

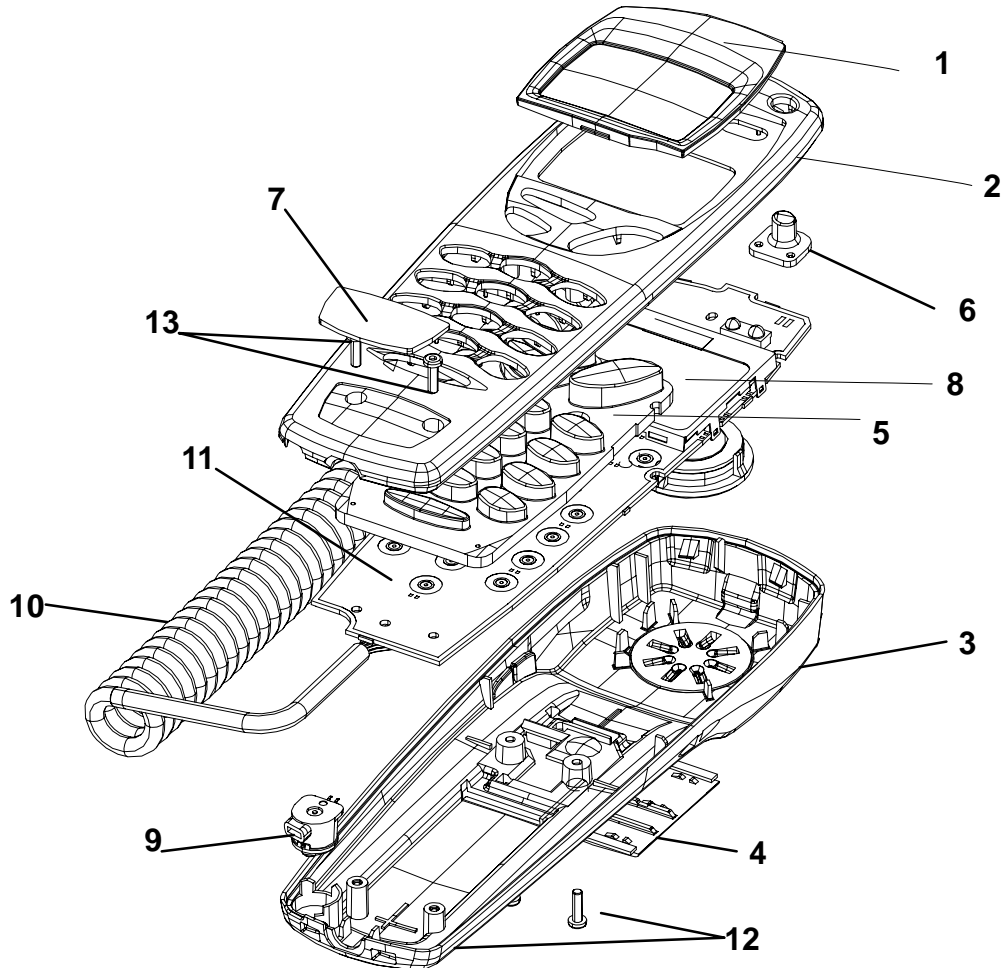
Programme's After Market Services NME-3 Series Transceivers

Mechanical Parts Assembly Instructions

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Handset – Mechanical Parts list



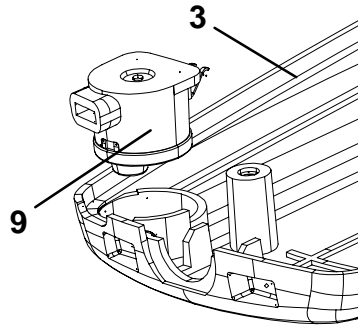
Item	Part Description	NMP – code
1	WINDOW	945 6568
2	A – COVER ASSY	9456610
3	B – COVER ASSY	9490099
4	SIM – DOOR ASSY	9490101
5	KEYMAT MODULE	979 4021
6	POWER KEY	979 0309
7	OEM LOGO (blank)	9430167
8	LCD MODULE	4850109
9	MIC BOOT ASSY	514 0115
10	CURLY CORD	978 0223
11	PCB ASSY	9854369
12	SCREW	629 0011
13	TYPE LABEL ROLL	937 0403

Handset – Assembly Instructions

NOTE: WEAR GLOVES DURING THE ENTIRE ASSEMBLY PROCESS

B – COVER SUB ASSEMBLY

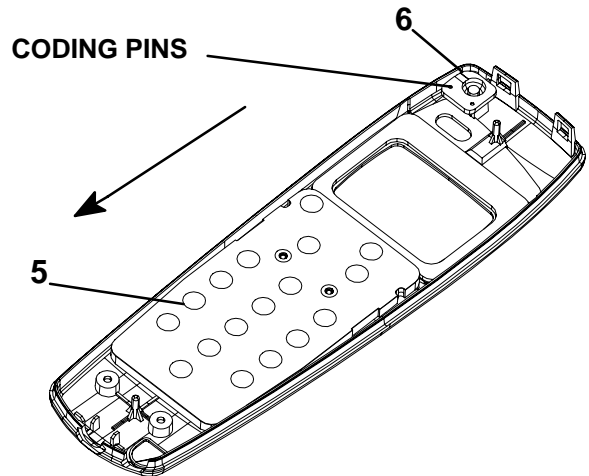
- B – cover (3) and A – cover to assembly jig
- Press mic. Boot assy (9) into B–cover (3)



NOTE: SPEAKER ASSY IS ULTRASONIC WELDED TO THE B-COVER

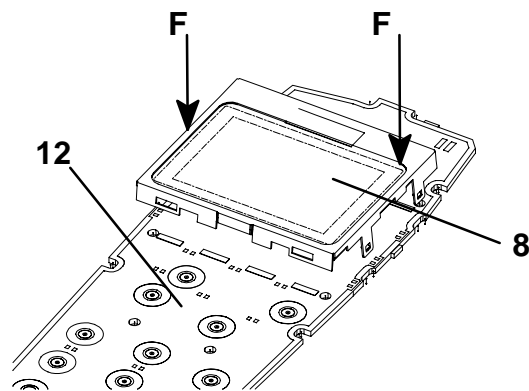
A – COVER PRE ASSEMBLY

- Power key (6) to A – cover (ensure, that both coding pins fit into the power key)
- Keymat (5) to A – cover (do not touch contact area)
- Clean contact pads of keymat module with compressed air in the direction of the arrow

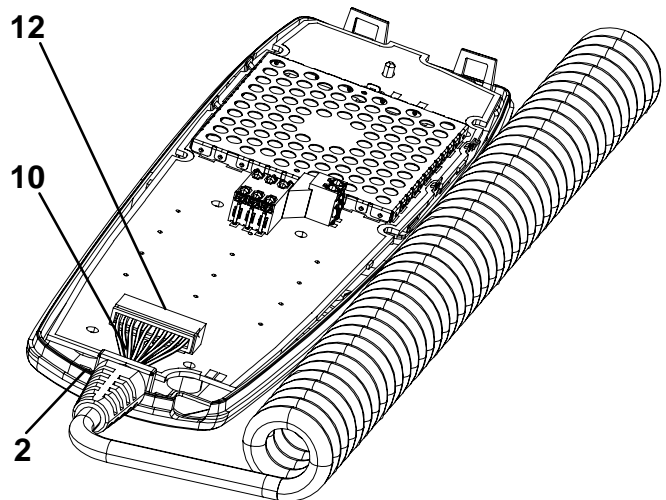


PCB SUB ASSEMBLY

- Check the LCD module version (Minna or Dude)
- Check that there is no rest at the PCB larger ca.0.2mm
- Fit LCD module (8) to the PCB assy (12)
- Check that all five LCD frame snappers fit accurately into the PCB

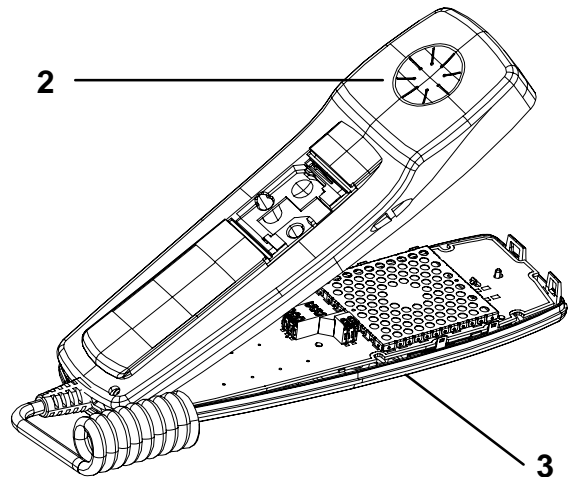


- The curly cord (10) plugs into the PCB assy. connector (12) – clamp it into place
- LCD protection foil off
- Clean PCB contact pads and LCD with compressed air
- PCB (12) to A – cover (2)
- Strain relief of curly cord (10) to A – cover, ensure it is fitted the right way
- The curly cord to the right side curls upwards
- Clean contact areas compressed air

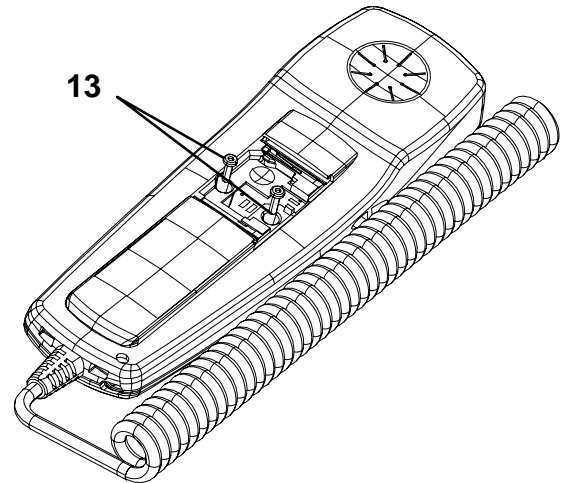


FINAL ASSEMBLY

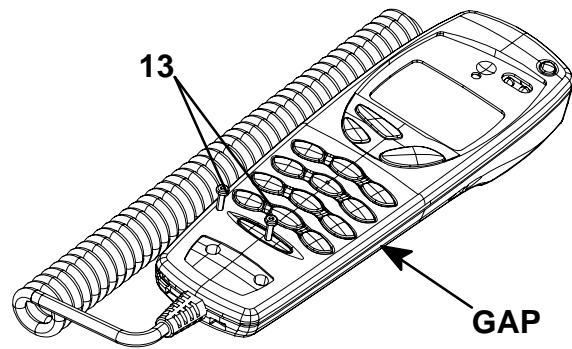
- Fit the bottom side of the B – cover (3) to the A – cover (2)
- Press B – cover to A – cover until it snaps home firmly.



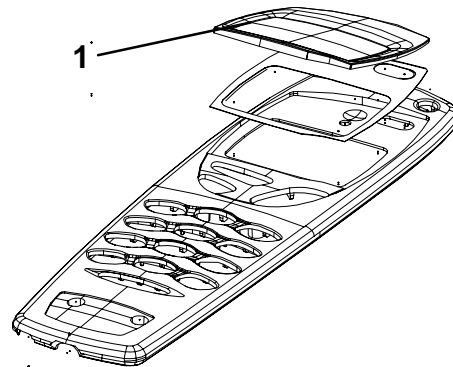
- 2 screws (13) through B – cover into A – cover domes (400 rpm, 30Ncm)



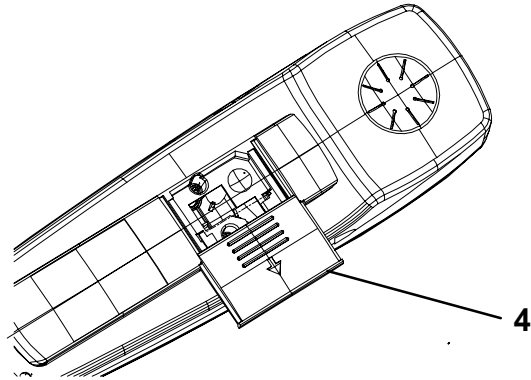
- Turn unit over to the keymat side
- 2 screws (13) trough A – cover into B – cover domes (400 rpm, 30Ncm)
- Verify that A – and B – cover are properly closed by checking that the gap between them is constant all around the Handset



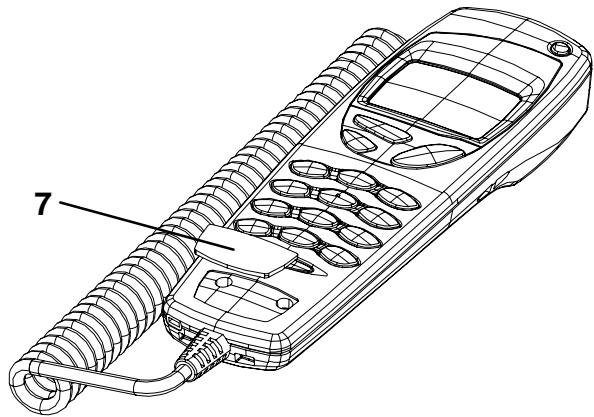
- Clean window with compressed air
- Pull window adhesive protection foil off the A – cover and ensure, that the adhesive foil does not lift at the finger lift side.
- Press window (1) to A – cover, top side first
- Press the window down till it clips home
- Press down the window to ensure fixation to B – cover
- Attach protection foil to mounted window



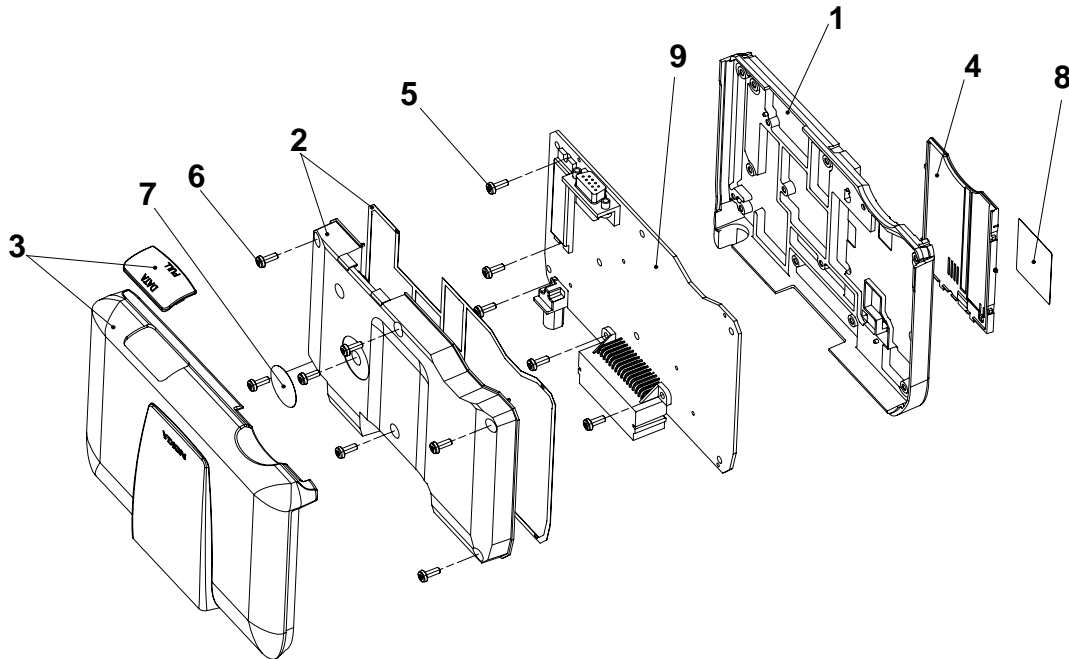
- Fit SIM – door (4) to the B – cover (till it firmly snap)
- Place type label to B – cover



- Pull OEM – logo (7) from the roll and stick it to the A – cover
- Ensure that the logo fits completely in the recess area
- Pack Handset into a plastic bag and bulk package

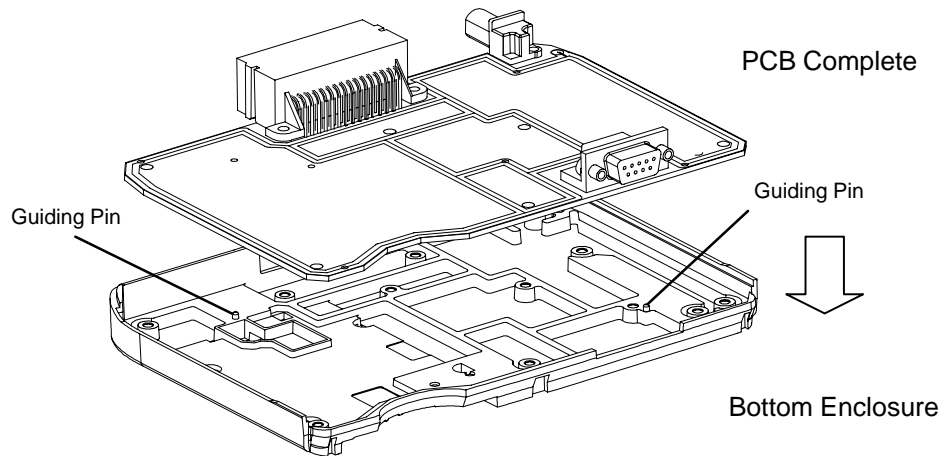


Radio Unit – Mechanical Parts List



Item	Part Description	NMP Code
1	BOTTOM ENCLOSURE	9537041
2	TOP SHIELD ASSY	9490057
3	TOP ENCLOSURE ASSY	9490056
4	SIM GUIDANCE	9450588
5	SCREWS M3x8 (5 off)	6290091
6	SCREWS M3x8 (7 off)	6290091
7	SEALING LABEL	9380933
8	NME-3 TYPE LABEL	9370402
9	GM8B RF/BASEBAND MODULE	0201346

Radio Unit – Assembly Instructions

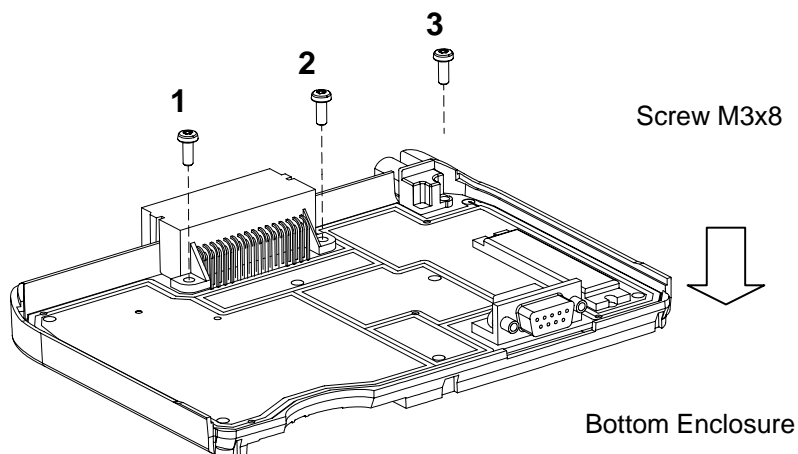


Level 0

Operation:
Mount PCB in Bottom Enclosure

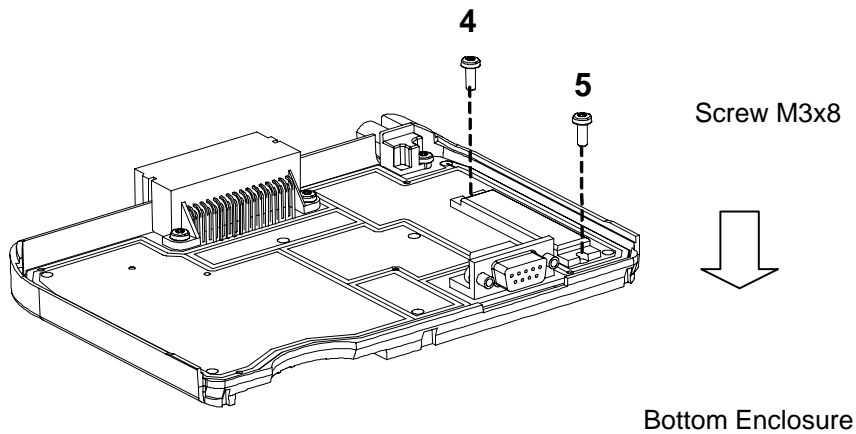
To check:

1. check that cutting rest is not bigger than 0.2mm
2. PCB positioned by guiding pins (press down until peak of guiding pin aligns upper surface of PCB)
3. Do not touch components



Level 1

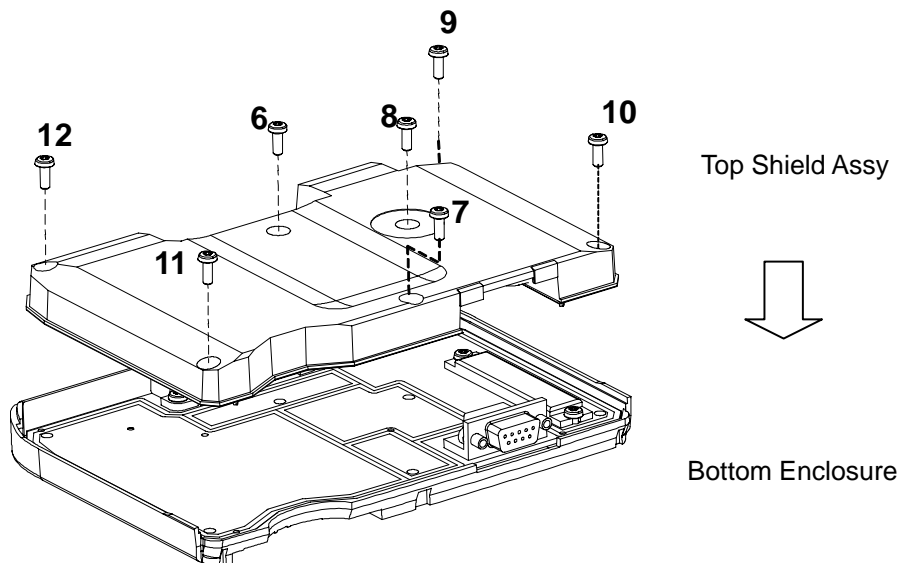
Operation:
Fasten PCB with with 3 screws in the numbered order : 1-3
(torque : 63 Ncm, speed 400-1200rpm)



Level 2

Operation:

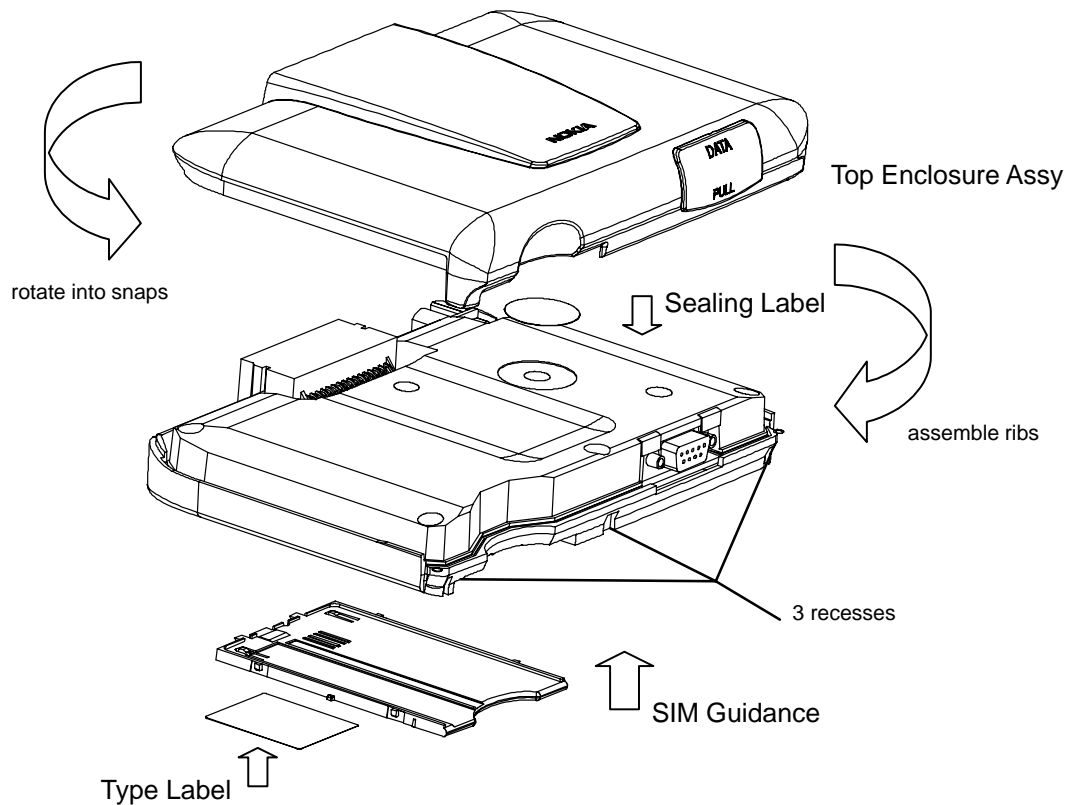
Fasten PCB and PA with 2 screws in the numbered order : 4+5
(torque : 63 Ncm; speed 400–1200 rpm)



Level 3

Operation:

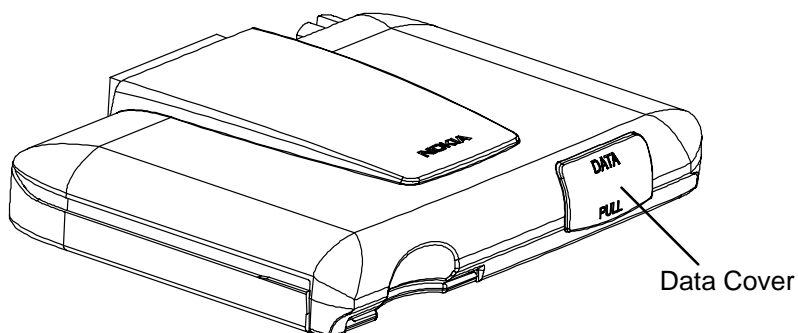
1. Mount Top Shield assembly
2. Fasten 7 screws in the numbered order: 6–12
3. (torque: 63 Ncm; speed 400–1200 rpm)
4. Clean inside with compression air
5. Check guiding pins
6. Check gasket pins



Level 4

Operation: (in Order)

1. Assemble SIM Guidance to Bottom Enclosure by jig.
2. Add the sealing label
3. Assembling Top Enclosure (assemble ribs on inside of Top Enclosure to the 3 recesses marked above. Rotate Top Enclosure until it snaps on the other side). Add the type label making sure that the label lies in the recess area.)

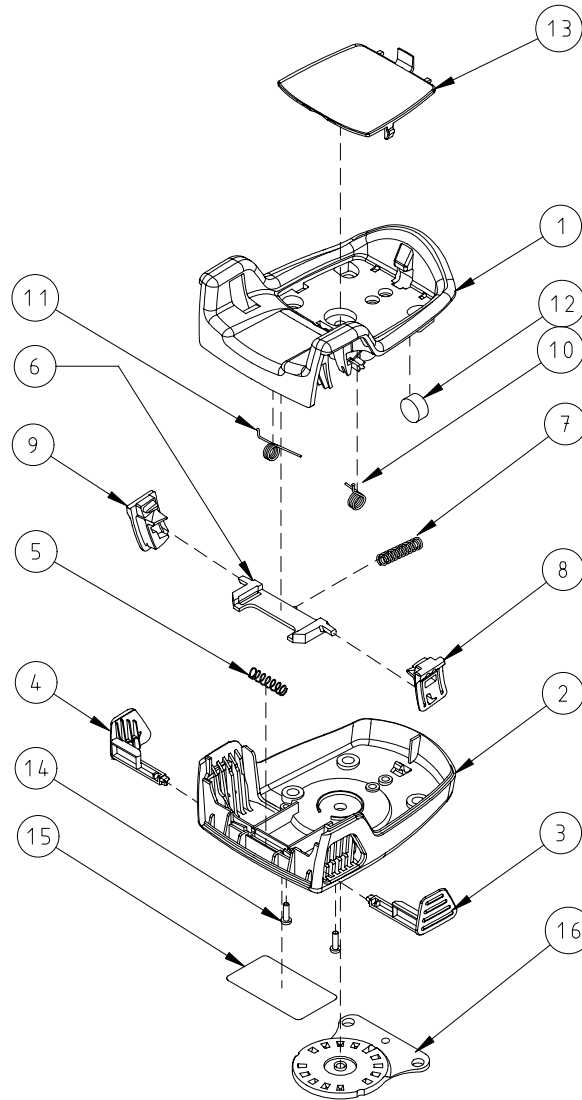


Level 5

To check:
existence of Data Cover

to put RU in plastic bag

Cradle –Mechanical Parts List



Item	Part Description	NMP Code
1	A COVER	9451519
2	B COVER	9451520
3	PUSH – RIGHT	9451504
4	PUSH – LEFT	9451522
5	SPRING PUSH	6400063
6	SLIDER	9460309
7	SPRING SLIDER	6400109
8	HOOK – RIGHT	9451501
9	HOOK – LEFT	9451521
10	SPRING HOOK – RIGHT	6400105
11	SPRING HOOK – LEFT	6400107
12	MAGNET	6490017
13	SCREW COVER	9451505
14	SCREW T6x8 (2 off)	6293005
15	LABEL	9380535
16	MOUNTING PLATE	9460310

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