 Hinge FPC Replacement



3.4 Coax Cable Conductive Cushion Replacement

Complete 2.1.1-2.1.5 of the disassembly procedure.

Complete the removal portion of 3.1 Antenna Assembly Replacement.

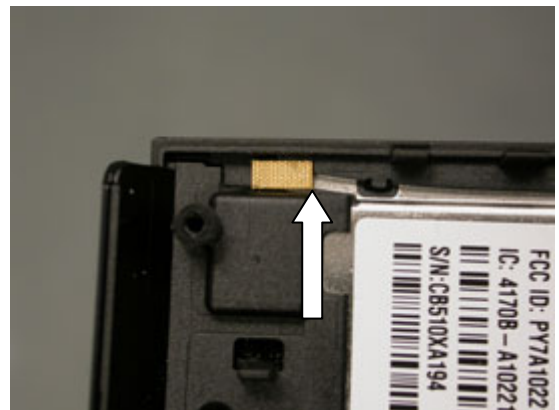
Complete 2.1.7 of the disassembly procedure.

Removal

Remove the old cushions using round tipped tweezers.

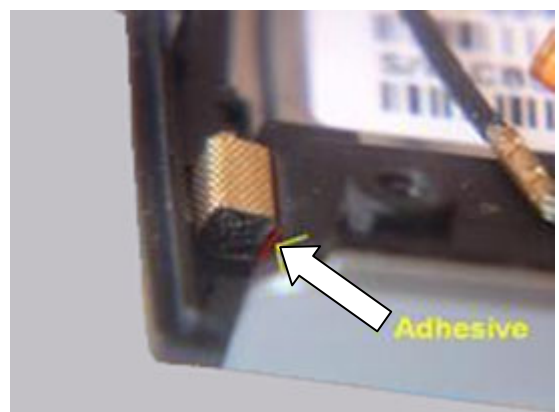


Place a new cushion in the location shown using round tipped tweezers. Line the edge of the cushion up with the edge of the plastic frame.



NOTE: MAKE SURE TO TURN THE CUSHION WITH ADHESIVE ACCORDING TO PICTURE

Place a new cushion in the location shown using round tipped tweezers. Turn the cushion with adhesive as shown in picture.



Complete 4.1.7 of the reassembly procedure.

Complete the installation portion of 3.1 Antenna Assembly Replacement

Complete 4.1.9-4.1.14 of the reassembly procedure.

3.5 Coax Cable Gasket Replacement

Complete 2.1.1-2.1.2 of the disassembly procedure.

Removal

Remove the coax cable gasket using round tipped tweezers.



Installation

Obtain a new coax cable gasket.

Position the coax cable gasket over the cable so that the notches on the gasket align with the features along the edge of the lower front cover.

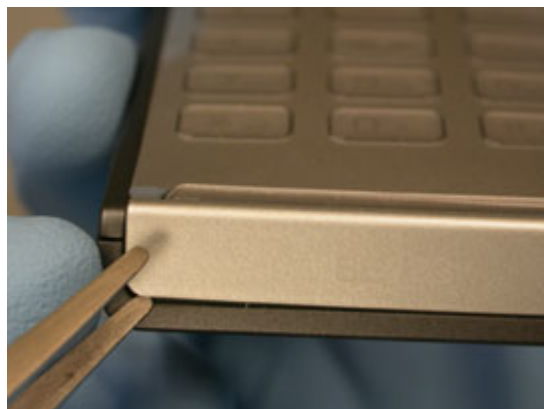


Complete 4.1.13-4.1.14 of the reassembly procedure.

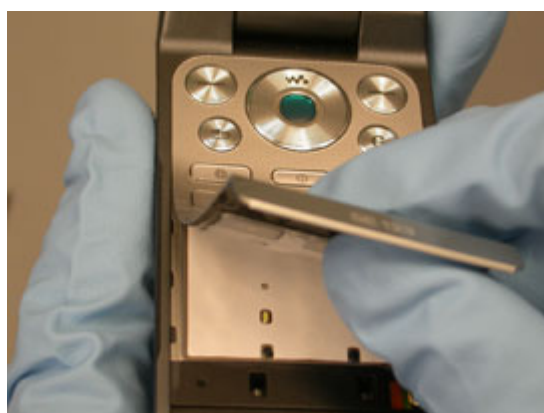
3.6 Co-brand Inlay Assembly Replacement

Removal

Lift up on the co-brand label with round tipped tweezers to separate the keyboard from the dome foil.



Peel the keyboard off the phone.



Installation

Obtain a new keyboard and co-brand label.

Place the co-brand label on the phone as shown and apply pressure over the surface so a good bond forms.



Line the bottom of the keyboard up with the co-brand label.



Lay the keyboard in the recessed area on the phone and apply pressure around the edge of the keyboard as shown so that a good bond forms.



3.7 Cover Light Panel Replacement

Complete the removal portion of 3.21 Main Window Label Replacement.

Removal

Pry one end of the cover light panel free using round tipped tweezers.

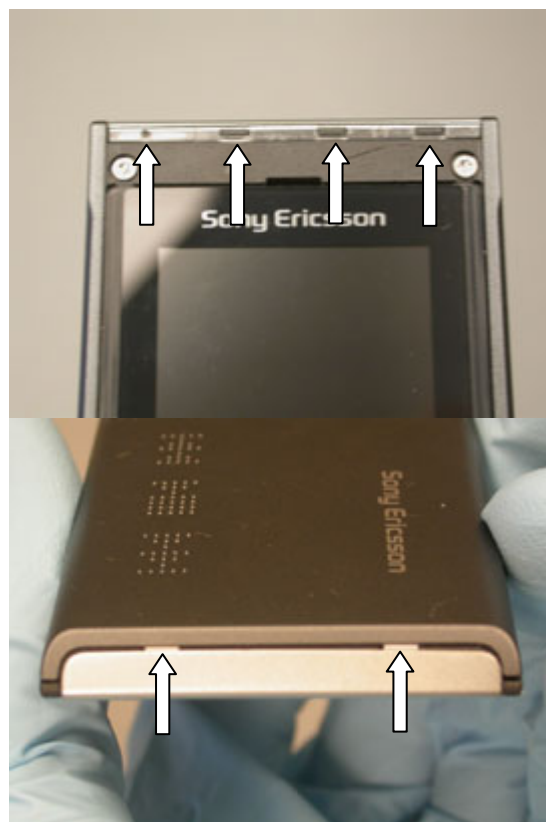
Grip the free end of the cover light panel and pull it off the phone.



Installation

Obtain a new cover light panel.

Place the cover light panel over the end of the phone so that the four positioning features line up.
Then press the two tabs under the upper rear cover.



Complete the installation portion of 3.21 Main Window Label Replacement.

3.8 Ear Speaker Replacement

Complete 2.1.1-2.1.2 and 2.1.9-2.1.14 of the disassembly procedure.

Removal

Pry the ear speaker out from the side shown using a pair of round tipped tweezers.

Note: Be sure to remove any adhesive residue

Installation

Obtain a new ear speaker.



Place the ear speaker in the position shown.

NOTE: DO NOT PRESS ON THE SPRING FINGERS



Complete 4.1.1-4.1.6 and 4.1.13-4.1.14 of the reassembly procedure.

3.9 Flex Plug Replacement

Complete 2.1.1-2.1.8 of the disassembly procedure.

Removal

Pry the flex plug with round tipped tweezers using the frame for leverage as shown.



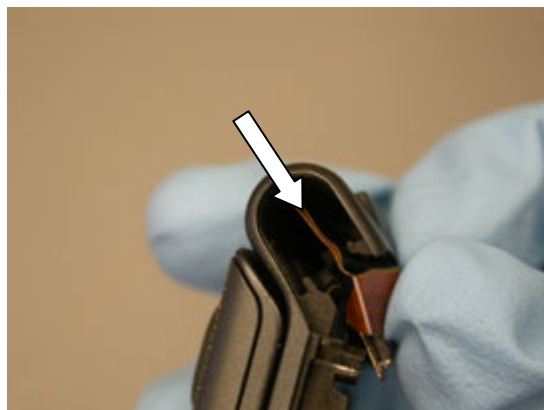
Pull the flex plug out.



Installation

Obtain a new flex plug.

Position the flex as shown and insert the plug.



Complete 4.1.7-4.1.14 of the reassembly procedure.

3.10 Hinge Replacement

Complete 2.1.1-2.1.8 of the disassembly procedure.

Complete the removal portion of 3.12 Hinge Plug Replacement.

Removal

Grip the sides of the hinge with a pair of needle-nose pliers and remove it.



Installation

Obtain a new hinge.

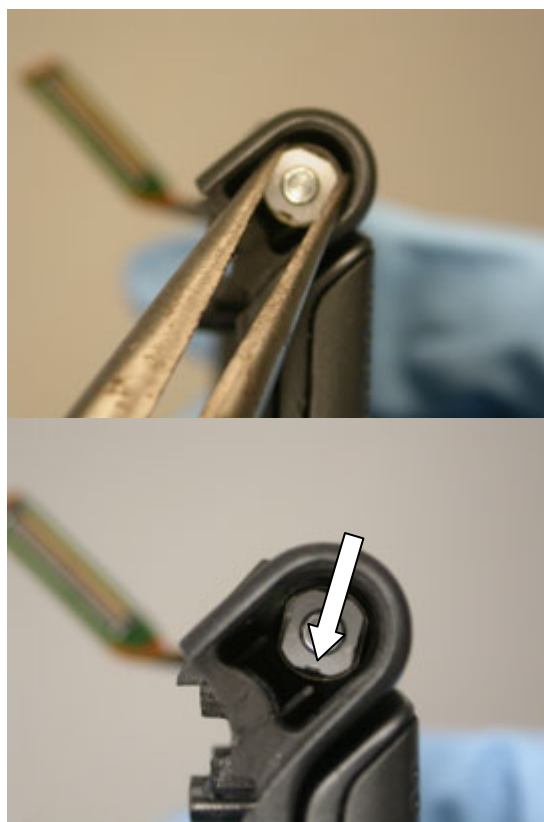


Insert the hinge using needle-nose pliers with the orientation shown.

NOTE: THE NOTCH IN THE HINGE SHOULD FACE THE TAB WITHIN THE HINGE CAVITY

Complete the installation portion of 3.12 Hinge Plug Replacement.

Complete 4.1.7-4.1.14 of the reassembly procedure.



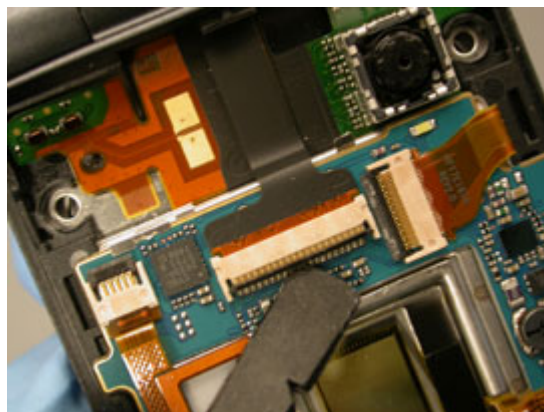
3.11 Hinge FPC Replacement

Complete 2.1.1-2.1.12 of the disassembly instructions.

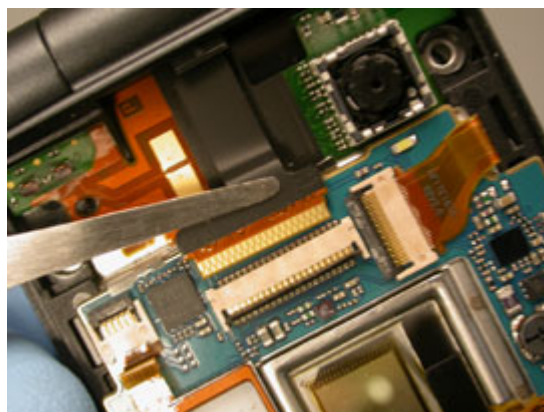
Complete the removal portion of 3.12, 3.10, and 3.9.

Removal

Open the hinge FPC ZIF connector.



Pull the flex out using round tipped tweezers.



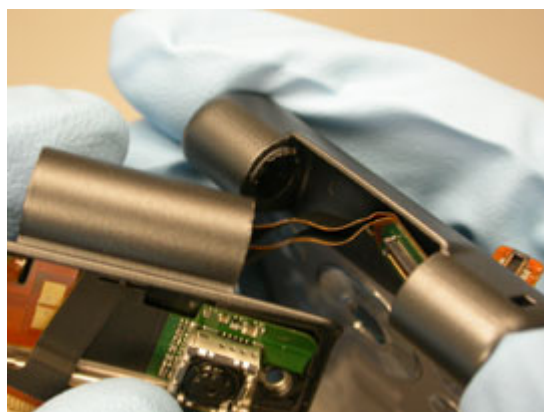
Lift the hinge FPC off the frame.



Wiggle the two phone halves carefully to separate them.



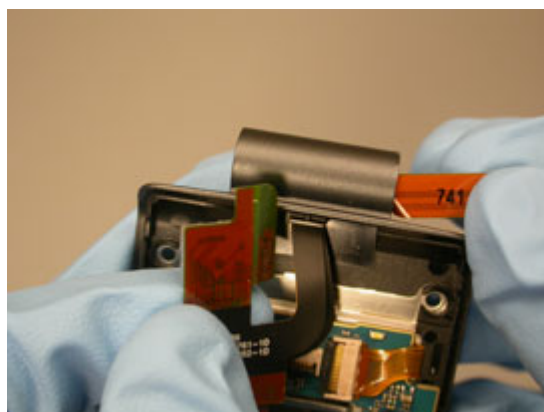
Feed the hinge flex through the cavity in the lower half.



Rotate the flex connector away from you so that you see the back.



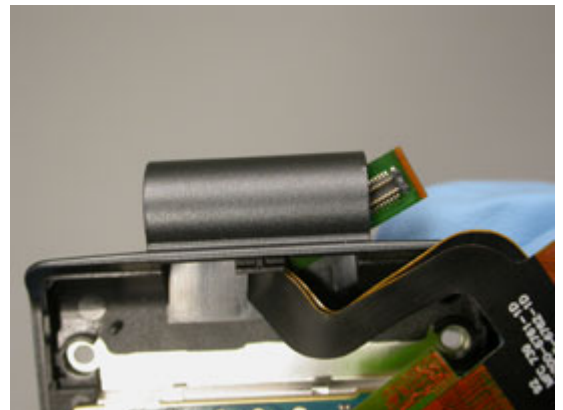
Pull the flex through far enough that you can flip the FPC over



Rotate the connector towards you so that you see the green side.



Feed the flex through.



Installation

Obtain a new hinge FPC.

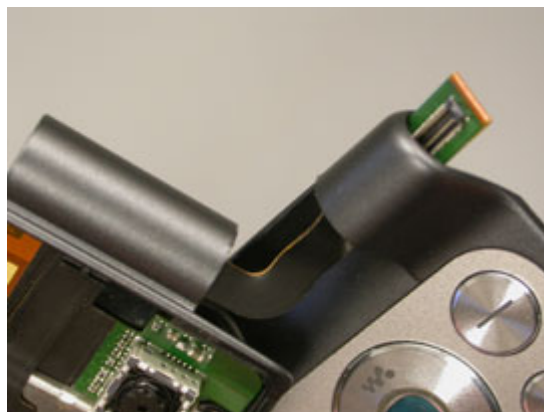
Carefully feed the flex connector into the hinge.



Pull the flex through the hinge.



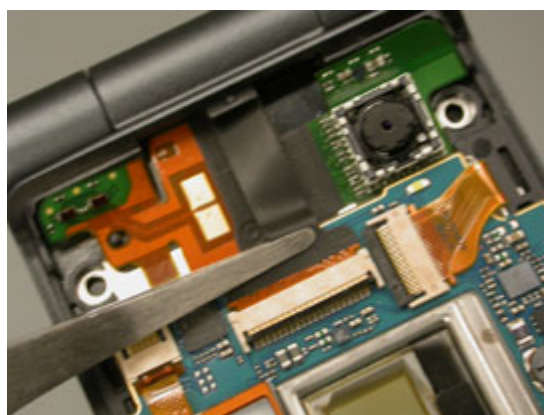
Feed the connector through the hinge of the lower half.



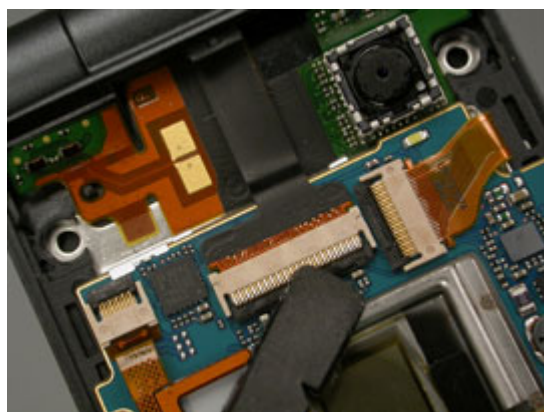
Snap the two halves together.



Insert the hinge flex into the ZIF connector.



Close the connector.



Complete the installation portion of 3.9, 3.10, and 3.12.
Complete 4.1.3-4.1.14 of the reassembly instructions.

3.12 Hinge Plug Replacement

Complete 2.1.1-2.1.8 of the disassembly procedure.

Removal

Insert the tip of the round tipped tweezers into the opening shown.

Pry the hinge plug out.



Grip the hinge plug with the tweezers as shown and remove it.



Installation

Obtain a new hinge plug.



Open the phone.



Insert the hinge plug into the hinge frame.

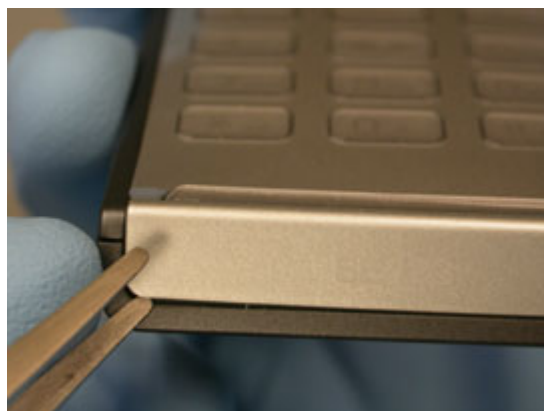


Complete 4.1.8-4.1.14 of the reassembly procedure.

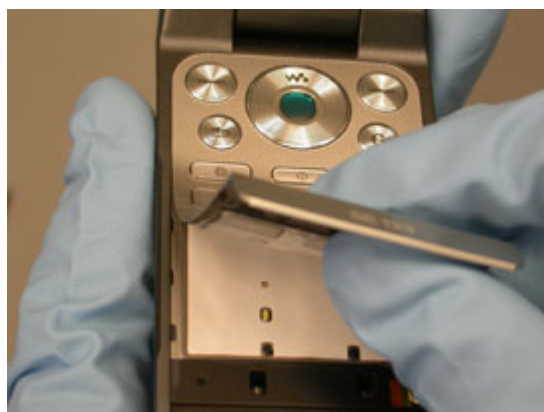
3.13 Keyboard Replacement

Removal

Lift up on the co-brand label with round tipped tweezers to separate the keyboard from the dome foil.



Peel the keyboard off the dome foil.



Installation

Obtain a new keyboard and co-brand label.

Place the co-brand label on the phone.



Line the bottom of the keyboard up with the co-brand label.



Lay the keyboard across the phone and press firmly to create a good bond.



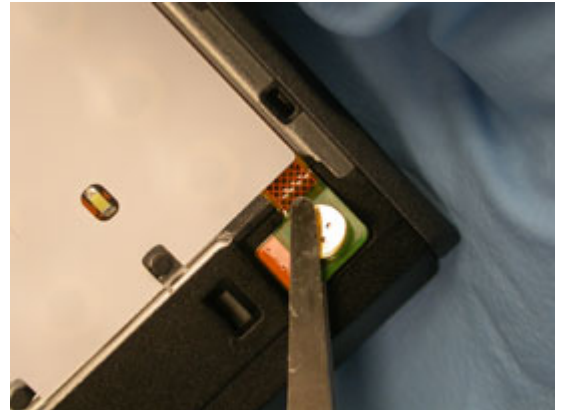
3.14 Keyboard FPC Assembly Replacement

Complete 2.1.1-2.1.8 of the disassembly procedure.

Complete the removal portions of 3.6 Cobrand Inlay Assembly.

Removal

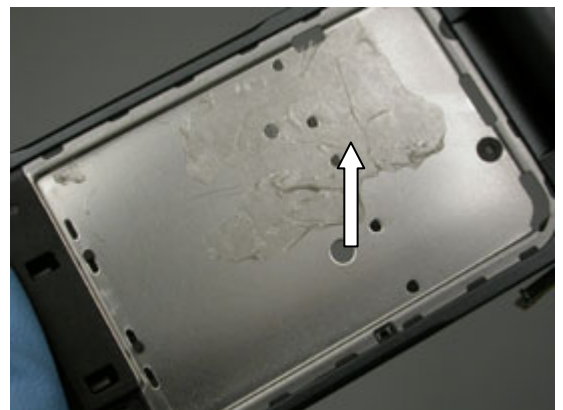
Use the round tipped tweezers to pry the microphone up.



Starting from the bottom right corner, peel the keypad FPC off the lower front cover.



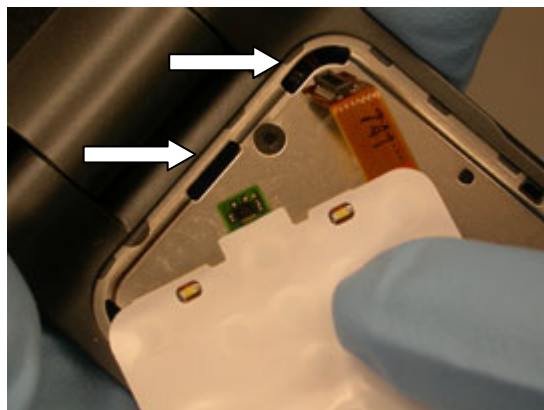
Remove any remaining adhesive.



Installation

Obtain a new keypad FPC.

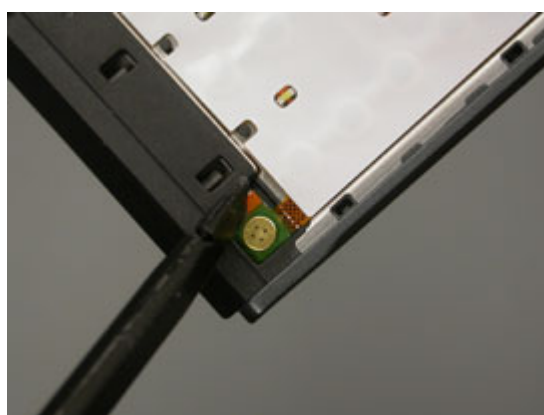
Insert the connector end and tab into the corresponding slots.



Line the top of the keypad FPC up with the recess and smooth the keypad across the phone.



Snap the microphone flex down into the recess.



Complete the installation portions of 3.6.

Complete 4.1.8-4.1.14 of the reassembly instructions.



3.15 Key Locking Assembly Replacement

Complete 2.1.1-2.1.5 of the disassembly procedure.

Remove the key locking assembly cover using round tipped tweezers.



Removal

Remove the key locking assembly with a pair of round tipped tweezers. Flex the top of the lower back cover to release the tab.



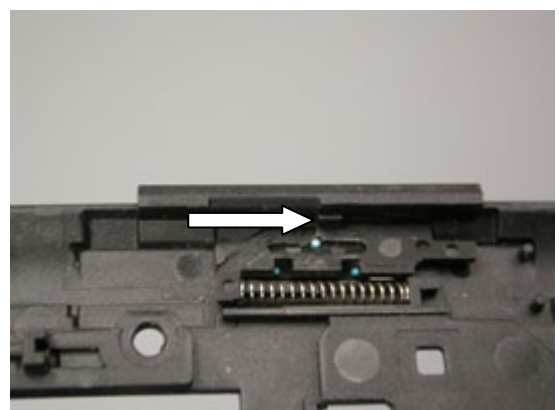
Installation

Obtain a new key locking assembly.

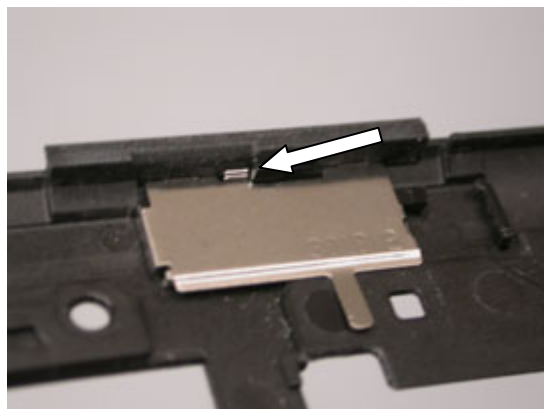


Insert the key locking assembly.

NOTE: ENSURE THE TAB LATCHES



Insert the keylock cover tab into the gap and snap the cover into place.



Complete 4.1.11-4.1.14 of the reassembly procedure.

3.16 Label Replacement

Complete 2.1.1-2.1.2 of the disassembly procedure.

Removal

Peel up a corner of the label using round tipped tweezers and remove the label.



Installation

Print a new label.

NOTE: IF YOU ARE PRINTING A BRAZIL OR VIVO LABEL, REFER TO SECTION 5 FOR MORE INFORMATION ON THE COUNTRY OF ORIGIN.

Align the corner of the label as shown.



Smooth the label out onto the surface.



Complete 4.1.13-4.1.14 of the reassembly procedure.

3.17 Loudspeaker Replacement

Complete 2.1.1-2.1.2 and 2.1.9-2.1.12 of the disassembly procedure.

Installation

Obtain a new loudspeaker.

Complete 4.1.3-4.1.6 and 4.1.13-4.1.14 of the reassembly procedure.

3.18 Lower Back Cover Replacement

Complete 2.1.1-2.1.5 of the disassembly procedure.

Installation

Obtain a new lower back cover.

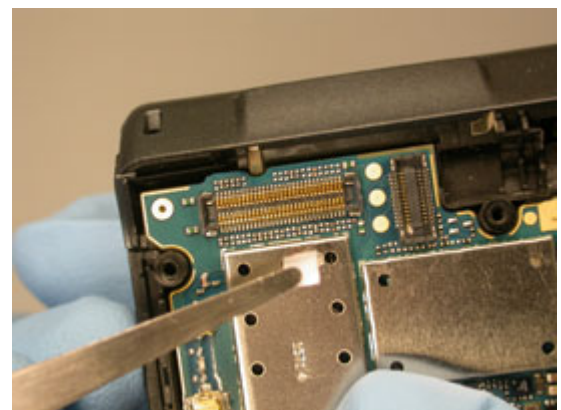
Complete 4.1.11-4.1.14 of the reassembly procedure.

3.19 Liquid Intrusion Indicator Replacement

Complete 2.1.1-2.1.7 of the disassembly procedure.

Removal

Remove the liquid intrusion indicator with round tipped tweezers.



Installation

Obtain a new liquid intrusion indicator.

Place the indicator as shown.



Complete 4.1.9-4.1.14 of the reassembly procedure.

3.20 Lower Front Cover Replacement

Complete 2.1.1-2.1.8 of the disassembly procedure.

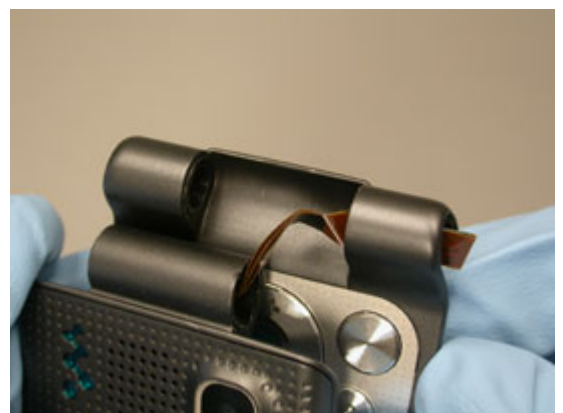
Complete the removal portions of 3.1, 3.9, 3.12 and 3.10.

Removal

Carefully wiggle the two halves apart.



Feed the hinge flex through the hinge cavity.

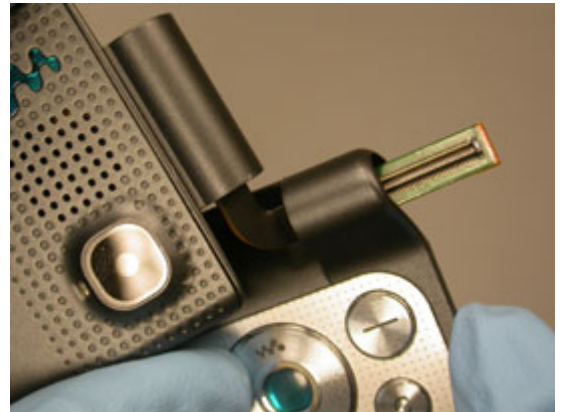


Installation

Obtain a new lower front cover assembly.



Feed the hinge flex through the hinge cavity.



Snap the two phone halves together.



Complete the installation portions of 3.10, 3.12, 3.9, and 3.1.

Complete 4.1.7-4.1.14 of the reassembly procedure.

3.21 Main Window Label Replacement

Complete 2.1.1-2.1.2 and 2.1.9 of the disassembly section.

Installation

Obtain a new main window label.

Complete 4.1.6 and 4.1.13-4.1.14 of the reassembly section.

3.22 Outer Display Replacement

Complete 2.1.1-2.1.2 and 2.1.9-2.1.13 of the disassembly procedure.

Installation

Obtain a new outer display.

Complete 4.1.2-4.1.6 and 4.1.13-4.1.14 of the reassembly procedure.

3.23 Screw Cover Replacement

Complete 2.1.1-2.1.3 of the disassembly procedure.

Installation

Obtain a new screw cover.

Complete 4.1.12-4.1.14 of the reassembly procedure.

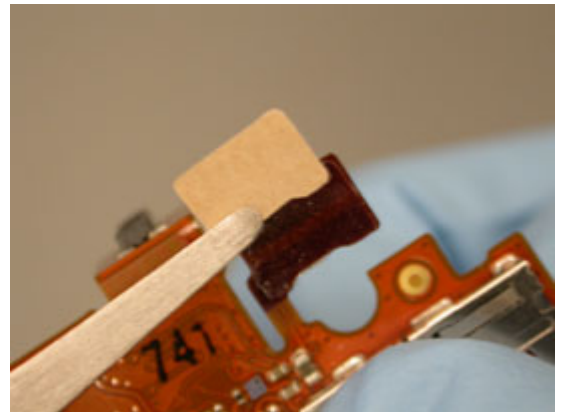
3.24 SIM Flex Replacement

Complete 2.1.1-2.1.7 of the disassembly section.

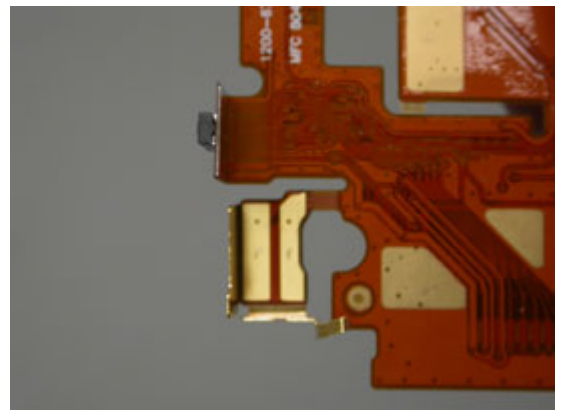
Installation

Obtain a new SIM flex and vibrator cap.

Peel the backing off the adhesive flex strip.



Place the flex strip into the vibrator cap.



Complete 4.1.9-4.1.14 of the reassembly section.

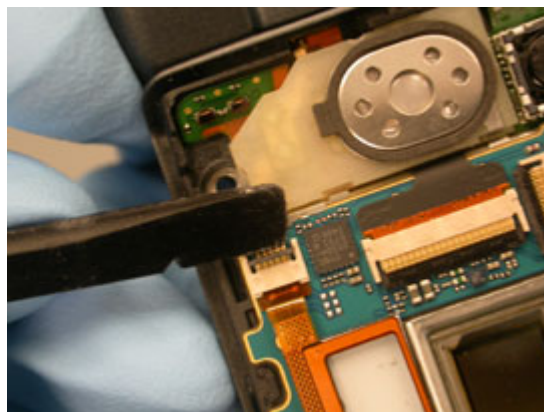
NOTE: BE SURE TO REPLACE THE ESD CUSHION

3.25 Touch Key Assembly Replacement

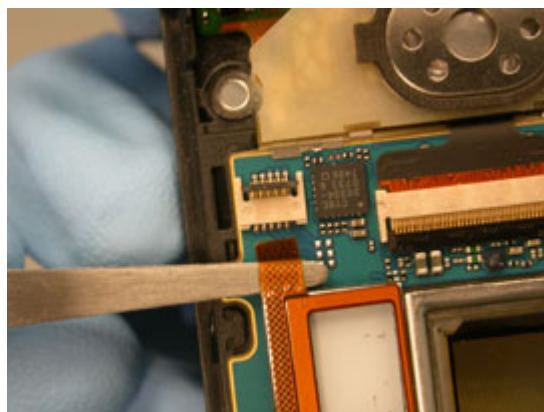
Complete 2.1.1-2.1.2 and 2.1.9-2.1.11 of the disassembly procedure.

Removal

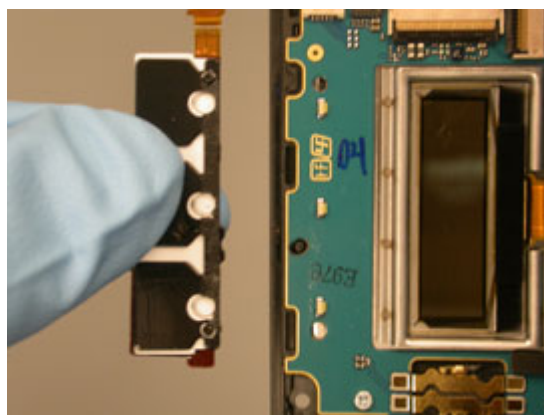
Flip the ZIF connector open using round tipped tweezers.



Carefully pull the flex out of the connector as shown.



Peel the touch keys off the upper PBA.

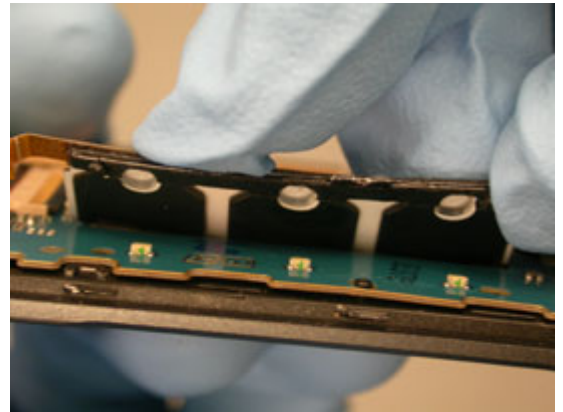


Installation

Obtain a new touch key assembly.



Line the LEDs on the PBA up with the ports on the back of the touch keys.

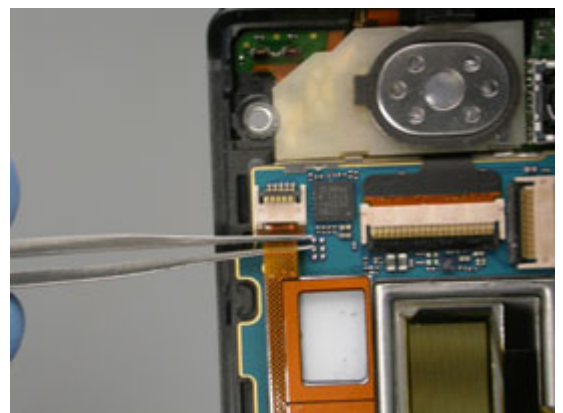


Adhere the touch keys to the PBA.

NOTE: THE TOUCH KEY ASSEMBLY SHOULD CLEAR THE ALIGNMENT PEG



Insert the flex into the connector using round tipped tweezers as shown.



Close the ZIF connector.



Complete 4.1.4-4.1.6 and 4.1.13-4.1.14 of the reassembly procedure.



3.26 Upper Back Cover Replacement

Complete 2.1.1-2.1.2 and 2.1.9-2.1.11 of the disassembly procedure.

Installation

Obtain a new upper back cover.

Complete 4.1.4-4.1.6 and 4.1.13-4.1.14 of the reassembly procedure.

3.27 Upper Front Assembly Replacement

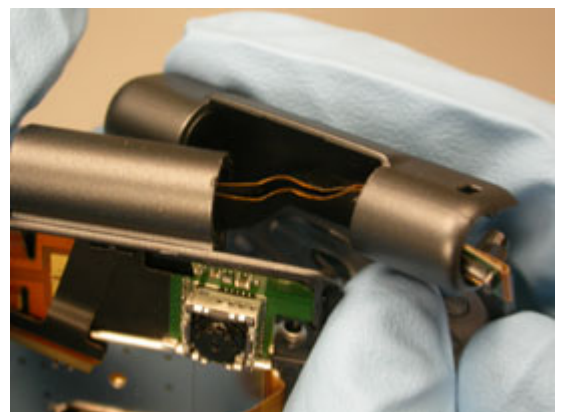
Complete 2.1.1-2.1.14 of the disassembly instructions.

Complete the removal portion 3.12, 3.10, 3.9, and 3.8.

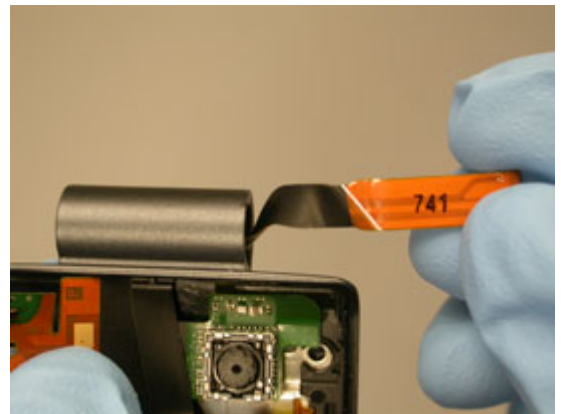
Removal

Wiggle the two phone halves carefully to separate them.

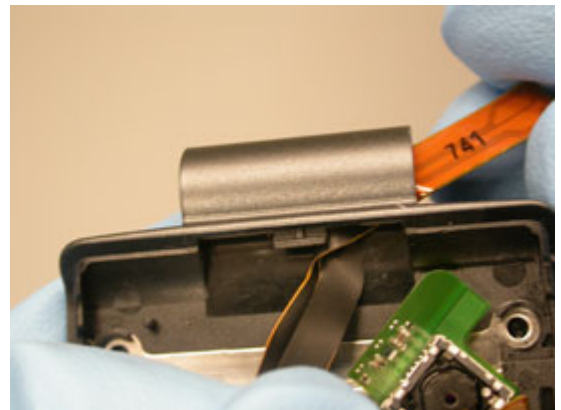
Feed the hinge flex through the cavity in the lower half.



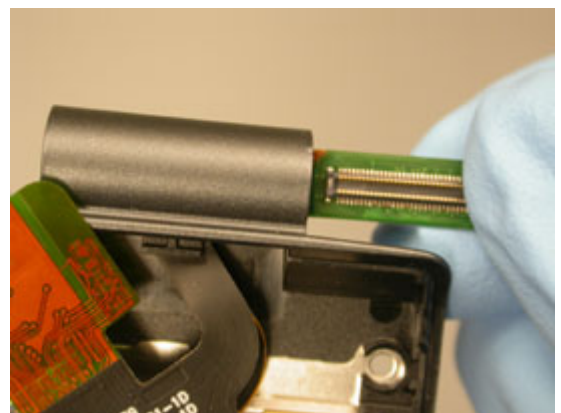
Rotate the flex connector towards from you so that you see the back.



Pull the flex through far enough that you can flip the FPC over



Rotate the connector towards you so that you see the green side.



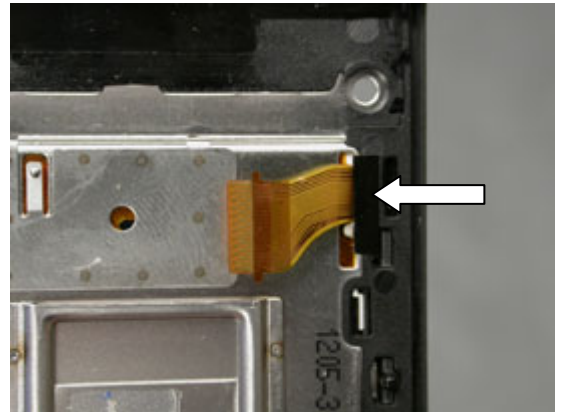
Feed the flex through.



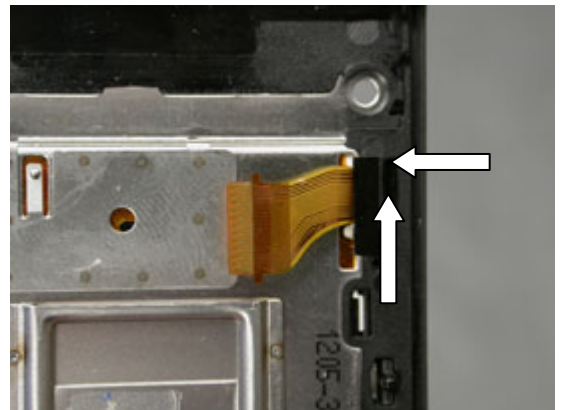
Installation

Obtain a new Upper Front Assembly.

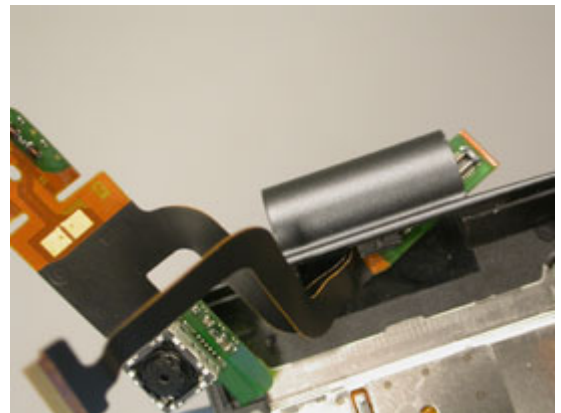
Inspect the upper front assembly for the protective plate tape. If it is not in place, install as instructed below.



While holding the LCD flex in place, position the protective plate tape so that the top edge of the tape is lined up with the horizontal edge of the slot and the side edge of the tape is 1mm away from the vertical edge of the slot as indicated by the arrows.



Carefully feed the flex connector into the hinge.-



Pull the flex through the hinge.





Feed the connector through the hinge of the lower half.



Snap the two halves together.



Complete the installation portion of 3.8, 3.9, 3.10, and 3.12.
Complete 4.1.4-4.1.14 of the reassembly instructions.

3.28 Upper PBA Replacement

Complete 2.1.1-2.1.2 and 2.1.9-2.1.14 of the disassembly procedure.

Installation

Obtain a new upper PBA.

Complete 4.1.1-4.1.6 and 4.1.13-4.1.14 of the reassembly procedure.

3.29 Vibrator Replacement

Complete 2.1.1-2.1.6 of the disassembly procedure.

Installation

Obtain a new vibrator.

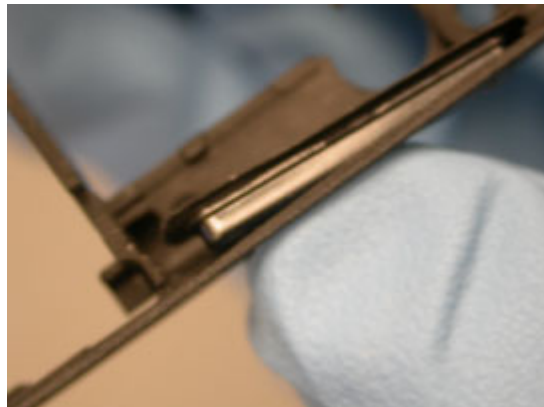
Complete 4.1.9-4.1.14 of the reassembly procedure.

3.30 Volume Key Replacement

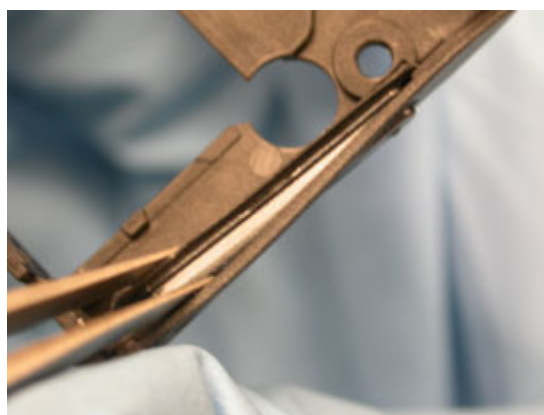
Complete 2.1.1-2.1.5 of the disassembly procedure.

Removal

Push the volume key in as shown.



Grip the volume key with round tipped tweezers.



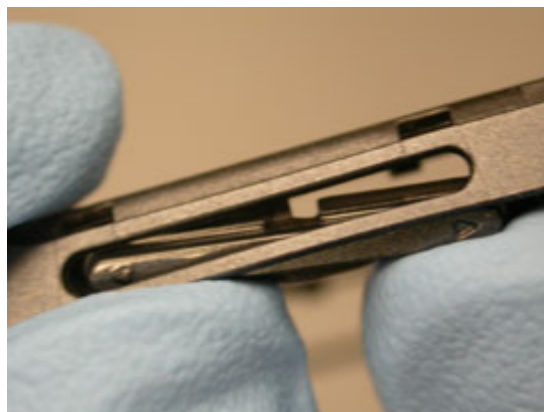
Remove the key.



Installation

Obtain a new volume key.

Insert the back of the key in front of the tab on the back cover.



Push the key into place.



Complete 4.1.10-4.1.14 of the reassembly procedure.

4 Reassembly

4.1 Overview

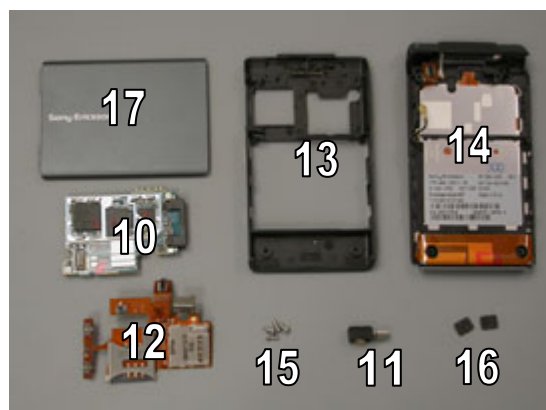
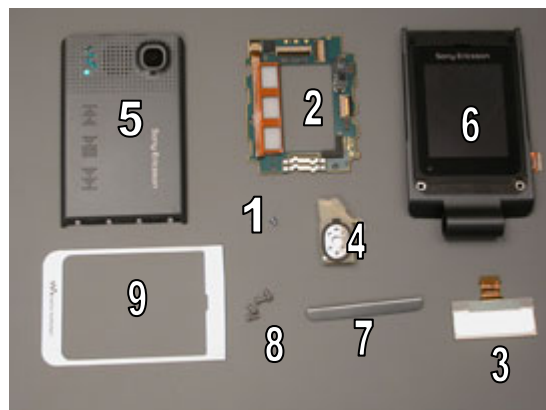
Reassemble in the following order:

Upper Half

- Upper PBA (2) and Upper PBA screws (1) to Upper Front (6)
- Outer Display (3)
- Loudspeaker (4)
- Upper Back Cover (5) to Upper Front (6)
- Cover Light Panel Assembly (7)
- Upper Front Screws (8)
- Main Window Label (9)

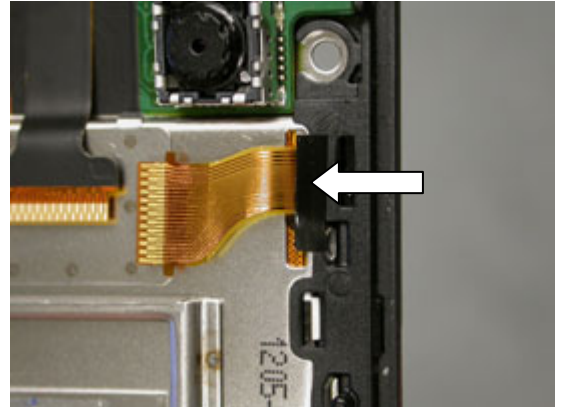
Lower Half

- Lower PCB (10)
- Vibrator (11)
- SIM/M2 Flex (12)
- Lower Back Cover (13) to Lower Front (14)
- Lower Back Screws (15)
- Screw Covers (16)
- Battery
- Battery Cover (17)

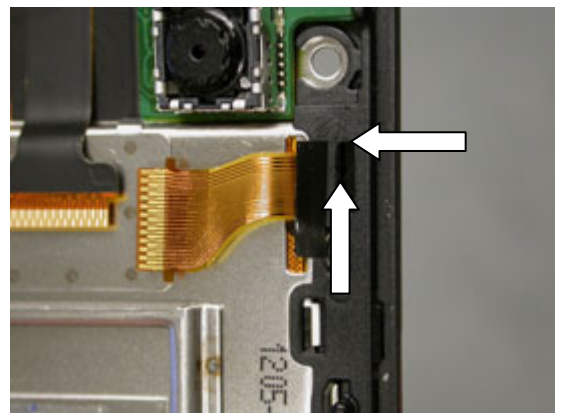


4.1.1 Upper PBA Installation

Inspect the upper front assembly for the protective plate tape. If it is not in place, install as instructed below.



While holding the LCD flex in place, position the protective plate tape so that the top edge of the tape is lined up with the horizontal edge of the slot and the side edge of the tape is 1mm away from the vertical edge of the slot as indicated by the arrows.

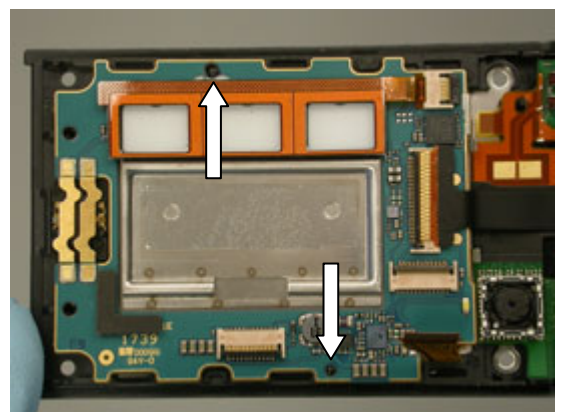


Insert the board under the tab shown.

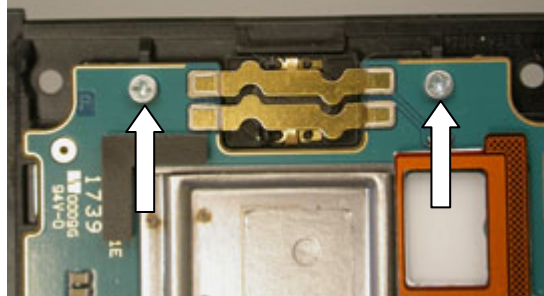
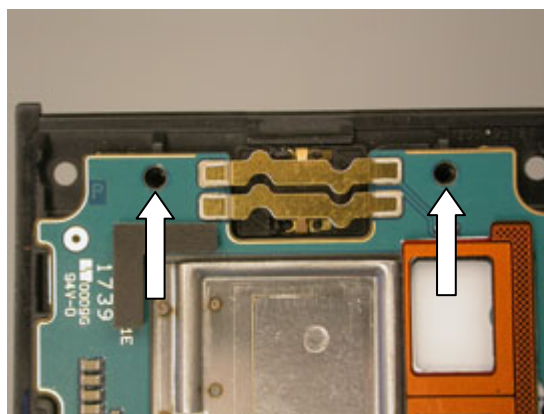


Lay the board down onto the frame using the alignment pegs.

NOTE: MAKE SURE THE HINGE FLEX AND MAIN DISPLAY FLEX ARE NOT UNDER THE BOARD



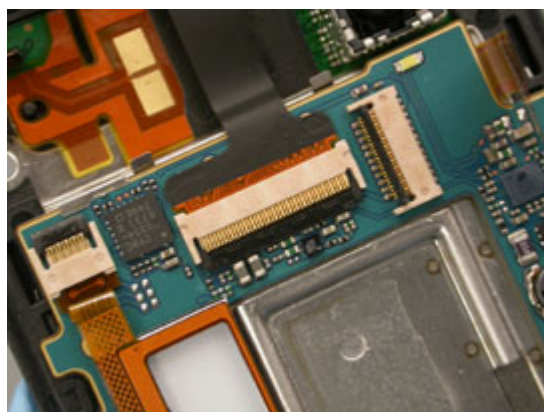
Insert two inner screws in the locations shown. Tighten to 9 Ncm using a JCIS-0 bit.



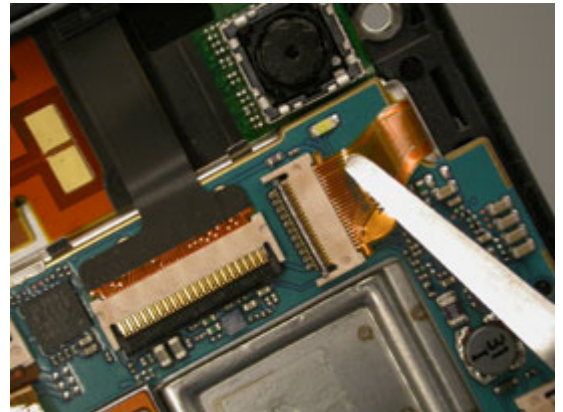
Insert the hinge flex into the ZIF connector on the PCB using round tipped tweezers.



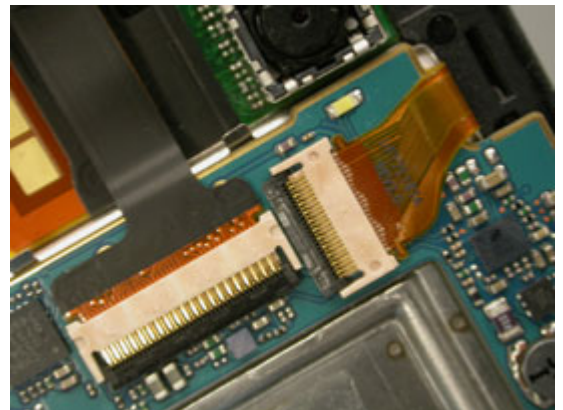
Close the ZIF connector.



Insert the display flex into the ZIF connector.

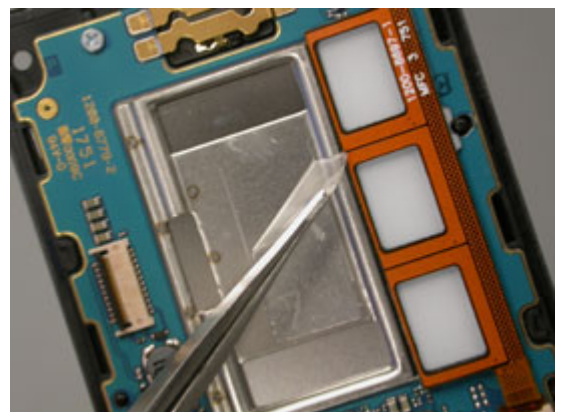


Close the ZIF connector.

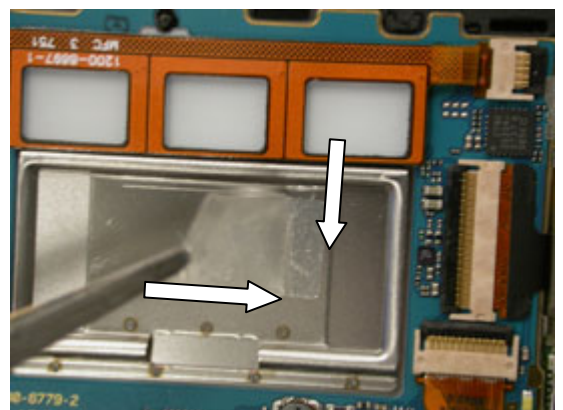


4.1.2 Outer Display Installation

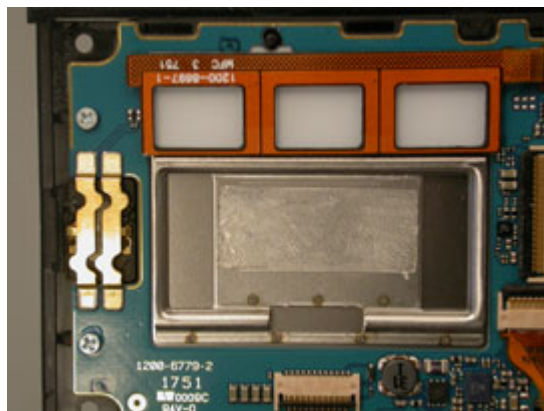
Peel off the outer display adhesive using round tipped tweezers.



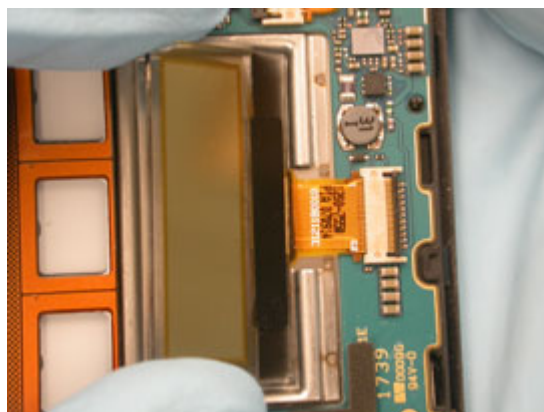
Place a new outer display adhesive in the recess, lining the edge up as shown.



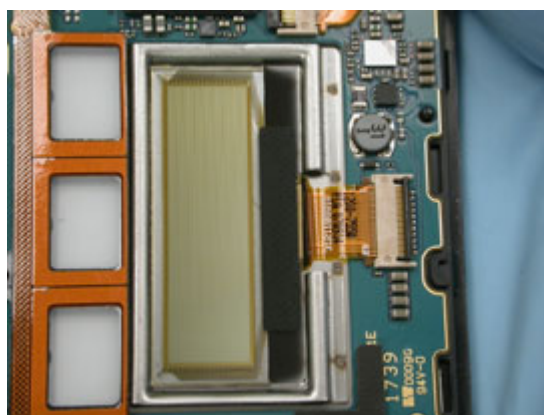
Lay the adhesive flat out over the recess.



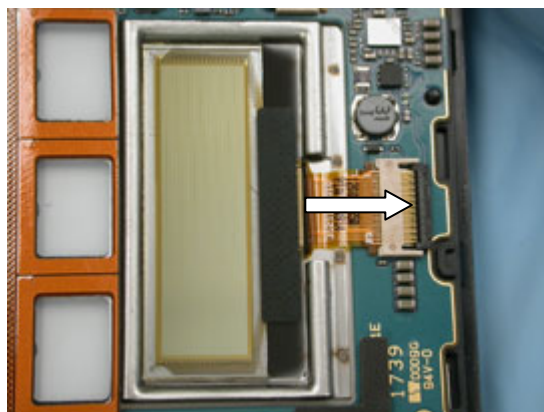
Insert the outer display flex into the ZIF connector as shown.



Lay the outer display into place on the upper front cover as shown.



Close the ZIF connector.



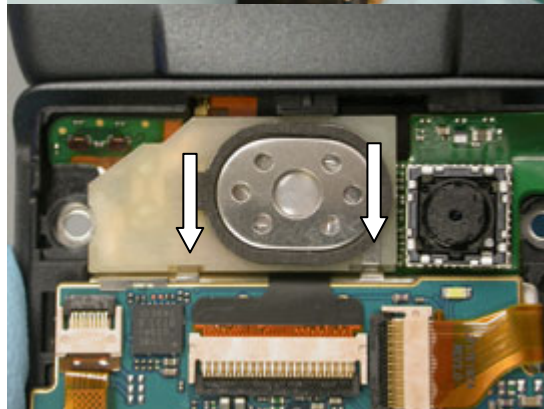
4.1.3 Loudspeaker Installation

Insert the tabbed end of the loudspeaker under tab at hinge opening.



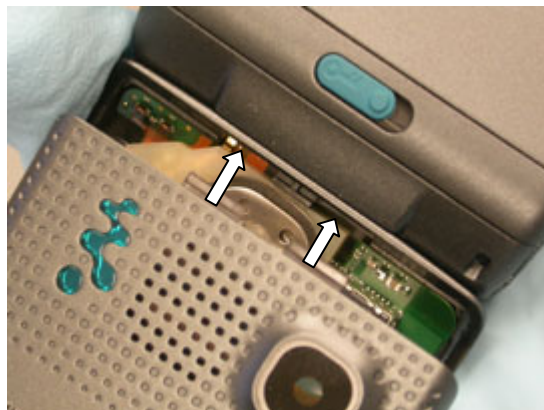
Press down on the edge of the loudspeaker shown so that the metal tabs that hold that side of the speaker box lock in place.

NOTE: ENSURE THE GROUNDING TAB DOES NOT GET BENT

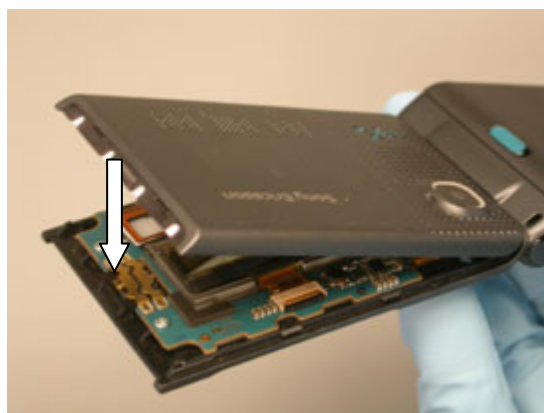


4.1.4 Upper Back Cover Installation

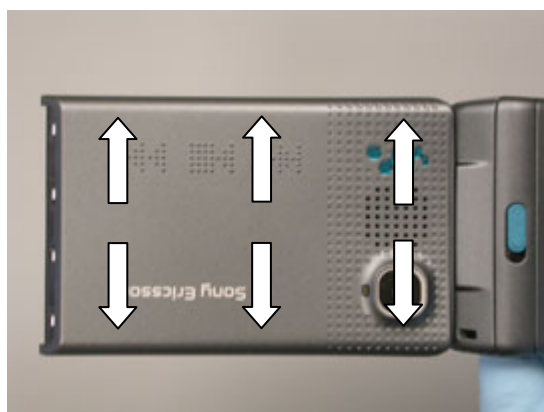
Insert the two tabs of the upper back cover into their notches on the frame.



Snap the end of the cover onto the frame.



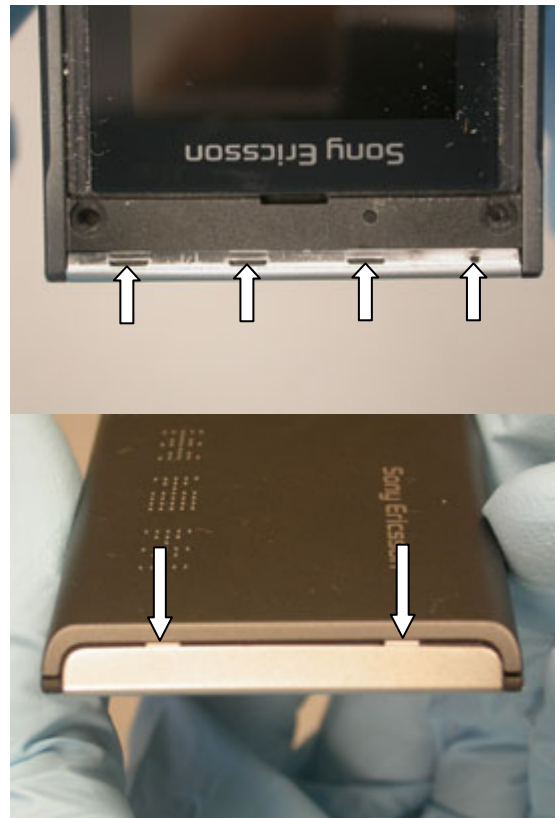
Press in the locations shown along the sides to lock the latches.





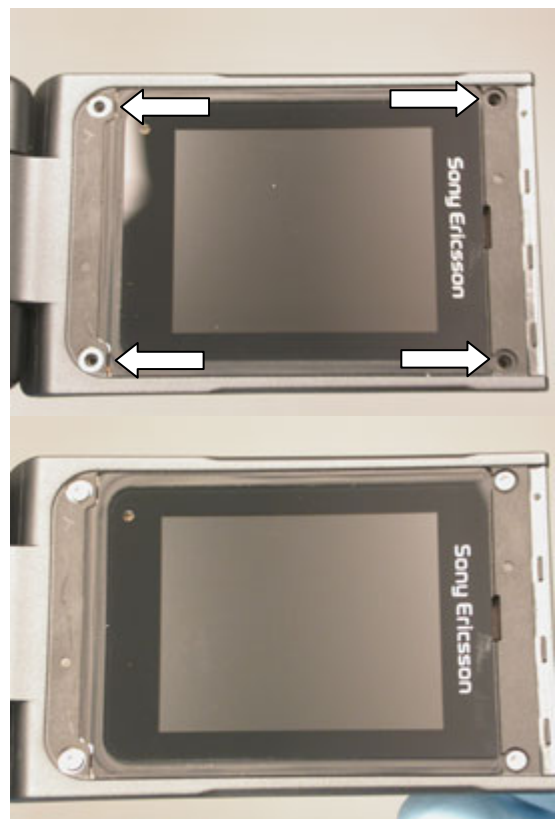
Place the cover light panel assembly over the end of the phone so that the four positioning features line up. Press the two tabs under the upper rear cover.

NOTE: DO NOT REUSE COVER LIGHT PANEL ASSEMBLY



4.1.5 Upper Front Screw Installation

Insert four screws in the locations shown. Tighten to 13 Ncm using a T5 bit.



4.1.6 Main Window Label Installation

Line the bottom of the main window label up with its cavity.

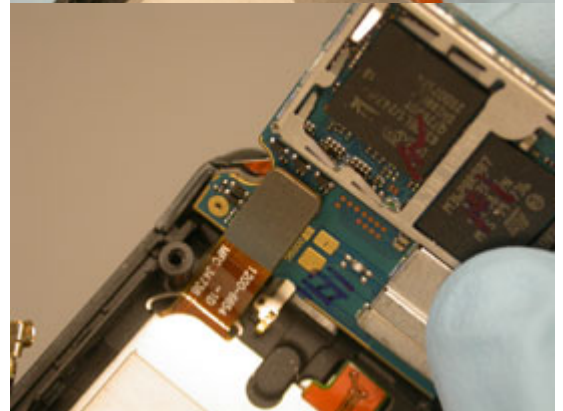
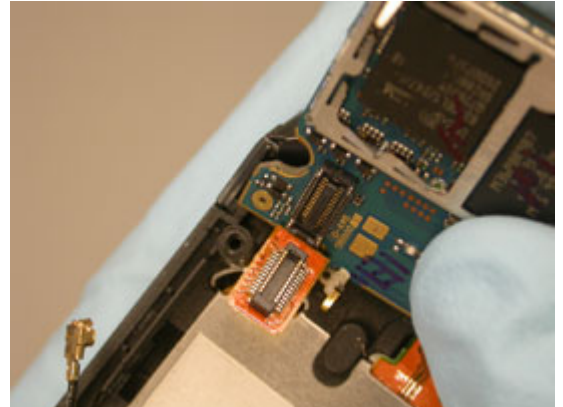


Work the label into its cavity and press over the surface of the entire gasket so a good bond forms.



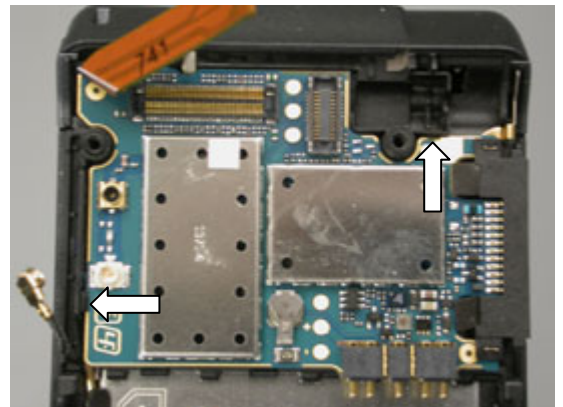
4.1.7 Lower PCB Installation

Connect the PCB and flex as shown.

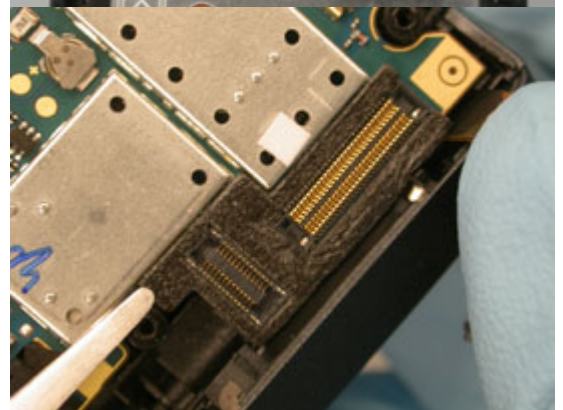


Lay the board into place and press on the board so that the two latches snap into place.

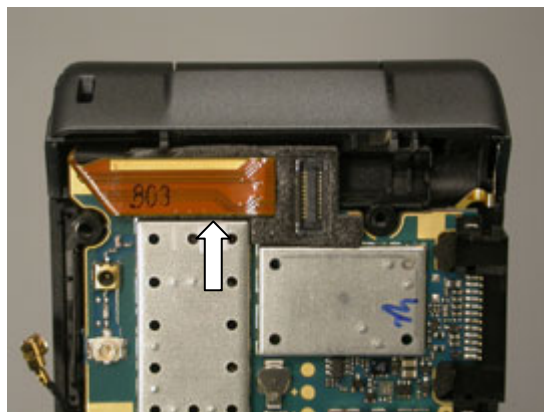
NOTE: ENSURE THE COAX CABLE IS NOT UNDER THE PCB



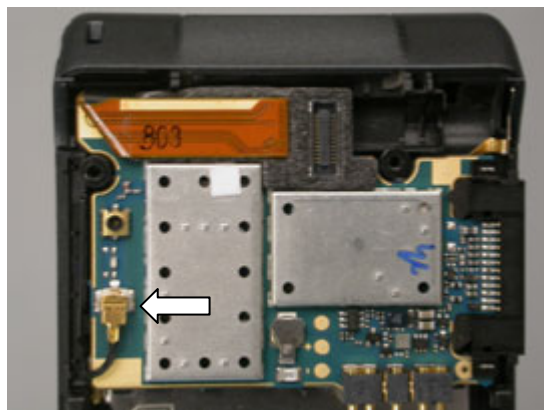
Lay the foam gasket into place.



Connect the flex as shown.



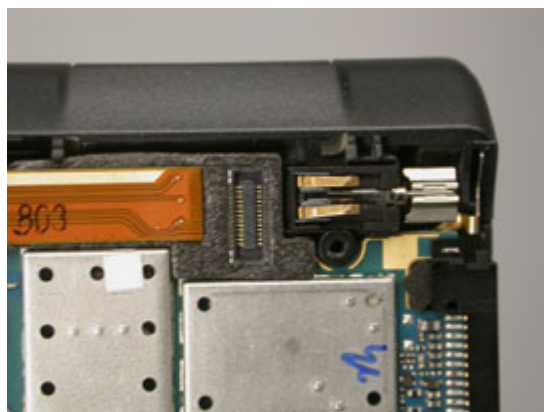
Connect the coax cable and position the connection so that it is oriented as shown.



4.1.8 Vibrator Installation

Place the vibrator in its cavity.

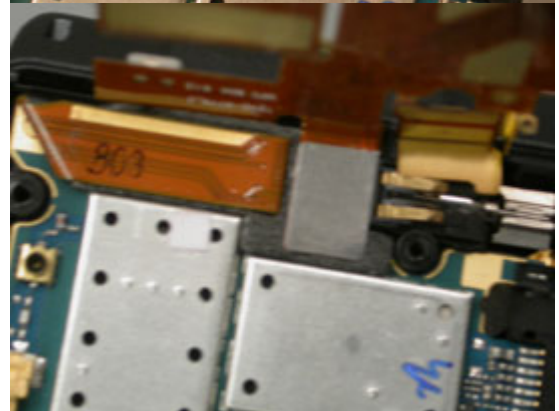
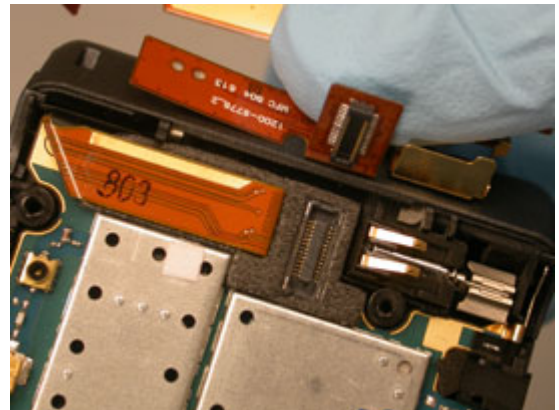
NOTE: DO NOT PRESS ON THE CONTACT FINGERS.





4.1.9 SIM/M2 Flex Installation

Connect the flex to the PCB as shown.



Place the vibrator cap over the vibrator.

NOTE: THE VIBRATOR CAP SHOULD FIT OUTSIDE THE RUBBER VIBRATOR GASKET

NOTE: ENSURE THE VIBRATOR CAP IS ABLE TO SPRING OFF THE VIBRATOR WHEN PRESSED ON



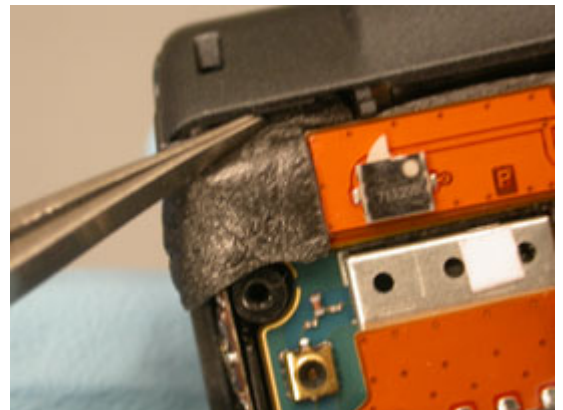
Position the volume key flex around the tab shown using the round tipped tweezers.



Place the ESD cushion on the hinge flex as shown.



Push the edges of the cushion into the gap as shown.



4.1.10 Lower Back Cover Installation

Insert the tab at the key lock end of the lower back cover under the edge of the lower front cover as shown.



Carefully lay the cover over the SIM/M2 flex and snap it into place.

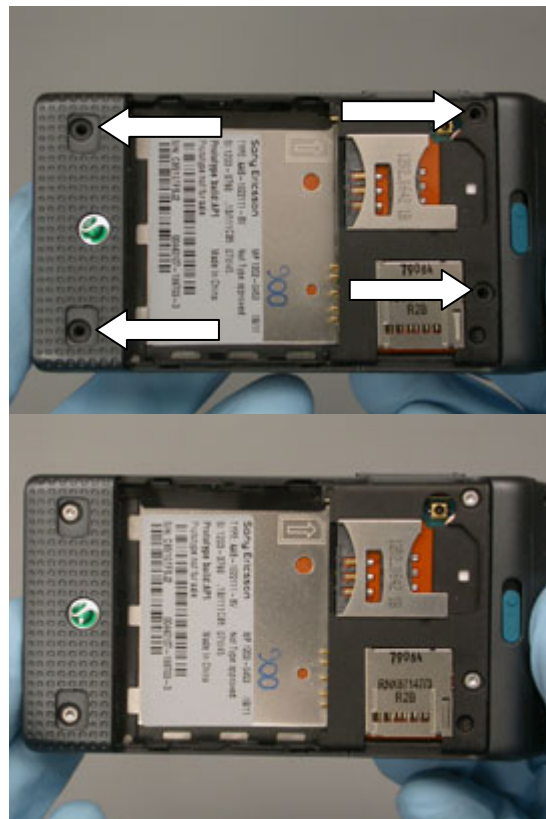


Snap the bottom half of the cover into place.



4.1.11 Lower Back Screw Installation

Insert the four screws in the locations shown. Tighten to 13 Ncm using a T5 bit.



4.1.12 Screw Cover Installation

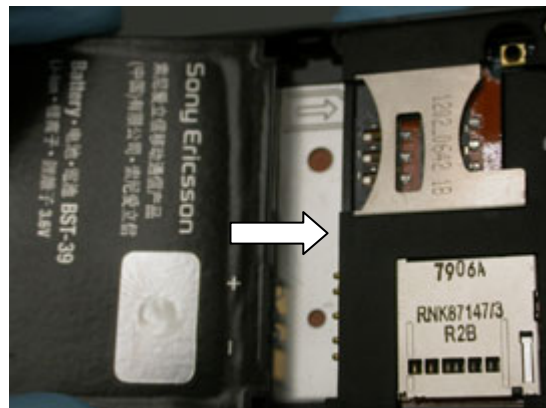
Place the screw covers in the screw cavities.

NOTE: DO NOT REUSE SCREW COVERS



4.1.13 Battery Installation

Insert the battery with the contacts aligned with the contact pins.

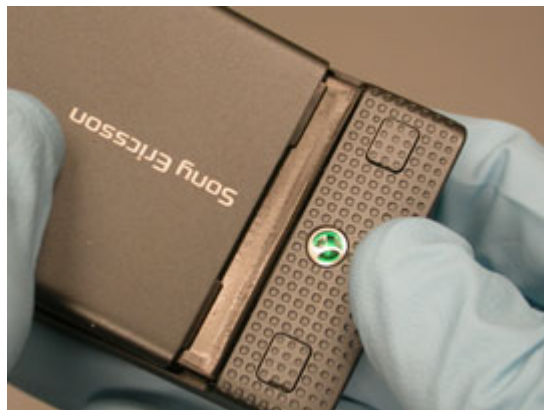


Push the battery into place.



4.1.14 Battery Cover Installation

Insert the tabs of the battery cover into the slots in the lower back cover.



Rotate the battery cover onto the phone and snap the battery cover into place.



5 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.



6 Revision History

Rev.	Date	Changes / Comments
1	February 26, 2008	Initial Release
2	April 14, 2008	Updated minor spelling and grammar errors
3	June 25, 2008	Protective plate tape added Coax cable conductive cushions added. Key locking Assembly cover added
4	July 02, 2008	Added brazil/vivo info
5	Okt 31, 2008	The Coax Cable Conductive Cushion Replacement section 3.4 is updated
6	2009-03-16	Note added to SIM/M2 flex