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# DROID TURBO 2 / Moto X Force



## DROID TURBO 2 / Moto X Force Level 2 – Service and Repair Manual

# REVISION HISTORY

Revision	Date	Notes
1	10/30/2015	Initial release.
2	12/04/2015	Bounce Chassis Screw Guide (3-00-F6-10000) added to Tools Required for Assembly and Battery Assembly.
3	01/28/2016	<ul style="list-style-type: none"> <li>• Figure 8 updated to include the DROID Logo.</li> <li>• Table 3 updated to include rework Audio Bezels and the DROID Logos.</li> <li>• Audio Bezel and DROID Logo added to Disassembly and Recovery Map.</li> <li>• Bounce Inlay Heating Plate (3-00-F5-10000) and "7x7" Hot Plate (4-00-Z2-10000 (220V) /4-00-Z3-10000 (110V)) added to the Tools Required for Disassembly.</li> <li>• The Rear Inlay Removal section was updated to include pre-heating instructions using the Bounce Inlay Heating Plate (3-00-F5-10000).</li> <li>• The following sections were added to Disassembly and Recovery:                             <ul style="list-style-type: none"> <li>○ Audio Deco Removal</li> <li>○ DROID Logo Removal</li> <li>○ Side Key Removal</li> </ul> </li> <li>• DROID Logo added to Assembly Map.</li> <li>• The Tools Required for Assembly section was updated to include the new Bounce Audio Bezel Press Tool (3-00-F7-10000) and an updated image of the Bounce Earpiece Deco Press Fixture (3-00-D8-10000).</li> <li>• The Rear Inlay Assembly section was updated to include assembly of the DROID Logo.</li> <li>• The Audio Deco Assembly section was updated to include rework Audio Bezels, updated images of the Bounce Earpiece Deco Press Fixture (3-00-D8-10000), and the new Bounce Audio Bezel Press Tool (3-00-F7-10000).</li> </ul>

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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.

# INTRODUCTION

## External Views



Figure 1. External Views

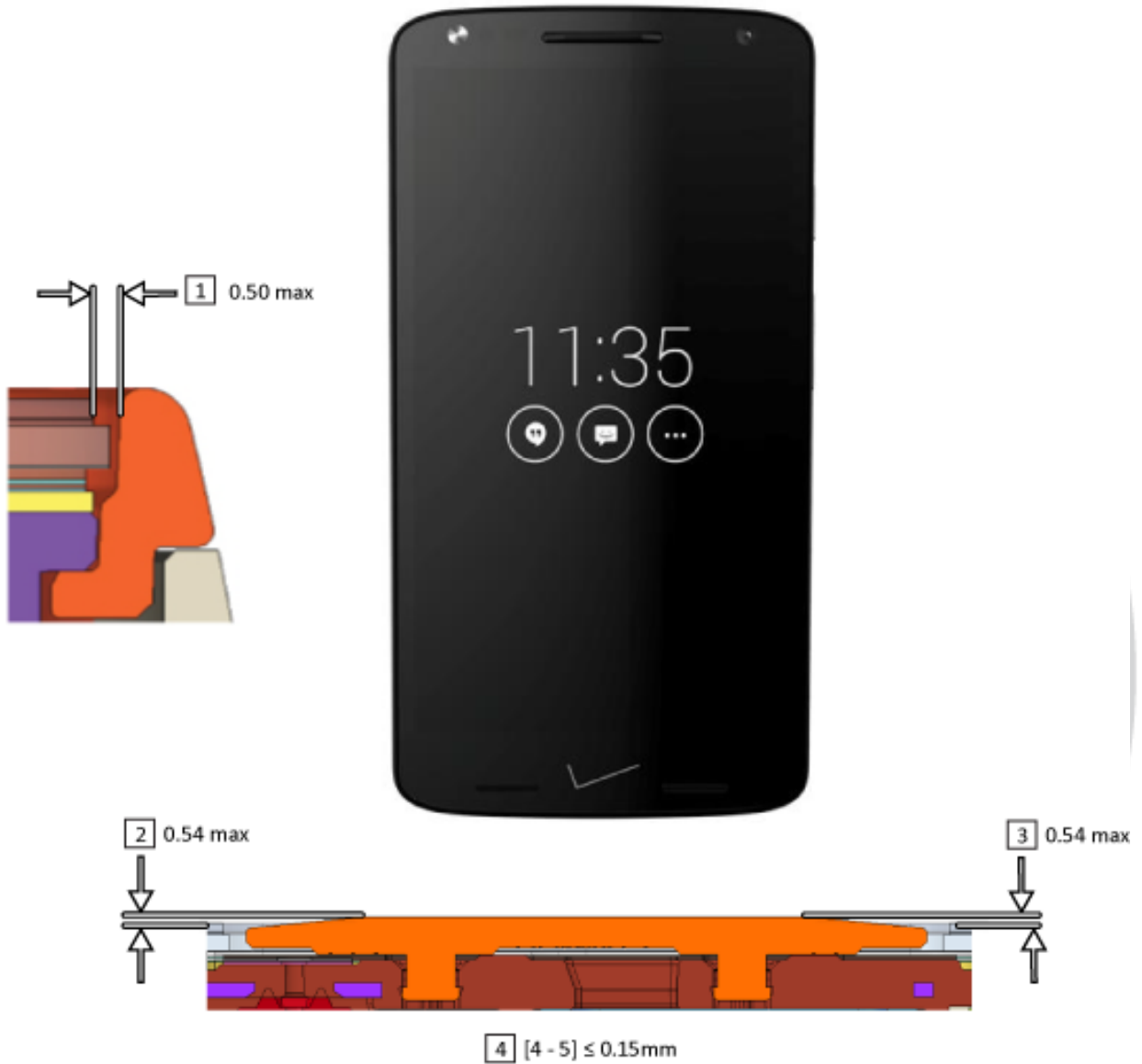


**Table 1. External Views Parts List**

<i>Reference #</i>	<i>Description</i>
1	Front-Facing LED Flash
2	Earpiece Speaker
3	Front-Facing Imager
4	Display Lens
5a	Power Key
5b	Volume Key
6	Rear-Facing Imager Bezel
7	Rear-Facing Imager
8	LED Flash
9	Motorola Logo
10	Rear Housing
11	USB Port
12	Headset Jack
13	SIM and SD Card Tray
14	Main Microphone
15a	Loudspeaker
15b	Loudspeaker

## 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**

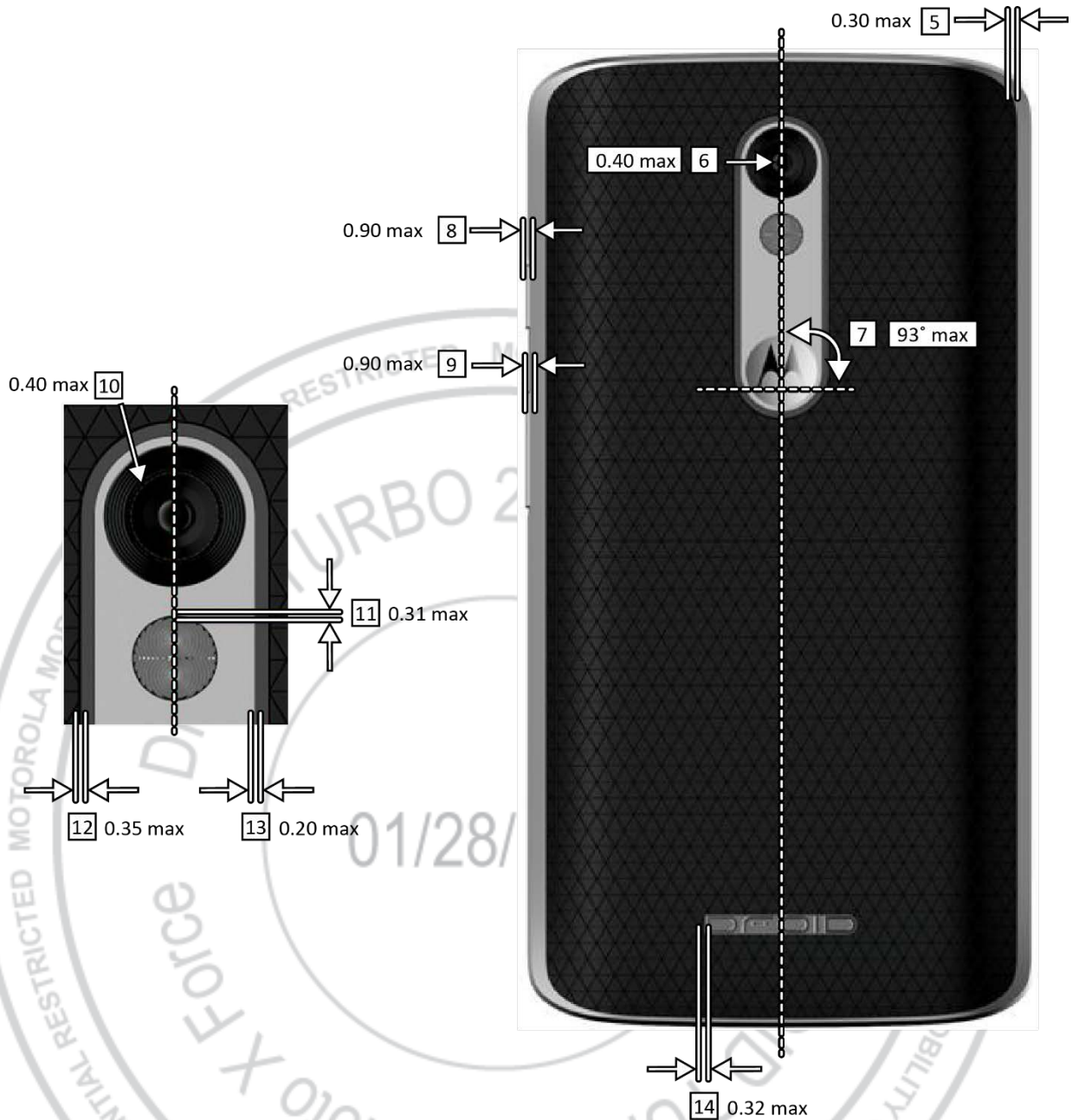
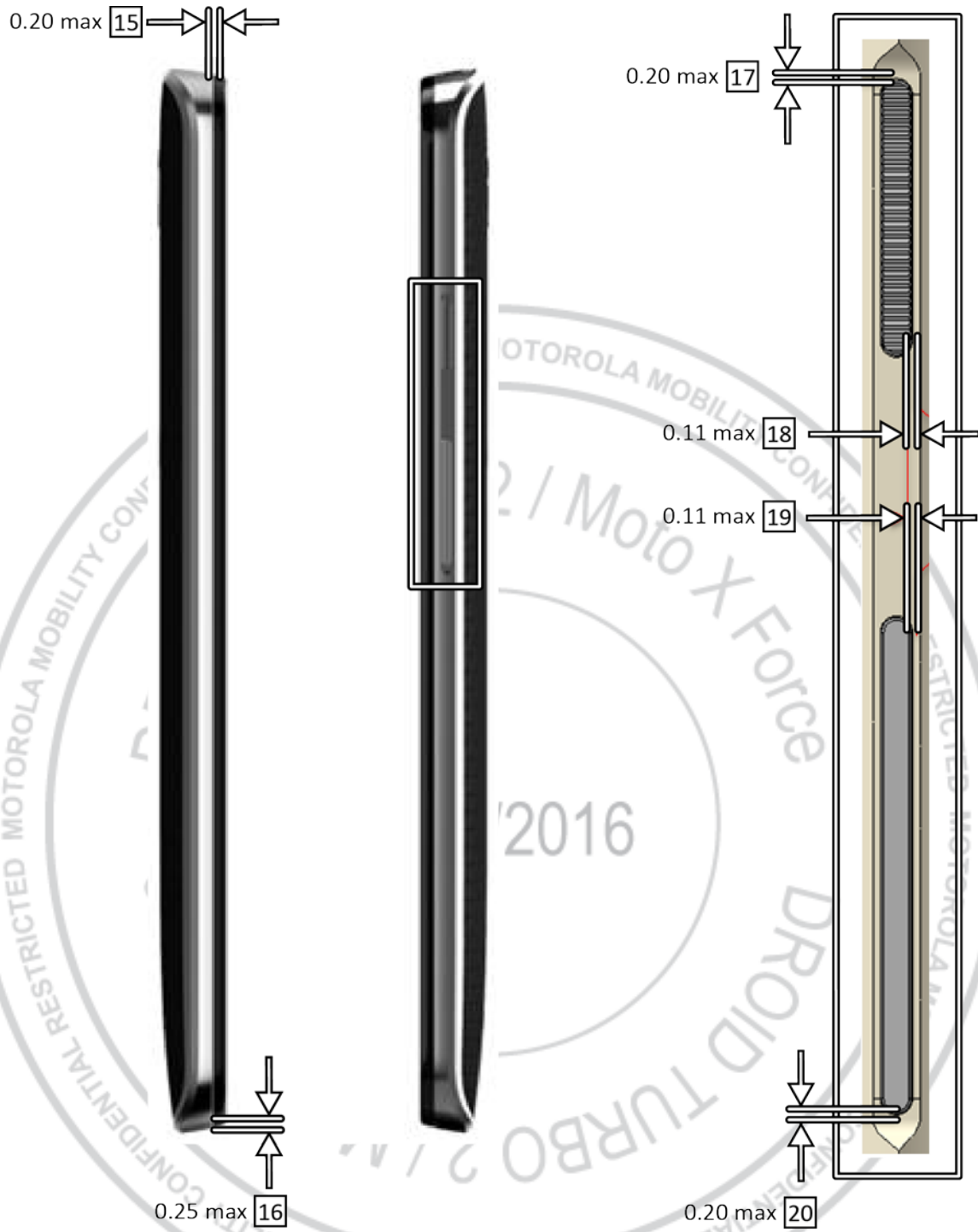


Figure 3. PSCD Rear View



**Figure 4. PSCD Side View**

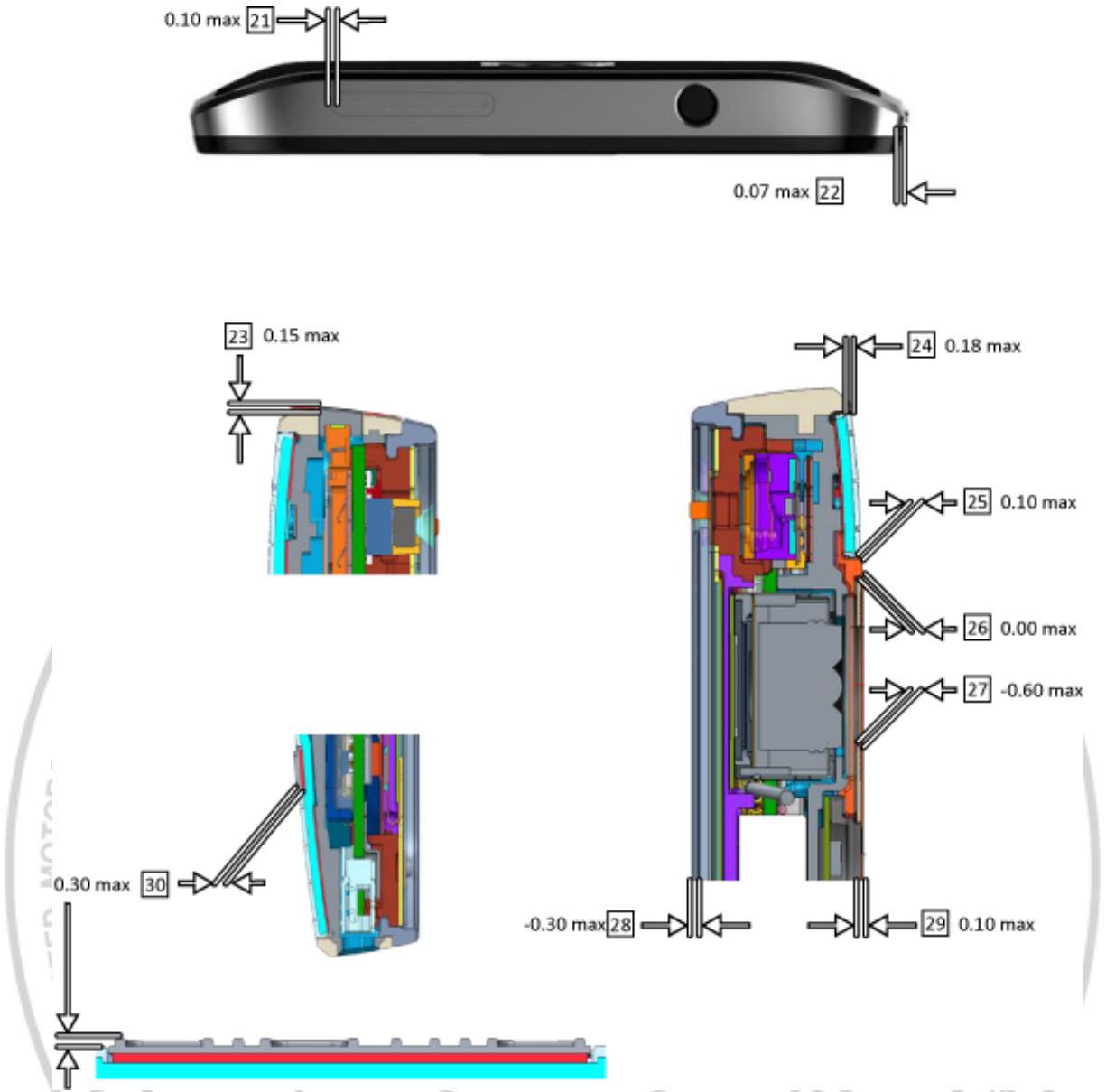
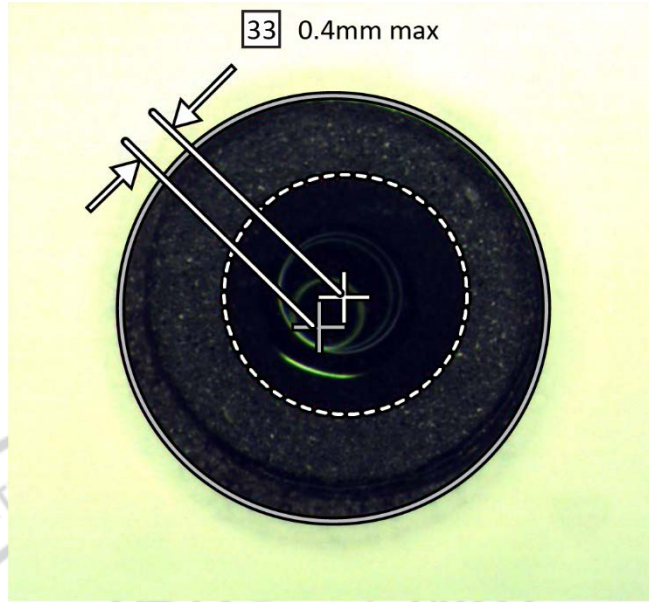


Figure 5. PSCD Top View and Cross Section View



**Figure 6. PSCD Display Alignment**



**Figure 7. PSCD Front-Facing Imager Alignment**



**Table 2. PSCD Gap Measurements**

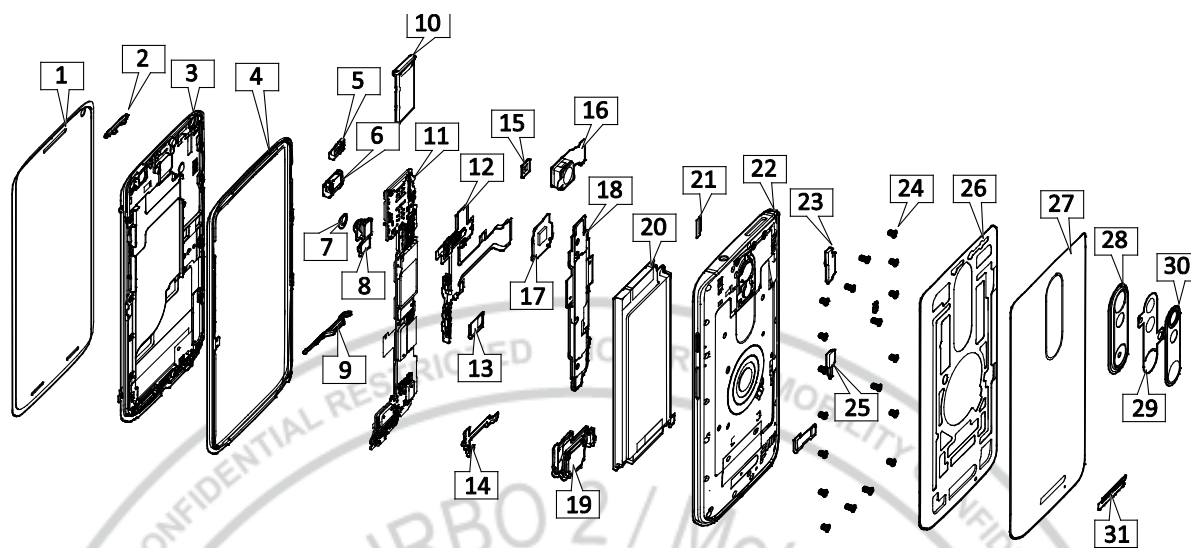
<i>Reference #</i>	<i>Description</i>
1	Front Rim Housing to Lens Liner Perimeter
2	Lens Liner to Audio Deco (Left Point) Step
3	Lens Liner to Audio Deco (Right Point) Step
4	Audio Deco Tilt (Left Point vs. Right Point) Step
5	Rear Band Housing to Rear Inlay Perimeter
6	Main Imager Center to Main Imager Lens Artwork Concentricity
7	Camera Deco M Logo Rotation
8	Power Key to Rear Band Housing Step
9	Volume Key to Rear Band Housing Step
10	Main Imager Center to Camera Deco Concentricity
11	Camera Deco to Flash Lens Perimeter
12	Rear Inlay to Rear Bezel Perimeter
13	Rear Bezel to Camera Deco Perimeter
14	Rear Inlay to Droid Logo Perimeter
15	Front Rim Housing to Rear Band Housing (Z)
16	Front Rim Housing to Rear Band Housing Step (X & Y)
17	Rear Band Housing to Power Key (Y)
18	Rear Band Housing to Power Key (Z)
19	Rear Band Housing to Volume Key (Z)
20	Rear Band Housing to Volume Key (Y)
21	Rear Band Housing to SIM Door Perimeter
22	Front Rim Housing to Rear Band Housing Step (X & Y)
23	Rear Band Housing to SIM Door Step
24	Rear Band Housing to Rear Inlay Step
25	Rear Inlay to Rear Bezel Step
26	Rear Bezel to Camera Deco Step
27	Camera Deco to Camera Lens Step
28	Front Rim Housing to Main Lens Step
29	Camera Deco to Camera Flash Lens Step
30	Rear Inlay to Droid Logo Step
31	Main Lens View Area to Display Active Area (X1-X2)
32	Main Lens View Area to Display Active Area (Y1-Y2)



<i>Reference #</i>	<i>Description</i>
33	Front-Facing Imager Center to Main Lens Artwork Center Concentricity



## Exploded Views



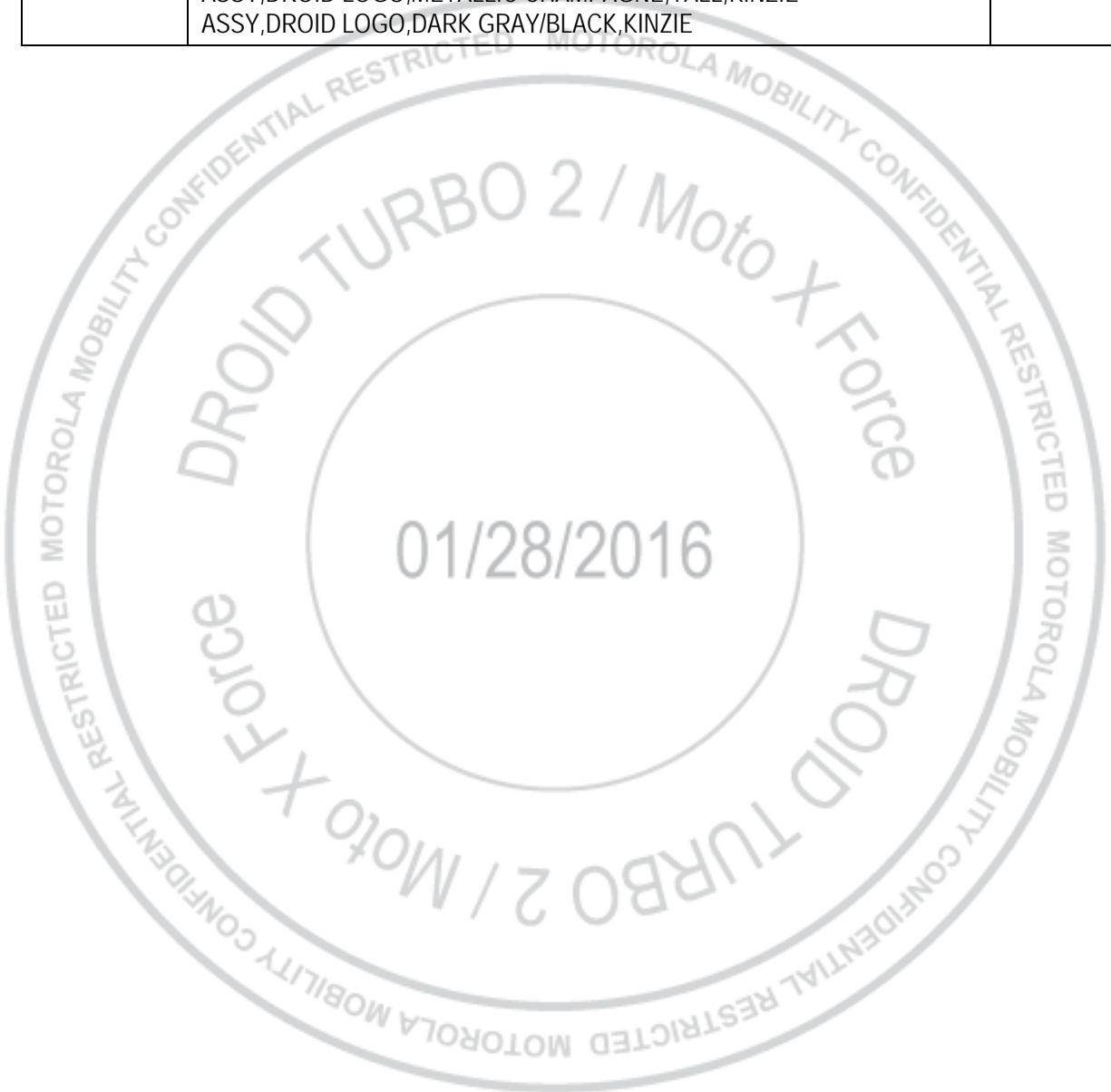
**Figure 8. Assembly Exploded View**

**Table 3. Exploded View Parts List**

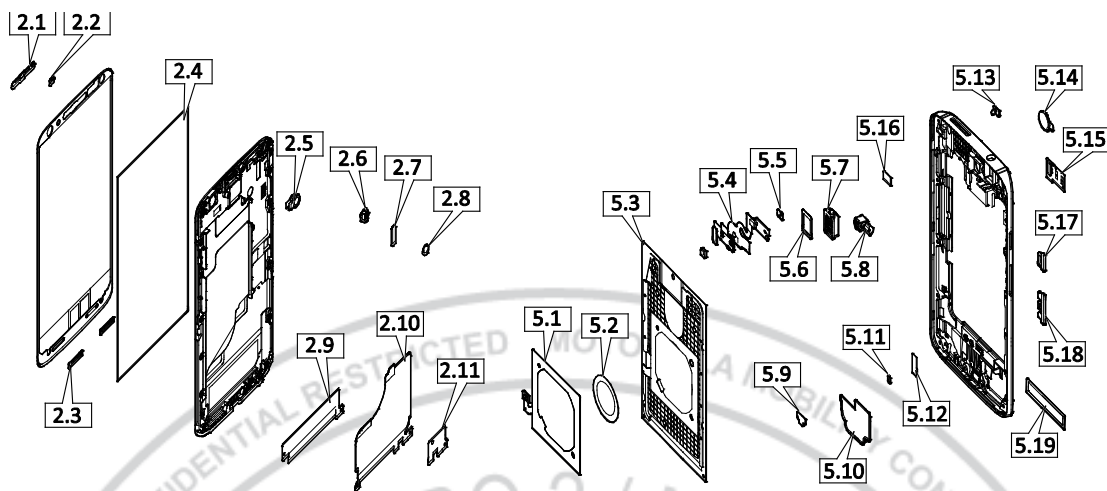
Reference #	Description	Recovery Part
1	DIE CUT,LINER,LENS,NO BRANDING	NO
2	ASSY,HSG,AU DECO,T&R,METALLIC RED,KINZIE (REWORK) BZL,AU DECO,METALLIC BLK (REWORK) BZL,AU DECO,METALLIC SLVR (REWORK) BZL,AU DECO,METALLIC DK GRY (REWORK) ASSY,HSG,AU DECO,T&R,METALLIC RED,KINZIE (ORIGINAL) BZL,AU DECO,METALLIC BLK (ORIGINAL) BZL,AU DECO,METALLIC SLVR (ORIGINAL) BZL,AU DECO,METALLIC DK GRY (ORIGINAL)	NO
3	ASSY,HSG,LENS W/FRONT HOUSING,PSA,BLACK,ROW,KINZIE ASSY,HSG,LENS W/FRONT HOUSING,PSA,WHITE,ROW,KINZIE	YES
4	HSG,FRNT RIM,DECORATED,BLACK HSG,FRNT RIM,DECORATED,WHITE	NO
5	GROM,SENSOR,KINZIE	NO
6	TRANSDUCER,OTHR,6X12X3,6X12X3MM RCVR F0=200HZ, AAC	NO
7	SEAL,O-RING,FRONT IMGR	NO
8	ASSY,FLXCKT,5MP IMAGER,KINZIE	YES
9	CABLE,COAX	YES

Reference #	Description	Recovery Part
10	ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,DARK MTLC GRAY, KINZIE ASSY,HSG,SIM DOOR,FULL FLOOR TRAY,LIGHT ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,METALLIC DK GRAY ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,METALLIC SILVER,KI ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,METALLIC CHAMPAGNE ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,RED,KINZIE	YES
11	ASSY,PWA,MN,BOUNCE VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	YES
12	ASSY,PWA,TOP,HSJ,VIBRATOR,KINZIE	YES
13	DIE CUT,ADHESIVE,PCB-CHASSIS	NO
14	ASSY,FLXCKT,IR LED,KINZIE	YES
15	PAD,CONDUCTIVE,FRONT IMGR	NO
16	ASSY,FLXCKT,CAMERA,REAR FACING 21MP IMAGER,KINZIE	YES
17	DIE CUT,ADHES,COP TAPE,PM8994	NO
18	ASSY,CHAS,REAR,KINZIE	YES
19	TRANSDUCER,POLYPHONIC,13X18X2P5	NO
20	ASSY,BAT,LI POLY,FB55,3760MAH,LG CHEM	YES
21	PAD,CONDUCTIVE,FRONT IMGR	NO
22	ASSY,HSG,REAR,METALLIC DK GRY ASSY,HSG,REAR,TIN SILVER,KINZIE ASSY,HSG,REAR,CHAMPAGNE,KINZIE ASSY,HSG,REAR,RED,KINZIE	YES
23	ASSY,HSG,STOPPER,EARPIECE/FLASH,KINZIE	YES
24	SCR,MACH,M1.4	NO
25	ASSY,HSG,STOPPER,NFC CONN	YES
26	DIE CUT,ADHESIVE,INLAY,REAR COVER	NO
27	ASSY,HSG,INLAY,CSR,BLACK,REAR COVER,ROW ASSY,HSG,INLAY,CSR,WINTER WHITE,REAR COV ASSY,HSG,INLAY,NYLON,BLACK,REAR CVR ASSY,HSG,INLAY,NYLON,BLACK,ROW,REAR CVR ASSY,HSG,INLAY,NYLON,GRAY,ROW,REAR CVR	YES
28	BZL,DECO,REAR,METALLIC DK GRY BZL,DECO,REAR,METALLIC SLVR BZL,DECO,REAR,METALLIC RED	YES

<i>Reference #</i>	<i>Description</i>	<i>Recovery Part</i>
29	DIE CUT,ADHES,CAMERA,DECO	NO
30	ASSY,CAMR DECO,METALLIC SLVR ASSY,CAMR DECO,METALLIC DK GRY ASSY,CAMR DECO,METALLIC CHMPGN ASSY,CAMR DECO,BLACK	YES
31	ASSY,DROID LOGO,DARK MTLC GRAY,KINZIE ASSY,DROID LOGO,DARK MTLC SILVER,KINZIE ASSY,DROID LOGO,METALLIC CHAMPAGNE,TALL,KINZIE ASSY,DROID LOGO,DARK GRAY/BLACK,KINZIE	NO



**Figure 9. Subassembly Exploded View**



**Table 4. Subassembly Exploded View Parts List**

Reference #	Description	Recovery Part
2.1	SCRN,MESH,EARPIECE, TOP	NO
2.2	SCRN,MESH,MIC5	NO
2.3	SCRN,MESH,METAL,BOTTOM,BLACK,KINZIE SCRN,MESH,METAL,BOTTOM,SILVER,KINZIE	NO
2.4	PAD,HT SPREADER,DISPLAY TO CHAS	NO
2.5	ASSY,HSG,FRNT FLSH LENS,KINZIE ASSY,HSG,FRNT FLSH LENS,WHITE,KINZIE	NO
2.6	GROM,SEAL,MIC 5	NO
2.7	PAD,CONNECTOR,REAR IMGR	NO
2.8	PAD,CUSHION,COAX CBL	N
2.9	DIE CUT,KAPTON TAPE,FRONT CHASSIS,3.2MM X 22.5MM	NO
2.10	DIE CUT,ADHES,CONDUCTIVE,DISPLAY FLX	NO
2.11	SCRN,MESH,MIC 1&4	NO
5.1	FLX,NFC,WLC	NO
5.2	SPCR,WLC COIL	NO
5.3	ASSY,HSG,REAR,ENDO,KINZIE	YES
5.4	ASSY,FLXCKT,AU	NO
5.5	SCRN,MESH,MIC 2,CORE	NO
5.6	SEAL,HSET JCK	NO
5.7	CONN,JACK,HEADSET,3.5 MM DIA	YES

**DROID TURBO 2 / Moto X Force**

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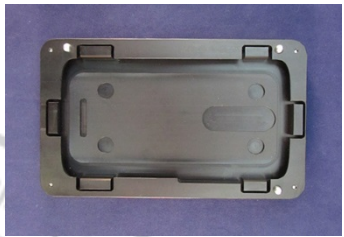


<i>Reference #</i>	<i>Description</i>	<i>Recovery Part</i>
5.8	ALERT DEVICE,VIBR,MOTOR, ROTARY, 11.75 MM X X 4.55 MM MOTOR BODY	YES
5.9	USB PAD	NO
5.10	DIE CUT,ADHES,LOUD	NO
5.11	PLT,METAL,ANTENNA,FEED,X+1	NO
5.12	SCRN,MESH,MIC3	NO
5.13	SCRN,MESH,MYLAR,MIC2,CAV	NO
5.14	LENS,IMAGER,REAR	NO
5.15	ASSY,FLXCKT,FLASH,BOUNCE	NO
5.16	PAD,CONNECTOR, FRNT IMGR	NO
5.17	BTN,POWER,GRAPHITE GRAY,KINZIE	YES
5.18	BTN,VOLUME,GRAPHITE GRAY,KINZIE	YES
5.19	SEAL,32014943 MYLAR, BV-REV_A	NO

01/28/2016

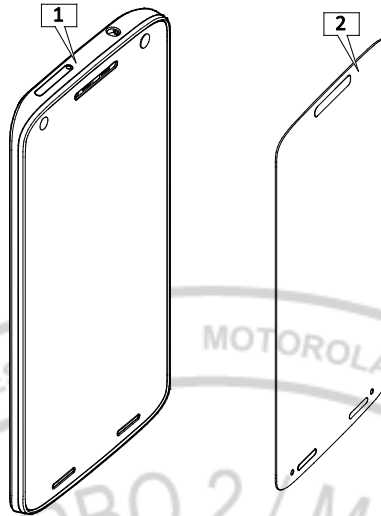
# DLN LINER REPLACEMENT

## Tools Required for DLN Liner Replacement

The following tools are required to replace the DLN Liner on the DROID TURBO 2 / Moto X Force phone.

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Bounce Lens Liner Alignment Fixture	3-00-E3-10000	
Lens Liner Roller		
Lens Removal Pick Tool	3-00-E4-10000	
Kimwipes	01018766001W	--
Alpha Dry Wipes	01018765001W	--
Compressed Air Spray Can	--	--
Gloves or Finger Collets	--	--

## MASC Procedure



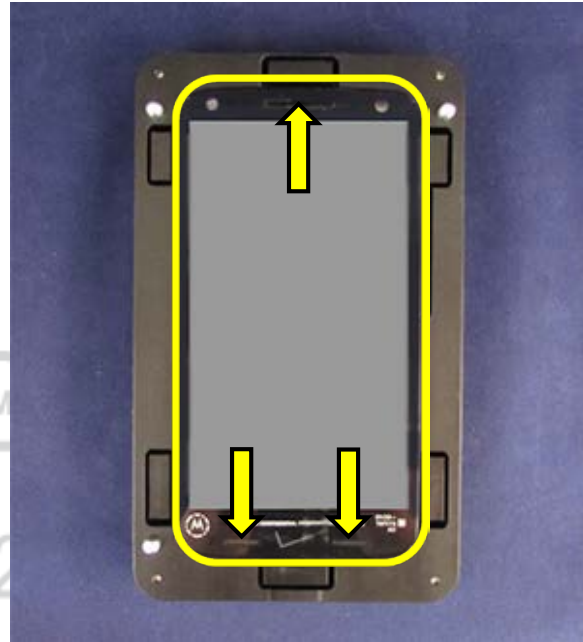
<i>Description</i>	<i>Reference #</i>
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,KINZIE ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,KINZIE	1
DIE CUT,LINER,LENS,NO BRANDING	2

1. Place the phone in the Bounce Lens Liner Alignment Fixture (3-00-E3-10000).





2. Place the alignment lid on the fixture.
3. Spray the Display and all 3 audio ports with compressed air to remove any dust or foreign material.



4. Use the Lens Removal Pick Tool (3-00-E4-10000) to lift the corner of the old DLN Liner, and then peel it off the Display.



5. Wipe the Display with a Kimwipe in a clockwise motion and remove any lint or dust.

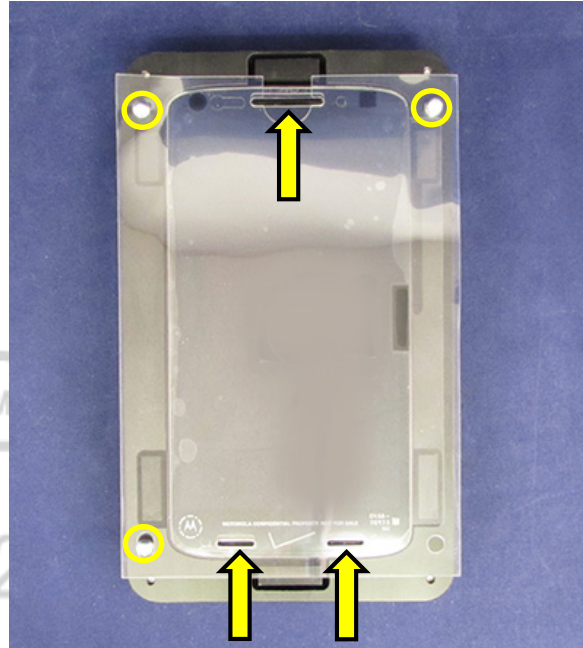


6. Wipe the Display with an Alpha Dry Wipe in a counterclockwise motion.

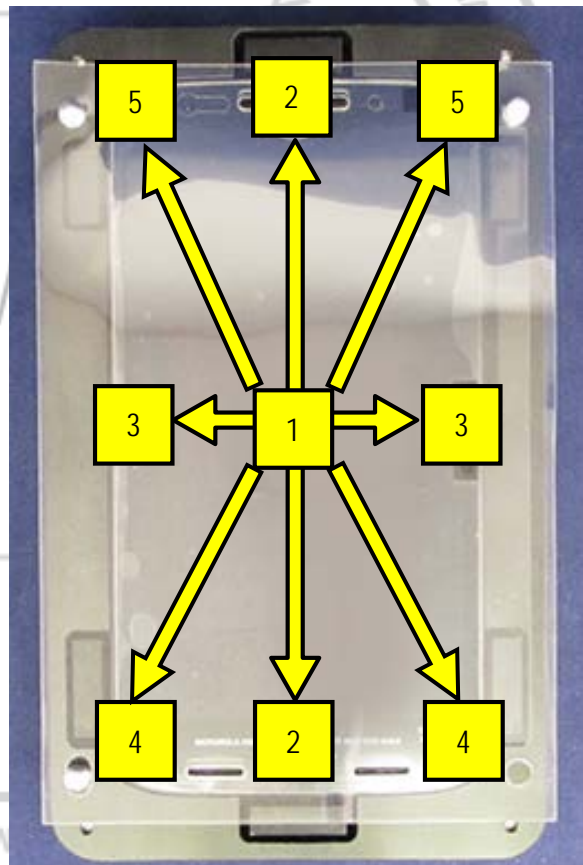


7. Spray the Display with compressed air to remove any dust or foreign material.
8. Verify the Display is free of lint, dust, or any other foreign material.

9. Remove the adhesive liner from the DLN Liner.
10. Place the DLN Liner into the fixture over the Display, using the pins in the fixture and the 3 audio ports and the 3 pins to align it.



11. Use the Lens Liner Roller or Lens Removal Pick Tool to apply manual pressure to the DLN Liner as follows:
  - Place the roller or pick on point 1 and slide out to point 2.
  - Place the roller or pick on point 1 and slide out to point 3.
  - Place the roller or pick on point 1 and slide out to point 4.
  - Place the roller or pick on point 1 and slide out to point 5.



12. Remove the top liner from the DLN Liner.
13. Remove the phone from the fixture.
14. Use the roller or pick to press out any remaining air bubbles.

**NOTE**

Small air bubbles will disappear over the next 48 hours.



## Customer Procedure

1. Power off the phone.
2. Use the Lens Removal Pick Tool to lift the corner. Then, peel off the lens.



3. Use the wet cloth, then dry cloth. Make sure there's no lint or dust left.



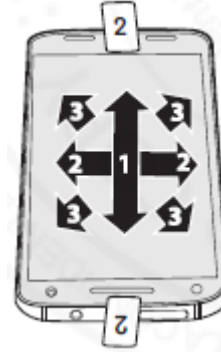
4. Pull tab 1 to remove the back cling.



5. Carefully align the new lens using the audio ports as guides.



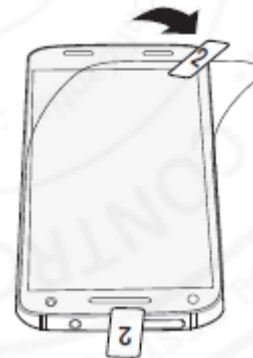
6. Press and drag down, then across the center. Wait 15 seconds, then press outward from the center.



7. Pull tab 2 to remove the top cling. Wait 24 hours and press out any remaining air bubbles.

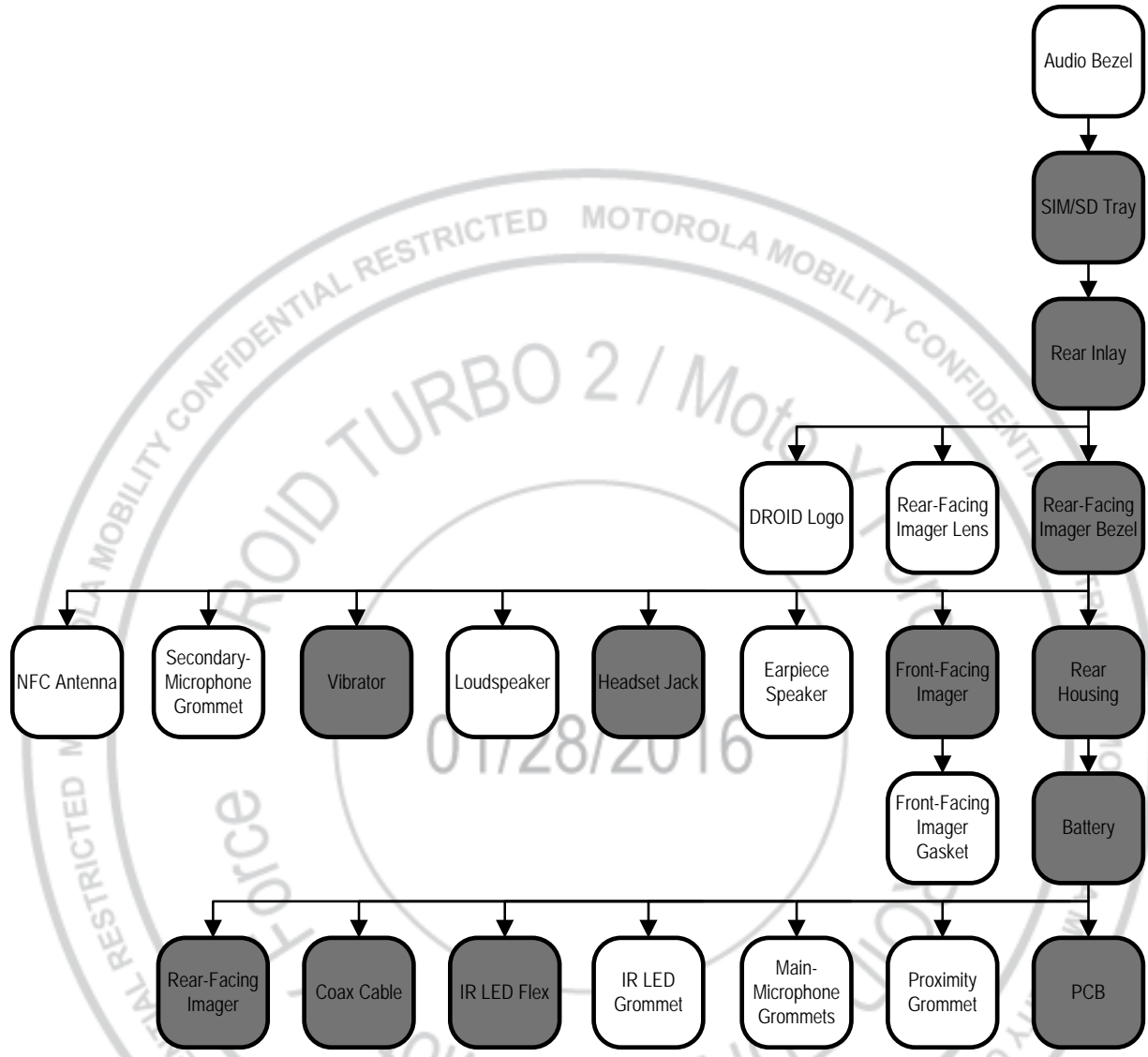
**NOTE**

Use the tool to gently press down any air pockets. Small air bubbles may disappear over the next 48 hours.



# DISASSEMBLY AND RECOVERY

## Disassembly and Recovery Map



\*Shaded parts may be eligible for parts recovery.

## Tools Required for Disassembly

The following tools are required to disassemble the DROID TURBO 2 / Moto X Force phone.

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Bounce Inlay Heating Plate	3-00-F5-10000	
"7x7" Hot Plate*	4-00-Z2-10000 (220V) / 4-00-Z3-10000 (110V)	
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	--	--

\*Hot Plates 4-00-Z2-10000 and 4-00-Z3-10000 are identical tools. The only difference is the voltage rating. Either the 220V 4-00-Z2-10000 or the 110V 4-00-Z3-10000 can be used with the Bounce Inlay Heating Plate (3-00-F5-10000).



## SIM/SD Tray Removal

### NOTE

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

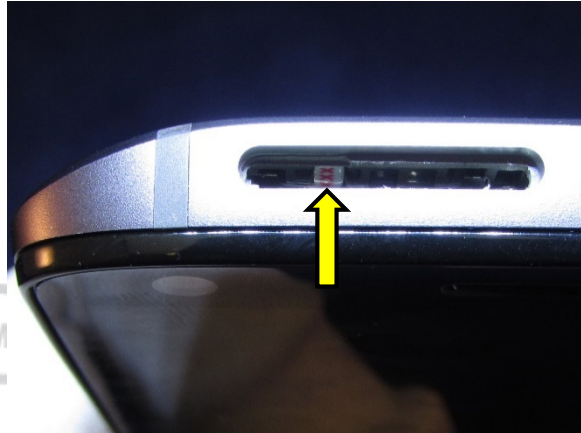


1. Insert the SIM Tray Removal Tool into the SIM/SD Tray hole.
2. Push the SIM Tray Removal Tool into the SIM/SD Tray hole until the SIM/SD Tray ejects from the phone.
3. Remove the SIM/SD Tray from the phone.



## Water Detection Label Inspection

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

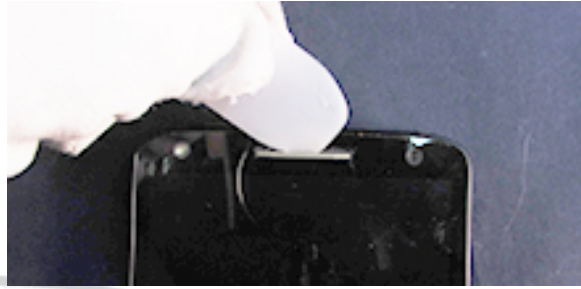


## Audio Deco Removal

Use the Thin Plastic Spudger to pry the Audio Bezel from the Display.

### NOTE

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



## Rear Inlay Removal

### NOTE

The Rear Inlay can be recovered and reused after removal.



1. Place the Bounce Inlay Heating Plate (3-00-F5-10000) on the Hot Plate.
2. Set the Hot Plate to 80 °C (176 °F).

### // CAUTION //

Do not set the Hot Plate temperature higher than 80 °C (176 °F). Damage to the phone may occur.

3. Wait 10-15 minutes for the Hot Plate to warm up.
4. Place the phone in the plate, with the Display side face up.
5. Wait 5-10 minutes for the Rear Inlay to warm up.
6. Remove the phone from the plate.

### // CAUTION //

Wear protective gloves when handling heated phones.

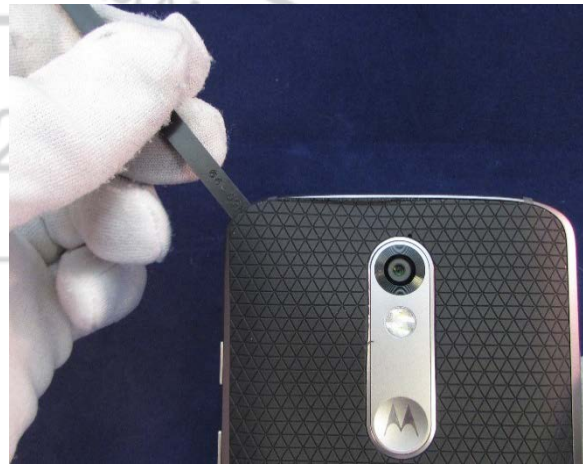
7. Insert the Thin Plastic Spudger at a 90° angle between the Rear Inlay and Rear-Facing Imager Bezel.



- Slide the Thin Plastic Spudger under the Rear Inlay at an angle towards the corner nearest the SIM/SD Tray slot. Slide the Spudger towards the corner until the corner of the Rear Inlay lifts from the Rear Housing.



- After the corner of the Rear Inlay is lifted from the Rear Housing, insert the flat end of the Blackstick between the Rear Inlay and Rear Housing.



- Slide the Blackstick around the perimeter of the Rear Inlay to separate the adhesive from the Rear Housing.

**// CAUTION //**

Do not insert the Blackstick in the indicated area.



11. Lift the Rear Inlay from the Rear Housing.



## Rear-Facing Imager Bezel Removal

### NOTE

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



Use the Blackstick to push the Rear-Facing Imager Bezel out of the Rear Inlay.

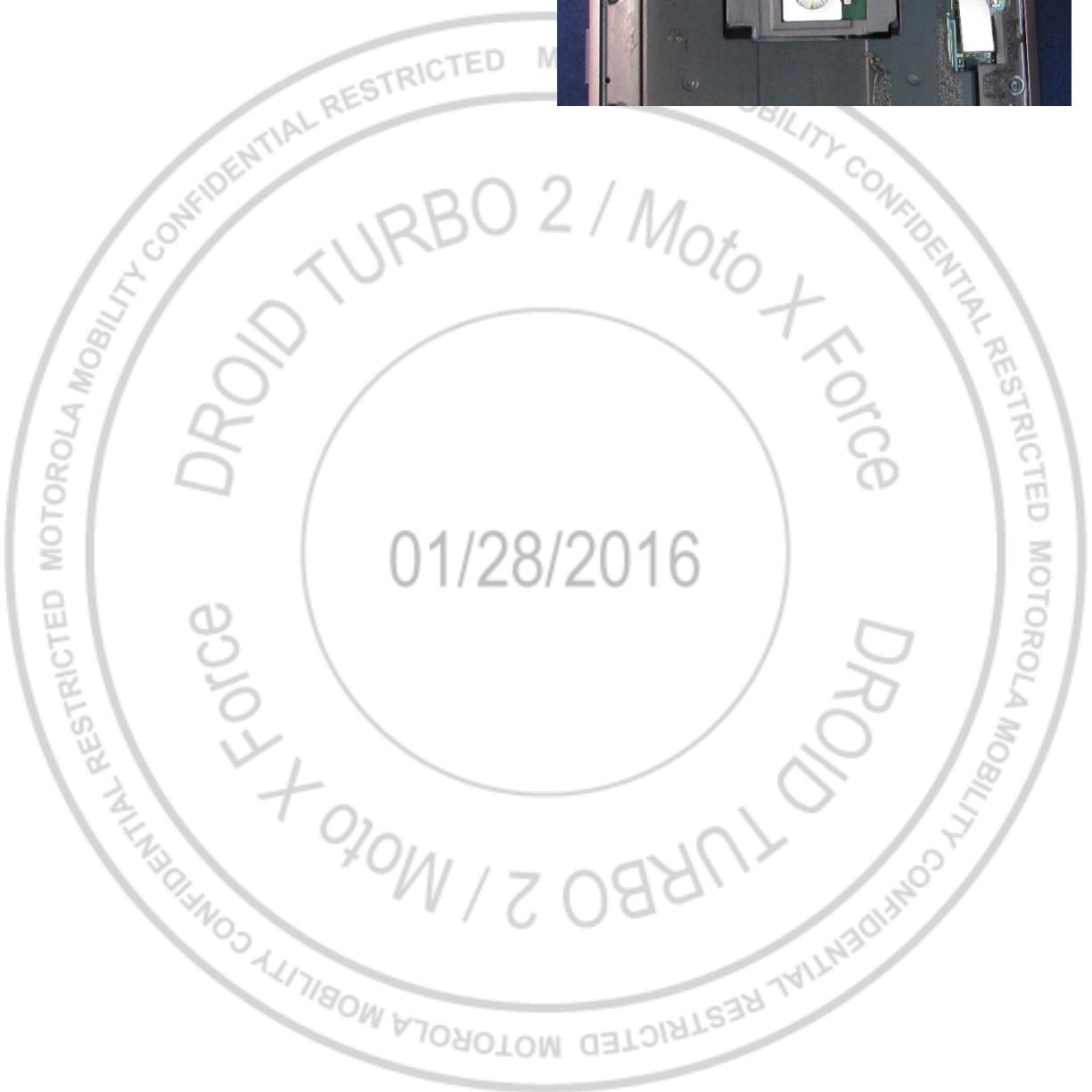
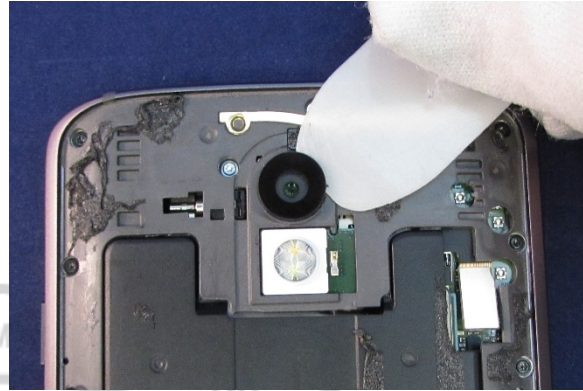


## Rear-Facing Imager Lens Removal

Use the Thin Plastic Spudger to pry the Rear-Facing Imager Lens from the Rear Housing.

### NOTE

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





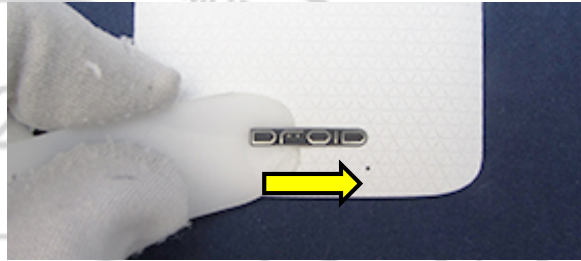
## DROID Logo Removal

### NOTE

After you remove the DROID Logo, you cannot reuse it.



1. Bend the bottom left corner of the Rear Inlay until the left edge of the DROID Logo lifts from the Rear Inlay.
2. Slide the Thin Plastic Spudger under the left edge of the DROID Logo. Slide the Spudger towards the right edge of the Logo until it lifts from the Rear Inlay.



## Rear Housing Removal

### NOTE

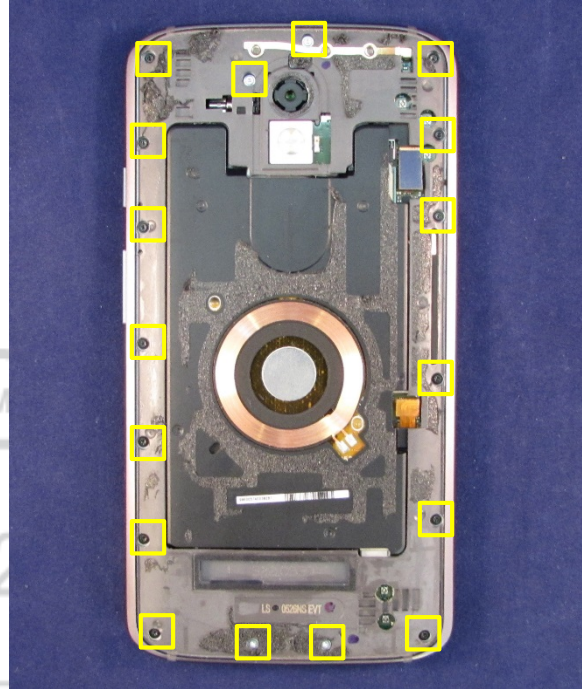
The Rear Housing can be recovered and reused after removal.



1. Use the flat end of the Blackstick to remove the NFC Flex Stopper.
2. Use the flat end of the Blackstick to disconnect the NFC Flex BtB Connector from the PCB.
3. Use the pointed end of the Blackstick to remove the Earpiece Flex Stopper.
4. Use the flat end of the Blackstick to disconnect the Earpiece Flex BtB Connector from the PCB.



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



6. Press and hold the Power Key and Volume Key.

**NOTE**

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

7. Lift the side of the Rear Housing opposite the Side Keys to remove it from the phone.



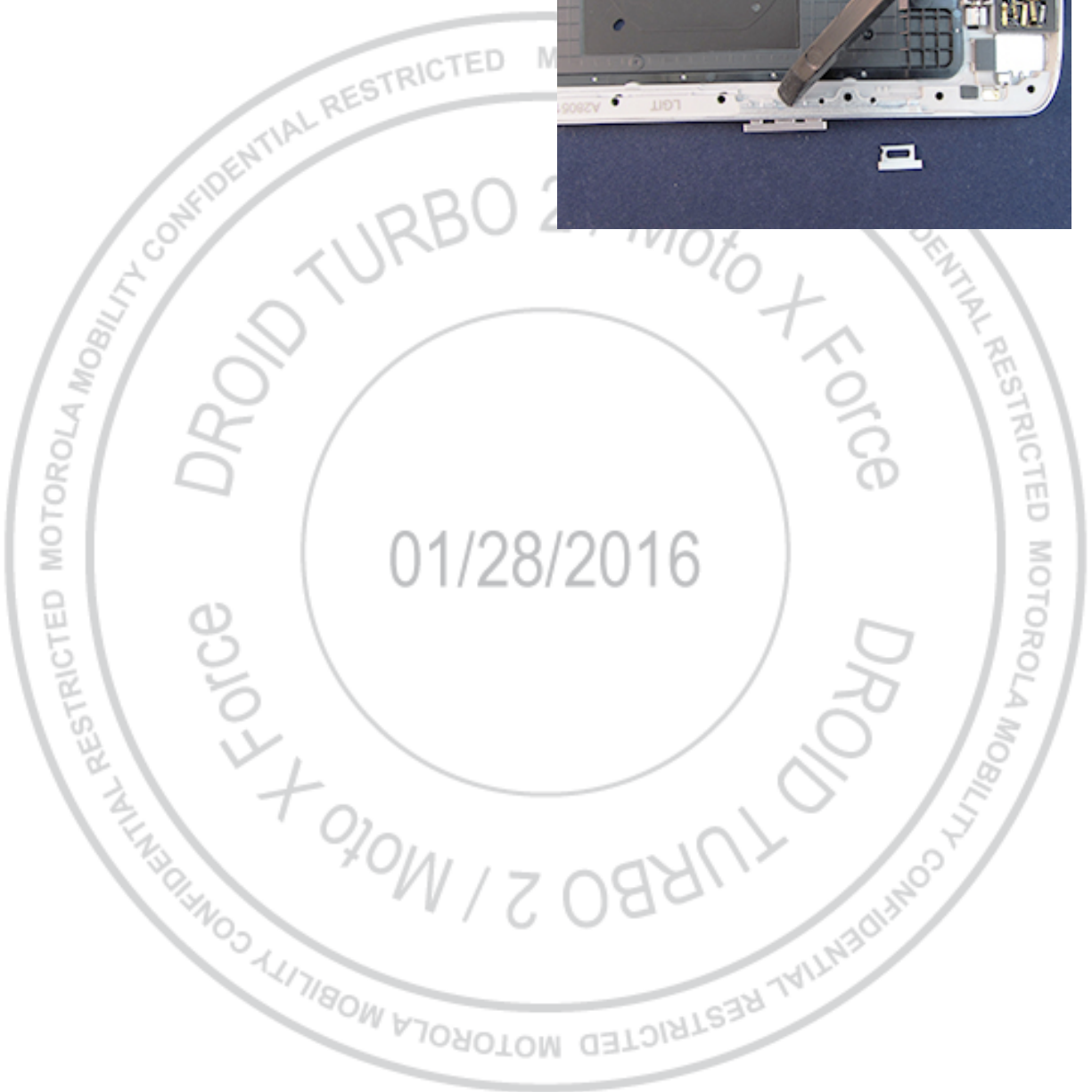
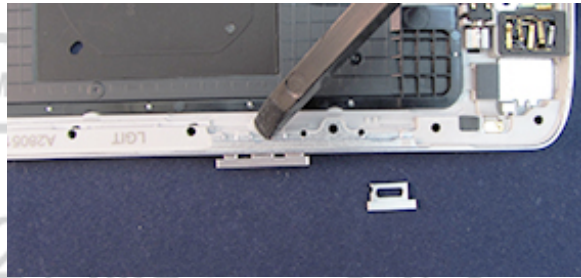
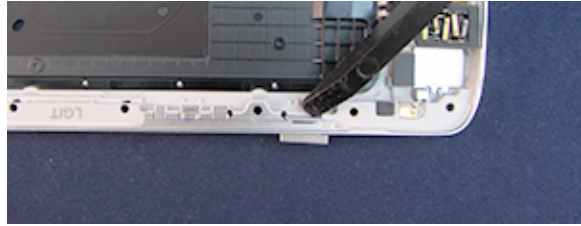
## Side Key Removal

### NOTE

The Side Keys can be recovered and reused after removal.



Use the flat end of the Blackstick to remove the Power Key and Volume Key from the Rear Housing.



## Battery Disconnection

### /// 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.

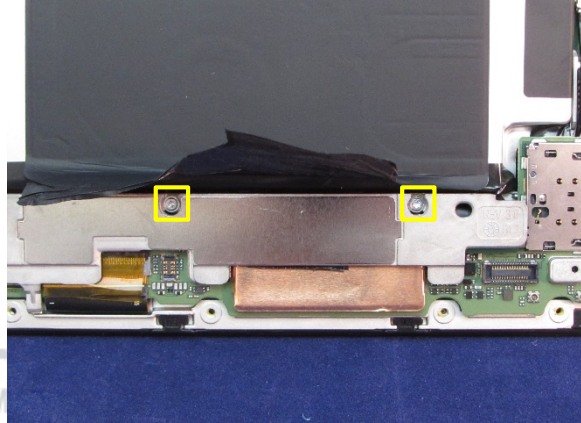
Prior to assembly, ensure Battery edges and surfaces are not dented or deformed, and that fixtures and parts that will contact the Battery are free of foreign material.

Ensure screws and screwdrivers do not contact the Battery.

1. Lift the Heat Spreader from the Chassis.



2. Remove the 2 3IP Screws from the Chassis.



3. Lift the Chassis from the phone.

**NOTE**

The Chassis can be recovered and reused after removal.



4. Use the flat end of the Blackstick to disconnect the Battery Flex BtB Connector from the PCB.



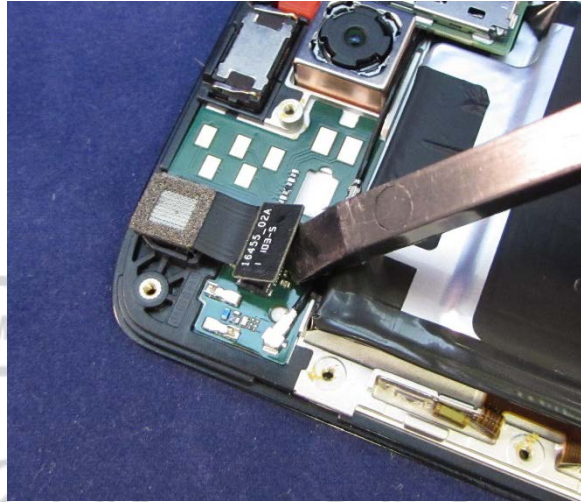
## Front-Facing Imager Removal

### NOTE

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



1. Use the flat end of the Blackstick to disconnect the Front-Facing Imager BtB Connector.
2. Lift the Front-Facing Imager out of the pocket of the Display.



## 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.



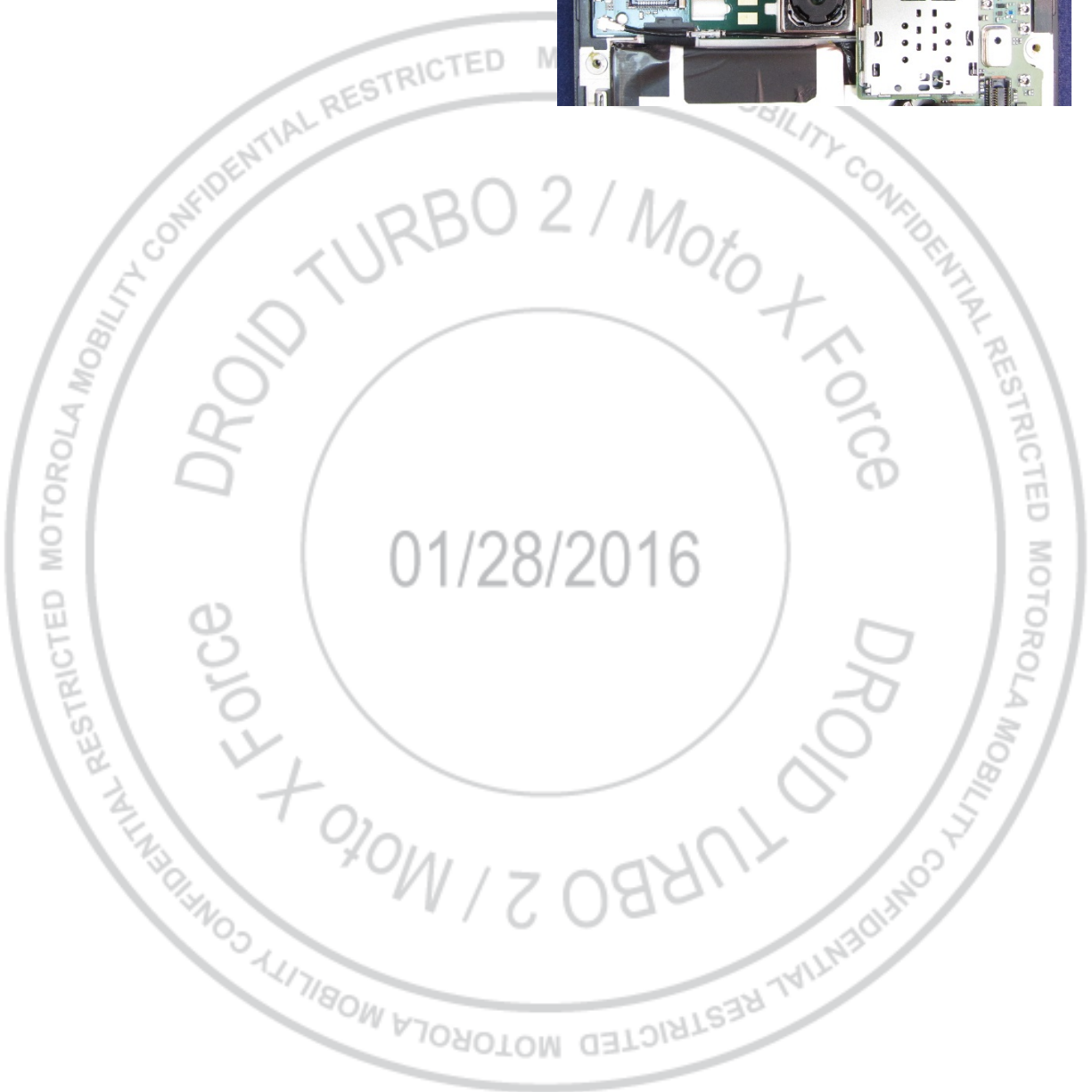
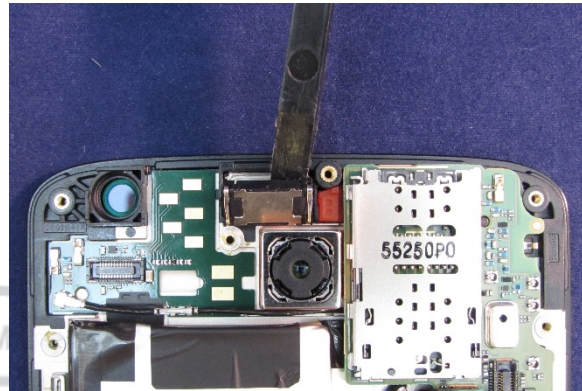


## Earpiece Speaker Removal

Use the flat end of the Blackstick to pry the Earpiece Speaker out of the pocket of the Display.

### NOTE

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

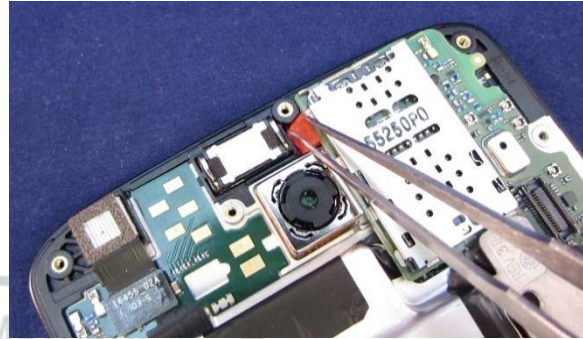


## Secondary-Microphone Grommet Removal

Use the Tweezers to remove the Secondary-Microphone Grommet from the Display.

### NOTE

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



## 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.

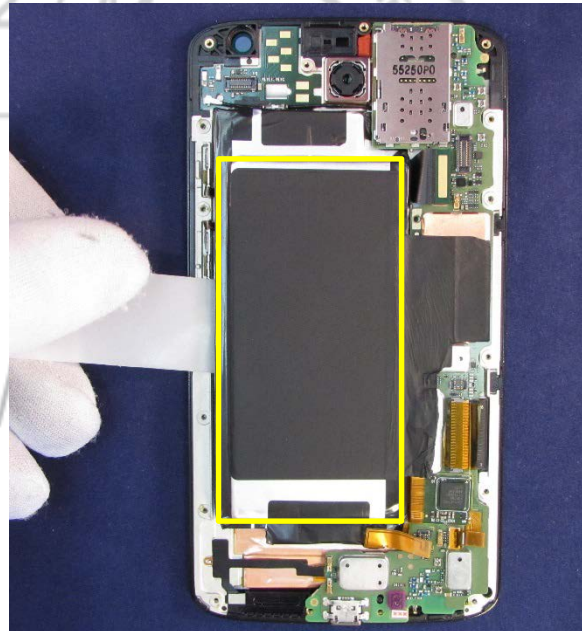
Ensure screws and screwdrivers do not contact the Battery.

### NOTE

The Battery can be recovered and reused after removal.



1. Slide the Thin Plastic Spudger between the Battery and Display in the highlighted area to separate the Battery Adhesive.
2. After the Battery Adhesive is separated from the Display, lift the Battery from the Display.
3. If the Battery Adhesive remains attached, use the Battery Pull Tab to aid in separating the Battery from the Display.



## PCB Removal

### NOTE

The PCB can be recovered and reused after removal.



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

### NOTE

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

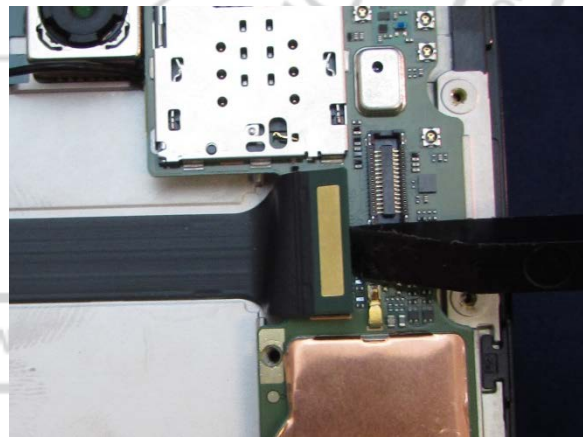
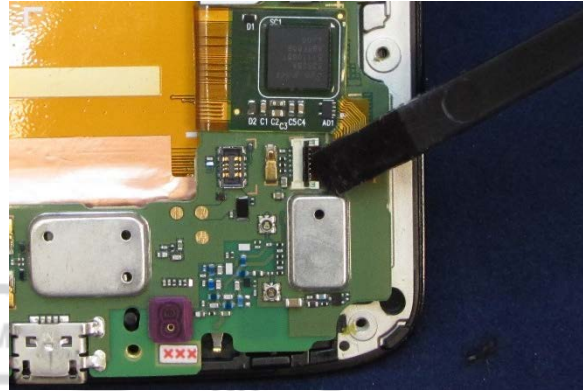


2. Use the flat end of the Blackstick to open the Touch Flex ZIF Connector Door.
3. Remove the Touch Flex from the connector.
4. Use the Thin Plastic Spudger to separate the Touch Flex from the PCB.

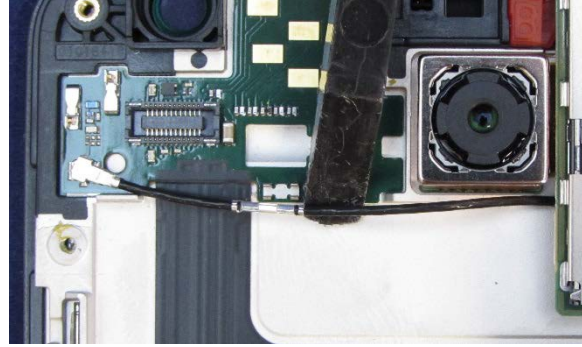
### // CAUTION //

Use caution when lifting the Touch Flex from the PCB. Damage to the Touch Flex may occur.

5. Use the flat end of the Blackstick to disconnect the Side-Key Flex BtB Connector.



6. Use the flat end of the Blackstick to lift the Coax Cable from the retaining clips.



7. Use the flat end of the Blackstick to disconnect the Coax Cable from the PCB.



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

**NOTE**

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



9. Use the flat end of the Blackstick to open the Display Flex ZIF Connector Door.
10. Remove the Display Flex from the connector.
11. Lift the PCB from the Display.

**// CAUTION //**

Do not damage the Display Flex, Touch Flex, or Coax Cable when removing the PCB.



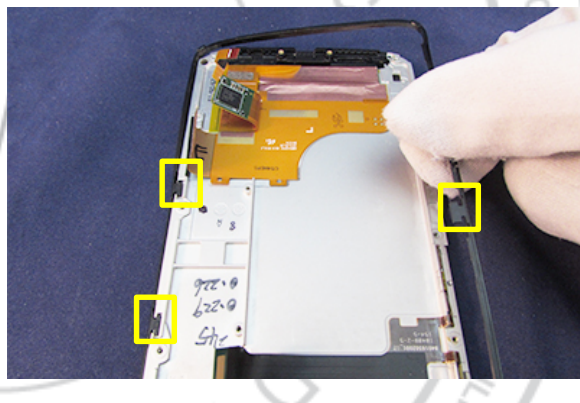
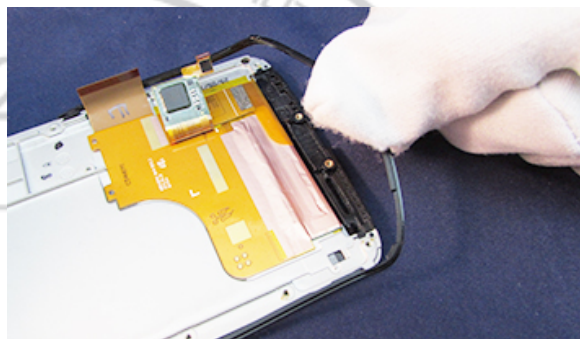
## Trim Ring Removal

### NOTE

The Trim Ring can be recovered and reused after removal.



1. Use the flat end of the Blackstick to pry the Trim Ring away from the recess on the bottom side of the Display.
2. Lift the two corners of the Trim Ring away from the bottom of the Display.
3. Continue lifting the Trim Ring away from both sides of the Display to disengage the 3 snaps.
4. Lift the Trim Ring away from the Display.



## IR LED Flex Removal

### NOTE

The IR LED Flex can be recovered and reused after removal.



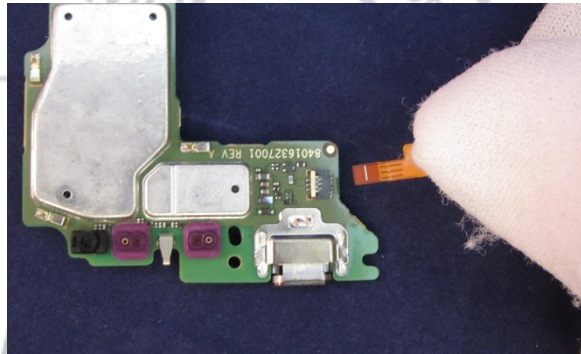
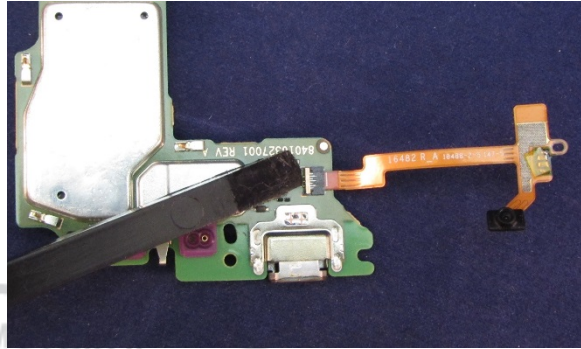
1. Use the Tweezers to remove the Kapton Tape from the IR LED Flex ZIF Connector.

### NOTE

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



2. Use the flat end of the Blackstick to open the IR LED Flex ZIF Connector door.
3. Remove the IR LED Flex from the connector.

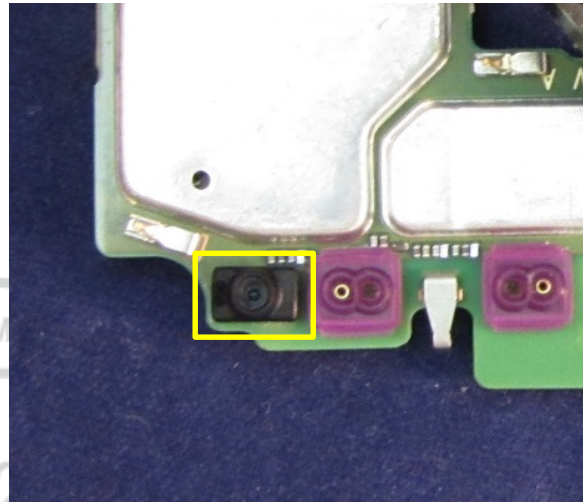


## IR LED Grommet Removal

Use the Tweezers to remove the IR LED Grommet from the PCB.

### NOTE

After you remove the IR LED Grommet, you cannot reuse it.





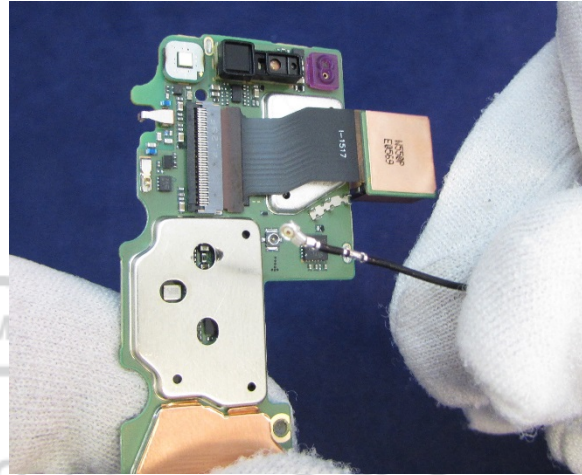
## Coax Cable Removal

### NOTE

The Coax Cable can be recovered and reused after removal.



Pull up on the Coax Cable to disconnect it from the PCB.



## Rear-Facing Imager Removal

### NOTE

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



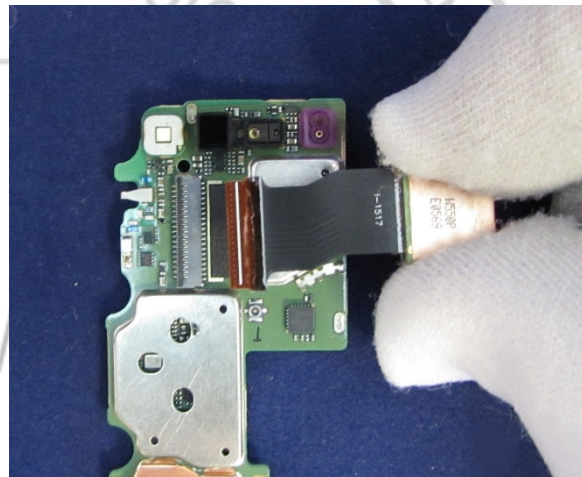
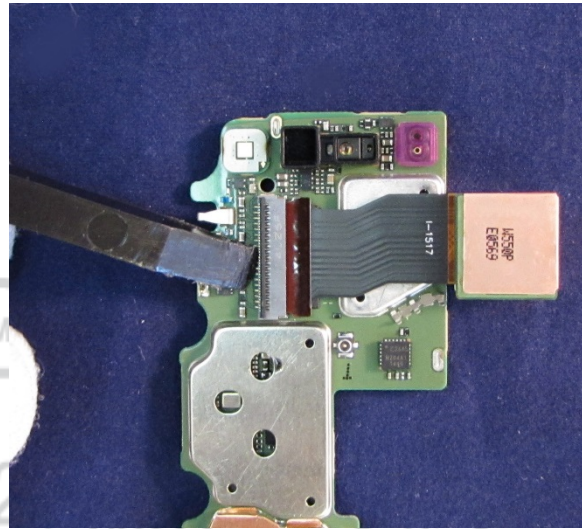
1. Use the Tweezers to remove the Kapton Tape from the Rear-Facing Imager ZIF Connector.

### 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.

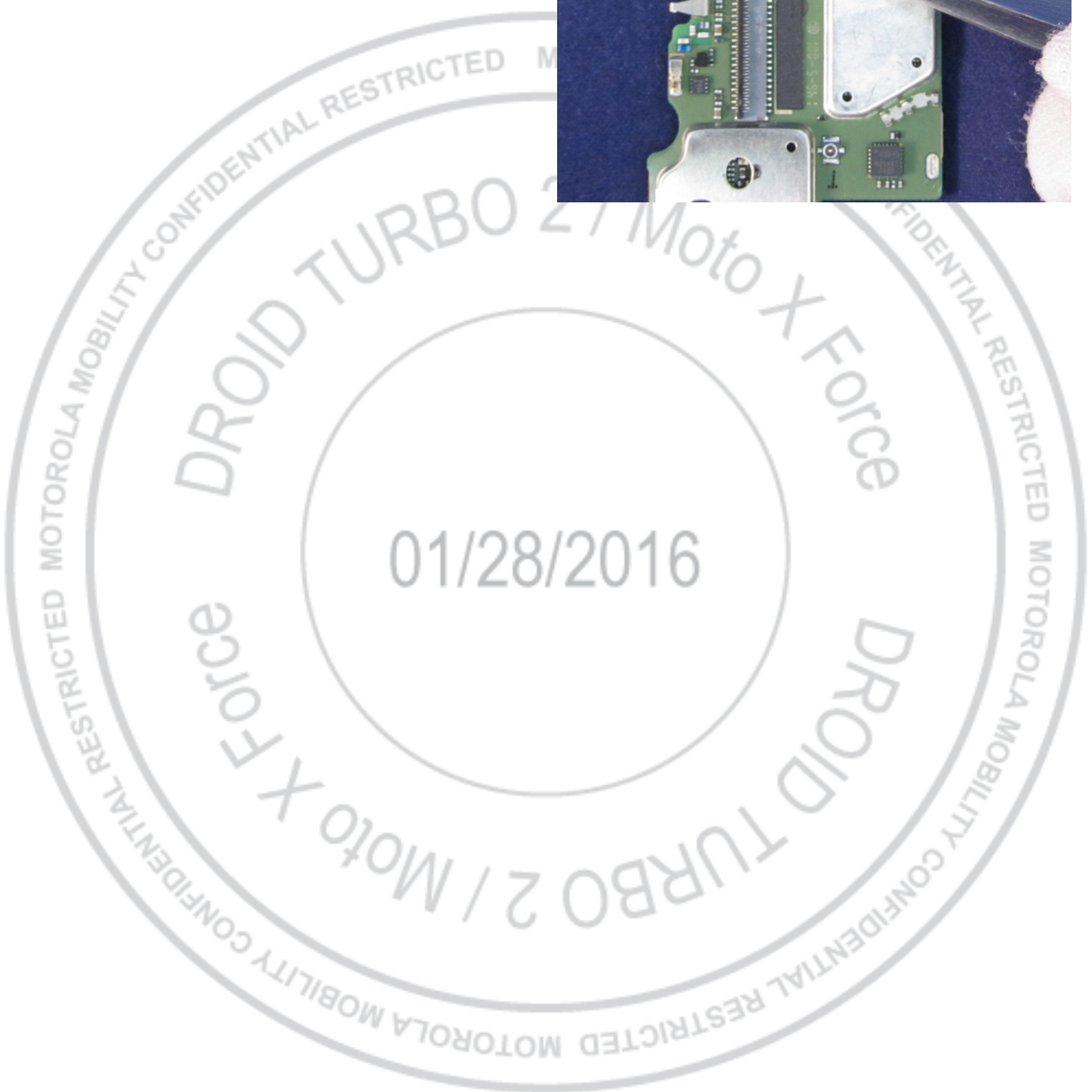


## Proximity Grommet Removal

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

### NOTE

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

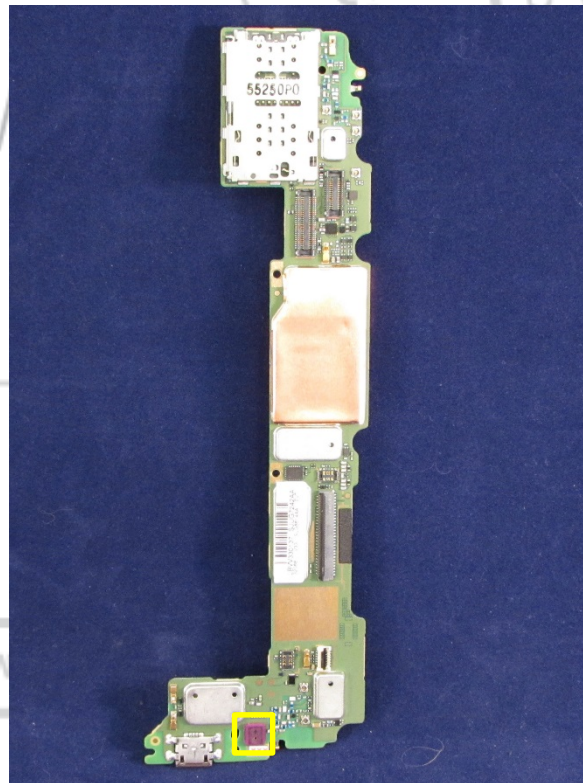
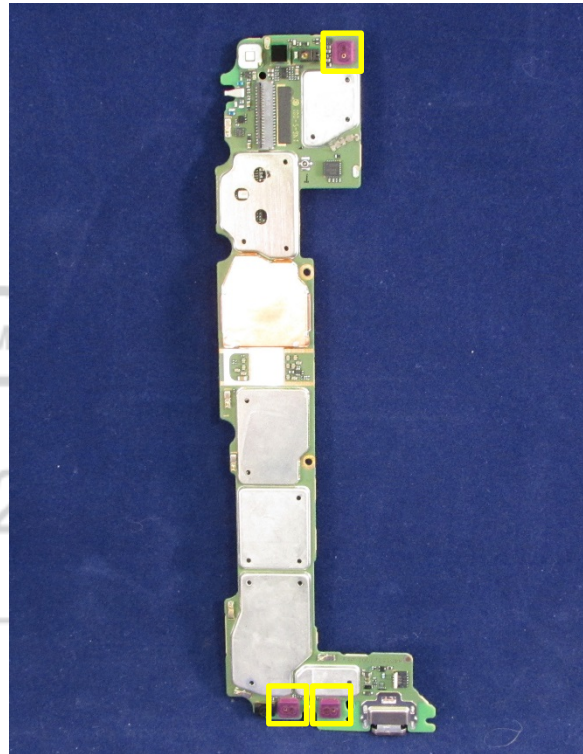


## Microphone Grommet Removal

Use the Tweezers to remove the 4 Microphone Grommets from the PCB.

### NOTE

After you remove the Microphone Grommets, you cannot reuse them.



## Loudspeaker Removal

Use the flat end of the Blackstick to pry the Loudspeaker from the Rear Housing.

### NOTE

After you remove the Loudspeaker, you cannot reuse it.



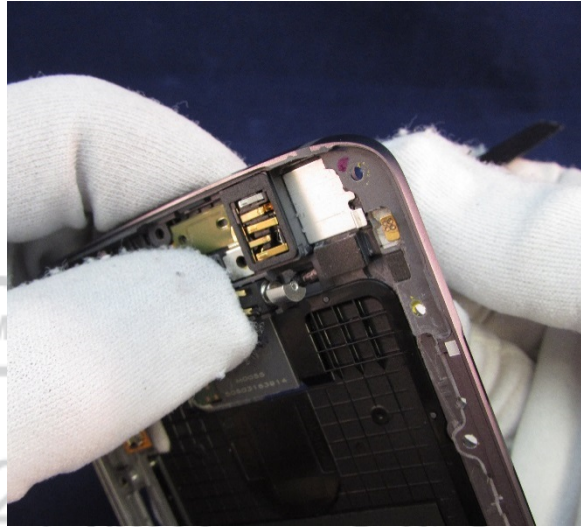
## Vibrator Removal

### NOTE

The Vibrator can be recovered and reused after removal.



1. Hold the Retaining Tab open.
2. With the Retaining Tab open, push the Vibrator out of the pocket of the Rear Housing.



## Headset Jack Removal

### NOTE

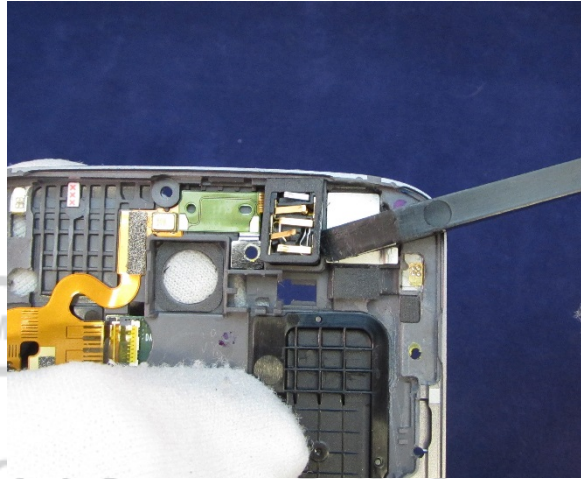
The Headset Jack and Headset Jack Gasket can be recovered and reused after removal.



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

### NOTE

The Headset Jack Gasket is adhered to and removed along with the Headset Jack.



## NFC Antenna Removal

Using both hands, push the NFC Antenna out of the Rear Housing.

### NOTE

After you remove the NFC Antenna, you cannot reuse it.





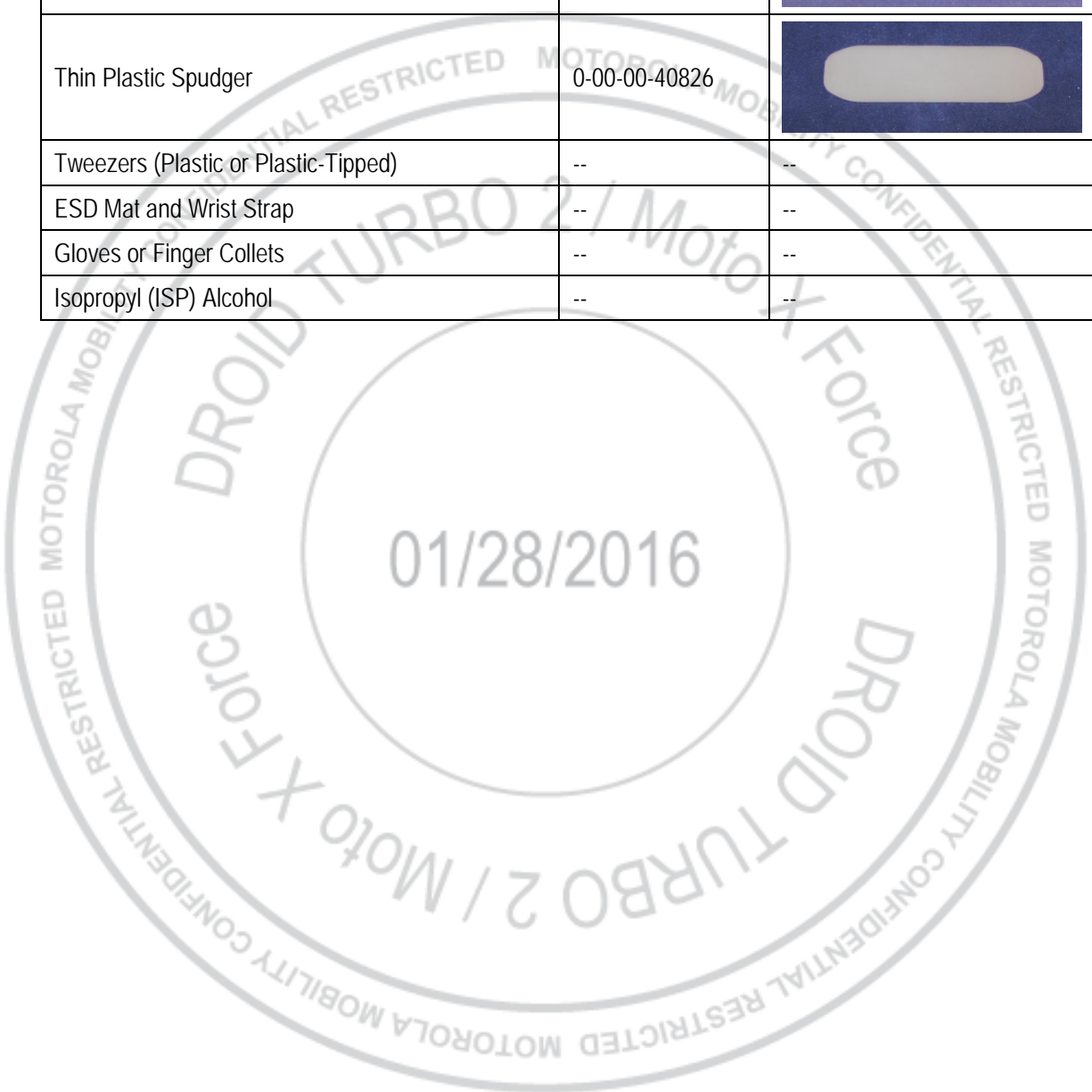


# PARTS REFRESH

## Tools Required for Parts Refresh

The following tools are required for parts refresh of the DROID TURBO 2 / Moto X Force phone.

<i>Description</i>	<i>Part #</i>	<i>Image</i>
Blackstick	--	
Thin Plastic Spudger	0-00-00-40826	
Tweezers (Plastic or Plastic-Tipped)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--
Isopropyl (ISP) Alcohol	--	--



## 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.

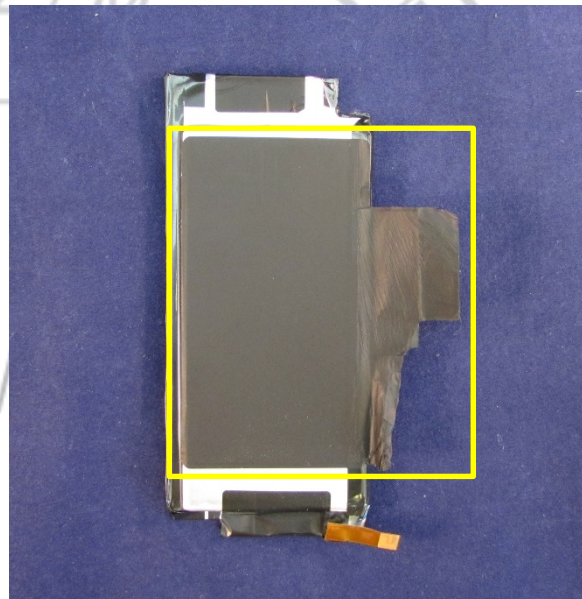
Prior to assembly, ensure Battery edges and surfaces are not dented or deformed, and that fixtures and parts that will contact the Battery are free of foreign material.

Ensure screws and screwdrivers do not contact the Battery.

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

### // CAUTION //

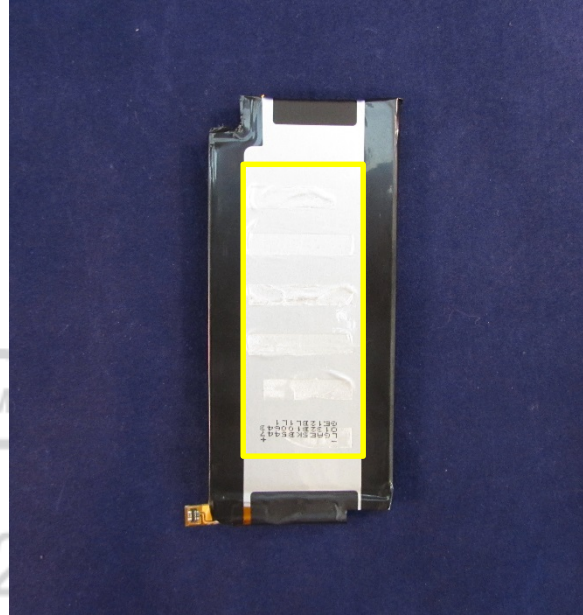
To prevent damage, do not allow sharp tools or screws to come in contact with the Battery.



2. 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.



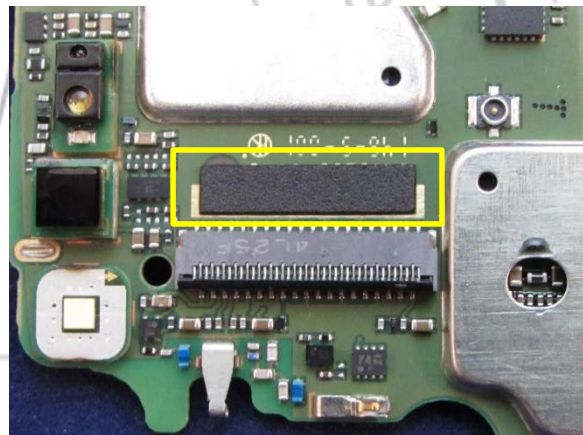
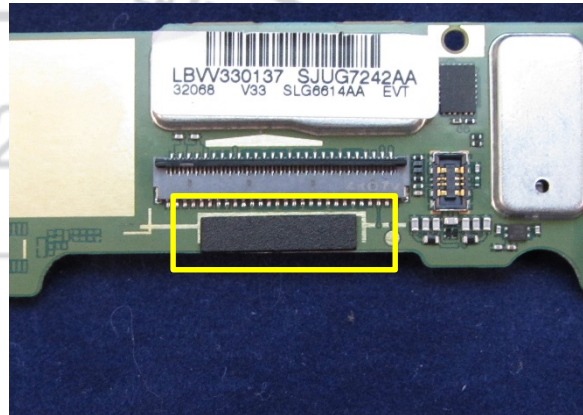
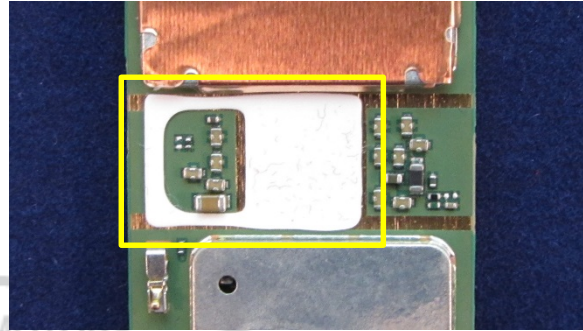
3. Inspect the Battery to verify it is not creased, crushed, or punctured.
4. If the Battery foil pack is wrinkled, slide the flat edge of the Blackstick against the foil pack to smooth out all wrinkles.

**// CAUTION //**

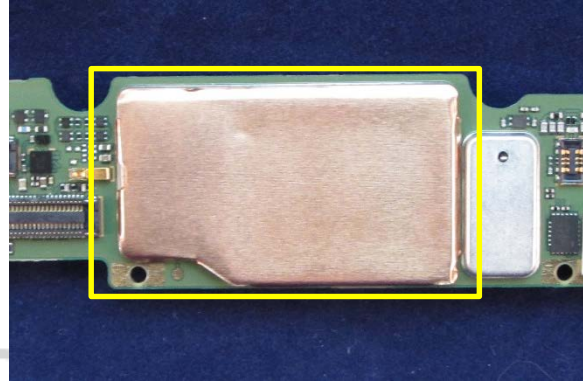
To prevent damage, do not allow sharp tools or screws to come in contact with the Battery.

## PCB Cleaning

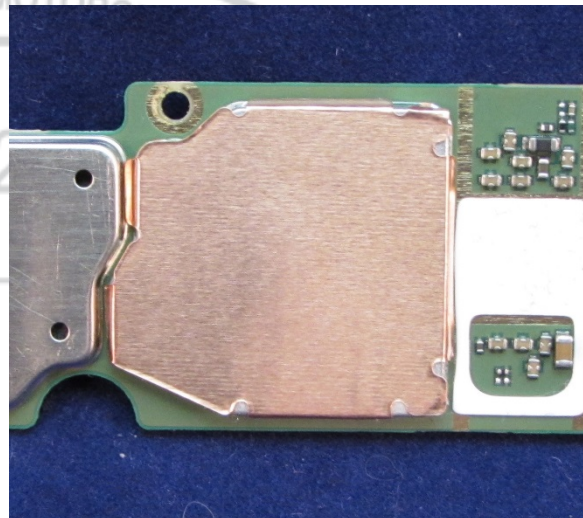
1. Use the Blackstick and ISP Alcohol to remove any remaining adhesive from the PCB.
2. Use the Blackstick and ISP Alcohol to remove the Display Flex ZIF Connector Pad.
3. Use the Blackstick and ISP Alcohol to remove the Rear-Facing Imager ZIF Connector Pad.



4. Use the Blackstick and ISP Alcohol to remove the IC Copper Tape.



5. Use the Blackstick and ISP Alcohol to remove the PCB Shield Copper Tape.

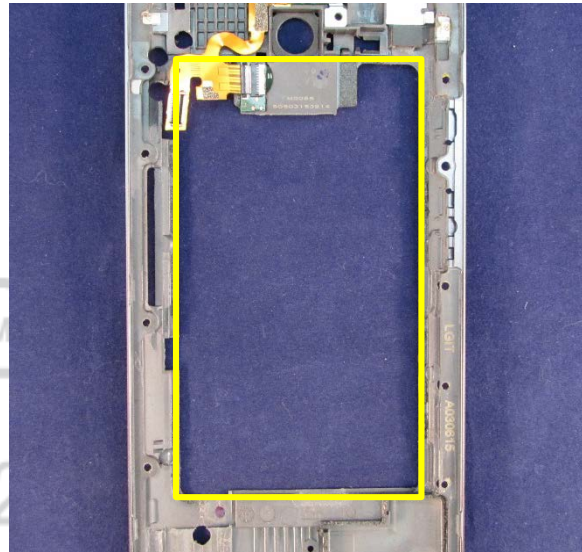


## Rear Housing Cleaning

1. Use the Blackstick and ISP Alcohol to remove any remaining adhesive left by the NFC Antenna.

### NOTE

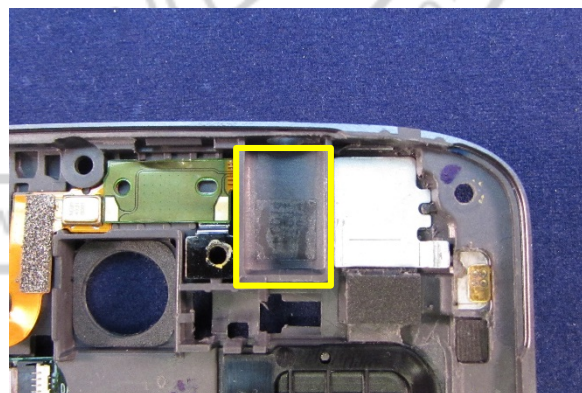
This step is applicable only if the NFC Antenna was removed during disassembly.



2. Use the Blackstick and ISP Alcohol to remove any remaining adhesive left by the Rear Inlay on the Rear Housing and NFC Antenna.



3. Use the Blackstick and ISP Alcohol to remove any remaining adhesive left by the Headset Jack.

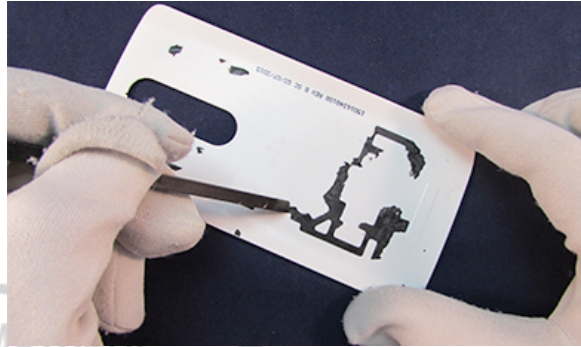


4. Use the Blackstick and ISP Alcohol to remove the Loudspeaker Gasket.



## Rear Inlay Cleaning

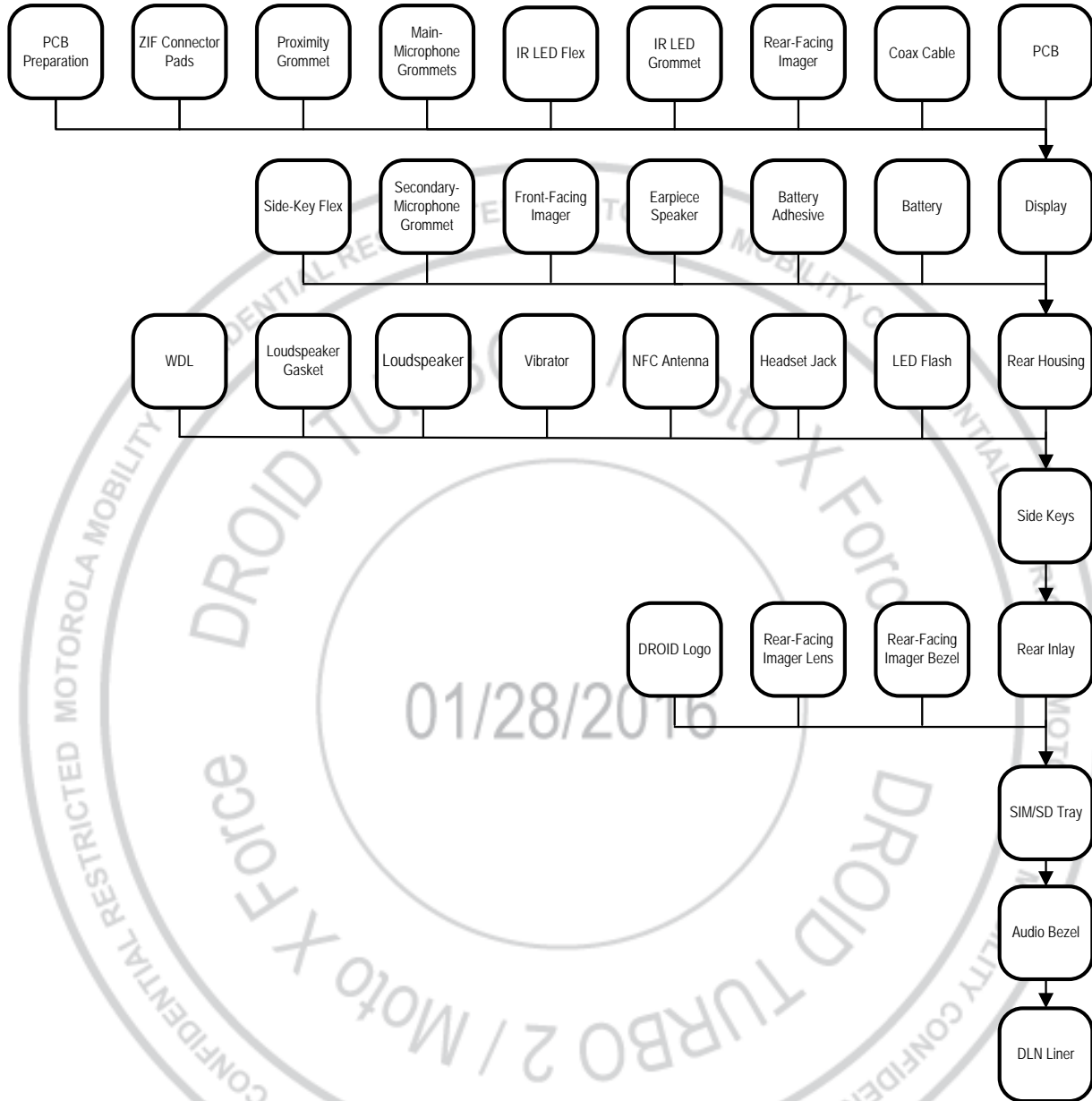
Use the Blackstick and ISP Alcohol to remove any remaining adhesive from the Rear Inlay.





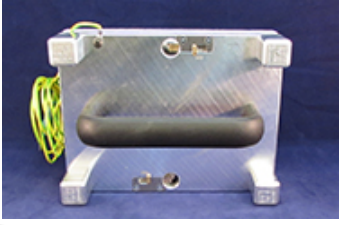
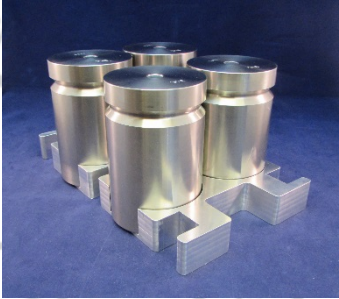
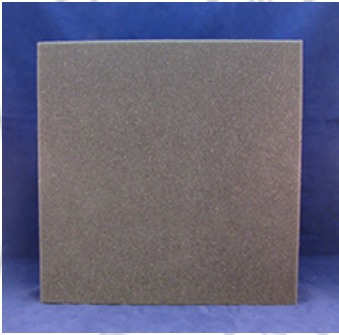
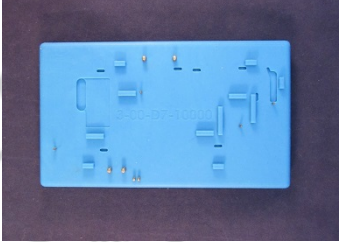

# ASSEMBLY

## Assembly Map




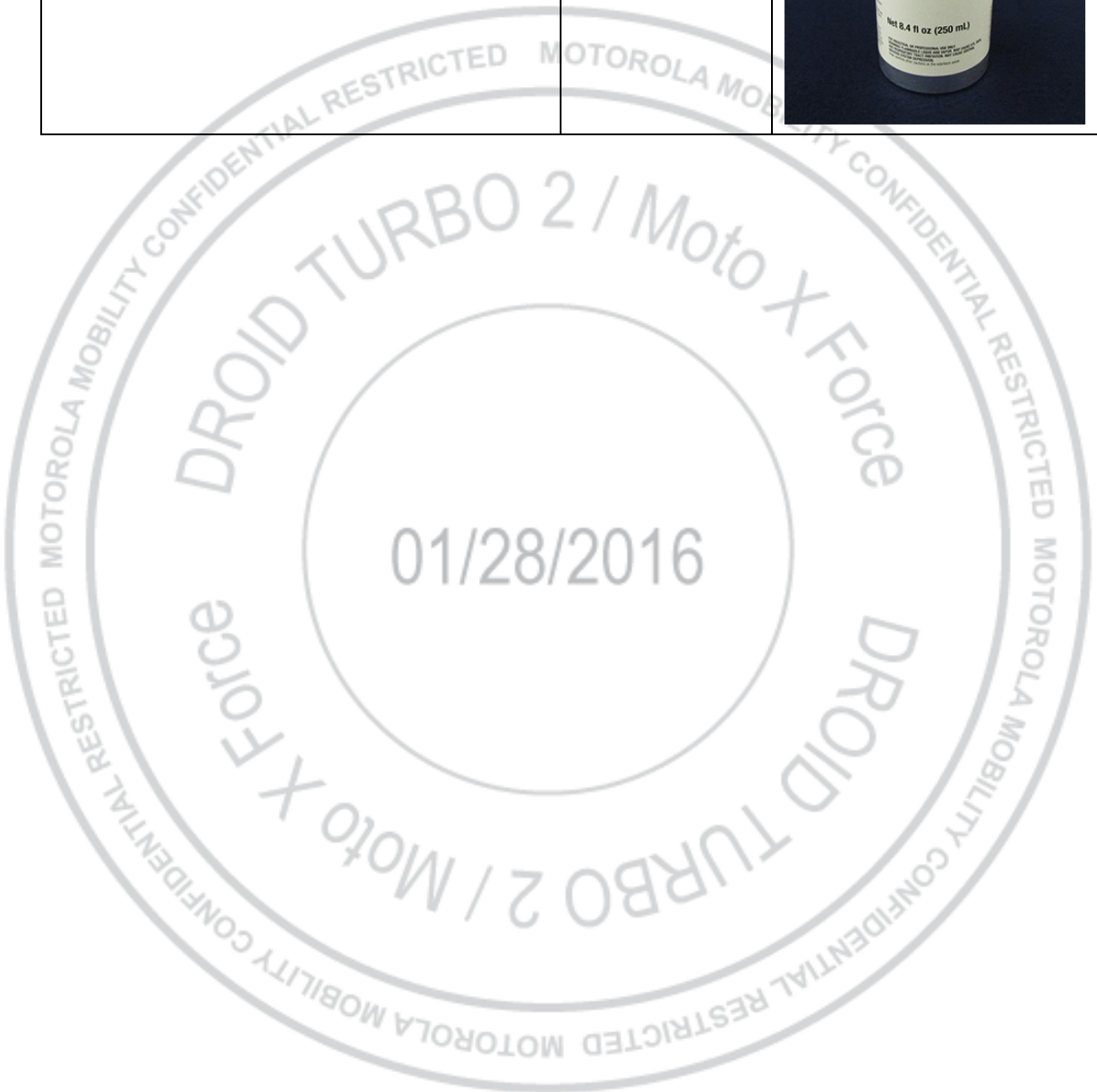
## Tools Required for Assembly

The following tools are required to assemble the DROID TURBO 2 / Moto X Force phone.

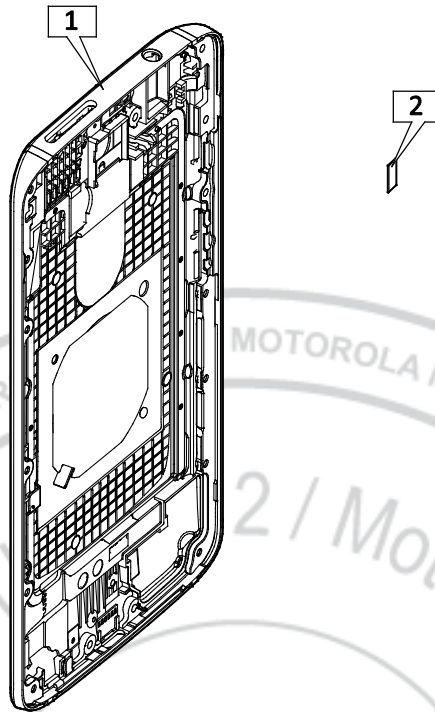
<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Universal Press Fixture	3-00-A3-10000	
Universal Press Weights	3-00-E5-10000	
Universal Nest	3-00-A7-10000	
Bounce PCB Assembly Fixture	3-00-D7-10000	
Bounce Earpiece Deco Press Fixture	3-00-D8-10000	

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Bounce Audio Gasket Alignment Fixture	3-00-D9-10000	
Bounce Inlay Adhesive Fixture	3-00-E8-10000	
Bounce Chassis Screw Guide	3-00-F6-10000	
Bounce Audio Bezel Press Tool	3-00-F7-10000	
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	--	--
Compressed Air Spray Can	--	--

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
3M AP-111 Adhesion Promoter	--	

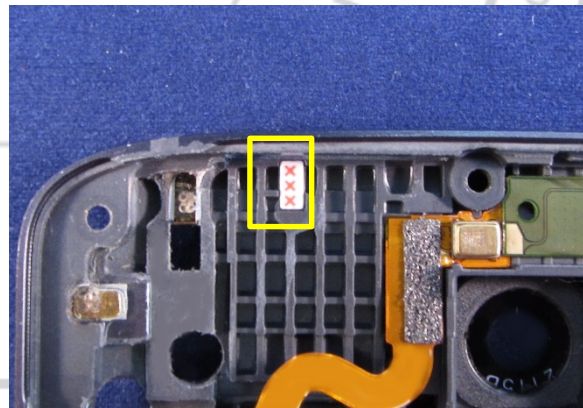


## Rear Housing WDL Assembly

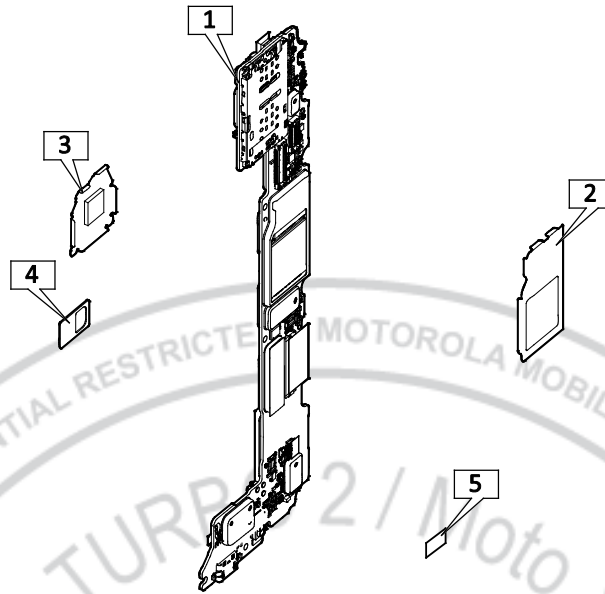


Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY ASSY,HSG,REAR,TIN SILVER,KINZIE ASSY,HSG,REAR,CHAMPAGNE,KINZIE ASSY,HSG,REAR,RED,KINZIE	1
LBL,WATER, DETECT	2

Place the Rear Housing WDL near the SIM/SD Card slot as shown.

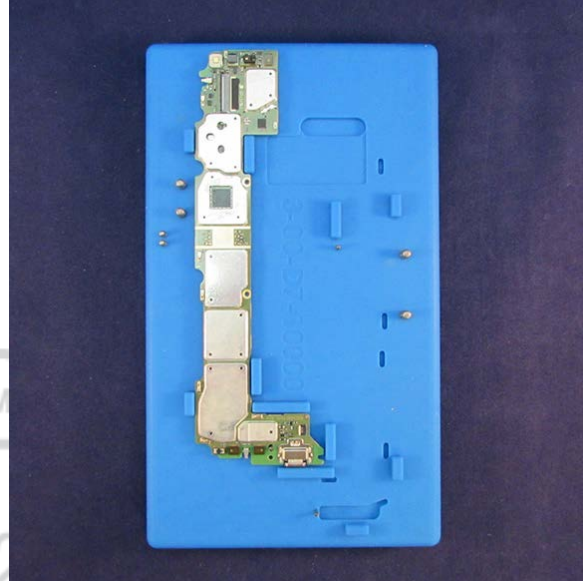


## PCB Preparation

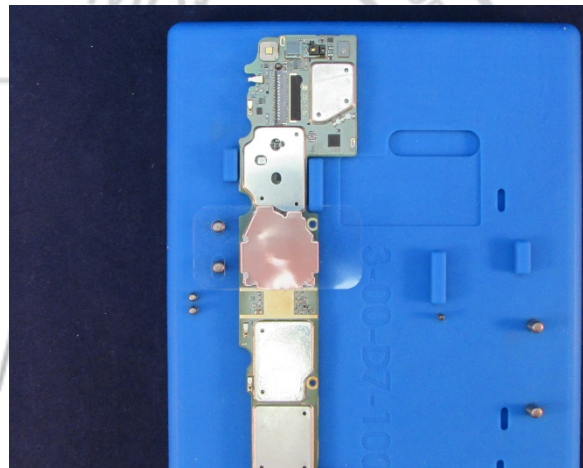


<i>Description</i>	<i>Reference #</i>
ASSY,PWA,MN,BOUNCE VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	1
DIE CUT,ADHESIVE,COPPER TAPE,MSM8994	2
DIE CUT,ADHES,COP TAPE,PM8994	3
DIE CUT,ADHESIVE,PCB-CHASSIS	4
LBL,WATER, DETECT	5

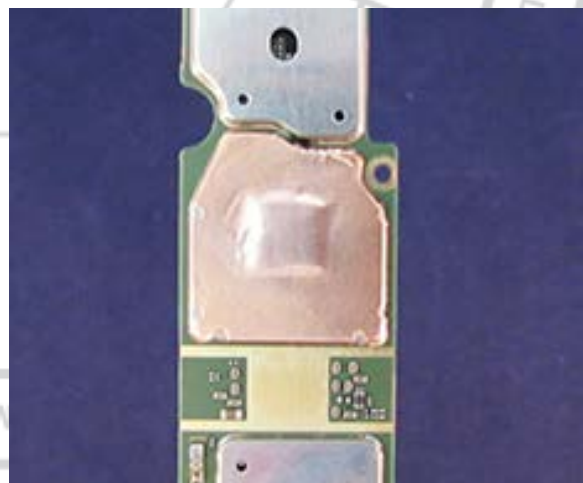
1. Place the PCB into the Bounce PCB Assembly Fixture (3-00-D7-10000).



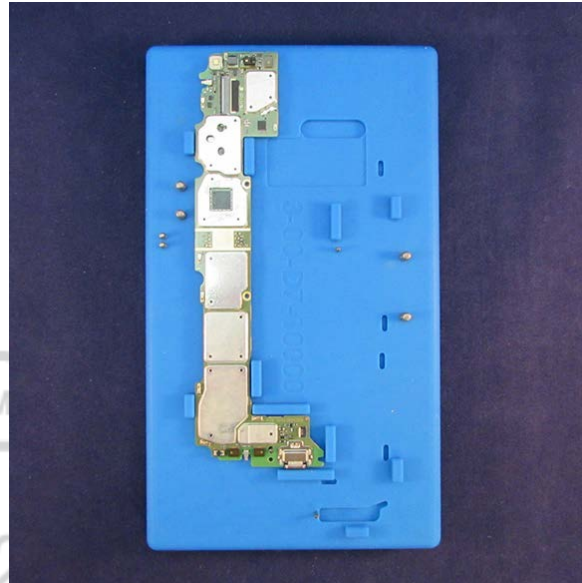
2. Remove the PCB Shield Copper Tape from the carrier.
3. Place the PCB Shield Copper Tape into the fixture over the PCB, using the pins in the fixture to align it.
4. Press down on the PCB Shield Copper Tape for 5 seconds to secure it to the PCB Shield.



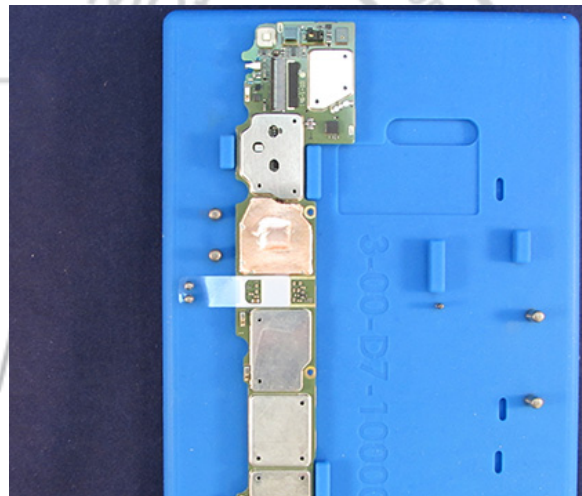
5. Remove the PCB from the fixture.
6. Remove the remaining liner from the PCB Shield Copper Tape.
7. Use the Blackstick to adhere the edges of the PCB Shield Copper Tape to the PCB Shield.



8. Place the PCB into the fixture.



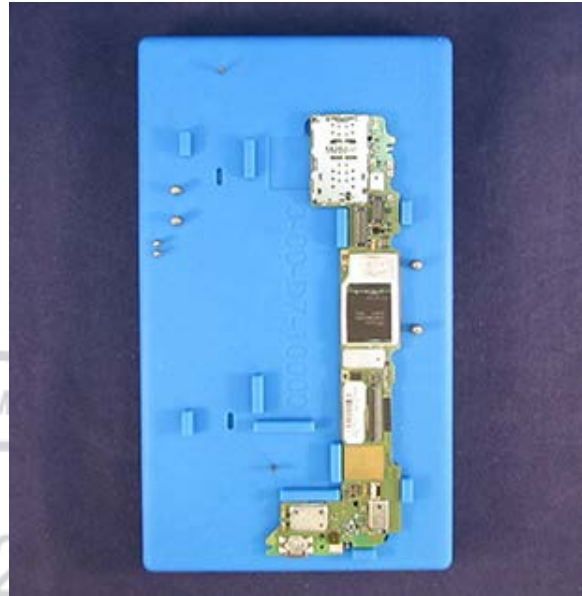
9. Remove the PCB Adhesive from the carrier.
10. Place the PCB Adhesive into the fixture, using the pins in the fixture to align it.
11. Press down on the PCB Adhesive for 5 seconds to secure it to the PCB.



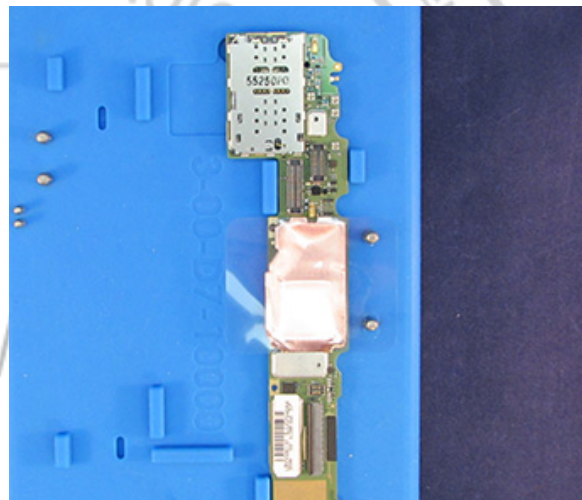
12. Remove the PCB from the fixture.
13. Remove the remaining liner from the PCB Adhesive.



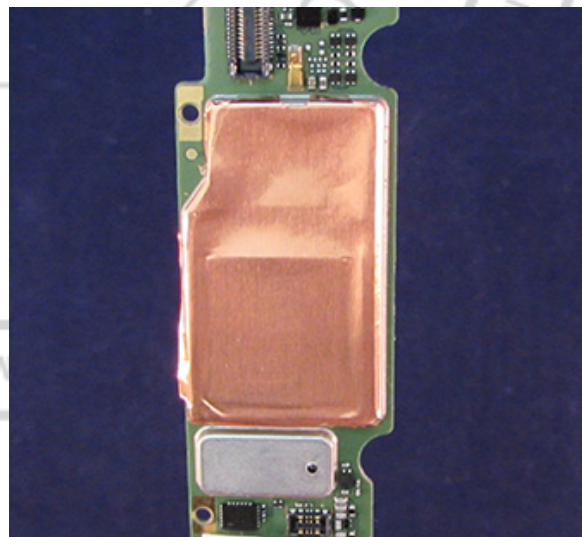
14. Place the PCB into the fixture.



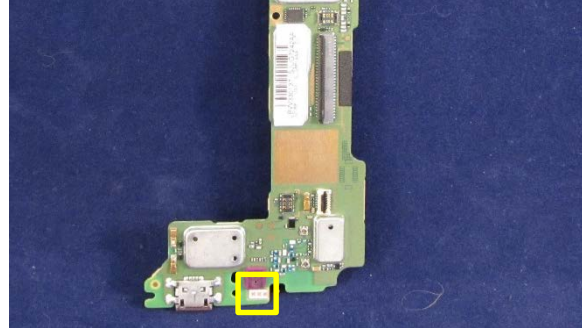
15. Remove the IC Copper Tape from the carrier.
16. Place the IC Copper Tape into the fixture, using the pins in the fixture to align it.
17. Press down on the IC Copper Tape for 5 seconds to secure it to the IC Shield.



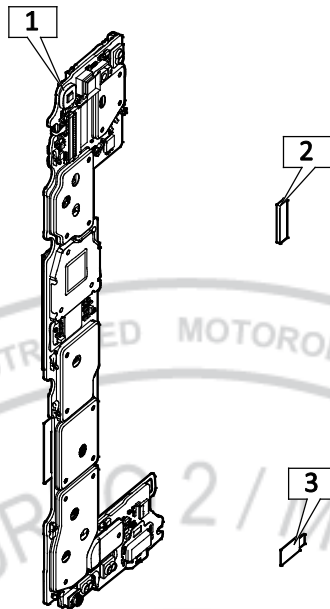
18. Remove the PCB from the fixture.
19. Remove the remaining liner from the IC Copper Tape.
20. Use the Blackstick to adhere the edges of the IC Copper Tape to the IC Shield.



21. Place the PCB WDL on the PCB in the location shown.
22. Press down on the PCB WDL for 5 seconds to secure it to the PCB.

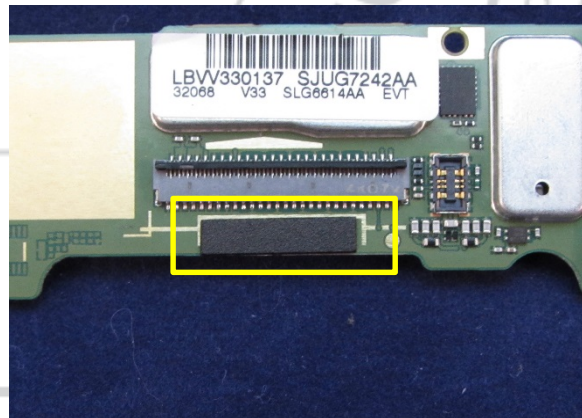


## ZIF Connector Pad Assembly

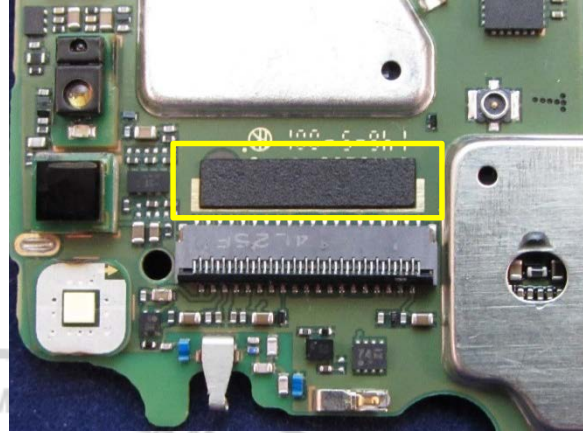


Description	Reference #
ASSY,PWA,MN,BOUNCE VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	1
PAD,CONNECTOR,REAR IMGR	2
Display Flex ZIF Connector Pad	3

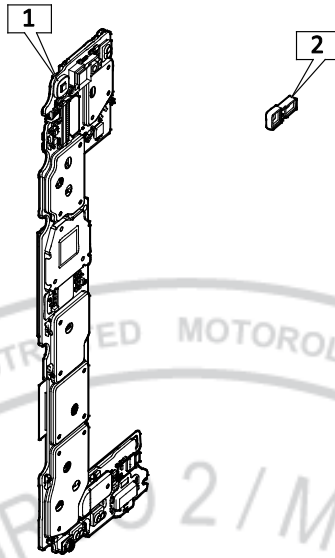
- Place the Display Flex ZIF Connector Pad on the PCB, using the etched markings on the PCB to align it.



2. Place the Rear-Facing Imager ZIF Connector Pad on the PCB, using the etched markings on the PCB to align it.

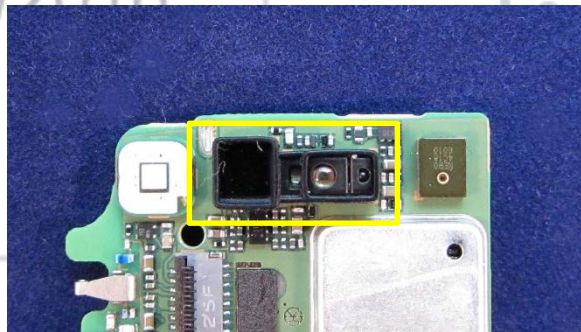


## Proximity Grommet Assembly



Description	Reference #
ASSY,PWA,MN,BOUNCE,VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	1
GROM,SENSOR,KINZIE	2

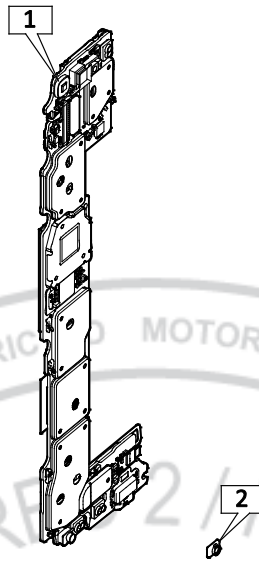
1. Use the Plastic Tweezers to place the Proximity Grommet in position on the Proximity Sensor.



2. Verify the Proximity Grommet is flush with the Proximity Sensor.

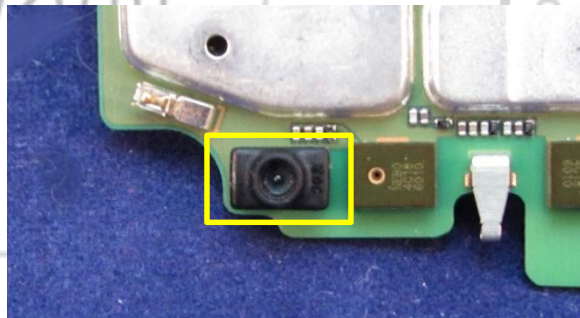


## IR LED Grommet Assembly



Description	Reference #
ASSY,PWA,MN,BOUNCE VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	1
SEAL,IR LED	2

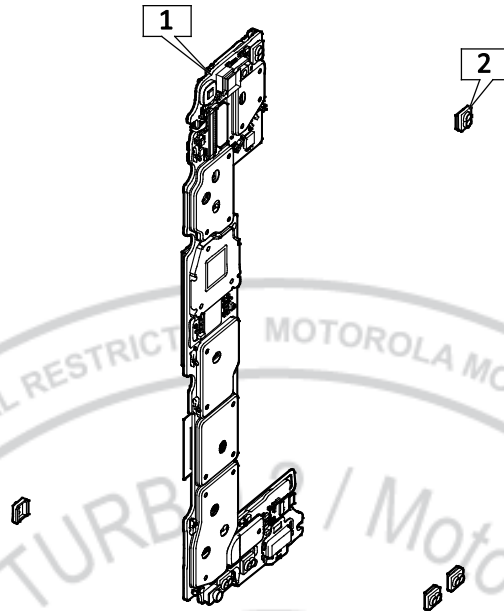
1. Use the Plastic Tweezers to place the IR LED Grommet in position on the IR LED.



2. Verify the IR LED Grommet is flush with the IR LED.

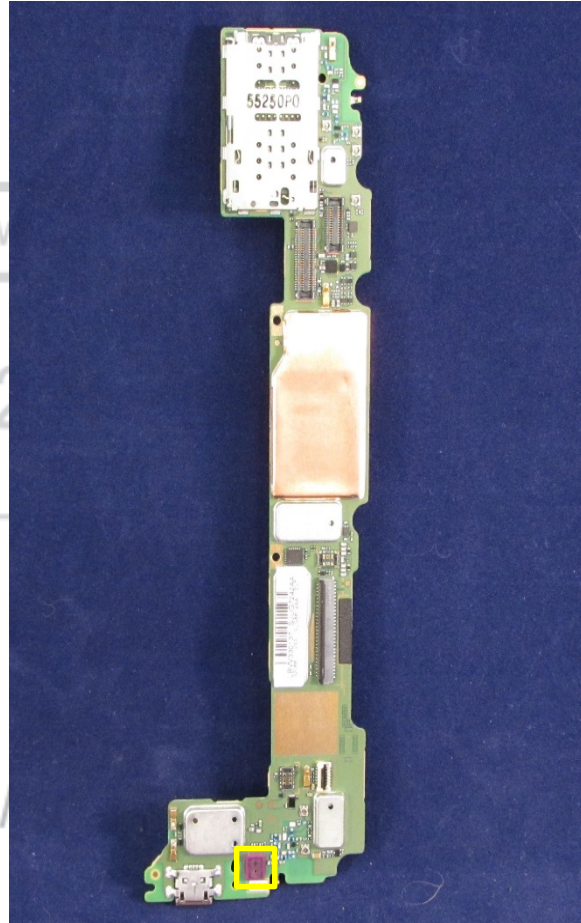
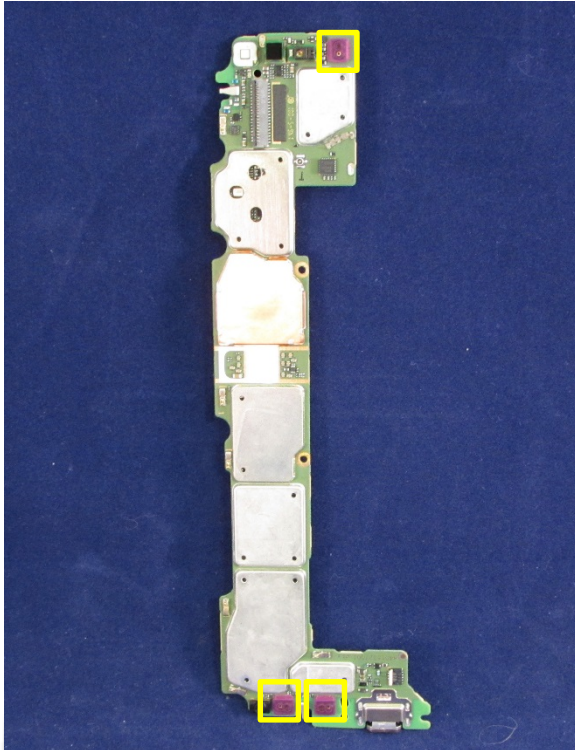


## Main-Microphone Grommet Assembly



Description	Reference #
ASSY,PWA,MN,BOUNCE VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	1
GROM,MIC PURPLE GROM,MIC ORANGE	2 (qty 4)

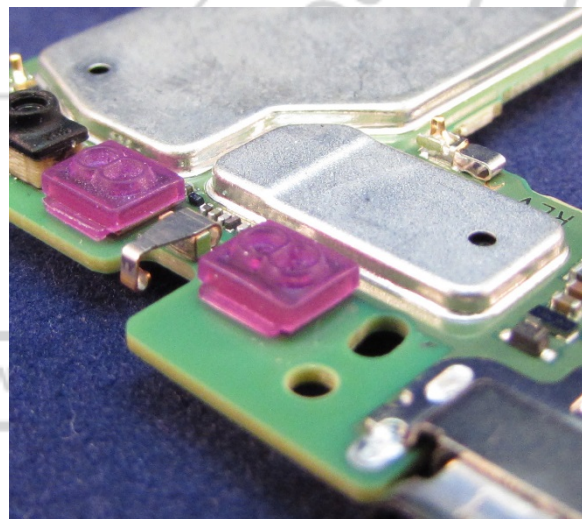
1. Use the Plastic Tweezers to place the 4 Main-Microphone Grommets in position on the Microphones.



2. Verify all 4 Microphone Grommets are flush with the PCB.

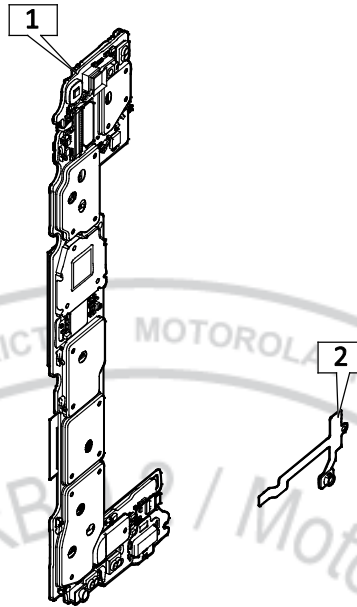
**NOTE**

Only 2 of the 4 Microphone Grommets are shown. The orientation of all 4 grommets is the same.



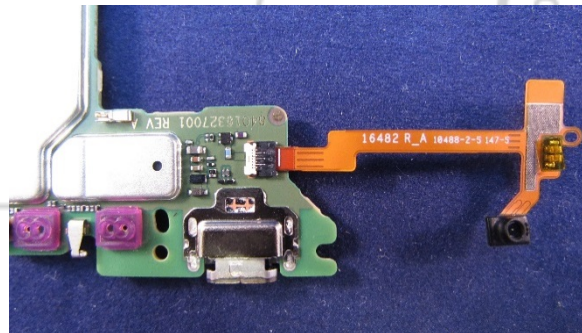


## IR LED Flex Assembly

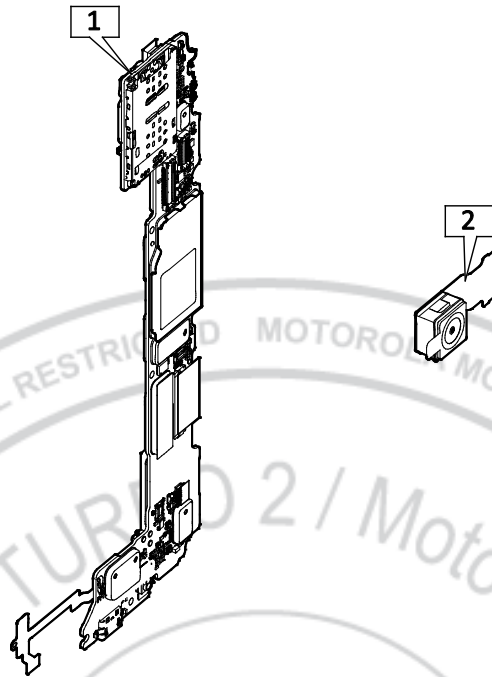


Description	Reference #
ASSY,PWA,MN,BOUNCE VZW	1
ASSY,PWA,MN,BOUNCE,ROW	
ASSY,PWA,MN,64 GB,BOUNCE,VZW	
ASSY,PWA,MN,64 GB,BOUNCE,ROW	
ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	
ASSY,FLXCKT,IR LED,KINZIE	2

1. Insert the IR LED Flex into the IR LED Flex ZIF Connector, using the white line as a guide for insertion depth.
2. Slide a fingertip across the ZIF Connector Door to close it.
3. Place Kapton Tape over the IR LED Flex ZIF Connector.

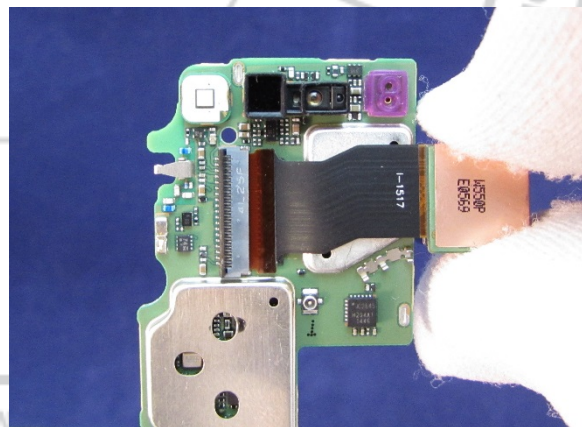


## Rear-Facing Imager Assembly

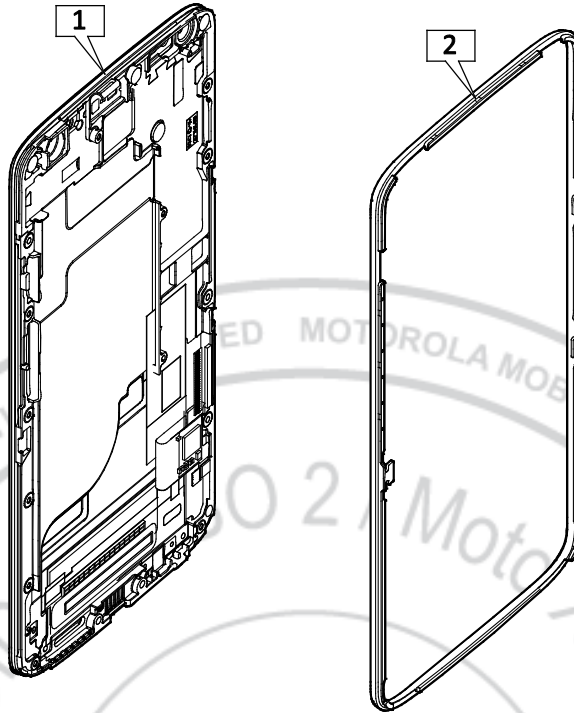


Description	Reference #
ASSY,PWA,MN,BOUNCE VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	1
ASSY,FLXCKT,CAMERA,REAR FACING 21MP IMAGER,KINZIE	2

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.

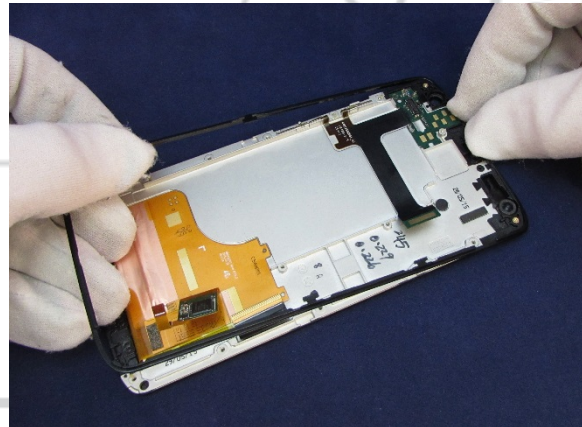


## Trim Ring Assembly

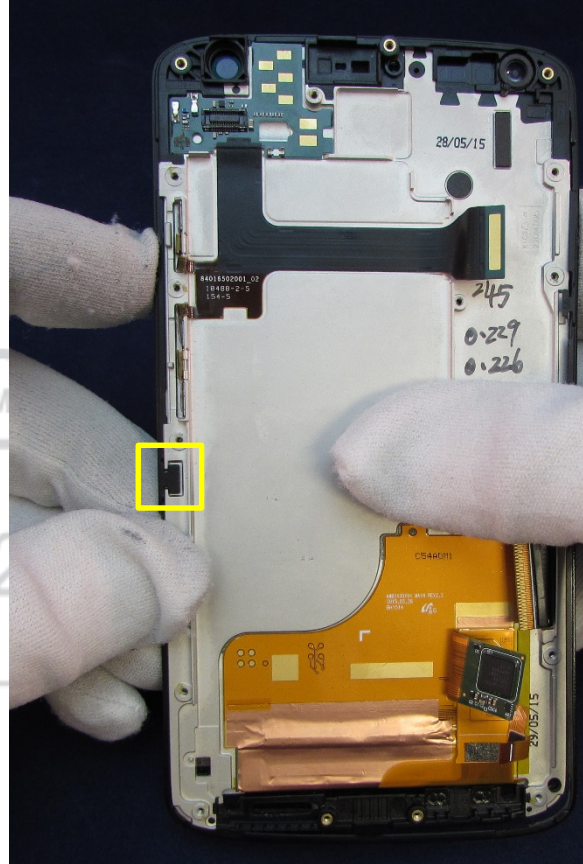


Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
HSG,FRNT RIM,DECORATED,BLACK	2
HSG,FRNT RIM,DECORATED,WHITE	2

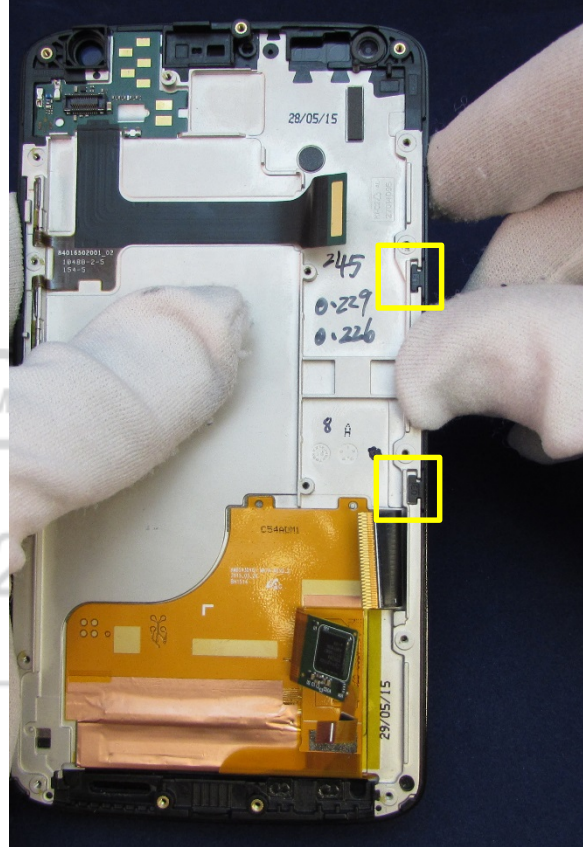
1. Place the top side of the Trim Ring onto the Display.



2. Push the left side of the Trim Ring into the recess of the Display and engage the snap.



3. Push the right side of the Trim Ring into the recess of the Display and engage the 2 snaps.



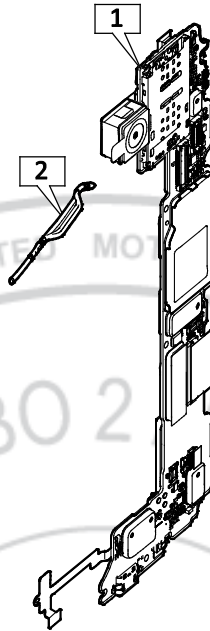
4. Push the USB Connector side of the Trim Ring into the recess of the Display.



5. Verify the Trim Ring is seated in the recess of the Display, and no light is visible between the Trim Ring and Display.



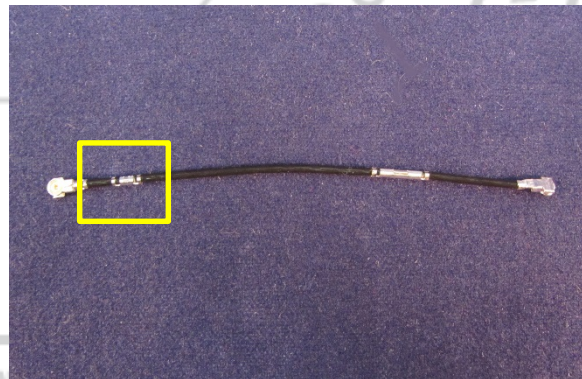
## Coax Cable Assembly



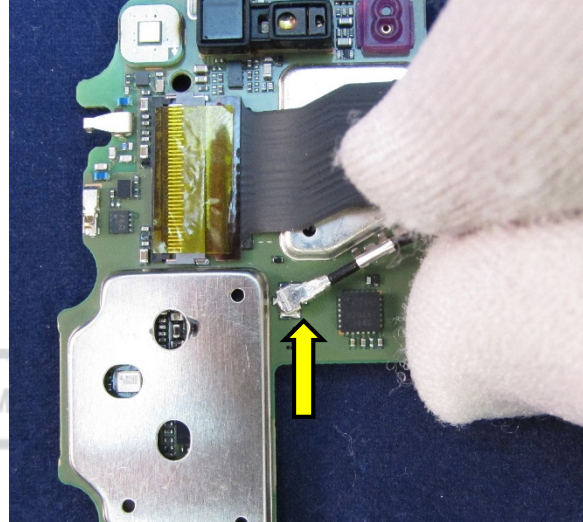
<i>Description</i>	<i>Reference #</i>
ASSY,PWA,MN,BOUNCE VZW ASSY,PWA,MN,BOUNCE,ROW ASSY,PWA,MN,64 GB,BOUNCE,VZW ASSY,PWA,MN,64 GB,BOUNCE,ROW ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	1
CABLE,COAX	2

**// CAUTION //**

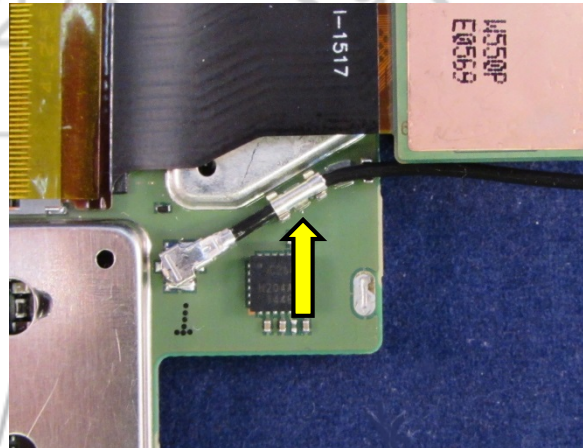
The Coax Cable must be assembled to the PCB with the small cable shield towards the PCB.



1. Place one end of the Coax Cable over the connector on the PCB.
2. Press down on the Coax Cable until it snaps in place.

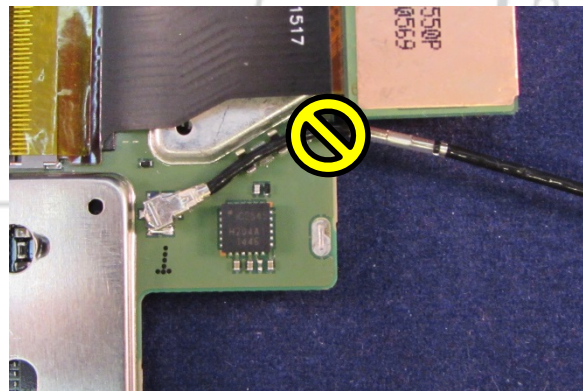


3. Push the Coax Cable and small cable shield into the guide on the PCB.



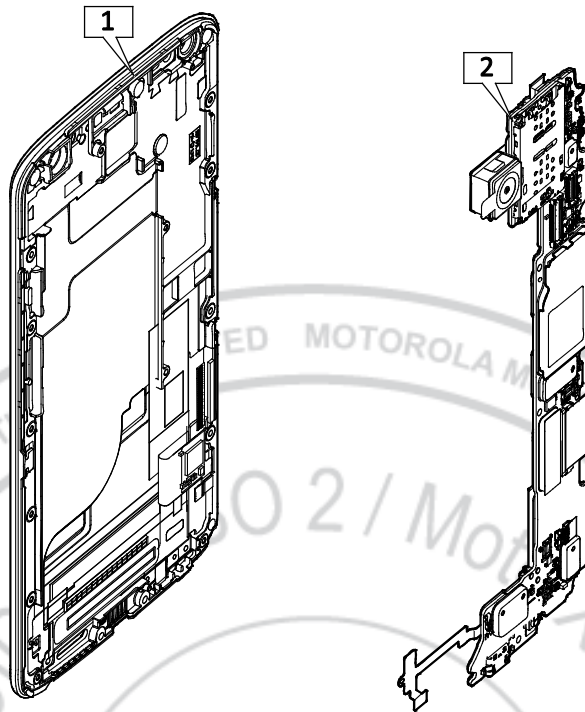
**// CAUTION //**

Make sure the Coax Cable is assembled with the small cable shield inserted in the guide on the PCB. If the Coax Cable is assembled as shown, remove it and connect the opposite end of the cable.



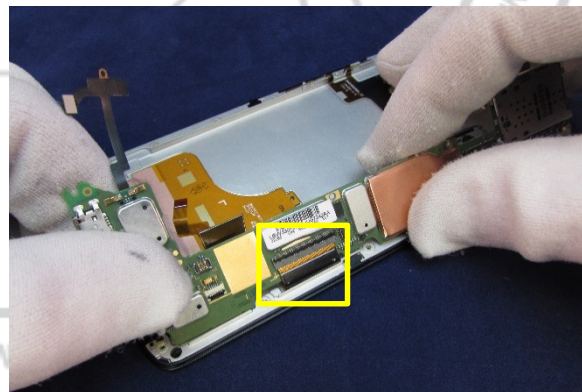


## PCB Assembly

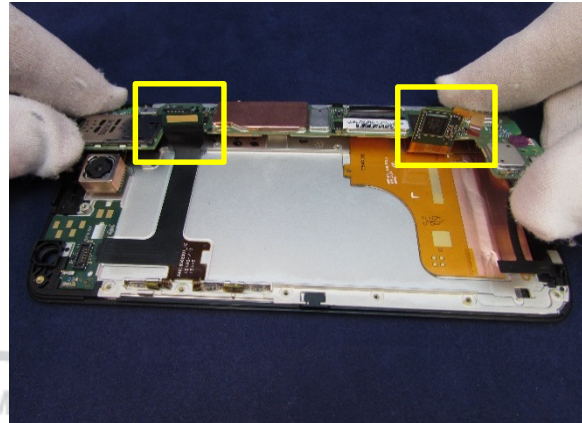


Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
ASSY,PWA,MN,BOUNCE VZW	2
ASSY,PWA,MN,BOUNCE,ROW	2
ASSY,PWA,MN,64 GB,BOUNCE,VZW	2
ASSY,PWA,MN,64 GB,BOUNCE,ROW	2
ASSY,PWA,MN,32 GB,BOUNCE,CHINA,ROW	2

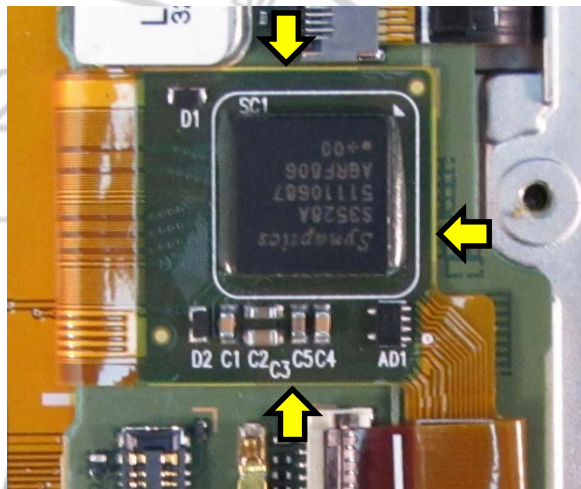
1. Insert the Display Flex into the Display Flex ZIF Connector.
2. Align the PCB to the Display along the edge opposite the Side Keys.



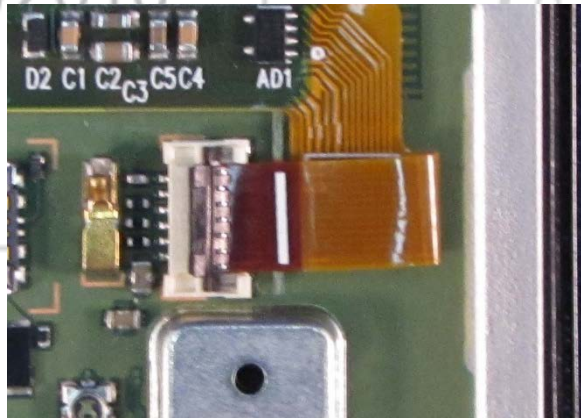
3. Lower the PCB into the Display, keeping the Side-Key Flex and Touch Flex from tucking underneath the PCB.



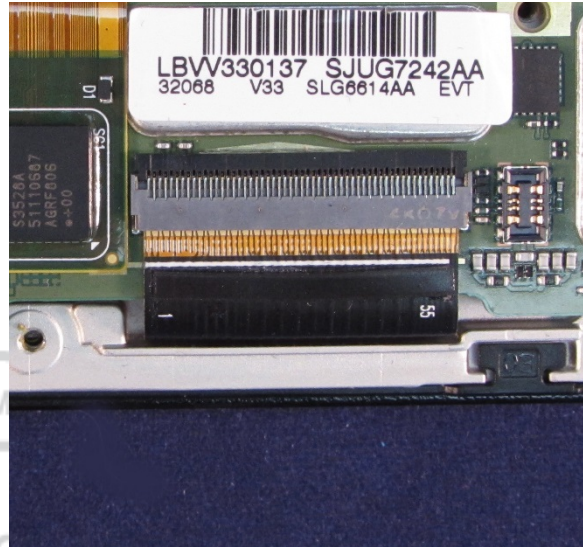
4. Remove the adhesive liner from the Touch Flex if present.
5. Fold the Touch Flex down onto the PCB, aligning it to the etched markings on the PCB.



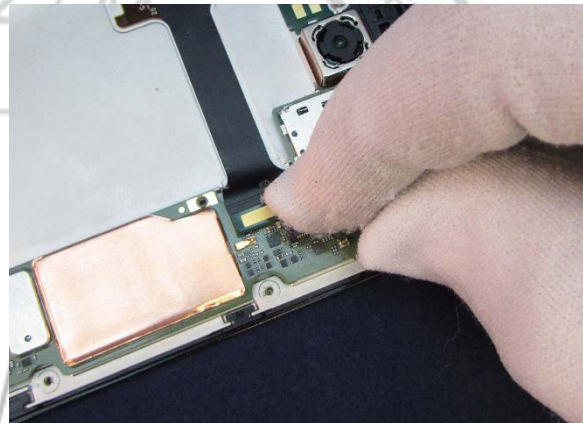
6. Insert the Touch Flex into the Touch Flex ZIF Connector. Use the white line as a guide for insertion depth.
7. Slide a fingertip across the ZIF Connector Door to close it.
8. Place Kapton tape over the Touch Flex ZIF Connector Door.



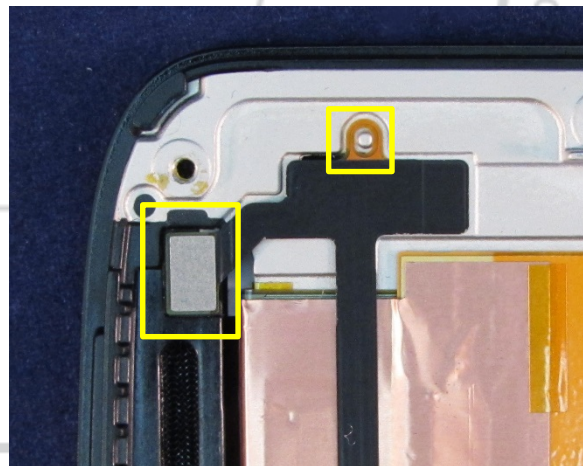
9. Verify the Display Flex is inserted in the Display Flex ZIF Connector. Use the white line as a guide for insertion depth.
10. Slide a fingertip across the ZIF Connector Door to close it.
11. Place Kapton Tape over the Display Flex ZIF Connector.



12. Press down on the Side-Key Flex to connect the Side-Key Flex BtB Connector.



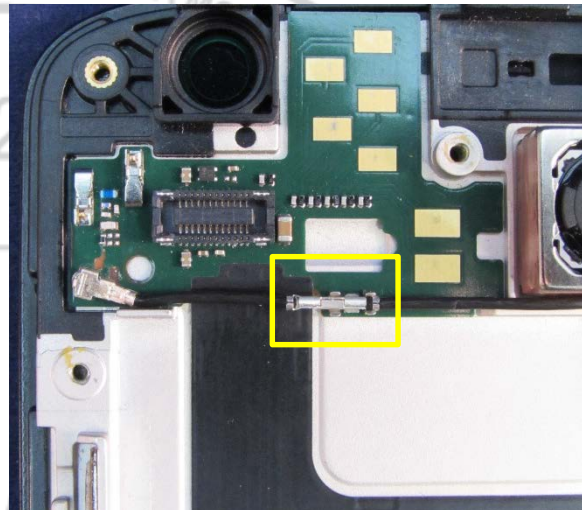
13. Place the IR LED Flex in position on the Display. Use the post in the Display to align the flex.
14. Push the IR LED Flex Sensor into the pocket of the Display.



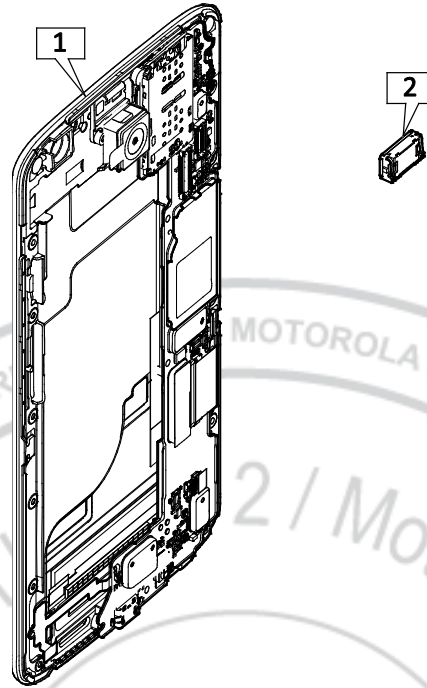
15. Place the end of the Coax Cable over the connector on the PCB.
16. Press down on the Coax Cable until it snaps in place.



17. Push the Coax Cable and large cable shield into the guide on the PCB.

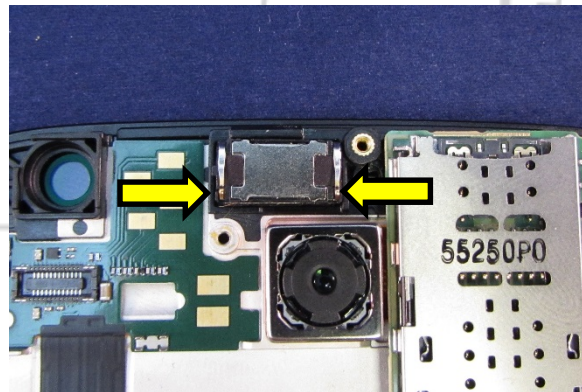


## Earpiece Speaker Assembly

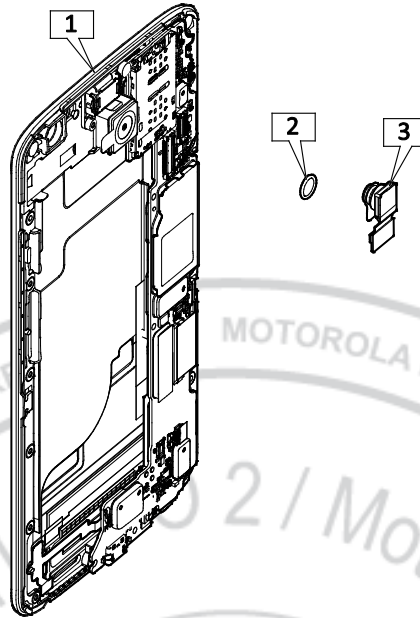


Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
TRANSDUCER,OTHR,6X12X3,6X12X3MM RCVR F0=200HZ, AAC	2

1. Remove the Earpiece Speaker adhesive liner.
2. Place the Earpiece Speaker in the pocket of the Display, with the raised speaker contacts facing away from the top edge of the phone as shown.
3. Press down on the Earpiece Speaker for 5 seconds to secure it to the Display.

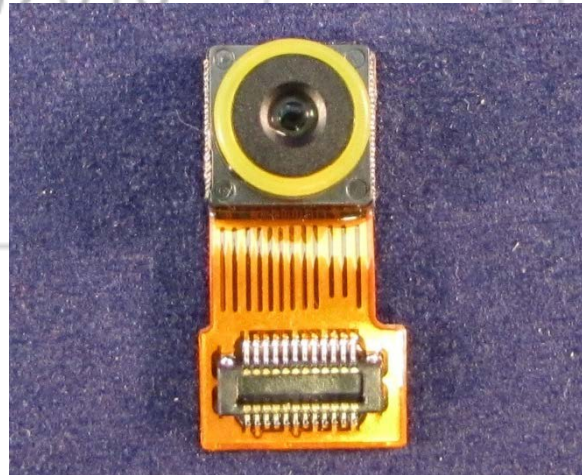


## Front-Facing Imager Assembly

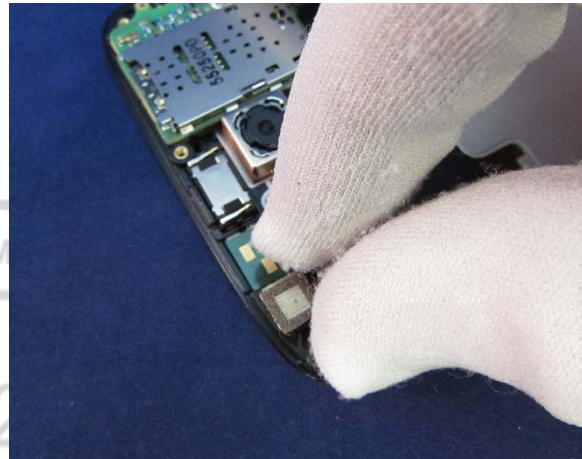


Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
SEAL,O-RING,FRONT IMGR	2
ASSY,FLXCKT,5MP IMAGER,KINZIE	3

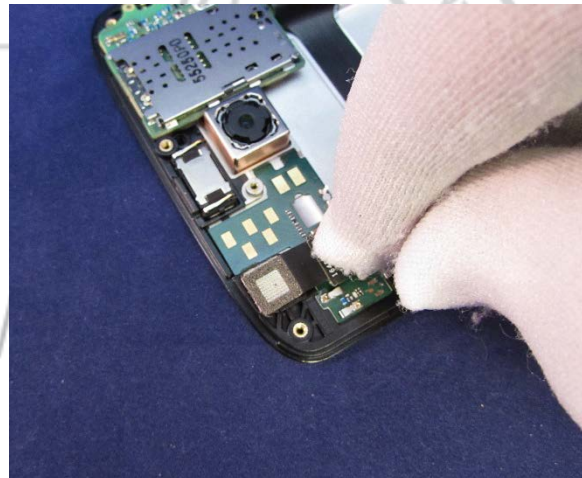
1. Place the Front-Facing Imager Gasket over the Front Facing Imager as shown.



2. Spray the Front-Facing Imager pocket in the Display with compressed air to remove any dust or foreign material.
3. Remove the protective liner from the Front-Facing Imager if present.
4. Place the Front-Facing Imager into the pocket of the Display.

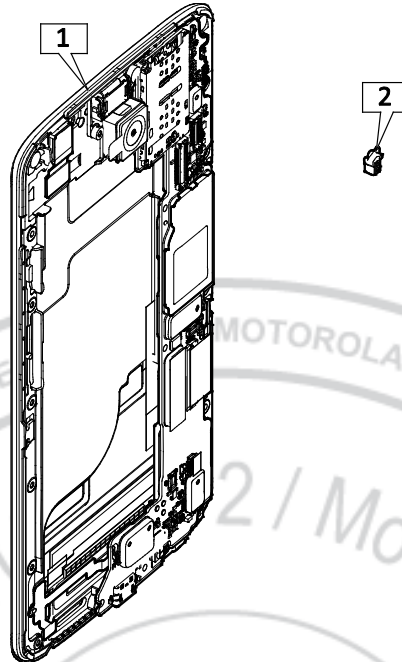


5. Press down on the Front-Facing Imager BiB Connector to connect it to the PCB.



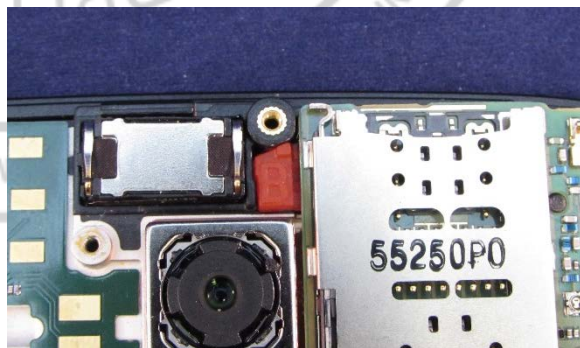


## Secondary-Microphone Grommet Assembly

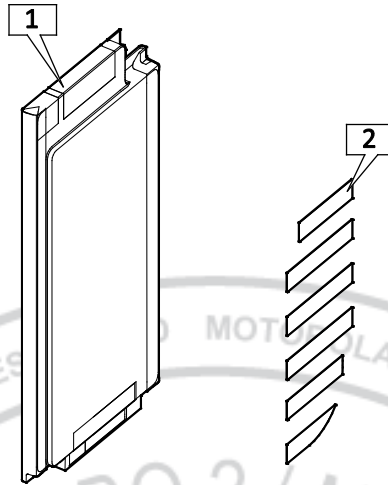


Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
GROM,SEAL,MIC 5	2

1. Use the Tweezers to place the Secondary-Microphone Grommet into position on the Display.
2. Verify the grommet is positioned as shown.
3. Press down on the Secondary-Microphone Grommet for 5 seconds to secure it to the Display.

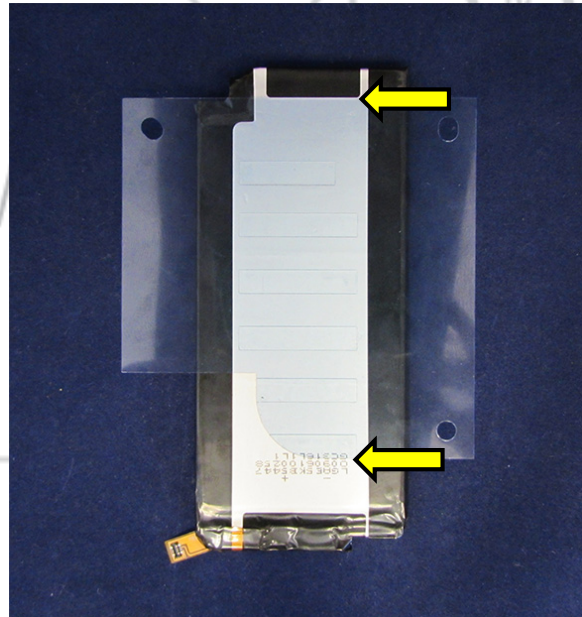


## Battery Adhesive Assembly

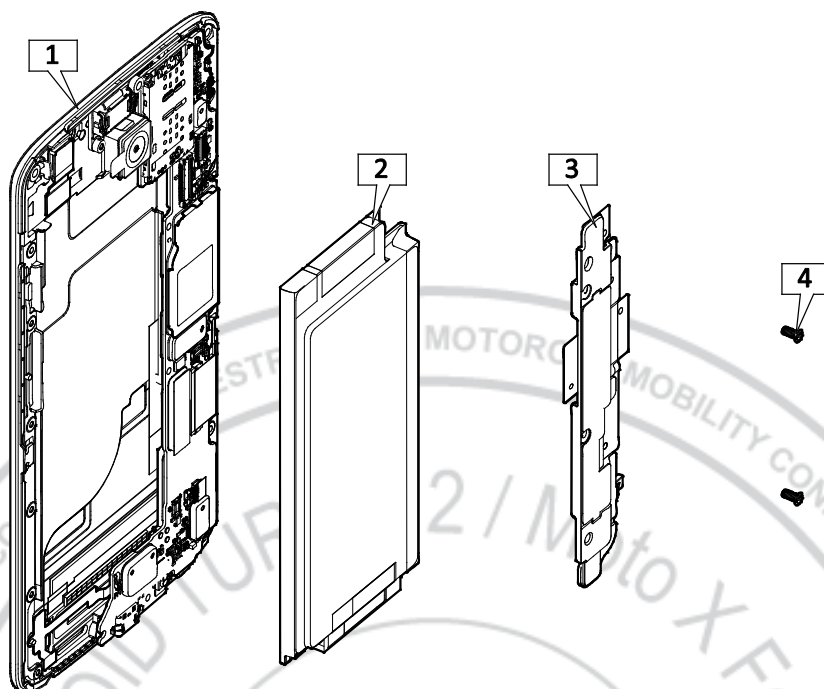


Description	Reference #
ASSY,BAT,LI POLY,FB55,3760MAH,LG CHEM	1
DIE CUT,ADHES,BAT	2

1. Remove the Battery Adhesive from the carrier.
2. Place the Battery Adhesive onto the Battery. Align the flat edge of the Battery Adhesive liner with the black Battery liner tape, and the curved edge of the adhesive with the text on the Battery foil pack. The Battery Adhesive should not overlap the black Battery liner.
3. Press down on the Battery Adhesive for 5 seconds to secure it to the Battery.



## Battery Assembly



Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	
ASSY,BAT,LI POLY,FB55,3760MAH,LG CHEM	2
ASSY,CHAS,REAR,KINZIE	3
SCR,MACH,M1.4	4 (qty 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.

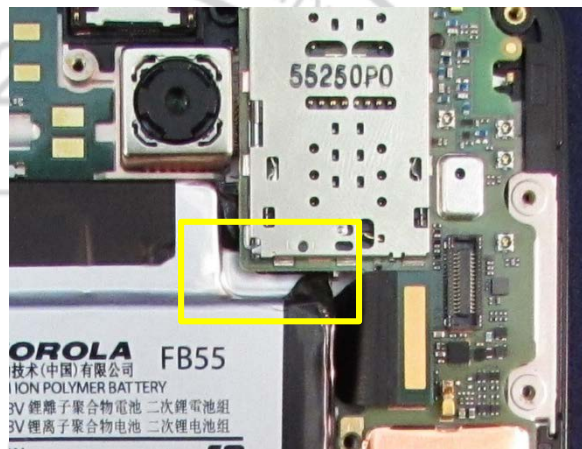
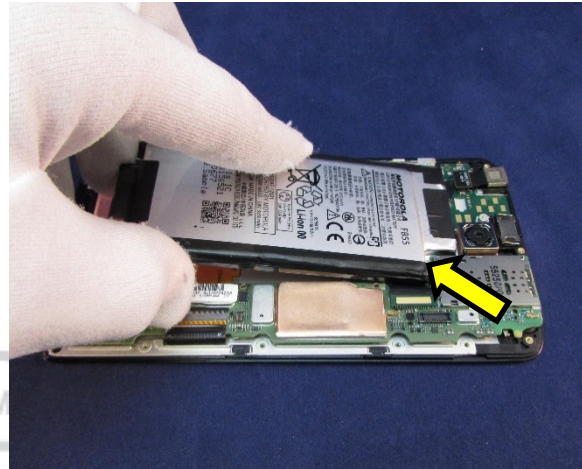
### // CAUTION //

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.

1. Remove the adhesive liner from the Battery Adhesive.
2. Place the Battery into the pocket of the Display, sliding the top-right corner of the Battery under the SIM/SD Tray slot.



3. Press down on the Battery for 5 seconds to secure it to the Display.



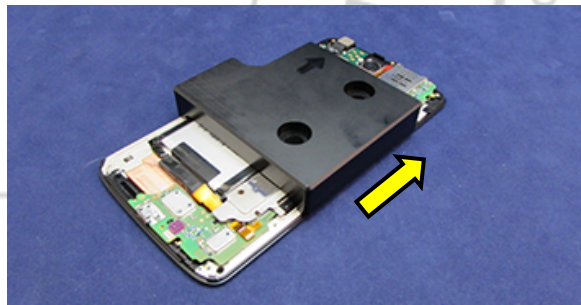
4. Press down on the Battery Flex BtB Connector to connect it to the PCB.



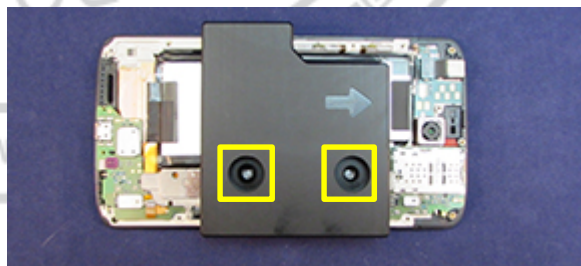
5. Place the Chassis over the PCB, using the screw holes in the Chassis to align it.



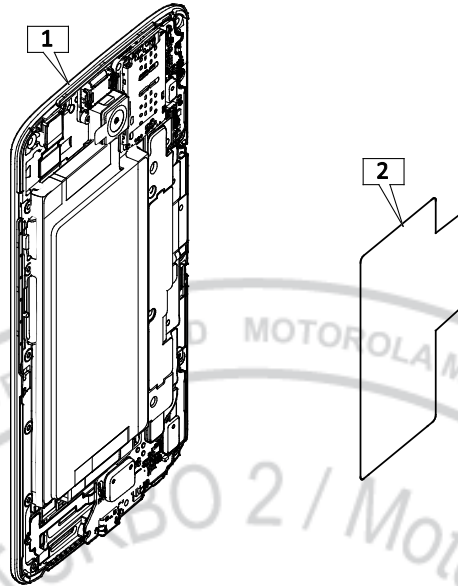
6. Place the Bounce Chassis Screw Guide (3-00-F6-10000) over the Chassis. Slide the fixture toward the top of the phone until it is aligned over the screw holes.



7. Tighten the 2 3IP Screws to 1.0 in-lbs (0.11 N m).



## Heatspreader Assembly



Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
DIE CUT,THRM SPREAD,MSM,KINZIE	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 //

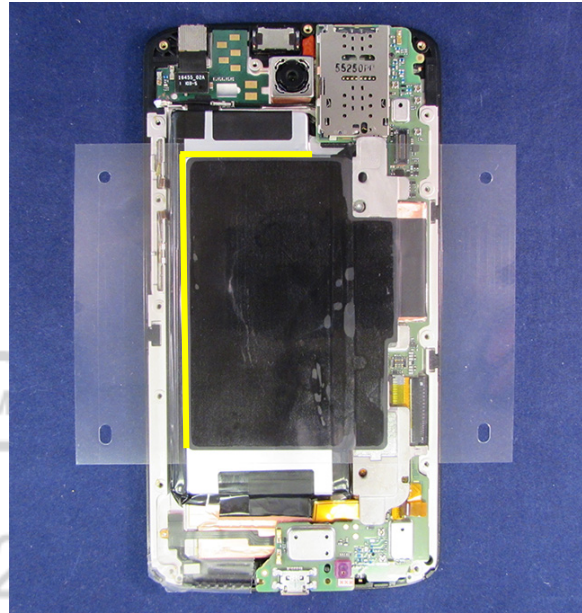
Handle the Battery Pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

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.

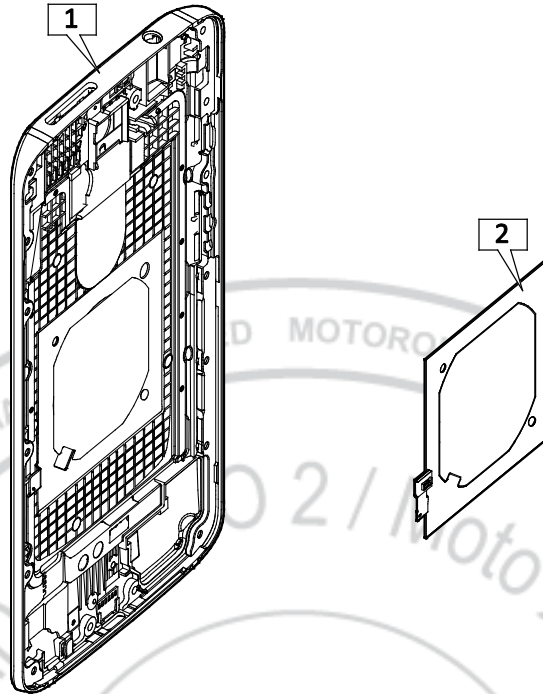
Ensure screws and screwdrivers do not contact the Battery.

1. Remove the Heatspreader adhesive liner.
2. Place the Heatspreader over the Battery and Chassis. Align the top and left sides to the raised features of the Battery.



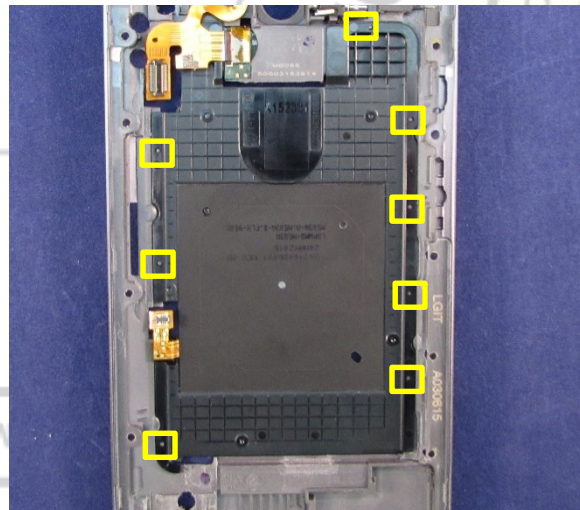
3. Press down on the Heatspreader for 5 seconds to secure it to the Battery and Chassis.

## NFC Antenna Assembly



Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY ASSY,HSG,REAR,TIN SILVER,KINZIE ASSY,HSG,REAR,CHAMPAGNE,KINZIE ASSY,HSG,REAR,RED,KINZIE	1
FLX,NFC,WLC	2

1. Remove the NFC Antenna adhesive liner.
2. Place the NFC Antenna into the cutout area of the Rear Housing. Use the posts in the Rear Housing to align the antenna.



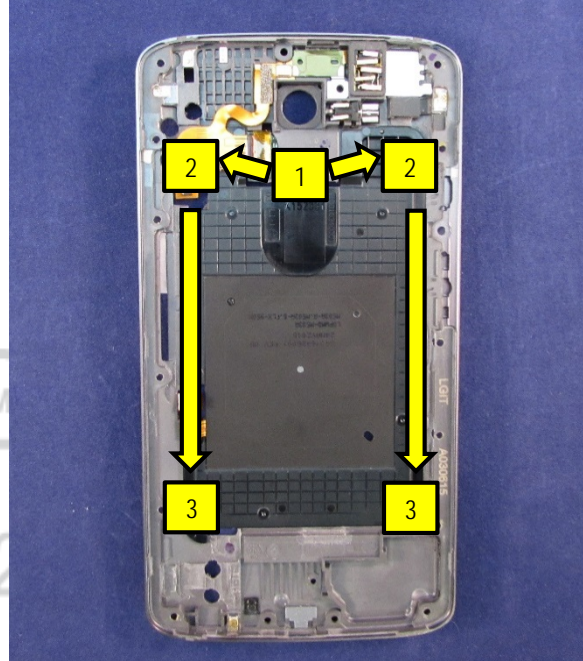


3. Apply manual pressure to the NFC Antenna as follows:
  - Place both thumbs on point 1 and slide them out to point 2.

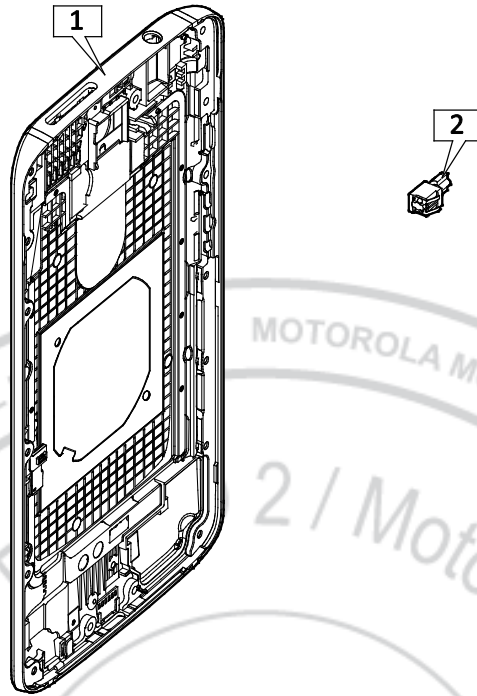
**// CAUTION //**

Do not apply pressure to the LED Flash Flex.  
Apply pressure to the NFC Antenna below the LED Flash Flex.

- Place both thumbs on point 2 and slide them down to point 3.

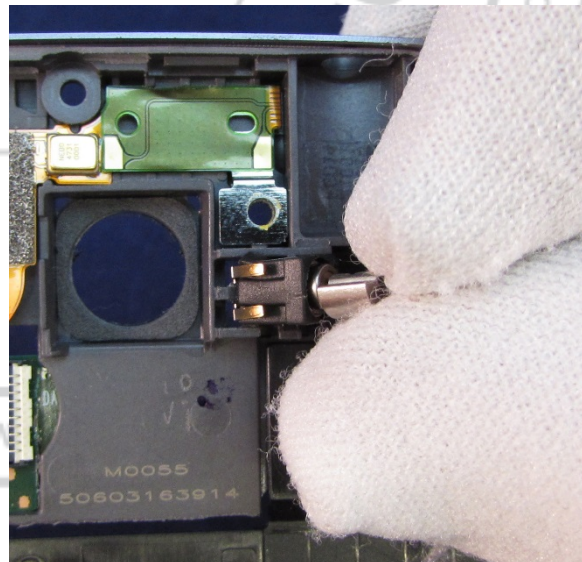


## Vibrator Assembly

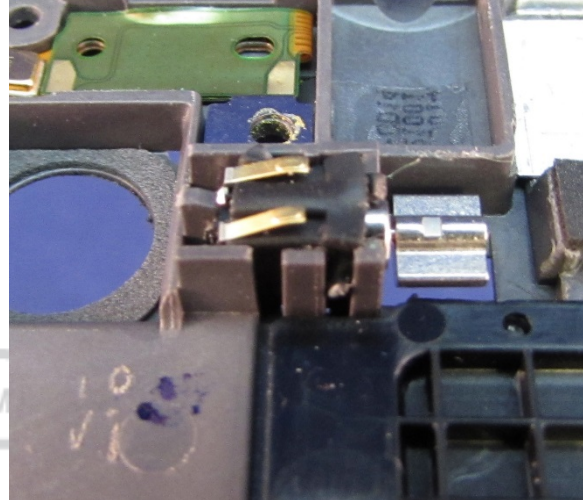


Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY ASSY,HSG,REAR,TIN SILVER,KINZIE ASSY,HSG,REAR,CHAMPAGNE,KINZIE ASSY,HSG,REAR,RED,KINZIE	1
ALERT DEVICE,VIBR,MOTOR, ROTARY, 11.75 MM X X 4.55 MM MOTOR BODY	2

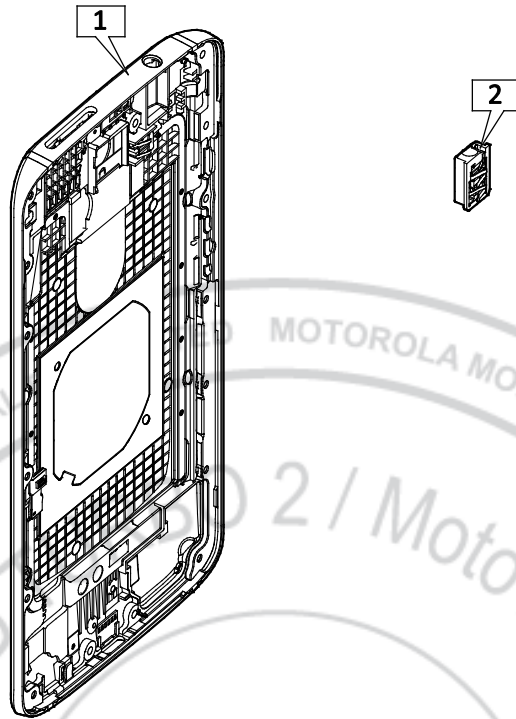
1. Place the Vibrator into the pocket of the Rear Housing.



2. Verify the Vibrator is fully seated in the pocket of the Rear Housing.



## Headset Jack Assembly



Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY	1
ASSY,HSG,REAR,TIN SILVER,KINZIE	
ASSY,HSG,REAR,CHAMPAGNE,KINZIE	
ASSY,HSG,REAR,RED,KINZIE	
CONN,JACK,HEADSET,3.5 MM DIA	2

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 //**

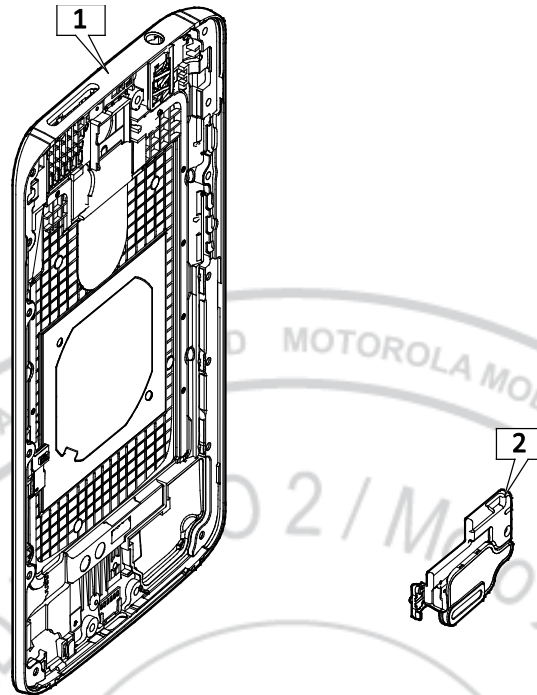
Do not damage the Headset Jack contacts when pressing it into the Rear Housing.



4. Verify the Headset Jack is flush to the edges of the pocket of the Rear Housing.

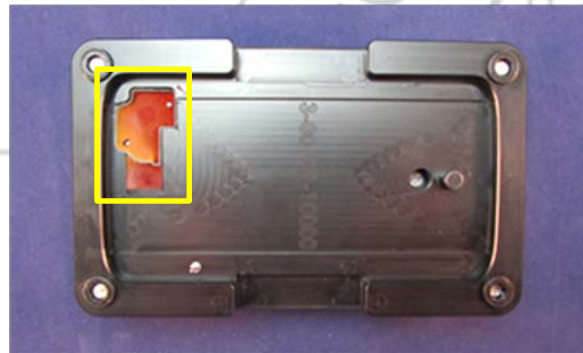


## Loudspeaker Assembly

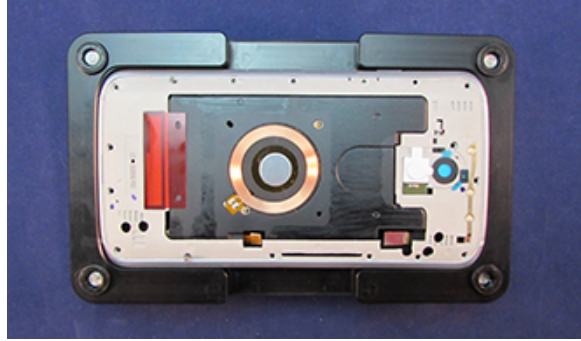


Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY ASSY,HSG,REAR,TIN SILVER,KINZIE ASSY,HSG,REAR,CHAMPAGNE,KINZIE ASSY,HSG,REAR,RED,KINZIE	1
TRANSDUCER,POLYPHONIC,13X18X2P5	2

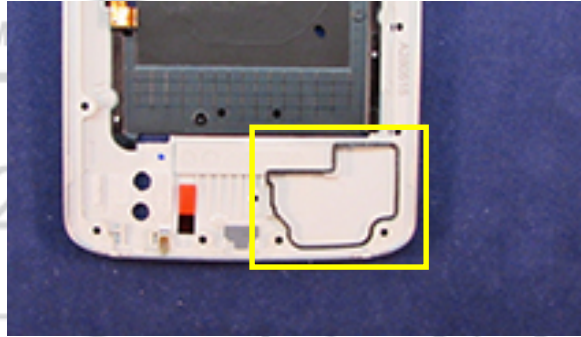
1. Remove the Loudspeaker Adhesive from the carrier.
2. Place the Loudspeaker Adhesive into the Bounce Audio Gasket Alignment Fixture (3-00-D9-10000), using the pins in the fixture to align it.



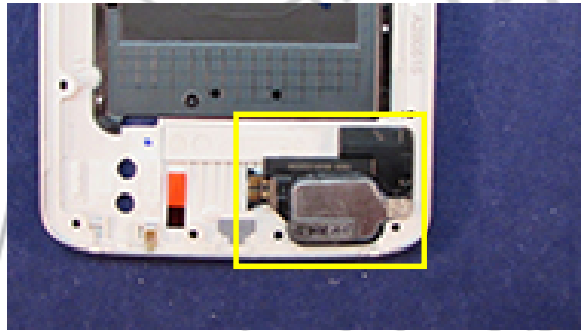
3. Place the Rear Housing into the fixture over the Loudspeaker Adhesive, using the pins in the fixture to align it.
4. Press down on the entire Rear Housing for 5 seconds to secure the adhesive.
5. Remove the Rear Housing from the fixture.



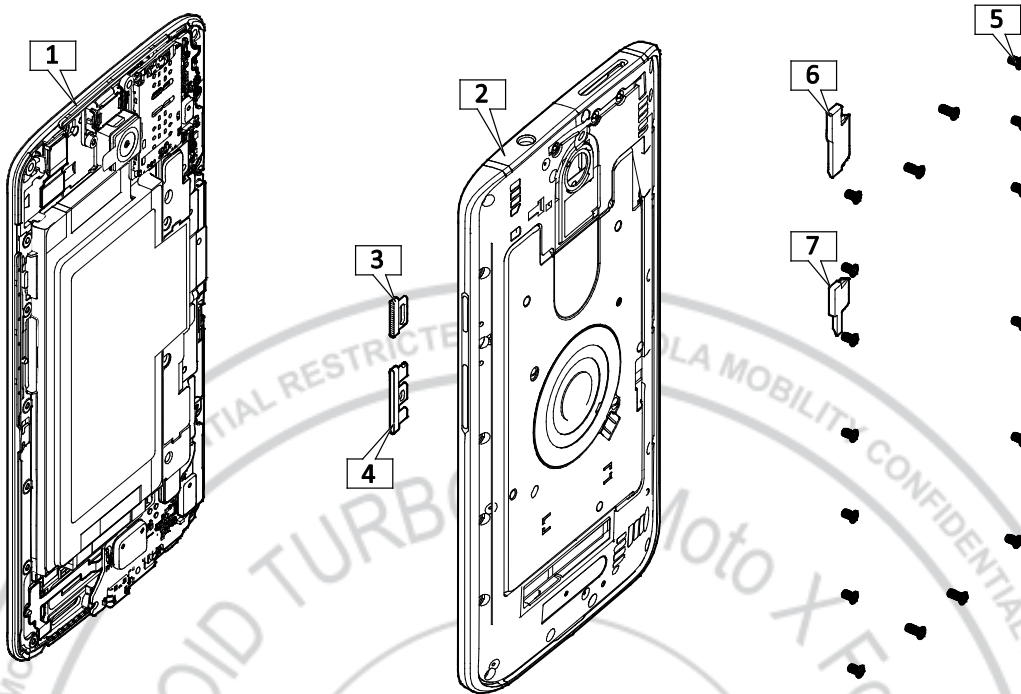
6. Remove the adhesive liner from the Loudspeaker Adhesive.



7. Place the Loudspeaker into the pocket of the Rear Housing.
8. Press down on the Loudspeaker for 5 seconds to secure it to the Rear Housing.



## Rear Housing Assembly

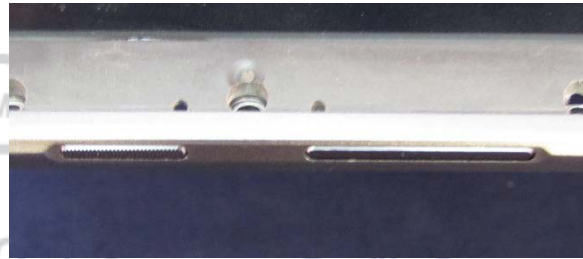
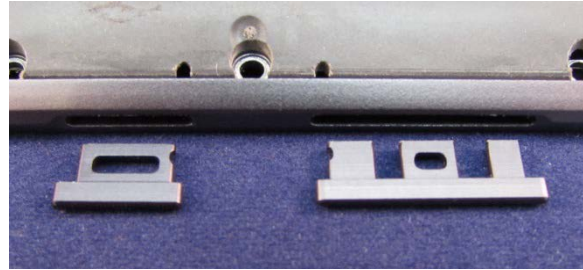


Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE	1
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
ASSY,HSG,REAR,METALLIC DK GRY	2
ASSY,HSG,REAR,TIN SILVER,KINZIE	2
ASSY,HSG,REAR,CHAMPAGNE,KINZIE	2
ASSY,HSG,REAR,RED,KINZIE	2
BTN,POWER,GRAPHITE GRAY,KINZIE	3
BTN,VOLUME,GRAPHITE GRAY,KINZIE	4
SCR,MACH,M1.4	5 (qty 19)
ASSY,HSG,STOPPER,EARPIECE/FLASH,KINZIE	6
ASSY,HSG,STOPPER,NFC CONN	7

1. Remove the protective liners from the Rear-Facing Imager and Loudspeaker Gasket opening if present.



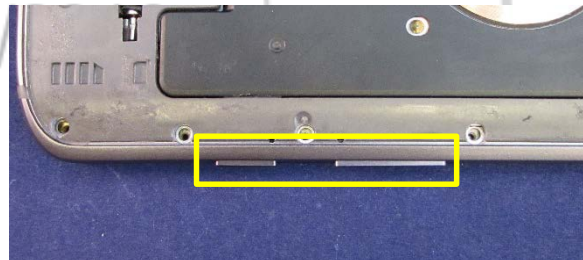
2. Insert the Side Keys into the slots of the Rear Housing. Orient the Side Keys as shown.
3. Push the Side Keys into the slots until they are flush with the edge of the Rear Housing.



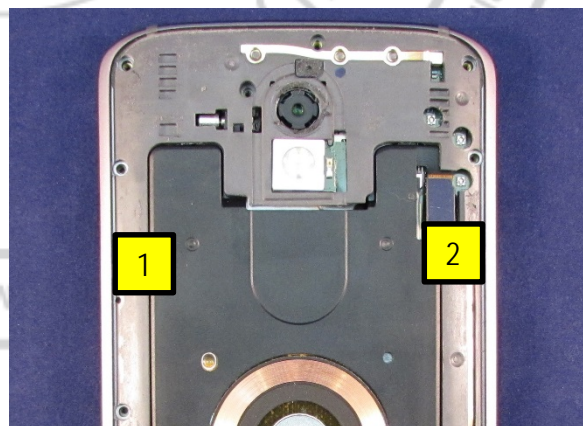
4. Place the Rear Housing over the phone. Place the key side of the Rear Housing over the phone first, then lower the side opposite the Side Keys into position.



5. Verify the profiles of the Side Keys are visible. The Side Keys should no longer be flush with the edge of the Rear Housing.



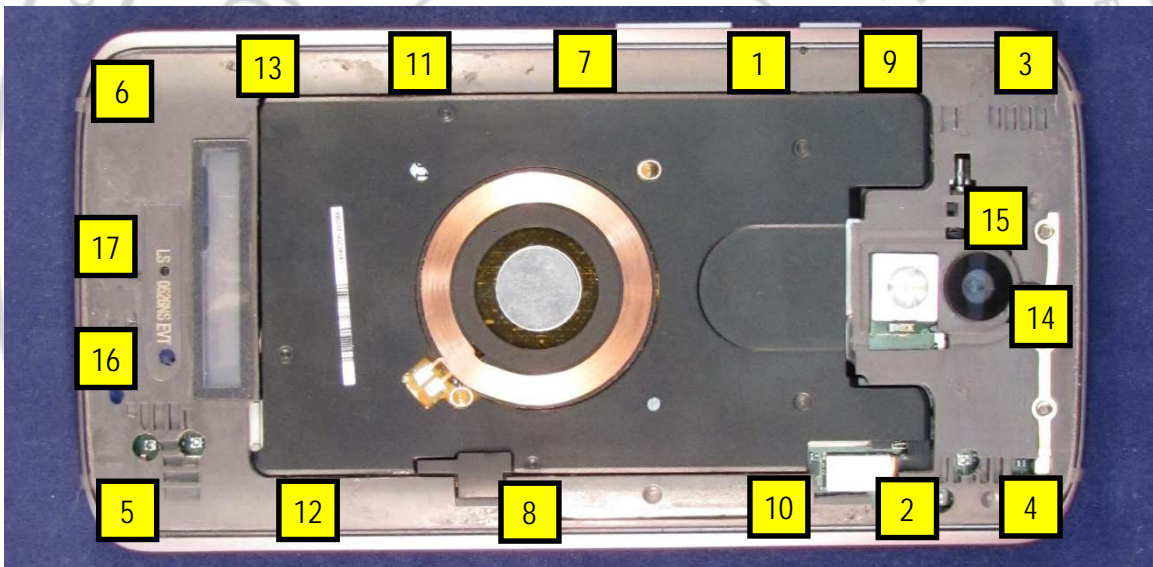
6. Tighten 3IP Screw #1 to 1.0 in-lbs (0.11N m).
7. Press the Power Key and Volume Key several times to verify the tactile response.
8. Tighten 3IP Screw #2 to 1.0 in-lbs (0.11N m).



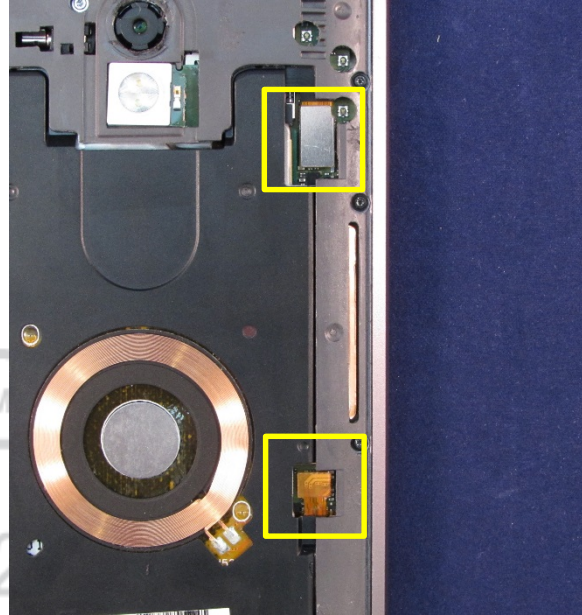
9. Press down on the USB Connector side of the Rear Housing to engage the snaps.



10. Tighten the 17 3IP screws to 1.0 in-lbs (0.11N m) in the order shown.



11. Press down on the Flash Flex BtB Connector to connect it to the PCB.
12. Press down on the NFC Antenna BtB Connector to connect it to the PCB.



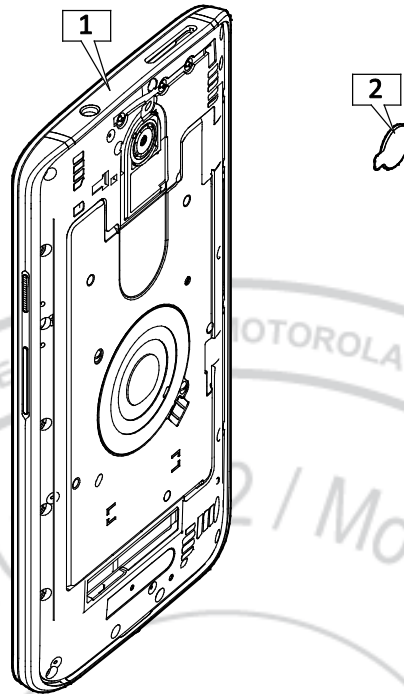
13. Insert the Flash Flex Stopper into the opening of the Rear Housing. The stopper must be inserted at the angle shown.
14. Press down on the Flash Flex Stopper until it snaps into place.



15. Insert the NFC Flex Stopper into the opening of the Rear Housing. The stopper must be inserted at the angle shown.
16. Press down on the NFC Flex Stopper until it snaps into place.



## Rear-Facing Imager Lens Assembly



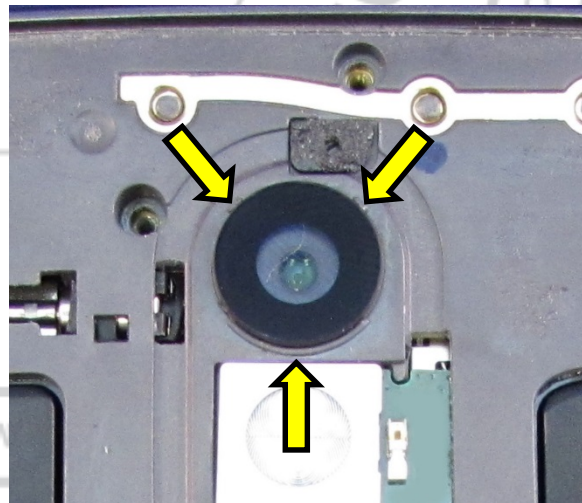
Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY	1
ASSY,HSG,REAR,TIN SILVER,KINZIE	
ASSY,HSG,REAR,CHAMPAGNE,KINZIE	
ASSY,HSG,REAR,RED,KINZIE	
LENS,IMAGER,REAR	2

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 features to align the lens.

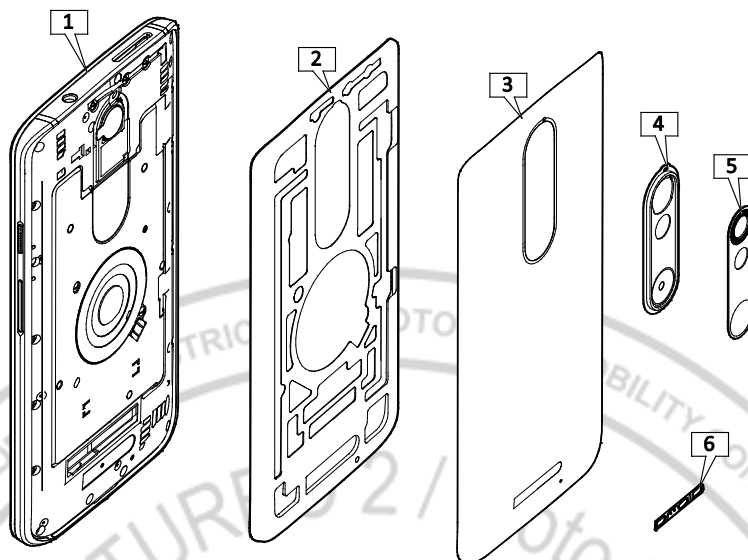
### NOTE

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.



## Rear Inlay Assembly



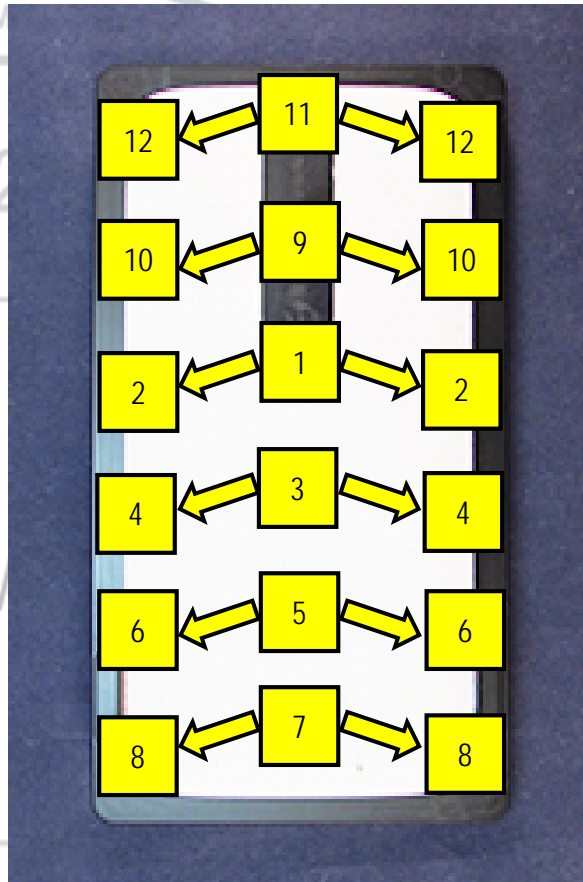
Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY ASSY,HSG,REAR,TIN SILVER,KINZIE ASSY,HSG,REAR,CHAMPAGNE,KINZIE ASSY,HSG,REAR,RED,KINZIE	1
DIE CUT,ADHESIVE,INLAY,REAR COVER	2
ASSY,HSG,INLAY,CSR,BLACK,REAR COVER,ROW ASSY,HSG,INLAY,CSR,WINTER WHITE,REAR COV ASSY,HSG,INLAY,NYLON,BLACK,REAR CVR ASSY,HSG,INLAY,NYLON,BLACK,ROW,REAR CVR ASSY,HSG,INLAY,NYLON,GRAY,ROW,REAR CVR	3
BZL,DECO,REAR,METALLIC DK GRY BZL,DECO,REAR,METALLIC SLVR BZL,DECO,REAR,METALLIC RED	4
ASSY,CAMR DECO,METALLIC SLVR ASSY,CAMR DECO,METALLIC DK GRY ASSY,CAMR DECO,METALLIC CHMPGN ASSY,CAMR DECO,BLACK	5
ASSY,DROID LOGO,DARK MTLG GRAY,KINZIE ASSY,DROID LOGO,DARK MTLG SILVER,KINZIE ASSY,DROID LOGO,METALLIC CHAMPAGNE,TALL,KINZIE ASSY,DROID LOGO,DARK GRAY/BLACK,KINZIE	6

1. Place the Inlay Adhesive into the Bounce Inlay Adhesive Fixture (3-00-E8-10000), using the pin in the fixture and the deco hole in the adhesive to align it.
2. Remove the adhesive liner from the Inlay Adhesive.



3. Place the Rear Inlay into the fixture over the Inlay Adhesive, using the pin in the fixture and the deco hole to align it.
4. Apply manual pressure to the Rear Inlay as follows:

- Place both thumbs on point 1 and slide them out to point 2.
- Place both thumbs on point 3 and slide them out to point 4.
- Place both thumbs on point 5 and slide them out to point 6.
- Place both thumbs on point 7 and slide them out to point 8.
- Place both thumbs on point 9 and slide them out to point 10.
- Place both thumbs on point 11 and slide them out to point 12.



5. Remove the Rear Inlay from the fixture.
6. Place the Rear Inlay on a flat surface.

7. Remove the adhesive liner from the Camera Deco.
8. Place the Camera Deco on the Rear-Facing Imager Bezel, aligning the Bezel Lens.
9. Press down on the Camera Deco for 5 seconds to secure it to the Rear-Facing Imager Bezel.



10. Remove the Rear-Facing Imager Bezel adhesive liner from the Rear Inlay.
11. Place the Rear-Facing Imager Bezel into position on the Rear Inlay. Verify the Bezel Lens is oriented toward the top of the Rear Inlay.
12. Press down on the Rear-Facing Imager Bezel for 5 seconds to secure it to the Rear Inlay.



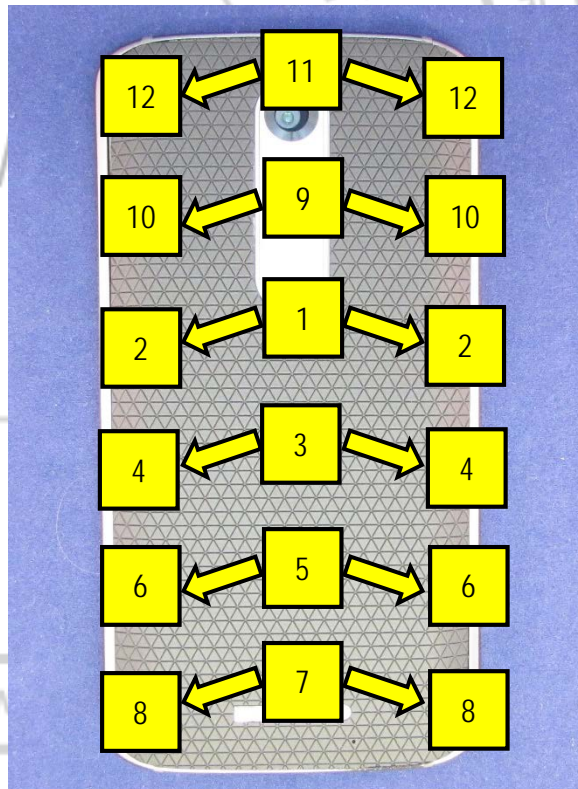
13. Use a cotton swab to apply 3M Adhesion Promoter 111 to the Rear Housing in the highlighted area.



14. Verify the liners on the Rear Housing and Flash Lens have been removed, if present.
15. Remove the remaining adhesive liner from the Rear Inlay.
16. Beginning at the top corners, apply the Rear Inlay to the Rear Housing.
17. Verify the Inlay is seated in all 4 corners and not overlapping any of the Rear Housing edges.

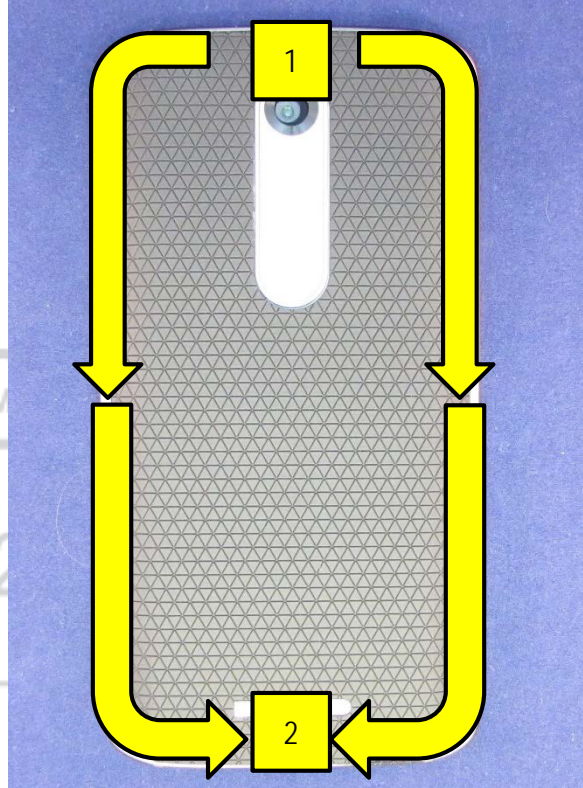


18. Apply manual pressure to the Rear Inlay as follows:
  - Place both thumbs on point 1 and slide them out to point 2.
  - Place both thumbs on point 3 and slide them out to point 4.
  - Place both thumbs on point 5 and slide them out to point 6.
  - Place both thumbs on point 7 and slide them out to point 8.
  - Place both thumbs on point 9 and slide them out to point 10.
  - Place both thumbs on point 11 and slide them out to point 12.





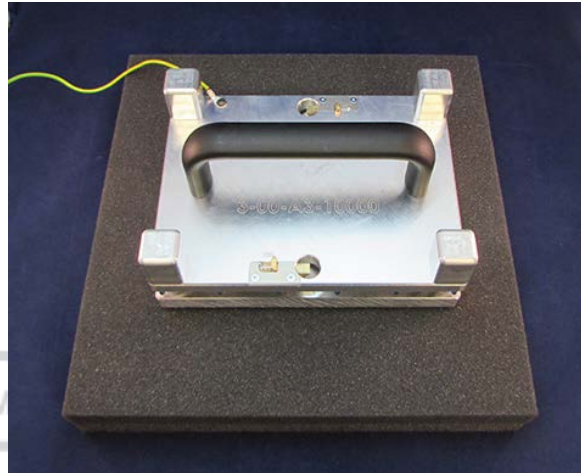
19. Place both thumbs on point 1 and slide them around the perimeter of the Rear Inlay to point 2.



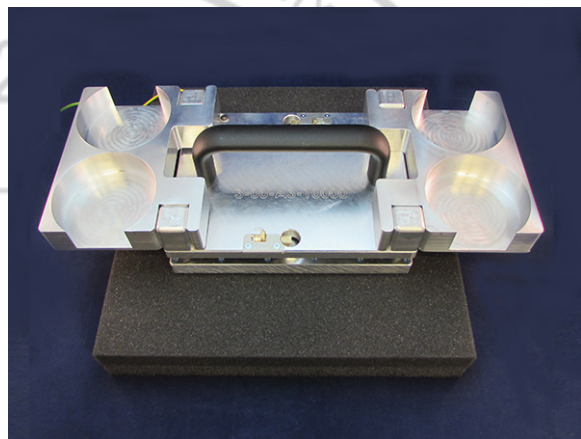
20. Place the phone onto the Universal Nest (3-00-A7-10000), with the Display side face up.



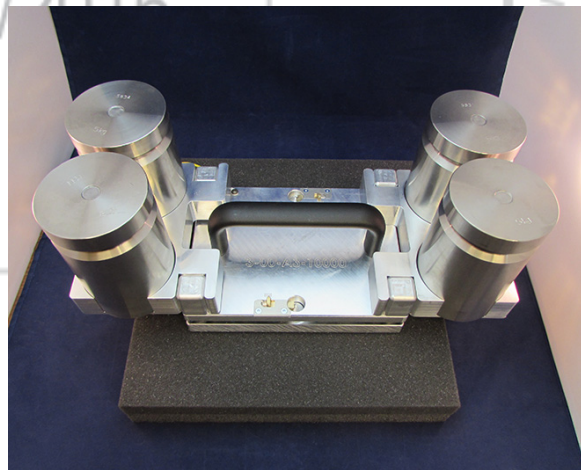
21. Place the Universal Press Fixture (3-00-A3-10000) onto the Universal Nest over the phone.



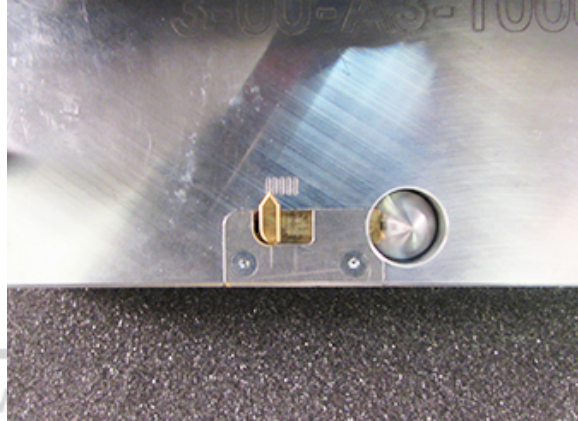
22. Place the brackets for the Universal Press Weights onto the Universal Press Fixture.



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



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



26. Remove the adhesive liner from the DROID Logo.
27. Place the DROID Logo in the recess in the Rear Inlay. Align the left, straight edge of the Logo first.

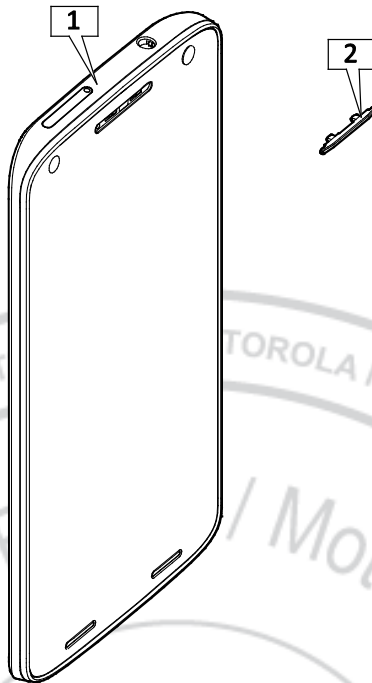


**NOTE**

The DROID Logo can be placed by hand or using the Plastic Tweezers.

28. Press down on the DROID Logo for 5 seconds to secure it to the Rear Inlay.

## Audio Deco Assembly



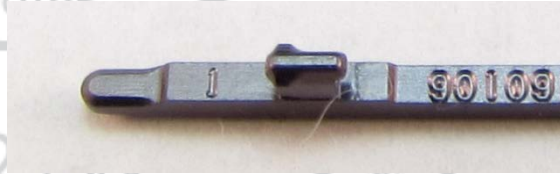
Description	Reference #
ASSY,HSG,LENS W/ FRNT HOUSING,PSA,BLACK,ROW,KINZIE ASSY,HSG,LENS W/ FRNT HOUSING,PSA,WHITE,ROW,KINZIE	1
ASSY,HSG,AU DECO,T&R,METALLIC RED,KINZIE (REWORK) BZL,AU DECO,METALLIC BLK (REWORK) BZL,AU DECO,METALLIC SLVR (REWORK) BZL,AU DECO,METALLIC DK GRY (REWORK) ASSY,HSG,AU DECO,T&R,METALLIC RED,KINZIE (ORIGINAL) BZL,AU DECO,METALLIC BLK (ORIGINAL) BZL,AU DECO,METALLIC SLVR (ORIGINAL) BZL,AU DECO,METALLIC DK GRY (ORIGINAL)	2

**NOTE**

When the Display is new, assemble using an original Audio Bezel. When the Display is reused, assemble using a rework Audio Bezel, which has added features on the tab.



Original Audio Bezel

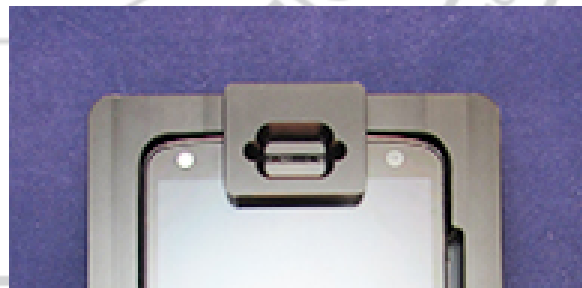


Rework Audio Bezel

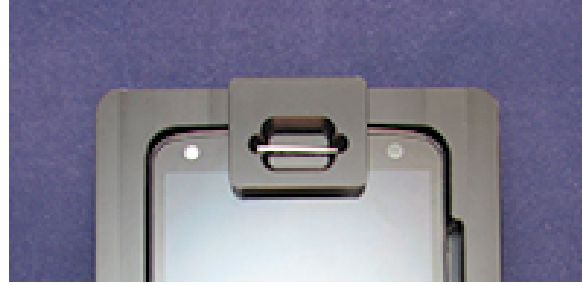
1. Place the phone into the Bounce Earpiece Deco Press Fixture (3-00-D8-10000).



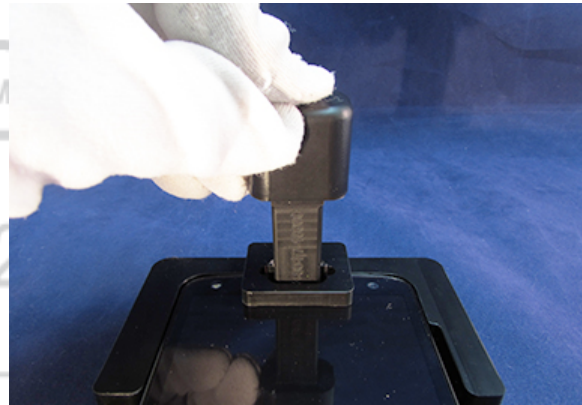
2. Place the alignment lid on the fixture over the Display, using the pins in the fixture to align it.



3. Insert the Audio Bezel into the slot in the alignment lid.



4. Use the Bounce Audio Bezel Press Tool (3-00-F7-10000) to press the Audio Bezel into the Display.



## SIM/SD Tray Assembly



Description	Reference #
ASSY,HSG,REAR,METALLIC DK GRY ASSY,HSG,REAR,TIN SILVER,KINZIE ASSY,HSG,REAR,CHAMPAGNE,KINZIE ASSY,HSG,REAR,RED,KINZIE	1
ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,DARK MTLG GRAY, KINZIE ASSY,HSG,SIM DOOR,FULL FLOOR TRAY,LIGHT ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,METALLIC DK GRAY ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,METALLIC SILVER,KI ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,METALLIC CHAMPAGNE ASSY,HSG,SIM DOOR, FULL FLOOR TRAY,SINGLE SIM,RED,KINZIE	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.

