



Working Instruction, Mechanical

Applicable for S500, W580

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1 Introduction

1.1 View of S500 and W580

S500



W580



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

- Coaxial Cable Removal Tool
- JCIS No. 0 Screw Bit



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 device
- 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 or a front opening tool may be used depending on the user’s preference.

2 Disassembly

2.1 Overview

Perform the disassembly in the following order:

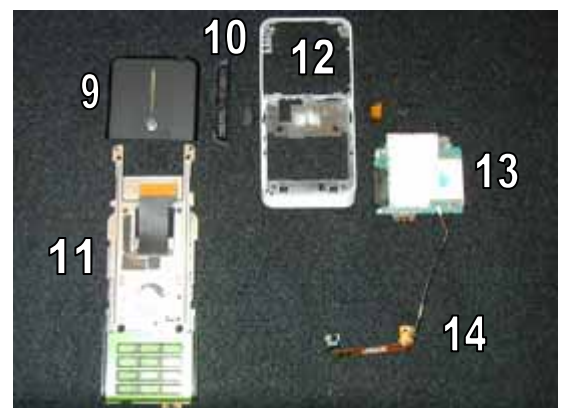
Upper Half of Phone

- Remove Battery Cover (1)
- Remove Battery (2)
- Remove Label (3)
- Remove Front Cover (4)
- Remove Camera Cover (6)
- Remove 6 Front Cover Screws (not shown)
- Separate Front Frame (7) and Rear Frame / Hinge Assembly (8)



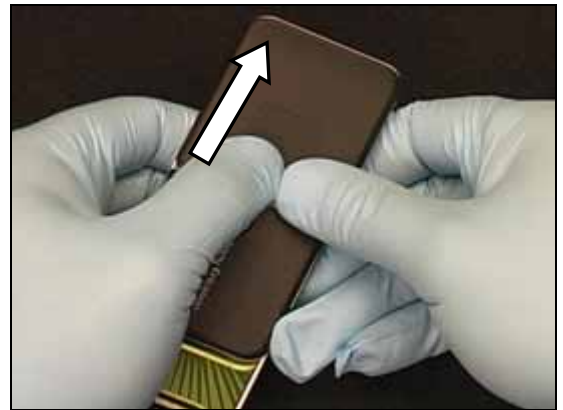
Lower Half of Phone

- Remove Upper Rear Cover (9)
- Remove 4 Rear Frame Screws (not shown)
- Remove Chin Cover (10)
- Remove Hinge Assembly (11) from Rear Frame (12)
- Remove PC Board/Antenna Assembly (13 & 14) from Rear Frame (12)
- Remove Antenna/cable Assembly (14) from PC Board (13)



2.1.1 Battery Cover Removal

Use thumbs to push the battery cover down until it stops.



Lift the end of the battery cover to remove it.



2.1.2 Battery Removal

Use a finger to lift the battery up.



Pull the battery out of the battery cavity.



2.1.3 Label Removal

Apply hot air to soften the adhesive.

NOTE: THE USE OF HOT AIR IS OPTIONAL.

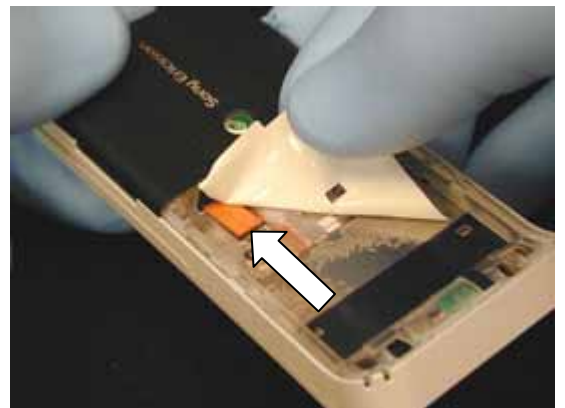


Use rounded tip tweezers to start the peeling up of the label.



Once the peeling of the label is started, use your fingers to remove the label.

NOTE: BE CAREFUL WHEN PULLING THE LABEL OFF THE FLEX CONNECTOR.



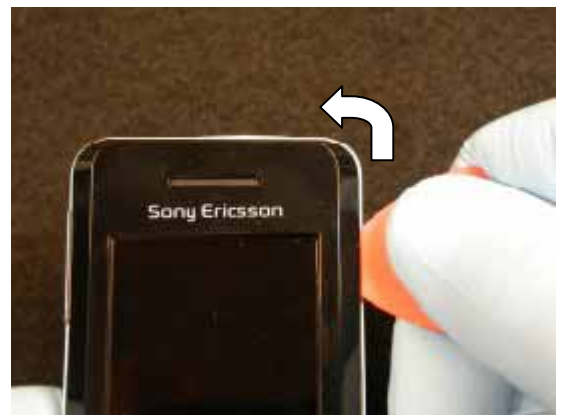
2.1.4 Front Cover Removal

Insert the plectrum in the front cover/ frame seam directly beside the upper right navigation key.

Slide the plectrum toward the top corner to release the right side latch.



Slide the plectrum around the top corner to release the upper right corner latch.



Continue around the top left corner to release the upper left corner latch.



Once the top of the volume key is reached remove the plectrum from the seam.

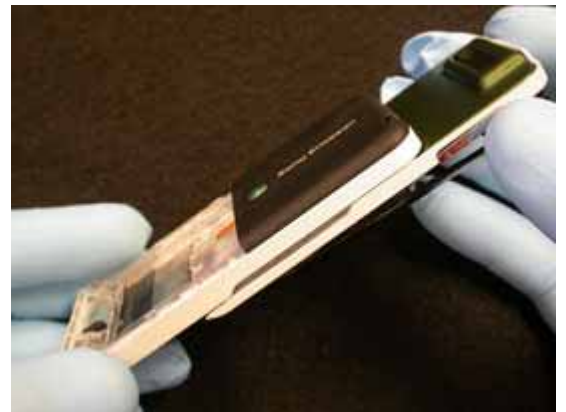


Insert the plectrum in the front cover/ frame seam directly beside the upper left navigation key.

Slide the plectrum toward the bottom of the volume key to release the left side latch.



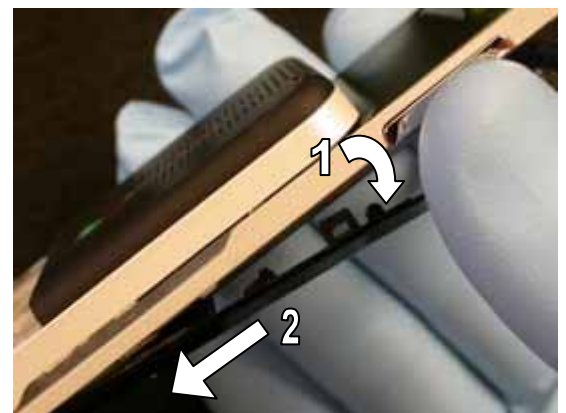
Slide the phone in the open position.



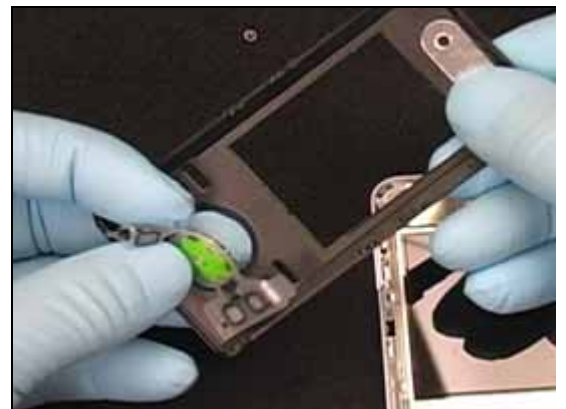
Rotate the upper end of the front cover away from the phone just enough that the side latches are clear of the frame

Then slide the cover down towards the keypad and off of the frame.

NOTE: DO NOT ROTATE THE FRONT COVER TOO FAR OR THE BOTTOM PEGS WILL BE DAMAGED.

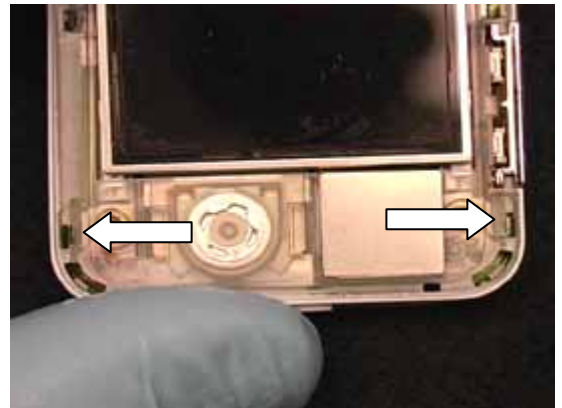


Separate the navigation keypad from the front cover.

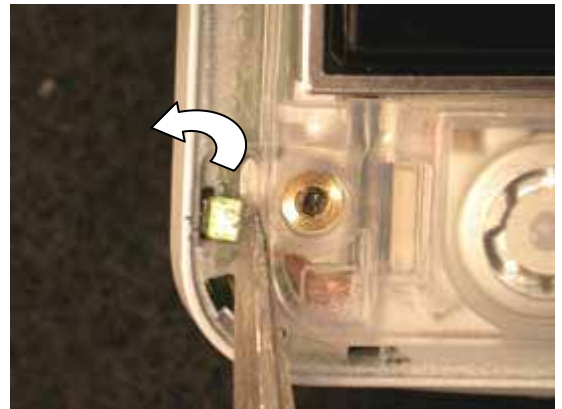


2.1.5 Camera Cover Removal

Locate the two tabs that hold the camera cover in place.



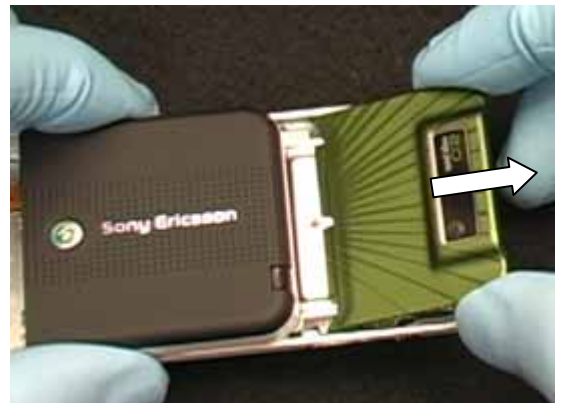
Use a rounded tipped tweezers to bend the metal tabs up.



Insert a plectrum between the camera cover and the frame in the location shown to pry the cover up.



Pull the lifted end of the camera cover as shown to remove the camera cover.



2.1.6 Front Cover Screw Removal (6 screws)

Slide the hinge into the open position, and then use a torque wrench and a JCIS-0 bit to remove the 4 visible screws.

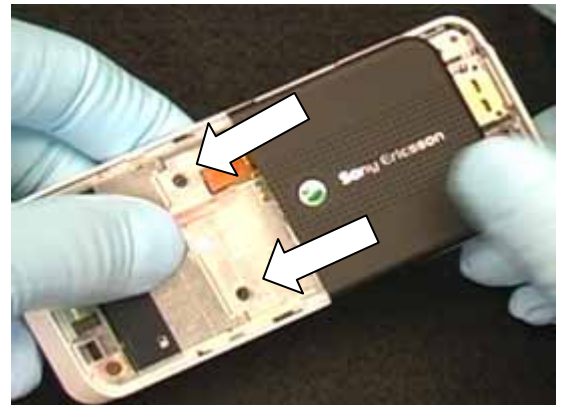
NOTE: DO NOT REUSE THE SCREWS.



Use the magnetism of the wrench to pull the bottom screws up through the hole in the hinge.

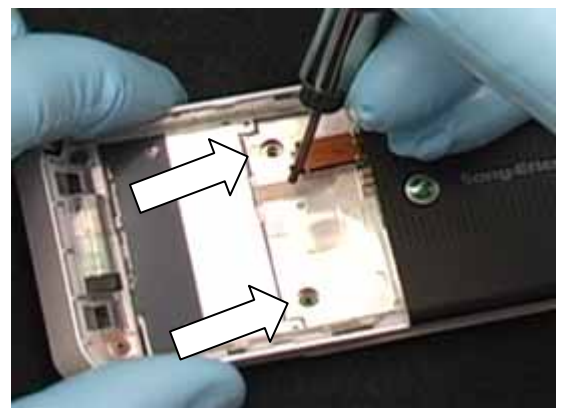


Slide the hinge partially closed until the remaining 2 screws are visible.



While holding the hinge in the partially closed position, remove the screws.

NOTE: DO NOT REUSE THE SCREWS.

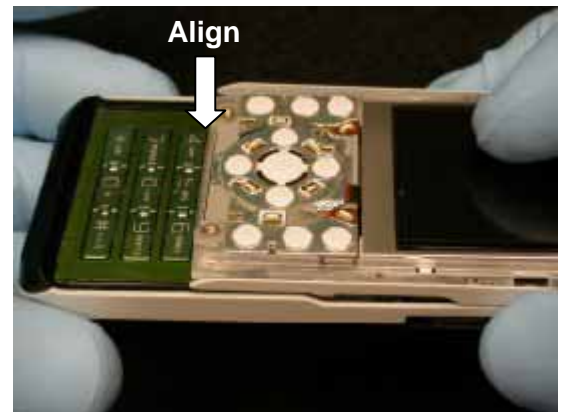


2.1.7 Front Frame Removal

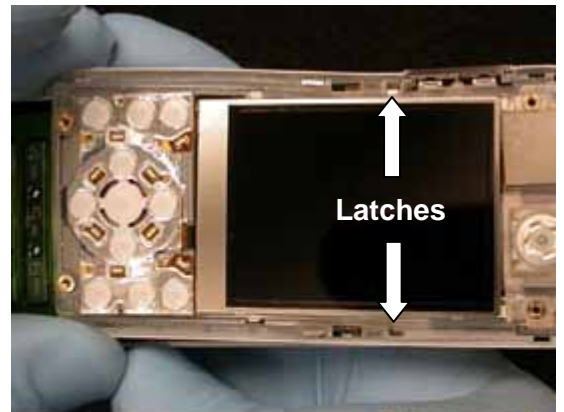
Slide the phone so that the bottom edge of the phone's upper half is aligned with the top edge of the 4, 5, & 6 row of keys.

NOTE: THE TWO HALVES OF THE PHONE WILL HAVE TO BE HELD IN PLACE TO MAINTAIN THIS ALIGNMENT.

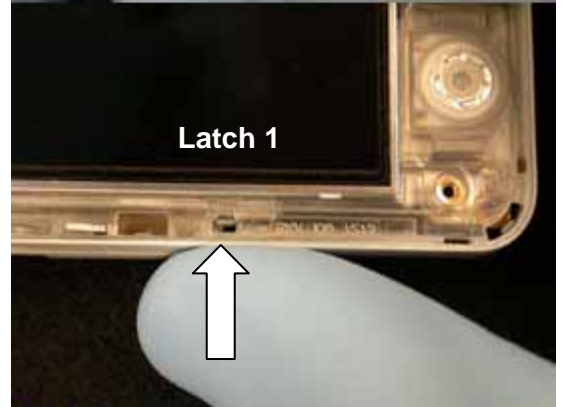
Lift the bottom edge of the phone's upper half approximately 10-15 mm.



With the bottom edge the phone's upper half lifted, locate the two side latches holding the front frame on the hinge.



One at a time, press inward on the side of the front frame at each of the latch locations to release the latches.



The front frame is now unlatched from the hinge.

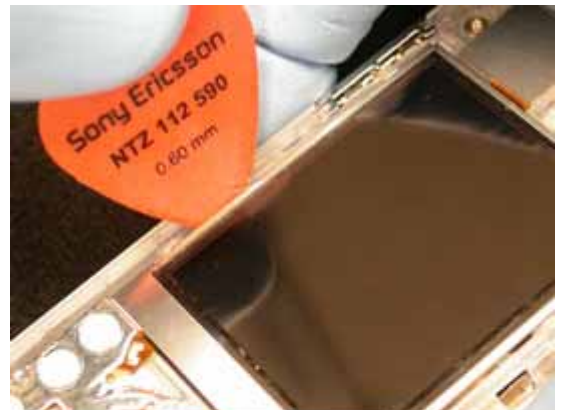
NOTE: THE LCD ASSEMBLY MUST BE DETTACHED BEFORE DISCONNECTING THE FLEX CONNECTION BETWEEN THE FRONT HALF OF THE PHONE AND THE HINGE ASSEMBLY TO REDUCE THE RISK OF FLEX FILM DAMAGE.



Lay the front of the phone loosely on top of the hinge



Insert the tip of the plectrum between the left side of the LCD assembly and the front frame.



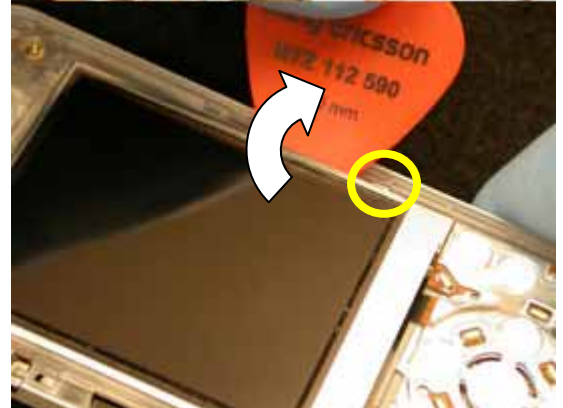
Rotate the plectrum away for the LCD to release the lower left side retention feature.



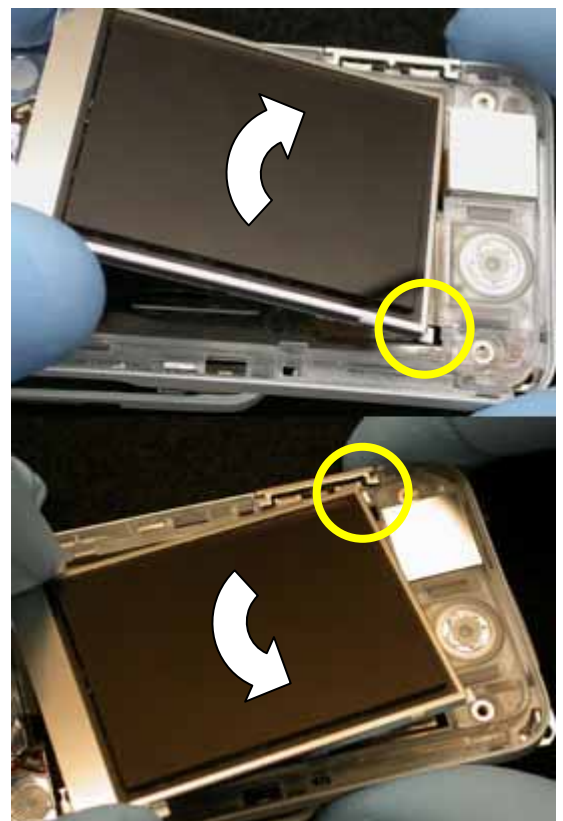
Insert the tip of the plectrum between the right side of the LCD and the front frame.



Rotate the plectrum away for the LCD to release the lower right side retention feature.

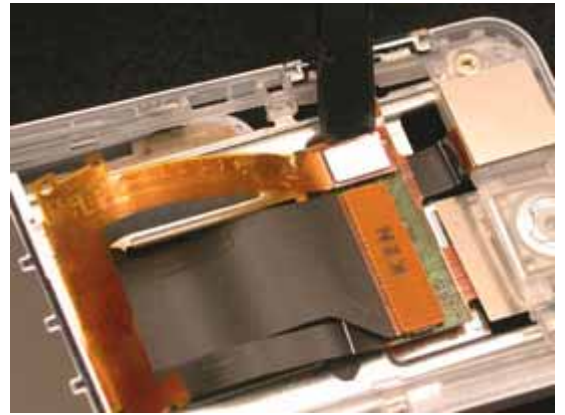


Free the upper two LCD retention features by wiggling to LCD to the left and right.



Once free, lift the LCD assembly out of the way and detach its flex connection using a pry tool.

Set the detached LCD assembly aside.

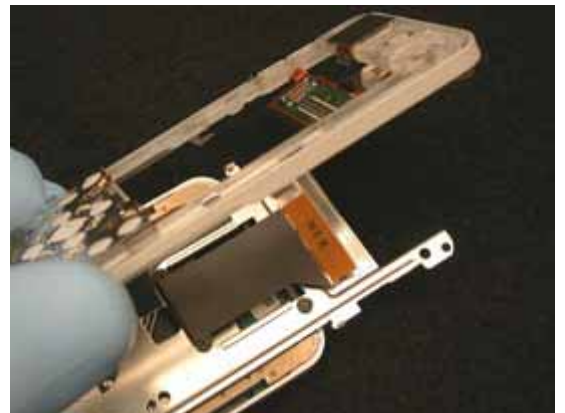


Using a pry tool, carefully disconnect the hinge flex from the bonzer flex.

NOTE: THERE ARE ADHESIVE STRIPS THAT HOLD THIS CONNECTION TOGETHER. BE CAREFUL NOT TO DAMAGE THE BONZER FLEX OR THE HINGE FLEX WHEN TRYING TO SEPARATE THE CONNECTION.



Once the hinge flex is disconnected, remove the front frame.



2.1.8 Upper Rear Cover Removal

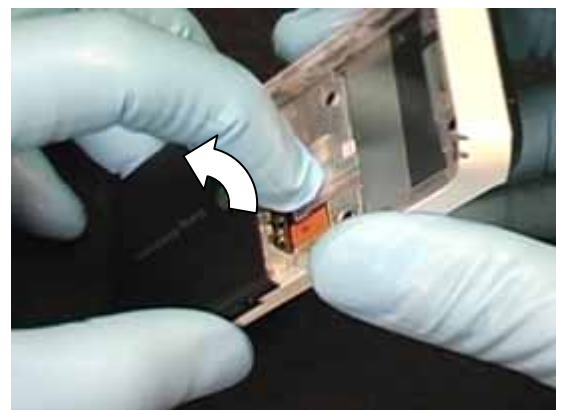
Insert a pry tool between the rear cover and the rear frame at the location shown.



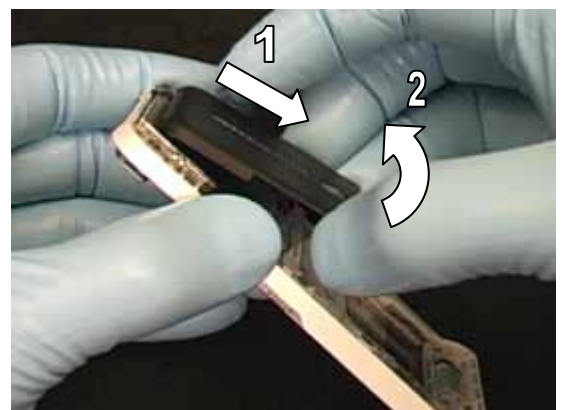
Push the pry tool into the seam and toward the left side of the cover so that latch holding the left corner of the cover releases.



Lift up on the rear cover to release the middle and right side latches.



Pull the rear cover down and rotate the lifted end of the cover away from the rear frame.



2.1.9 Rear Frame Screw Removal (4 screws)

Use a torque wrench and a JCIS-0 bit to remove the 4 screws.

NOTE: DO NOT REUSE THE SCREWS.

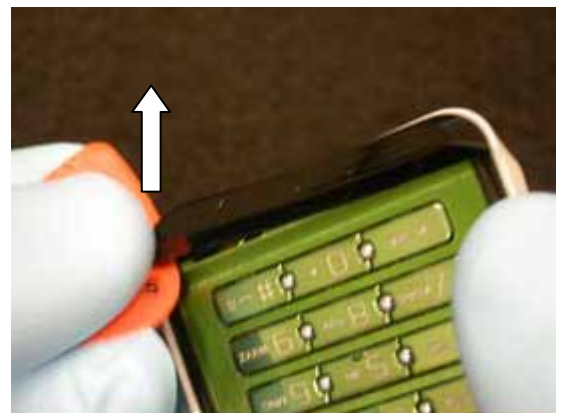


2.1.10 Chin Cover Removal

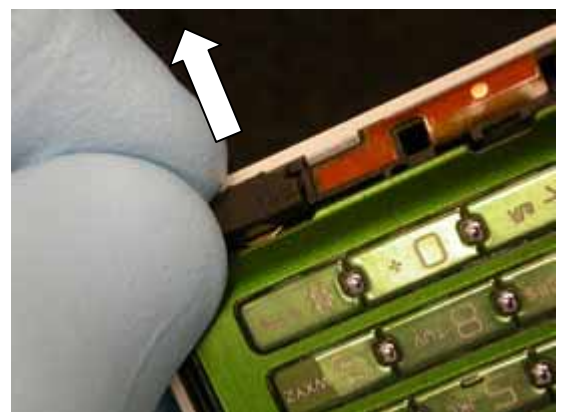
Insert the plectrum between the keypad and the left end of the chin cover.



Using the plectrum, lift up of the left end of the chin cover to get the chin cover to unsnap from the rear frame.

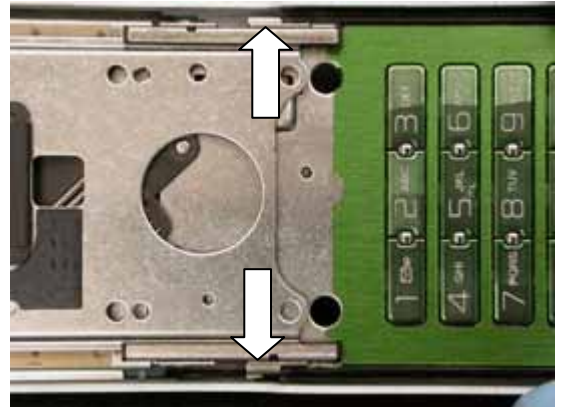


Remove the microphone gasket using your fingers.

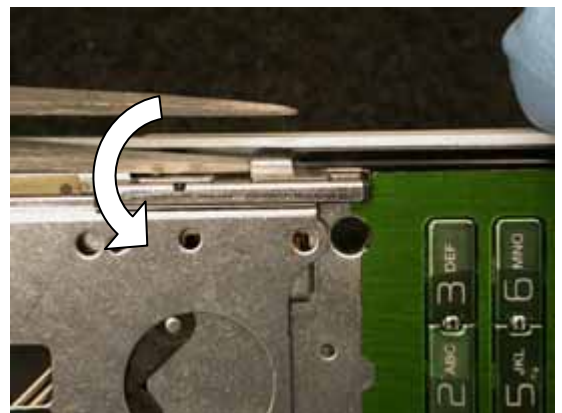


2.1.11 Hinge Assembly Removal from Rear Frame

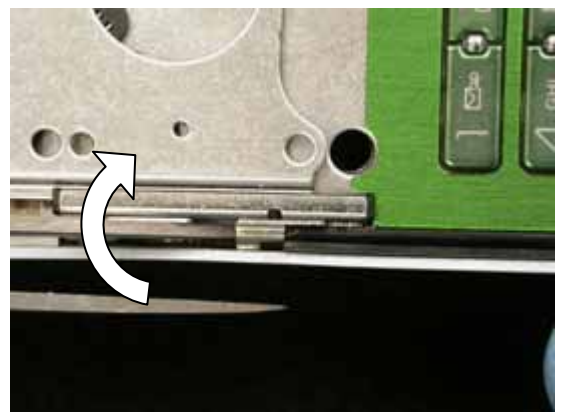
With the hinge open and the keypad up, locate the metal clips holding the hinge assembly on the rear frame.



Insert tweezers or a small screwdriver under one of the metal clips and twist toward the center of the phone to release the latch.



Insert tweezers or a small screwdriver under the other metal clip and twist toward the center of the phone to release the latch.

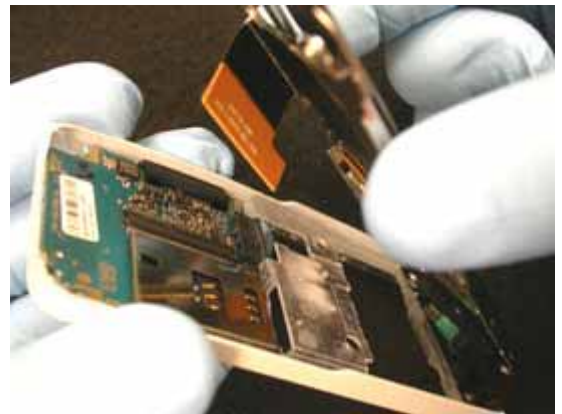


Lift the “non-keypad” end of the hinge assembly away from the rear frame.

Use a pry tool to unplug the hinge-to-board connector.



Lift the hinge assembly from the rear frame.



2.1.12 PC Board/Antenna assembly Removal from Rear Frame

Use tweezers to remove the power key.

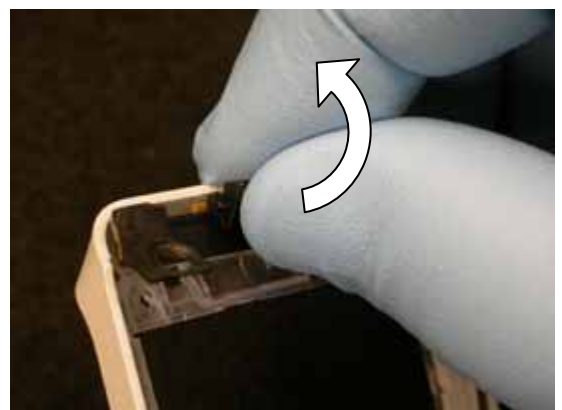


Use tweezers to remove the Bluetooth tape.



Grip the middle of the antenna assembly and rotate it away from the circuit board to free the antenna from the rear frame

Leave the antenna sitting on the rear frame over its cavity.



Use a pry tool to release the board from the latches beside the SIM connector.



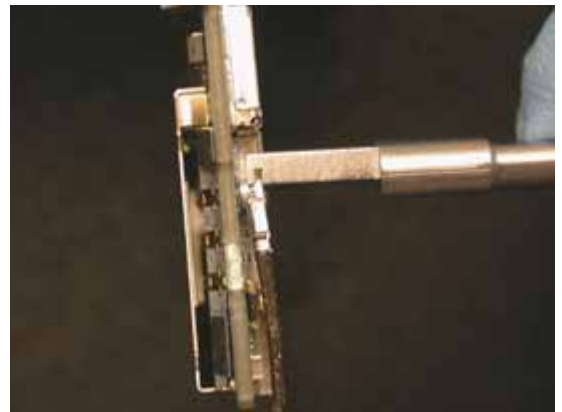
Lift the circuit board, coaxial cable, and antenna as one unit from the rear frame.



2.1.13 Antenna/Cable Assembly Removal from PC Board

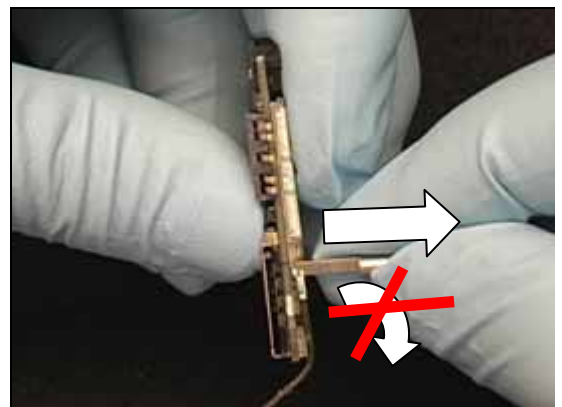
NOTE: USE THE REMOVAL TOOL OR THE BOARD CONNECTOR MAY BE DAMAGED.

Insert the slot of the tool onto the end of the coaxial cable connector.



Pull the connector directly away from the PC board.

NOTE: DO NOT ROTATE.



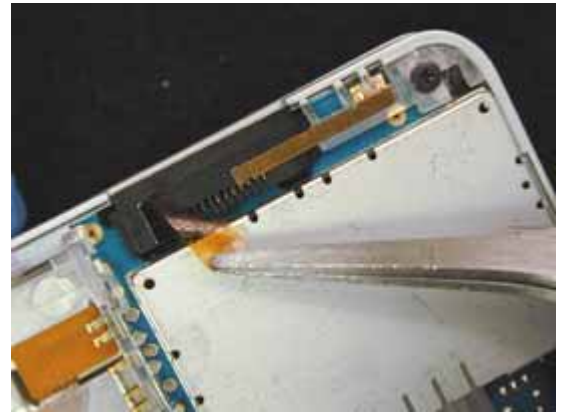
3 Part Replacement

3.1 Bluetooth Antenna

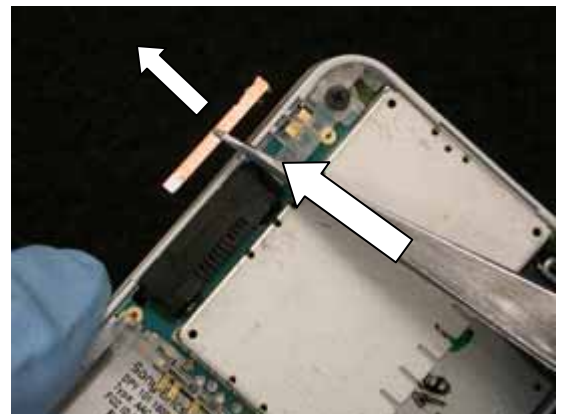
Remove the battery cover, battery, and upper rear cover as instructed in disassembly procedure 2.1.1, 2.1.2, and 2.1.8.

Removal

Remove the Bluetooth tape using tweezers.

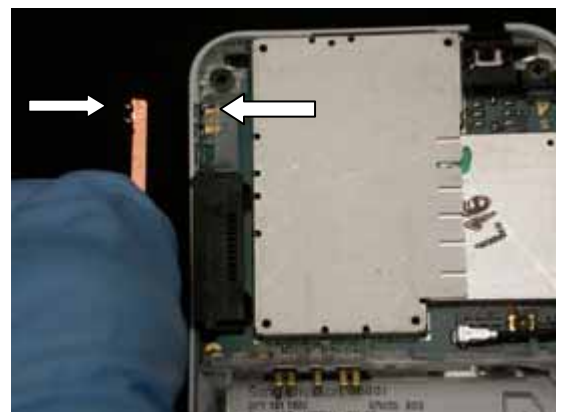


Remove the Bluetooth antenna from the rear frame by sliding it toward the edge of the frame.



Installation

Insert the bent pins of the antenna into the slots of the frame.

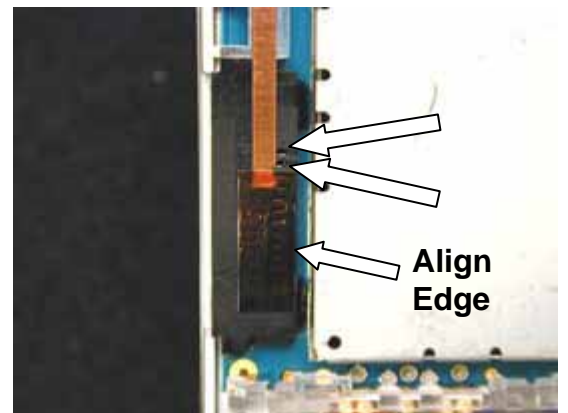


Using a nylon pointer, push the antenna into place.



Install the Bluetooth tape using tweezers. Align the tape with the inside edge of the system connector and leave two holes exposed.

Reinstall the upper rear cover, battery, and battery cover as instructed in reassembly procedure 4.1.5, 4.1.12, and 4.1.13.



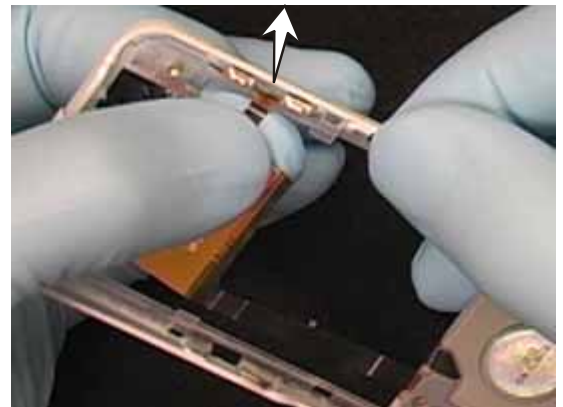
3.2 Bonzer Flex

Removal

Perform sections 2.1.1-2.1.7 of the disassembly procedure

Perform the removal portion of the Volume Key Replacement procedure

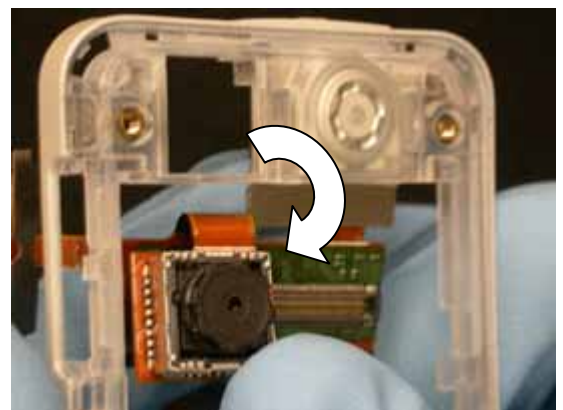
Pull the volume key switches out of the slot of the front frame.



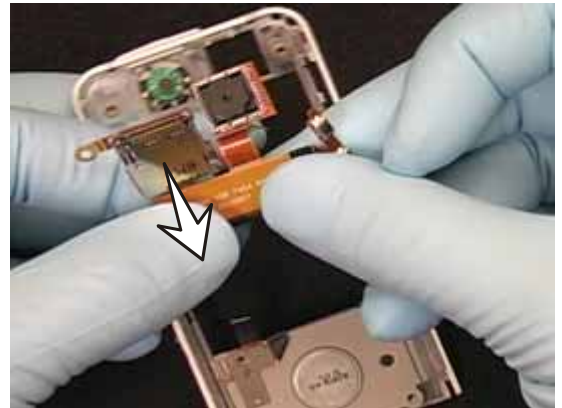
Push the camera out of its cavity.



Fold the camera portion of the flex in front of the LCD connector.



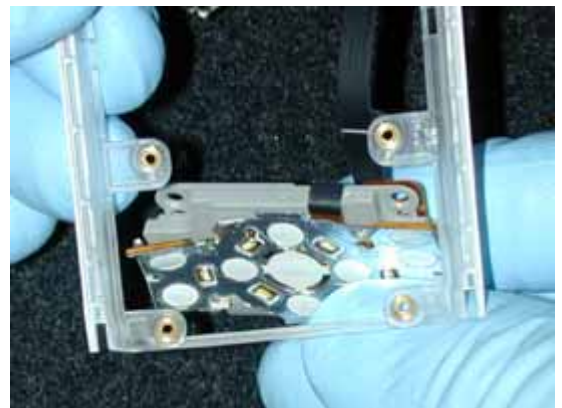
Lift the portion of the flex containing the memory stick holder from the front frame.



Fold the top corners of the dome foil a small amount off the speaker box.

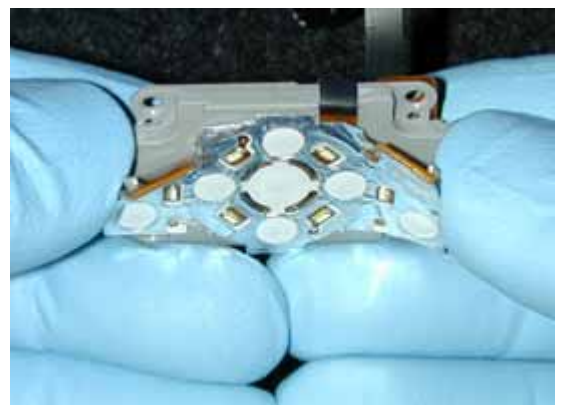


Push the bottom of the speaker box from the frame.

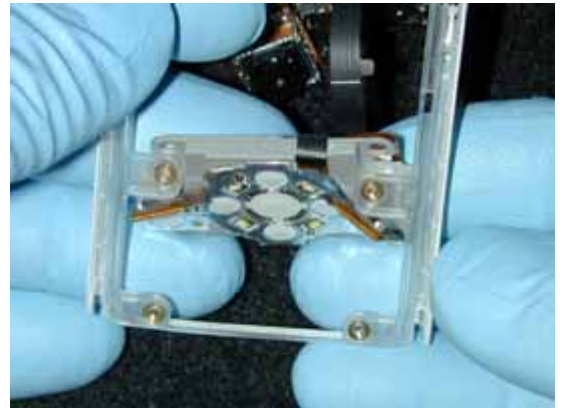


Installation

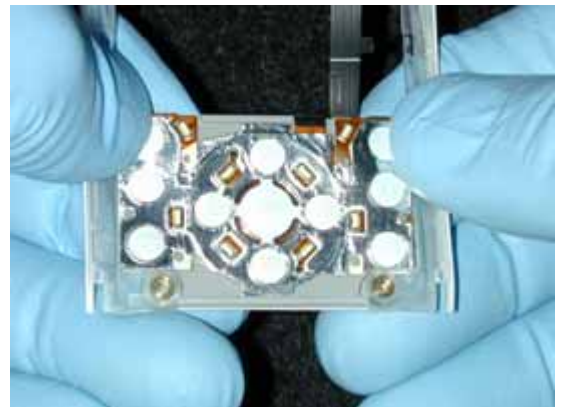
Fold the top corners of the dome foil a small amount off the speaker box.



Insert the top of the navigation keypad/ speaker box into the cavity on the frame with the keypad in front of the frame and the speaker box in back of the frame.



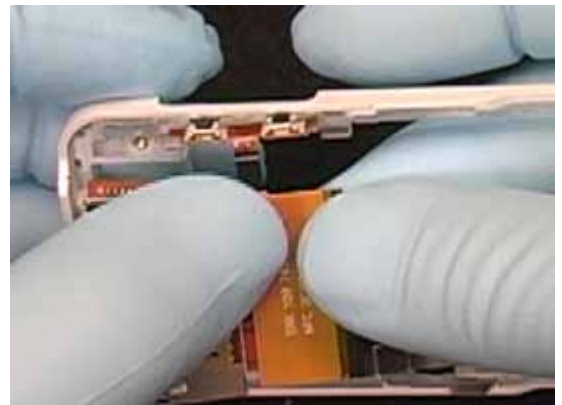
Fold the top corners of the navigation keypad down onto the frame.



Insert the camera into its cavity.



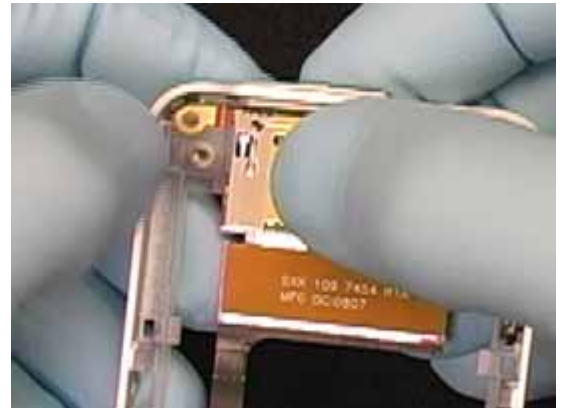
Insert the volume switches into their cavity.



Place the memory stick holder portion of the flex within its retaining features in the front frame.

Perform the installation portion of the Volume Key Replacement procedure

Perform the reassembly procedure starting at section 4.1.7

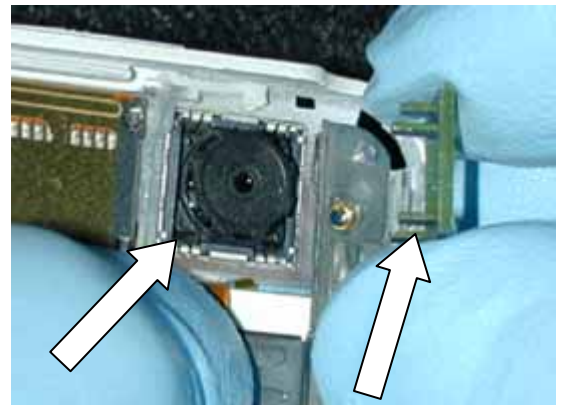


3.3 Camera

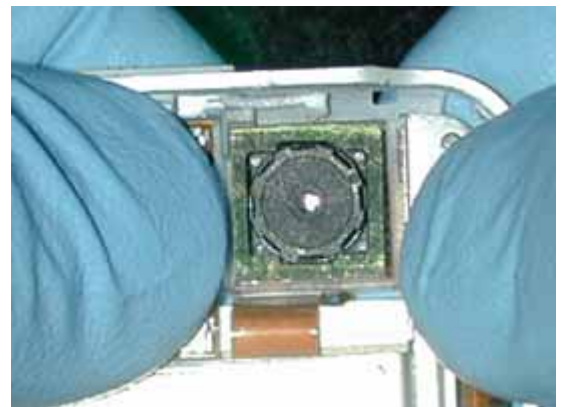
Removal

Remove the Front Cover and the Camera Cover as shown in Disassembly sections 2.1.4-2.1.5.

Align the pegs of the camera removal tool with the slots in the camera socket to determine the correct orientation.



Insert the pegs into the slots and press the tool completely onto the camera.

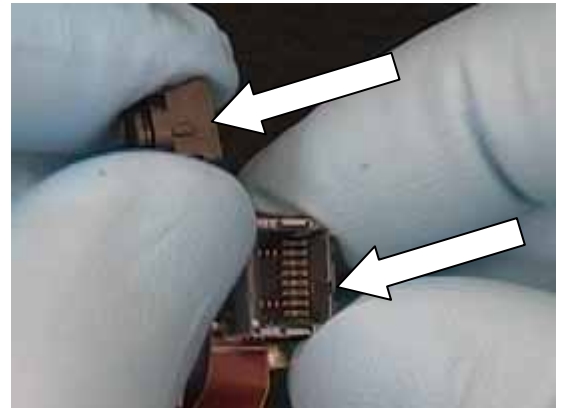


Remove the tool and the camera from the socket.



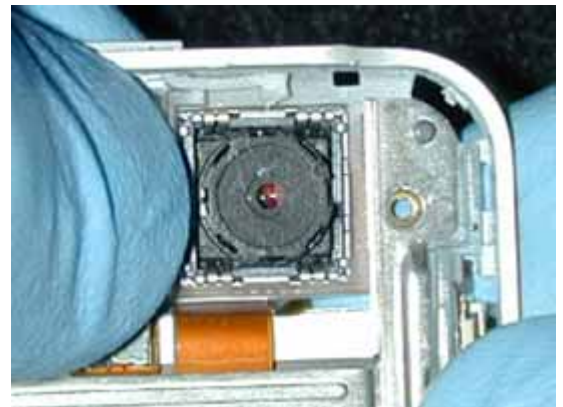
Installation

Align the tab on the camera with the slot of the socket.



Insert the camera into the socket and push it down.

Replace the Camera Cover and Front Cover as shown in Reassembly section 4.1.9 - 4.1.10.



3.4 Camera Cover

Removal

Perform sections 2.1.4 - 2.1.5 of the disassembly procedure.

Obtain a new Camera Cover.

Installation

Perform sections 4.1.9 - 4.1.10 of the reassembly procedure.

3.5 Chin Cover

Removal

Perform section 2.1.10 of the disassembly procedure.

Obtain a new Chin Cover.

Installation

Perform section 4.1.6 of the reassembly procedure.

3.6 Coaxial Cable and Antenna

Removal

Perform sections 2.1.4 - 2.1.13 of the disassembly procedure.

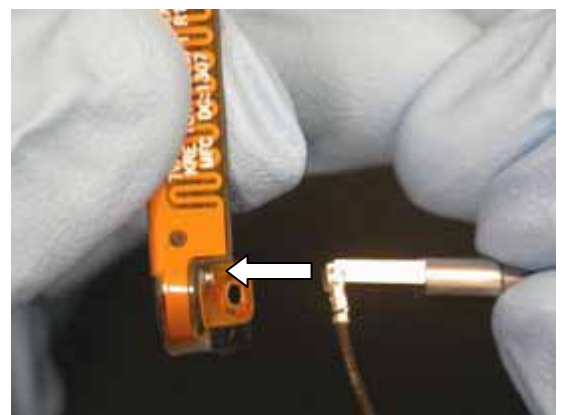
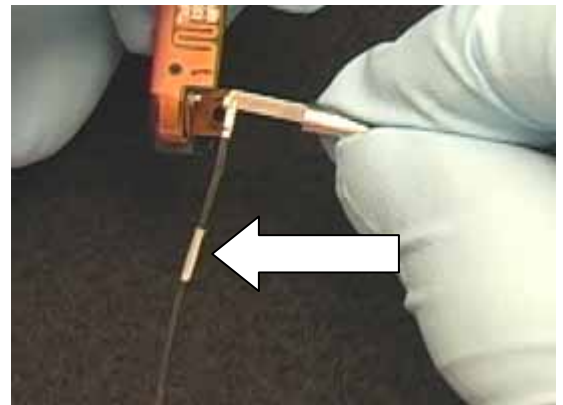
NOTE: IF THE COAXIAL CABLE CONNECTOR IS REMOVED FROM THE ANTENNA, THEN THE ANTENNA MUST BE REPLACED.

Installation

NOTE: CONNECT THE END OF THE COAXIAL CABLE TO THE ANTENNA THAT HAS THE METAL SLEEVE CLOSEST TO IT

Insert the connector into the slot of the tool, and then snap the connector onto the antenna.

Perform sections 4.1.1 – 4.1.13 of the reassembly procedure



3.7 Front Cover

Removal

Perform section 2.1.4 of the disassembly procedure.

Obtain a new Front Cover.

Installation

Perform section 4.1.10 of the reassembly procedure.

3.8 Front Frame

Removal

Perform sections 2.1.1 -2.1.7 of the disassembly procedure.

Perform the removal portion of the Volume Key Replacement procedure

Perform the removal portion of the Bonzer Flex Replacement procedure

Perform the removal portion of the Receiver and Gasket Replacement procedure

Obtain a new Front frame.

Installation

Perform the installation portion of the Receiver and Gasket Replacement procedure

Perform the installation portion of the Bonzer Flex Replacement procedure

Perform the installation portion of the Volume Key Replacement procedure

Perform the reassembly procedure starting at section 4.1.7



3.9 Hinge Assembly

Removal

Perform sections 2.1.1 -2.1.11 of the disassembly procedure

Obtain a new Hinge Assembly

Installation

Perform the installation portion of the Wear Strip Replacement procedure

Perform sections 4.1.3 -4.1.13 of the reassembly procedure

3.10 Keypad

Remove the Chin Cover and microphone gasket as instructed in section 2.1.10 of the disassembly procedure.

Removal

Use a plectrum to lift a corner of the keypad enough to grip onto the keypad.



Carefully peel the keypad off the hinge assembly.



Align the tabs and notches on the keypad with the tabs and holes indicated on the hinge assembly.



Apply pressure over the surface of the keypad so that a good bond to the hinge assembly occurs.

Reinstall the microphone gasket and chin cover as instructed in section 4.1.6 of the reassembly procedure.



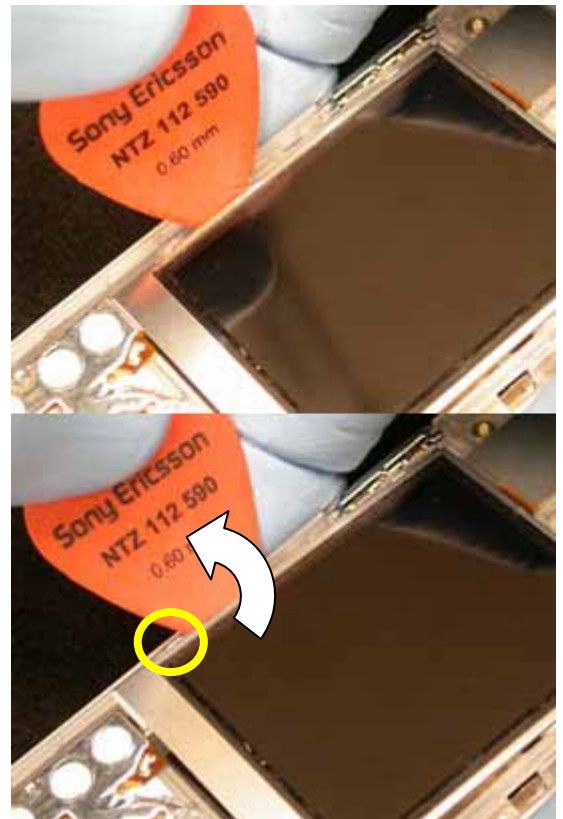
3.11 LCD Assembly

Removal

Remove the Front Cover as instructed in section 2.1.4 of the disassembly procedure.

Insert the tip of the plectrum between the left side of the LCD assembly and the front frame.

Rotate the plectrum away for the LCD to release the lower left side retention feature.



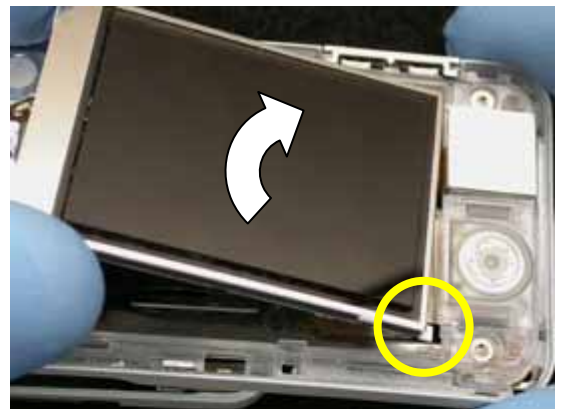
Insert the tip of the plectrum between the right side of the LCD and the front frame.



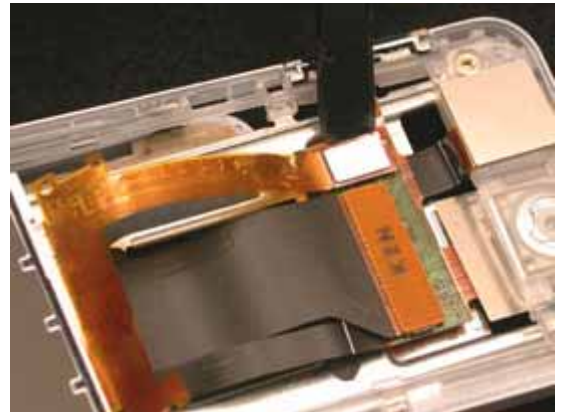
Rotate the plectrum away from the LCD to release the lower right side retention feature.



Free the upper two LCD retention features by wiggling the LCD to the left and right.

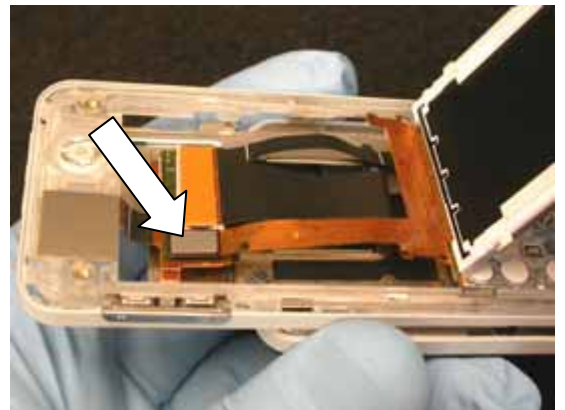


Once free, lift the LCD assembly out of the way and detach its flex connection using a pry tool.



Installation

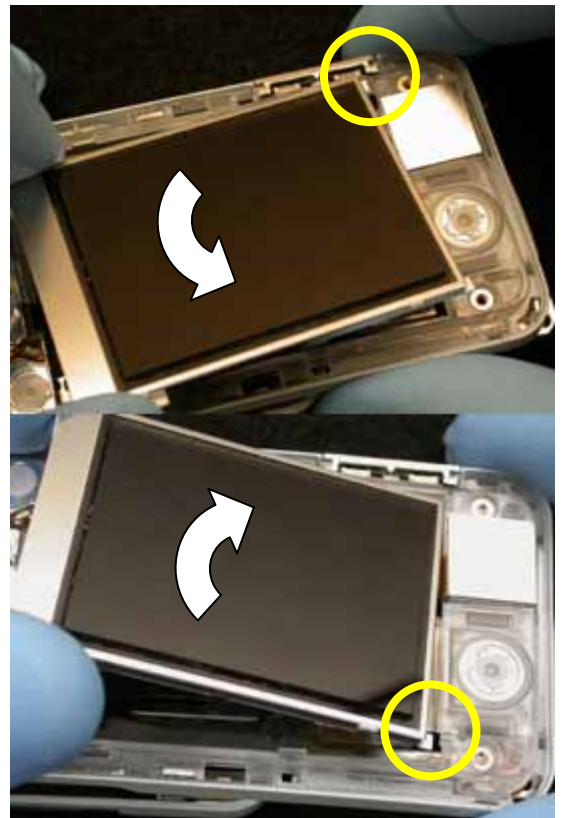
Orient the LCD as shown and plug the LCD's flex into the bonzer flex.



Fold the LCD so that it lays over its cavity.



Insert the upper two LCD retention features into their slots in the front frame by wiggling to LCD to the right and then the left.



Insert the tip of the plectrum between the left side of the LCD assembly and the front frame.

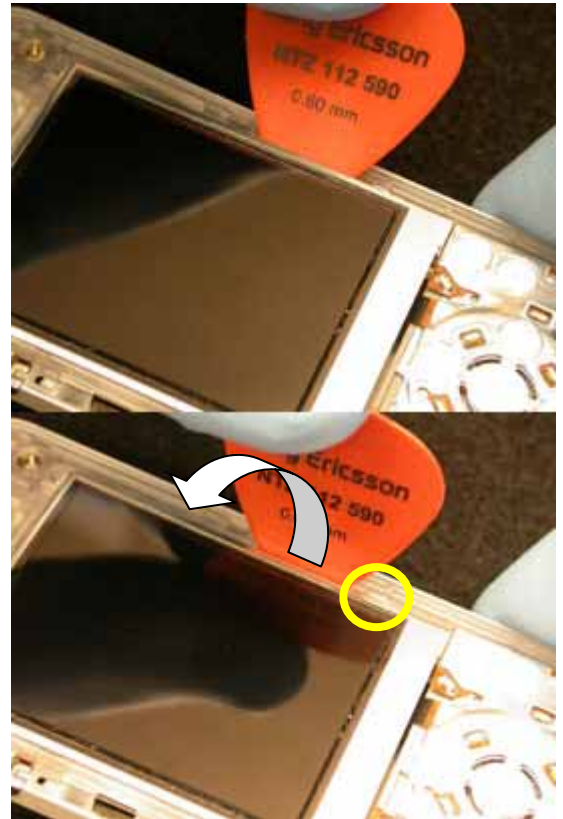


Rotate the plectrum towards the LCD to insert the lower left side retention feature into its slot in the front frame.

Insert the tip of the plectrum between the right side of the LCD and the front frame.

Rotate the plectrum towards the LCD to insert the lower right side retention feature into its slot in the front frame.

Reinstall the front cover as instructed in section 4.1.10 of the reassembly procedure.



3.12 Liquid Intrusion Indicator

Removal

Perform sections 2.1.1 -2.1.11 of the disassembly procedure

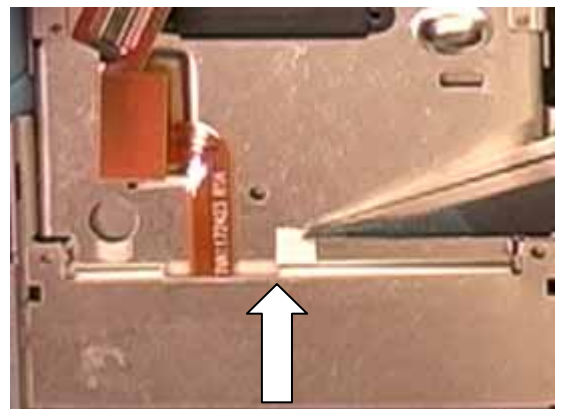
Remove the old liquid intrusion indicator



Installation

Align the bottom, left corner of the new indicator with the edge of the slot in the hinge.

Perform sections 4.1.3 -4.1.13 of the reassembly procedure



3.13 Main Keypad Flex

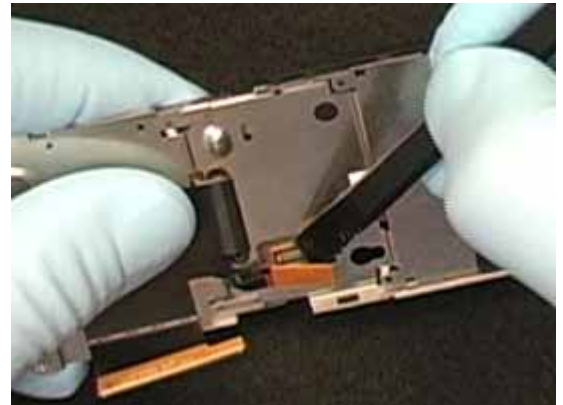
Removal

NOTE: THE MAIN KEYPAD FLEX CANNOT BE REUSED!

Perform sections 2.1.1 -2.1.11 of the disassembly procedure.

Perform the removal portion of the Keypad Replacement procedure

Use a pry tool to disconnect the flex connection.



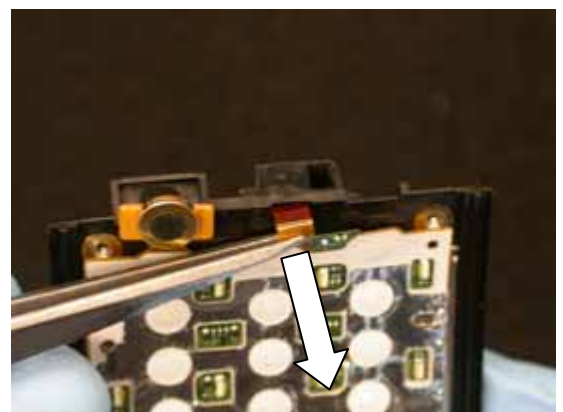
Use a pry tool to remove the vibrator.



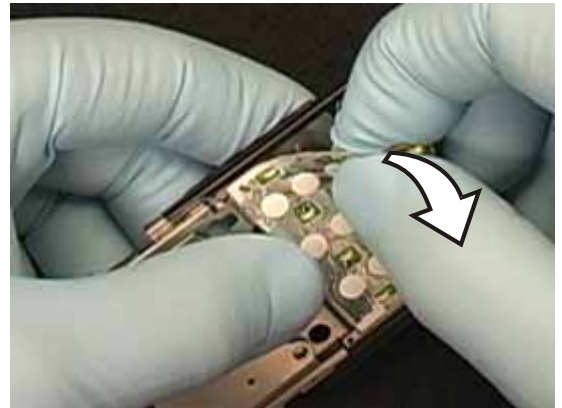
Lift the microphone flex off the hinge.



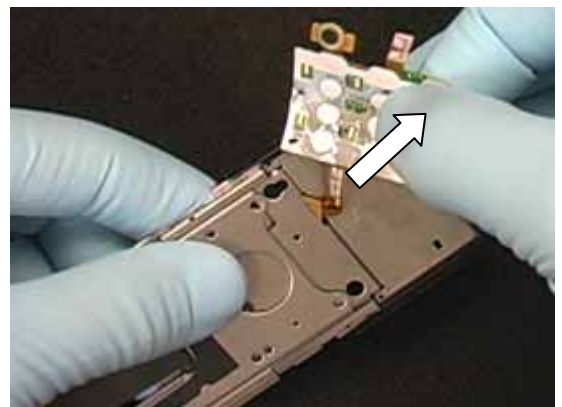
Pull the vibrator pads through the slot in the hinge.



Peel the dome foil off the hinge.



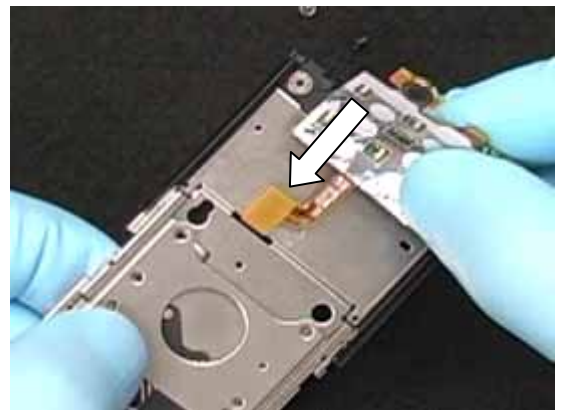
Pull the flex connector through the hole in the hinge.
Remove any adhesive residue from the hinge assembly.
Remove the microphone from the old keypad flex by performing the removal portion of the Microphone Replacement procedure



Installation

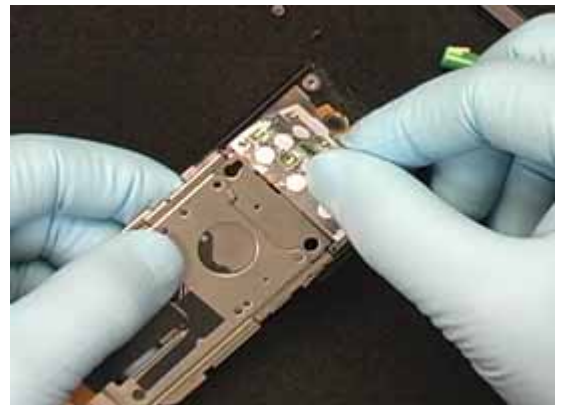
Install the microphone in the new keypad flex by performing the installation portion of the Microphone Replacement procedure

Push the flex connector through the hole in the hinge.

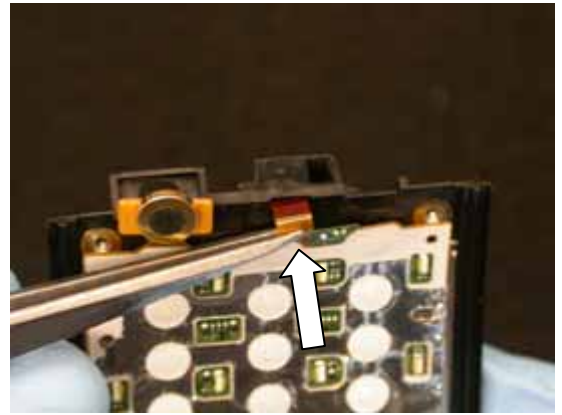


Using the features around the hinge assembly's keypad area for alignment, place the keypad flex on the hinge.

Apply pressure over the dome foil portion of the keypad flex so that a good bond is formed



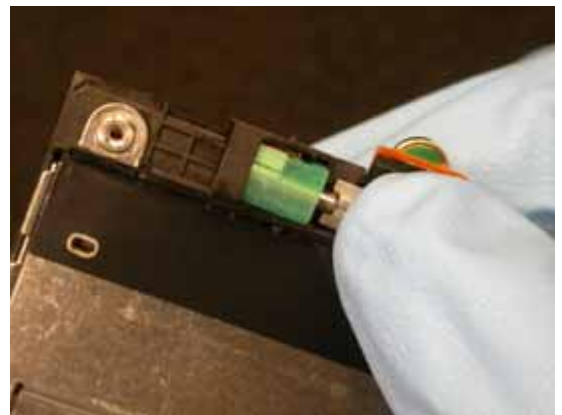
Insert the vibrator connector through the slot.



Orient the vibrator so that its spring fingers are toward the vibrator contact pads and insert the vibrator into its cavity.



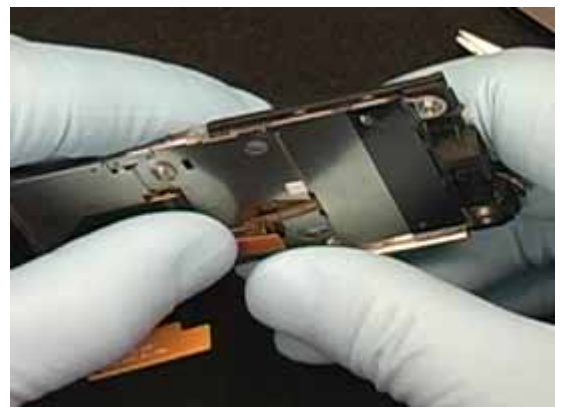
Push the vibrator down into place.



Plug the keypad flex to the hinge flex.

Perform sections 4.1.3 -4.1.13 of the reassembly procedure

Perform the installation portion of the Keypad Replacement procedure



3.14 Memory Stick Cover

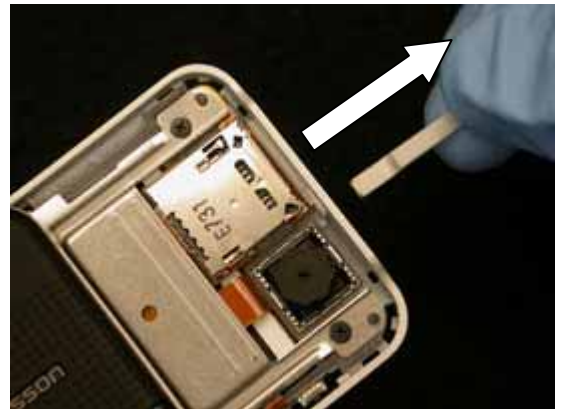
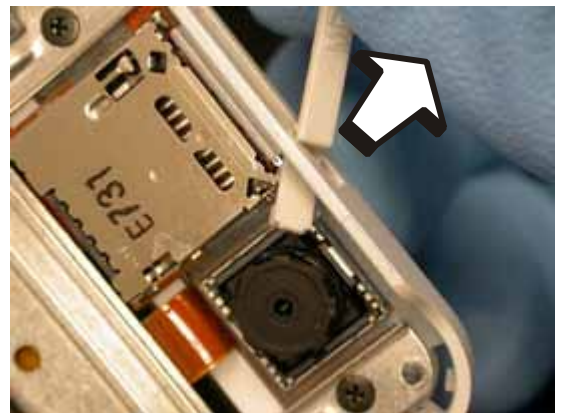
Removal

Remove the front cover and camera cover as shown in sections 2.1.4 - 2.1.5 of the Disassembly procedure.

Pull the memory stick cover out of its cavity.

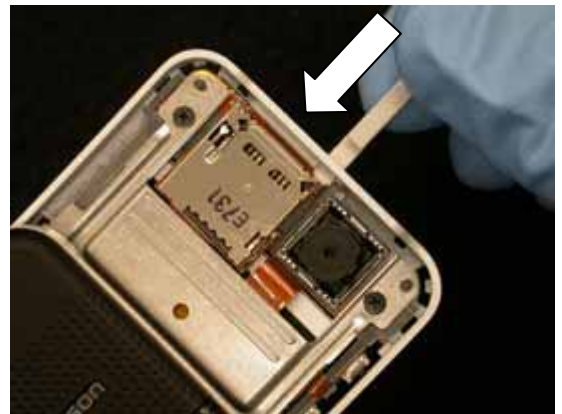
Rotate the memory stick cover down to free the inside latch from the peg on the frame.

Pull the cover out of the hole.

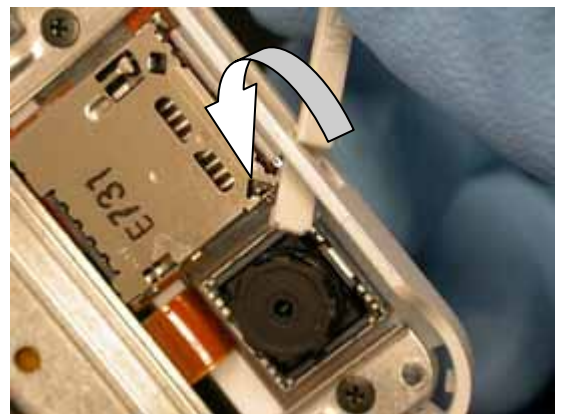


Installation

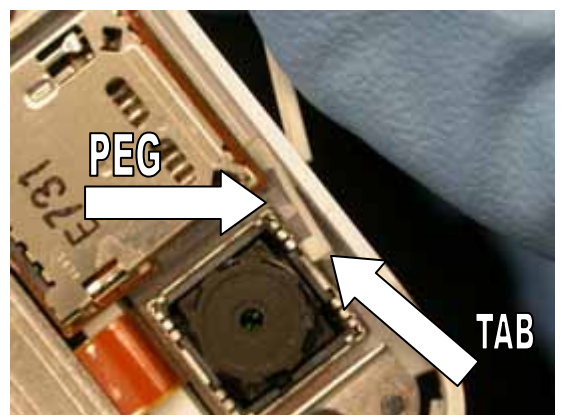
Insert the tabbed end of the cover through the hole.



Twist the cover and push the tab down behind the peg on the carrier.



Make sure the tab is behind the peg.



Push the cover into its cavity.

Replace the Camera Cover and Front Cover as in 4.1.9-4.1.10 of the reassembly procedure.



3.15 Microphone

Removal

Remove the Chin Cover and Microphone Gasket as shown in section 2.1.10 of the Disassembly procedure.

Perform the removal portion of the Keypad Replacement procedure

Insert a plectrum between the microphone and the flex.

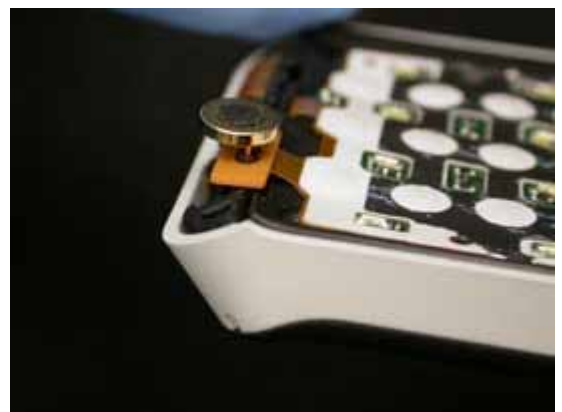
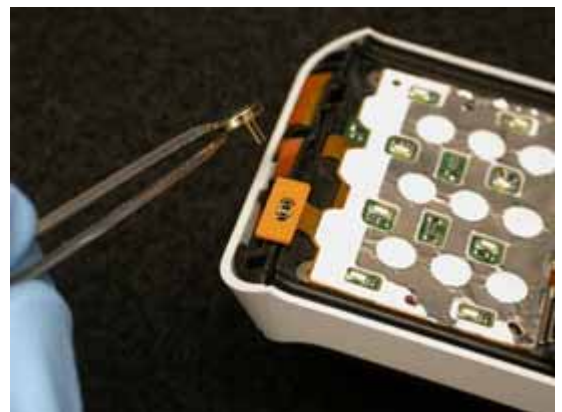
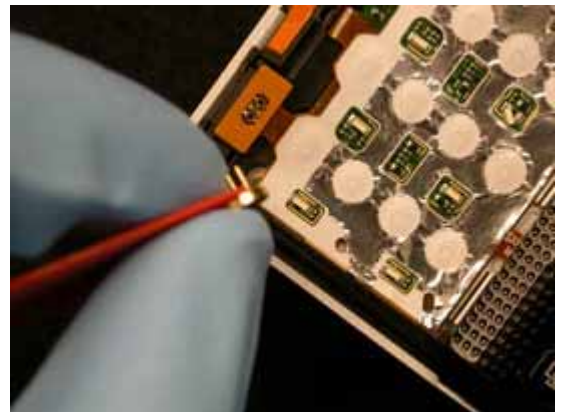
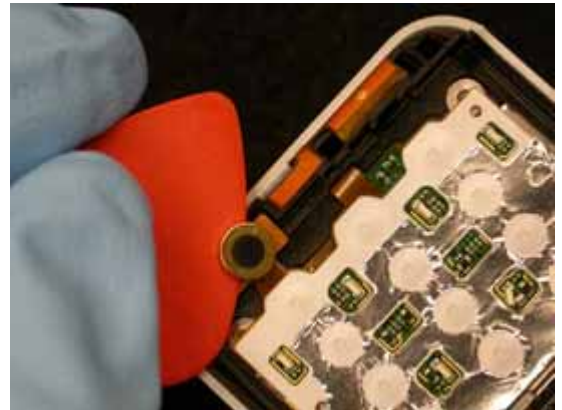
Hold the flex with one finger while working the microphone pins out of the holes.

NOTE: LIMIT THE AMOUNT OF STRESS ON THE KEYPAD FLEX WHEN REMOVING THE MICROPHONE.

Installation

Orient the microphone so the pins are toward the phone and the side of the microphone that its contact pins are closest too is toward the keypad dome foil.

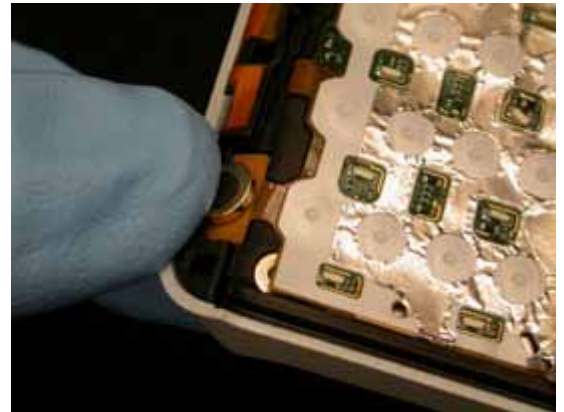
Insert the pins into the holes.



Push the microphone down completely.

Perform section 4.1.6 of the reassembly procedure

Perform the installation portion of the Keypad Replacement procedure



3.16 Microphone Gasket

Removal

Remove the chin cover and microphone gasket as instructed in disassembly procedure 2.1.10.

Installation

Install the microphone gasket and the chin cover as instructed in reassembly procedure 4.1.6.

3.17 Navigation Keypad

Removal

Remove the battery cover, battery, and front cover as instructed in disassembly procedure 2.1.1, 2.1.2, and 2.1.4.

Installation

Reinstall the front cover, battery, and battery cover as instructed in reassembly procedure 4.1.10, 4.1.12, and 4.1.13

3.18 Power Key

Removal

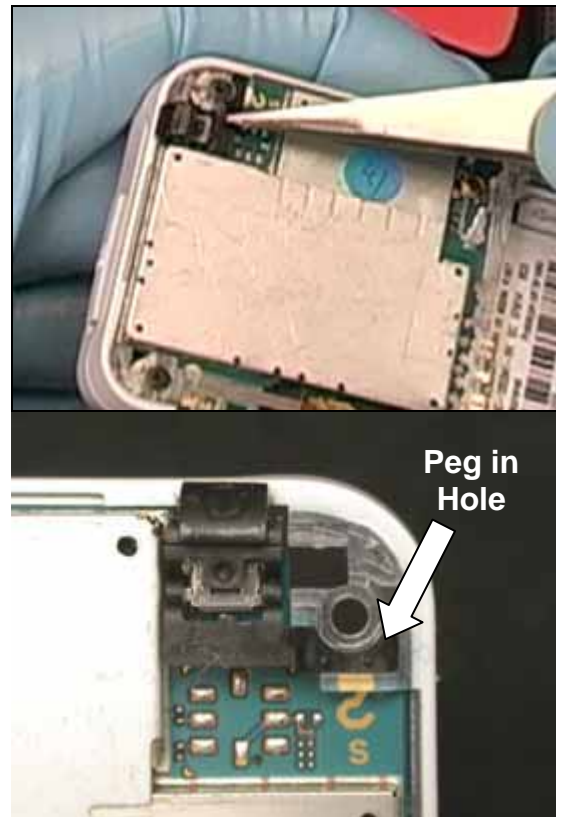
Remove the battery cover, battery, and upper rear cover as instructed in disassembly procedure 2.1.1, 2.1.2, and 2.1.8.

Using tweezers, remove the power key.

Installation

Insert the peg of the power key into the hole on the rear frame and press power key into place.

Reinstall the upper rear cover, battery, and battery cover as instructed in reassembly procedure 4.1.5, 4.1.12, and 4.1.13.



3.19 Rear Frame / Pad

Removal

Perform sections 2.1.1-2.1.12 of the disassembly procedure

Installation

NOTE: WHEN REPLACING THE REAR FRAME, BE SURE TO INSTALL A COAXIAL CABLE GROUND PAD IN THE COAXIAL CABLE SLOT.

Using tweezers, align the end of the coaxial cable ground pad with the end of the plastic rail in the frame as shown.

Press the coaxial cable ground pad into the cable slot.

Perform the reassembly procedure starting at section 4.1.2



3.20 Receiver and Gasket

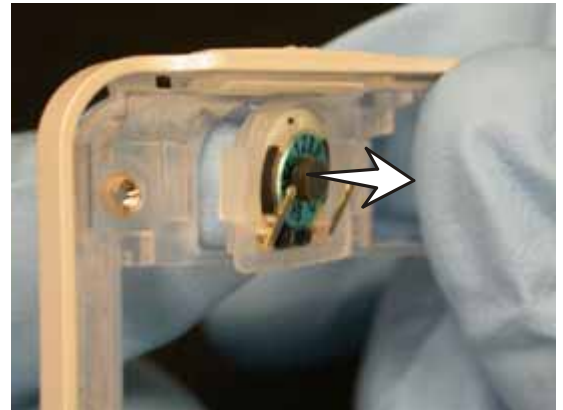
Removal

Perform sections 2.1.1-2.1.7 of the disassembly procedure

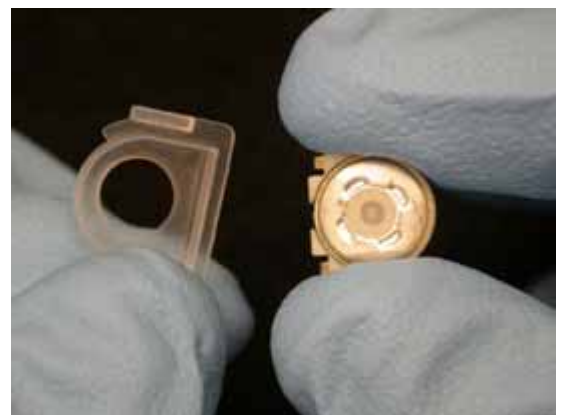
Perform the removal portion of the Volume Key Replacement procedure

Perform the removal portion of the Bonzer Flex Replacement procedure

Push the receiver and gasket out of the cavity on the front frame.



Separate the receiver and the gasket.



Installation

Insert the receiver into the receiver gasket.

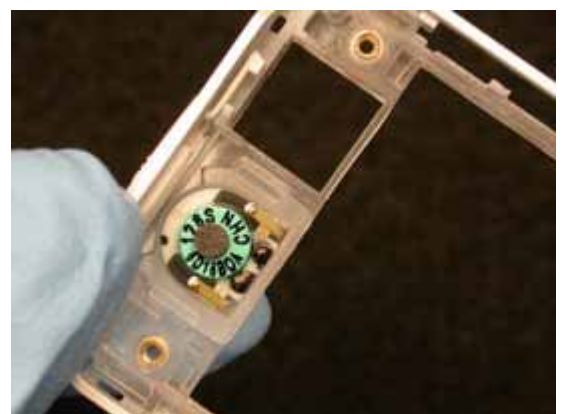


Insert the receiver/gasket assembly into the cavity on the front frame.

Perform the installation portion of the Bonzer Flex Replacement procedure

Perform the installation portion of the Volume Key Replacement procedure

Perform the reassembly procedure starting at section 4.1.7

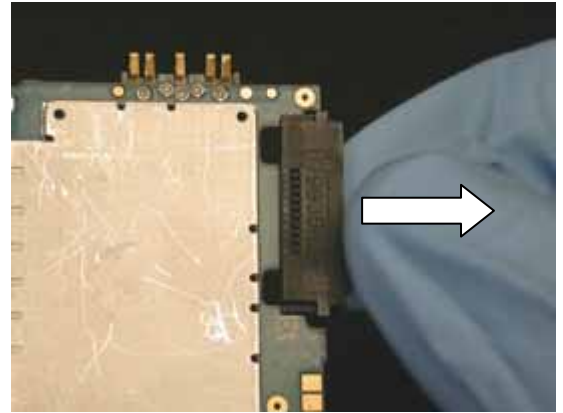


3.21 System Connector

Removal

Perform sections 2.1.1-2.1.12 of the disassembly procedure

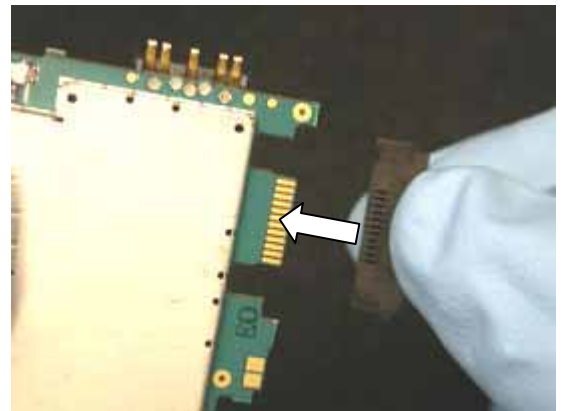
Pull the system connector off of the PC board.



Installation

Push the system connector onto the PC board.

Perform the reassembly procedure starting at section 4.1.2



3.22 Upper Rear Cover

Removal

Remove the battery cover, battery, and upper rear cover as instructed in disassembly procedure 2.1.1, 2.1.2, and 2.1.8.

Installation

Reinstall the upper rear cover, battery, and battery cover as instructed in reassembly procedure 4.1.5, 4.1.12, and 4.1.13

3.23 Vibrator

Removal

Perform sections 2.1.1-2.1.11 of the disassembly procedure

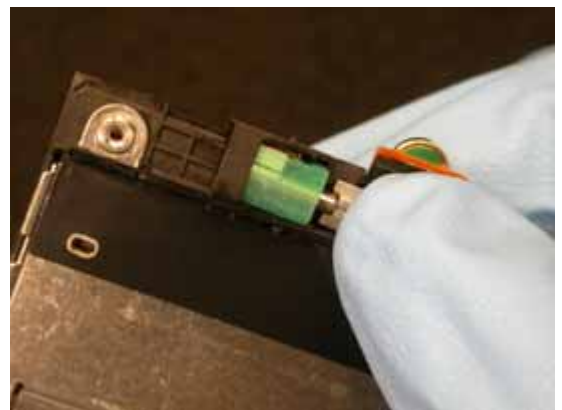
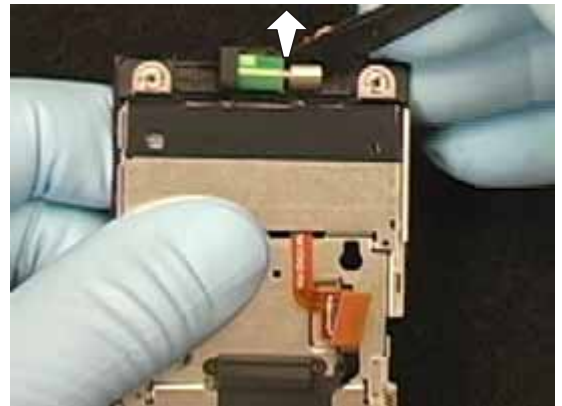
Gently lift the vibrator out of its cavity.

Installation

Orient the vibrator so that its spring fingers are toward the vibrator contact pads and insert the vibrator into its cavity.

Push the vibrator down into place.

Perform the reassembly procedure starting at section 4.1.3

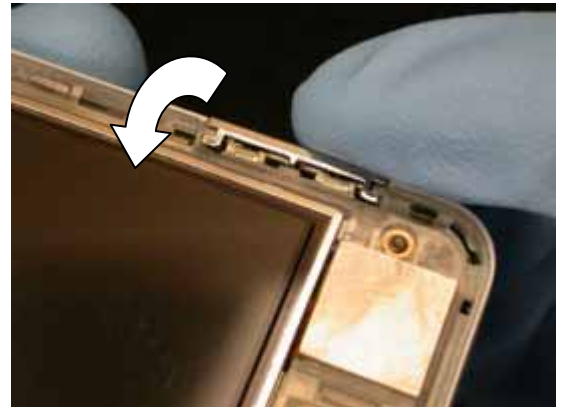


3.24 Volume Key

Removal

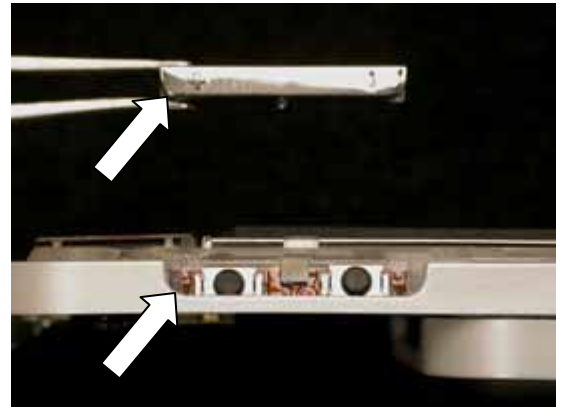
Remove the front cover as instructed in disassembly procedure 2.1.5

Lifting from the bottom of the volume key, rotate it towards the display to free it from its cavity.



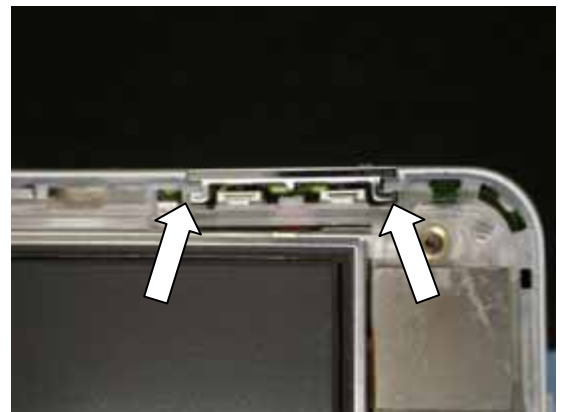
Installation

Orient the volume key so that the shape of the key corresponds to the shape of its cavity in the frame.



Work the volume key into its opening so that the features at each end of the volume key mate with the features of the frame as shown.

Reinstall the front cover as instructed in reassembly procedure 4.1.10



3.25 Wear Strips

Removal

Perform sections 2.1.1-2.1.11 of the disassembly procedure

NOTE: DO NOT REUSE WEAR STRIPS!

Grip the curved end of the wear strip.

Pull the strip off the hinge assembly.

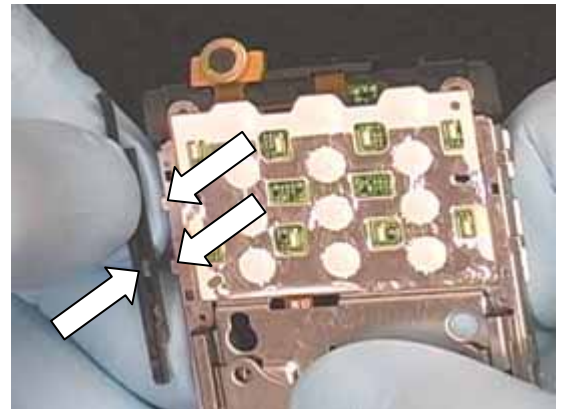


Installation

NOTE: THE CURVED END OF THE WEAR STRIPS GO TOWARDS THE END OF THE HINGE ASSEMBLY WHERE THE MICROPHONE IS LOCATED!

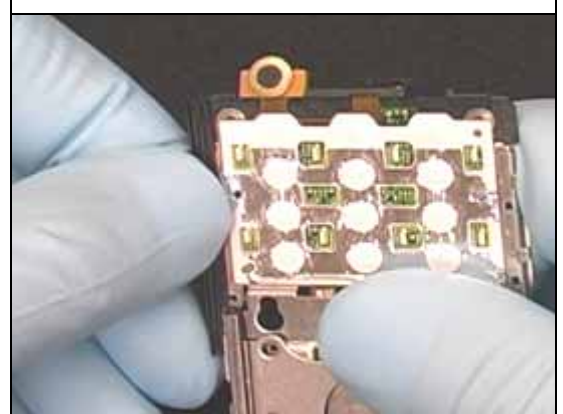
NOTE: THERE IS A LEFT SIDE WEAR STRIP AND A RIGHT SIDE WEAR STRIP.

Align the tabs on the hinge assembly with the holes in the wear strip.



Snap the wear strip onto the hinge assembly.

Perform the reassembly procedure starting at section 4.1.3



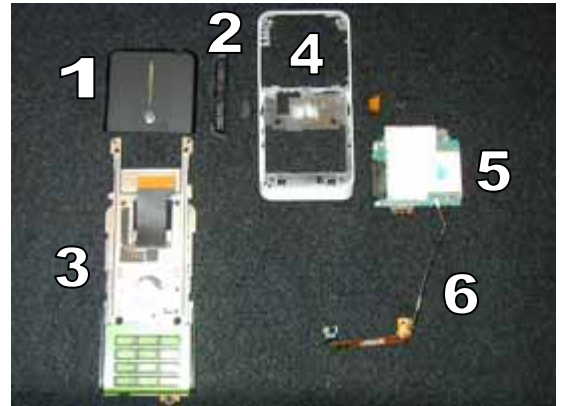
4 Reassembly

4.1 Overview

Perform the reassembly in the following order:

Lower half of phone

- Attach antenna/coax cable assembly(6) to PC Board (5)
- Install PC Board/Antenna assembly (5 & 6) into Rear Frame (4)
- Attach Hinge Assembly (3) to Rear Frame (4)
- Install 4 Rear Frame Screws (not shown)
- Install Upper Rear Cover (1)
- Install Chin Cover (2)



Upper half of phone

- Attach Front Frame (14) and Rear Frame / Hinge Assembly (15)
- Install 6 Front Cover Screws (not shown)
- Install Camera Cover (13)
- Install Front Cover (12)
- Install Label (11)
- Install Battery (10)
- Install Battery Cover (9)

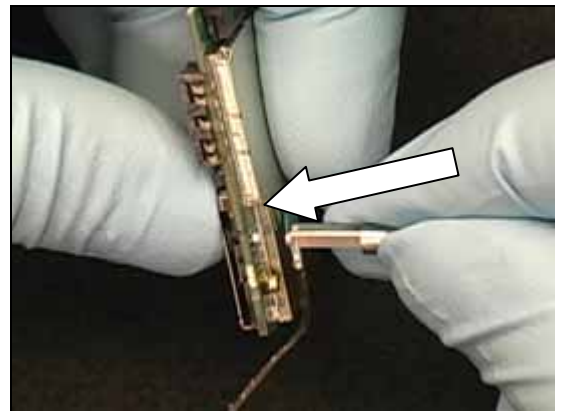


4.1.1 Antenna/Cable Assembly Installation to PC Board

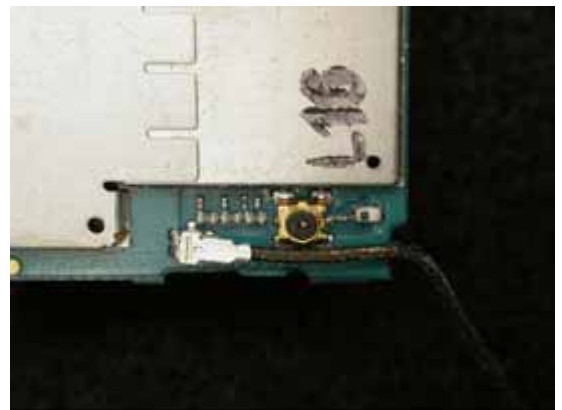
Insert the connector on the end of the antenna coaxial cable into the slot in the coax removal tool.



Using the tool, snap the connector onto the PC board.



Rotate the coax cable so that it is oriented to the circuit board as shown.



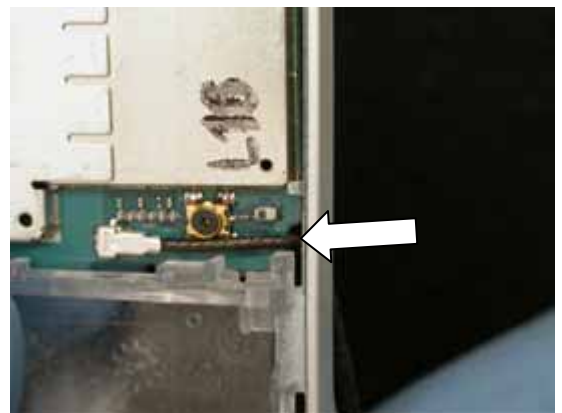
4.1.2 PC Board and Antenna Installation

Insert the side of the PC board with the system connector into place under the Bluetooth antenna.

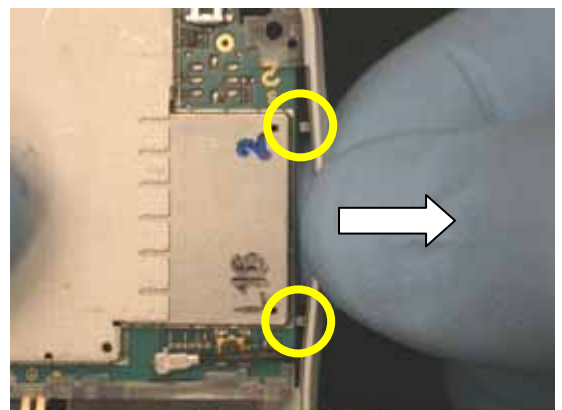
NOTE: THERE IS A SLOT IN THE EDGE OF THE REAR FRAME IN WHICH THE SYSTEM CONNECTOR SITS.



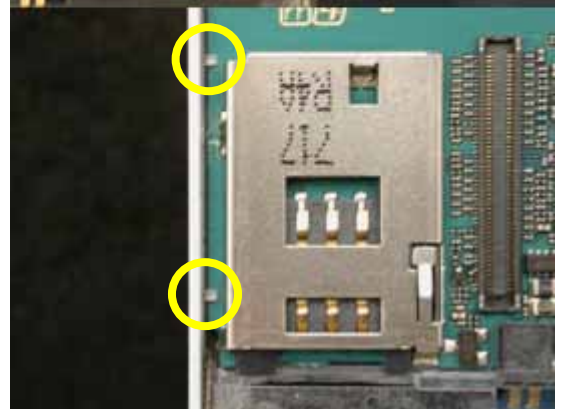
Position the coaxial cable so that it passes through the hole formed between the notch in the circuit board and the rear frame.



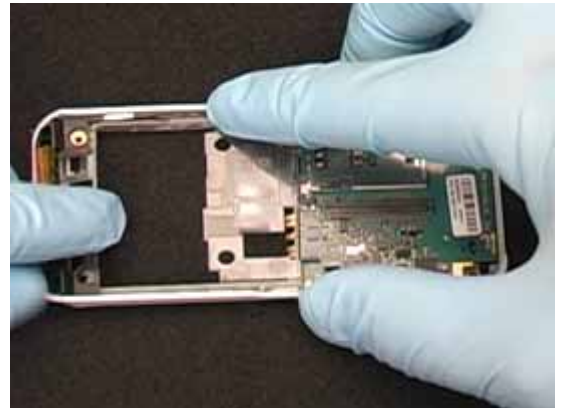
Work the side of the circuit board opposite the system connector into the rear frame by pulling the portion of the rear frame indicated away for the circuit board so that the two snaps clear the board's edge.



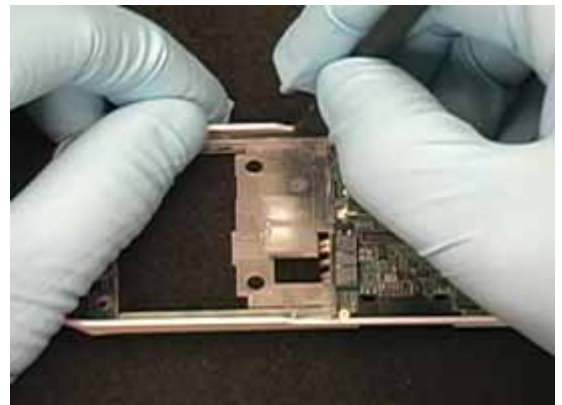
NOTE: THE TWO SNAPS SHOULD REST AGAINST ITS SIM CONNECTOR SIDE OF THE CIRCUIT BOARD.



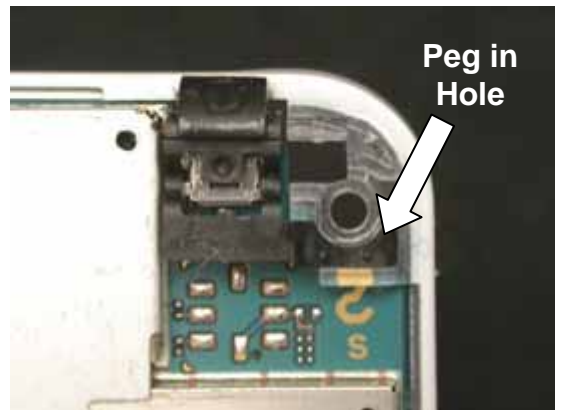
Snap the antenna assembly into its cavity.



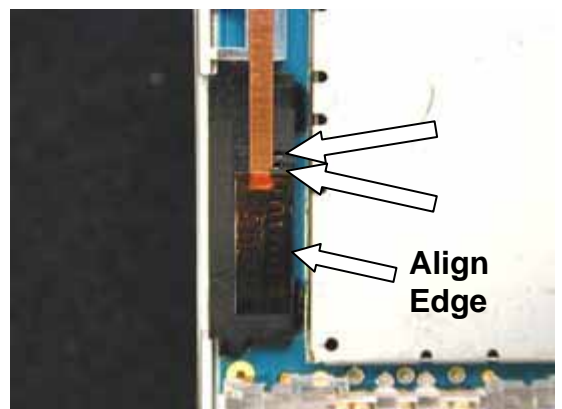
Push the coaxial cable down into the slot of the frame using a pry tool.



Insert the peg of the power key into the hole on the rear frame and press it into place

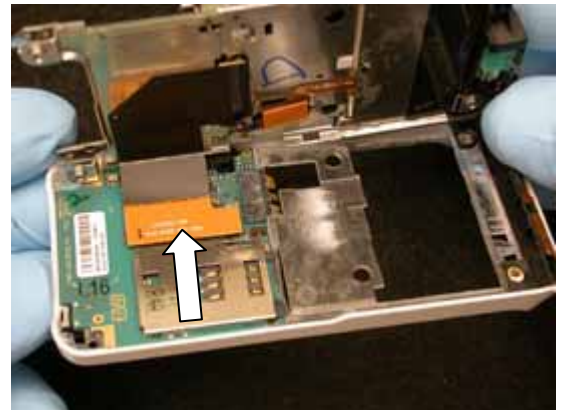


Install the Bluetooth tape using tweezers. Align the tape with the inside edge of the system connector and leave two holes exposed.



4.1.3 Hinge Assembly Installation to Rear Frame

Plug the hinge flex connector into the socket on the PC board.

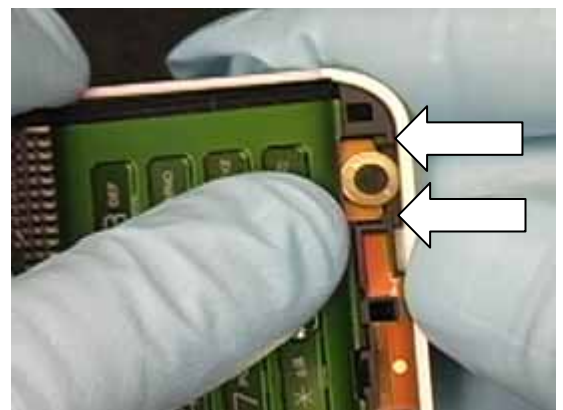


Lay the hinge assembly on top of the frame

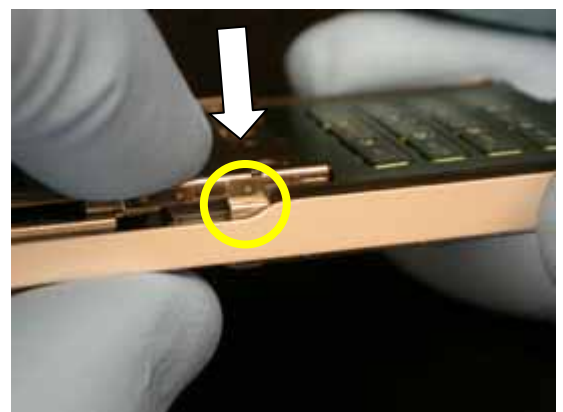


Press the end of the hinge assembly that contains the microphone into the rear frame.

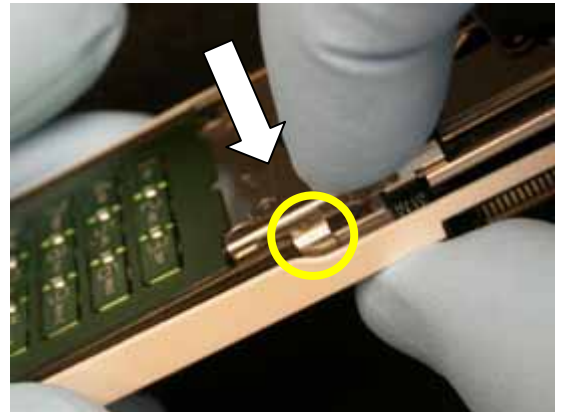
NOTE: MAKE SURE THE MICROPHONE FLEX IS UNDER THE TABS OF THE ANTENNA PLASTIC.



Snap the tab on one side of the frame in the slot on the hinge.



Snap the other side into place.



4.1.4 Rear Frame Screw Installation (4 Screws)

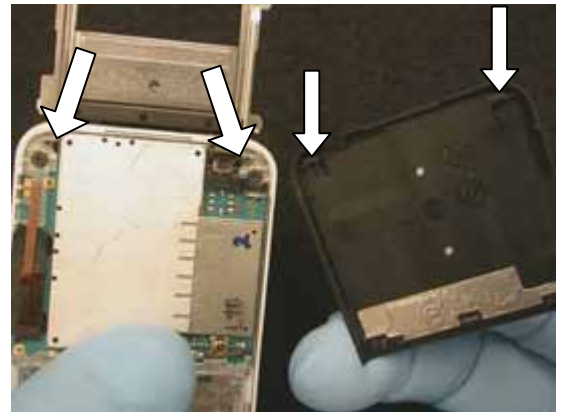
NOTE: DO NOT REUSE THESE SCREWS.

Use 8 N*cm and a JCIS No. 0 bit to install the four new screws.

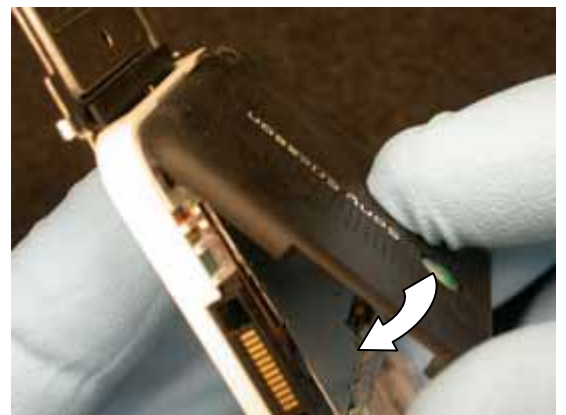


4.1.5 Upper Rear Cover Installation

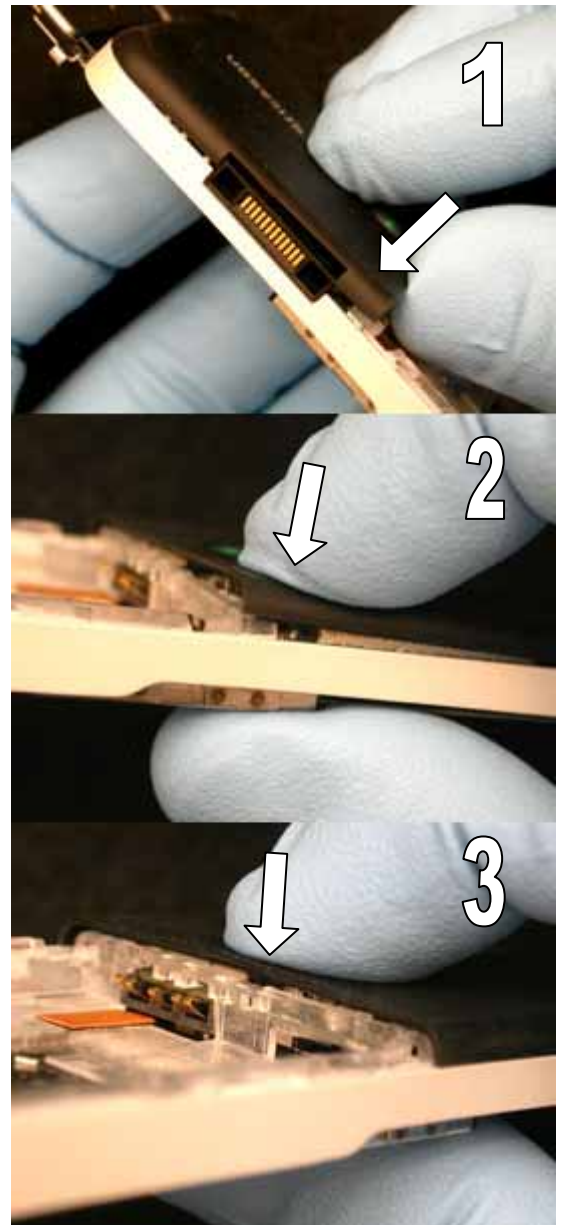
Insert the two indicated tabs on the upper rear cover into the slots on the frame.



Rotate the cover down toward the phone.

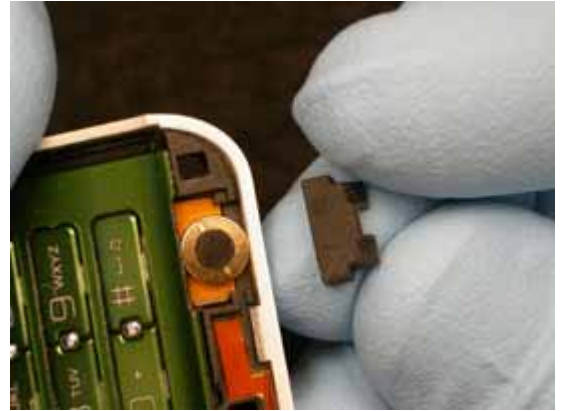


Snap the remaining 3 tabs into place.
(Shown in pictures 1, 2, and 3)



4.1.6 Chin Cover Installation

Orient the microphone gasket so that the wider side of the gasket toward the keypad.



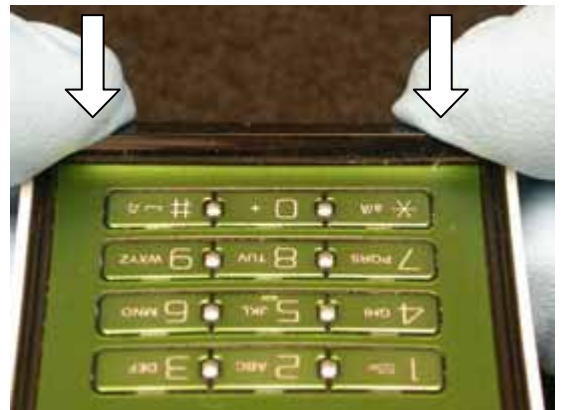
Press the gasket over the microphone as shown.



Insert the tabs of the chin cover into the slots.

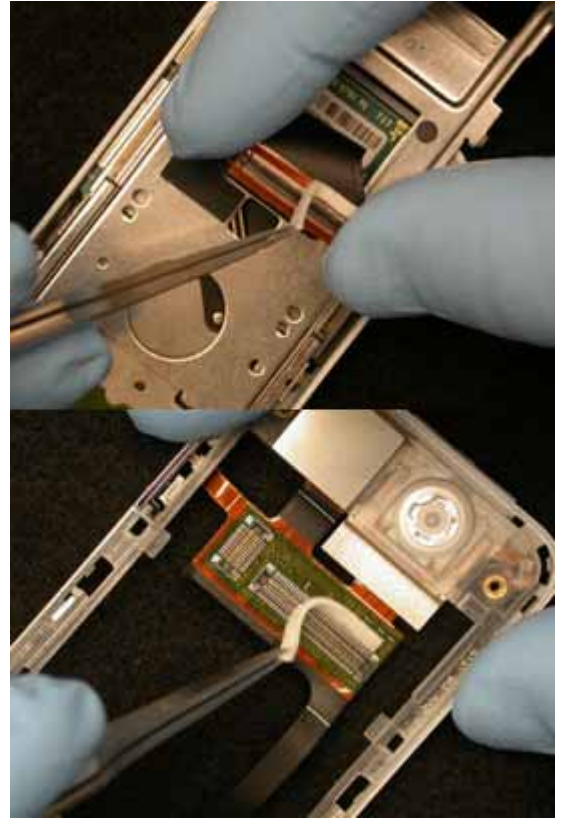


Push down on the cover to snap all the tabs into place.



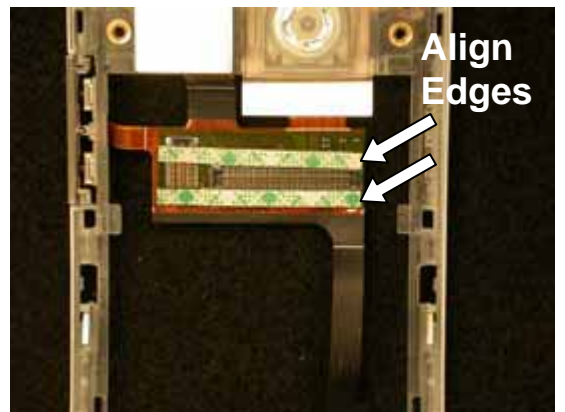
4.1.7 Front Frame Installation

Remove any remains of the two pieces of connector tape from each half of the hinge to bonzer flex connection.

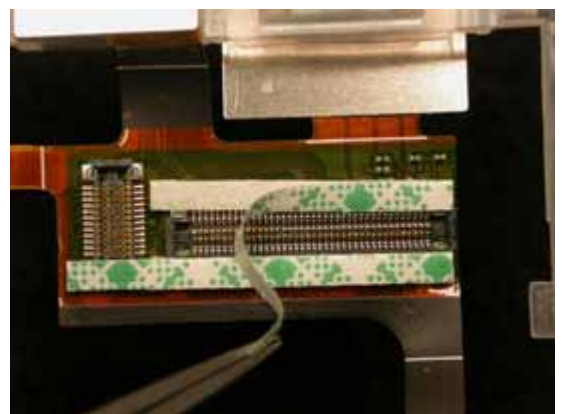


Add two new pieces of tape around the connection on the bonzer flex as shown.

NOTE: ALIGN THE EDGE OF THE TAPE WITH THE EDGE OF THE FLEX AS INDICATED.



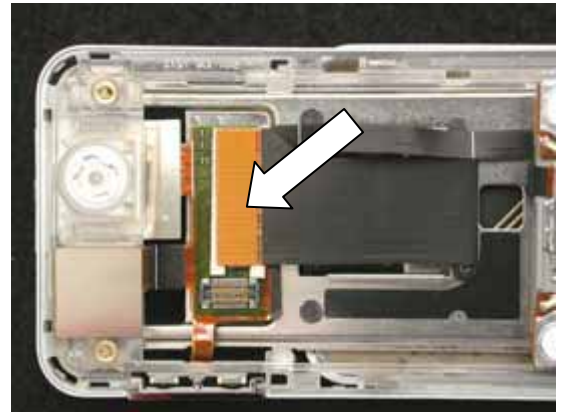
Remove the protective film from each piece of tape.



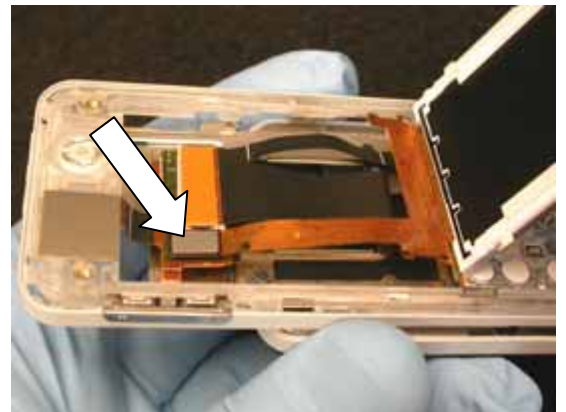
Position the front frame over the hinge assembly so that the bonzer/hinge flex connection lines up.

Plug the hinge flex into the corresponding bonzer flex connection.

Apply a small amount of pressure so that the tape bonds.



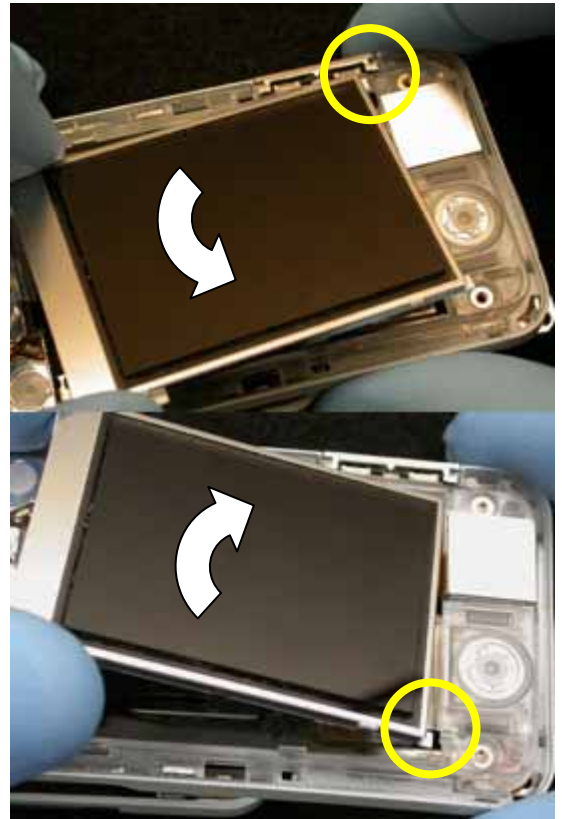
Orient the LCD as shown and plug the LCD's flex into the bonzer flex.



Fold the LCD so that it lays over its cavity.



Insert the upper two LCD retention features into their slots in the front frame by wiggling to LCD to the right and then the left.



Insert the tip of the plectrum between the left side of the LCD assembly and the front frame.



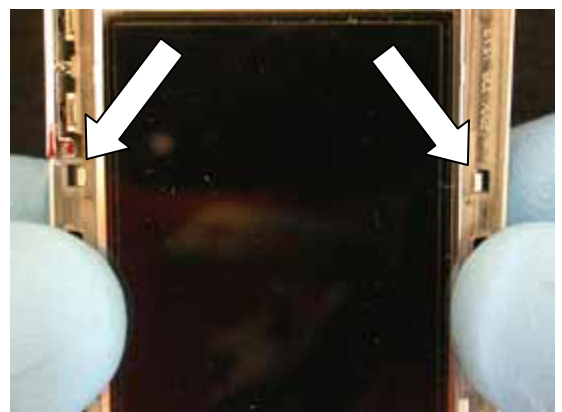
Rotate the plectrum towards the LCD to insert the lower left side retention feature into its slot in the front frame.

Insert the tip of the plectrum between the right side of the LCD and the front frame.

Rotate the plectrum towards the LCD to insert the lower right side retention feature into its slot in the front frame.

Holding the front frame and hinge assembly at the top, slide the phone closed.

Press in on the front frame at two side latches to get the hinge and front frame latched together.

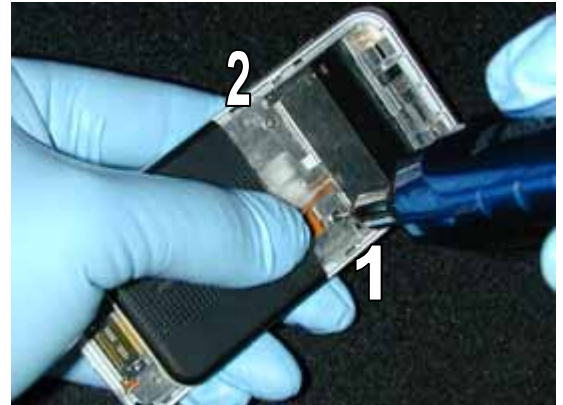


4.1.8 Front Frame Screw Installation (6 Screws)

NOTE: DO NOT REUSE THESE SCREWS.

NOTE: INSERT THE SCREWS IN THE ORDER SHOWN IN THE FOLLOWING TWO PHOTOS.

Push the hinge closed a small amount until the screw holes on the front frame are visible. Use 6 N*cm and a JCIS No. 0 bit to install the new screws.



Push the hinge open and install the remaining four screws.

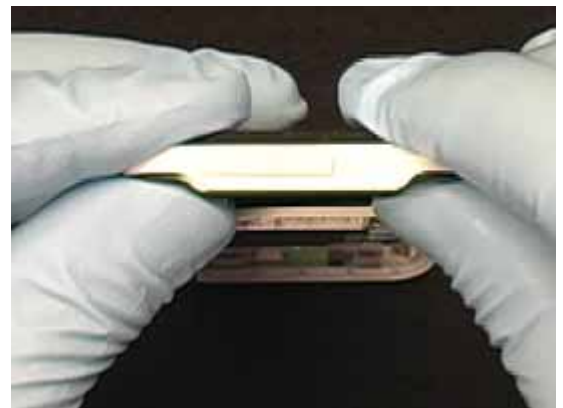
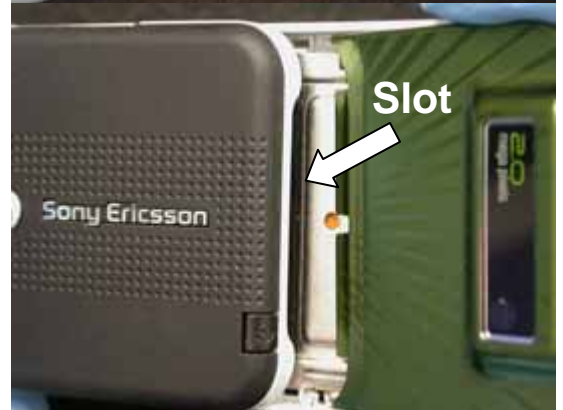
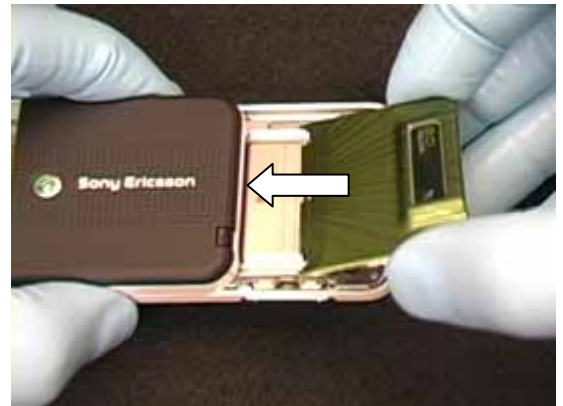


4.1.9 Camera Cover Installation

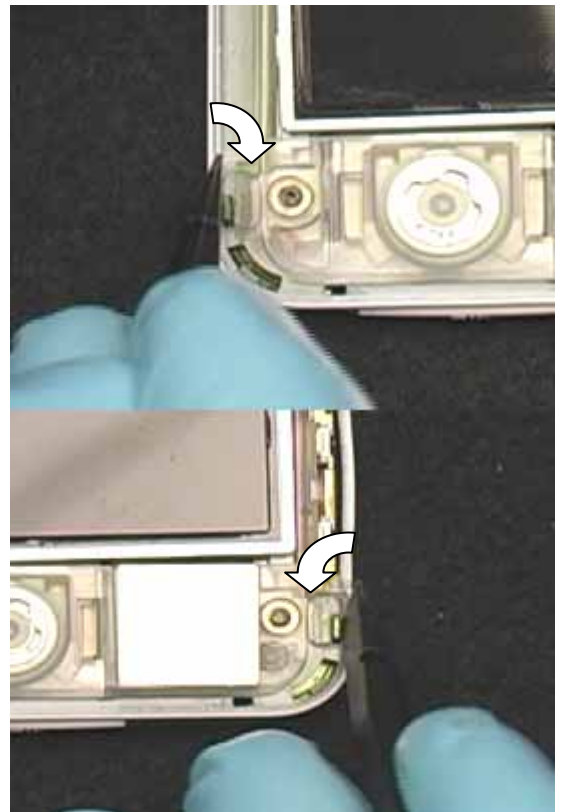
NOTE: DO NOT REUSE THE CAMERA COVER.

Insert the bottom edge of a new cover into the slot indicated.

Push the cover down into the front frame so the surfaces of the cover are flush with the edges of the front frame.

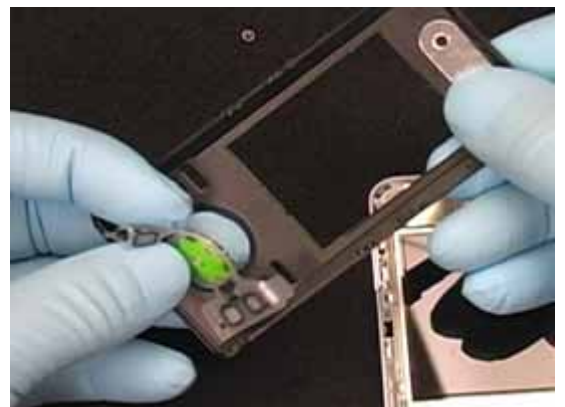


While holding the camera cover in place, turn the phone over and bend the two metal tabs toward the center.

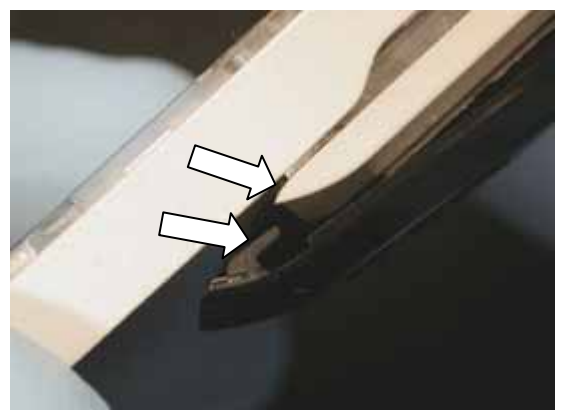


4.1.10 Front Cover Installation

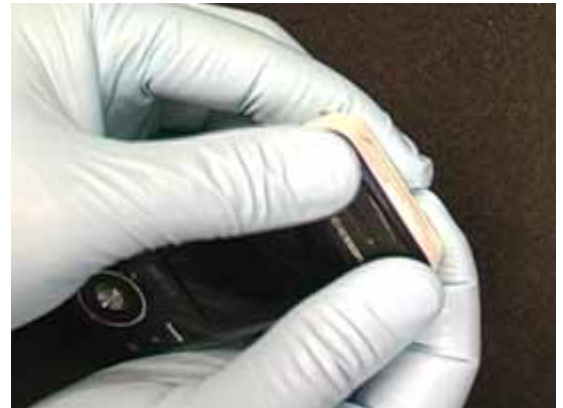
Place the keypad into the front cover.



Slide the hooks at the bottom of the front cover into the slots on the frame.



Squeeze the sides and top of the phone to snap the front cover into place.



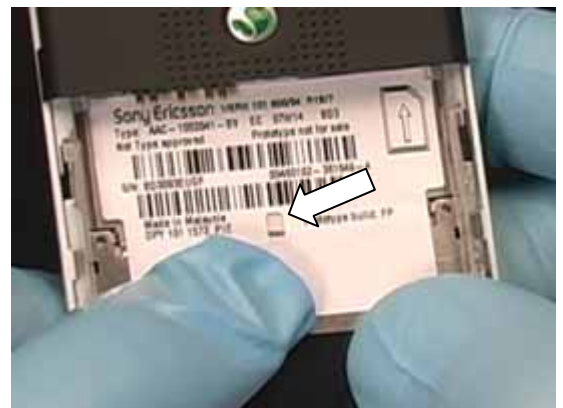
4.1.11 Label Installation

NOTE: DO NOT REUSE THE OLD LABEL. PRINT A NEW LABEL.

Insert the top side of the label under the battery connector.

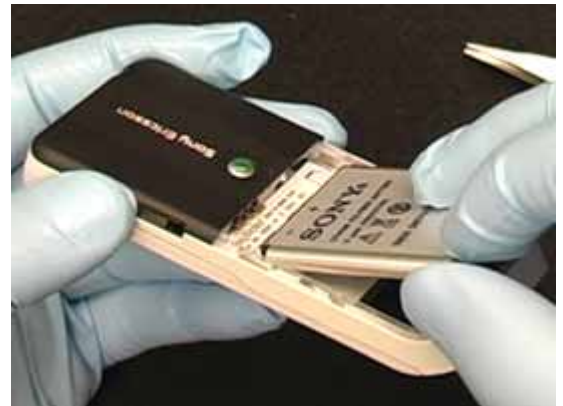


Push the label down into the battery cavity and make sure the Liquid Intrusion Indicator shows through the square hole.



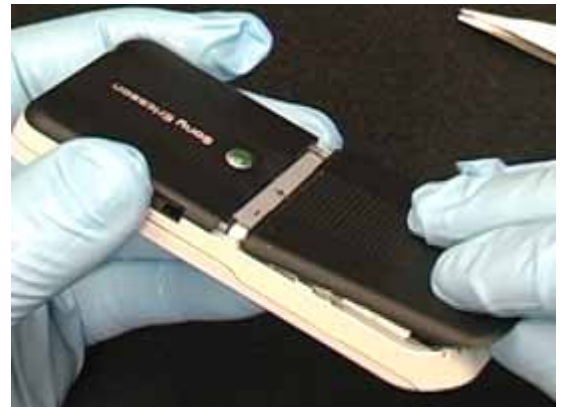
4.1.12 Battery Installation

Install the battery.

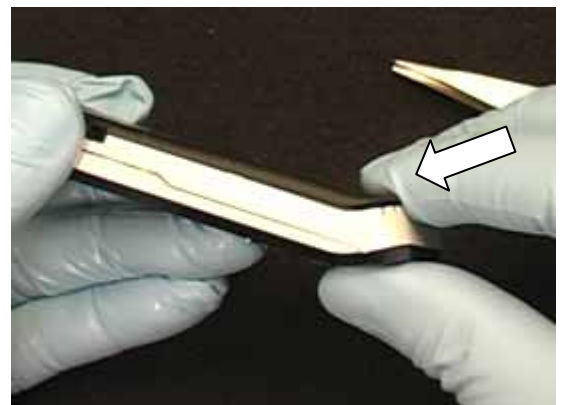


4.1.13 Battery Cover Installation

Insert the tabs of the battery cover into the slots on the frame.



Push the bottom edge of the battery cover downward and towards the top of the phone to get the battery cover to slide into place.



5 Revision History

Rev.	Date	Changes / Comments
A	2007-May-30	Initial Release
B	2007-July-17	<ul style="list-style-type: none">• Updated disassembly and reassembly procedures to accommodate the addition of the tape between the bonzer and hinge flexs• Updated blurry pics
C	2007-September-5	<ul style="list-style-type: none">• Updated references in replacement sections