



Moto g55 5G

Level 2 – Service and Repair Manual





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## Revision History

Revision	Date	Notes
1	08/12/2024	Initial Release.
1.1	09/05/2024	Added SIM Tray Waterproof Mylar Removal and Assembly.





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## Chapter 1. Safety Information

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### Important

This manual includes technical instructions for replacing genuine parts in this product.

Read the entire manual before your repair.

Always use the latest version of this product service manual for repair.

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### Cautions and Warnings

Failure to follow the repair instructions or not to use genuine parts or proper tools may damage the device or compromise the device's functionality or water resistance.

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

Turn off the device before repair.

Loose screws, extra screws, or small parts inside the device can cause safety issue. Set aside all parts and screws removed during repair.





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## Chapter 2. Introduction

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### Acronyms and Abbreviations

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Table 1. Acronyms and Abbreviations

Abbreviation	Meaning
PU	Polyurethane
PMMA	Polymethylmethacrylate
PCB	Printed Circuit Board
MIC	Microphone
NFC	Near Field Communication
BTB	Board to Board
FPC	Flexible Printed Circuit
FPS	Fingerprint Sensor



## External Views

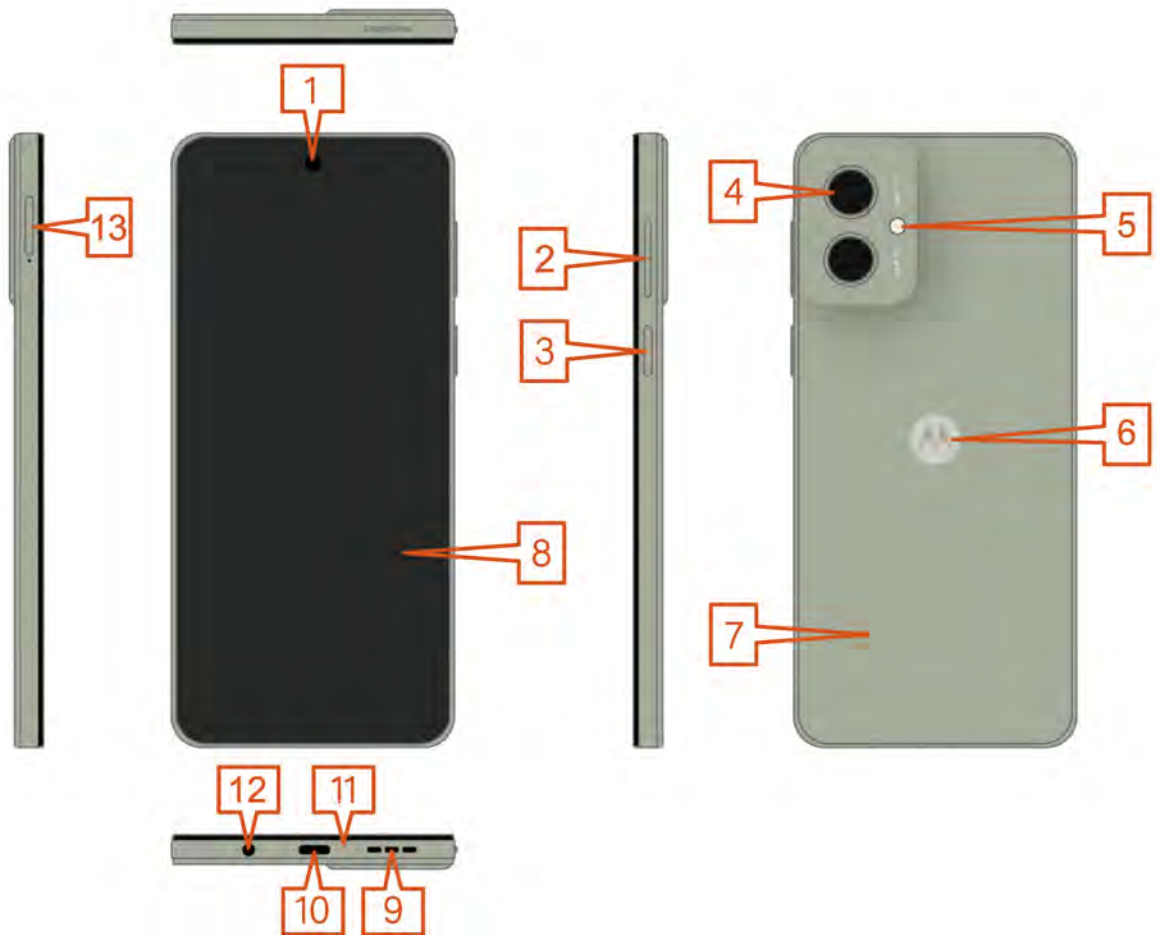


Figure 1. External Views

Table 2. External Views Parts List

Reference #	Description
1	Front-Facing Camera
2	Volume Key
3	Power Key / FPS
4	Rear-Facing Camera
5	Flashlight
6	Batwing Logo
7	Rear Inlay
8	Display Lens
9	Loudspeaker
10	USB Type-C
11	MIC

Table 2. External Views Parts List (continued)

Reference #	Description
12	Audio Jack
13	Sim Door



## Main Exploded Views

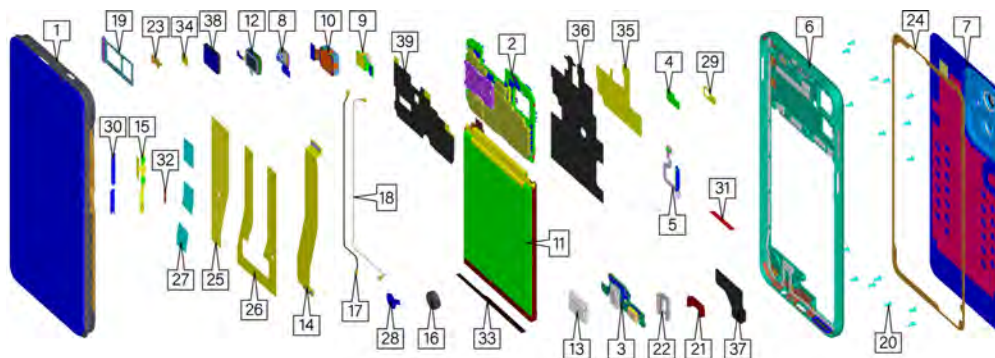


Figure 2. Assembly Exploded View

Table 3. Assembly Exploded View Parts List

Reference #	Description	Recovery Part
1	TPLCM,XT2435 CS	Yes
2	ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	Yes
3	ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	Yes
4	ASSY,DTR BRD,Taipei BR FLSH PCBA ASSY,DTR BRD,FLSH,XT2435 CS	Yes
5	HSG,FPS KIT,BLK,XT2435 CS HSG,FPS KIT,GRN,XT2435 CS HSG,FPS KIT,RED,XT2435 CS	Yes
6	HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	Yes

Table 3. Assembly Exploded View Parts List (continued)

Reference #	Description	Recovery Part
7	HSG,BAT CVR,BLK,PMMA,XT2435 CS HSG,BAT CVR,GRN,PU,XT2435 CS HSG,BAT CVR,RED,PU,XT2435 CS	Yes
8	MDL,CAMR,16M,front;C2EF06;Q Tech,FF:Devo	Yes
9	MDL,CAMR,8M,rear,C48A04;Qtech,AF:Cancun5	Yes
10	MDL,CAMR,50M,rear,C3PS66;Qtech,OIS:Cancu	Yes
11	ACCY,BAT,5000mAh,QA50,VK446590,Jaide ACCY,BAT,5000mAh,QA50,VK446590,Jaide,Lot	Yes
12	WT710400000241+receiver0.45mm,126dB1KHz	No
13	WT710300101131+Horn BOX component 1217	Yes
14	WT713301014121+MAIN-FPC,yaqi,MOLEX 40pin	Yes
15	WT713301014141+SIDE_KEY_FPC,39.32x10.29	Yes
16	WT710611000931+motor,B102740BA34-X	Yes
17	WT715601014021+black coaxial cable;DL	Yes
18	WT715601014011+white coaxial cable;DL	Yes
19	WT713001102011+single card tray,black sp WT713001102031+single card tray,light gr WT713001102041+single card tray,rose red	Yes
20	WT710900000721+Screw M1.4x3.2xT5Black;PG	No
21	WT712301014011+rubber sleeve,black;YC	Yes
22	WT712301014021+rubber sleeve,black;YC	Yes
23	WT712301014031+rubber sleeve,black;YC	Yes
24	WT712101102071+PMMA BATCVR ADH YH CS WT712101102081+PU BATCVR ADH YH CS	No
25	XT2343,ADH,BAT_Left,711501014711 CSS	No
26	XT2343,ADH,BAT_Right,711501014721 CSS	No
27	XT2343,ADH,MN FPC,711501014731 CSS	No
28	XT2343,ADH,VBRT,710600000221 CSS	No
29	XT2343,ADH,FLSH BD,711501014741 CSS	No
30	XT2343,ADH,SideFPC,713301014051 CSS	No
31	WT712101014221+battery cover adhesive,YH	No
32	WT712401014091+FPC SIDE KEY Foam,YH	No
33	WT712401014011+bottom protection foam	No
34	WT712101014021+2MGround conductive cloth	No
35	WT712101014011+Shielding Copper Foil;YH	No
36	WT715001062011+LS 6K- BOT shield heat di	No
37	WT715001102011+BOX Thermal film_LS	No

Table 3. Assembly Exploded View Parts List (continued)

Reference #	Description	Recovery Part
38	WT712901014231+HeatSink aluminumBlock;GN	No
39	WT715001014161, LS 6K TOP shielding cove	No
-	WT712700589051+IMEI label_35.6x27.6mm_QF	No
-	WT712700341031+waterproof labelFWZ	No
-	WT712101102111+Middle frame resonance gl	No
-	WT712101102121+Middle frame resonance RE	No
-	WT712401102011+Resonance Foam YH	No
-	WT712101102171+CardTray WaterProof MYLAR	No

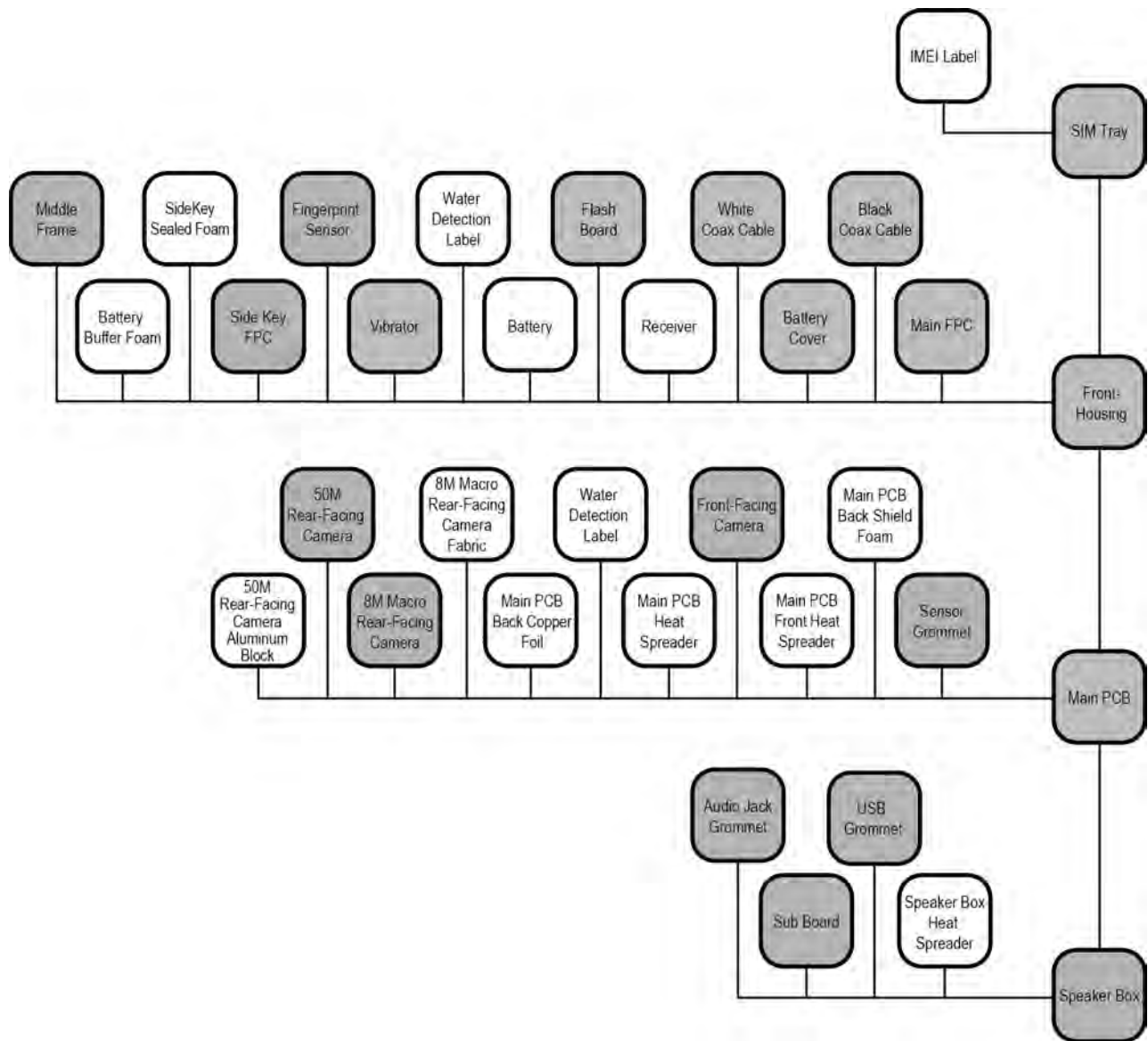




## Chapter 3. Disassembly and Recovery

### 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 g55 5G phone.

NOTE
Improper tools may cause damage to components.

Description	Part #	Picture/Drawing
3 mm Allen Wrench	--	
Anti-static foam pad Pad thickness : ≥5mm Pad Material : silicone rubber, as reference Silicone Clean Matt (RG-400)	--	
Regen-i Removal Fixture <a href="https://www.regeni.com/">https://www.regeni.com/</a>	RG271	
Hot Plate	--	
SIM/SD Tray Removal Tool	--	

Description	Part #	Picture/Drawing
Black Stick	--	
Torque Driver	--	
Shim	Moto g55 5G 4-00-5L-10000	
Torx Bit	Moto g55 5G 09/05/2024 --	
BtB Tool	Moto g55 5G --	
MINI Desktop LCD Freezing Separator	TBK-578	

Description	Part #	Picture/Drawing
Sealed Bag	--	
Plastic Tweezers	--	
Oven	Moto g55 5G RG-202F	
Thin Plastic Spudger	09/05/2024 0-00-00-40826	
PU Inlay Disassembly Tool	Moto g55 5G 30007085	
ESD Mat	--	--
Wrist Strap	--	--
Gloves	--	--

## SIM Tray Removal

### NOTE

The SIM Tray can be recovered and reused after removal.

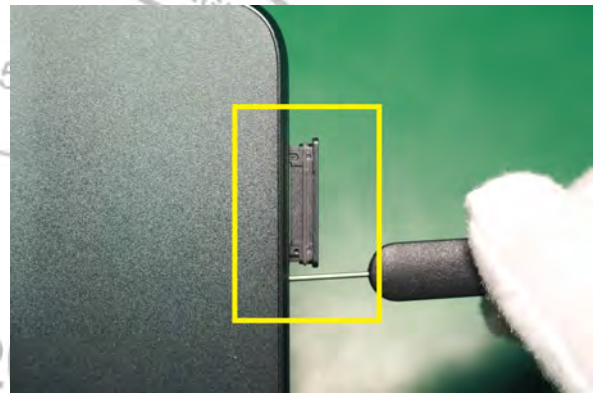


1. Power off the device before beginning with the procedure. Use the SIM Tray Removal pin to push into the SIM Tray hole.

### WARNING

Disassembling the device without turning it off may cause data loss.

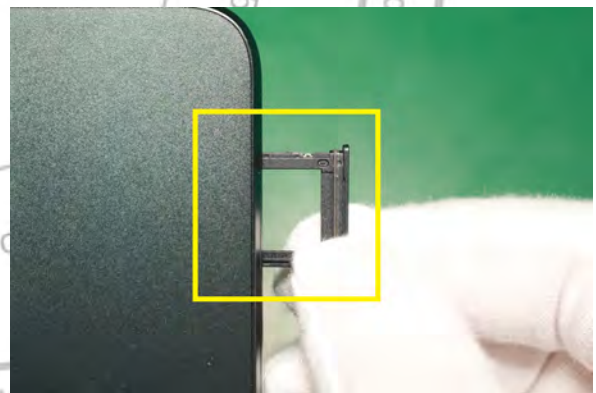
2. Press the SIM Tray removal tool to make it pop-out as shown.



3. Use fingers to take out the SIM Tray.

### NOTE

Remove the SIM Tray vertically outwards to avoid deformation.



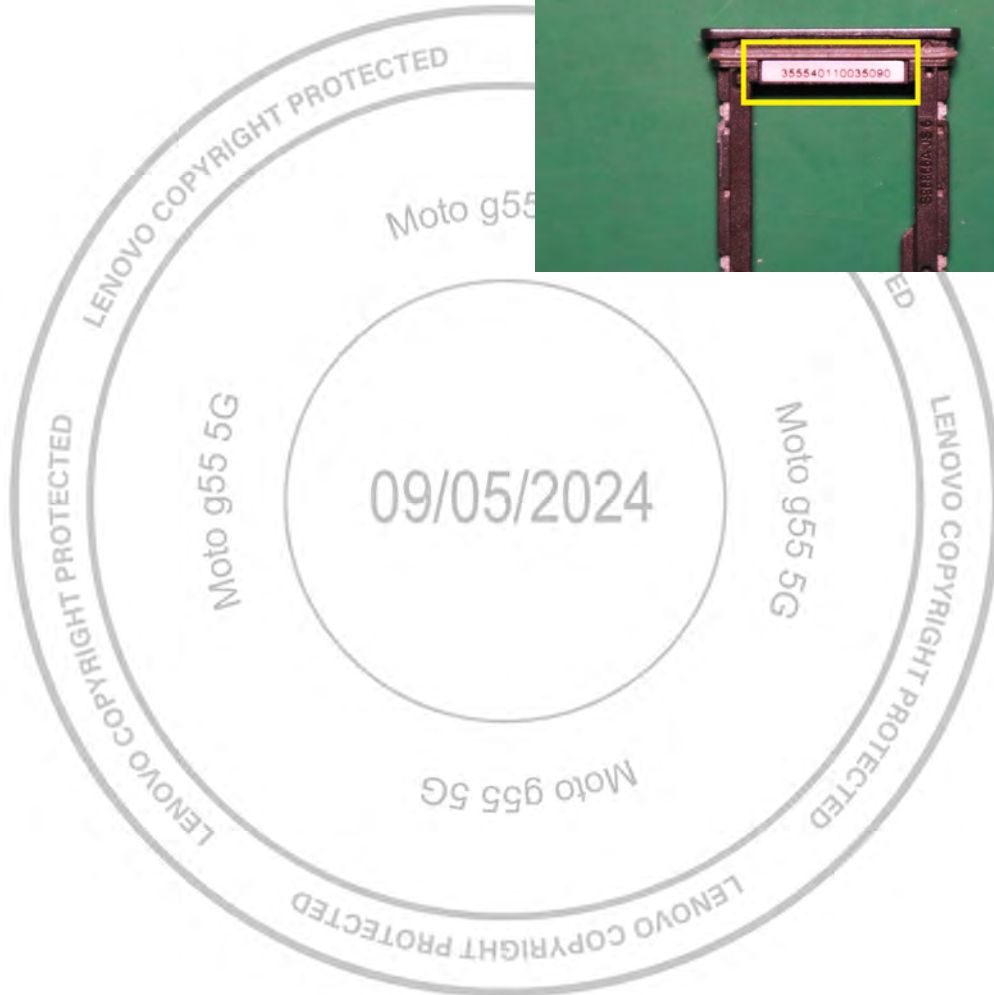
## IMEI Label Removal

### 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.

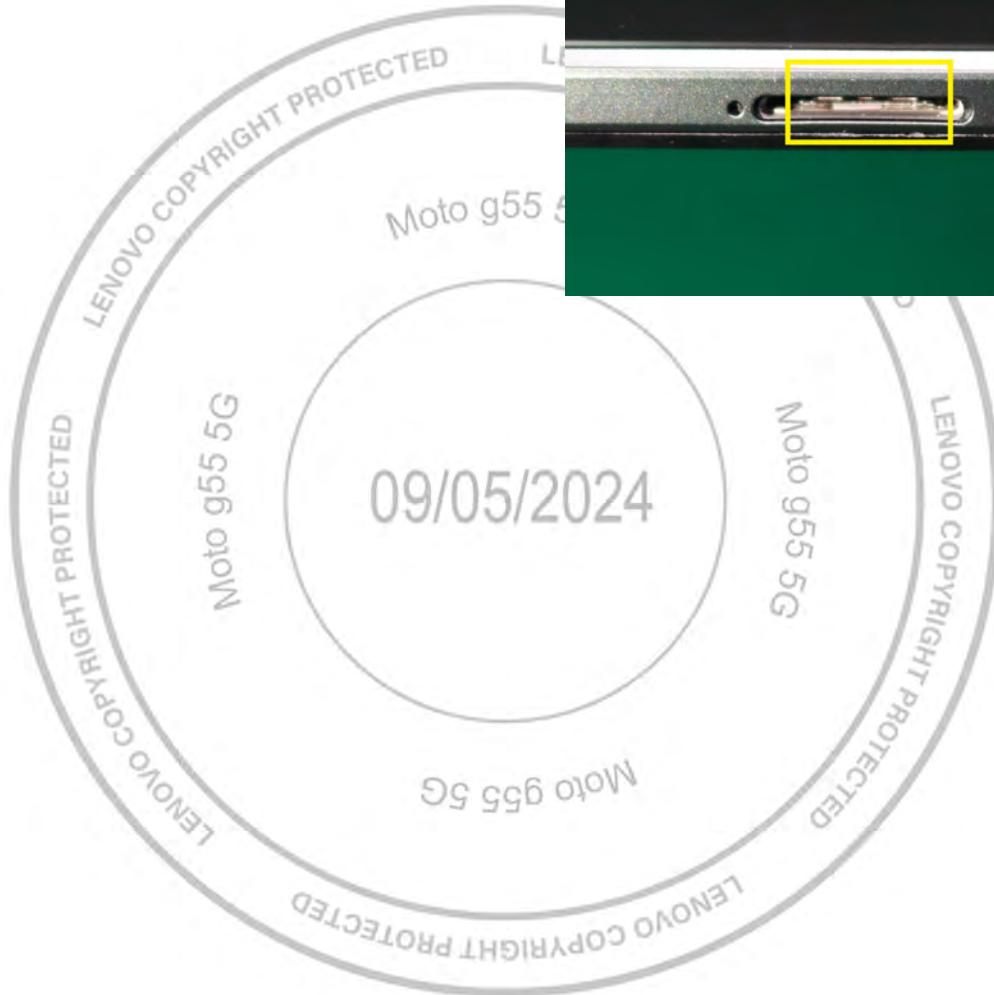
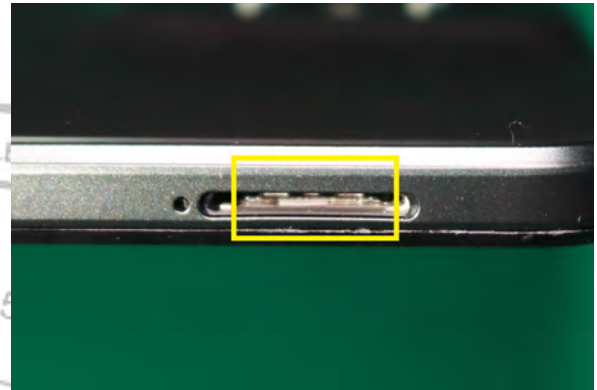


## Water Detection Label Inspection

### NOTE

If the Water Detection Label (WDL) has been activated, follow Return Un-Repaired (RUR) guidelines for further instructions.

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



## Battery Cover Removal

### Preheating for Battery Cover Removal

#### NOTE

The Battery Cover can be recovered and reused after removal.



#### NOTE

PMMA Battery Cover Removal Method A, PMMA Battery Cover Removal Method B, and PU Battery Cover Removal have the same preheating steps, as shown below.

#### // CAUTION //

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

1. Place the phone in the Oven, with the Battery Cover side down.



2. Wait 10 minutes for the Battery Cover Adhesive to warm up.

#### NOTE

If the phone is not heated sufficiently, the disassembly could damage the part.

3. Remove the phone from the oven.

#### // CAUTION //

Wear protective gloves when handling heated phones.

#### NOTE

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



## PMMA Battery Cover Removal Method A

### NOTE

The PMMA Battery Cover can be recovered and reused after removal if it is undamaged.



1. Use the Suction Cup Tool to create a gap between the PMMA Battery Cover and the Front-Housing.



2. Use the Thin Plastic Spudger to disengage the PMMA Battery Cover from all the sides of the phone. Start at the point as shown.

### //CAUTION//

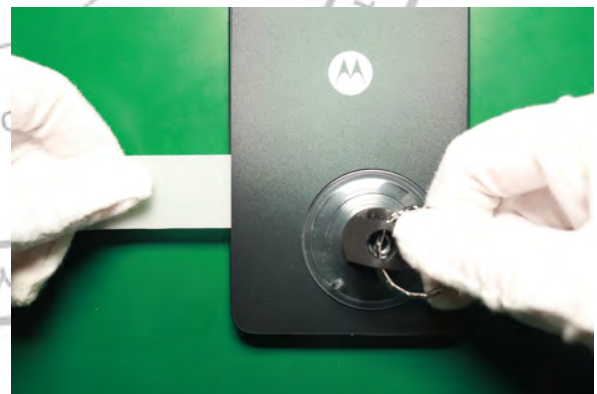
Do not insert the Thin Plastic Spudger more than 10 mm to prevent damaging internal components.



### NOTE

Carefully remove the PMMA Battery Cover to avoid scratch with the camera deco edge.

3. Use the Thin Plastic Spudger to disengage the PMMA Battery Cover from all the sides of the phone.



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4. Use the Thin Plastic Spudger to disengage the PMMA Battery Cover from all the sides of the phone.



5. Move the Thin Plastic Spudger in the direction as shown.



6. Pull the PMMA Battery Cover up toward bottom and upper side.



**NOTE**  
Make sure not to rotate the PMMA Battery Cover too much, it will cause PMMA Battery Cover crack.



**NOTE**  
Make sure to pry PMMA Battery Cover up slowly and keep PMMA Battery Cover be flat when separate PMMA Battery Cover with Middle Frame.



7. Split the PMMA Battery Cover from the phone.



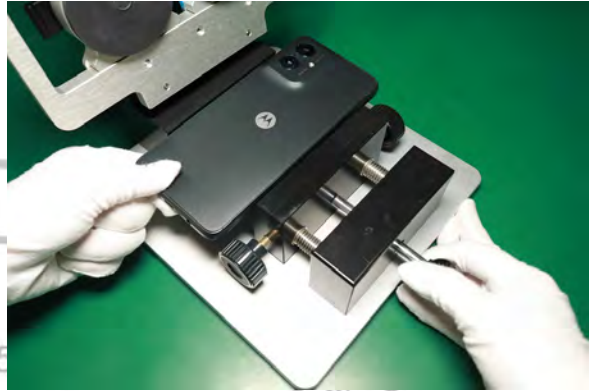
## PMMA Battery Cover Removal Method B

### NOTE

The PMMA Battery Cover can be recovered and reused after removal if it is undamaged.



1. Pull the handle outwards and place the phone over the fixture according to the Display orientation facing down.



2. Use fingers to activate the Side Threads on both sides to hold the phone in position.



3. Rotate the Main Thread to the initial position (where the top holder is fully horizontal).

### //CAUTION//

Make sure that suction cup avoids icon location.



4. Use both hands to press the Top Holder of the fixture for 5 seconds.



5. Use fingers to place the Suction Cup Lock upright so that it is attached to the PMMA Battery cover of the device.

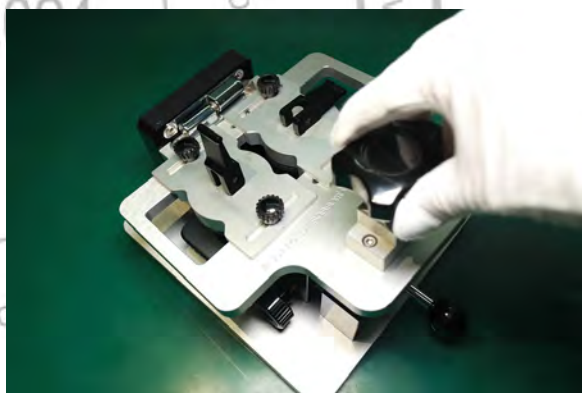
<b>NOTE</b>
Use the Suction Cup to attach to the bottom of the phone to prevent it from pressing the Camera Lens.

<b>NOTE</b>
Please use one Suction Cup when disassemble PMMA Battery Cover and Middle Frame and make sure to attach the suction cup on the edges of the phone.



6. Rotate the Main Thread clockwise to disengage the PMMA Battery Cover from the Front-Housing.

<b>NOTE</b>
Do not rotate the Main Thread to the end position to avoid damaging the PMMA Battery Cover.

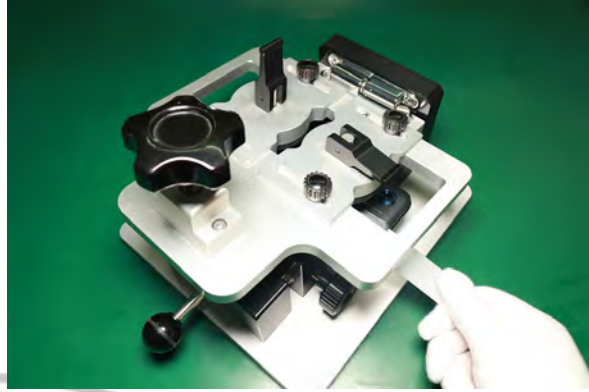


7. Use the Thin Plastic Spudger to cut the Battery Cover Adhesive from one side of the Regen-i Removal Fixture.



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8. Use the Thin Plastic Spudger to cut the Battery Cover Adhesive from the other side of the Regen-i Removal Fixture.



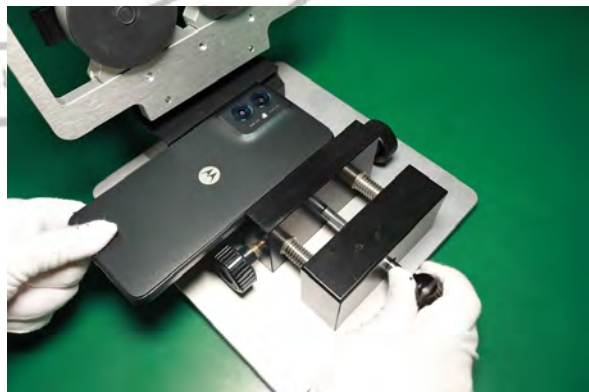
9. Use fingers to place the Suction Cup locks back in horizontal direction to release the Suction Cup.



10. Use fingers to lift the Top Holder of the fixture and release the Side Threads on both sides.



11. Pull the handle outwards and take out the phone.



12. Move the Thin Plastic Spudger clockwise to cut the Battery Cover Adhesive along the edges of the phone.

**//CAUTION//**

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



13. Pull the PMMA Battery Cover up toward bottom and upper side.



**NOTE**

Make sure not to rotate the PMMA Battery Cover too much, it will cause PMMA Battery Cover crack.



**NOTE**

Make sure to pry PMMA Battery Cover up slowly and keep PMMA Battery Cover be flat when separate PMMA Battery Cover with Middle Frame.



14. Split the PMMA Battery Cover from the phone.





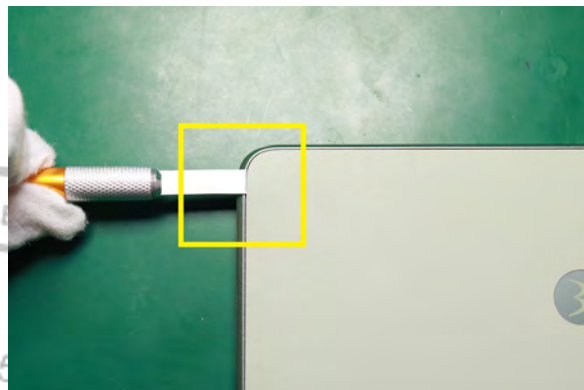
## PU Battery Cover Removal

### NOTE

The PU Battery Cover can be recovered and reused after removal if it is undamaged.



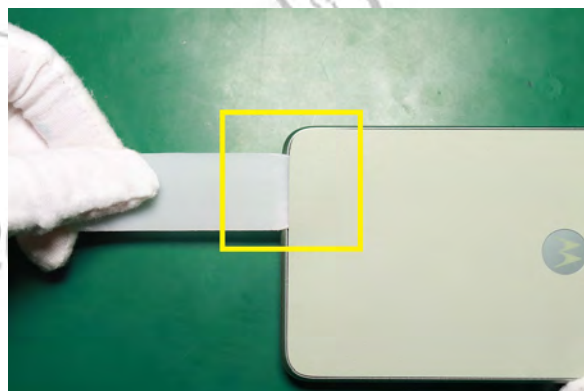
1. Use the PU Inlay Disassembly Tool to create a gap between the PU Battery Cover and the Front-Housing.



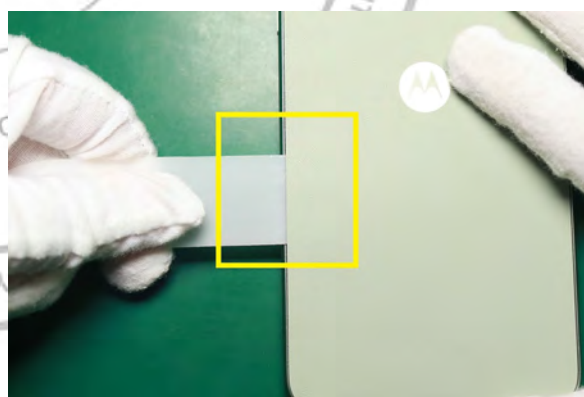
2. Use the Thin Plastic Spudger to disengage the PU Battery Cover from all the sides of the phone. Start at the point as shown.

### //CAUTION//

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



3. Use the Thin Plastic Spudger to disengage the PU Battery Cover from all the sides of the phone.



4. Move the Thin Plastic Spudger in the direction as shown.



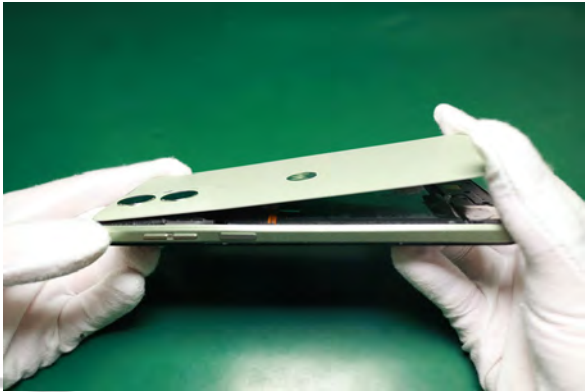
5. Pull the PU Battery Cover up toward bottom and upper side.



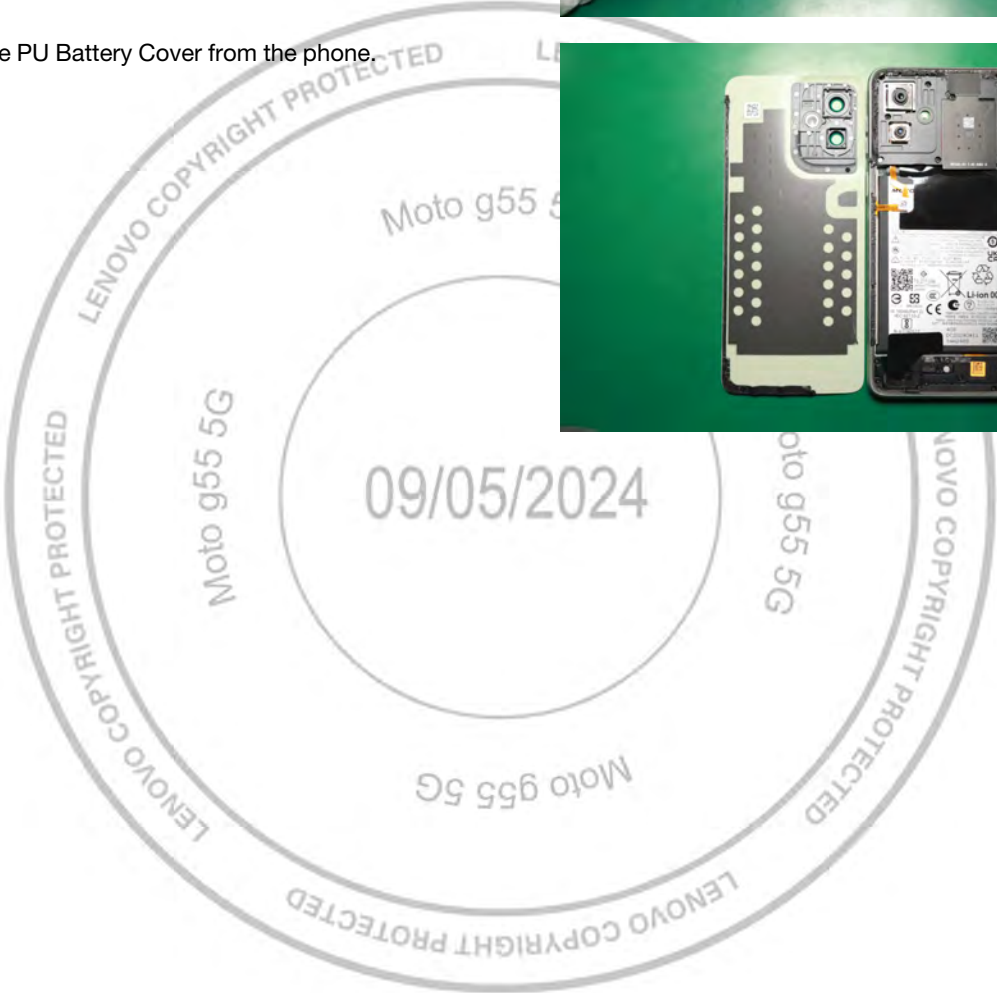
**NOTE**

Make sure not to rotate the PU Battery Cover too much, it will cause PU Battery Cover crack.

<b>NOTE</b>
Make sure to pry PU Battery Cover up slowly and keep PU Battery Cover be flat when separate PU Battery Cover with Middle Frame.



6. Split the PU Battery Cover from the phone.



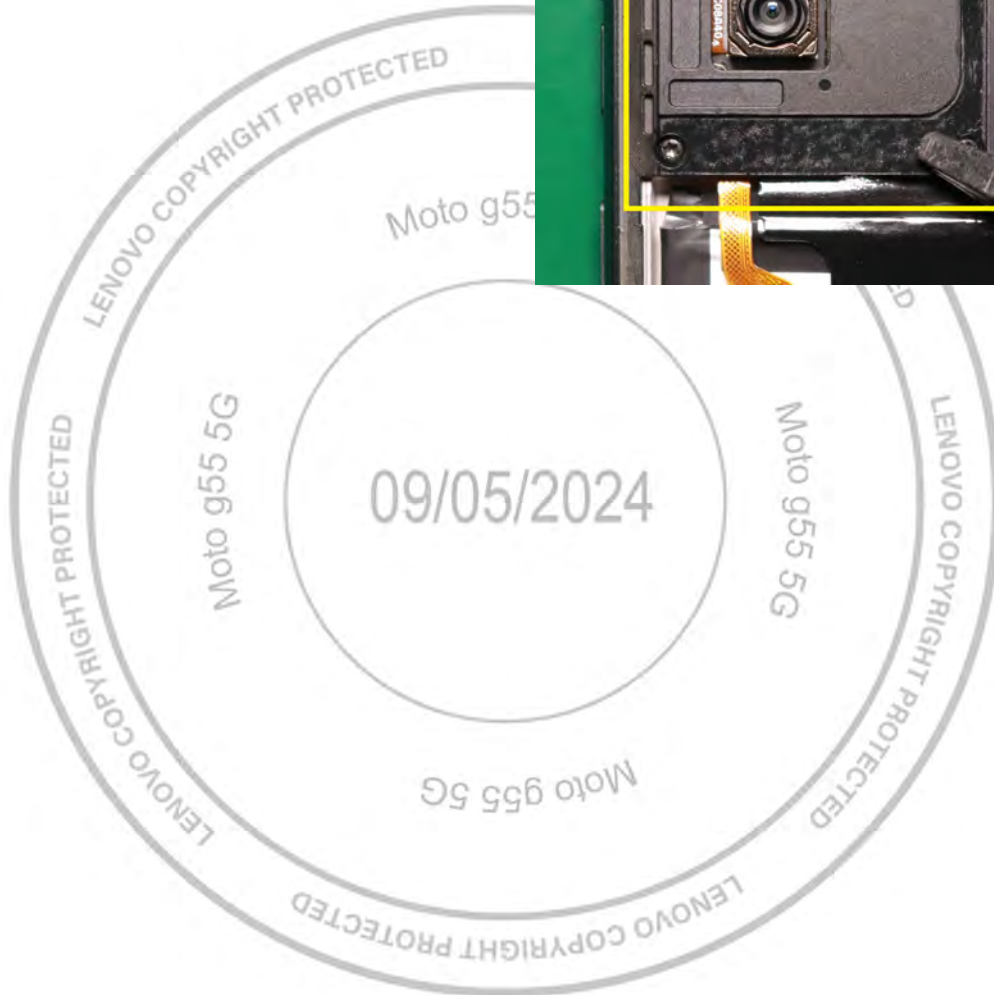
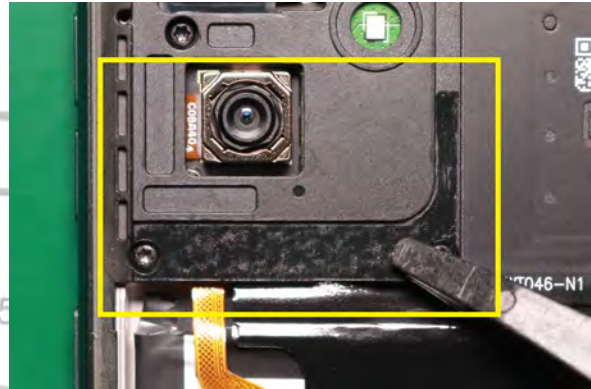
## PMMA & PU Middle Frame Anti-shock Adhesive Removal

### NOTE

After you remove the PMMA & PU Middle Frame Anti-shock Adhesive, you cannot reuse it.



Use the Plastic Tweezer to remove the Middle Frame Anti-shock Adhesive from the location as shown.



## Middle Frame Removal

### NOTE

The Middle Frame can be recovered and reused after removal.



1. Use the Torque Driver with PH00 Bit to remove the 16 screws as shown.

Screw Reuse Policy	
North America	No
Latin America & Caribbean	Yes
East Europe	Yes
West Europe	Yes
Middle East & Africa	Yes
Southern & Pacific Asia	Yes
Oceania & Japan	No

### NOTE

Keep the screws properly.

### WARNING

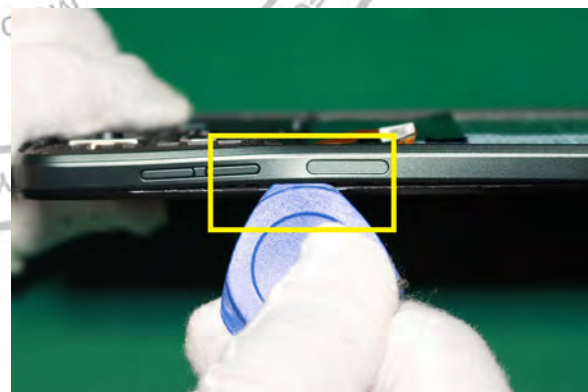
The screwdriver tip should be of the correct size for the screw head. Misuse of the screwdriver may cause damage.



2. Use the Shim to create a gap between Front-Housing and Middle Frame from the Volume Key position as shown.

### WARNING

Do not insert the Shim too much to avoid damaging other components.



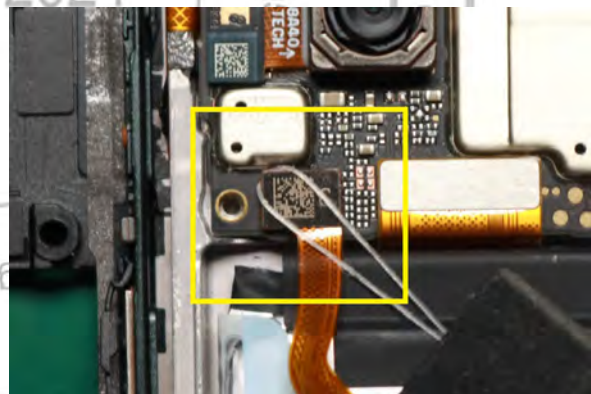
3. Use the Shim in the direction as shown.



4. Use the BtB tool to disengage the Fingerprint Sensor Connector from the location as shown.

**WARNING**

Be careful to avoid damaging the Fingerprint Sensor Connector.



5. Split the Middle Frame from the phone.

**WARNING**

Be careful to avoid damaging the Fingerprint Sensor FPC.

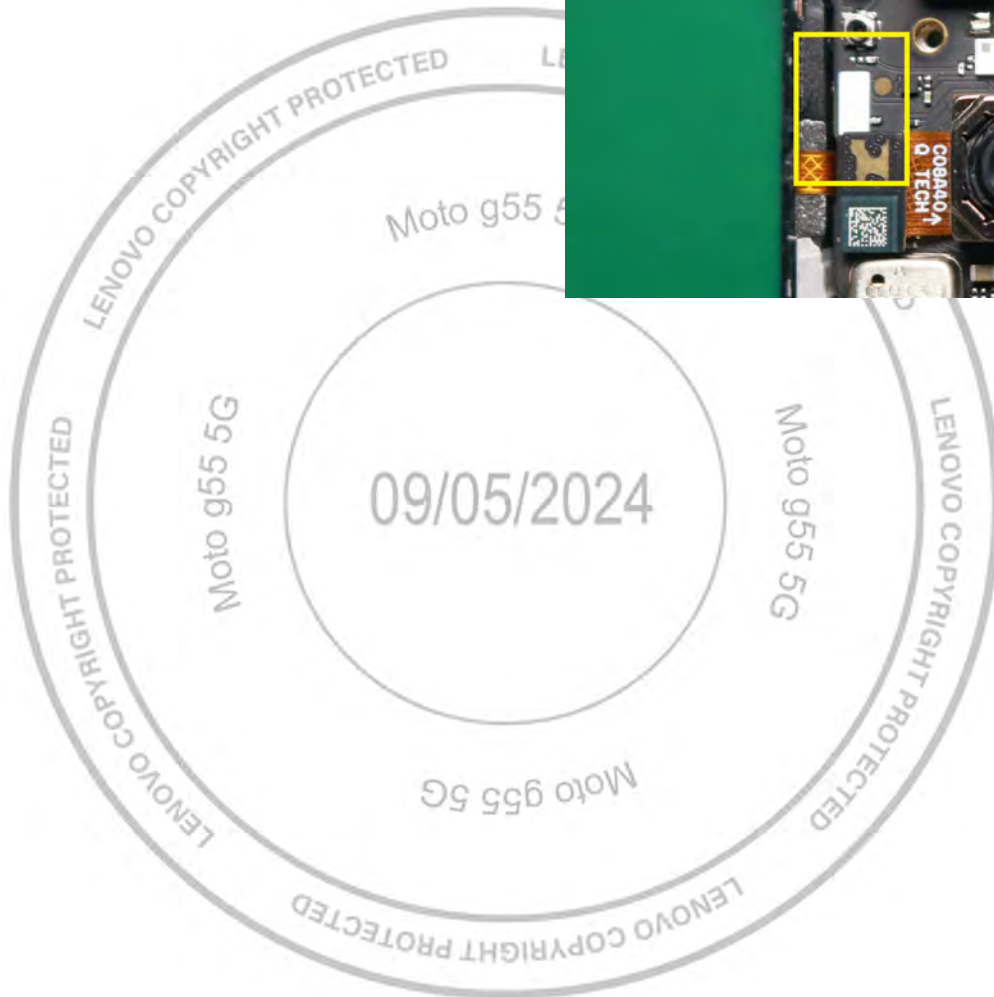
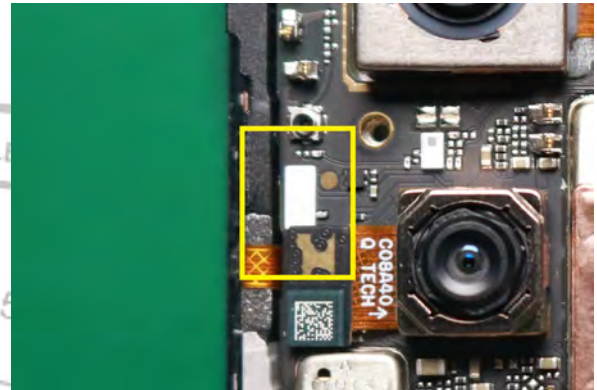


## Water Detection Label Inspection

### NOTE

If the Water Detection Label (WDL) has been activated, follow Return Un-Repaired (RUR) guidelines for further instructions.

Inspect the WDL on the Main PCB for signs of activation.



## Fingerprint Sensor Removal

### NOTE

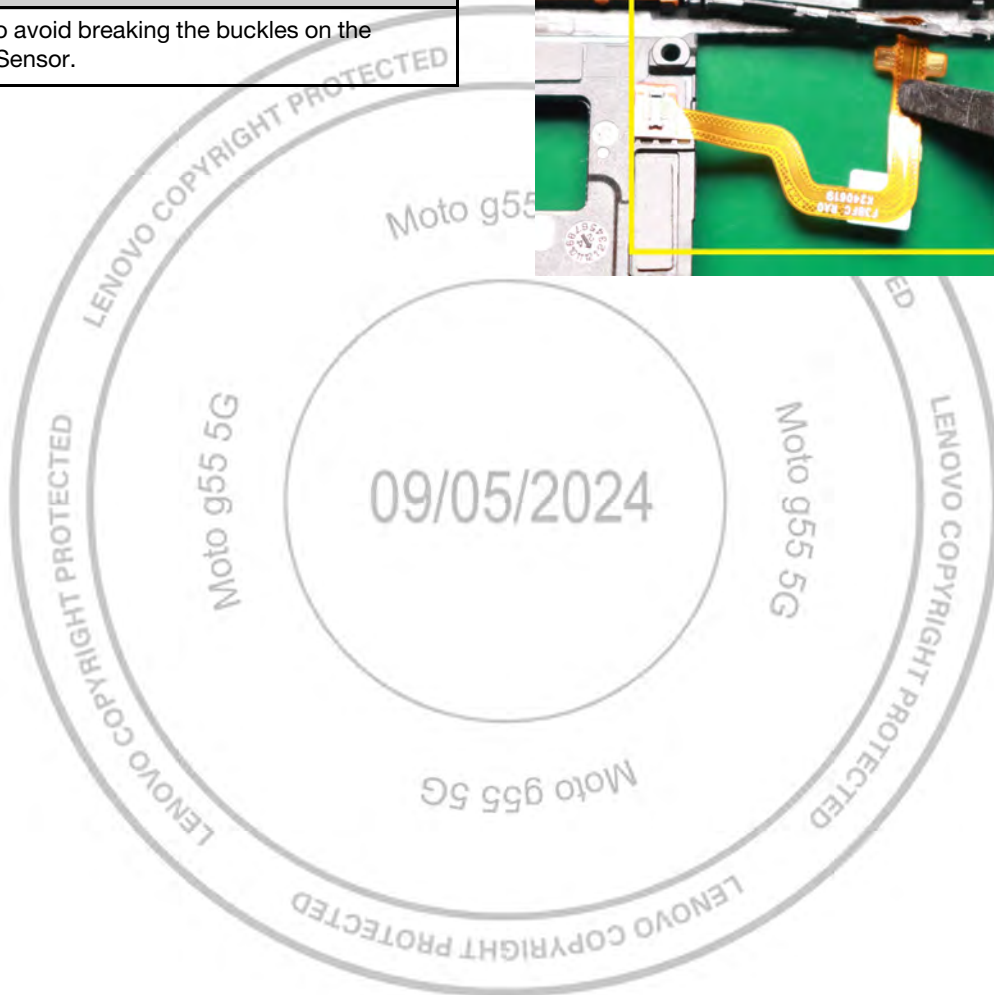
The Fingerprint Sensor can be recovered and reused after removal.



Use the Plastic Tweezer to remove the Fingerprint Sensor from the location as shown.

### NOTE

Be careful to avoid breaking the buckles on the Fingerprint Sensor.





## Flash Board Removal

### NOTE

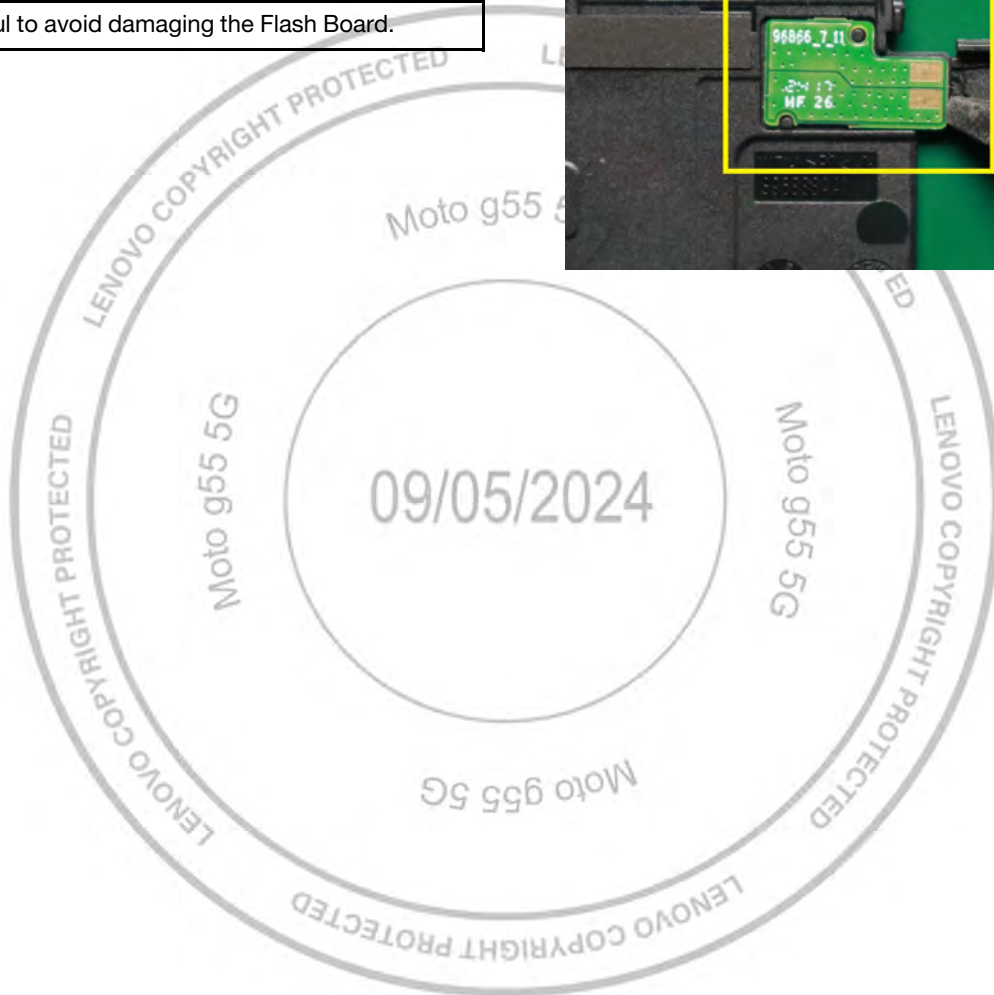
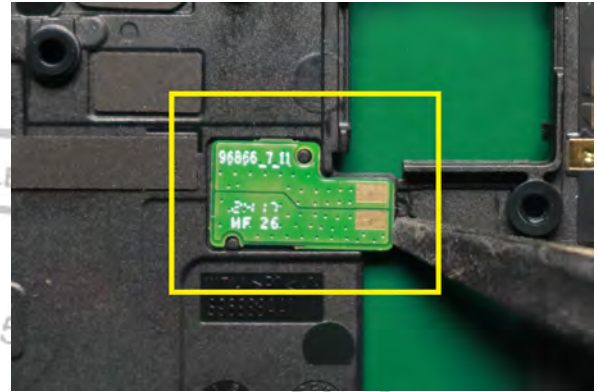
The Flash Board can be recovered and reused after removal.



Use the pointed end of the Black Stick to disengage and remove the Flash Board from the location as shown.

### NOTE

Be careful to avoid damaging the Flash Board.



## Main PCB Heat Spreader Removal

### NOTE

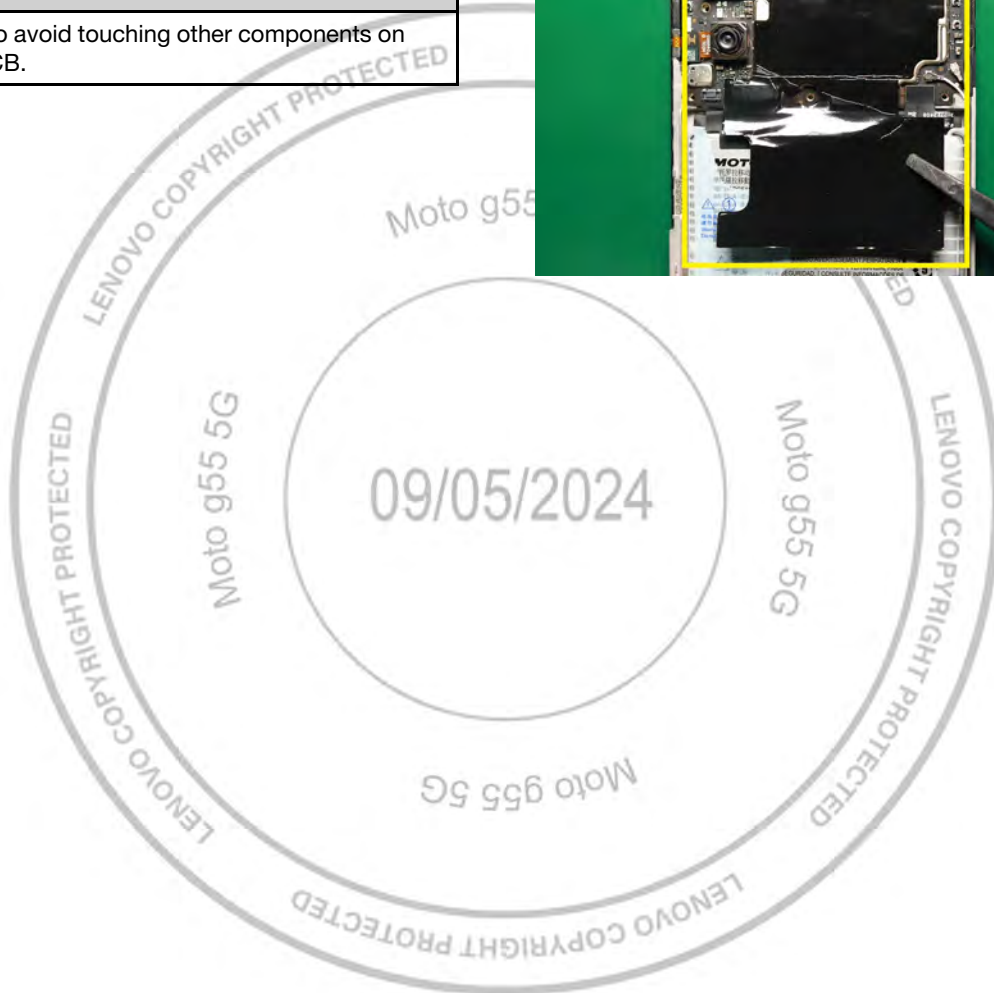
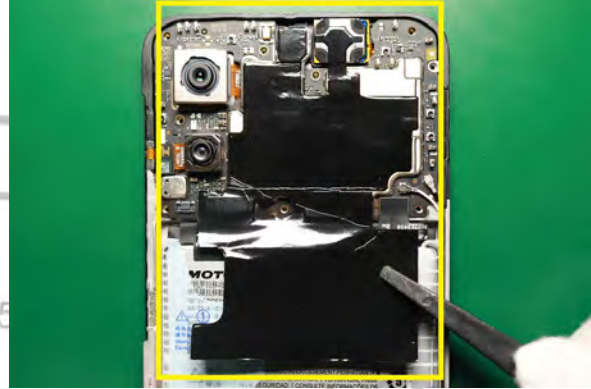
After you remove the Main PCB Heat Spreader, you cannot reuse it.



Use the Plastic Tweezer to remove the Main PCB Heat Spreader from the location as shown.

### NOTE

Be careful to avoid touching other components on the Main PCB.



## Main PCB Removal

### NOTE

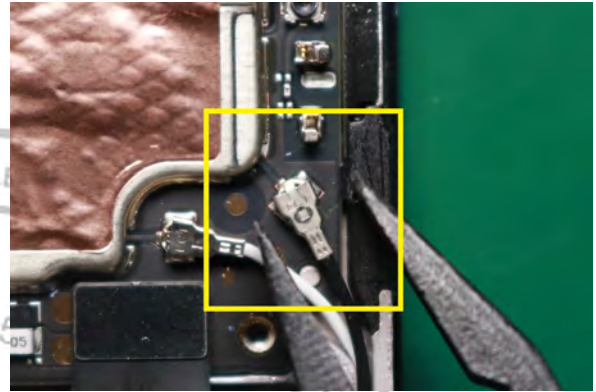
The Main PCB can be recovered and reused after removal.



1. Use the Plastic Tweezer to disconnect the Black Coax Cable from the location as shown.

### NOTE

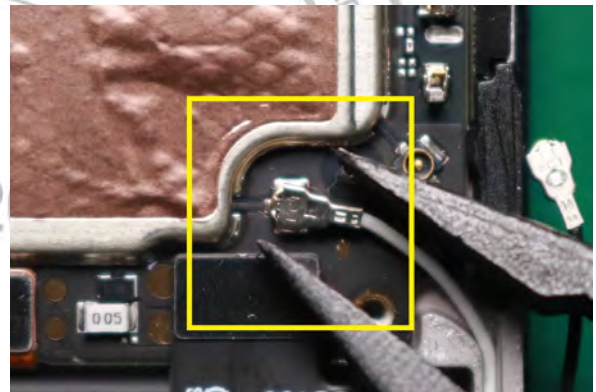
Be careful to avoid damaging the metal ring of the Black Coax Cable.



2. Use the Plastic Tweezer to disconnect the White Coax Cable from the location as shown.

### NOTE

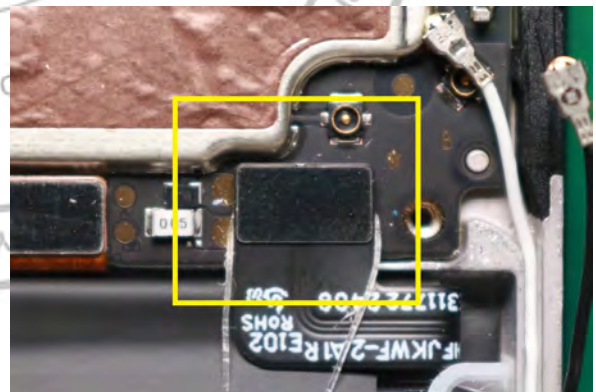
Be careful to avoid damaging the metal ring of the White Coax Cable.



3. Use the BtB tool to disengage the Battery Flex BtB Connector from the Main PCB as shown.

### NOTE

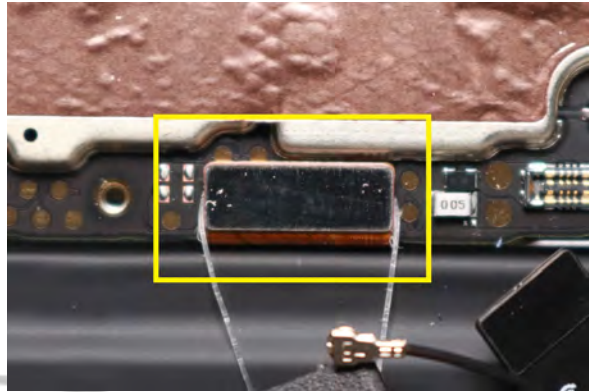
Be careful to avoid damaging the BtB connector.



4. Use the BtB tool to disengage the Main FPC BtB Connector from the Main PCB as shown.

**NOTE**

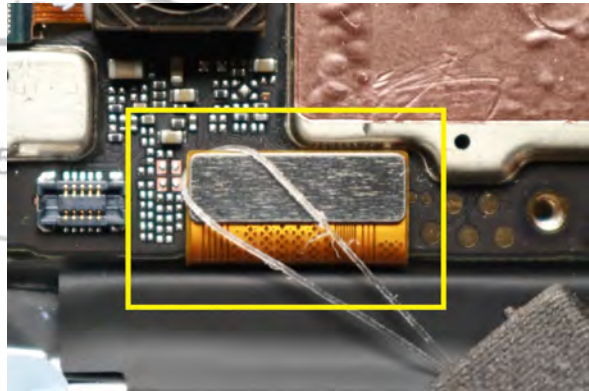
Be careful to avoid damaging the BtB connector.



5. Use the BtB tool to disengage the TP FPC BtB Connector from the Main PCB as shown.

**NOTE**

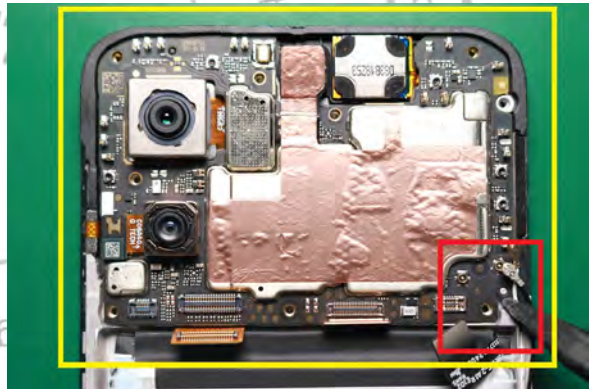
Be careful to avoid damaging the BtB connector.



6. Use the pointed end of the Black Stick to lift and remove the Main PCB from the location as shown.

**NOTE**

Do not lift too hard to damage the Main PCB.



## 50M Rear-Facing Camera Removal

### NOTE

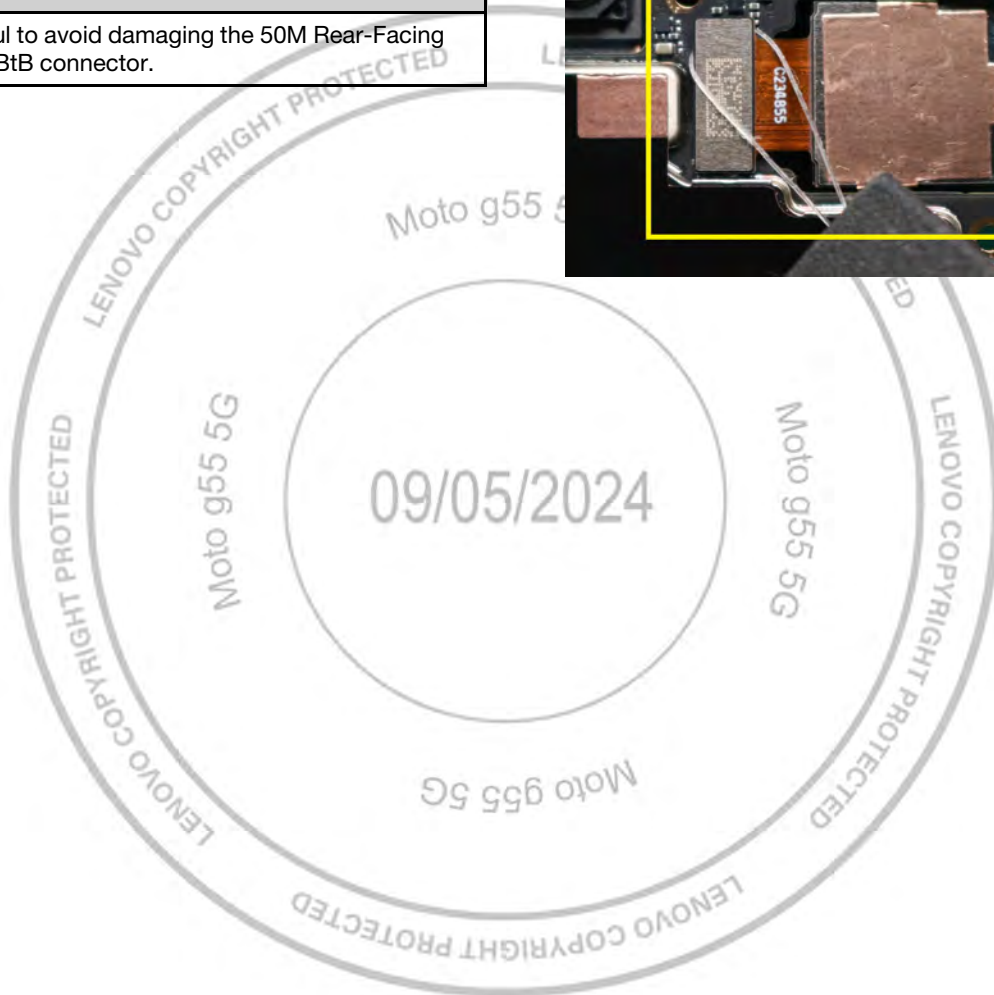
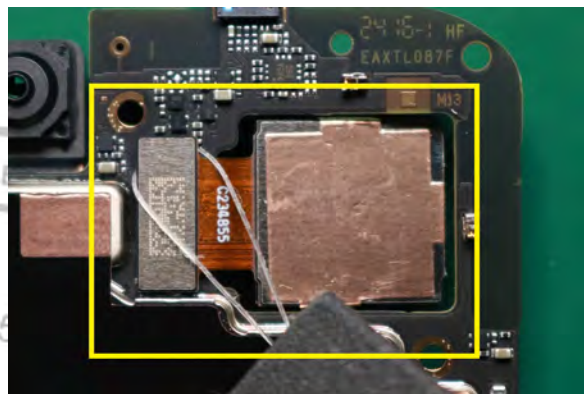
The 50M Rear-Facing Camera can be recovered and reused after removal.



Use the BtB tool to disengage and remove the 50M Rear-Facing Camera from the location as shown.

### NOTE

Be careful to avoid damaging the 50M Rear-Facing Camera BtB connector.



## 8M Macro Rear-Facing Camera Removal

### NOTE

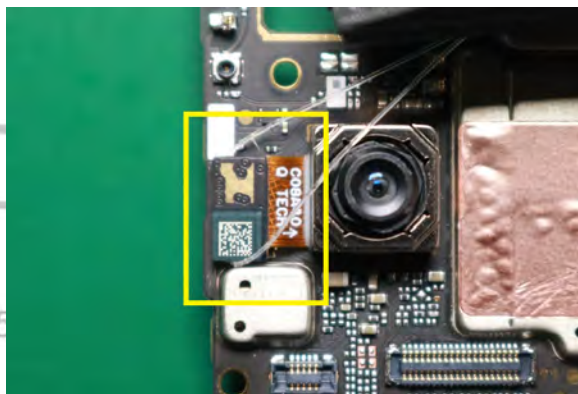
The 8M Macro Rear-Facing Camera can be recovered and reused after removal.



1. Use the BtB tool to remove the 8M Macro Rear-Facing Camera from the Main PCB as shown.

### NOTE

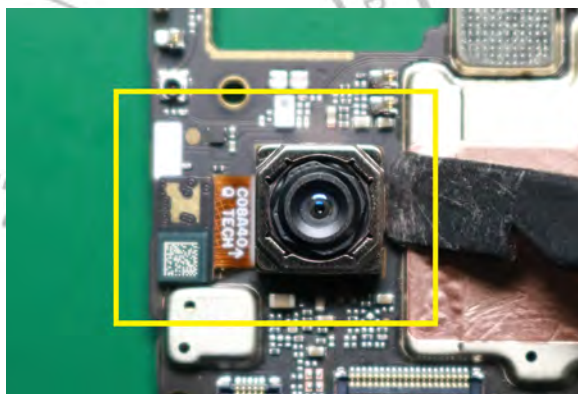
Be careful to avoid damaging the 8M Macro Rear-Facing Camera BtB connector.



2. Use the flat end of the Black Stick to disengage and remove the 8M Macro Rear-Facing Camera.

### WARNING

Be careful to avoid damaging the 8M Macro Rear-Facing Camera since it has back adhesive.



## Main PCB Back Copper Foil Removal

### NOTE

After you remove the Main PCB Back Copper Foil, you cannot reuse it.



Use the Plastic Tweezer to remove the Main PCB Back Copper Foil from the location as shown.

### NOTE

Be careful to avoid touching other components on the Main PCB.



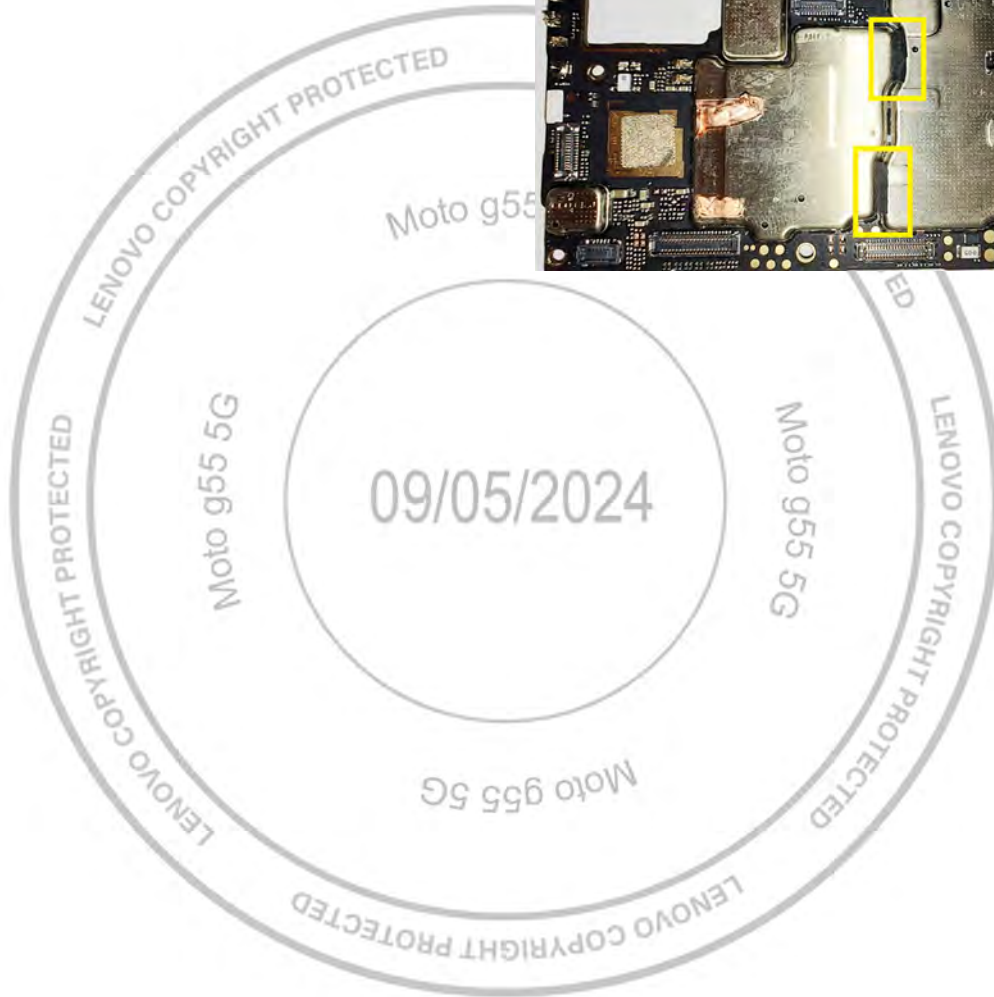
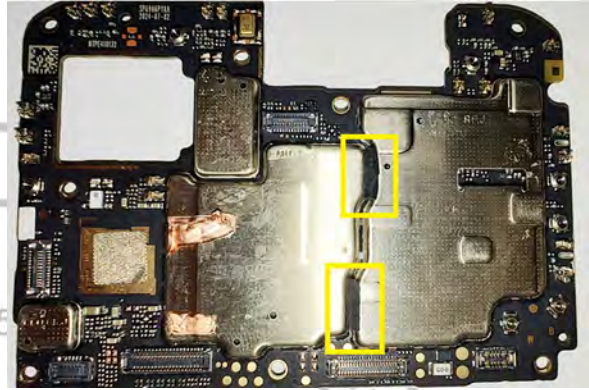
## Main PCB Bottom Shield Foam Removal

### NOTE

After you remove the Main PCB Bottom Shield Foam, you cannot reuse it.



Use the Plastic Tweezer to remove the Main PCB Bottom Shield Foam from the location as shown.





## Front-Facing Camera Removal

### NOTE

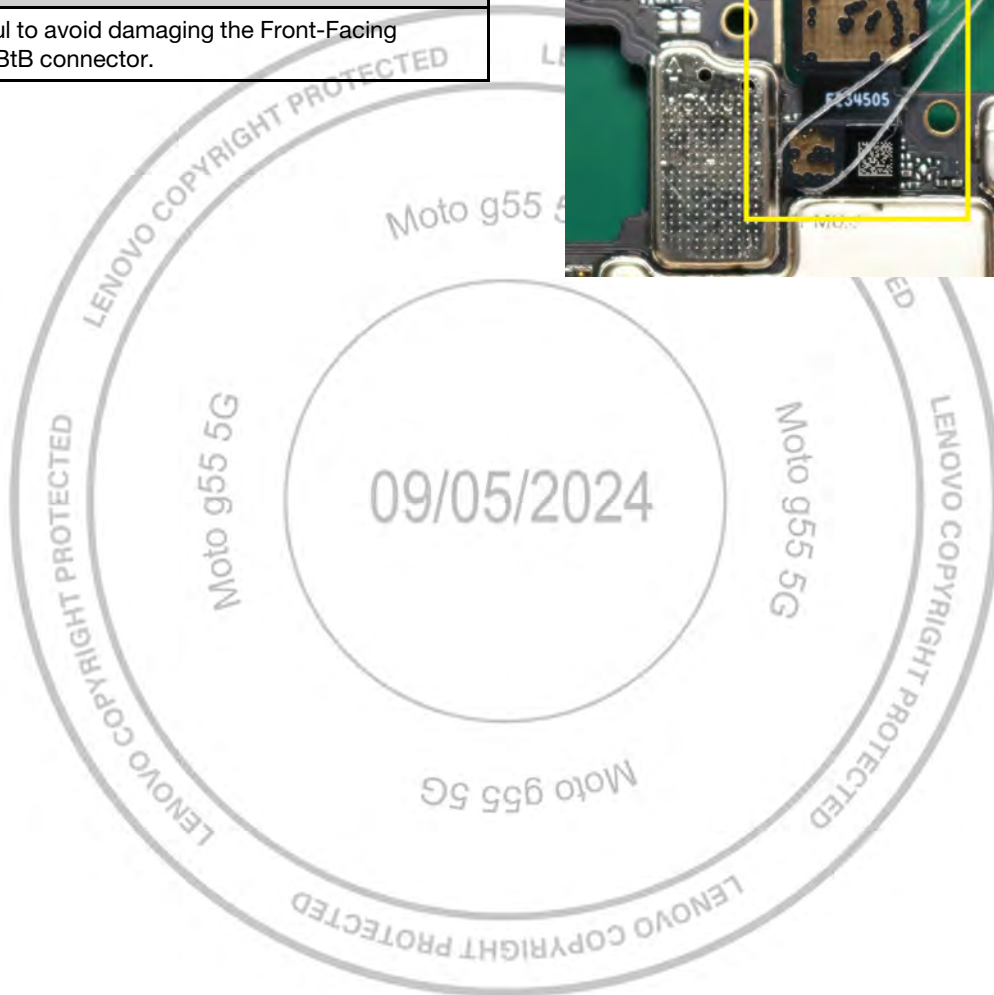
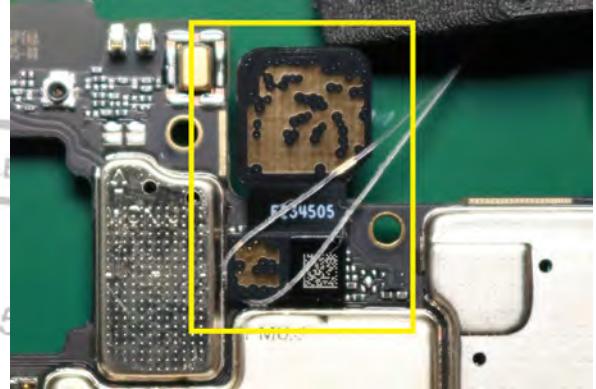
The Front-Facing Camera can be recovered and reused after removal.



Use the BtB tool to disengage and remove Front-Facing Camera from the location as shown.

### NOTE

Be careful to avoid damaging the Front-Facing Camera BtB connector.



## Speaker Box Removal

### NOTE

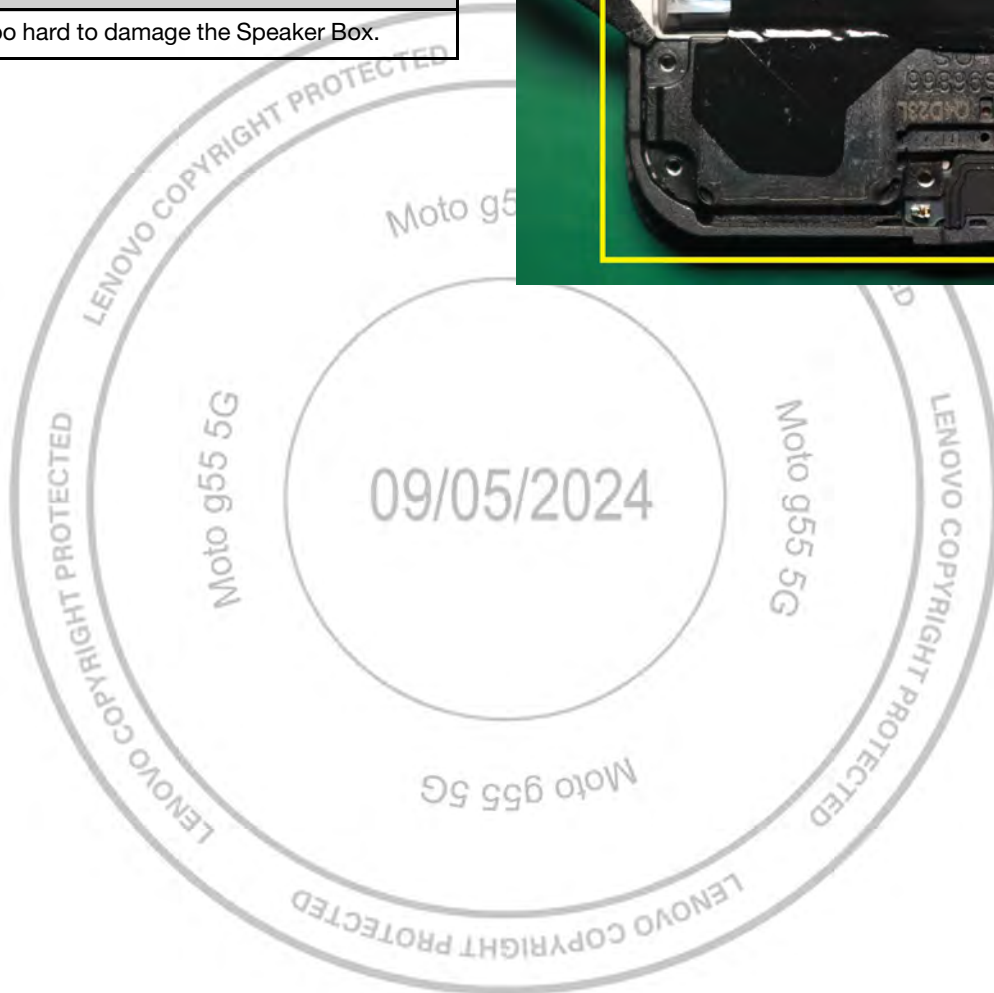
The Speaker Box can be recovered and reused after removal.



Use the pointed end of the Black Stick to lift and remove the Speaker Box from the location as shown.

### NOTE

Do not lift too hard to damage the Speaker Box.



## Black Coax Cable Removal

### NOTE

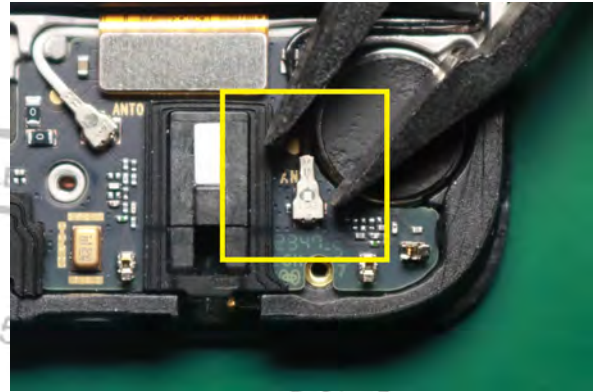
The Black Coax Cable can be recovered and reused after removal.



1. Use the Plastic Tweezer to disconnect the Black Coax Cable from the location as shown.

### NOTE

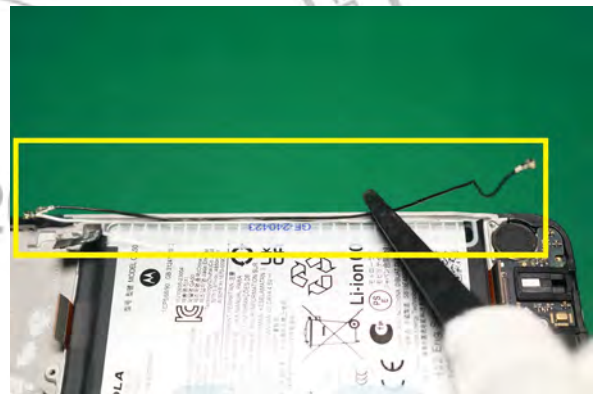
Be careful to avoid damaging the metal ring of the Black Coax Cable.



2. Use the Plastic Tweezer to remove the Black Coax Cable from the location as shown.

### NOTE

Coax Cable cannot be reused in North America refurbish operation.



## White Coax Cable Removal

### NOTE

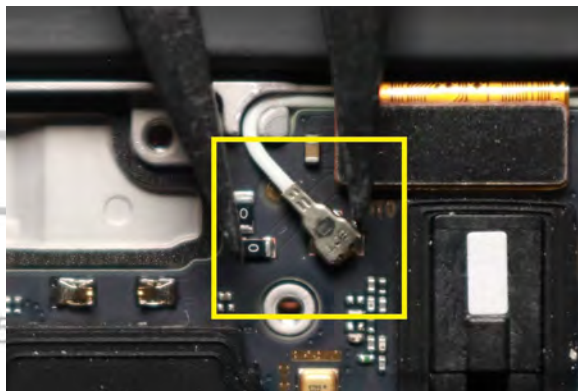
The White Coax Cable can be recovered and reused after removal.



1. Use the Plastic Tweezer to disconnect the White Coax Cable from the location as shown.

### NOTE

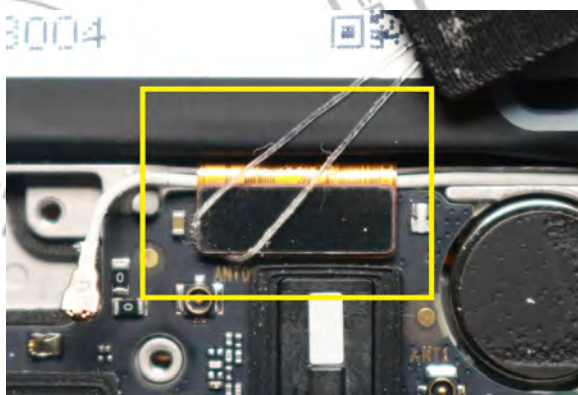
Be careful to avoid damaging the metal ring of the White Coax Cable.



2. Use the BtB tool to disengage the Main FPC BtB Connector from the location as shown.

### NOTE

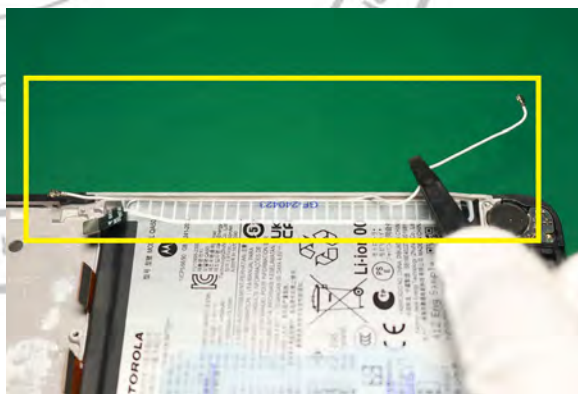
Be careful to avoid damaging the BtB connector.



3. Use the Plastic Tweezer to remove the White Coax Cable from the location as shown.

### NOTE

Coax Cable cannot be reused in North America refurbish operation.



## Sub Board Removal

### NOTE

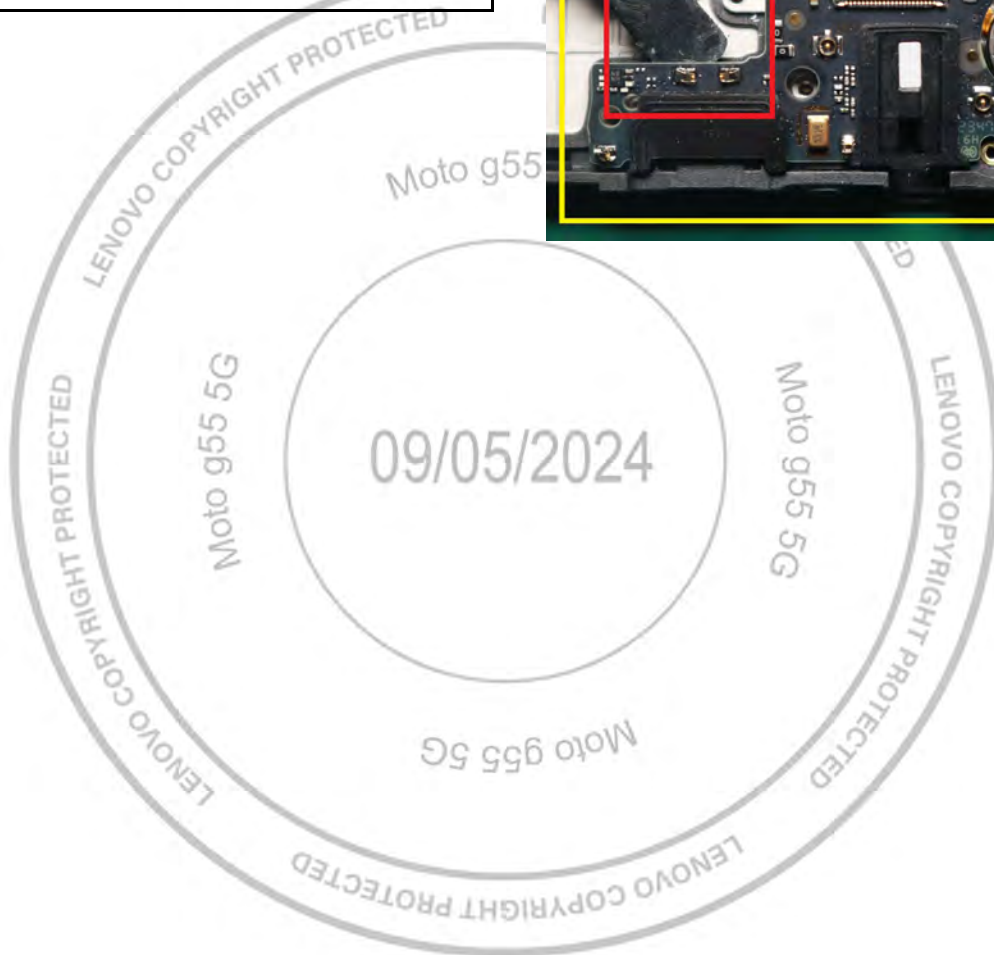
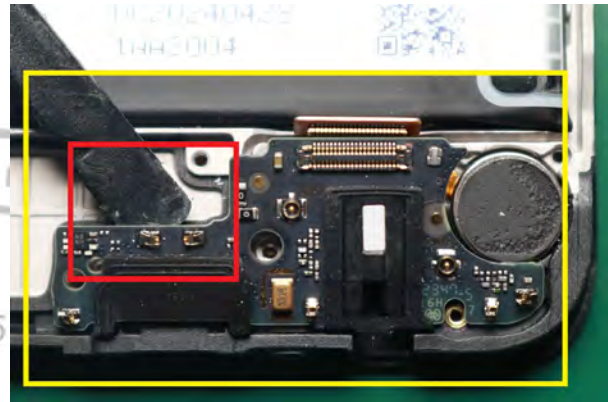
The Sub Board can be recovered and reused after removal.



Use the flat end of the Black Stick to lift and remove the Sub Board from the location as shown.

### NOTE

Do not lift too hard to damage the Sub Board.



## Audio Jack Grommet Removal

### NOTE

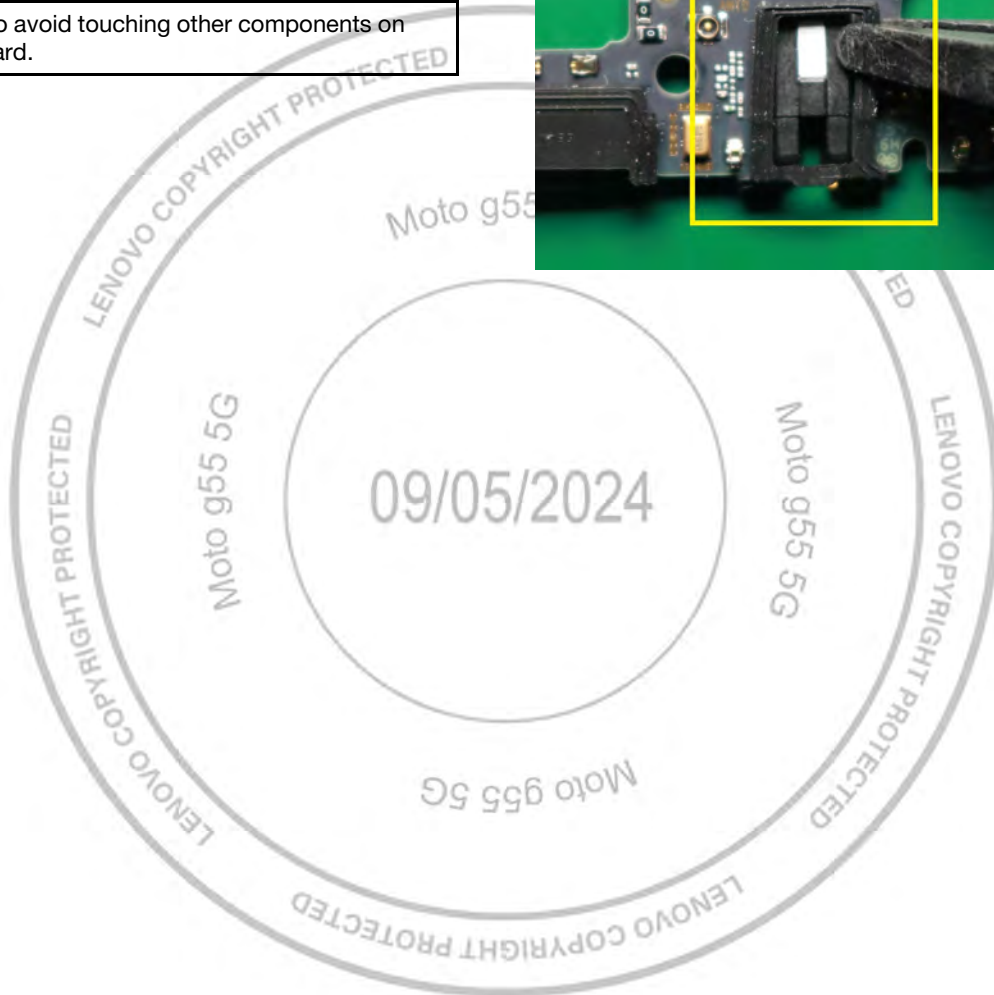
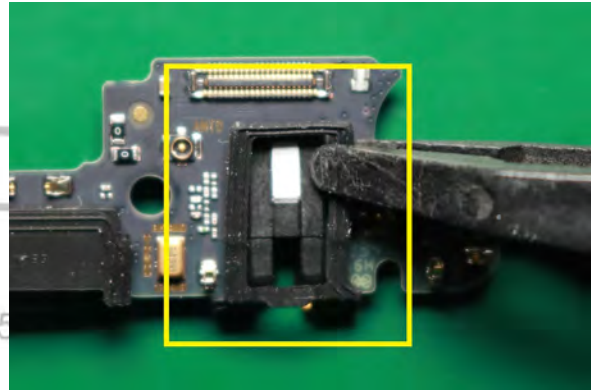
The Audio Jack Grommet can be recovered and reused after removal.



Use the Plastic Tweezer to remove the Audio Jack Grommet from the location as shown.

### NOTE

Be careful to avoid touching other components on the Sub Board.



## USB Grommet Removal

### NOTE

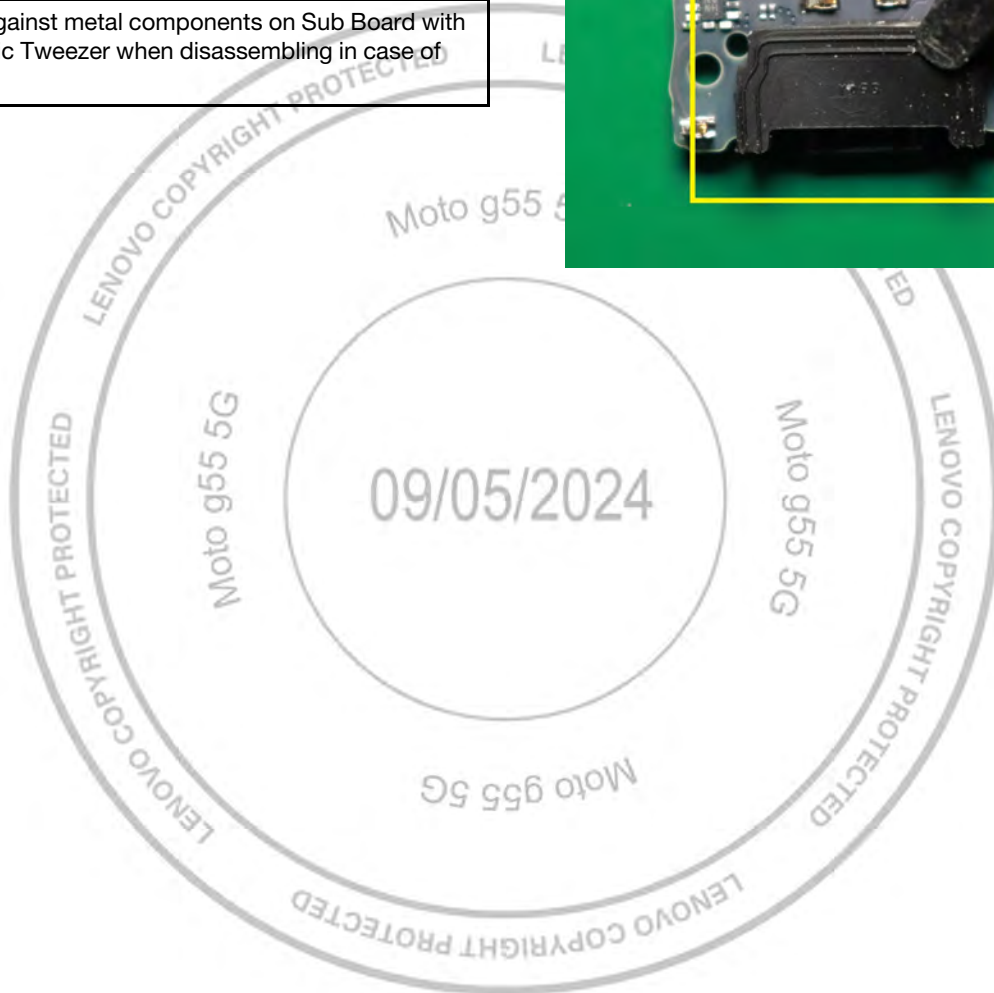
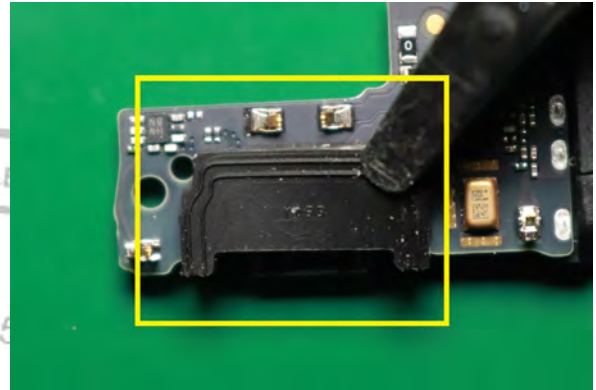
The USB Grommet can be recovered and reused after removal.



Use the Plastic Tweezer to remove the USB Grommet from the location as shown.

### NOTE

Do not against metal components on Sub Board with the Plastic Tweezer when disassembling in case of damage.



## Battery Removal

### Battery Removal Method A (for WW except EU)

#### /// 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

Remove the Battery only if it is defective or damaged. After you remove it, you cannot reuse it.



#### // CAUTION //

Handle the Battery Pack with care. If dropped on 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 through 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. Set the temperature of 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.

#### NOTE

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

2. Place the phone on the Hot Plate, with the Display side down.



3. Wait 10 minutes for the adhesive to warm up.

#### NOTE

Heat the phone sufficiently to avoid damaging the part.



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4. Use the Thin Plastic Spudger to cut the adhesives from the top of the Battery.



5. Use the Thin Plastic Spudger to cut the adhesives from the side of the Battery.



6. Use the Thin Plastic Spudger to cut the adhesives from the bottom of the Battery.



7. Use fingers to carefully lift the Battery.



## Battery Removal Method B (for EU)

### /// 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

Remove the Battery only if it is defective or damaged. After you remove it, you cannot reuse it.



### // CAUTION //

Handle the Battery Pack with care. If dropped on 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 through 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. Set the temperature of 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.

### NOTE

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

2. Place the phone on the Hot Plate, with the Display side down.



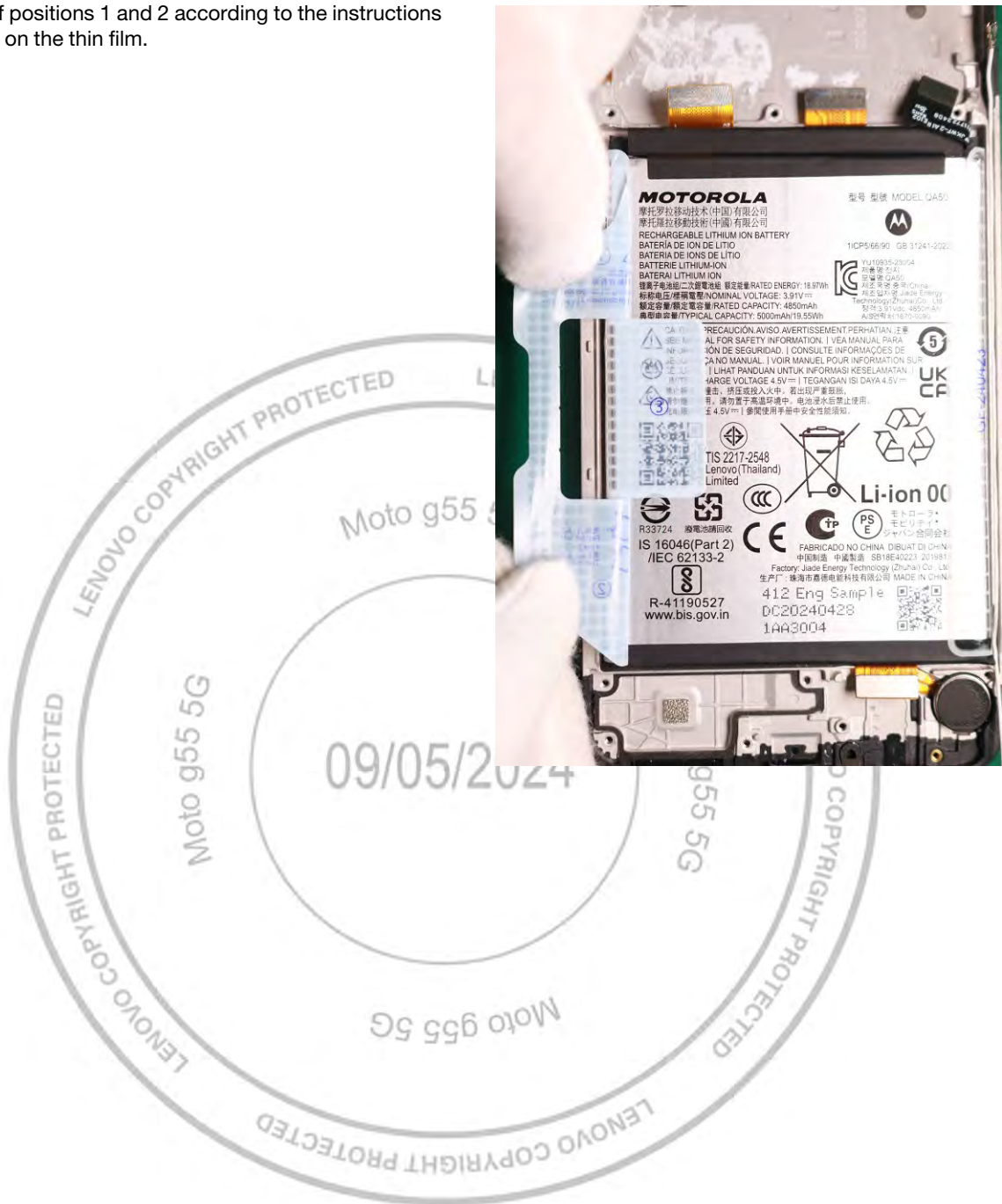
3. Wait 10 minutes for the adhesive to warm up.

### NOTE

Heat the phone sufficiently to avoid damaging the part.

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4. Peel off positions 1 and 2 according to the instructions printed on the thin film.



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- Lift position 3 and remove the battery by pulling the film out.



- Remove the easy-peel film.



## Battery Removal Method C

### /// 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

Ensure the display assembly is fully dried before reuse to avoid any potential liquid damage after assembled.

### NOTE

Drying the display assembly in an oven with 60°C for 2-3 mins is needed prior to using.

### // CAUTION //

Handle the Battery Pack with care. If dropped on 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 through 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. The power supply line is more than 2.5 meters away.
2. Allow enough space for heat dissipation, more than 1 meter is recommended.



3. Avoid more than 2 hours idle time and turn off overnight.



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- Turn on the Freezing Separator.

**NOTE**

The switch is on the back.



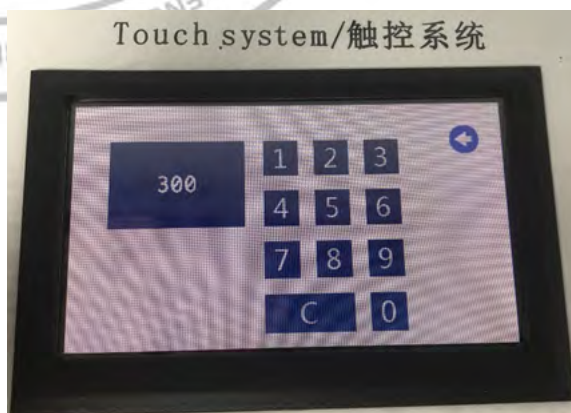
- Select the Language menu and set the desired language.



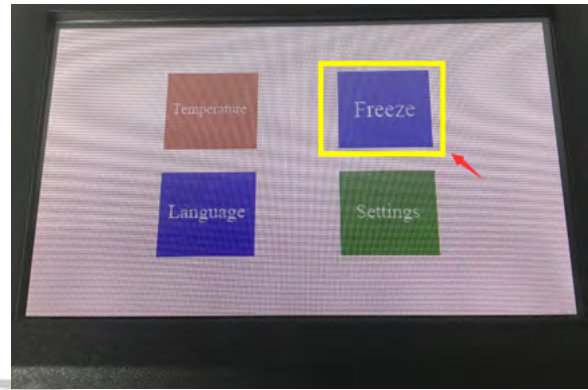
- Select the settings menu, set the temperature and Freezing times.  
Set the temperature to -40 °C: Click the temperature menu, enter 40 on the screen number. Then press the arrow in the upper right corner to return.



- Set the Freezing time to 300 seconds (5 Minutes): Click the time menu, enter 300 on the screen number. Then press the arrow in the upper right corner to return to the main menu.



8. Click Freeze menu, then click the start menu.



9. Verify the temperature reaches the setting value. When the temperature reaches -40 degrees, the compressor will stop, then open the door.

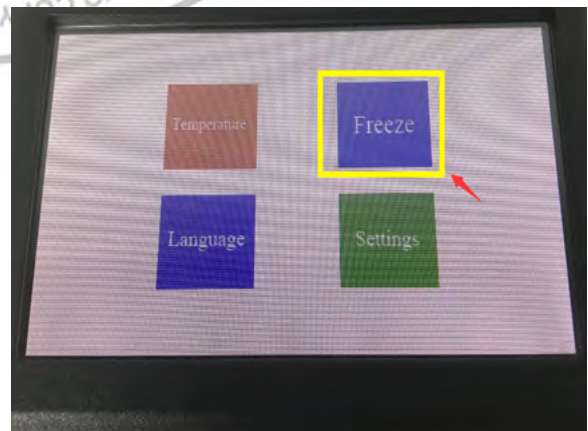


10. Put display into sealing bag and seal then put 1~2 Display into cold plate and close the door.

**NOTE**  
Please wear cotton gloves during placement to avoid contact with frozen surface and injury to hands. Phone or display need face down.



11. Click Freeze menu.



- Click the start menu.

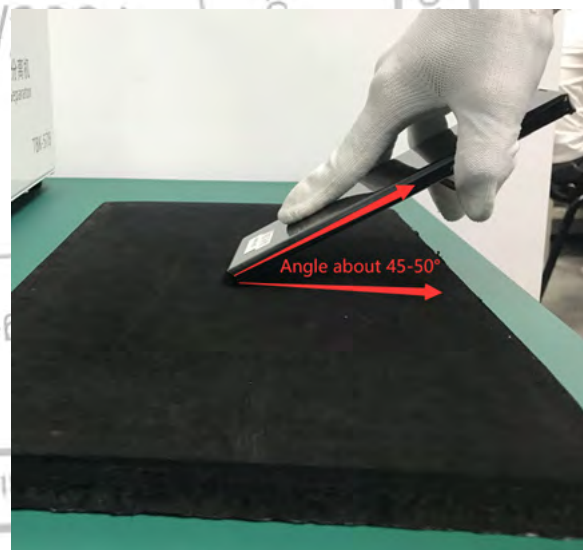


- After clicking the Start menu, Start the countdown, and freeze it for 5 minutes. When the countdown time reaches, the device will alarm and ring three times.
- Open the door. Take out one Display at the time with wearing cotton gloves. Take out the Display in the order it was put in.

**NOTE**

Please wear cotton gloves during taking to avoid contact with frozen surface and injury to hands.

- Remove the Battery.
- Take out the frozen assembly from the bags.
- Holding the Display place the Battery face down with the ESD sponge pad at an angle of about 45-50 degrees, and hit on the pad 3-4 times, the Battery will fall off automatically.
- After the Battery removed. Immediately put the Batteries and Display into two different sealed bag and sealed into bags for temperature return.





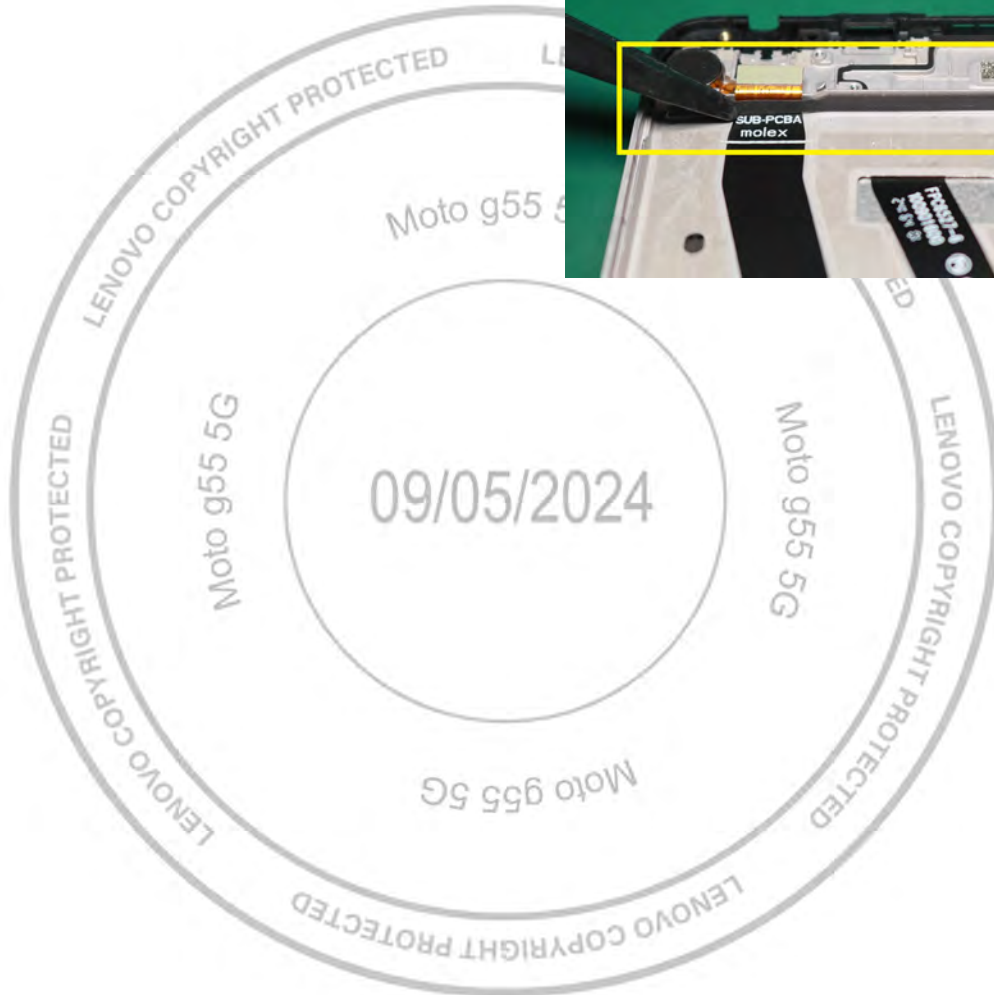
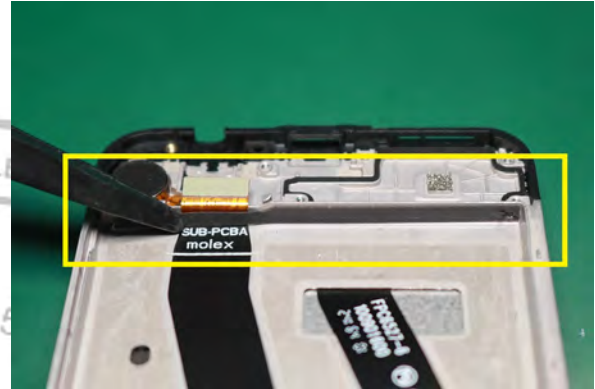
## Battery Buffer Foam Removal

### NOTE

After you remove the Battery Buffer Foam, you cannot reuse it.



Use the Plastic Tweezer to remove the Battery Buffer Foam from the location as shown.



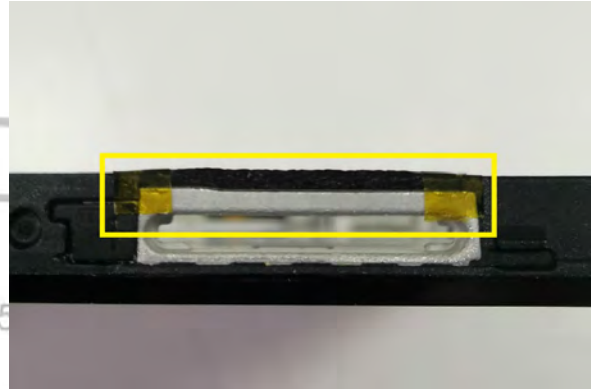
## SIM Tray Waterproof Mylar Removal

### NOTE

After you remove the SIM Tray Waterproof Mylar, you cannot reuse it.



Use the Plastic Tweezer to remove the SIM Tray Waterproof Mylar from the location as shown.



## Main FPC Removal

### NOTE

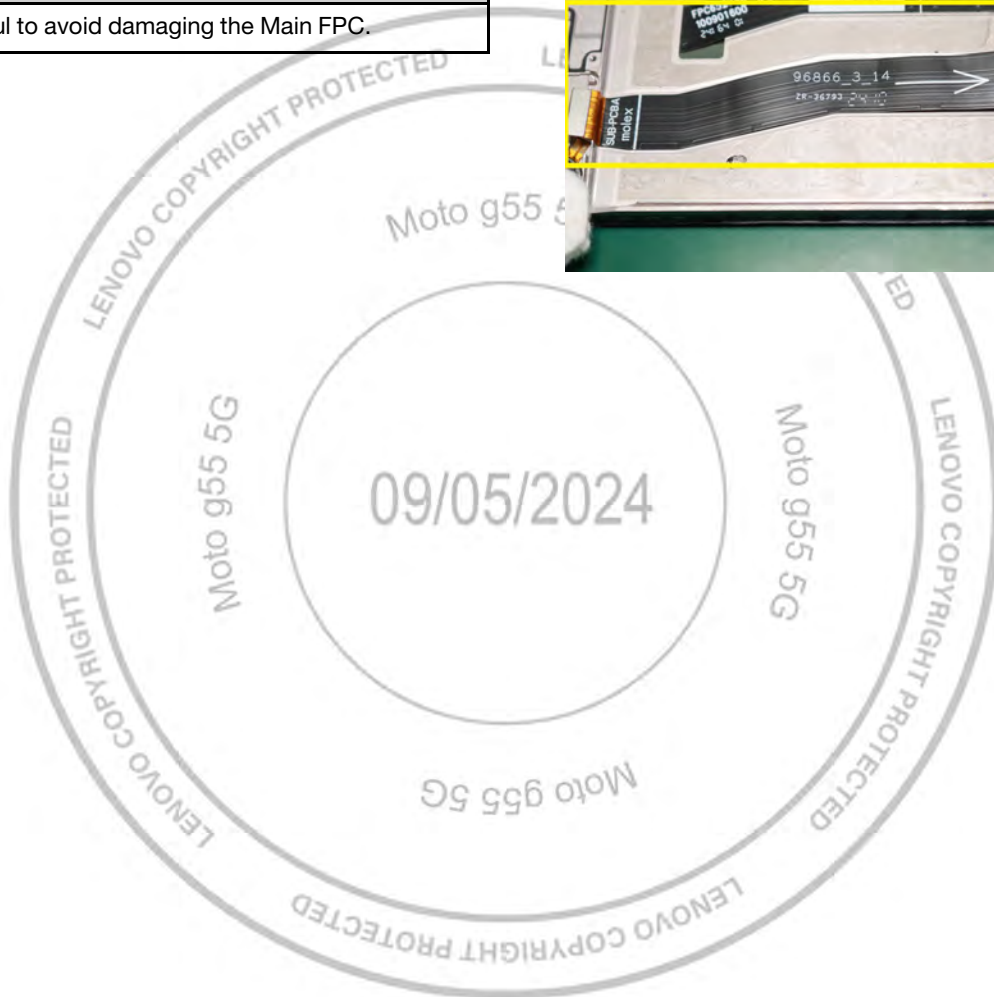
The Main FPC can be recovered and reused after removal.



Use fingers to remove the Main FPC from the location as shown.

### NOTE

Be careful to avoid damaging the Main FPC.



## Vibrator Removal

### NOTE

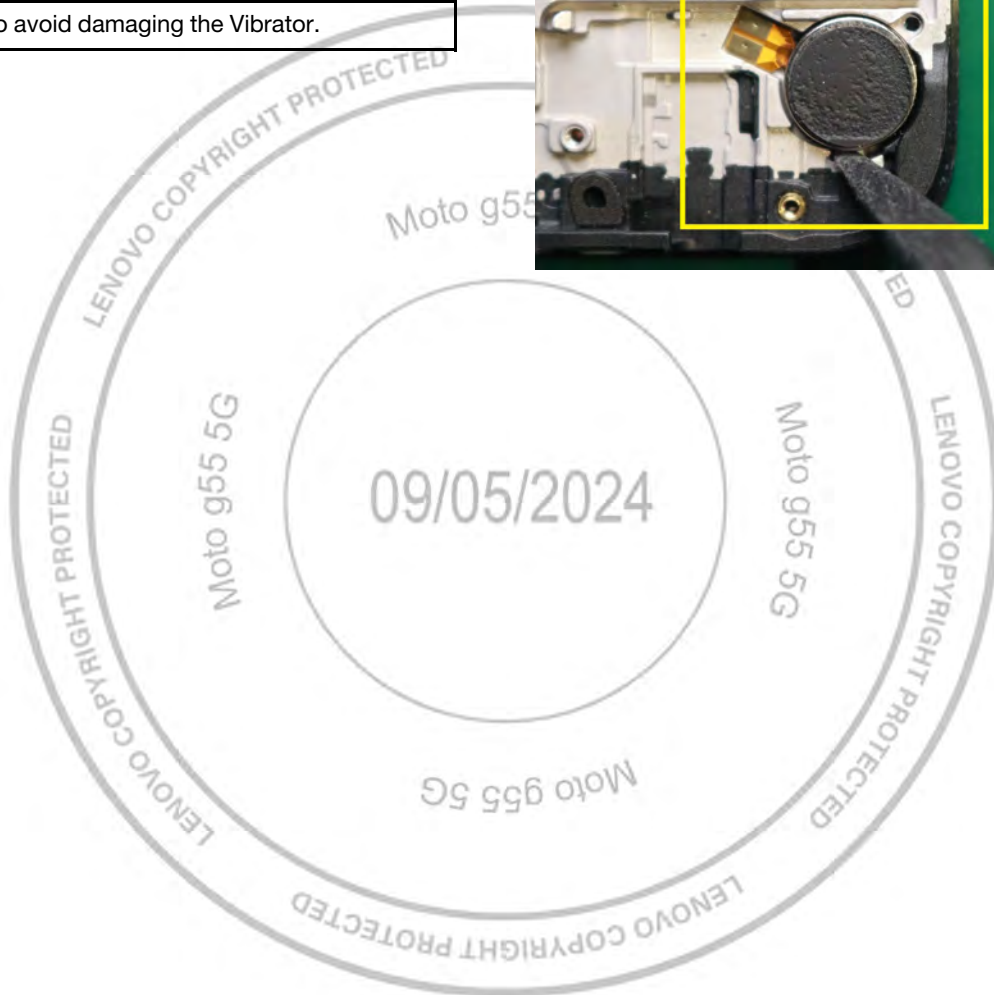
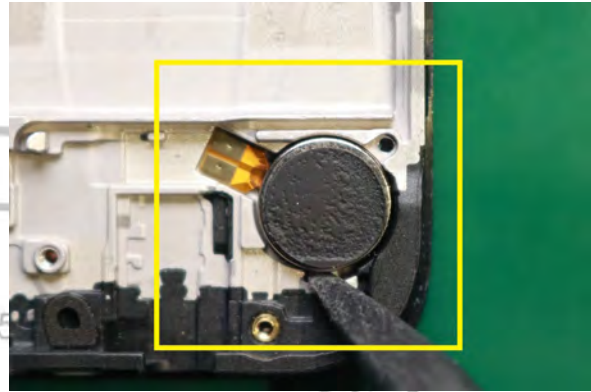
The Vibrator can be recovered and reused after removal.



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

### NOTE

Be careful to avoid damaging the Vibrator.



## Sensor Grommet Removal

### NOTE

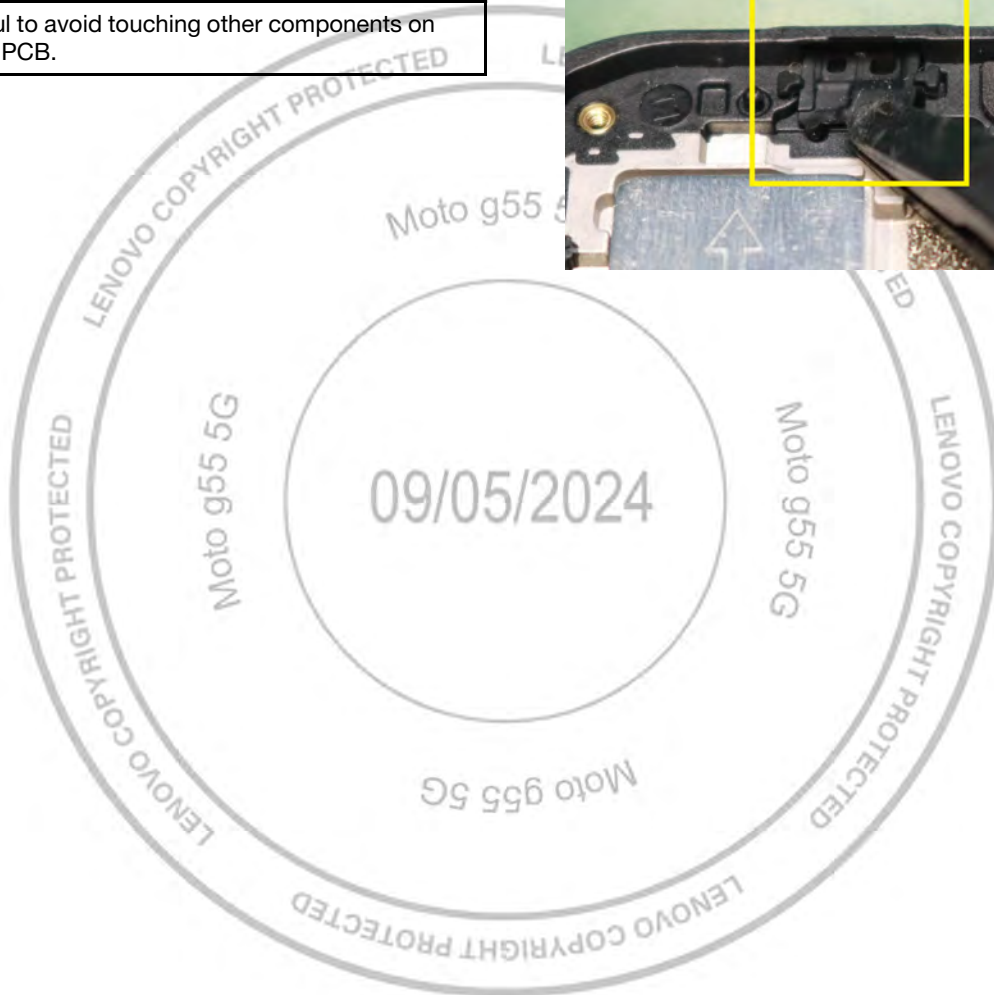
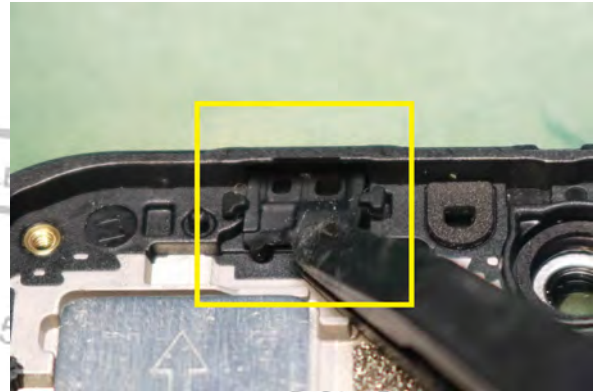
The Sensor Grommet can be recovered and reused after removal.



Use the Plastic Tweezer to remove the Sensor Grommet from the location as shown.

### NOTE

Be careful to avoid touching other components on the Main PCB.



## Receiver Removal

### NOTE

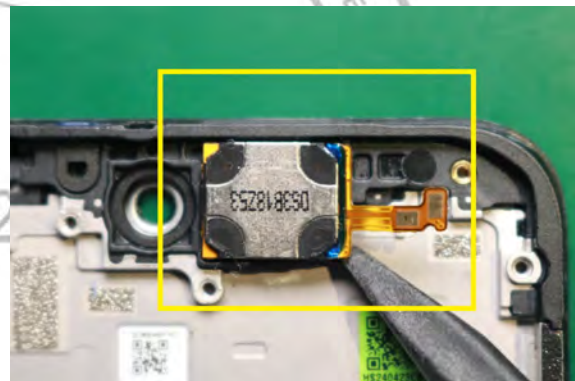
After you remove the Receiver, you cannot reuse it.



1. Use the pointed end of the Black Stick to disengage the Receiver FPC from the location as shown.



2. Use the pointed end of the Black Stick to disengage and remove the Receiver from the location as shown.



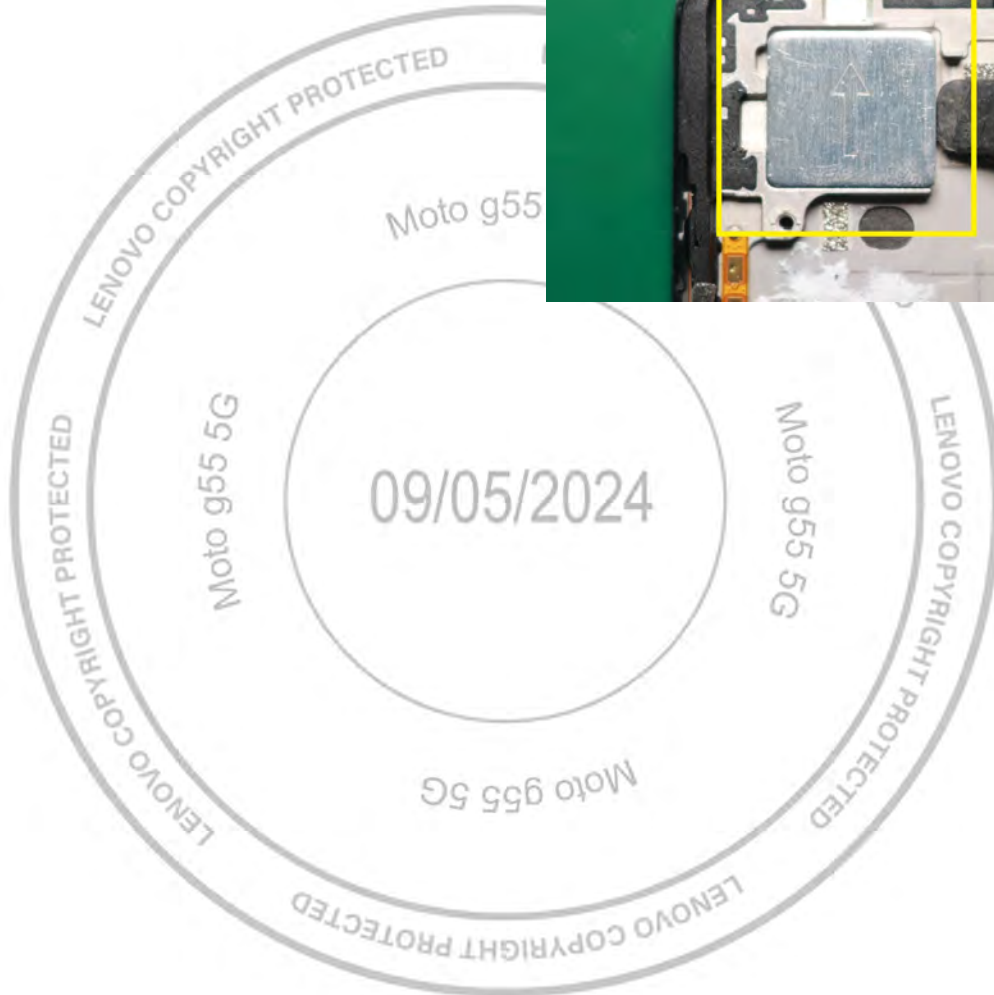
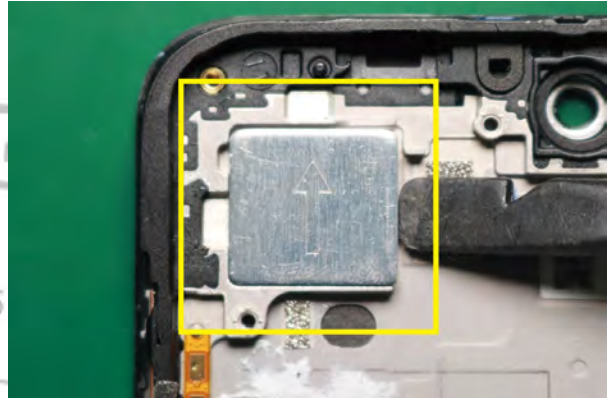
## 50M Rear-Facing Camera Aluminum Block Removal

### NOTE

After you remove the 50M Rear-Facing Camera Aluminum Block, you cannot reuse it.



Use the flat end of the Black Stick to lift and remove the 50M Rear-Facing Camera Aluminum Block from the location as shown.



## Side Key FPC Removal

### NOTE

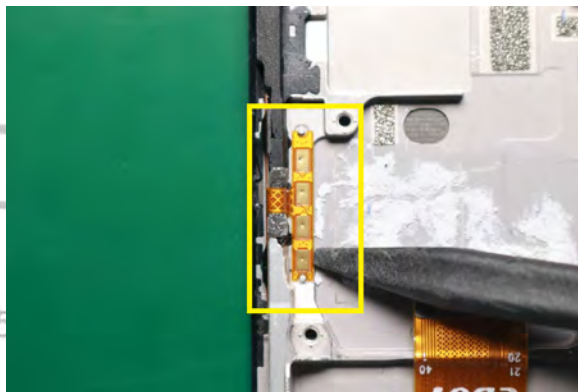
The Side Key FPC can be recovered and reused after removal.



1. Use the pointed end of the Black Stick to disengage the Side Key FPC from the location as shown.

### NOTE

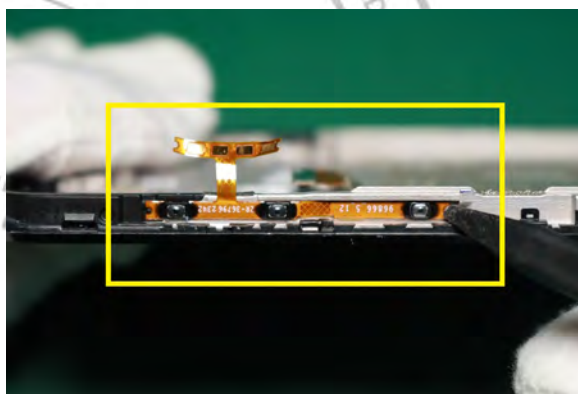
Be careful to avoid damaging the Side Key FPC.



2. Use the pointed end of the Black Stick to remove the Side Key FPC from the location as shown.

### NOTE

Be careful to avoid damaging the Side Key FPC.





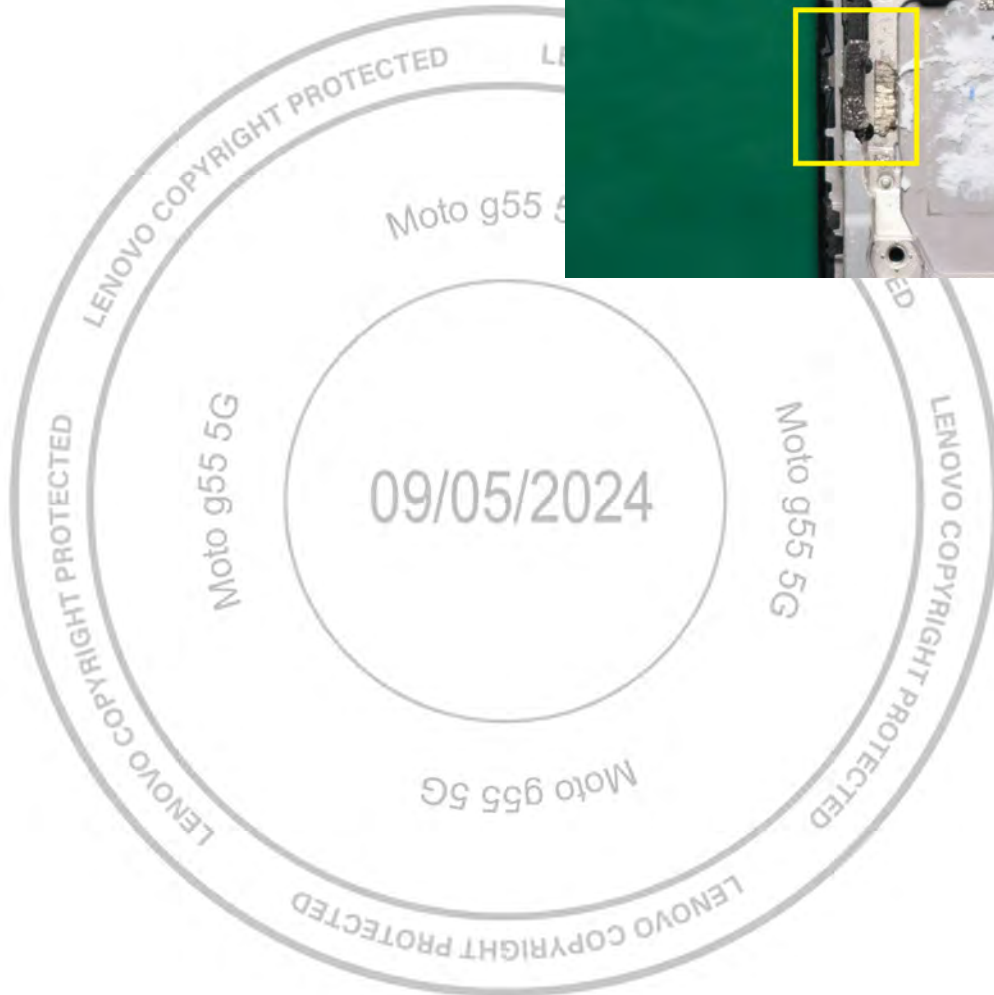
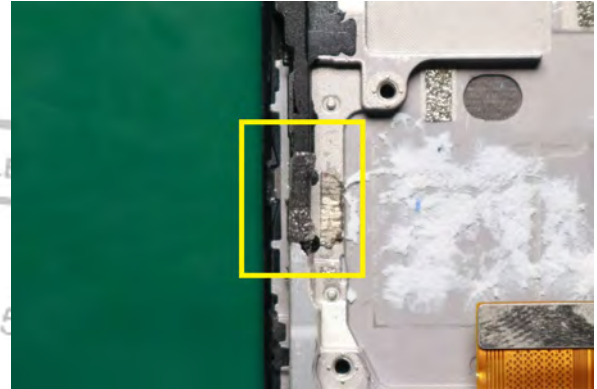
## Side Key Sealed Foam Removal

### NOTE

After you remove the Side Key Sealed Foam, you cannot reuse it.



Use the Plastic Tweezer to remove the Side Key Sealed Foam from the location as shown.






## Chapter 4. Parts Refresh

### Tools Required for Parts Refresh

The following tools are required for parts refresh of the Moto g55 5G phone.

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

## Battery Cover Cleaning

Use the ISP Alcohol and Cotton Swabs to remove all the adhesives on the Battery Cover as shown.

**/// CAUTION ///**

Remove the adhesive carefully to avoid damage to the Battery Cover.

**/// CAUTION ///**

Inadequate cleaning will result in degraded assembly quality.



## Front-Housing Cleaning

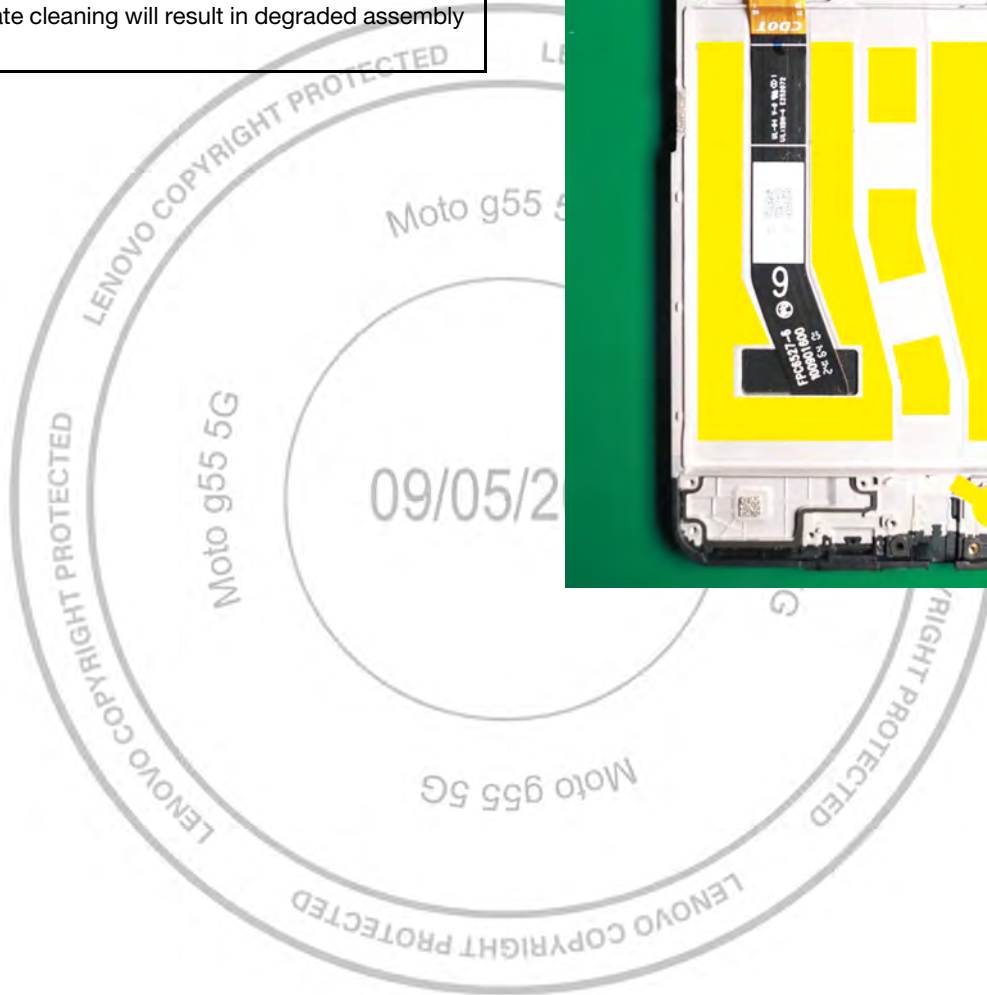
Use the Cotton Swabs with ISP Alcohol to remove all the adhesives from the location as shown.

**/// CAUTION ///**

Remove the adhesive carefully to avoid damage to the Front-Housing.

**/// CAUTION ///**

Inadequate cleaning will result in degraded assembly quality.



## Middle Frame Cleaning

Use the Cotton Swabs with ISP Alcohol to remove all the adhesives from the location as shown.

**/// CAUTION ///**

Remove the adhesive carefully to avoid damage to the Middle Frame.

**/// CAUTION ///**

Inadequate cleaning will result in degraded assembly quality.



## Front-Housing Cleaning

Use Plastic Scraper to remove the most part of Thermal putty from the Front-Housing.

**/// CAUTION ///**

Remove the Thermal putty carefully to avoid damage to the Front-Housing.

**/// CAUTION ///**

Inadequate cleaning will result in degraded assembly quality.



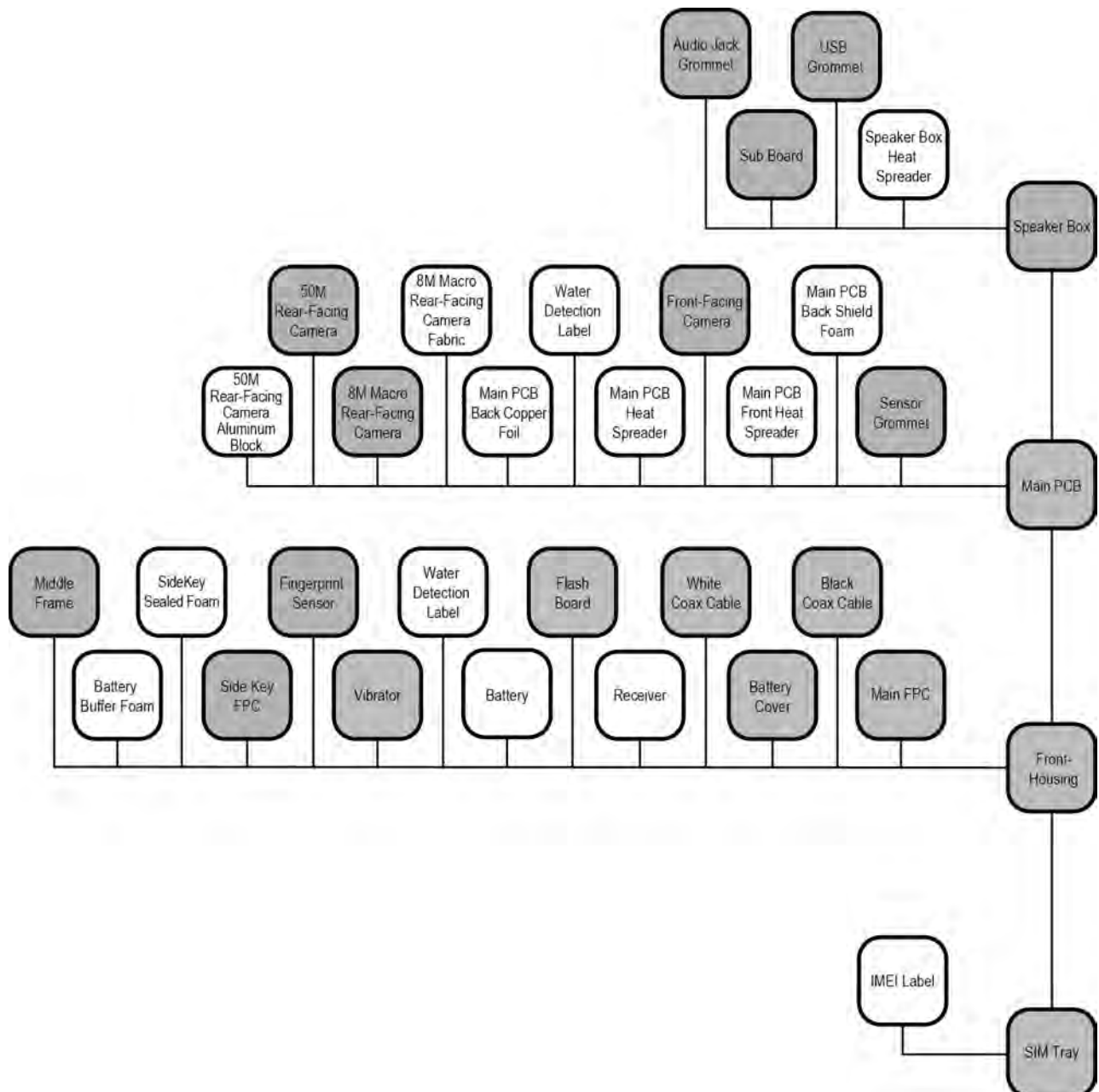




## Chapter 5. Assembly

### Assembly Map






\*Shaded parts may be eligible for parts recovery





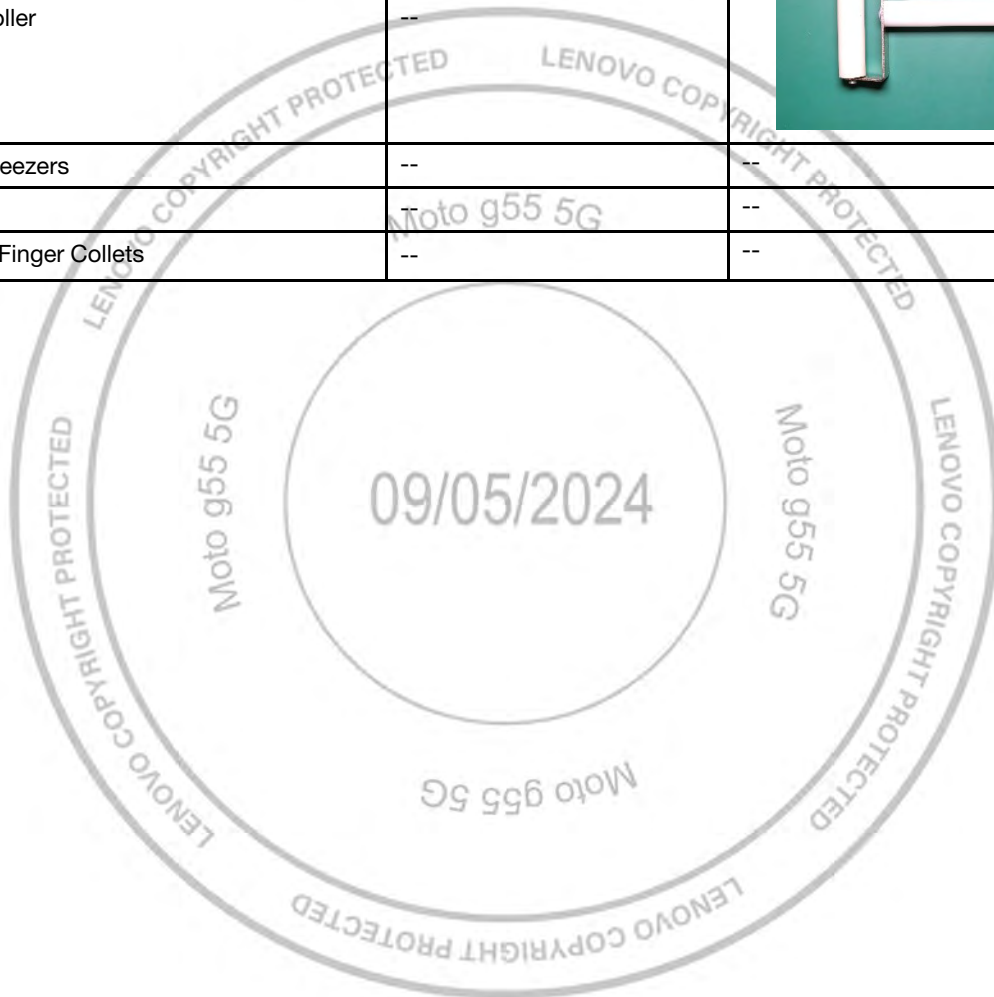
## Tools Required for Assembly

The following tools are required to assemble the Moto g55 5G phone.

NOTE
Improper tools may cause damage to components.

Description	Part #	Picture/Drawing
Black Stick	--	
Torque Driver	--	
Torx Bit	--	
Regen-I Pneumatic Press System <a href="https://www.regeni.com/">https://www.regeni.com/</a>	RG262	
Inlay Adhesive Alignment Supplier: AMS Email: <a href="mailto:holger.grube@amsde.com">holger.grube@amsde.com</a> <a href="https://amsde.com/en">https://amsde.com/en</a>	1-00-Y3-10000	

Description	Part #	Picture/Drawing
Inlay Press - Holder with Pad Supplier: AMS Email: holger.grube@amsde.com <a href="https://amsde.com/en">https://amsde.com/en</a>	1-00-Y4-10000 1-00-W1-10000	
Manual Roller	--	
Plastic Tweezers	--	--
Tweezers	Moto g55 5G	--
Gloves or Finger Collets	--	--



## SIM Tray Waterproof Mylar Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT712101102171+CardTray WaterProof MYLAR	-

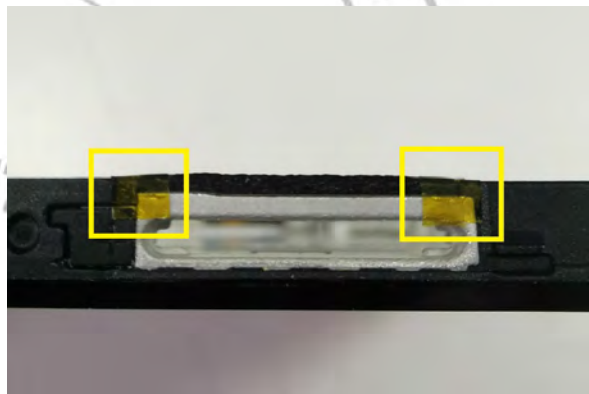
1. Use the Plastic Tweezer to place the SIM Tray Waterproof Mylar on the location as shown and peel off the liner.

**NOTE**  
The SIM Tray Waterproof Mylar should be pasted strictly in place.

**NOTE**  
Press firmly for seconds 3 times to activate the adhesive.



2. Use the Plastic Tweezer to place the SIM Tray Waterproof Mylar on the location as shown.



## Water Detection Label Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT712700341031+waterproof labelFWZ	-

Use the Plastic Tweezer to place the Water Detection Label (WDL) on the Front-Housing as shown.



## Receiver Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT71040000241+receiver0.45mm,126dB1KHz	12

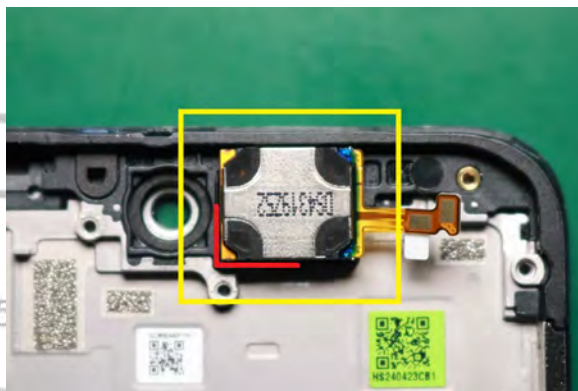
1. Use the Plastic Tweezer to place and secure the Receiver on the location aligning with the red lines as shown.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive.

**NOTE**

The Receiver should be assembled strictly in place. Improper installation will affect the signal of the phone.



2. Use the Plastic Tweezer to place the Receiver FPC on the location aligning with the pins as shown.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive.

**NOTE**

Be careful to not damage the Receiver FPC.



## Side Key Sealed Foam Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT712401014091+FPC SIDE KEY Foam,YH	32

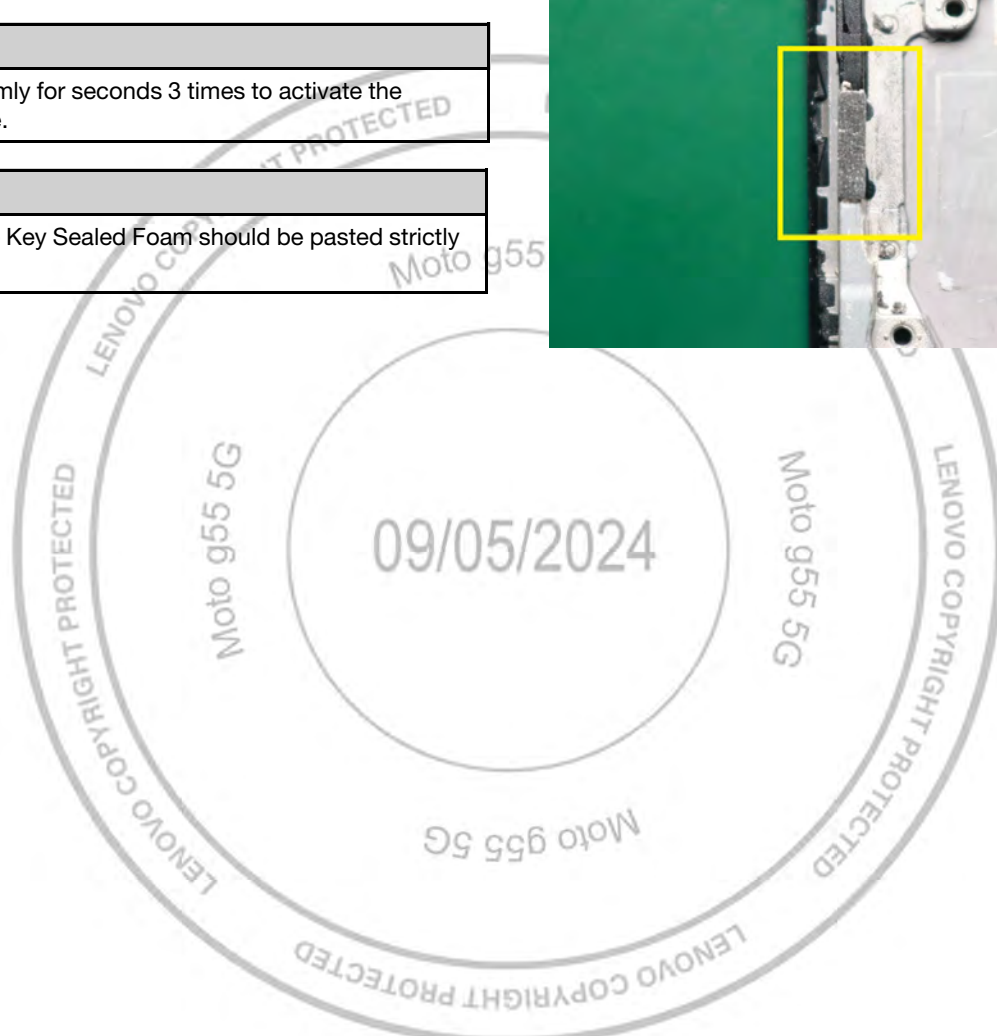
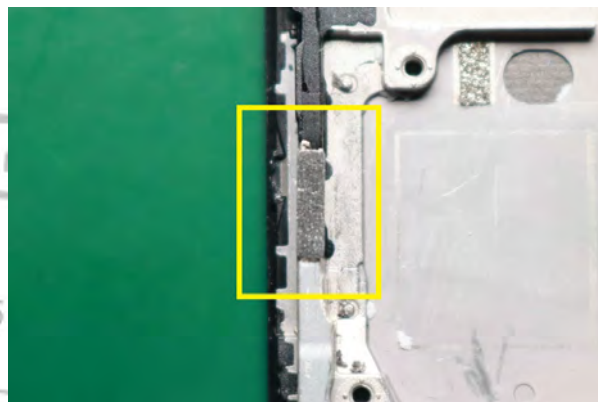
Use the Plastic Tweezer to place and secure the Side Key Sealed Foam on the location as shown.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive.

**NOTE**

The Side Key Sealed Foam should be pasted strictly in place.



## Side Key FPC Adhesive Assembly

Description	Reference #
WT713301014141+SIDE_KEY_FPC,39.32x10.29	15
XT2343,ADH,SideFPC,713301014051 CSS	30

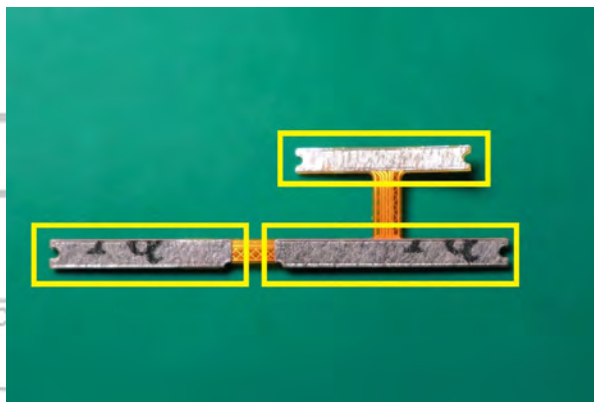
Use the Plastic Tweezer to place the Side Key FPC Adhesive on the location as shown and peel off the liners.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liners.

**NOTE**

The Side Key FPC Adhesive should be pasted strictly in place.





## Side Key FPC Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT713301014141+SIDE_KEY_FPC,39.32x10.29	15

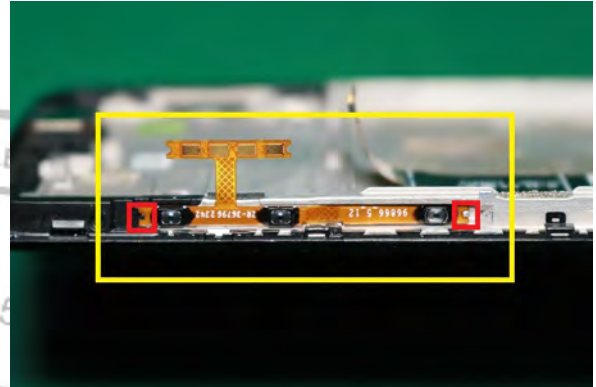
1. Use the Plastic Tweezer to place and secure the Side Key FPC on the location aligning with the pins as shown.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive.

**NOTE**

The Side Key FPC should be pasted strictly in place.



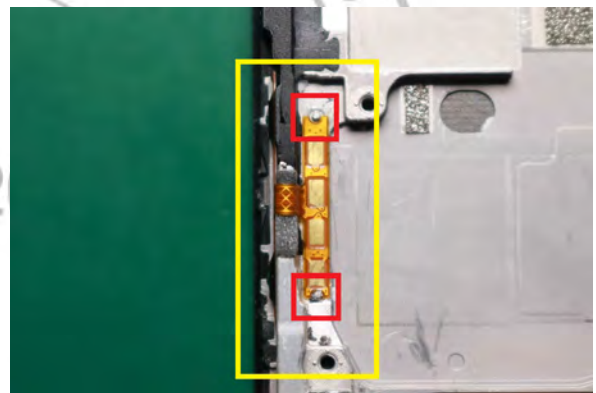
2. Use the Plastic Tweezer to place and secure the Side Key FPC on the location aligning with the pins as shown.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive.

**NOTE**

The Side Key FPC should be pasted strictly in place. Improper installation will affect the adjustment of the volume.



## 50M Rear-Facing Camera Aluminum Block Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT712901014231+HeatSink aluminumBlock;GN	38

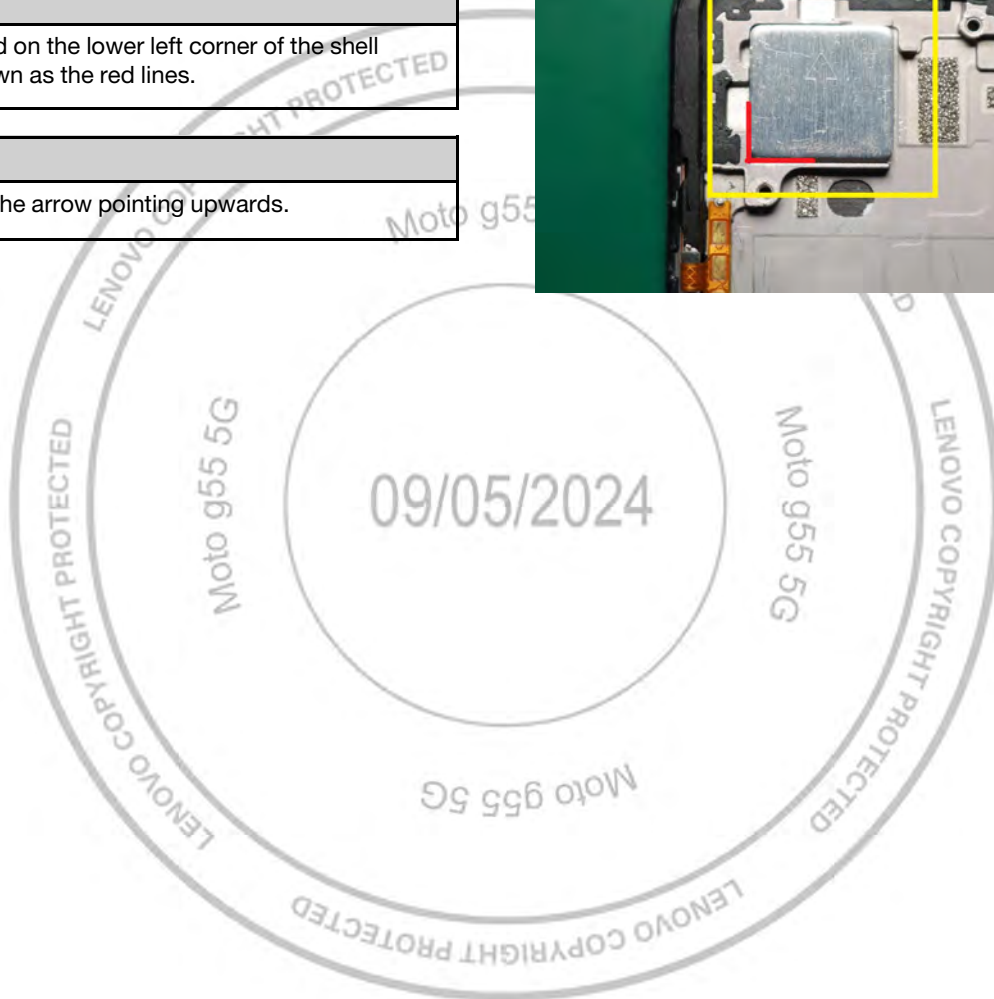
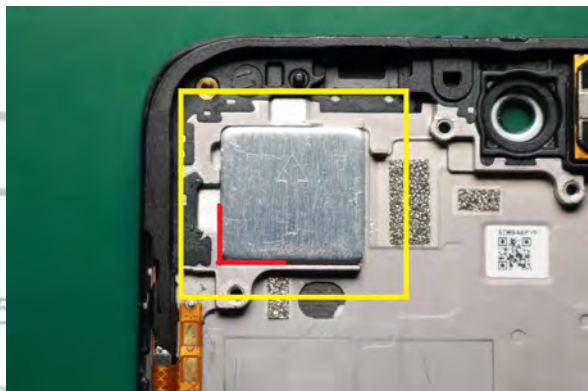
Use fingers to place and secure the 50M Rear-Facing Camera Aluminum Block on the location as shown.

**NOTE**

Install based on the lower left corner of the shell groove shown as the red lines.

**NOTE**

Install with the arrow pointing upwards.



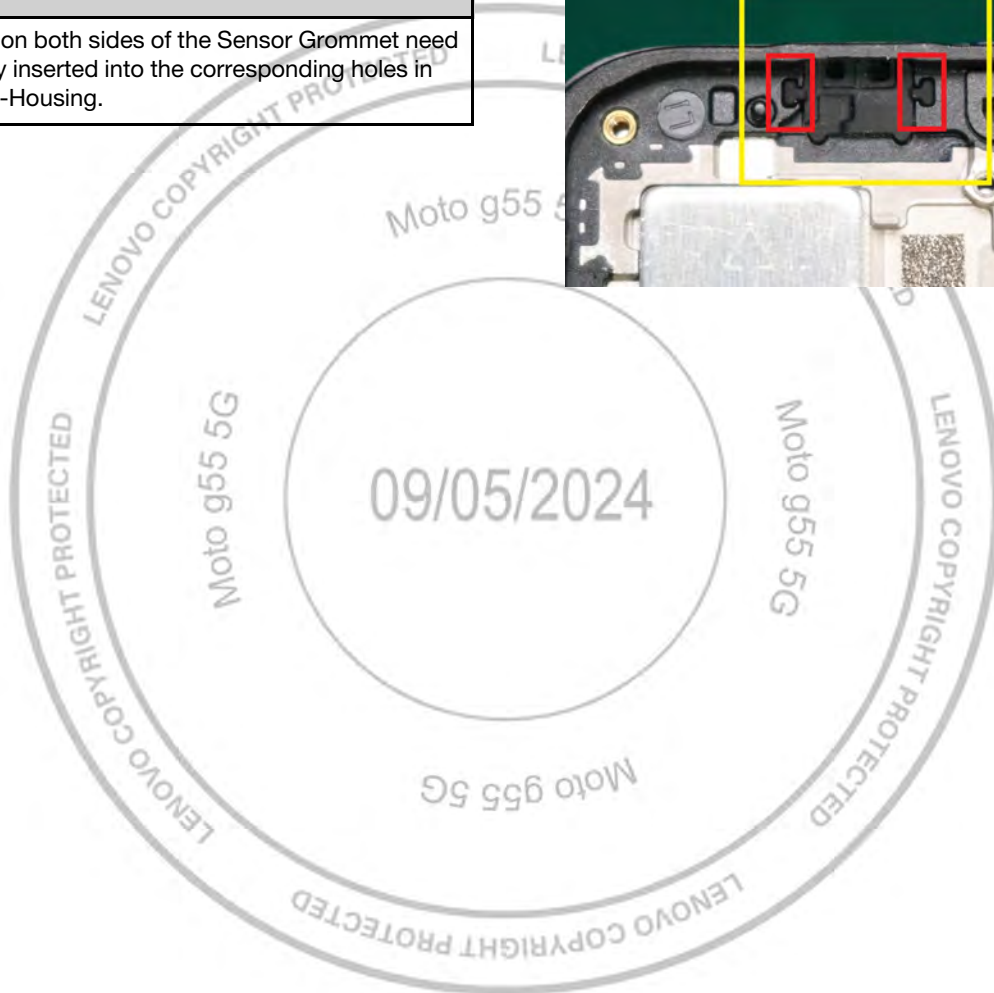
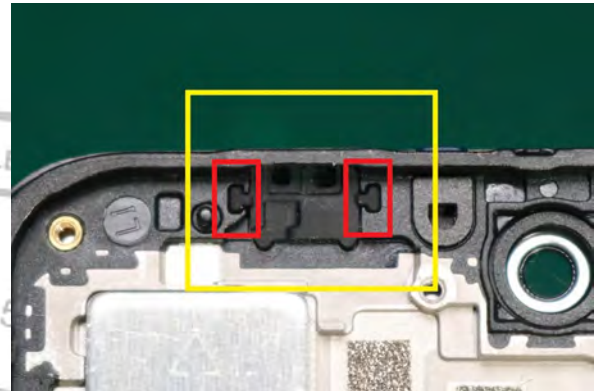
## Sensor Grommet Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT712301014031+rubber sleeve,black;YC	23

Use the Plastic Tweezer to place and secure the Sensor Grommet on the location as shown.

### NOTE

The ears on both sides of the Sensor Grommet need to be fully inserted into the corresponding holes in the Front-Housing.



## Vibrator Adhesive Assembly

Description	Reference #
WT710611000931+motor,B102740BA34-X	16
XT2343,ADH,VBRT,710600000221 CSS	28

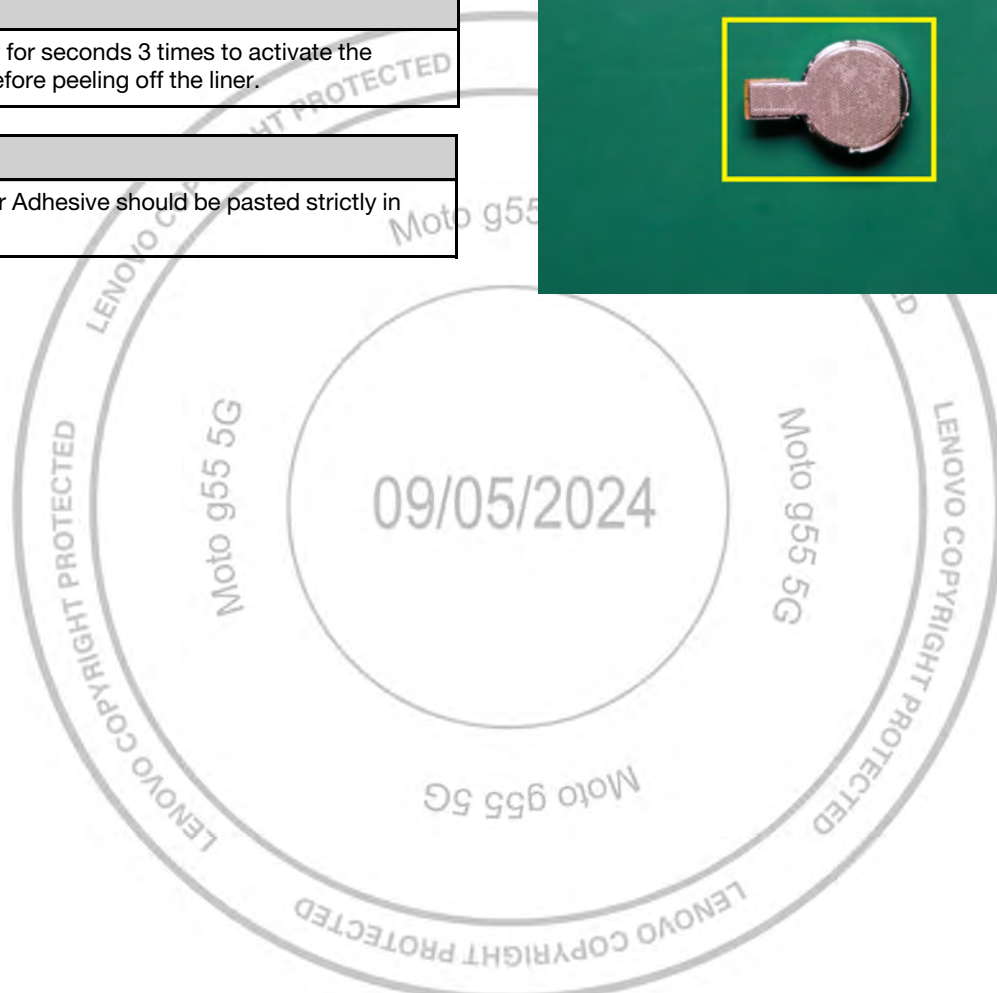
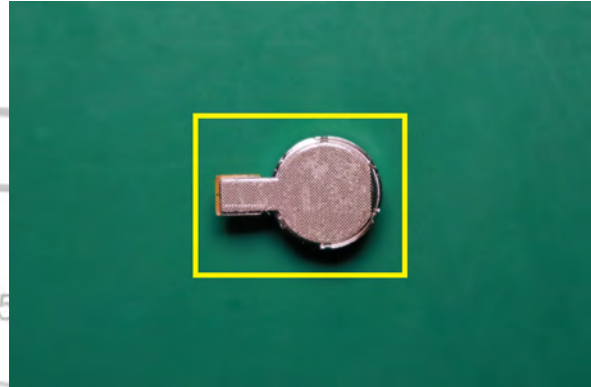
Use the Plastic Tweezer to place the Vibrator Adhesive on the location as shown and peel off the liner.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.

**NOTE**

The Vibrator Adhesive should be pasted strictly in place.



## Vibrator Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT710611000931+motor,B102740BA34-X	16

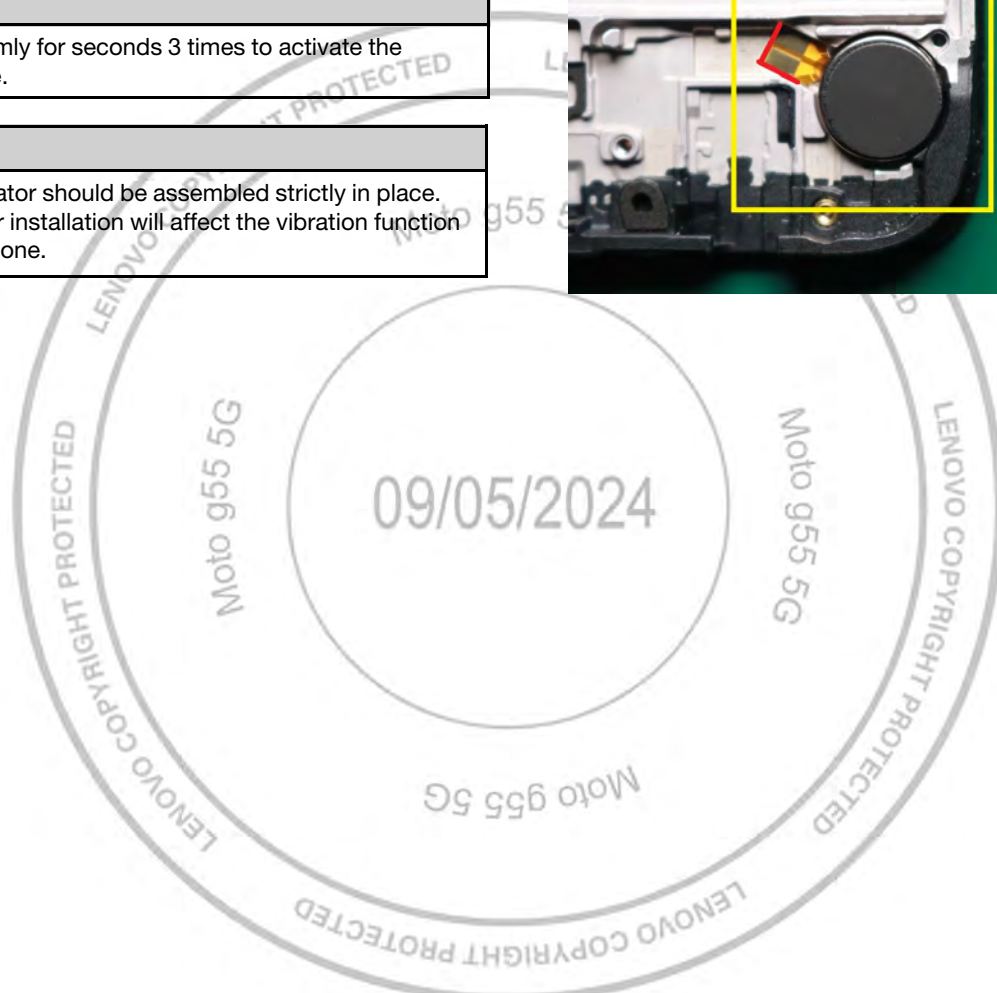
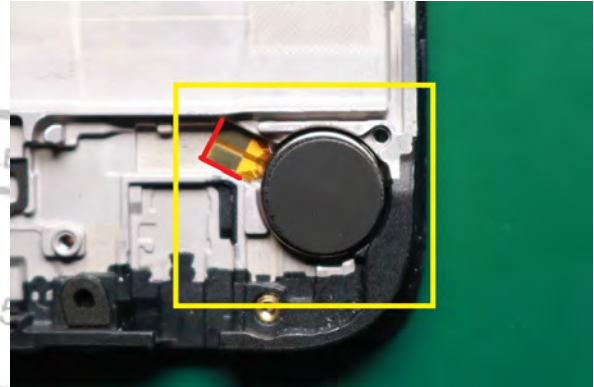
Use the Plastic Tweezer to place the Vibrator on the location as shown.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive.

**NOTE**

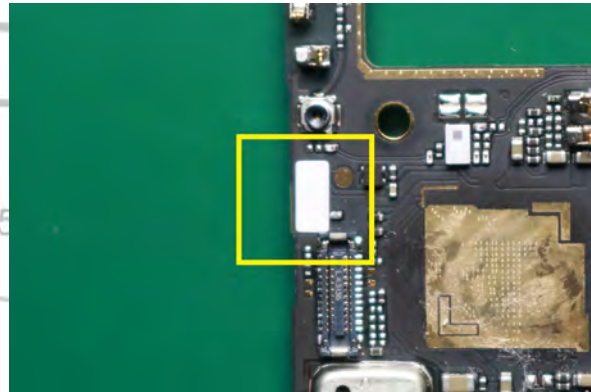
The Vibrator should be assembled strictly in place. Improper installation will affect the vibration function of the phone.



## Water Detection Label Assembly

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
WT712700341031+waterproof labelFWZ	-

Use the Plastic Tweezer to place the Water Detection Label (WDL) on the Main PCB as shown.



## 8M Macro Rear-Facing Camera Fabric Assembly

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
WT712101014021+2MGround conductive cloth	34

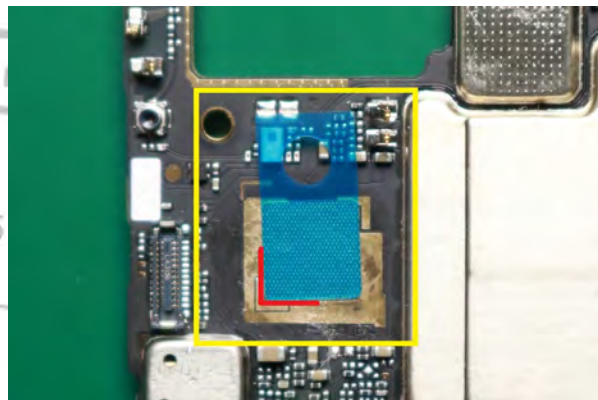
Use the Plastic Tweezer to place and secure the 8M Macro Rear-Facing Camera Fabric on the Main PCB as shown.

### NOTE

The 8M Macro Rear-Facing Camera Fabric should be pasted strictly in place.

### NOTE

Align the right angle of the Fabric with the red line on the Main Board.



## Main PCB Front Heat Spreader Assembly (for BR)

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
WT715001014161, LS 6K TOP shielding cove	39

Use the Plastic Tweezer to place the Main PCB Front Heat Spreader on the location as shown and peel off the liner.

### NOTE

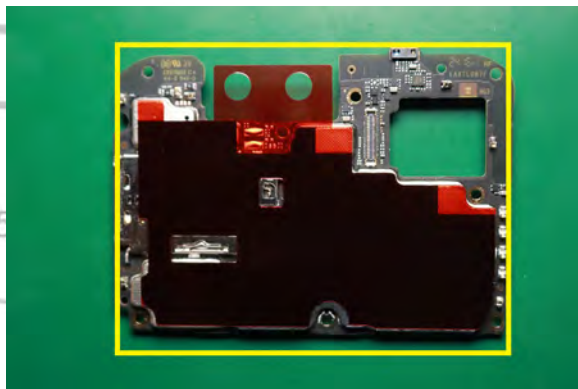
Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.

### NOTE

Improper installation will affect the heat dissipation of the phone.

### NOTE

Be careful to not touch other components on the Main PCB.

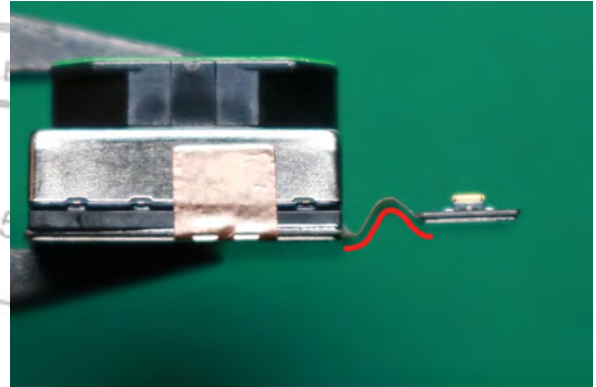




## 50M Rear-Facing Camera Assembly

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
MDL,CAMR,50M,rear,C3PS66;Qtech,OIS:Canca	10

1. Pre-fold the 50M Rear-Facing Camera FPC as shown.



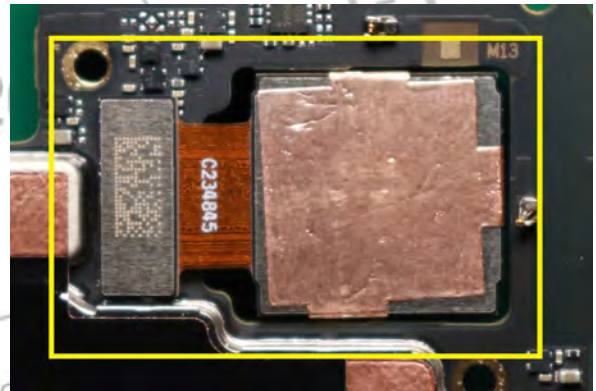
2. Use fingers to place and secure the 50M Rear-Facing Camera BtB Connector on the Main PCB as shown.

**NOTE**

Align the interface before securing to avoid damaging the contacts.

**NOTE**

The 50M Rear-Facing Camera should be assembled strictly in place. Improper installation will affect the photograph function of the phone.



## 8M Macro Rear-Facing Camera Assembly

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
MDL,CAMR,8M,rear,C48A04;Qtech,AF:Cancun5	9

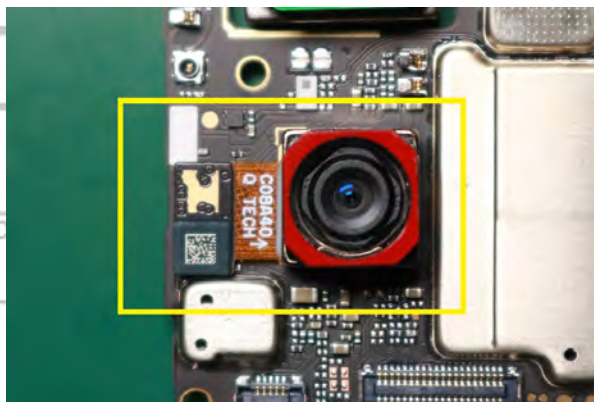
Use fingers to place and secure the 8M Macro Rear-Facing Camera on the Main PCB as shown and do not remove the protective cover in this step.

**NOTE**

Align the interface before securing to avoid damaging the contacts.

**NOTE**

The 8M Macro Rear-Facing Camera should be assembled strictly in place. Improper installation will affect the photograph function of the phone.



## Thermal Gel Assembly

### NOTE

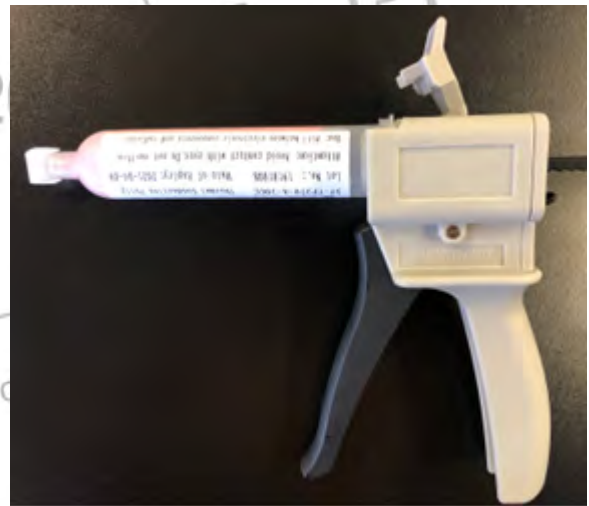
This procedure is only required when replacing the Main PCB or Front Housing.

## Thermal Gel Syringe size package and Needle Gauges description

1. TDS SY-TP350 5ml can operate without dispensing tool.



2. TDS SY-TP350 30ml operate with dispensing tool.



3. Henkel LF350 30ml operate with dispensing tool.



- 4. Cooler Master and Artic Thermal Gel syringe package.



- 5. When use Artic and Cooler Master 30ml package suggest using 18-gauge needle.



- 6. When use SY-TP350 or Henkel LF350 30ml package suggest using 14- or 15-gauge needle.



## Front-Housing Thermal Gel Location Assembly

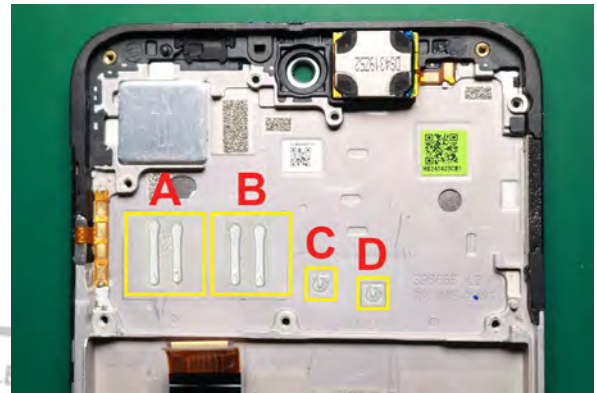
Noticing on the Front-Housing and refer to Thermal Gel shape as shown

A :  $125 \pm 0.005 \text{mg}$

B :  $125 \pm 0.005 \text{mg}$

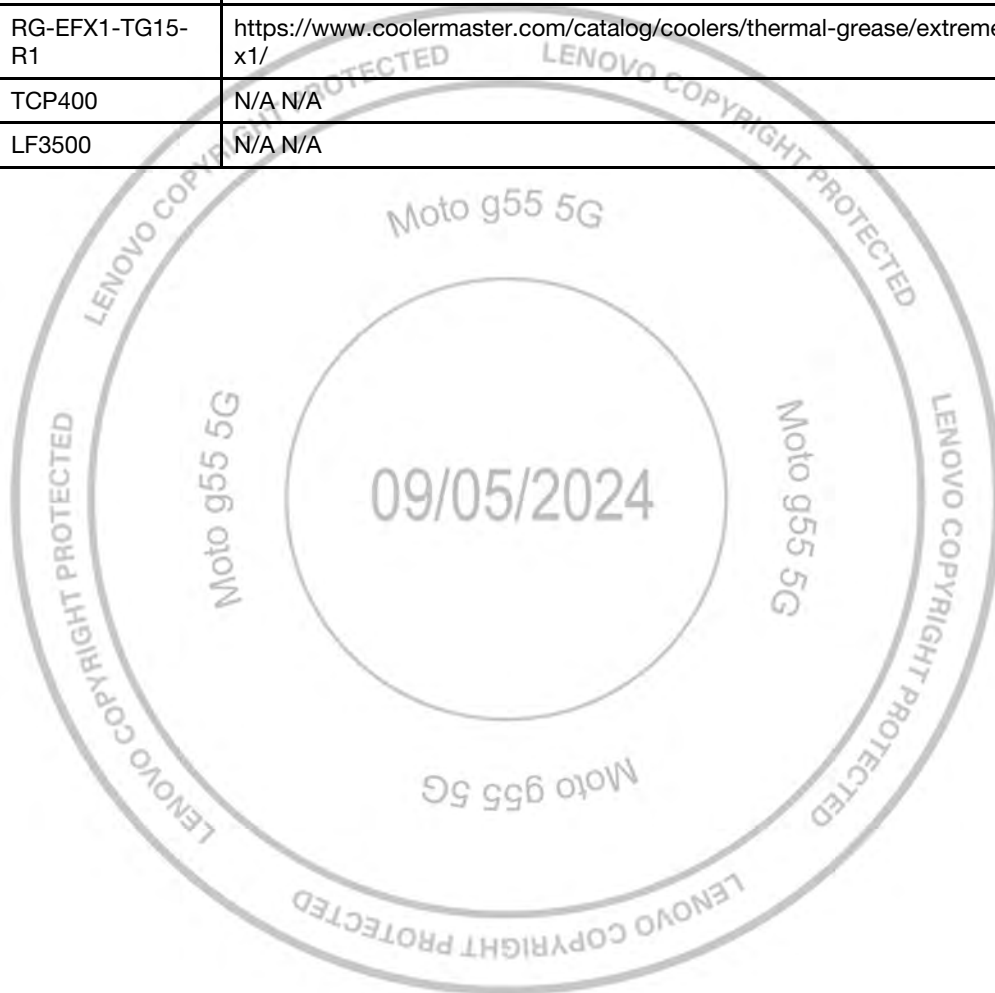
C :  $20 \pm 0.005 \text{mg}$

D :  $20 \pm 0.005 \text{mg}$



## Thermal Gel list that can be acceptable substitutes

Brand	Model	URL
Cool Master	MGY-OSSG-N15M-R1	<a href="https://www.coolermaster.com/catalog/coolers/thermal-grease/mastergel-pro/">https://www.coolermaster.com/catalog/coolers/thermal-grease/mastergel-pro/</a>
	MGZ-NDSG-N15M-R1	<a href="https://www.coolermaster.com/catalog/coolers/thermal-grease/mastergel-maker/">https://www.coolermaster.com/catalog/coolers/thermal-grease/mastergel-maker/</a>
	RG-ICE1-TG15-R1	<a href="https://www.coolermaster.com/catalog/coolers/thermal-grease/ic-essential-e1/">https://www.coolermaster.com/catalog/coolers/thermal-grease/ic-essential-e1/</a>
	RG-ICE2-TA15-R1	<a href="https://www.coolermaster.com/catalog/coolers/thermal-grease/ic-essential-e2/">https://www.coolermaster.com/catalog/coolers/thermal-grease/ic-essential-e2/</a>
	RG-EFX1-TG15-R1	<a href="https://www.coolermaster.com/catalog/coolers/thermal-grease/extreme-fusion-x1/">https://www.coolermaster.com/catalog/coolers/thermal-grease/extreme-fusion-x1/</a>
Electrolube	TCP400	N/A N/A
Henkel	LF3500	N/A N/A



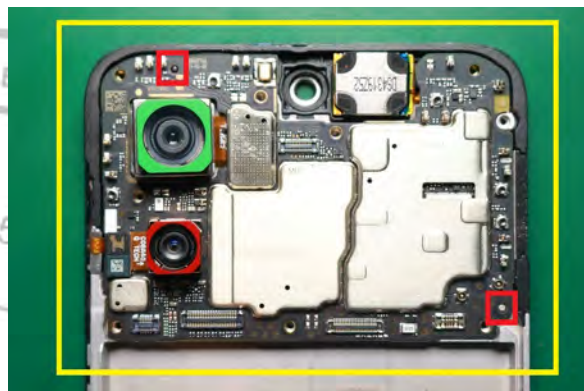
## Main PCB Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2

1. Make sure to place the Main PCB on the Front-Housing aligning with the pins as shown.

### NOTE

Be careful to not touch other components on the Main PCB.



### NOTE

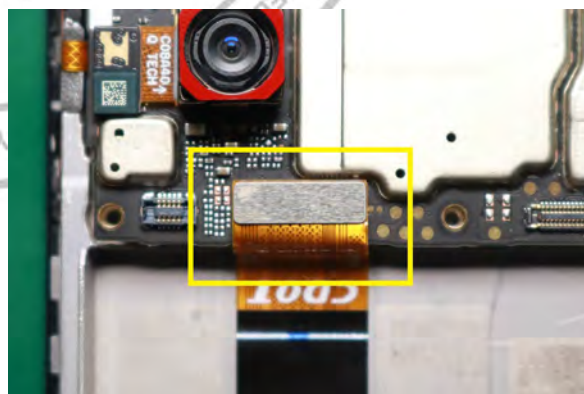
Incline the Main PCB and insert the Proximity Sensor first and insert the Main PCB into the Front-Housing at certain degrees.



2. Use fingers to place and secure the TP FPC BtB Connector on the Main PCB as shown.

### NOTE

Align the interface before securing to avoid damaging the contacts.



## Front-Facing Camera Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
MDL,CAMR,16M,front;C2EF06;Q Tech,FF:Devo	8

Use fingers to place and secure the Front-Facing Camera on the location as shown.

### NOTE

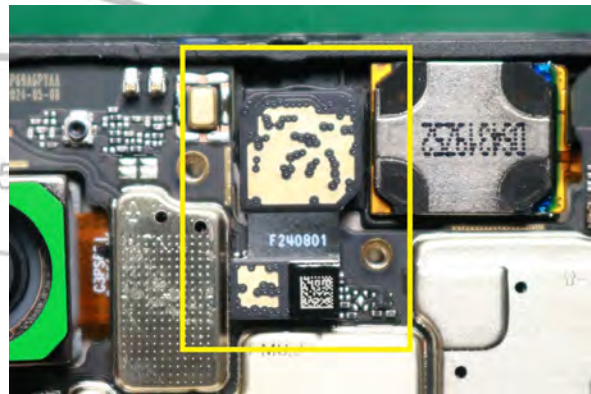
Align the interface before securing to avoid damaging the contacts.

### NOTE

Make sure the Front-Facing Camera is installed into the recess of the Front-Housing.

### NOTE

The Front-Facing Camera should be assembled strictly in place. Improper installation will affect the photograph function of the phone.

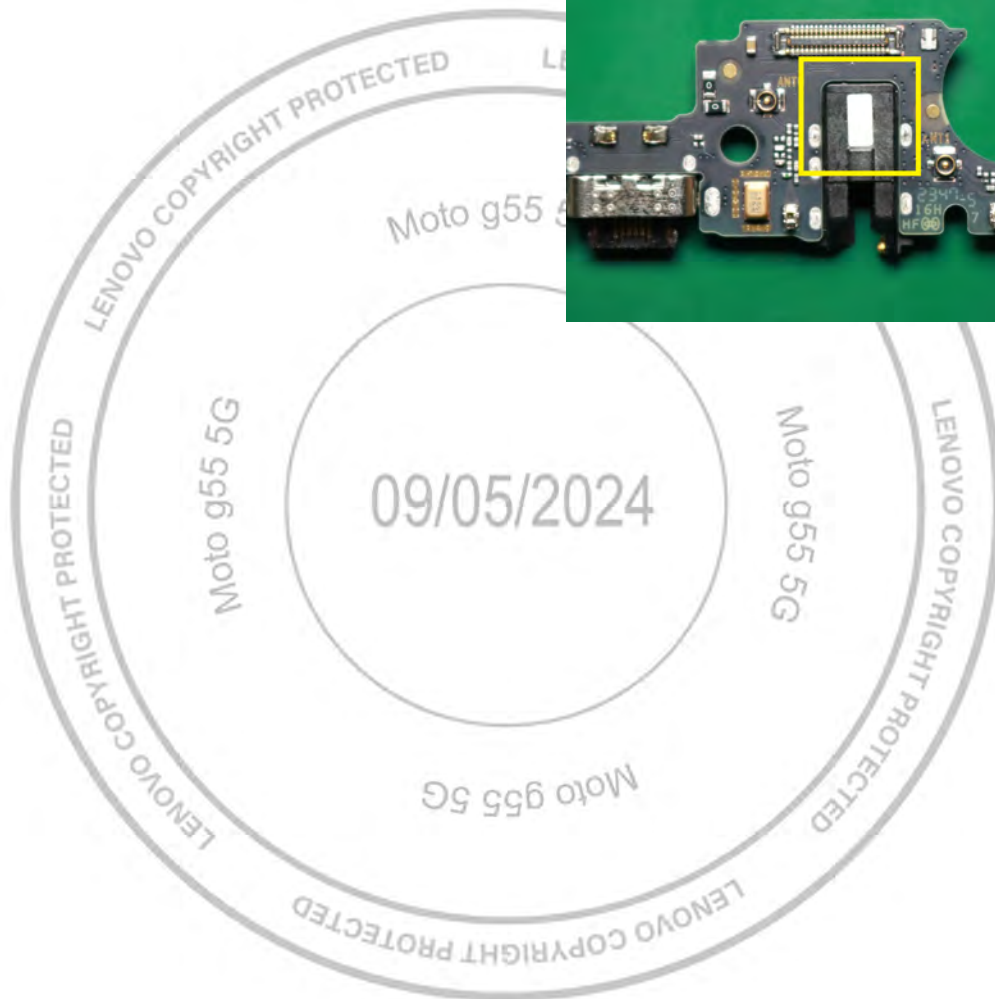
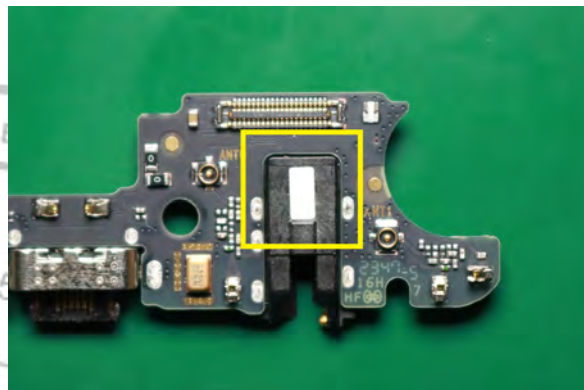




## Water Detection Label Assembly

Description	Reference #
ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	3
WT712700341031+waterproof labelFWZ	-

Use the Plastic Tweezer to place the Water Detection Label (WDL) on the Sub Board as shown.



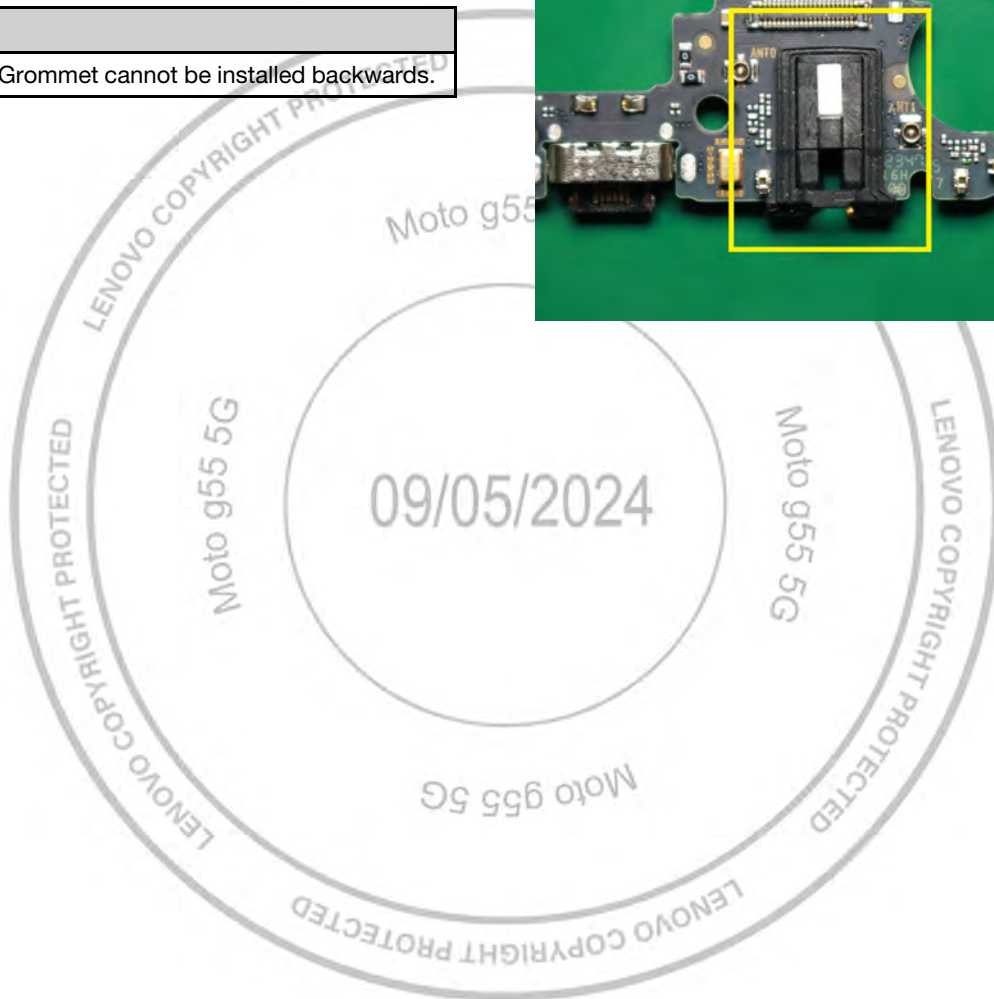
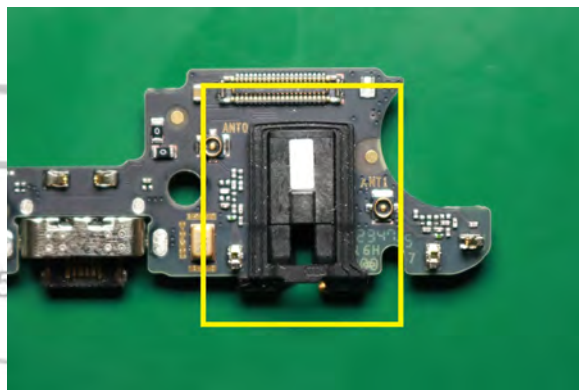
## Audio Jack Grommet Assembly

Description	Reference #
ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	3
WT712301014021+rubber sleeve,black;YC	22

Use the Plastic Tweezer to place the Audio Jack Grommet on the location as shown.

### NOTE

Audio Jack Grommet cannot be installed backwards.



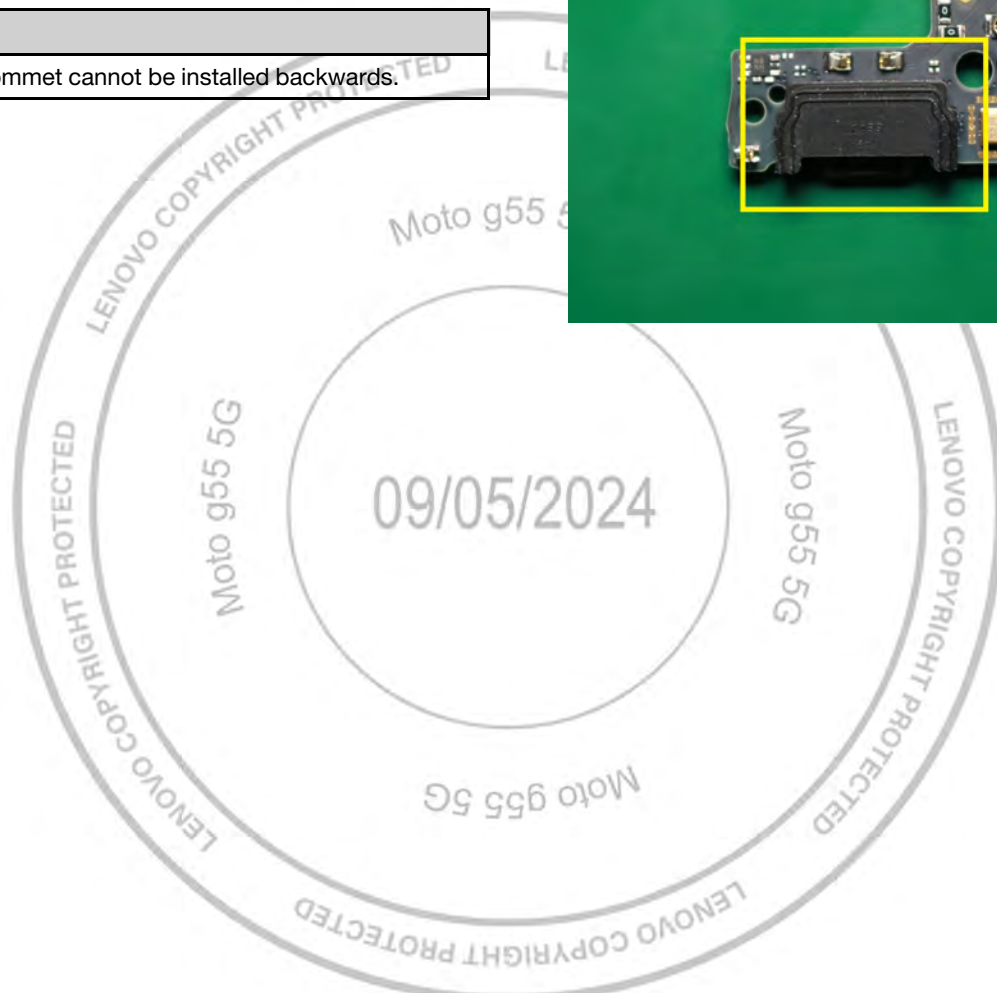
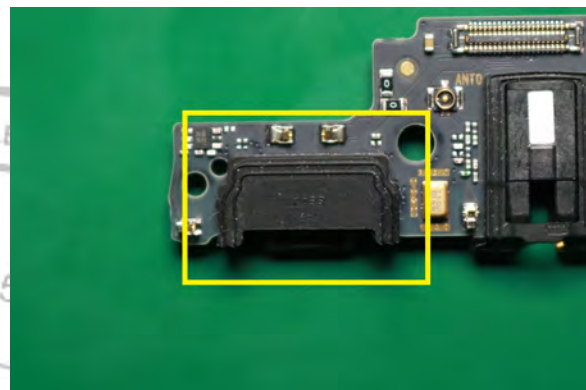
## USB Grommet Assembly

Description	Reference #
ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	3
WT712301014011+rubber sleeve,black;YC	21

Use the Plastic Tweezer to place the USB Grommet on the location as shown.

**NOTE**

USB Grommet cannot be installed backwards.



## Sub Board Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	3
WT715601014021+black coaxial cable;DL	17

Use fingers to place the Sub Board on the location as shown.

**NOTE**

Be careful to not touch other components on the Sub Board.



**NOTE**

Make sure to insert the Sub Board at certain degrees as shown.



## White Coax Cable Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	3
WT715601014011+white coaxial cable;DL	18

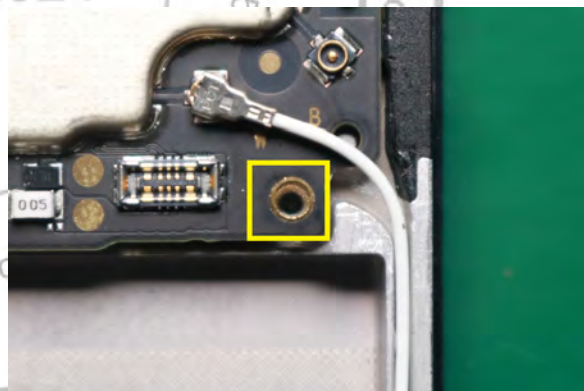
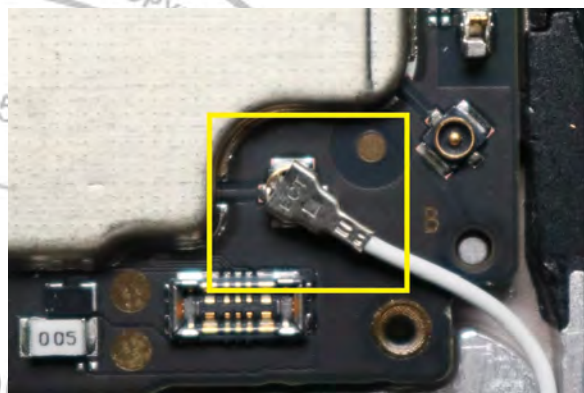
1. Use the Plastic Tweezer to place and secure the White Coax Cable on the Main PCB as shown.

**NOTE**

Align the interface before securing to avoid damaging the contacts.

**NOTE**

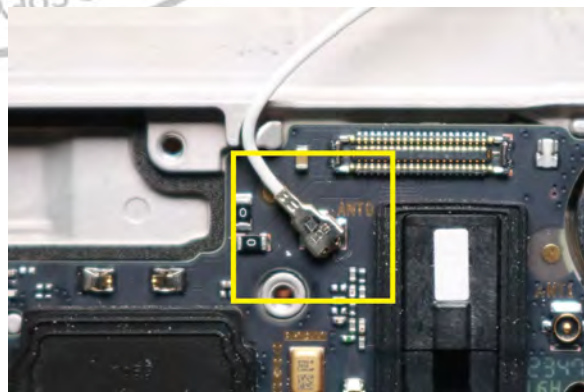
Ensure that the White Coax Cable does not cover the screw hole.



2. Use the Plastic Tweezer to place and secure the White Coax Cable on the Sub Board as shown.

**NOTE**

Align the interface before securing to avoid damaging the contacts.



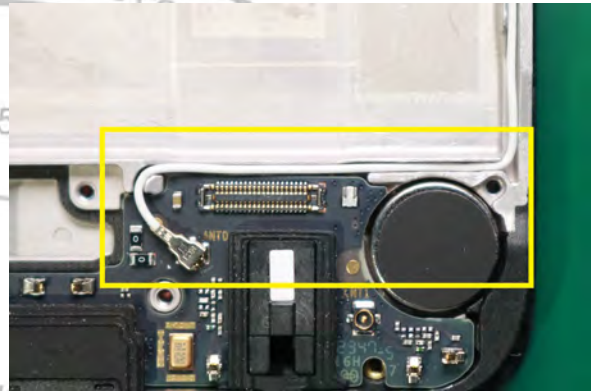
3. Use the flat end of the Black Stick to place the White Coax Cable on the pocket of the recess of the phone.

**NOTE**

Use the flat end of the Black Stick to place the White Coax Cable on the pocket from the Main PCB side to Sub Board side as shown.



4. Organize the White Coax Cable over the vibrator and then arrange the bend on the left side.



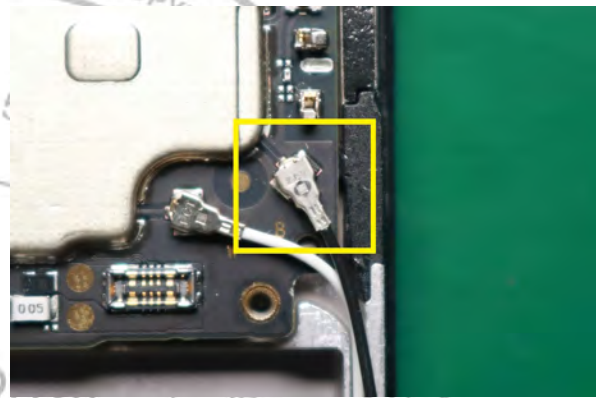
## Black Coax Cable Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	3
WT715601014021+black coaxial cable;DL	17

1. Use the Plastic Tweezer to place and secure the Black Coax Cable on the Main PCB as shown.

**NOTE**

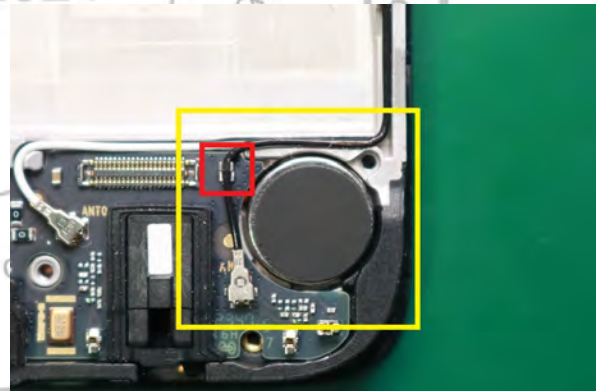
Align the interface before securing to avoid damaging the contacts.



2. Use the Plastic Tweezer to place and secure the Black Coax Cable on the Sub Board and place the Black Coax Cable into the cable guide on the Front Housing as shown.

**NOTE**

The Black Coax Cable must be clipped into the Sub Board clip.



3. Use the flat end of the Black Stick to place the Black Coax Cable on the pocket of the recess of the phone.

**NOTE**

Use the pointed end of the Black Stick to place the Black Coax Cable on the pocket from Main PCB side to Sub Board side as shown.



## Main FPC Adhesive Assembly

Description	Reference #
TPLCM,XT2435 CS	1
XT2343,ADH,MN FPC,711501014731 CSS	27

Use the Plastic Tweezer to place the Main FPC Adhesive on the location as shown and peel off the liner.

**NOTE**

The Main FPC Adhesive should be pasted strictly in place.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.





## Main FPC Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
ASSY,DTR BRD,Taipei BR Sub PCBA ASSY,DTR BRD,USB,XT2435 CS	3
WT713301014121+MAIN-FPC,yaqi,MOLEX 40pin	14

1. Use fingers to place and secure the Main FPC on the Main PCB as shown.

**NOTE**

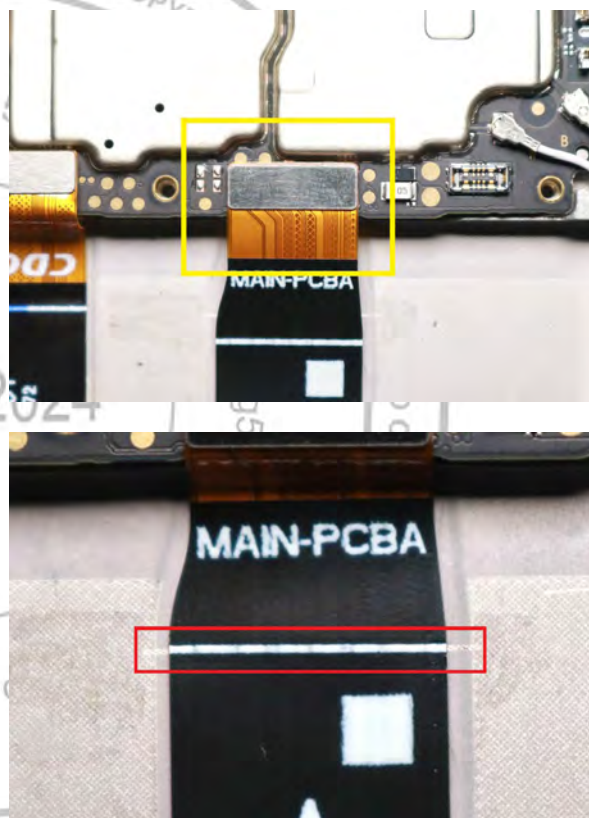
Make sure the Main FPC is buckled up on the Main PCB end with the font MAIN-PCBA at one end.

**NOTE**

Align the interface before securing to avoid damaging the contacts.

**NOTE**

The white line on the Main FPC should be aligned with the indicating line on the Front-Housing.



2. Use fingers to place and secure the Main FPC on the Sub Board as shown.

**NOTE**

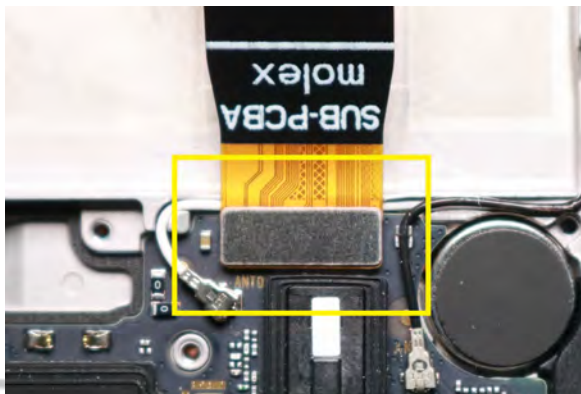
Make sure the Main FPC is buckled up on the Sub Board end with the font SUB-PCBA at one end.

**NOTE**

Align the interface before securing to avoid damaging the contacts.

**NOTE**

The white line on the Main FPC should be aligned with the indicating line on the Front-Housing.



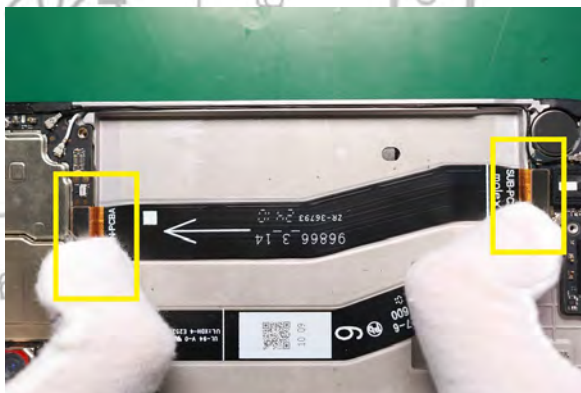
3. Use fingers to place the Main FPC on the Front-Housing as shown.

**NOTE**

Place the Main FPC strictly following the cable guide on the Front Housing.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive.



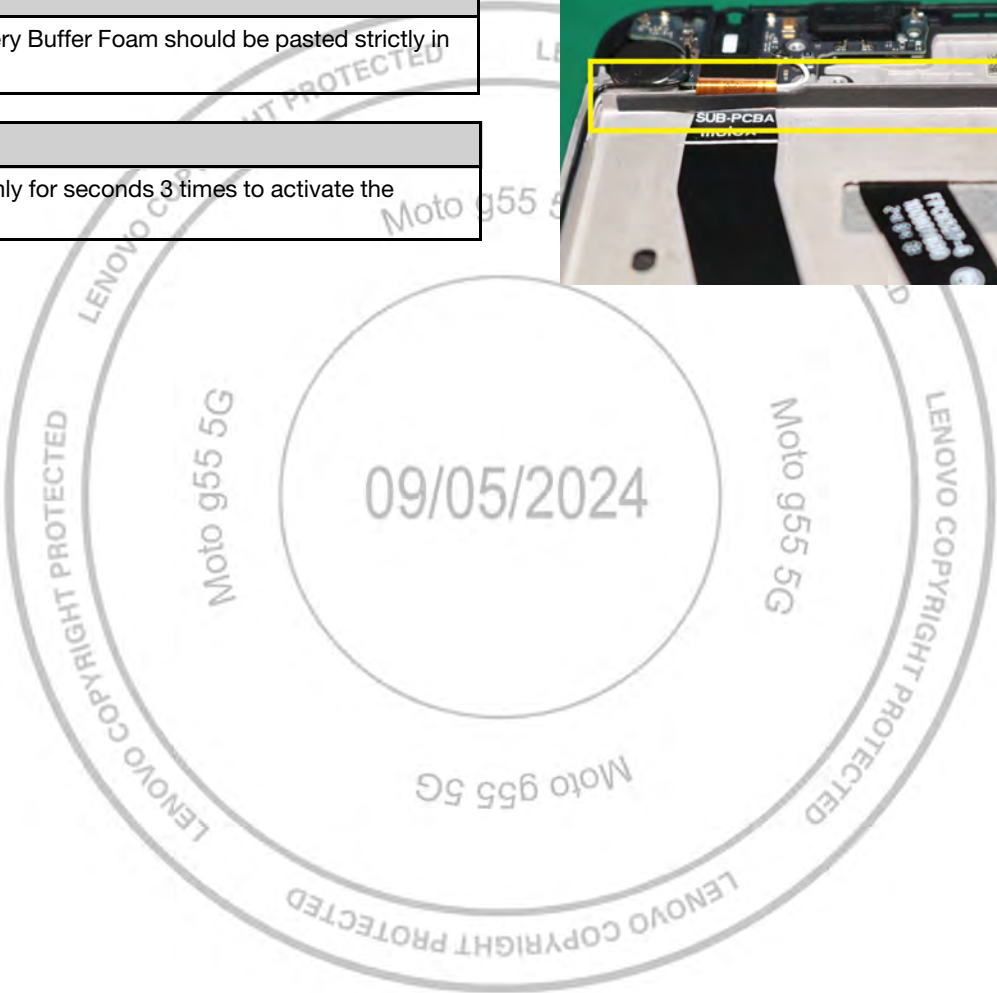
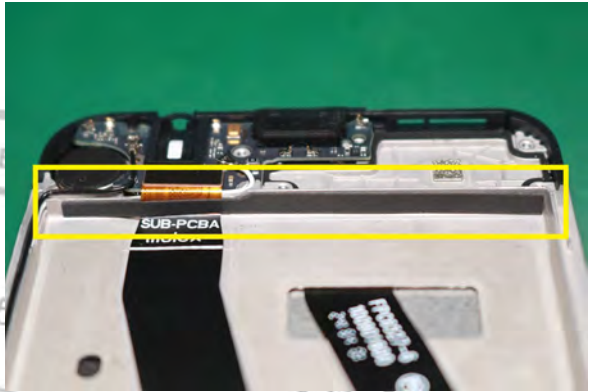
## Battery Buffer Foam Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT712401014011+bottom protection foam	33

Use the Plastic Tweezer to place the Battery Buffer Foam on the location as shown.

**NOTE**  
The Battery Buffer Foam should be pasted strictly in place.

**NOTE**  
Press firmly for seconds 3 times to activate the adhesive.



## Left Battery Adhesive Assembly

Description	Reference #
TPLCM,XT2435 CS	1
XT2343,ADH,BAT_Left,711501014711 CSS	25

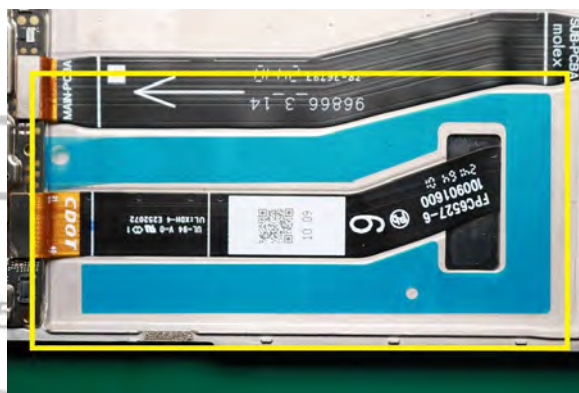
Use the Plastic Tweezer to place the Left Battery Adhesive on the Front-Housing as shown and peel off the liner.

**NOTE**

The Battery Adhesive should be pasted strictly in place.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



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## Right Battery Adhesive Assembly

Description	Reference #
TPLCM,XT2435 CS	1
XT2343,ADH,BAT_Right,711501014721 CSS	26

Use the Plastic Tweezer to place the Right Battery Adhesive on the Front-Housing as shown and peel off the liner.

### NOTE

The Battery Adhesive should be pasted strictly in place.

### NOTE

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



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## Battery Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
ACCY,BAT,5000mAh,QA50,VK446590, Jiade ACCY,BAT,5000mAh,QA50,VK446590, Jiade, Lot	11

### /// 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

The EU battery comes with an easy-tear film. Although the appearance differs from the illustrated battery, the installation method is the same.

### // 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. Peel off the liners of the Battery Adhesive. Then, use fingers to place and secure the Battery on the location as shown.

### NOTE

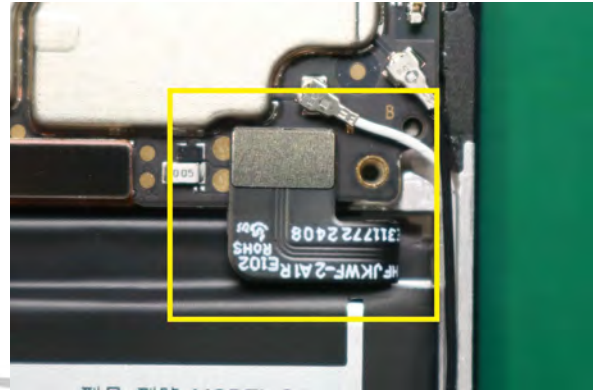
Make sure to assembly the Battery using the bottom of the Battery compartment as marked in red.



2. Use fingers to place and secure Battery BtB Connector on the location as shown.

**NOTE**

Align the interface before securing to avoid damaging the contacts.



3. Use the Manual Roller to roll over the Battery for 10 cycles to secure the Battery as shown.

**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.

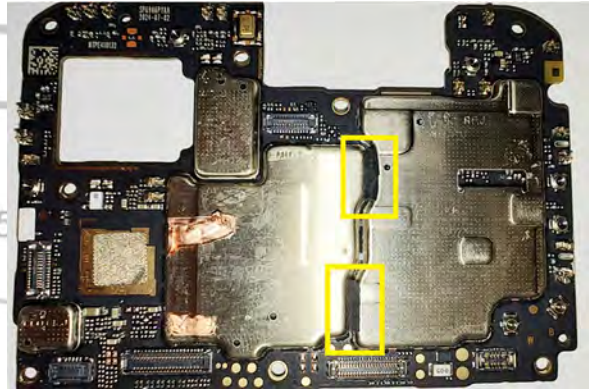


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## Main PCB Bottom Shield Foam Assembly

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
WT712401102011+Resonance Foam YH	-

Use the Plastic Tweezer to place the Main PCB Bottom Shield Foam on the location as shown.





## Main PCB Back Copper Foil Assembly

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
MDL,CAMR,16M,front;C2EF06;Q Tech,FF:Devo	8
WT712101014011+Shielding Copper Foil;YH	35

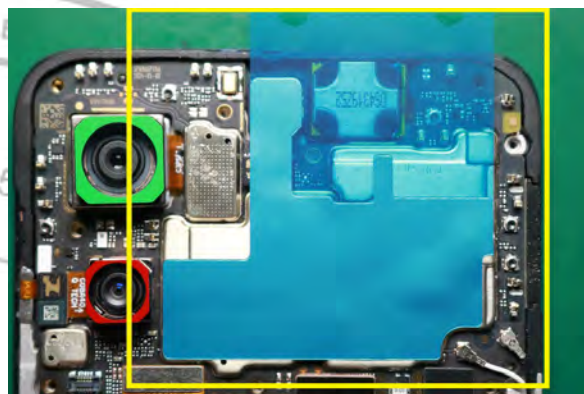
Use the Plastic Tweezer to place the Main PCB Back Copper Foil on the location as shown and peel off the liner.

### NOTE

Be careful to not touch other components on the Main PCB.

### NOTE

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



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## Main PCB Heat Spreader Assembly

Description	Reference #
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
MDL,CAMR,16M,front;C2EF06;Q Tech,FF:Devo	8
WT715001062011+LS 6K- BOT shield heat di	36

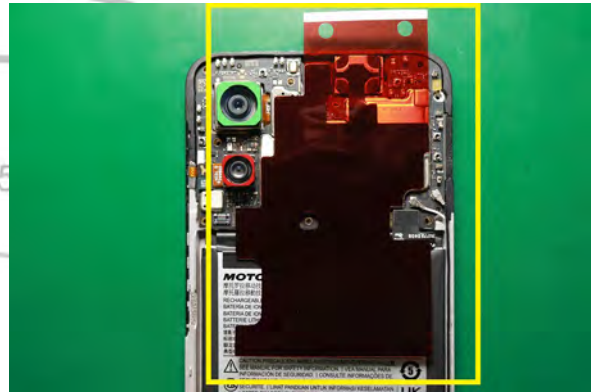
Use the Plastic Tweezer to place the Main PCB Heat Spreader on the location as shown and peel off the liner.

### NOTE

Improper installation will affect the heat dissipation of the phone.

### NOTE

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



## Flash Board Adhesive Assembly

Description	Reference #
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6
XT2343,ADH,FLSH BD,711501014741 CSS	29

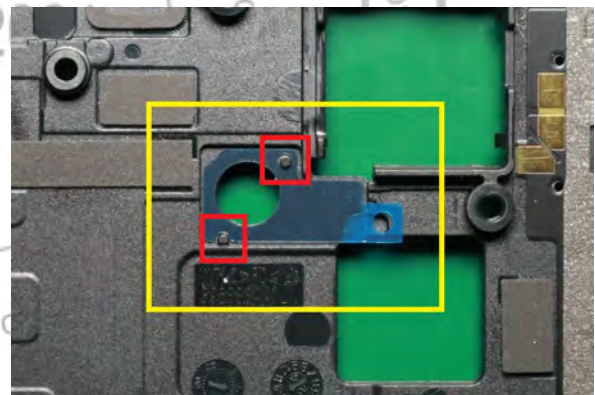
Use the Plastic Tweezer to place the Flash Board Adhesive on the location aligning with the pins as shown and peel off the liner.

**NOTE**

The Flash Board Adhesive should be pasted strictly in place.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



## Flash Board Assembly

Description	Reference #
ASSY,DTR BRD,Taipei BR FLSH PCBA ASSY,DTR BRD,FLSH,XT2435 CS	4
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6

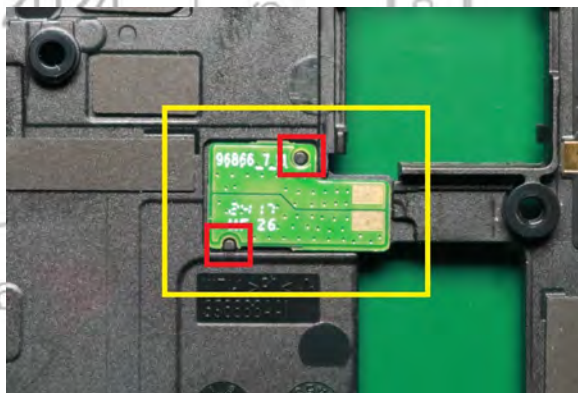
Use the Plastic Tweezer to place the Flash Board on the location aligning with the pins as shown.

### NOTE

The Flash Board should be assembled strictly in place. Improper installation will affect the flash light function of the phone.

### NOTE

Press firmly for seconds 3 times to activate the adhesive.



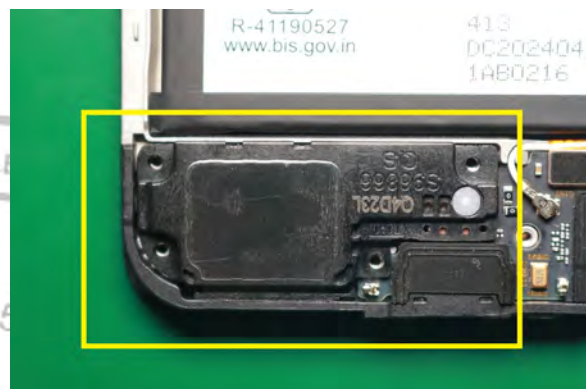
## Speaker Box Assembly

Description	Reference #
XT2363,TPLCM,70101387H001	1
WT710300101131+Horn BOX component 1217	13

Use the Plastic Tweezer to place the Speaker Box on the location as shown.

### NOTE

The Speaker Box should be assembled strictly in place. Improper installation will affect the sound function of the phone.



### NOTE

Insert the speaker box into the Sub Board at certain degrees.



## Fingerprint Sensor Assembly

Description	Reference #
HSG,FPS KIT,BLK,XT2435 CS HSG,FPS KIT,GRN,XT2435 CS HSG,FPS KIT,RED,XT2435 CS	5
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6

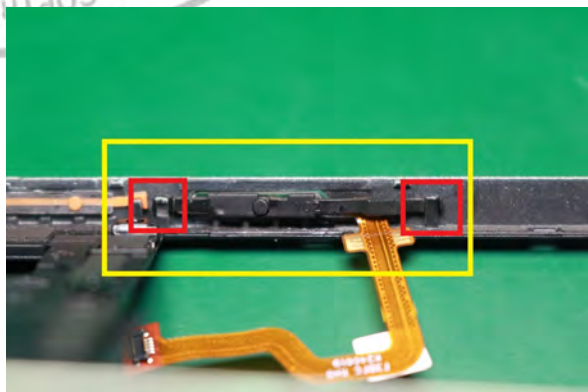
1. Pre-bend the Fingerprint Sensor to about 90 degrees as shown before assembly.



2. Use the Plastic Tweezer to place the Fingerprint Sensor on the location aligning with the pins as shown.

### NOTE

The Fingerprint Sensor should be assembled strictly in place. Improper installation will affect the fingerprint recognition of the phone.





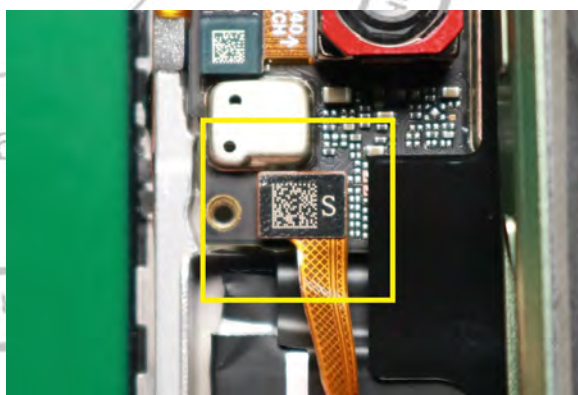
## Middle Frame Assembly

Description	Reference #
TPLCM,XT2435 CS	1
ASSY,BD KIT,Taipei BR 8+256 MB ASSY,BD KIT,8+256 DS,P+E,MX,XT2435 CS ASSY,BD KIT,8+256 SS,PorE,MX,XT2435 CS ASSY,BD KIT,8+256 DS,P+E,EU,XT2435 CS	2
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6
WT71090000721+Screw M1.4x3.2xT5Black;PG	20

1. Use fingers to place and secure the Fingerprint Sensor BtB connector on the location as shown.

**NOTE**

Align the interface before securing to avoid damaging the contacts.

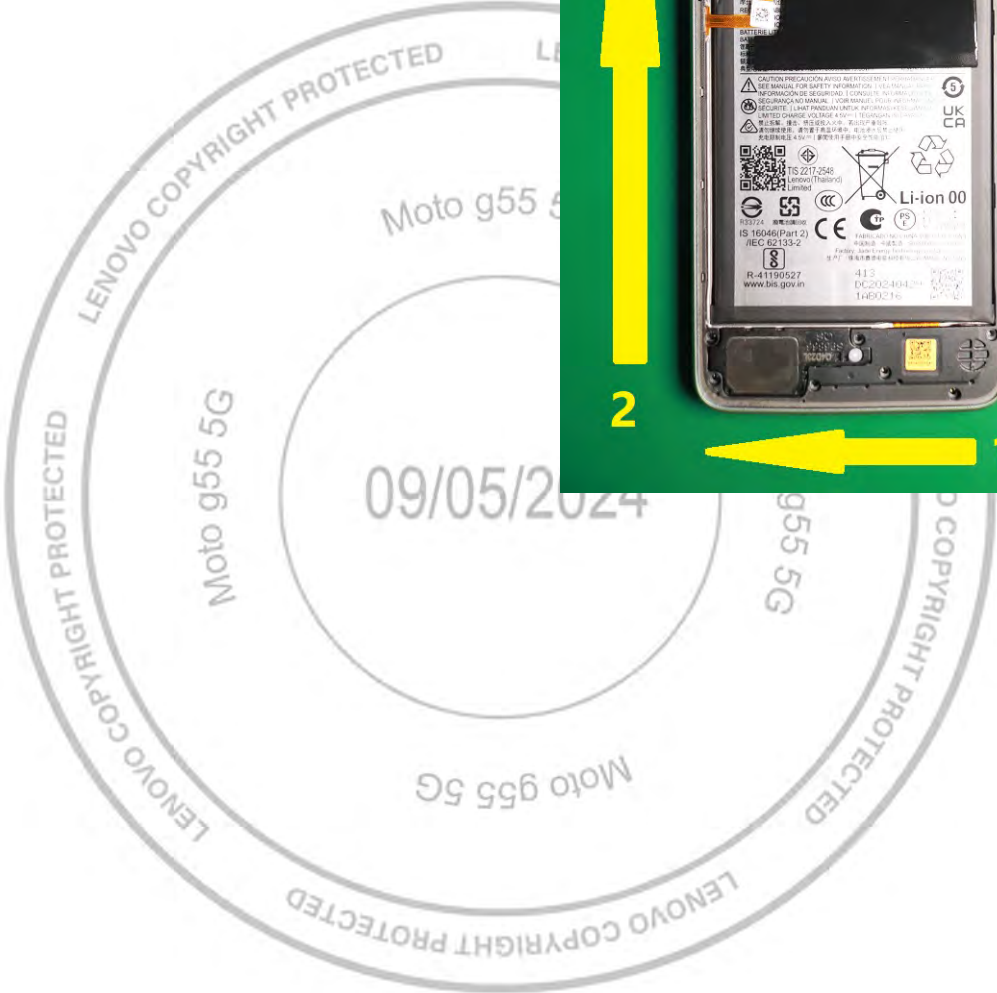




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2. Use fingers to place bottom of the Middle Frame and snap the buckles into place. Then, secure the Middle Frame in order of steps 1 to 4 as shown..

<b>NOTE</b>
Make sure all the buckles are snapped in place.



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3. Use Torque Driver with Torx Bit to tighten the 16 screws as shown (0.95±0.05 kgf-cm).

**NOTE**

The screws should not be over tightened or loosened. Improper twisting force may cause damage or components to fall out.



## Speaker Box Heat Spreader Assembly

Description	Reference #
ACCY,BAT,5000mAh,QA50,VK446590,Jaide ACCY,BAT,5000mAh,QA50,VK446590,Jaide,Lot	11
WT710300101131+Horn BOX component 1217	13
WT715001102011+BOX Thermal film_LS	37

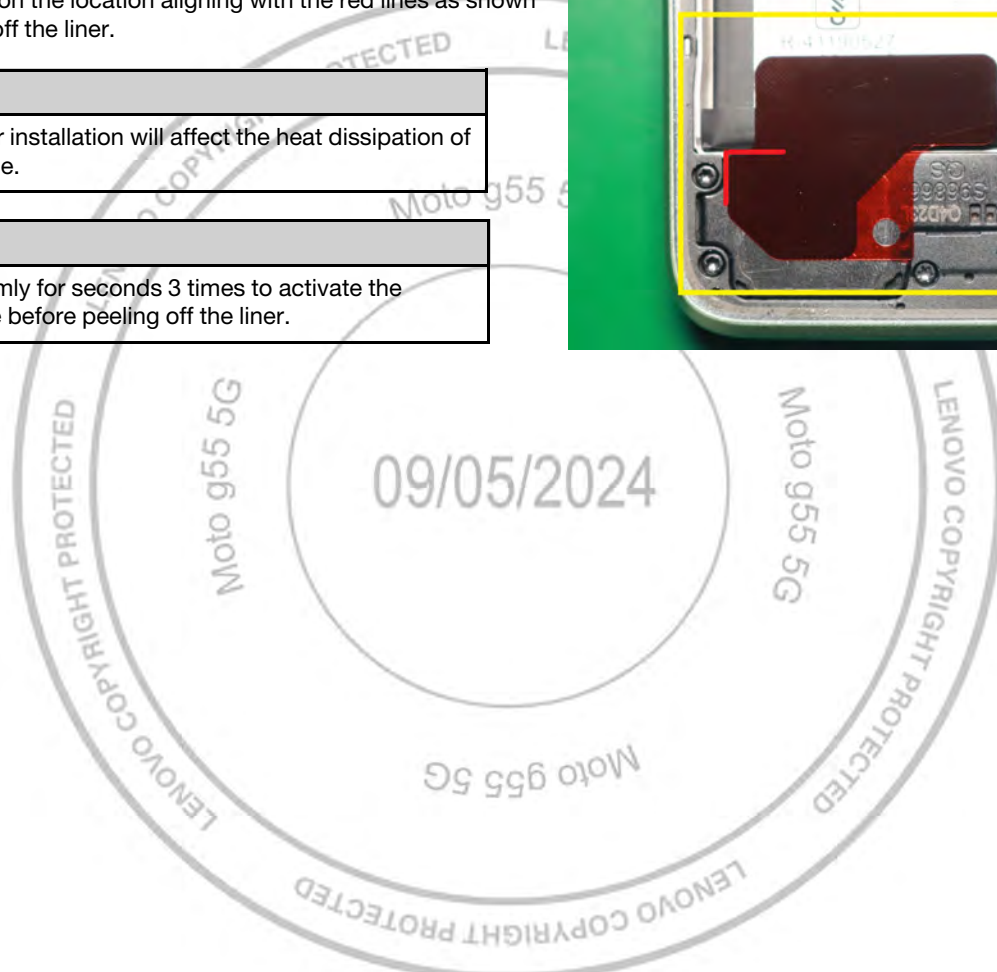
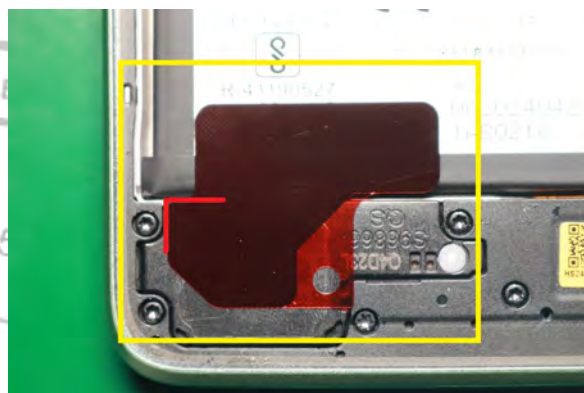
Use the Plastic Tweezer to place the Speaker Box Heat Spreader on the location aligning with the red lines as shown and peel off the liner.

**NOTE**

Improper installation will affect the heat dissipation of the phone.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



## PMMA Middle Frame Anti-shock Adhesive Assembly

Description	Reference #
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6
WT712101102111+Middle frame resonance gl	-

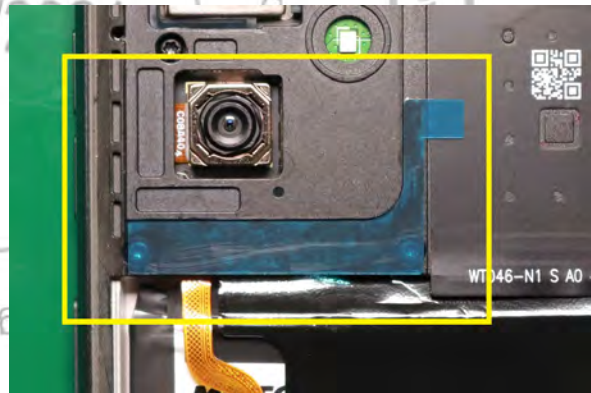
Use the Plastic Tweezer to place the PMMA Middle Frame Anti-shock Adhesive on the location as shown and peel off the liner.

**NOTE**

The PMMA Middle Frame Anti-shock Adhesive should be pasted strictly in place.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



## PU Middle Frame Anti-shock Adhesive Assembly

Description	Reference #
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6
WT712101102121+Middle frame resonance RE	-

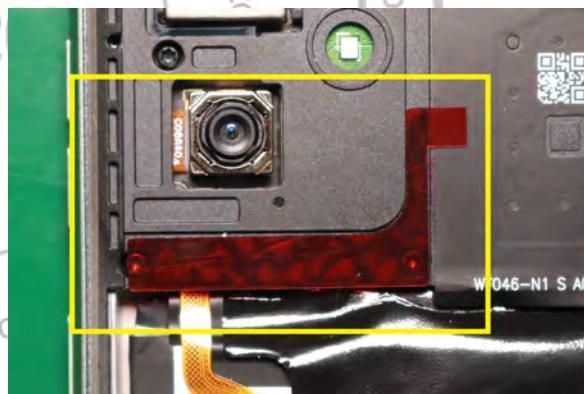
Use the Plastic Tweezer to place the PU Middle Frame Anti-shock Adhesive on the location as shown and peel off the liner.

**NOTE**

The PU Middle Frame Anti-shock Adhesive should be pasted strictly in place.

**NOTE**

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



## Inlay Bottom Small Adhesive Assembly

Description	Reference #
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6
WT712101014221+battery cover adhesive,YH	31

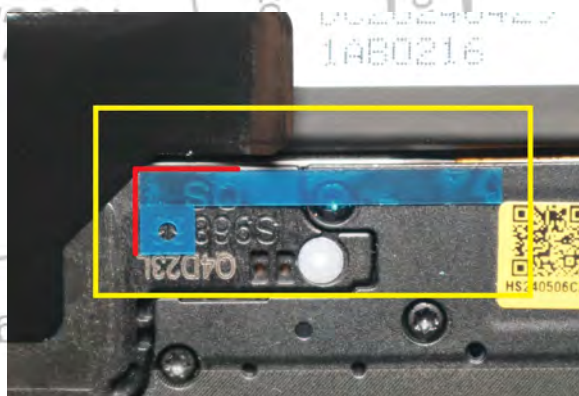
Use the Plastic Tweezer to place the Inlay Bottom Small Adhesive on the location as shown and peel off the liner.

### NOTE

The Inlay Bottom Small Adhesive should be pasted strictly in place.

### NOTE

Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



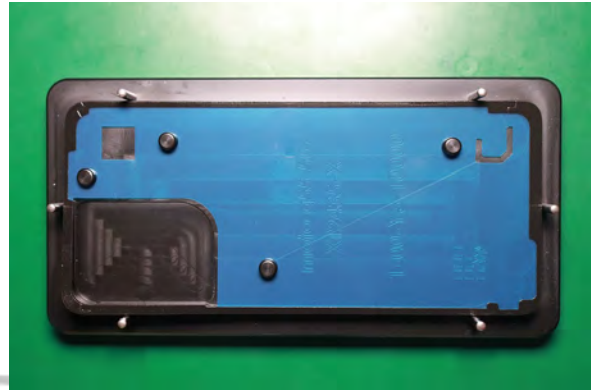
## PMMA & PU Battery Cover Assembly

Description	Reference #
TPLCM,XT2435 CS	1
HSG,MID FRM,BLK,ETCH,BR,XT2435 CS HSG,MID FRM,GRN,ETCH,BR,XT2435 CS HSG,MID FRM,RED,ETCH,BR,XT2435 CS HSG,MID FRM,BLK,XT2435 CS HSG,MID FRM,GRN,XT2435 CS HSG,MID FRM,RED,XT2435 CS HSG,MID FRM,BLK,ETCH,LA,XT2435 CS HSG,MID FRM,GRN,ETCH,LA,XT2435 CS HSG,MID FRM,RED,ETCH,LA,XT2435 CS HSG,MID FRM,BLK,ETCH,UK,XT2435 CS HSG,MID FRM,GRN,ETCH,UK,XT2435 CS HSG,MID FRM,RED,ETCH,UK,XT2435 CS HSG,MID FRM,BLK,ETCH,EU,XT2435 CS HSG,MID FRM,GRN,ETCH,EU,XT2435 CS HSG,MID FRM,RED,ETCH,EU,XT2435 CS HSG,MID FRM,BLK,ETCH,RS,XT2435 CS HSG,MID FRM,GRN,ETCH,RS,XT2435 CS HSG,MID FRM,RED,ETCH,RS,XT2435 CS HSG,MID FRM,BLK,ETCH,AP,XT2435 CS HSG,MID FRM,GRN,ETCH,AP,XT2435 CS HSG,MID FRM,RED,ETCH,AP,XT2435 CS	6
HSG,BAT CVR,BLK,PMMA,XT2435 CS HSG,BAT CVR,GRN,PU,XT2435 CS HSG,BAT CVR,RED,PU,XT2435 CS	7
WT712101102071+PMMA BATCVR ADH YH CS WT712101102081+PU BATCVR ADH YH CS	24

1. Peel off the liner of the Battery Cover Adhesive and use the Plastic Tweezer to position the Battery Cover Adhesive on the Battery Cover Adhesive Alignment as shown.

**NOTE**

PMMA Battery Cover Adhesive liner is blue. PU Battery Cover Adhesive liner is red.



2. Use fingers to place the Battery Cover on the Battery Cover Adhesive Alignment as shown.



3. Use fingers to press down the Battery Cover with the Battery Cover Adhesive Alignment as shown.

**NOTE**

Make sure to press the Battery Cover and the alignment at the same time.

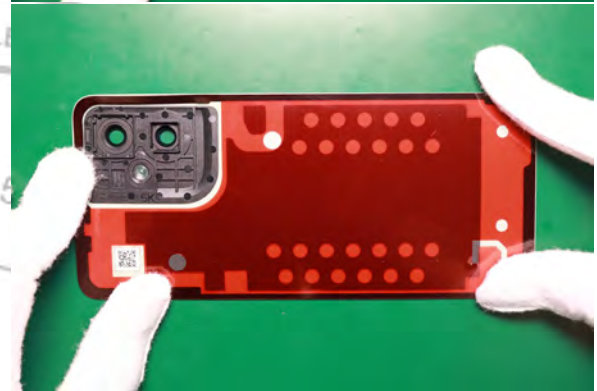




- Use fingers to press the surrounding Battery Cover Adhesive 3 times to activate it as shown and peel off the liner.

**NOTE**  
The Battery Cover needs to be pre-pressed 3 times along the back-adhesive area by hand in case the adhesive was removed with the liner.

**NOTE**  
PMMA Battery Cover Adhesive liner is blue. PU Battery Cover Adhesive liner is red.



- Use fingers to place the Battery Cover on the Middle Frame as shown.

**NOTE**  
Before attaching the Battery Cover to the Middle Frame, remove the camera protectors first.



- Power on pneumatic press system by press power switch to "ON" position.

**NOTE**  
Please read pneumatic press system user manual prior to operation.



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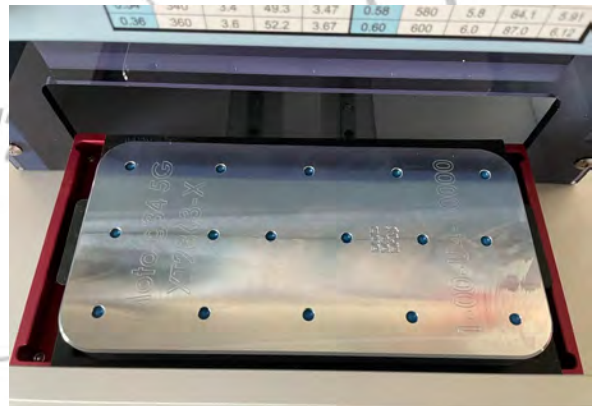
7. Assemble press rubber pad (1-00-Y4-10000) and generic inlay press holder(1-00-W1-10000) to inlay press fixture.



8. Pull out press drawer from chamber and place the phone onto the base rubber pad in pneumatic press system as shown.



9. Place the Inlay press fixture on top of the phone as shown.



10. Push the press system drawer into the chamber and set program to No.6 by press "Program" button repeatedly, check the "Pressure" (Mpa) shows "0.30" and "Time" (sec) shows "30" as shown.



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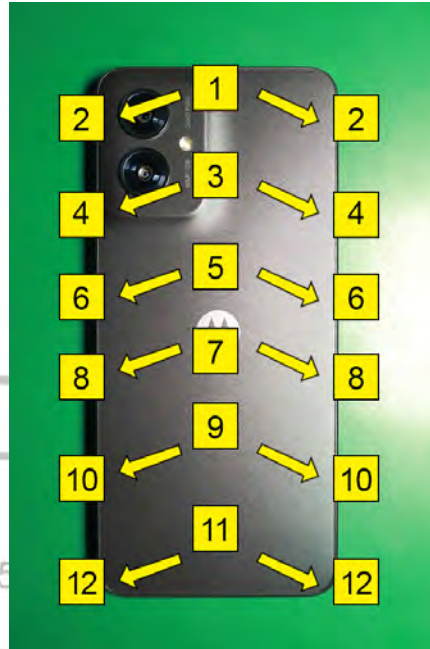
11. Press both of “Start” on the left and right side to initiate press process. Wait 30 seconds until process is finished.



12. Pull out the drawer from the press chamber, remove the Inlay press fixture, then take out the phone.



13. Apply manual pressure to the Battery Cover as follows:
14. Place both thumbs on point 1 (in middle of the Battery Cover) and slide them out to point 2.
15. Place both thumbs on point 3 and slide them out to point 4.
16. Place both thumbs on point 5 and slide them out to point 6.
17. Place both thumbs on point 7 and slide them out to point 8.
18. Place both thumbs on point 9 and slide them out to point 10.
19. Place both thumbs on point 11 and slide them out to point 12.



20. Place both thumbs on point 1 and slide them around the perimeter of the Battery Cover to point 2. Use fingers to press around the perimeter of the Camera bezel point 3 as shown.



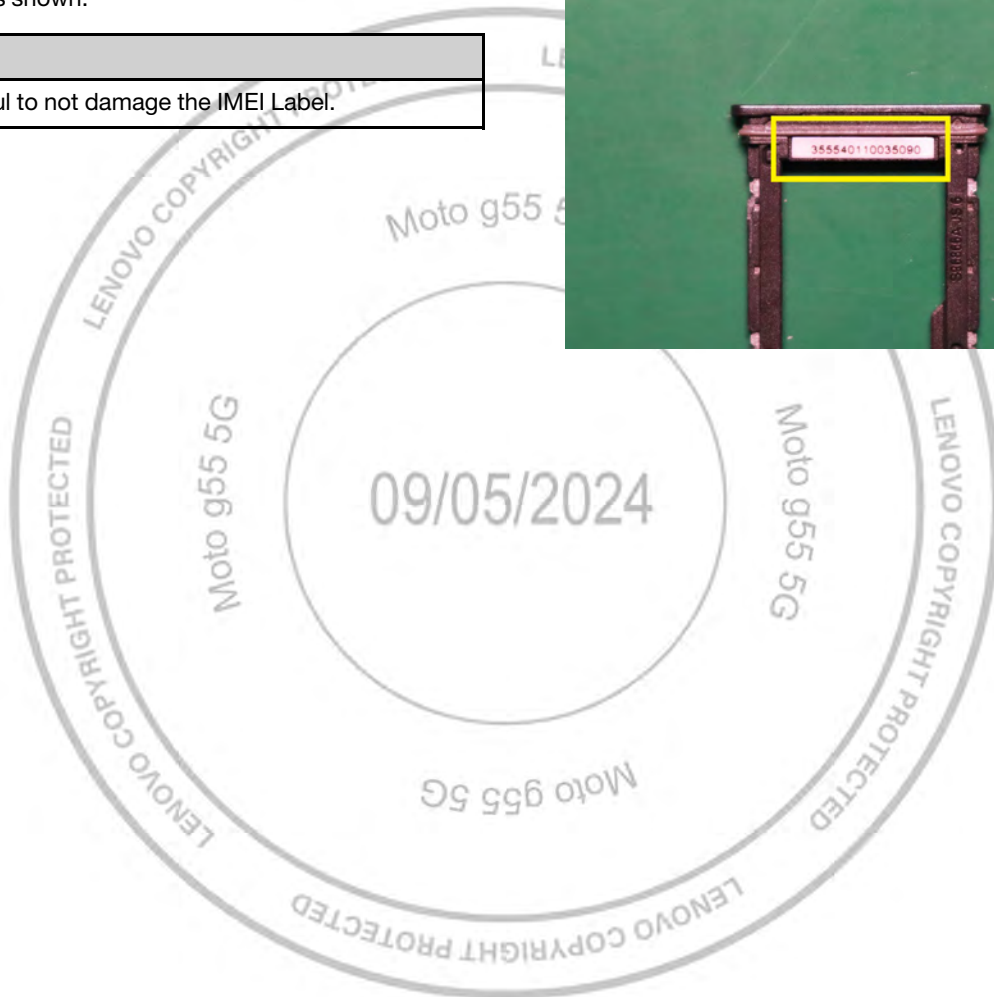
## IMEI Label Assembly

Description	Reference #
WT713001102011+single card tray,black sp WT713001102031+single card tray,light gr WT713001102041+single card tray,rose red	19
WT712700589051+IMEI label_35.6x27.6mm_QF	-

Use the Plastic Tweezer to place the IMEL Label on the location as shown.

**NOTE**

Be careful to not damage the IMEI Label.



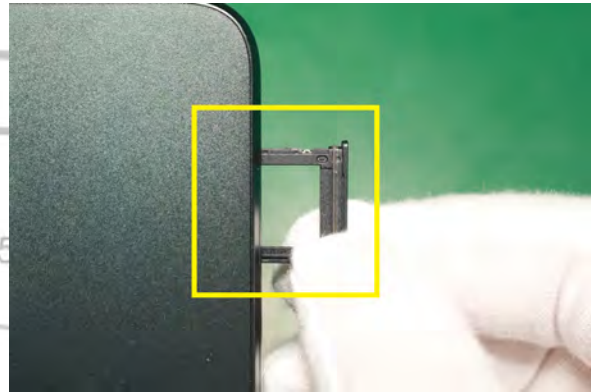
## SIM Tray Assembly

Description	Reference #
TPLCM,XT2435 CS	1
WT713001102011+single card tray,black sp WT713001102031+single card tray,light gr WT713001102041+single card tray,rose red	19

1. Insert the SIM Tray in the transceiver as shown.

**NOTE**

Do not shake the SIM Tray during the insertion.



2. Use finger to press the SIM Tray until it secures into the transceiver.

## Chapter 6. Assembly Quality check

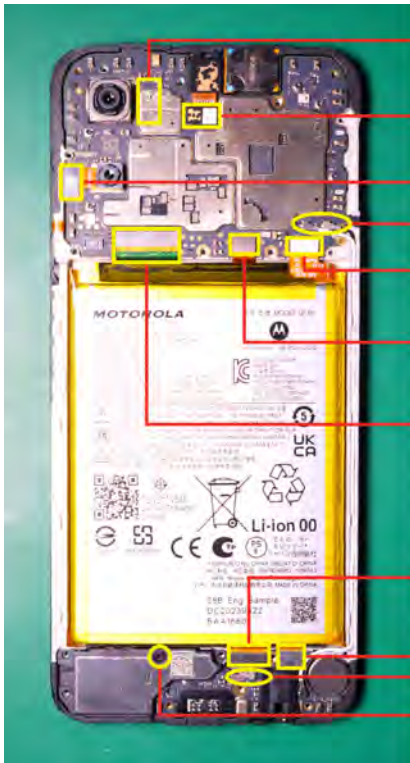
### Battery Quality Check



Check if battery adhesive is reused or with residue from the old one



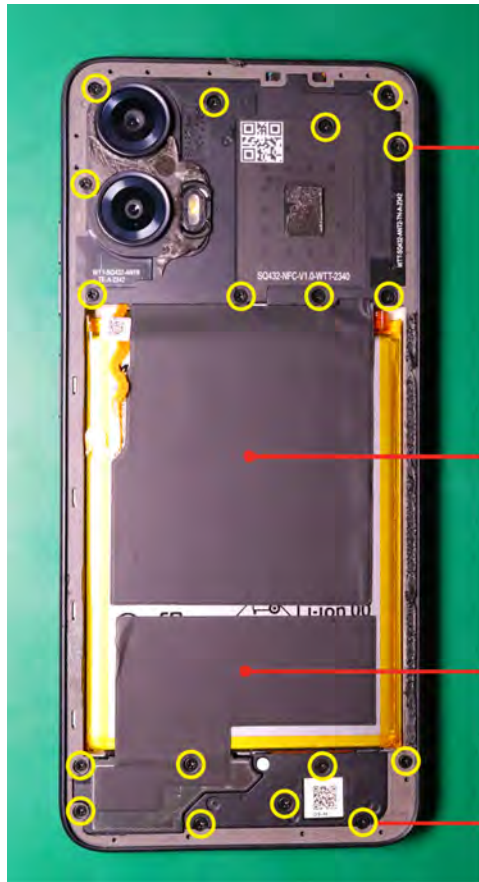
## Connector Quality Check



- Check if the rear facing camera connector is well-seated and there's no sign of damage.
- Check if the front facing camera connector is well-seated and there's no sign of damage.
- Check if the rear facing camera connector is well-seated and there's no sign of damage.
- Check if the battery connector is well-seated and there's no sign of damage.
- Check if the main flex connector is well-seated and there's no sign of damage.
- Check if the LCD connector is well-seated and there's no sign of damage.
- Check if the coax cable connector is well-seated and there's no sign of damage.
- Check if the LCD connector is well-seated and there's no sign of damage.
- Check if the main flex connector is well-seated and there's no sign of damage.
- Check if any missing/unseated screws.



## Screws Quality Check



Check if any missing/unseated screws.

Check if any missing/misaligned heat spreader.

Check if any missing/misaligned heat spreader.

Check if any missing/unseated screws.





## Chapter 7. Battery Safety Guidelines

Handle Battery with care. 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 or screwdrivers or any sharp tools 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.

Batteries should be handled with care to avoid damage to the cell (example: scratch, dent, puncture), insulation or protective circuit.

Mishandling or contact with foreign material may increase risk of swelling, rupture, burning, or other failure to function safely when used by the customer.

Do not puncture, deform, crush, or disassemble battery.

Do not shorten the connector leads, do not submerge in water, or expose to extreme temperatures.

If battery pack has leaking fluids, do not touch any fluids.



## Chapter 8. Guidance for Handling Lithium Ion Batteries

When handling devices with Li-Ion batteries, it is imperative to take basic precautionary measures and follow best practices. This guidance does not contain device-specific training procedures. Please refer to your internal organizational procedures or OEM training materials for device-specific battery replacement procedures.

Batteries that are swollen and/or have a crease, dent, puncture or other deformation shall be removed and replaced with a new battery. These batteries shall not be reused.

---

### Background

Like many consumer electronics devices, mobile devices contain Li-Ion batteries and sensitive electronic components that are designed to be serviced by qualified technicians. Li-Ion batteries are a safety-critical component of these devices and must be handled with care.

When fully or partially charged, Li-Ion batteries can combust if punctured, bent, dented or damaged. Basic best practices can minimize incidents with Li-Ion batteries. All appropriate measures to protect personnel against possible chemical, thermal, and/or explosion hazards shall be taken.

It is important to note that consumer do-it-yourself (DIY) battery replacement or repair kits, often made available via third parties, do not ensure safety-critical best practices. Some may not adhere to basic lithium battery design requirements, although form and fit criteria are met. It is very important to use battery packs approved by the OEM.

Technicians who perform device repairs shall be properly trained and provided with the appropriate tools, components and work instructions. Careless work during a repair, or the use of improper components, can lead to safety risks including battery thermal events.

The batteries used in most modern devices are contained in a soft pouch protected by the outer enclosure of the device. When the device enclosure is opened for a repair, the battery can be damaged by tools or other components making contact with the battery. Damaging the battery can create a safety risk.

It is highly recommended and in many cases an OEM requirement to replace a soft pouch battery that has been removed from a device, as the removal process could damage the battery. A removed battery, including those "harvested" from other devices, does not provide the same guarantee of quality and safety as a new battery.

Use the highest quality components/batteries available along with proper tools.

Any repair requiring the removal of screws or other components shall be carefully performed to ensure that loose screws or misaligned components are not left inside a device. Loose screws or misaligned components can damage the battery and potentially lead to a battery thermal event.

Appropriate final testing according to each organization's internal processes and procedures shall be done to ensure the quality and safety of any repair. Best practices including checking and re-checking your work will ensure these standards are met.

---

### Battery Service: Required Equipment

Technicians shall possess the following equipment for working on Li-Ion batteries:

- Neoprene or nitrile gloves (EN 374) or equivalent
- Heat-resistant gloves
- Safety glasses
- Cleaning wipes (to clean safety glasses)
- 8-10 cups of clean, dry, untreated sand, stored in a container as specified below
- Wide-mouth non-breakable plastic quick-pour sand container with a flip-top lid
  - The sand container shall be within arm's reach (2 ft. or 0.6 m), on either side of the workstation, for immediate access during an unexpected thermal event. It shall not be stored above or below the workstation.
- Hand broom with dustpan
- Existing ESD bags or re-sealable, plastic disposal bags, and boxes
- Yellow fireproof safety cabinet
- Re-sealable aluminized bags
- Voltmeter and appropriate wiring

---

## Battery Service: Precautions, Training and Handling Guidelines

Technicians shall follow these precautions and guidelines when working on Li-Ion batteries:

- Wear safety glasses whenever handling batteries.
- Remove jewelry items such as rings, wristwatches, pendants or any other loose wearable items that could come in contact with the battery terminals.
- Always inspect Standard Operating Procedures (SOP) prior to disassembly to ensure the proper temperature guidelines are followed when disassembling devices.
- Do not handle battery packs if they feel warm or hot to the touch or look deformed, included, but not limited to, swollen, crushed, have breached.
- Do not attempt to handle a venting battery or device containing one.
- All swollen, creased, dented, punctured or otherwise deformed batteries shall be processed in accordance with appropriate SOP.
- Handle batteries with signs of leakage in a well-ventilated area.
- Always have all safety equipment available (quick-pour sand container, ABC fire extinguisher, fire safety gloves and dedicated Li-Ion battery containment device) when disassembling or processing devices with internal soft-pouch batteries.
- Cover all metal work surfaces with an insulating material (ESD mat). Work areas shall be kept clean and free of metal or sharp objects that could short the contacts, or puncture or damage the cover to the battery.
- All tools shall be made of ESD material with no sharp edges in order to prevent dents and punctures.
- Promptly dispose of used batteries in accordance with local regulations.

## Battery Safety Training

Every technician handling batteries, regardless of their skill level, shall complete battery safety training that includes the best practices described in this document. Training shall take place on a regular basis, with the recommended frequency being once a year. It is also recommended to undergo training if and when an unfamiliar battery pack design or chemistry is to be handled.

## Battery Handling

Technicians shall follow these key handling and safety points when working on Li-Ion batteries. Some can be dangerous to the persons carrying them out. All appropriate measures to protect personnel against possible chemical, thermal, and/or explosion hazards shall be taken.

- Do not subject batteries or battery-powered devices to high levels of force.
- All appropriate measures to protect personnel against possible chemical, thermal, and/or explosion hazards shall be taken.
- Excessive force shall not be used to free a battery lodged inside the housing.
- Check for proper fit before inserting the battery into any type of housing.
- Batteries shall not be forced into the battery cavity.
- Do not expose Li-Ion batteries to liquids.
- Only use inspection tools (such as calipers and rulers) that are made from, or covered with, a non-conductive material.
- Properly connect the battery in the electronic device, charger or testing equipment.
- Use only certified chargers. Non-certified chargers may not properly charge or may over-charge a battery, causing swelling.
- Discharge battery only in an approved device.
- Do not short circuit the battery.
- Do not directly solder a battery.
- Never attempt to open a battery.
- Never attempt to repair a battery.
- Remove batteries from a device that will not be used for an extended period of time (if possible).
- Do not reuse soft-pouch batteries.

If something unusual is noticed, stop using the battery. If the battery or battery-powered device gives off an unusual odor, overheats, vents, sparks, is discolored, deformed or reacts unusually in any way during use, recharging or storage, remove it from the device or battery charger and discontinue use.

- Never use a battery if it is swollen, dented, creased, punctured.
- Keep metal tools away from batteries.
- **NEVER USE WATER TO PUT OUT A BATTERY FIRE.** Only use an ABC fire extinguisher and Li-Ion battery containment device with sand.
- **The most effective way to stop a thermal runaway (battery fire) is by smothering the battery or device immediately with plenty of clean, dry sand, dumped all at once from the quick-pour container. Also have immediate access to an ABC-type fire extinguisher in the event the reaction is not contained by the sand.**

## New Battery Installation

The service provider shall follow this guidance when working with new Li-Ion battery assemblies:

- Follow the provided work instructions.
- When required to remove a battery that is installed in a device using adhesive, always use new battery adhesives to install the replacement battery. Reusing the adhesive left on the housing could lead to the battery coming loose and may cause safety issues.
- Before placing new adhesive, completely remove and clean any residue left on the housing using isopropyl alcohol or other suitable solvent before placing new adhesive.

- Never place a new adhesive on top of existing adhesive since it increases the height and could cause interference with the internal space or battery cavity.
- Ensure proper alignment of the adhesive to the housing surface is critical for proper bonding strength.
- Do not use clamps to hold the battery pack in place during the rework process.
- Ensure proper use of press and hand roller so that adhesive properly bonds to the housing and battery. Insufficient bonding may cause the battery to loosen, resulting in safety issues.
- Some batteries may require application of pads and/or tape after assembly; follow provided work instructions to attach protective materials.
- Inspect the housing to ensure no sharp edges contact the battery.
- Inspect battery flex or cable for signs of damage.
- Inspect the connectors on the battery flex/cables and board to ensure they are not damaged or corroded.
- Proper alignment of the battery to the housing surface is critical for safety.
- Do not place labels on the battery unless required by the OEM.
- Ensure the battery connector is properly connected to the board.
- Secure all battery connectors and the battery pack itself by using properly placed adhesive tape and wraps. This should be clearly explained in the work instruction.

## Storage Guidelines

Technicians shall follow these Li-Ion battery storage guidelines:

- Store batteries in a well-ventilated, dry area. The storage temperature shall be between -4° F (-20° C) and 113° F (-45° C), or according to the battery manufacturer's guidelines.
  - Lithium ion batteries function best in the temperature range of 32° to 95° F (0° to 35° C)
- Store batteries in an isolated area, away from combustible materials and preferably in a fireproof safety container.
- Store lithium batteries in their original protective cases, padding and boxes.
- Do not compress or force batteries into boxes if they do not fit.
- Store used batteries in a separate location from new batteries.
- Make sure to place only one battery in each box or pad, exactly as provided by the manufacturer.
- Any Li-Ion battery storage area shall have immediate access to a quick-pour sand container with sand, an ABC fire extinguisher and a Li-Ion battery containment device.
- Never stack heavy objects on top of boxes containing Li-Ion batteries and take necessary precautions to avoid crushing or puncturing the cell case. Severe damage may potentially lead to hazardous chemical release or a battery thermal event.
- Minimize the number of Li-Ion battery boxes that are stacked on top of each other.
- Do not allow excessive quantities of batteries to accumulate in any storage area.

## Battery Recycling and Shipment

Technicians shall source a recycling provider and adhere to their prescribed shipping procedures. The recycler shall have appropriate certifications including R2.

To find the list of R2 recyclers, reference <https://sustainableelectronics.org/recyclers>.

Li-Ion batteries are dangerous goods and can pose a safety risk if not prepared and shipped in compliance with international transport regulations. Technicians shall follow the IATA Lithium Battery Shipping Regulations (LBSR) Guide when shipping Li-Ion batteries.



## Employee Emergency Action Plan

The service provider shall have an employee emergency action plan documented and communicated to technicians. Technicians shall be familiar with their organization's employee emergency action plan.

## First Aid Procedures

The service provider shall have first aid equipment on-hand at all times and documented procedures for handling incidents.





## Chapter 9. Broken Glass Handling Guide

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### Important

The displays and some of inlay are made of glass. The glass could break if the phone is dropped on a hard surface, receives a substantial impact, or is crushed, bent, or deformed.

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### Cautions and Warnings

Don't attempt to remove chipped or cracked glass shards.

Put on safety glasses with side shields and the cut-resistant gloves.

Use a vacuum cleaner to remove glass pieces from your workspace and phone.





## Chapter 10. Disassembly Depth

#	Back cover	Battery	Front-Facing Camera
1	"Step 1" on page 16	"Step 1" on page 16	"Step 1" on page 16
2	"Step 2" on page 17	"Step 2" on page 17	"Step 2" on page 17
3	"Step 3" on page 18	"Step 3" on page 18	"Step 3" on page 18
4		"Step 4" on page 13	"Step 4" on page 13
5		"Step 5" on page 29	"Step 5" on page 29
6		"Step 6" on page 30	"Step 6" on page 30
7		"Step 7" on page 30	"Step 7" on page 30
8		"Step 8" on page 50	"Step 8" on page 34
9		"Step 9" on page 51	"Step 9" on page 39
10			"Step 10" on page 41

#	Rear-facing camera	External charging port	Main microphone(s)
1	"Step 1" on page 16	"Step 1" on page 16	"Step 1" on page 16
2	"Step 2" on page 17	"Step 2" on page 17	"Step 2" on page 17
3	"Step 3" on page 18	"Step 3" on page 18	"Step 3" on page 18
4	"Step 4" on page 13	"Step 4" on page 13	"Step 4" on page 13
5	"Step 5" on page 29	"Step 5" on page 29	"Step 5" on page 29
6	"Step 6" on page 30	"Step 6" on page 30	"Step 6" on page 30
7	"Step 7" on page 30	"Step 7" on page 30	"Step 7" on page 30
8	"Step 8" on page 34	"Step 8" on page 42	"Step 8" on page 42
9	"Step 9" on page 35	"Step 9" on page 43	"Step 9" on page 43
10.	"Step 10" on page 36	"Step 10" on page 45	"Step 10" on page 45
11.	"Step 11" on page 37		

#	Speaker	Display assembly	Mechanical buttons
1	"Step 1" on page 16	"Step 1" on page 16	"Step 1" on page 16
2	"Step 2" on page 17	"Step 2" on page 17	"Step 2" on page 17
3	"Step 3" on page 18	"Step 3" on page 18	"Step 3" on page 18
4	"Step 4" on page 13	"Step 4" on page 13	"Step 4" on page 13
5	"Step 5" on page 29	"Step 5" on page 29	"Step 5" on page 29
6	"Step 6" on page 30	"Step 6" on page 30	"Step 6" on page 30
7	"Step 7" on page 30	"Step 7" on page 30	"Step 7" on page 30

#	Speaker	Display assembly	Mechanical buttons
8	"Step 8" on page 42	"Step 8" on page 34	"Step 8" on page 32
9		"Step 9" on page 35	"Step 9" on page 34
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