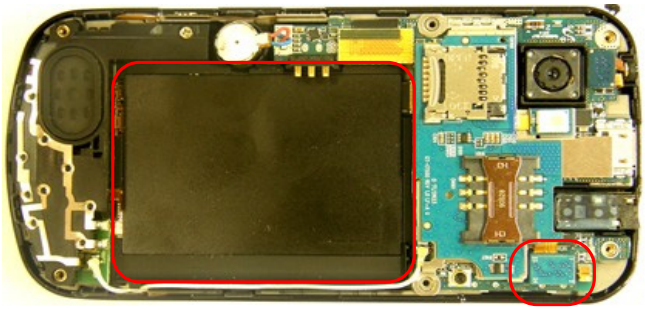
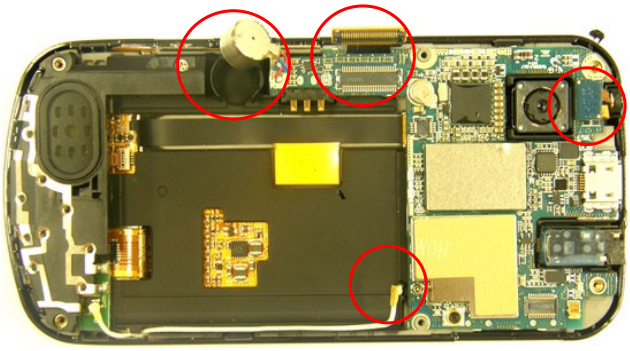
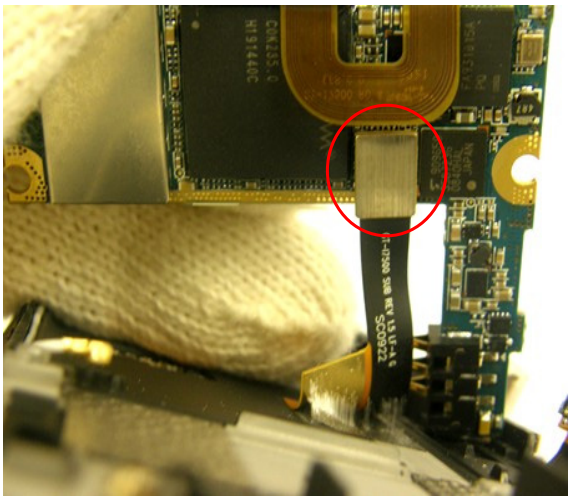
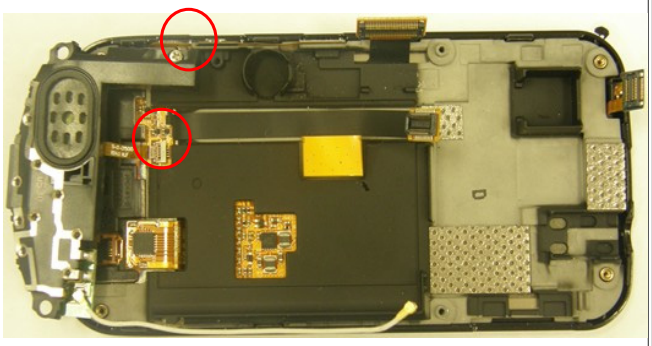
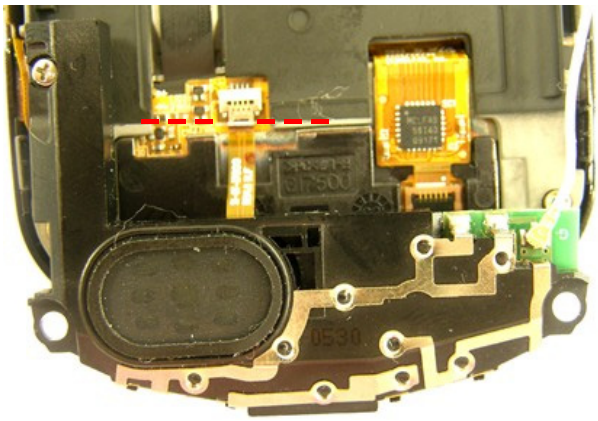
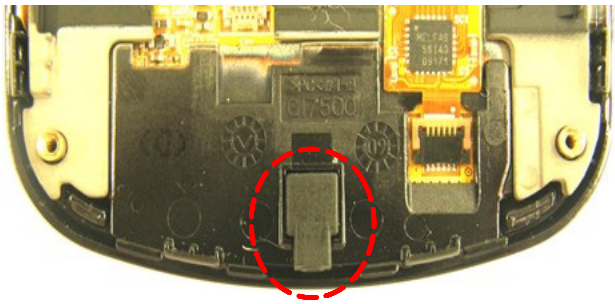
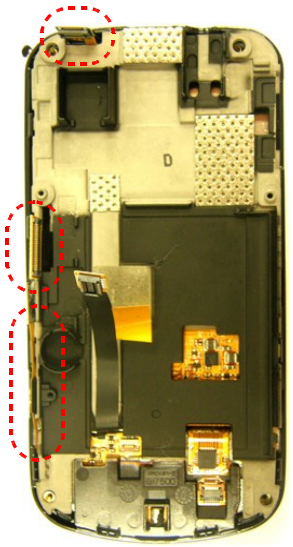
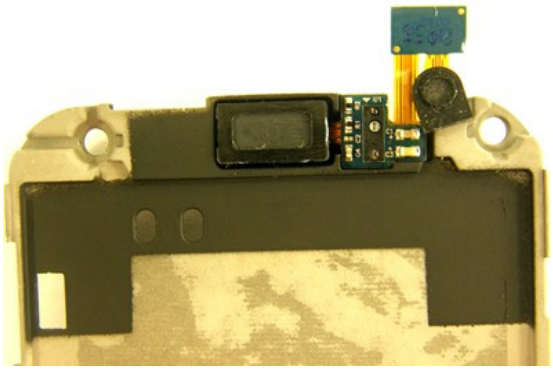
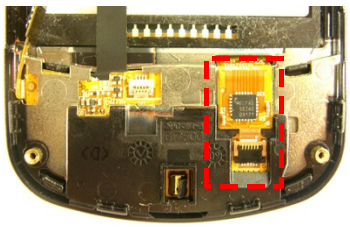
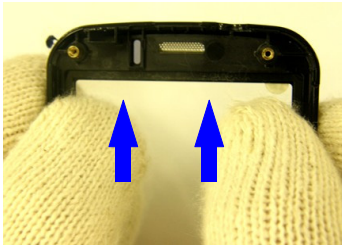
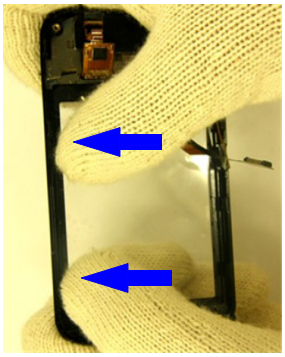
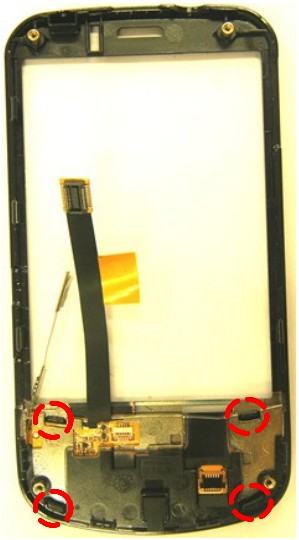
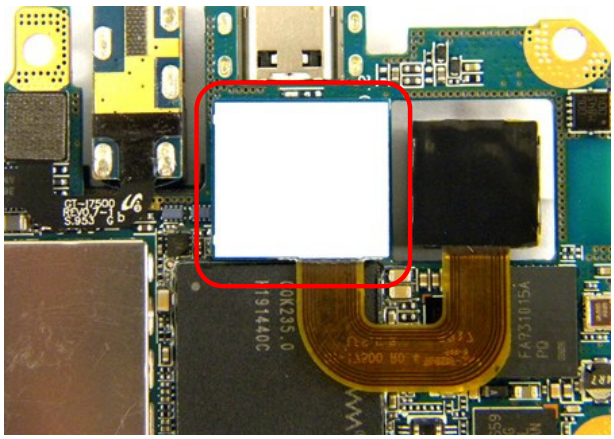
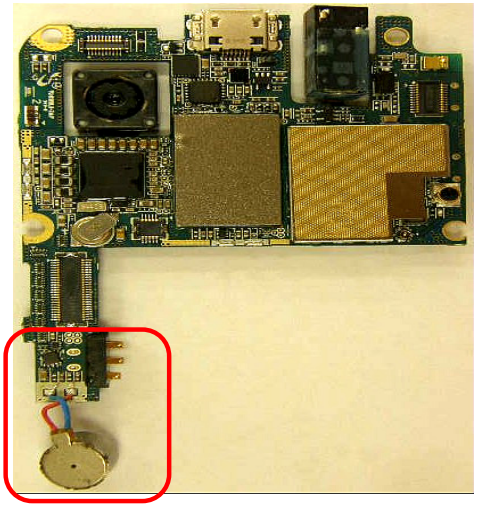
11. Disassembly and Assembly Instructions

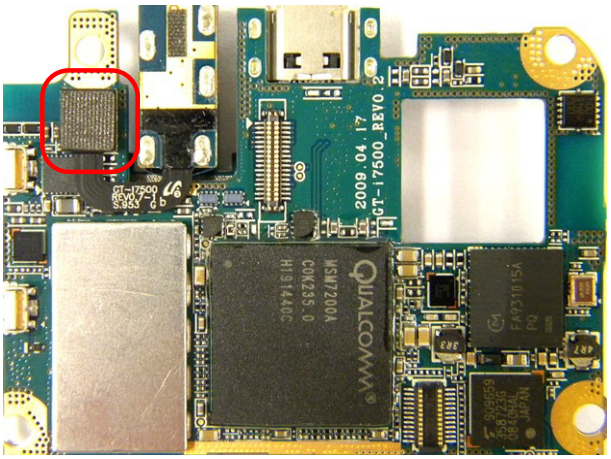
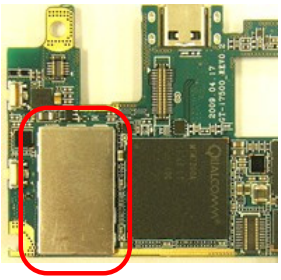
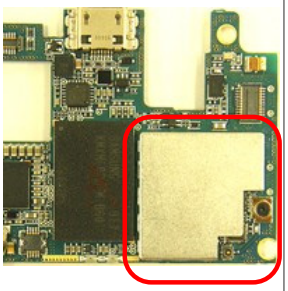
11-1. Disassembly

1 Remove the 'Rear' by unscrewing those 6 points on the picture. 	2 With the disassembly JIG unhook the rear cover 
1) SCREW Torque: 1.2 ~ 1.4kgf.cm	1) Make sure not to damage the rear and leave scratch on it
3 Disconnect the connector of SUB PBA from the Main PBA and remove the tape 	4 Disconnect LCD connector, cable, sensor connector and the motor. 
1) Disconnect the connector of SUB PBA from the Main PBA and remove the tape	1) Make sure not to damage the connectors and FPCBs.

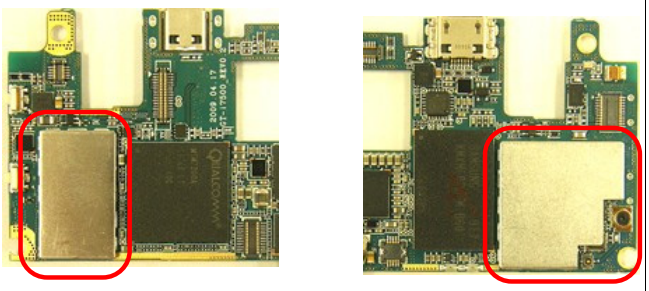
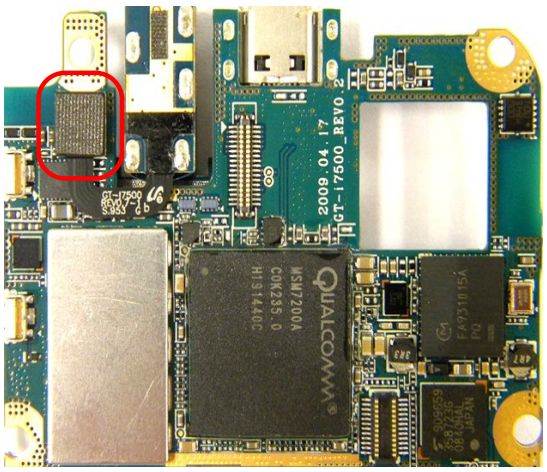
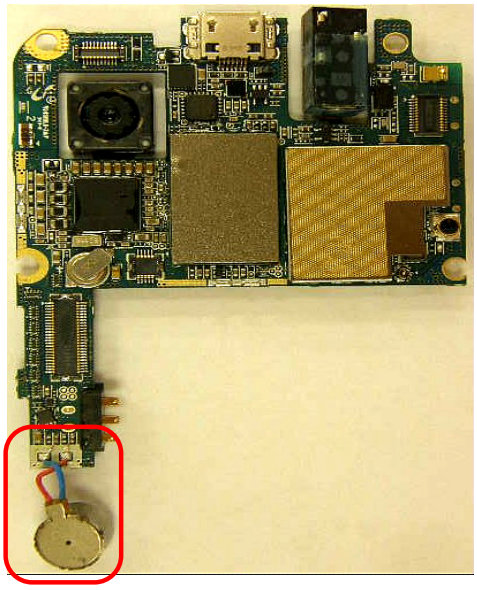
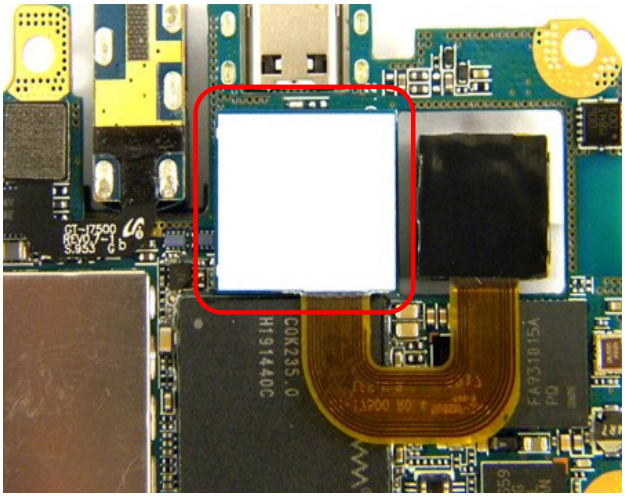
5 Disconnect the Key connector at the back of the PBA 	6 Unscrew the screw and disconnect the FPCB then remove the intenna 
1) Make sure not to damage the connector and the FPCB.	1) SCREW Torque: 1.2 ~ 1.4kgf.cm
7 Open the locker to remove the FPCB. 	8 Remove the rubber cap. 
1) Make sure not to damagme the FPCB during the process.	1) Make sure not to damage the FPCB when disassemble the Sidekey FPCB

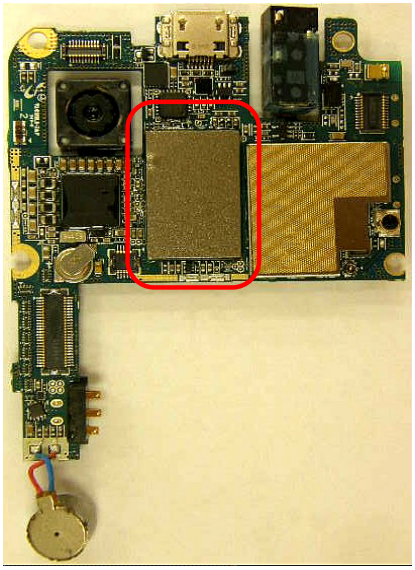
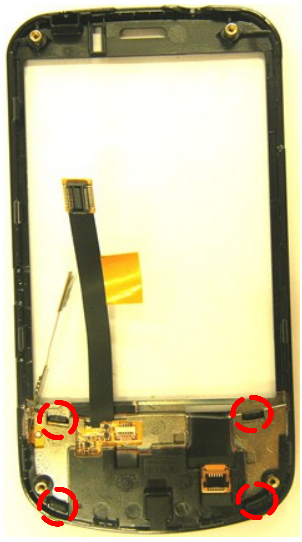
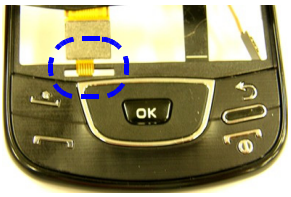
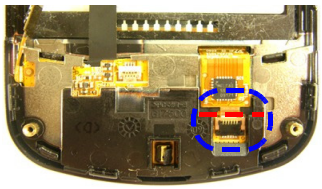
9 Detach the side key FPCB and lift the sensor connector to remove the bracket from the 'front' 	10 Push the sensor from the behind to detach from the bracket. 
1) Make sure not to damage the LCD connector.	1) Make sure not to damage sensor FPCB.
11 1) Lift the upper side of the LCD with those two points on the picture to remove it from the 'front' 2) Open the locker to remove TSP FPCB  	12 1) Leave the TSP ass'y in the high temperature chamber(70℃, 10min) then remove the TSP from the 'front' - TSP disassembly procedure. Top → left & right side → Bottom  
1) Make sure not to damage the LCD	1) Make sure not to damage the TSP

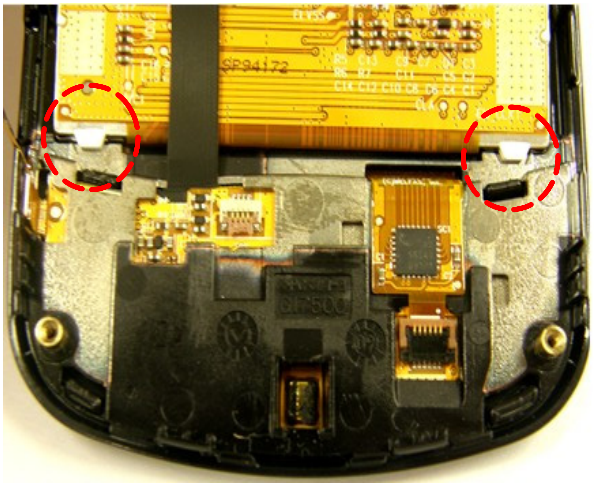
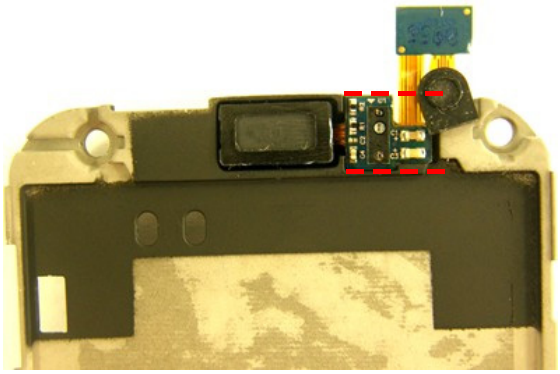
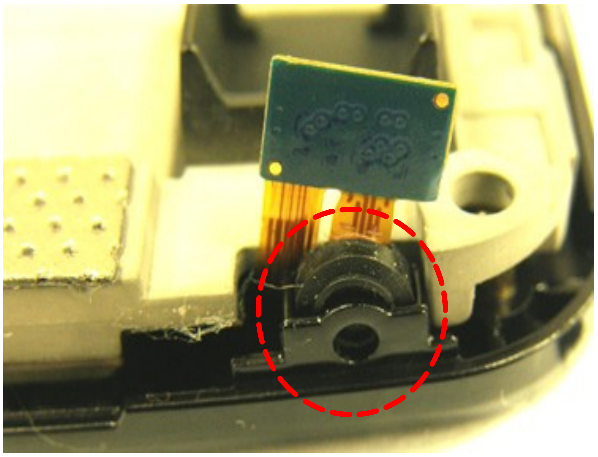
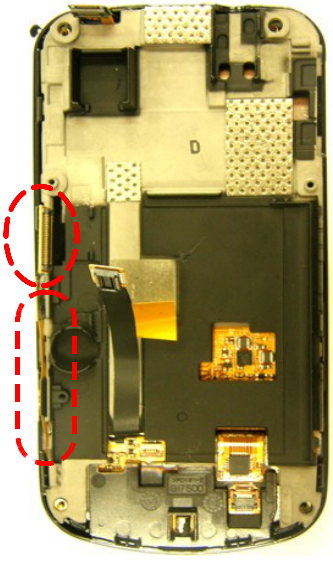
13 Remove the key pad by unhooking those 4 points on the picture. 	14 Remove the KEY FPCB by lifting the bottom with the tweezers 
1) Make sure not to damage the keypad	1) Make sure not to damage the Key FPCB
15 Disconnect the Camera module from the PBA 	16 Iron the solder to remove the motor. (Lead Free : 350~380℃) 
1) Make sure not to damage Camera FPCB	1) Make sure not to damage the components around the motor.

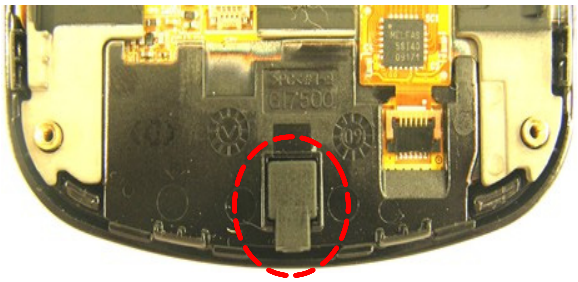
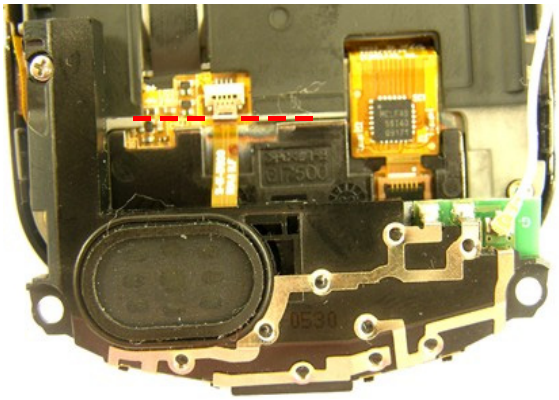
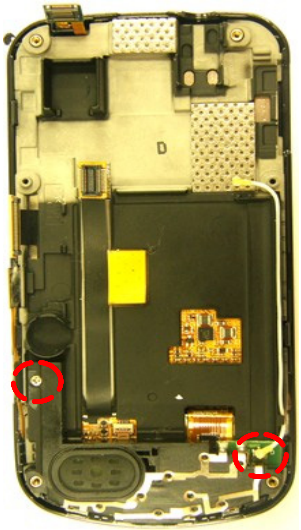
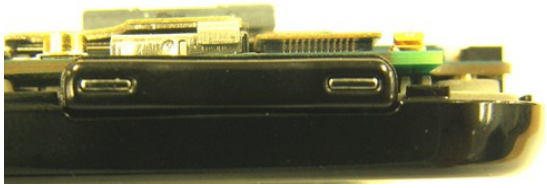
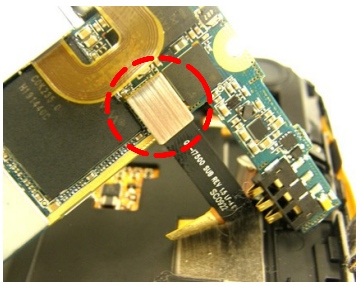
17 Disconnect the ear-jack conncetor.	18 Remove those two shield cans on the picture.
	 
1) Make sure not to damage the ear-jack FPCB	1) Make sure not to damage those shield cans and the components.

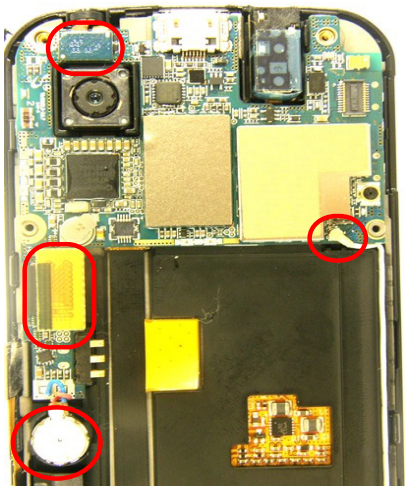
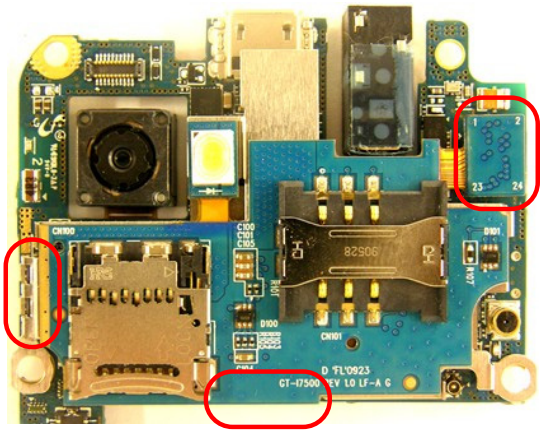
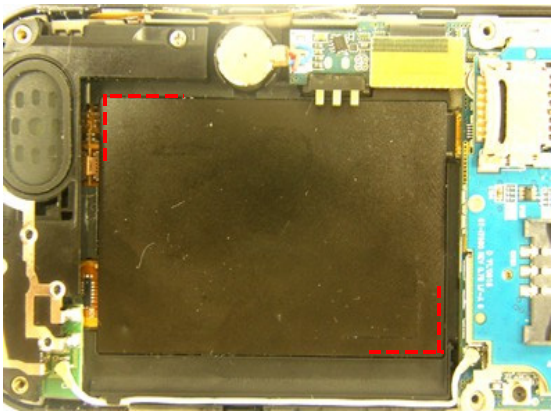
11-2. Assembly

1 Assemble two shield cans on the picture on the PBA 	2 Connect the Ear-jack connector 
1) Make sure not to make any damage on the shield cans.	1) Make sure not to damage FPCB
3 By using iron, solder in motor on the PBA (Lead Free : 350~380℃) 	4 Remove the release paper on the FPCB and connect to the PBA 
1) Make sure not to damage any components around the area.	1) Make sure not to damage the FPCB.

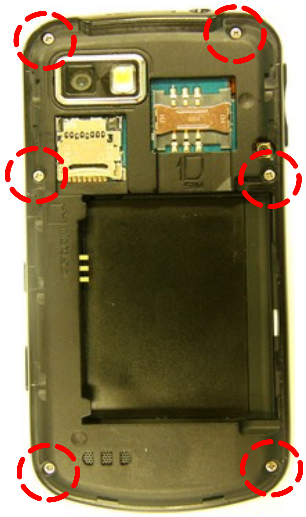
5 Attach the absorber on the memory. 	6 Remove the KEYFPCB release paper then attach from the bottom. 
1) Make sure the absorber is fit inside the border.	1) Make sure not to damage FPCB
7 Assemble keypad by placing 4hooks at the 4 points on the picture 	8 Remove the window release paper and insert FPCB through the groove. Insert it into the connector until the silk reach the margin and lock. Press the window after it is attached.  
1) Make sure not to damage the keypad	1) Make sure not to damage the FPCB while working on it.

9 Remove the release paper and attach the LCD to the 'front' from the bottom where 	10 Removetthe sensor FPCB release paper and insert the receiver inside the platform on the LCD bracket. Then attach the sensor 
1) Make sure not to damage LCD.	1) Make sure not to damage the sensor FPCB and prevent it from sticking out
11 Drivers 4 screws on the rear (torque:1.0~1.2) 	12 Insert the LCD connector through the groove and assemble the bracket with the 'front'. 
1) Make sure MIC rubber does not come off and get damaged.	1) Make sure not to damage the side-key FPCB during assembly.

13 Cover the MIC with the MIC rubber 	14 Insert the speaker FPCB until its silk reach the margin. 
1) Make sure it does get loose.	1) Make sure not to damage the FPCB while inserting it.
15 1) Screw it after the antenna is assembled. 2) Connect the cable and place it inside the groove 	16 Insert the volume key then connect the key connector on the PBA  
1) SCREW Torque: 1.2 ~ 1.4kgf.cm 2) Make sure the cable does not stick out.	1) Make sure not to damage key FPCB.

17 1) Connect LCD, sensor, and intenna cable. 2) Remove the motor release paper and attach the motor to the bracket. 	18 1) Remove the SUB PBA release paper then place SUB PBA can with the clip on the PBA 2) Connect the connector of the SUB PBA on the Main PBA 
1) Make sure not to damage any of these items.	1) Make sure not to damage the clip during SUB PBA assembly. 2) Also try not to damage the connector FPCB.
19 Attach the tape and make it fit inside the margin then press it until it gets not loose. 	20 Assemble the 'rear' starting from the opposite side of the camera key. 
1) Make the tape fit inside the border.	1) Make sure not to damage the 'Lock' key and the Camera key.

21	Screw 6 points and finish assembly.



1) SCREW Torque: 1.2 ~ 1.4kgf.cm