

Lenovo

Moto E5 Play



Moto E5 Play

Level 2 – Service and Repair Manual

REVISION HISTORY

Revision	Date	Notes
1	07/16/2018	Initial release.
2	11/05/2018	<ul style="list-style-type: none">Added parts to the Assembly section: Speaker FPC, WiFi Antenna, and Diversity Antenna.Removed parts from the Assembly section: Rear Housing and Main Antenna.

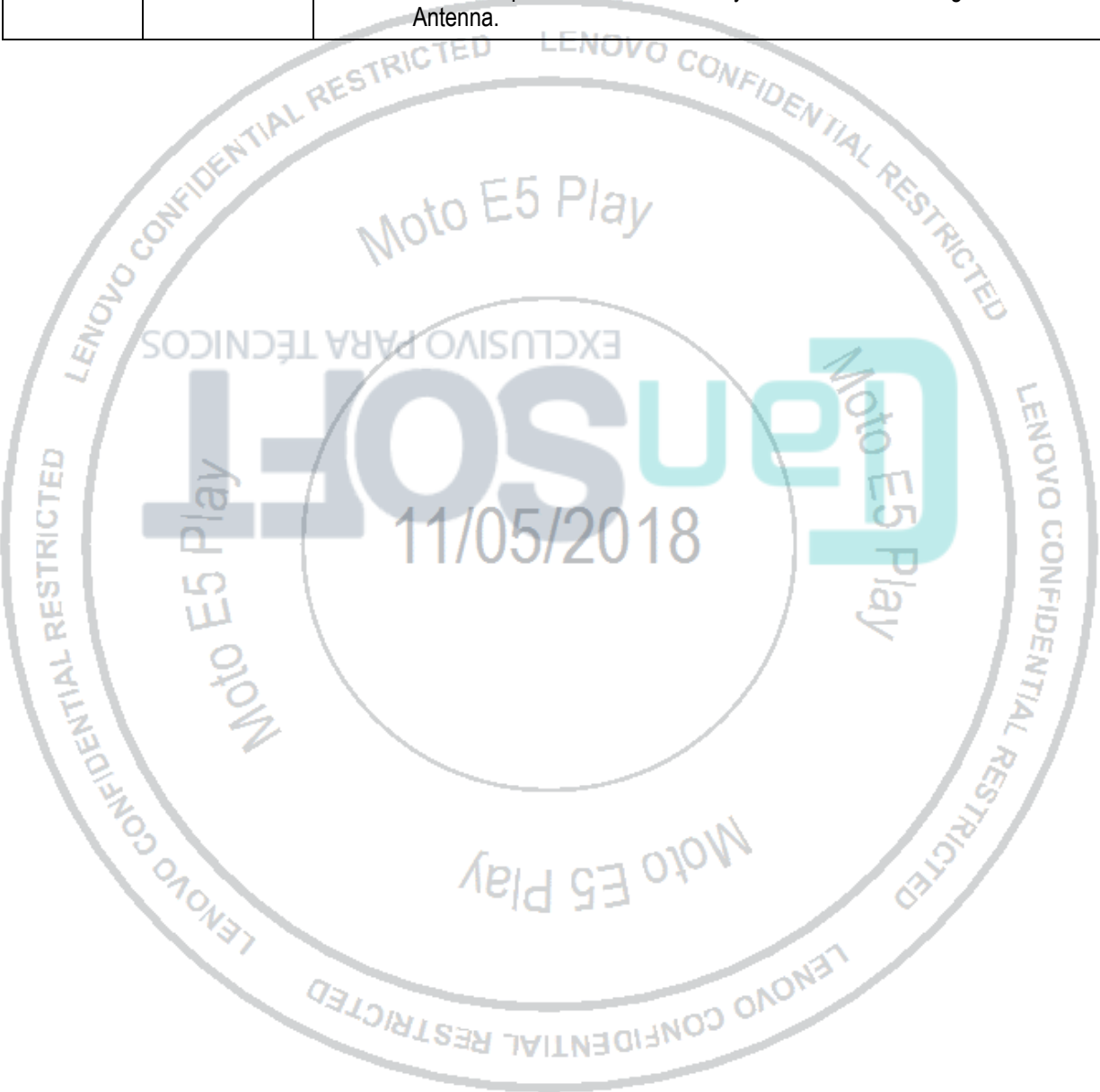


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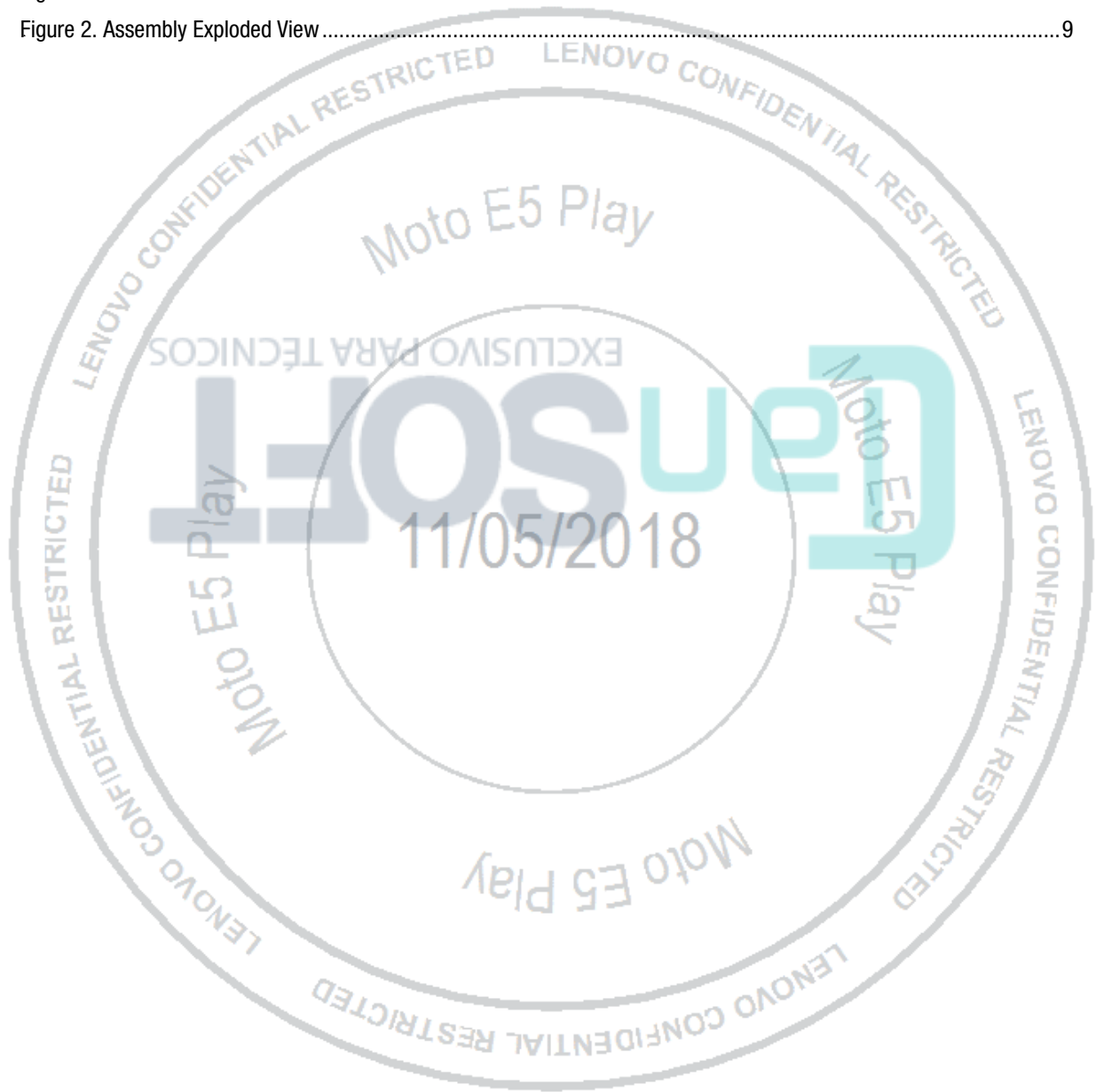
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SAFETY INFORMATION

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

Reference #	Description
1	Secondary Microphone
2	Headset Jack
3	Front-Facing Imager
4	Speaker Mesh
5	Front-Facing Flash
6	Display
7	Volume Key

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Reference #	Description
8	Power Key
9	Rear-Facing Imager
10	Rear-Facing Flash
11	Primary Microphone
12	USB Port



EXPLODED VIEWS

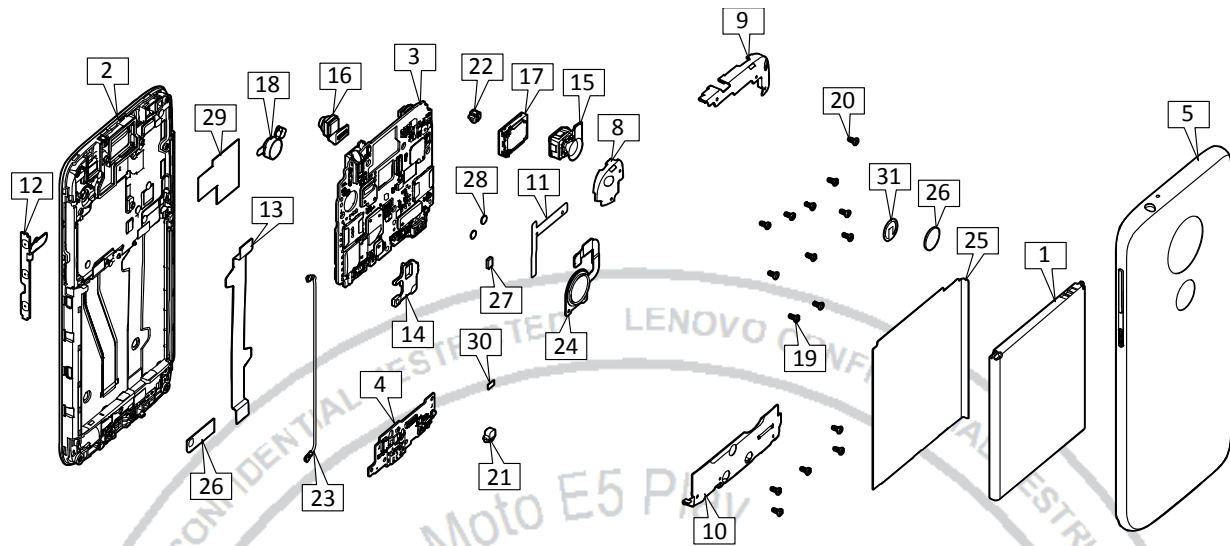


Figure 2. Assembly Exploded View

Table 2. Assembly Exploded View Parts List

Reference #	Description	Recovery Part
1	ACCY,BAT,2120mAh,JE30,ATL355763,ATL,ROW	YES
2	XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	YES
3	XT1920-19 MB_1+16G_DS&715201006731CS XT1920-16 MB_1+16G_DS&715201006761CS XT1920-15 MB_1+16G_SS&715201006771CS XT1920-18 MB_1+16G_SS&715201006781CS ASSY,BD KIT,Golf Lite 2+16 DS CKD	YES
4	XT1920-18 Sub board&715201006741CS XT1920-15 Sub board&715201006791CS ASSY,DTR BRD,Golf Lite ANT BR AR	YES
5	XT1920-16 Batt Cover_BL&712601007191CS XT1920-16 Batt Cover_GL&712601007201CS WT+7126CK001741+Batcover Assy WT+7126CK001891+Batcover Assy GLD XT1920 Rear housing_DS&711500309411CS XT1920 Rear housing_SS&711500309401CS XT1920 Rear housing_BOT&711500309421CS	YES
8	WT+711100309071+DIV Antenna_S XT1920-15 BWG ANT&711100309111 CS	NO

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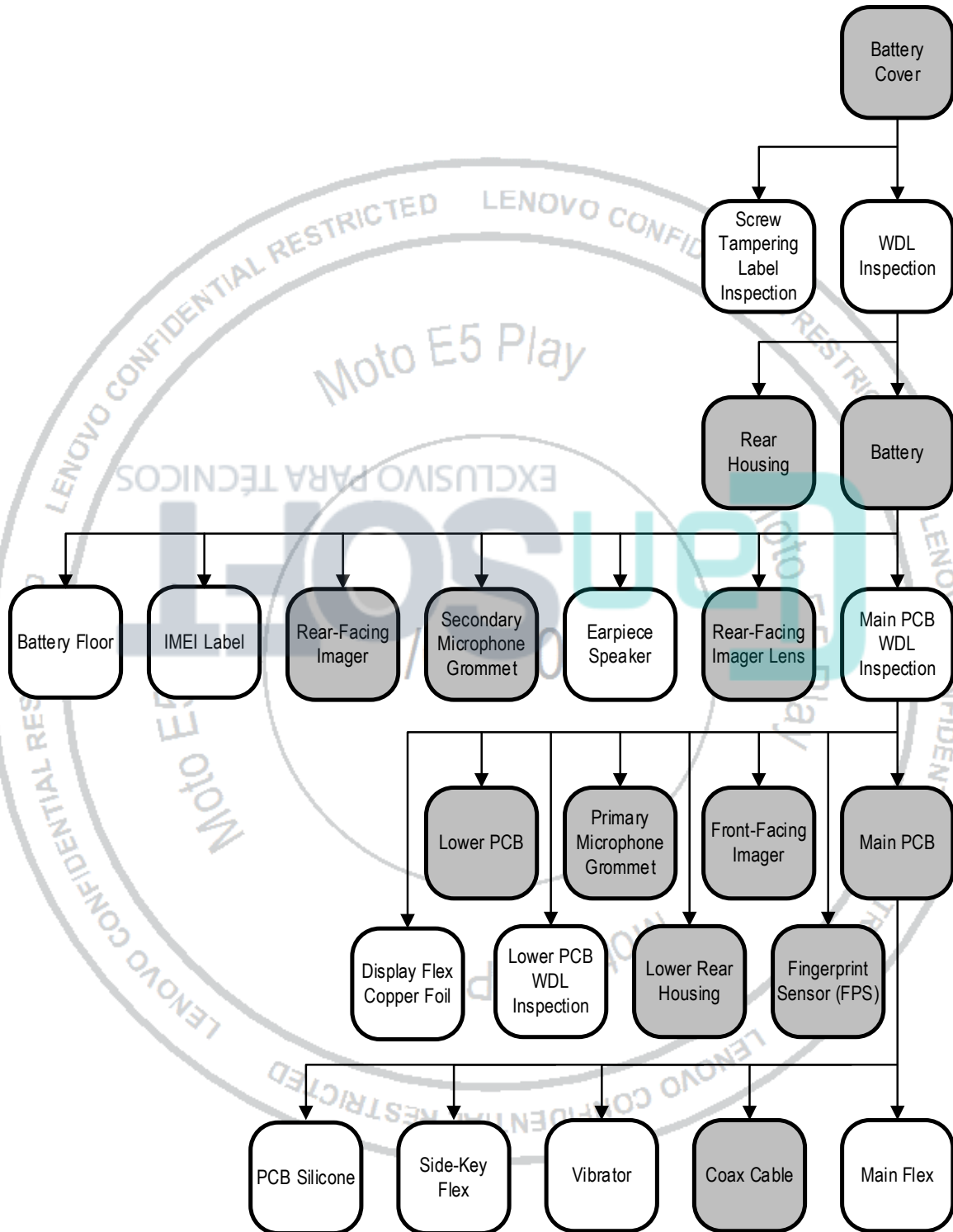
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Reference #	Description	Recovery Part
9	XT1920-15 DIV ANT&711100309101 CS WT+711100309071+DIV Antenna_S	NO
10	XT1920-15 Main ANT&711100309091 CS WT+711100309061+MAIN Antenna_S	NO
11	WT+713300309041+SPK FPC	YES
12	WT+713300309021+Sidekey FPC	YES
13	WT+713300309011+Main FPC	NO
14	WT+711500309051+FPS holder	NO
15	IMGR MDL,CMOS,8MP,8.56MMX8.62MMX4.66MM,M	NO
16	WT+710200309061+Front Cam 5M_QH	NO
17	WT+710324100221+SPK	YES
18	WT+710613000071+Zach Motor_A	YES
19	WT+710922000611+Screw BLK	YES
20	WT+710921000771+Screw WHT	YES
21	WT+712300309031+Sub Mic Rubber	NO
22	WT+712300309021+Main Mic Rubber	YES
23	WT+715302000691+Coaxial Cable	NO
24	MDL,FNGRPRT,Golf lite,ET516,RING,CTG,BLK	NO
25	WT+712700309021+Bat Mylar_FQ	NO
26	WT+711900309011+Rear Cam Lens	NO
27	WT+712400309011+FPS Ground Sponge	NO
28	WT+702703802391+waterproof	NO
29	WT+712100309031+ TP FPC Copper	NO
30	WT+712700207041+Water detector	NO
31	XT1920-15 R-CAM Lens Adhe&712100309111CS	
--	WT+712700207031+IMEI label	NO

*Refer to this table as a reference to parts listed in the [Assembly](#) section.

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 Moto E5 Play phone.

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Blackstick	--	
T5 Torx Bit	--	
Torque Driver (Adjustable)	--	
Shim	4-00-5L-10000	
Thin Plastic Spudger	0-00-00-40826	
Tweezers (Plastic or Plastic-Tipped)	--	--
Tweezers (Metal)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--

Battery Cover Removal

NOTE

The Battery Cover can be recovered and reused after removal.



1. Use the Shim to release the snaps at the bottom right corner of the phone as shown.
2. Continue to disengage the Battery Cover snaps around the edges of the phone.
3. Use your fingers to remove the Battery Cover from the Front Housing as shown.

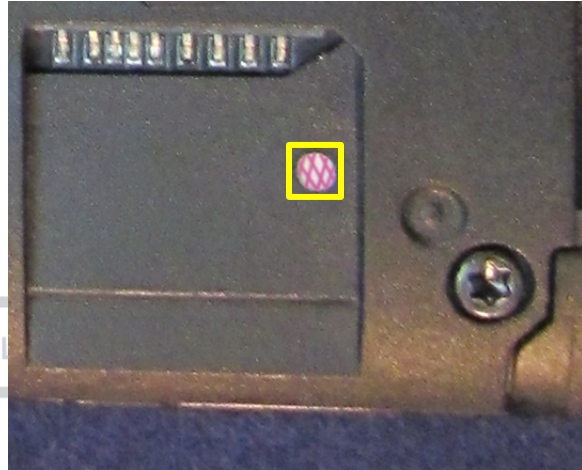


Water Detection Label (WDL) Inspection

NOTE

If the WDL is activated, the phone's warranty no longer applies.

Inspect the WDL on the Main PCB, which is visible through the hole located in the SD Slot on the Rear Housing. Verify it is placed correctly and examine it for signs of activation.



Screw Tampering Label Inspection

NOTE

If either of the Screw Tampering Labels are damaged, the phone's warranty no longer applies.

1. Inspect the Screw Tampering Label on the Lower Rear Housing. Verify it is placed correctly and examine it for signs of tampering.
2. Inspect the Screw Tampering Label on the Upper Rear Housing. Verify it is placed correctly and examine it for signs of tampering.



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 if it is undamaged.



1. From the recess at the bottom of the Battery, use the Shim to press upwards on the Battery to release it from the phone.
2. Lift the Battery out of the pocket in the Front Housing.



Rear Housing Removal

NOTE

The Rear Housing can be recovered and reused after removal.



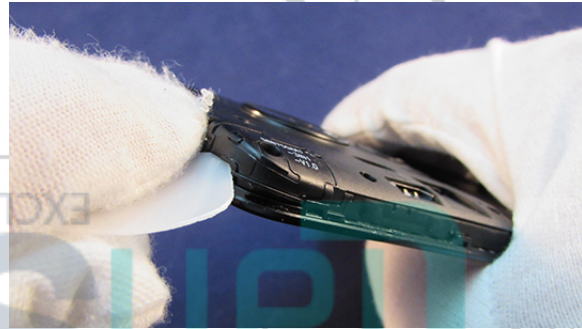
1. Use the Torque Driver and the T5 Torx Bit to remove the 10 T5 Torx Machine Screws from the Rear Housing.

NOTE

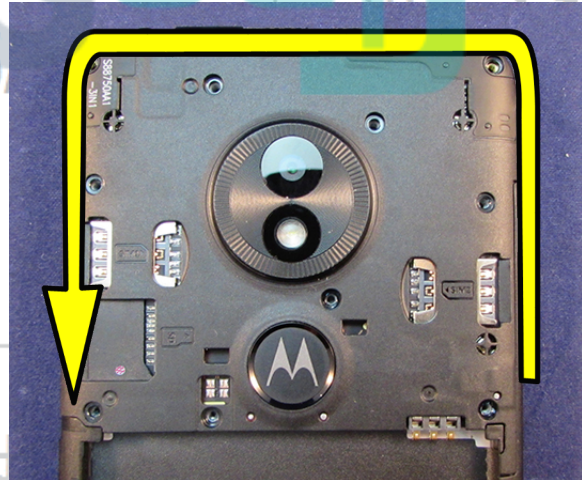
After you remove the Machine Screws, you cannot reuse them.



2. Insert the Thin Plastic Spudger between the Rear Housing and Front Housing and disengage the side snap.



3. Continue to disengage the snaps around the edges of the Rear Housing.



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4. Lift the Rear Housing and remove it from the Front Housing.

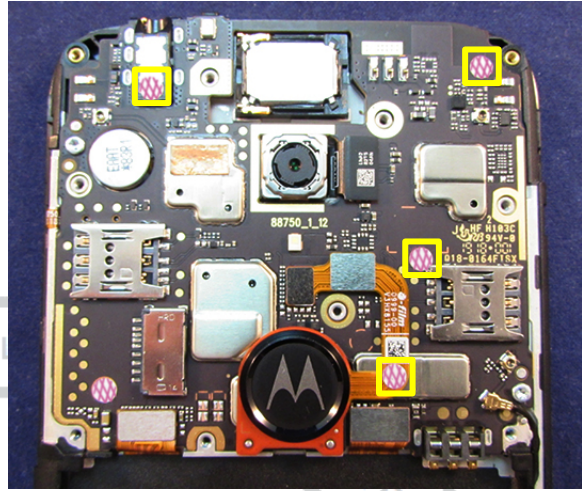


Main PCB WDL Inspection

NOTE

If any of the WDLs are activated, the phone's warranty no longer applies.

Inspect the 4 other WDLs indicated on the Main PCB and attached components. Verify they are placed correctly and examine them for signs of activation.



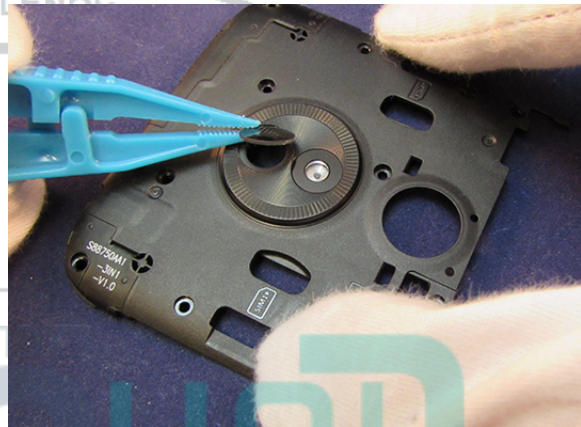
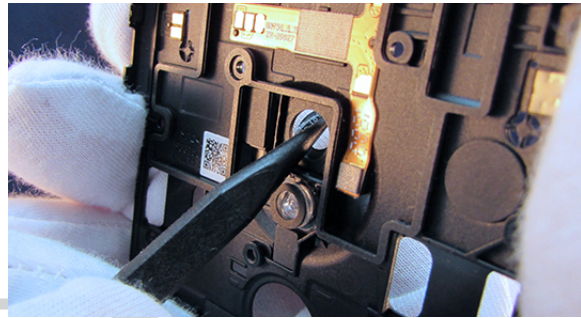
Rear-Facing Imager Lens Removal

NOTE

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



1. Use the pointed end of the Blackstick to gently push the Rear-Facing Imager Lens away from the Rear Housing.
2. Use the Plastic Tweezers to lift the Rear-Facing Imager Lens from the pocket on the Rear Housing.



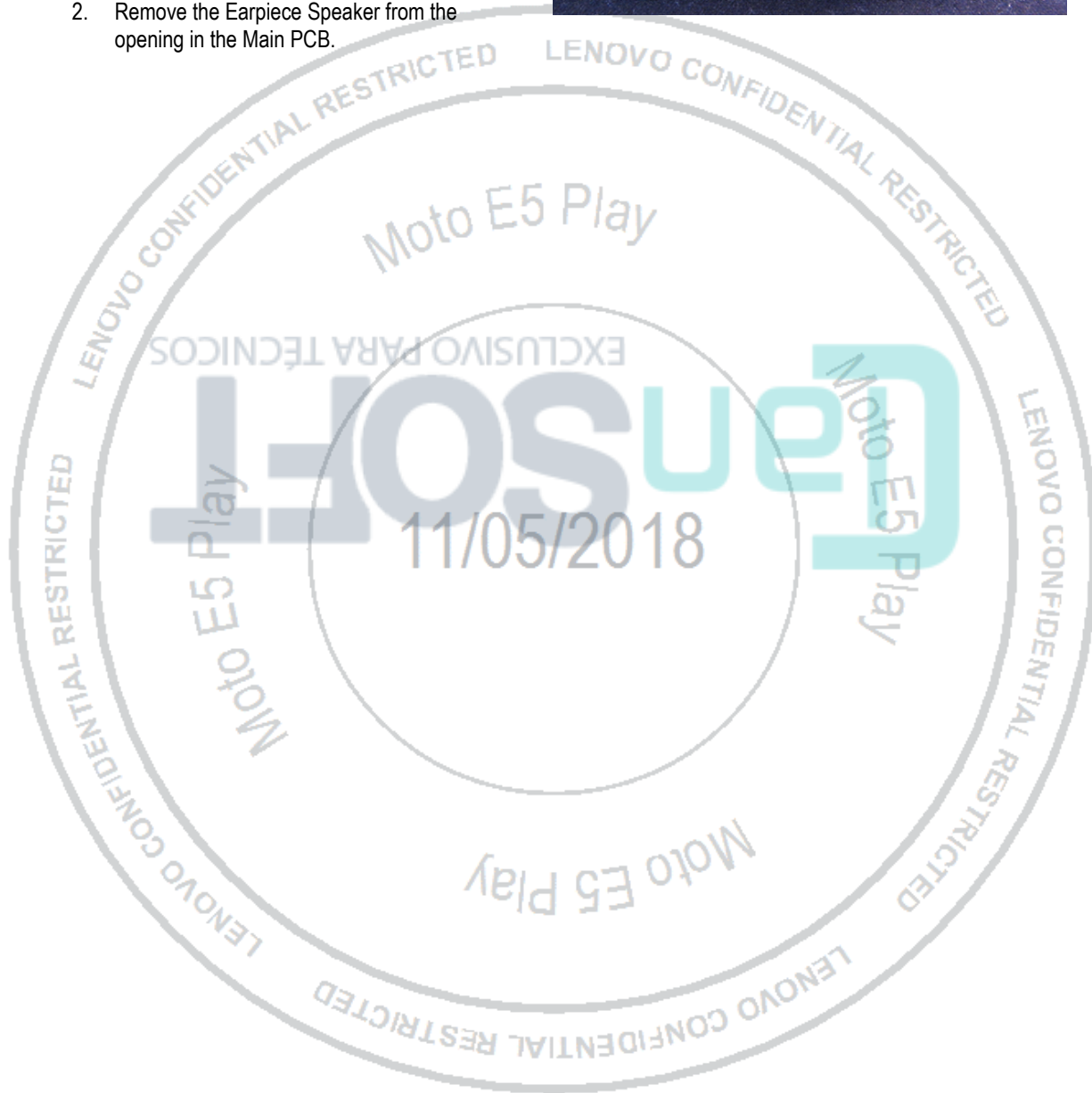
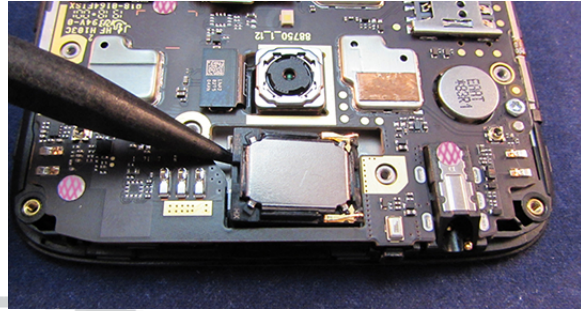
Earpiece Speaker Removal

NOTE

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



1. Use the pointed end of the Blackstick to pry up the Earpiece Speaker through the opening in the Main PCB at the location shown.
2. Remove the Earpiece Speaker from the opening in the Main PCB.



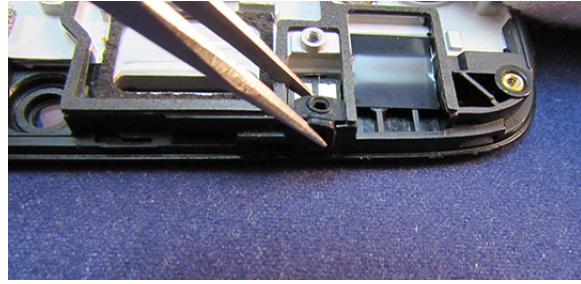
Secondary Microphone Grommet Removal

NOTE

The Secondary Microphone Grommet can be recovered and reused after removal.



Use the Tweezers to remove the Secondary Microphone Grommet from the pocket in the Front Housing.



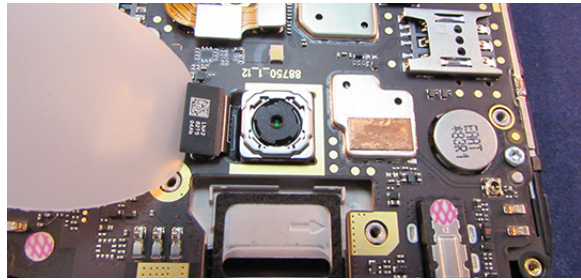
Rear-Facing Imager Removal

NOTE

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



1. Use the Thin Plastic Spudger to disengage the BtB Connector from the Main PCB.
2. Remove the Rear-Facing Imager from the opening in the Main PCB.



IMEI Label Removal

NOTE

After you remove the IMEI Label, you cannot reuse it. You will have to print and attach a new label.



Use the Tweezers to remove the IMEI Label from the Battery Floor.



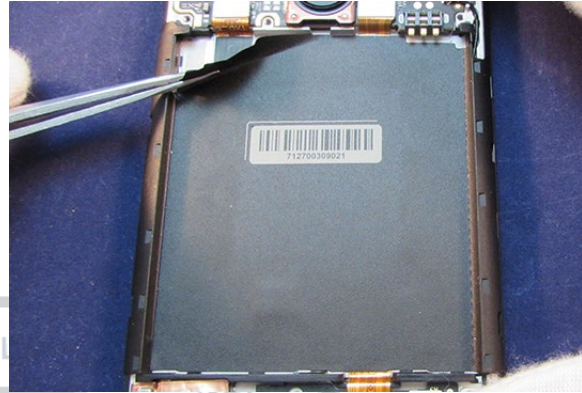
Battery Floor Removal

NOTE

After you remove the Battery Floor, you cannot reuse it.



1. Use the Tweezers to peel up one corner of the Battery Floor as shown.
2. Use your fingers to completely peel the Battery Floor from the Front Housing.



Main PCB Removal

NOTE

The Main PCB can be recovered and reused after removal.



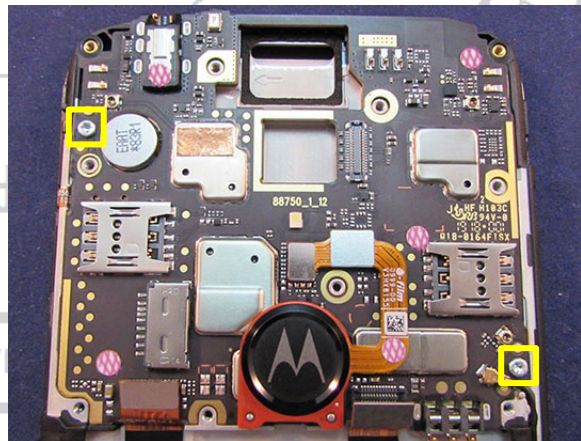
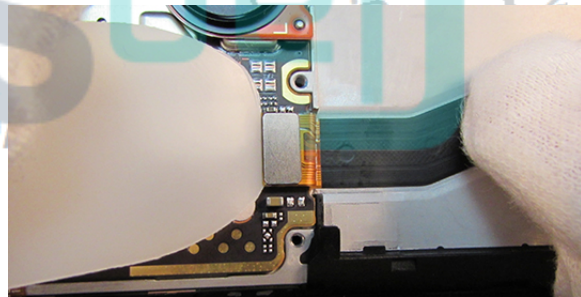
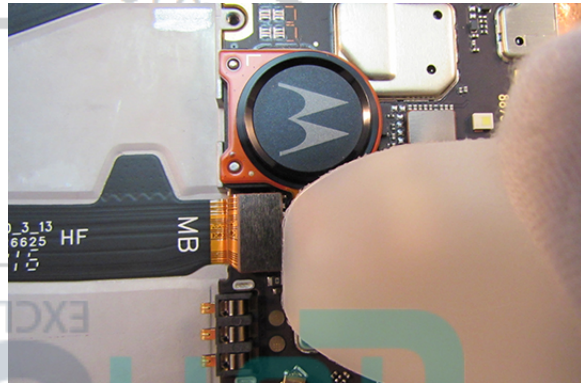
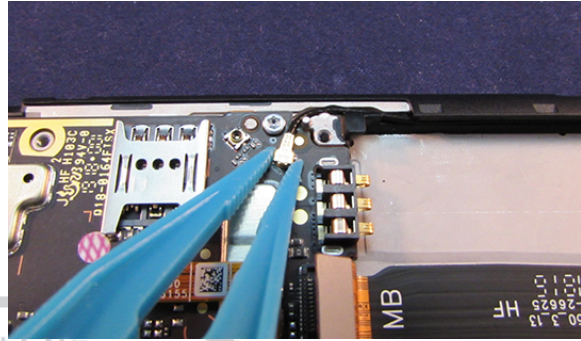
1. Use the Plastic Tweezers to disconnect the Coax Cable BtB Connector from the Main PCB.
2. Use the Thin Plastic Spudger to disengage the Main Flex BtB Connector from the Main PCB.
3. Use the Thin Plastic Spudger to disengage the Display Flex BtB Connector from the Main PCB.
4. Use the Torque Driver and the T5 Torx Bit to remove the 2 T5 Torx Machine Screws from the Main PCB.

NOTE

After you remove the Machine Screws, you cannot reuse them.



5. Remove the Main PCB from the pocket in the Front Housing.



Fingerprint Sensor Removal

NOTE

The Fingerprint Sensor (FPS) can be recovered and reused after removal.



1. Use the Thin Plastic Spudger to disengage the FPS BtB Connector from the Main PCB.
2. Use the flat end of the Blackstick to loosen the FPS from the Main PCB.
3. Lift the FPS from the Main PCB.
4. Use the Thin Plastic Spudger to pry the FPS Holder from the back of the FPS.

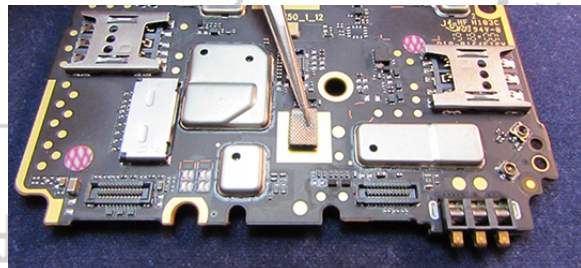
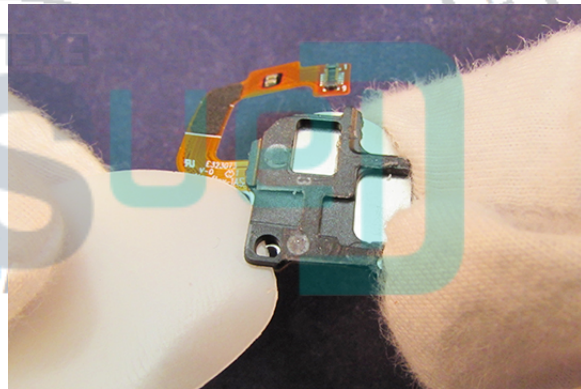
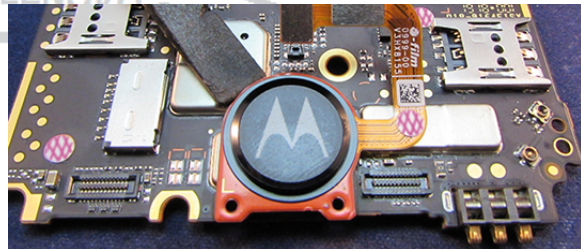
//CAUTION//

Use care not to damage the FPS.

5. Use the Tweezers to remove the FPS Conductive Foam from the Main PCB.

NOTE

After you remove the FPS Conductive Foam, you cannot reuse it.



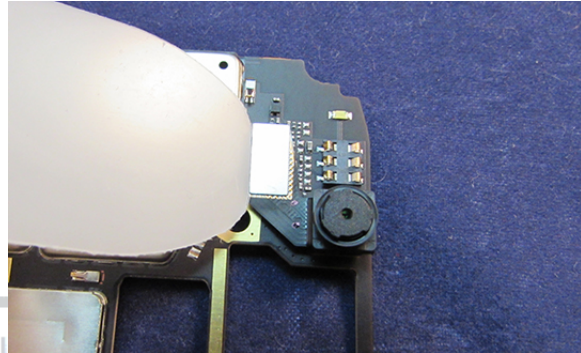
Front-Facing Imager Removal

NOTE

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



1. Use the Thin Plastic Spudger to disengage the Front-Facing Imager BtB Connector from the Main PCB.
2. Use your fingers to remove the Front-Facing Imager from the opening in the Main PCB.



Lower Rear Housing Removal

NOTE

The Lower Rear Housing can be recovered and reused after removal.



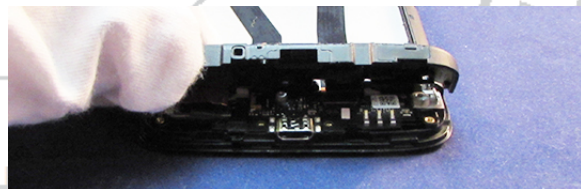
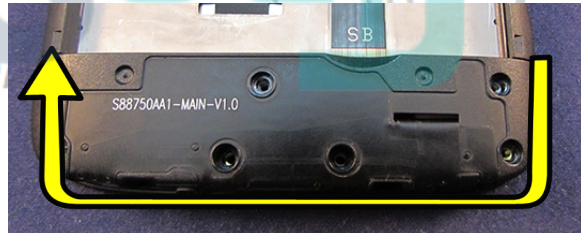
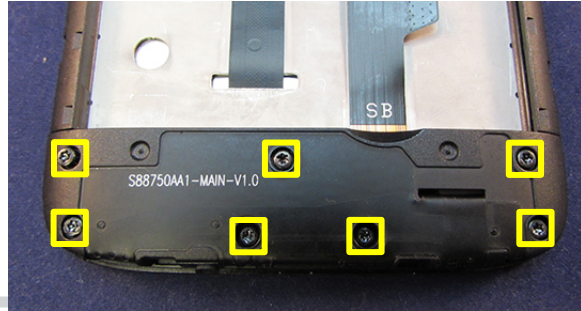
1. Use the Torque Driver and the T5 Torx Bit to remove the 7 T5 Torx Machine Screws from the Lower Rear Housing.

NOTE

After you remove the Machine Screws, you cannot reuse them.



2. Insert the Thin Plastic Spudger between the Lower Rear Housing and the Front Housing and disengage the side snaps.
3. Continue to disengage the snaps around the edges of the Rear Housing.
4. Lift the Lower Rear Housing and remove it from the Front Housing.



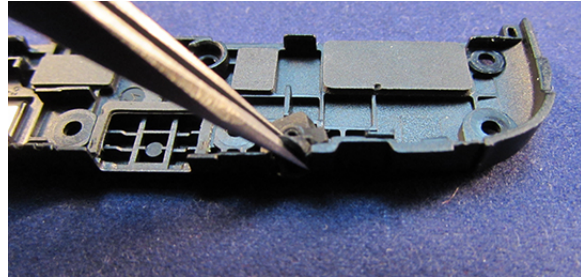
Primary Microphone Grommet Removal

NOTE

The Primary Microphone Grommet can be recovered and reused after removal.



Use the Tweezers to remove the Primary Microphone Grommet from the Front Housing.

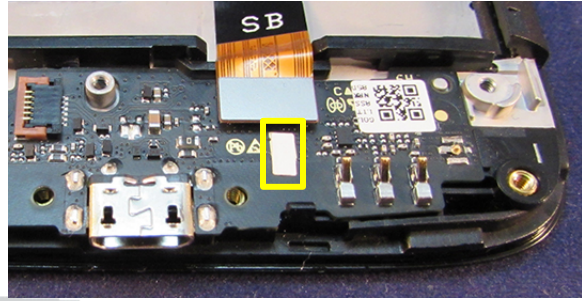


Lower PCB WDL Inspection

NOTE

If the WDL is activated, the phone's warranty no longer applies.

Inspect the WDL on the Lower PCB. Verify it is placed correctly and examine it for signs of activation.



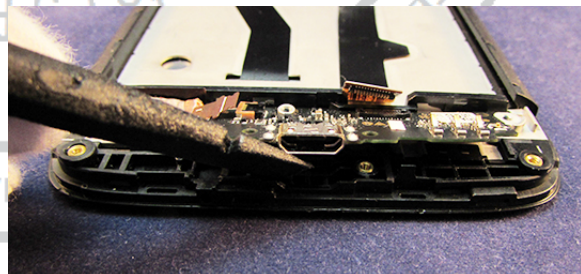
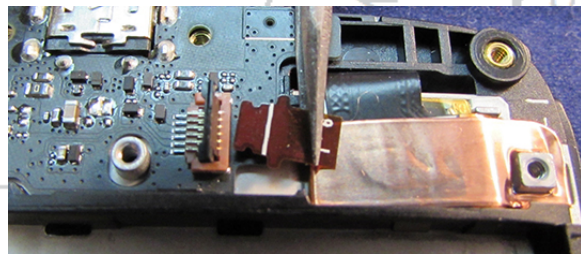
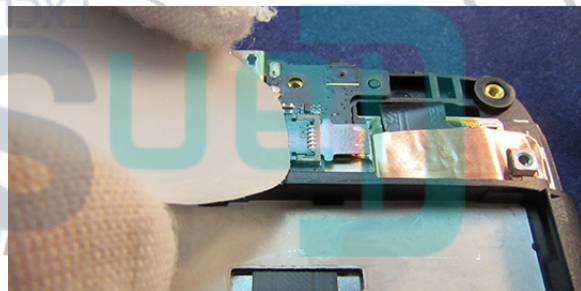
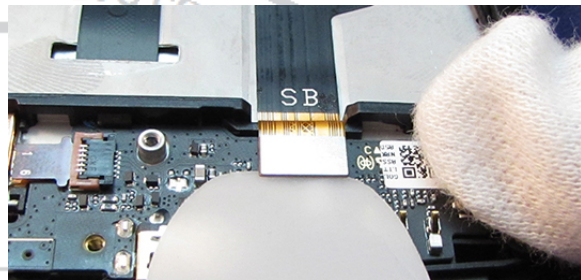
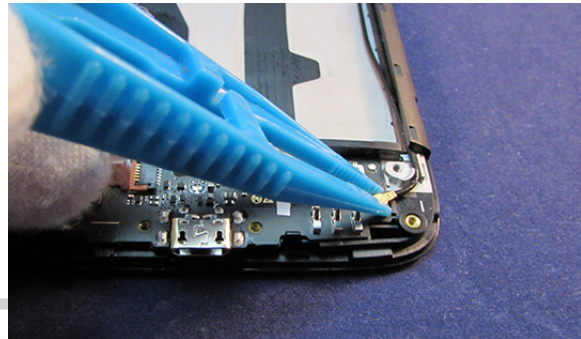
Lower PCB Removal

NOTE

The Lower PCB can be recovered and reused after removal.



1. Use the Plastic Tweezers to disconnect the Coax Cable BtB Connector from the Lower PCB.
2. Use the Thin Plastic Spudger to disconnect the Main Flex BtB Connector from the Lower PCB.
3. Use the Thin Plastic Spudger to open the Display Flex ZIF Connector door.
4. Use the Tweezers to gently remove the Display Flex from the ZIF Connector Door.
5. Use the flat end of the Blackstick to lift the Lower PCB from the pocket in the Front Housing.
6. Remove the Lower PCB from the pocket in the Front Housing.



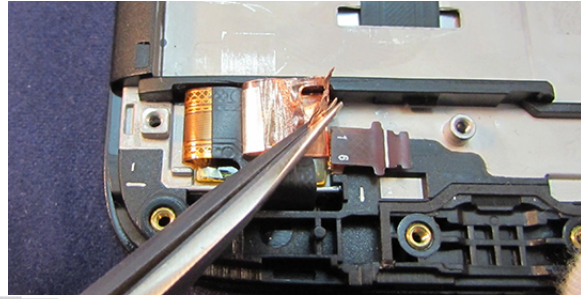
Display Flex Copper Foil Removal

NOTE

After you remove the Display Flex Copper Foil, you cannot reuse it.



Use the Tweezers to remove the Display Flex Copper foil from the Flex.



//CAUTION//

Use care when removing the Copper Foil. The Display Flex is fragile.



Main Flex Removal

NOTE

After you remove the Main Flex, you cannot reuse it.



Use the Thin Plastic Spudger to lift the Main Flex from the recess in the Front Housing.



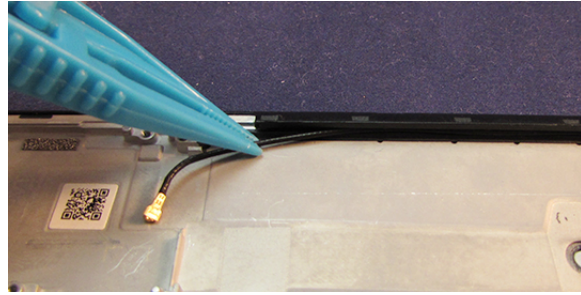
Coax Cable Removal

NOTE

The Coax Cable can be recovered and reused after removal.



Use the Plastic Tweezers to remove the Coax Cable from the channel in the Front Housing.



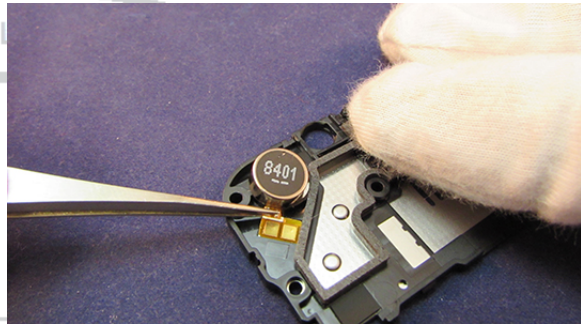
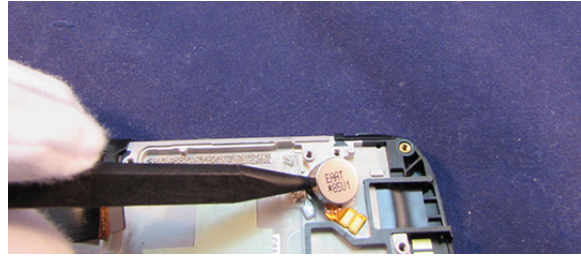
Vibrator Removal

NOTE

After you remove the Vibrator, you cannot reuse it.



1. Use the pointed end of the Blackstick to pry the Vibrator from the pocket at the location shown.
2. Use the Tweezers to disengage the Vibrator Flex from the Front Housing.
3. Remove the Vibrator from the Front Housing.



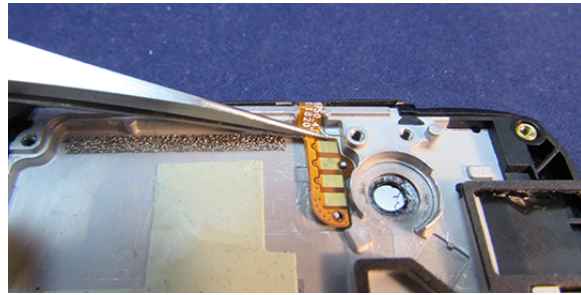
Side-Key Flex Removal

NOTE

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



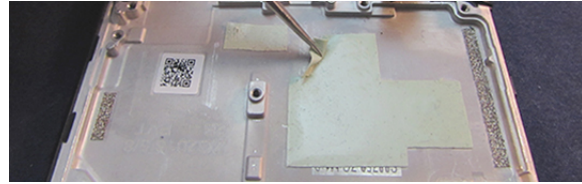
1. Use the Tweezers to disengage the Side-Key Flex from the floor of the Front Housing.
2. Use the Thin Plastic Spudger to pry the Side-Key Flex from the wall of the Front Housing.



PCB Silicone Removal

NOTE

After you remove the PCB Silicone, you cannot reuse it.




Use the Tweezers to remove the PCB Silicone from the Front Housing.

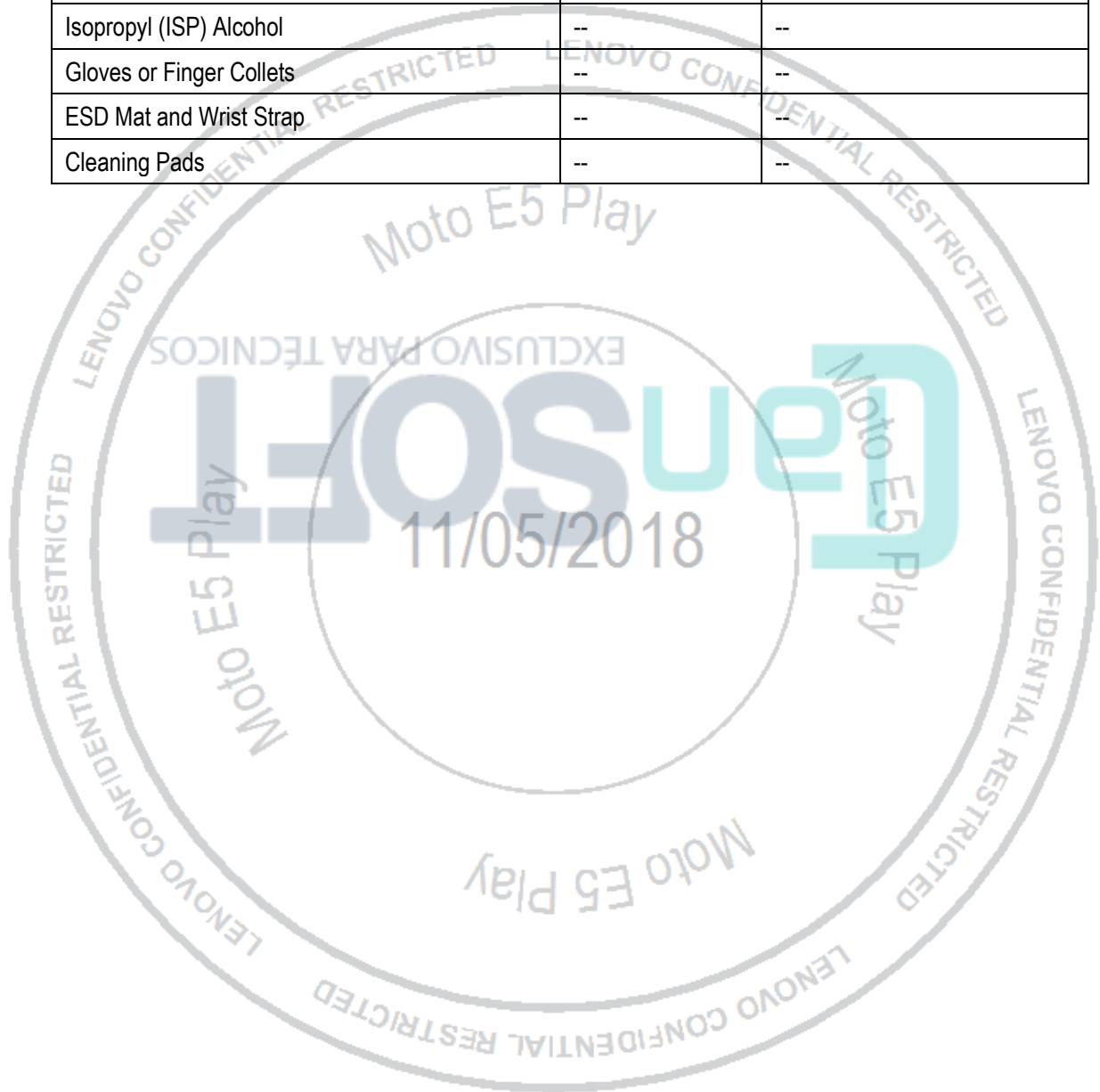


PARTS REFRESH

Tools Required for Parts Refresh

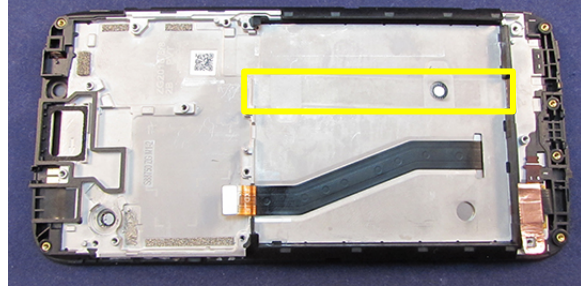
The following tools are required for parts refresh of the Moto E5 Play phone.

<i>Description</i>	<i>Part #</i>	<i>Image</i>
Blackstick	--	
Isopropyl (ISP) Alcohol	--	--
Gloves or Finger Collets	--	--
ESD Mat and Wrist Strap	--	--
Cleaning Pads	--	--

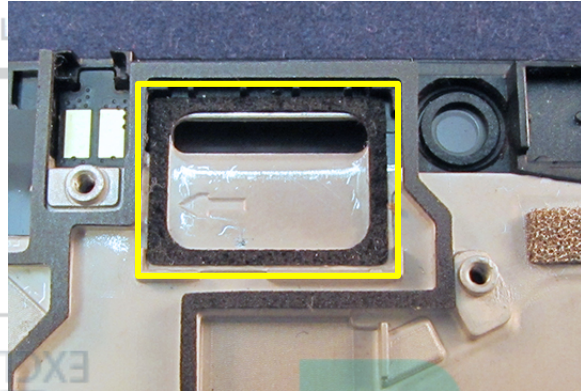


Front Housing Cleaning

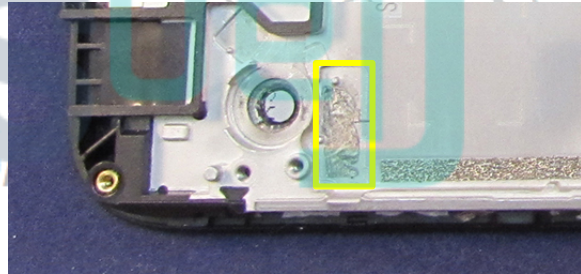
1. Use ISP Alcohol and the flat end of the Blackstick to remove any remaining adhesive from where the Main Flex was attached to the Front Housing.



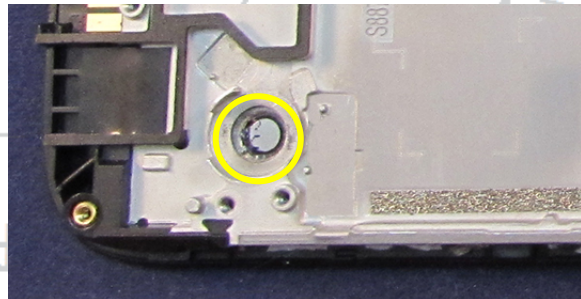
2. Use ISP Alcohol and the flat end of the Blackstick to remove any remaining adhesive from where the Earpiece Speaker was attached to the Front Housing.



3. Use ISP Alcohol and the flat end of the Blackstick to remove any remaining adhesive from where the Side-Key Flex was attached to the Front Housing.



4. Use ISP Alcohol and the flat end of the Blackstick to remove any remaining adhesive from where the Vibrator was attached to the Front Housing.

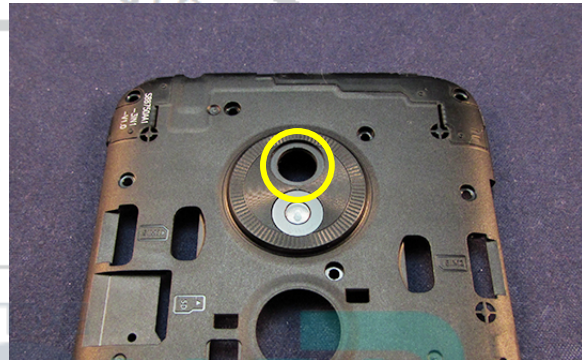


Rear-Facing Imager Lens Cleaning

1. Use ISP Alcohol and the flat end of the Blackstick to remove any remaining adhesive from the Rear-Facing Imager Lens.

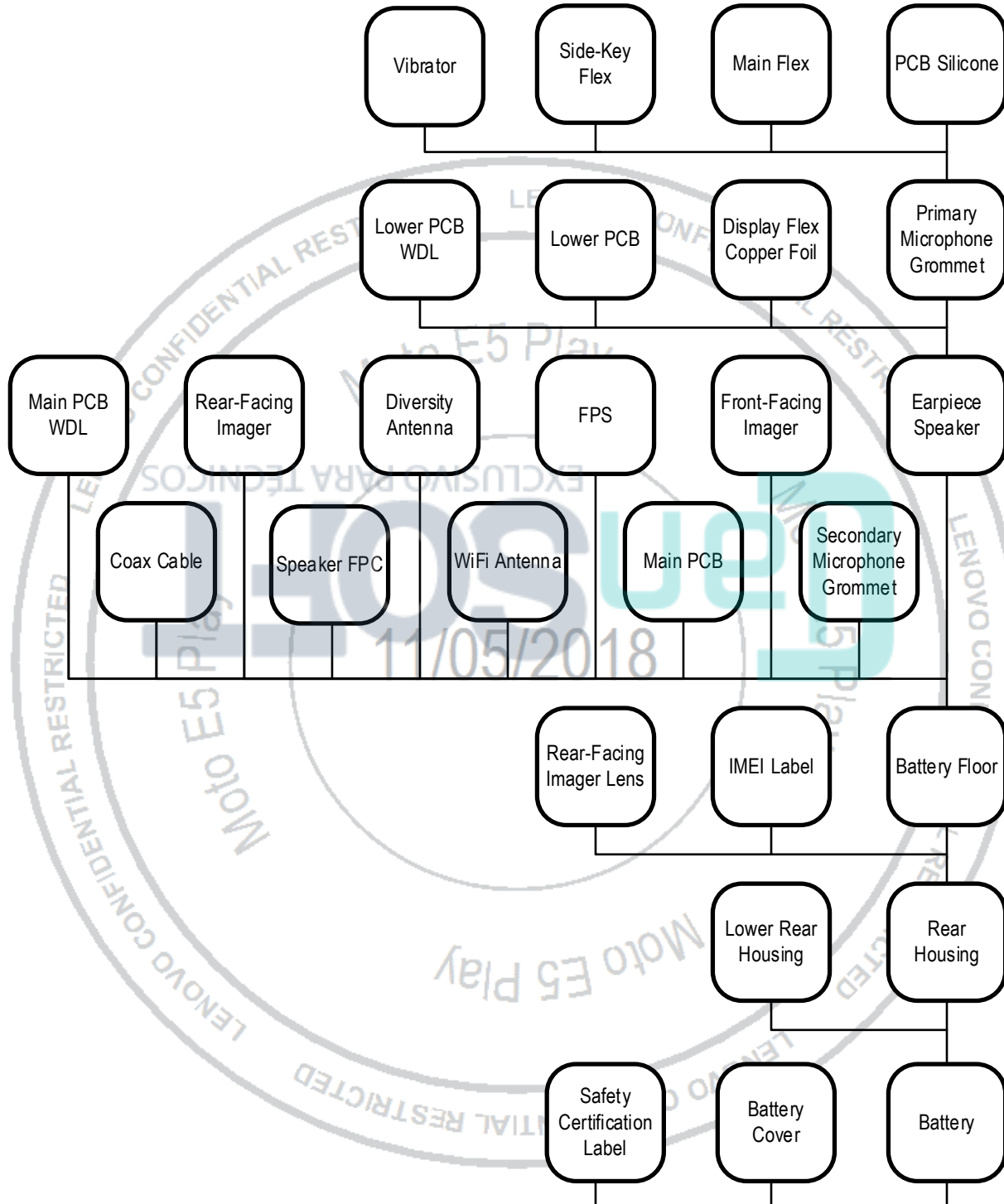


2. Use ISP Alcohol and the flat end of the Blackstick to remove any remaining adhesive from where the Rear-Facing Imager Lens was attached to the Rear Housing.






ASSEMBLY

Assembly Map



Tools Required for Assembly

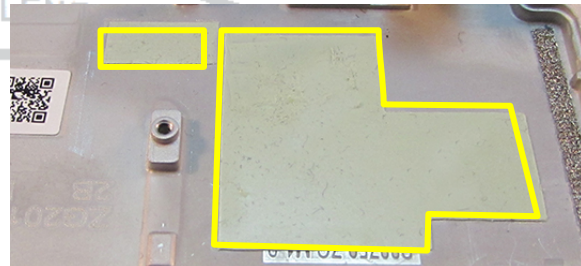
The following tools are required to assemble the Moto E5 Play phone.

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Blackstick	--	
T5 Torx Bit	--	
Torque Driver (Adjustable)	--	
Tweezers (Plastic or Plastic-Tipped)	--	--
Tweezers (Metal)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--

PCB Silicone Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+702703802391+waterproof WT+715000309061+PMC silicone_LS WT+715000309051+BB Silicone_LS	28

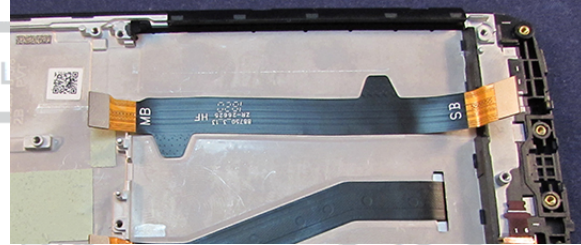
1. Use the Tweezers to place the PCB Silicone onto the Front Housing as shown.
2. Slide a fingertip across the Silicone to secure it to the Front Housing.



Main Flex Assembly

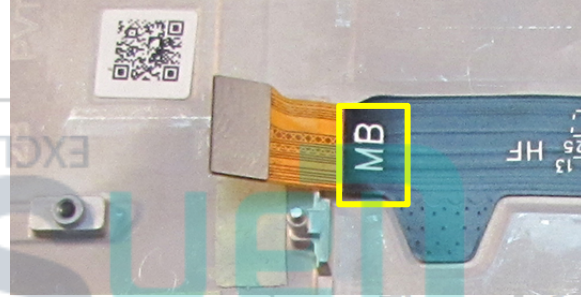
Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+713300309011+Main FPC	13

1. Peel the Main Flex from the carrier.
2. Place the Main Flex into the recess on the Front Housing in the location shown.

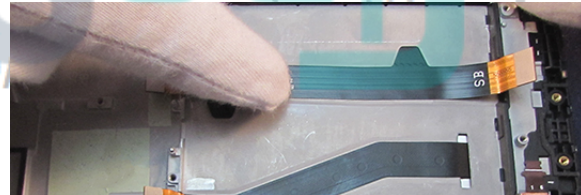


NOTE

Ensure the end of the Main Flex labeled MB is oriented toward the pocket for the Main PCB as shown.



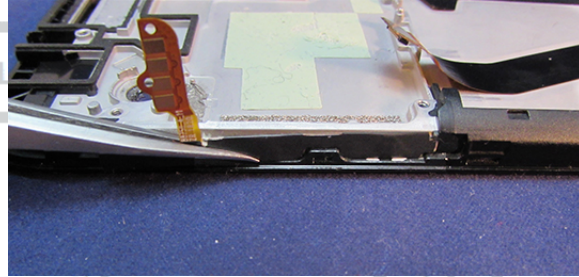
3. Slide a fingertip across the Main Flex to secure it to the Front Housing.



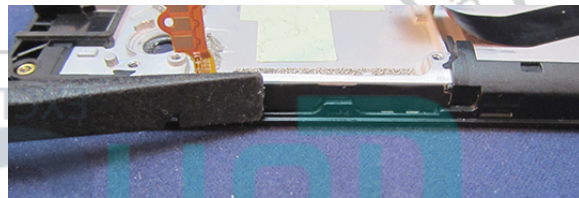
Side-Key Flex Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+713300309021+Sidekey FPC	12

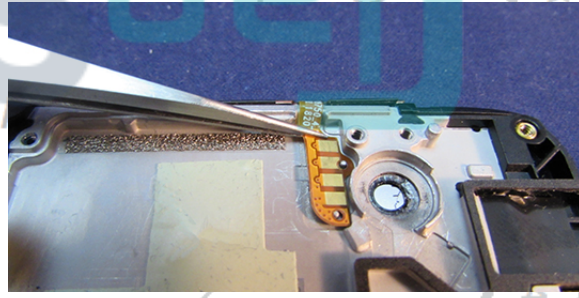
1. Peel the liners from Side-Key Flex.
2. Use the Tweezers to place the Side-Key Flex onto the outer wall of the Front Housing as shown.



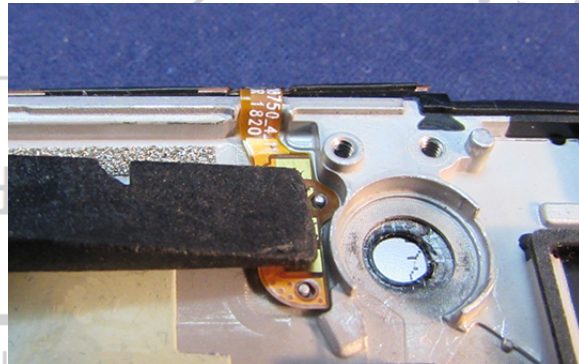
3. Slide the flat end of the Blackstick across the Side-Key Flex to secure it to the Front Housing.



4. Use the Tweezers to place the contacts of the Side-Key Flex into the recess on the floor of the Front Housing as shown.



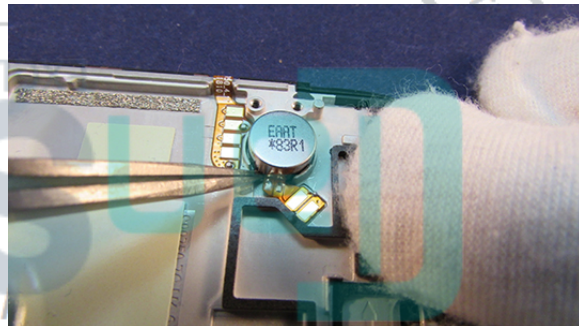
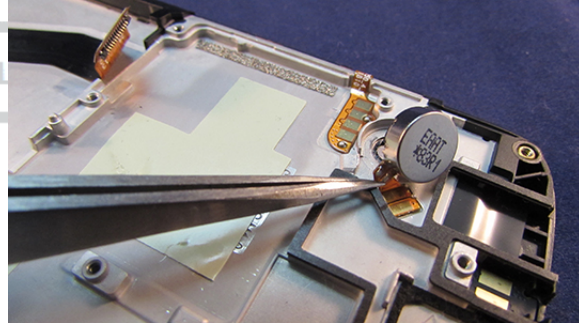
5. Slide the flat end of the Blackstick across the Side-Key Flex contacts to secure them to the Front Housing.



Vibrator Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+710613000071+Zach Motor_A	18

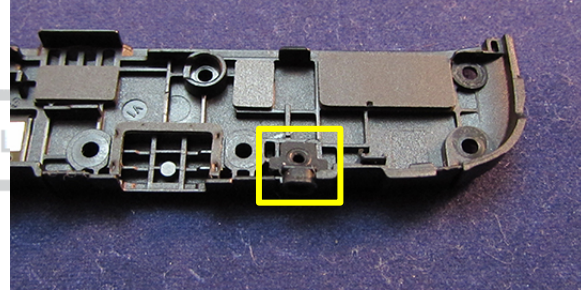
1. Peel the liners from the Vibrator.
2. Use the Tweezers to place the Vibrator Flex into the recess on the Front Housing as shown.
3. Press down for 5 seconds to secure the Vibrator Flex to the Front Housing.
4. Use the Tweezers to place the Vibrator into the pocket on the Front Housing as shown.
5. Press down for 5 seconds to secure the Vibrator to the Front Housing.



Primary Microphone Grommet Assembly

Description	Reference #
XT1920-15 Main ANT&711100309091 CS WT+711100309061+MAIN Antenna_S	10
WT+712300309021+Main Mic Rubber	22

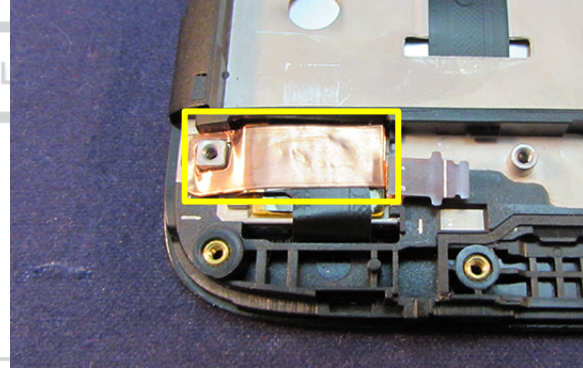
Use the Tweezers to place the Primary Microphone Grommet into the pocket in the Lower Rear Housing as shown.



Display Flex Copper Foil Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+712100309031+ TP FPC Copper	29

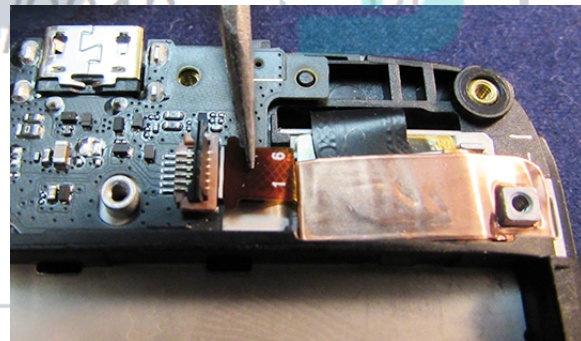
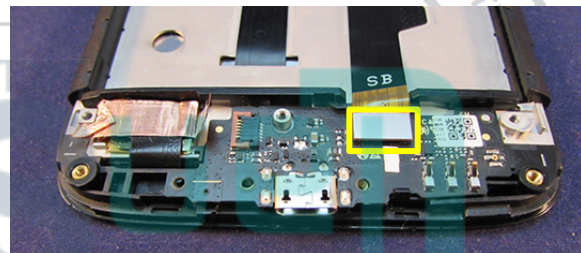
1. Peel the Display Flex Copper Foil from the carrier.
2. Use the Tweezers to place the Display Flex Copper Foil onto the Flex as shown.



Lower PCB Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
XT1920-18 Sub board&715201006741CS XT1920-15 Sub board&715201006791CS ASSY,DTR BRD,Golf Lite ANT BR AR	4
WT+713300309011+Main FPC	13

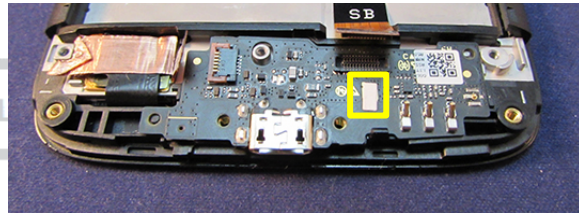
1. Use the Tweezers to place the Lower PCB into the pocket on the Front Housing as shown.
2. Apply rolling pressure to connect the Main Flex to the BtB Connector to the Lower PCB as shown.
3. Verify the Display Flex ZIF Connector Door is open.
4. Use the Tweezers to insert the Display Flex into the ZIF Connector as shown. Use the white line on the Flex as a guide for insertion depth.
5. Slide a fingertip across the Display Flex ZIF Connector Door to close it.



Lower PCB WDL Assembly

Description	Reference #
XT1920-18 Sub board&715201006741CS XT1920-15 Sub board&715201006791CS ASSY,DTR BRD,Golf Lite ANT BR AR	4
WT+712700207041+Water detector	30

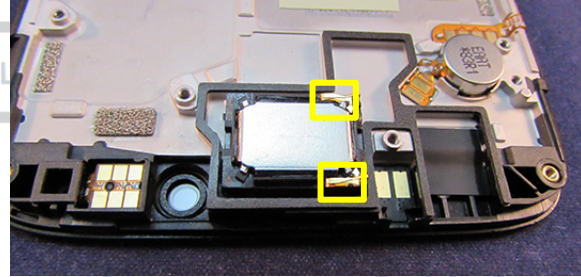
1. Use the Tweezers to place the Lower PCB WDL on the Lower PCB as shown.
2. Press down for 5 seconds to secure the WDL to the Lower PCB.



Earpiece Speaker Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+710324100221+SPK	17

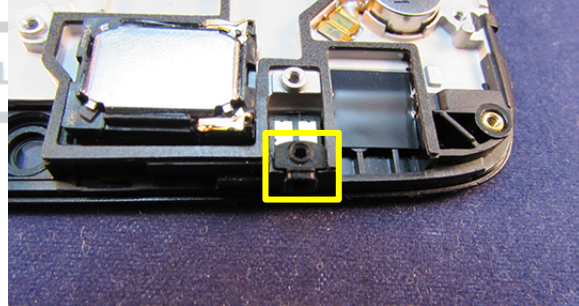
1. Peel the Earpiece Speaker from the carrier.
2. Use the Tweezers to place the Earpiece Speaker into the pocket on the Front Housing, with the copper contacts oriented as shown.
3. Press down for 5 seconds to secure the Earpiece Speaker to the Front Housing.



Secondary Microphone Grommet Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+712300309031+Sub Mic Rubber	21

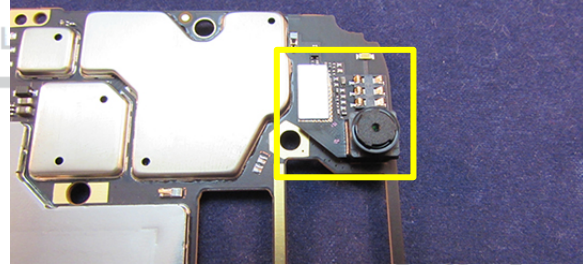
Use the Tweezers to place the Secondary Microphone Grommet into the pocket in the Front Housing as shown.



Front-Facing Imager Assembly

Description	Reference #
XT1920-19 MB_1+16G_DS&715201006731CS XT1920-16 MB_1+16G_DS&715201006761CS XT1920-15 MB_1+16G_SS&715201006771CS XT1920-18 MB_1+16G_SS&715201006781CS ASSY,BD KIT,Golf Lite 2+16 DS CKD	3
IMGR MDL,CMOS,8MP,8.56MMX8.62MMX4.66MM,M	15

1. Remove the liner from the Front-Facing Imager, if present.
2. Place the Front-Facing Imager onto the Main PCB as shown.
3. Apply rolling pressure to secure the Front-Facing Imager BtB Connector to the Main PCB.



Main PCB Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
XT1920-19 MB_1+16G_DS&715201006731CS XT1920-16 MB_1+16G_DS&715201006761CS XT1920-15 MB_1+16G_SS&715201006771CS XT1920-18 MB_1+16G_SS&715201006781CS ASSY,BD KIT,Golf Lite 2+16 DS CKD	3
WT+713300309011+Main FPC	13
WT+710921000771+Screw WHT	20

1. Place the Main PCB into the pocket on the Front Housing as shown.

NOTE

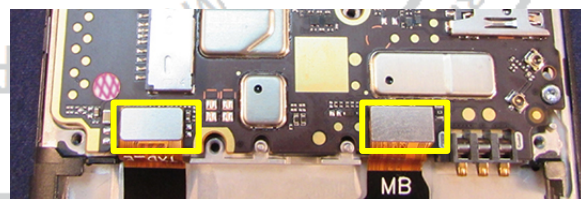
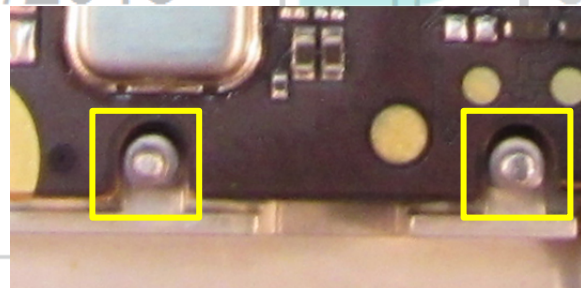
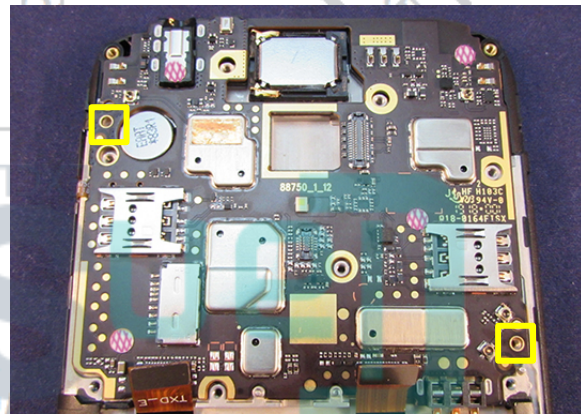
Make sure the Main PCB lines up with the FPS Pins as shown.

2. Use the Torque Driver and T5 Torx Bit to tighten the 2 T5 Torx Machine Screws to 1.0 ± 0.10 in-lb (0.11 ± 0.01 N·m).

NOTE

Use only the 2 silver Screws for this operation. Do not use the black Screws.

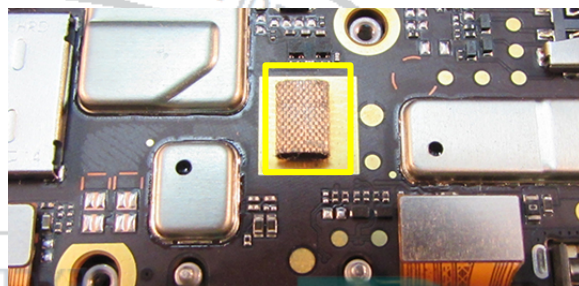
3. Apply rolling pressure to the Display Flex BtB Connector and the Main Flex BtB Connector to secure them to the Main PCB.



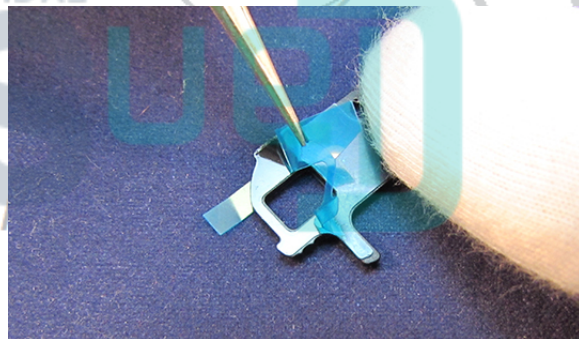
FPS Assembly

Description	Reference #
XT1920-19 MB_1+16G_DS&715201006731CS XT1920-16 MB_1+16G_DS&715201006761CS XT1920-15 MB_1+16G_SS&715201006771CS XT1920-18 MB_1+16G_SS&715201006781CS ASSY,BD KIT,Golf Lite 2+16 DS CKD	3
WT+711500309051+FPS holder	14
MDL,FNGRPRT,Golf lite,ET516,RING,CTG,BLK	24
WT+712400309011+FPS Ground Sponge	27

1. Use the Tweezers to place the FPS Conductive Foam on the Main PCB in the location shown.

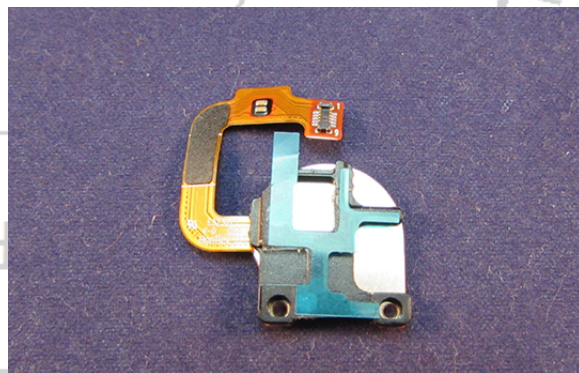


2. Peel the liner from the side of the FPS Holder that will attach to the FPS.



3. Place the FPS Holder onto the FPS as shown.

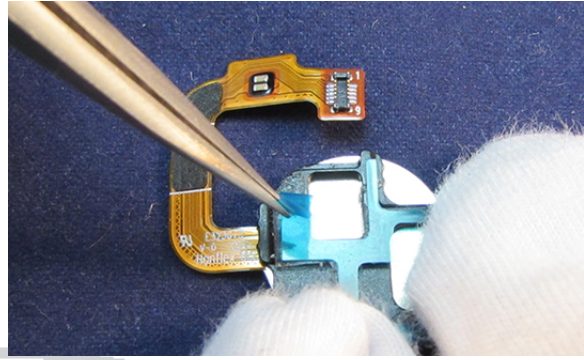
4. Press down for 5 seconds to secure the FPS Holder to the FPS.



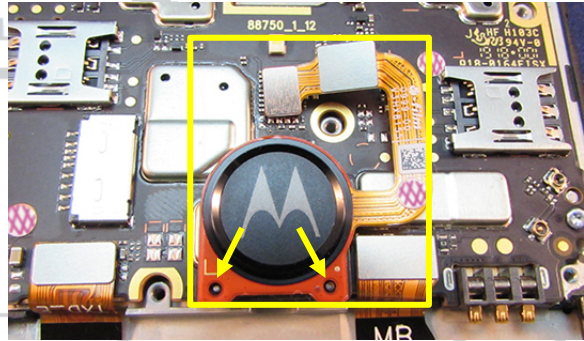
Moto E5 Play

Level 2 – Service and Repair Manual

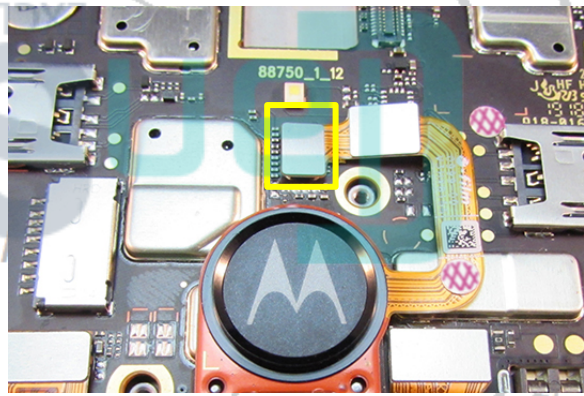
5. Peel the liner from the back of the FPS Holder that will attach to the Main PCB.



6. Place the FPS onto the Main PCB, making sure the holes in the FPS align with the pins on the Front Housing.
7. Press down for 5 seconds to secure the FPS to the Main PCB.



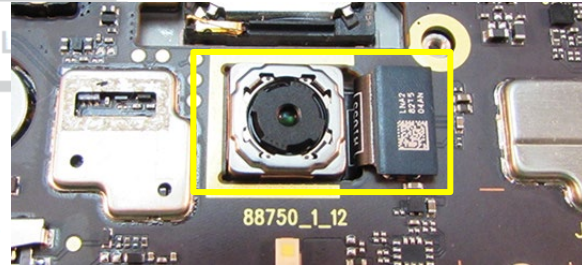
8. Apply rolling pressure to secure the FPS BtB Connector to the Main PCB.



Rear-Facing Imager Assembly

Description	Reference #
XT1920-19 MB_1+16G_DS&715201006731CS XT1920-16 MB_1+16G_DS&715201006761CS XT1920-15 MB_1+16G_SS&715201006771CS XT1920-18 MB_1+16G_SS&715201006781CS ASSY,BD KIT,Golf Lite 2+16 DS CKD	3
WT+710200309061+Front Cam 5M_QH	16

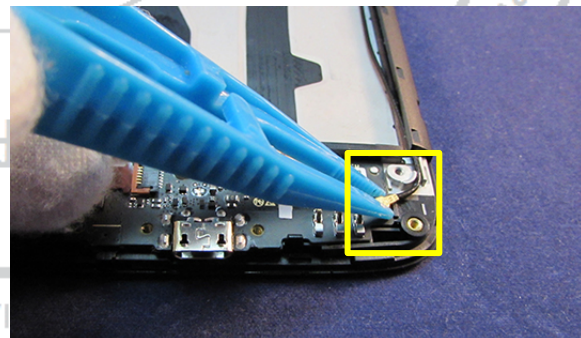
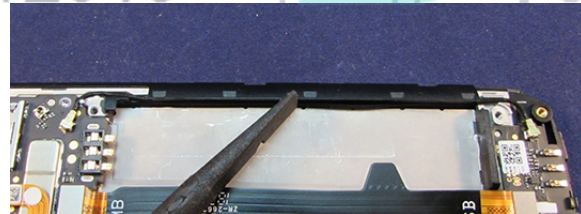
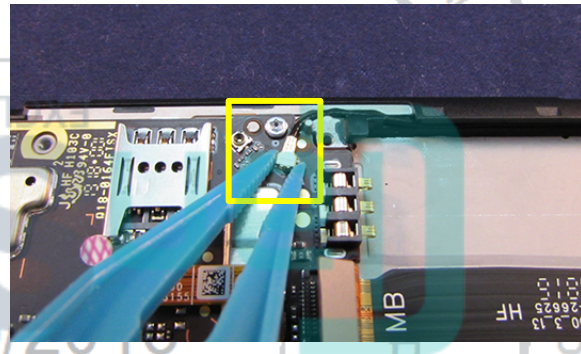
1. Place the Rear-Facing Imager into the opening in the Main PCB as shown.
2. Apply rolling pressure to connect the Rear-Facing Imager BtB Connector to the Main PCB.



Coax Cable Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
XT1920-19 MB_1+16G_DS&715201006731CS XT1920-16 MB_1+16G_DS&715201006761CS XT1920-15 MB_1+16G_SS&715201006771CS XT1920-18 MB_1+16G_SS&715201006781CS ASSY,BD KIT,Golf Lite 2+16 DS CKD	3
XT1920-18 Sub board&715201006741CS XT1920-15 Sub board&715201006791CS ASSY,DTR BRD,Golf Lite ANT BR AR	4
WT+715302000691+Coaxial Cable	23

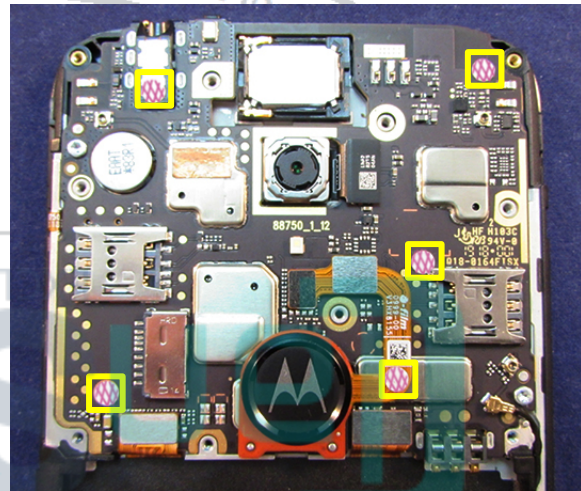
1. Use the Plastic Tweezers to connect one BtB Connector to the Main PCB.
2. Use rolling pressure to connect the BtB Connector to the PCB.
3. Pass the Coax Cable through the channel in the Front Housing.
4. Use the flat end of the Blackstick to secure the Coax Cable into the channel.
5. Use the Plastic Tweezers to connect the other BtB Connector to the Lower PCB.
6. Use rolling pressure to connect the BtB Connector to the PCB.



Main PCB WDL Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
MDL,FNGRPRT,Golf lite,ET516,RING,CTG,BLK	24
WT+702703802391+waterproof WT+715000309061+PMC silicone_LS WT+715000309051+BB Silicone_LS	28

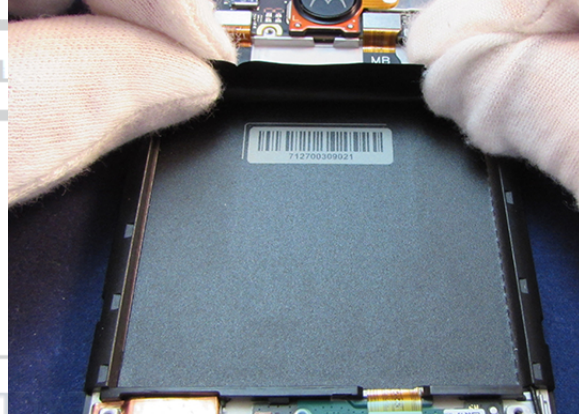
1. Ensure all 5 Main PCB WDLs are placed in the locations shown.
2. Use the Tweezers to replace any missing WDLs.
3. Press down for 5 seconds to secure each of the WDLs to the Main PCB.



Battery Floor Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+712700309021+Bat Mylar_FQ	25

1. Remove the adhesive liner from the Battery Floor.
2. Align the Battery Floor to the recess in the Front Housing, aligning the edge of the Battery Floor to the edge of the recess.
3. Lower the Battery Floor completely into the recess in the Front Housing.
4. Wipe the Battery Floor with a card to smooth out any wrinkles and remove any air bubbles.



IMEI Label Assembly

Description	Reference #
WT+712700309021+Bat Mylar_FQ	25
WT+712700207031+IMEI label	--

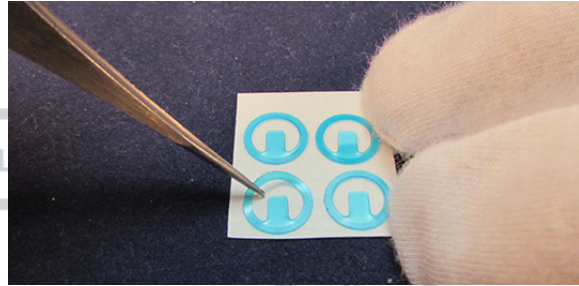
1. Remove the adhesive liner from the IMEI Label.
2. Place the IMEI Label on the Battery Floor, aligning the center of the IMEI Label with the center of the Battery Floor.



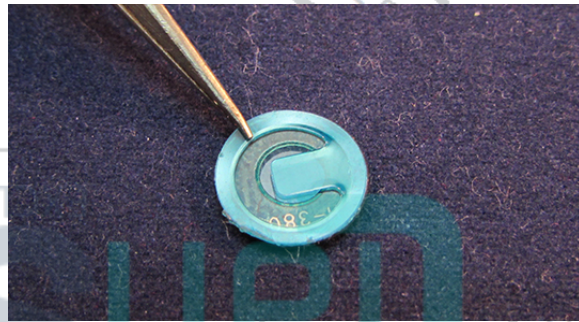
Rear-Facing Imager Lens Assembly

Description	Reference #
WT+711900309011+Rear Cam Lens	26
XT1920-15 R-CAM Lens Adhe&712100309111CS	31

1. Use the Tweezers to remove the Rear-Facing Imager Lens Adhesive from the protective carrier.



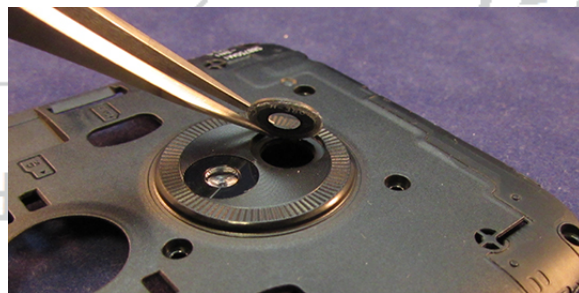
2. Use the Tweezers to place the Lens Adhesive onto the Rear-Facing Imager Lens as shown, with the sticky side attached to the inside surface of the lens. Use care to center the Adhesive on the Lens.



3. Use the Tweezers to peel away the liner from the Lens Adhesive.



4. Use the Tweezers to place the Rear-Facing Imager Lens into the pocket on the Rear Housing as shown.

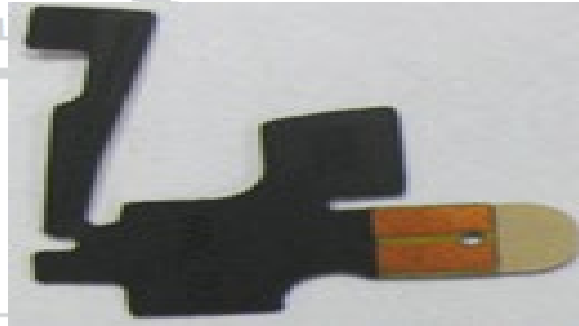


5. Press down for 5 seconds to secure the Rear-Facing Imager Lens to the Rear Housing.

WiFi Antenna Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
XT1920-15 BWG ANT&711100309111 CS WT+711100309081+BWG Antenna_S	8

1. Remove the WiFi Antenna from the carrier.



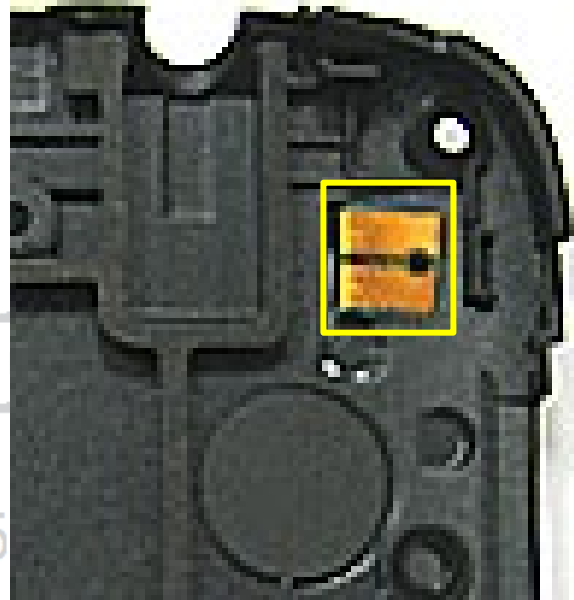
2. Use your fingers to fold the WiFi Antenna over the corner of the Rear Housing in the location shown.
3. Press down for 10 seconds to secure the WiFi Antenna to the Rear Housing.



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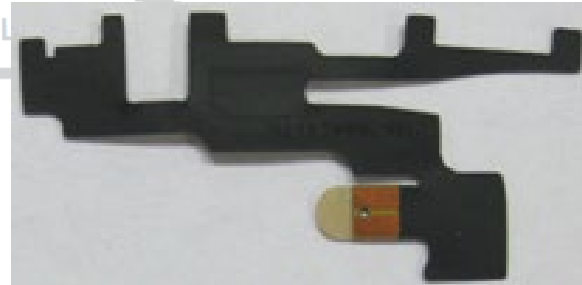
4. Use your fingers to fold the edge of the WiFi Antenna over the slot in the Rear Housing so that the arrow is oriented in the direction shown.



Diversity Antenna Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
XT1920-15 DIV ANT&711100309101 CS WT+711100309071+DIV Antenna_S	9

1. Remove the Diversity Antenna from the carrier.



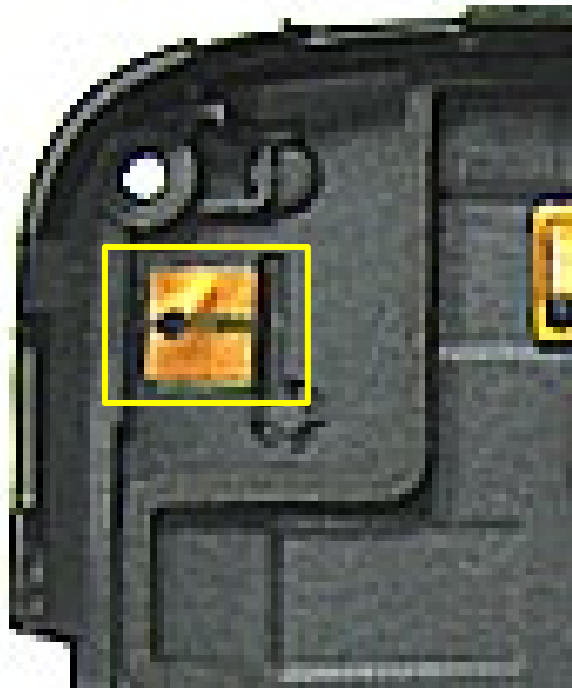
2. Use your fingers to fold the Diversity Antenna over the edge of the Rear Housing in the location shown.
3. Press down for 10 seconds to secure the Diversity Antenna to the Rear Housing.



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4. Use your fingers to fold the edge of the Diversity Antenna over the slot in the Rear Housing so that the arrow is oriented in the direction shown.



Speaker FPC Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+713300309041+SPK FPC	11

1. Remove the Speaker Flexible Printed Circuit (FPC) from the carrier.
2. Place the Speaker FPC into the pocket of the Rear Housing in the location shown.



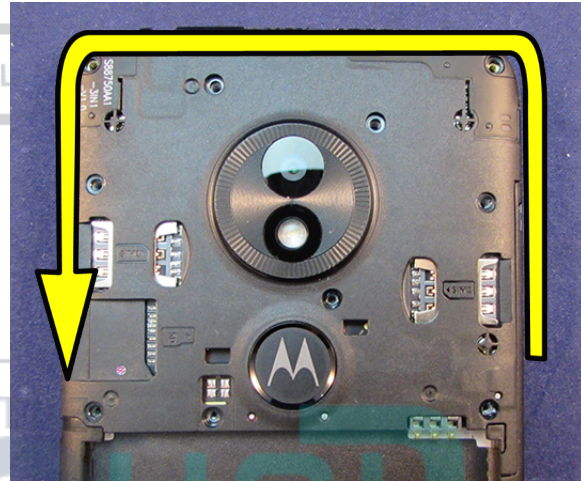
3. Use your fingers to line up the Speaker FPC with the alignment pins in the locations shown.
4. Press down for 10 seconds to secure the Speaker FPC to the Rear Housing.



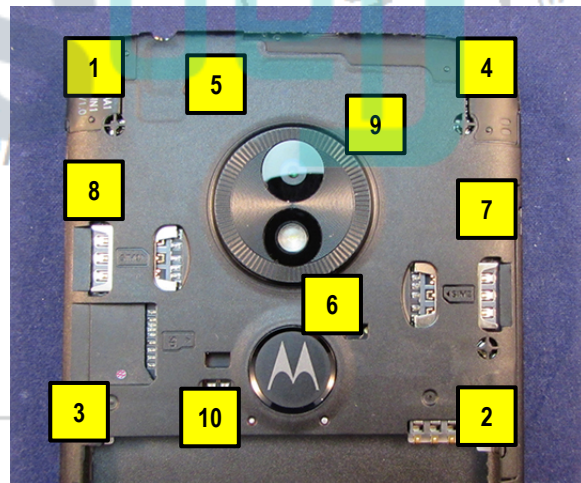
Rear Housing Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
WT+710922000611+Screw BLK	19

1. Remove any remaining protective carriers or liners from the Rear Housing, Front Housing, and the Main PCB.
2. Place the Rear Housing on the Front Housing.
3. Engage the snaps around the edges of the Rear Housing.



4. Use the Torque Driver and T5 Torx Bit to tighten the 10 T5 Torx Machine Screws to 1.0 ± 0.10 in-lb (0.11 ± 0.01 N·m) in the order shown.



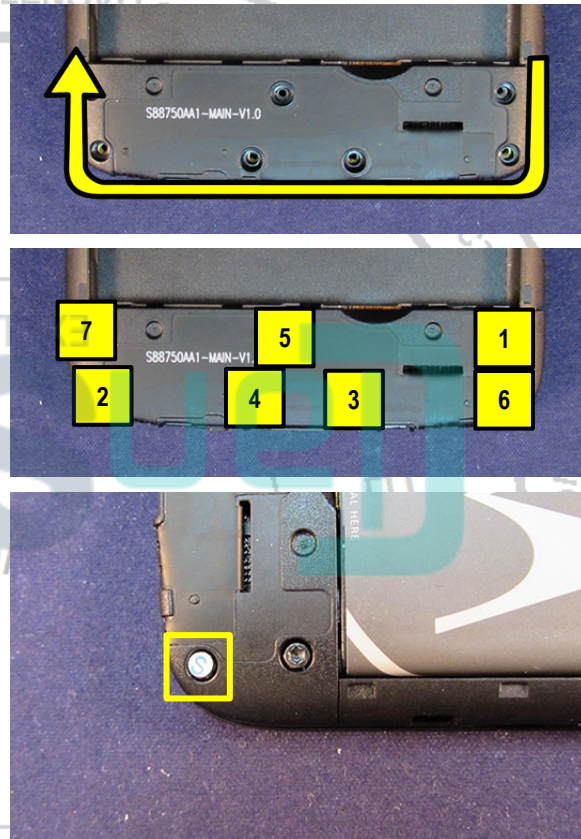
5. Apply a Screw Tampering Label to the Screw shown.



Lower Rear Housing Assembly

Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
XT1920-15 Main ANT&711100309091 CS WT+711100309061+MAIN Antenna_S	10
WT+710922000611+Screw BLK	19

- Place the Lower Rear Housing on the Front Housing as shown.
- Engage the snaps around the edges of the Lower Rear Housing.
- Use the Torque Driver and T5 Torx Bit to tighten the 7 T5 Torx Machine Screws to 1.0 ± 0.10 in-lb (0.11 ± 0.01 N m) in the order shown.
- Apply a Screw Tampering Label to the Screw shown.



Battery Assembly

Description	Reference #
ACCY,BAT,2120mAh,JE30,ATL355763,ATL,ROW	1
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	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. Place the Battery into the pocket on the phone in the orientation shown.
2. Press down on the Battery until it snaps into place.



Battery Cover Assembly

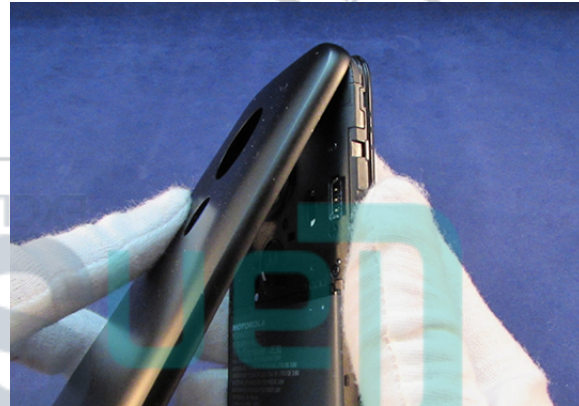
Description	Reference #
XT1920-15 TP LCM ASSY_BL&712601007171CS XT1920-15 TP LCM ASSY_GL&712601007181CS HSG,BND,BLK,WT+7126CK001711+LDA Assy WT+7126CK001881+LDA Assy GLD	2
XT1920-16 Batt Cover_BL&712601007191CS XT1920-16 Batt Cover_GL&712601007201CS WT+7126CK001741+Batcover Assy WT+7126CK001891+Batcover Assy GLD XT1920 Rear housing_DS&711500309411CS XT1920 Rear housing_SS&711500309401CS XT1920 Rear housing_BOT&711500309421CS	5

1. Align and engage the snaps in the top edge of the Battery Cover with the snaps in the top edge of the Front Housing.

NOTE

The Battery Cover must engage the Front Housing at an angle, top edge first, as shown.

2. While holding the top edge of the Battery Cover in position, engage the bottom corner snaps.



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3. Engage the remaining snaps around the perimeter of the phone until the Battery Cover is securely assembled to the Front Housing.

