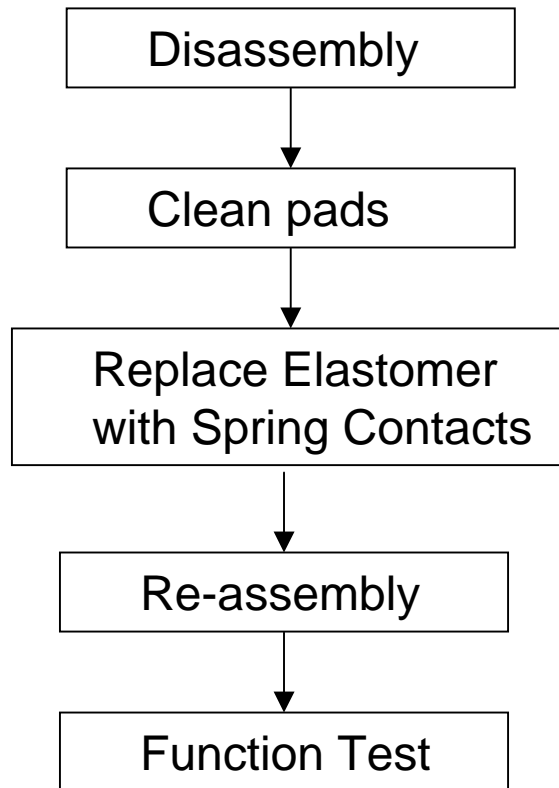


Work Instruction of Elastomer Replacement with Spring Contact

- Flow Chart of Elastomer Replacement
- Note: ESD wristlet is a must when touching components, Finger cot is a must when touching display, golden pads and spring contact.



Work Instruction of Elastomer Replacement with Spring Contact

- Unfix the 4 screws
- Take off the rear-housing and PCB board



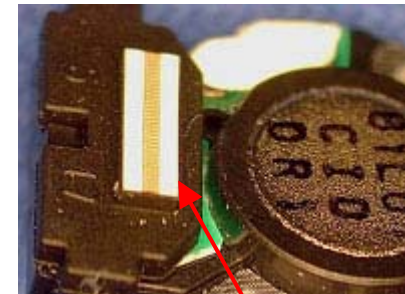
Work Instruction of Elastomer Replacement with Spring Contact

- Disassemble the flip from the base
- Note: make sure the flex cable is in the gap before removing the front housing.



Work Instruction of Elastomer Replacement with Spring Contact

- Take off the 4 screw covers and unfix the flip screws
- Take off the flip cover, chassis, snubber, camera cover and camera
- Take off the LCD model together with flex cable
- Remove and discard the 3987819M02 Elastomer



Elastomer

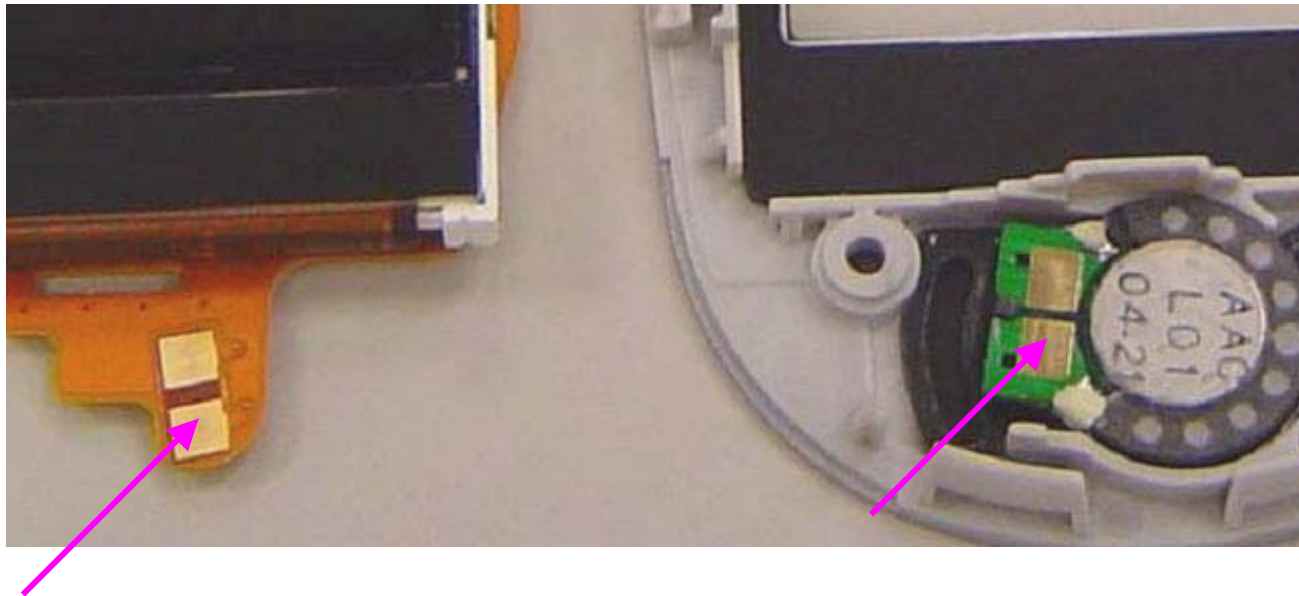
Work Instruction of Elastomer Replacement with Spring Contact

- Separate the flex from the LCD module
- Paste the 0771469B01 Flex Stiffener on back of flex
- A simple fixture can be used to ensure the alignment



Work Instruction of Elastomer Replacement with Spring Contact

- Clean both flex pads and speaker pads with Isopropyl Alcohol (IPA)
- Inspect under magnification to ensure no foreign material is present on pads



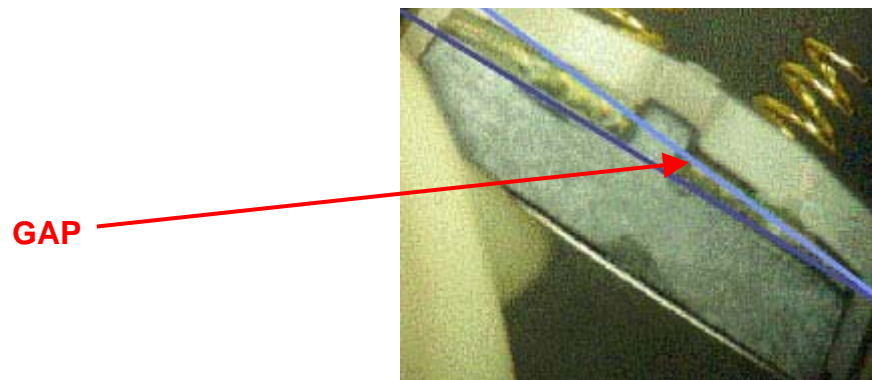
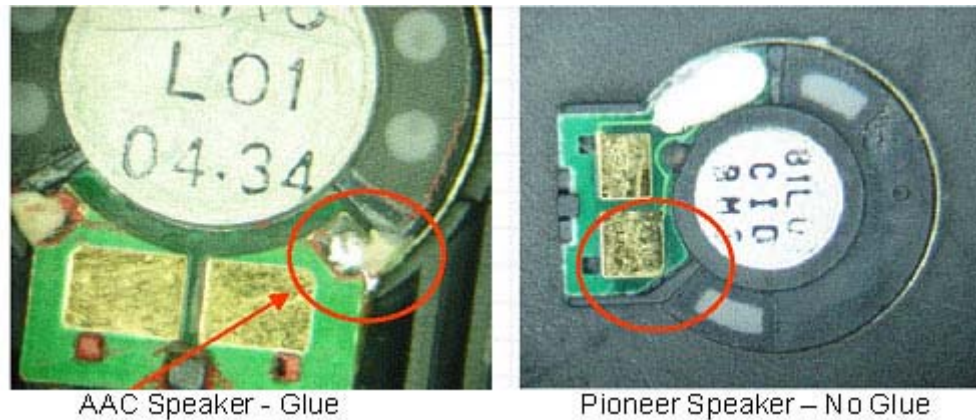
Work Instruction of Elastomer Replacement with Spring Contact

- Attach the 3989791L03 Spring Contact on the speaker
- Make sure it's aligned well



Work Instruction of Elastomer Replacement with Spring Contact

- There is a potential alignment issue present when attaching the L03 Spring Contact to some AAC Speakers due to variance in the height of the glue. See images below.
- If this issue is observed, the AAC Speaker should be replaced to allow proper mating with the new Spring Contacts.



Work Instruction of Elastomer Replacement with Spring Contact

- Assemble back the LCD module with flex
- Assemble back the camera module
- Paste a kapton tape (1190142N01) on the flex and pcb to make sure the locating column of flip base is within flex locating hole of flex cable
- Reassemble the phone and Retest

