



Working Instructions, SP/Mechanical

Applicable for T610/T618

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1 Disassembly

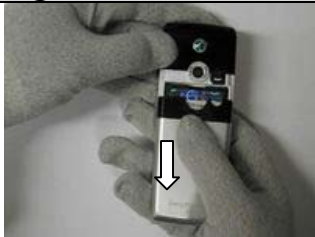


Process Tools

- Torque screwdriver, torx no.6 set to 20 Ncm.
- Blunt Pair of tweezers
- Antenna Cover Opener NTZ 112 520
- Flex film Assembly Tool NTZ 112 521
- Front opening tool NTZ 112 302
- Camera gasket assembly tool NTZ 112 507



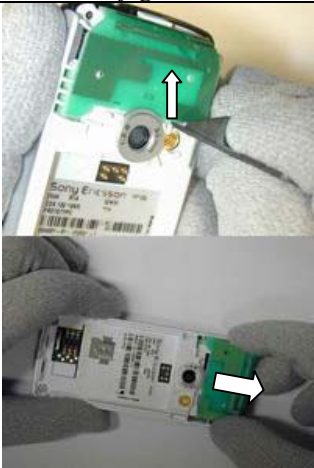

Equipment

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



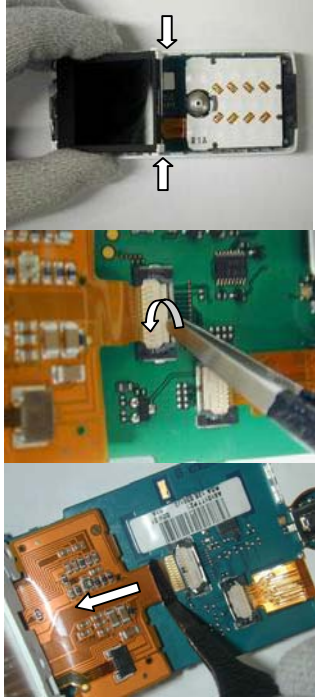
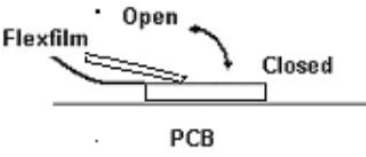
Instructions

#	Figure	Instruction	Note
1	 <i>fig1.1</i>	Remove the battery cover with your fingers. Slide the battery cover down. <i>(fig1.1)</i>	
2	 <i>fig1.2</i>	Remove the battery by lifting it up with your fingers. <i>(fig1.2)</i>	
3	 <i>fig1.3</i>	Remove the rubber plug for the external antenna with a pair of tweezers. <i>(fig1.3)</i>	

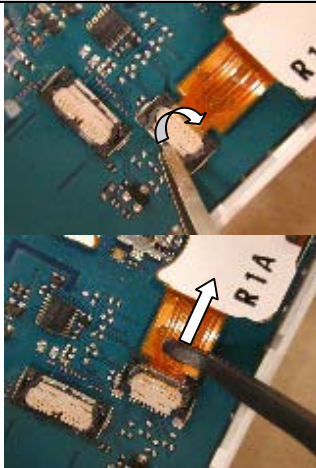
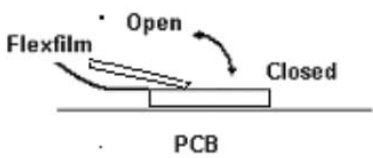
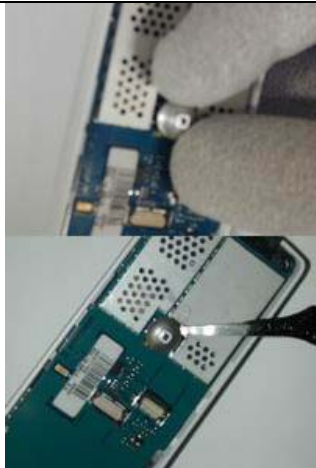

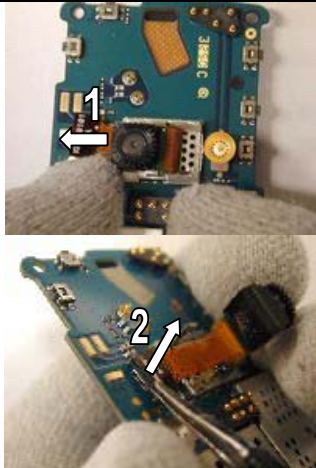


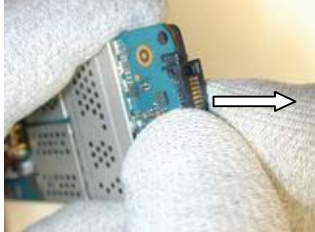


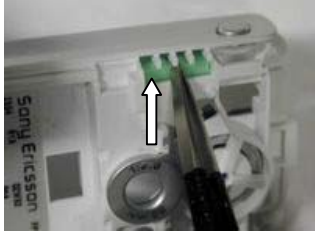


#	Figure	Instruction	Note
4	 <i>fig 1.4</i>	Remove the antenna cover. Use the Antenna Cover Opening tool. Push the tool inside the battery cavity in the arrow direction until it contacts the battery cavity wall. The cover should only be pushed until the snap lock is released. Then remove the antenna cover with your fingers. <i>(fig 1.4)</i>	Be careful not to damage the close clips on the antenna cover with the antenna cover opening tool. If you damage it you must replace the antenna cover.
5	 <i>fig1.5</i>	Remove the on/off key with your fingers. <i>(Fig. 1.5)</i>	
6	 <i>fig1.6</i>	Remove the antenna assembly by using the front opening tool NTZ 112 302. Release it and then gently remove it with your fingers. <i>(fig1.6)</i>	Gently push the antenna assembly in the arrow direction.
7	 <i>fig1.7</i>	Remove the 4 screws. <i>(fig1.7)</i>	Removed screws can not be reused and must be scrapped.



#	Figure	Instruction	Note
8	 <i>fig 1.8</i>	<p>Open the phone with the Front opening tool.</p> <p>Begin as the picture shows.</p> <p>If necessary gently move the tool along the gap both ways until the latch on the inside is loose. If necessary do the same thing at the other side.</p> <p>(Fig 1.8)</p>	<p>Be careful not to scratch the phone with the Front opening tool.</p>
9	 <i>fig 1.9</i>	<p>Remove the keyboard with your fingers.</p> <p>(fig 1.9)</p>	
10	 <i>fig 1.10</i>	<p>Lift the display up with your fingers. You may have to loose the latches at the arrows.</p> <p>Open the FPC- connector connected to the display with a pair of tweezers.</p>  <p>Remove the Flex film from the FPC-connector with the flex-film-assembly tool.</p> <p>(fig 1.10)</p>	<p>Do not touch the display-glass with your fingers</p> <p>Be careful not to damage the FPC-connector.</p> <p>Use the correct pair of tweezers !!</p>



#	Figure	Instruction	Note
11	 <p><i>fig1.11</i></p>	<p>Open the FPC-connector connected to the dome foil assembly with a pair of tweezers.</p>  <p>Remove the Flex film from the FPC- connector with the flex film assembly tool.</p> <p>(<i>fig1.11</i>)</p>	<p>Be careful not to damage the FPC-connector.</p> <p>Use the correct pair of tweezers !!</p>
12	 <p><i>fig 1.12</i></p>	<p>Remove the joystick button with your fingers.</p> <p>If necessary use a pair of tweezers. Put the tweezers under the joystick button and press gently upwards.</p> <p>(<i>fig 1.12</i>)</p>	<p>Be careful not to damage the button,gasket and PCB when using a pair of tweezers.</p>
13	 <p><i>Fig1.13</i></p>	<p>Release the PCB from the Frame cavity by overturn the frame.</p> <p>(<i>fig 1.13</i>)</p>	
14	 <p><i>Fig1.14</i></p>	<p>Remove the camera from the camera holder by sliding it gently with your fingers in the arrow (1) direction.</p> <p>Lift the camera board to board connector (2) gently with a pair of tweezers.</p> <p>(<i>fig1.14</i>)</p>	<p>Be careful not to damage the camera holder or camera flexfilm when removing the camera.</p> <p>Be careful not to damage the components on the PCB when using the pair of tweezers.</p>

#	Figure	Instruction	Note
15	 <p><i>Fig 1.15</i></p>	Remove the system connector from the board with your fingers. <i>(fig 1.15)</i>	
16	 <p><i>fig1.16</i></p>	Remove the speaker gasket. Use a pair of tweezers. <i>(fig 1.16)</i>	Removed speaker gasket can not be reused and must be scrapped. Do not touch the contact pads on the speaker with your fingers.
17	 <p><i>fig1.17</i></p>	Pick up the speaker from the frame cavity with a pair of tweezers. <i>(fig 1.17)</i>	Do not touch the contact pads on the speaker with your fingers.
18	 <p><i>fig1.18</i></p>	Remove the vibrator by pushing it from the rear end of the frame with a pair of tweezers. <i>(fig1.18)</i>	Do not touch or damage the vibrator contact springs.
19	 <p><i>fig1.19</i></p>	Pick up the microphone from the Frame with a pair of tweezers. <i>(fig 1.19)</i>	Do not touch the elastomer by your fingers.
20	 <p><i>fig1.20</i></p>	Gently push the Volume/camera key in from the outside (1) then pick it up on the inside with a pair of tweezers. <i>(fig1.20)</i>	Be gentle ! The rubber can be damaged when picking it up (2)

#	Figure	Instruction	Note
21	 <p><i>fig 1.21</i></p>	<p>Remove the internet access key by gently pushing it from the outside in (1)</p> <p>Pick it up on the inside with a pair of tweezers.</p> <p><i>(fig 1.21)</i></p>	<p>Be gentle ! The rubber can be damaged when picking it up (2)</p>
22	 <p><i>fig 1.22</i></p>	<p>Remove the Sim lock lid with your fingers by first open it..</p> <p>Lift it up (1) and then pull it backwards (2).</p> <p><i>(fig 1.22)</i></p>	
23	 <p><i>fig 1.23</i></p>	<p>Remove the camera ring by pressing it out with the camera gasket assembly tool.</p> <p><i>(fig 1.23)</i></p>	<p>The camera ring is not to be reused.</p>

2 Reassembly


Process Tools

- Torque screwdriver, torx no.6 set to 20 Ncm.
- Blunt Pair of tweezers.
- Flex film Assembly Tool NTZ 112 521
- Camera gasket assembly tool NTZ 112 507






Equipment

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



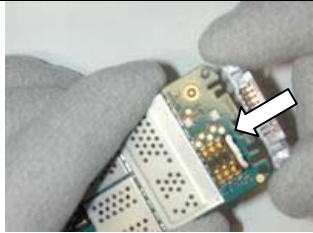
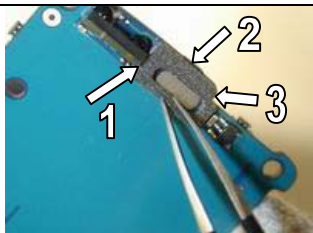

Instructions

#	Figure	Instruction	Note
24	 <p><i>fig2.1</i></p>	<p>Put the SIM-lock lid into the frame cavity (1) flip it down (2) and lock it (3).</p> <p><i>(fig 2.1)</i></p>	

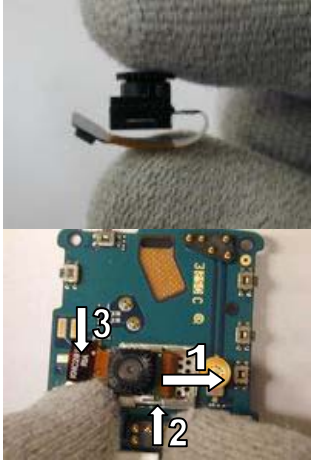

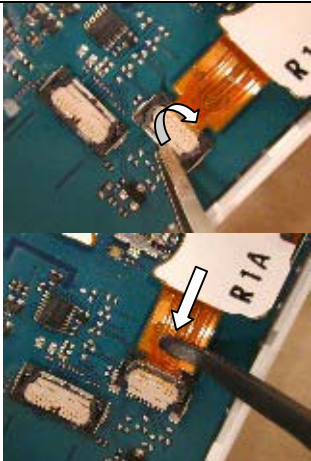
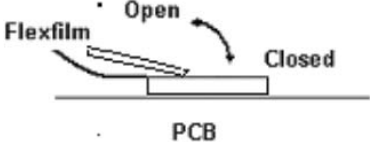


#	Figure	Instruction	Note
25	 <p><i>fig 2.2</i></p>	<p>Remove the camera gasket from the carrier tape with the camera gasket tool</p> <p>Mount the camera gasket in the camera ring with the Camera gasket tool.</p> <p>Mount the camera ring in the frame cavity with the camera gasket tool (fig2.2)</p>	<p>Make sure that the adhesive side is up (in the arrow direction).</p> <p>Make sure the camera ring is oriented correctly. The text “33mm” shall be at the same side as the antenna connector opening.</p>
26	 <p><i>fig2.3</i></p>	<p>Mount the vibrator with a pair of tweezers. Push it gently down, with the contact springs up, into the frame cavity with the flywheel in the arrow direction. (fig 2.3).</p>	<p>Do not touch or damage the vibrator contact springs.</p>
27	 <p><i>fig2.4</i></p>	<p>Put the microphone in its place with a pair of tweezers. The microphone does not have to be mounted in any special direction. (fig2.4)</p>	<p>Do not touch the elastomer with your fingers but make sure the elastomer is pointing upwards.</p>
28	 <p><i>fig2.5</i></p>	<p>Mount the internet access key with the narrow side down. Use a pair of tweezers. The rubber mat extended must be tight attached to the cavity walls. (fig 2.5)</p>	<p>Be careful not to damage the rubber with the pair of tweezers (arrow).</p>
29	 <p><i>fig2.6</i></p>	<p>Mount the volume/camera key with a pair of tweezers. The rubber mat extended must be fitted behind the support pegs at the arrows. (fig 2.6)</p>	<p>Make sure that the volume/camera key rubber has contact with the Frame cavity walls.</p> <p>Be careful not to damage the rubber with the pair of tweezers.</p>

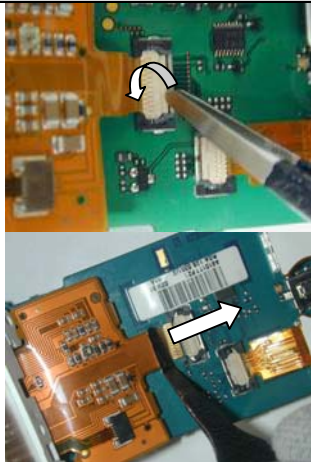
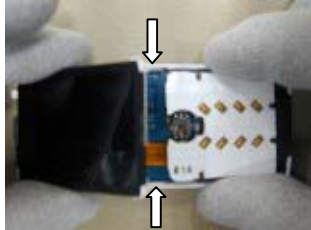
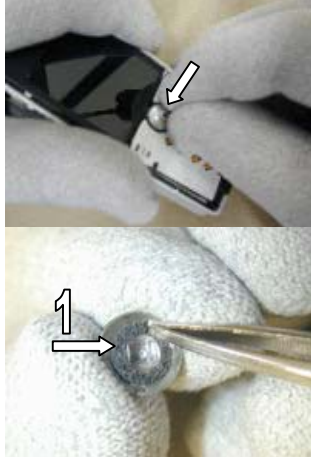






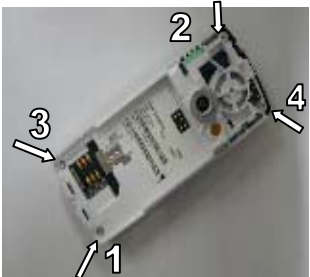

#	Figure	Instruction	Note
30	 <i>fig2.7</i>	Pick up the speaker from the tape & reel with the flex film assembly tool and mount the speaker in the Frame cavity. (fig.2.7).	The contact pads on the speaker must be mounted upwards. Do not contaminate the speaker contact pads.
31	 <i>fig2.8</i>	Mount the speaker gasket over the speaker. The gasket shall not cover the contact pads and speaker cavity edge at the arrows. (fig 2.8)	
32	 <i>fig 2.9</i>	Mount the system connector on the PCB with your fingers. Push it on in the arrow direction (fig 2.9)	The system connector will be straight and parallel to the bottom line of the PCB. Wrongly mounted it can cause damage to the small components close to the PCB bottom line.
33	 <i>fig 2.10</i>	Mount the sound channel gasket on the PCB with a pair of tweezers. Use the IRDA sidewall (1), the PCB edge (2) and the PCB cut (3) to place it in the correct position. (fig2.10)	
34	 <i>fig 2.11</i>	Mount the camera holder over the shielding can with your fingers. Snap fit the holder centred over the shielding can and make sure that the camera stop pin (arrow) is correctly oriented. (fig 2.11)	The camera holder has normally not been removed in disassembly. This is only to be done if the camera holder has been removed by accident.

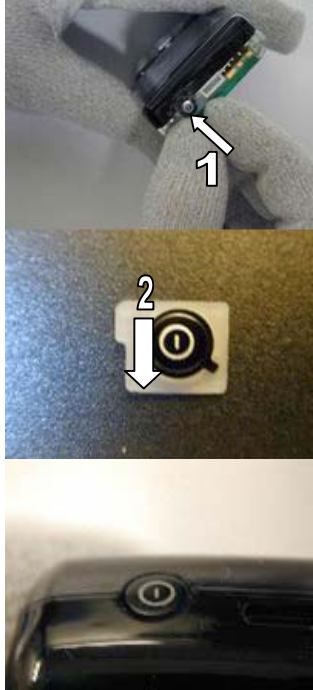





#	Figure	Instruction	Note
35	 <i>Fig2.12</i>	<p>Pick up the camera with your fingers. The flex film on the camera must be folded under the camera.</p> <p>Push the camera into the camera holder (1) and use the camera stop pins (2) for the right position.</p> <p>Snap fit the camera flex film (3) on to the PCB connector with your fingers.</p> <p>(fig2.12)</p>	
36	 <i>fig2.13</i>	<p>Place the PCB in the frame cavity.</p> <p>Start by putting the volume and camera switch side into frame cavity and then lay the PCB down.</p> <p>(fig2.13).</p>	<p>Make sure that the switches on the PCB are in contact with the camera/volume key.</p> <p>Check also that the switch for internet is in contact with the internet key.</p>
37	 <i>fig 2.14</i>	<p>Open the FPC connector and mount the dome foil into the FPC connector.</p>  <p>Take a new Key foil and mount it in the FPC connector. Push it into the FPC connector with the flex film assembly tool. It is in the proper position when the edge is tight to the FPC connector.</p> <p>(fig 2.14)</p>	<p>Be careful not to damage the flex film with the flex film assembly tool.</p> <p>Make sure the FPC connector is properly closed.</p>



#	Figure	Instruction	Note
38	 <p><i>fig2.15</i></p>	<p>Open the FPC connector and mount the display assembly flex film into the FPC connector.</p> <p>Use the flex film assembly tool. Close the ZIF connector with a pair of tweezers. (<i>fig 2.15</i>)</p>	<p>Make sure the flex film is in the proper position before closing the FPC connector.</p> <p>Be careful not to damage the flex film with the tool.</p> <p>Make sure that the ZIF connector is properly closed.</p>
39	 <p><i>fig 2.16</i></p>	<p>Gently press the display edges with your thumbs until the two latches at the arrows locks the display assembly in the proper position with a “click” sound. (<i>fig 2.16</i>)</p>	
40	 <p><i>fig 2.17</i></p>	<p>Press the joystick button down onto the square plastic pin on the joystick switch.</p> <p>Make assure the gasket (1) is left on the button (<i>fig2.17</i>)</p>	<p>The button does not have to be oriented in any special direction.</p>
41	 <p><i>fig2.18</i></p>	<p>Pick up the keyboard with your fingers and mount it over the dome foil assembly. Use the 4 guiding pins on the dome foil assembly to mount the keyboard in its correct position. (<i>fig2.18.</i>)</p>	

#	Figure	Instruction	Note
42	 fig2.19	<p>Pick up the front and remove the dust protection foil inside the front with a pair of tweezers. Make sure no dust, particles or adhesive remains on the glass.</p> <p>(fig2.19)</p>	<p>Be careful not to scratch the inside of the window with the pair of tweezers.</p> <p>It is very important to make sure the front glass is clean.</p> <p>Use air blow equipment</p>
43	 fig2.20	<p>Remove the display protection foil. Remove the adhesive residue and all kinds of dust particles before mounting the front and frame together.</p> <p>(fig2.20)</p>	<p>It is very important to make sure the display is clean.</p> <p>Use air blow equipment.</p>
44	 fig 2.21	<p>Place the front over the frame.</p> <p>(fig 2.21)</p>	
45	 fig2.22	<p>Mount the screws with washers in the order 1 to 4.</p> <p>(fig2.22)</p>	<p>Use Torque screwdriver torx no 6 set to 20 Ncm Screw until the torque is reached.</p> <p>Removed screws cannot be reused and must be scrapped.</p>
46	 fig2.23	<p>Place the antenna assembly on the cavity as the picture shows with your fingers. Then push the antenna assembly in the arrow direction until a click sound is heard.</p> <p>(fig 2.23)</p>	<p>Be careful not to damage the pogo pins on the board.</p>

#	Figure	Instruction	Note
47	 <p><i>fig2.24</i></p>	<p>Mount the on/off key with your fingers (1).</p> <p>The narrow end on the on/off key (2) shall be mounted in the front.</p> <p>Correct oriented (<i>fig2.24</i>)</p>	
48	 <p><i>fig 2.25</i></p>	<p>Mount the rubber plug for the external antenna connector. (<i>fig 2.25</i>)</p>	<p>Make sure the rubber plug is correct oriented.</p> <p>See the cut corner at the arrow.</p>
49	 <p><i>fig2.26</i></p>	<p>Push the antenna cover in the arrow direction over the antenna assembly with your fingers. (<i>fig 2.26</i>)</p>	<p>Make sure that the antenna cover has not been damaged when opening the phone. If the close clip or any other part is damaged, the antenna cover must be replaced.</p>
50	 <p><i>fig2.27</i></p>	<p>Push and press on the antenna cover with your thumbs until it properly fits in place with a click sound. (<i>fig 2.27</i>)</p>	<p>Press down against the frame where the left snap lock is located on the antenna cover.</p>



3 Replacement of Mechanical Parts

3.1 Microphone

3.1.1 Process tools



- Pair of tweezers

3.1.2 Equipment

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

3.1.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig 3.1.1</i>	Remove the microphone from the frame cavity with a pair of tweezers. <i>(fig3.1.1)</i>	
2	 <i>fig3.1.2</i>	Pick up the new microphone with a pair of tweezers. Mount the microphone in the cavity in the frame. Press the microphone to the bottom of the frame cavity <i>fig3.1.2)</i>	Do not touch the elastomer. The microphone does not have to be oriented in any special direction except the elastomer that must be pointing upwards

- Assemble the phone as described in *2 Reassembly*

3.2 Vibrator Assembly

3.2.1 Process Tools


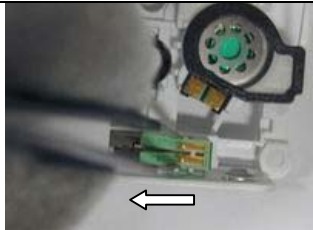
- Pair of tweezers.

3.2.2 Equipment

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

3.2.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig3.2.1</i>	Remove the vibrator. Use a pair of tweezers. <i>(fig 3.2.1)</i>	To remove the vibrator press on it from the rear side of the frame
2		Take a new vibrator.	Hold the vibrator on the rubber parts.
3	 <i>fig3.2.2</i>	Mount the vibrator in the frame cavity with a pair of tweezers. <i>(fig3.2.2).</i>	Do not touch or damage the vibrator contact springs. The flywheel shall be in the arrow direction

- Assemble the phone as described in *2 Reassembly*



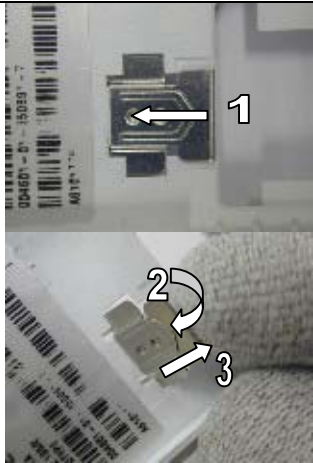

3.3 SIM-lock lid

3.3.1 Equipment

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

3.3.2 Instructions

- Disassemble the phone as described in 1 Disassembly

1	 <p><i>fig3.3.1</i></p>	<p>Remove the old SIM-lock lid with your fingers by first pushing it in open position (1)</p> <p>Lift it up (2) and pull it backwards (3)</p> <p><i>(fig3.3.1)</i></p>	
2	 <p><i>fig3.3.2</i></p>	<p>Mount the SIM-lock lid with your fingers. Put the SIM-lock lid into the frame (1) cavity and push it down (2)</p> <p>Lock the SIM-lock lid by pushing it backwards (3).</p> <p><i>(fig3.3.2)</i></p>	

- Assemble the phone as described in 2 Reassembly

3.4 Speaker

3.4.1 Process Tools

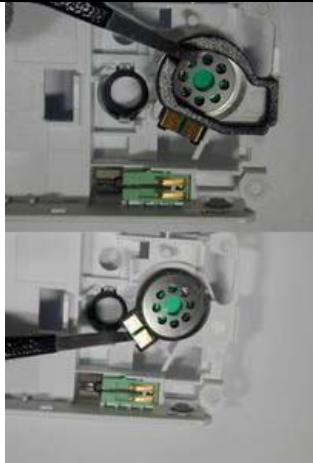
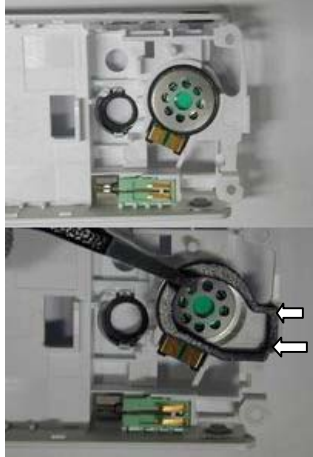
- Pair of tweezers

3.4.2 Equipment

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

3.4.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <p><i>fig3.4.1</i></p>	<p>Remove the speaker gasket with a pair of tweezers.</p> <p>Remove the speaker with a pair of tweezers. (<i>fig3.4.1</i>).</p>	
2	 <p><i>fig3.4.2</i></p>	<p>Mount the speaker in the frame cavity with a pair of tweezers</p> <p>Mount the speaker gasket over the speaker. The gasket shall not cover the contact pads and speaker cavity edge at the arrows. (<i>fig3.4.2</i>)</p>	<p>Do not touch the speaker pads with your fingers.</p>

- Assemble the phone as described in *2 Reassembly*


3.5 Keyboard

3.5.1 Equipment

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

3.5.2 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <p><i>fig3.5.1</i></p>	Replace the old keys with a new set with your fingers. <i>(fig3.5.1)</i>	Use the 4 guiding pins on the dome foil assembly to mount the keypad in the proper position.

- Assemble the phone as described in *2 Reassembly*

3.6 Volume/Camera Key

3.6.1 Process Tools



- Pair of tweezers.

3.6.2 Equipment

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

3.6.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <p><i>fig3.6.1</i></p>	<p>Gently push the Volume/camera key in from the outside (1) then pick it up on the inside with a pair of tweezers.</p> <p><i>(fig3.6.1)</i></p>	<p>Be gentle ! The rubber can be damaged when picking it up (2)</p>
2	 <p><i>fig3.6.2</i></p>	<p>Take a new volume/camera key and mount it in the frame with a pair of tweezers. The rubber mat extend must be fitted behind the support pegs at the arrows.</p> <p><i>(fig 3.6.2)</i></p>	<p>Make sure that the volume/camera key rubber has contact with the Frame cavity walls.</p> <p>Be gentle ! The rubber can be damaged when picking it up</p>

- Assemble the phone as described in *2 Reassembly*



3.7 Internet Access Key

3.7.1 Process tools

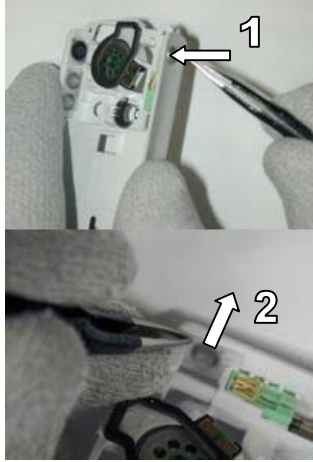

- Pair of tweezers

3.7.2 Equipment

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

3.7.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig3.7.1</i>	Remove the internet access key by gently pushing it from the outside in (1) and then pick it up on the inside with a pair of tweezers (2). <i>(fig 3.7.1)</i>	Be gentle ! The rubber can be damaged when picking it up (2)
3	 <i>fig3.7.2</i>	Mount the internet access key with a pair of tweezers. The rubber mat extend must be tight attached to the cavity walls. <i>(fig 3.7.2)</i>	Be careful not to damage the rubber with the pair of tweezers (arrow).

- Assemble the phone as described in *2 Reassembly*

3.8 Sound channel Gasket

3.8.1 Process Tool

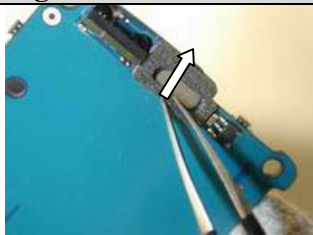
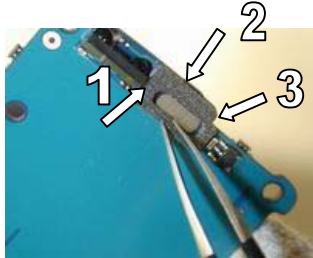
- Pair of tweezers.

3.8.2 Equipment

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

3.8.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig3.8.1</i>	Remove the sound channel gasket from the PCB with a pair of tweezers. (fig3.8.1)	Do not reuse the sound channel gasket.
2		Take a new sound channel gasket with a pair of tweezers.	
3	 <i>fig3.8.2</i>	Mount the sound channel gasket onto the PCB. Use the IRDA sidewall (1), the PCB edge (2) and the PCB cut (3) to place it in the proper position. (fig 3.8.2)	

- Assemble the phone as described in *2 Reassembly*

3.9 Joystick gasket

3.9.1 Process Tool



- Pair of tweezers.

3.9.2 Equipment

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

3.9.3 Instructions

Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig 3.9.1</i>	<p>Remove the old joystick gasket with a pair of tweezers.</p> <p>The joystick gasket is not always possible to remove in one piece.</p> <p>(<i>fig 3.9.1</i>)</p>	<p>Remove all left residues with alcohol.</p>
2	 <i>fig 3.9.2</i>	<p>. Pick up the joystick gasket with a pair of tweezers and the joystick with your fingers. Place the gasket in the centre of the joystick button</p> <p>. (<i>fig 3.9.2</i>)</p>	

- Assemble the phone as described in *2 Reassembly*



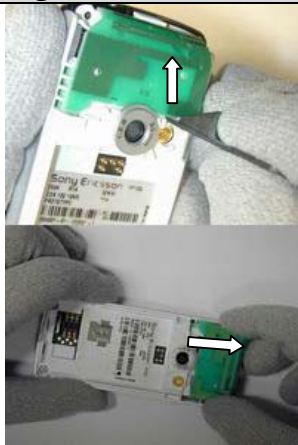

3.10 Antenna assembly

3.10.1 Equipment

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

3.10.2 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig3.10..1</i>	Remove the antenna assembly Use the front opening tool to release it and then gently remove it with your fingers (<i>fig 3.10.1</i>)	Push the antenna assembly forward in the arrow direction.
2		Take a new antenna assembly.	
3	 <i>fig3.10.2</i>	Place the antenna assembly on the cavity with your fingers as the picture shows. Then push the antenna assembly in the arrow direction until a click sound is heard. (<i>fig 3.10.2</i>)	Be careful not to damage the pogo pins on the board.

- Assemble the phone as described in *2 Reassembly*



3.11 Dome Foil assembly

3.11.1 Process tool

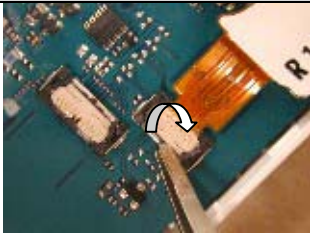
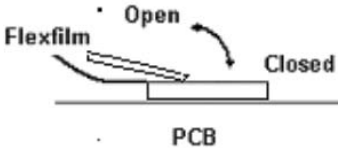
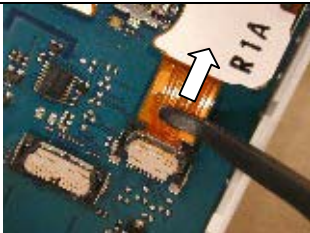
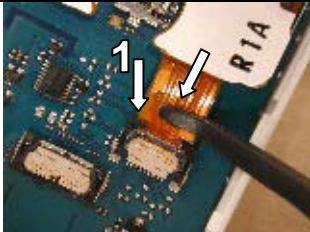
- Blunt Pair of tweezers
- Flexfilm assembly tool NTZ 112 521

3.11.2 Equipment

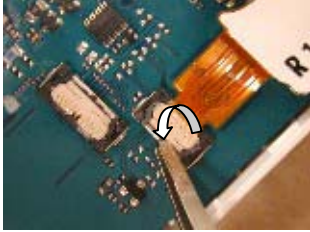
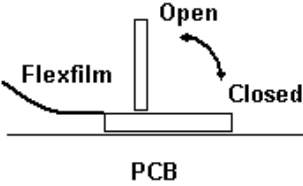
- ESD-gloves (cotton gloves)
- ESD-wristband

3.11.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <p><i>Fig3.11.1</i></p>	<p>Open the FPC connector to the key foil assembly with a pair of tweezers.</p>  <p>(fig3.11.1)</p>	Be careful not to damage the FPC-connector.
2	 <p><i>Fig 3.11.2</i></p>	<p>Remove the dome foil with the flex film assembly tool.</p> <p>(fig 3.11.2)</p>	
3	 <p><i>Fig 3.11.3</i></p>	<p>Take a new Key foil and mount it in the FPC connector. Push it into the FPC connector with the flex film assembly tool. It is in the proper position when the edge (1) is tight to the FPC connector.</p> <p>(fig 3.11.3)</p>	Be careful not to damage the flex film with the flex film assembly tool.



#	Figure	Instruction	Note
4	 <i>Fig3.11.4</i>	<p>Close the FPC connector with a pair of tweezers.</p>  <p>(fig3.11.4)</p>	

- Assemble the phone as described in 2 *Reassembly*



3.12 Display assembly

3.12.1 Process tool

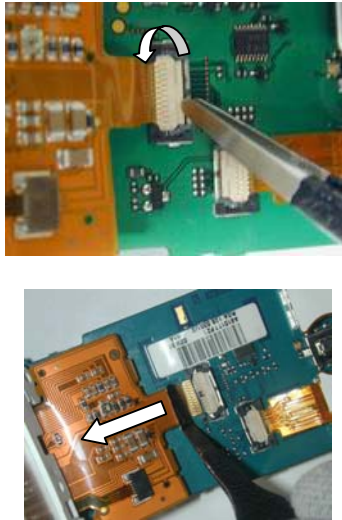
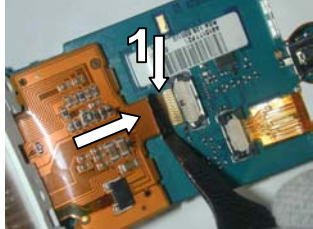
- Blunt Pair of tweezers
- Flex film assembly tool NTZ 112 521

3.12.2 Equipment

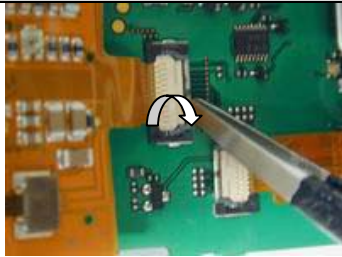
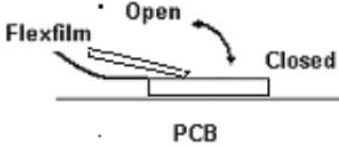
- ESD-gloves (cotton gloves)
- ESD-wristband

3.12.3 Instructions

- Disassembly the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig3.12.1</i>	<p>Lift the display up with your fingers and open the FPC-connector connected to the display with a pair of tweezers.</p> <p>Remove the Flex film from the FPC-connector with the flex- film-assembly tool. . (<i>fig 3.12.1</i>)</p>	<p>Be careful not to damage the FPC-connector.</p> <p>Do not touch the display-glass with your fingers.</p> <p>Use the correct pair of tweezers !!</p>
3	 <i>fig3.12.2</i>	<p>Take a new display assembly and mount it in the FPC connector. Push the flex film into the FPC connector with the flex film assembly tool. It is in the proper position when the edge (1) is tight to the FPC connector. (<i>fig3.12.2</i>)</p>	<p>Be careful not to damage the flex film with the flex film assembly tool.</p>



#	Figure	Instruction	Note
4	 <p><i>fig 3.12.3</i></p>	<p>Close the FPC connector with a pair of tweezers.</p>  <p>(fig3.12.3)</p>	<p>Be careful not to damage the flex film with the tool.</p> <p>Make sure that the FPC connector is properly closed.</p>

- Assemble the phone as described in 2 Reassembly



3.13 Camera ring and camera ring gasket

3.13.1 Process tool



- Camera gasket tool NTZ 112 507
- Pair of tweezers.

3.13.2 Equipment

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

3.13.3 Instructions

- Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig3.13.1</i>	Remove the camera ring by pressing it out with the camera gasket assembly tool. (Fig 3.13.1)	The camera ring is not to be reused.
2	 <i>fig3.13.2</i>	Remove the camera gasket from the carrier tape with the camera gasket tool Mount the camera gasket in the camera ring with the Camera gasket tool. Mount the camera ring in the frame cavity with the camera gasket tool (fig3.13.2)	Make sure that the adhesive side is up (in the arrow direction). Make sure the camera ring is oriented correctly. The text “33mm” must be at the same side as the antenna connector opening.

- Assemble the phone as described in *2 Reassembly*

3.14 Front replacement, Light Gasket

3.14.1 Process tools

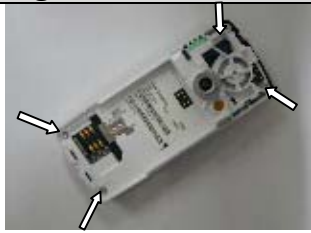



- Pair of tweezers.

3.14.2 Equipment

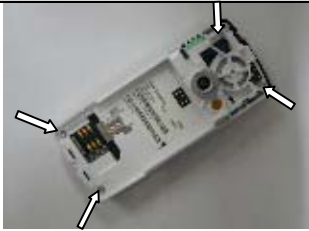


- ESD-gloves (cotton gloves)
- ESD-wristband

3.14.3 Instructions

Disassemble the phone as described in *1 Disassembly*

#	Figure	Instruction	Note
1	 <i>fig3.14.1</i>	Remove the four screws at the arrows. (fig3.14.1)	Use screwdriver, torx no 6. Removed screws cannot be reused and must be scrapped.
2	 <i>fig3.14.2</i>	Mount the light gasket in the front, use a pair of tweezers. (fig 3.14.1)	New fronts are delivered without light gasket
3	 <i>fig3.14.3</i>	Pick up the front and remove the dust protection foil inside the front with a pair of tweezers. Make assure no dust, particles or adhesive remains on the glass. (fig3.14.3)	Be careful not to scratch the inside of the window with the pair of tweezers. It is very important to make sure the front glass is clean. Use air blow equipment
4	 <i>fig3.14.4</i>	Remove the display protection foil. Remove the adhesive residue and all kind of dust particles before mounting the front and frame together (fig3.14.4)	It is very important to make sure the display is clean. Use air blow equipment.



#	Figure	Instruction	Note
1	 <i>fig3.14.1</i>	Remove the four screws at the arrows. (fig3.14.1)	Use screwdriver, torx no 6. Removed screws cannot be reused and must be scrapped.
5	 <i>fig 3.14.5</i>	Place the front over the frame. (Fig 3.14.5)	
6	 <i>fig3.14.6</i>	Mount the screws with washer in the order 1 to 4. (fig3.14.6)	Use Torque screwdriver torx no 6 set to 20 Ncm Screw until the torque is reached. Removed screws cannot be reused and must be scrapped.

Assemble the phone as described in 2 Reassembly



4. Process Tools for Label

- Hot air blower.
- Pair of tweezers.

4.1 Instructions

This instruction should be used when you intend to exchange an old label and/or mount a new one.

1. Heat up the label with a hot air blower.
2. Carefully remove the label, make sure that all the residue is removed. Do not scratch the frame.
3. Printing: The text must be fully readable visually and through bar code readers.
4. Take the new label and place it in the battery cavity. The label should be centred and parallel to the sides of the cavity.

NOTE! Make sure there are no air bubbles under the label. Only one label is allowed in the battery cavity.



5 Revision History

Rev.	Date	Changes / Comments
C	2003-06-06	Chaged picture of Zif -contact
B	2003-05-27	Additional note text when handling the antenna cover
A	2003-04-24	First release