

Working Instruction, Mechanical

Applicable for F500 and K500 family

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1 Disassembly

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits 6, NTZ 112 288
- Flex film assembly tool NTZ 112 521
- Blunt pair of tweezers, pair of tweezers
- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540
- Front opening tool NTZ 112 302/2

Equipment


- ESD-gloves (cotton gloves)
- ESD-wristband

Instruction




- Keep all contact surfaces clean of dirt and hand-grease


Phone views

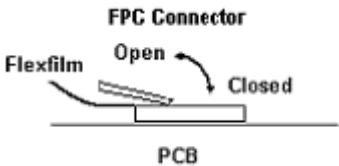
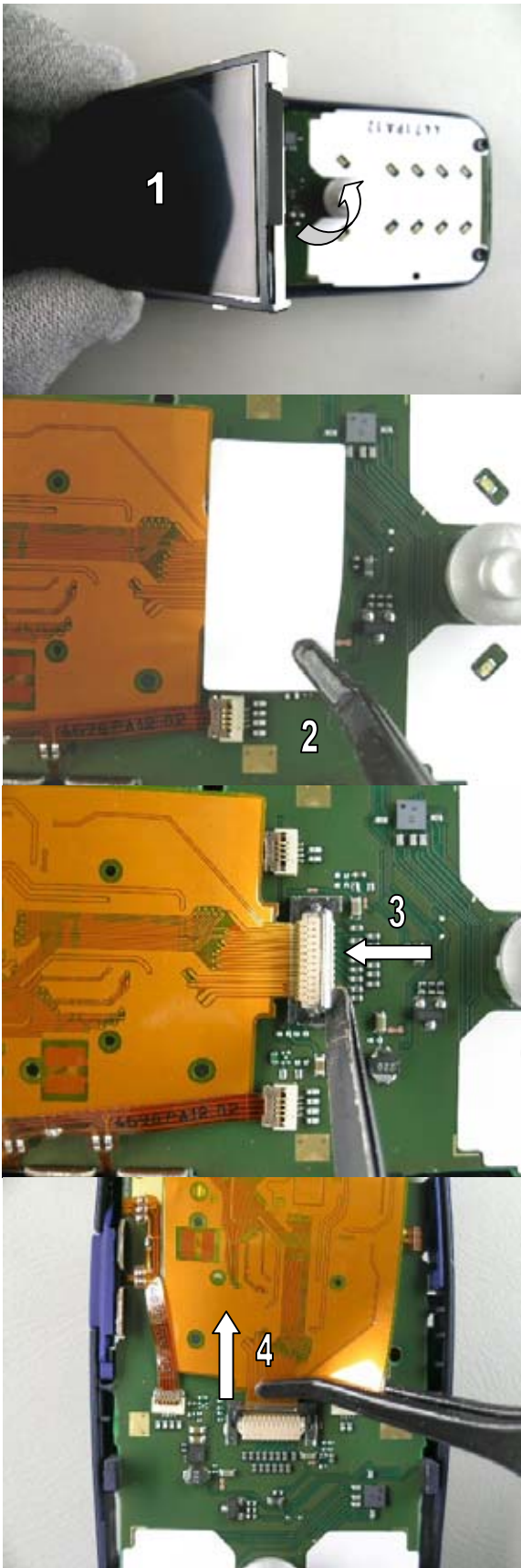


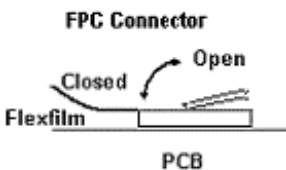
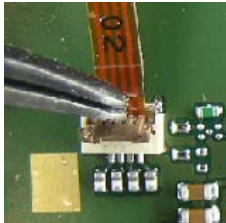
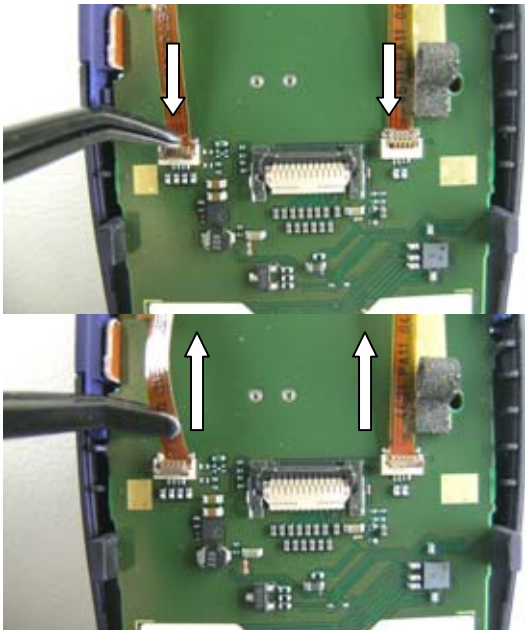
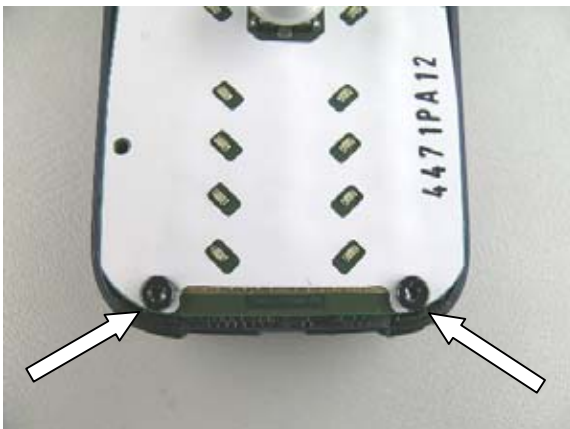
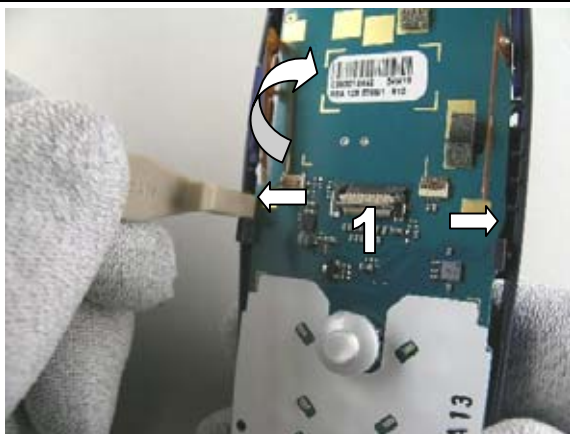
Step-by-Step Instructions		
1	<p>NOTE! Turn off the phone.</p> <p>Remove the battery cover with your fingers. Put a finger in the cavity and bend/lift the cover straight up like the picture show.</p>	
2	<p>Remove the battery from the phone with your fingers. Press on the plastic spring (1) in the arrow direction to unleash the battery.</p> <p>NOTE! It will be more easy if you at the same time turn the phone around.</p>	



	Step-by-Step Instructions	
3	<p>NOTE! Be careful not to scratch the frame with the opening tool.</p> <p>Picture of the Snap opening tool NTZ 112 544.</p>  <p>NOTE! The tool has a chamfer on one side (1). This side should be directed towards the phone.</p> <p>Use the Snap opening tool NTZ 112 544 to separate the frame from the front. Place it as the picture shows (2).</p> <p>NOTE! Do not bend the tool, just push straight in the arrow direction (3). If you bend the tool then it will be destroyed!!</p> <p>And press hard until they become separated from each other.</p> <p>Do the same thing on the other side of the phone (4).</p>	
4	<p>NOTE! Be careful not to scratch the frame with the K700i/front opening tool.</p> <p>Picture of the new K700i/Front opening tool NTZ 112 540.</p>  <p>Press (hard) with the K700i/front opening tool NTZ 112 540 between the front and the frame (1) until you get a small gap in the upper side of the phone.</p> <p>The phone has two “sidehooks” (2) in the frame – Bend the front little to booth sides so the side hooks come loose.</p> <p>NOTE! Make sure that they (the sidehooks) are fully open/released.</p>	

	Step-by-Step Instructions	
5	<p>NOTE! Be careful not to damage the bottom hooks (1) and the frame when they separate from each other.</p> <p>Do NOT bend the front to much apart from the frame (2) due to the hooks in the bottom end of the front.</p> <p>Then slide the front backwards from the frame (3).</p> <p>NOTE! Sometimes the keyboard will fall out when the front is disassembled.</p>	
6	<p>Remove the Speaker Grommet with a blunt pair of tweezers.</p>	
7	<p>NOTE! When handling the main LCD be careful and do not ever touch the display glass.</p> <p>Remove the two inside cabinet screws at the top of the LCD carrier.</p> <p>NOTE! Removed screws cannot be reused and must be scrapped.</p>	

	Step-by-Step Instructions	
8	<p>Use the front opening tool to separate the main LCD from the frame. Two frame snap fit hooks, located in the middle section, shall be released. Place the opening tool between the LCD and the frame and turn the tool until the LCD is free.</p> <p>(Do the same thing on the other side of the phone).</p>	

	Step-by-Step Instructions	
9	<p>Gently lift up the LCD with your fingers (1).</p> <p>NOTE! Always be careful not to damage the LCD flexfilm with the tweezers.</p> <p>Remove the Zif tape with the flex film assembly tool (2).</p> <p>NOTE! Removed tape cannot be reused and must be scrapped.</p> <p>NOTE! Be very careful not to damage/destroy the FPC connector clamp with the tweezers.</p> <p>Open the FPC connector with a pair of tweezers (3).</p>  <p>Remove the display assembly from the FPC connector with the flex film assembly tool (4).</p>	

	Step-by-Step Instructions	
10	<p>NOTE! Be very careful not to damage the FPC connector clamp when opening it. The clamp may fall off and then the connector must be replaced (electrical repair).</p> <p>Open the two FPC connectors, in the arrows direction, with the flex film assembly tool.</p>   <p>Remove the flexfilm from both FPC connectors by using the flex film assembly tool.</p>	
11	<p>Remove the two inside screws at the end of the phone.</p> <p>NOTE! Removed screws cannot be reused and must be scrapped.</p>	
12	<p>With the front opening tool, gently release the PCB from the two frame hooks (1).</p>	

	Step-by-Step Instructions	
13	<p>NOTE! PCB and frame are connected by camera flexfilm.</p> <p>Release the PCB from the frame by overturning the frame as the picture shows.</p> <p>NOTE! Be careful with the tweezers and do not damage the board-to-board connector.</p> <p>Disconnect the camera flexfilm board-to-board connector by lifting upwards with the flex film assembly tool.</p>	
14	<p>Front, frame and PCB disassembled.</p>	

2 Reassembly

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Flex film assembly tool NTZ 112 521
- Blunt pair of tweezers, pair of tweezers
- Front opening tool NTZ 112 302/2

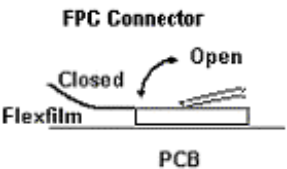
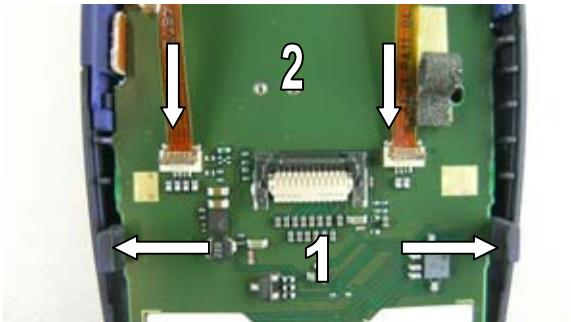
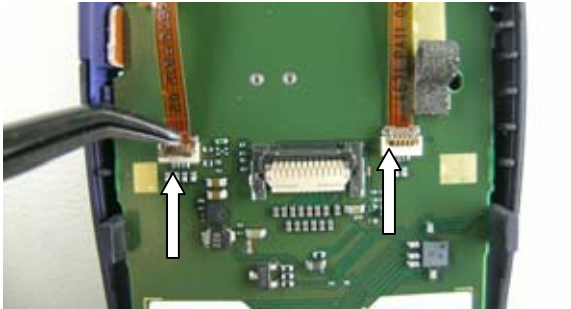
Equipment

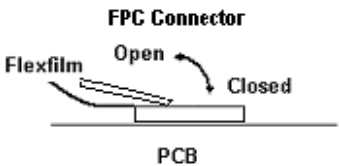
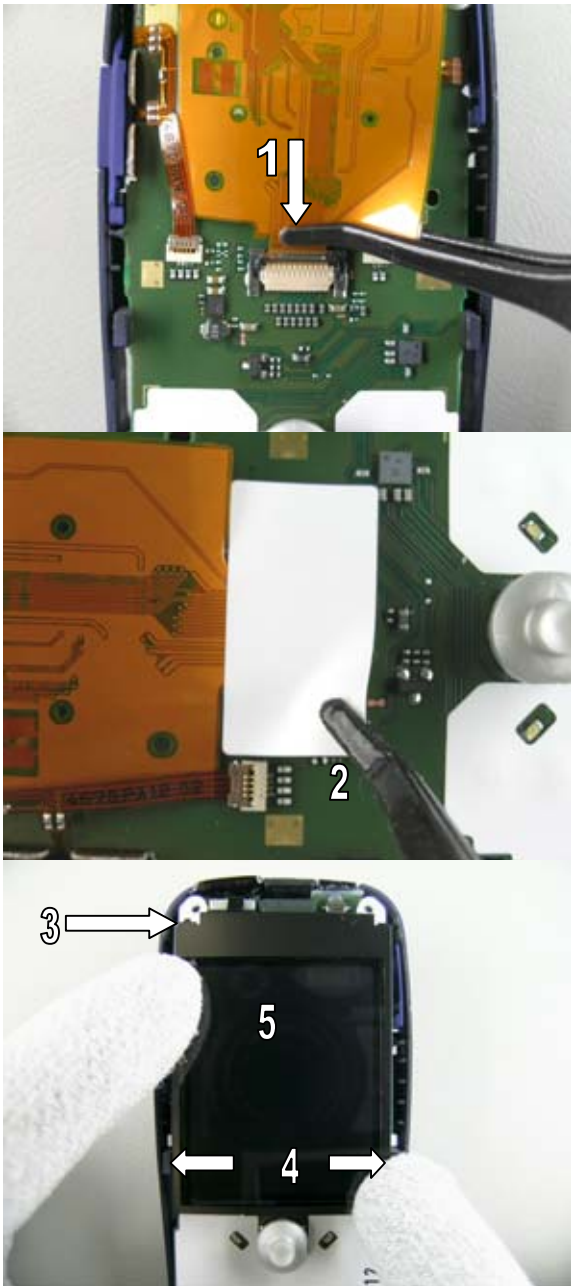

- ESD-gloves (cotton gloves)
- ESD-wristband





Instruction



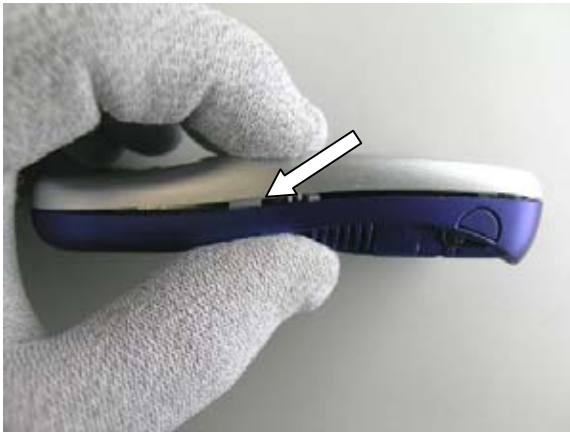

Keep all contact surfaces clean of dirt and hand-grease

	Step-by-Step Instructions	
1	<p>Place the PCB to the left in the frame between the camera flexfilm board-to-board connector (1) and volume/camera flexfilm (2).</p> <p>Connect the camera flexfilm board-to-board connector with your fingers or with the flex film assembly tool.</p> <p>Fold away the internet access key flexfilm (3) to the right before you place the PCB into the frame like the picture shows.</p> <p>NOTE! Check so the PCB is correctly assembled, take help from the guidepin (4).</p>	

	Step-by-Step Instructions	
2	<p>NOTE! Make sure that the main PCB is in the right position and properly locked by the two hooks (1) on each side of the frame.</p> <p>Assemble the two flexfilms (2) on both FPC connectors using the flex film assembly tool. Assure that flexfilms are pushed all the way into the connector.</p> <p>NOTE! Be very careful not to damage the FPC connector clamp when closing it. The clamp may fall off and then the connector must be replaced (electrical repair).</p> <p>Close the two FPC connectors with the flex film assembly tool.</p>  <p>The diagram shows a cross-section of the FPC connector assembly. It labels the 'FPC Connector', 'Flexfilm', and 'PCB'. An arrow indicates the 'Closed' position where the flexfilm is inserted into the connector, and another arrow indicates the 'Open' position where the flexfilm is being inserted or removed.</p>	  <p>The top photograph shows the internal components of the device with two white arrows pointing to the FPC connectors (labeled 1) and two white arrows pointing to the flexfilms (labeled 2). The bottom photograph shows the same components with two white arrows pointing to the FPC connectors, indicating the next step in the assembly process.</p>

	Step-by-Step Instructions	
3	<p>NOTE! Do not touch the display glass with your fingers.</p> <p>Assemble the display flexfilm into the FPC connector (1). Use the flex film assembly tool. Close the FPC connector with a blunt pair of tweezers.</p>  <p>The diagram shows a cross-section of the FPC connector assembly. It labels the 'FPC Connector', 'Flexfilm', 'Open' (the state before assembly), and 'Closed' (the state after assembly). The assembly is shown being inserted into a 'PCB'.</p> <p>Assemble a new Zif tape with the help of a pair of tweezers (2).</p> <p>Gently fold the LCD with your fingers to the correct position by using the frame guiding pin (3). Make sure that the LCD assembly is locked by the two frame snap fit hooks (4).</p> <p>NOTE! If you have assembled a new display: Remember to remove the display protection foil (5) with a pair of tweezers.</p>	 <p>This block contains three photographs illustrating the assembly steps for step 3. The top photo shows the display flexfilm being inserted into the FPC connector, labeled with a '1' and an arrow. The middle photo shows a white Zif tape being applied to the back of the display assembly, labeled with a '2' and an arrow. The bottom photo shows the LCD assembly being folded into the phone's frame, labeled with a '3' and an arrow. It also shows the frame snap fit hooks being used to lock the assembly, labeled with a '4' and arrows. A white protective foil is visible on the screen, labeled with a '5'.</p>
4	<p>NOTE! Use 15 Ncm of torque for the screws.</p> <p>Assemble four new screws. Tighten the cabinet screws according to screw sequence shown in the picture.</p>	 <p>This block contains a photograph showing the back of the phone's cabinet with four screws being tightened. The screws are numbered 1, 2, 3, and 4 in a clockwise sequence starting from the top-left corner. The phone's internal components and the display assembly are visible through the transparent back cover.</p>

	Step-by-Step Instructions	
5	<p>NOTE! The thick part of the grommet should be directed upwards.</p> <p>Reassemble the speaker grommet with a blunt pair of tweezers or with your fingers.</p>	
6	<p>Place the keyboard into the front.</p> <p>NOTE! Assure that the front glass is clean. Use air blow equipment.</p> <p>NOTE! If you have assembled a new front: Remember to remove the protection foil inside the front, with a pair of tweezers, before assembling. Be careful not to scratch the glass with the tweezers.</p>	
7	<p>NOTE! Be careful as the keyboard easily fall out from its position.</p> <p>Reassembling of the front starts like the pictures shows. Place the front over the frame. Start at the end of the phone.</p>	
8	<p>Place the front and frame together, be careful at the end of the phone because of the two “teeth” at each corner. Do NOT press the phone completely together.</p>	

	Step-by-Step Instructions	
9	<p>Press down the cavity with your fingers (see the arrow) until the front and frame are assembled together.</p> <p>NOTE! Make sure that the irda window is in its right position.</p>	
10	<p>Gently press with your fingers on the corners on the front and the frame.</p> <p>NOTE! Make sure that there are no gaps around the corners.</p>	
11	<p>Finally, press on the middle of the phone on both sides until the two latches at the arrow locks the front and frame together with a “click” sound.</p> <p>NOTE! Check so there is no gaps around the phone. If there still is a gap somewhere, gently press the two half’s together with your fingers.</p>	
12	<p>Place the battery into the frame cavity. Start at the battery connector area (1), press upwards towards the camera then push it down.</p> <p>NOTE! Make sure that the plastic spring at the end of the frame cavity is locked (2).</p>	

	Step-by-Step Instructions	
13	Slide the battery cover like the picture shows. Start at the top of the phone,	
14	Press on the end of the cover with your fingers until the cover locks to the frame.	
15	Reassembly of the phone is done.	

3 Replacement of Mechanical Parts

Equipment

- ESD-gloves (cotton gloves)
- ESD-wristband

Instruction

Tools listed under each heading in this chapter “Replacement of Mechanical Parts” is just a help for the user when disassembling and reassembling the phone.

- Use $15\text{Ncm} \pm 6\%$ of torque for the screws.
- Keep all contact surfaces clean of dirt and hand-grease

3.1 Front assembly

Tools

- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540

Replacement of *Front assembly*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.2 Zif tape

Tools

- Snap opening tool NTZ 112 544
- Blunt pair of tweezers
- Flex film assembly tool NTZ 112 521
- Front opening tool NTZ 112 302/2
- K700i/Front opening tool NTZ 112 540

Replacement of *Zif tape*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.3 128x160 TFT/LCD/Display module

Tools

- Snap opening tool NTZ 112 544
- Torque screwdriver, set to 15Ncm \pm 6%. Bits6, NTZ 112 288
- Flex film assembly tool NTZ 112 521
- Front opening tool NTZ 112 302/2
- K700i/Front opening tool NTZ 112 540

Replacement of the *Display module*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.4 Battery cover assembly

Tools

- By hand

Replacement of the *Battery cover assembly*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.5 Speaker grommet

Tools



- Snap opening tool NTZ 112 544
- Blunt pair of tweezers.
- K700i/Front opening tool NTZ 112 540

Replacement of the *Speaker grommet*: Check Disassembly and Reassembly headings and draw attention to the Note comments.

3.6 External antenna plug

Tools

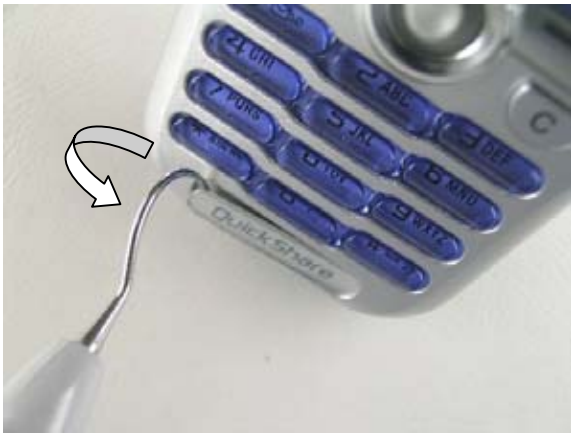
- Blunt pair of tweezers
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	Remove the battery cover, and then remove the external antenna plug by pressing from the back with your fingers.	
2	Assemble a new external antenna plug with your fingers.	

- Reassemble the phone as described in *2 Reassembly*.

3.7 Co-brand inlay


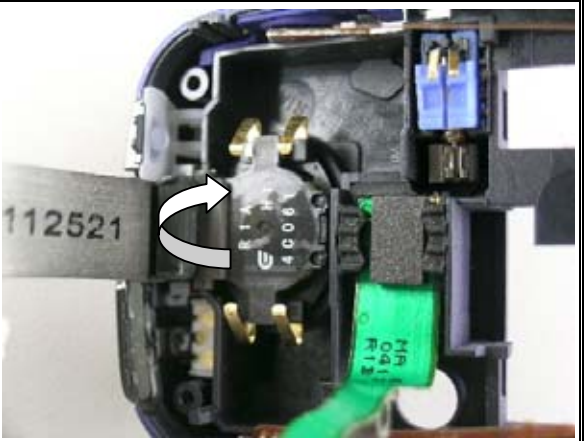
- Dentist hook
- Blunt pair of tweezers

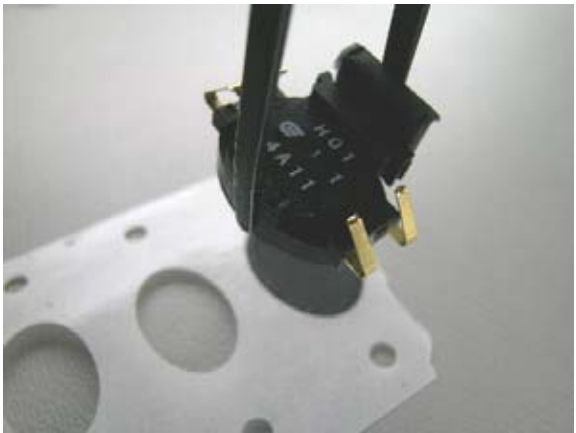
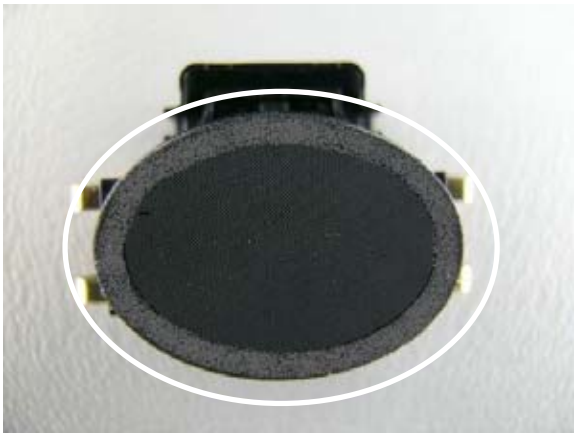
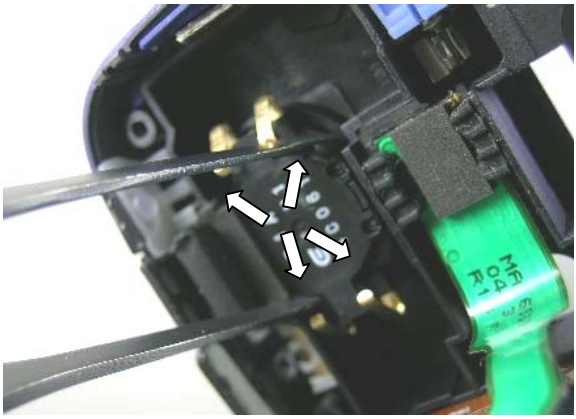
Step-by-Step Instructions		
1	<p>NOTE! Be careful not to scratch the front with the dentist hook.</p> <p>If necessary – clean the surface of the co-branded cavity with Isopropyl alcohol.</p> <p>Gently remove the old co-brand inlay with a dentist hook like the picture shows.</p> <p>Assemble a new co-brand inlay with a blunt pair of tweezers or by hand.</p>	

3.8 Dual speaker assembly

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- Flex film assembly tool NTZ 112 521
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers
- Front opening tool NTZ 112 302/2
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! There`s two types of speakers used in this product. The picture shows a CITIZEN speaker which is marked with a C.</p> <p>If you replace a Citizen speaker you can only replace it with another Citizen speaker.</p> <p>The other brand is HOSIDEN – this speaker doesn`t have any markings on it.</p> <p>This speaker must also be replaced with a Hosiden speaker.</p>	
2	<p>NOTE! Be gently with the flex film assembly tool.</p> <p>Use the opposite end of the flex film assembly tool to remove the old speaker, start like the picture shows. Gently bend with the tool between the frame and the speaker until the dual speaker come loose.</p>	

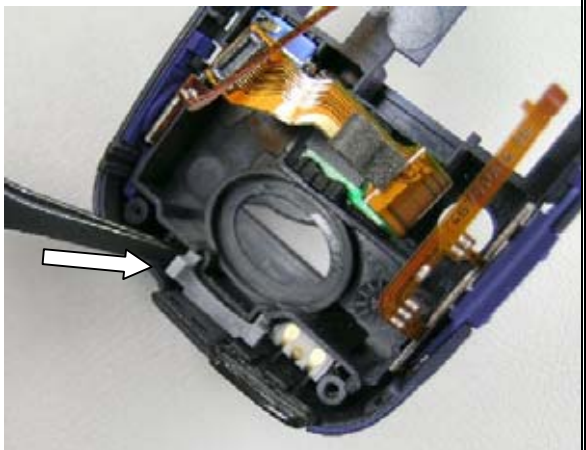
	Step-by-Step Instructions	
3	Peel off the protection foil from the new speaker and assemble a new speaker cloth.	
4	NOTE! Check so the speaker cloth is correctly assembled.	
5	NOTE! If necessary – remove the old speaker gasket adhesive remains from the speaker cavity. 1. Do not press in the center of the speaker (damage may occur). 2. Do not touch or damage the dual speaker contact springs with your fingers. Place the speaker into the frame cavity. Press gently on the speaker edges with a pair of tweezers to secure a good fit.	

- Reassemble the phone as described in 2 *Reassembly*.

3.9 Top hook support

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- Flex film assembly tool NTZ 112 521
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers
- Front opening tool NTZ 112 302/2
- Disassemble the phone as described in *1 Disassembly*.

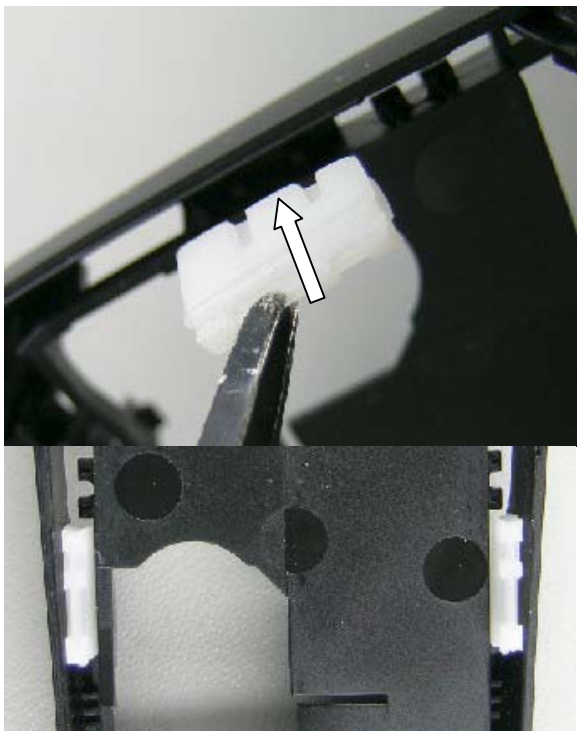
Step-by-Step Instructions		
1	<p>NOTE! Remove the Dual speaker first (See 3.8 in this chapter).</p> <p>Remove the old Top hook support with a blunt pair of tweezers like the picture shows and replace it with a new one.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.10 Side hook support

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- Flex film assembly tool NTZ 112 521
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers
- Front opening tool NTZ 112 302/2
- Disassemble the phone as described in *1 Disassembly*.

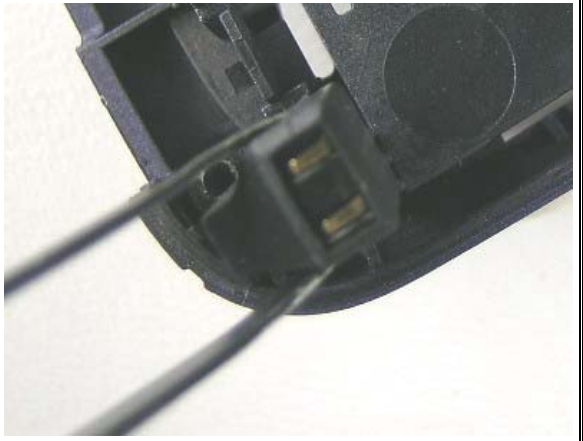
Step-by-Step Instructions		
1	<p>NOTE! Remove the Main PCB first (See chapter 1. Disassembly).</p> <p>Remove the old side hook supports with a blunt pair of tweezers like the picture shows and replace them with new ones.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.11 Microphone assembly

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- Flex film assembly tool NTZ 112 521
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers
- Front opening tool NTZ 112 302/2
- Disassemble the phone as described in *1 Disassembly*.


Step-by-Step Instructions		
1	<p>NOTE! Do not touch the contact springs with your fingers or the tweezers.</p> <p>Remove the old microphone with a blunt pair of tweezers.</p> <p>Assemble the new microphone in the reverse direction with the tweezers.</p> <p>NOTE! Press the microphone to the bottom of the cavity.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.12 Keyboard

Tools

- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540
- Disassemble the phone as described in *1 Disassembly*.


Step-by-Step Instructions		
1	Replace the keyboard in the cabinet with a new one by hand.	

- Reassemble the phone as described in *2 Reassembly*.

3.13 Vibrator assembly

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- Flex film assembly tool NTZ 112 521
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers
- Front opening tool NTZ 112 302/2
- Disassemble the phone as described in *1 Disassembly*.

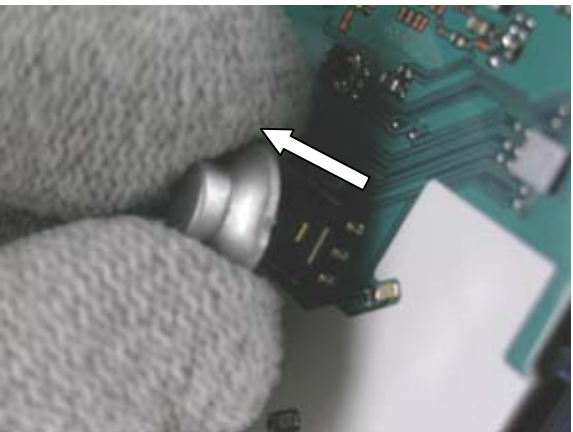


Step-by-Step Instructions		
1	<p>NOTE! Do not touch the vibrator contact springs or damage the flywheel.</p> <p>Lift up the vibrator motor with a blunt pair of tweezers, start like the picture shows.</p> <p>Assemble a new vibrator in the reverse direction. Use a blunt pair of tweezers.</p> <p>NOTE! Press the vibrator to the bottom of the cavity.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.14 Joystick button and Dust gasket

Tools

- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540
- Disassemble the phone as described in *1 Disassembly*.

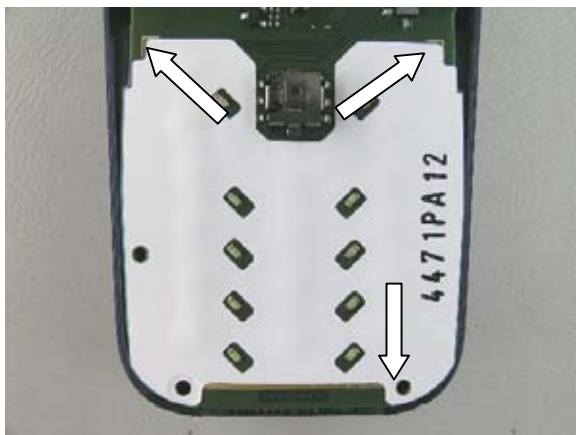
Step-by-Step Instructions		
1	<p>Remove the old joystick button with your fingers.</p> <p>NOTE! The button can be reassembled in any direction.</p> <p>When assembling a new joystick button you must first assemble a new dust gasket. Assemble the dust gasket with a blunt pair of tweezers.</p> <p>NOTE! Make sure that the dust gasket is assembled in the right position.</p>	  

- Reassemble the phone as described in *2 Reassembly*.

3.15 Dome switch foil

Tools

- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers
- Disassemble the phone as described in *1 Disassembly*.

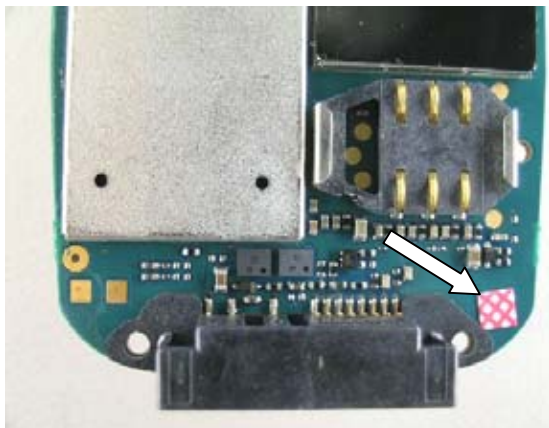
Step-by-Step Instructions		
1	<p>Remove the dome switch foil with a blunt pair of tweezers or by hand.</p> <p>After removal – clean the surface of the PCB with Isopropyl alcohol.</p> <p>NOTE! The dome switch foil should be aligned to the markings and the holes on the PCB.</p> <p>Assemble a new one with your fingers.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.16 Water indicator

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540
- Flex film assembly tool NTZ 112 521
- Blunt pair of tweezers
- Front opening tool NTZ 112 302/2
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Notice the water label position on the picture.</p> <p>If necessary, clean the surface with Isopropyl alcohol before you assemble the new label.</p> <p>Remove the old water indicator and replace it with a new one.</p>	

- Reassemble the phone as described in *2 Reassembly*.

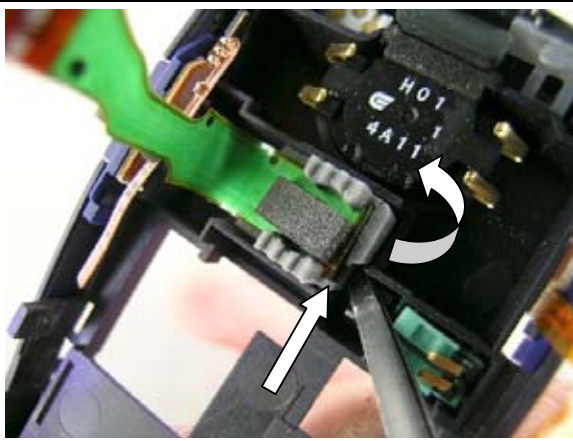
3.17 Camera assembly, Camera conductive gasket and Camera cover

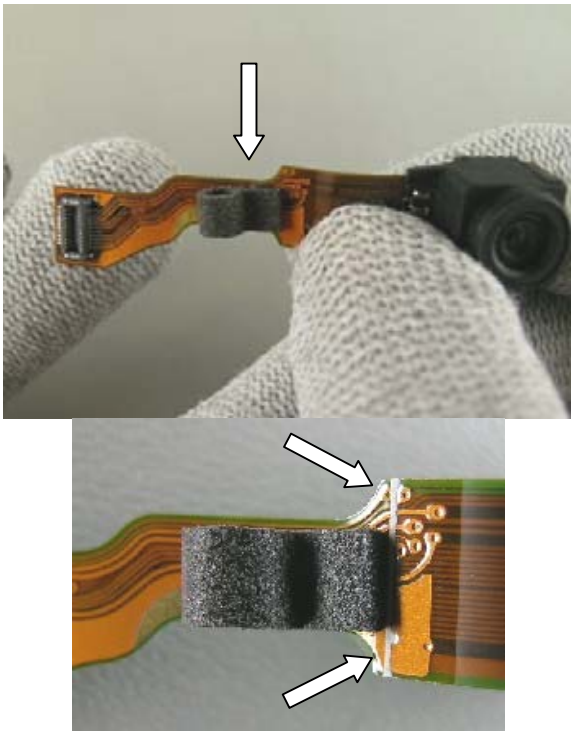

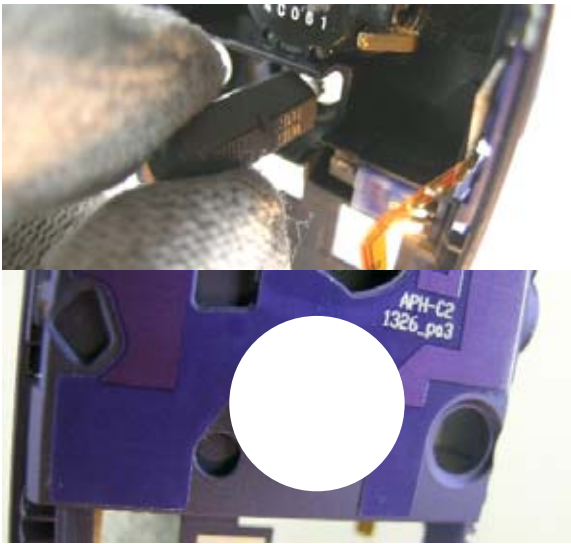
Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- Front opening tool NTZ 112 302/2
- Flex film assembly tool NTZ 112 521
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers

Instruction

- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>NOTE! Be careful with the camera assembly and flexfilm.</p> <p>Remove the camera assembly by placing a blunt pair of tweezers according to the arrow. Press the tweezers in (close to the camera wall) and gently lift the camera assembly straight up.</p> <p>Assemble a new camera assembly, press it to the bottom of the cavity with your fingers.</p>	



	Step-by-Step Instructions	
2	<p>Take the camera assembly and assemble the camera conductive gasket as the picture shows.</p> <p>NOTE! The end of the conductive gasket should be placed by the line.</p>	
3	<p>Press from the back of the frame on the old camera cover with your fingers until it falls out.</p>	
4	<p>Assemble a new camera cover from the inside of the frame, gently push with the torx bits 6 like the pictures shows on the edges around the camera cover until it's assembled in the right position.</p> <p>NOTE! Turn the frame assembly around and check that the camera cover edge is visible all around the frame opening.</p>	

- Assemble the phone as described in 2 Reassembly.

3.18 Flexfilm Volume and Camera keys

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
 - Snap opening tool NTZ 112 544
 - Front opening tool NTZ 112 302/2
 - Flex film assembly tool NTZ 112 521
 - K700i/Front opening tool NTZ 112 540
 - Blunt pair of tweezers
- Disassemble the phone as described in *1 Disassembly*.

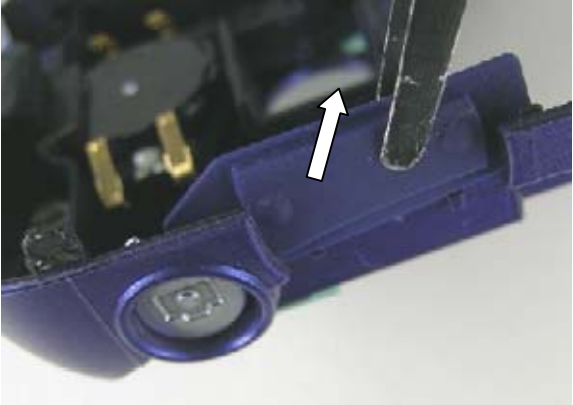

Step-by-Step Instructions		
1	<p>Place the Front opening tool NTZ 112 302/2 like the arrow show (1); gently lift the flex film plate out until it's free from the two hooks (2). At the same time pull out the flexfilm from the frame with your other hand like the picture shows (3).</p> <p>Assemble a new flexfilm in the reverse direction. Use the flex film assembly tool.</p> <p>NOTE! Make sure the flexfilm is assembled in the right position and locked by the two hooks.</p>	
		

- Reassemble the phone as described in *2 Reassembly*.

3.19 Camera button + Volume button

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
 - Snap opening tool NTZ 112 544
 - Front opening tool NTZ 112 302/2
 - Flex film assembly tool NTZ 112 521
 - K700i/Front opening tool NTZ 112 540
 - Blunt pair of tweezers
- Disassemble the phone as described in *1 Disassembly*.

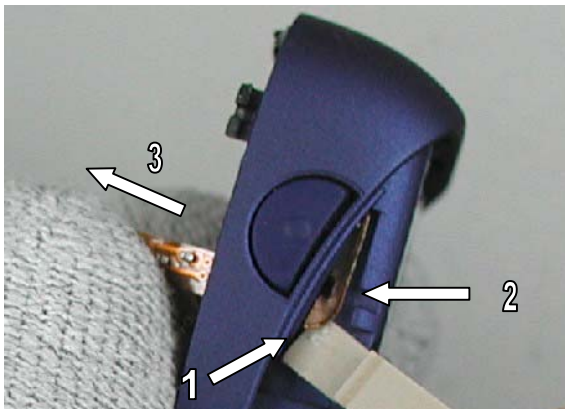
Step-by-Step Instructions		
1	<p>NOTE! Be careful not to damage the camera/volume rubber button with the tweezers.</p> <p>Remove the old camera/volume button with a blunt pair of tweezers.</p> <p>Assemble a new camera/volume button in the reverse direction. Use the tweezers or your fingers.</p>	
2	<p>NOTE! Make sure that the camera/volume buttons are assembled in the right position.</p> <p>Assemble the rubber button behind the guide pin by the arrow.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.20 Flexfilm Internetkey

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
 - Snap opening tool NTZ 112 544
 - Flex film assembly tool NTZ 112 521
 - K700i/Front opening tool NTZ 112 540
 - Front opening tool NTZ 112 302/2
 - Blunt pair of tweezers
 - Dentist hook
- Disassemble the phone as described in *1 Disassembly*.

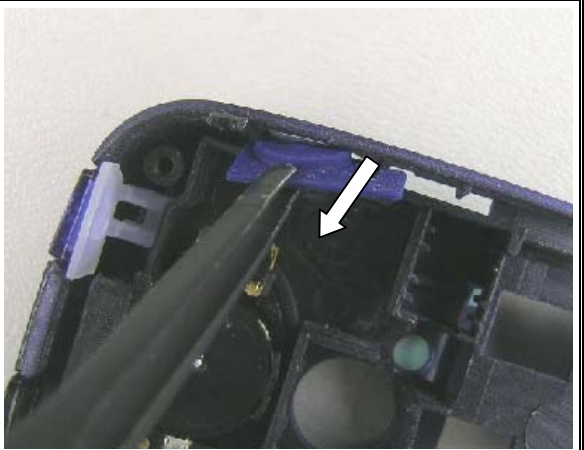
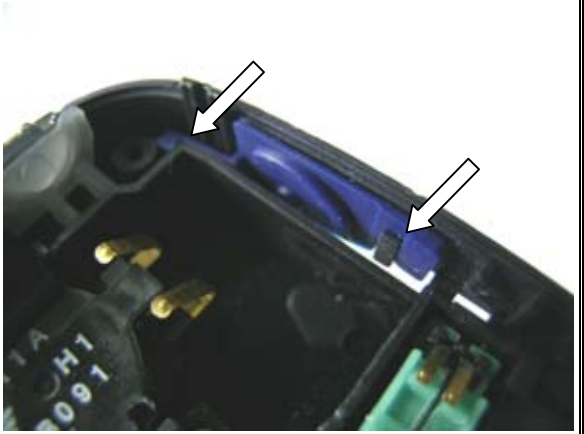
Step-by-Step Instructions		
1	<p>Place the Front opening tool NTZ 112 302/2 like the arrow show (1); gently lift the flex film plate out until it's free from the hook (2). At the same time pull out the flexfilm from the frame with your other hand like the picture shows (3).</p> <p>Assemble a new flexfilm in the reverse direction. Use the flex film assembly tool.</p> <p>NOTE! Make sure the flexfilm is assembled in the right position and locked by the two hooks.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.21 Internet button

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
 - Snap opening tool NTZ 112 544
 - K700i/Front opening tool NTZ 112 540
 - Front opening tool NTZ 112 302/2
 - Flex film assembly tool NTZ 112 521
 - Blunt pair of tweezers
- Disassemble the phone as described in *1 Disassembly*.


Step-by-Step Instructions		
1	<p>NOTE! Be careful not to damage the internet rubber button with the tweezers.</p> <p>Remove the old internet button with a blunt pair of tweezers.</p> <p>Assemble a new camera/volume button in the reverse direction. Use the tweezers or your fingers.</p>	
2	<p>NOTE! Make sure that the internet button is assembled in the right position.</p> <p>Assemble the rubber button behind the guide pins.</p>	

- Reassemble the phone as described in *2 Reassembly*.

3.22 On/Off button

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
 - Snap opening tool NTZ 112 544
 - K700i/Front opening tool NTZ 112 540
 - Front opening tool NTZ 112 302/2
 - Flex film assembly tool NTZ 112 521
 - Blunt pair of tweezers
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>Remove the old On/Off button with a blunt pair of tweezers or your fingers.</p> <p>Assemble a new On/Off button into the frame with the tweezers.</p> <p>NOTE! Make sure that the On/Off button is assembled in the right position.</p>	



- Reassemble the phone as described in *2 Reassembly*.

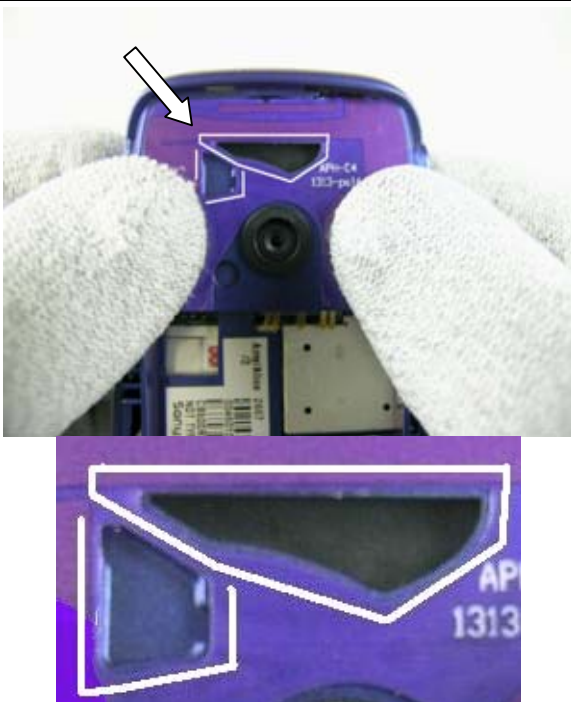
3.23 Antenna assembly

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540
- Front opening tool NTZ 112 302/2
- Flex film assembly tool NTZ 112 521
- Blunt pair of tweezers
- Screw driver tip width 6-8mm

- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	Remove the antenna flexfilm from the frame with a blunt pair of tweezers or with your fingers.	
2	<p>Press on the antenna carrier plug with a screw driver, tip width 6-8 mm. Start pressing from the inside of the frame until the whole antenna assembly is released.</p> <p>NOTE! When the antenna assembly has been removed, clean the surface of the frame (backside) with Isopropyl alcohol.</p>	


	Step-by-Step Instructions	
3	<p>NOTE! Be careful with the antenna plug and flexfilm.</p> <p>Start reassemble the new antenna assembly by pressing the antenna plug into the frame with your fingers or take help of a screw driver, tip width 6-8 mm like the picture shows (If it's hard to push the antenna plug down into the frame).</p> <p>NOTE! The antenna plug is correctly assembled when the frame and plug are in the same level</p>	
4	<p>NOTE! Be careful with the antenna flexfilm.</p> <p>Gently fold the antenna flexfilm into the right position (see white alignment markings on the picture) with the flex film assembly tool or with your fingers.</p>	

- Reassemble the phone as described in 2 *Reassembly*.

3.24 Irda window

Tools

- Snap opening tool NTZ 112 544
- K700i/Front opening tool NTZ 112 540
- Blunt pair of tweezers
- Disassemble the phone as described in *1 Disassembly*.

Step-by-Step Instructions		
1	<p>Remove the old IRDA window with a blunt pair of tweezers or your fingers.</p> <p>After removal of IRDA-window, use your fingers to mount a new IRDA window and press it to the bottom.</p> <p>NOTE! When the IRDA-window is mounted check the gap between frame and IRDA-window. The maximum gap allowed is 0.1mm.</p>	

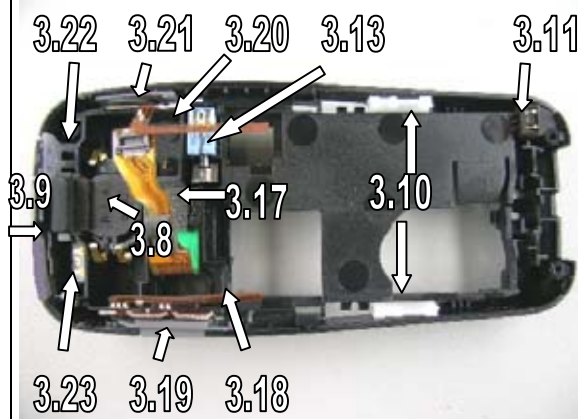
Reassemble the phone as described in *2 Reassembly*

3.25 Frame assembly

Tools

- Torque screwdriver, set to 15 Ncm \pm 6%. Bits6, NTZ 112 288
 - Snap opening tool NTZ 112 544
 - Flex film assembly tool NTZ 112 521
 - Front opening tool NTZ 112 302/2
 - K700i/Front opening tool NTZ 112 540
 - Blunt pair of tweezers
 - Dentist hook
- Disassemble the phone as described in *1 Disassembly and 3 Replacement of Mechanical Parts 3.8, 3.9, 3.10, 3.11, 3.13, 3.17, 3.18, 3.19, 3.20, 3.21, 3.22, 3.23*

Step-by-Step Instructions	
1	<p>Replace the old frame with a new one.</p> <p>NOTE! Assemble the 12 frame assembly components found in chapter 3 <i>Replacement of Mechanical Parts</i>.</p>



- Reassemble the phone as described in *2 Reassembly and 3 Replacement of Mechanical Parts 3.8, 3.9, 3.10, 3.11, 3.13, 3.17, 3.18, 3.19, 3.20, 3.21, 3.22, 3.23*

4 Label

Tools

- Hot air flow solder station
- Blunt pair of tweezers
- Zebra printer and computer

Instruction

This instruction should be used when you are intending to exchange an old label or assemble a new one.

NOTE!

Notice the position of the label before removal.

Only one label is allowed on the frame.

1. Read the old label and/or write the information into the Labelmake program.
2. Heat up the label with a hot air flow solder station, if needed.
3. Carefully remove the label, make sure that all residues are gone. If necessary, clean the surface with Isopropyl alcohol. Do not scratch the frame.
4. Check that the right label format is loaded in the Zebra printer.
5. Write a new label by using the program Labelmake. Check that the printing is ok.
6. Take the new label and place it onto the frame according to *Fig 1*. Make sure that the label is placed in the right position.



Fig 1

5 Revision History

Rev.	Date	Changes / Comments
A	2004-07-02	Initial release
B	2004-07-13	Revision update due to publishing problems
C	2004-08-19	K500 Added
D	2004-10-08	Snap Tool information added
E	2005-04-19	Updated with heading 3.24 (Irda window)