



Assembly/Disassembly Manual

Motorola™ Milestone



GSM 850, 900, 1800, 1900, UMTS 2100, 1900, 850,
Diversity 2100, aGPS

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Mobile Devices Business,

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Tools and Test Equipment

The following table lists tools and test equipment recommended for disassembly and reassembly of DROID telephones. Use either the listed items or equivalents.

Table 1. General Test Equipment and Tools

Motorola Part Number	Description	Application
	Tweezers, plastic	Used during assembly/ disassembly
	Antistatic Mat kit	Provides protection from damage to device caused by electrostatic discharge (ESD)
----	Torque Driver bit T5IP. Torque setting is 1.3 in-lbs or 14.69 N-cm (+10%)	Main housing screws
----	Torque Driver bit T5IP. Torque setting is 1.0 in-lbs or 11.30 N-cm (+10%)	PCB screws
----	Cross JIS #00 screwdriver bit. Torque setting is 1.8 in-lbs or 20.34 N-cm (+10%)	Slider housing screws
19501980 (AMS) ¹	Generic Press Fixture	
4-00-4C-10000 (AMS) ¹	EL Panel Mylar alignment and press	Main keypad Mylar assembly
4-00-4D-10000 (AMS) ¹	Main Lens Press	Lens assembly
4-00-4C-10000 (AMS) ¹	Keypad Press	Main keypad assembly
4-00-4A-10000 (AMS) ¹	Cap Press	Lens/flash cover assembly
4-00-Z1-10000 (AMS) ¹	Alignment Fixture Set	Multiple part alignments
0-00-00-30005 (AMS) ¹	Disassembly tool, plastic with flat and pointed ends (manual opening tool)	Used during assembly/disassembly

1. To order tooling please visit the AMS online-shop: <http://www.online-shop.ams-fl.com>

Disassembly

The procedures in this section provide instructions for the disassembly/ assembly of DROID phones. Tools and equipment used for the phone are listed in Table 1, preceding.



Many of the integrated devices used in this equipment are vulnerable to damage from electrostatic discharge (ESD). Ensure adequate static protection is in place when handling, shipping, and servicing the internal components of this equipment.



Avoid stressing the plastic in any way to avoid damage to either the plastic or internal components.

Removing the Battery Cover and Battery



All batteries can cause property damage and/or bodily injury, such as burns if a conductive material, such as jewelry, keys, or beaded chains touch exposed terminals. The conductive material may complete an electrical circuit (short circuit) and become quite hot. Exercise care in handling any charged battery, particularly when placing it inside a pocket, purse, or other container with metal objects.

1. Ensure the phone is turned off.
2. Slide the battery cover in a downward direction.



Figure 1. Releasing Battery Door

3. Lift up and remove the battery door.

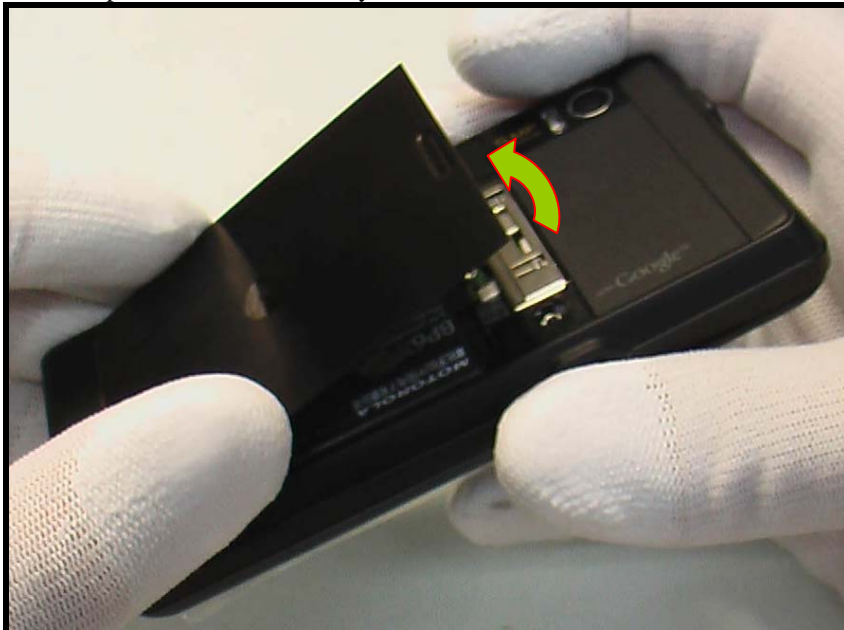


Figure 2. Removing the Battery cover

4. Lift the top edge of the battery first then lift it completely out of the battery compartment.



Figure 3. Removing the battery



There is a danger of explosion if the Lithium Ion battery is replaced incorrectly. Replace only with the same type of battery or equivalent as recommended by the battery manufacturer. Dispose of used batteries according to the manufacturer's instructions.

Removing the Rear housing



This product contains static-sensitive devices. Use anti-static handling procedures to prevent electrostatic discharge (ESD) and component damage.

1. Using the flat wedge tool, remove the camera/flash lens cover by prying from illustrated corner.



Do not reuse camera/flash lens

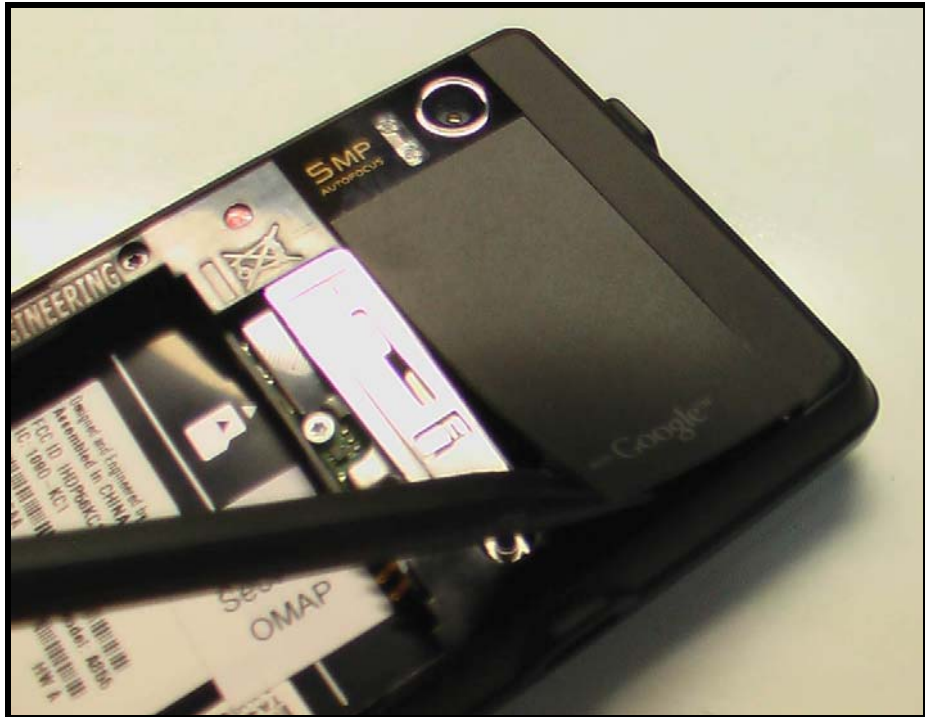


Figure 4. Removing Camera/flash lens cover

2. Using the flat wedge tool, pry off the speaker grill.



Do not reuse speaker grill



Figure 5. Removing the speaker grill

- Using a flat wedge tool, pry of the antenna cap.



Do not reuse antenna cap

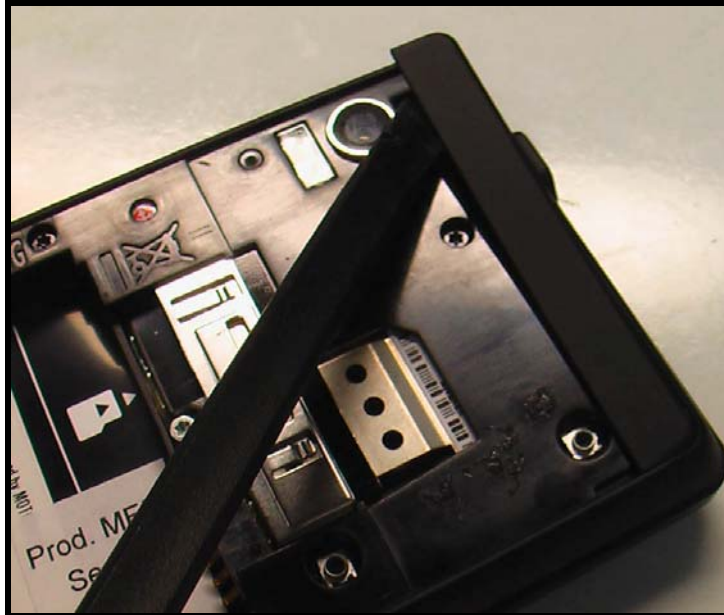


Figure 6. Removing the antenna cap

- Using a flat wedge tool, pry off the battery label.



Figure 7. Removing the battery label

- Using a Torx driver with a T-5 bit, remove 7 screws of the phone. Discard screws. Do not reuse.

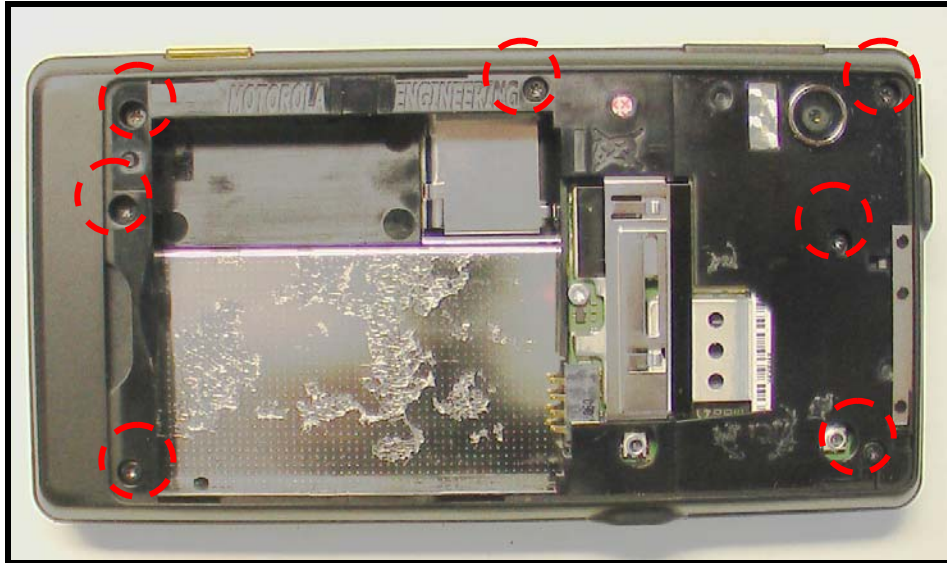


Figure 8. Remove main screws (7 points)

- Pry away the housing center hook feature.

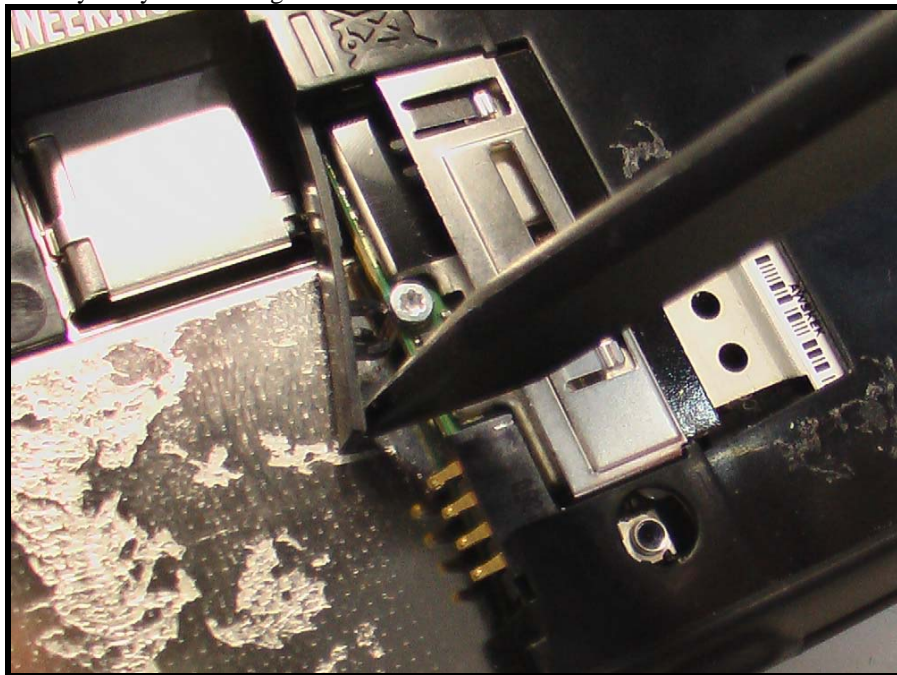


Figure 9. Releasing housing hook feature

7. Using a flat wedge tool, starting near the headset disengage the locking tab by prying 45 degrees.



Figure 10. Releasing locking tab near headset jack

8. Continue sliding the wedge tool around near the USB connector and disengage the next locking tab.



Figure 11. Releasing locking tab near USB connector

9. Continue releasing the next tab at the bottom side of the phone.

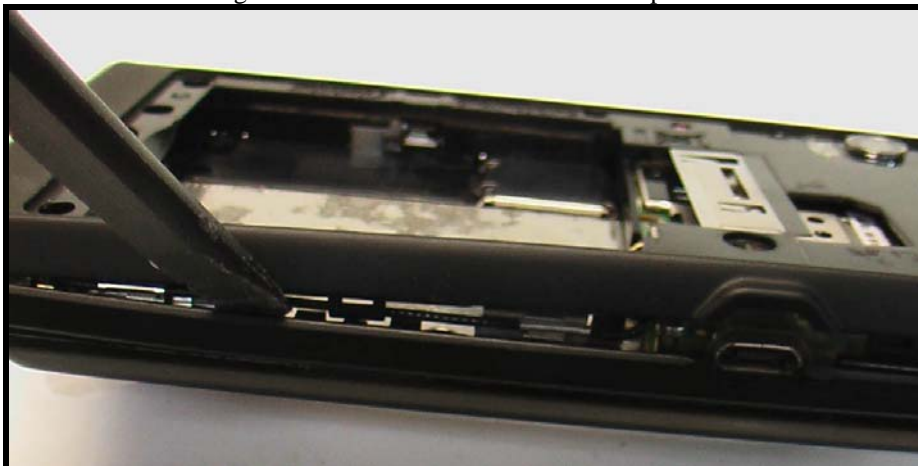


Figure 12. Releasing locking tab near bottom side

10. Release the next tab located next to the volume keys.



Figure 13. Releasing locking tab near volume key

11. Release the next locking tab near the camera key.



Figure 14. Releasing locking tab near camera key

12. Slowly lift up the rear housing pivoting from the bottom edge and shift housing side to side until bottom snaps are released.



Do not use prying tools at the bottom edge of the housing as it may cause damage to the main antenna coating of the acoustic assembly

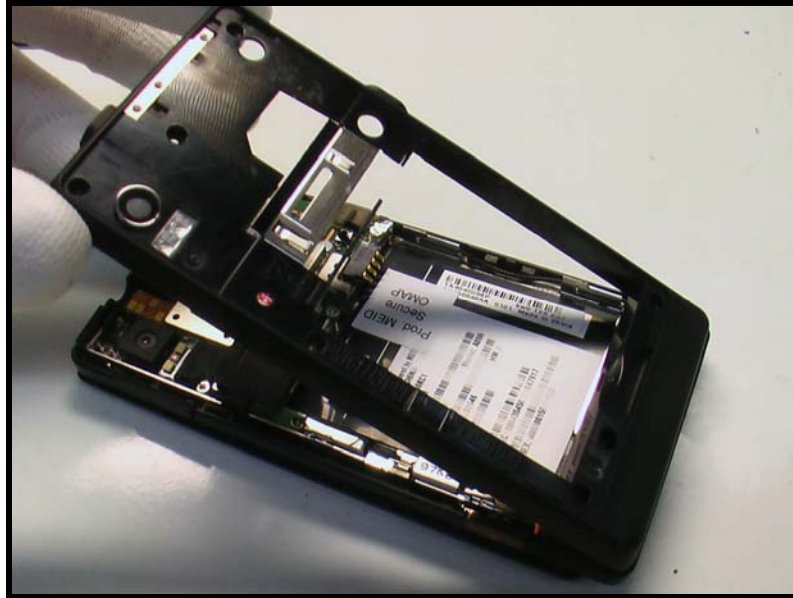


Figure 15. Lifting the rear housing

Removing the Main PCB

1. Using a flat wedge tool, pry up coax RF connector.

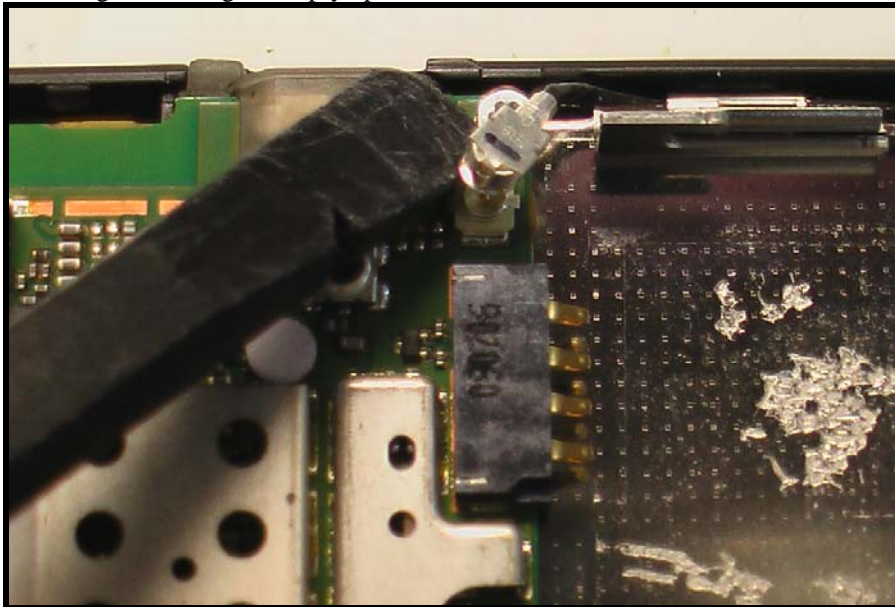


Figure 16. Removing the Coax RF connector

2. Using a torx driver with T5IP bit, remove the 3 PCBscrews.



Figure 17. Removing PCB screws (3 points)

3. Using a flat wedge tool, pry off the side key flex connector.

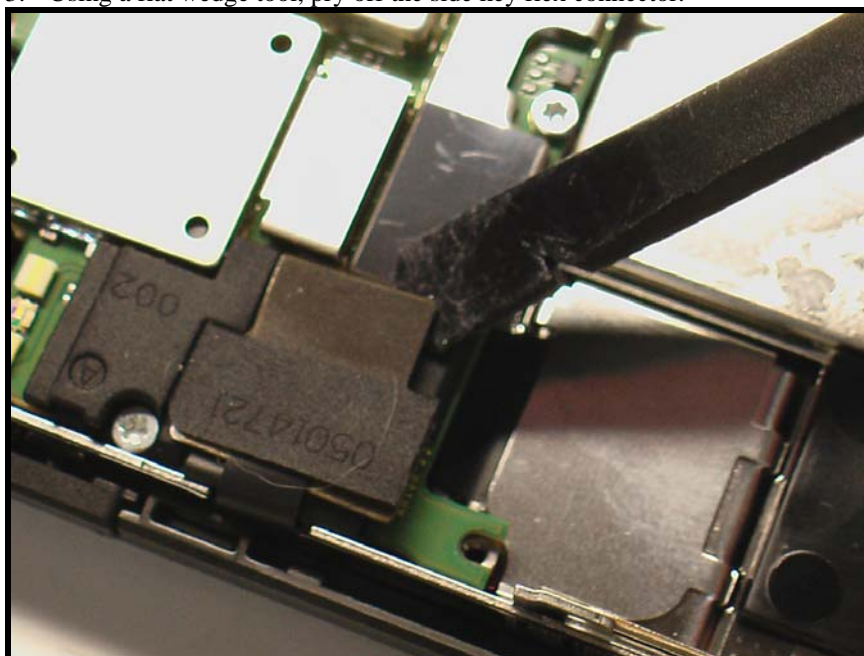


Figure 18. Disengage side key flex connector

4. Using a flat wedge tool, pry off the slider flex connector.

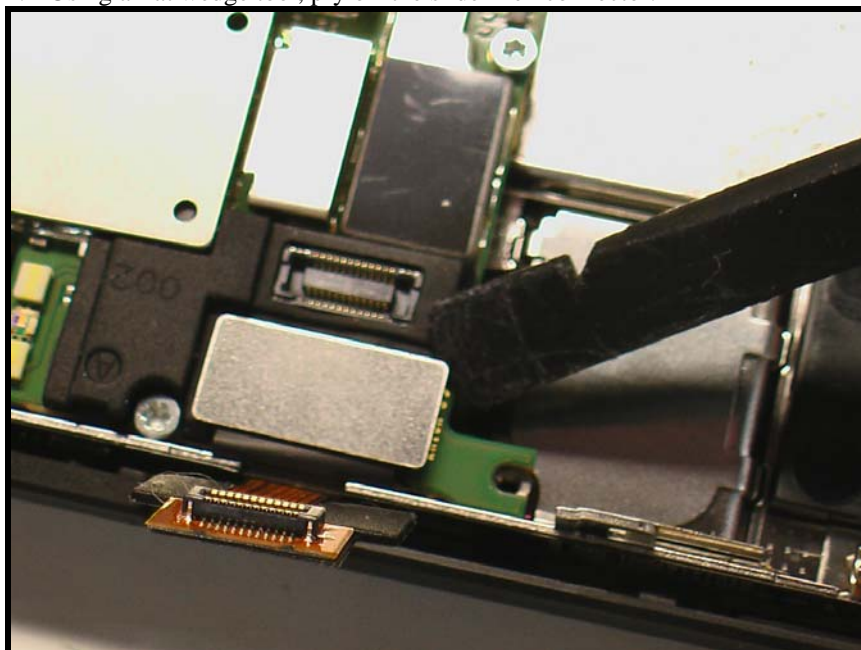


Figure 19. Disengaging slider flex connector

5. Carefully fold over the main PCB and disconnect the keyboard flex connector.

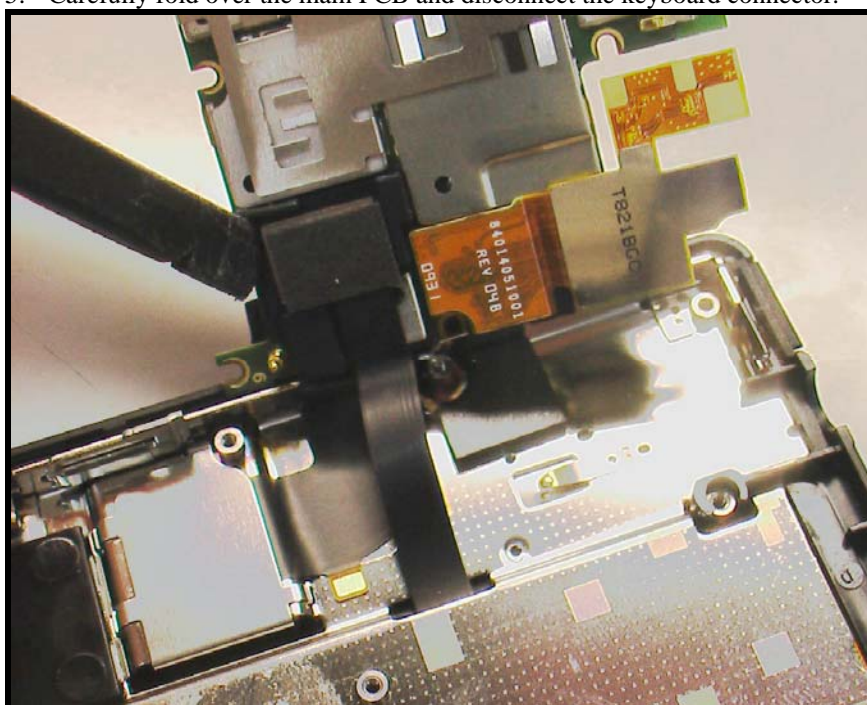


Figure 20. Disengaging keyboard flex connector

6. Using a pointed tool, pry off main PCB shield.

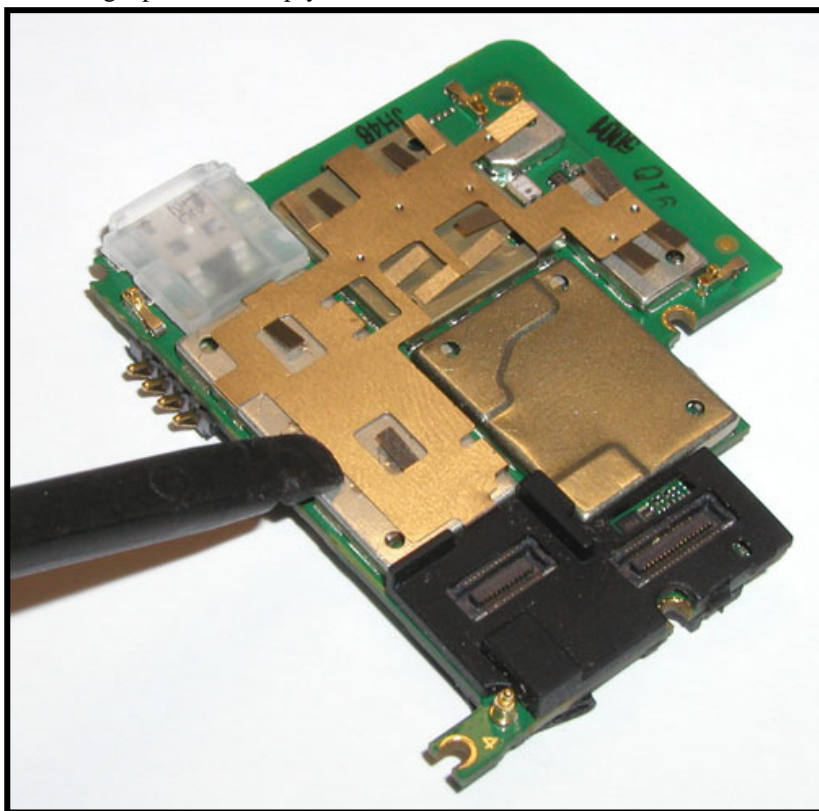


Figure 21. Removing PCB shield

Removing Camera Assembly

1. Using a flat wedge tool, pry off the camera assembly connector.

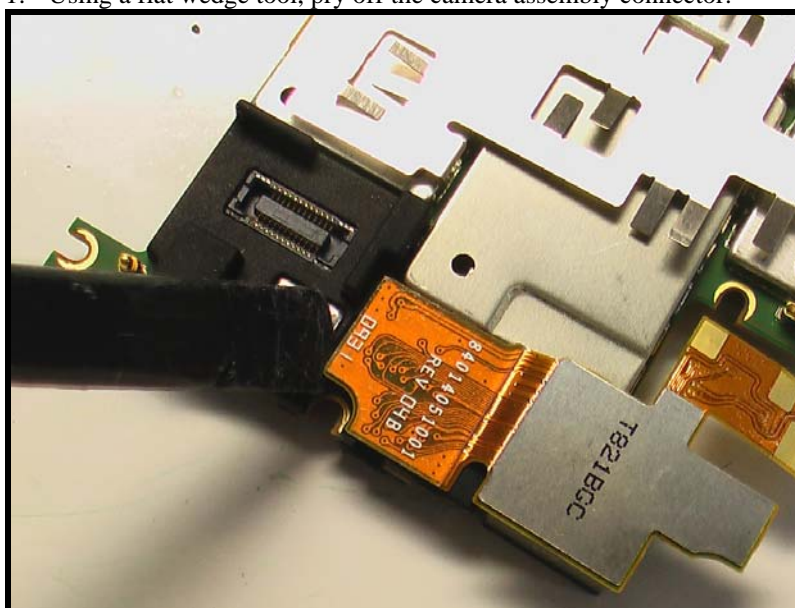


Figure 22. Removing camera assembly flex

2. Lift away the connector rubber seal to remove.

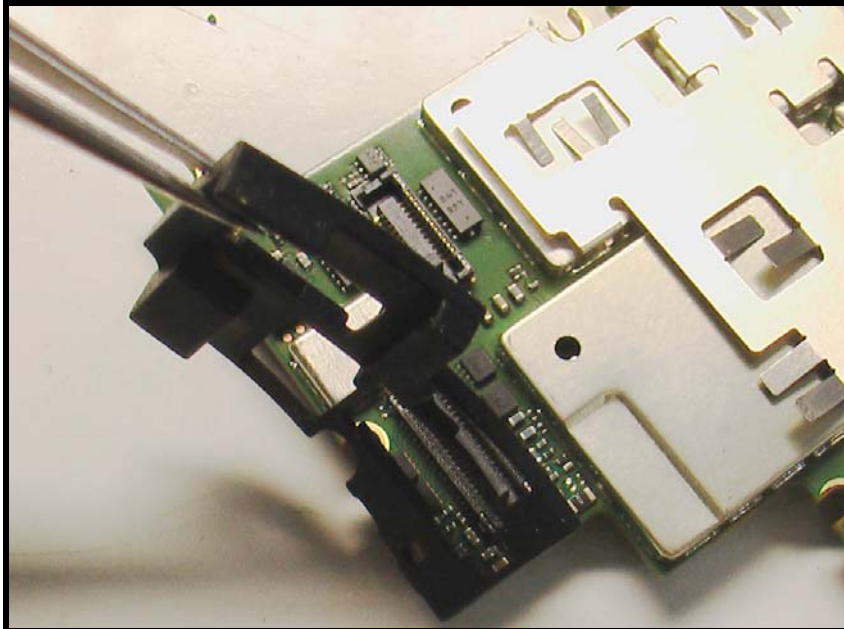


Figure 23. Removing the connector rubber seal

Removing the Keyboard Frame

1. Using a pointed tool, remove all side buttons.

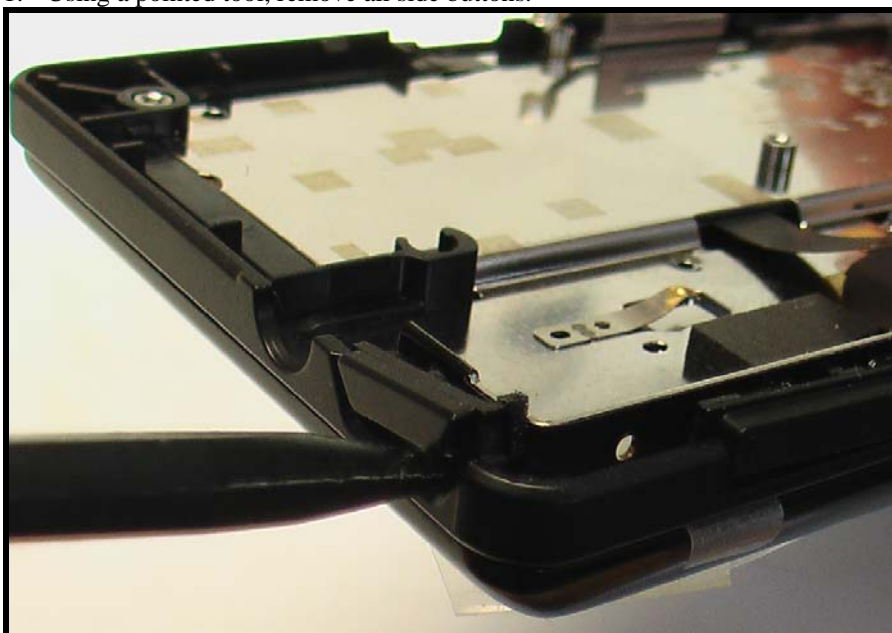


Figure 24. Removing Power/Lock key

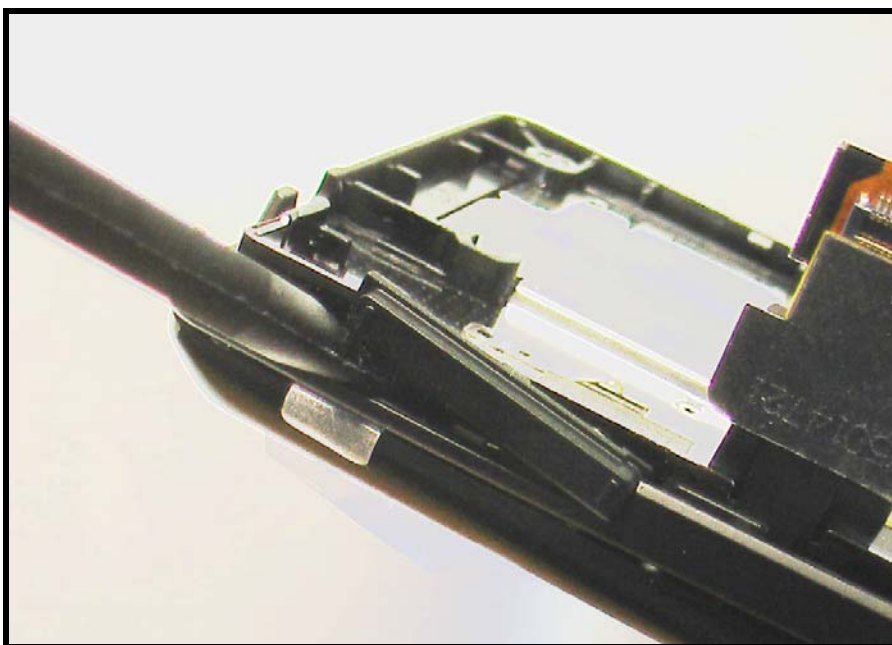


Figure 25. Removing Volume keys

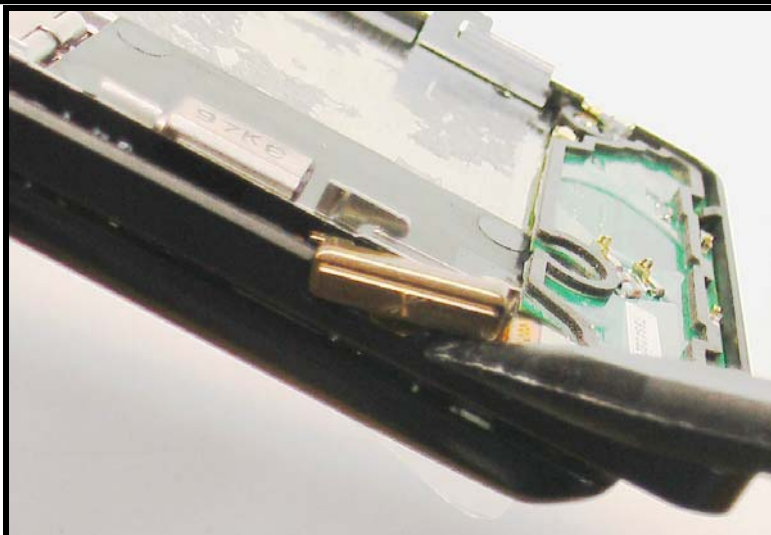


Figure 26. Removing camera key

2. Using a pointed tool, release the RF coax cable from the 2 retaining clips.

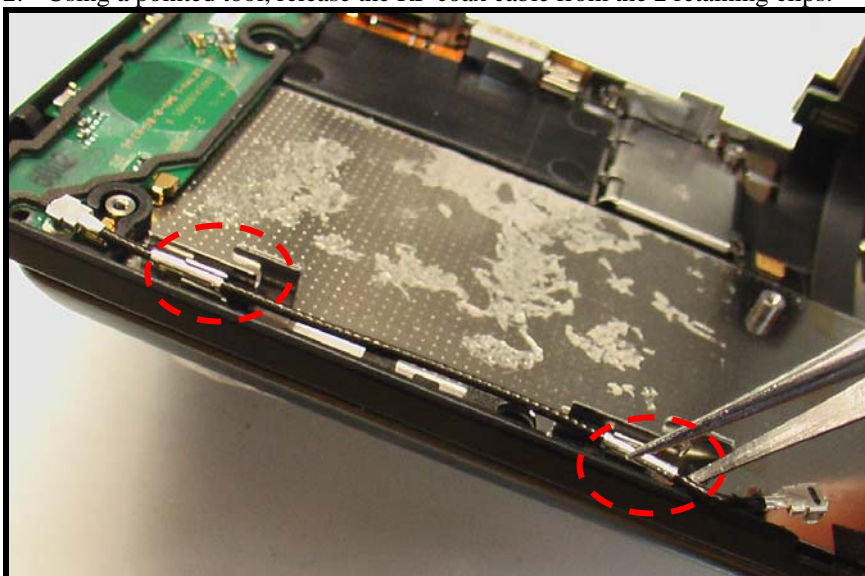


Figure 27. Removing the RF coax cable

3. Using a flat wedge tool, disengage the RF coax connector.

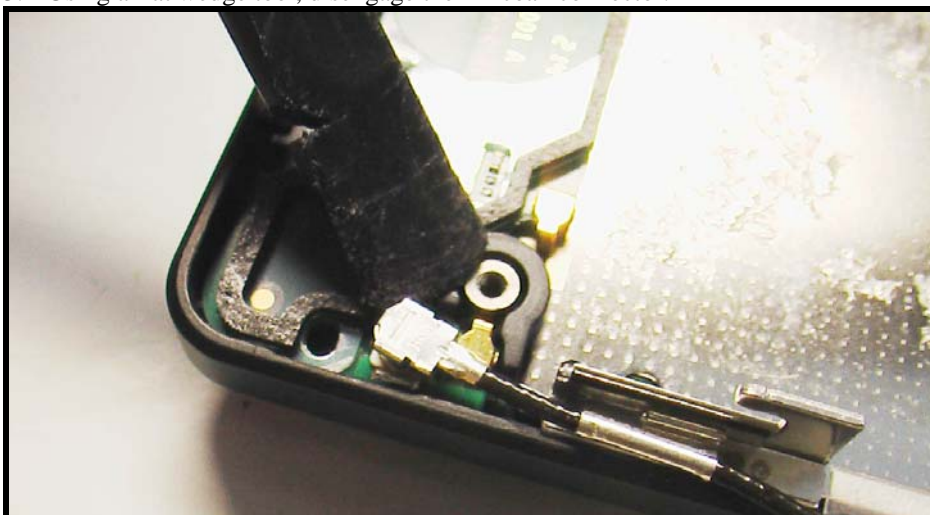


Figure 28. Removing the RF coax cable connector

- Using a flat wedge tool, pry off the vibrator flex cable.

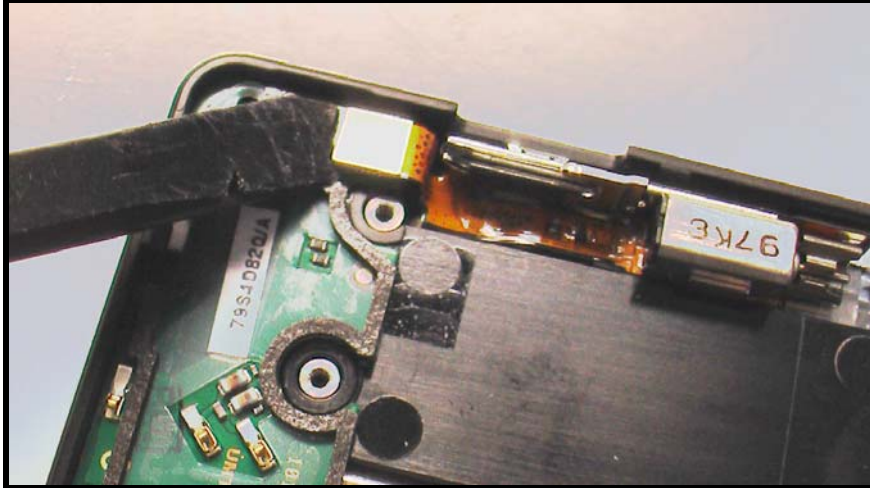


Figure 29. Disengaging the vibrator flex cable

- Using a pointed tool, peel off the water seal adhesive.

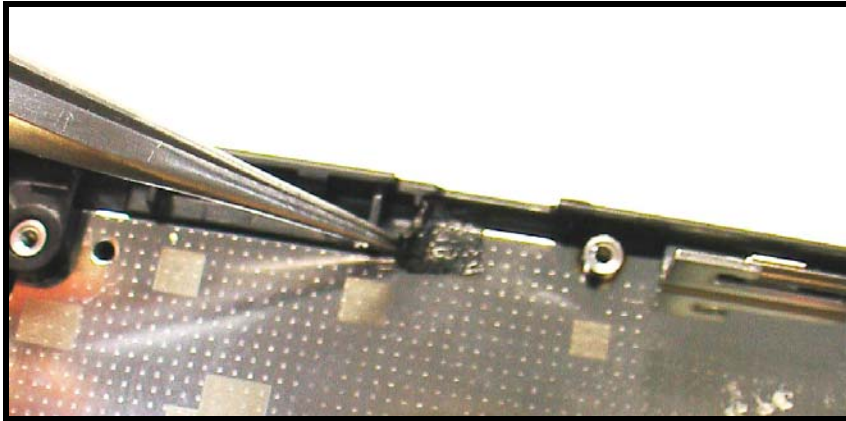


Figure 30. Removing the water seal adhesive

- Carefully lift the keyboard frame starting from the side as illustrated.

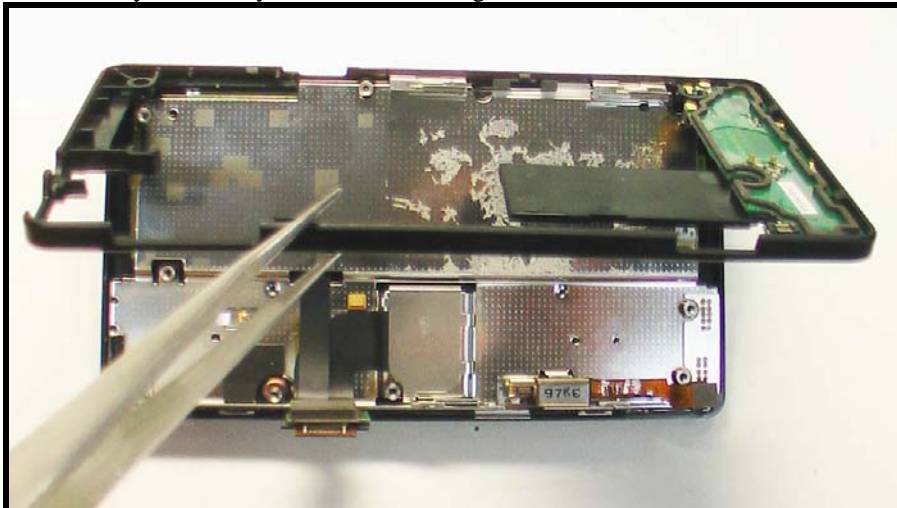


Figure 31. Removing the keyboard frame

Removing the slider assembly

1. While the slider is closed, using a driver with JIS #00 cross bit, remove the 4 indicated screws.



Due to high torque settings, approximately 7 lbs (31 N) of downward force is required to remove screws. Insufficient downward force can increase risk of stripping screw head.

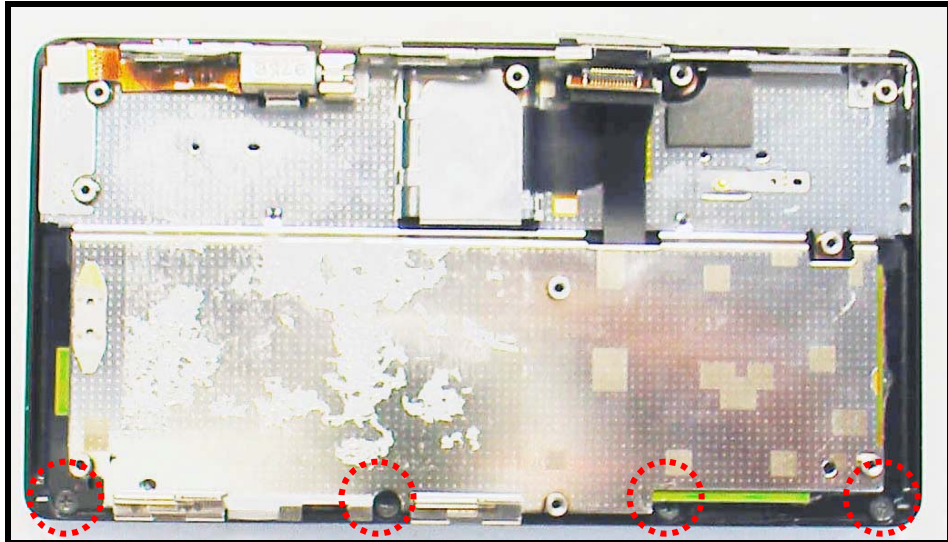


Figure 32. Removing slider screws (4 points)

2. Open the slider about 50% to expose the screw located in the center edge. Remove 5 screws in the illustrated locations.

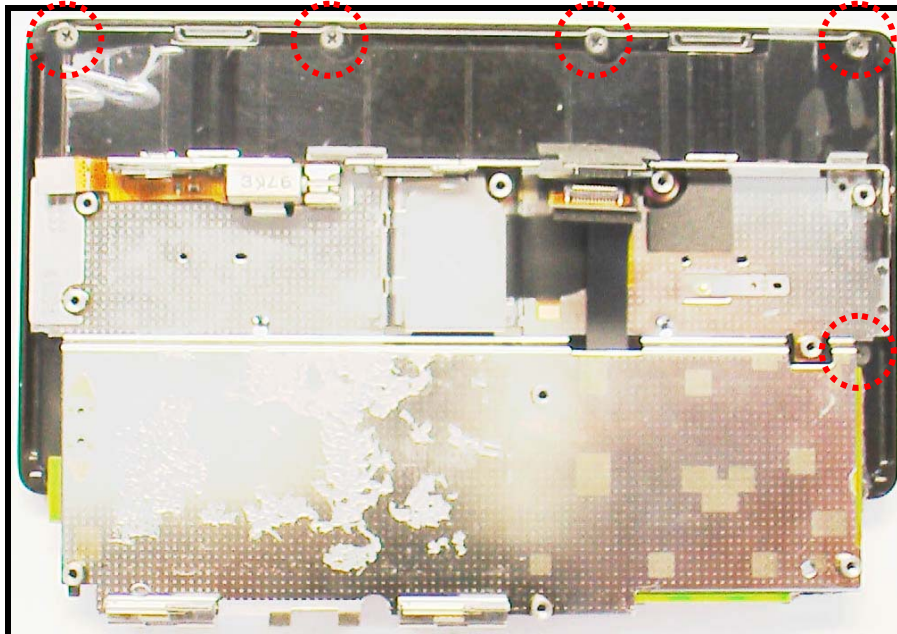


Figure 33. Removing slider screws (5 points)

3. Fully open the slide to gain access to the final screw.
4. Using the driver with JIS #00 cross bit, remove the final screw.

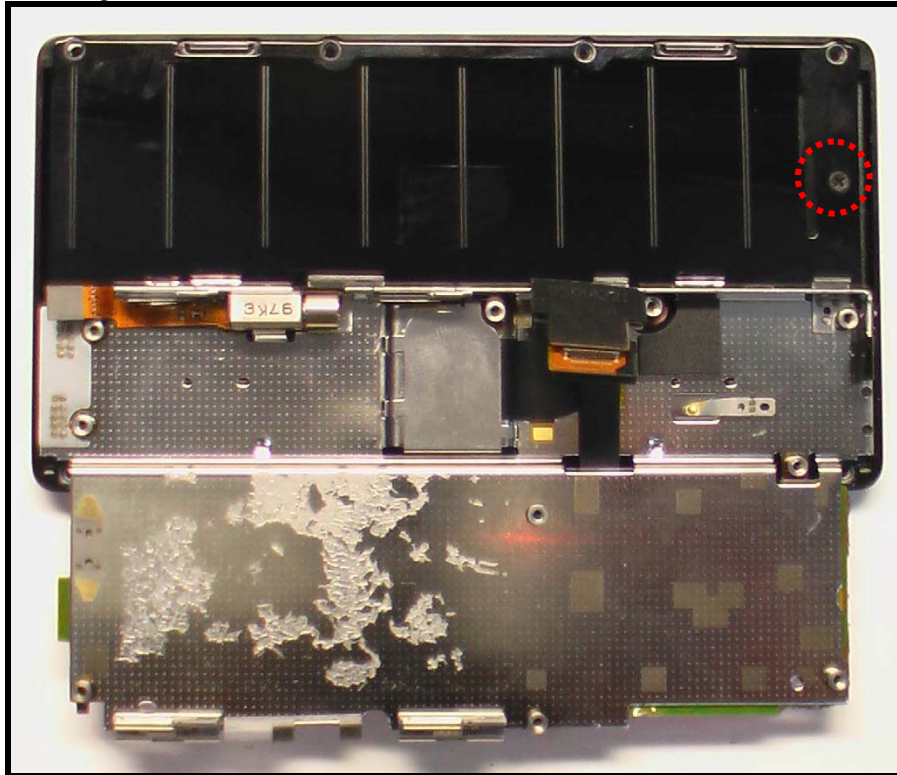


Figure 34. Removing slider screw (1 points)

5. Using a flat wedge tool, pry off the dynamic flex metal cover.

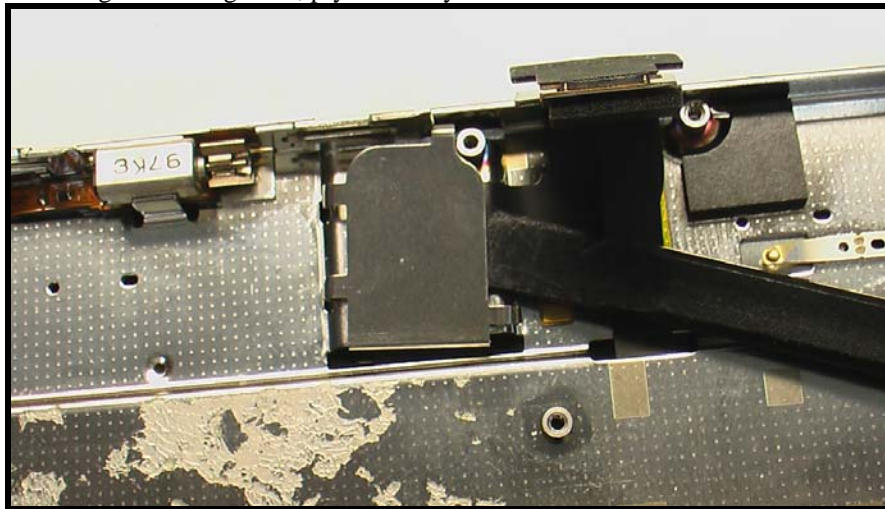


Figure 35. Removing dynamic flex cover

6. Carefully peel away the dynamic flex from the chassis in the direction shown to prevent damage.

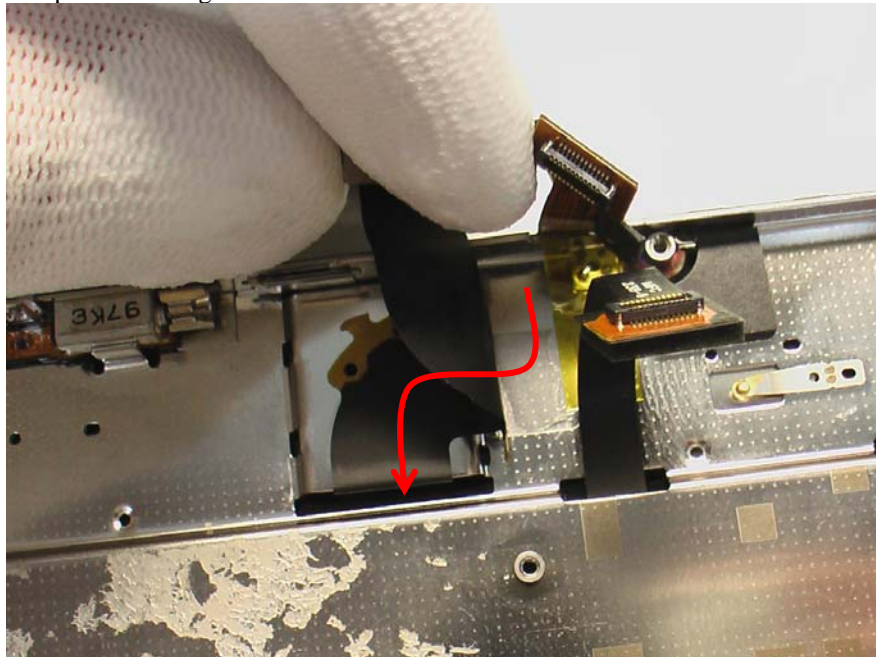


Figure 36. Lifting dynamic flex from chassis

7. Carefully separate the slider chassis from the slider housing and using a flat wedge tool, reach inside to lift dynamic flex away from chassis.

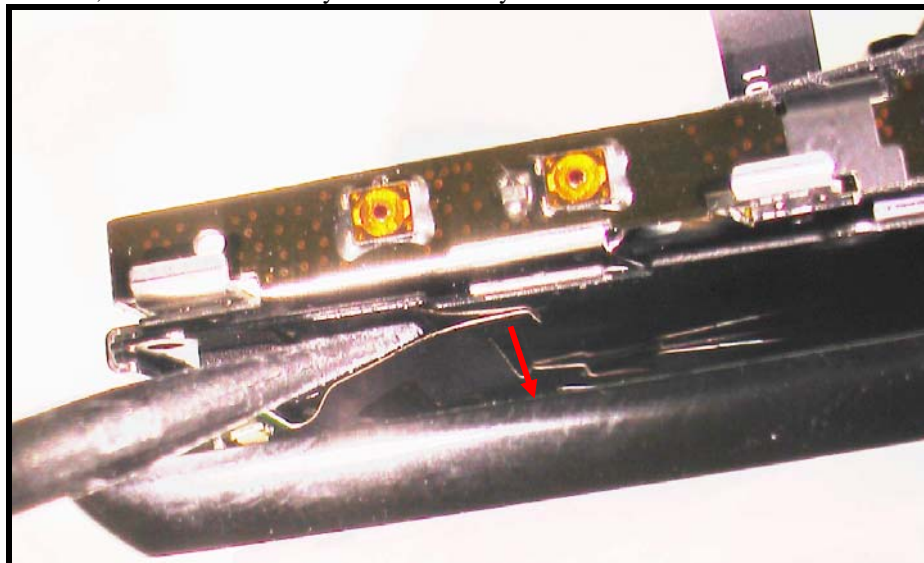


Figure 37. Lift dynamic flex from chassis

8. Reach further inside to lift the second area of adhesive for the dynamic flex.

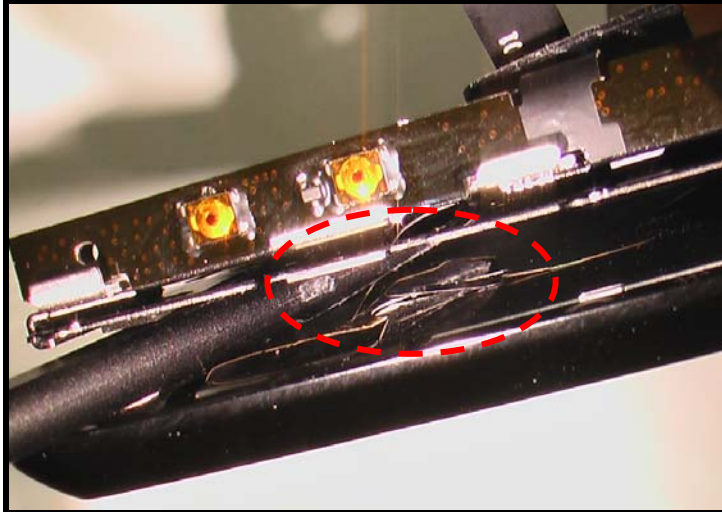


Figure 38. Lifting the second adhesive from the dynamic flex

9. Open the slider in a position where the dynamic flex openings for the slider plate and slider chassis are aligned.

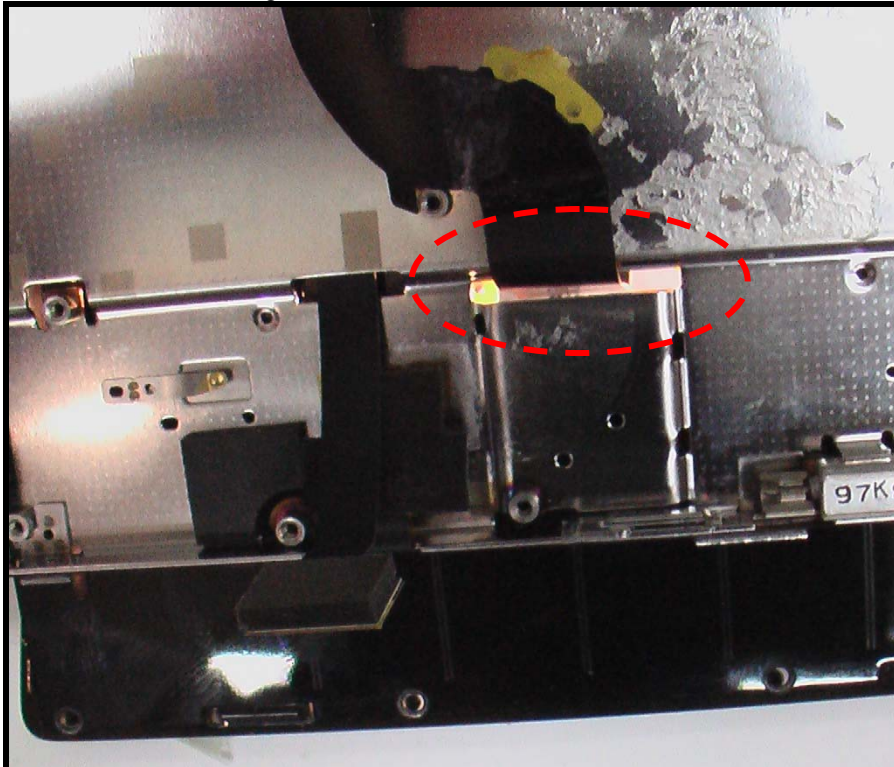


Figure 39. Aligning slider chassis and slider plate

10. Carefully feed the dynamic flex through the opening.



Figure 40. Feeding dynamic flex

11. Slide the slider plate to separate from slider chassis.

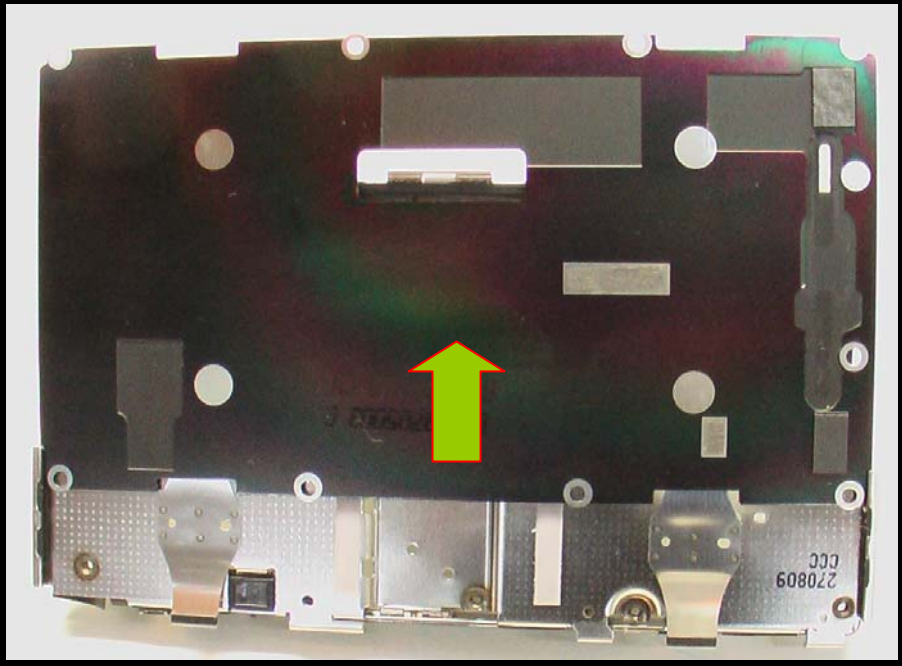


Figure 41. removing slider plate

Remove Dynamic Flex

1. Using tweezers, peel the water ingress seal starting from the illustrated corner.

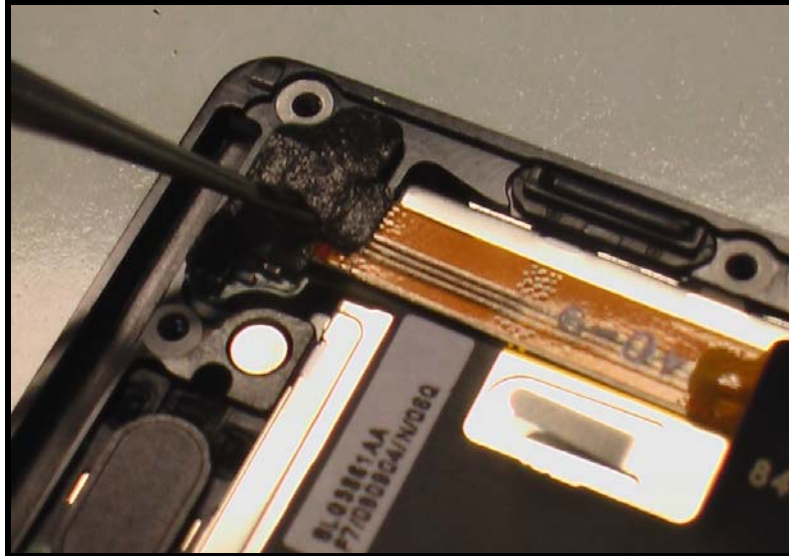


Figure 42. Removing water ingress seal (display connector side)

2. Using tweezers, lift the zip connector latch then pull the display flex away from the connector.

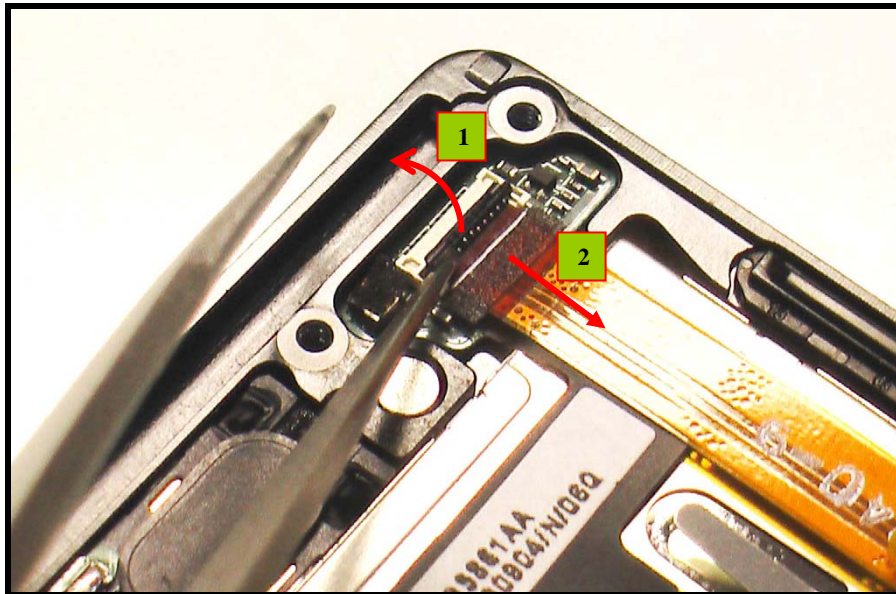


Figure 43. Removing display flex

3. Using tweezers, peel the water ingress seal starting from the illustrated corner.

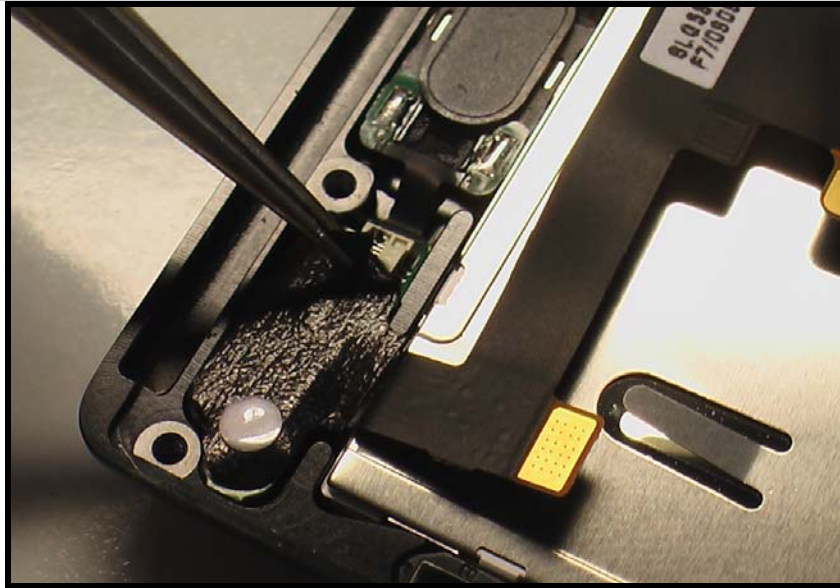


Figure 44. Removing the water ingress seal (ITO connector side)

4. Using a pointed tool, lift the ZIF connector lock and then pull the ITO flex away from the connector.

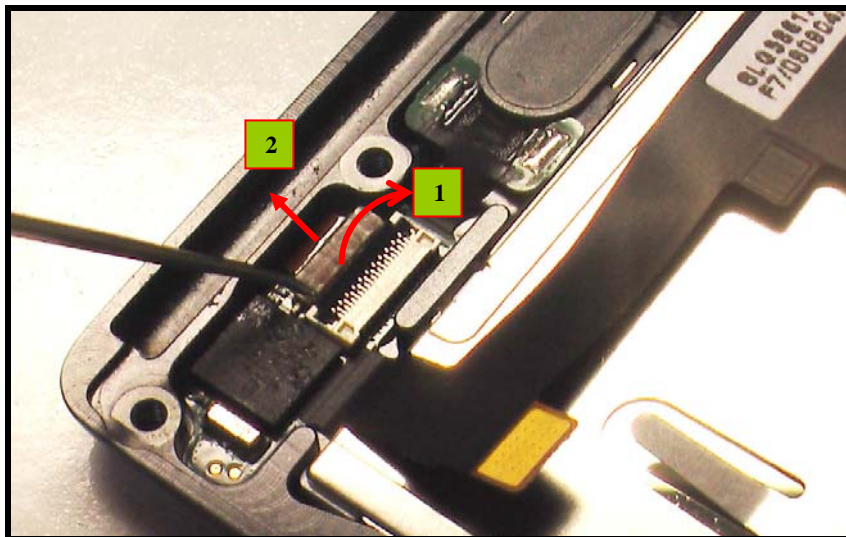


Figure 45. Removing the ITO flex connector

5. Using a wedge tool, carefully pry off the earpiece speaker from the housing.

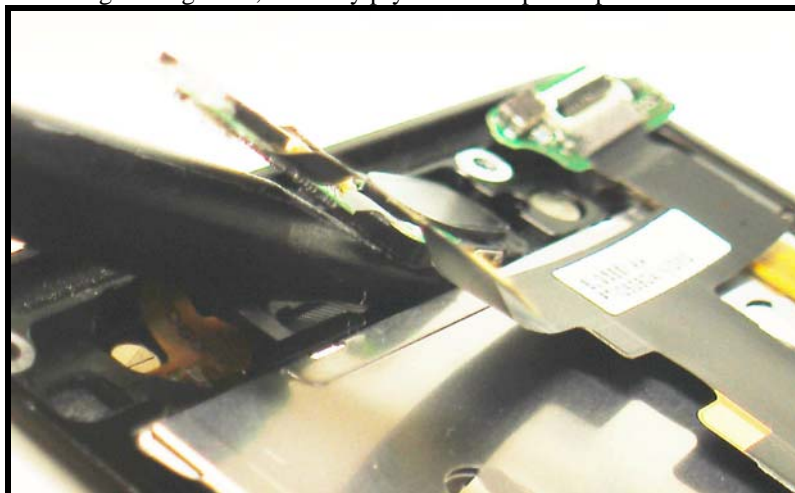


Figure 46. Lifting the earpiece speaker

6. Carefully peel away the dynamic flex from the display module.

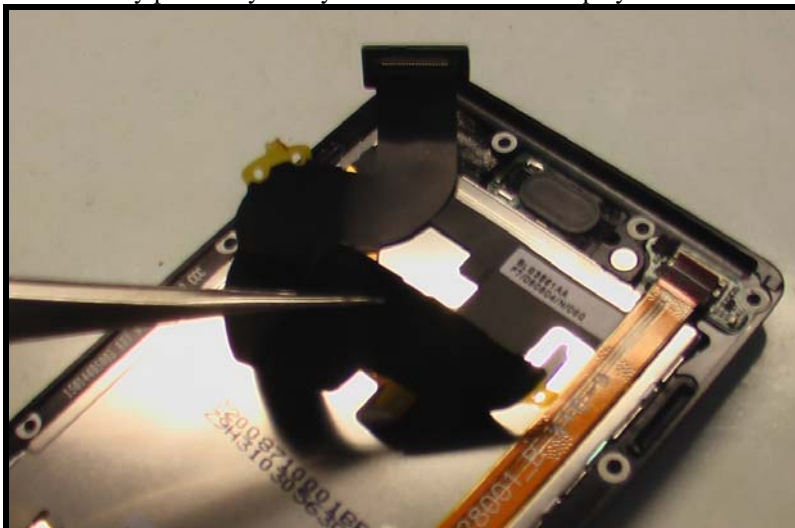


Figure 47. Removing dynamic flex

Removing the Display module

1. Using a flat wedge tool, carefully pry the display off the slider housing.

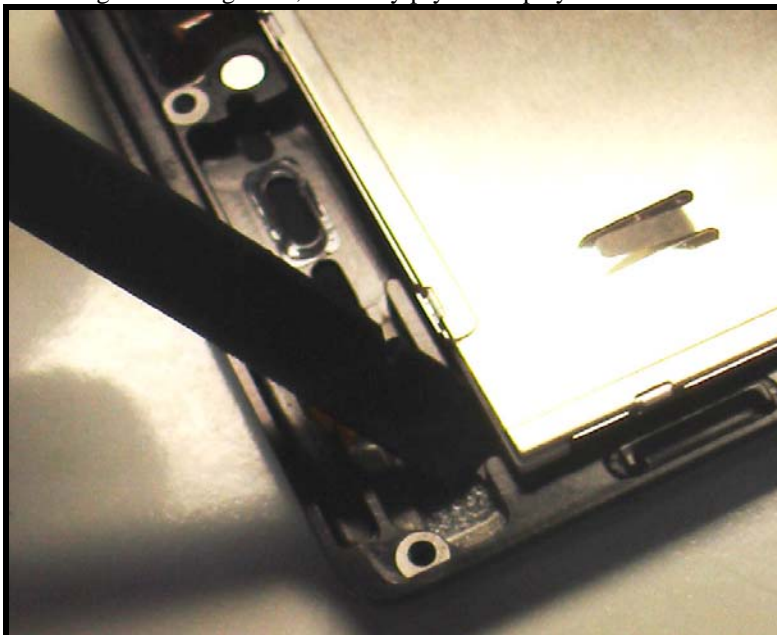


Figure 48. Removing display module

2. Carefully lift the display module as illustrated.



Figure 49. Lifting the display module

Removing Keypad, Mylar, and Keypad flex

1. Using a pointed tool, separate the keypad from the mylar starting from the illustrated corner.
2. As the corner is lifted, continue running the tool along the bottom edge.

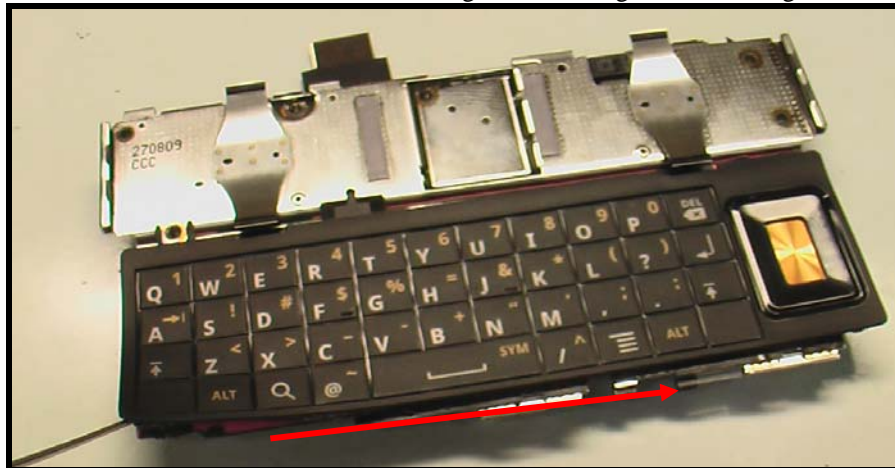


Figure 50. Lifting the keypad

3. Continue lifting the keypad as you slide around the navigation key.

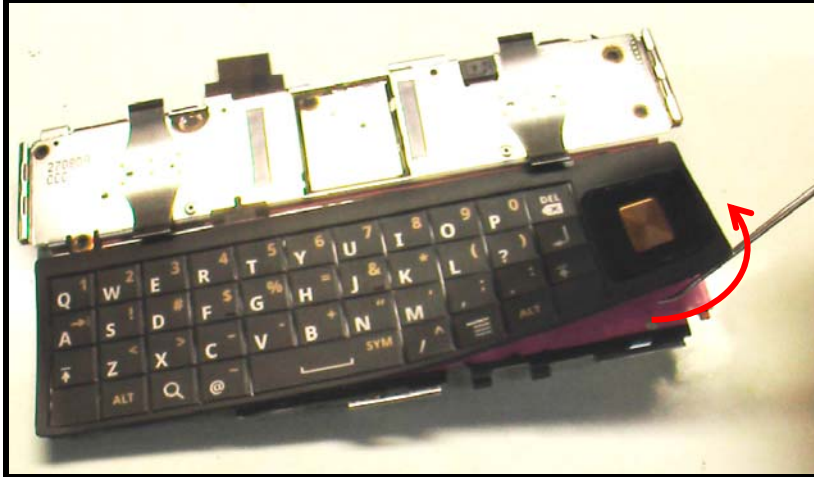


Figure 51. Continue lifting keypad around navigation key

4. Continue lifting from the top edge, and then completely remove when the end is reached.



Pay close attention on avoiding damage to the EL panel in the indicated areas

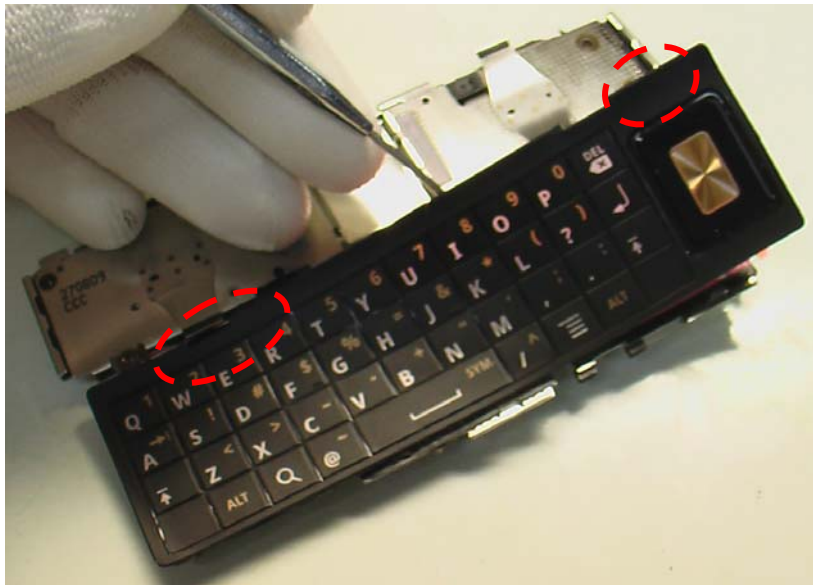


Figure 52. Continue lifting keypad along top

5. Using a pointed tool, separate the EL panel from the keypad flex, then peel off.

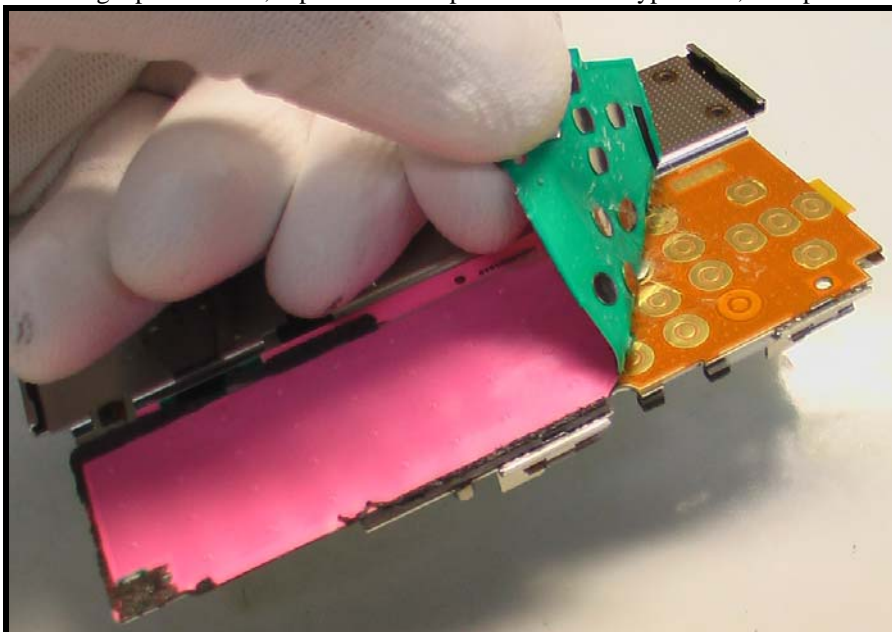


Figure 53. Removing EL panel

6. Using a pointed tool, lift the keypad flex from the slider chassis.

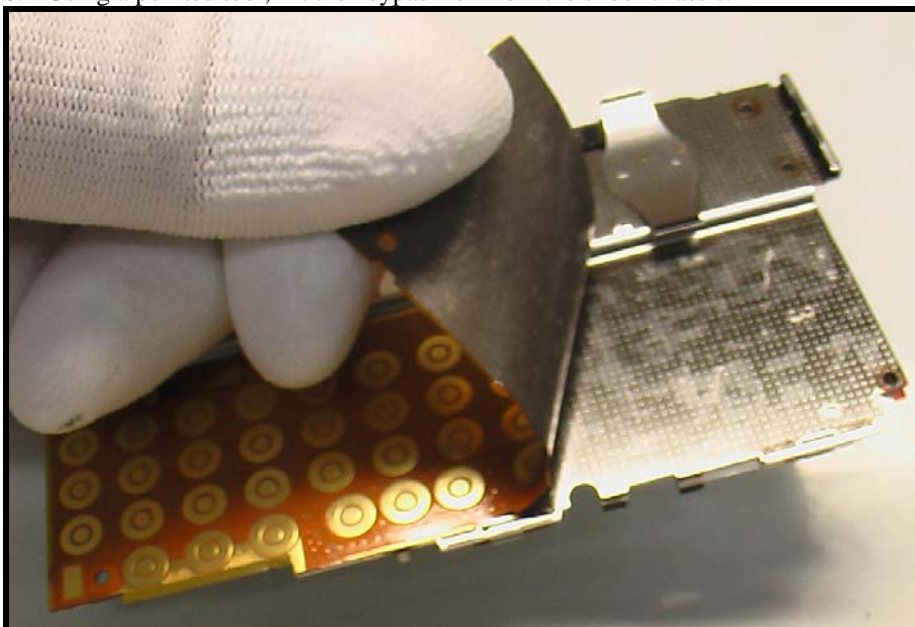


Figure 54. Lifting the keypad flex

7. After lifting the keypad flex from the slider chassis, feed the flex through the chassis opening as illustrated.



Remove the foam pad from the flex connector for easier removal if the flex assembly is going to be reused

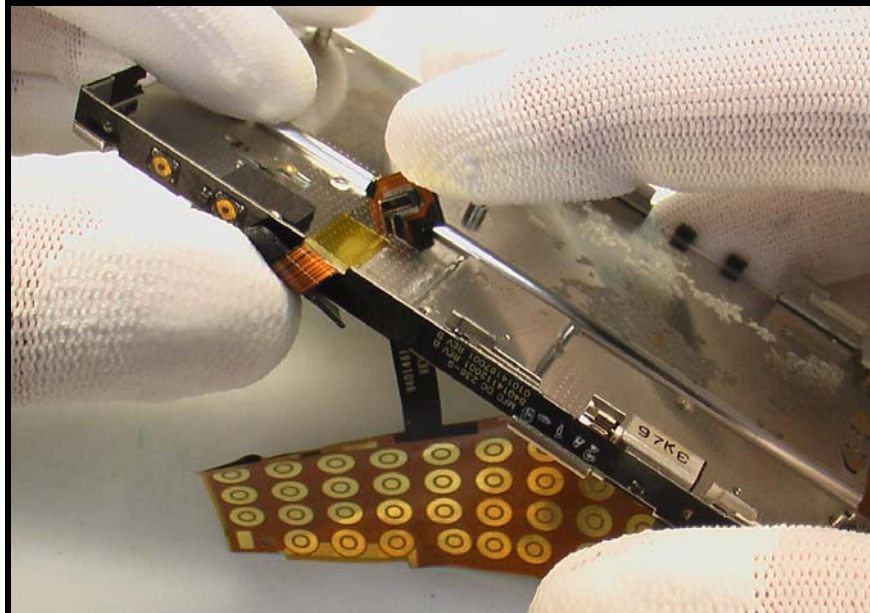


Figure 55. Feeding flex through chassis opening

Removing Headset Jack

1. Using a pointed tool, pry off the headset jack.

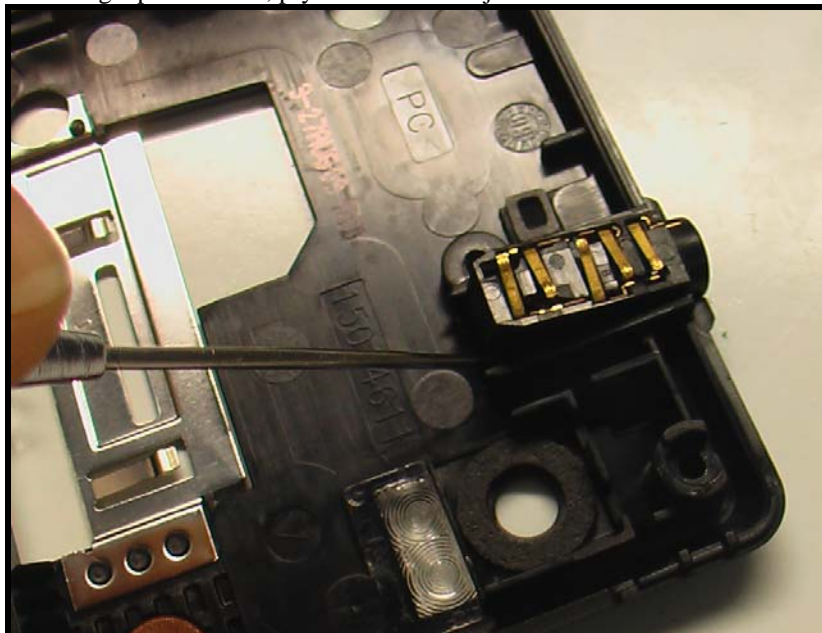


Figure 56. Removing headset jack

Assembly

Slider Outer Assembly

1. Apply 3M CA-100 glue to magnet cavity.



Figure 57. Gluing magnet

2. Place magnet in cavity and wipe off excess glue.

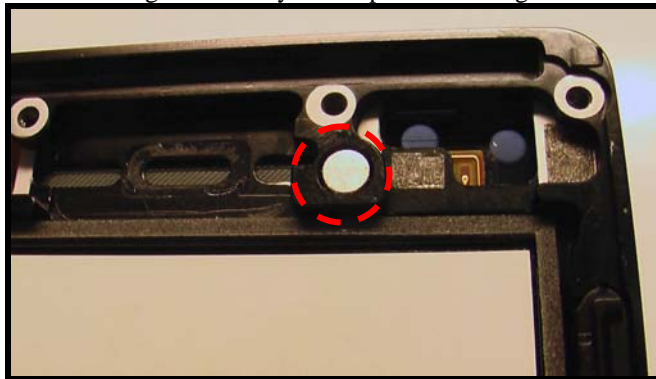


Figure 58. Place magnet

3. Place earpiece speaker grill on alignment fixture, then place slider housing over fixture and manually press in area to activate adhesive.



Figure 59. Earpiece speaker alignment

4. Place an adhesive strip in the plastic insert mold for the slider side stoppers. Remove adhesive backing.

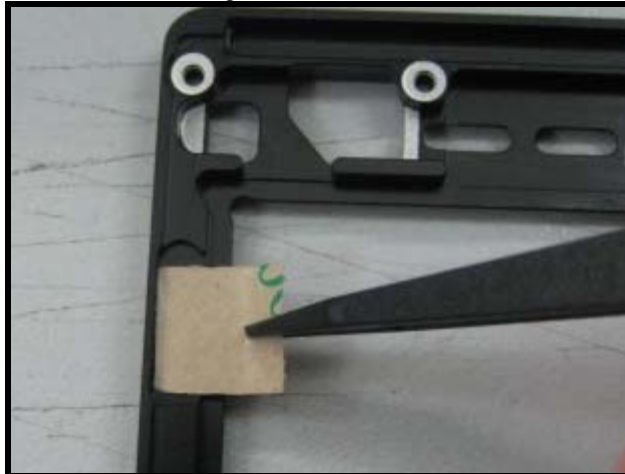


Figure 60. Slider side stopper adhesive (4 points)

5. Place 4 plastic slider stoppers in the illustrated locations. Insure that the orientation is correct.

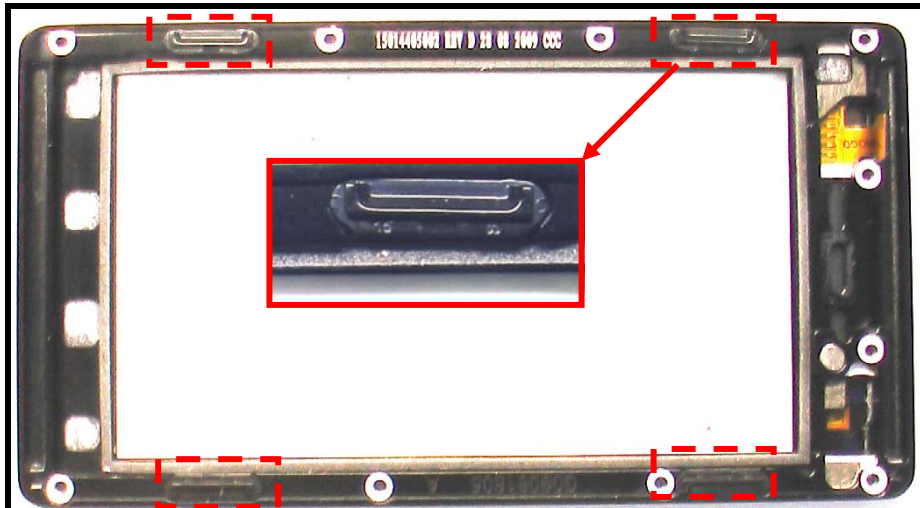


Figure 61. Placing plastic inserts

6. Place LCD gasket in alignment fixture.



Figure 62. Aligning LCD gasket

7. Place slider housing over LCD gasket alignment fixture and manually press.



Figure 63. Pressing slider housing over LCD gasket

Lens Assembly

1. Remove the adhesive backing of the main lens assembly.



Insure that the work station is free of dust and no foreign materials are introduced when working with lens assemblies

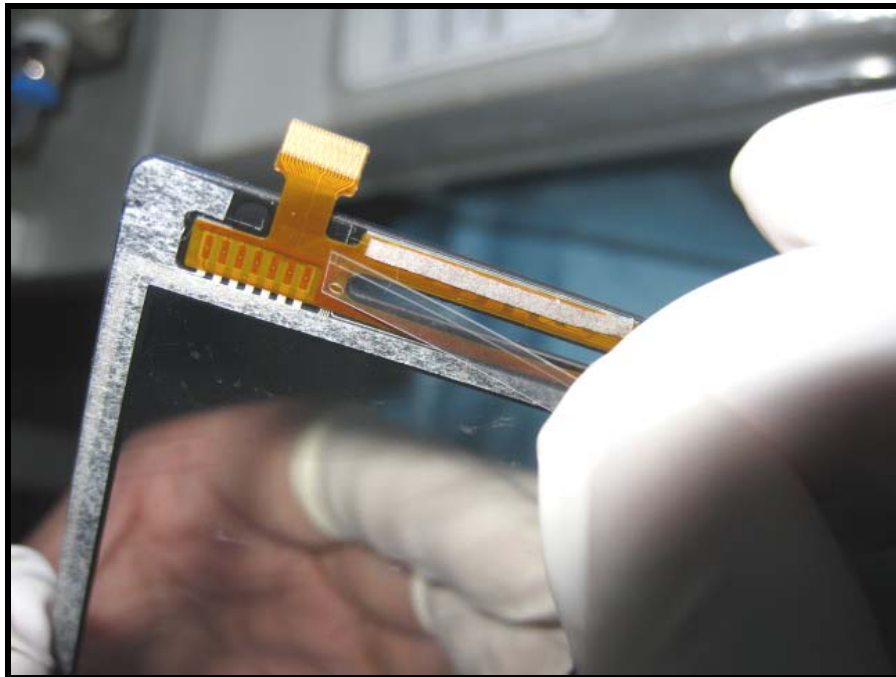


Figure 64. Removing lens adhesive backing

2. Starting at the top of the slider housing, align lens to housing.



Insure that the ITO flex is fed through the housing opening

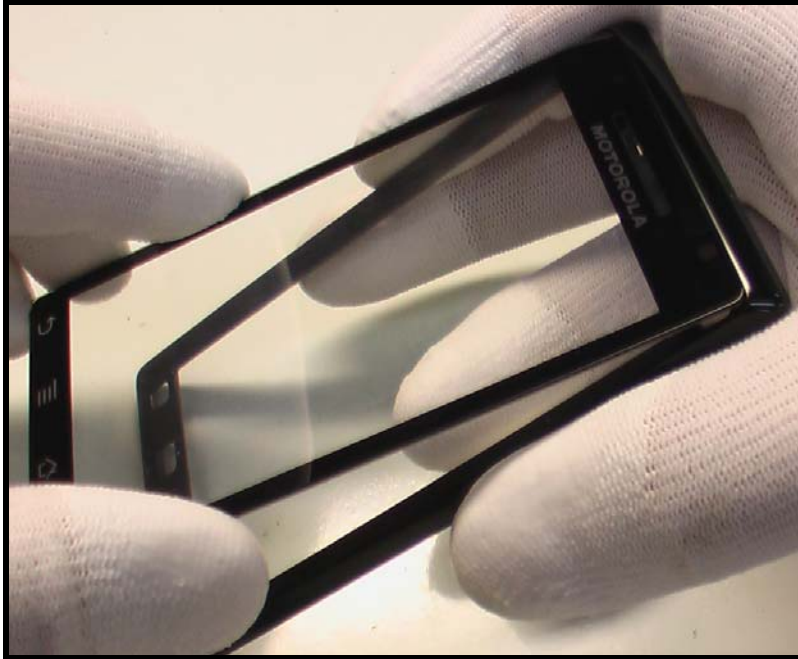


Figure 65. Aligning main lens

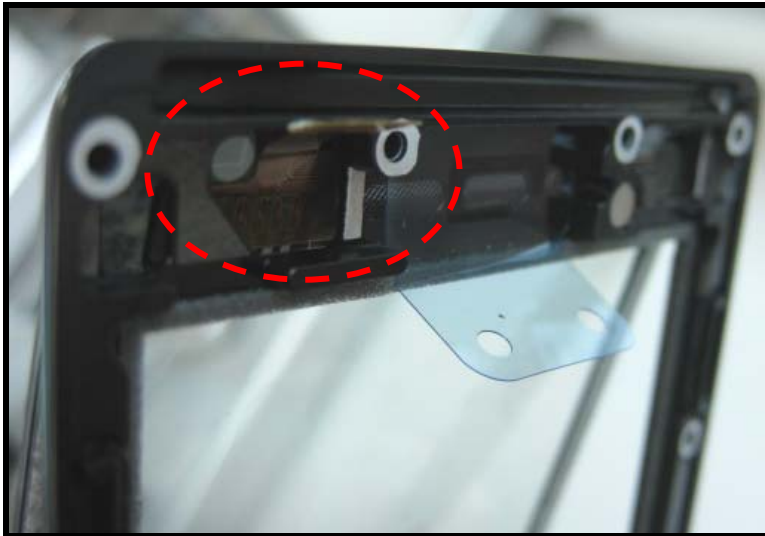


Figure 66. ITO fed through opening

3. Remove earpiece speaker port adhesive backing.



Figure 67. Removing earpiece speaker port adhesive backing

4. Place the grounding adhesives on the slider housing as illustrated.

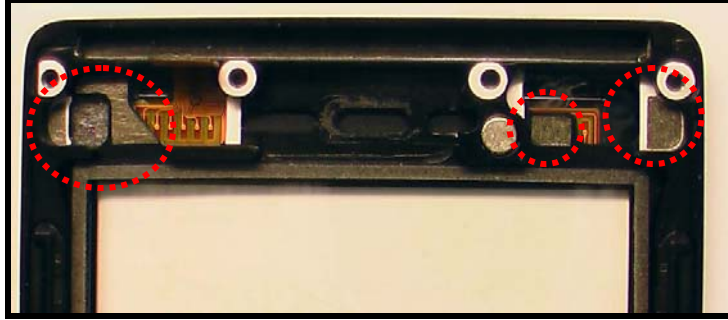


Figure 68. Place ground adhesives



Avoid touching the inside lens and prevent any foreign materials from sitting on the lens

Display Assembly

1. Remove any foreign materials from lens and display air or a lens cloth.



If reusing a display, insure that all foreign materials (old display gasket material) are removed

2. Align the display from one side to insure that the display flex is seated against the housing mold, then press the display against the housing.

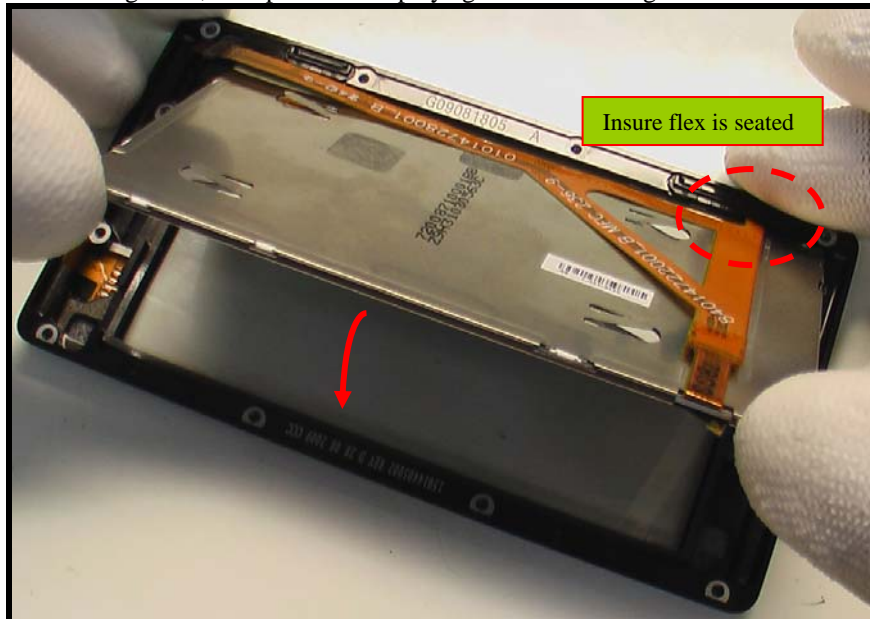


Figure 69. Aligning display in housing

Hydra-flex Assembly

1. Before placing Hydra-flex, insure that non-conductive adhesives are placed in illustrated areas.

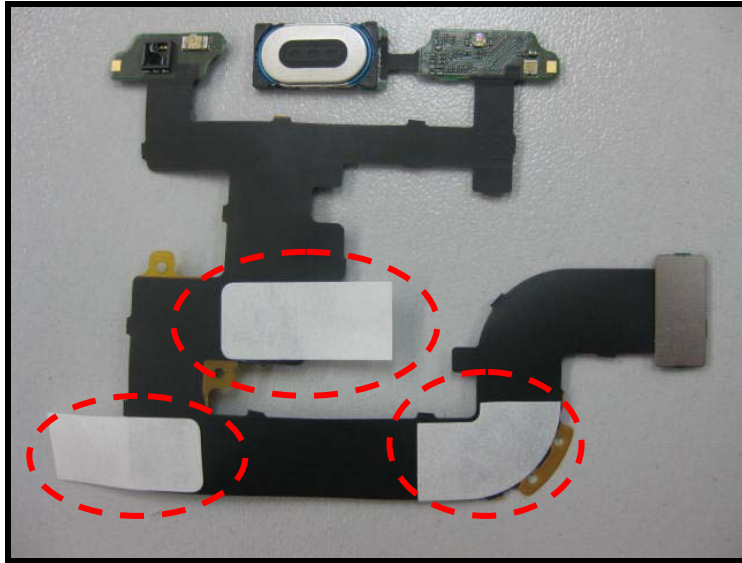


Figure 70. Placing adhesives on hydra-flex

2. Also insure that ground adhesives are placed on the other side of the hrdra-flex.

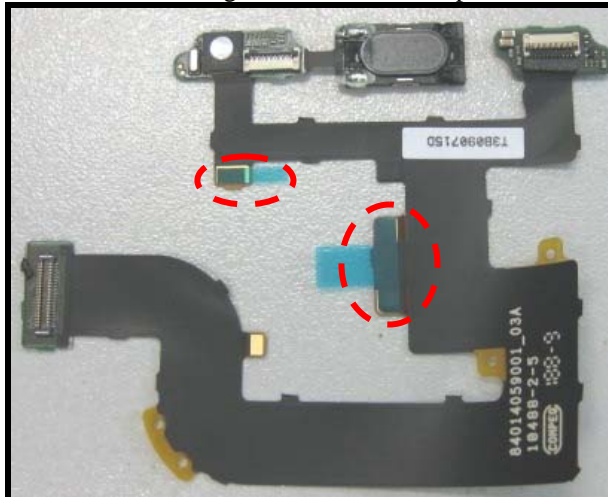


Figure 71. Placing ground adhesives

3. Place the proximity grommet as illustrated.



Figure 72. Placing proximity grommet

4. Remove earpiece speaker adhesive backing and align speaker to slider housing.
5. Press in speaker area to activate adhesive.



Figure 73. Pressing earpiece speaker

6. Insert the ITO flex in connector and lock ZIF connector. Insure white line indicator is aligned with ZIF connector.

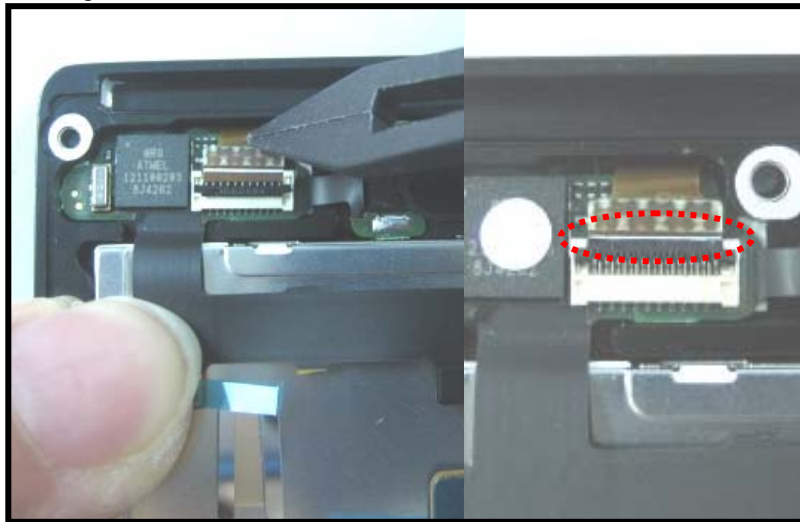


Figure 74. ITO flex assembly

7. Insert the display flex connector and latch the ZIF connector lock. Insure that the white line indicator is aligned with the ZIF connector.

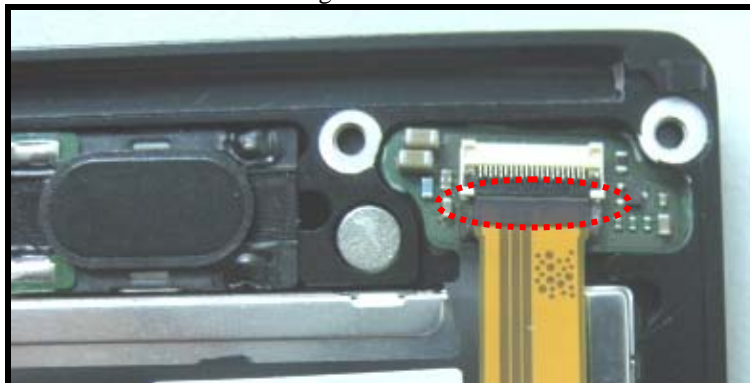


Figure 75. Display flex connector assembly

8. Place a pad over the display flex as illustrated.

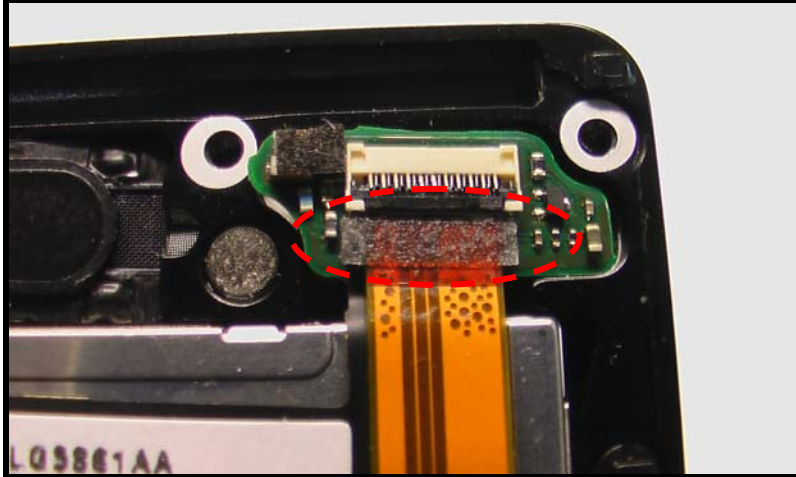


Figure 76. Placing a pad over display flex

9. Place a water ingress seal over the display connector as illustrated. Press in surrounding areas to insure good adhesion.



Figure 77. Placing water ingress over display connector

10. Place a water ingress seal over the ITO connector as illustrated. Press in surrounding areas to insure good adhesion.



Figure 78. Placing water ingress over ITO connector

11. Place a water detect indicator and pad over the ITO ingress seal.

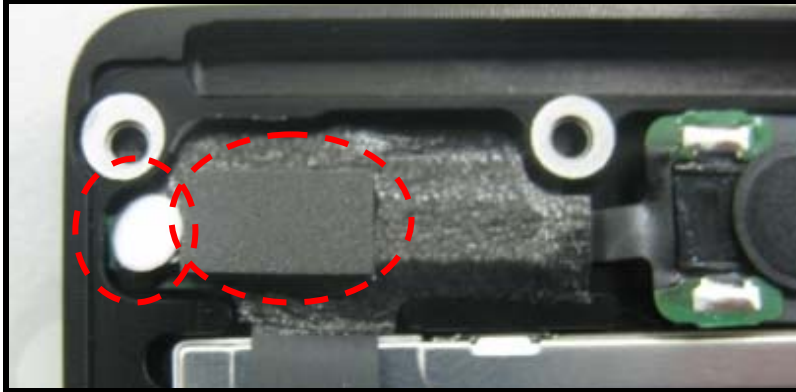


Figure 79. Placing pad and water detect indicator

Slider Assembly

1. Remove the backing of the EL dome assembly and place in alignment fixture.

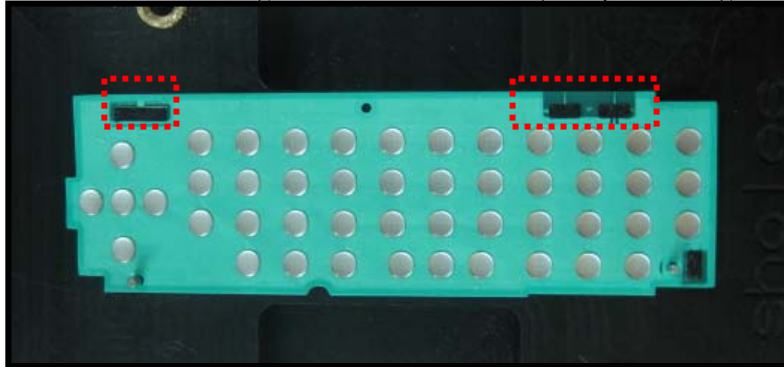


Figure 80. Placing EL dome assembly

2. Place keyboard flex assembly over fixture. Insure alignment posts are used for proper alignment.

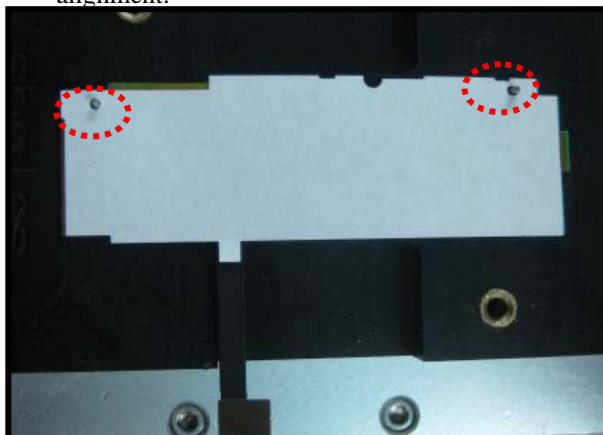


Figure 81. Placing Keyboard flex

- Using a press fixture, press assembly and hold for 5 seconds.

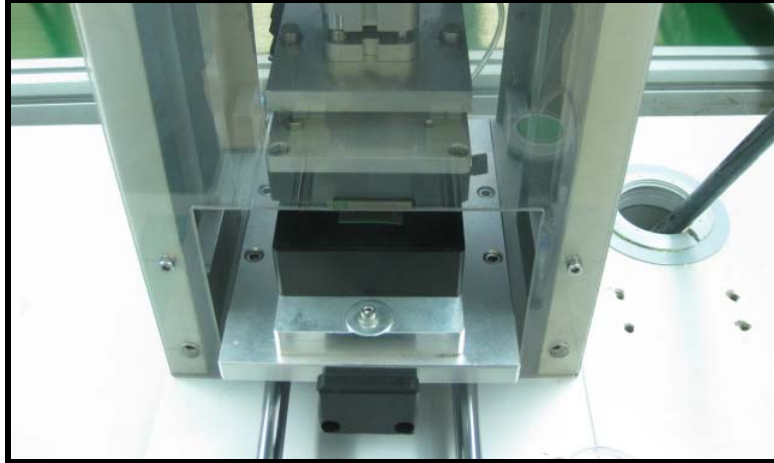


Figure 82. Press keyboard assembly

- Place a pad and kapton tape in illustrated areas.

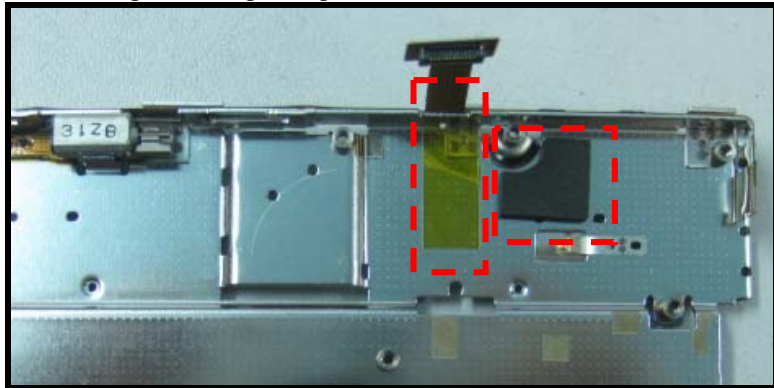


Figure 83. Placing a pad and kapton tape on slider chassis

- Feed the keyboard flex assembly through the slider chassis opening.

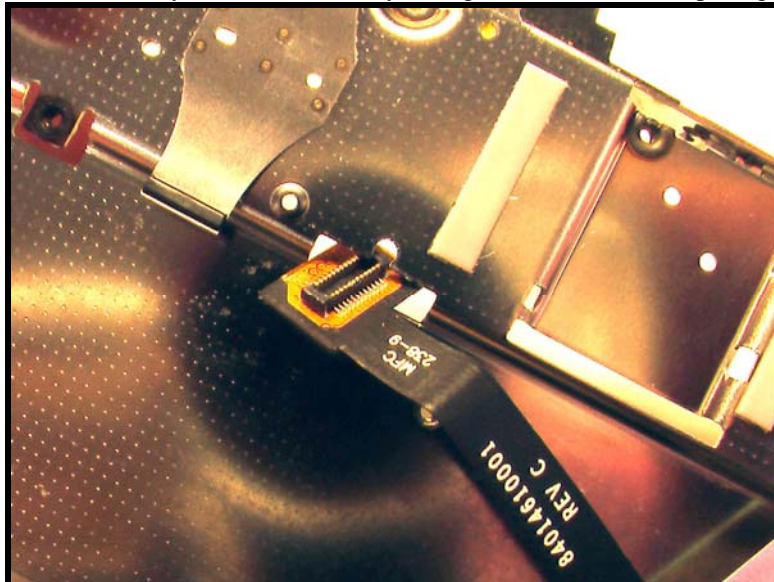


Figure 84. Feeding the keyboard flex assembly

- Using the alignment posts, align the slider chassis and the keyboard flex assembly over the alignment fixture.

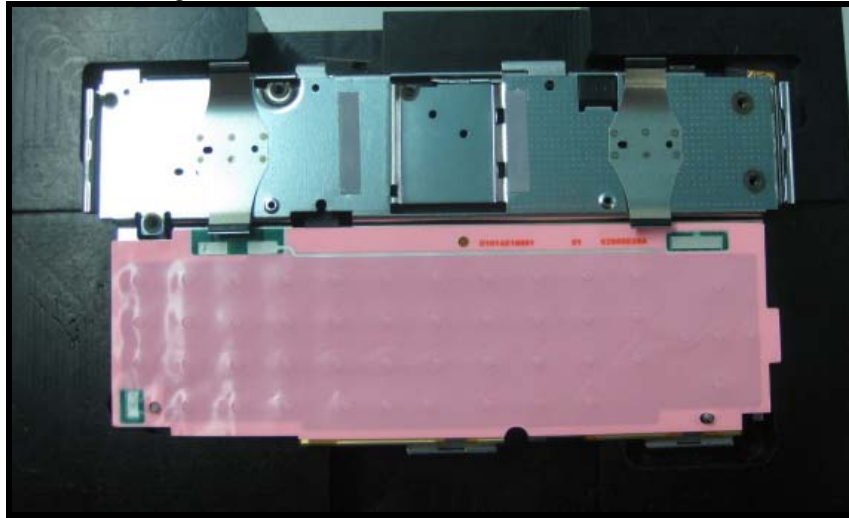


Figure 85. Aligning the slider chassis and keyboard flex assembly

- Place a pad and speaker grill on the slider plate as illustrated.

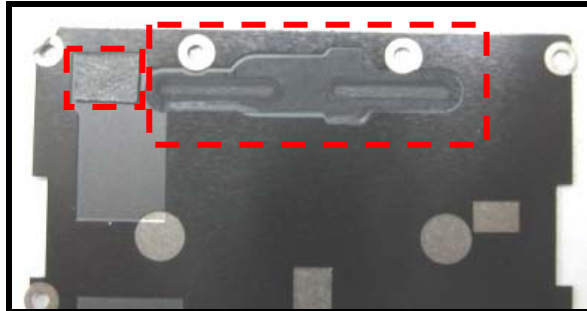


Figure 86. Placing speaker grill and pad

- Align the slider plate to the slider chassis and slide downward.

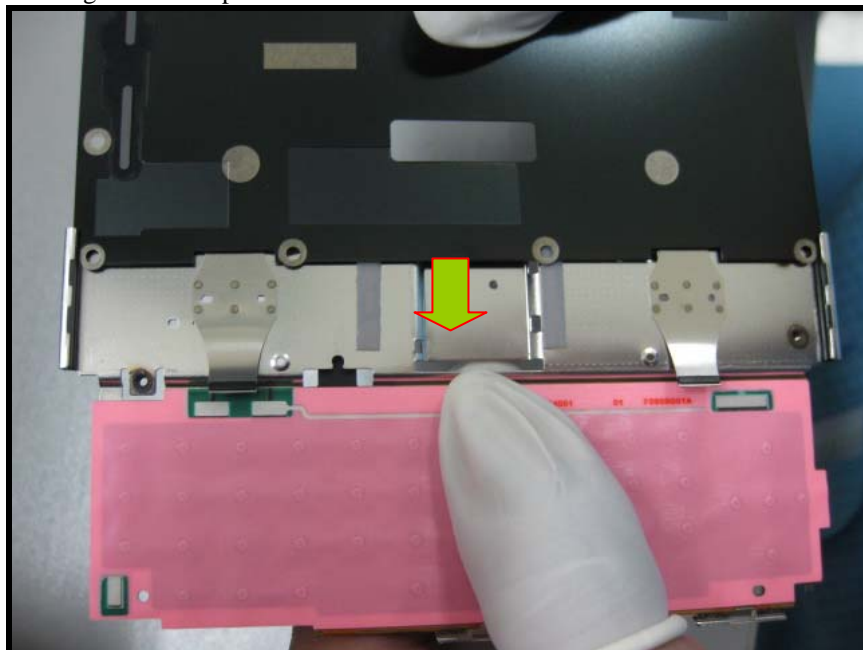


Figure 87. Installing slider plate

9. Place a pad over the metal stiffener of the keyboard flex assembly connector.

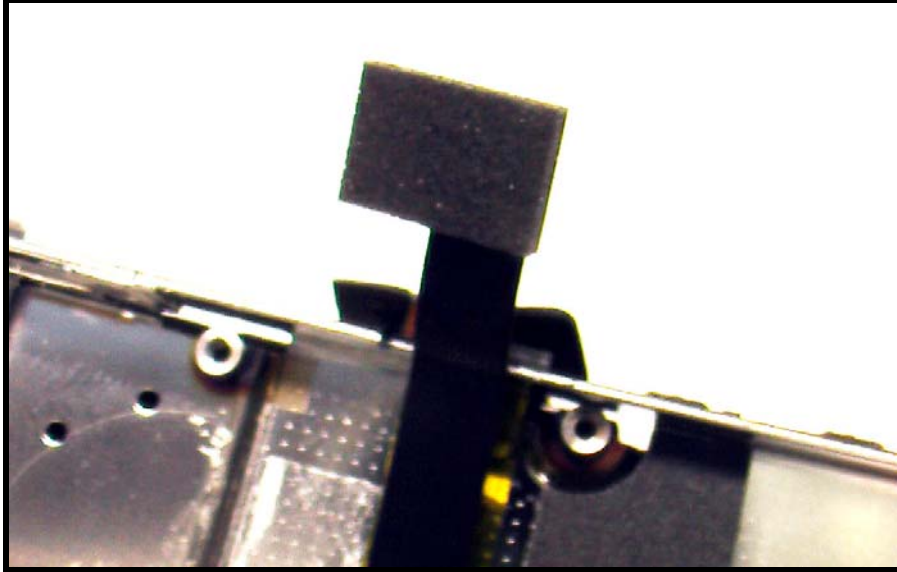


Figure 88. Placing pad over metal stiffener

10. Remove the adhesive backing for the ground tape.

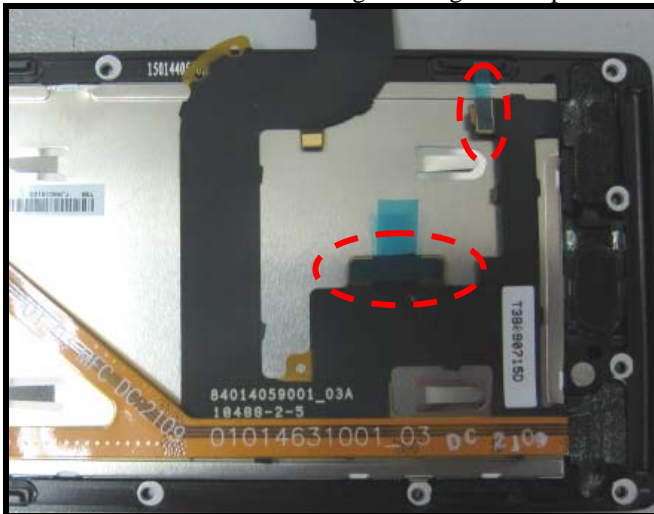


Figure 89. Removing backing for ground tape

11. Position the slider plate until the opening for the slider chassis and slider plate are aligned.

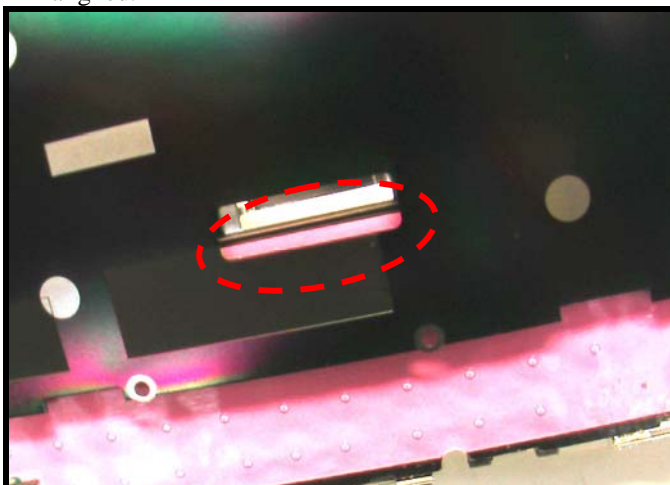


Figure 90. Aligning slider opening

12. Carefully feed the dynamic flex through the slider opening.



Figure 91. Feeding dynamic flex

13. Carefully pull the dynamic flex through the opening.



Use caution when pulling dynamic flex through opening to prevent damage



Figure 92. Pulling dynamic flex through slider

14. Align the screw holes for the slider plate and slider outer housing.

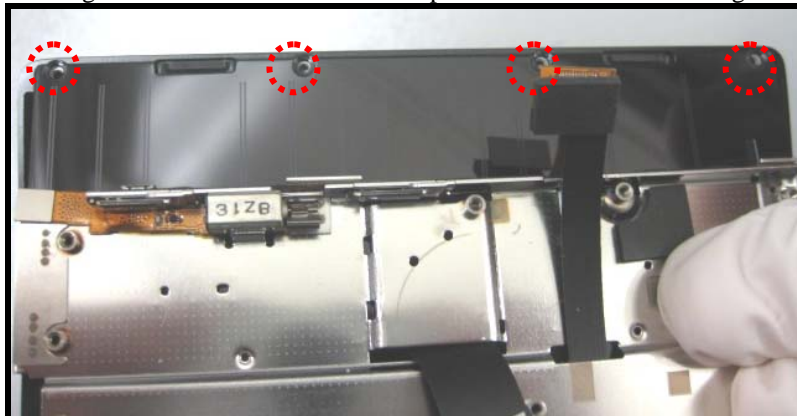


Figure 93. Align slider screw holes

Using a driver with JIS #00 cross bit and torque setting of 1.8 in-lbs(20.34 N-cm), install 4 screws in the indicated order.

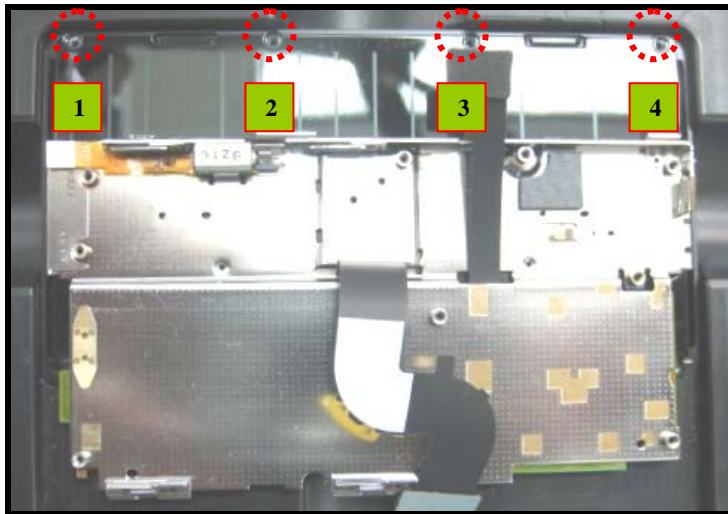


Figure 94. Installing slider screws (4 points)

15. Fully open the slide and install the next screw using the same bit size and settings.

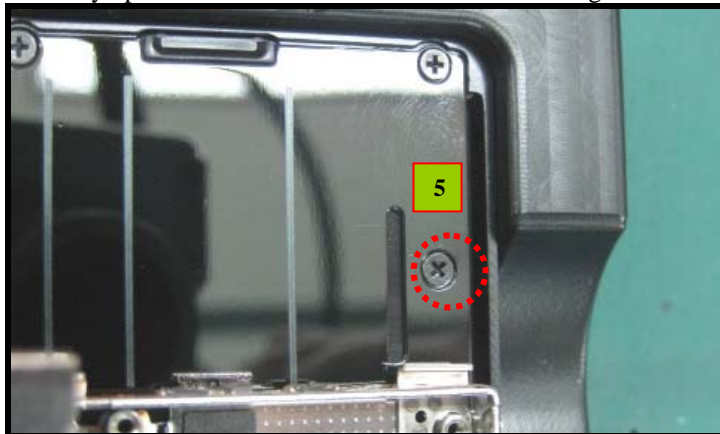


Figure 95. Installing slider side screw (1 point)

16. Close the slider until the next side screw hole is visible, then using the same bit size and settings, install screw.

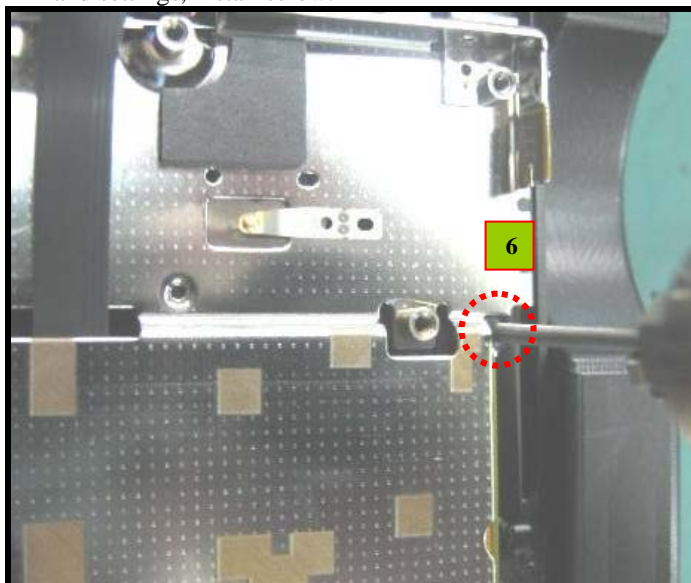


Figure 96. Installing 2nd slider side screw (1 point)

17. Fully close the slider and using the same bit size and setting, install the screws in the indicated order.

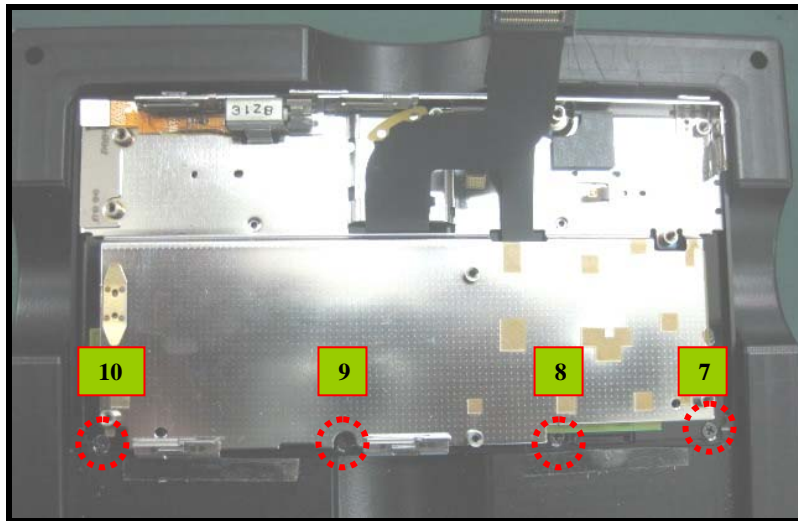


Figure 97. Install slider screws at bottom (4 points)

18. Remove the adhesive backing and use the alignment holes to position the dynamic flex to the slider chassis.

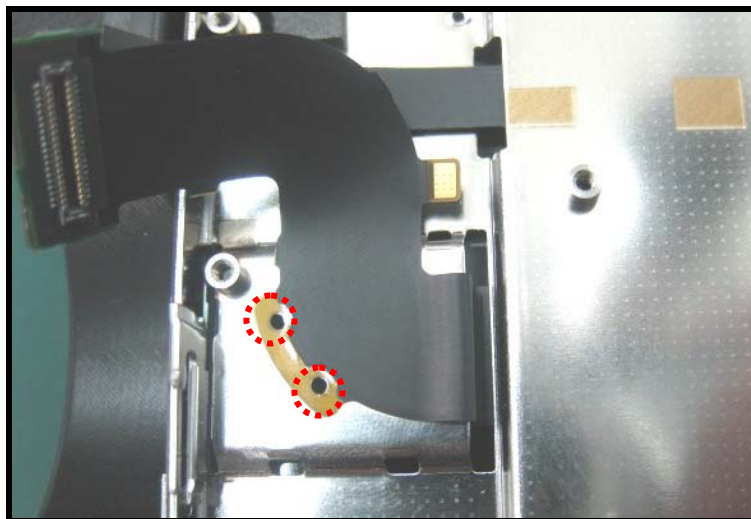


Figure 98. Aligning the dynamic flex to the slider chassis

19. Press on the dynamic flex to activate adhesive. Also push down any excess flex into the slider slot.

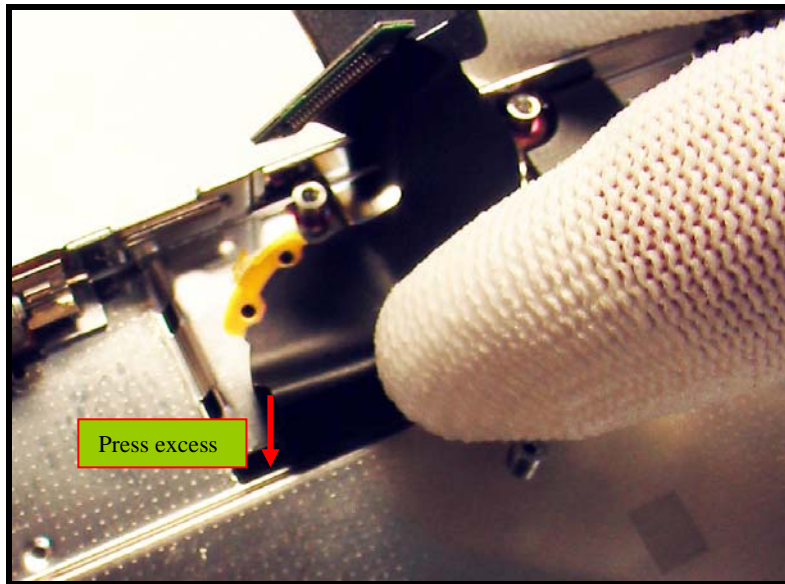


Figure 99. Pressing on dynamic flex

20. Slide the dynamic flex retaining clip in the direction illustrated.

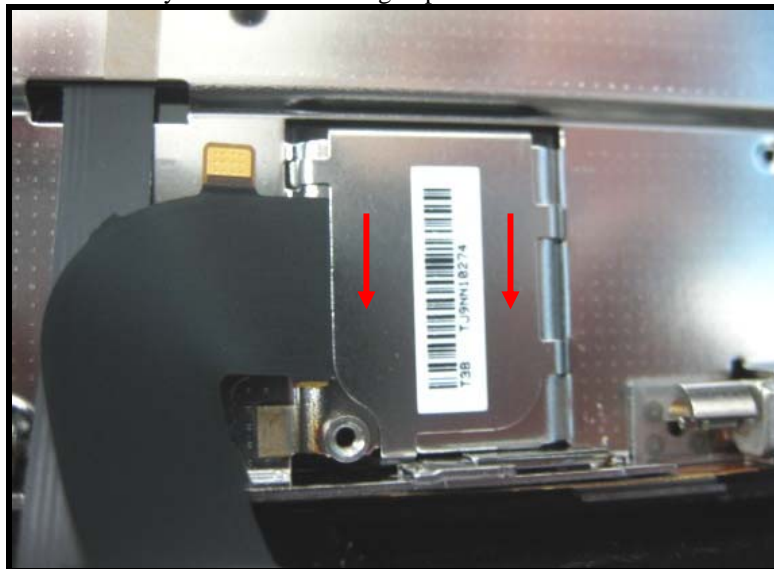


Figure 100. Attaching dynamic flex retaining clip

Main PCB Assembly

1. Slightly open the slider.

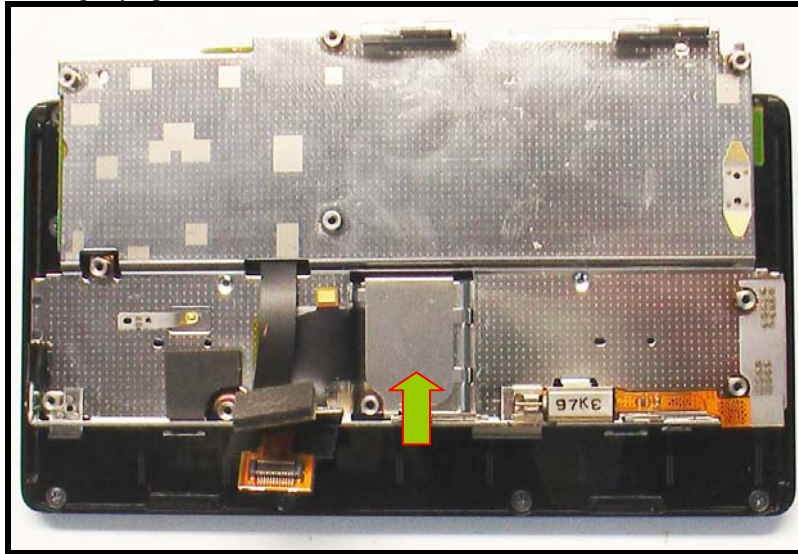


Figure 101. Opening slider

2. Assemble the front housing to the slider assembly by latching to the hooks (1) and aligning to the screw openings (2).

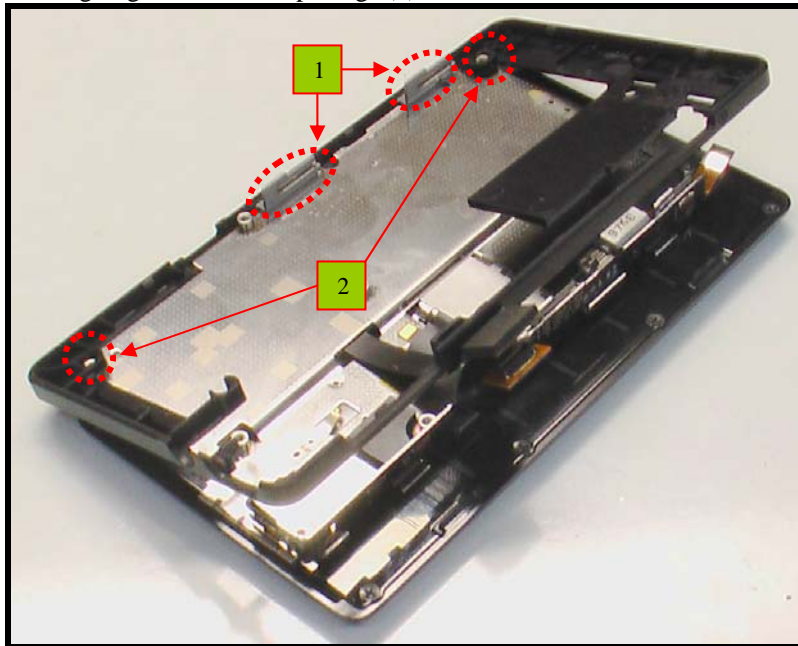


Figure 102. Aligning front housing to slider

3. Guide the 3 flex assemblies on the inside of the front housing.

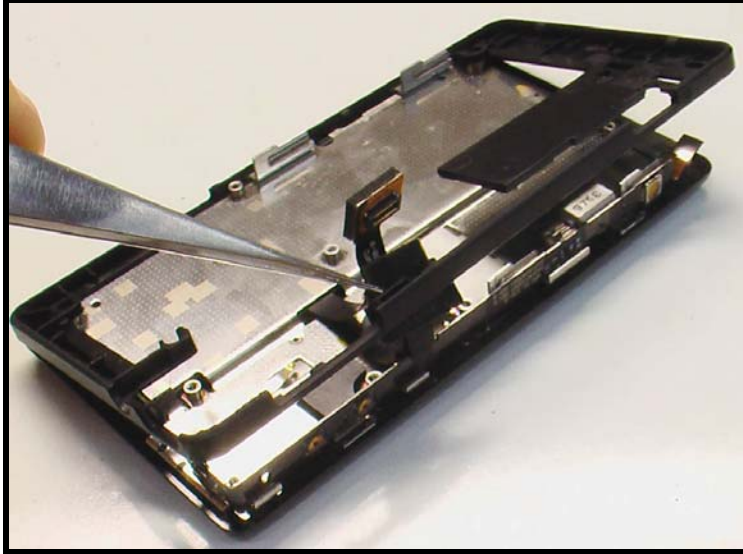


Figure 103. Guiding flexes to inside of housing

4. Lift the side flex connector to insure it lays over the housing.



Insure that side flex connector is not under housing



Figure 104. Lifting Side flex connector

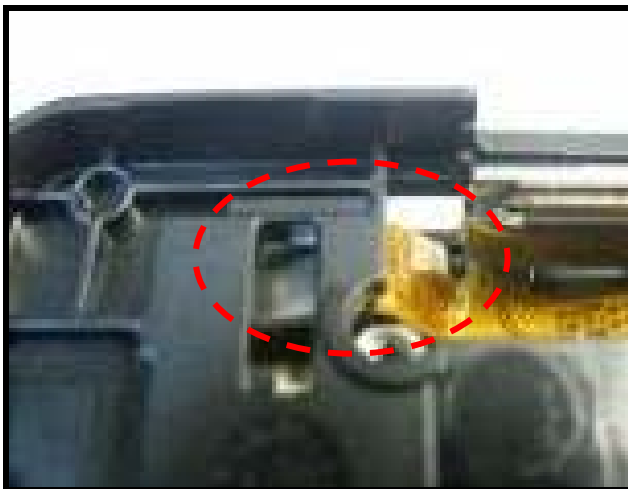


Figure 105. Wrong side flex assembly

5. Press down on Front housing to fully seat on slider assembly.

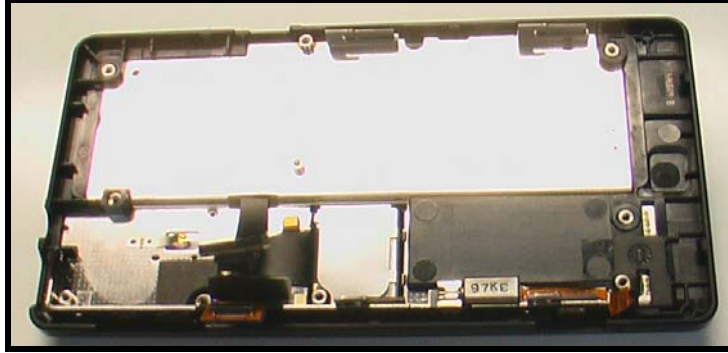


Figure 106. Fully seat front housing on slider assembly

6. Place foam coax support on slider assembly.

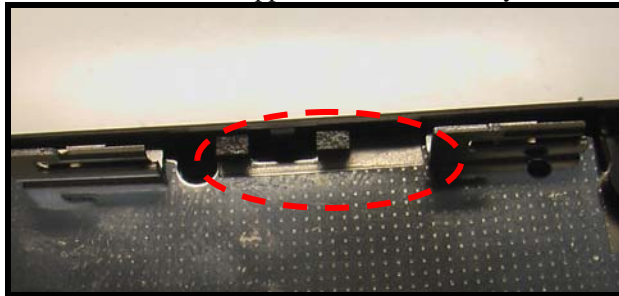


Figure 107. Foam support

7. Place rubber grommet around USB connector.

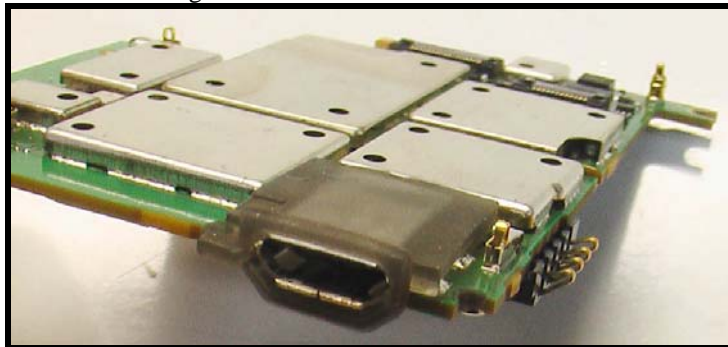


Figure 108. USB rubber grommet

8. Place board grommet over connectors.

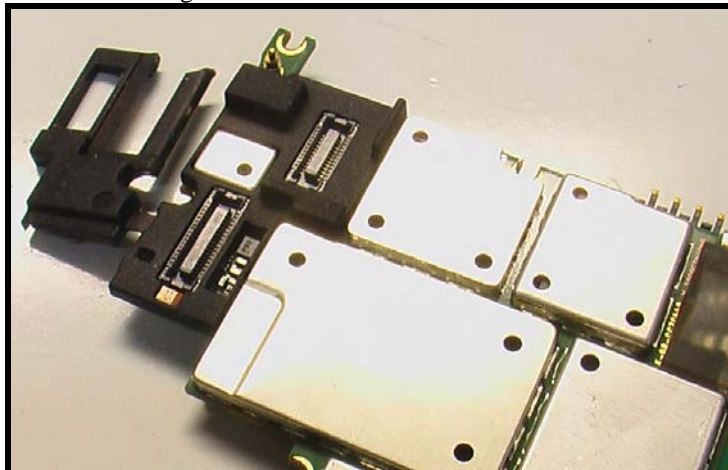


Figure 109. Board grommet

9. Attached camera assembly to main board.

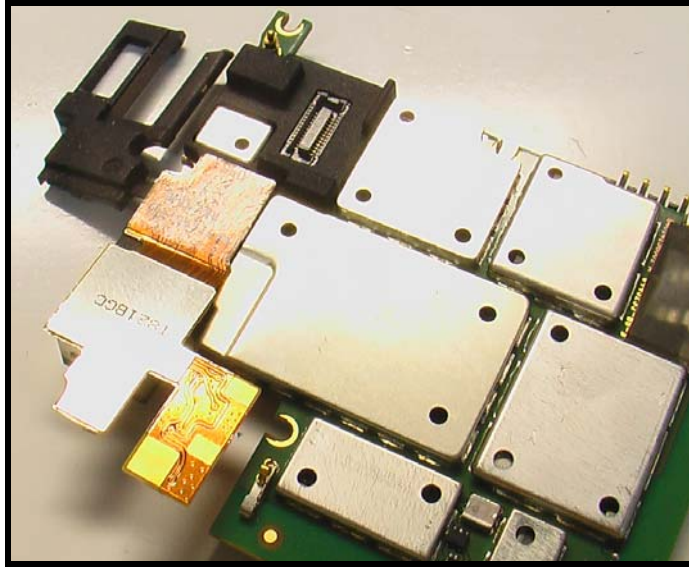


Figure 110. Attaching camera assembly

10. Clip the boot strap over the main board shields.

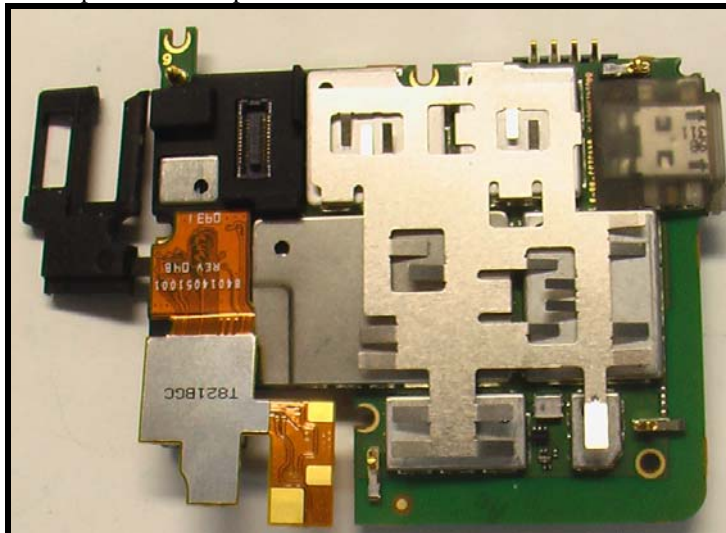


Figure 111. Attaching the boot strap

11. Flip main board over to the other side and wrap board grommet around the BTB connectors.

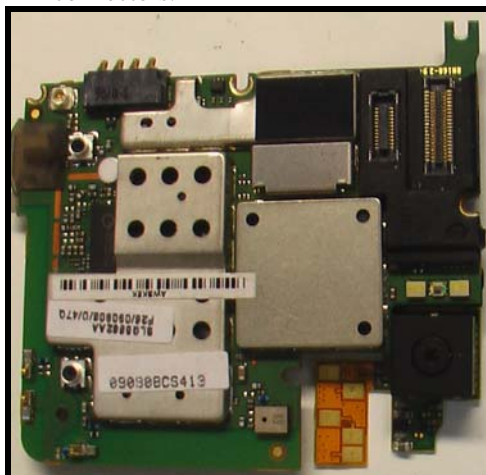


Figure 112. Board grommet over other side

12. Position main board at a 90 degree angle and attach the dynamic flex connector.



Insure that all flex connectors fully snap into place

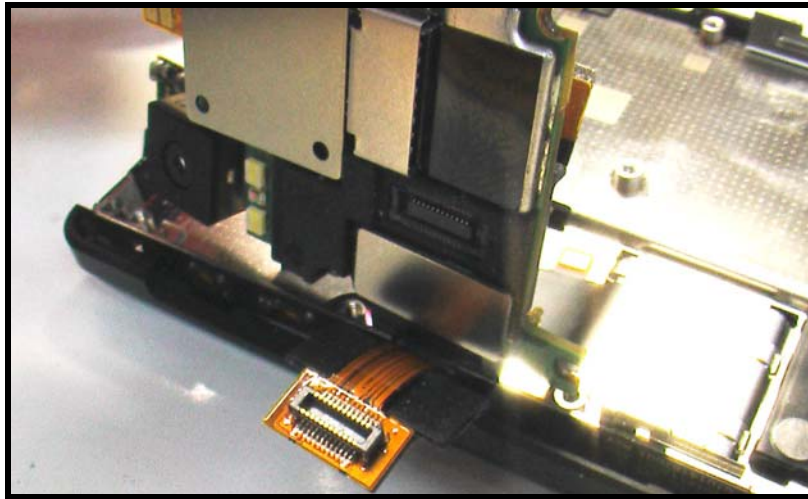


Figure 113. Connecting the dynamic flex connector

13. Connect the side button flex connector.

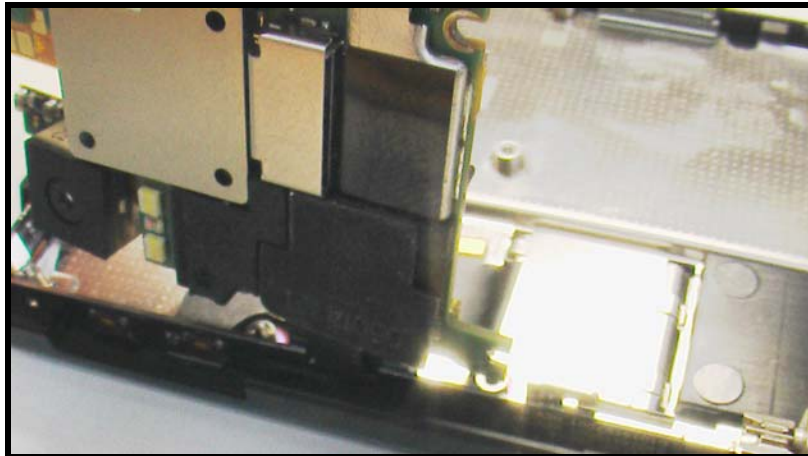


Figure 114. Connecting the side key flex connector

14. From the inside, connect the keyboard flex connector.

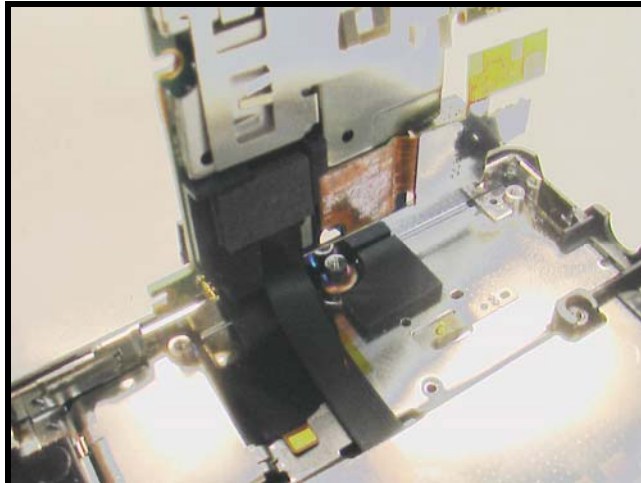


Figure 115. Attaching the keyboard flex connector

15. Fold over the main board on the slider assembly.

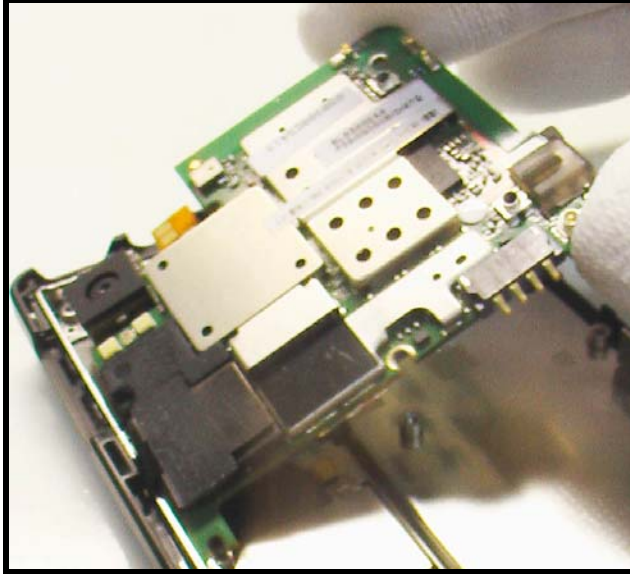


Figure 116. Placing main board

16. Press down on the main board to insure it's seated and aligned properly.

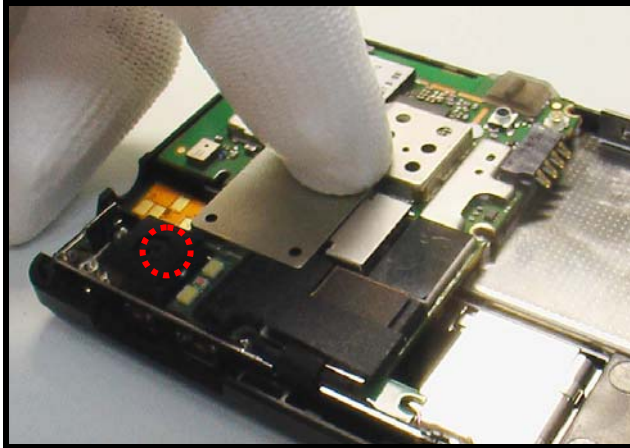


Figure 117. Aligning main board

17. Using a driver with T5IP torx bit, install 3 PCB screws in the indicated order with a torque setting of 1.0 in-lbs (11.30 N-cm).

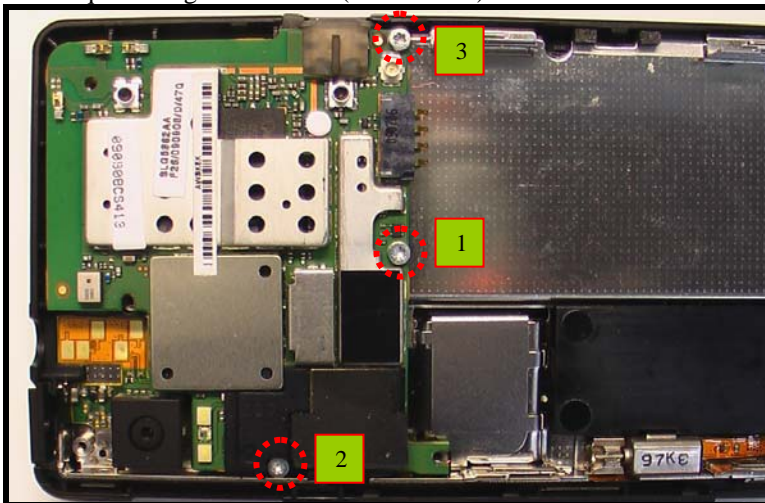


Figure 118. Installing PCB screws (3 points)

Antenna / Acoustic Chamber Assembly

1. Remove the adhesive backing from the audio gasket and place in alignment fixture.



Figure 119. Audio gasket alignment

2. Using the alignment fixture, place the audio board over the audio gasket and press to activate adhesive.



Figure 120. Audio board alignment

3. Remove the adhesive backing from the audio board and using the alignment fixture, place the adhesive layer over the audio board assembly.
4. Press in all areas to activate adhesive.



Figure 121. Placing audio board adhesive

5. Place a foam grommet over the mic.

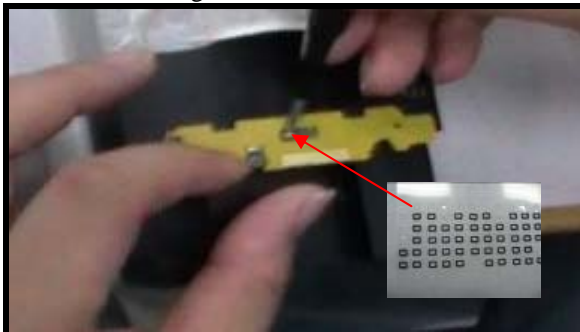


Figure 122. Placing mic foam grommet

6. Remove the backing of the loudspeaker adhesive and place over alignment fixture.



Figure 123. Placing loudspeaker adhesive

7. Using the alignment fixture, place the loudspeaker over the adhesive layer and press.



Figure 124. Applying adhesive layer to loudspeaker

8. Remove loudspeaker from fixture and place in acoustic chamber assembly. Press to insure good adhesion.



Figure 125. Placing loudspeaker

9. Place speaker screen as illustration. Press to insure good adhesion.



Figure 126. Placing loudspeaker screen

10. Remove the adhesive backing from the audio board assembly.



Figure 127. Placing adhesive on audio board

11. While holding the side flex up, attach the audio board to the main assembly.

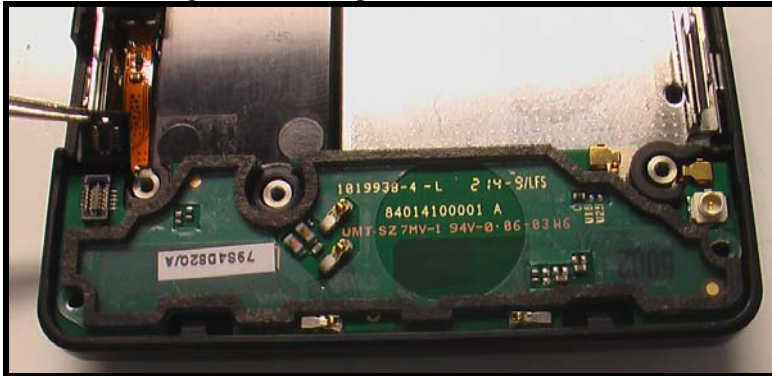


Figure 128. Placing audio board

12. Place the acoustic chamber assembly over the audio board.

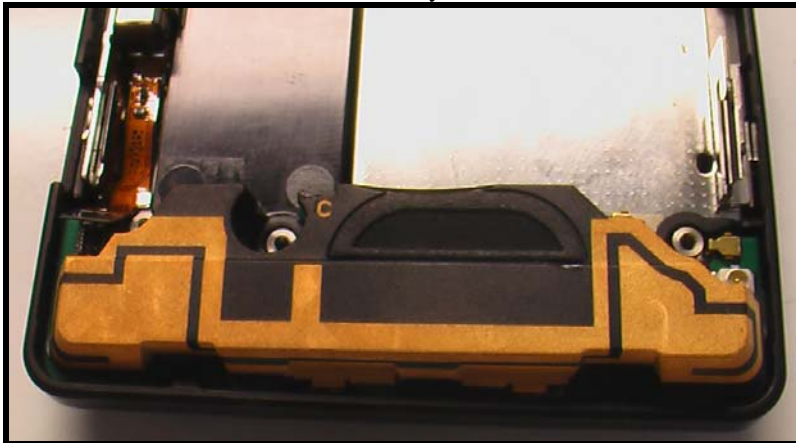


Figure 129. Placing acoustic chamber

13. Attach the side flex connector.



Avoid any scratches or damage to acoustic chamber antenna coating

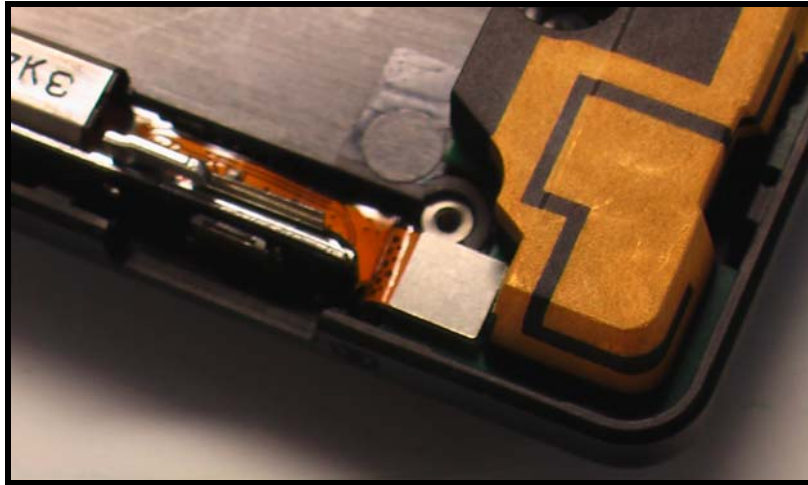


Figure 130. Attaching the side flex connector

Rear Housing Assembly

1. Apply a water detect indicator in the indicated area.

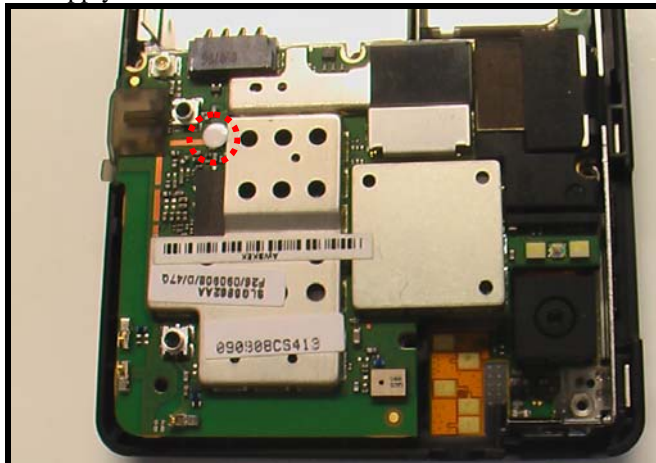


Figure 131. Water detect indicator on main board

2. Verify that the main board is aligned by verifying that the PCB screw hole is aligned with the housing assembly screw boss.

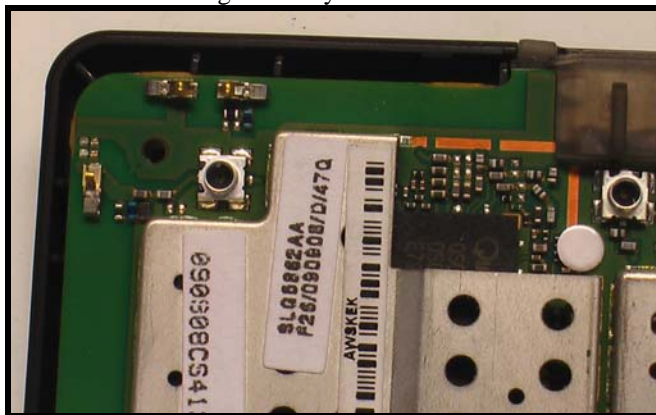


Figure 132. Main board screw alignment verification

3. Install the RF coax cable with the connector that does not have a black marking on the audio board antenna connector.

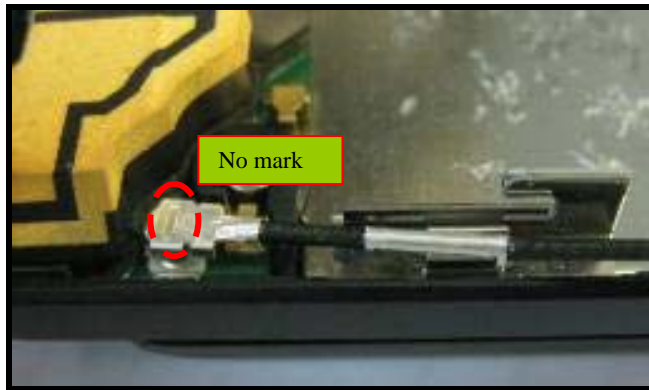


Figure 133. Attaching RF coax connector on audio board

4. Clamp the RF coax wire to the indicated clip.



Figure 134. Clamping RF coax wire

5. Clamp the RF coax wire to the second clip.



Figure 135. Clamping RF coax wire to 2nd clip

6. Attach the RF coax connector with a black marking on the main board RF connector.

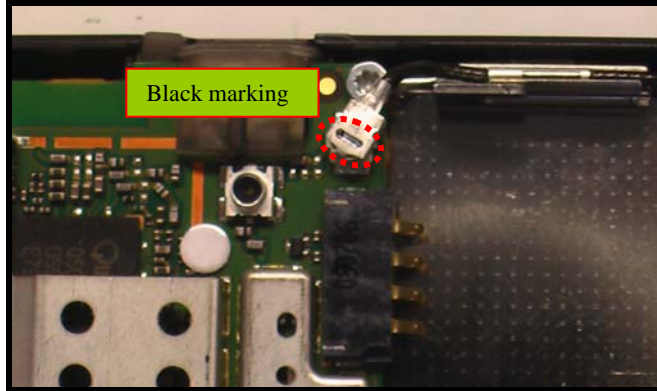


Figure 136. Attaching RF coax to main board

7. Position the RF coax cable so that it runs along the foam guides.



Figure 137. RF coax wire alignment

8. Place the camera key in the correct orientation.

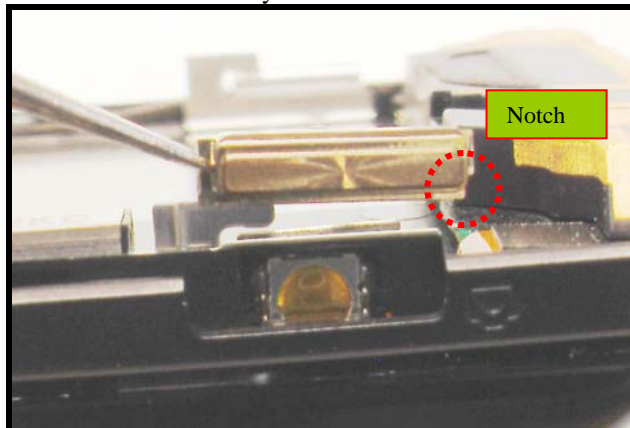


Figure 138. Placing camera key

9. Place volume key in the correct orientation.

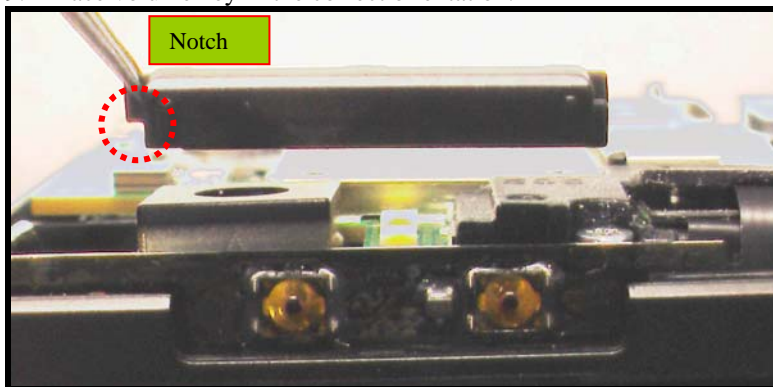


Figure 139. Placing volume key

10. Place the power key in the correct orientation.

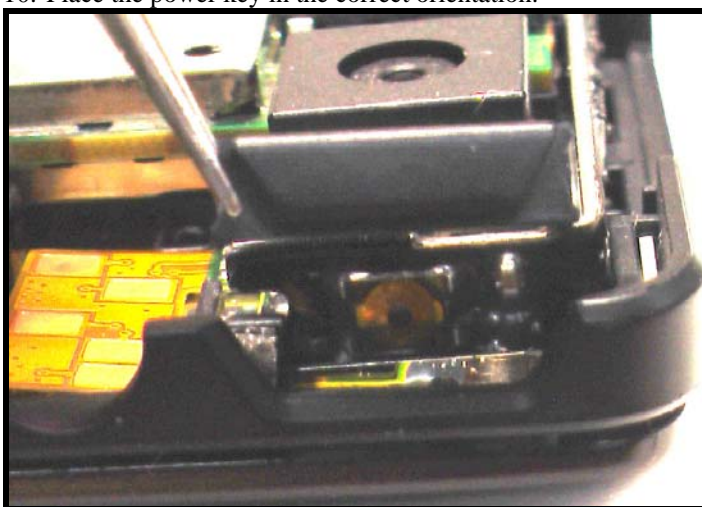


Figure 140. Placing Power Key

11. Place adhesive strip on rear housing.



Figure 141. Placing adhesive for headset jack

12. Place headset jack on housing. Press to insure good adhesion.



Figure 142. Placing headset jack

13. Insure that the headset jack is flush with the housing.

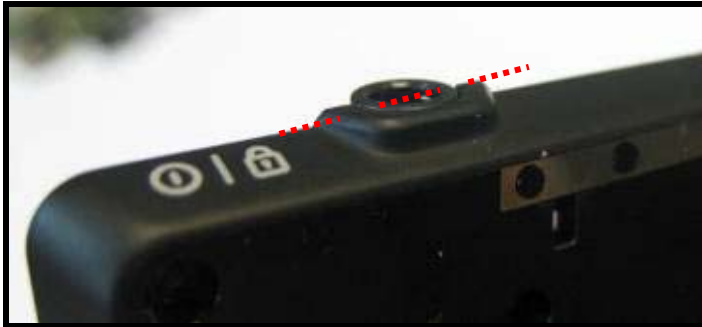


Figure 143. Headset flush with housing

14. Blow air in flash and camera lens area to insure no foreign materials are present.

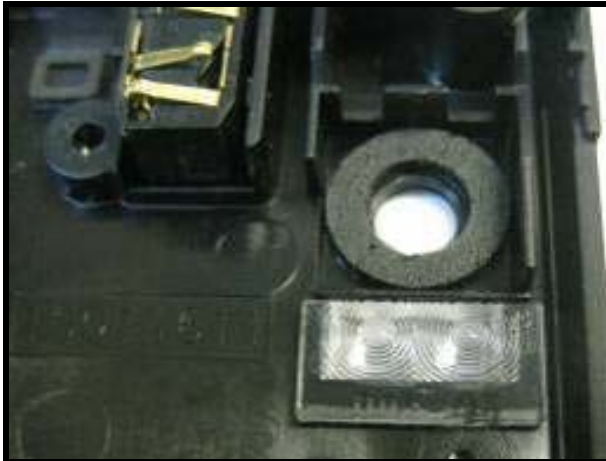


Figure 144. Remove foreign material from lens

15. Perform a final inspection to insure that the side keys are placed, acoustic assembly is aligned, SD card insulator is placed, and rubber connector cover is placed.

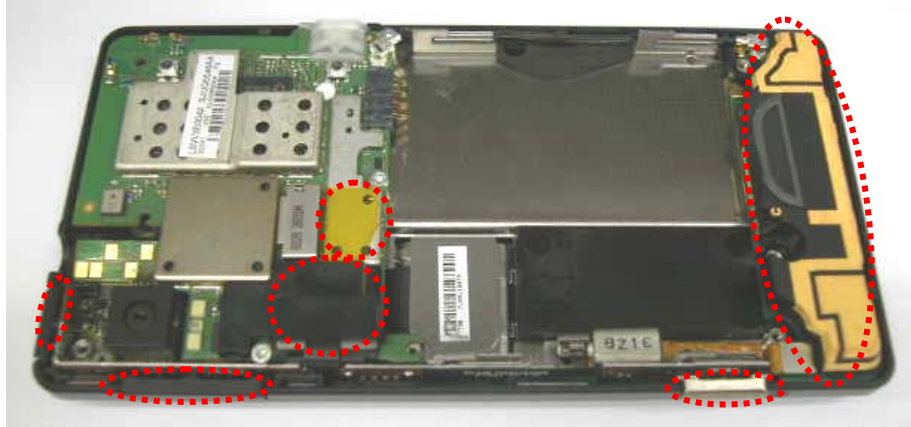


Figure 145. Final inspection before assembly

16. Starting from the camera side, attach the rear housing to the assembly.



Do not press around the camera lens area



Figure 146. Rear housing assembly

17. While the rear housing is being closed, guide the rear housing hook on the side of the main board.



Figure 147. Guide the rear housing hook around the edge

18. Press the rest of the rear housing against the front housing assembly until all side locking tabs are engaged.



Figure 148. Assembly of rear housing

19. Carefully push the rear housing hook into the screw post.



If the hook is deformed, replace the rear housing.

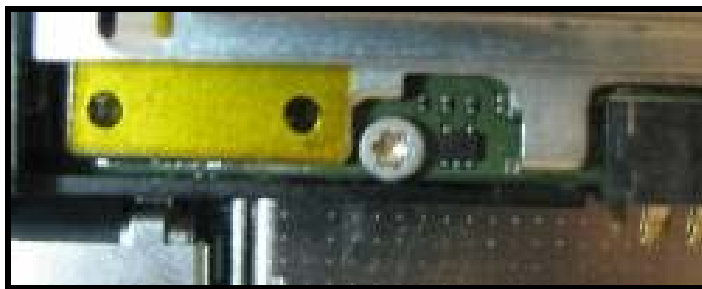


Figure 149. Housing hook pressed against board

20. Using a driver with torx T5IP bit, install 7 screws with a torque setting of 1.3 in-lbs (14.69 N-cm) in the order illustrated.



Figure 150. Installing rear housing screws (7 points)

Final Assembly

1. Remove the adhesive backing and attach the antenna cap as illustrated.



Figure 151. Attaching antenna cap

2. Insert the battery label tab in the corner near the SD card holder.



Figure 152. Insert battery label tab

3. Press edge of battery label against housing wall near the battery connector.



Figure 153. Aligning battery label

4. Press on battery label to insure good adhesion.



Figure 154. Press on battery label

5. Position the slider in a fully open position.



Figure 155. Slider in open position

6. Slide the keypad under the slider edge and press into position.



Figure 156. Placing keypad

7. Beginning from the camera side, attach the camera/flash cover on the housing and press to insure good adhesion.



Figure 157. Placing camera/flash cover

8. Starting from one side, attach the speaker grill and press to insure good adhesion.



Figure 158. Placing speaker grill

9. Using the keypad press fixture, press the keypad for 5 seconds.



Figure 159. Press keypad (Required fixture)

10. Using the lens cover press, press the lens cover for 5 seconds.



Figure 160. Press lens cover (Required Fixture)