

Lenovo

motorola one



Lenovo motorola one Level 2 – Service and Repair Manual

CONFIDENTIAL REPORT

REVISION HISTORY

<i>Revision</i>	<i>Date</i>	<i>Notes</i>
1	09/13/2018	Initial draft



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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	Sim Tray
2	Headset Jack
3	Secondary MIC
4	Loud Speaker
5	USB Port
6	Front Facing Flash
7	Earpiece Speaker
8	Volume Key
9	Power Key
10	Display
11	Front Housing
12	Rear-Facing Camera
13	Flash Lens
14	Finger Print Sensor
15	Battery Inlay

Main Exploded Views

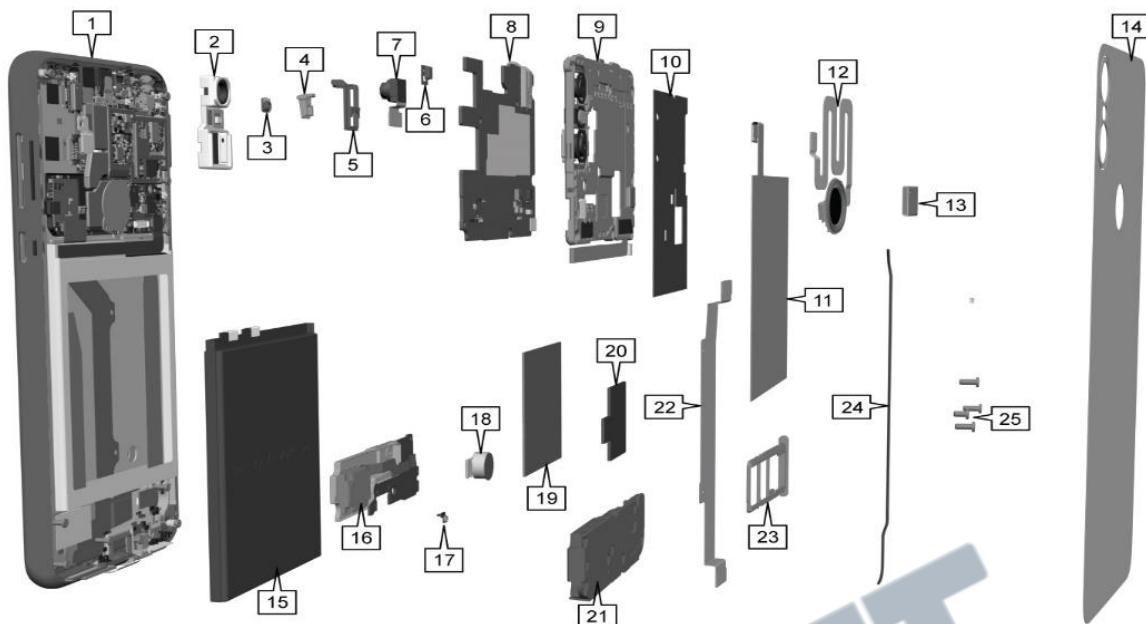


Figure 2. Assembly Exploded View

Table 2. Assembly Exploded View Parts List

Reference #	Description	Recovery Part
1	XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	YES
2	LC+2640SK000015+L3520 bk cam 13+2 XL	YES
3	XT1941 Receiver&2626AA000002 CS	No
4	XT1941 MIC1 Rubber&5061AA000061 CS	YES
5	LC+5061SK000059+L3520 ear_rubb(DP)	YES
6	LC+5061SK000058+L3520 gg_rub(DP)	YES
7	MDL,CAMR,8MP,OFILM L4H7F70 COB FF 30PIN	YES
8	XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	YES
9	XT1941 Rear Housing_WH&7601AA000071 CS XT1941 Rear Housing_BL&7601AA000072 CS	YES
10	LC+5460SK000046+L3520 bat cover film(YH)	YES
11	LC+5022SK000028+L3520 NFC(JW)	NO
12	MDL,FNGRPRT,K9S,ET516,CTG FG,BLK,SLVR,BL MDL,FNGRPRT,K9S,ET516,CTG FG,WHT,SLVR,SL	YES
13	LC+5090SK000043+L3520 zhiwen sheet	NO

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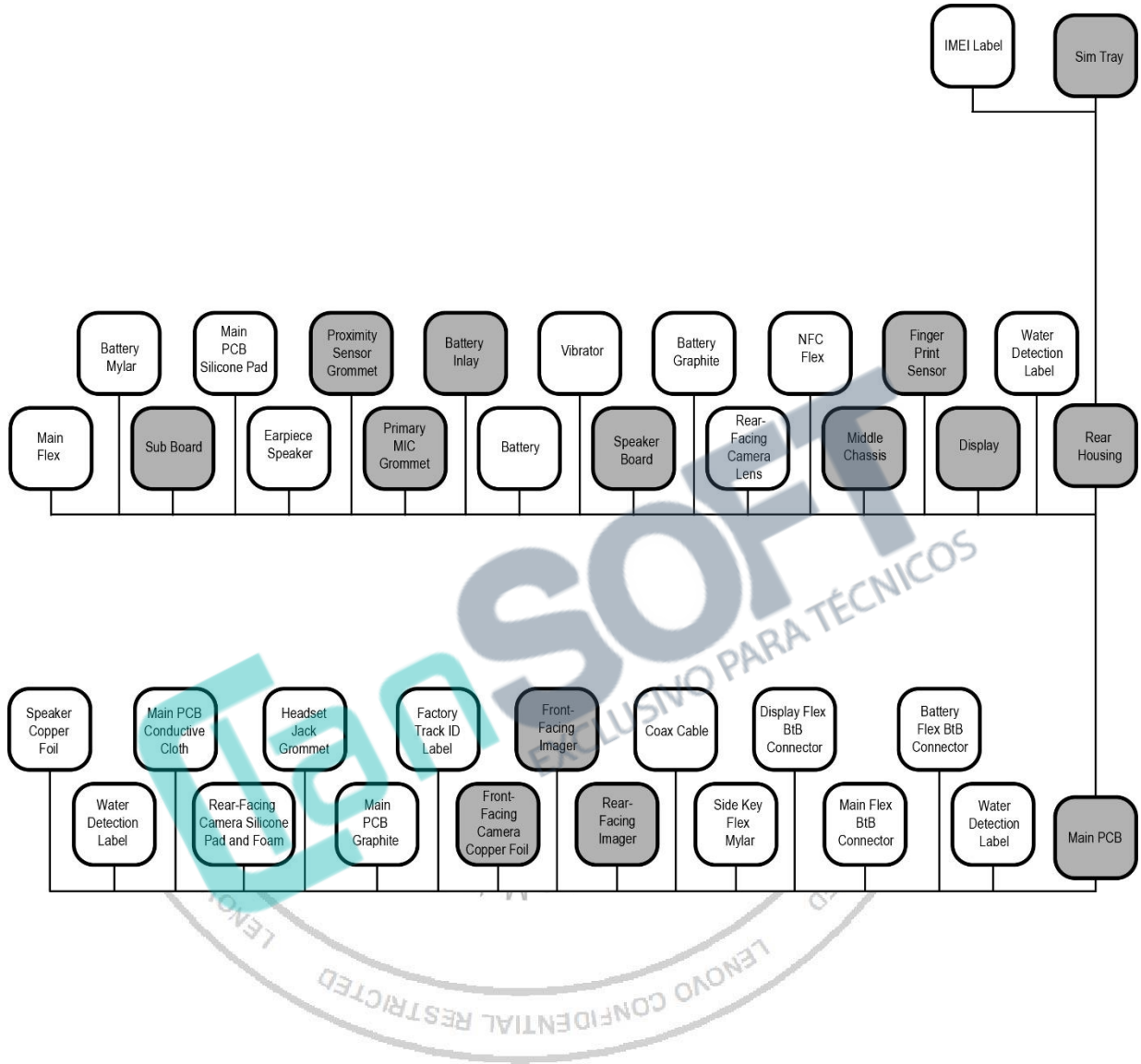
Reference #	Description	Recovery Part
14	LC+5023SK000003+L3520 bat cover(WH WG) LC+5023SK000002+L3520 bat cover(BK WG)	YES
15	ASSY,BAT,LI POLY,HE50,AMPEREX TYP5000MAH ACCY,BAT,ACCESSORY,BATTERY,3000mAh,JE40;	NO
16	XT1941-4 Sub Board&6818AA00132 CS XT1941-3 Sub Board&6818AA00 CS XT1941-3 BR DS CKD SUB PCBA FOR MP	YES
17	XT1941 MIC2 Rubber&5061AA000060 CS	YES
18	XT1941 Motor&2623AA000006 CS	NO
19	LC+5460SK000087+bat thermal film(YH)	NO
20	LC+5470SK000025+L3520 BOX cu foil(YH)	NO
21	LC+5016SK000016+L3520 SPK BOX(HS+HT)	YES
22	XT1941 Main FPC&6680AA000047 CS	NO
23	LC+5017SK000074+L3520 SIM tray(SI LM DU) LC+5017SK000076+L3520 SIM tray(BK LM DU) XT1941 SIM TRAY_SS_WH&5017AA000095 CS XT1941 SIM TRAY_SS_BL&5017AA000092 CS	YES
24	XT1941 RF Cable&5234AA000005 CS	NO
25	LC+4610SK000026+L3520 screw_M1.4_3.5(BK)	NO
--	LC+5480SK000069+L3520 bat_mylar	NO
--	LC+5450SK000088+L3520 FP elec foam	NO
--	LC+5480SK000053+L3520 side key mylar	NO
--	LC+5460SK000050+L3520 thermal rub1(YH)	NO
--	LC+5460SK000056+L3520 thermal rub2(YH)	NO
--	LC+5460SK000052+L3520 thermal rub3(YH)	NO
--	LC+5470SK000026+L3520 f_cam foil(YH)	NO
--	LC+5460SK000049+L3520 rear LED rub(YH)	NO
--	LC+5460SK000047+L3520 MB rear film(YH)	NO
--	LC+5430SK000101+L3520 rear led poron	NO
--	LC+5450SK000112+L3520 r_ke&MB elec foam	NO
--	LC+5450SK000110+L3520 r_CAM&MB elec foam	NO
--	LC+5430SK000147+L3520 S_MIC poron	NO
--	LC+Y70151569+LXF_L3600_A01LDI_LABEL	NO

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

DISASSEMBLY AND RECOVERY

Disassembly and Recovery Map

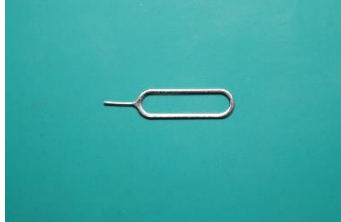




*Shaded parts may be eligible for parts recovery.



Tools Required for Disassembly

The following tools are required to disassemble the motorola one phone.

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Robusta S Battery Inlay Removal Insert	MR-M2-001-032	
Heating Plate	3-00-V5-10000	
Moto Display/Inlay Removal Fixture	MR-M2-001	
3 mm Allen Wrench	--	
Hot Plate	--	
Thin Plastic Spudger	0-00-00-40826	

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
SIM/SD Tray Removal Tool	--	
Black Stick	--	
Torque Driver	--	
PH0 Torx Bit	--	
Shim	4-00-5L-10000	
Tweezer (Plastic)	--	--
ESD Mat	--	--
Wrist Strap	--	--
Gloves or Finger Collets	--	--

SIM Tray Removal

NOTE

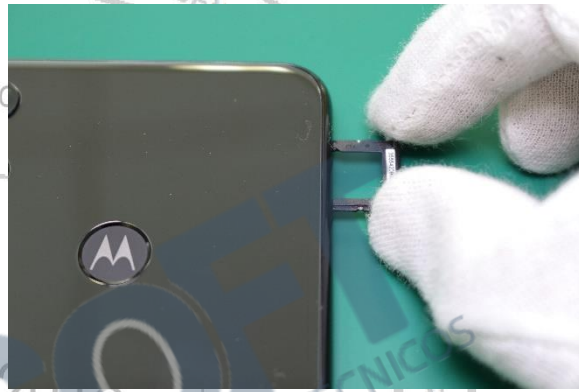
The SIM Tray can be recovered and reused after removal.



1. Use the SIM Tray Removal pin to push into the SIM Tray hole as shown.



2. Press the pin into the SIM Tray to make it pop-out. Use your fingers to remove the SIM Tray.



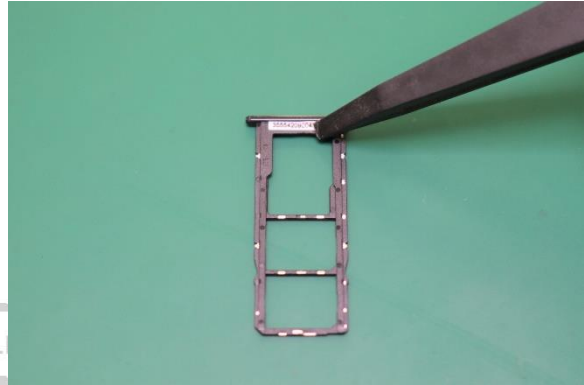
IMEI Label Removal

NOTE

Remove the IMEI Label only if necessary. After you remove it, you cannot reuse it.



Use the plastic Tweezer to remove the IMEI Label from the SIM tray.



Water Detection Label Inspection

NOTE

If the Water Detection Label (WDL) is activated, the phone's warranty no longer applies.

Inspect the Water Detection Label inside the SIM Tray Slot for signs of activation. Use external light if needed.



Battery Inlay Removal

Preheating for Battery Inlay Removal

NOTE

The Battery Inlay can be recovered and reused after removal.



NOTE

Battery Inlay Removal Methods A and B have the same preheating steps, as shown below.

// CAUTION //

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

1. Set the Hot Plate to 80 °C (176 °F).

NOTE

Preheating with an oven is also acceptable if the oven is set to the same temperature.

2. Place the phone in the Heating Plate, with the Battery Inlay side down.



3. Wait 10 minutes for the Battery Inlay Adhesive to warm up.

4. Remove the phone from the Heating Plate or the oven.

// CAUTION //

Wear protective gloves when handling heated phones.

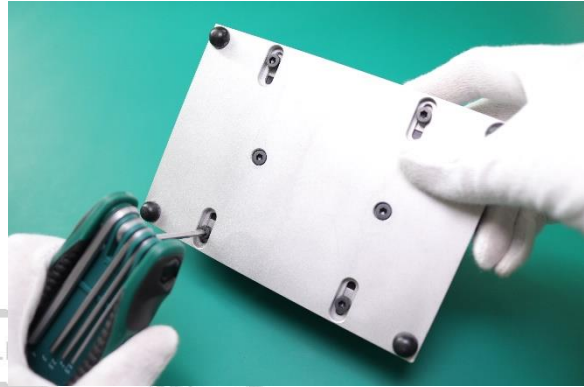
NOTE

Perform the Battery Inlay removal procedure before the phone starts to cool off.



Battery Inlay Removal Method A

1. Use the 3 mm Allen Wrench to loosen the screws holding the side rails on the Battery Inlay Fixture. Do not remove the rails.



2. Use the 3 mm Allen Wrench to remove the 2 center screws.



3. Orient the Battery Inlay Removal Insert in relation to the Display Removal Fixture as shown. Place the Insert in the Battery Removal Fixture.



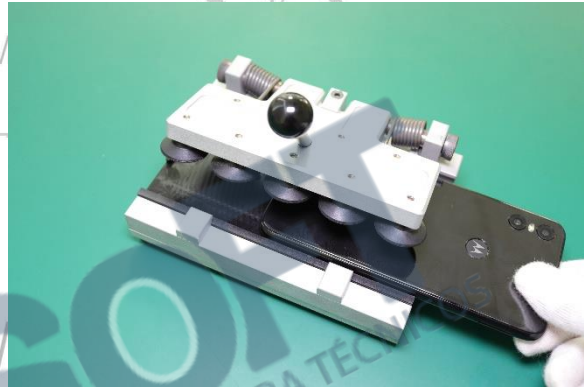
4. Use fingers to remove the pin from the Fixture.



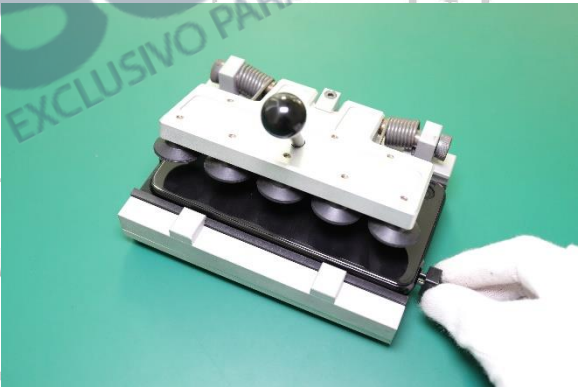
5. Slide both side rails on the Display Removal Fixture firmly against the Battery Inlay Insert. Use the 3 mm Allen Wrench to tighten the 4 outside screws on the underside of the Display Removal Fixture.



6. Follow preheating steps described on Page 18.
7. Slide the phone into the Battery Removal Fixture as shown. Center the phone in the Fixture.



8. Use fingers to insert the pin into the phone and the Fixture.



9. Press down on the Battery Removal Fixture handle to bring the suction cups in contact with the Battery Inlay. Make sure all suction cups are attached to the Battery Inlay.

// CAUTION //

Use care when pressing down on the Battery Removal Fixture handle. Damage to the phone may occur.

NOTE

Begin this step before the phone starts to cool off.

10. As the Battery Inlay begins to release from the phone, use the Thin Plastic Spudger to gently pry the Battery Inlay as shown.

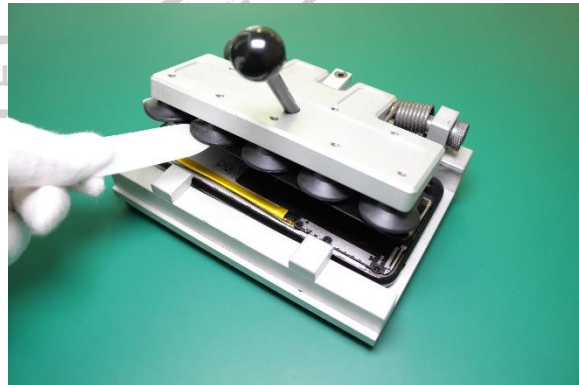
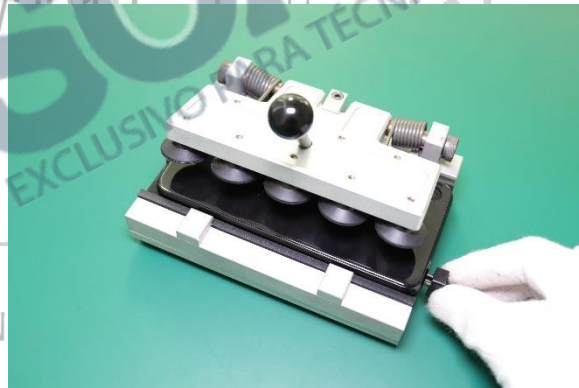
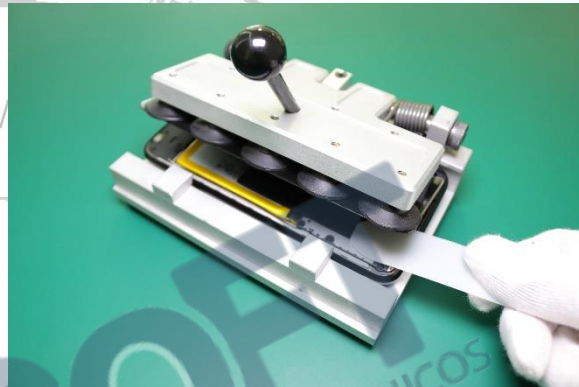
// CAUTION //

Do not insert the Thin Plastic Spudger more than 1mm to prevent damaging internal components.

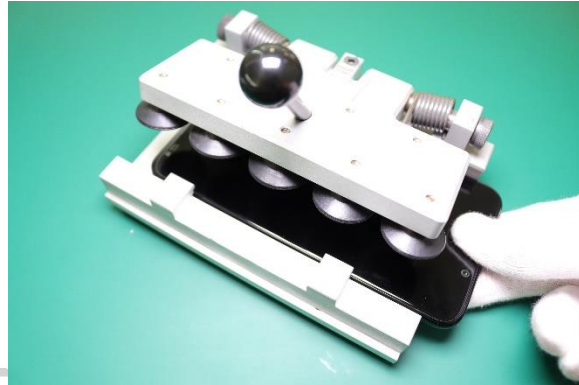
11. Use the Thin Plastic Spudger to gently cut the adhesive from the top of the Battery Inlay as shown.

12. Use fingers to remove the pin from the phone and Fixture.

13. Use the Thin Plastic Spudger to break the suction on the suction cups attached to the Battery Inlay.



14. After all the suction cups have been released, carefully slide the phone out of the Battery Removal Fixture.



15. Carefully lift the Battery Inlay from the Rear Housing.



Battery Inlay Removal Method B

1. Follow preheating steps described on page18.

2. Use a Suction Cup tool to hold the Battery Inlay firmly and create a gap between the Battery Inlay and the phone.



3. Use the Thin Plastic Spudger to disengage the Battery Inlay from the all sides of the Rear Housing.

// CAUTION //

Do not insert the Thin Plastic Spudger more than 10 mm to prevent damaging internal components.



4. Use the Thin Plastic Spudger to loosen or cut the adhesive holding the Battery Inlay. If necessary, reheat the phone as you work your way around the edges of the phone.

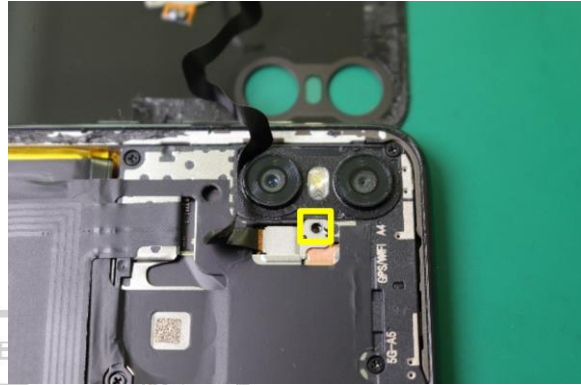


5. Carefully lift the Battery Inlay from the Rear Housing.



Battery Inlay Removal Completion

1. Use the Torque Driver with ph0 Torx Bit to loosen the screw holding the rail on the Display Flex Shield as shown.



2. Use the plastic Tweezer to remove the Steel Sheet as shown.



3. Use the flat end of the Black Stick to remove the FPS Flex.



4. Remove the Battery Inlay from the phone.



Battery Mylar Removal

NOTE

Remove the Battery Mylar only if necessary. After you remove it, you cannot reuse it.



1. Use the flat end of the Black Stick to gently peel the Battery Mylar as shown.
2. Use the plastic Tweezer to remove the Battery Mylar from the Battery Inlay.



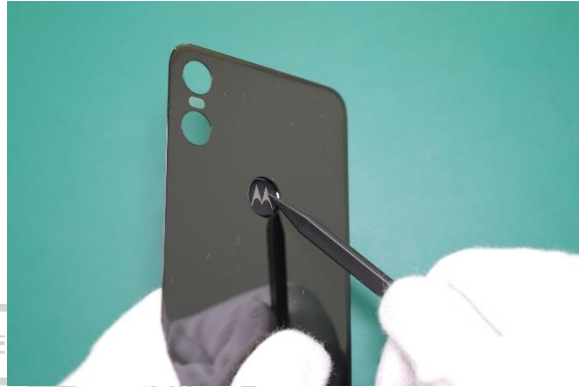
Finger Print Sensor Removal

NOTE

The Finger Print Sensor can be recovered and reused after removal.



Use the pointed end of the Black Stick to push out the Finger Print Sensor from the Battery Inlay as shown.



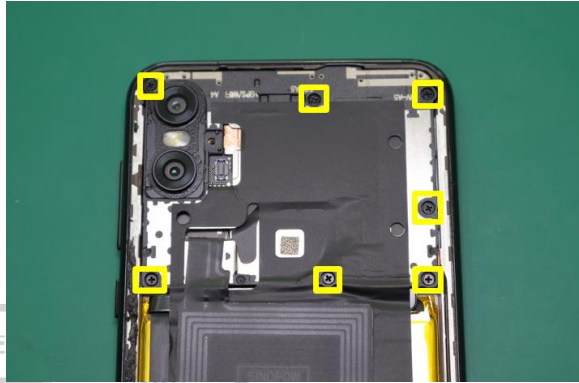
Middle Chassis Removal

NOTE

The Middle Chassis can be recovered and reused after removal.



1. Use the Torque Driver with ph0 Torx Bit to loosen the screws shown.



2. Use the flat end of the Black Stick to lift up the Middle Chassis.



3. Use fingers to lift the Middle Chassis from the Rear Housing as shown.



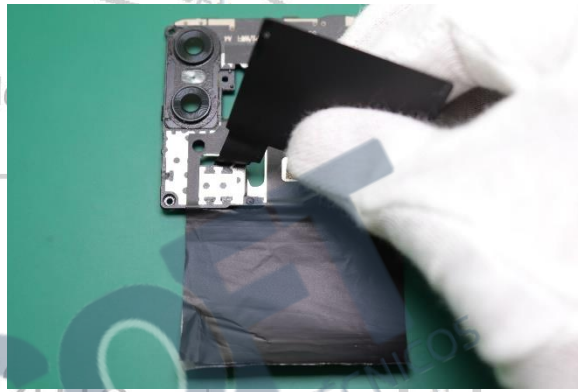
NFC Flex Removal

NOTE

Remove the NFC Flex only if necessary. After you remove it, you cannot reuse it.



1. Use the flat end of the Black Stick to disengage the NFC Flex from the pocket on the Middle Chassis.
2. Use your fingers to remove the NFC Flex from the Middle Chassis as shown.



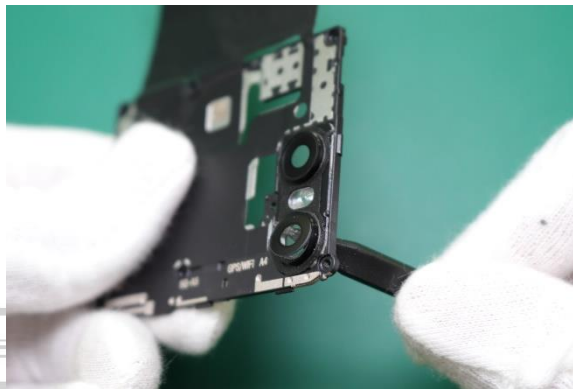
Rear-Facing Camera Lens Removal

NOTE

Remove the Rear-Facing Camera Lens only if it is defective or damaged.



1. Use your pointed end of the Black Stick to carefully disengage and push out the Rear-Facing Camera Lens above the Flash Lens.
2. Use your pointed end of the Black Stick to carefully disengage and push out the Rear-Facing Camera Lens below the Flash Lens.



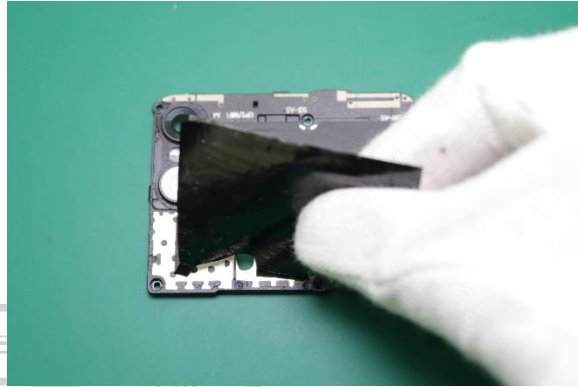
Battery Inlay Graphite Removal

NOTE

Remove the Battery Inlay Graphite only if necessary. After you remove it, you cannot reuse it.



Use fingers to peel off the Battery Inlay Graphite as shown.



Water Detection Label Inspection

NOTE

If the Water Detection Label (WDL) is activated, the phone's warranty no longer applies.

Inspect the Water Detection Label on the Main PCB for signs of activation.



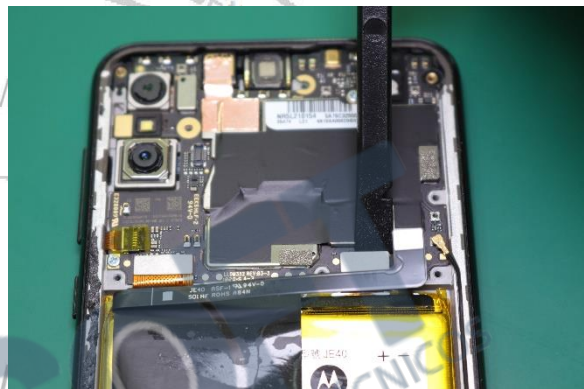
Main PCB Removal

NOTE

The Main PCB can be recovered and reused after removal.



1. Use the flat end of the Black Stick to remove the Battery Flex BtB Connector from the pocket on the Main PCB.
2. Use the flat end of the Black Stick to disengage the Main Flex BtB Connector from the Main PCB.
3. Use the flat end of the Black Stick to remove the Display Flex BtB Connector.
4. Use the plastic Tweezer to remove the Side Key Flex Mylar as shown.



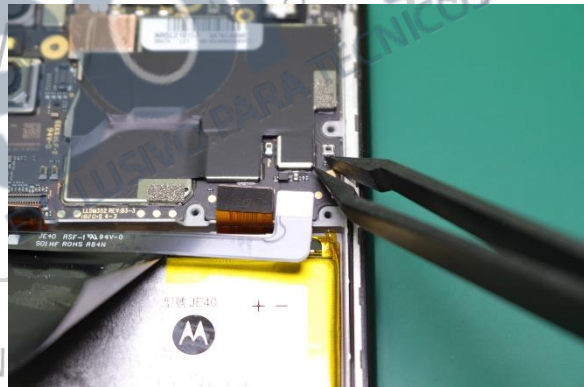
5. Use the flat end of the Black Stick to open the ZIF Connector Door.



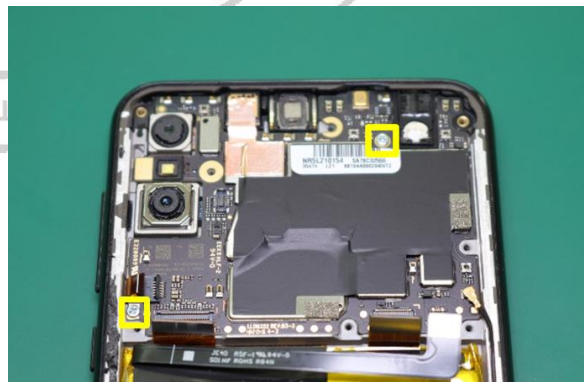
6. Use the plastic Tweezer to remove the Side Key Flex from the Main PCB carefully.



7. Use the plastic Tweezer to remove the Coax Cable from the location on the Main PCB as shown.



8. Use Torque Driver with ph0 Torx Bit to loosen the screws shown.



9. Use the flat end of the Black Stick to remove Main PCB from the Rear Housing.



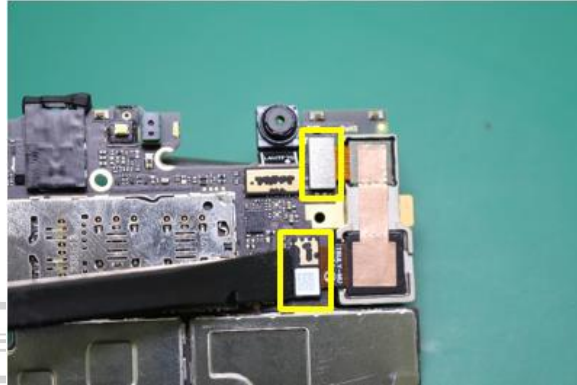
Rear-Facing Imager Removal

NOTE

Remove the Earpiece Speaker foam only if it is defective or damaged.



Use the flat end of the Black Stick to remove the Rear-Facing Imager as shown.



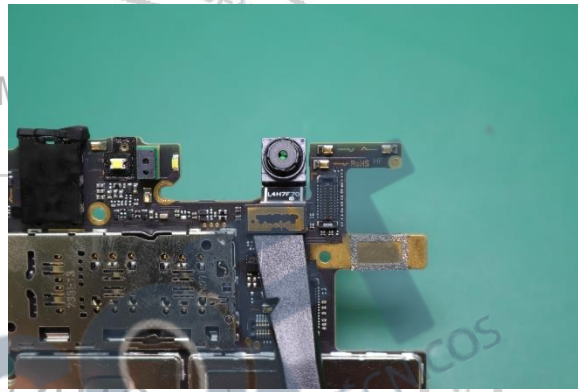
Front-Facing Imager Removal

NOTE

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



1. Use the plastic Tweezer to remove the Front-Facing Camera Copper Foil.
2. Use the flat end of the Black Stick to remove the Front-Facing Imager from the Main PCB.



Front-Facing Camera Copper Foil Removal

NOTE

Remove the Front-Facing Camera Copper Foil only if it is defective or damaged. After you remove it, you cannot reuse it.



Use the plastic Tweezer to remove the Front-Facing Camera Copper Foil as shown.



Factory Track ID Label Removal

NOTE

Remove the Factory Track ID Label only if it is defective or damaged. After you remove it, you cannot reuse it. You will need to reprint and place a new label.



Use the plastic Tweezer to remove the Factory Track ID Label from the CPU shield on the Main PCB.



Main PCB Graphite Removal

NOTE

Remove the Main PCB Graphite only if necessary. After you remove it, you cannot reuse it.



Use the plastic Tweezer to peel the Main PCB Graphite from the Shields on the Main PCB as shown.



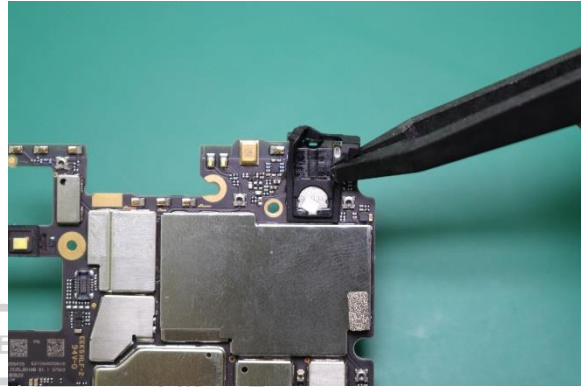
Headset Jack Grommet Removal

NOTE

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



Use the plastic Tweezer to place the Headset Jack Grommet as shown.



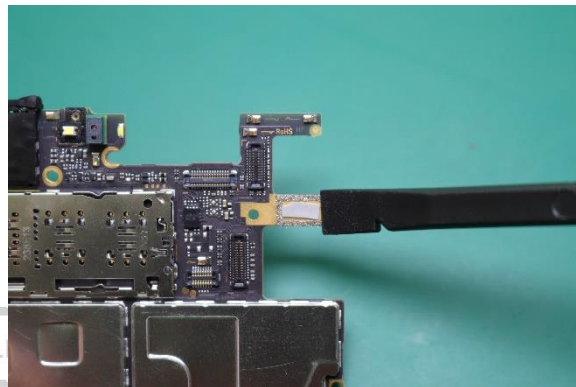
Rear-Facing Camera Silicone Pad and Foam Removal

NOTE

Rear-Facing Camera Silicone Pad and Foam cannot be recovered and reused after removal.



1. Use the flat end of the Black Stick to remove the Rear-Facing Camera Silicone Pad from the Main PCB.
2. Use the plastic Tweezer to remove the Rear-Facing Camera Foam as shown.



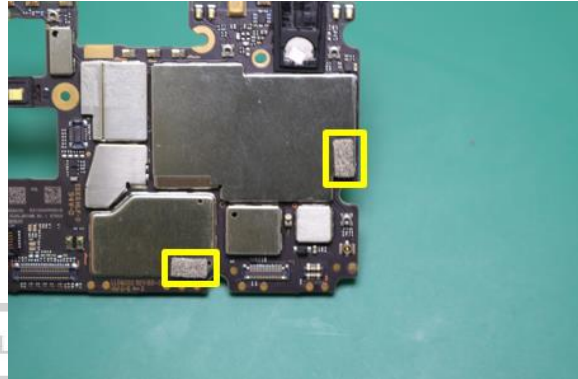
Main PCB Conductive Cloth Removal

NOTE

Remove the Main PCB Conductive Cloth only if necessary. After you remove it, you cannot reuse it.



Use the flat end of the Black Stick to remove the Main PCB Conductive Cloth from the location on the Main PCB.



Speaker Board Removal

NOTE

The Speaker Board can be recovered and reused after removal.



1. Use the Torque Driver with p0 Torx Bit to loosen the screws on the Speaker Board as shown.
2. Use the flat end of the Black stick to lift the Speaker Board from the Rear Housing.

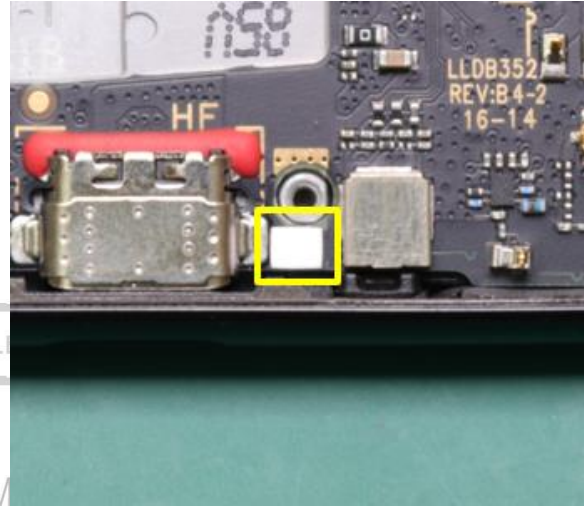


Water Detection Label Inspection

NOTE

If the Water Detection Label (WDL) is activated, the phone's warranty no longer applies.

Inspect the Water Detection Label on the Main PCB for signs of activation.



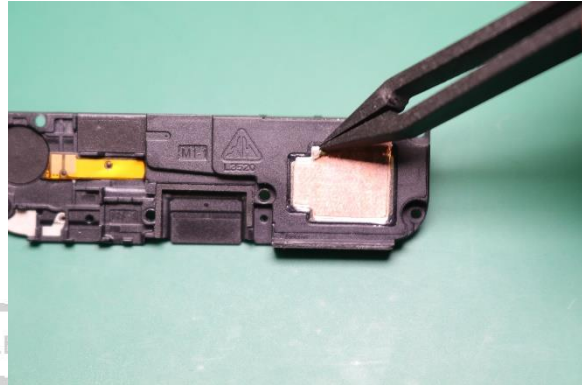
Speaker Copper Foil Removal

NOTE

Remove the Speaker Copper Foil only if necessary. After you remove it, you cannot reuse it.



Use the plastic Tweezer to remove the Secondary Mic Grommet from the Main PCB as shown.



Sub Board Removal

NOTE

The Sub Board can be recovered and reused after removal.



1. Use the flat end of the Black Stick to carefully remove the Connector from the location on the Sub Board.
2. Use the plastic Tweezer to remove Coax Cable as shown.
3. Use the flat end of the Black Stick to lift the Sub Board from the Rear Housing.



Vibrator Removal

NOTE

Remove the Vibrator only if necessary. After you remove it, you cannot reuse it.



Use the pointed end of the Black Stick to remove the Vibrator from the location as shown.



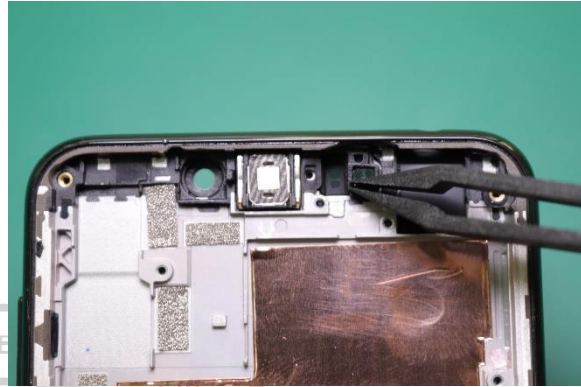
Primary MIC Grommet Removal

NOTE

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



Use the plastic Tweezer to remove the Primary MIC Grommet as shown.



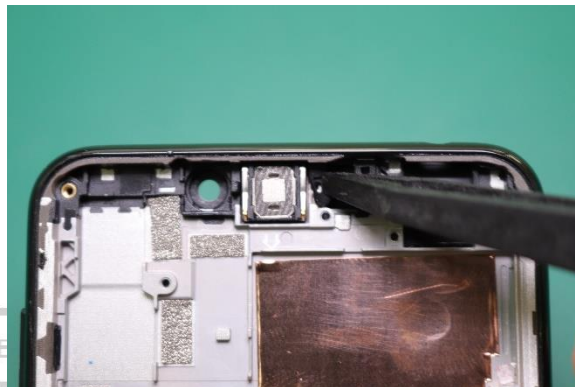
Proximity Sensor Grommet Removal

NOTE

The Proximity Sensor Grommet can be recovered and reused after removal.



Use the plastic Tweezer to remove the Proximity Sensor Grommet as shown.



Earpiece Speaker Removal

NOTE

Remove the Earpiece Speaker only if necessary. Once you remove it, you cannot reuse it.



Use the flat end of the Black Stick to remove the Earpiece Speaker from the pocket as shown.



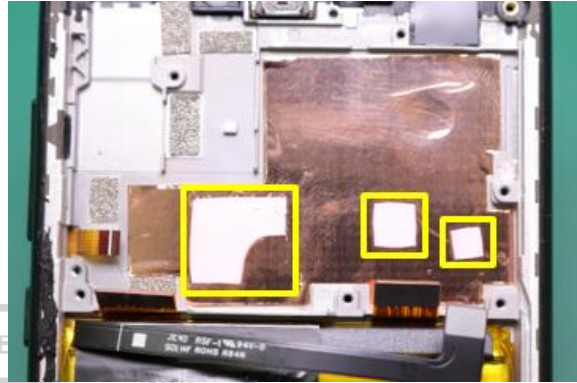
Main PCB Silicone Pad Removal

NOTE

The Main PCB Silicone Pad cannot be recovered and reused after removal.



Use the flat end of the Black Stick to remove the Main PCB Silicone Pad from the Main PCB as shown.



Battery Graphite Removal

NOTE

The Battery Graphite can be recovered and reused after removal.



Use the plastic Tweezer to peel off the Battery Graphite from the Battery as shown.



Battery Removal

Preheating for Battery Removal

NOTE

Remove the Battery only if necessary. After you remove it, you cannot reuse it.



// CAUTION //

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

1. Set the Hot Plate to 80 °C (176 °F).

NOTE

Preheating with an oven is also acceptable if the oven is set to the same temperature.

2. Place the phone in the Heating Plate, with the Display side down.



3. Wait 10 minutes for the Display Adhesive to warm up.
4. Remove the phone from the Heating Plate or the oven.

// CAUTION //

Wear protective gloves when handling heated phones.

NOTE

Perform the Battery removal procedure before the phone starts to cool off.

Battery Removal Procedure

1. Use the Thin Plastic Spudger to cut the adhesive on the sides of the Battery as shown.



2. Use fingers to remove the Battery from the Rear Housing.



Main Flex Removal

NOTE

The Main Flex cannot be recovered and reused after removal.



Use fingers to peel off the Main Flex as shown.



Secondary MIC Grommet Removal

NOTE

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



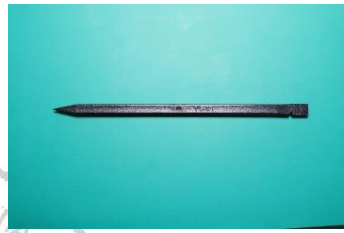
Use the plastic Tweezer to remove the Secondary Mic Grommet from the location on the Rear Housing as shown.



PARTS REFRESH

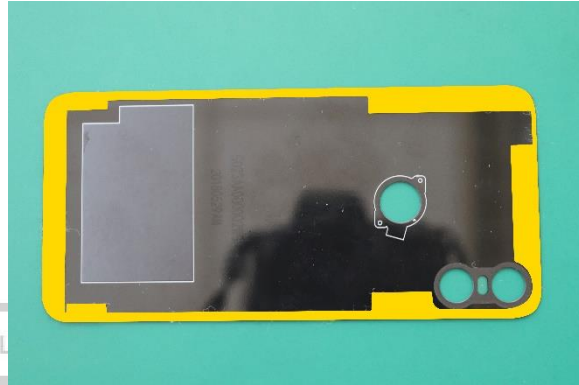
Tools Required for Parts Refresh

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

<i>Description</i>	<i>Part #</i>	<i>Image</i>
Black Stick	--	
Plastic Tweezer	--	--
ESD Mat	--	--
Wrist Strap	--	--
Isopropyl (ISP) Alcohol	--	--
Cotton Swabs	--	--
Cleaning Pads	--	--
Gloves or Finger Collets	--	--

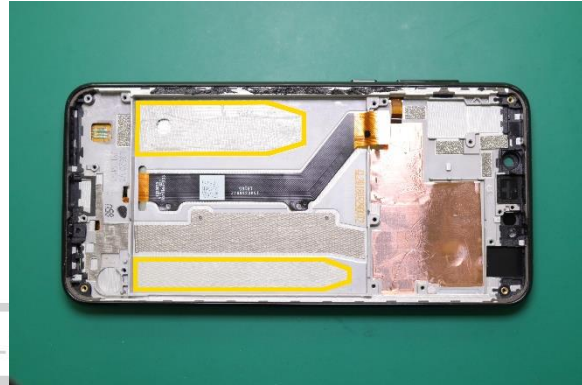
Battery Inlay Cleaning

Use the Black Stick to remove all the adhesives on the Battery Inlay.



Rear Housing Cleaning

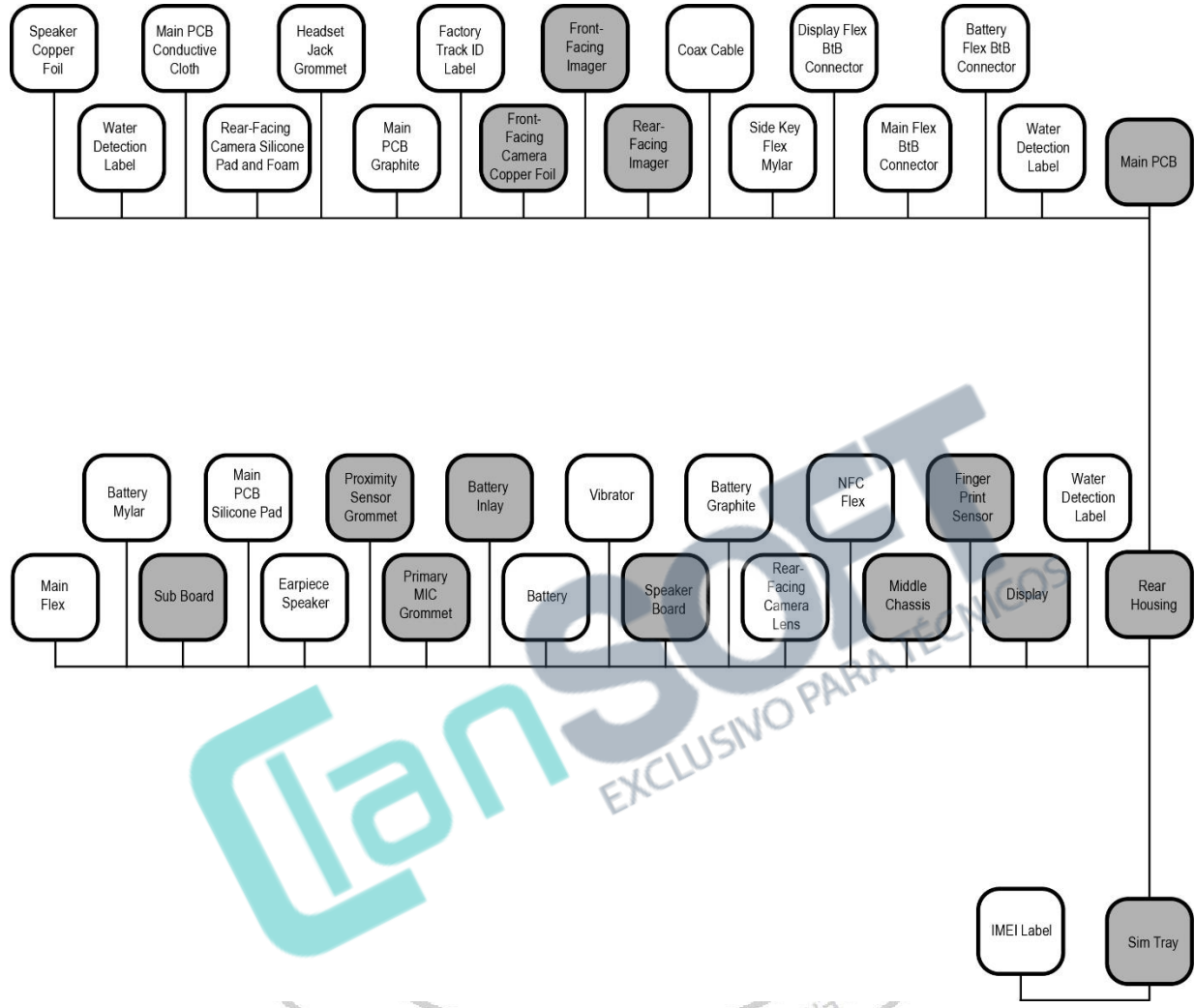
Use the Cotton Swabs with ISP Alcohol to remove all the adhesives on front side of the Rear Housing.



ASSEMBLY

Assembly Map





*Shaded parts may be eligible for parts recovery.



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Tools Required for Assembly

The following tools are required to assemble the motorola one phone.

<i>Description</i>	<i>Part #</i>	<i>Picture / Drawing</i>
Black Stick	--	
ph00 Bit (Adjustable)	--	
3 mm Allen Wrench	--	
Torque Driver	--	
Manual Roller	--	--
Tweezers (Plastic)	--	--
Gloves or Finger Collets	--	--

Primary MIC Grommet Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 MIC1 Rubber&5061AA000061 CS	4

Use the plastic Tweezer to place the Primary Mic Grommet as shown.



Main Flex Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 Main FPC&6680AA000047 CS	22
XT1941 Main FPC Adhes&5450AA000163 CS	-

1. Peel the Main Flex from the carrier.

2. Use fingers to carefully place the Main Flex onto the Rear Housing, sticky side down.

NOTE

Be sure the printing on the Main Flex is oriented in relation to the Rear Housing as shown. The word Main should be near the Main PCB.



Battery Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
ASSY,BAT,LI POLY,HE50,AMPEREX TYP5000MAH ACCY,BAT,ACCESSORY,BATTERY,3000mAh,JE40;	15
XT1941 Batt Adhes_1&5420AA000172 CS	-
XT1941 Batt Adhes_2&5420AA000171 CS	-

/// 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.

NOTE

Use the Fixture to assemble the Battery.

// 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 Adhesive on the location on the Rear Housing as shown and peel off the liner.



2. Use fingers to place the Battery on the Rear Housing as shown.



3. Use the Manual Roller to roll over the Battery for 10 cycles to secure the Battery on the Rear Housing.

NOTE

For each cycle roll the Manual Roller from top to bottom of the Battery and vice versa.

NOTE

Each cycle should last for 3 seconds.



Battery Graphite Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
ASSY,BAT,LI POLY,HE50,AMPEREX TYP5000MAH ACCY,BAT,ACCESSORY,BATTERY,3000mAh,JE40;	15
LC+5460SK000087+bat thermal film(YH)	19

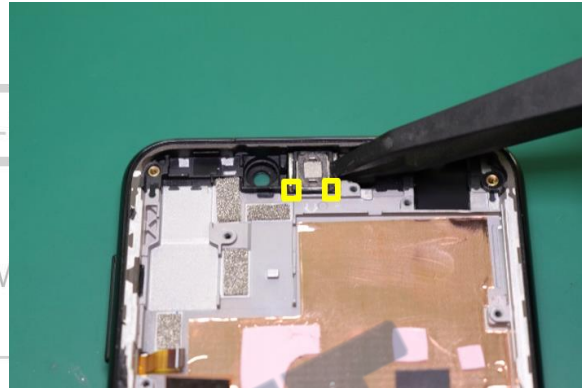
Use fingers to place the Battery Graphite on the Battery as shown.



Earpiece Speaker Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 Receiver&2626AA000002 CS	3

Use the plastic Tweezer to place the Earpiece Speaker on the location on the Rear Housing aligning with the pins as shown.



Proximity Sensor Grommet Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
LC+5061SK000058+L3520 gg_rub(DP)	6

Use the plastic Tweezer to place the Proximity Sensor Grommet on the Rear Housing.



Secondary MIC Grommet Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 MIC2 Rubber&5061AA000060 CS	17
LC+5430SK000147+L3520 S_MIC poron	-

Use the plastic Tweezer to place the Secondary MIC Grommet on the Rear Housing.



Sub Board Adhesive Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 Sub board Adhes&5450AA000162 CS	-

Use fingers to place the Sub Board Adhesive on the location on the Rear Housing.



Vibrator Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 Motor&2623AA000006 CS	18
XT1941 Motor Adhes&5450AA000164 CS	-

Use the plastic Tweezer to place the Vibrator in the pocket on the Rear Housing.



Sub Board Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941-4 Sub Board&6818AA00132 CS XT1941-3 Sub Board&6818AA00 CS XT1941-3 BR DS CKD SUB PCBA FOR MP	16
LC+4610SK000026+L3520 screw_M1.4_3.5(BK)	25

1. Use the plastic Tweezer to place the Sub Board on the location as shown.



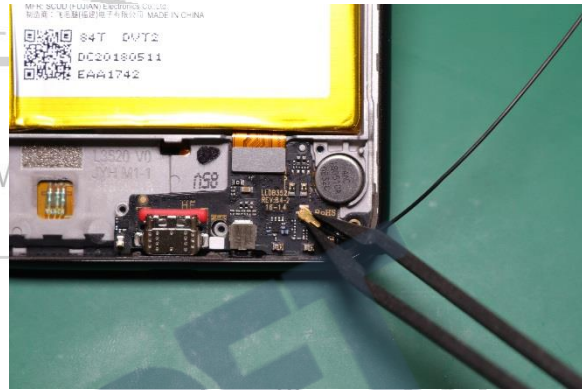
2. Use fingers to lock the Main Flex BtB connector as shown.



Coax Cable Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941-4 Sub Board&6818AA00132 CS XT1941-3 Sub Board&6818AA00 CS XT1941-3 BR DS CKD SUB PCBA FOR MP	16
XT1941 RF Cable&5234AA000005 CS	24

1. Use the plastic Tweezer to place the Coax Cable on the Cable Connector.



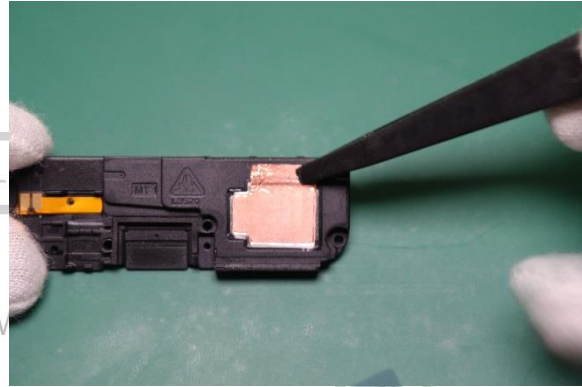
2. Use fingers to place the Coax Cable in the pocket as shown.



Speaker Copper Foil Assembly

<i>Description</i>	<i>Reference #</i>
LC+5470SK000025+L3520 BOX cu foil(YH)	20
LC+5016SK000016+L3520 SPK BOX(HS+HT)	21

Use the plastic Tweezer to place the Speaker Copper Foil in the location on the Speaker Board.



Speaker Board Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941-4 Sub Board&6818AA00132 CS XT1941-3 Sub Board&6818AA00 CS XT1941-3 BR DS CKD SUB PCBA FOR MP	16
LC+5016SK000016+L3520 SPK BOX(HS+HT)	21

1. Use fingers to place the Speaker Board as shown.



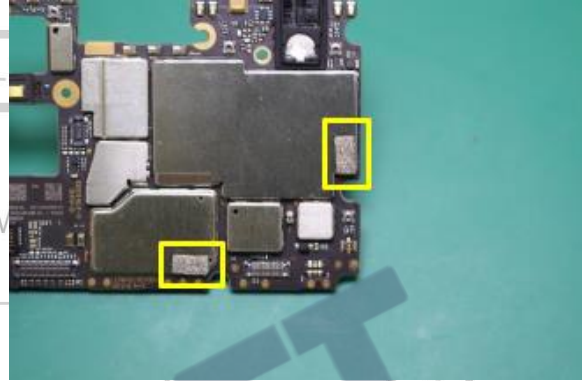
2. Use the Torque Driver with ph0 Torx Bit to tighten the screws shown.



Main PCB Conductive Cloth Assembly

Description	Reference #
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8
LC+5450SK000112+L3520 r_ke&MB elec foam	-

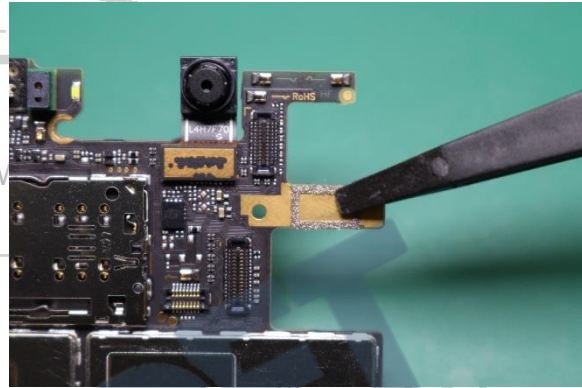
Use the plastic Tweezer to place the Main PCB Conductive Cloth on the location shown on the Main PCB.



Rear-Facing Camera Silicone Pad and Foam Assembly

Description	Reference #
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8
LC+5460SK000049+L3520 rear LED rub(YH)	-
LC+5450SK000110+L3520 r_CAM&MB elec foam	-

1. Use the plastic Tweezer to place the Rear-Facing Camera Foam as shown.



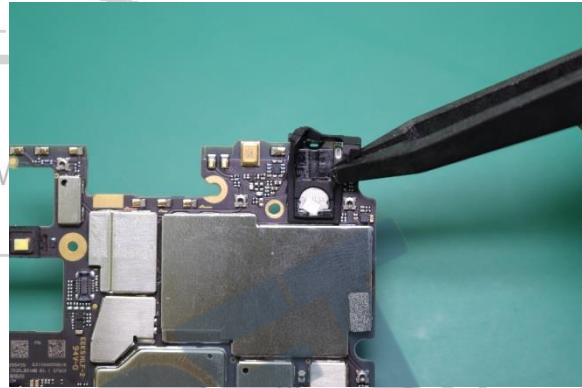
2. Use the plastic Tweezer to place the Rear-Facing Camera Silicone Pad on the Main PCB.



Headset Jack Grommet Assembly

Description	Reference #
LC+5061SK000059+L3520 ear_rubb(DP)	5
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8
LC+5420SK000117+L3520 audiojack adh	-

Use the plastic Tweezer to place the Headset Jack Grommet on the Main PCB as shown.



Main PCB Graphite Assembly

<i>Description</i>	<i>Reference #</i>
LC+5061SK000059+L3520 ear_rubb(DP)	5
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8
LC+5420SK000117+L3520 audiojack adh	-

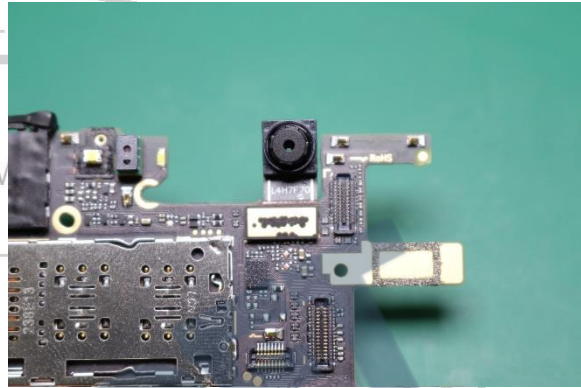
Use the plastic Tweezer to place the Main PCB Graphite on the Main PCB as shown



Front-Facing Imager Assembly

Description	Reference #
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8
MDL,CAMR,8MP,OFILM L4H7F70 COB FF 30PIN	7
LC+5470SK000026+L3520 f_cam foil(YH)	-

1. Use fingers to place the Front-Facing Imager on the Main PCB.



2. Use the plastic Tweezer to place the Front-Facing Camera Copper Foil.



Rear-Facing Imager Assembly

<i>Description</i>	<i>Reference #</i>
LC+2640SK000015+L3520 bk cam 13+2 XL	2
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8

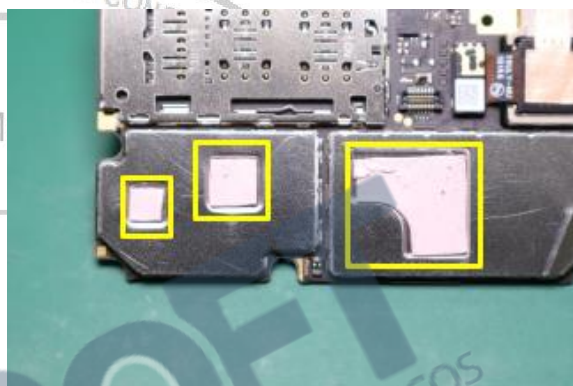
Use fingers to place and secure the Rear-Facing Imager on the Main PCB.



Main PCB Silicone Pad Assembly

Description	Reference #
LC+5460SK000050+L3520 thermal rub1(YH)	-
LC+5460SK000056+L3520 thermal rub2(YH)	-
LC+5460SK000052+L3520 thermal rub3(YH)	-
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8

Use the plastic Tweezer to place the Main PCB Silicone Pad on the Main PCB as shown.



Main PCB Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941-4 4+64G MB_DS&6818AA000134 CS XT1941-3 4+64G MB_DS&6818AA000131 CS XT1941-5 4+64G MB_SS&6818AA000133 CS XT1941-3 BR DS CKD PCBA FOR MP	8
LC+5480SK000053+L3520 side key mylar	-
LC+5480SK000069+L3520 bat_mylar	-
LC+4610SK000027+L3520 screw_M1.4_2.5(SL)	-

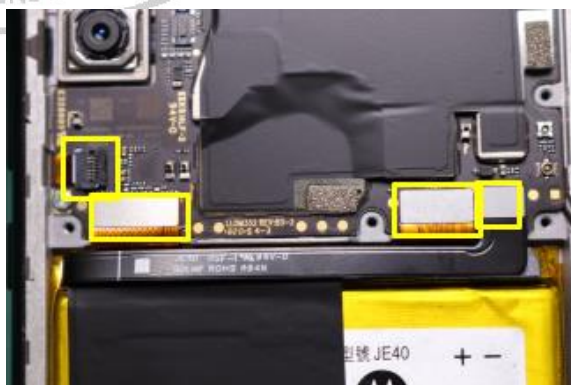
1. Use fingers to place the Main PCB in the location on the Rear Housing.



2. Use Torque Driver with ph0 Torx Bit to tighten the screws shown.



3. Use fingers to connect the Battery Flex BtB Connector, Main Flex BtB Connector, and Display Flex BtB Connector on the Main PCB.



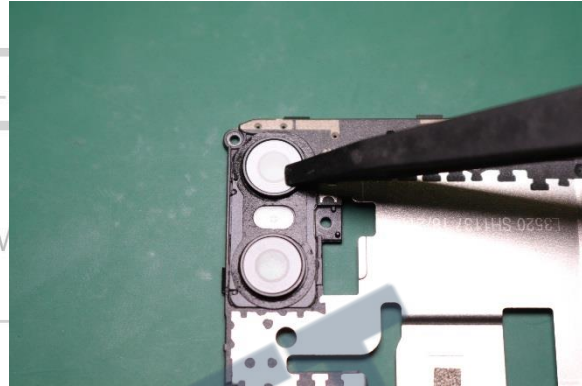
4. Use the plastic Tweezer to place the Side Key Flex Mylar as shown.



Rear-Facing Camera Lens Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 Rear Housing_WH&7601AA000071 CS XT1941 Rear Housing_BL&7601AA000072 CS	9
LC+5030SK000031+L3520 back cam lens(IS)	-
XT1941 Cam lens Adhes&5420AA000173 CS	-

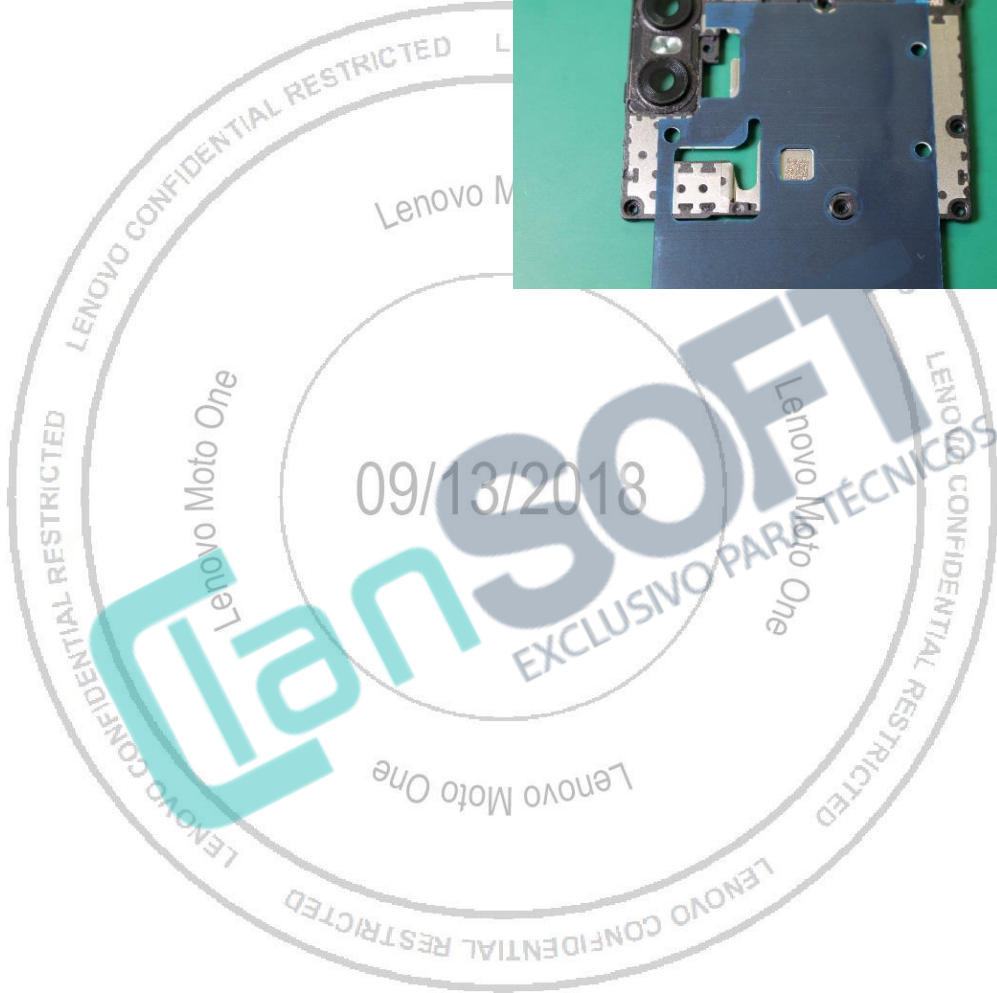
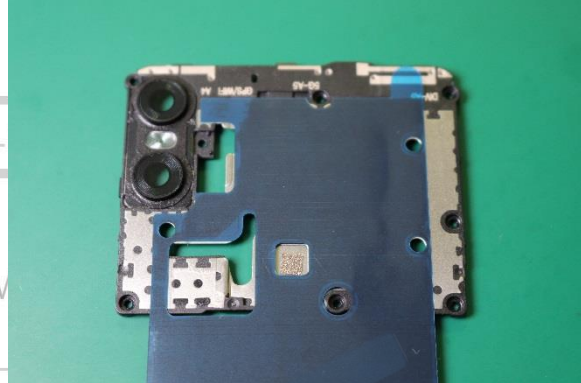
Use the plastic Tweezer to place the Rear-Facing Camera Lens as shown.



Battery Inlay Graphite Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 Rear Housing_WH&7601AA000071 CS XT1941 Rear Housing_BL&7601AA000072 CS	9
LC+5460SK000046+L3520 bat cover film(YH)	10

Use fingers to place and secure the Battery Inlay Graphite on the Battery Inlay.



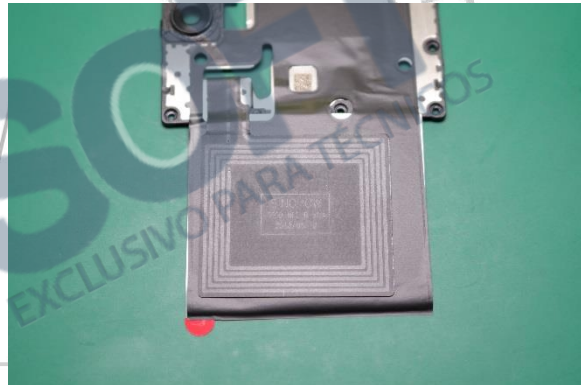
NFC Flex Assembly

Description	Reference #
XT1941 Rear Housing_WH&7601AA000071 CS XT1941 Rear Housing_BL&7601AA000072 CS	9
LC+5460SK000046+L3520 bat cover film(YH)	10
LC+5022SK000028+L3520 NFC(JW)	11

1. Use your fingers to connect the NFC Flex on the connector on the Middle Chassis with two pins in alignment.



2. Use fingers to place the NFC Flex on the Middle Chassis.



Middle Chassis Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 Rear Housing_WH&7601AA000071 CS XT1941 Rear Housing_BL&7601AA000072 CS	9
LC+5460SK000046+L3520 bat cover film(YH)	10
LC+5022SK000028+L3520 NFC(JW)	11

1. Use fingers to place the Middle Chassis in the pocket on the Rear Housing as shown.



2. Use fingers to attach the rest part of the graphite to the battery.



3. Use Torque Driver with ph0 Torx Bit to tighten the screws shown.



Finger Print Flex Assembly

Description	Reference #
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 Rear Housing_WH&7601AA000071 CS XT1941 Rear Housing_BL&7601AA000072 CS	9
MDL,FNGRPRT,K9S,ET516,CTG FG,BLK,SLVR,BL MDL,FNGRPRT,K9S,ET516,CTG FG,WHT,SLVR,SL	12
LC+5090SK000043+L3520 zhiwen sheet	13
LC+5450SK000088+L3520 FP elec foam	-
LC+5420SK000086+L3520 FP adhesive	-

1. Use the plastic Tweezer to place the Finger Print Flex in the location as shown.



2. Use the plastic Tweezer to place the steel sheet on the Finger Print Flex.



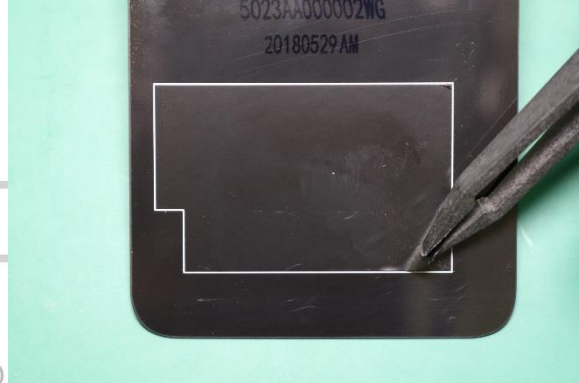
3. Use the Torque Driver with p0 Torx Bit to tighten the screw shown.



Battery Mylar Assembly

<i>Description</i>	<i>Reference #</i>
5480SK000069+L3520 bat_mylar	-

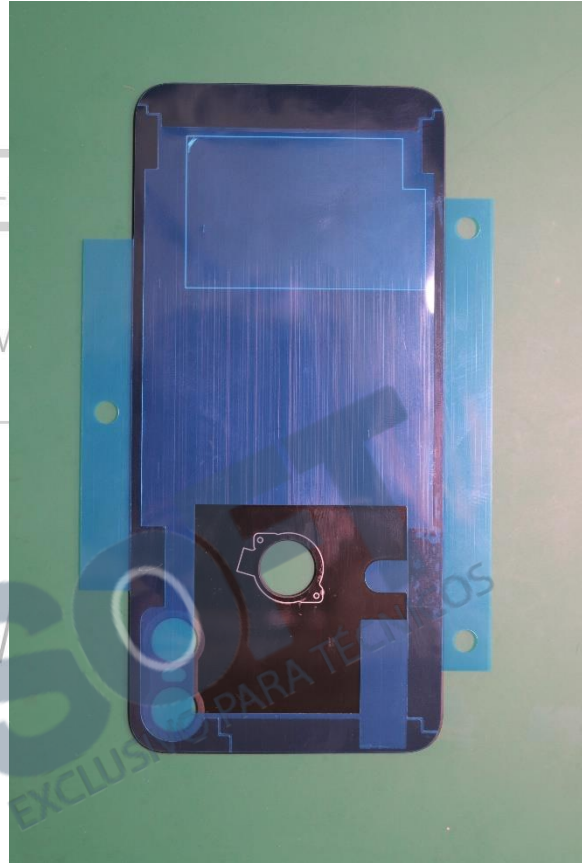
Use the plastic Tweezer to place the Battery Mylar on the location on the Battery Inlay as shown.



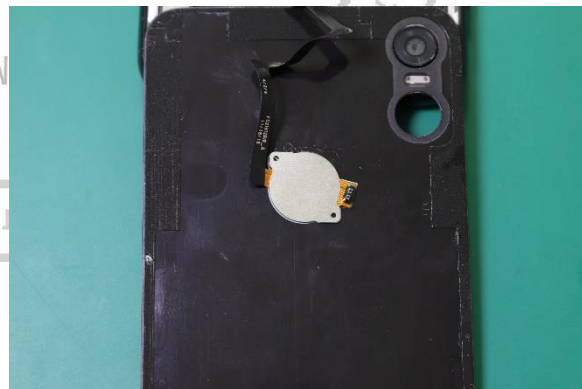
Battery Inlay Assembly

<i>Description</i>	<i>Reference #</i>
LC+5023SK000003+L3520 bat cover(WH WG) LC+5023SK000002+L3520 bat cover(BK WG)	14

- 1 Use the Plastic Tweezer to place the to position the Battery Inlay Adhesive to the Inlay in place, aligning the adhesive liner with the opening and the edges of the inlay as shown.



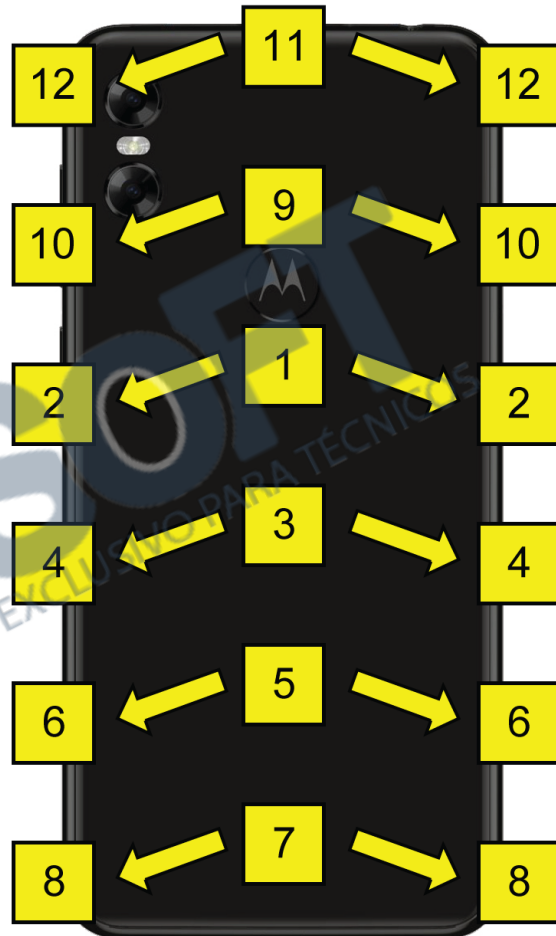
- 2 Use fingers to attach the Finger Print Sensor to the Battery Inlay.



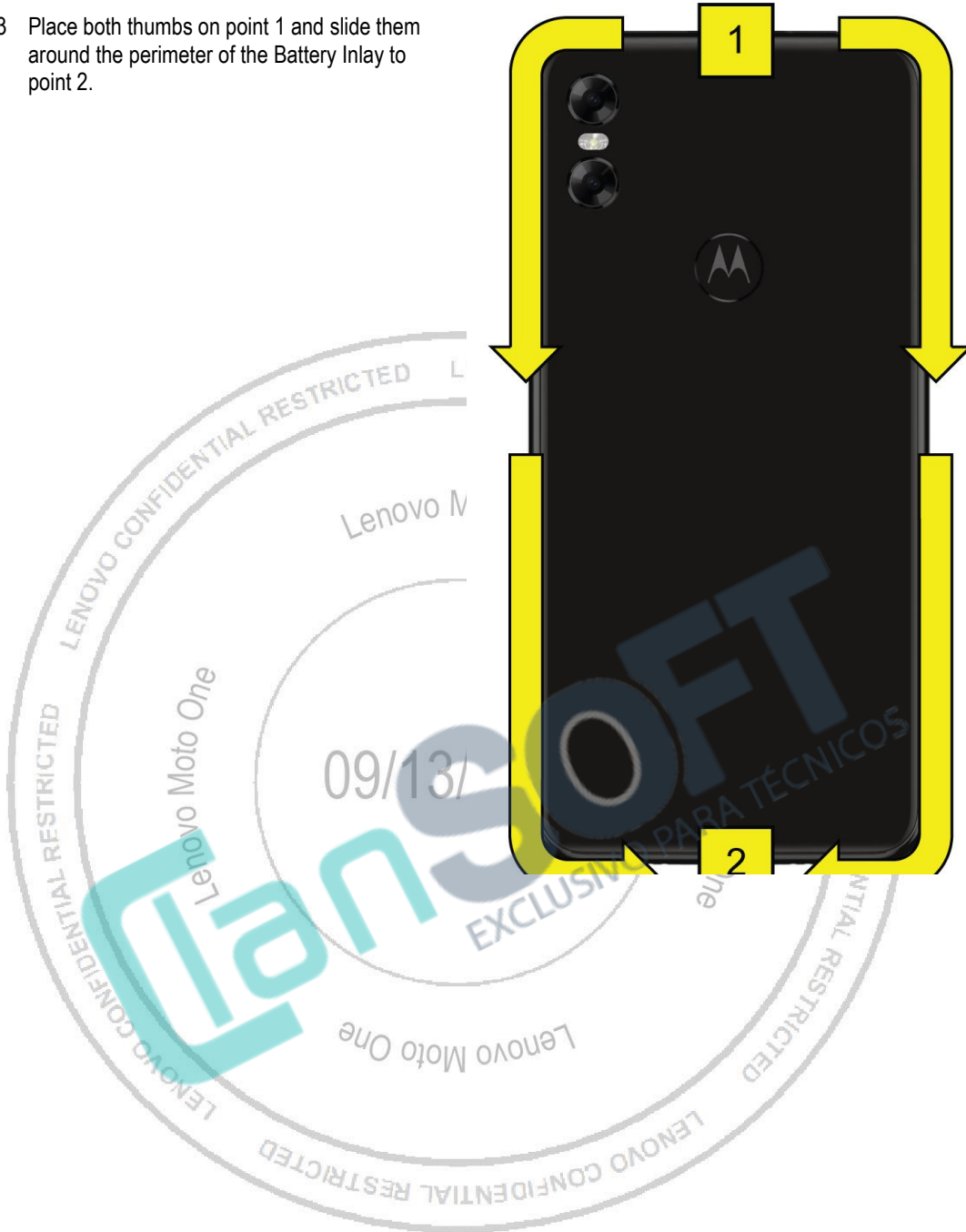
- 3 Verify the liners on the Battery Inlay and Imager Deco have been removed, if present.
- 4 Beginning at the top corners, attach the Battery to the Phone. Verify the Rear-Facing Camera fits through the hole in the Battery Inlay.
- 5 Verify the Inlay is seated in all 4 corners and not overlapping any of the Front Housing Edges.



- 6 Apply manual pressure to the Battery Inlay in the following sequence:
- 7 Place both thumbs on point 1 (in the middle of the Inlay) and slide them out to point 2.
- 8 Place both thumbs on point 3 and slide them out to point 4.
- 9 Place both thumbs on point 5 and slide them out to point 6.
- 10 Place both thumbs on point 7 and slide them out to point 8.
- 11 Place both thumbs on point 9 and slide them out to point 10.
- 12 Place both thumbs on point 11 and slide them out to point 12.



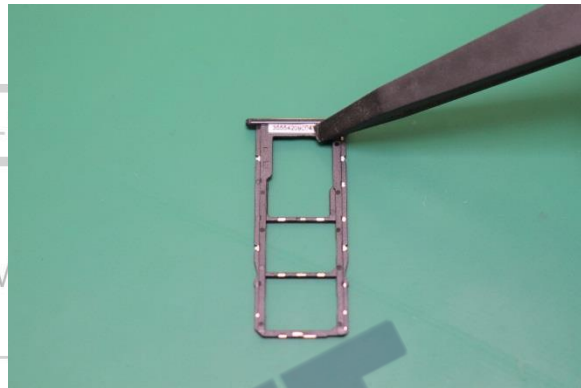
- 13 Place both thumbs on point 1 and slide them around the perimeter of the Battery Inlay to point 2.



IMEI Label Assembly

<i>Description</i>	<i>Reference #</i>
LC+5017SK000074+L3520 SIM tray(SI LM DU) LC+5017SK000076+L3520 SIM tray(BK LM DU) XT1941 SIM TRAY_SS_WH&5017AA000095 CS XT1941 SIM TRAY_SS_BL&5017AA000092 CS	23

Use the plastic Tweezer to place the IMEI Label on the SIM tray.



Sim Tray Assembly

<i>Description</i>	<i>Reference #</i>
XT1941 TP+LCM ASSY_WH&5079AA000041 CS XT1941 TP+LCM ASSY_BL&5079AA000042 CS	1
XT1941 Rear Housing_WH&7601AA000071 CS XT1941 Rear Housing_BL&7601AA000072 CS	9
LC+5017SK000074+L3520 SIM tray(SI LM DU) LC+5017SK000076+L3520 SIM tray(BK LM DU) XT1941 SIM TRAY_SS_WH&5017AA000095 CS XT1941 SIM TRAY_SS_BL&5017AA000092 CS	23

Use fingers to push Sim Tray in the Sim Tray Slot as shown.

