Lenovo

Moto C Plus

Lenovo Moto C Plus

Level 2 – Service and Repair Manual

REVISION HISTORY

Revision	*Date*	*Notes*
1	05/23/2017	Initial release.

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SAFETY INFORMATION

Cautions and Warnings

Electrostatic Discharge

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

Battery Safety Guidelines

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

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

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

Soldering Safety Guidelines

Handle the Soldering Iron with care. Staff engaged in soldering tasks not involving BGA components must be trained and work in accordance with the requirements of IPC-A-610 and IPC-7711, and work in accordance with J-STD-001.

Ensure that the components used for electrical repair meet the following requirements:

- Solder paste is tin- and lead-free.
- Solder wire is lead-free.
- Flux, whether liquid or gel, is No Clean RMA flux.

INTRODUCTION

External Views

Figure 1. External Views

Table 1. External Views Parts List

Reference #	*Description*
1	Headset Jack
2	USB Port
3	Front Flash
4	Earpiece Speaker
5	Front-Facing Imager
6	Display
7	Volume Key
8	Power Key
9	Front Housing
10	Rear-Facing Imager
11	Rear-Facing Imager Lens
12	Flash Lens
13	Battery Cover
14	Loudspeaker

Exploded Views

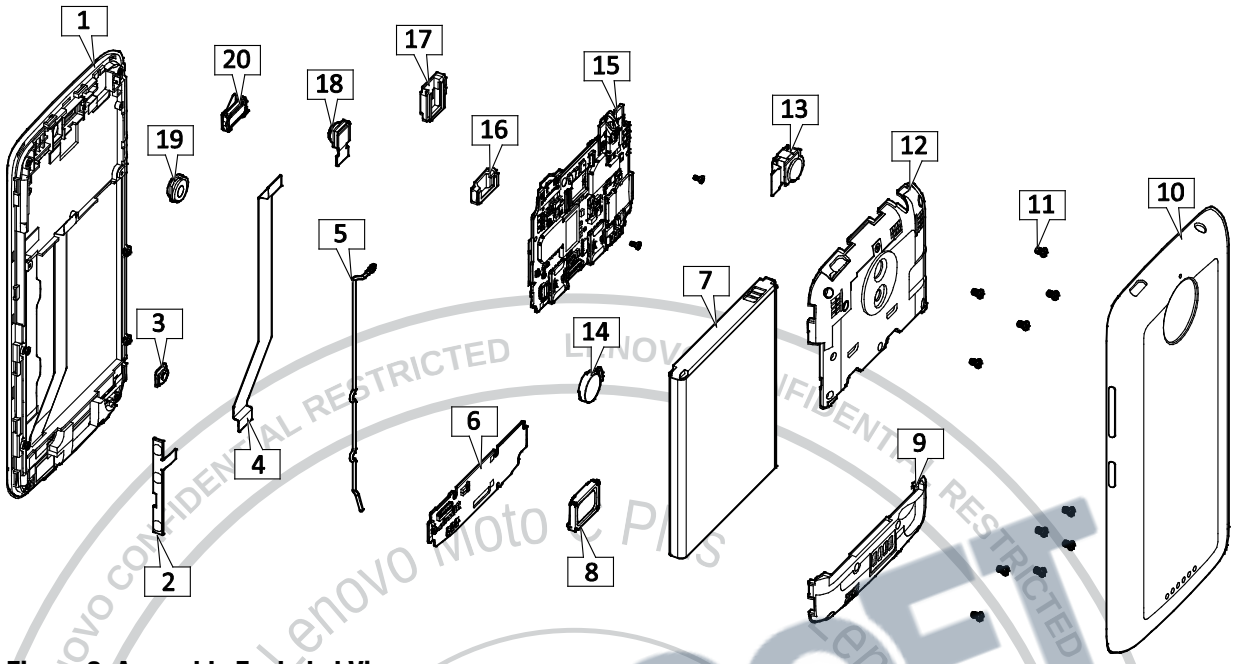


Figure 2. Assembly Exploded View

Table 2. Assembly Exploded View Parts List

Reference #	*Description*	*Recovery Part*
1	XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	YES
2	WD+69100100069S71+SIDEKEY FPC	NO
3	WD+50240100071S71+Main MIC Rubber	YES
4	WD+69500100039S71+MAIN FPC	YES
5	WD+53340100039S71+COAXIAL CABLE	YES
6	XT1724 Sub Board&*72500100202 CS XT1721 Sub Board&*72500100198 CS	YES
7	Po:HC60;CS556070;SWD;4000mAh;WW	YES
8	WD+25200100025S71+SPK	NO
9	XT1724 SubBoard Cover&*72600100212 CS XT1721 SubBoard Cover&*72600100211 CS	YES
10	XT172X BatteryCover GL&*72600100203 CS XT172X BatteryCover RD&*72600100205 CS XT172X BatteryCover WH&*72600100204 CS XT172X BatteryCover BL&*72600100206 CS	YES
11	WD+44100100074S71+Scross Screw	NO

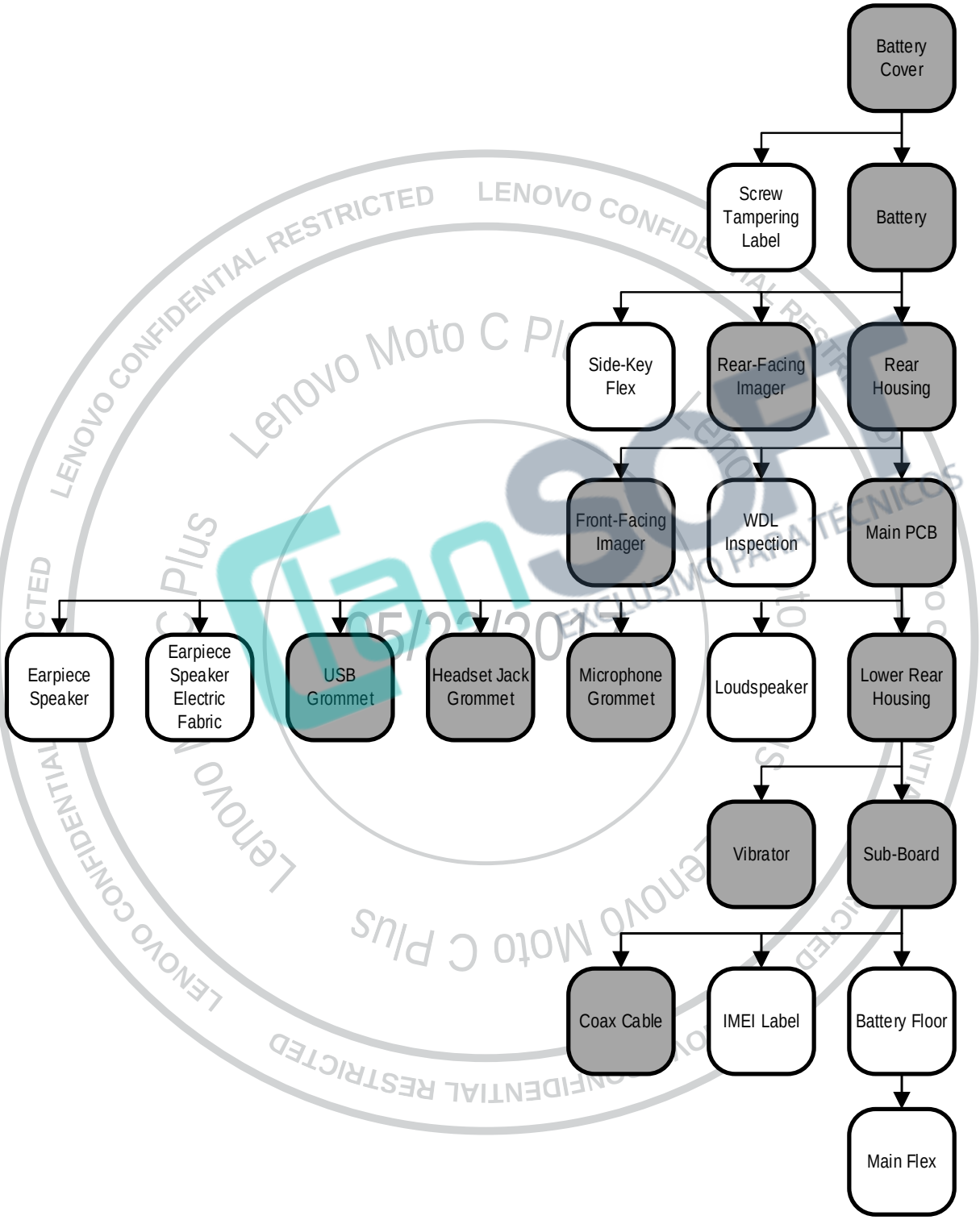
Reference #	*Description*	*Recovery Part*
12	XT1724 Rear Cover D_SIM&*72600100210 CS XT1724 Rear Cover S_SIM&*72600100209 CS XT1721 Rear Cover S_SIM&*72600100208 CS XT1721 Rear Cover D_SIM&*72600100207 CS	YES
13	MDL,CAMR,8MP,L4H8A10 O-FILM 30pin MDL,CAMR,8MP,F4H8CAZ Q-TECH 30pin	YES
14	WD+25220100025S71+MOTOR	YES
15	XT1723 D_SIM MB 2+16G&*72500100197 CS XT1723 D_SIM MB 1+16G&*72500100199 CS XT1723 S_SIM MB 1+16G&*72500100200 CS XT1723 Tesco SSL MB 1+16G&*72500100226CS XT1721 D_SIM MB 1+16G&*72500100201 CS XT1724 D_SIM MB 1+16G&*72500100203 CS XT1725 S_SIM MB 1+16G&*72500100204 CS XT1725 GT SSL MB 1+16G&*72500100206 CS XT1725 TIGO SSL MB 1+16G&*72500100207 CS ASSY,BD KIT,XT1726,BR,8+1,DTV,DS,CKD	YES
16	WD+50240100075S71+USB Cover Rubber	YES
17	WD+50240100073S71+Headest Rubber	YES
18	WD+25410100064S71+Front camera	YES
19	WD+50240100077S71+F CAM CoverRubber	YES
20	WD+25240100003S71+Receiver	NO
--	WD+54250100040S71+Earphone	YES
--	WD+54320100069S71+2A USB Cable NA woven	YES
--**	WD+56600100081S71+SPK ELECTRIC FABRIC	NO
--	WD+58500010300S71+WATERPROOF LABEL	NO
--	WD+56600100101S71+F CAM ELEC FABRIC	NO
--	WD+73150100080S71+IMEI label	NO
--	WD+58500100069S71+Tamper Evidence Label	NO
--	WD+73170100202S71+Battery compartment la	NO

*Refer to this table as a reference to parts listed in the Assembly section.

**This part is used only in Brazil

DISASSEMBLY

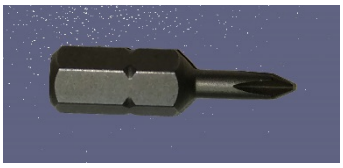
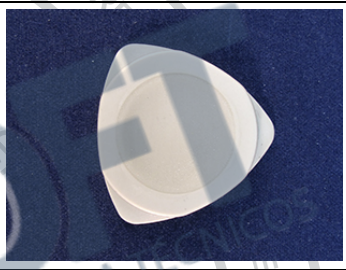
Disassembly Map



*Shaded parts may be eligible for parts recovery.

Tools Required for Disassembly

The following tools are required to disassemble the Moto C Plus.

Description	*Part #*	*Picture / Drawing*
Blackstick	--	
JCIS #0 Bit	--	
Torque Driver (Adjustable)	--	
Shim	4-00-5L-10000	
Thin Plastic Spudger	0-00-00-40826	
Soldering Iron	--	--
Tweezers (Plastic or Plastic-Tipped)	--	--
Tweezers (Metal)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--
Isopropyl (ISP) Alcohol	--	--

Battery Cover Removal

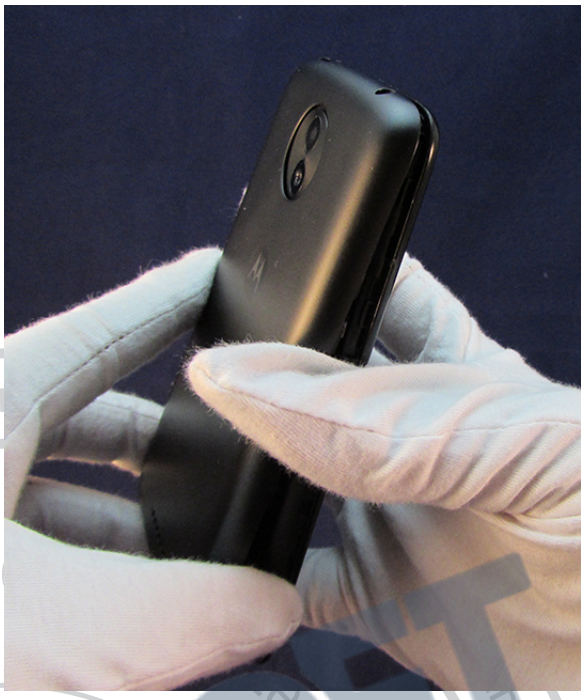
NOTE

The Battery Cover can be recovered and reused after removal.

1. Starting at the cutout in the bottom right of the phone, use the Shim to disengage the Battery Cover snaps from the Front Housing.

2. Continue to disengage the Battery Cover snaps around the edges of the phone.

3. After the Battery Cover snaps have been disengaged, lift the Battery Cover away as shown, to remove it from the Front Housing.



Battery Removal

/// WARNING ///

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

// CAUTION //

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

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

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

Ensure screws and screwdrivers do not contact the Battery.

NOTE

The Battery can be recovered and reused after removal.

1. From the recess at the bottom of the Battery, press upwards on the Battery to release it from the Front Housing.

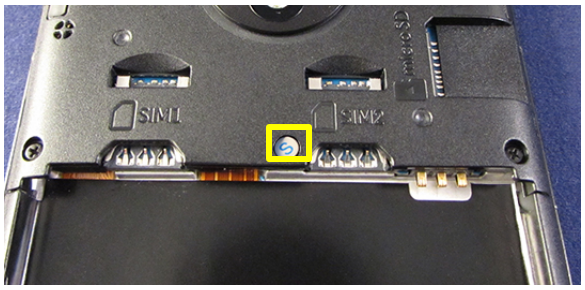
2. Lift the Battery out of the pocket in the Front Housing.

Screw Tampering Label Inspection

NOTE

If a Screw Tampering Label is damaged, the phone's warranty no longer applies.

Inspect the Screw Tampering Label on the Rear Housing. Verify that it is correctly placed, and examine it for signs of tampering.

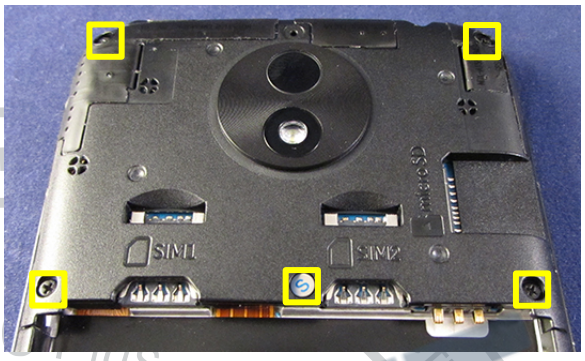


Rear Housing Removal

NOTE

The Rear Housing can be recovered and reused after removal.

1. Use the Torque Driver and JCIS #0 Bit to remove the 5 JCIS #0 Machine Screws from the Rear Housing.

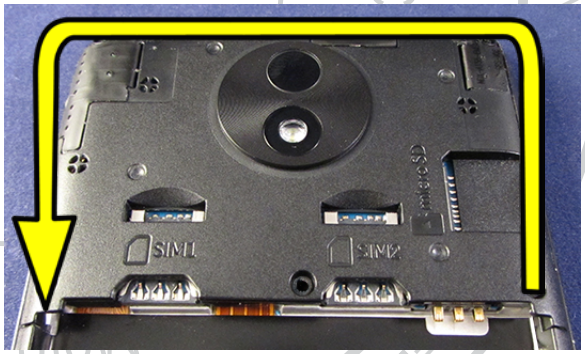


NOTE

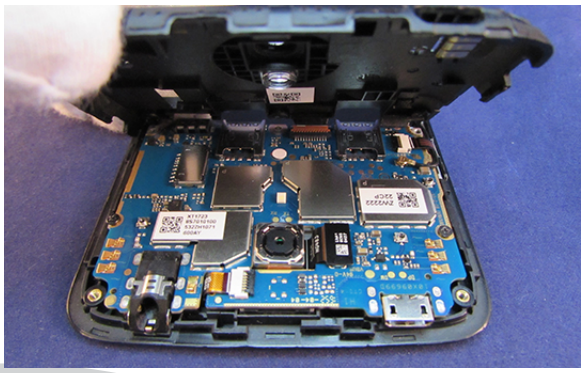
After you remove the JCIS #0 Machine Screws, you cannot reuse them.

2. Insert the Shim in the cutout near the USB Port and pry the Rear Housing from the Front Housing.

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



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

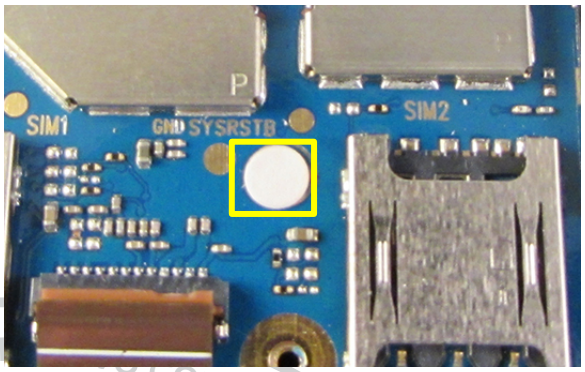


Water Detection Label Inspection

NOTE

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

Inspect the WDL, which is on the Main PCB as shown. Verify that it is correctly placed and examine it for signs of activation.

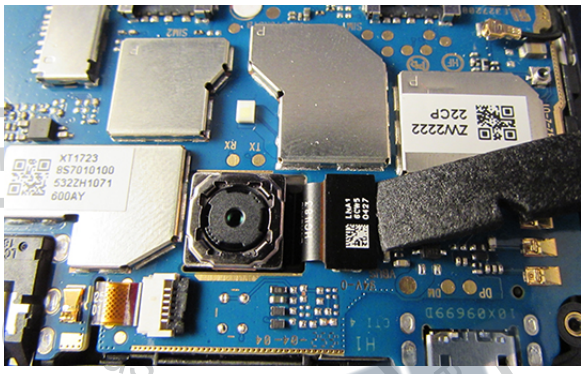


Rear-Facing Imager Removal

NOTE

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

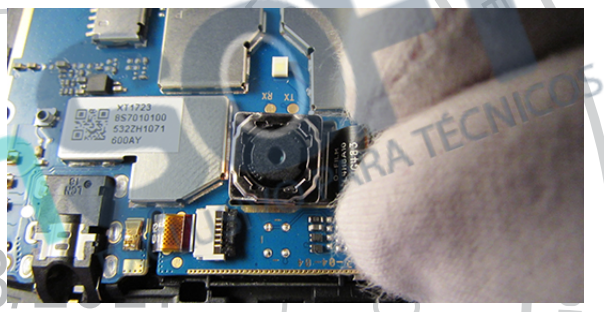
1. Use the flat end of the Blackstick to disconnect the Rear-Facing Imager BtB Connector from the Main PCB.



// CAUTION //

When lifting the Rear-Facing Imager BtB Connector, leverage the Blackstick against the Main PCB at the location shown. Damage to the Rear-Facing Imager or Main PCB may occur if the Blackstick is leveraged against any other area.

2. Use your fingers to lift the Rear-Facing Imager out of the pocket on the Main PCB.

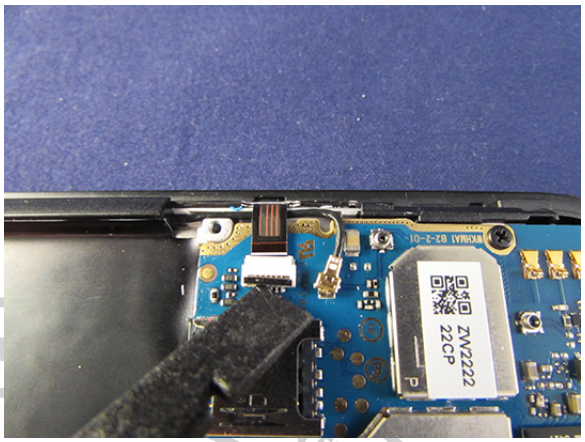


Main PCB Removal

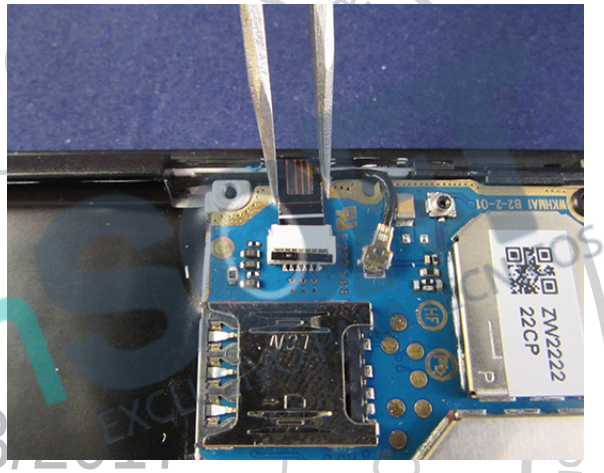
NOTE

The Main PCB can be recovered and reused after removal.

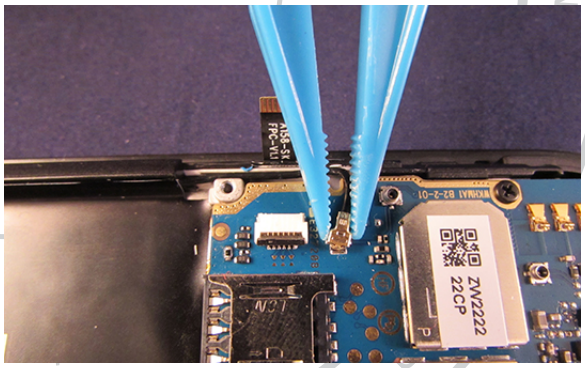
1. Use the flat end of the Blackstick to open the Side-Key Flex ZIF Connector Door on the Main PCB.



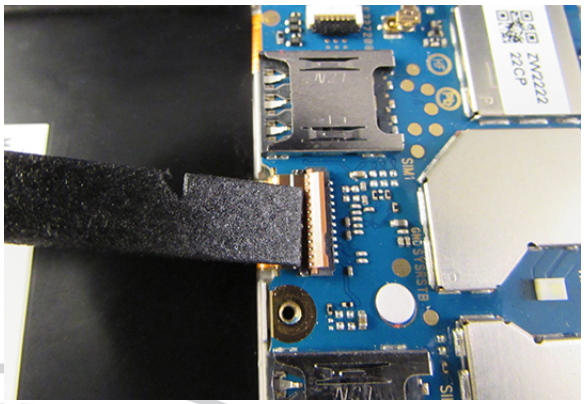
2. Use the Tweezers to disconnect the Side-Key Flex from the Side-Key ZIF Connector.



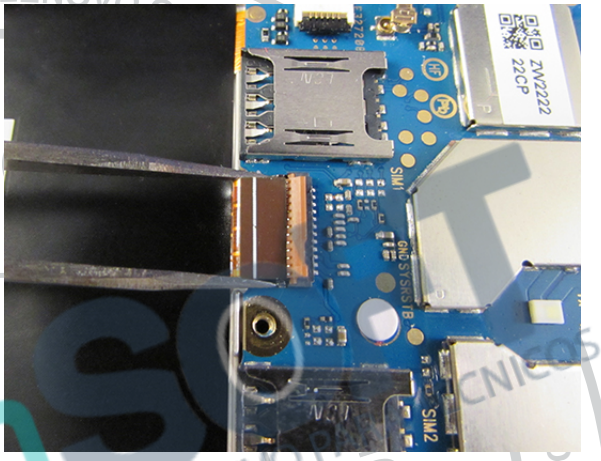
3. Use the Plastic Tweezers to disconnect the Coax Cable from the Main PCB.



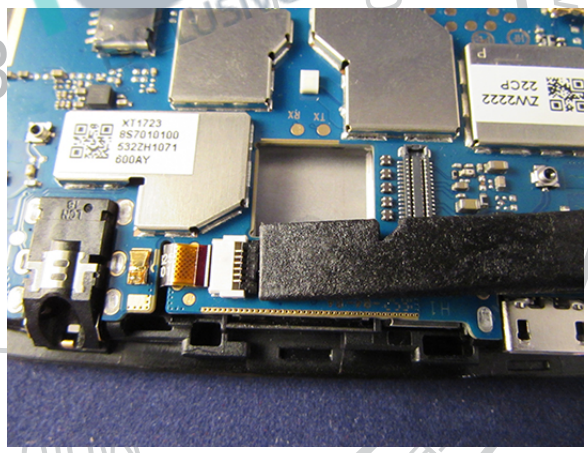
4. Use the flat end of the Blackstick to open the Main Flex ZIF Connector Door.



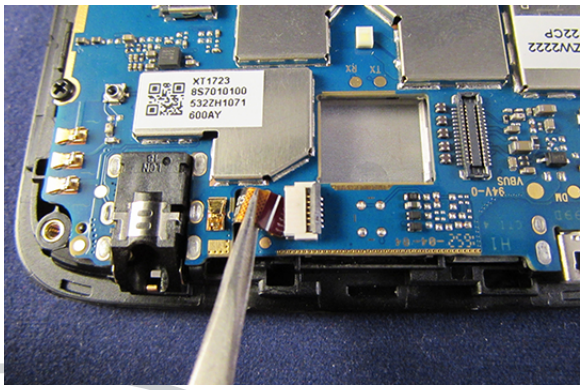
5. Use the Tweezers to disconnect the Main Flex from Main Flex Connector.



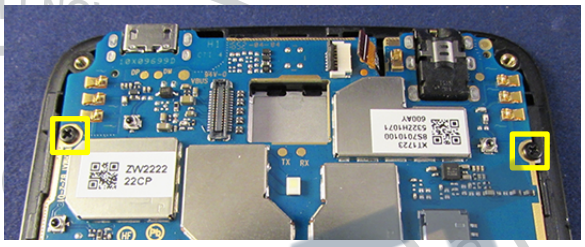
6. Use the flat end of the Blackstick to open the Touch Sensor Flex ZIF Connector Door.



7. Use the Tweezers to disconnect the Touch Sensor Flex from the Touch Sensor Flex Connector.



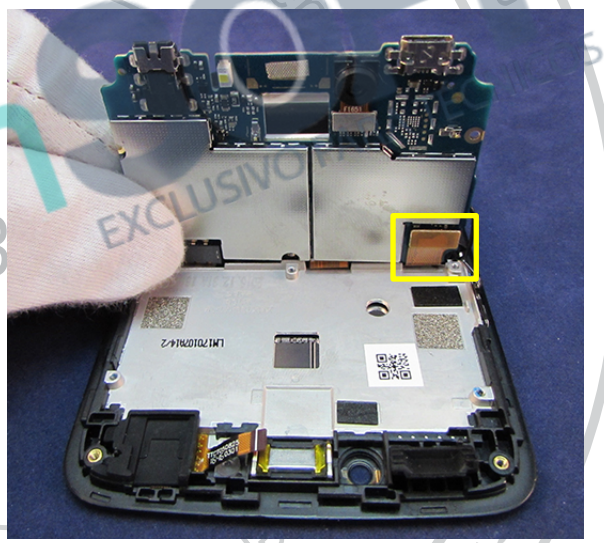
8. Use the Torque Driver and JCIS #0 Bit to remove the 2 JCIS #0 Machine Screws from the Main PCB.



NOTE

After you remove the JCIS #0 Machine Screws, you cannot reuse them.

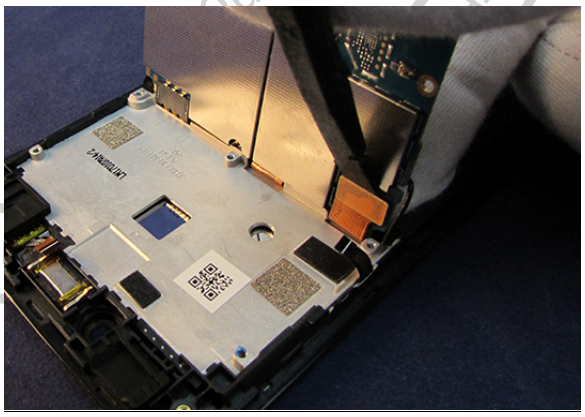
9. Lift the Main PCB upward to expose the Display Flex connected to the underside of the Main PCB as shown. Do not lift the Main PCB excessively.



// CAUTION //

Avoid putting stress on the Display Flex when removing the Main PCB.

10. Use the flat end of the Blackstick to disconnect the Display Flex BtB Connector from the back of the Main PCB.



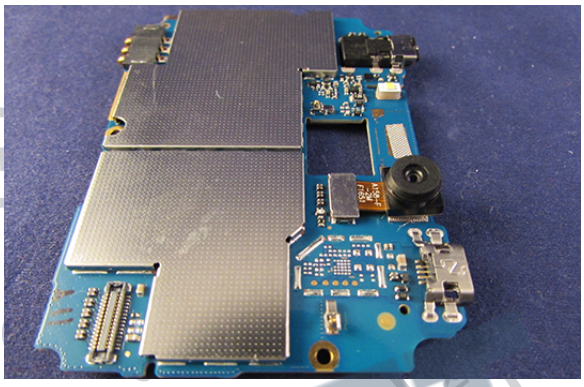
11. Remove the Main PCB.

Front-Facing Imager Removal

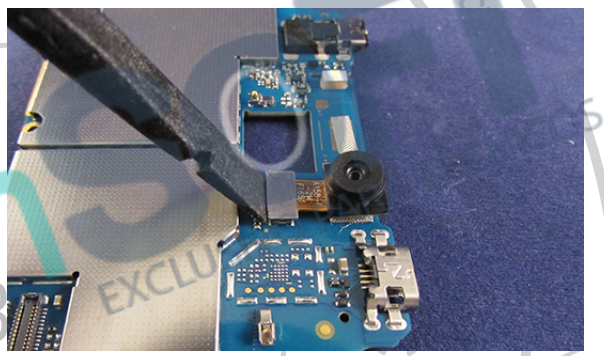
NOTE

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

1. Flip over the Main PCB.



2. Use the flat end of the Blackstick to disconnect the Front-Facing Imager BTB Connector from the Main PCB.
3. Use your fingers to remove the Front-Facing Imager from the Main PCB.



NOTE

The following step is to be performed on Brazil phones only.

NOTE

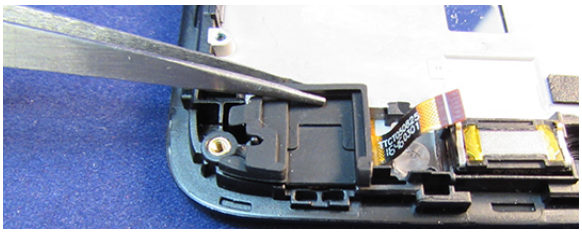
Remove the Front-Facing Imager Electric Fabric only if it is defective or damaged. After you remove it, you cannot reuse it.

4. Use the Tweezers to remove the Front-Facing Imager Electric Fabric from the Main PCB.

Headset Jack Grommet Removal

NOTE

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



Use the Tweezers to lift the Headset Jack Grommet from the Front Housing.

NOTE

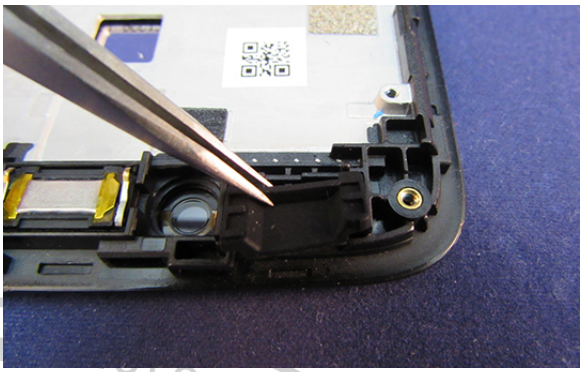
There is no need to remove the Touch Sensor Flex.

USB Grommet Removal

NOTE

The USB Grommet can be recovered and reused after removal.

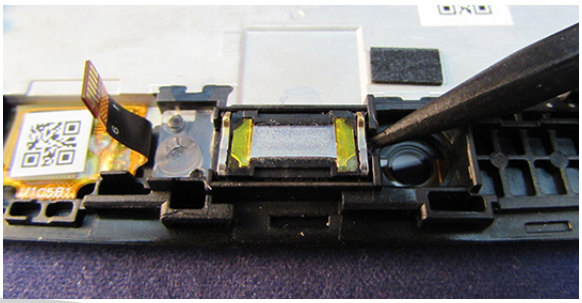
Use the Tweezers to lift the USB Grommet from the Front Housing.



Earpiece Speaker Removal

NOTE

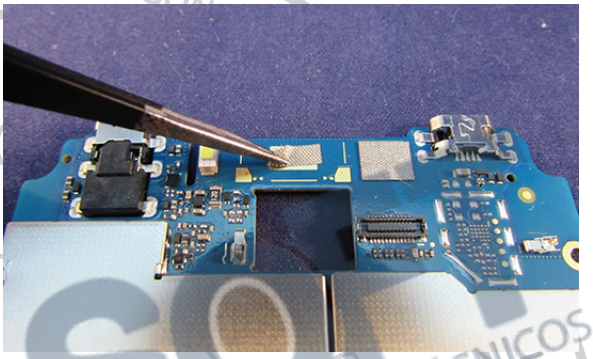
Remove the Earpiece Speaker and the Earpiece Speaker Electric Fabric** only if they are defective or damaged. After you remove the them, you cannot reuse them.



1. Use the pointed end of the Blackstick to pry the Earpiece Speaker out of the pocket in the Front Housing.

NOTE

The following step is to be performed on Brazil phones only.



2. Use the Tweezers to remove the Earpiece Speaker Electric Fabric from the Main PCB.

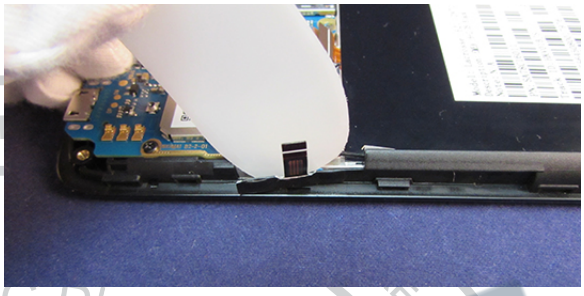
**Brazil phones only

Side-Key Flex Removal

NOTE

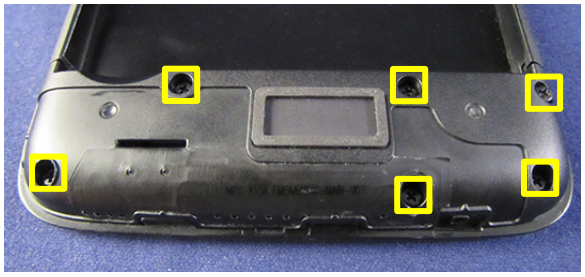
Only replace the Side-Key Flex if it is damaged. After you remove the Side-Key Flex, you cannot reuse it.

Use the Thin Plastic Spudger to pry the Side-Key Flex away from the Front Housing.



Lower Rear Housing Removal

1. Use the Torque Driver and the JCIS #0 Bit to remove the 6 JCIS #0 Machine Screws from the Lower Rear Housing.

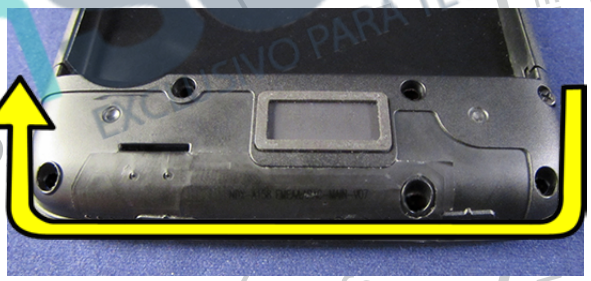


NOTE

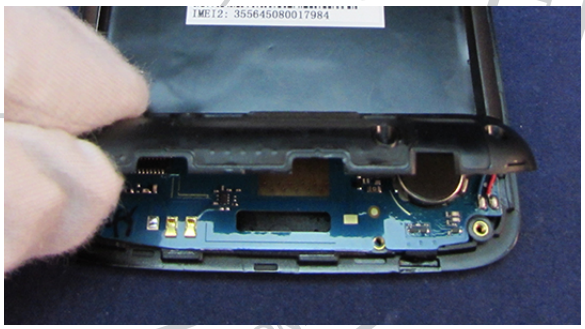
After you remove the JCIS #0 Machine Screws, you cannot reuse them.

2. Insert the Shim in the cutout near the lower right corner of the Lower Rear Housing and disengage the snaps from the Front Housing.

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



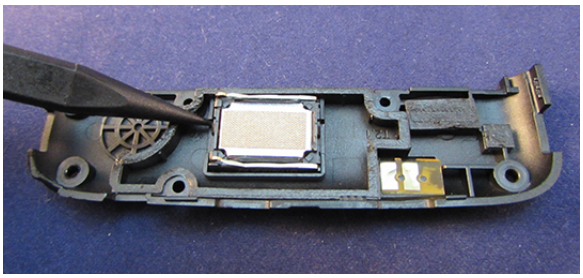
4. Lift the Lower Rear Housing away from the Front Housing.



Loudspeaker Removal

NOTE

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



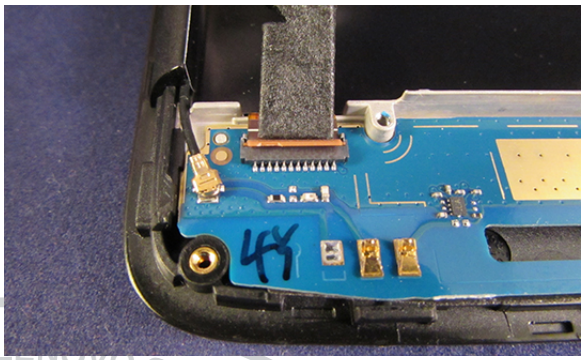
Use the pointed end of the Blackstick to pry the Loudspeaker out of the pocket in the Lower Rear Housing.

Sub-Board Removal

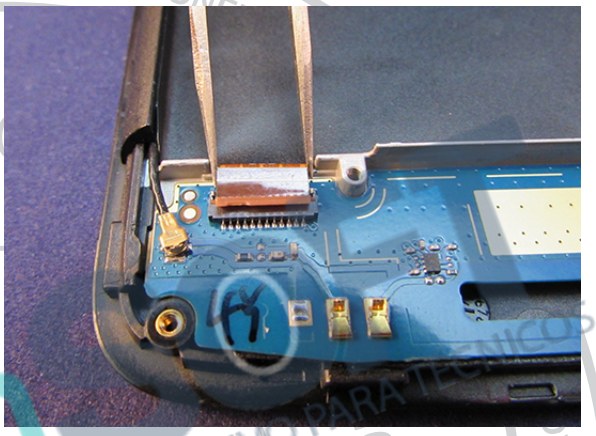
NOTE

The Sub-Board can be recovered and reused after removal.

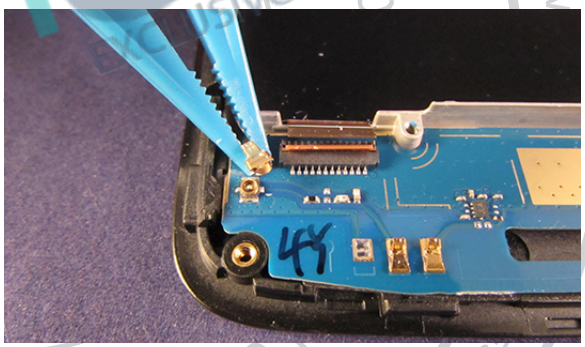
1. Use the flat end of the Blackstick to open the Main Flex ZIF Connector Door on the Sub-Board.



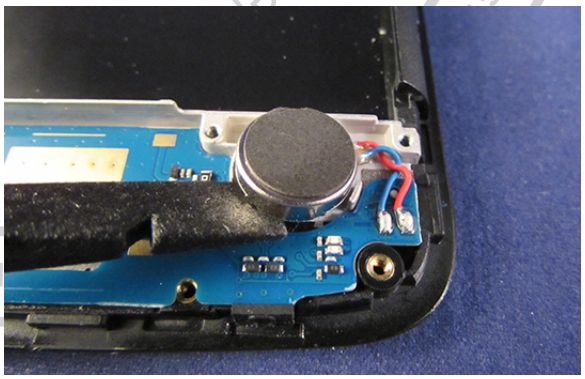
2. Use the Tweezers to disconnect the Main Flex from the Main Flex ZIF Connector.



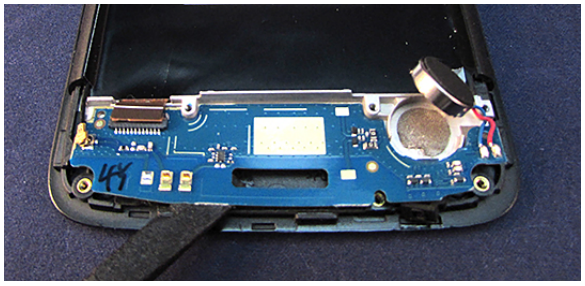
3. Use the Plastic Tweezers to disconnect the Coax Cable from the Sub-Board.



4. Use the flat end of the Blackstick to gently pry the Vibrator, separating the adhesive from the Front Housing.



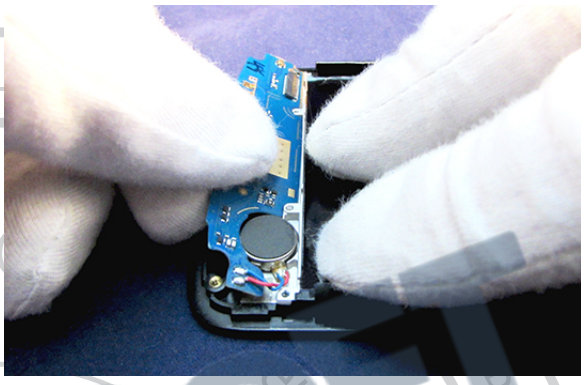
5. Use the flat end of the Blackstick to gently pry the Sub-Board from the pocket on the Front Housing.



// CAUTION //

Do not pry up on the Sub-Board any more than necessary. The Sub-Board may flex excessively and become damaged.

6. Lift the Sub-Board from the Front Housing.



Vibrator Removal

/// WARNING ///

Staff engaged in soldering tasks not involving BGA components must be trained and work in accordance with the requirements of IPC-A-610 and IPC-7711, and work in accordance with J-STD-001.

// CAUTION //

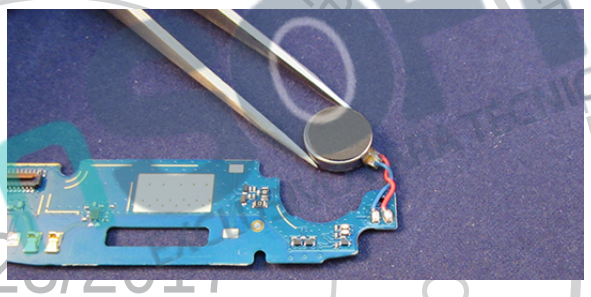
Ensure that tin or lead solder is not used in any electrical repair. Solder wire and solder paste used in electrical repair must be lead free. Actual composition of the wire/paste may be separately defined by individual manufacturers.

Flux used for electrical repair, whether liquid or gel, must be No Clean RMA flux.

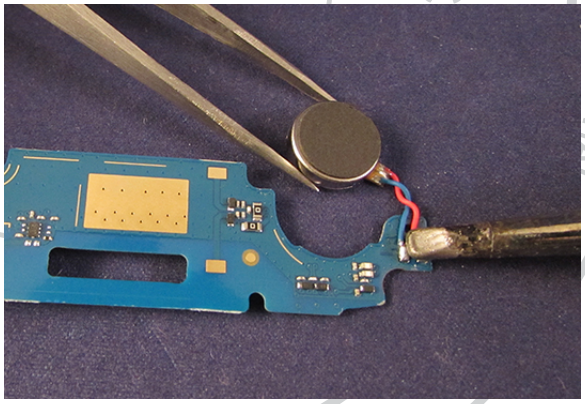
NOTE

The Vibrator can be recovered and reused after removal.

1. Plug in the Soldering Iron and heat it for 10 minutes.
2. Place the Sub-Board on a flat, steady surface and use the Tweezers to hold the Vibrator steady.



3. Use the Soldering Iron to separate the leading wires of the Vibrator from the Sub-Board.
4. Lift the Vibrator away from the Sub-Board.



IMEI Label Removal

NOTE

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

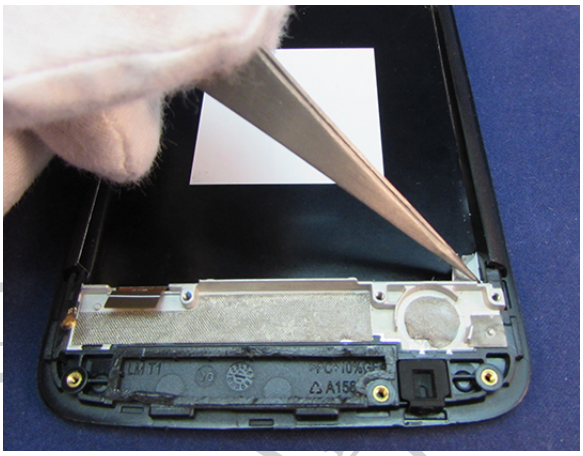
Use the Tweezers to slowly peel the IMEI label from the Battery Floor.

Battery Floor Removal

NOTE

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

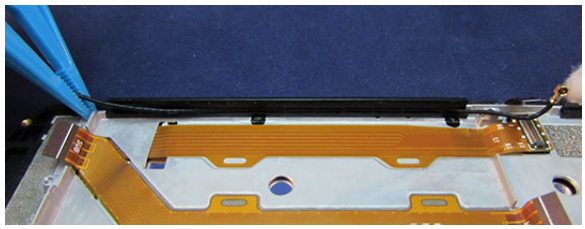
Use the Tweezers to slowly peel the Battery Floor away from the Front Housing.



Coax Cable Removal

NOTE

The Coax Cable can be recovered and reused after removal.



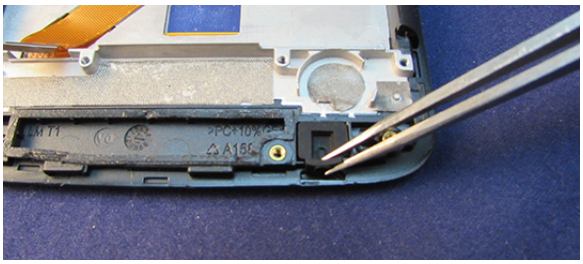
Use the Plastic Tweezers to gently pull the Coax Cable from the channel in the Front Housing.

Microphone Grommet Removal

NOTE

The Microphone Grommet can be recovered and reused after removal.

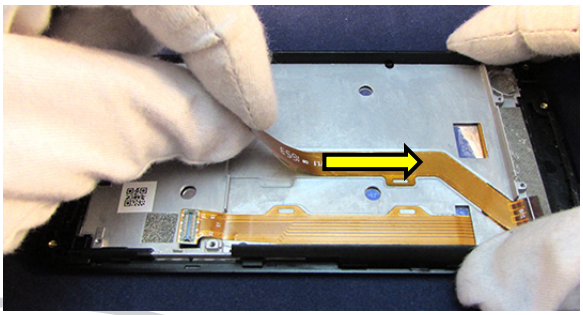
Use the Tweezers to remove the Microphone Grommet from the pocket on Front Housing.



Main Flex Removal

NOTE

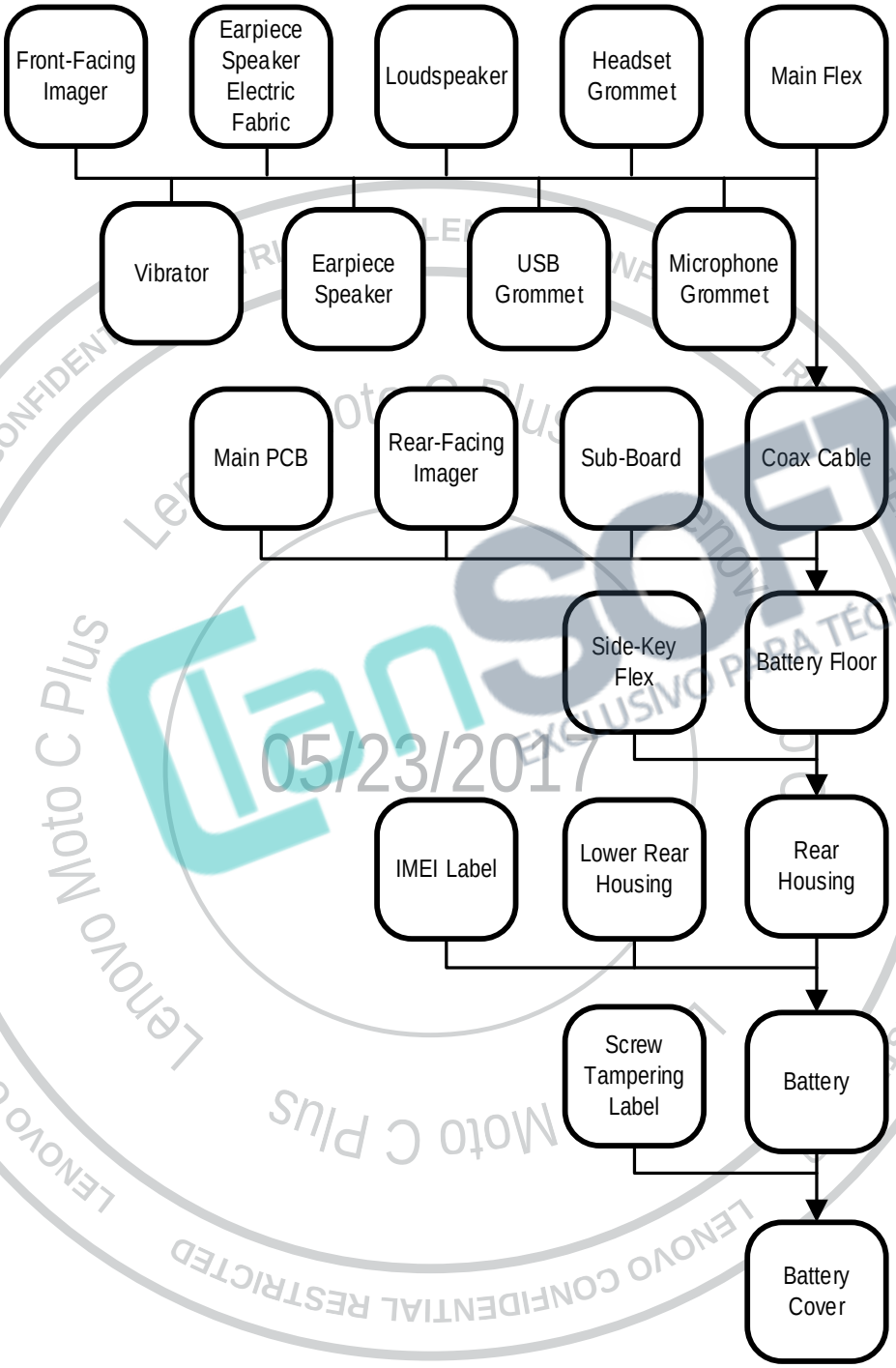
The Main Flex can be recovered and reused after removal if it is undamaged.



Use your fingers to gently peel the Main Flex from the Front Housing.

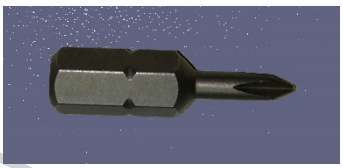
ASSEMBLY

Assembly Map



Tools Required for Assembly

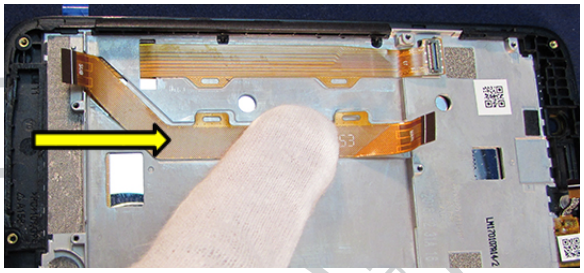
The following tools are required to assemble the Moto C Plus.

Description	*Part #*	*Picture / Drawing*
Blackstick	--	
JCIS #0 Bit	--	
Torque Driver (Adjustable)	--	
Soldering Iron	--	--
Tweezers (Plastic or Plastic-Tipped)	--	--
Tweezers (Metal)	--	--
ESD Mat and Wrist Strap	--	--
Gloves or Finger Collets	--	--

Main Flex Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+69500100039S71+MAIN FPC	4

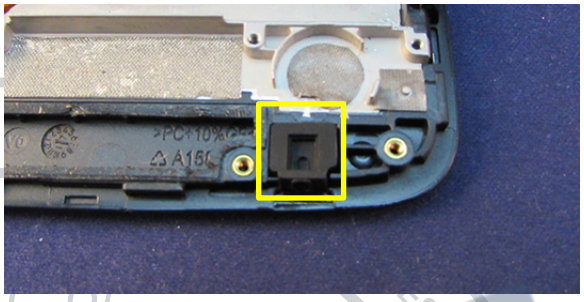
1. Remove the liner from the Front housing. Align the Main Flex with the etchings in the Front Housing.
2. Place a finger on one end of the Main Flex and slide it to the other end to secure it to the Front Housing.



Microphone Grommet Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+50240100071S71+Main MIC Rubber	3

Use your fingers to place the Microphone Grommet into the pocket in the Front Housing. Verify that the Microphone Grommet is oriented as shown.



Vibrator Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+25220100025S71+MOTOR	14

/// WARNING ///

Staff engaged in soldering tasks not involving BGA components must be trained and work in accordance with the requirements of IPC-A-610 and IPC-7711, and work in accordance with J-STD-001.

// CAUTION //

Ensure that tin or lead solder is not used in any electrical repair. Solder wire and solder paste used in electrical repair must be lead free. Actual composition of the wire/paste may be separately defined by individual manufacturers.

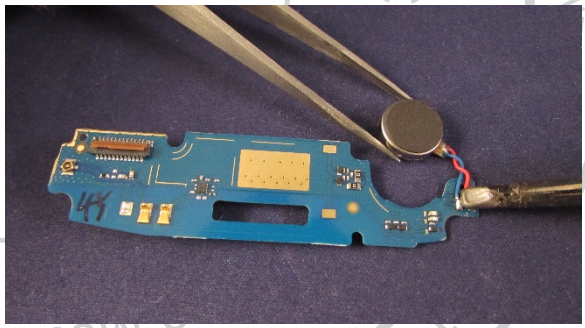
Flux used for electrical repair, whether liquid or gel, must be No Clean RMA flux.

1. Plug in the Soldering Iron and heat it for 10 minutes.
2. Use the Soldering Iron to melt a small amount of solder paste on the wire leads of the Vibrator.

// CAUTION //

Control the amount of solder paste to prevent a short circuit.

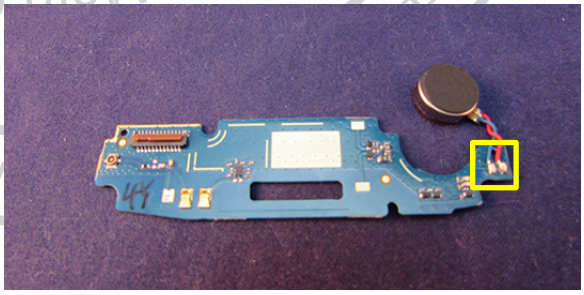
3. Hold the Vibrator steady, aligning the two leading wires with the Sub-Board Welding Plate.



// CAUTION //

Connect the red wire to the right joint (positive) on the Sub-Board, and connect the blue wire to the left joint (negative).

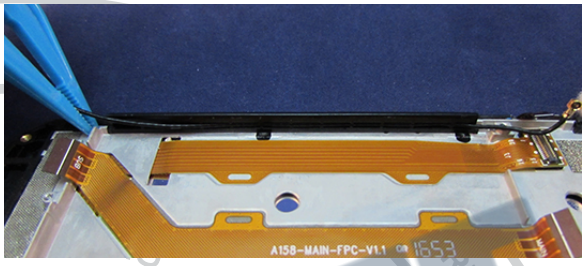
4. Use the Soldering Iron to weld the leading wires of the Vibrator to the Sub-Board. Keep the soldering joint smooth, and avoid virtual welding, solder joint icicles, and short circuits.



Coax Cable Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
XT1724 Sub Board&*72500100202 CS XT1721 Sub Board&*72500100198 CS	6
WD+53340100039S71+COAXIAL CABLE	5

1. Use the Plastic Tweezers to center the Coax Cable

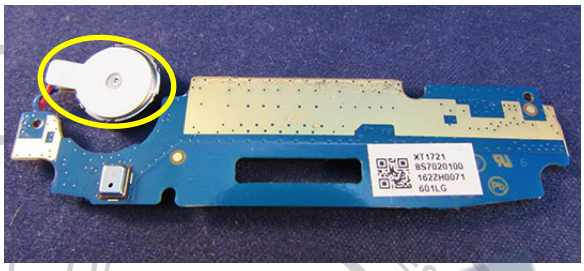


2. Use the flat end of the Blackstick to push the Coax Cable into the channel on the left edge of the Front Housing.

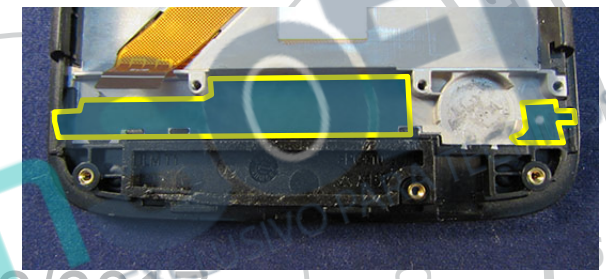
Sub-Board Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
XT1724 Sub Board&*72500100202 CS XT1721 Sub Board&*72500100198 CS	6

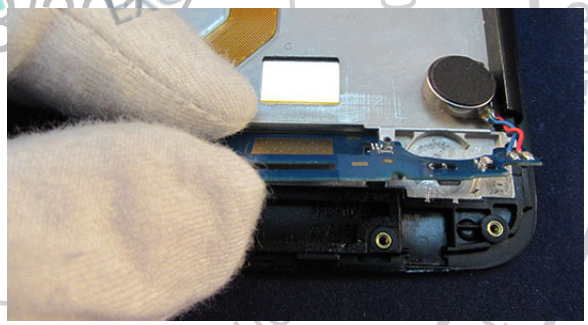
1. Peel the Adhesive liner from the Vibrator.



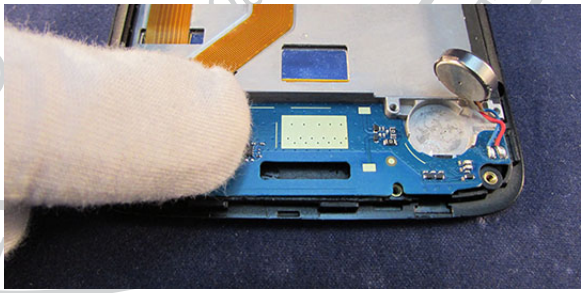
2. Peel the protective liners from the Sub-Board pockets on the Rear Housing.



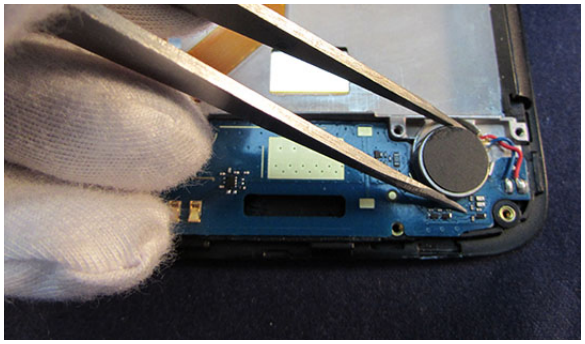
3. Place the Sub-Board into the pocket on the Front Housing, aligning it to the screw bosses on the Front Housing.



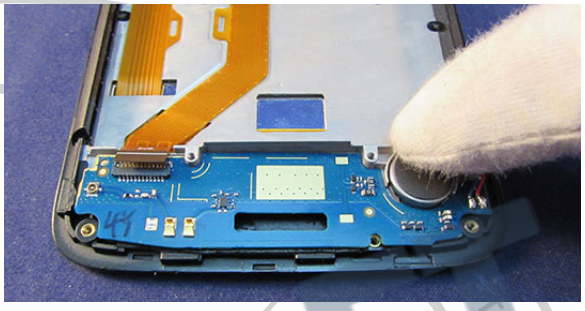
4. Press down on the Sub-Board for 5 seconds to secure it to the Front Housing.



5. Use the Tweezers to place the Vibrator in the pocket on the Front Housing. Be careful not to put any stress on the Vibrator wires.



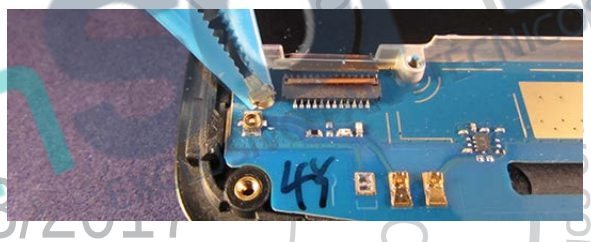
6. Press down on the Vibrator for 5 seconds to secure it to the Front Housing.



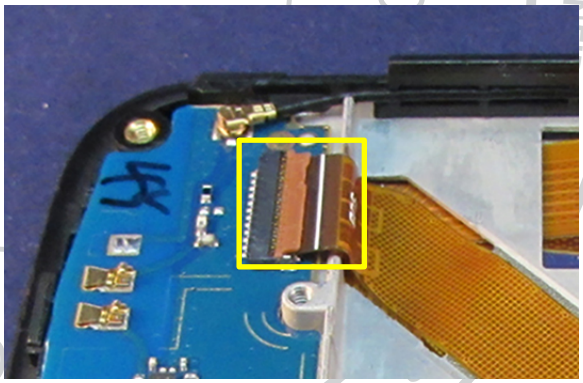
// CAUTION //

Verify you did not damage the Vibrator wires or the Main Flex while placing the Sub-Board on the Front Housing.

7. Use the Plastic Tweezers to connect the Coax Cable to the Sub-Board.

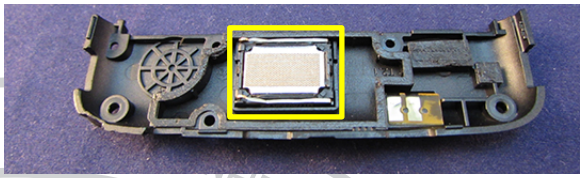


8. Verify that the Main Flex ZIF Connector Door on the Sub-Board is open.
9. Use the Tweezers to insert the Main Flex into the Main Flex ZIF Connector using the white line as a guide for insertion depth.
10. Slide a fingertip across the ZIF Connector Door to close it.



Loudspeaker Assembly

Description	*Reference #*
XT1724 SubBoard Cover&*72600100212 CS XT1721 SubBoard Cover&*72600100211 CS	9
WD+25200100025S71+SPK	8

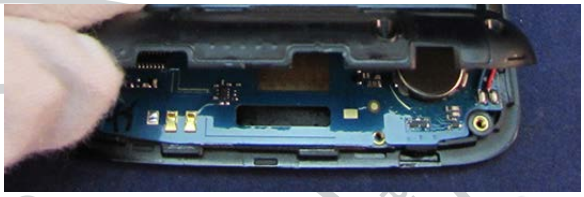


1. Remove the Loudspeaker from the carrier, if present.
2. Place the Loudspeaker into the pocket in the Lower Rear Housing. Verify that the copper contacts are facing up, and are oriented as shown.
3. Press down on the Loudspeaker for 5 seconds to secure it to the Lower Rear Housing.

Lower Rear Housing Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
XT1724 SubBoard Cover&*72600100212 CS XT1721 SubBoard Cover&*72600100211 CS	9
WD+44100100074S71+Scross Screw	11 (qty. 6)

1. Align the Lower Rear Housing to the Front Housing.



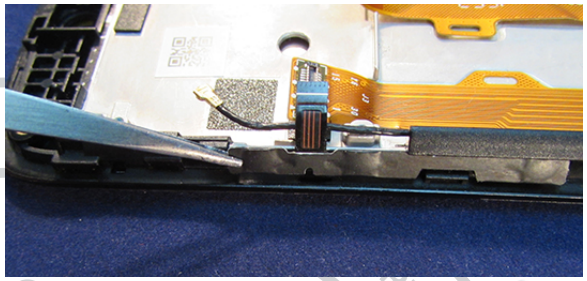
2. Press down to engage the snaps around the edges of the Lower Rear Housing.

3. Use the Torque Driver and JCIS #0 Bit to tighten the 6 JCIS #0 Machine Screws to 0.7+/-0.1 kgf (1.54+/-0.22 lbf) in the order shown.

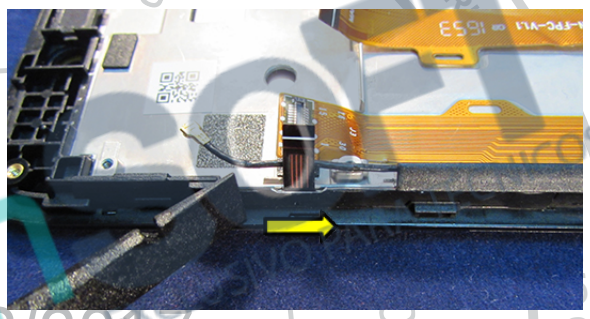
Side-Key Flex Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+69100100069S71+SIDEKEY FPC	2

1. Remove the adhesive carrier from the Side-Key Flex.
2. Use the Tweezers to align the Side-Key Flex to the recess along the left edge of the Front Housing wall as shown.



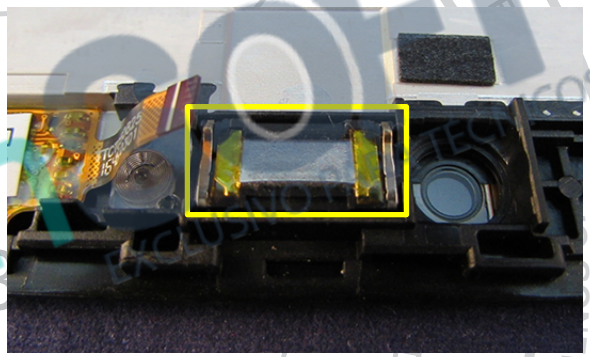
3. Slide the flat end of the Blackstick along the Side-Key Flex to secure it to the Front Housing.



Earpiece Speaker Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
XT1723 D_SIM MB 2+16G&*72500100197 CS XT1723 D_SIM MB 1+16G&*72500100199 CS XT1723 S_SIM MB 1+16G&*72500100200 CS XT1723 Tesco SSL MB 1+16G&*72500100226CS XT1721 D_SIM MB 1+16G&*72500100201 CS XT1724 D_SIM MB 1+16G&*72500100203 CS XT1725 S_SIM MB 1+16G&*72500100204 CS XT1725 GT SSL MB 1+16G&*72500100206 CS XT1725 TIGO SSL MB 1+16G&*72500100207 CS ASSY,BD KIT,XT1726,BR,8+1,DTV,DS,CKD	15
WD+25240100003S71+Receiver	20
WD+56600100081S71+SPK ELECTRIC FABRIC	--**

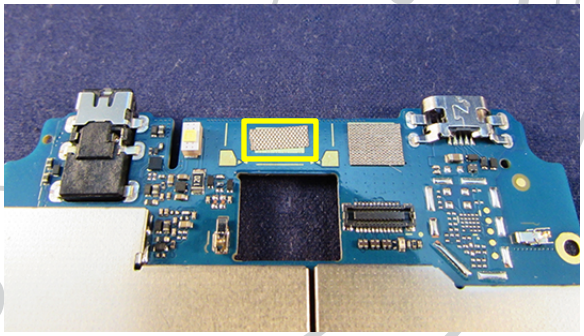
1. Remove the Earpiece Speaker from the carrier, if present.
2. Place the Earpiece Speaker into the pocket in the Front Housing. Verify that the copper contacts are facing up, and are oriented as shown.
3. Press down on the Earpiece Speaker for 5 seconds to secure it to the Front Housing.



NOTE

The following steps are to be performed on Brazil phones only.

4. Remove the Earpiece Speaker Electric Fabric from the carrier.
5. Attach the Earpiece Speaker Electric Fabric to the Main PCB as shown.
6. Press down for 5 seconds to secure the Fabric to the Main PCB.

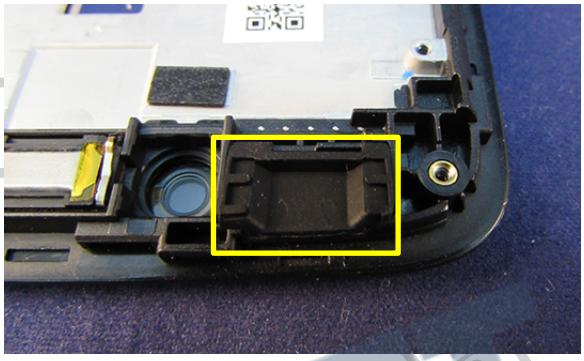


** Brazil phones only

USB Grommet Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+50240100075S71+USB Cover Rubber	16

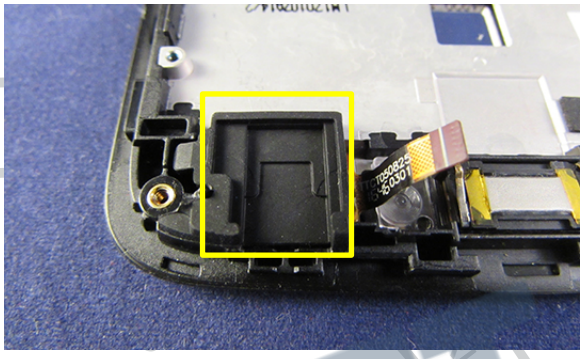
Use your finger to press the USB Grommet into the pocket in the Front Housing.



Headset Jack Grommet Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+50240100073S71+Headest Rubber	17

1. Use your finger to press the Headset Jack Grommet into the pocket in the Front Housing.

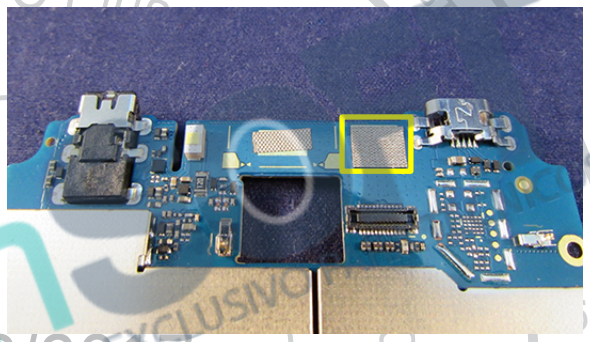


Front-Facing Imager Assembly

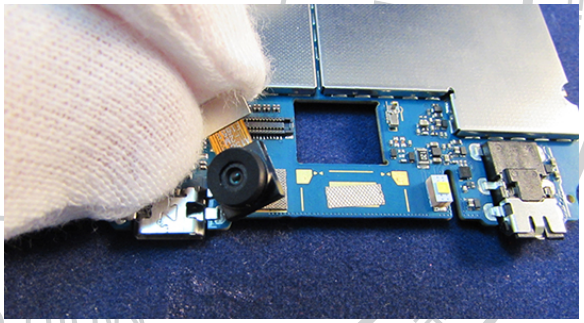
Description	*Reference #*
XT1723 D_SIM MB 2+16G&*72500100197 CS XT1723 D_SIM MB 1+16G&*72500100199 CS XT1723 S_SIM MB 1+16G&*72500100200 CS XT1723 Tesco SSL MB 1+16G&*72500100226CS XT1721 D_SIM MB 1+16G&*72500100201 CS XT1724 D_SIM MB 1+16G&*72500100203 CS XT1725 S_SIM MB 1+16G&*72500100204 CS XT1725 GT SSL MB 1+16G&*72500100206 CS XT1725 TIGO SSL MB 1+16G&*72500100207 CS ASSY,BD KIT,XT1726,BR,8+1,DTV,DS,CKD	15
WD+25410100064S71+Front camera	18
WD+56600100101S71+F CAM ELEC FABRIC	--

NOTE

Steps 1 – 3 are to be performed on Brazil phones only.

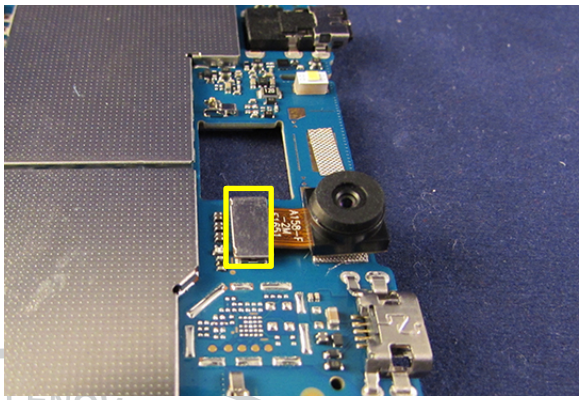


1. Remove the Front-Facing Imager Electric Fabric from the carrier.
2. Attach the Front-Facing Imager Electric Fabric to the Main PCB as shown.
3. Press down for 5 seconds to secure the Fabric to the Main PCB.



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

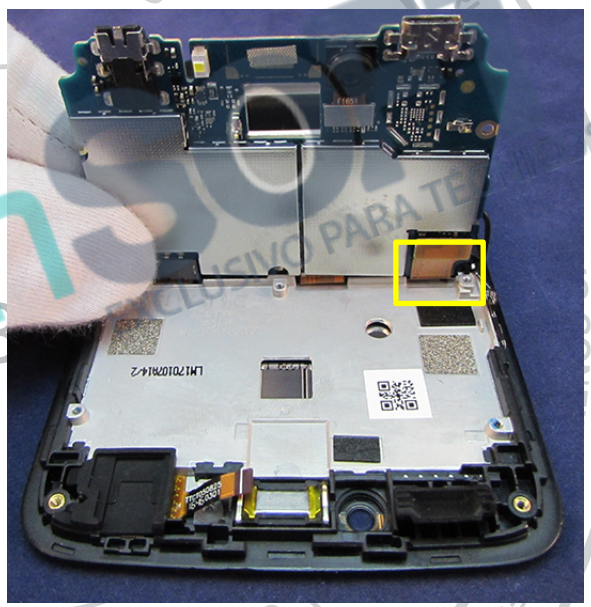
5. Use rolling pressure to connect the Front-Facing Imager BtB Connector to the Main PCB.



Main PCB Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
XT1723 D_SIM MB 2+16G&*72500100197 CS XT1723 D_SIM MB 1+16G&*72500100199 CS XT1723 S_SIM MB 1+16G&*72500100200 CS XT1723 Tesco SSL MB 1+16G&*72500100226CS XT1721 D_SIM MB 1+16G&*72500100201 CS XT1724 D_SIM MB 1+16G&*72500100203 CS XT1725 S_SIM MB 1+16G&*72500100204 CS XT1725 GT SSL MB 1+16G&*72500100206 CS XT1725 TIGO SSL MB 1+16G&*72500100207 CS ASSY,BD KIT,XT1726,BR,8+1,DTV,DS,CKD	15
WD+44100100074S71+Scross Screw	11 (qty. 2)

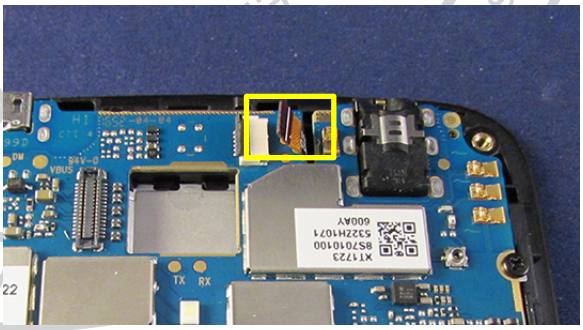
1. Remove any protective carriers from the Front Housing and Main PCB, if present.
2. Place the Main PCB into the pocket in the Front Housing, aligning the bottom edge of the Main PCB to the bottom edge of the pocket as shown.
3. Use rolling pressure to connect the Display Flex BtB Connector to the back of the Main PCB. Do not lift the Main PCB excessively.



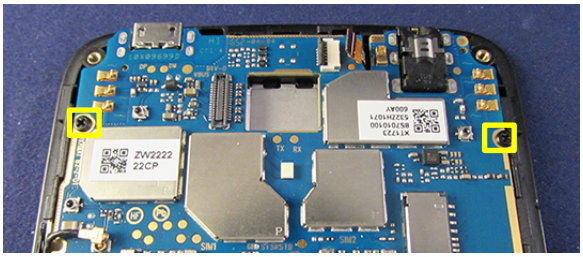
// CAUTION //

Avoid putting stress on the Display Flex when moving the Main PCB.

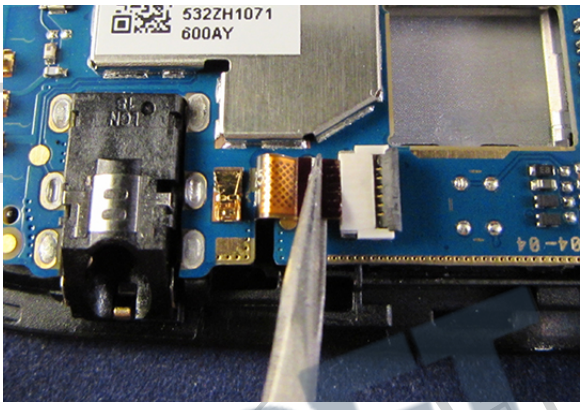
4. Thread the Touch Sensor Flex through the opening in the Main PCB as shown.
5. Carefully place the Main PCB flat in the pocket on the Front Housing, aligning it to the screw bosses in the Front Housing.



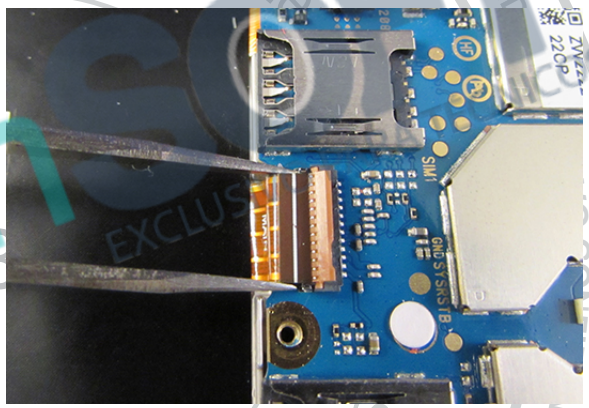
6. Use the Torque Driver and JCIS #0 Bit to tighten the 2 JCIS #0 Machine Screws to 0.7+/-0.1 kgf (1.54+/-0.22 lbf) to assemble the Main PCB to the Front Housing.



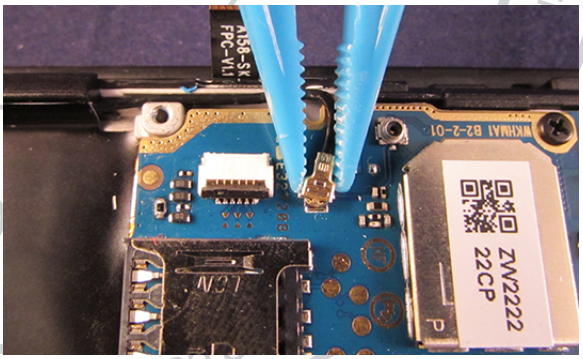
7. Verify that the Touch Sensor Flex ZIF Connector Door on the Main PCB is open.
8. Use the Tweezers to insert the Touch Sensor Flex into Touch Sensor Flex ZIF Connector, using the white line as a guide for insertion depth.
9. Slide a fingertip across the ZIF Connector Door to close it.



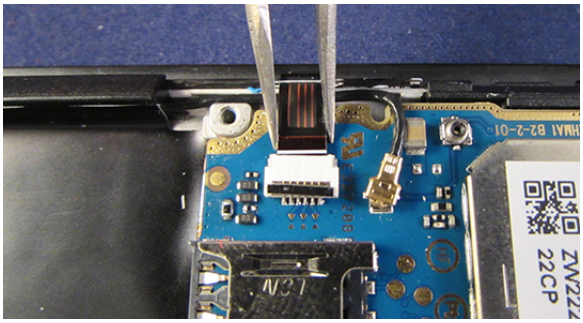
10. Verify that the Main Flex ZIF Connector Door on the Main PCB is open.
11. Use the Tweezers to insert the Main Flex into the Main Flex ZIF Connector, using the white line as a guide for insertion depth.
12. Slide a fingertip across the ZIF Connector Door to close it.



13. Use the Plastic Tweezers to connect the Coax Cable to the Main PCB.



14. Verify that the Side-Key Flex ZIF Connector Door on the Main PCB is open.
15. Use the Tweezers to insert the Side-Key Flex into the Side-Key Flex ZIF Connector, using the white line for insertion depth.



NOTE

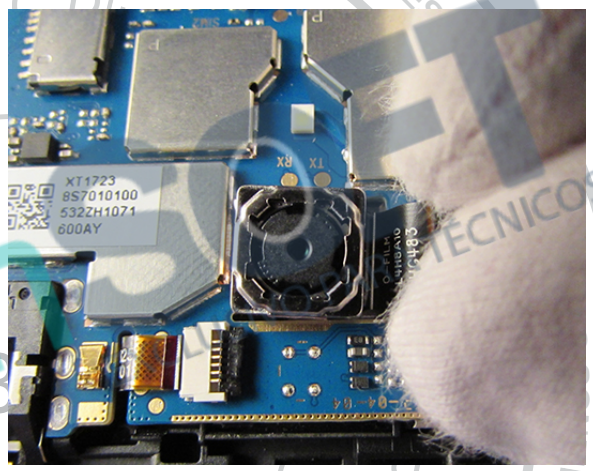
Verify that the Coax Cable is under the Side-Key Flex.

16. Slide a fingertip across the Side-Key Flex ZIF Connector Door to close it.

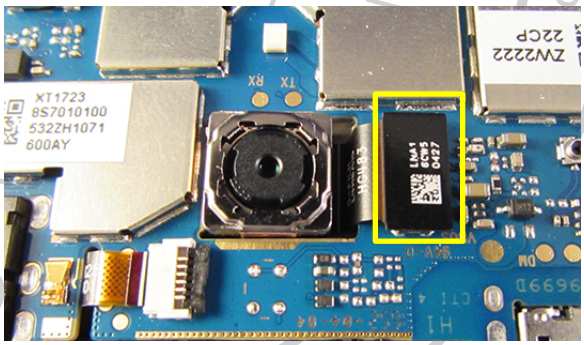
Rear-Facing Imager Assembly

Description	*Reference #*
XT1723 D_SIM MB 2+16G&*72500100197 CS XT1723 D_SIM MB 1+16G&*72500100199 CS XT1723 S_SIM MB 1+16G&*72500100200 CS XT1723 Tesco SSL MB 1+16G&*72500100226CS XT1721 D_SIM MB 1+16G&*72500100201 CS XT1724 D_SIM MB 1+16G&*72500100203 CS XT1725 S_SIM MB 1+16G&*72500100204 CS XT1725 GT SSL MB 1+16G&*72500100206 CS XT1725 TIGO SSL MB 1+16G&*72500100207 CS ASSY,BD KIT,XT1726,BR,8+1,DTV,DS,CKD	15
MDL,CAMR,8MP,L4H8A10 O-FILM 30pin MDL,CAMR,8MP,F4H8CAZ Q-TECH 30pin	13

1. Use your fingers to place the Rear-Facing Imager into the opening on the Main PCB.



2. Use rolling pressure to connect the Rear-Facing Imager BtB Connector to the Main PCB.

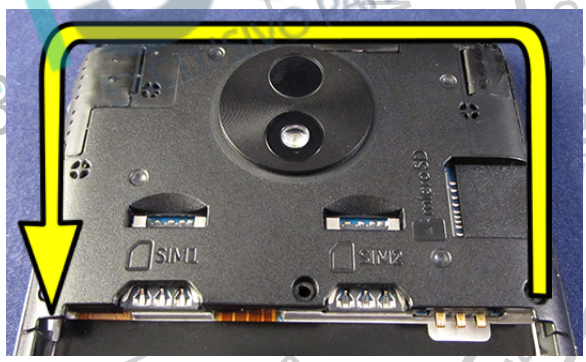


Rear Housing Assembly

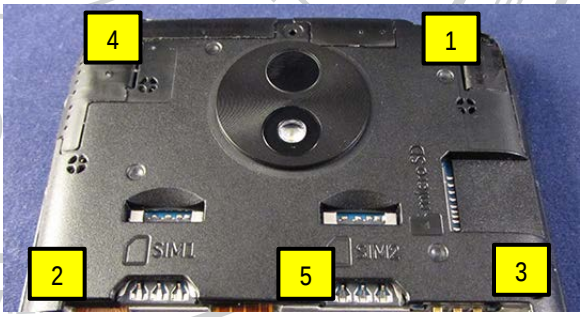
Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+44100100074S71+Scross Screw	11 (qty. 5)
XT1724 Rear Cover D_SIM&*72600100210 CS XT1724 Rear Cover S_SIM&*72600100209 CS XT1721 Rear Cover S_SIM&*72600100208 CS XT1721 Rear Cover D_SIM&*72600100207 CS	12
WD+58500100069S71+Tamper Evidence Label	--

1. Remove all protective carriers from the Housing, Main PCB, and Rear-Facing Imager.
2. Place the Rear Housing on the Font Housing.

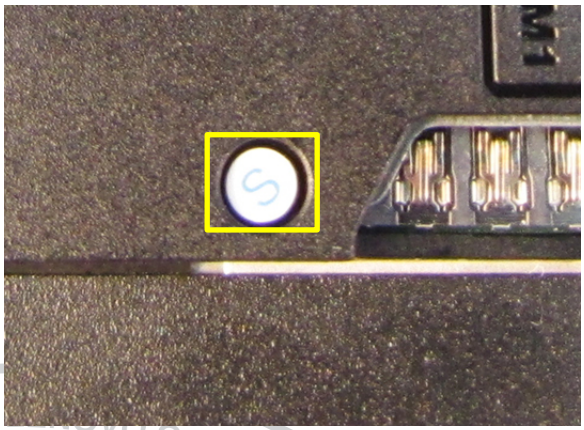
3. Engage the snaps around the edges of the Rear Housing.



4. Align the Rear Housing to the Front Housing.
5. Use the Torque Driver and JCIS #0 Bit to tighten the 5 JCIS #0 Machine Screws to 0.7+/-0.1 kgf (1.54+/-0.22 lbf) in the order shown to assemble the Rear Housing to the Front Housing in the order shown.



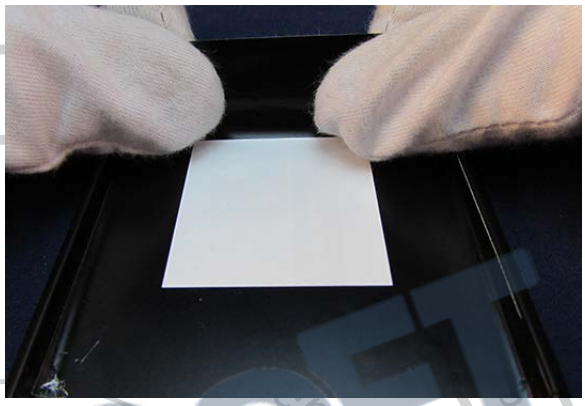
6. Apply a Screw Tampering Label to the head of the Machine Screw shown.



Battery Floor Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+73170100202S71+Battery compartment la	--

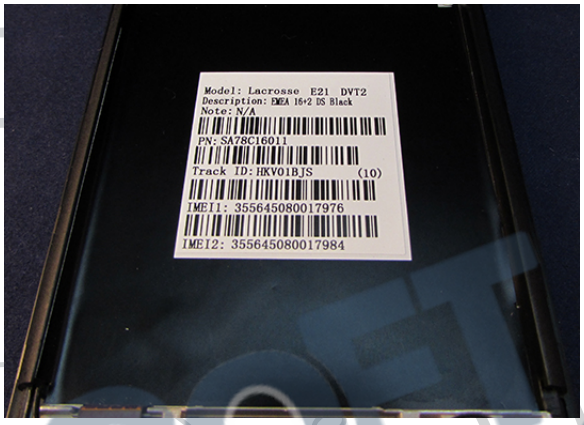
1. Remove the adhesive carrier from the Battery Floor.
2. Align the edge of the Battery Floor to the edge of the recess in the Front Housing.
3. Lower the Battery Floor completely into the recess in the Front Housing.
4. Wipe the Battery Floor with a card to smooth out any wrinkles and remove any air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



IMEI Label Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
WD+73170100202S71+Battery compartment la	--
WD+73150100080S71+IMEI label	--

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



Battery Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
Po:HC60;CS556070;SWD;4000mAh;WW	7

/// WARNING ///

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

// CAUTION //

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

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

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

Ensure screws and screwdrivers do not contact the Battery.

1. Align the contacts on the Battery as shown and place the Battery into the pocket in the Front Housing.
2. Press down on the Battery until it snaps into place.

Battery Cover Assembly

Description	*Reference #*
XT172X TP LCM ASSY GL&*72600100202 CS XT172X TP LCM ASSY BL&*72600100213 CS	1
XT172X BatteryCover GL&*72600100203 CS XT172X BatteryCover RD&*72600100205 CS XT172X BatteryCover WH&*72600100204 CS XT172X BatteryCover BL&*72600100206 CS	10

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

NOTE

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

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

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