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DROID MAXX 2 / Moto X Play

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DROID MAXX 2 / Moto X Play
Level 2 – Service and Repair Manual

REVISION HISTORY

Revision	*Date*	*Notes*
1	08/07/2015	Initial release.
2	08/18/2015	Images added to Rear Housing Preparation for the Audio Gasket Alignment Fixture and Audio Gasket.
3	10/26/2015	Added the Universal Press Weights to the Tools Required for Assembly and the Rear Cover Assembly.

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SAFETY INFORMATION

Cautions and Warnings

Electrostatic Discharge

The phone components may be damaged by electrostatic discharge (ESD). Always use an ESD mat and ground strap when working with internal components.

Battery Safety Guidelines

Handle Battery with care. Ensure Battery edges and surfaces are not dented or deformed. If the Battery Pack is dropped to the floor, it may be internally damaged and must be scrapped.

Ensure all surfaces, fixtures, and phone components contacting the Battery are smooth and clean.

- Ensure Battery and its insulation are not damaged (e.g. scratched, dented, punctured) prior to and throughout assembly.
- Prior to assembly, ensure Battery edges and surfaces are not dented or deformed, and that fixtures and parts that will contact the Battery are free of foreign material.
- Ensure screws and screwdrivers do not contact the Battery.
- Failure to adhere to Safety Critical Note(s) may increase risk of rupture, burning, or failure to function safely when used by the customer.

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INTRODUCTION

External Views

Figure 1. External Views

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Table 1. External Views Parts List

Reference #	*Description*
1	Earpiece Speaker
2	Front-Facing Imager
3	Main Display
4a	Power Key
4b	Volume Key
5	LED Flash
6	Rear-Facing Imager
7	Rear-Facing Imager Bezel
8	Motorola Logo
9	Main Microphone
10	Front Housing
11	Rear Housing
12	SIM and SD Card Tray
13	Headset Jack
14	USB Port

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PSCD Gaps

All dimensions are in millimeters (mm). The following gaps are considered maximum allowable without further approval from a supervisor. Measure gaps at an angle perpendicular to the surface/area being measured. Feeler Gauges must not be used at an angle as they will give false-positive results.

Figure 2. PSCD Front View

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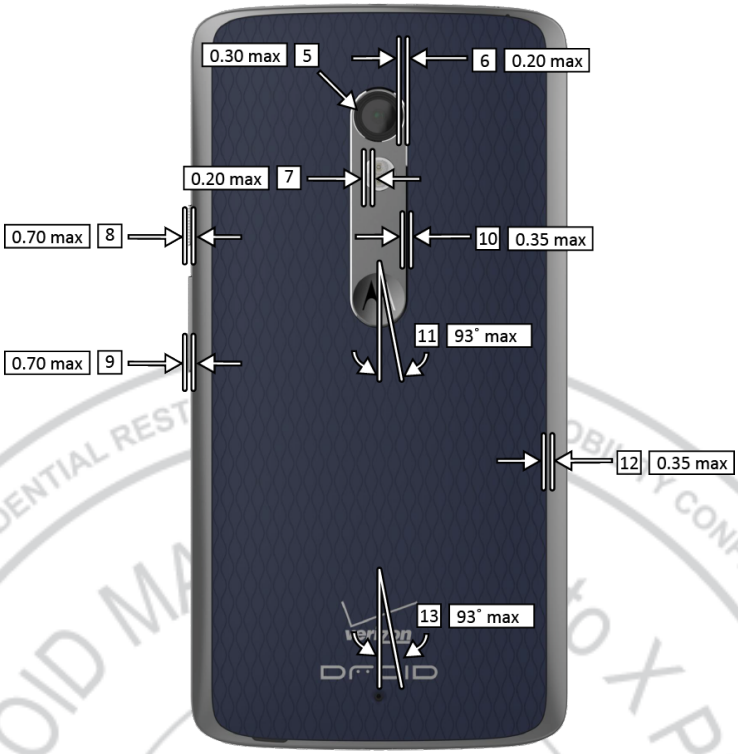

Figure 3. PSCD Rear View

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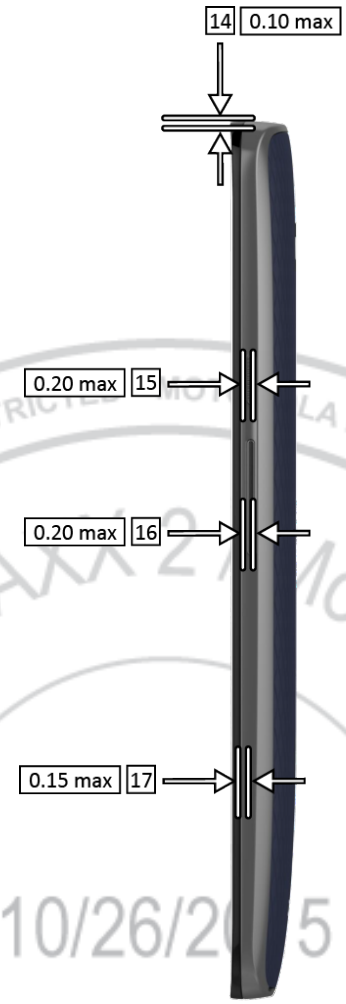

Figure 4. PSCD Side View

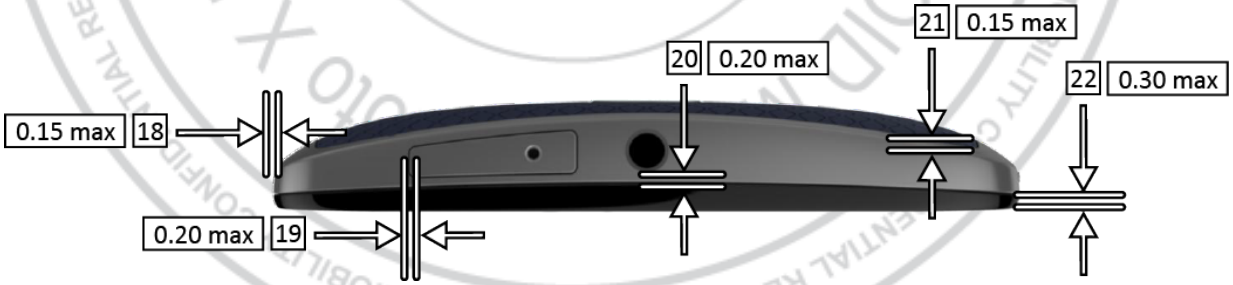

Figure 5. PSCD Top View

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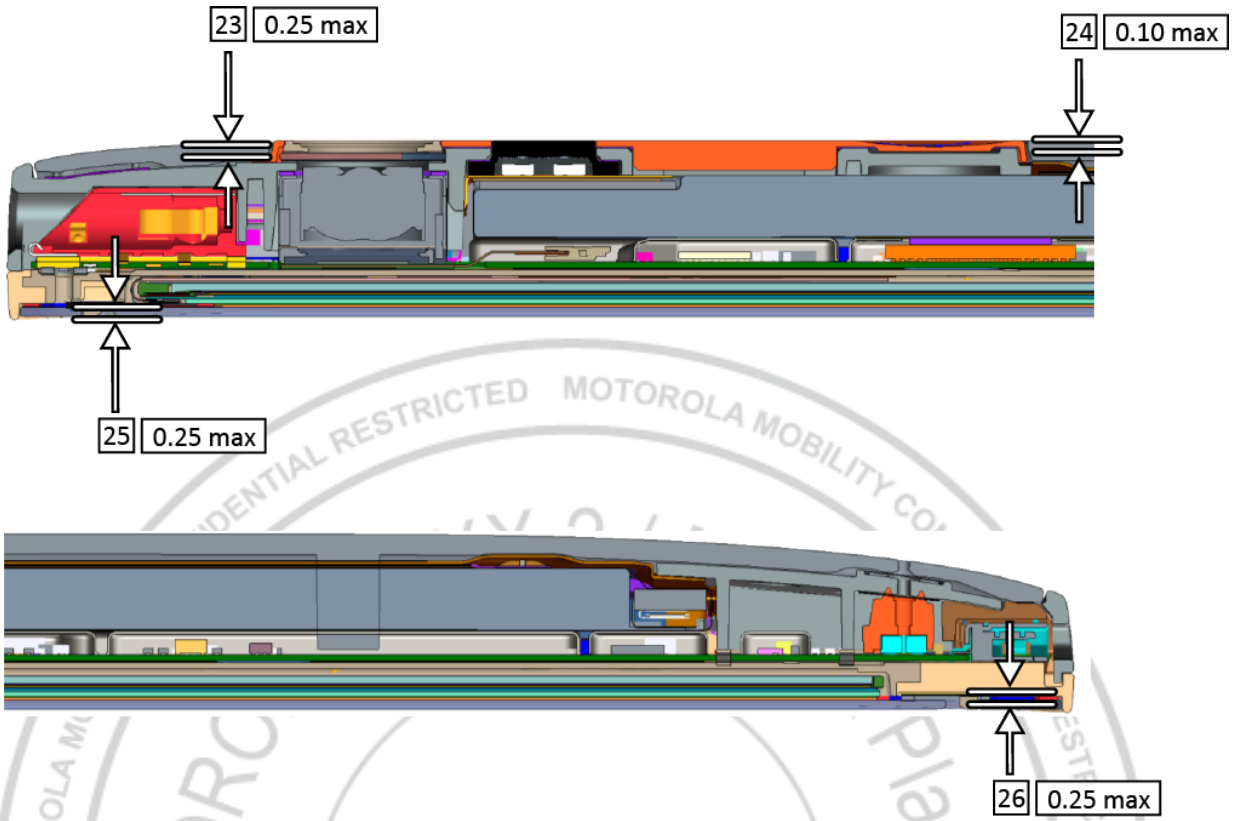

Figure 6. PSCD Cross Section View

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Figure 7. PSCD Display Alignment

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Table 2. PSCD Gap Measurements

Reference #	*Description*
1	Earpiece Bezel to Main Lens Perimeter
2	Front-Facing Imager Eye to Main Lens Artwork Concentricity
3	Main Lens to Front Housing Perimeter
4	Main Microphone to Main Lens Perimeter
5	Rear-Facing Imager Eye to Camera Lens Artwork Concentricity
6	Camera Lens to Camera Bezel Perimeter
7	LED Flash to Camera Bezel Perimeter
8	Power Key to Housing Step
9	Volume Key to Housing Step
10	Camera Bezel to Rear Cover Perimeter
11	Motorola Logo (tips of "M") to Rear Cover Rotation
12	Rear Cover to Rear Housing Perimeter
13	Carrier Logo to Rear Cover Rotation
14	SIM and SD Card Tray to Housing Step
15	Power Key to Rear Housing Perimeter
16	Volume Key to Rear Housing Perimeter
17	Front Housing to Rear Housing Perimeter
18	Front Housing to Rear Housing Step
19	SIM and SD Card Tray to Rear Housing Perimeter
20	Front Housing to Rear Housing Perimeter
21	Rear Cover to Rear Housing Step
22	Main Lens to Front Housing Step
23	Rear Inlay to Camera Bezel Step
24	Rear Inlay to Camera Bezel Step
25	Main Lens to Front Housing Step
26	Main Lens to Front Housing Step
27	Main Lens Horizontal Alignment
28	Main Lens Vertical Alignment

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Exploded Views

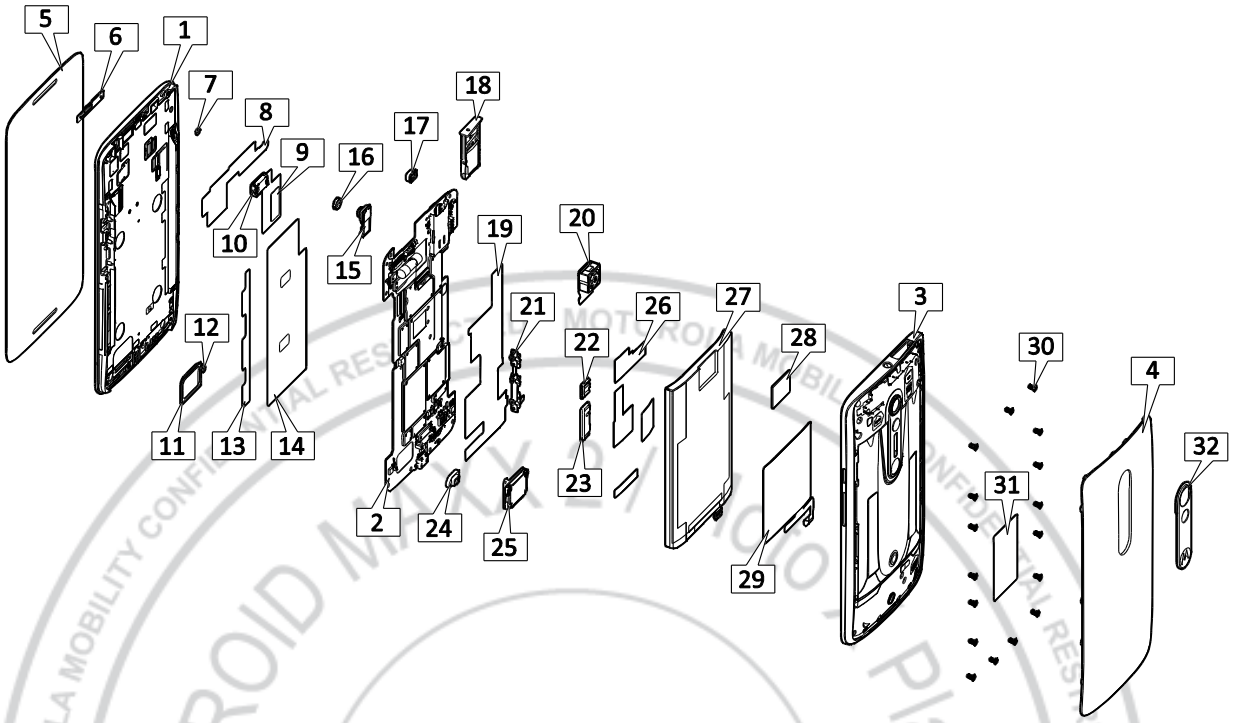

Figure 8. Assembly Exploded View

Table 3. Exploded View Parts List

Reference #	*Description*	*Recovery Part*
1	ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	YES
2	ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB – R	YES
3	ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	YES
4	HSG,REAR,COVER,CSR,LUX VZ CHALK HSG,REAR,COVER, SFT TOUCH, LUX NAVY VZ HSG,REAR,COVER, SFT TOUCH, LUX BLK HSG,REAR,COVER,CSR,LUX CHALK HSG,REAR,COVER, SFT TOUCH, LUX NAVY	YES
5	PROT LNR,LENS,DISPLAY, LUX	NO
6	BZL,EARPC,LUX MTLC SLVR BZL,EARPC,LUX,METALLIC DK GRY	NO
7	GSKT,LED, NOTIFICATION, LUX	NO

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Reference #	*Description*	*Recovery Part*
8	DIE CUT,COP TAPE, LED SHIELD, LUX	NO
9	DIE CUT,COP TAPE, TOUCH SHIELD, LUX	NO
10	TRANSDUCER,OTHR,.566V,W/ ADHES AND LINER	NO
11	GSKT,LOUDSPEAKER, FRNT VOLUME, LUX	NO
12	SCRN,MIC,MESH, PRIMARY, LUX	NO
13	DIE CUT,ADHES,PCB TO FH CHASSIS, LUX	NO
14	DIE CUT,ADHES,HT SPREADER, LUX	NO
15	ASSY,FLXCKT,MODULE,5MP, FF IMGR	YES
16	GROM,IMAGER, FRNT FACING 5MP, LUX	NO
17	GROM,PROX, LUX	NO
18	ASSY,SIM TRAY, DUAL, TIN SILVER, LUX ASSY,SIM TRAY, DUAL, DK TITANIUM, LUX	YES
19	DIE CUT,TAPE, COPPER, MSM SHIELD, LUX	NO
20	ASSY,FLXCKT,MODULE, 21MP, RF IMGR	YES
21	ASSY,FLXCKT,SIDE KEY, LUX	NO
22	BTN,PWR,LUX, TIN SLVR BTN,PWR,LYNX, LIC	NO
23	BTN,VOL,LUX TIN SLVR BTN,VOL,LUX, LIC	NO
24	GROM,MIC,TERTIARY MIC, LUX	NO
25	TRANSDUCER,OTHR,2.2V,AAC W/ ADHES W/ LINER	NO
26	DIE CUT,ADHES,BATTERY, LUX	NO
27	ASSY,BAT,FL40,LI POLYMER,LG CHEM,TYP3630 MAH	YES
28	GSKT,PORON,FLSH FLEX, LUX	NO
29	FIXED INDUCTOR,NFC FLEX, LUX	NO
30	SCREW,ENDO, M1.4X0.3, 2.8L, LUX SCREW,ENDO, M1.4X0.3, 3.1L, LUX	NO
31	IMEI LABEL	NO
32	ASSY,BZL,CAMERA, LUX TIN SLVR ASSY,BZL,CAMERA, LUX DK Ti	NO

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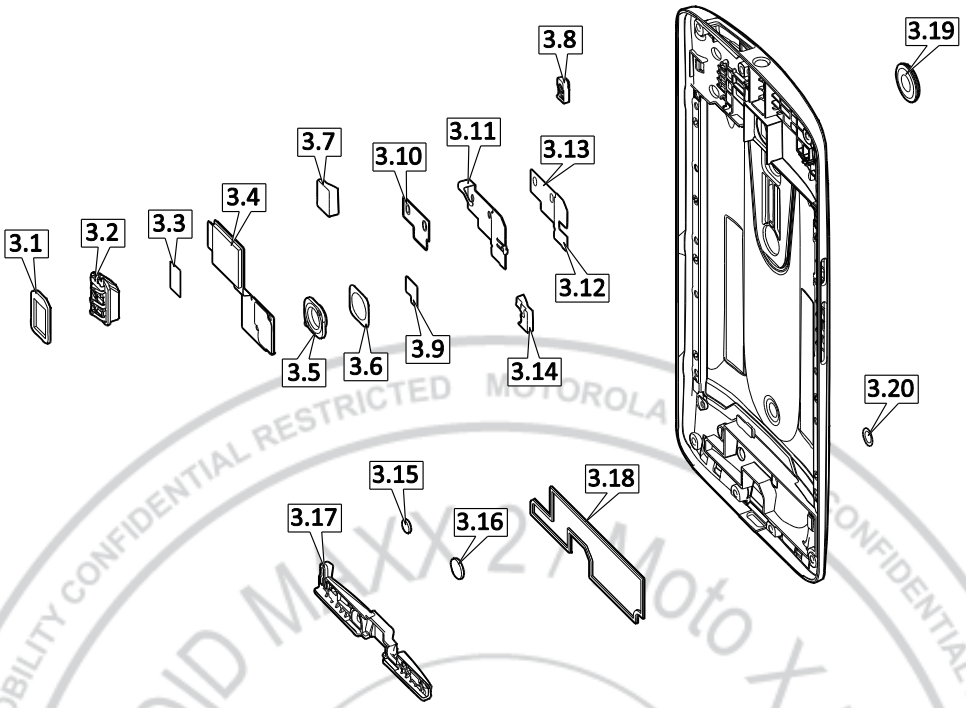

Figure 9. Subassembly Exploded View

Table 4. Subassembly Exploded View Parts List

Reference #	*Description*	*Recovery Part*
3.1	SEAL,GSKT,HSET JCK	NO
3.2	CONN,JACK,HEADSET,3.5 MM DIA	YES
3.3	DIE CUT,ADHES,HSET JACK, OLYMPUS	NO
3.4	ASSY,FLXCKT,LED FLASH, LUX	YES
3.5	LENS,FLASH, LUX	NO
3.6	DIE CUT,ADHES,FLSH LENS/REAR HOUSING, LUX	NO
3.7	GROM,PCB, DIVERSITY, LUX	NO
3.8	GROM,MIC,SEC MIC, LUX	NO
3.9	DIE CUT,TAPE, COPPER, LUX	NO
3.10	ASSY,FLXCKT,AU,LUX	NO
3.11	SPRT,STIFNR,BRACKET,AUDIO,LUX	NO
3.12	DIE CUT,ADHES,BRACKET, AU FLEX, LUX	NO
3.13	DIE CUT,ADHES,BRACKET, AU FLEX, 2, LUX	NO
3.14	GROM,PCB, WIFI, LUX	NO
3.15	PAD,NFC CONNECTORY, BACKUP, LUX	NO

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Reference #	*Description*	*Recovery Part*
3.16	PAD,BAT CONNECTOR, BACKUP, LUX	NO
3.17	HSG,REAR,BOT CARRIER, W/ANTENNA, GREY, LUX	NO
3.18	GSKT,ACSTC CHAMBER, LUX	NO
3.19	ASSY,PRD OTH,CAMR LENS, LUX	NO
3.20	SCRN,MIC,MESH, TERTIARY. CAVITY SIDE, LUX	NO

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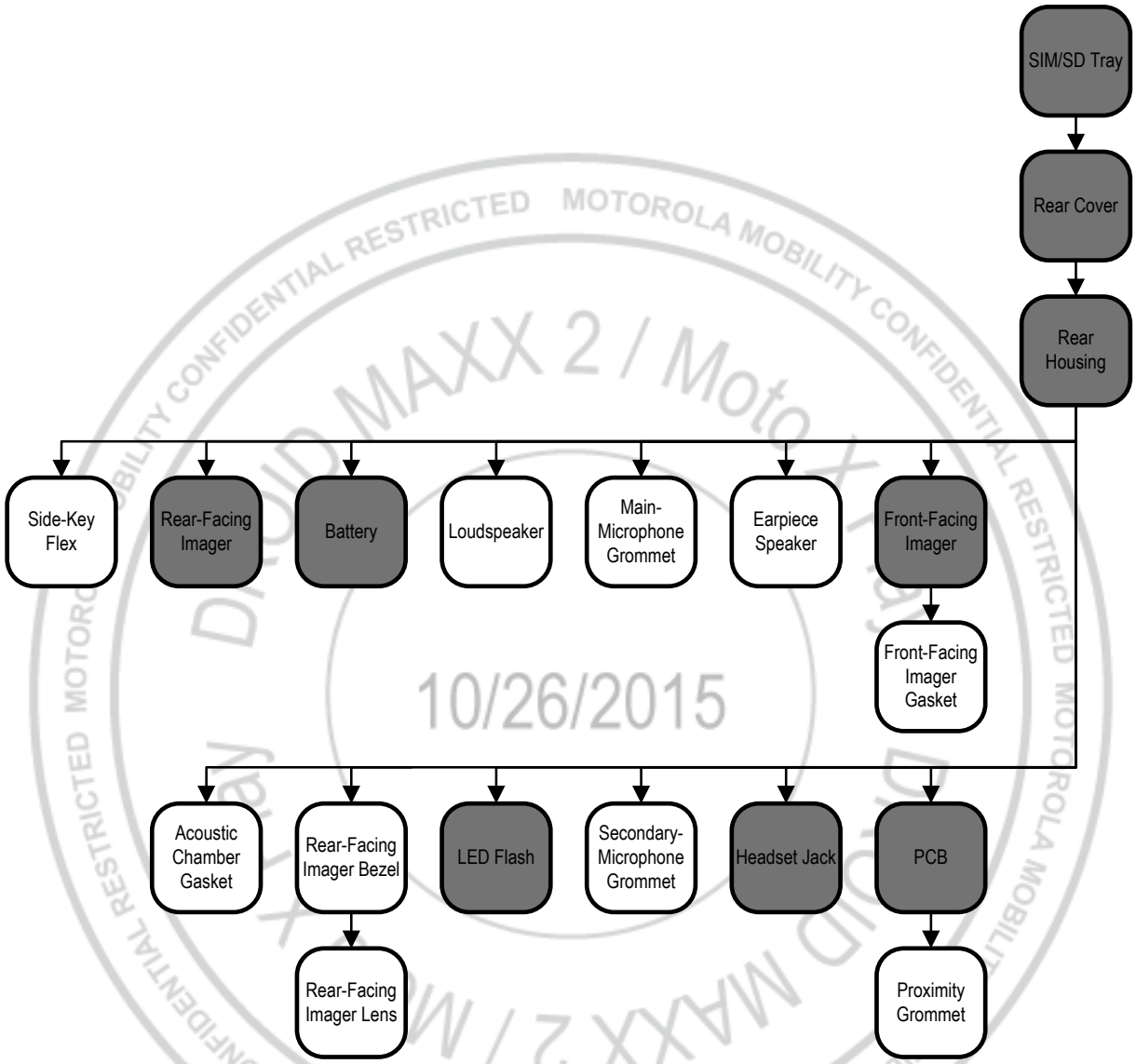
DISASSEMBLY AND RECOVERY

Disassembly and Recovery Map



*Shaded parts may be eligible for parts recovery.

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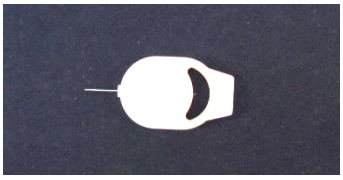
Tools Required for Disassembly

The following tools are required to disassemble the DROID MAXX 2 / Moto X Play phone.

Description	*Part #*	*Picture / Drawing*
SIM Tray Removal Tool	4-00-U2-10000	
Blackstick	--	
3IP Torx Bit	--	
Thin Plastic Spudger	0-00-00-40826	
Tweezers (Plastic or Plastic-Tipped)	--	--
Tweezers (Metal)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--
Isopropyl (ISP) Alcohol	--	--

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SIM/SD Tray Removal

NOTE

The SIM/SD Tray can be recovered and reused after removal.

1. Insert the SIM Tray Removal Tool into the SIM/SD Tray hole.

2. Push the SIM Tray Removal Tool into the SIM/SD Tray hole until the SIM/SD Tray ejects from the phone. The white dot is visible when the SIM/SD Tray retaining clips have released.

3. Remove the SIM/SD Tray from the phone.

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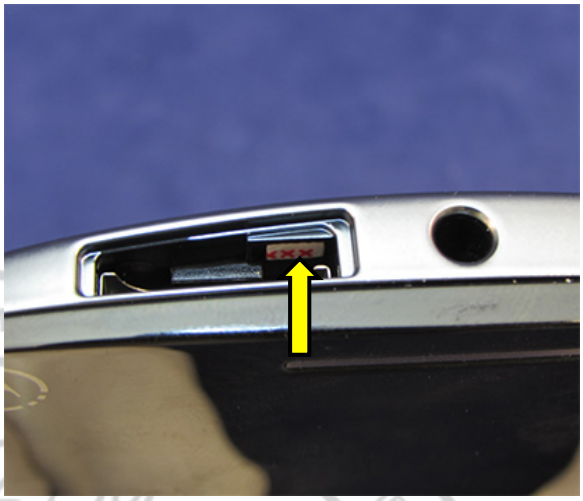
Water Detection Label Inspection

Inspect the Water Detection Label (WDL) visible through the SIM/SD Tray slot.



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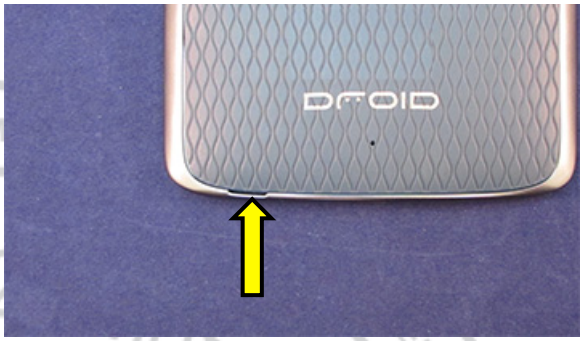
Rear Cover Removal

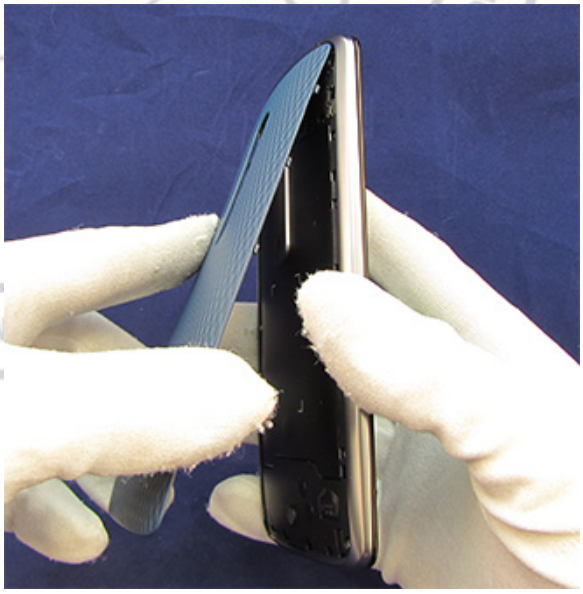
NOTE

The Rear Cover can be recovered and reused after removal.

1. Starting at the cutout near the USB Connector, use a fingernail to release the Rear Cover snaps on the USB Connector side of the phone.



2. Lift the Rear Cover away from the Rear Housing to disengage the remaining snaps.



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Rear Housing Removal

NOTE

The Rear Housing can be recovered and reused after removal.

1. Remove the 17 3IP Screws from the Rear Housing.

2. Lift the Rear Housing from the phone.

NOTE

The Side Keys will fall out when the Rear Housing is removed from the phone.

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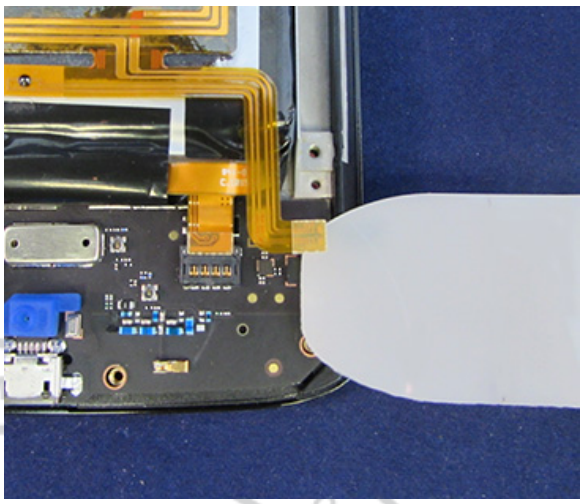
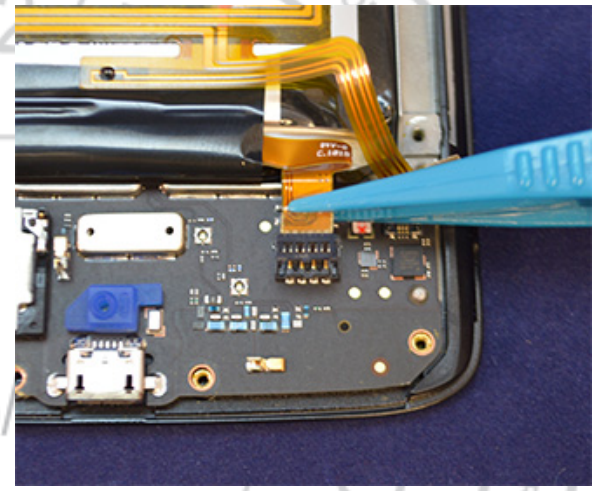
3. Use the Thin Plastic Spudger to disconnect the NFC Antenna.



4. Use the Plastic Tweezers to disconnect the Battery.



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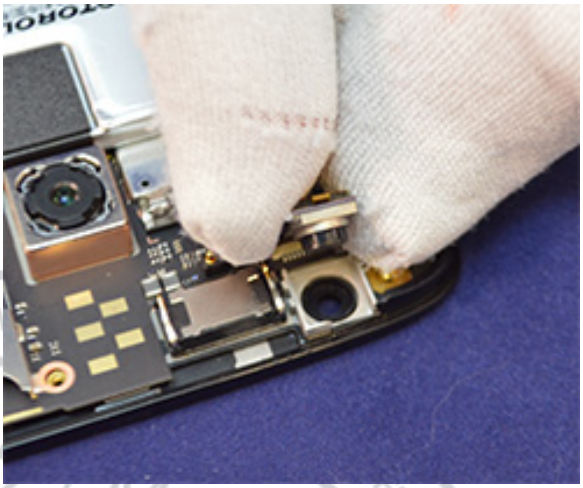
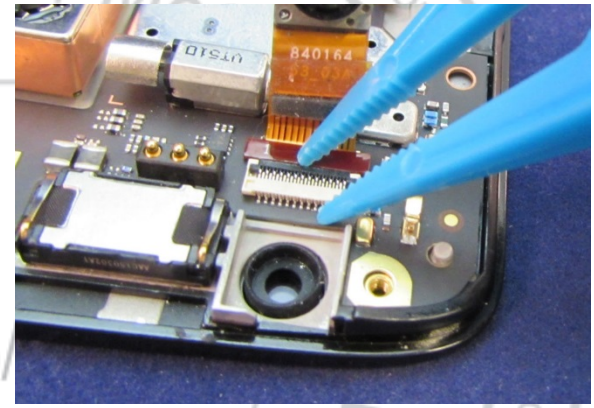
Front-Facing Imager Removal

NOTE

The Front-Facing Imager can be recovered and reused after removal.



1. Lift the Front-Facing Imager out of the pocket of the Display.



2. Use the Plastic Tweezers to remove the Kapton Tape from the Front-Facing Imager ZIF Connector.

NOTE

After you remove the Kapton Tape, you cannot reuse it.

3. Use the tip of the Plastic Tweezers to open the Front-Facing Imager ZIF Connector door.

4. Remove the Front-Facing Imager from the connector.

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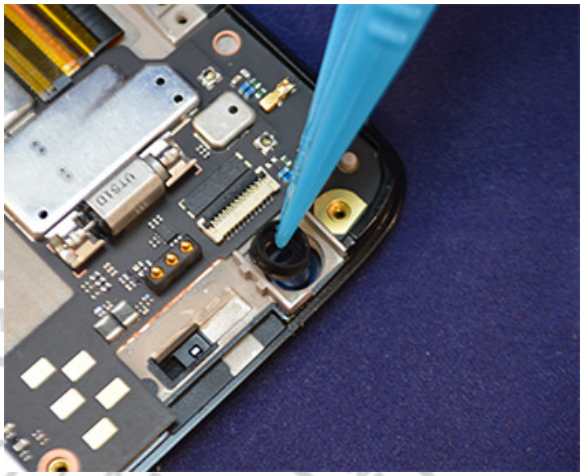
Front-Facing Imager Gasket Removal

Use the Plastic Tweezers to remove the Front-Facing Imager Gasket from the pocket of the Display.



NOTE

After you remove the Front-Facing Imager Gasket, you cannot reuse it.

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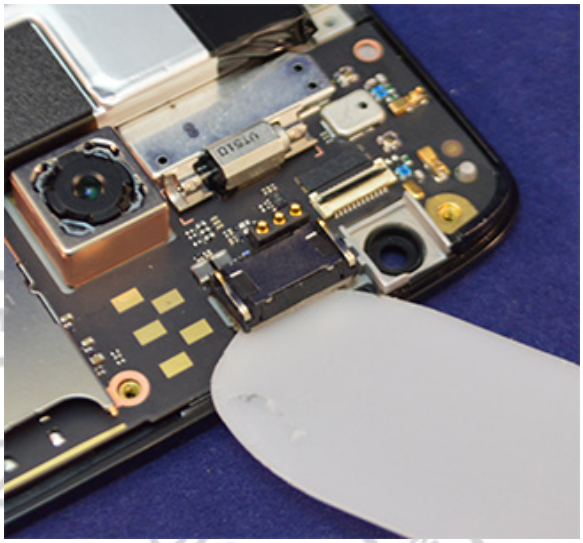
Earpiece Speaker Removal

Use the Thin Plastic Spudger to pry the Earpiece Speaker out of the pocket of the Display.



NOTE

After you remove the Earpiece Speaker, you cannot reuse it.

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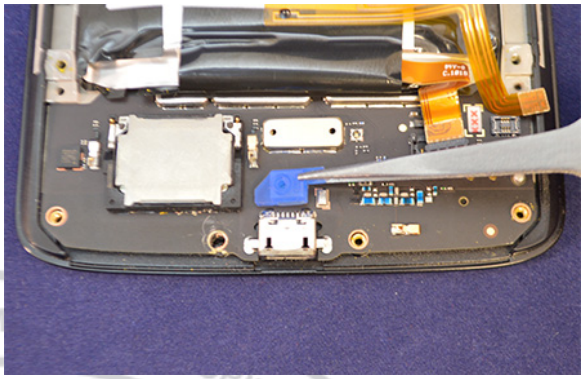
Main-Microphone Grommet Removal

Use the Tweezers to remove the Main-Microphone Grommet from the PCB.



NOTE

After you remove the Main-Microphone Grommet, you cannot reuse it.

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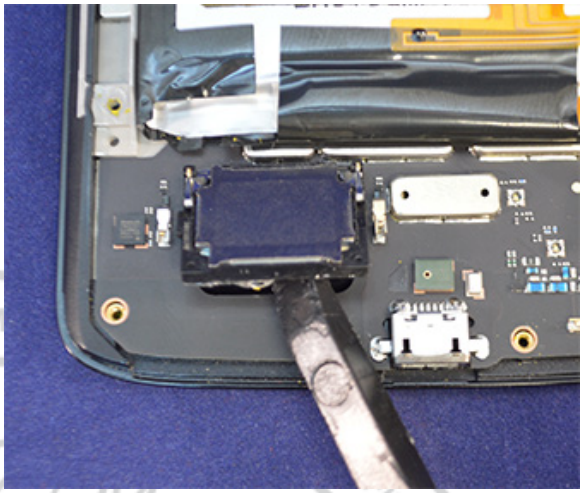
Loudspeaker Removal

Use the flat end of the Blackstick to pry the Loudspeaker from the PCB at the location shown.



NOTE

After you remove the Loudspeaker, you cannot reuse it.

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Battery Removal

/// WARNING ///

Failure to adhere to Safety Critical Note(s) may increase risk of rupture, burning, or failure to function safely when used by the customer. Refer to the Battery Safety Guidelines.

// CAUTION //

Handle the Battery Pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

Ensure Battery and its insulation are not damaged (e.g. scratched, dented, punctured) prior to and throughout assembly.

Prior to assembly, ensure Battery edges and surfaces are not dented or deformed, and that fixtures and parts that will contact the Battery are free of foreign material.

Ensure screws and screwdrivers do not contact the Battery.

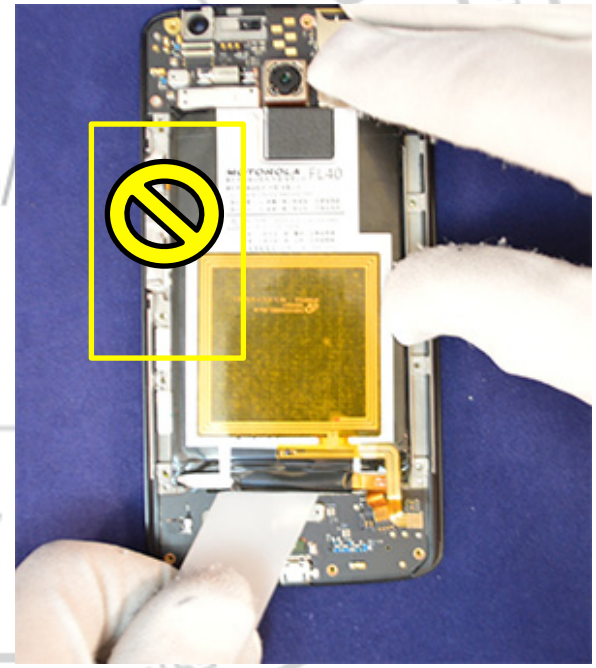
NOTE

The Battery can be recovered and reused after removal.

1. Insert the Thin Plastic Spudger between the Battery and PCB Shields at location shown.

// CAUTION //

Do not insert the Thin Plastic Spudger near the Key Flex.



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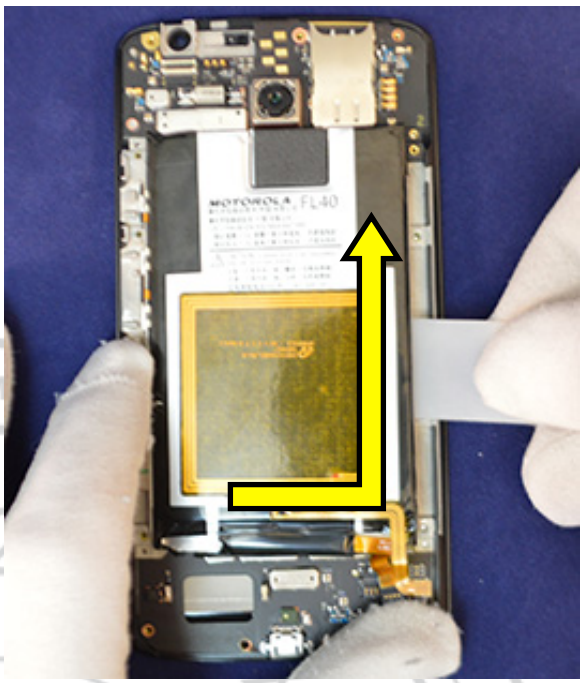
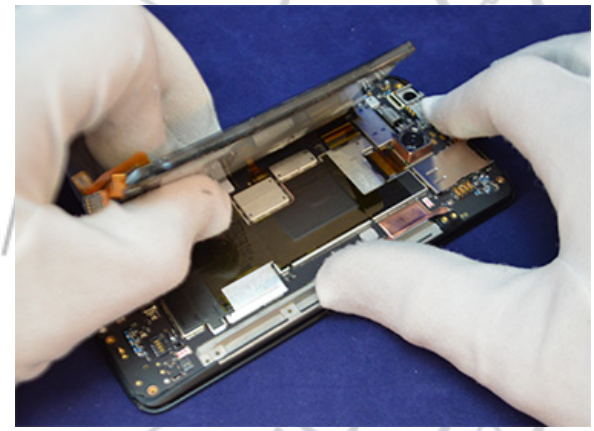
2. Slide the Thin Plastic Spudger to the right and up the length of the Battery to separate the Battery Adhesive from the PCB Shields.



// CAUTION //

Do not damage the Battery flex tail or the NFC Antenna flex tail.

3. After the Battery Adhesive is separated from the PCB Shields, lift the Battery from the PCB. Lift the side of the Battery opposite the Side Keys.
4. If the Battery Adhesive remains attached, use the Battery Pull Tab to aid in separating the Battery from the PCB.



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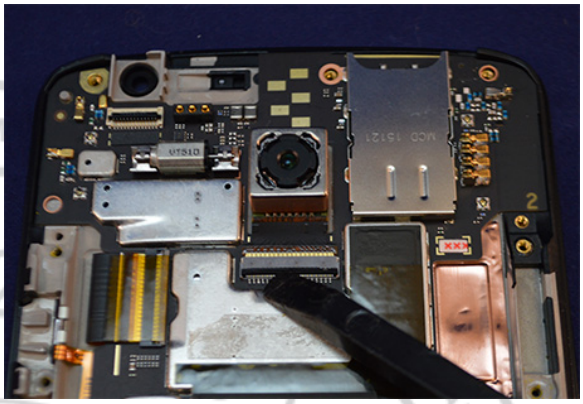
Rear-Facing Imager Removal

NOTE

The Rear-Facing Imager can be recovered and reused after removal.

1. Use the Tweezers to remove the Kapton Tape from the Rear-Facing Imager ZIF Connector.

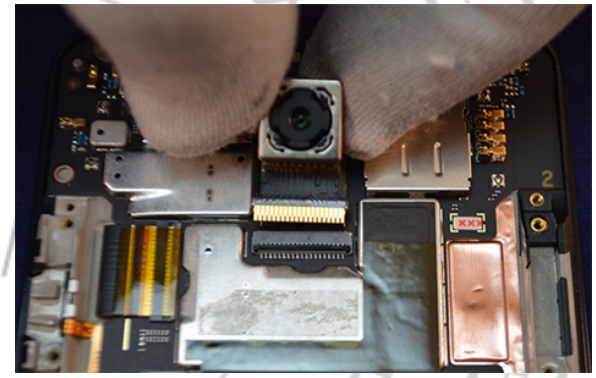


NOTE

After you remove the Kapton Tape, you cannot reuse it.

2. Use the flat end of the Blackstick to open the Rear-Facing Imager ZIF Connector door.

3. Remove the Rear-Facing Imager from the connector.



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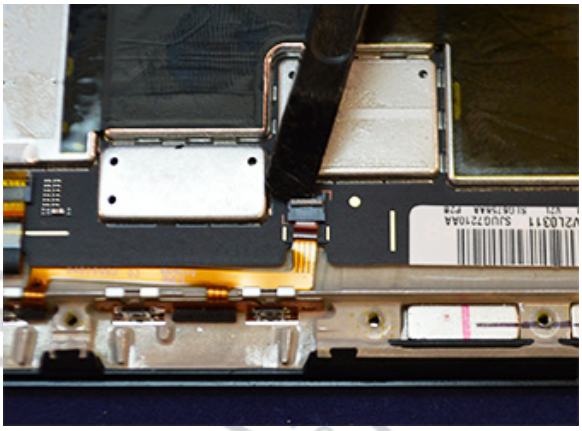
Side-Key Flex Removal

1. Use the Tweezers to remove the Kapton Tape from the Side-Key Flex ZIF Connector door.

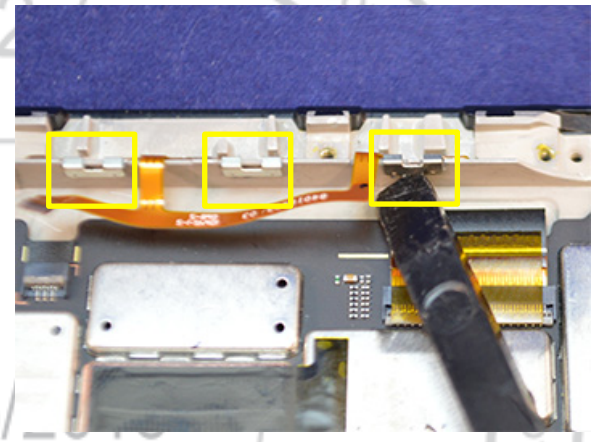


NOTE

After you remove the Kapton Tape, you cannot reuse it.

2. Use the flat end of the Blackstick to open the Side-Key Flex ZIF Connector door.

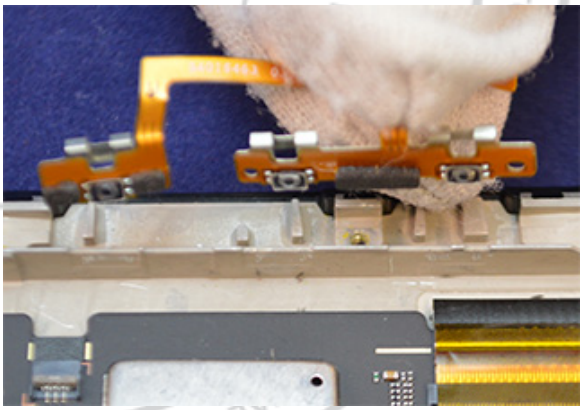
3. Use the flat end of the Blackstick to disengage the Side-Key Flex clips. Use the Blackstick to lift the clips up and off of the rail on the Display.



NOTE

After you remove the Side-Key Flex, you cannot reuse it.

4. Lift the Side-Key Flex from the rail on the Display.



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PCB Removal

NOTE

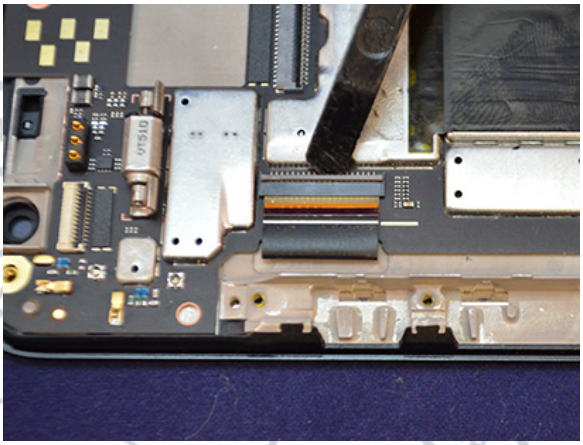
The PCB can be recovered and reused after removal.

1. Remove the Kapton Tape from the Display Flex ZIF Connector.

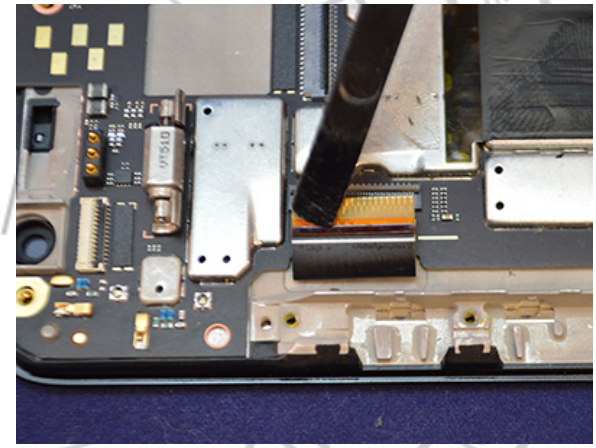
NOTE

After you remove the Kapton Tape, you cannot reuse it.

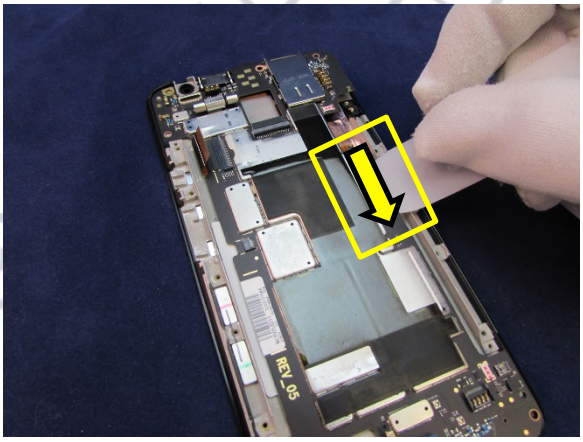
2. Use the flat end of the Blackstick to open the Display Flex ZIF Connector Door.



3. Push the Blackstick against the ledge on the Display Flex to remove the flex from the Display Flex ZIF Connector.



4. Slide the Thin Plastic Spudger between the PCB and Display at the location shown. Slide the Thin Plastic Spudger in the same direction as the arrow points in the highlighted area.



// CAUTION //

Slide the Thin Plastic Spudger only in the same direction as the arrows in the highlighted areas. Damage to the PCB Grounding Pins may occur if the Thin Plastic Spudger slides in the opposite direction.

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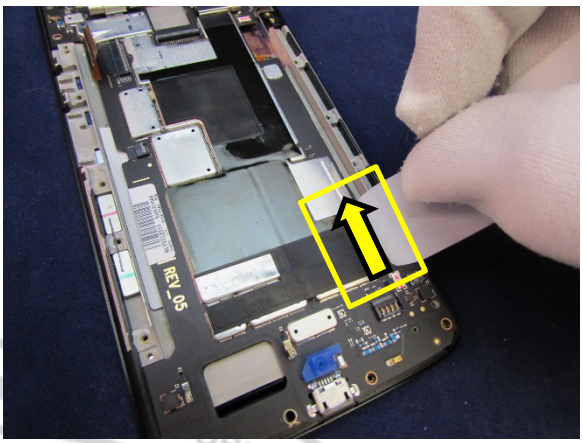
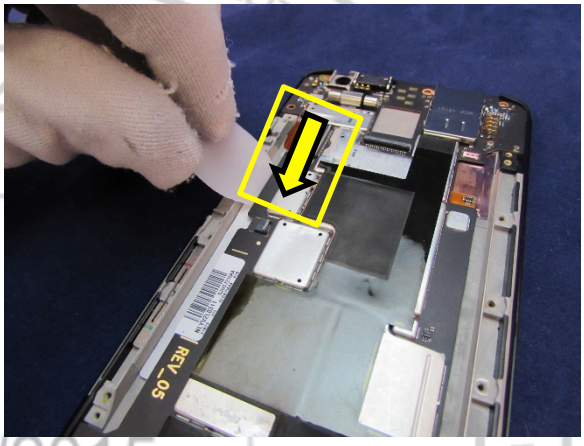
5. Slide the Thin Plastic Spudger between the PCB and Display at the location shown. Slide the Thin Plastic Spudger in the same direction as the arrow points in the highlighted area.



// CAUTION //

Slide the Thin Plastic Spudger only in the same direction as the arrows in the highlighted areas. Damage to the PCB Grounding Pins may occur if the Thin Plastic Spudger slides in the opposite direction.

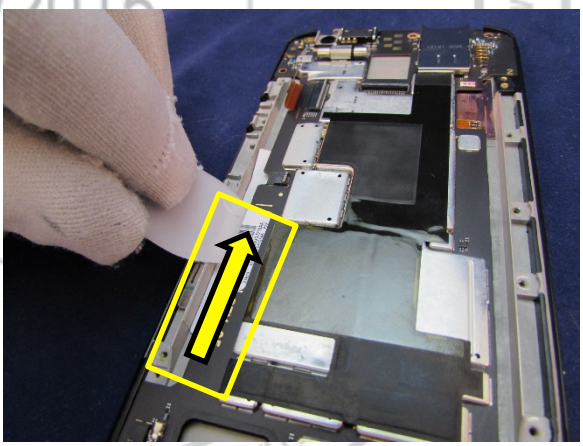
6. Slide the Thin Plastic Spudger between the PCB and Display at the location shown. Slide the Thin Plastic Spudger in the same direction as the arrow points in the highlighted area.



// CAUTION //

Slide the Thin Plastic Spudger only in the same direction as the arrows in the highlighted areas. Damage to the PCB Grounding Pins may occur if the Thin Plastic Spudger slides in the opposite direction.

7. Slide the Thin Plastic Spudger between the PCB and Display at the location shown. Slide the Thin Plastic Spudger in the same direction as the arrow points in the highlighted area.



// CAUTION //

Slide the Thin Plastic Spudger only in the same direction as the arrows in the highlighted areas. Damage to the PCB Grounding Pins may occur if the Thin Plastic Spudger slides in the opposite direction.

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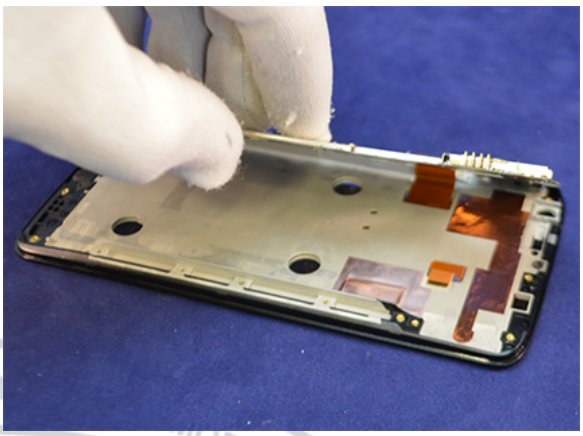
8. After the PCB Adhesives are separated, lift the PCB from the Display.



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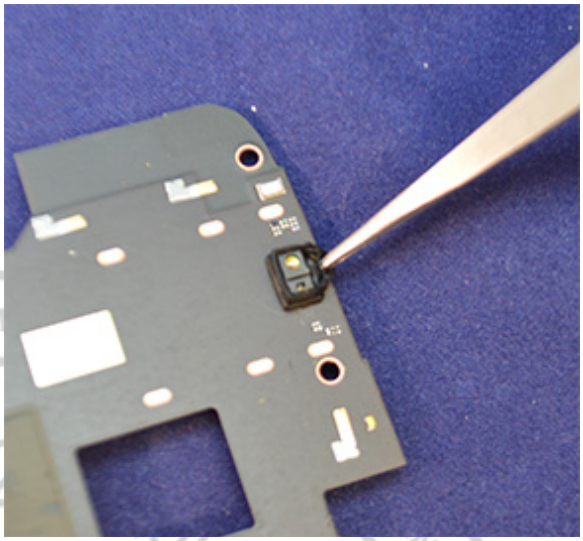
Proximity Grommet Removal

Use the Tweezers to remove the Proximity Grommet from the PCB.



NOTE

After you remove the Proximity Grommet, you cannot reuse it.

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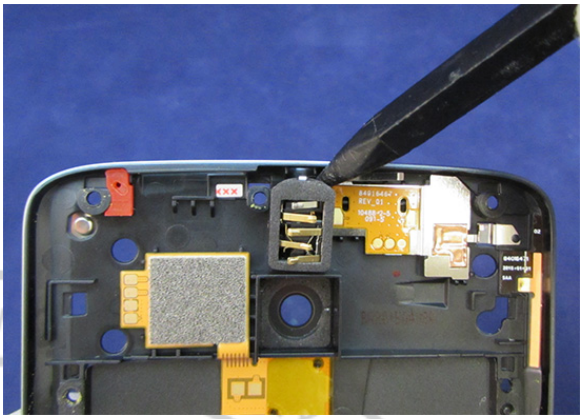
Headset Jack Removal

NOTE

The Headset Jack and Headset Jack Gasket can be recovered and reused after removal.

Use the pointed end of the Blackstick to pry the Headset Jack from the pocket of the Rear Housing.



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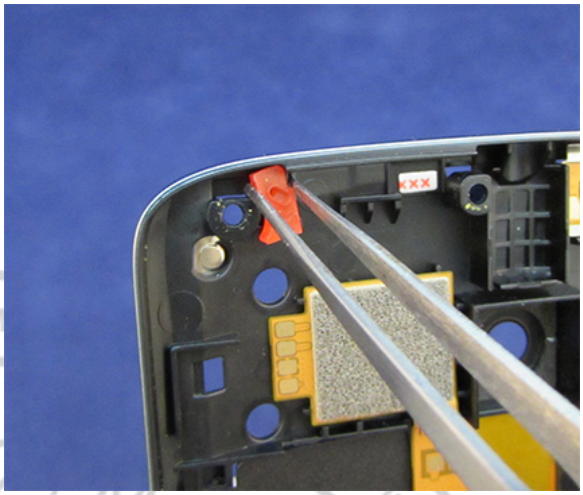
Secondary-Microphone Grommet Removal

Use the Tweezers to remove the Secondary-Microphone Grommet from the Rear Housing.



NOTE

After you remove the Secondary-Microphone Grommet, you cannot reuse it.

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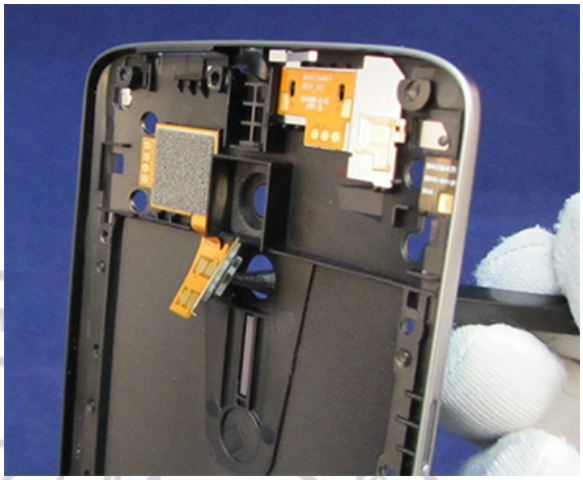
LED Flash Removal

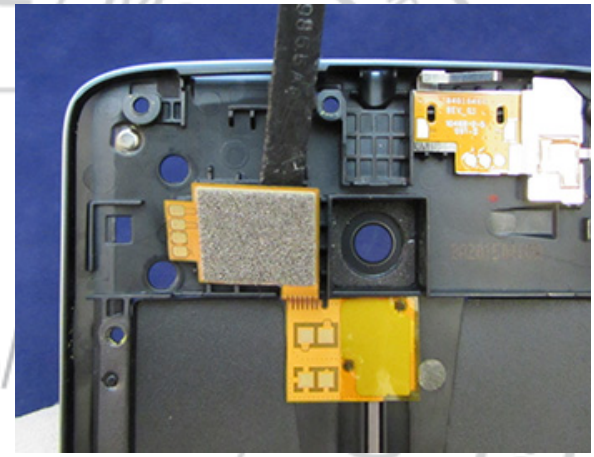
NOTE

The LED Flash can be recovered and reused after removal.

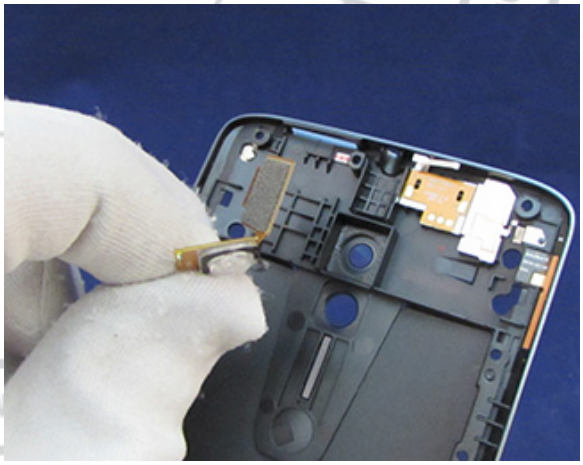
1. From the outside of the Rear Housing, use the pointed end of the Blackstick to push the LED Flash out of the Rear Housing.



2. Use the flat end of the Blackstick to pry the LED Flash Flex free from the Rear Housing.



3. Lift the LED Flash from the Rear Housing.



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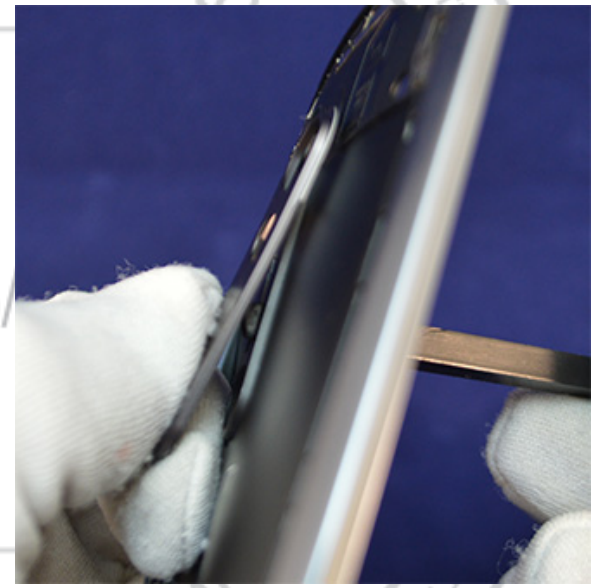
Rear-Facing Imager Bezel Removal

From the inside of the Rear Housing, use the flat end of the Blackstick to push the Rear-Facing Imager Bezel out of the Rear Housing.

NOTE

After you remove the Rear-Facing Imager Bezel, you cannot reuse it.



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Rear-Facing Imager Lens Removal

NOTE

The Rear-Facing Imager Deco Ring is attached to the Rear-Facing Imager Lens. The Rear-Facing Imager Deco Ring is removed when the Rear-Facing Imager Lens is removed.

From the inside of the Rear Housing, use the pointed end of the Blackstick to push the Rear-Facing Imager Lens out of the Rear Housing.

NOTE

After you remove the Rear-Facing Imager Lens, you cannot reuse it.

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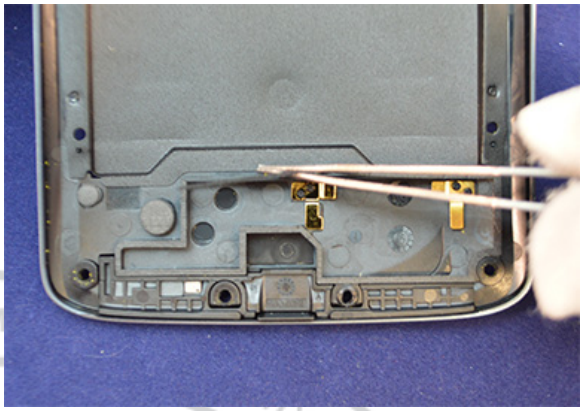
Audio Gasket Removal

Use the Tweezers and ISP Alcohol to remove the Audio Gasket from the Rear Housing.



NOTE

After you remove the Audio Gasket, you cannot reuse it.

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PARTS REFRESH

Tools Required for Parts Refresh

The following tools are required for parts refresh of the Lynx phone.

Description	*Part #*	*Image*
Blackstick	--	
Tweezers (Plastic or Plastic-Tipped)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--
Isopropyl (ISP) Alcohol	--	--

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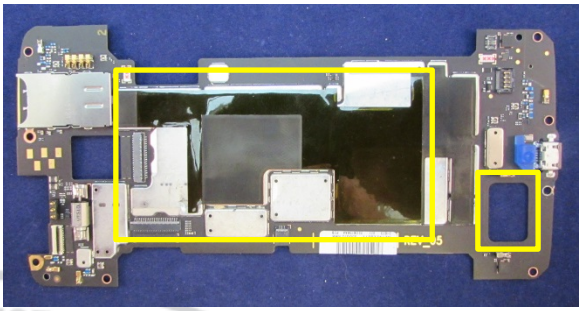
PCB Cleaning

NOTE

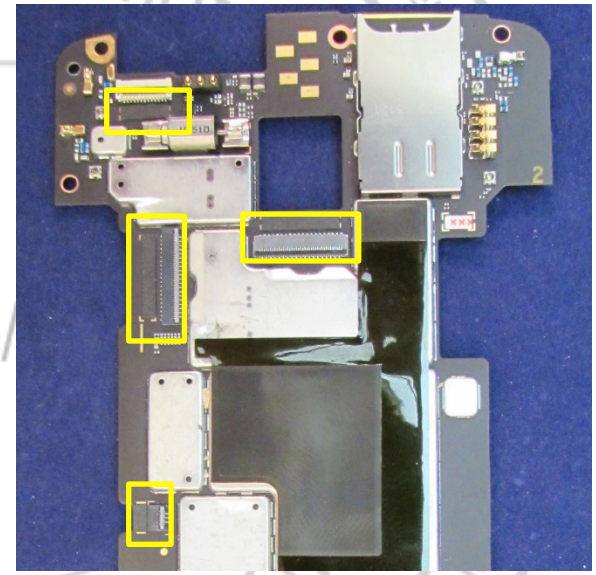
Remove the Thermal Spreader only if it is damaged. After you remove it, you cannot reuse it.



1. Use the flat end of the Blackstick to remove the Front Thermal Spreader from the PCB Shields.
2. Use the flat end of the Blackstick and ISP Alcohol to remove all Front Thermal Spreader adhesive from the PCB Shields.
3. Use the Blackstick and ISP Alcohol to remove any remaining adhesive from where the Loudspeaker attaches to the PCB.

NOTE

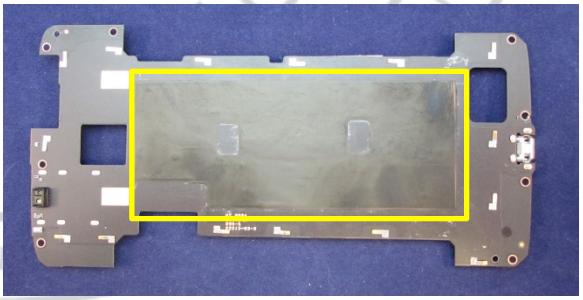
Remove the Flex Shims only if they are damaged or if thermal work will be performed on the PCB. After you remove them, you cannot reuse them.



4. Use the Tweezers to remove the Flex Shims for the following components:
   - Front-Facing Imager Flex
   - Rear-Facing Imager Flex
   - Side-Key Flex
   - Display Flex

NOTE

Remove the Thermal Spreader only if it is damaged. After you remove it, you cannot reuse it.



5. Use the flat end of the Blackstick to remove the Rear Thermal Spreader from the back of the PCB.
6. Use the flat end of the Blackstick and ISP Alcohol to remove all Rear Thermal Spreader adhesive from the back of the PCB.

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7. Verify that the Display-Flex ZIF Connector Door is open.

// CAUTION //

If the ZIF Connector Door is closed, the ZIF Connector may be damaged.

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Battery Cleaning

/// WARNING ///

Failure to adhere to Safety Critical Note(s) may increase risk of rupture, burning, or failure to function safely when used by the customer. Refer to the Battery Safety Guidelines.

// CAUTION //

Handle the Battery Pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

Ensure Battery and its insulation are not damaged (e.g. scratched, dented, punctured) prior to and throughout assembly.

Prior to assembly, ensure Battery edges and surfaces are not dented or deformed, and that fixtures and parts that will contact the Battery are free of foreign material.

Ensure screws and screwdrivers do not contact the Battery.

1. Use the Blackstick and ISP Alcohol to remove any remaining adhesive from the Battery.

// CAUTION //

To prevent damage, do not allow sharp tools or screws to come in contact with the Battery.

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2. Use the Blackstick and ISP Alcohol to remove any remaining adhesive from where the NFC Antenna attaches to Battery.

// CAUTION //

To prevent damage, do not allow sharp tools or screws to come in contact with the Battery.

3. Inspect the Battery to verify it is not creased, crushed, or punctured.
4. If the Battery foil pack is wrinkled, slide the flat edge of the Blackstick against the foil pack to smooth out all wrinkles.

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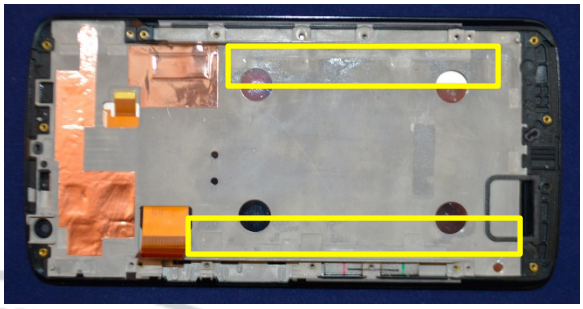
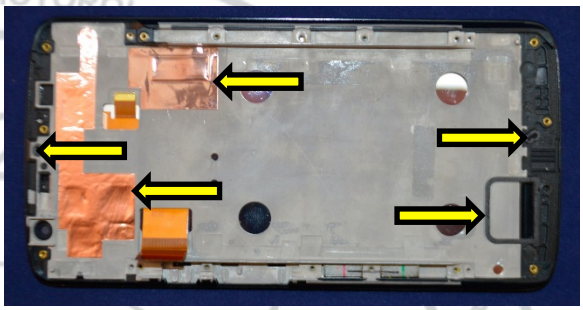
Display Cleaning

// CAUTION //

Use care when cleaning the Display. Do not separate the Display from the Lens or damage the Display Flex.



1. Use the Blackstick and ISP Alcohol to remove any remaining adhesive from the Display.



2. Use the Tweezers and ISP Alcohol to remove the following components:
   - Loudspeaker Gasket
   - Notification LED Gasket
   - Tertiary Microphone Mesh
   - Touch Shield Copper Tape
   - LED Shield Copper Tape

3. Inspect the Display Flex to verify it is not torn, creased, or otherwise damaged.

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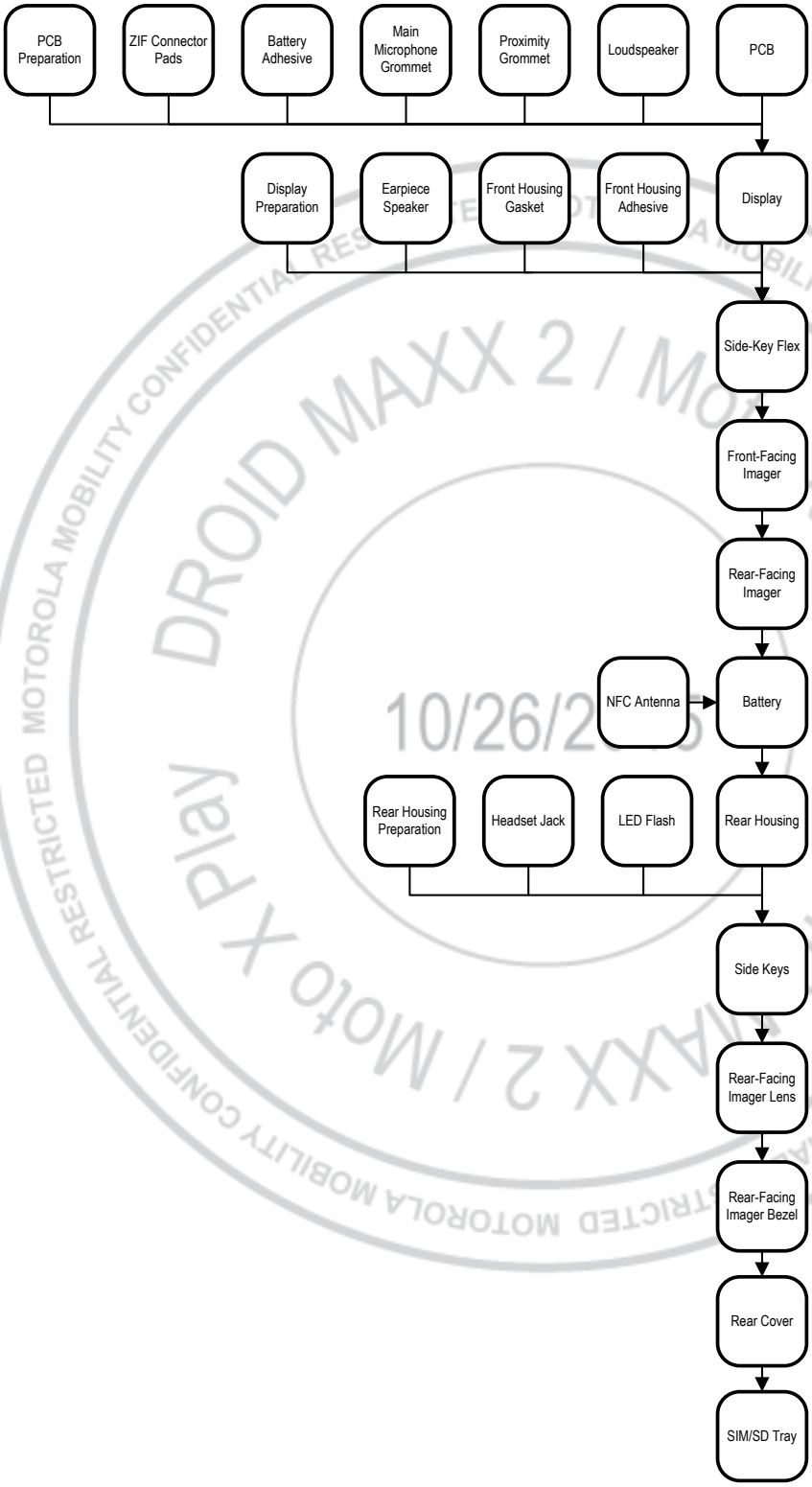
ASSEMBLY

Assembly Map



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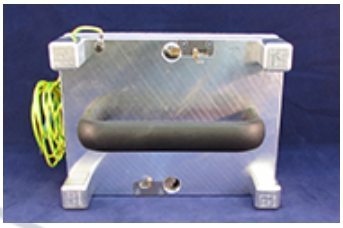
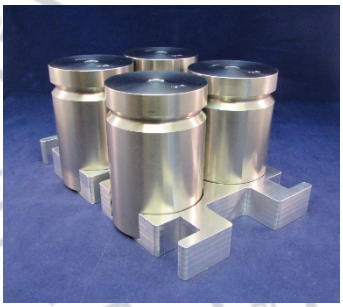
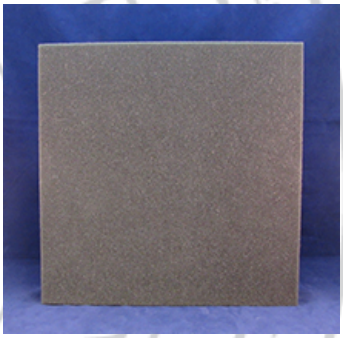
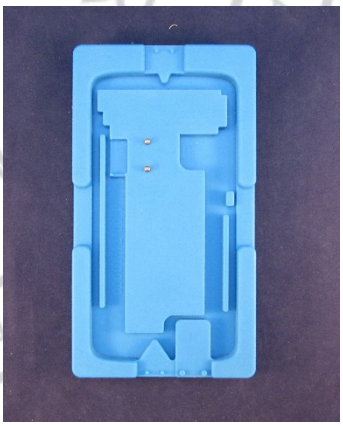
Tools Required for Assembly

The following tools are required to assemble the DROID MAXX 2 / Moto X Play phone.

Description	*Part #*	*Picture / Drawing*
Universal Press Fixture	3-00-A3-10000	
Universal Press Weights	3-00-E5-10000	
Universal Nest	3-00-A7-10000	
Lynx Lens Alignment Fixture	4-00-Z6-10000	

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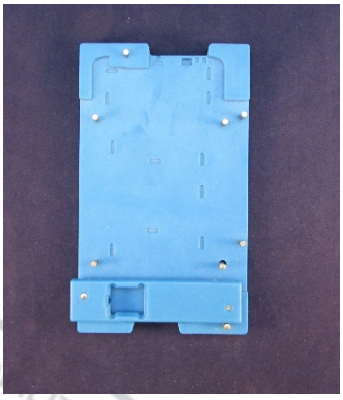
Description	*Part #*	*Picture / Drawing*
Lynx PCB Alignment Fixture	4-00-Z7-10000	
Lynx NFC Alignment Fixture	4-00-Z8-10000	
Lynx Bezel Alignment Fixture	4-00-Z9-10000	
Lynx Audio Gasket Alignment Fixture	3-00-C1-10000	
Blackstick	--	

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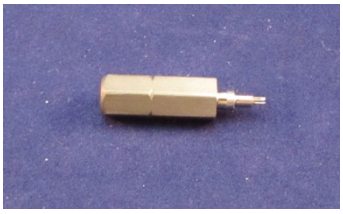
Description	*Part #*	*Picture / Drawing*
3IP Torx Bit	--	
Torque Driver (Adjustable)	--	
Tweezers (Plastic or Plastic-Tipped)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--
Isopropyl (ISP) Alcohol	--	--
Cotton Swabs	--	--
Deionized Air	--	--

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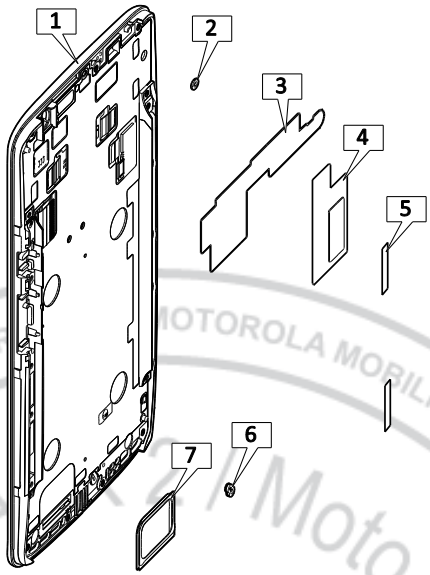
Display Preparation



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
GSKT,LED, NOTIFICATION, LUX	2
DIE CUT,COP TAPE, LED SHIELD, LUX	3
DIE CUT,COP TAPE, TOUCH SHIELD, LUX	4
DIE CUT,ADHES,PCB TO FH CORNER, LUX	5
SCRN,MIC,MESH, TERTIARY. CAVITY SIDE, LUX	6
GSKT,LOUDSPEAKER, FRNT VOLUME, LUX	7

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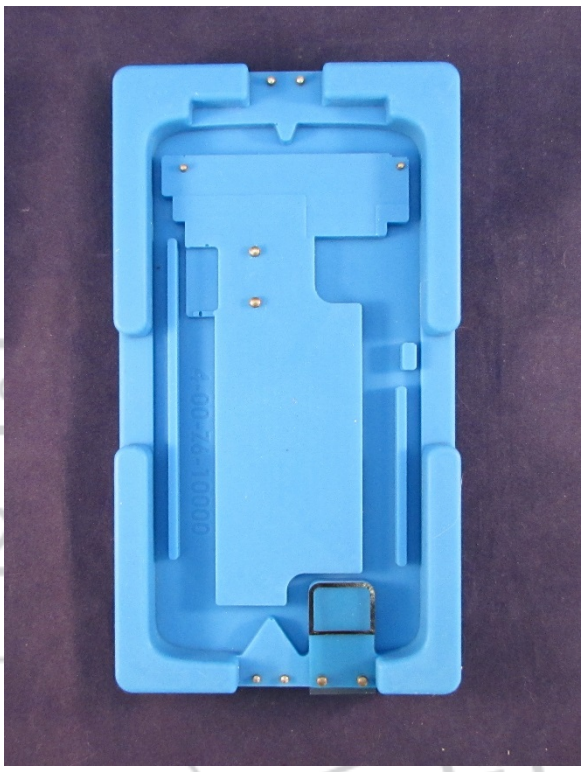
1. Remove the Loudspeaker Gasket from the carrier.
2. Place the Loudspeaker Gasket into the Lynx Lens Alignment Fixture (4-00-Z6-10000), using the pins in the fixture to align it.



3. Place the Display into the fixture over the Loudspeaker Gasket.
4. Press down on the Display for 5 seconds to secure the Loudspeaker Gasket.
5. Remove the Display from the fixture.

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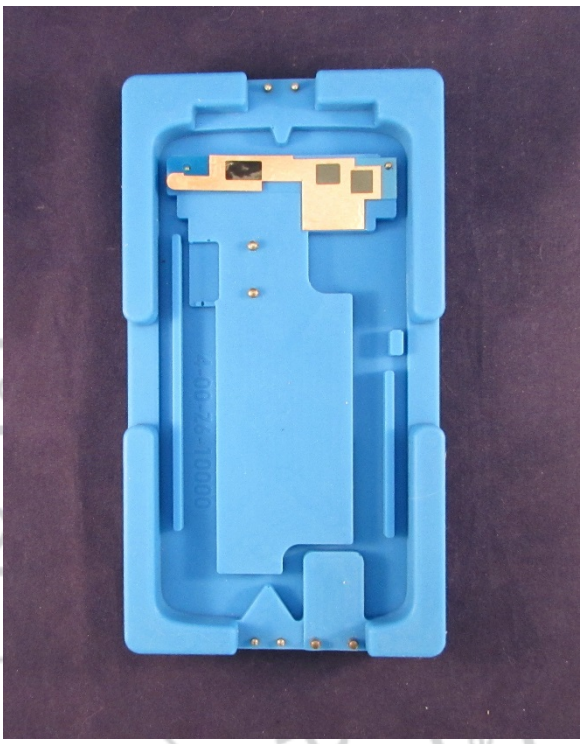
6. Remove the LED Shield Copper Tape from the carrier.
7. Place the LED Shield Copper Tape into the fixture, using the pins in the fixture to align it.



8. Place the Display into the fixture over the LED Shield Copper Tape.
9. Press down on the Display for 5 seconds to secure the LED Shield Copper Tape.
10. Remove the Display from the fixture.

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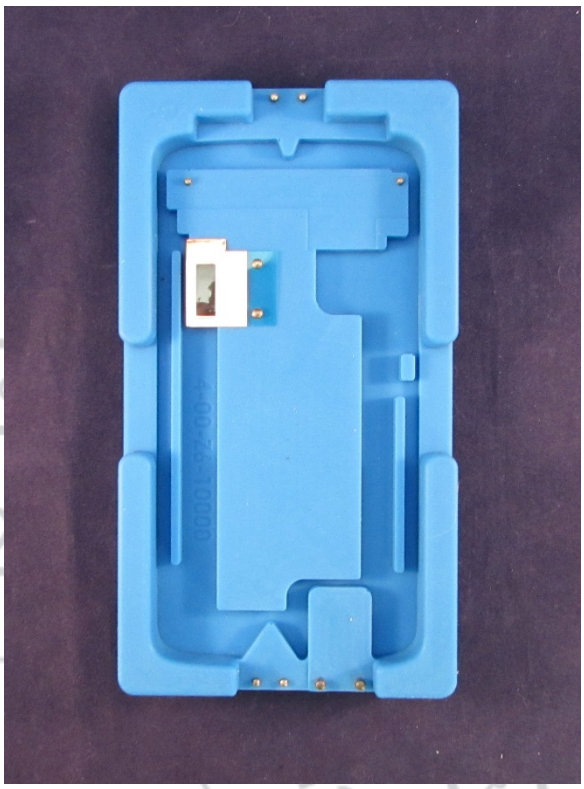
11. Remove the Touch Shield Copper Tape from the carrier.
12. Place the Touch Shield Copper Tape into the fixture, using the pins in the fixture to align it.



13. Place the Display into the fixture over the Touch Shield Copper Tape.
14. Press down on the Display for 5 seconds to secure the Touch Shield Copper Tape.
15. Remove the Display from the fixture.

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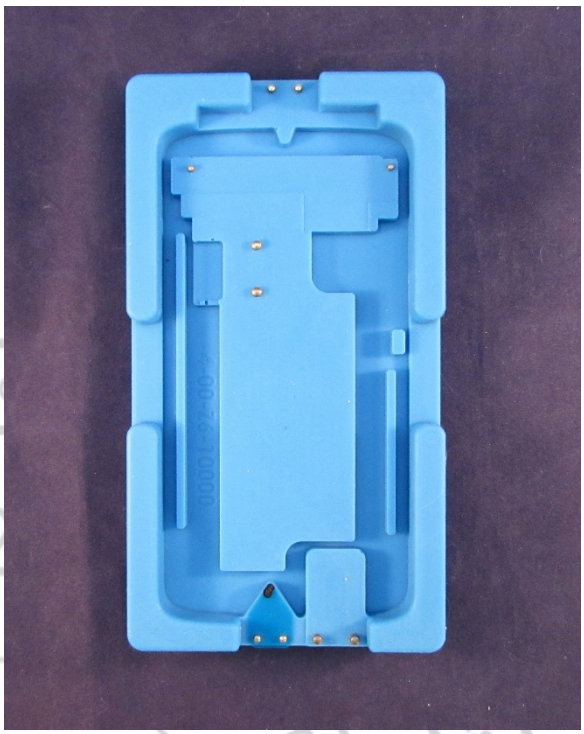
16. Remove the Tertiary Microphone Mesh from the carrier.
17. Place the Tertiary Microphone Mesh into the fixture, using the pins in the fixture to align it.



18. Place the Display into the fixture over the Tertiary Microphone Mesh.
19. Press down on the Display for 5 seconds to secure the Tertiary Microphone Mesh.
20. Remove the Display from the fixture.

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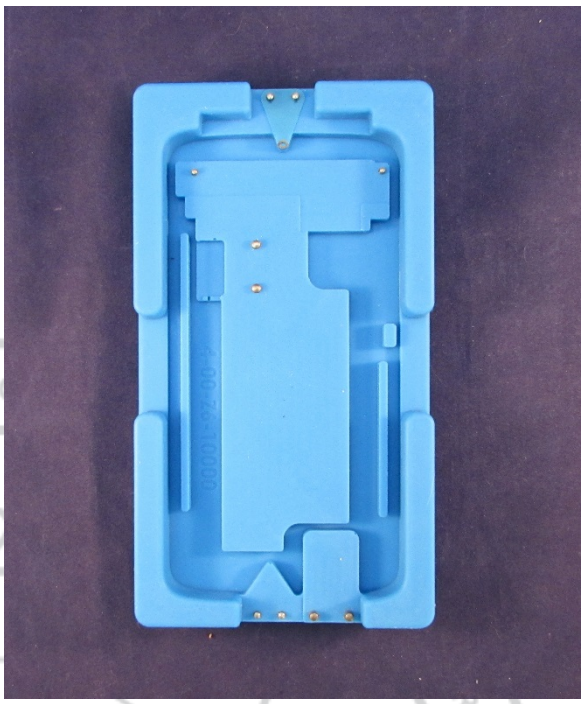
21. Remove the Notification LED Gasket from the carrier.
22. Place the Notification LED Gasket into the fixture, using the pins in the fixture to align it.



23. Place the Display into the fixture over the Notification LED Gasket.
24. Press down on the Display for 5 seconds to secure the Notification LED Gasket.
25. Remove the Display from the fixture.

26. Remove the liners from the LED Shield and Touch Shield Copper Tapes.

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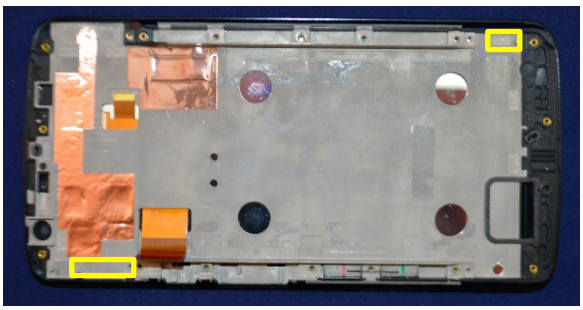
27. Place 2 adhesive strips on top of each other in each of the 2 Front Housing locations indicated.
28. Inspect the adhesive strips for proper placement. The strips should be close to the alignment pins and not cover the grounding pockets.



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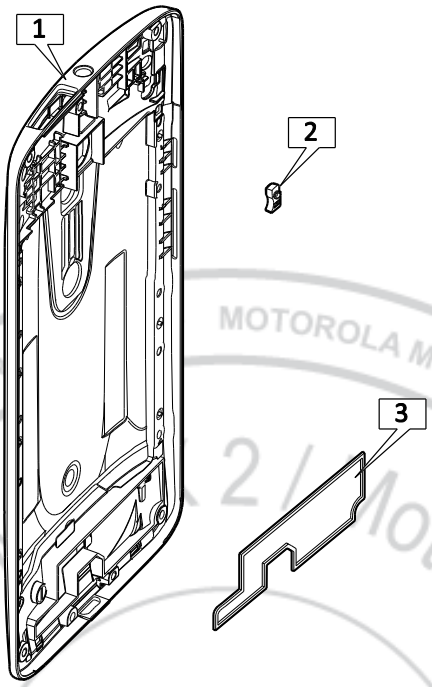
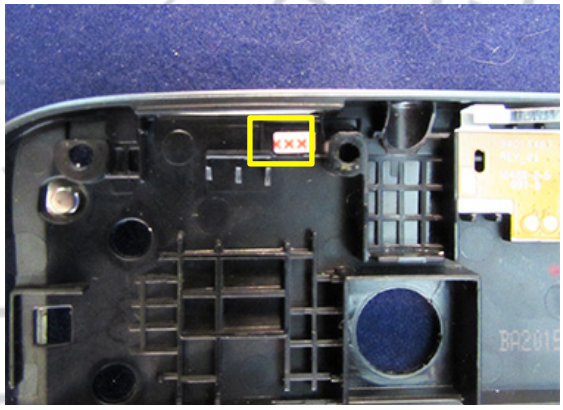
Rear Housing Preparation



Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
GROM,MIC,SEC MIC, LUX	2
GSKT,ACSTC CHAMBER, LUX	3
LBL,WATER, DETECT	N/A

1. Place the Rear Housing WDL in the pocket as shown.



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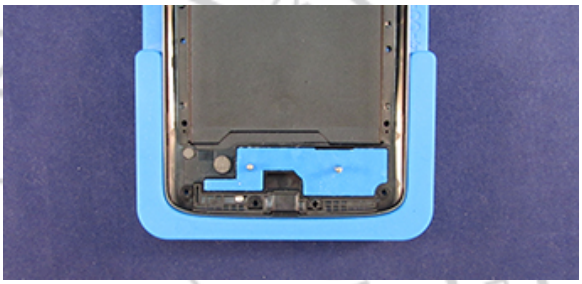
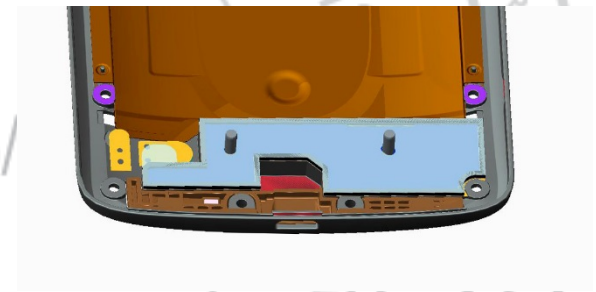
2. Place the Rear Housing into the Lynx Bezel Alignment Fixture (4-00-Z9-10000).

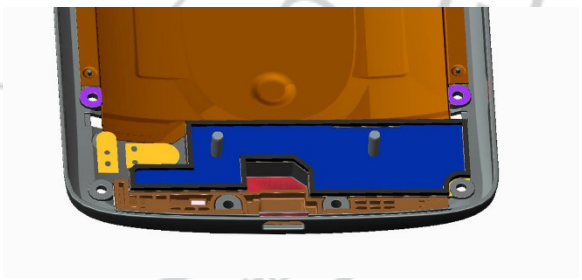
3. Place the Lynx Audio Gasket Alignment Fixture (3-00-C1-10000) into the recess in the Rear Housing.



4. Remove the Audio Gasket from the carrier.
5. Place the Audio Gasket over the Rear Housing, using the pins in the alignment fixture to align it.
6. Press down on the Audio Gasket for 5 seconds to secure it to the Rear Housing.



7. Remove the liner from the Audio Gasket.



8. Remove the Lynx Audio Gasket Alignment Fixture from the Rear Housing.

// CAUTION //

The Audio Gasket liner and Lynx Audio Gasket Alignment Fixture must be removed from the Rear Housing. Damage to the phone or incorrect assembly may occur.

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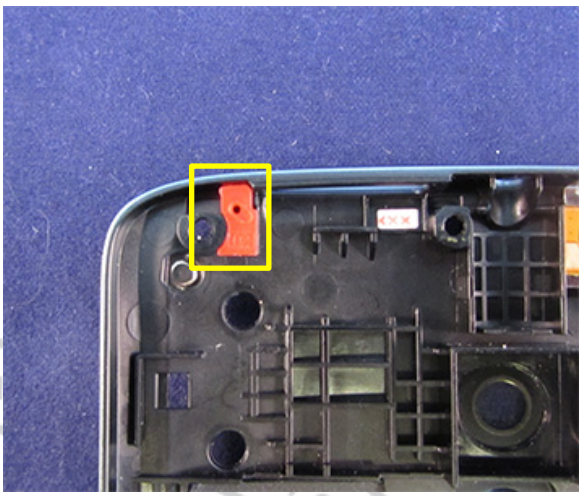
9. Use the Tweezers to place the Secondary-Microphone Grommet into the Rear Housing.



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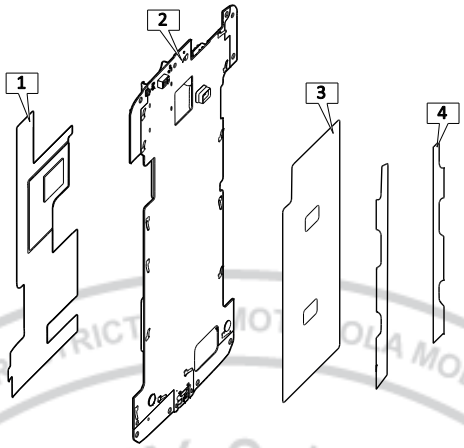
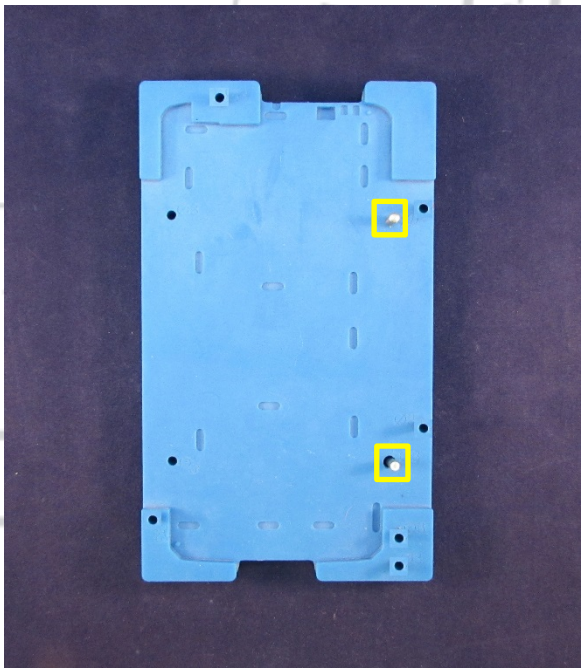
PCB Preparation



Description	*Reference #*
DIE CUT,TAPE, COPPER, MSM SHIELD, LUX	1
ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB - R	2
DIE CUT,ADHES,HT SPREADER, LUX	3
DIE CUT,ADHES,PCB TO FH CHASSIS, LUX	4
LBL,WATER, DETECT	N/A

1. Place 2 locating pins in the PCB Alignment Fixture (4-00-Z7-10000) in the locations shown.



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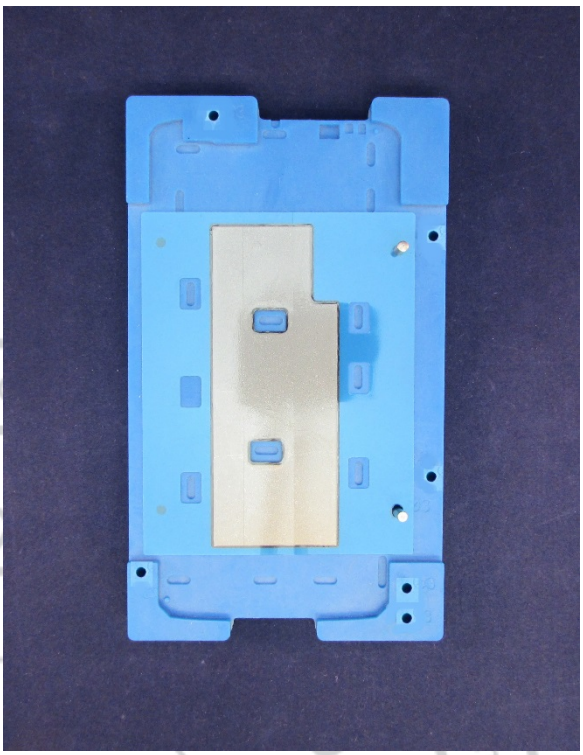
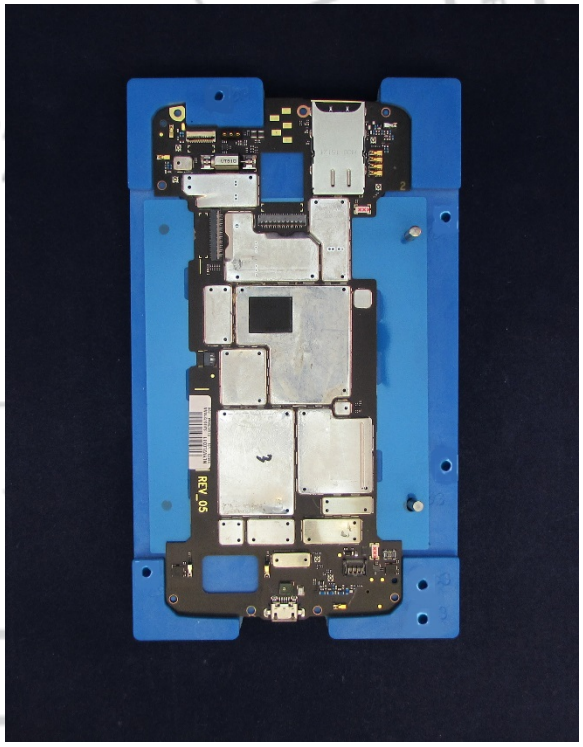
2. Remove the liner from the silver side of the Rear Heat Spreader.
3. Place the Rear Heat Spreader into the fixture, using the pins in the fixture to align it.



4. Place the PCB into the fixture.
5. Press down on the PCB for 5 seconds to secure the adhesive.
6. Remove the PCB from the fixture.
7. Peel the remaining liner off the Rear Heat Spreader.



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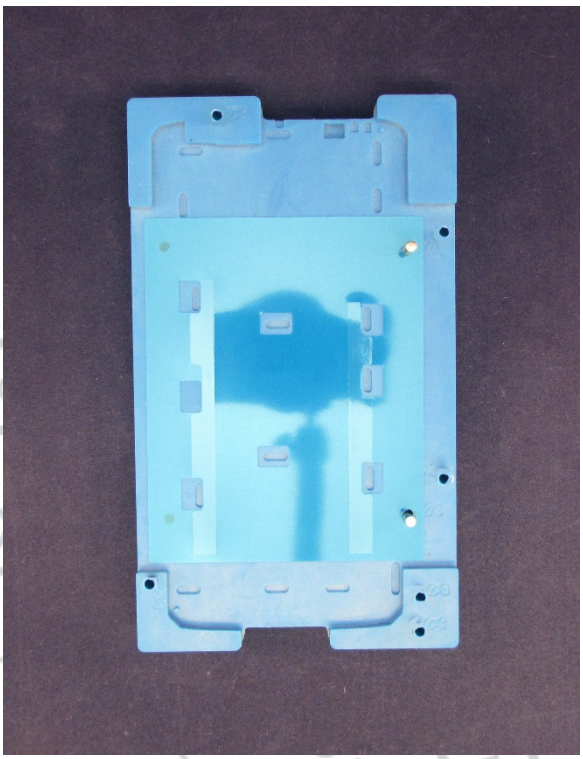
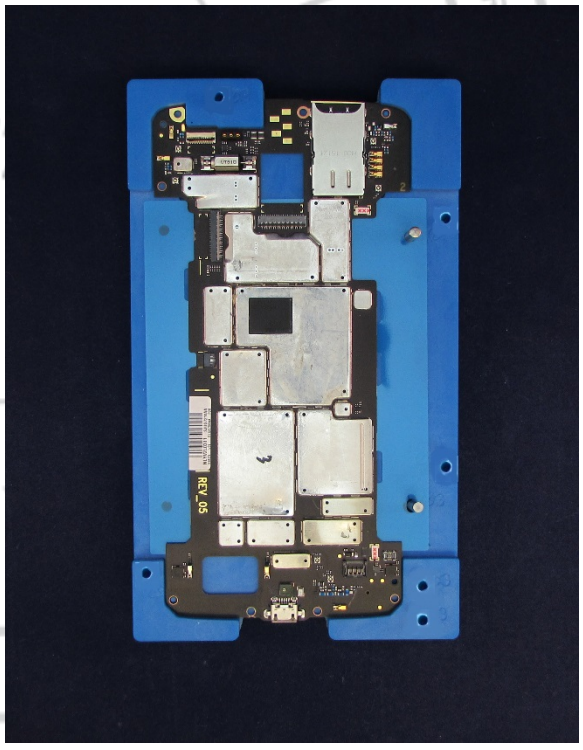
8. Remove the PCB Adhesive from the carrier.
9. Place the PCB Adhesive into the fixture, using the pins in the fixture to align it.



10. Place the PCB into the fixture over the adhesive.
11. Press down on the PCB for 5 seconds to secure the PCB Adhesive to the PCB.



12. Remove the PCB from the fixture.

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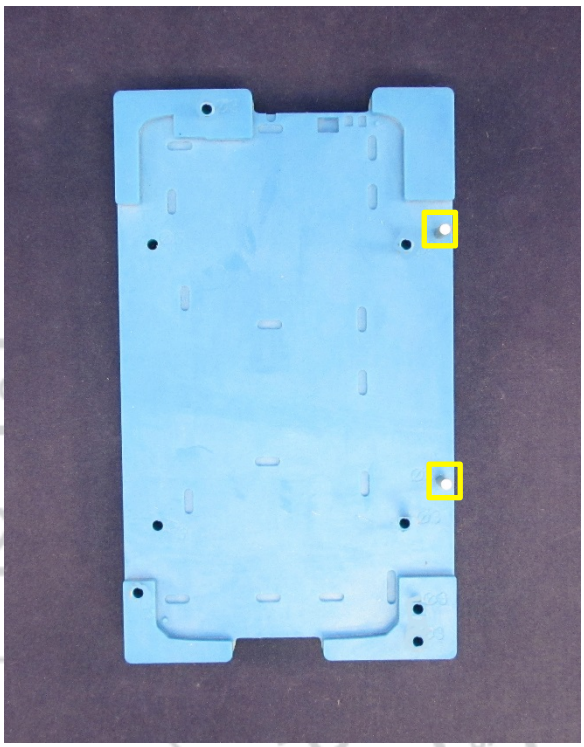
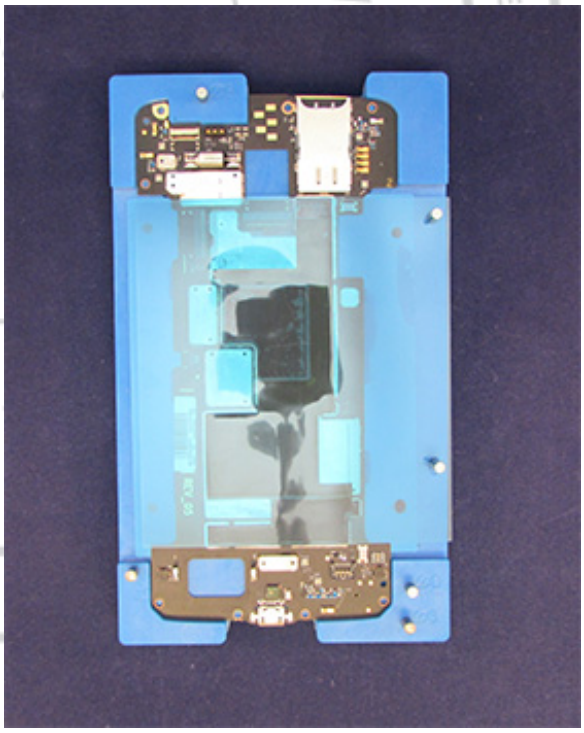
13. Remove the 2 locating pins from the fixture.
14. Place the 2 locating pins in the positions shown.



15. Place the PCB into the fixture.
16. Remove the liner from the silver side of the Front Heat Spreader.
17. Place the Front Heat Spreader into the fixture, using the pins in the fixture to align it.
18. Press down on the Front Heat Spreader for 5 seconds to secure it to the PCB Shields.



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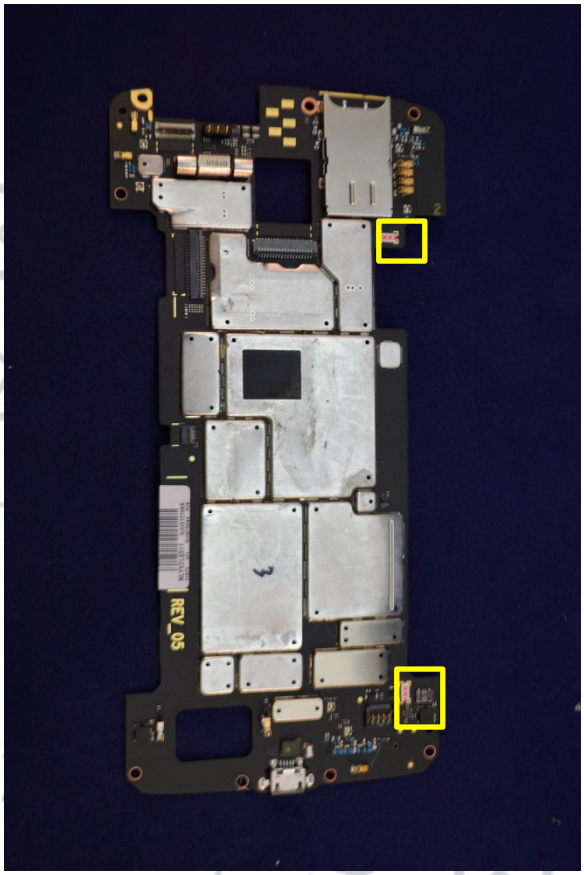
19. Remove the PCB from the fixture.
20. Peel the remaining liner off the Front Heat Spreader.
21. Place the 2 PCB WDLs on the PCB in the locations shown.
22. Press down on the WDLs for 5 seconds to secure them to the PCB.



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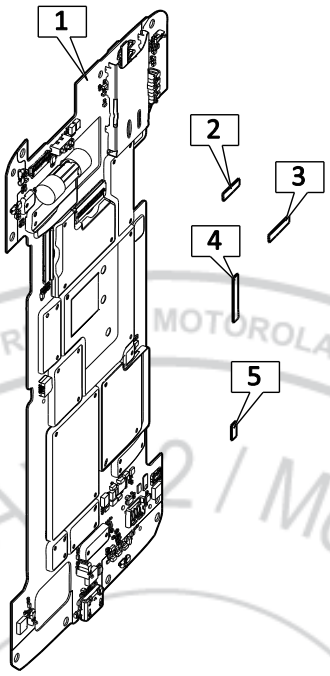
ZIF Connector Pad Assembly



Description	*Reference #*
ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB - R	1
PAD,2MP IMGR FLX ASSY, QUARK	2
PAD,20MP IMGR FLX ASSY, QUARK	3
PAD,DISP FLEX, LUX	4
PAD,SIDE KEY FLX ASSY, LUX	5

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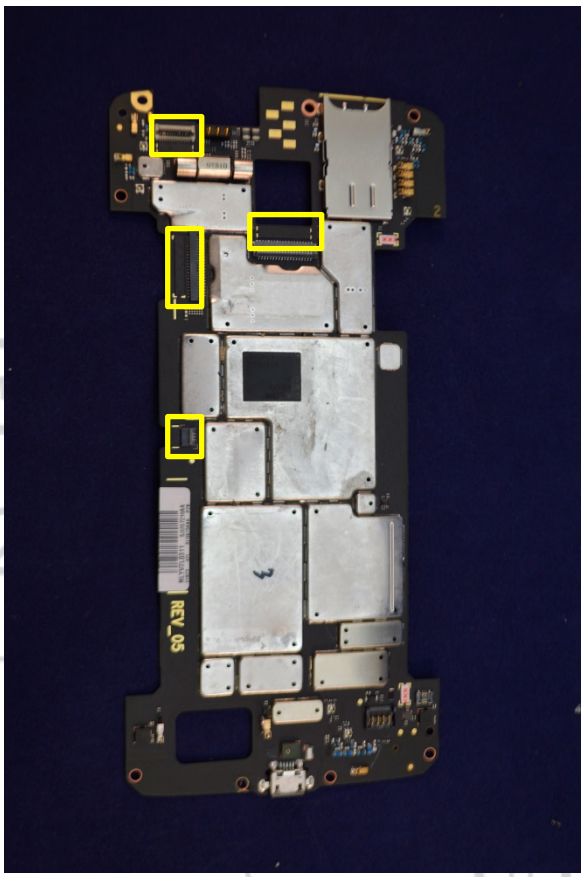
1. Remove the protective liner from the Front Thermal Spreader if present.
2. Place 4 ZIF Connector Pads on the PCB as shown.



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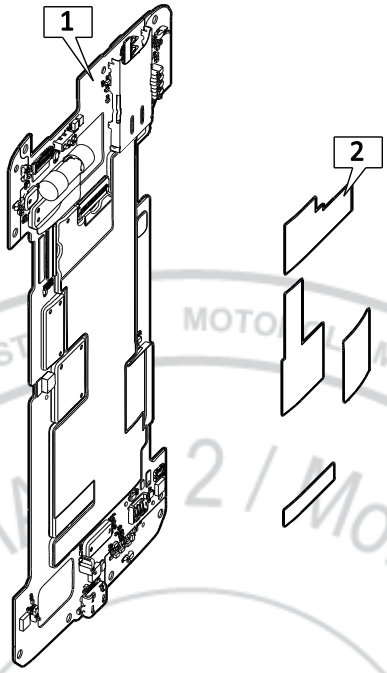
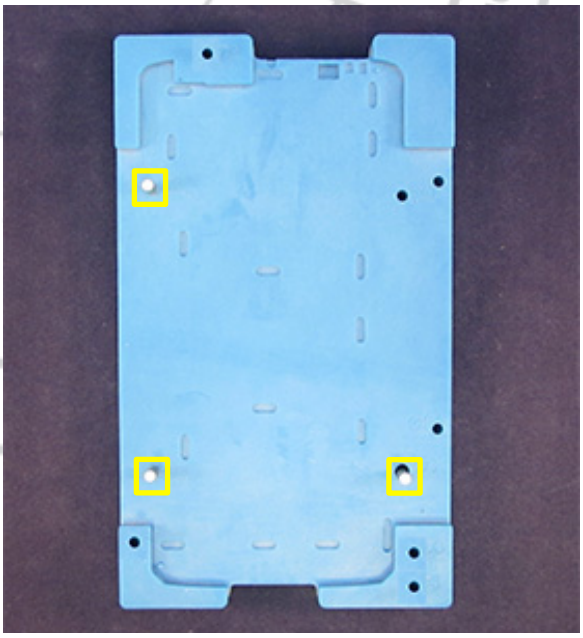
Battery Adhesive Assembly



Description	*Reference #*
ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB - R	1
DIE CUT,ADHES,BATTERY, LUX	2

1. Place 3 locating pins in the PCB Alignment Fixture (4-00-Z7-10000) in the locations shown.



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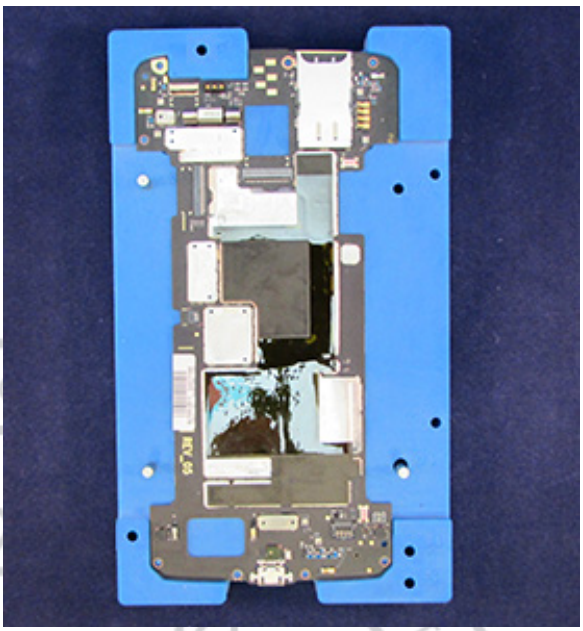
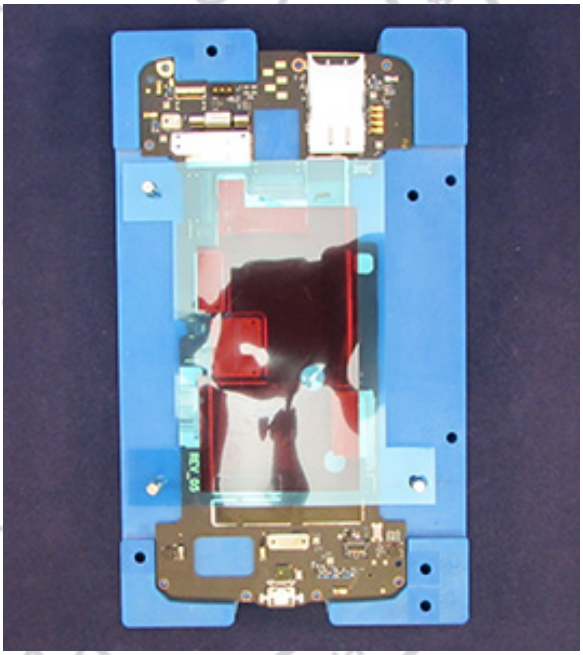
2. Remove the protective liners from the Front and Rear Thermal Spreaders if present.
3. Place the PCB into the fixture.



4. Remove the adhesive liner from the Battery Adhesive.
5. Place the Battery Adhesive into the fixture over the PCB, using the pins in the fixture to align it.
6. Press down on the Battery Adhesive for 5 seconds to secure it to the PCB.



7. Remove the PCB from the fixture.
8. Peel the outer liner off the Battery Adhesive. The inner liner remains in place.

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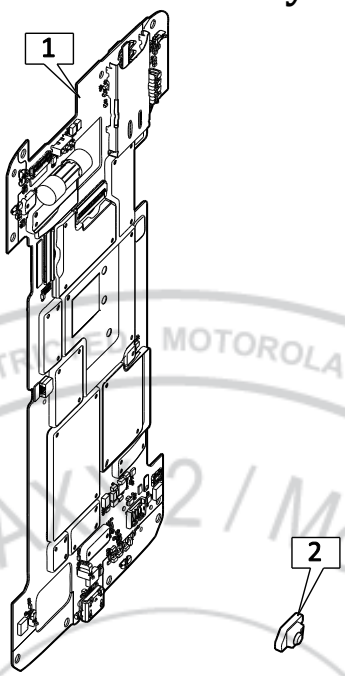
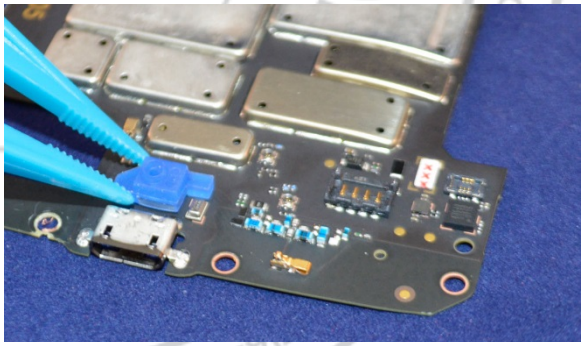
Main-Microphone Grommet Assembly

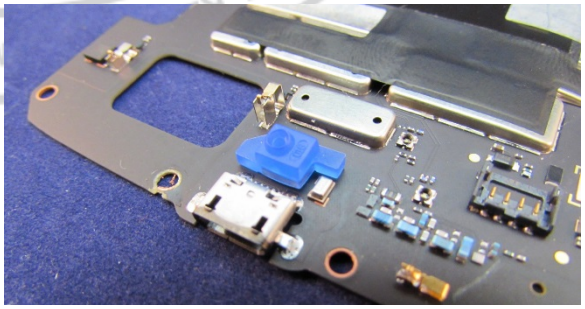


Description	*Reference #*
ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB - R	1
GROM,MIC,TERTIARY MIC, LUX	2

1. Use the Plastic Tweezers to place the Main-Microphone Grommet in position on the Main Microphone.



2. Verify that the Main-Microphone Grommet is flush with the PCB and oriented as shown.



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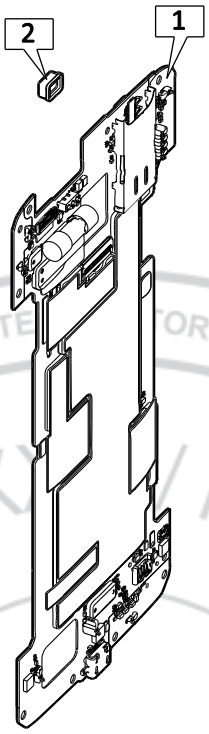
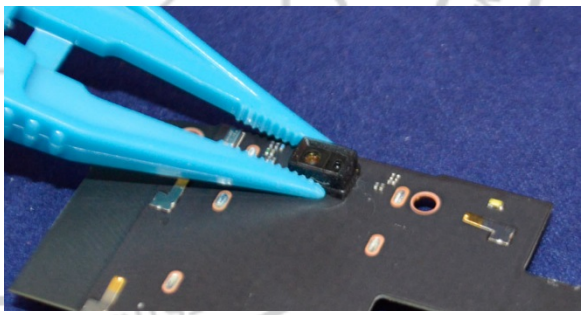
Proximity Grommet Assembly

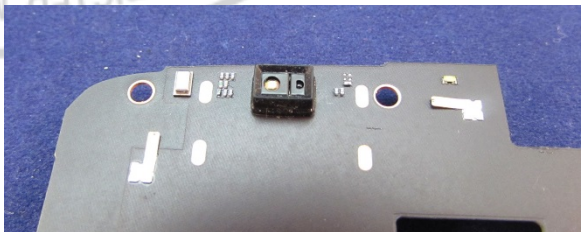


Description	*Reference #*
ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB - R	1
GROM,PROX, LUX	2

1. Use the Plastic Tweezers to place the Proximity Grommet in position on the Proximity Sensor.



2. Verify that the Proximity Grommet is flush with the PCB.



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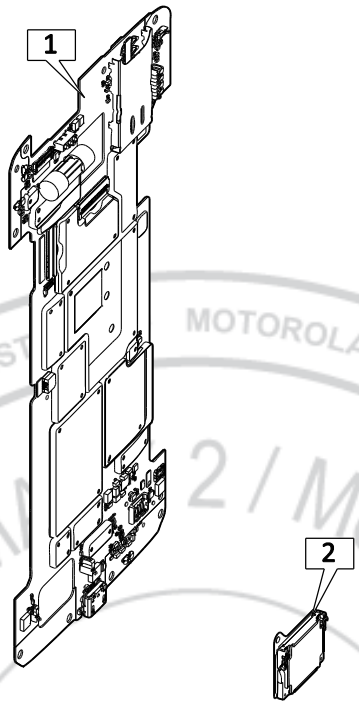
Loudspeaker Assembly



Description	*Reference #*
ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB - R	1
TRANSDUCER,OTHR,2.2V,AAC W/ ADHES W/ LINER	2

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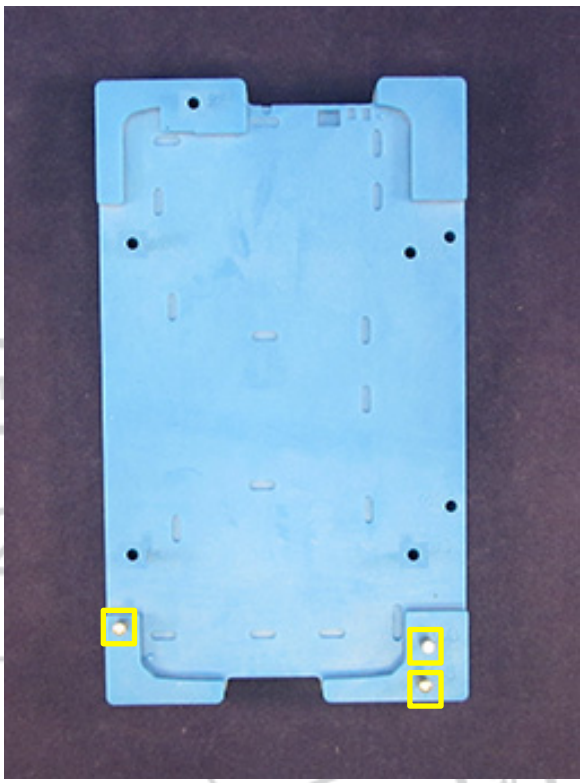
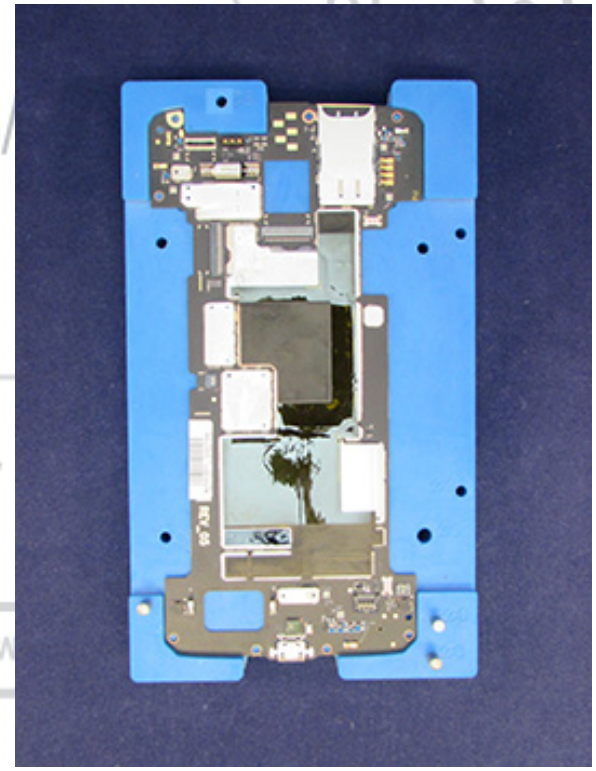
1. Place 3 locating pins in the PCB Alignment Fixture (4-00-Z7-10000) in the locations shown.



2. Place the PCB into the fixture.



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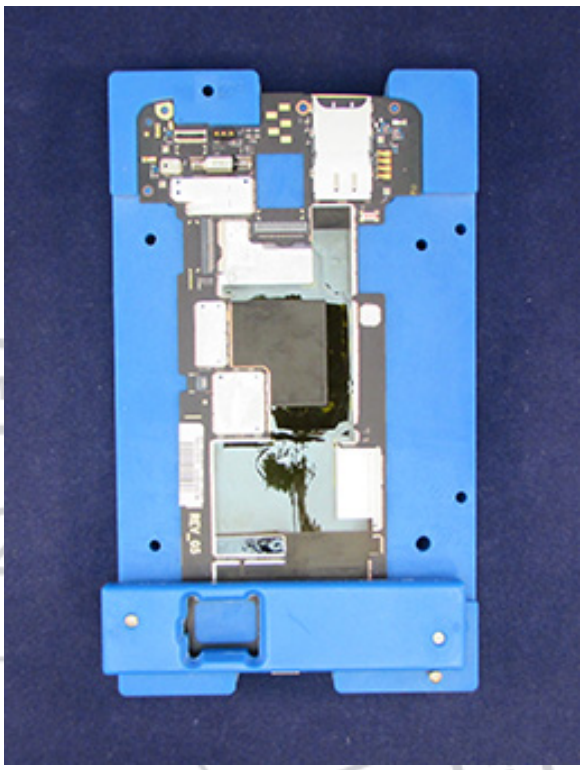
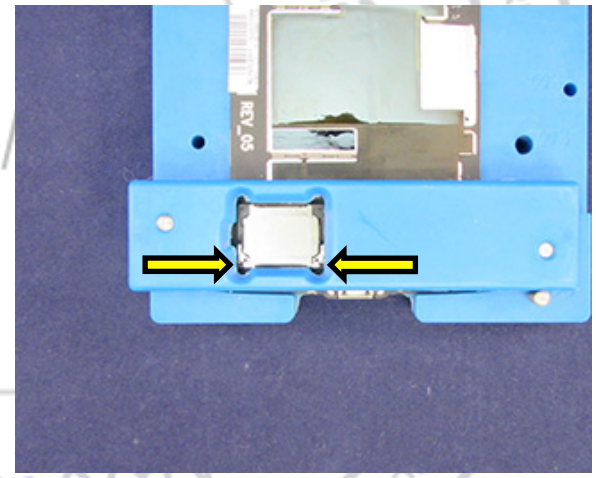
3. Place the Loudspeaker alignment plate on the fixture over the PCB.



4. Place the Loudspeaker into the pocket of the alignment plate with the Loudspeaker contacts facing the USB Connector end of the PCB.
5. Press down on the Loudspeaker for 5 seconds to secure it to the PCB.



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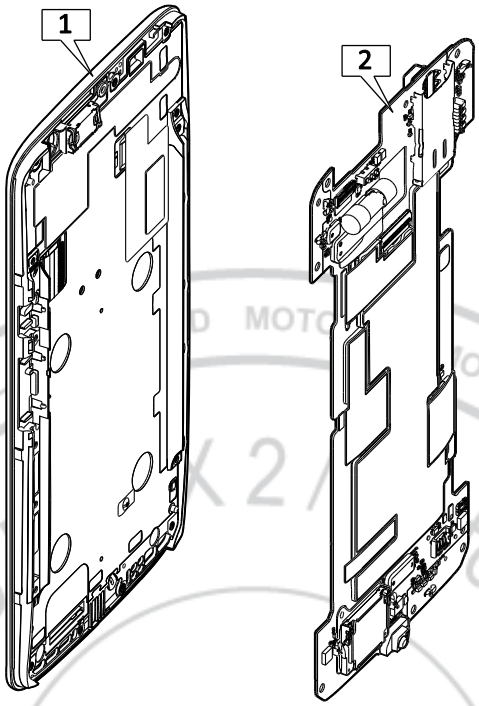
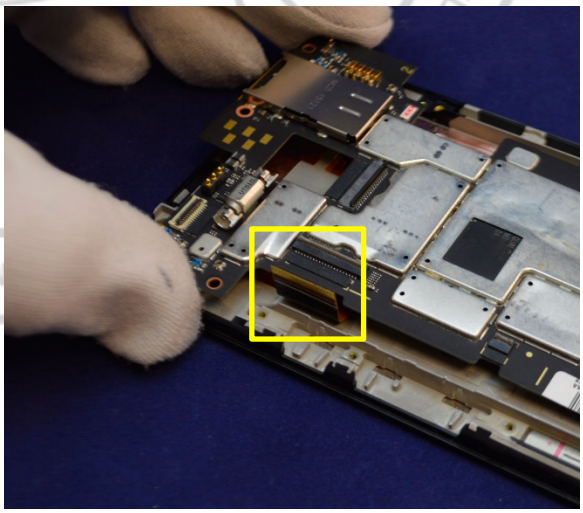
PCB Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
ASSY,PWA,XCVR,LYNX 16GB DBG - VZ ASSY,PWA,XCVR,LYNX 16GB DBG - LATAM ASSY,PWA,XCVR,LYNX 16GB DBG - R ASSY,PWA,XCVR,LYNX 32GB - R	2

1. Place the PCB into the Front Housing, keeping the Display Flex from tucking underneath the PCB.



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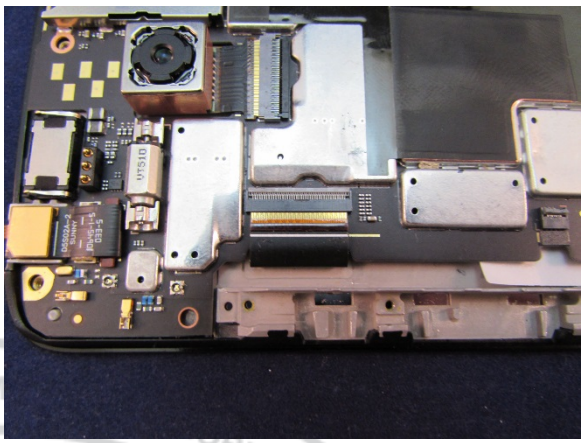
2. Insert the Display Flex into the ZIF Connector. Use the white line as a guide for insertion depth.
3. Slide a fingertip across the ZIF Connector Door to close it.
4. Place Kapton Tape over the Display Flex ZIF Connector.



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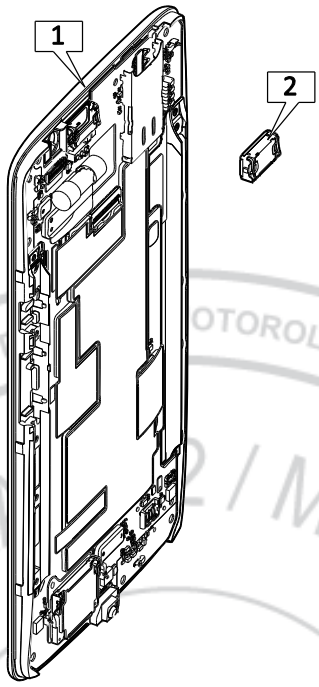
Earpiece Speaker Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
TRANSDUCER,OTHR,.566V,W/ ADHES AND LINER	2

1. Remove the Earpiece Speaker adhesive liner.
2. Place the Earpiece Speaker in the Display, using the alignment tab on the Earpiece Speaker to align it to the cutout on the Front-Facing Imager pocket.
3. Press down on the Earpiece Speaker for 5 seconds to secure it to the Display.

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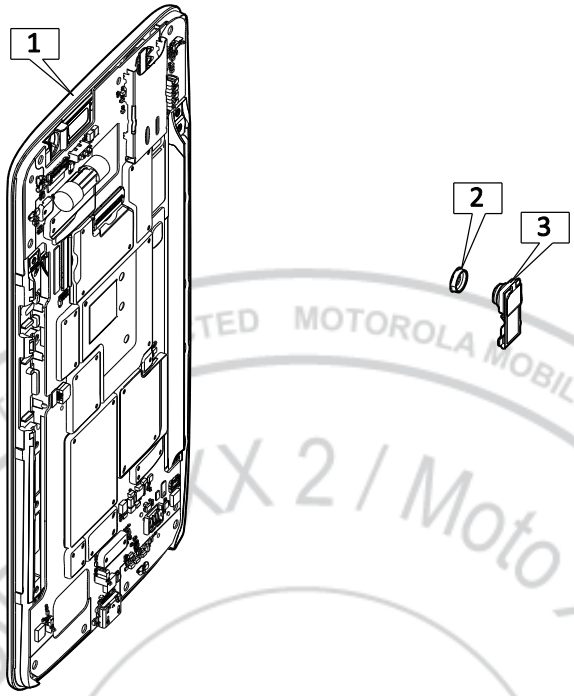
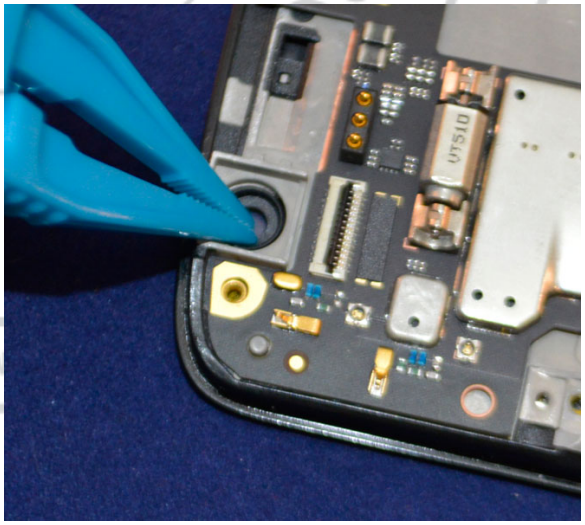
Front-Facing Imager Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
GROM,IMAGER, FRNT FACING 5MP, LUX	2
ASSY,FLXCKT,MODULE,5MP, FF IMGR	3

1. Use deionized air to clear any debris from the Front-Facing Imager pocket in the Display.
2. Remove the Front-Facing Imager Gasket from the carrier.
3. Use the Plastic Tweezers to place the Front-Facing Imager Gasket into the pocket of the Display.



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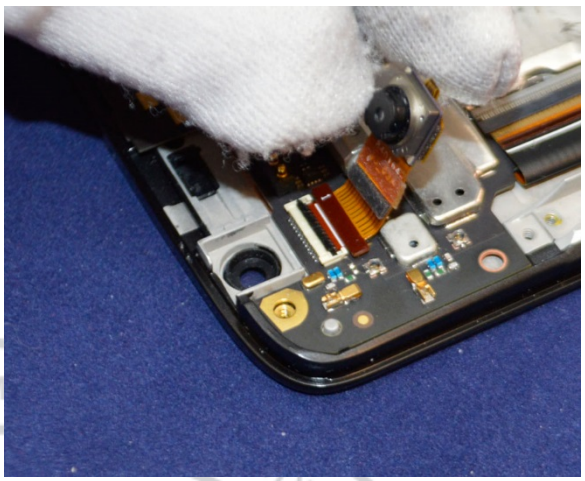
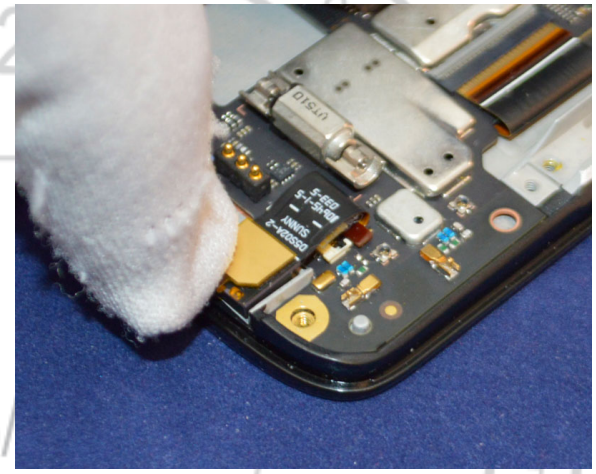
4. Remove the protective liner from the Front-Facing Imager.
5. Insert the Front-Facing Imager Flex into the Front-Facing Imager ZIF Connector. Use the white line as a guide for insertion depth.
6. Slide a fingertip across the ZIF Connector Door to close it.
7. Place Kapton Tape over the Front-Facing Imager ZIF Connector.



8. Fold the Front-Facing Imager into the pocket.
9. Press down on the Front-Facing Imager to secure it in the pocket.



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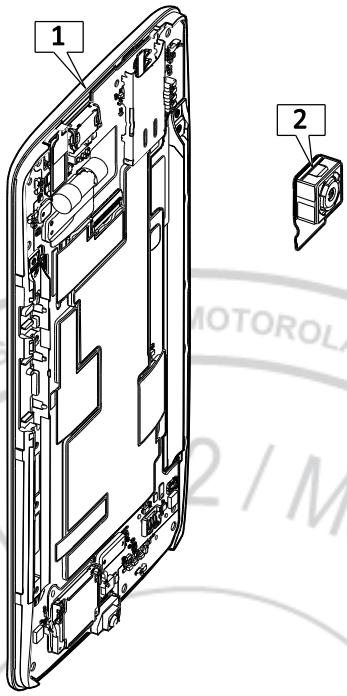
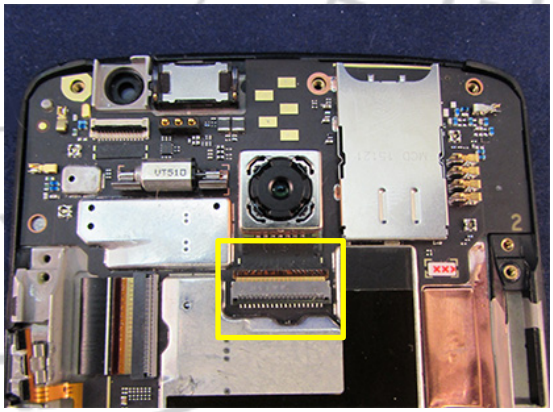
Rear-Facing Imager Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
ASSY,FLXCKT,MODULE, 21MP, RF IMGR	2

1. Insert the Rear-Facing Imager Flex into the Rear-Facing Imager ZIF Connector.
2. Slide a fingertip across the ZIF Connector Door to close it.
3. Place Kapton Tape over the Rear-Facing Imager ZIF Connector.



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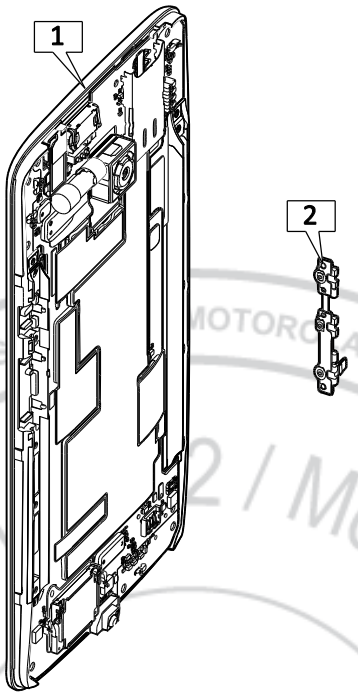
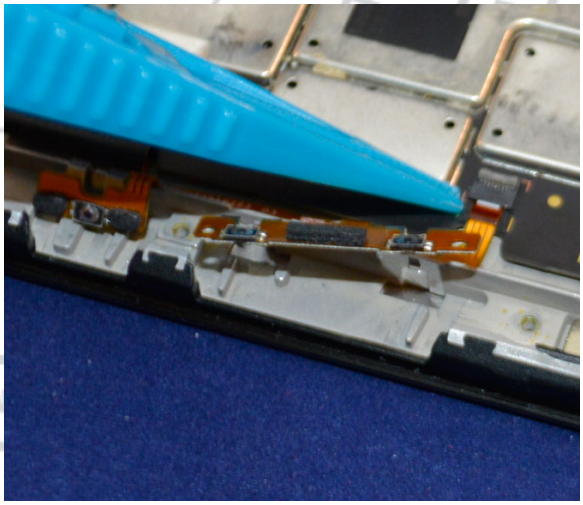
Side-Key Flex Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
ASSY,FLXCKT,SIDE KEY, LUX	2

1. Use the Plastic Tweezers to insert the Side-Key Flex into the ZIF Connector. Use the white line as a guide for insertion depth.
2. Slide a fingertip across the Side-Key Flex ZIF Connector Door to close it.
3. Place Kapton Tape over the Side-Key Flex ZIF Connector.



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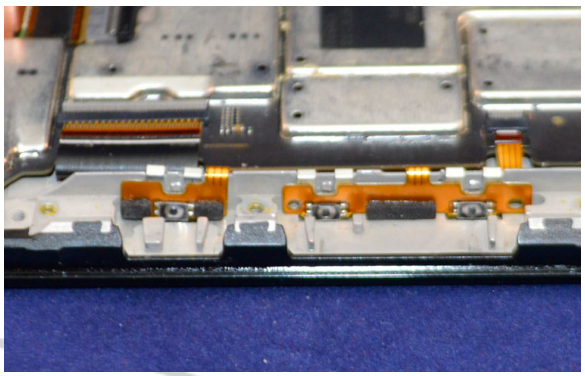
4. Remove the adhesive liner from the Side-Key Flex.
5. Use the alignment feature and metal hooks to position the Side-Key Flex in the pocket of the Front Housing.
6. Inspect the Side-Key Flex to verify that the pads are aligned with the key features.



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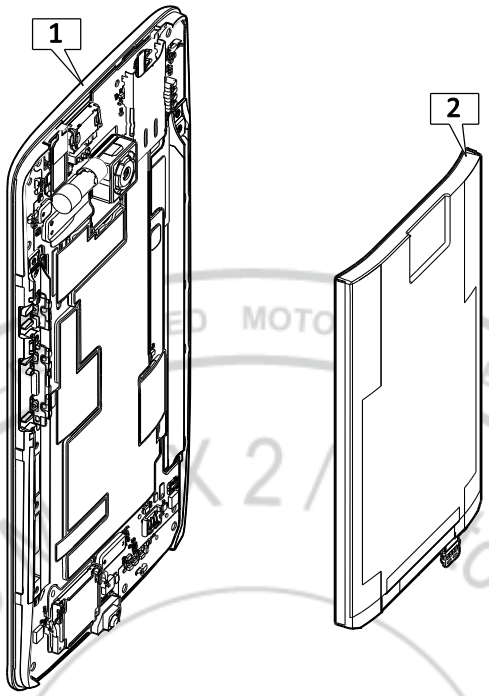
Battery Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
ASSY,BAT,FL40,LI POLYMER,LG CHEM,TYP3630 MAH	2

/// WARNING ///

Failure to adhere to Safety Critical Note(s) may increase risk of rupture, burning, or failure to function safely when used by the customer. Refer to the Battery Safety Guidelines.

// CAUTION //

Handle the Battery Pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

Ensure Battery and its insulation are not damaged (e.g. scratched, dented, punctured) prior to and throughout assembly.

Prior to assembly, ensure Battery edges and surfaces are not dented or deformed, and that fixtures and parts that will contact the Battery are free of foreign material.

Ensure screws and screwdrivers do not contact the Battery.

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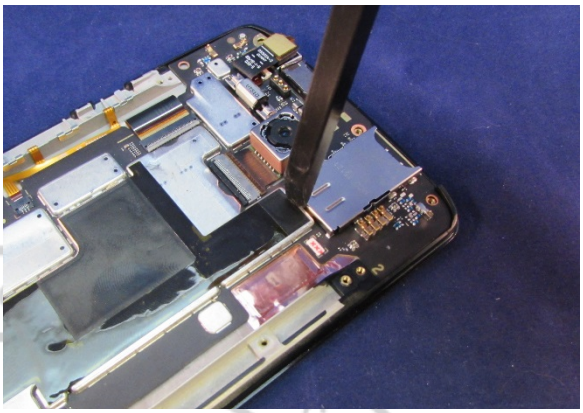
1. Remove the liner from the Battery Adhesive.

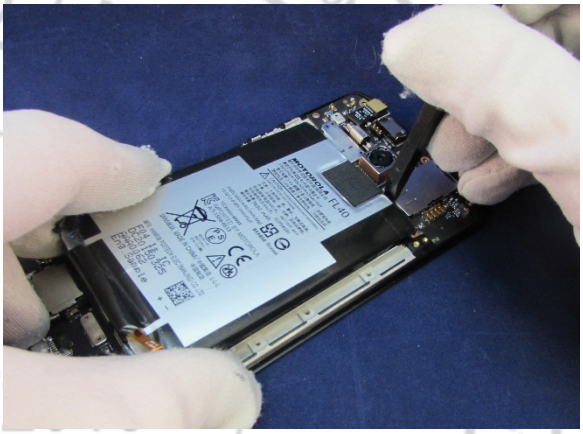
2. Hold the flat end of the Blackstick against the SIM/SD Tray slot on the PCB as shown.



NOTE

The Blackstick is used to correctly distance the Battery from the SIM/SD Tray slot.

3. While holding the flat end of the Blackstick against the SIM/SD Tray slot, place the Battery over the Battery Adhesive.



4. Press down on the Battery for 5 seconds to secure it to the PCB.

// CAUTION //

Do not connect the Battery at this time. Damage to the phone may occur. The Battery must not be connected until Rear Housing Assembly.

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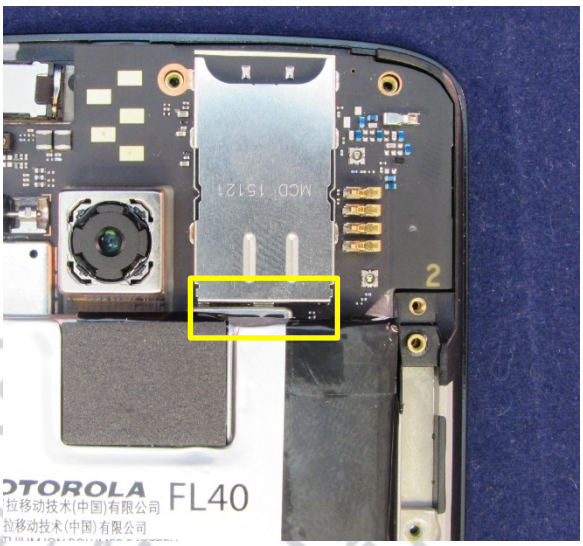
5. Verify that there is a gap between the Battery and SIM/SD Tray slot.



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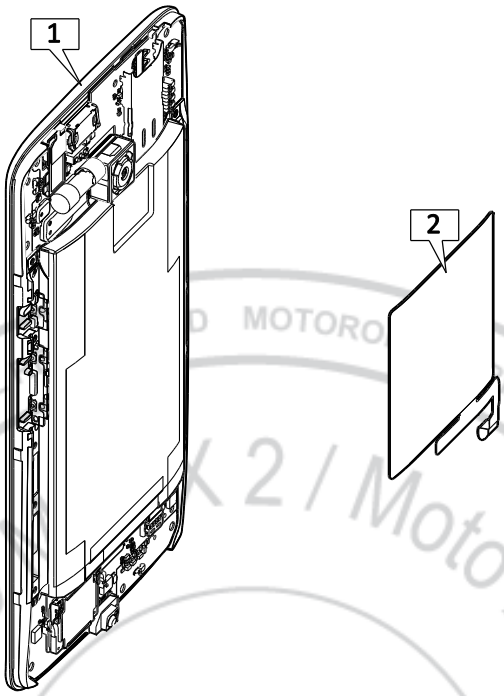
NFC Antenna Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
FIXED INDUCTOR,NFC FLEX, LUX	2

/// WARNING ///

Failure to adhere to Safety Critical Note(s) may increase risk of rupture, burning, or failure to function safely when used by the customer. Refer to the Battery Safety Guidelines.

// CAUTION //

Handle the Battery Pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

Ensure Battery and its insulation are not damaged (e.g. scratched, dented, punctured) prior to and throughout assembly.

Prior to assembly, ensure Battery edges and surfaces are not dented or deformed, and that fixtures and parts that will contact the Battery are free of foreign material.

Ensure screws and screwdrivers do not contact the Battery.

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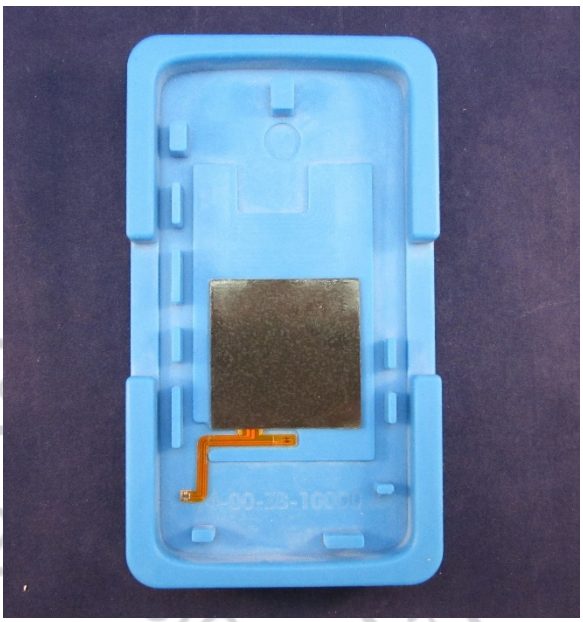
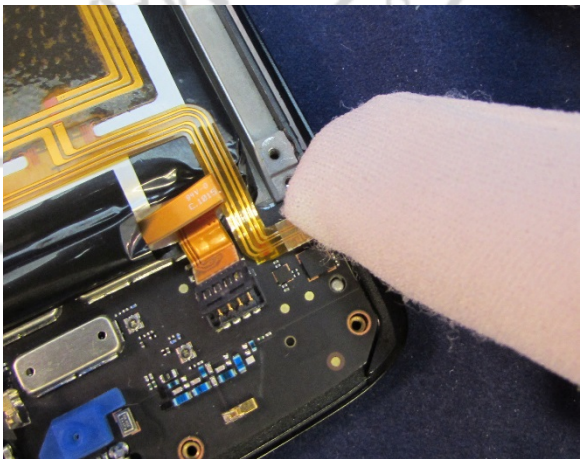
1. Remove the NFC Antenna adhesive liner.
2. Place the NFC Antenna into the NFC Alignment Fixture (4-00-Z8-10000) with the adhesive facing up.



3. Place the phone into the fixture with the Battery facing down.
4. Press down on the phone for 5 seconds to secure the NFC Antenna to the Battery.

5. Remove the phone from the fixture.
6. Press down on the NFC Antenna connector to connect it to the PCB.



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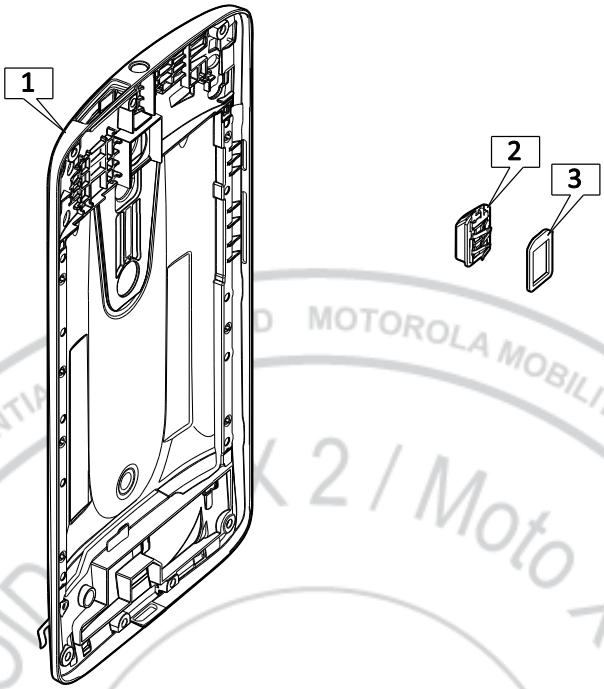
Headset Jack Assembly

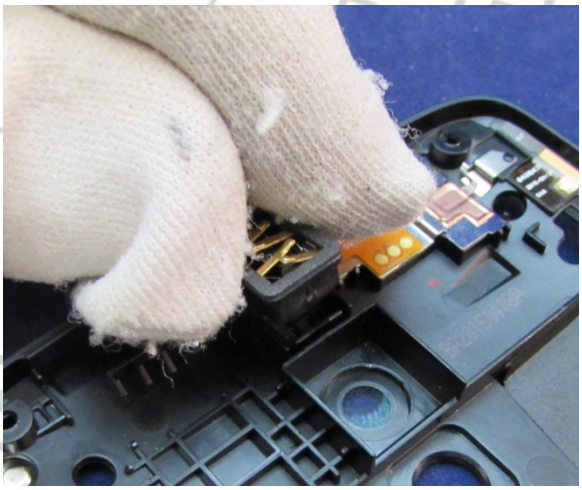


Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
CONN,JACK,HEADSET,3.5 MM DIA	2
SEAL,GSKT,HSET JCK	3

1. Remove the Headset Jack adhesive liner.
2. Place the Headset Jack into the pocket of the Rear Housing.
3. Press down on the Headset Jack for 5 seconds to secure it in the Rear Housing.

// CAUTION //

Do not damage the Headset Jack contacts when pressing it into the Rear Housing.



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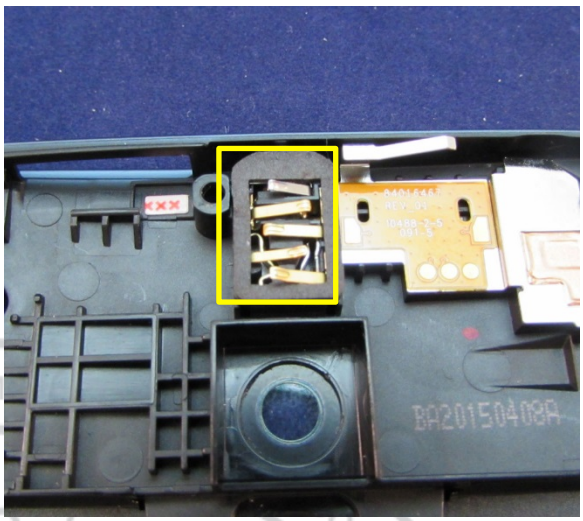
4. Remove the Headset Jack Gasket from the carrier.
5. Place the Headset Jack Gasket into position over the Headset Jack.
6. Press down on the Headset Jack Gasket for 5 seconds to secure it to the Headset Jack.



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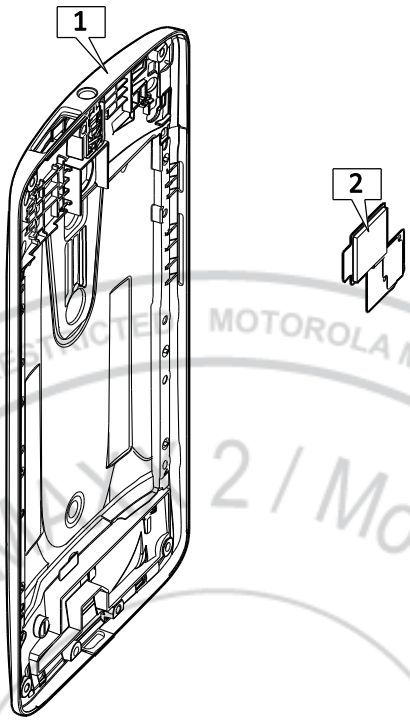
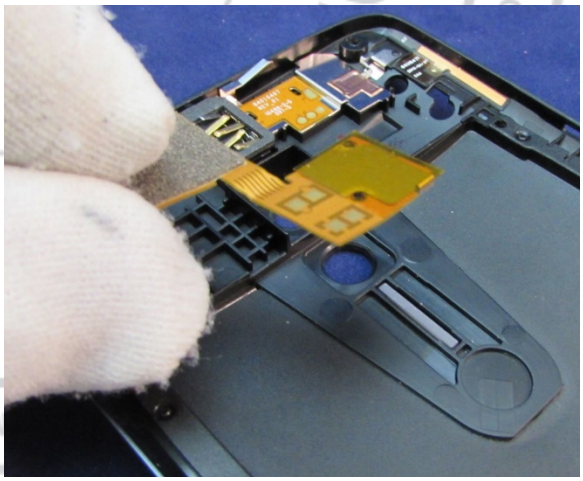
LED Flash Assembly



Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
ASSY,FLXCKT,LED FLASH, LUX	2

1. Remove the adhesive liner from the LED Flash.
2. Place the LED Flash into the Rear Housing.



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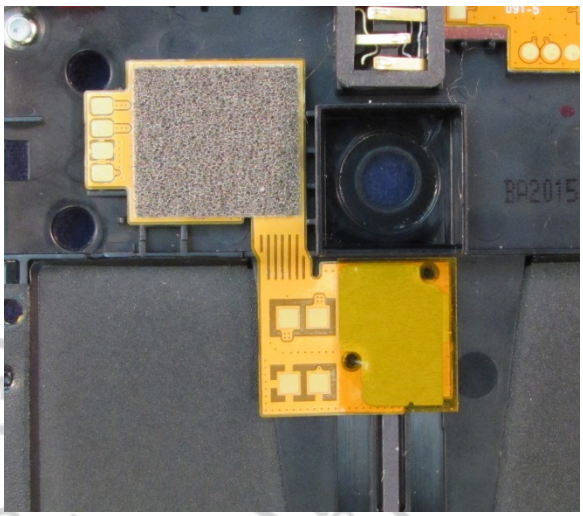
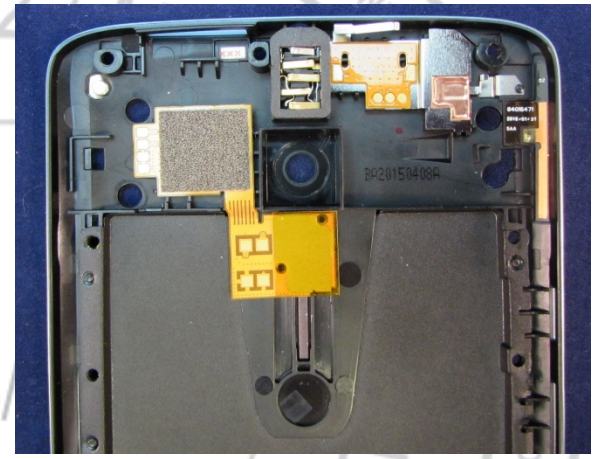
3. Verify that the LED Flash is placed in the Rear Housing as shown.



4. Press down on the LED Flash for 5 seconds to secure it to the Rear Housing.



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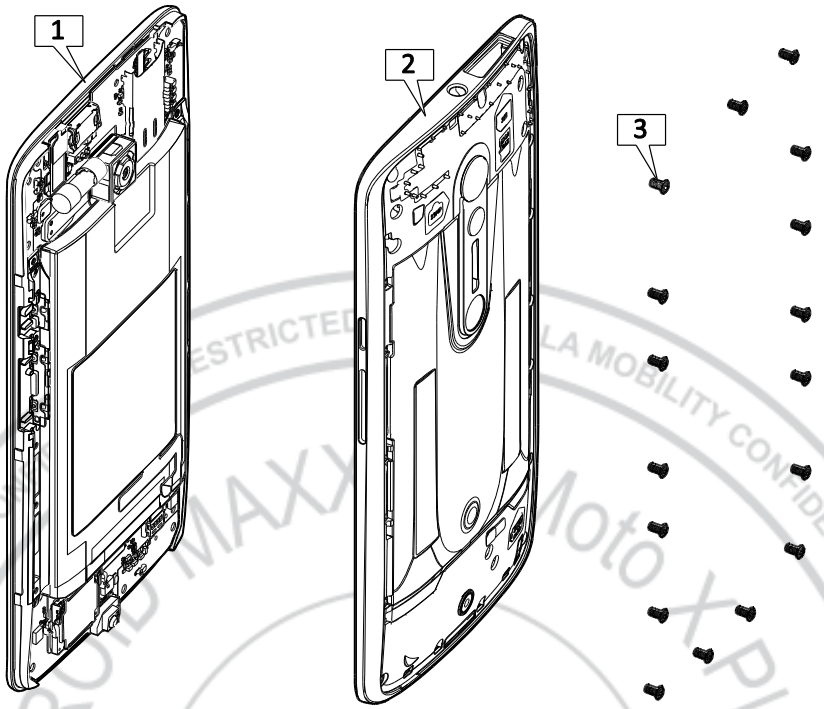
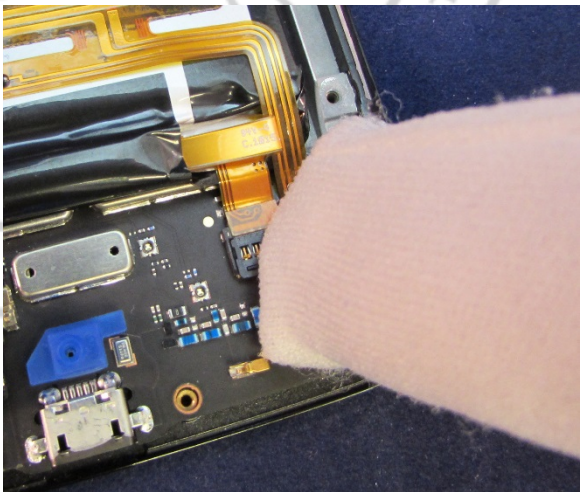
Rear Housing Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	2
SCREW,ENDO, M1.4X0.3, 2.8L, LUX SCREW,ENDO, M1.4X0.3, 3.1L, LUX	3

1. Press down on the Battery Connector to connect it to the PCB.



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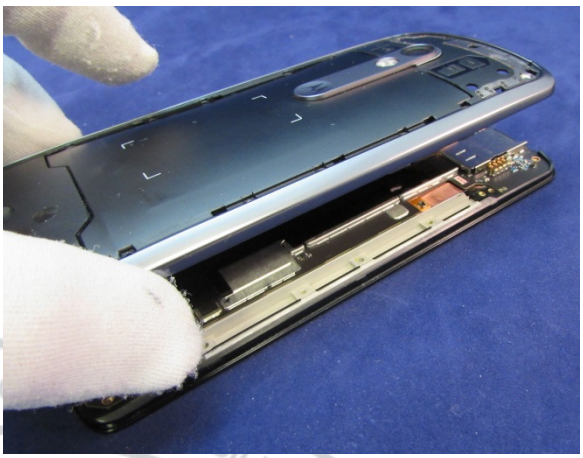
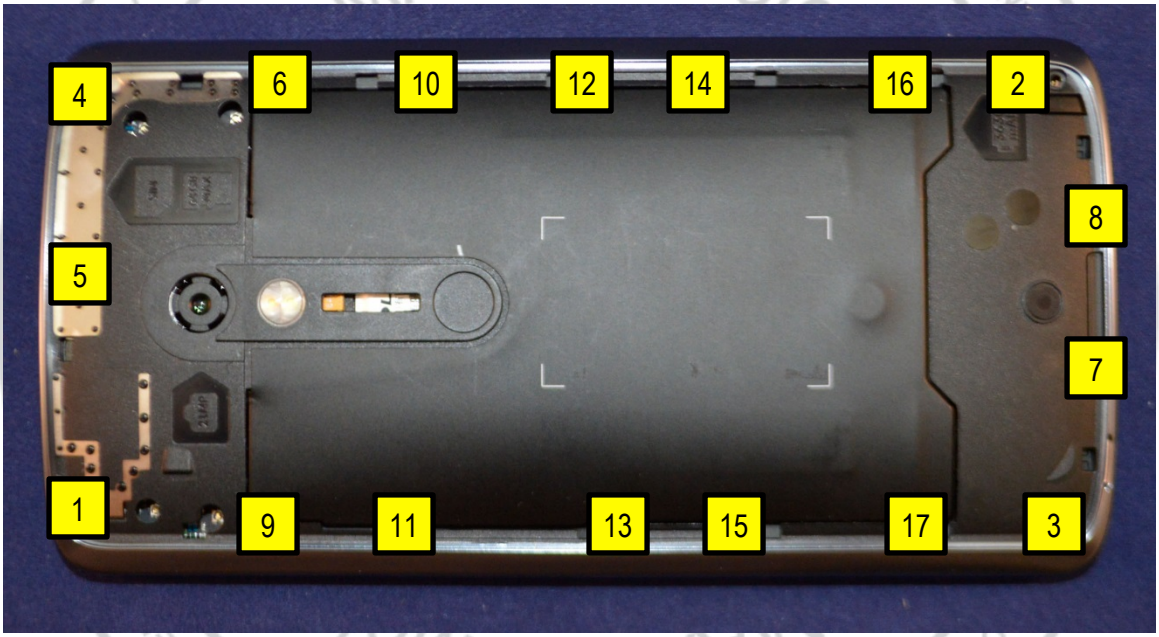
2. Remove the protective liners from the Rear-Facing Imager, Loudspeaker Gasket, and Rear-Facing Imager opening if present.
3. Place the Rear Housing over the phone assembly.



4. Tighten the 17 3IP screws to 0.8 in-lbs in the order shown.



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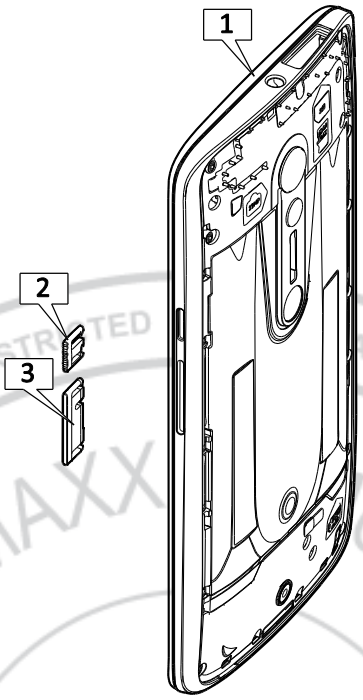
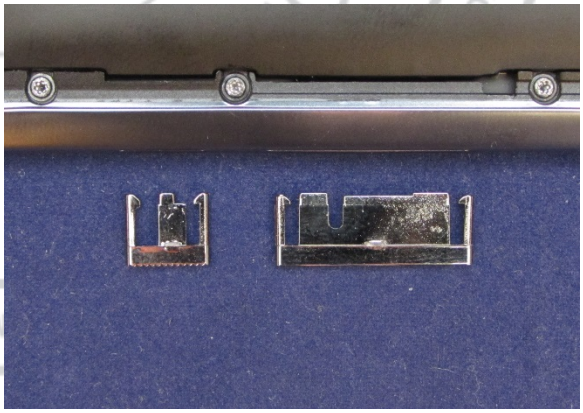
Side Key Assembly



Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
BTN,PWR,LUX, TIN SLVR BTN,PWR,LYNX, LIC	2
BTN,VOL,LUX TIN SLVR BTN,VOL,LUX, LIC	3

NOTE

The Power Key and Volume Key alignment features are oriented to the Rear Housing as shown.



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1. Place the Power and Volume keys into the Side Key pockets. Use the alignment features on each key and in each pocket to orient the keys.
2. Push each key into the pocket until it snaps into place.
3. Press the Power Key and Volume Key several times to verify the tactile response.

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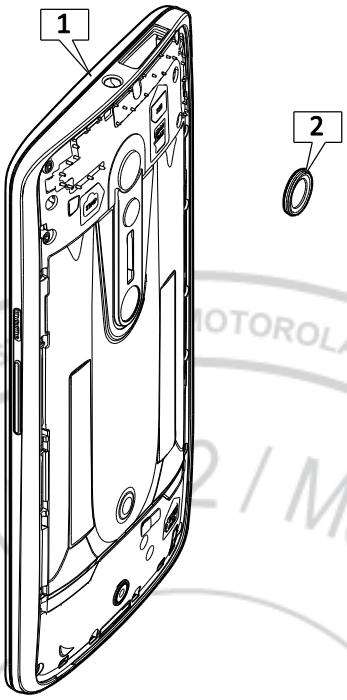
Rear-Facing Imager Lens Assembly



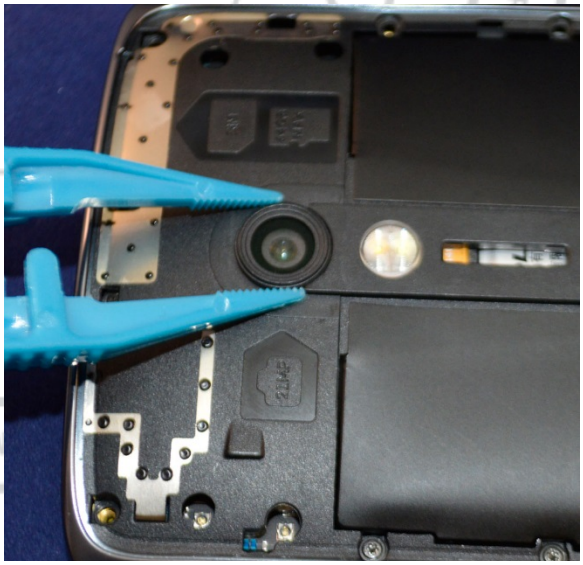
Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
ASSY,PRD OTH,CAMR LENS, LUX	2

1. Remove the adhesive liner from the Rear-Facing Imager Lens.
2. Place the Rear-Facing Imager Lens on the Rear Housing, using the raised feature to align the lens.

NOTE

The Rear-Facing Imager Lens can be placed by hand or using the Plastic Tweezers.

3. Press down on the Rear-Facing Imager Lens for 5 seconds to secure it to the Rear Housing.



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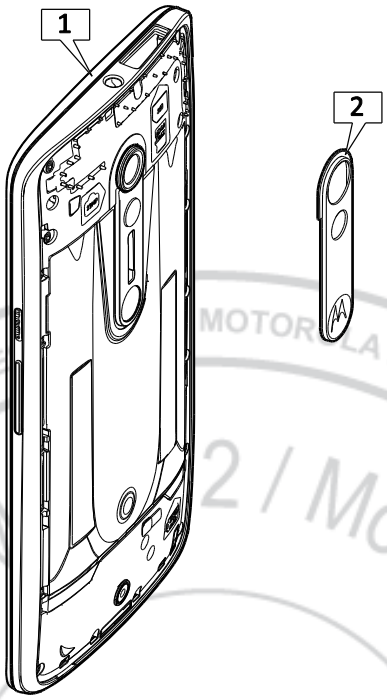
Rear-Facing Imager Bezel Assembly



Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
ASSY,BZL,CAMERA, LUX TIN SLVR ASSY,BZL,CAMERA, LUX DK TI	2

1. Remove the adhesive liner from the Rear-Facing Imager Bezel.
2. Place the Rear-Facing Imager Bezel on the Rear Housing, using the openings for the Rear-Facing Imager Lens and LED Flash to align it.
3. Press down on the Rear-Facing Imager Bezel for 5 seconds to secure it to the Rear Housing.

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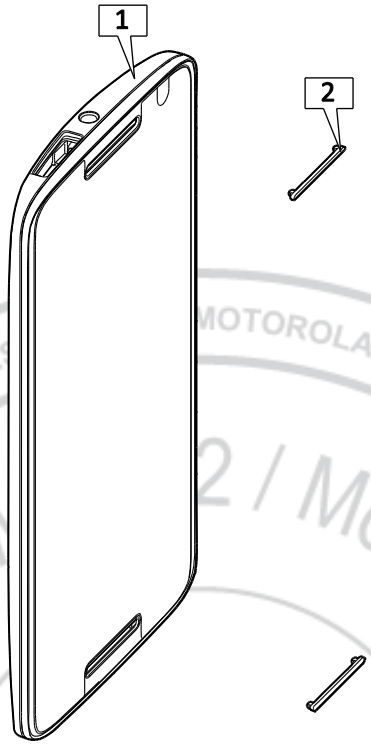
Earpiece Speaker Bezel and Loudspeaker Bezel Assembly



Description	*Reference #*
ASSY,HSG,FRNT,PROTO, LUX DARK ASSY,HSG,FRNT,PROTO, LUX WHT ASSY,HSG,FRNT,PROTO, LUX DARK	1
BZL,EARPC,LUX MTLC SLVR BZL,EARPC,LUX,METALLIC DK GRY	2

1. Place the phone into the Lynx Bezel Alignment Fixture (4-00-Z9-10000).

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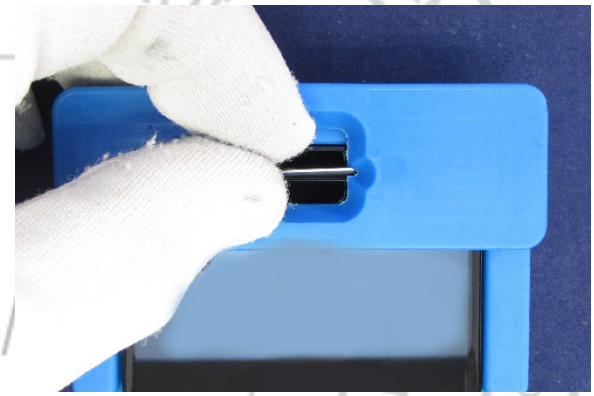
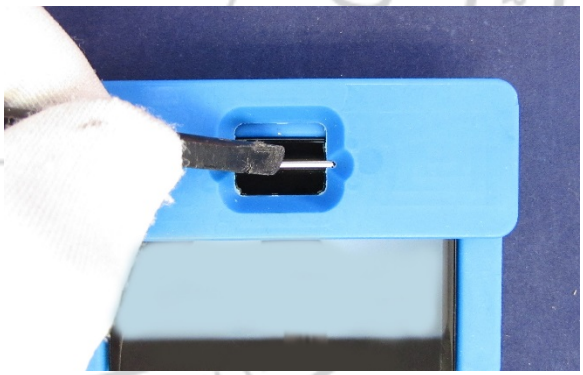
2. Place the alignment lids over the fixture.

3. Insert the Earpiece Speaker Bezel into the slot in the alignment lid.



4. Use the flat end of the Blackstick to press the Earpiece Speaker Bezel into the Display.



5. Repeat steps 3 and 4 for the Loudspeaker Bezel.

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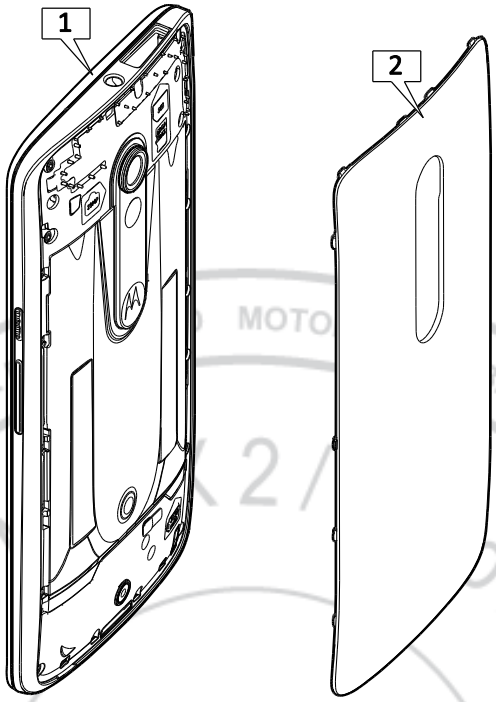
Rear Cover Assembly



Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
HSG,REAR,COVER,CSR,LUX VZ CHALK HSG,REAR,COVER, SFT TOUCH, LUX NAVY VZ HSG,REAR,COVER, SFT TOUCH, LUX BLK HSG,REAR,COVER,CSR,LUX CHALK HSG,REAR,COVER, SFT TOUCH, LUX NAVY	2

1. Place the Rear Cover into the pocket of the Rear Housing.

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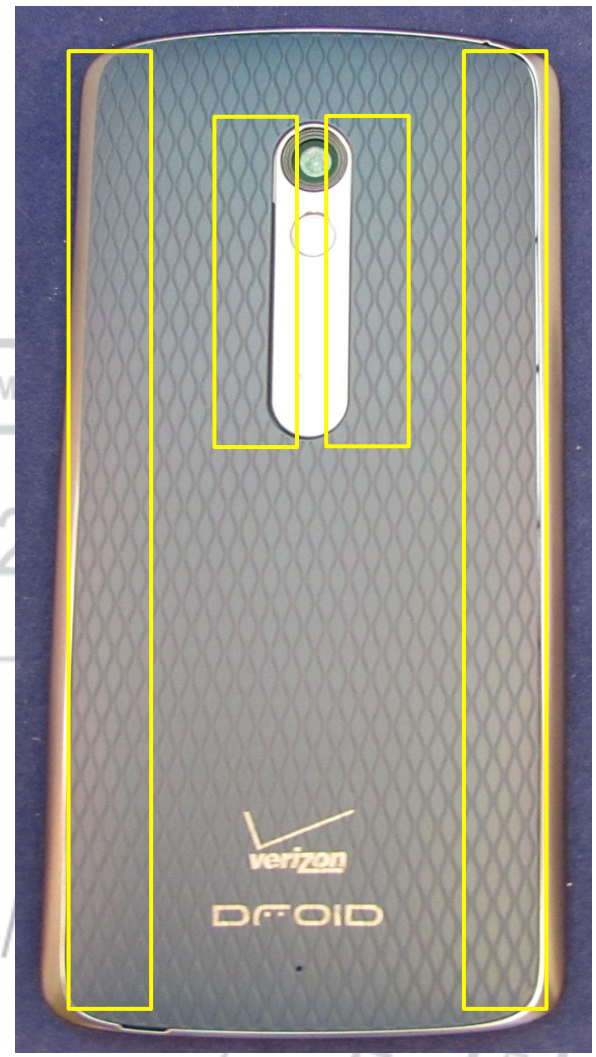
2. Press the sides of the Rear Cover to engage the snap features.
3. Verify the Rear Cover is flush with the rim of the Rear Housing.



4. Place the phone onto the Universal Nest (3-00-A7-10000), with the Display side face up.

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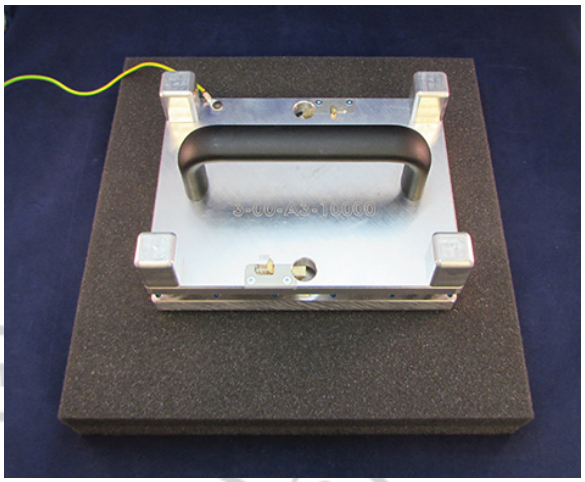
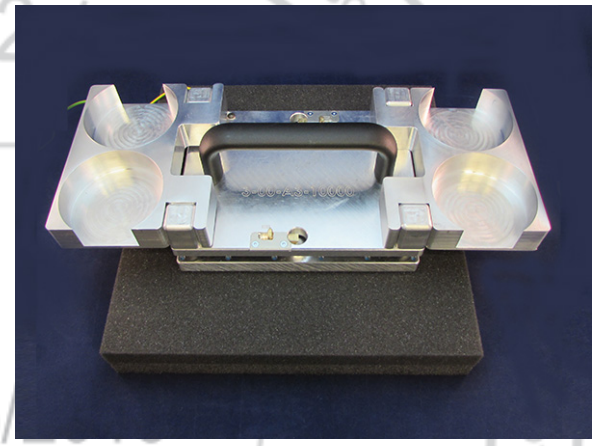
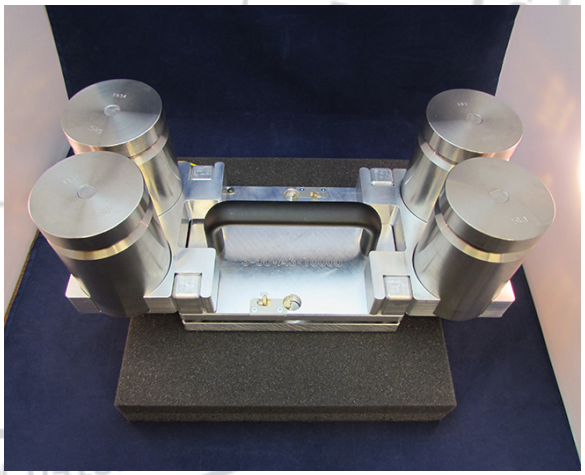
5. Place the Universal Press Fixture (3-00-A3-10000) onto the Universal Nest over the phone.



6. Place the brackets for the Universal Press Weights (3-00-E5-10000) onto the Universal Press Fixture.



7. While holding the Universal Press Fixture in position, place the Universal Press Weights into the brackets.



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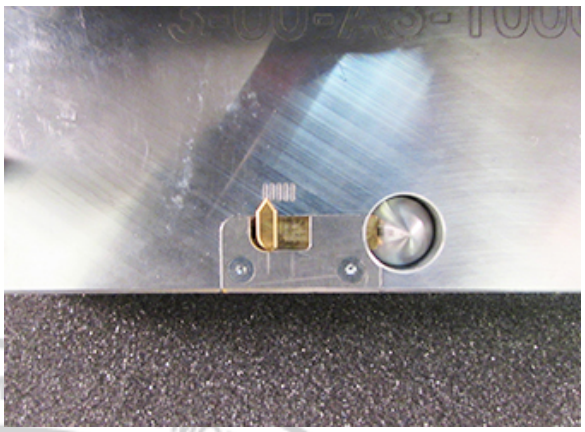
8. Using both hands, press down on the phone with the Universal Press Fixture at 500 N m for 5 seconds.
9. Repeat two more times.



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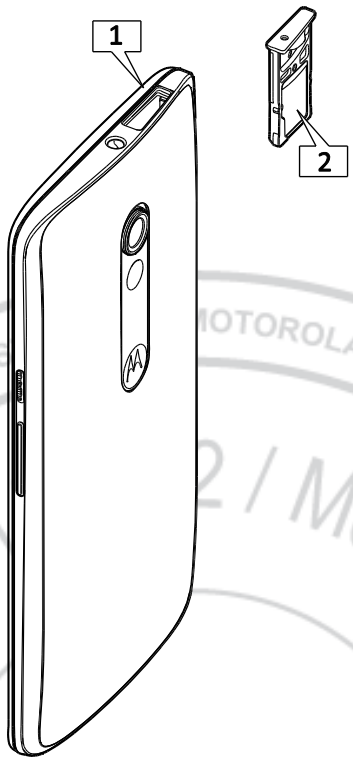
SIM/SD Tray Assembly



Description	*Reference #*
ASSY,HSG,REAR,LUX TIN SLVR ASSY,HSG,REAR,LUX	1
ASSY,SIM TRAY, DUAL, TIN SILVER, LUX ASSY,SIM TRAY, DUAL, DK TITANIUM, LUX	2

1. Insert the SIM/SD Tray into the Rear Housing assembly. The small hole should be oriented toward the Headset Jack.
2. Verify the SIM/SD Tray is flush with the Rear Housing.

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