

Lenovo

Moto Edge 2023



Moto Edge 2023

Level 2 – Service and Repair Manual

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REVISION HISTORY

<i>Revision</i>	<i>Date</i>	<i>Notes</i>
1	07/14/2023	Initial Release.
1.1	08/21/2023	Update DISCLAIMER & WARNING.
		Update the descriptions of Regen-I Pneumatic Press System, Inlay press - holder with pad, Inlay press - holder with pad, and Battery Cover Adhesive Alignment.
2	12/06/2023	Added Front-Housing Box Mylar Removal and Front-Housing Box Mylar Assembly.

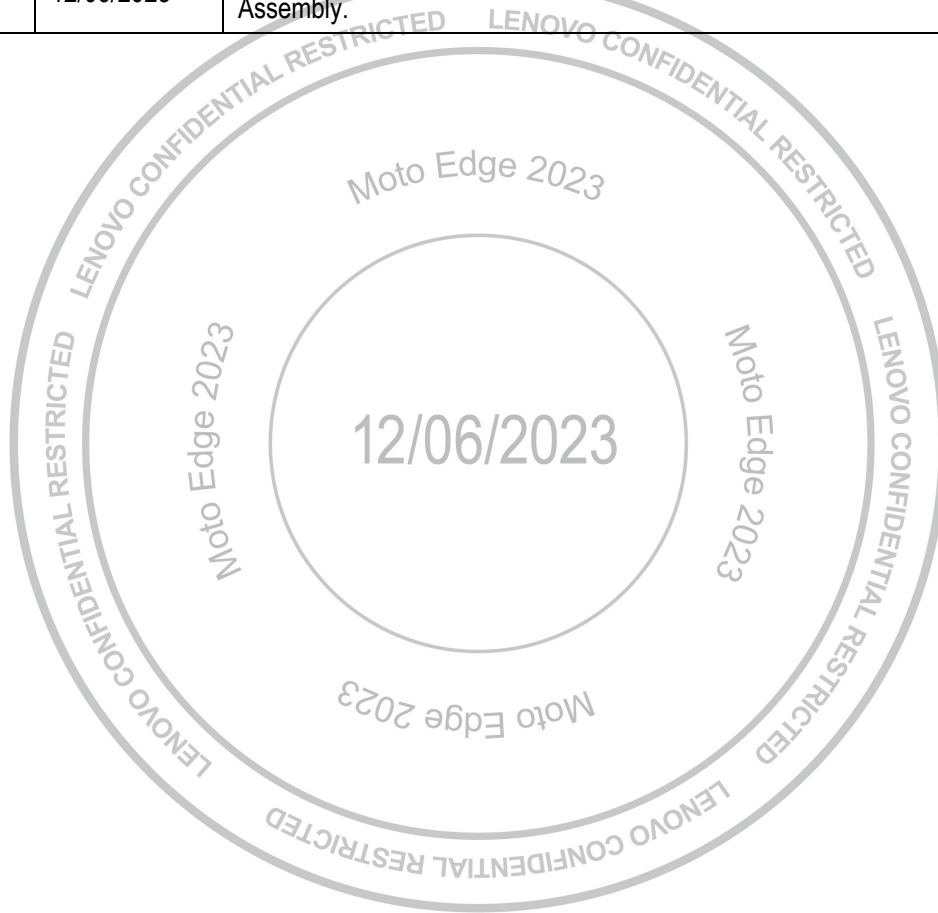


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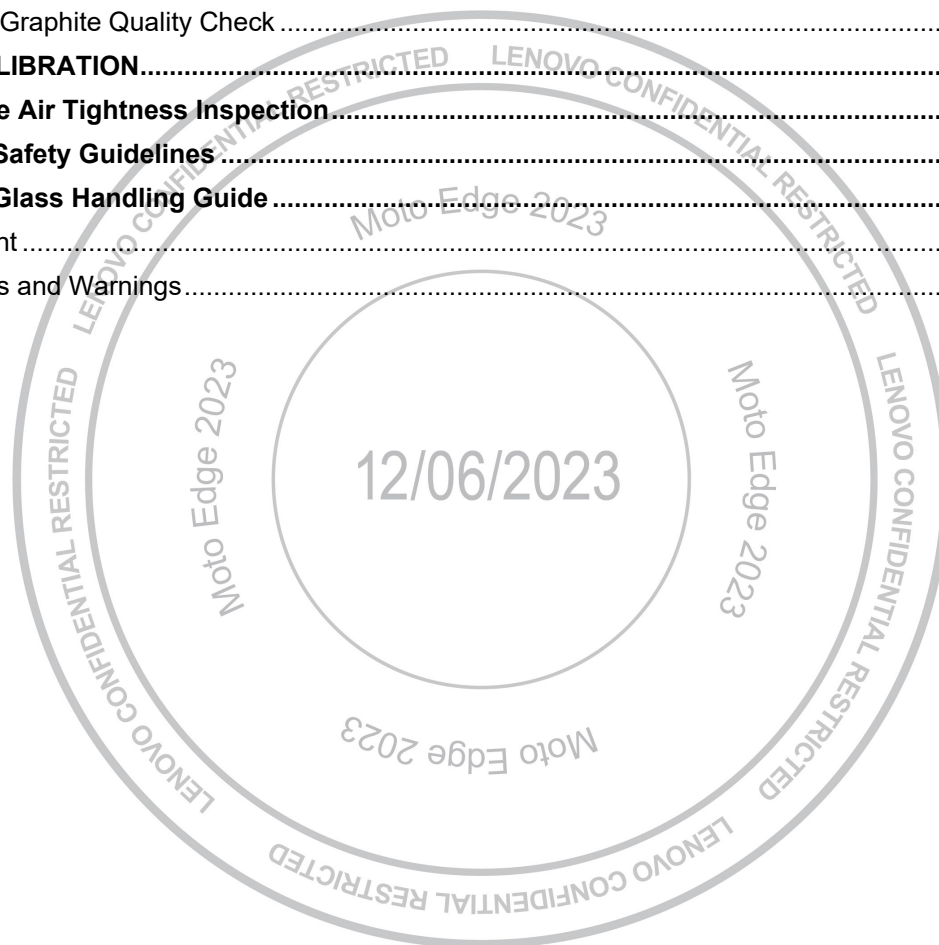
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INTRODUCTION

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.

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.



INTRODUCTION

External Views

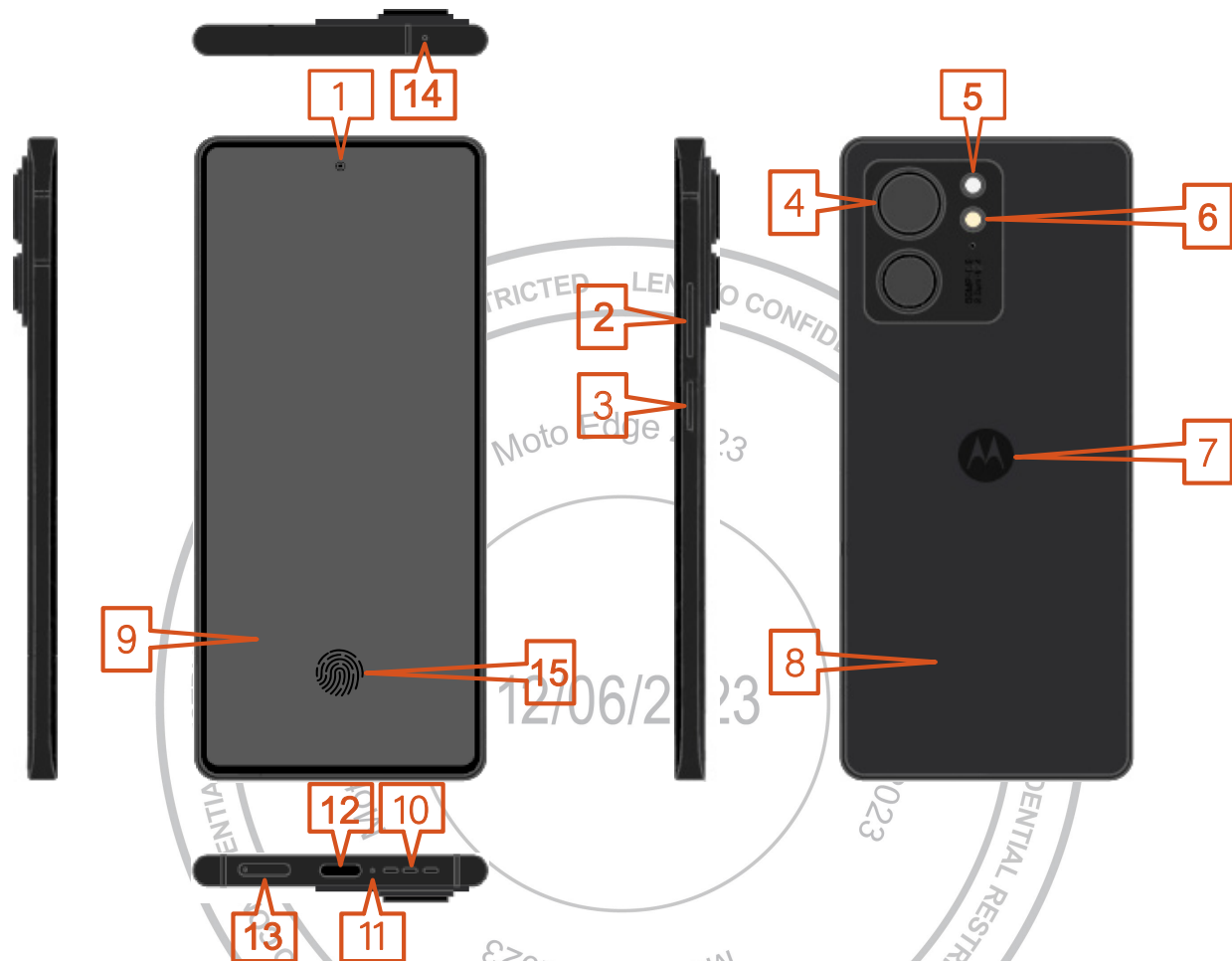


Figure 1. External Views

Table 1. External Views Parts List

<i>Reference #</i>	<i>Description</i>
1	Front-Facing Camera
2	Volume Key
3	Power Key
4	Rear-Facing Camera
5	Light Sensor
6	Flashlight
7	Batwing Logo
8	Rear Inlay
9	Display Screen
10	Loudspeaker
11	Primary MIC
12	USB Type C
13	Sim Door
14	Secondary MIC
15	FOD

Main Exploded Views

Figure 2. Assembly Exploded View

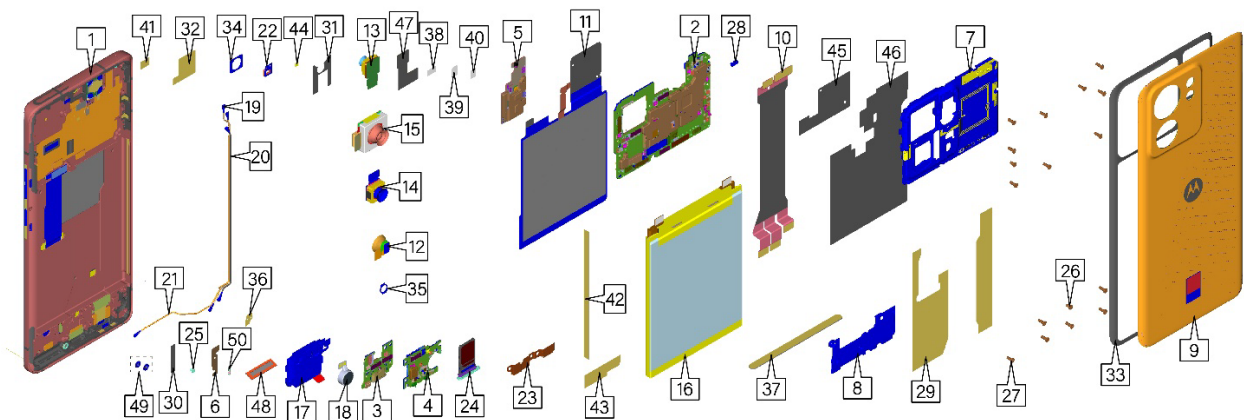


Table 2. Assembly Exploded View Parts List

Reference #	Description	Recovery Part
1	XT2305,TPLCM,BLK CS	Yes
2	XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	Yes
3	XT2305,USB Sub Board CS	Yes
4	XT2305,SIM Board CS	Yes
5	XT2305,Stack Board CS	Yes
6	XT2305,RF ANT Board CS	Yes
7	XT2305,Top Bracket CS	Yes
8	ANT,EXTRNL,AION,ASSY_BOT_BRACKET	Yes
9	XT2305,INLAY,PU,BLK CS	Yes
10	ASSY,FLX,London na MN FPC,2L	No
11	Lyriq FPC WLC	No
12	FINGERPRT SCANNER,ofilm,FOD, EL721	Yes
13	MDL,CAMR,32M,front;LGD2A10;O-FILM,AF:TUN	Yes
14	MDL,CAMR,13M,rear,L1336A40;O-FILM,AF:Lon	Yes
15	MDL,CAMR,50M,rear;L50AA40;O-FILM,AF:Lond	Yes
16	ACCY,BAT,4400mAh,PG44,ATL466383,NVT	Yes
17	AU,SPKR,11x15x2.48mm,8Ohms,Fpc CONT,GP C	Yes
18	Vibrator,235Hz,D8xH3.25,L0832F-0012	No
19	CBL,DATA,AION,CABLE1	Yes
20	CBL,DATA,AION,CABLE2	Yes
21	CBL,DATA,AION,CABLE5	Yes
22	HDW,BRKT,AION,MIC3_BRACKET	No

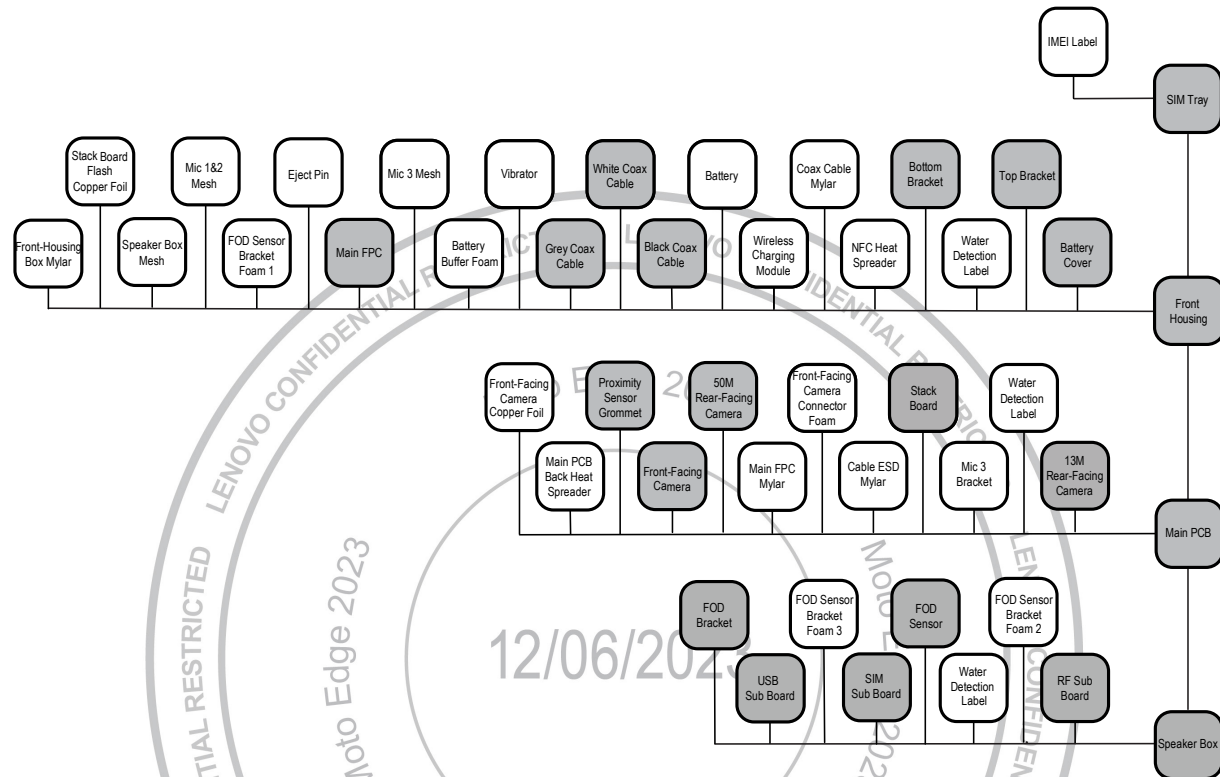
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Reference #	Description	Recovery Part
23	HDW,OTHR,AION,FOD_METAL_BRACKET	Yes
24	LYRIQ ASSY_SINGLE_SIM_TRAY_BLK	Yes
25	ZEEKR SCREW_M1P2_1P55_H03_CROSS	No
26	HDW,SCR,STL,M1.4x0.30x2.5mm_Clear	No
27	HDW,SCR,Tooth_screw_M1.4x0.30x3.6mm	No
28	GROM,CUST,AION,PSENSOR_GROMMET	Yes
29	DICUT,FOAM,AION,BATTERY_ADH	No
30	DICUT,ADHS,AION_BOX_INLAY_ADH	No
31	DICUT,ADHS,AION_MIC3_BRACKET_ADH	No
32	DICUT,FOAM,AION,STACK_PCB_ADH	No
33	DIECUT_AION_INLAY_PSA_FOR_SERVICE	No
34	DICUT,FOAM,AION,FRT_CAM_GAS_2	No
35	DICUT,FOAM,AION,FOV_ADH	No
36	DICUT,FOAM,AION,SPK_FPC_ADH	No
37	DICUT,FOAM,AION,BATTERY_SUP_GAS	No
38	DICUT,FOAM,AION_FOD_BRACKET_COND_GASKET	No
39	DICUT,FOAM,AION,FOD_BRACKET_GASKET_2	No
40	DICUT,FOAM,AION,FOD_BRACKET_GASKET_3	No
41	DICUT,FOAM,AION,FRT_CAM_CON_GASKET	No
42	DICUT,FOAM,AION,CABLE_PET	No
43	DICUT,FOAM,AION,MAIN_FPC_MYLAR	No
44	DICUT,ADHS,AION_CABLE_ESD_MYLAR	No
45	THRM,HT DISP,N,AION,GRAPHITE_NFC	No
46	THRM,HT DISP,N,AION,GRAPHITE_PMU	No
47	THRM,HT DISP,N,AION,GRAPHITE_RECEIVER	No
48	DICUT,FOAM,AION,IP68_BOX_HOLE_GASKET	No
49	Lyriq Foam_Mesh_Mic_Middle_HSG	No
50	Lyriq Ejection_Pin_SIM_Tray_IP68	No
-	DUBAI Screw2_M1.4x3,Silver	No
-	DICUT,ADHS,AION_STACK_TOP_ADH	No
-	DICUT,ADHS,AION_MIC3_GASKET	No
-	LBL,IMEI,9X1.3mm,Full Size 35.6x27.6mm	No
-	DICUT,WATERPROOF,Waterproof LBL TMO	No
-	PKG,OTHR,London NA PPR SLV LIN	No
-	DICUT,ADHS,AION,STACK_FLASH_COPPER	No
-	DICUT,PSA,AION_HSG_BOX_MYLAR	No

DISASSEMBLY AND RECOVERY


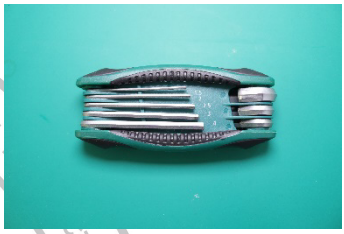

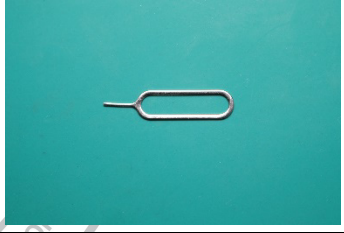
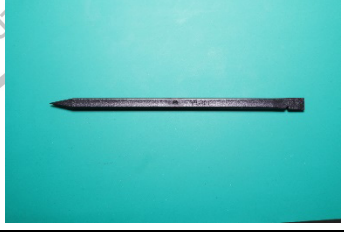

Disassembly and Recovery Map

*Shaded parts may be eligible for parts recovery.




Tools Required for Disassembly


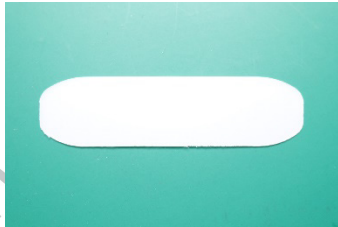

The following tools are required to disassemble the Moto Edge 2023.

<i>Description</i>	<i>Part #</i>	<i>Picture/Drawing</i>
Anti-Static foam pad Pad thickness : $\geq 5\text{mm}$ Pad Material : silicone rubber, as reference silicone clean. Matt : (RG-400)	--	
3 mm Allen Wrench	--	
Hot Plate	--	
SIM/SD Tray Removal Tool	--	
Black Stick	--	
Torque Driver	--	

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Description	Part #	Picture/Drawing
Shim	4-00-5L-10000	
PH00 Bit	--	
BtB	--	
MINI Desktop LCD Freezing Separator	TBK-578	
Sealed Bag	--	
Plastic Tweezers	--	

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<i>Description</i>	<i>Part #</i>	<i>Picture/Drawing</i>
Oven	RG-202F	
Thin Plastic Spudger	0-00-00-40826	
PU Inlay Disassembly Tool	30007085	
ESD Mat	--	
Wrist Strap	--	
Gloves	--	

SIM Tray Removal

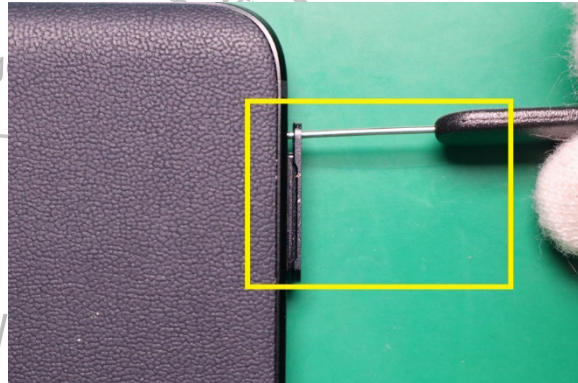
NOTE

The SIM Tray can be recovered and reused after removal.

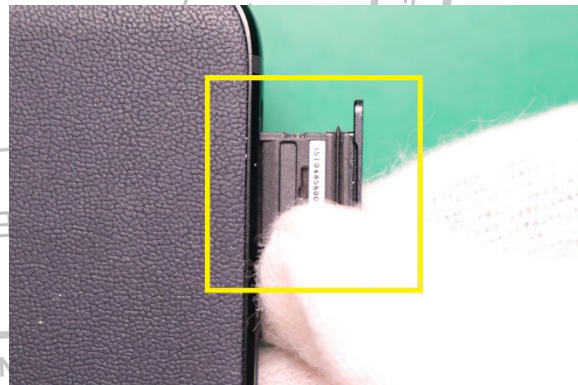


1. Power off the device before beginning with the procedure. Use the SIM Tray Removal pin to push into the SIM Tray hole.

2. Press the SIM Tray Removal Tool to make it pop-out as shown.



3. Use fingers to take out the SIM Tray.



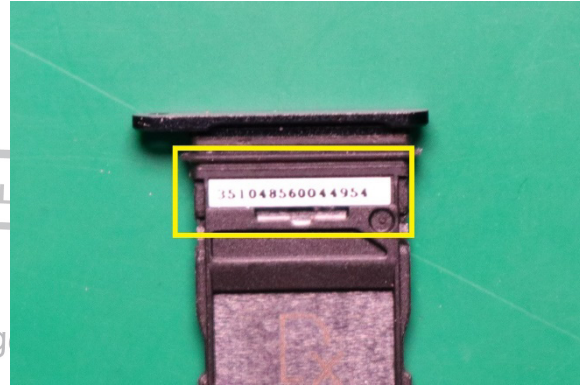
IMEI Label Removal

NOTE

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



Use the Plastic Tweezer to remove the IMEI Label from the SIM Tray.

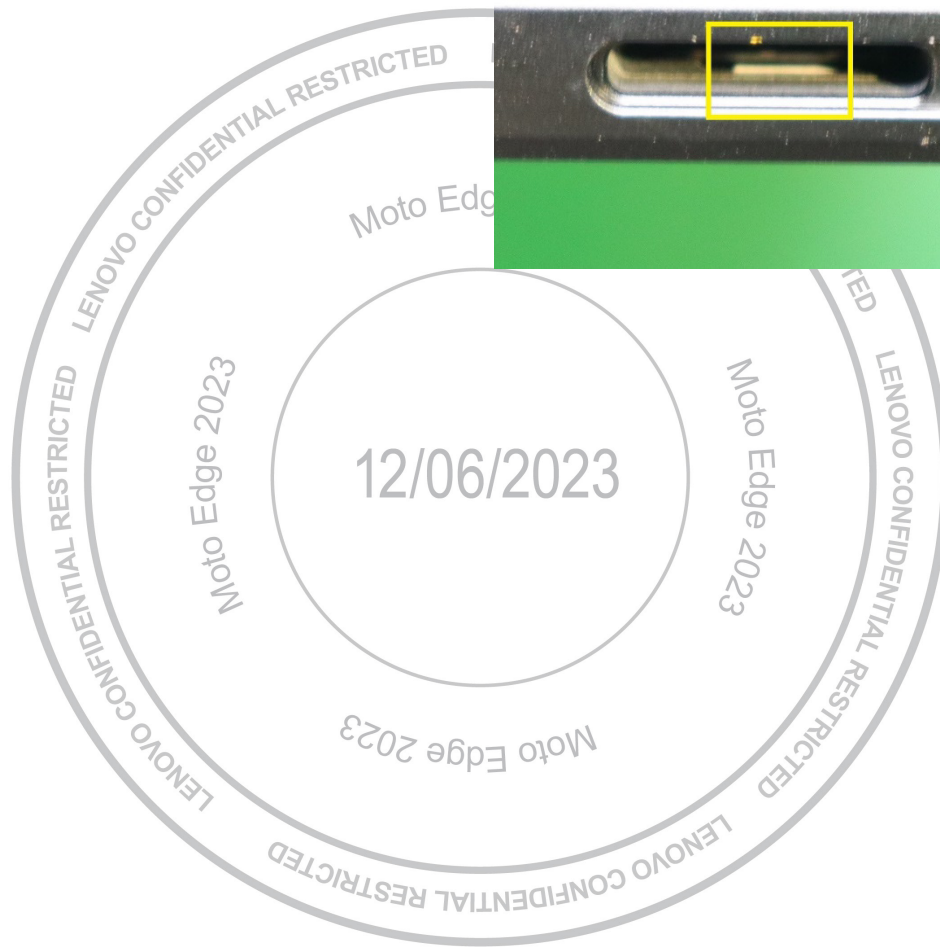
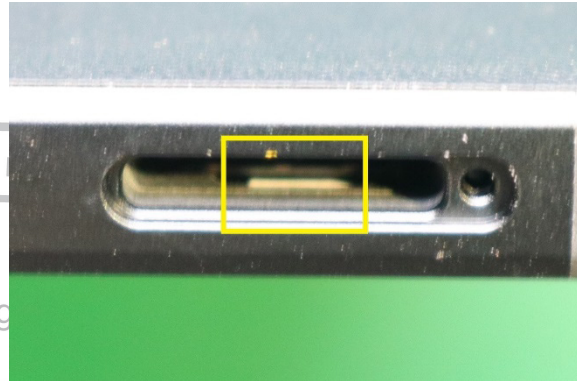


Water Detection Label Inspection

NOTE

If the Water Detection Label (WDL) 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.



// 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.
3. Remove the phone from the oven.

// CAUTION //

Wear protective gloves when handling heated phones.

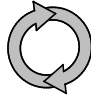
NOTE

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

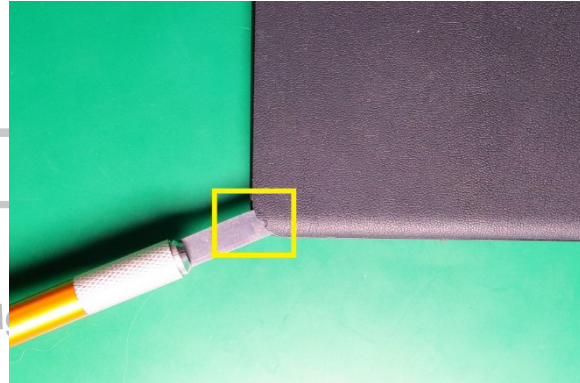
Battery Cover Removal

NOTE

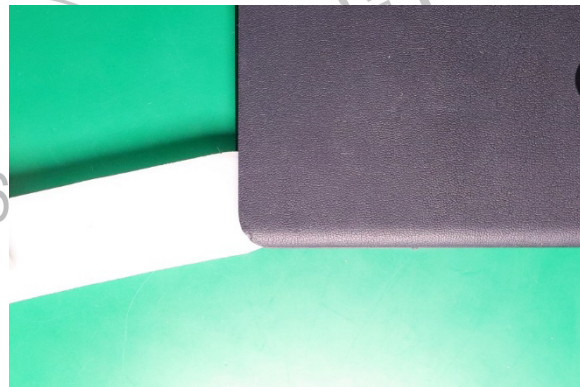
The Battery Cover can be recovered and reused after removal if it is undamaged.



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



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

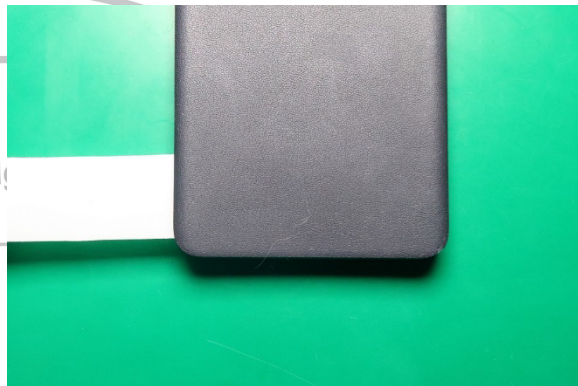


//CAUTION//

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

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



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



5. Split the Battery Cover from the phone.



Top Bracket Removal

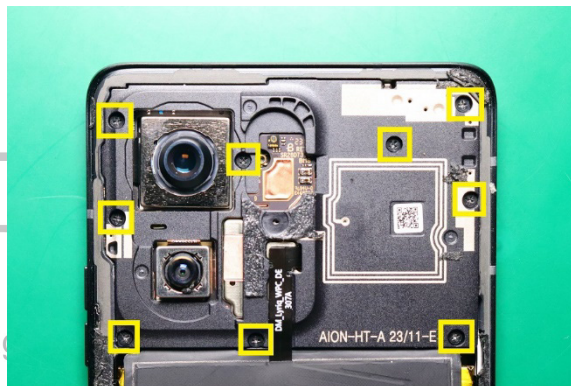
NOTE

The Top Bracket can be recovered and reused after removal.

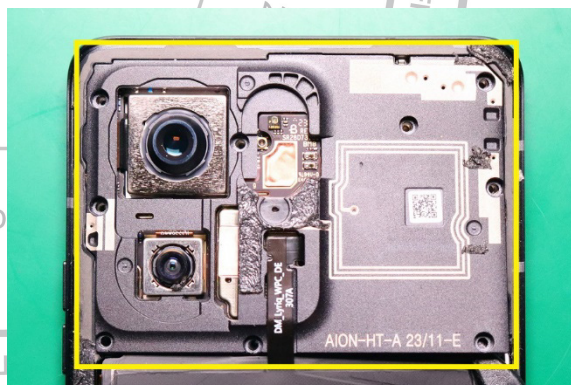


1. Use the Torque Driver with PH00 Bit to remove nine screws as shown.

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



2. Use the pointed end of the Black Stick to lift the Top Bracket from the location as shown.

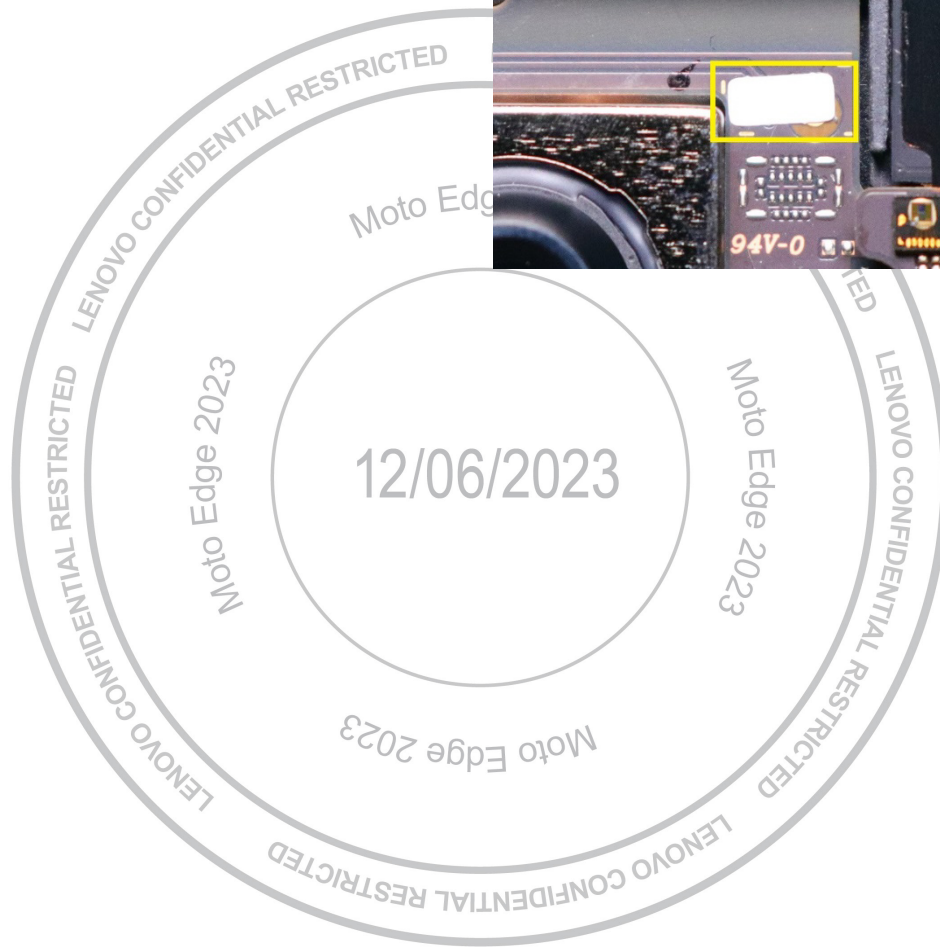
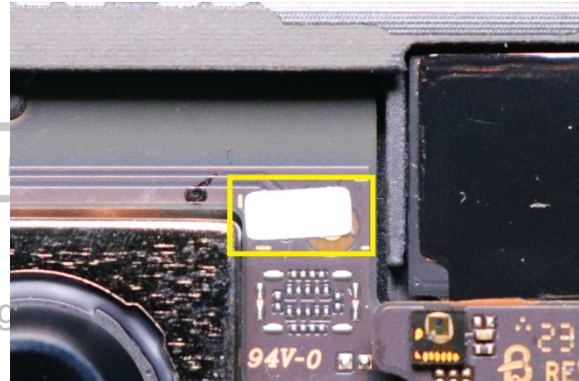


Water Detection Label Inspection

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.



Bottom Bracket Removal

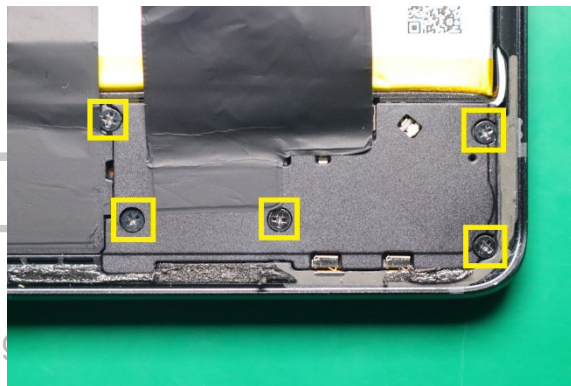
NOTE

The Bottom Bracket can be recovered and reused after removal.

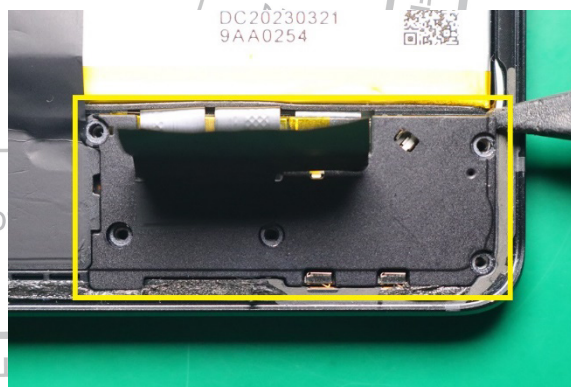


1. Use the Torque Driver with PH00 Bit to remove five screws as shown.

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



2. Use the pointed end of the Black Stick to lift the Bottom Bracket from the location as shown.

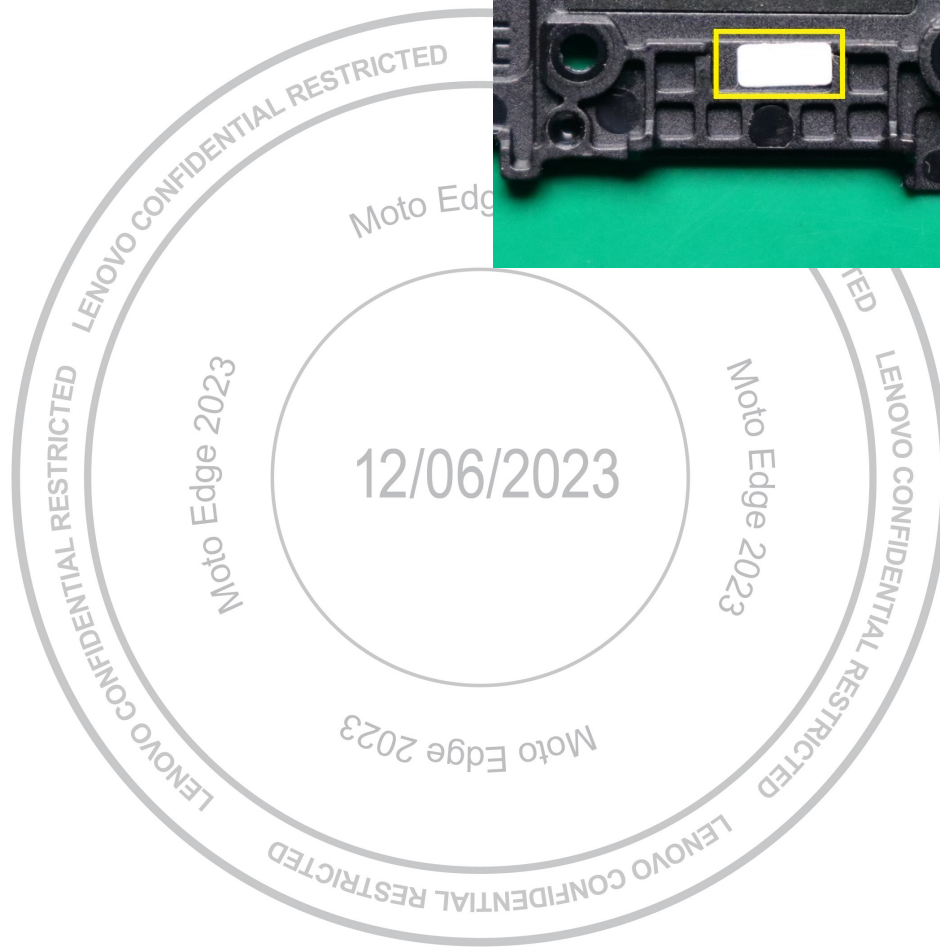
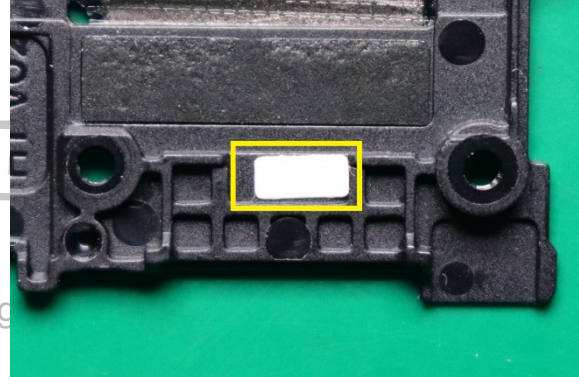


Water Detection Label Inspection

NOTE

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

Inspect the WDL on the Bottom Bracket for signs of activation.



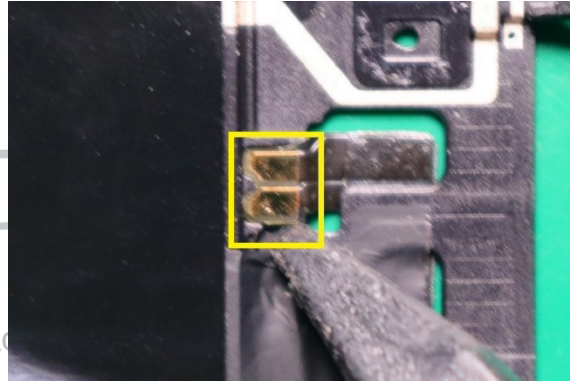
Wireless Charging Module Removal

NOTE

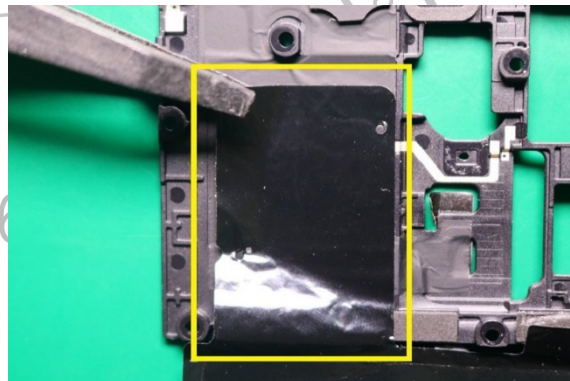
After you remove the Wireless Charging Module, you cannot reuse it.



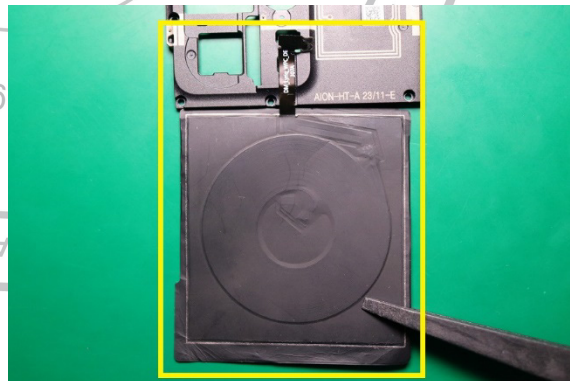
1. Use the pointed end of the Black Stick to disengage the Wireless Charging Module FPC from the location as shown.



2. Use the Plastic Tweezer to peel off the heat spreader from the location as shown.



3. Use the Plastic Tweezer to remove the Wireless Charging Module from the location as shown.



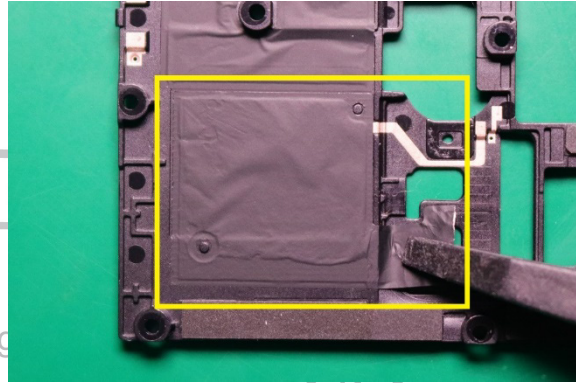
NFC Heat Spreader Removal

NOTE

After you remove the NFC Heat Spreader, you cannot reuse it.



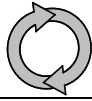
Use the Plastic Tweezer to remove the NFC Heat Spreader from the location as shown.



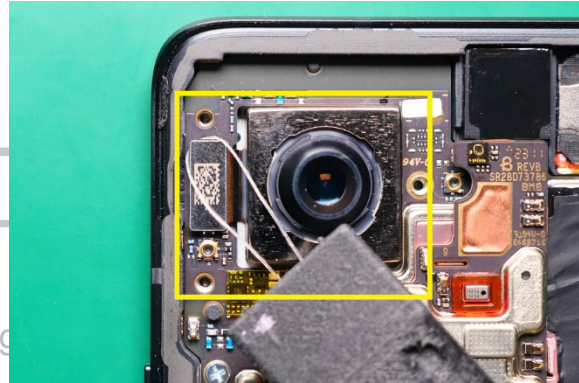
50M Rear-Facing Camera Removal

NOTE

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



1. Use the BtB tool to disengage the 50M Rear-Facing Camera BtB Connector from the location as shown.
2. Use the pointed end of the Black Stick to remove the 50M Rear-Facing Camera from the location as shown.



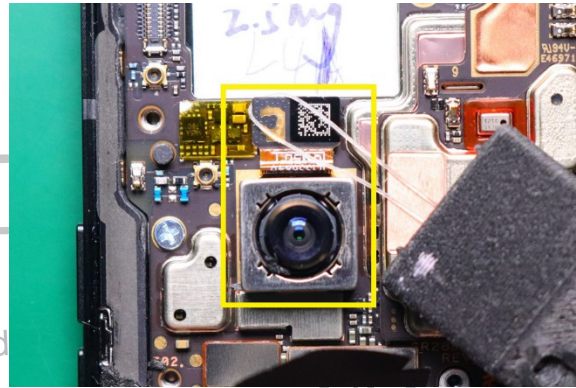
13M Rear-Facing Camera Removal

NOTE

The 13M Rear-Facing Camera can be recovered and reused after removal.



Use the BtB tool to disengage and remove the 13M Rear-Facing Camera from the location as shown.



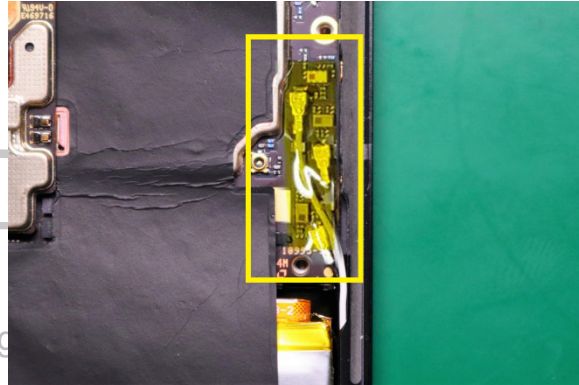
Cable ESD Mylar Removal

NOTE

After you remove the Cable ESD Mylar, you cannot reuse it.



Use the Plastic Tweezer to remove the Cable ESD Mylar from the location as shown.



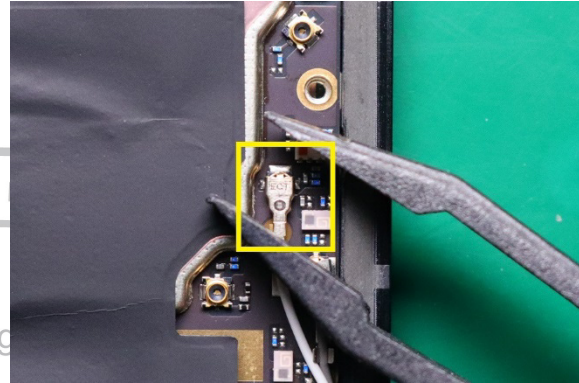
Main PCB Removal

NOTE

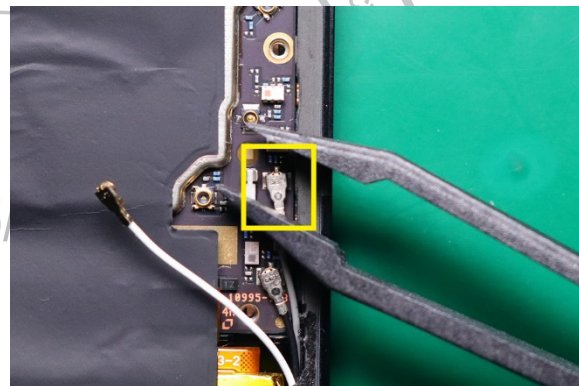
The Main PCB can be recovered and reused after removal.



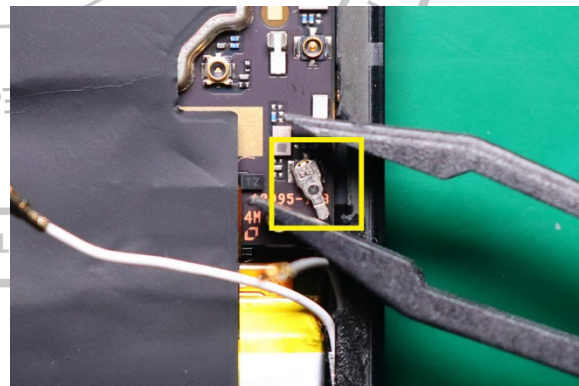
1. Use the Plastic Tweezer to disconnect the White Coax Cable from the location as shown.



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



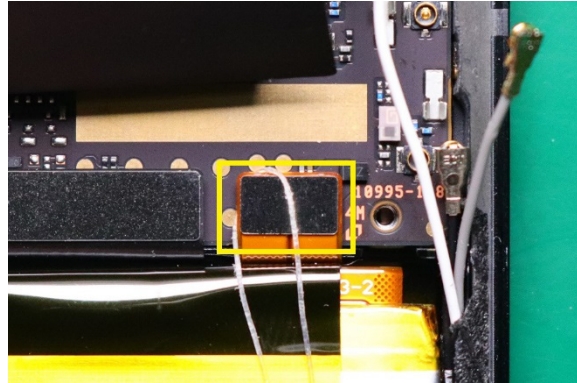
3. Use the Plastic Tweezer to disconnect the Black Coax Cable from the location as shown.



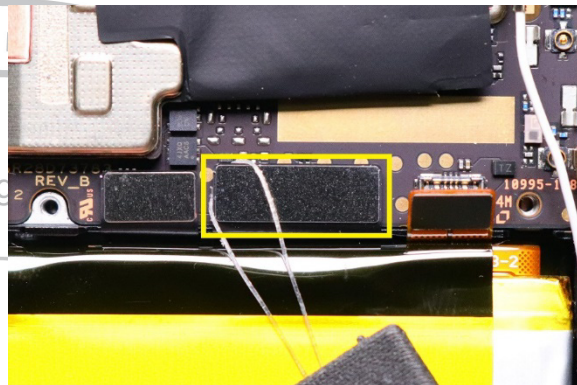
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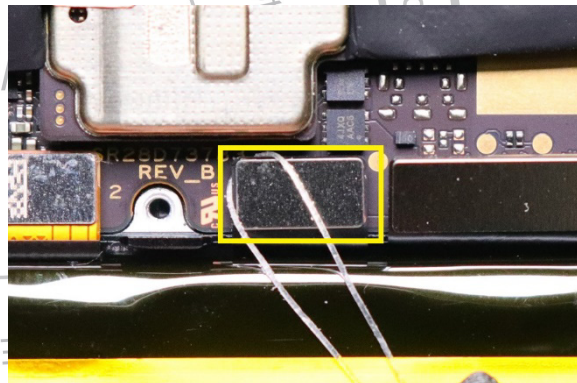
4. Use the BtB tool to disengage the Battery BtB Connector from the Main PCB as shown.



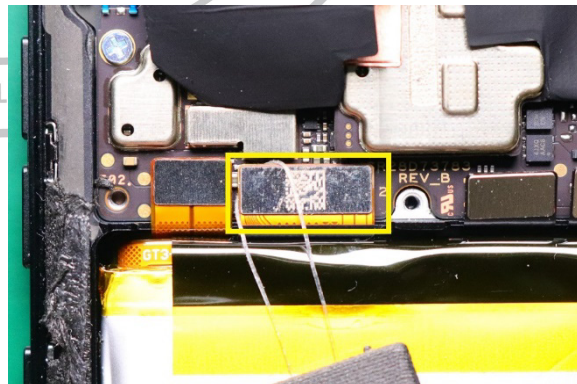
5. Use the BtB tool to disengage the Main FPC BtB Connector from the Main PCB as shown.



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



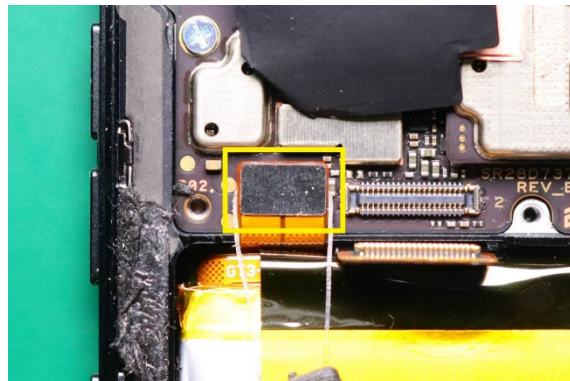
7. Use the BtB tool to disengage the Display Flex BtB Connector from the Main PCB as shown.



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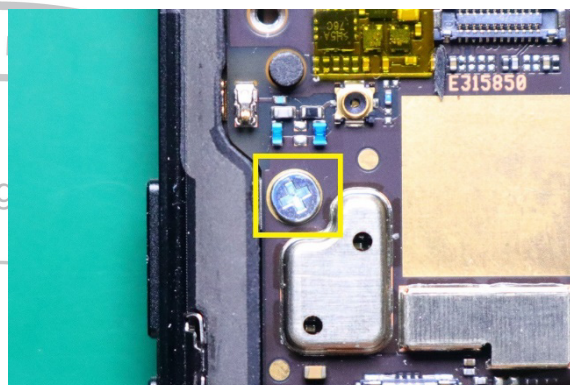
Level 2 – Service and Repair Manual

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



- Use the Torque Driver with PH00 Bit to remove the screw 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



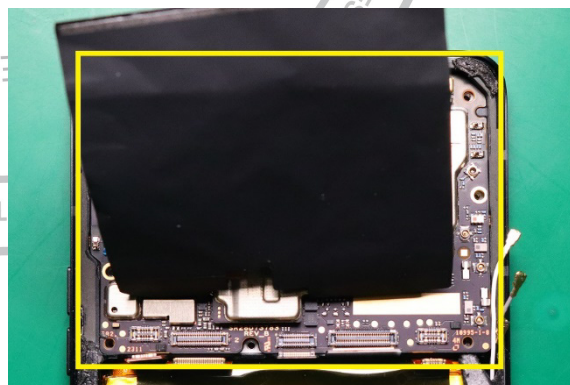
- Use the pointed end of the Black Stick to lift the Main PCB from the location as shown.

NOTE

Carefully lift the Front-Facing Camera area since there is back adhesive for Front-Facing camera.

NOTE

Carefully lift the Main PCB to avoid damaging the Main PCB, BtB connectors and Coax Cable.



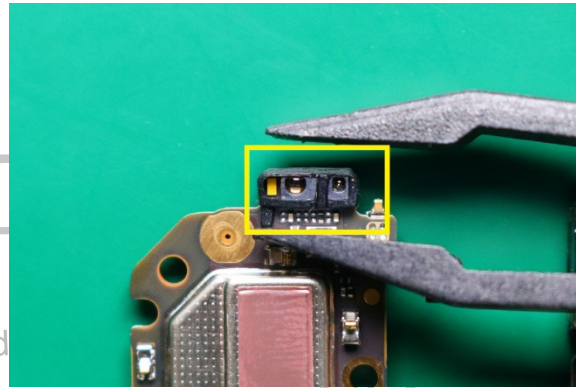
Proximity Sensor Grommet Removal

NOTE

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



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



Stack Board Removal

NOTE

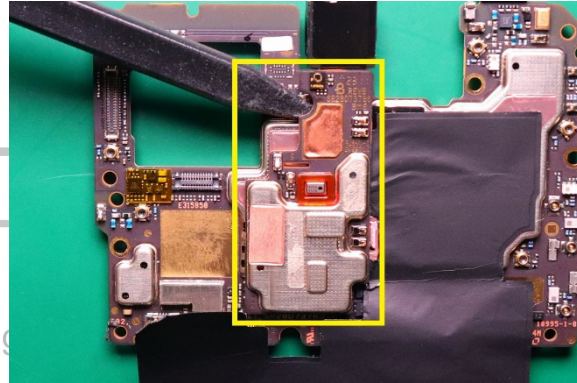
The Stack Board can be recovered and reused after removal.



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

NOTE

Carefully lift the Stack Board to avoid damage since there is back adhesive for the Stack Board.



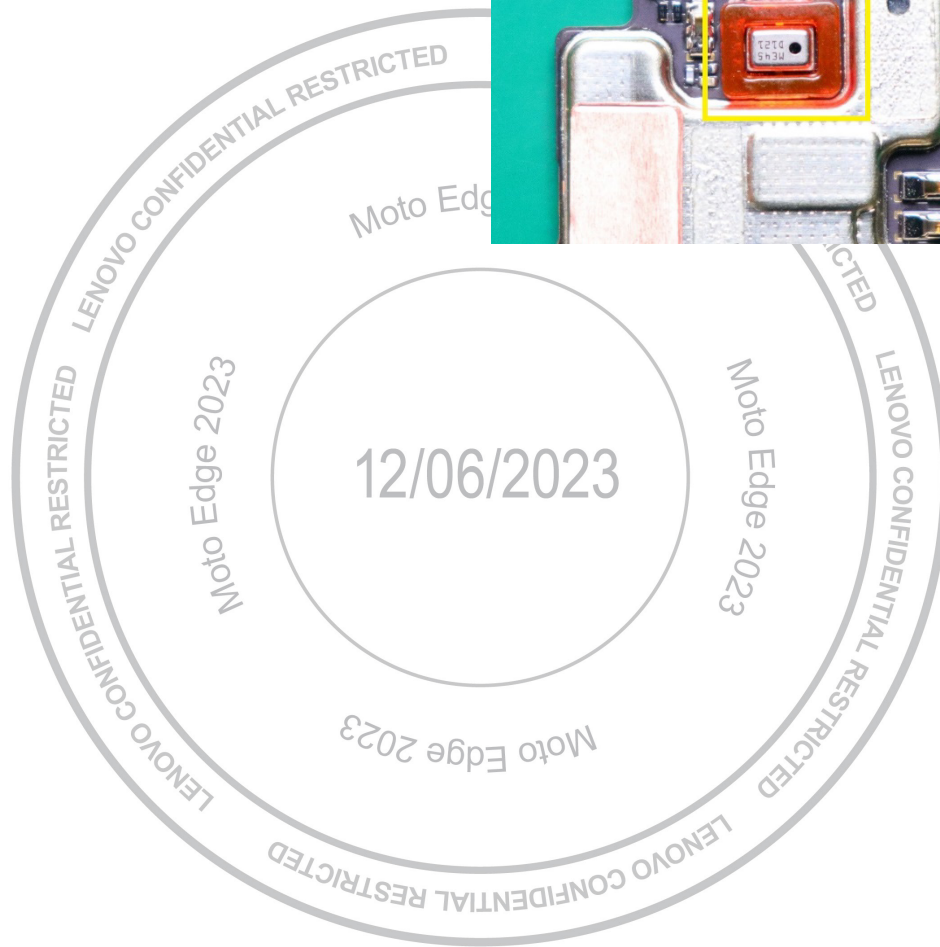
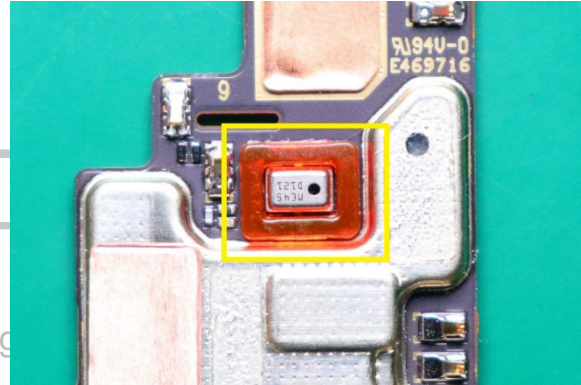
Mic 3 Bracket Removal

NOTE

After you remove the Mic 3 Bracket, you cannot reuse it.



Use the Plastic Tweezer to disengage and remove the Mic 3 Bracket from the location as shown.



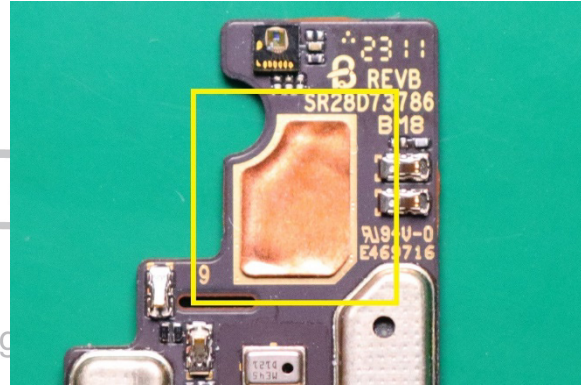
Stack Board Flash Copper Foil Removal

NOTE

After you remove the Stack Board Flash Copper Foil, you cannot reuse it.



Use the Plastic Tweezer to remove the Stack Board Flash Copper Foil from the location as shown.



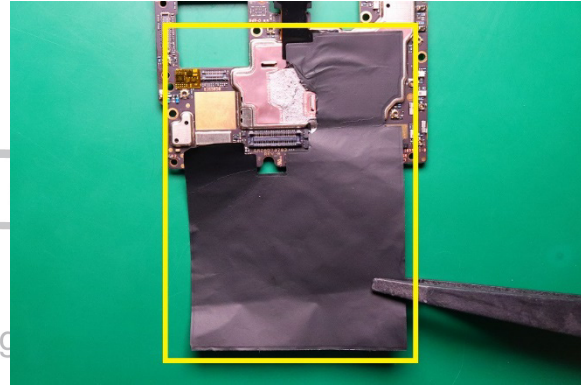
Main PCB Back Heat Spreader Removal

NOTE

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



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



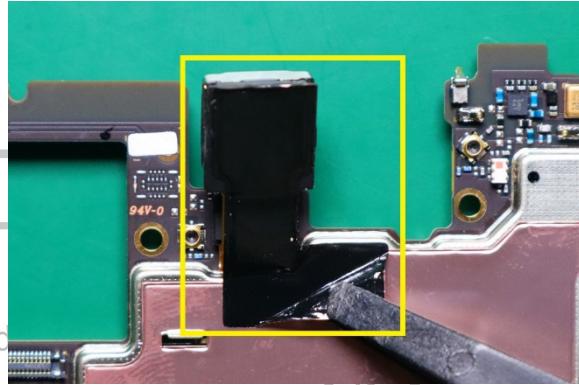
Front-Facing Camera Copper Foil Removal

NOTE

After you remove the Front-Facing Camera Copper Foil, you cannot reuse it.



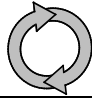
Use the Plastic Tweezer to remove the Front-Facing Camera Copper Foil from the location as shown.



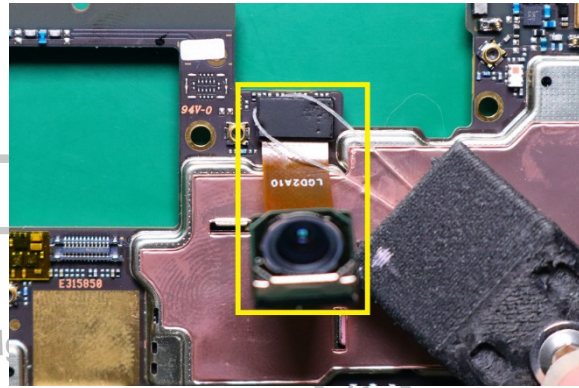
Front-Facing Camera Removal

NOTE

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



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



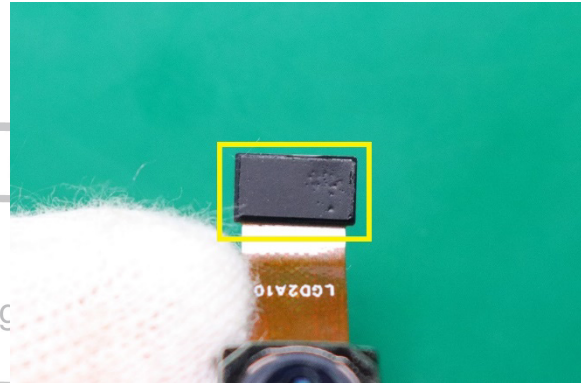
Front-Facing Camera Connector Foam Removal

NOTE

After you remove the Front-Facing Camera Connector Foam, you cannot reuse it.



Use the Plastic Tweezer to remove the Front-Facing Camera Connector Foam from the location as shown.



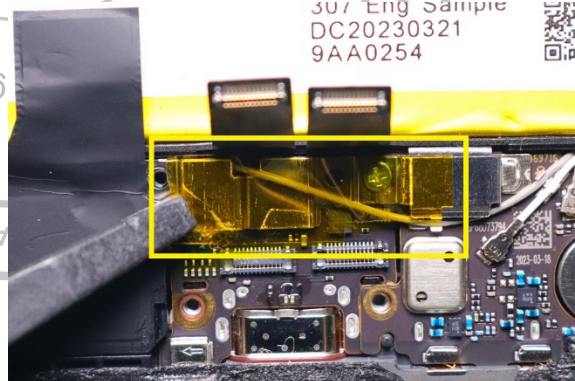
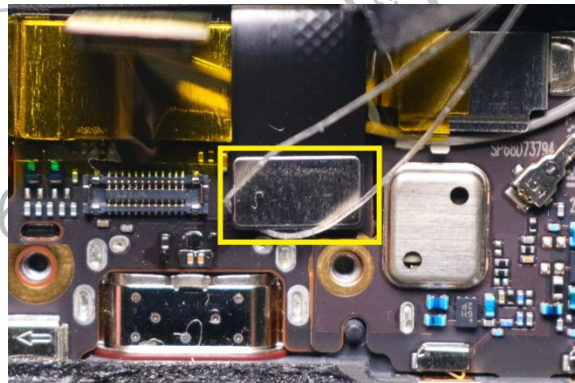
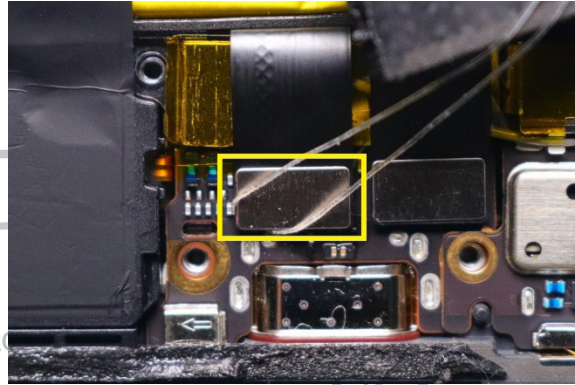
Main FPC Mylar Removal

NOTE

After you remove the Main FPC Mylar, you cannot reuse it.



1. Use the BtB tool to disengage the Main FPC BtB Connector from the USB Sub Board as shown.
2. Use the BtB tool to disengage the Main FPC BtB Connector from the USB Sub Board as shown.
3. Use the Plastic Tweezer to remove the Main FPC Mylar from the location as shown.



FOD Bracket Removal

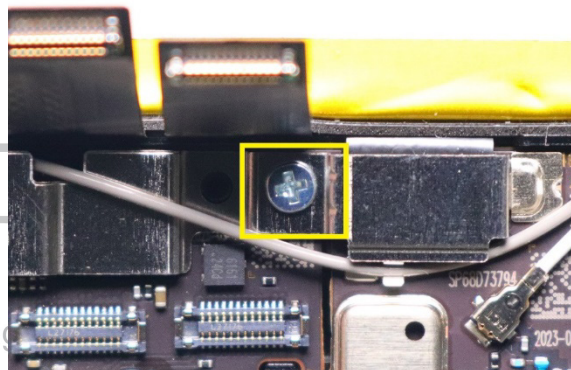
NOTE

The FOD Bracket can be recovered and reused after removal.



1. Use the Torque Driver with PH00 Bit to remove the screw 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



2. Use the Plastic Tweezer to remove the FOD Bracket from the location as shown.

NOTE

Carefully lift the FOD Bracket to avoid damaging the Grey Coax Cable.



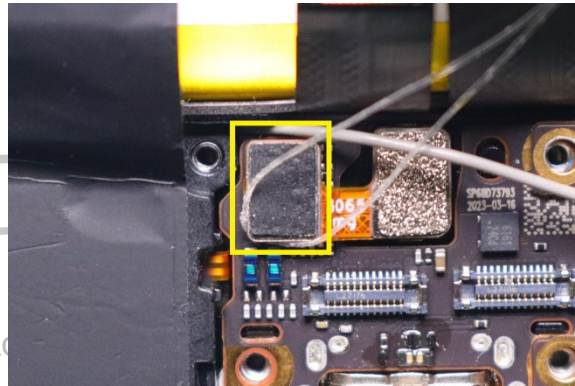
FOD Sensor Removal

NOTE

The FOD Sensor can be recovered and reused after removal.



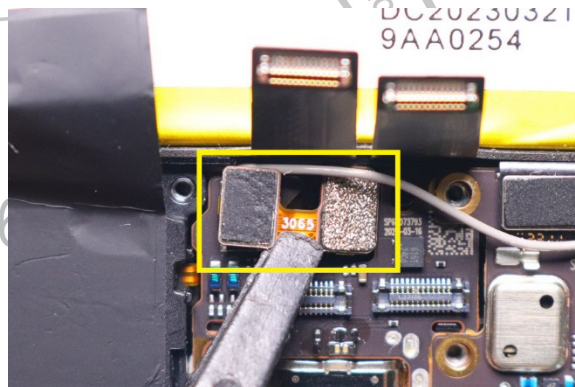
1. Use the BtB tool to disengage the FOD Sensor BtB Connector from the USB Sub Board as shown.



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

NOTE

Carefully lift the FOD Sensor to avoid damage since there is back adhesive for the FOD Sensor.



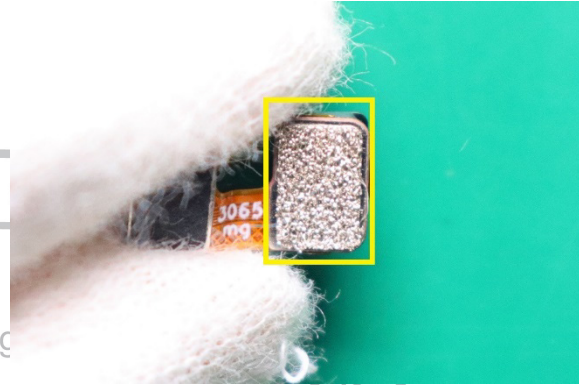
FOD Sensor Bracket Foam 2 Removal

NOTE

After you remove the FOD Sensor Bracket Foam 2, you cannot reuse it.



Use the Plastic Tweezer to remove the FOD Sensor Bracket Foam 2 from the location as shown.



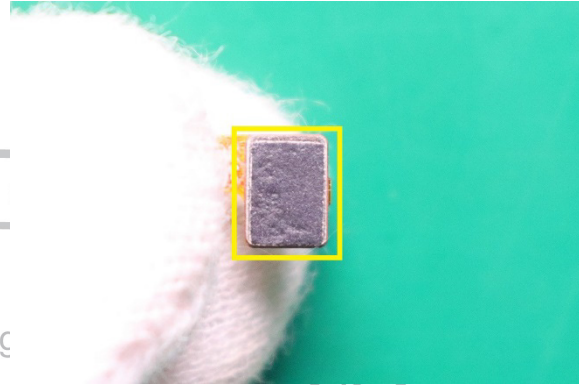
FOD Sensor Bracket Foam 3 Removal

NOTE

After you remove the FOD Sensor Bracket Foam 3, you cannot reuse it.



Use the Plastic Tweezer to remove the FOD Sensor Bracket Foam 3 from the location as shown.



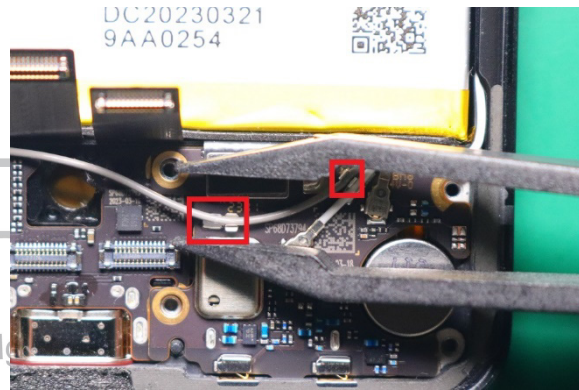
SIM Sub Board Removal

NOTE

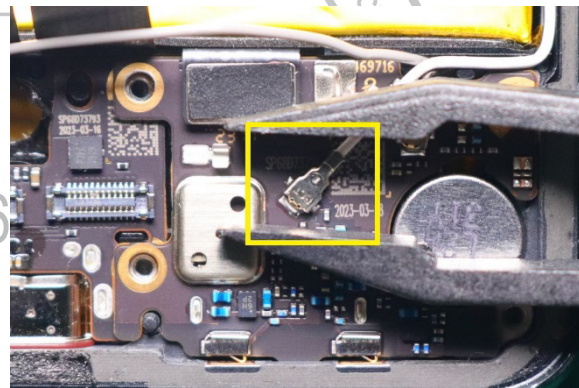
The SIM Sub Board can be recovered and reused after removal.



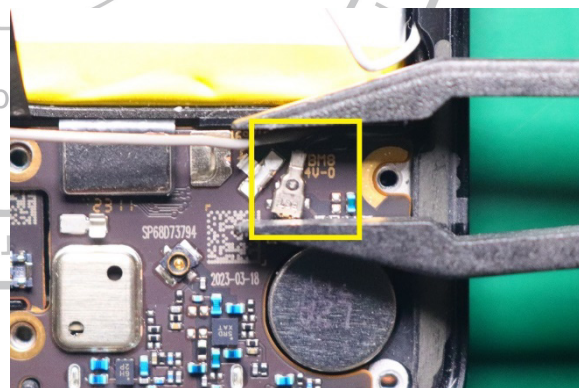
1. Use the Plastic Tweezer to remove the Grey Coax Cable from the cable guide from the location as shown.



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



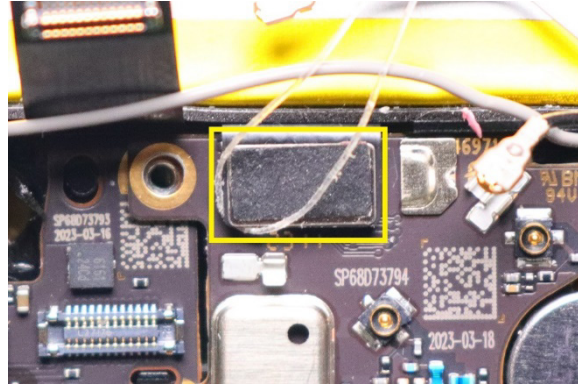
3. Use the Plastic Tweezer to disconnect the Black Coax Cable from the location as shown.



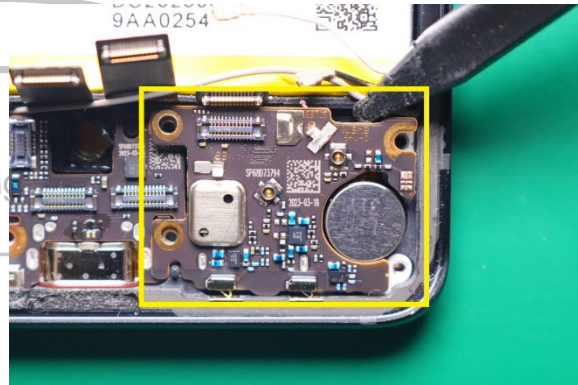
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4. Use the BtB tool to disengage the Main FPC BtB Connector from the SIM Sub Board as shown.



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



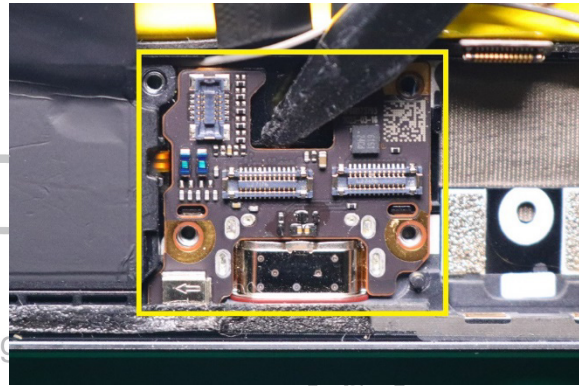
USB Sub Board Removal

NOTE

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



Use the Plastic Tweezer to lift and remove the USB Sub Board from the location as shown.



Speaker Box Removal

NOTE

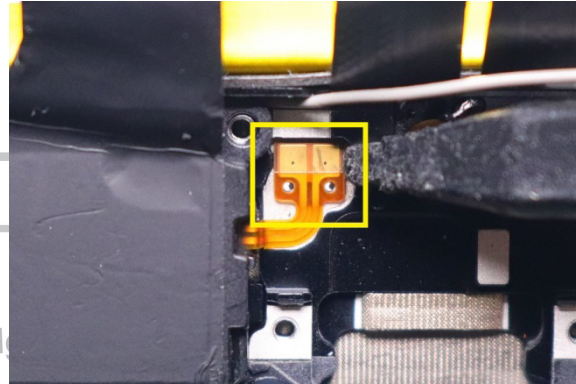
The Speaker Box can be recovered and reused after removal.



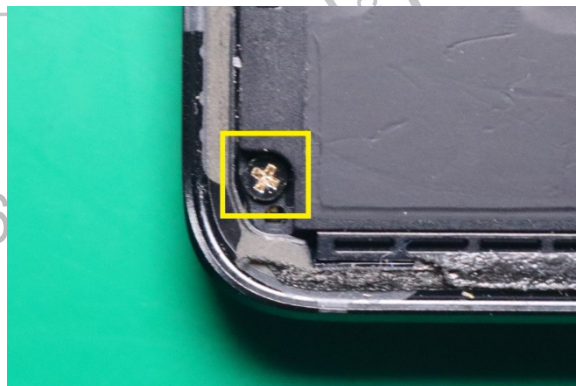
1. Use the pointed end of the Black Stick to disengage the Speaker Box FPC from the location as shown.

NOTE

Carefully disengage the Speaker Box FPC since there is back adhesive for Speaker Box FPC.

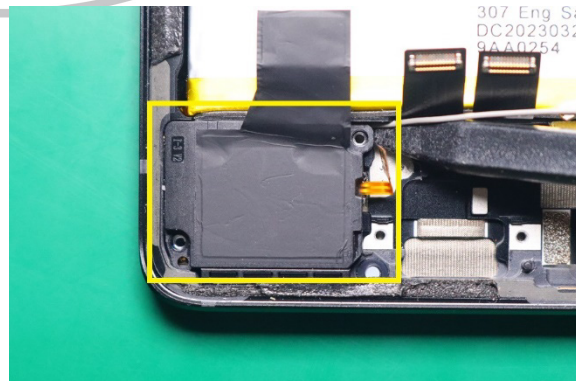


2. Use the Torque Driver with PH00 Bit to remove the screw as shown.



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

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



RF Sub Board Removal

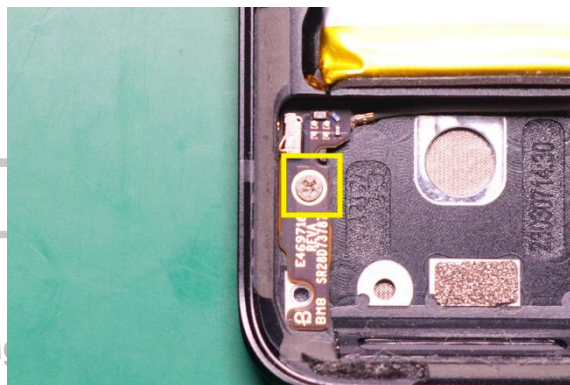
NOTE

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



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

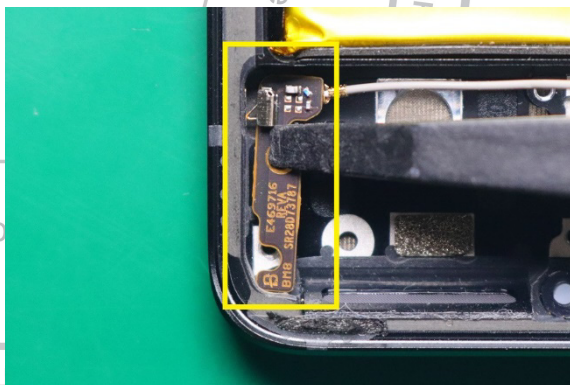
Screw Reuse Policy	
North America	No
Latin America & Caribbean	Yes
East Europe	Yes
West Europe	Yes
Middle East & Africa	Yes
Southern & Pacific Asia	Yes
Oceania & Japan	No



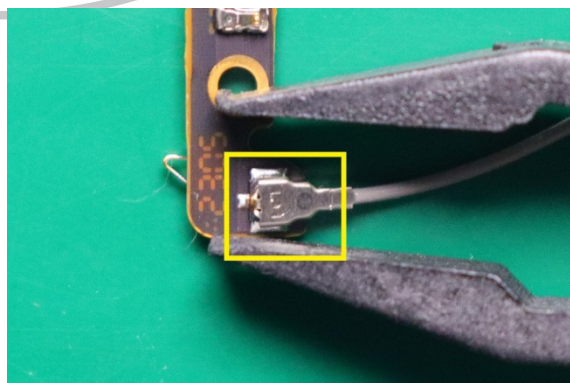
2. Use the Black Tweezer to remove the RF Sub Board from the location as shown.

NOTE

Carefully remove the RF Sub Board since the Grey Coax Cable is connected to the back of RF Sub Board.



3. Turn over the RF Sub Board and use the Plastic Tweezer to disconnect the Grey Coax Cable from the location as shown.



Battery Removal

Battery Removal Method A

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.

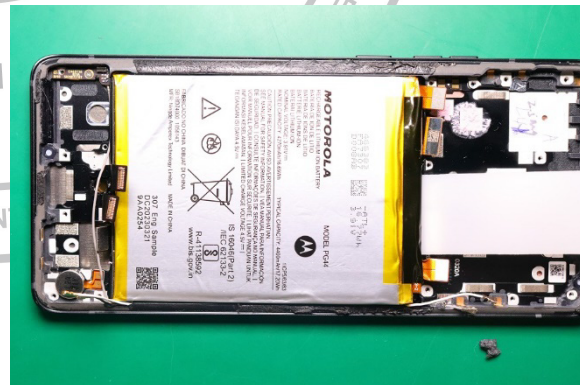
NOTE

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.



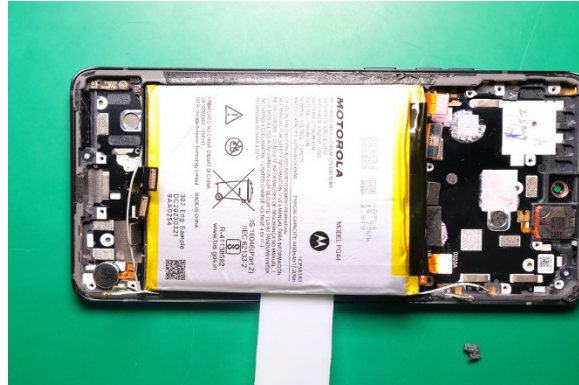
3. Wait 10 minutes for the adhesive to warm up.
4. Use the Thin Plastic Spudger to cut the adhesives from the top of the Battery.



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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

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.

4. Turn on the Freezing Separator.

NOTE

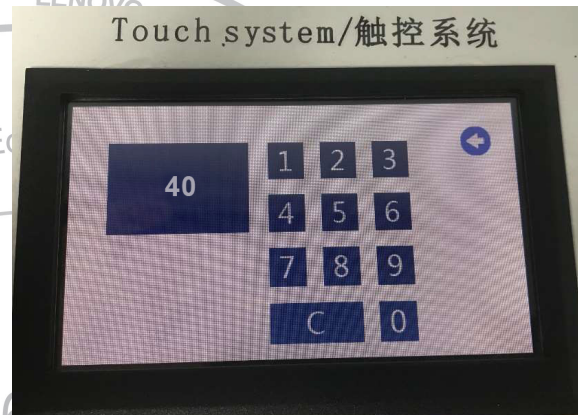
The switch is on the back.



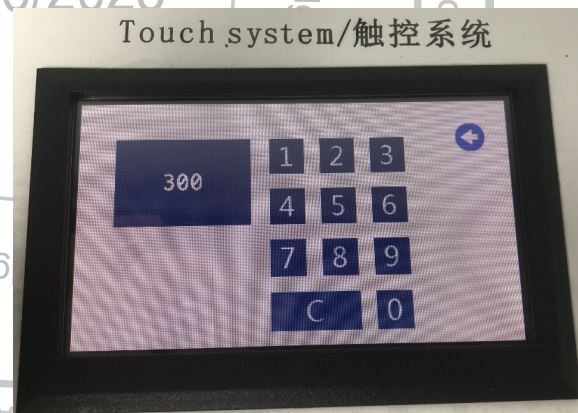
5. Select the Language menu and set the desired language.



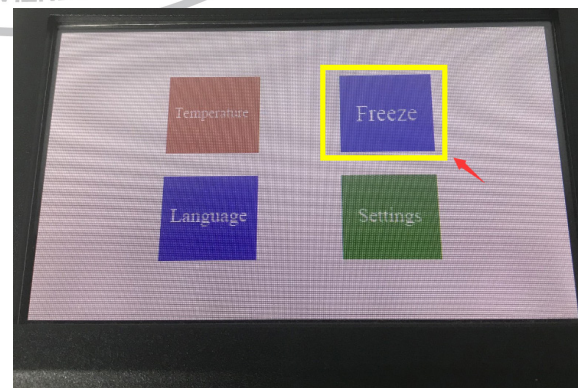
6. Select the settings menu, set the temperature and Freezing times.
Set the temperature to -40°C: Click the temperature menu, enter 40 on the screen number. Then press the arrow in the upper right corner to return.



7. 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.



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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.

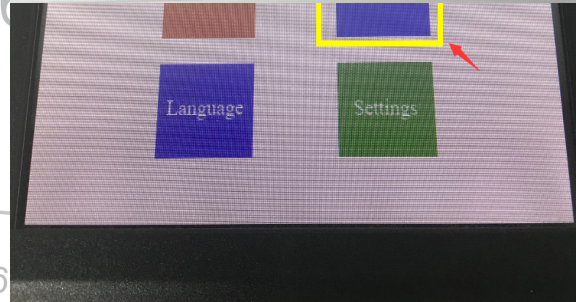
NOTE

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.



12. Click the start menu.

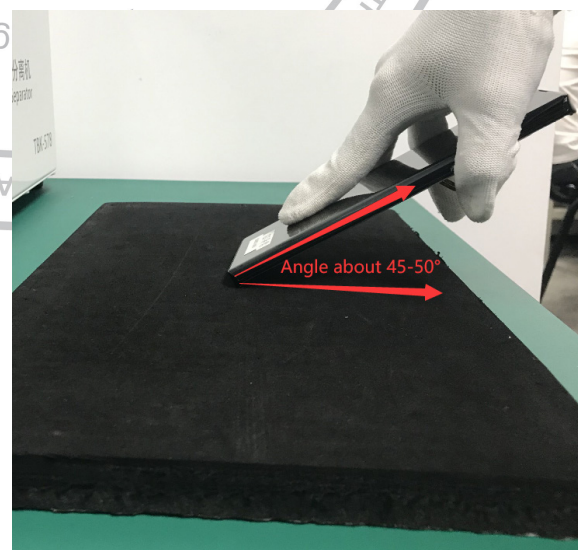


13. After clicking the Start menu, Start the countdown, and freeze it for 5 minutes. When the countdown time reaches, the device will alarm and ring three times.
14. Open the door. Take out one Display at the time with wearing cotton gloves. Take out the Display in the order it was put in.

NOTE

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

15. Remove the Battery:
16. Take out the frozen assembly from the bags.
17. 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.
18. After the Battery removed. Immediately put the Batteries and Display into two different sealed bag and sealed into bags for temperature return.



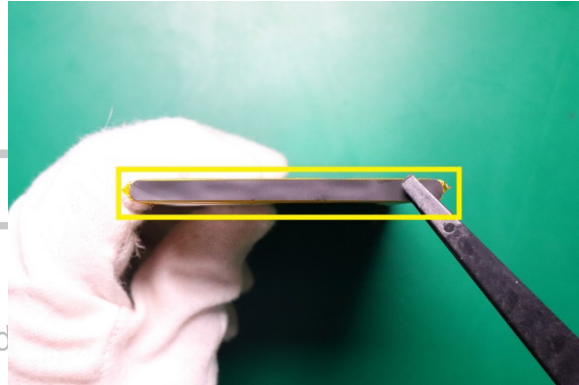
Battery Buffer Foam Removal

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.



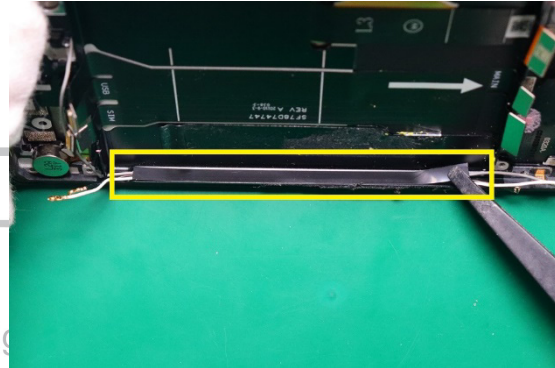
Coax Cable Mylar Removal

NOTE

After you remove the Coax Cable Mylar, you cannot reuse it.



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



White Coax Cable Removal

NOTE

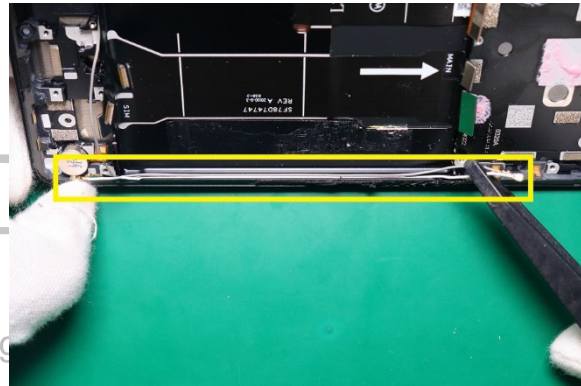
The White Coax Cable can be recovered and reused after removal.



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.



Black Coax Cable Removal

NOTE

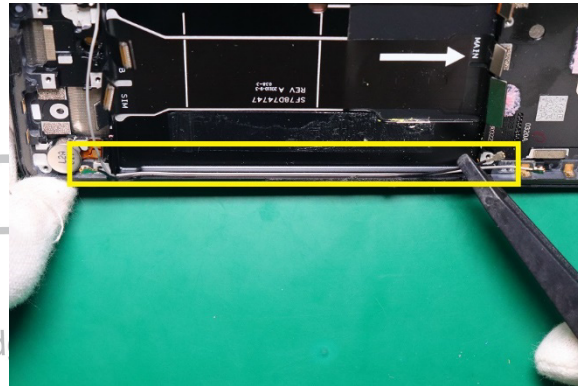
The Black Coax Cable can be recovered and reused after removal.



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.



Grey Coax Cable Removal

NOTE

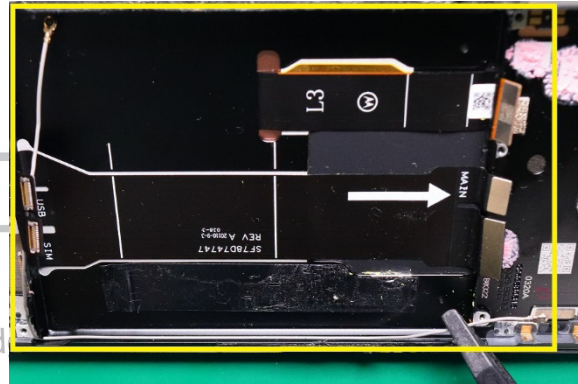
The Grey Coax Cable can be recovered and reused after removal.



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

NOTE

Coax cable cannot be reused in North America refurbish operation.



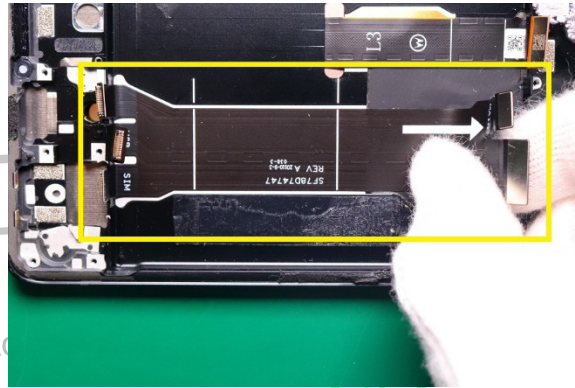
Main FPC Removal

NOTE

The Main FPC can be recovered and reused after removal.



Use fingers to peel off the Main FPC from the location as shown.



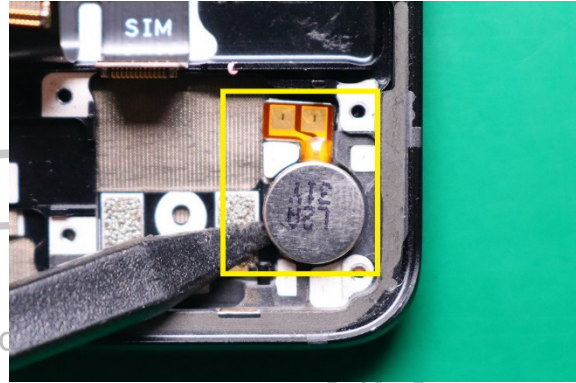
Vibrator Removal

NOTE

After you remove the Vibrator, you cannot reuse it.



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



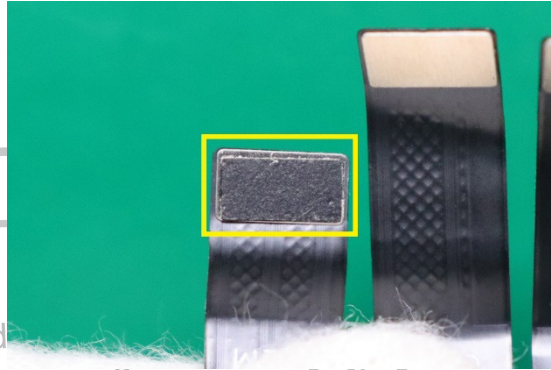
FOD Sensor Bracket Foam 1 Removal

NOTE

After you remove the FOD Sensor Bracket Foam 1, you cannot reuse it.



Use the Plastic Tweezer to remove the FOD Sensor Bracket Foam 1 from the location as shown.



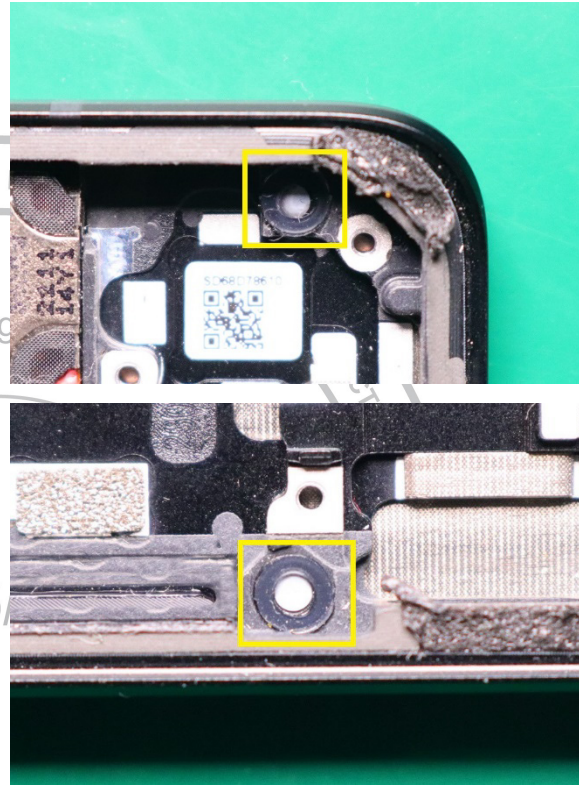
Mic 1&2 Mesh Removal

NOTE

After you remove the Mic 1&2 Mesh, you cannot reuse it.



Use the pointed end of the Black Stick to disengage and remove the Mic 1&2 Mesh from the locations as shown.



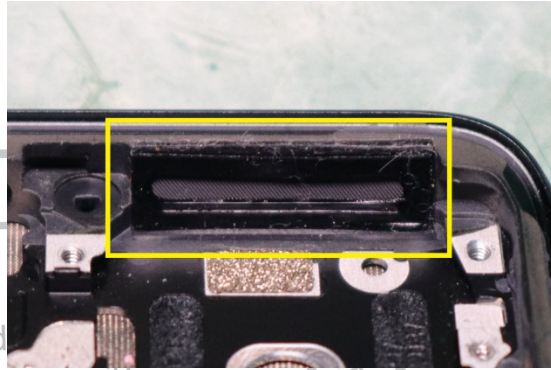
Speaker Box Mesh Removal

NOTE

After you remove the Speaker Box Mesh, you cannot reuse it.



Use the Plastic Tweezer to remove the Speaker Box Mesh from the location as shown.



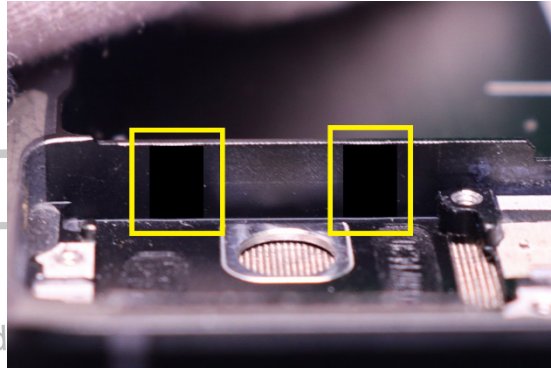
Front-Housing Box Mylar Removal

NOTE

After you remove the Front-Housing Box Mylar, you cannot reuse it.



Use the Plastic Tweezer to remove two pieces of the Front-Housing Box Mylar from the location as shown.



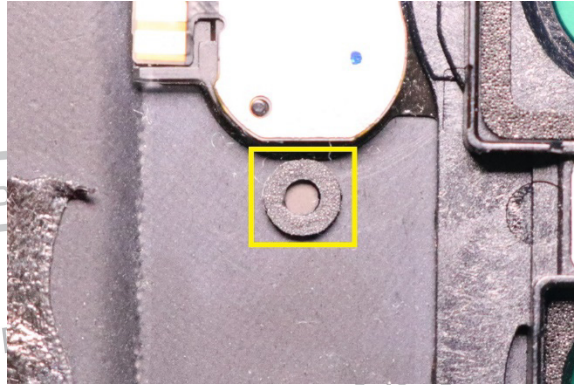
Mic 3 Mesh Removal

NOTE

After you remove the Mic 3 Mesh, you cannot reuse it.



Use the pointed end of the Black Stick to disengage and remove the Mic 3 Mesh from the location as shown.



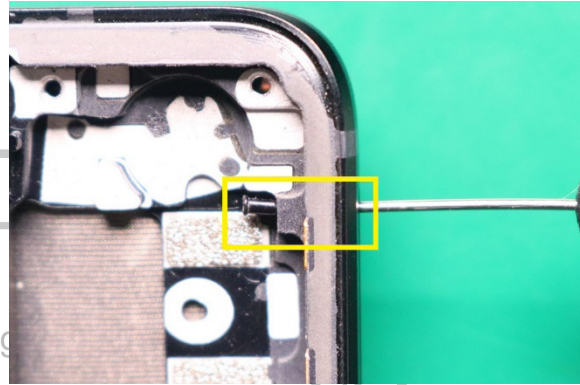
Eject Pin Removal

NOTE

After you remove the Eject Pin, you cannot reuse it.



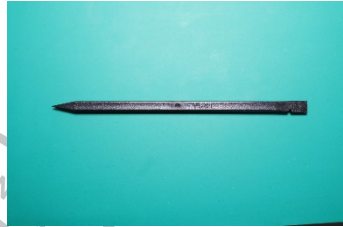
Use the SIM Tray Removal Tool to push out the Eject Pin from the location as shown.



PARTS REFRESH

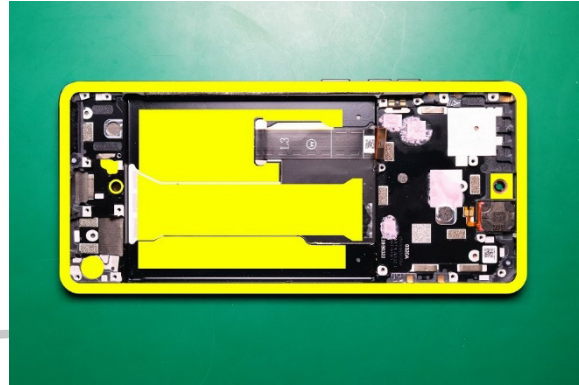
Tools Required for Parts Refresh

The following tools are required for parts refresh of the Moto Edge 2023.

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

Front-Housing Cleaning

Use the ISP Alcohol and Cotton Swabs to remove all the adhesives on the Front-Housing as shown.

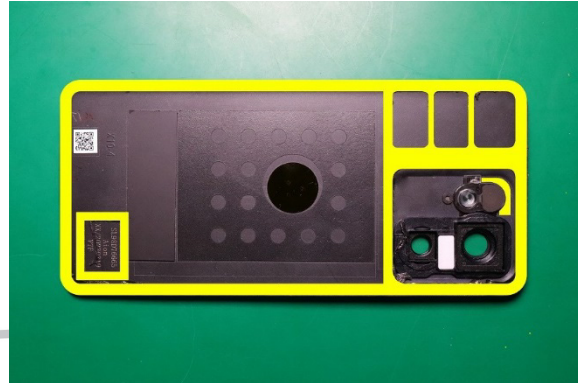


Battery Cover Cleaning

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

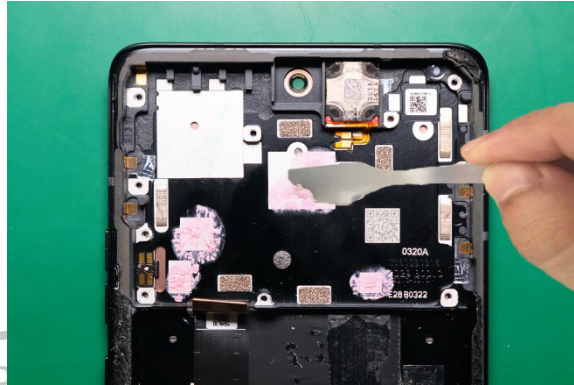
/// CAUTION ///

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



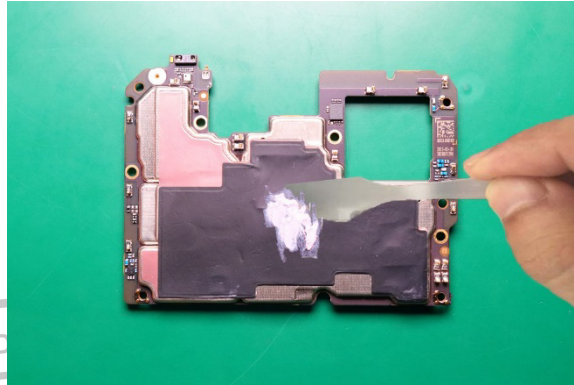
Front-Housing Cleaning

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



Main PCB Cleaning

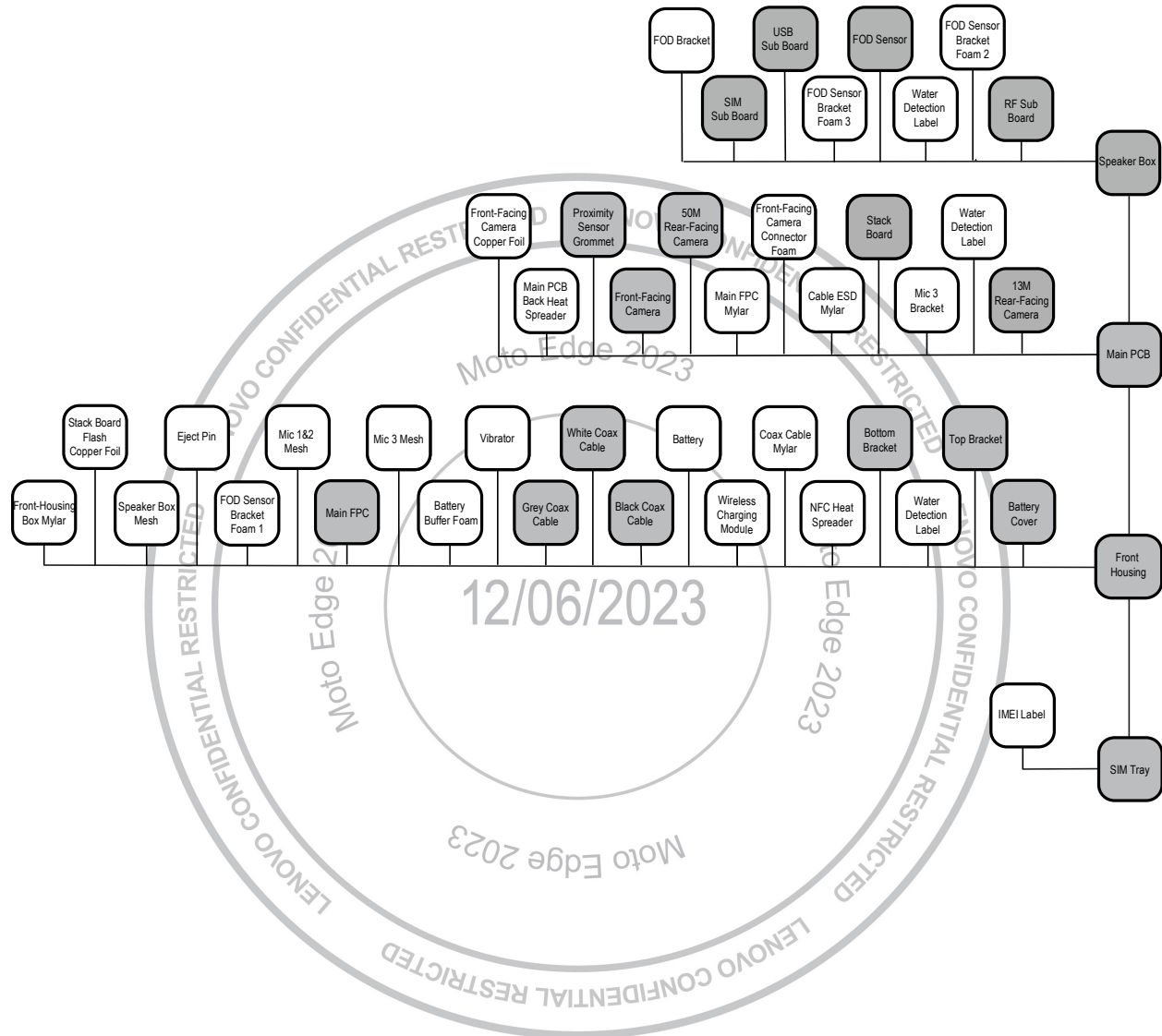
Use Plastic Scraper to remove the most part of Thermal putty from the Front-Housing.



ASSEMBLY

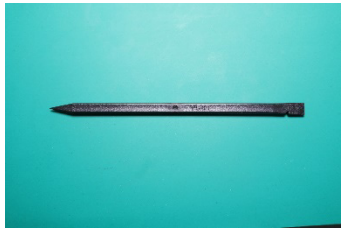





Assembly Map

*Shaded parts may be eligible for parts recovery.


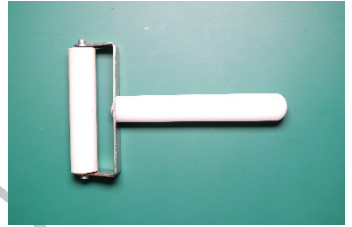



Tools Required for Assembly

The following tools are required to assemble the Moto Edge 2023.

<i>Description</i>	<i>Part #</i>	<i>Picture/Drawing</i>
Black Stick	--	
Torque Driver	--	
PH00 Bit	--	
Regen-I Pneumatic Press System https://www.regeni.com/	RG262	
Inlay press - holder with pad Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-S2-10000	
Inlay press - holder with pad Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-S3-10000	

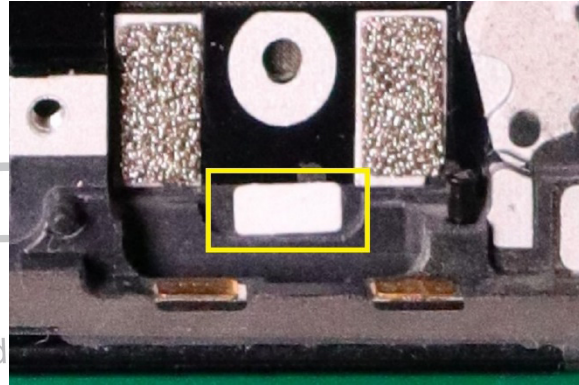
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<i>Description</i>	<i>Part #</i>	<i>Picture/Drawing</i>
Battery Cover Adhesive Alignment Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-S1-10000	
Manual Roller	--	
AP-111 Note: 3M N200 or 3M K500 can be alternative material for 3M AP-111.	-	
Cotton Swabs	-	-
Plastic Tweezers	--	-
Tweezers	--	-
Gloves or Finger Collets	--	-

Water Detection Label Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,WATERPROOF,Waterproof LBL TMO	-

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



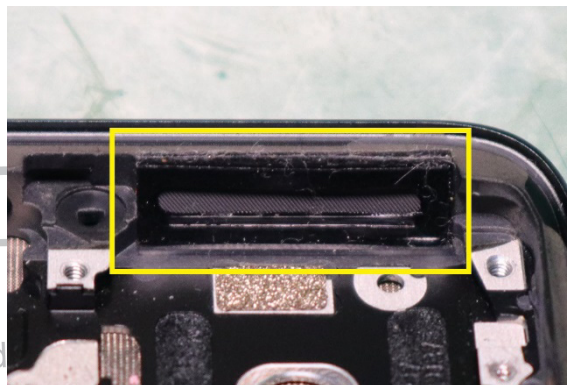
Speaker Box Mesh Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,FOAM,AION,IP68_BOX_HOLE_GASKET	48

Use the Plastic Tweezer to place the Speaker Box Mesh on the location as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



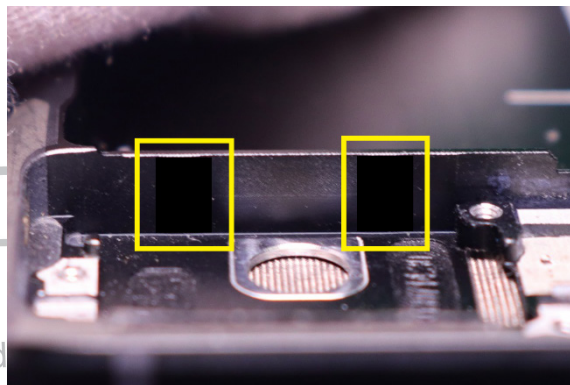
Front-Housing Box Mylar Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,PSA,AION_HSG_BOX_MYLAR	-

Use the Plastic Tweezer to place two pieces of the Front-Housing Box Mylar on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



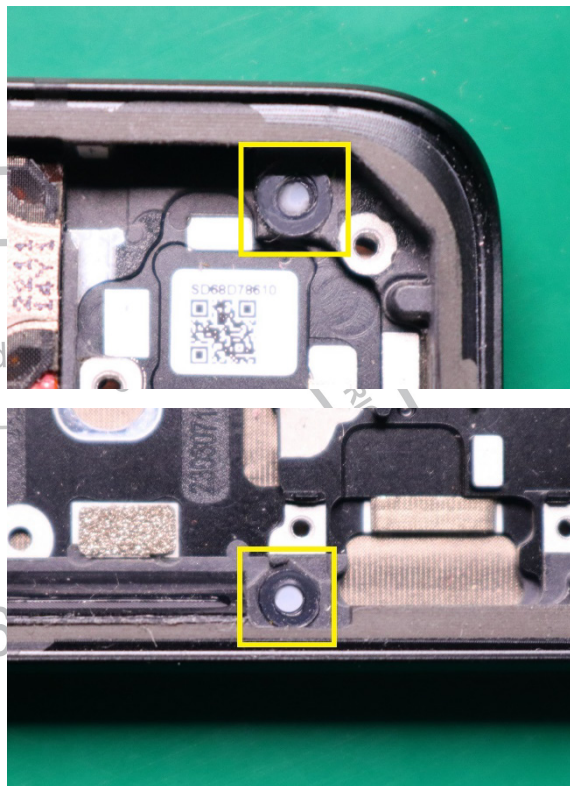
Mic 1&2 Mesh Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
Lyriq Foam_Mesh_Mic_Middle_HSG	49

Use the Plastic Tweezer to place the Mic 1&2 Mesh on the location as shown and peel off the liners.

NOTE

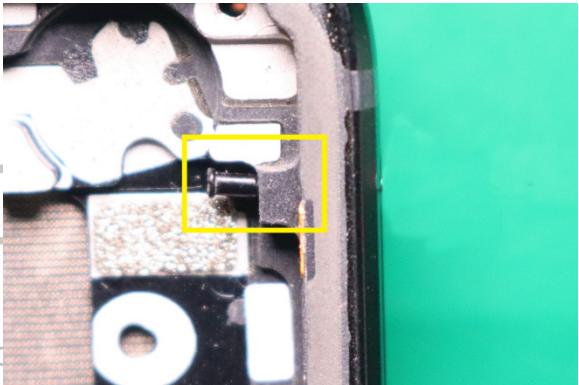
Press firmly for seconds 3 times to activate the adhesive.



Eject Pin Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
Lyriq Ejection_Pin_SIM_Tray_IP68	50

Use the Plastic Tweezer to push the Eject Pin into the slot on the Front Housing.



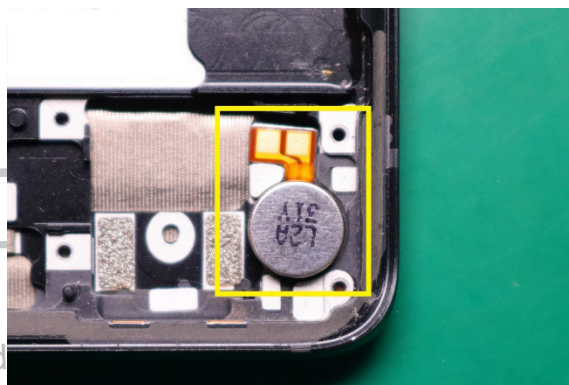
Vibrator Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
Vibrator,235Hz,D8xH3.25,L0832F-0012	18

Peel off the liner of the Vibrator and use the Plastic Tweezer to place the Vibrator on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



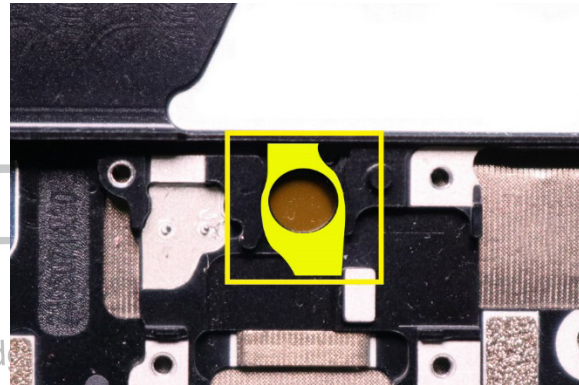
FOD Sensor Adhesive Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,FOAM,AION,FOV_ADH	35

Use the Plastic Tweezer to place the FOD Sensor Adhesive on the location as shown and do not peel off the liner at this step.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



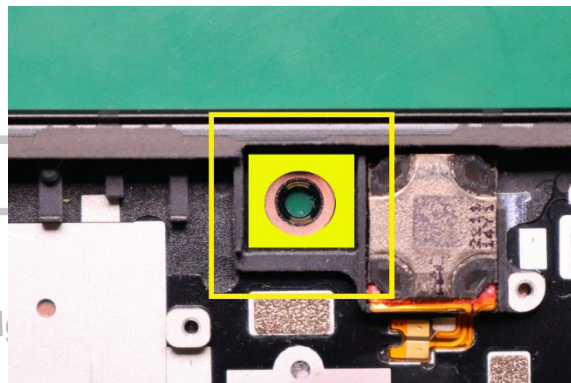
Front-Facing Camera Adhesive Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,FOAM,AION,FRT_CAM_GAS_2	34

Use the Plastic Tweezer to place the Front-Facing Camera Adhesive on the location as shown and do not peel off the liner at this step.

NOTE

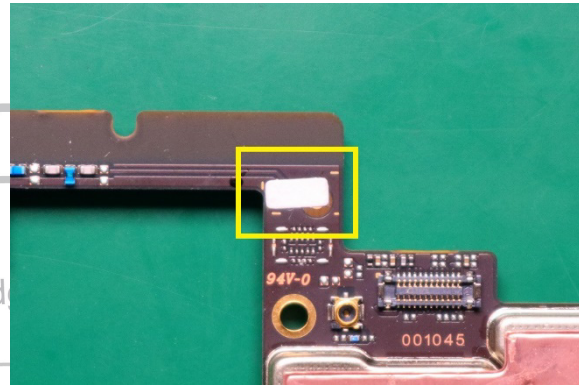
Press firmly for seconds 3 times to activate the adhesive.



Water Detection Label Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
DICUT,WATERPROOF,Waterproof LBL TMO	-

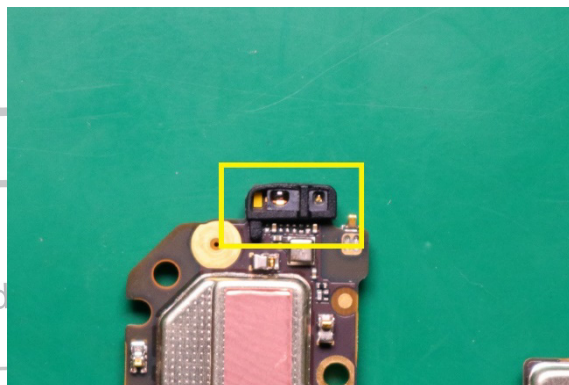
Use the Plastic Tweezer to place the Water Detection Label (WDL) on the location as shown.



Proximity Sensor Grommet Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
GROM,CUST,AOIN,PSENSOR_GROMMET	28

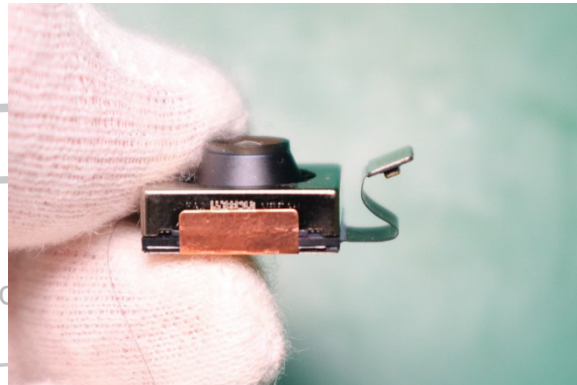
Use the Plastic Tweezer to place and secure the Proximity Sensor Grommet on the location as shown.



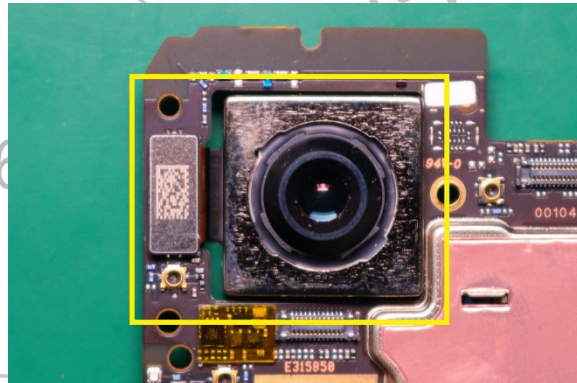
50M Rear-Facing Camera Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
MDL,CAMR,50M,rear;L50AA40;O-FILM,AF:Lond	15

1. Pre-bend the 50M Rear-Facing Camera Flex before assembling 50M Rear-Facing Camera as shown.



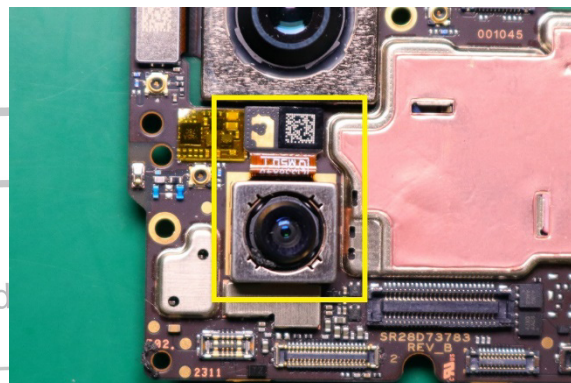
2. Use fingers to place and secure the 50M Rear-Facing Camera on the location as shown.



13M Rear-Facing Camera Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
MDL,CAMR,13M,rear,L1336A40;O-FILM,AF:Lon	14

Use the fingers to place and secure the 13M Rear-Facing Camera on the location as shown.



Thermal Gel Assembly

NOTE

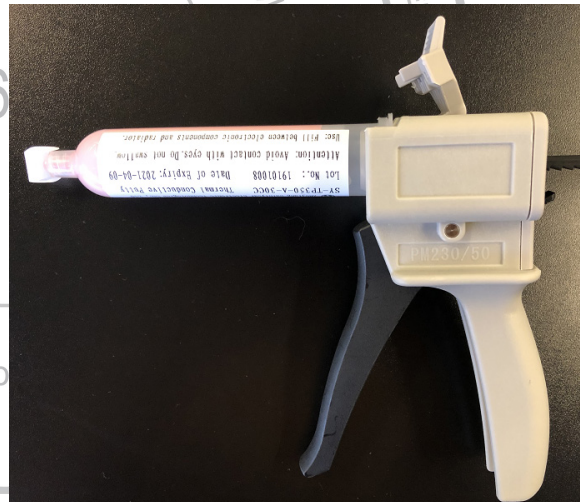
This procedure is only required when replacing the Main PCB or Front Housing.

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.



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- Cooler Master and Artic Thermal Gel syringe package.



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

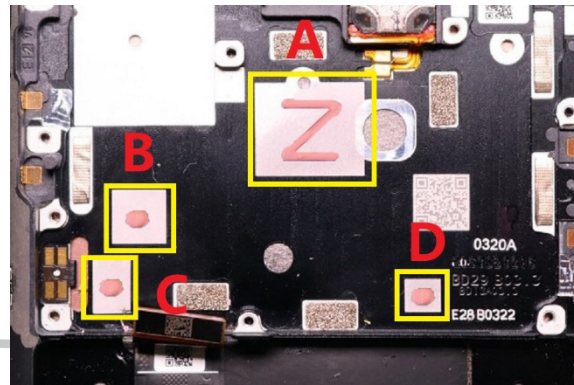


- When use SY-TP350 or Henkel LF350 30ml package suggest using 14- or 15-gauge needle.



Thermal Gel Location Assembly

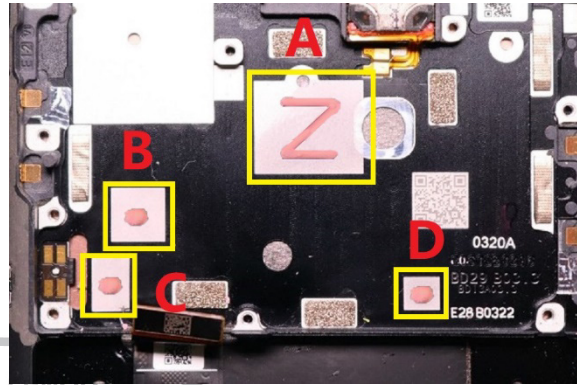
Noticing on the Front-Housing and refer to Thermal Gel shape as shown.



Thermal Gel Assembly Method A by Weight

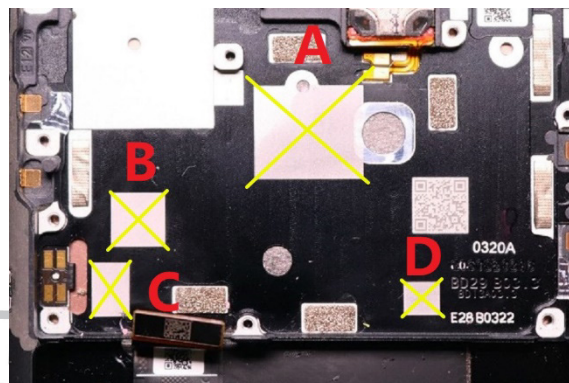
Add Thermal Conductive Gel (136mg±13mg) on the visual block as shown.

Thermal Gel area	Weight / mg
Point A	70±7
Point B	22±5
Point C	22±5
Point D	22±5



Thermal Gel Assembly Method B by Area

1. Use the pen to mark the point on the Front-Housing as shown.



2. Use the 18-gauge needle (green color) for Artic and Cooler Master.
Use the 14/15-gauge needle for Henkel LF350.
3. Use the Tweezer to cut off the string of thermal gel from the needle.

NOTE

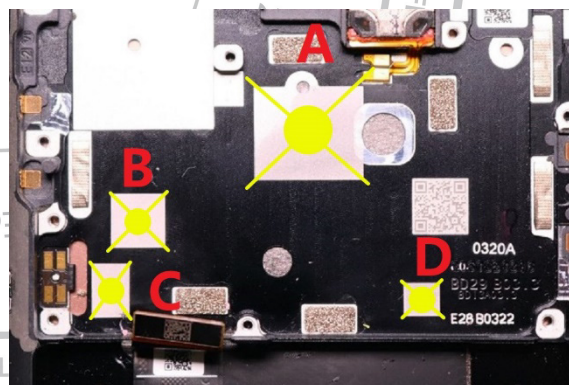
The tip of the Needle and Tweezers must be cleaned after each application.

4. Heat conductive gel is extruded according to the amount of heat conductive gel.

NOTE

Care not to exceed the diameter while applying the Thermal gel.

Thermal Gel area	Diameter /mm
Point A	6
Point B	2
Point C	2
Point D	2



5. Use the Thermal Gel described below:

NOTE

Needle must be replaced daily.



Thermal Gel list that can be acceptable substitutes

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

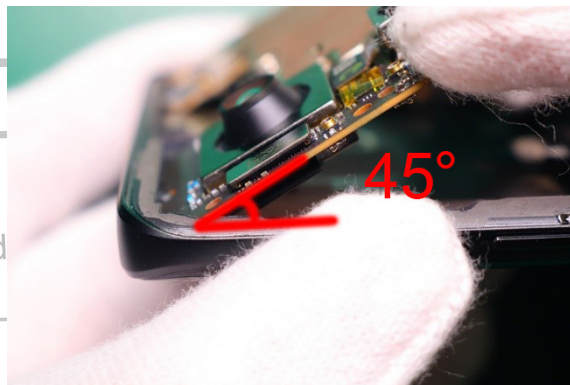
12/06/2023

Main PCB Assembly

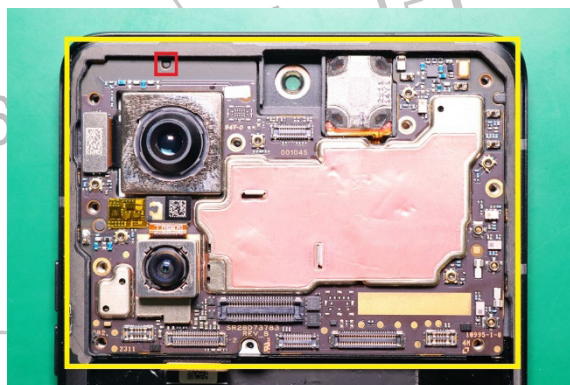
Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
HDW,SCR,STL,M1.4x0.30x2.5mm_Clear	26

NOTE

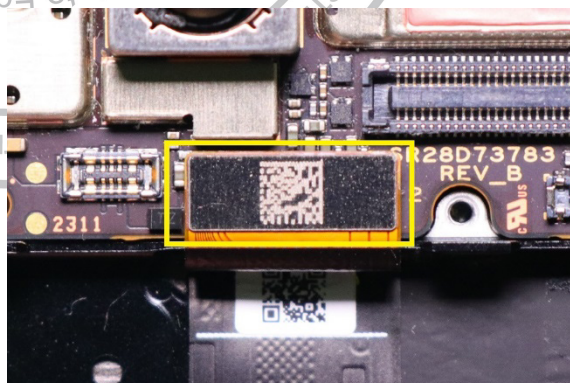
Insert the Main PCB with the Front-Housing at 45 degrees.



1. Use fingers to place the Main PCB on the location aligning with the pin as shown.

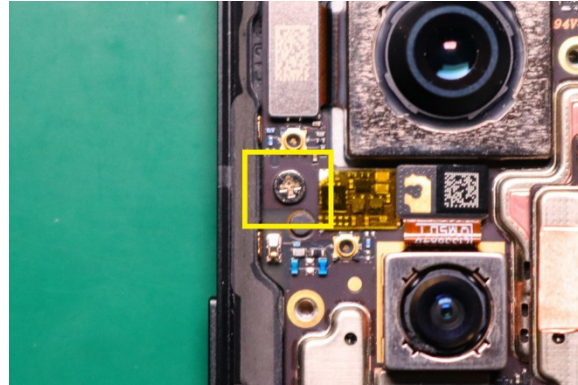


2. Use fingers to place and secure the Display Flex BTB Connector on the location as shown.



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3. Use the Torque Driver with PH00 Bit to tighten the screw as shown (0.7 ± 0.056 kgf-cm).



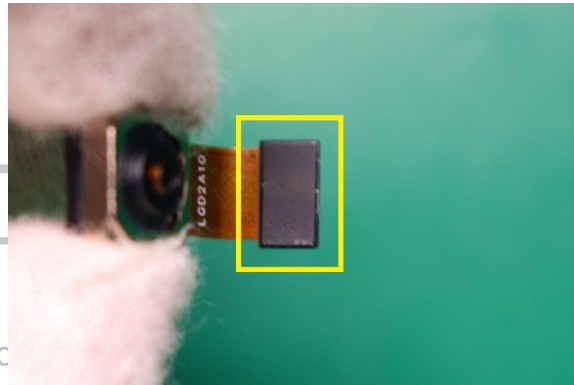
Front-Facing Camera Connector Foam Assembly

Description	Reference #
MDL,CAMR,32M,front;LGD2A10;O-FILM,AF:TUN	13
DICUT,FOAM,AION,FRT_CAM_CON_GASKET	41

Use the Plastic Tweezer to place the Front-Facing Camera Connector Foam on the location as shown.

NOTE

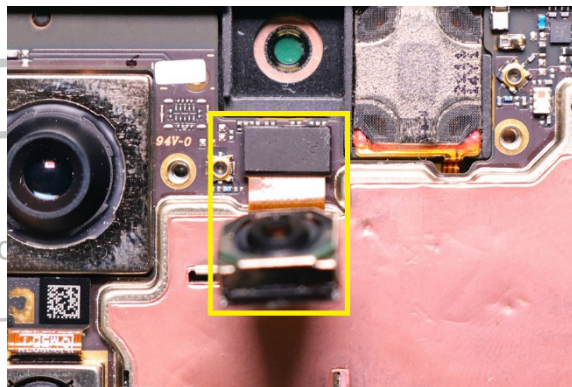
Press firmly for seconds 3 times to activate the adhesive.



Front-Facing Camera Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
MDL,CAMR,32M,front;LGD2A10;O-FILM,AF:TUN	13

1. Peel off the liner of Front-Facing Camera Adhesive, then, use fingers to place and secure the Front-Facing Camera on the location as shown.



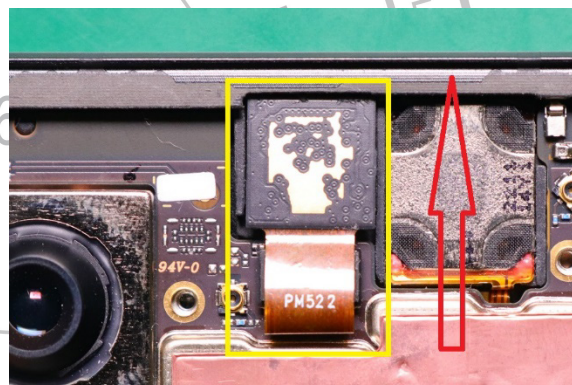
2. Use fingers to bend the Front-Facing Camera FPC as shown.

NOTE

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

NOTE

Press firmly for seconds 3 times to activate the adhesive.



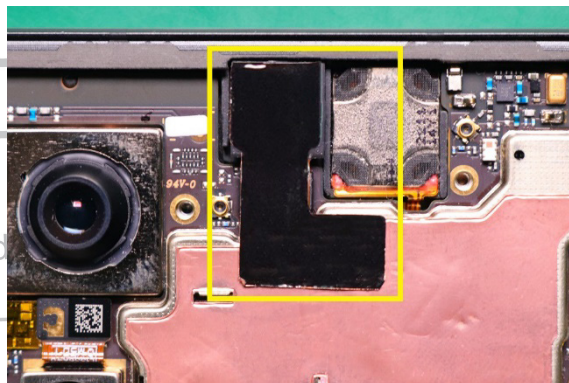
Front-Facing Camera Copper Foil Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
MDL,CAMR,32M,front;LGD2A10;O-FILM,AF:TUN	13
THRM,HT DISP,N,AION,GRAPHITE_RECEIVER	47

Use the Plastic Tweezer to place the Front-Facing Camera Copper Foil on the location as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



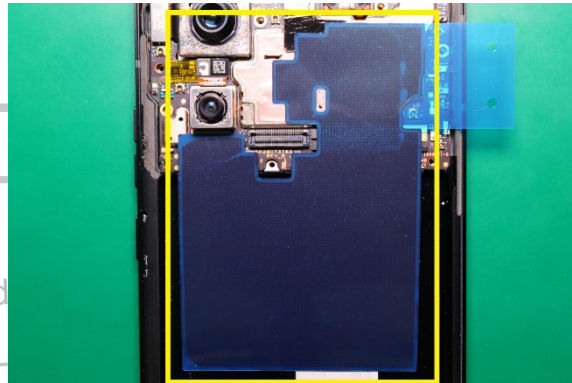
Main PCB Back Heat Spreader Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
THRM,HT DISP,N,AION,GRAPHITE_PMU	46

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

NOTE

Press firmly for seconds 3 times to activate the adhesive.



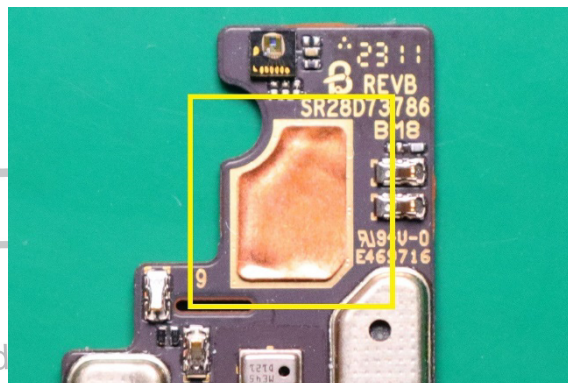
Stack Board Flash Copper Foil Assembly

Description	Reference #
XT2305,Stack Board CS	5
DICUT,ADHS,AION,STACK_FLASH_COPPER	-

Use the Plastic Tweezer to place the Stack Board Flash Copper Foil on the location as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



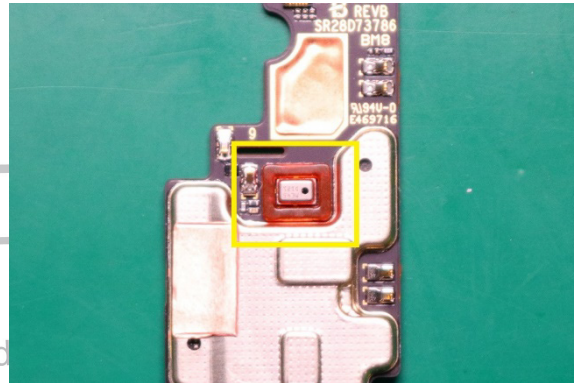
Mic 3 Bracket Assembly

Description	Reference #
XT2305,Stack Board CS	5
HDW,BRKT,AION,MIC3_BRACKET	22

Use the Plastic Tweezer to place the Mic 3 Bracket on the location as shown and peel off the liner.

NOTE

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



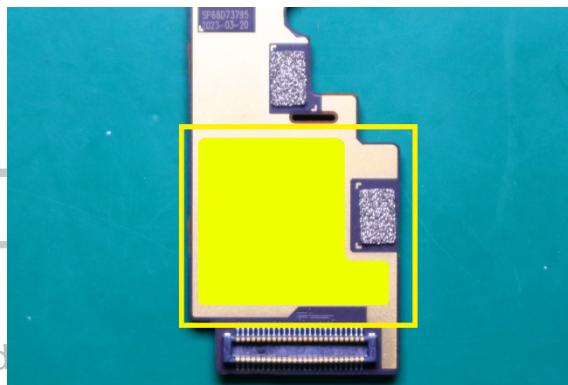
Stack Board Adhesive Assembly

Description	Reference #
XT2305,Stack Board CS	5
DICUT,FOAM,AION,STACK_PCB_ADH	32

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

NOTE

Press firmly for seconds 3 times to activate the adhesive.



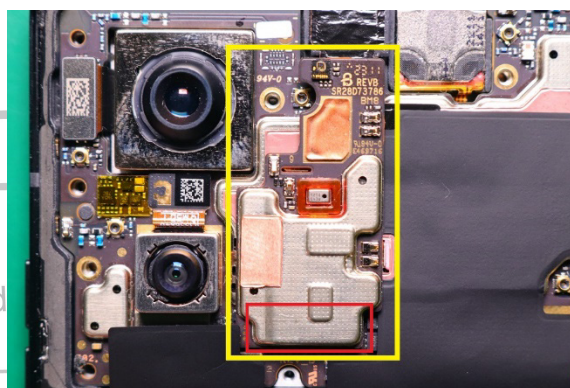
Stack Board Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
XT2305,Stack Board CS	5

Use fingers to place and secure the Stack Board on the location as shown.

NOTE

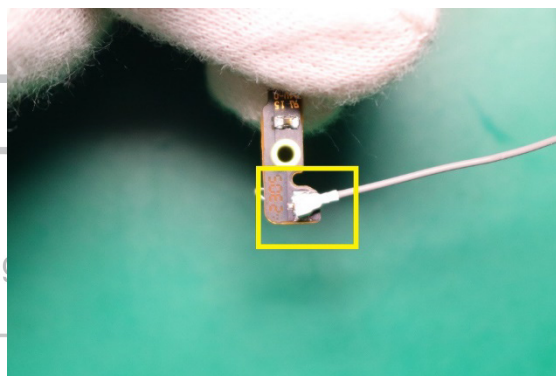
Press firmly for seconds 3 times to activate the adhesive.



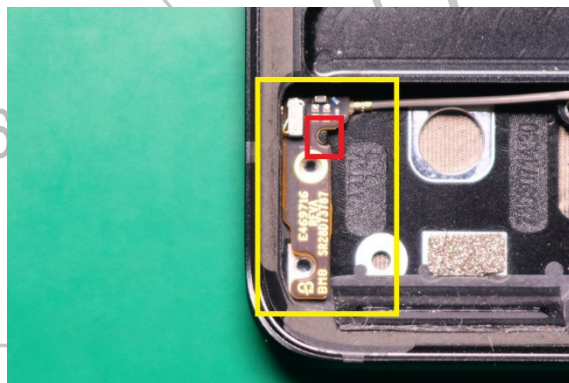
RF Sub Board Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,RF ANT Board CS	6
CBL,DATA,AION,CABLE5	21
ZEEKR SCREW_M1P2_1P55_H03_CROSS	25

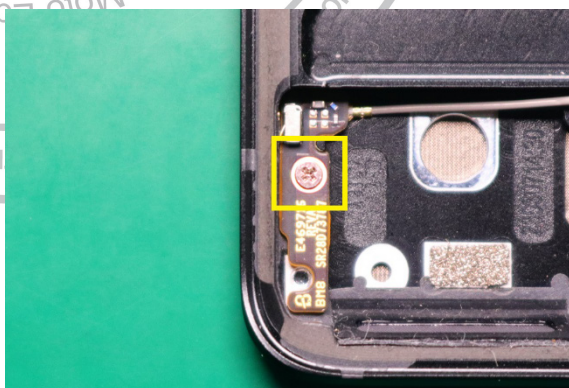
1. Use the Plastic Tweezer to place and secure the Grey Coax Cable on the back of RF Sub Board as shown.



2. Use fingers to turn around and place the RF Sub Board on the location aligning with the pin as shown.

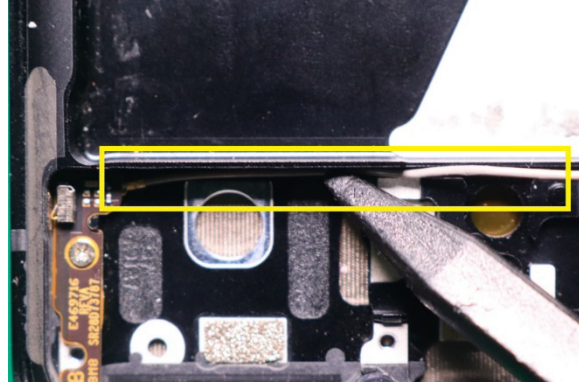


3. Use the Torque Driver with PH00 Bit to tighten the screw as shown (0.5 ± 0.04 kgf-cm).



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4. Use the pointed end of the Black Stick to place the Grey Coax Cable into the recess on the Front-Housing.



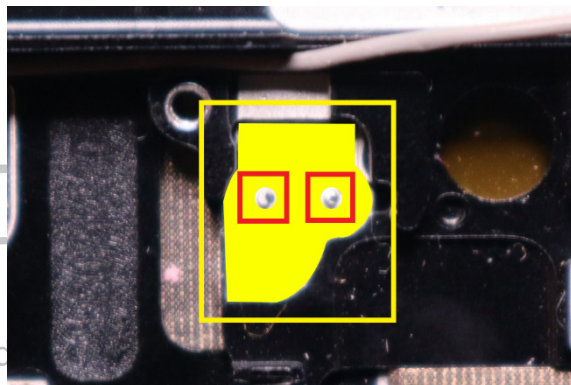
Speaker Box Adhesive Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,FOAM,AION,SPK_FPC_ADH	36

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

NOTE

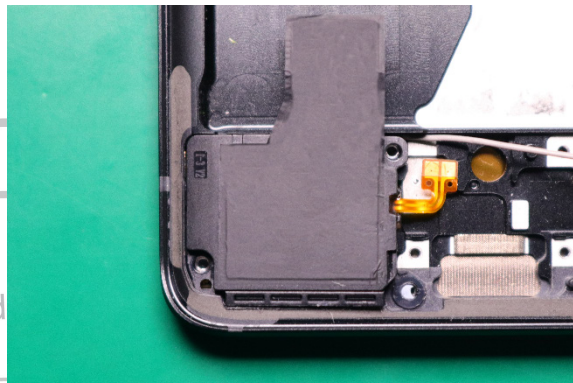
Press firmly for seconds 3 times to activate the adhesive.



Speaker Box Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
AU,SPKR,11x15x2.48mm,8Ohms,Fpc CONT,GP C	17
DUBAI Screw2_M1.4x3,Silver	-

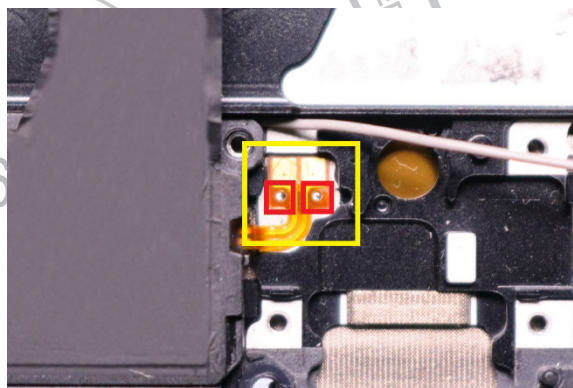
1. Use fingers to place the Speaker Box on the location as shown.



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

NOTE

Press the FPC area firmly for seconds 3 times to activate the adhesive.



3. Use the Torque Driver with PH00 Bit to tighten the screw as shown (0.95 ± 0.076 kgf-cm).



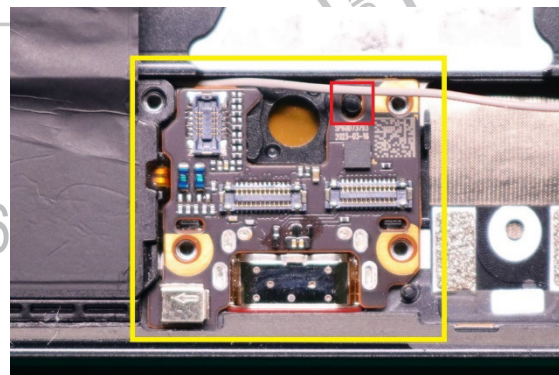
USB Sub Board Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,USB Sub Board CS	3

NOTE

Insert the USB Sub Board with the Front-Housing at some degrees.

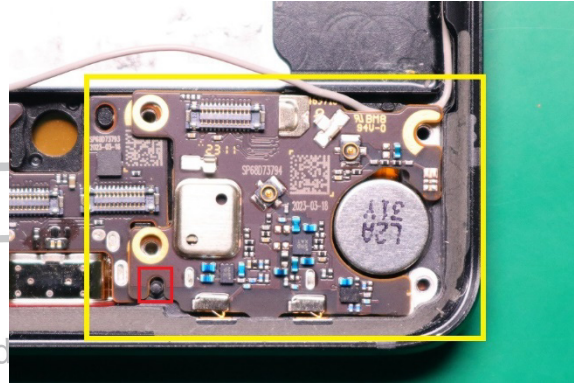
Use the Plastic Tweezer to place the USB Sub Board on the location aligning with the pin as shown.



SIM Sub Board Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,SIM Board CS	4

Use the Plastic Tweezer to place the SIM Sub Board on the location aligning with the pin as shown.



FOD Sensor Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,USB Sub Board CS	3
FINGERPRT SCANNER,ofilm,FOD, EL721	12

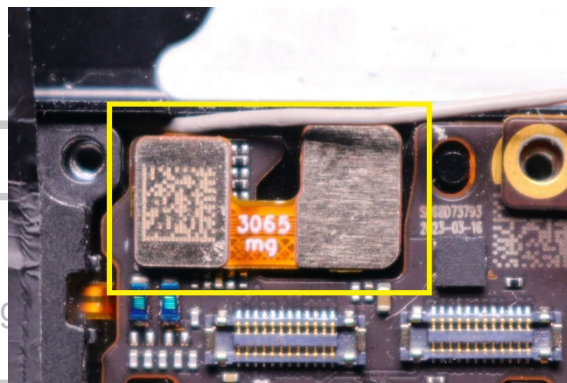
Peel off the liner of the FOD Sensor Adhesive, then, use the Plastic Tweezer to place and secure the FOD Sensor on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

Make sure the FOD Sensor is installed into the recess of the Front-Housing.



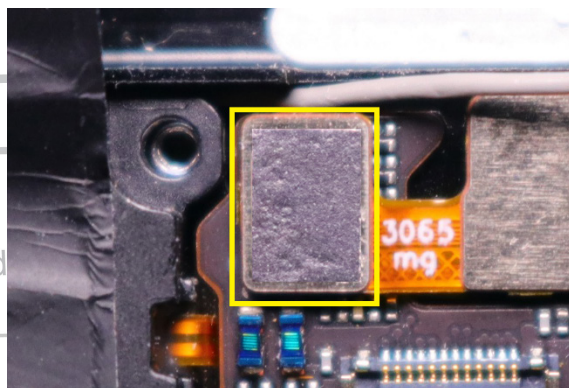
FOD Sensor Bracket Foam 3 Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,USB Sub Board CS	3
FINGERPRT SCANNER,ofilm,FOD, EL721	12
DICUT,FOAM,AION,FOD_BRACKET_GASKET_3	40

Use the Plastic Tweezer to place the FOD Sensor Bracket Foam 3 on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



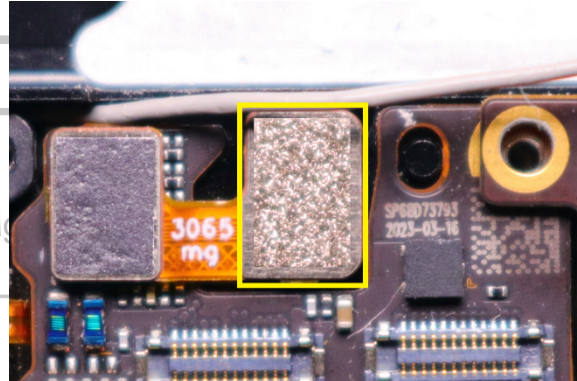
FOD Sensor Bracket Foam 2 Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,USB Sub Board CS	3
FINGERPRT SCANNER,ofilm,FOD, EL721	12
DICUT,FOAM,AION,FOD_BRACKET_GASKET_2	39

Use the Plastic Tweezer to place the FOD Sensor Bracket Foam 2 on the location as shown.

NOTE

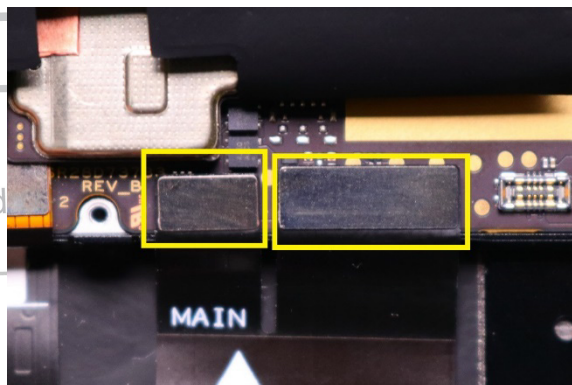
Press firmly for seconds 3 times to activate the adhesive.



Main FPC Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
XT2305,SIM Board CS	4
ASSY,FLX,London na MN FPC,2L	10

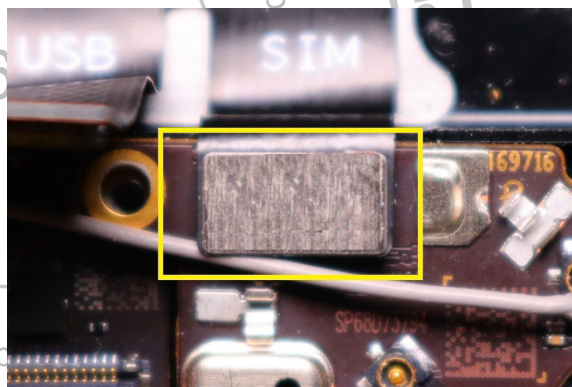
1. Use fingers to place and secure the Main FPC Flex BtB Connectors on the Main PCB as shown.



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

NOTE

Do not secure the left two connectors at this step.



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3. Use fingers to carefully place the Main FPC on the phone as shown, sticky side down.

NOTE

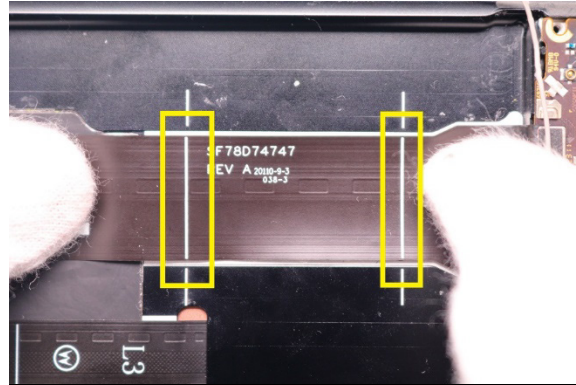
Press firmly for seconds 3 times to activate the adhesive.

NOTE

The white lines on the Main FPC should be aligned with the white lines on the Front Housing.

NOTE

The Main FPC should be assembled into the recess on the Front-Housing and cannot deflect.



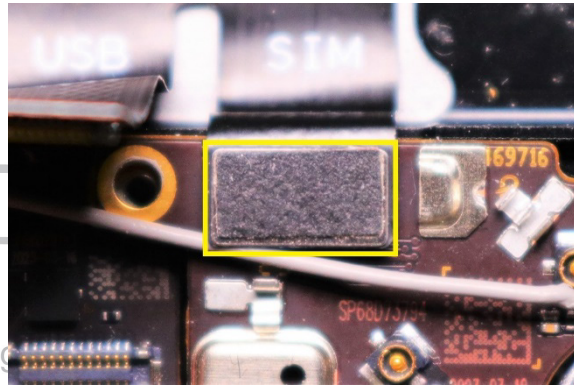
FOD Sensor Bracket Foam 1 Assembly

Description	Reference #
ASSY,FLX,London na MN FPC,2L	10
DICUT,FOAM,AION_FOD_BRACKET_COND_GASKET	38

Use the Plastic Tweezer to place the FOD Sensor Bracket Foam 1 on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

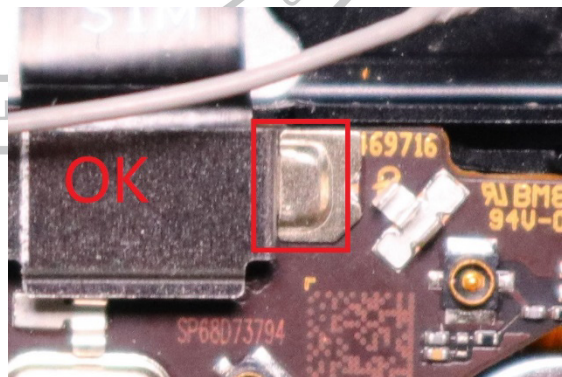
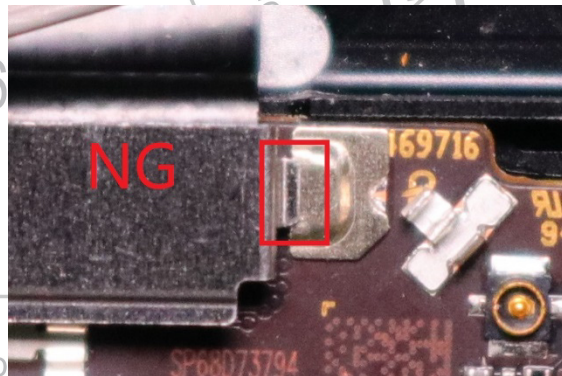
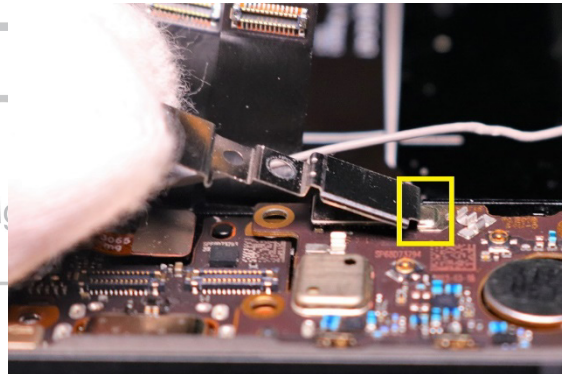


FOD Sensor Bracket Assembly

Description	Reference #
XT2305,USB Sub Board CS	3
XT2305,SIM Board CS	4
CBL,DATA,AION,CABLE5	21
HDW,OTHR,AION,FOD_METAL_BRACKET	23
HDW,SCR,STL,M1.4x0.30x2.5mm_Clear	26

NOTE

Make sure to insert the right end of the FOD Sensor Bracket into the slot on the SIM Sub Board.



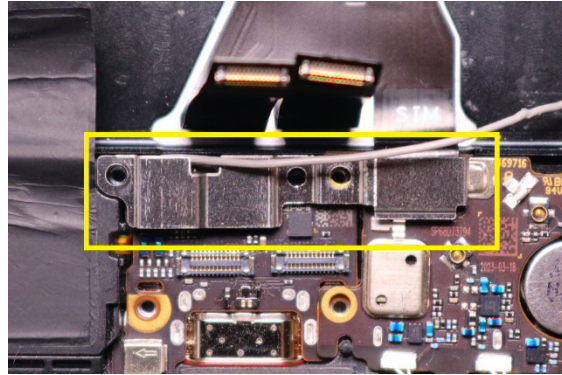
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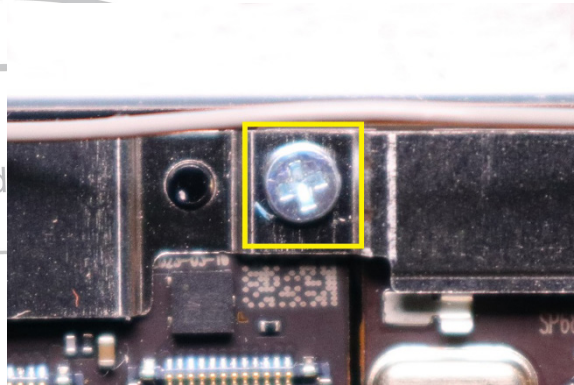
1. Use the Plastic Tweezer to place the FOD Sensor Bracket on the location as shown.

NOTE

Make sure the Grey Coax Cable passes through the groove on the FOD Sensor Bracket.



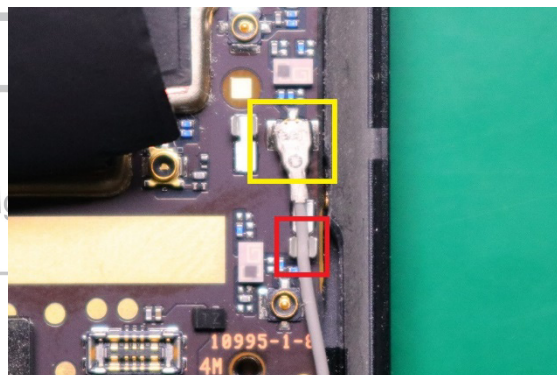
2. Use the Torque Driver with PH00 Bit to tighten the screw as shown (0.7 ± 0.056 kgf-cm).



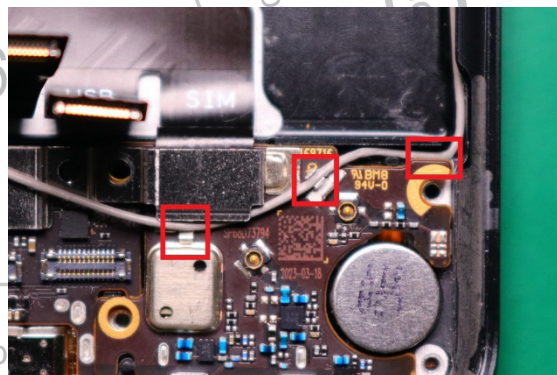
Grey Coax Cable Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
XT2305,SIM Board CS	4
CBL,DATA,AION,CABLE5	21

1. Use the Plastic Tweezer to place and secure the Grey Coax Cable on the location as shown.



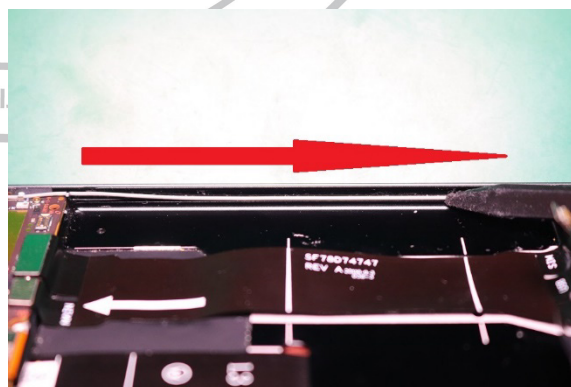
2. Use the Plastic Tweezer to place the Grey Coax Cable into the cable guide on the locations as shown.



3. Use the pointed end of the Black Stick to place the Grey Coax cable into the pocket of the recess of the Front Housing.

NOTE

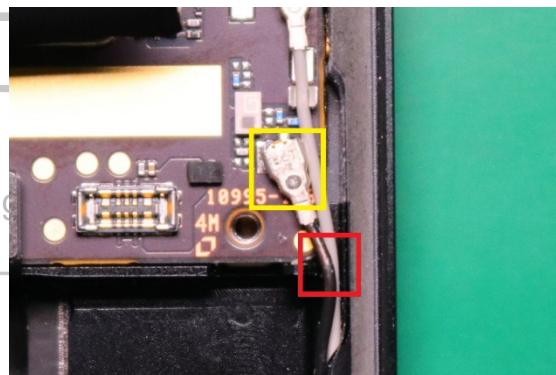
Place the Grey Coax Cable from the Main PCB side to the SIM Sub Board Side.



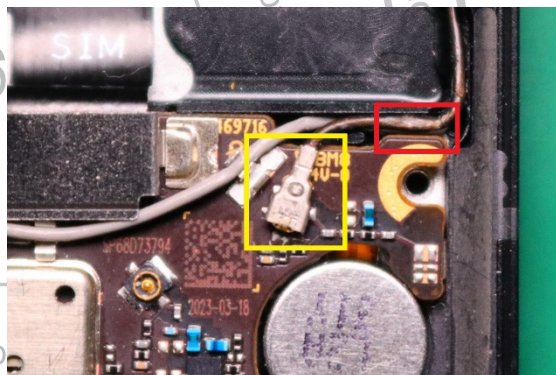
Black Coax Cable Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
XT2305,SIM Board CS	4
CBL,DATA,AION,CABLE2	20

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



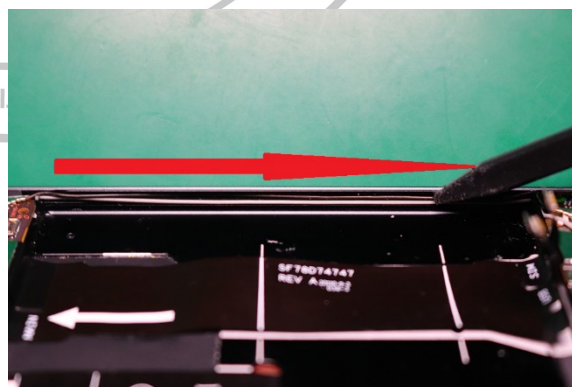
2. Use the Plastic Tweezer to place and secure the Black Coax Cable on the location as shown.



3. Use the pointed end of the Black Stick to place the Black Coax cable into the pocket of the recess of the Front Housing.

NOTE

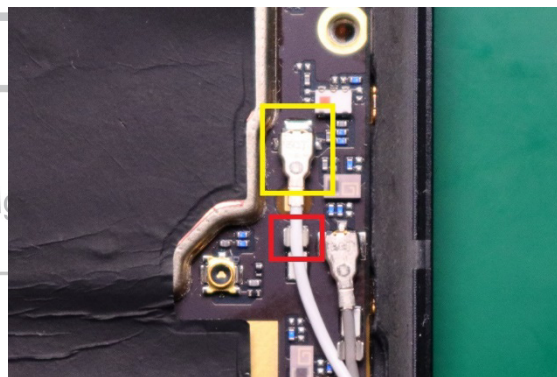
Place the Black Coax Cable from the Main PCB side to the SIM Sub Board Side.



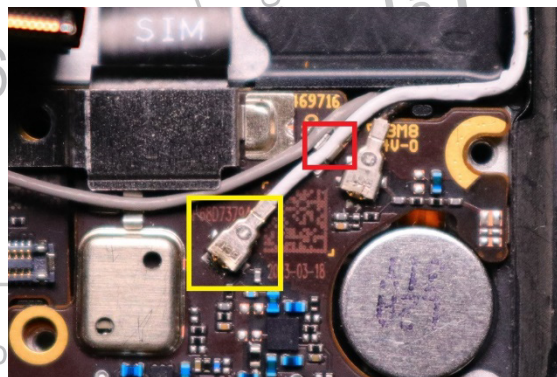
White Coax Cable Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
XT2305,SIM Board CS	4
CBL,DATA,AION,CABLE1	19

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



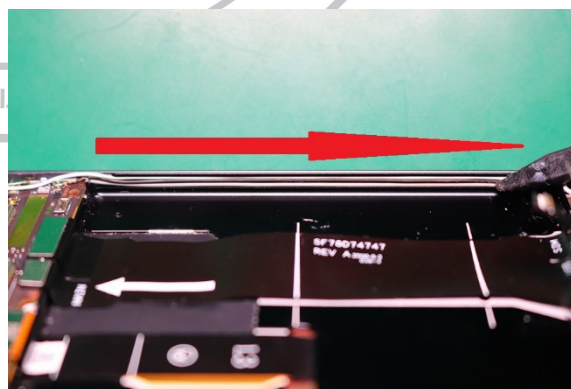
2. Use the Plastic Tweezer to place and secure the White Coax Cable on the location as shown.



3. Use the pointed end of the Black Stick to place the White Coax cable into the pocket of the recess of the Front Housing.

NOTE

Place the White Coax Cable from the Main PCB side to the SIM Sub Board Side.



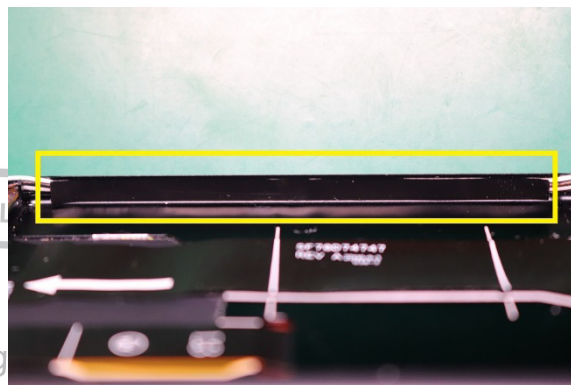
Coax Cable Mylar Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,FOAM,AION,CABLE_PET	42

Use the Plastic Tweezer to place the Coax Cable Mylar on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



Cable ESD Mylar Assembly

Description	Reference #
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
DICUT,ADHS,AION_CABLE_ESD_MYLAR	44

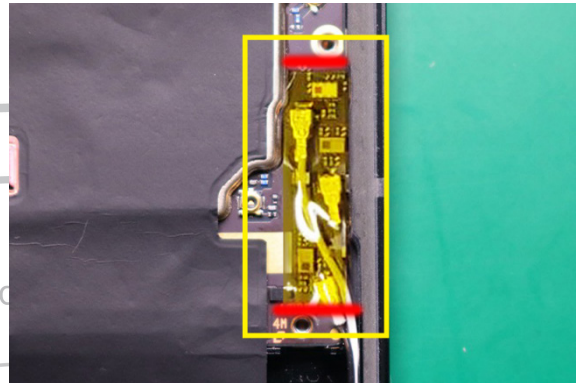
Use the Plastic Tweezer to place the Cable ESD Mylar on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The Cable ESD Mylar cannot exceed the red lines and cover the screw holes.



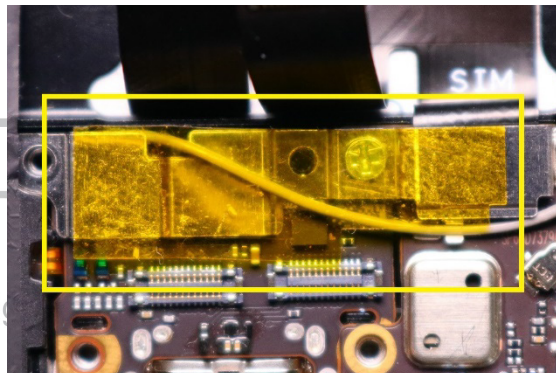
Main FPC Mylar Assembly

Description	Reference #
ASSY,FLX,London na MN FPC,2L	10
HDW,OTHR,AION,FOD_METAL_BRACKET	23
DICUT,FOAM,AION,MAIN_FPC_MYLAR	43

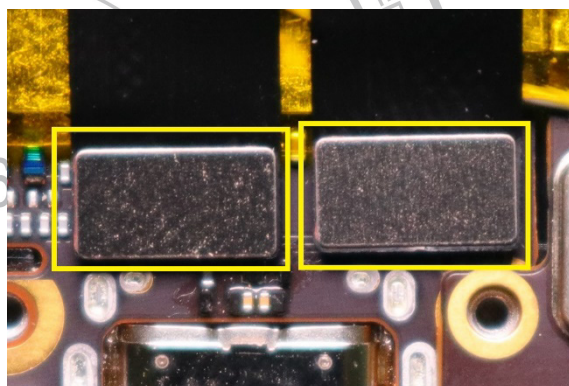
1. Use the Plastic Tweezer to place the Main FPC Mylar on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



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



Battery Adhesive Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
DICUT,FOAM,AION,BATTERY_ADH	29

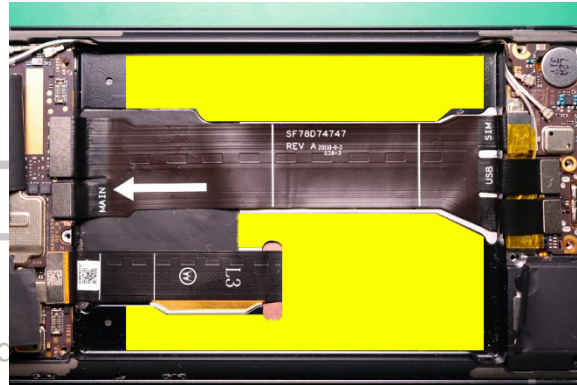
Use the Plastic Tweezer to place the Battery Adhesive on the location as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The Battery Adhesive cannot wrinkle.



Battery Buffer Foam Assembly

Description	Reference #
ACCY,BAT,4400mAh,PG44,ATL466383,NVT	16
DICUT,FOAM,AION,BATTERY_SUP_GAS	37

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

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The Battery Buffer Foam should not exceed the edge of the Battery.



Battery Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
ACCY,BAT,4400mAh,PG44,ATL466383,NVT	16

/// 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.

// CAUTION //

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

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

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

Ensure screws and screwdrivers do not contact the Battery.

1. Use fingers to place the Battery on the Front-Housing as shown.

NOTE

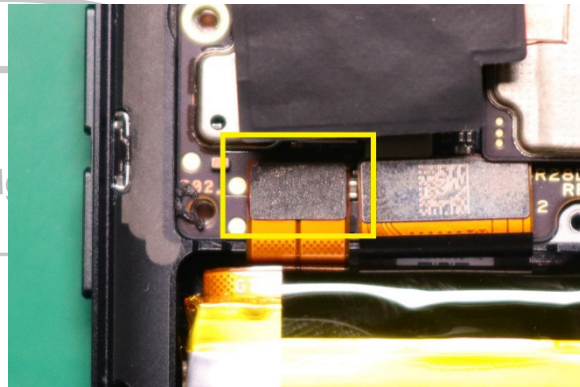
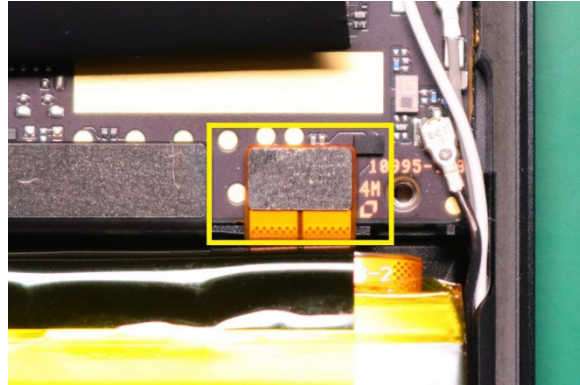
Make sure to assemble the Battery using the bottom left corner marked as red.



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2. Use fingers to place and secure two Battery BtB Connectors on the Main Board as shown.



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.



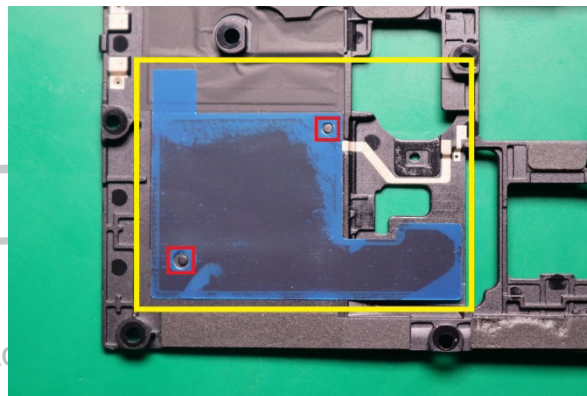
NFC Heat Spreader Assembly

Description	Reference #
XT2305,Top Bracket CS	7
THRM,HT DISPN,AION,GRAPHITE_NFC	45

Use the Plastic Tweezer to place the NFC Heat Spreader on the location aligning with the pins as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



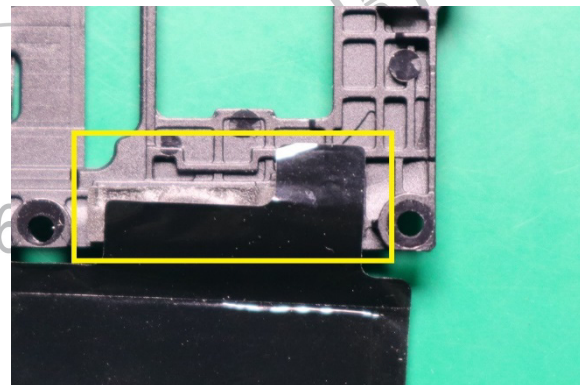
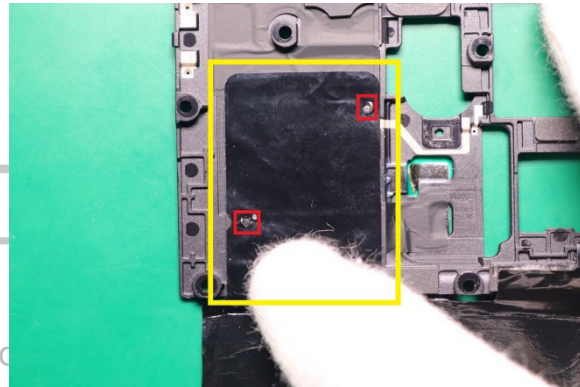
Wireless Charging Module Assembly

Description	Reference #
XT2305,Top Bracket CS	7
Lyriq FPC WLC	11

1. Use the Plastic Tweezer to place the Wireless Charging Module on the location aligning with the pins as shown and peel off the liner.

NOTE

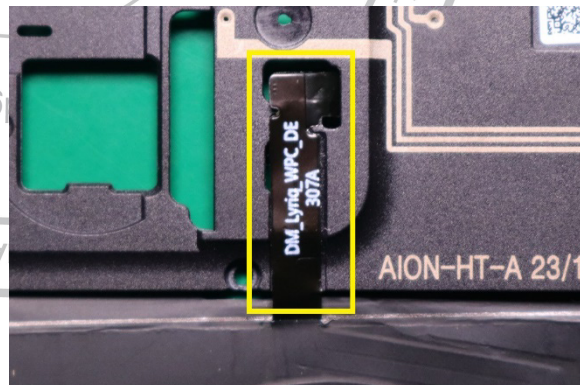
Press firmly for seconds 3 times to activate the adhesive.



2. Use the Plastic Tweezer to place the Wireless Charging Module on the location as shown.

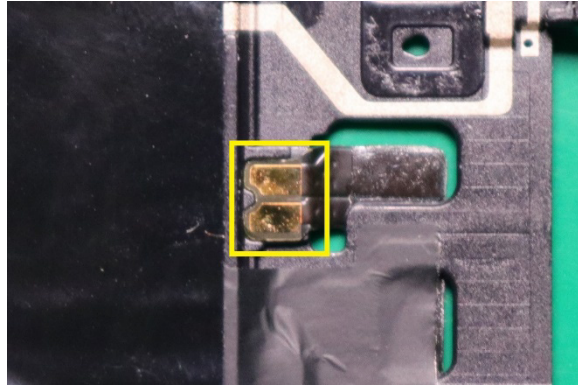
NOTE

Press firmly for seconds 3 times to activate the adhesive.



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3. Use the Plastic Tweezer to place and secure the Wireless Charging FPC on the location as shown.



Stack Board-Top Bracket Adhesive Assembly

Description	Reference #
XT2305,Stack Board CS	5
DICUT,ADHS,AION_STACK_TOP_ADH	-

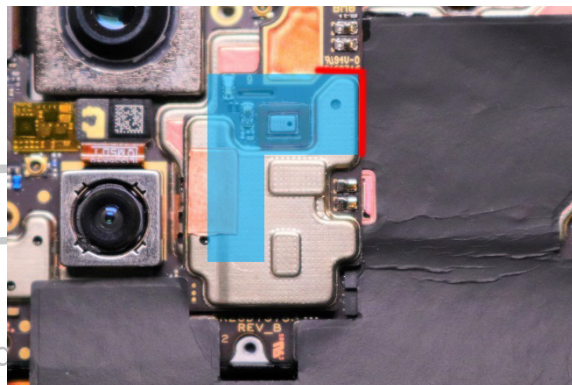
Use the Plastic Tweezer to place the Stack Board-Top Bracket Adhesive on the location as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The Stack Board-Top Bracket Adhesive cannot exceed the edge of the metal shielding cover.



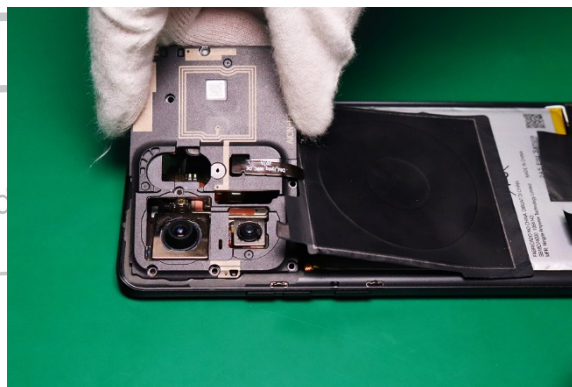
Top Bracket Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305-1,MB,8+256 DSL,SPEC CS XT2305-1,MB,8+256 DSL,DISH CS XT2305-1,MB,8+256 DS,RTL CS	2
XT2305,Top Bracket CS	7
HDW,SCR,Tooth_screw_M1.4x0.30x3.6mm	27

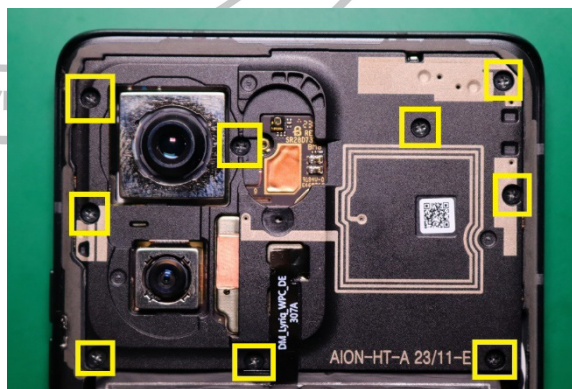
NOTE

Close the buckles on the left sides of the Top Bracket first.

1. Use fingers to place the Top Bracket on the Front-Housing as shown.



2. Use the Torque Driver with PH00 Bit to tighten nine screws as shown (0.8 ± 0.064 kgf-cm).



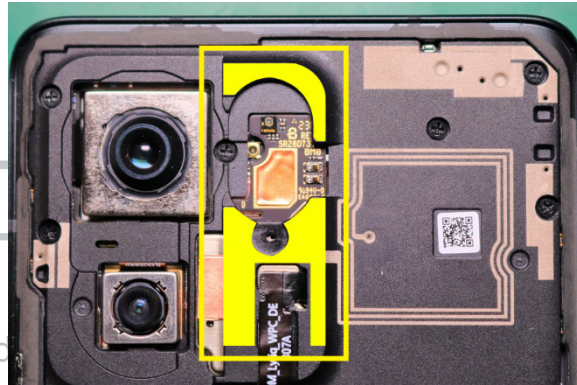
Mic 3 Bracket Adhesive Assembly

Description	Reference #
XT2305,Top Bracket CS	7
DICUT,ADHS,AION_MIC3_BRACKET_ADH	31

Use the Plastic Tweezer to place the Mic 3 Bracket Adhesive on the location as shown and peel off the liner.

NOTE

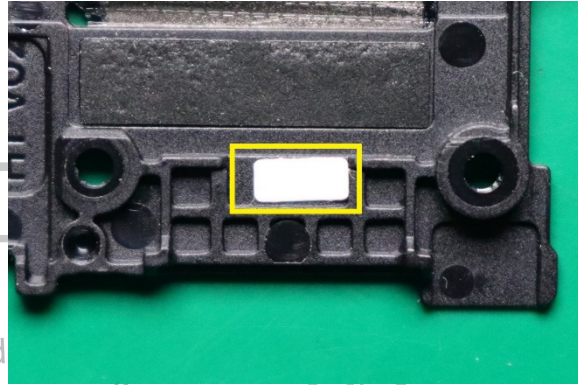
Press firmly for seconds 3 times to activate the adhesive.



Water Detection Label Assembly

Description	Reference #
ANT,EXTRNL,AION,ASSY_BOT_BRACKET	8
DICUT,WATERPROOF,Waterproof LBL TMO	-

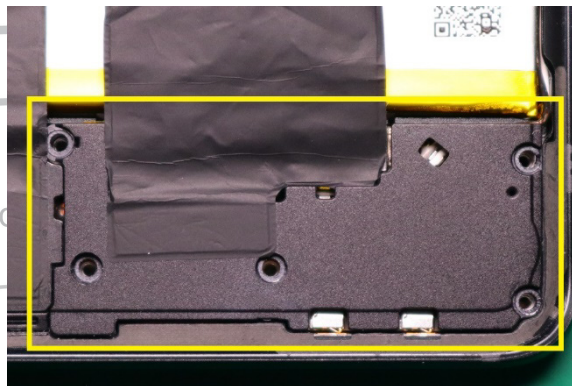
Use the Plastic Tweezer to place the Water Detection Label (WDL) on the location as shown.



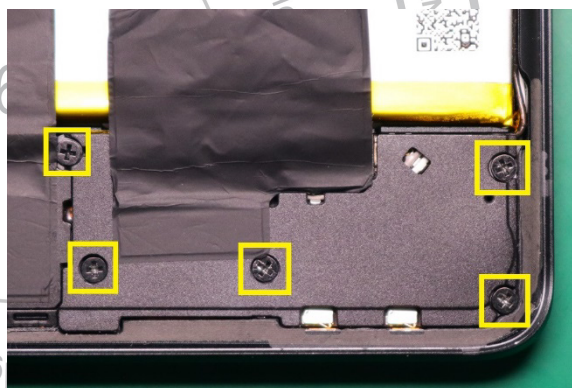
Bottom Bracket Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,USB Sub Board CS	3
XT2305,SIM Board CS	4
ANT,EXTRNL,AION,ASSY_BOT_BRACKET	8
HDW,SCR,Tooth_screw_M1.4x0.30x3.6mm	27

1. Use fingers to place the Bottom Bracket on the location as shown.



2. Use the Torque Driver with PH00 Bit to tighten five screws as shown (0.8 ± 0.064 kgf-cm).



Inlay-Speaker Adhesive Assembly

Description	Reference #
ANT,EXTRNL,AION,ASSY_BOT_BRACKET	8
DICUT,ADHS,AION_BOX_INLAY_ADH	30

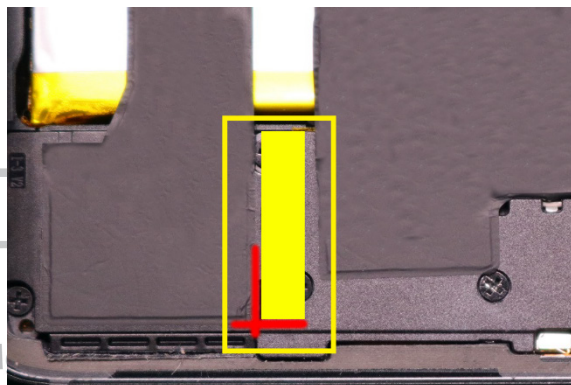
Use the Plastic Tweezer to place the Inlay-Speaker Adhesive on the location as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The Inlay-Speaker Adhesive cannot exceed the red lines.



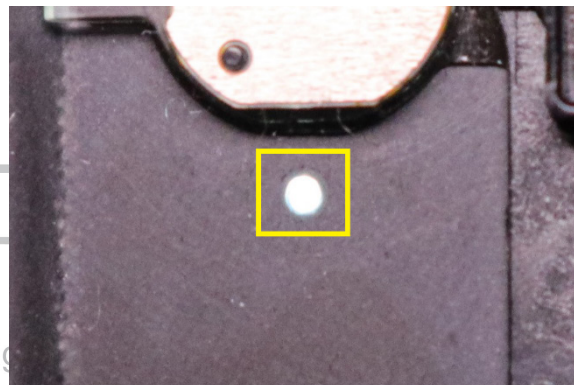
Mic 3 Mesh Assembly

Description	Reference #
XT2305,INLAY,PU,BLK CS	9
DICUT,ADHS,AION_MIC3_GASKET	-

1. Use fingers to place the Battery Cover on the light source for positioning as shown.

NOTE

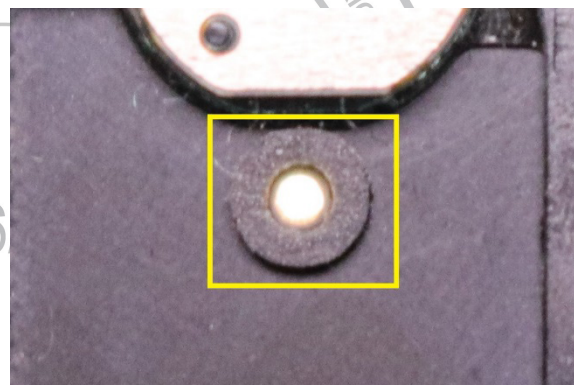
The mobile phone flashlight can be used as a light source.



2. Use the Plastic Tweezer to place the Mic 3 Mesh on the location as shown.

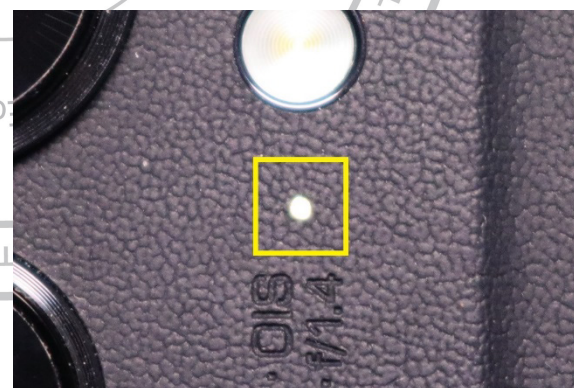
NOTE

Press firmly for seconds 3 times to activate the adhesive.



NOTE

After assembly, use external light to check if the Mic 3 hole is circular, if not, it requires reinstallation.



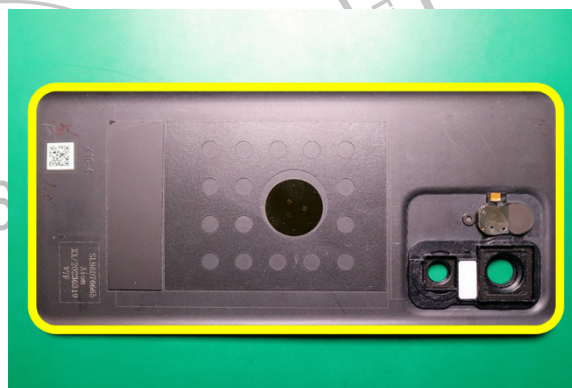
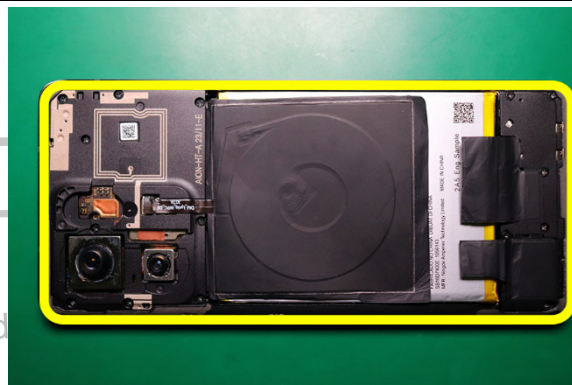
Battery Cover Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
XT2305,INLAY,PU,BLK CS	9
DIECUT_AION_INLAY_PSA_FOR_SERVICE	33

1. Use the cotton swabs and ISP Alcohol to clean the Front Housing and Battery Cover as shown.

//CAUTION//

Front Housing and Battery Cover cleaning are critical to the phone's water resistance. You must thoroughly clean the surface with ISP Alcohol and allow it to dry completely before applying 3M AP-111 Adhesion Promoter.



2. Wait for the ISP Alcohol to dry completely.

//CAUTION//

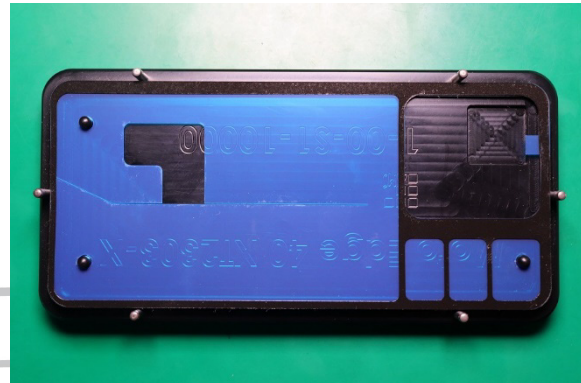
Do not use the same cotton swabs to clean with ISP Alcohol and apply 3M AP-111 Adhesion Promoter. The Battery Cover will not properly adhere to the Front-Housing if the cotton swabs are reused. The cotton swabs may be used for two applications of the same chemical, but then must be discarded.

3. Repeat step 1 – 2 one time.
4. Use clean cotton swabs to apply 3M AP-111 Adhesion Promoter to the Front Housing and Battery Cover.

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5. Wait for the 3M AP-111 Adhesion Promoter to dry.
6. Use the Plastic Tweezer to position the Battery Cover Adhesive on the Battery Cover Adhesive Alignment as shown.



7. Use fingers to position the Battery Cover on the Battery Cover Adhesive as shown.



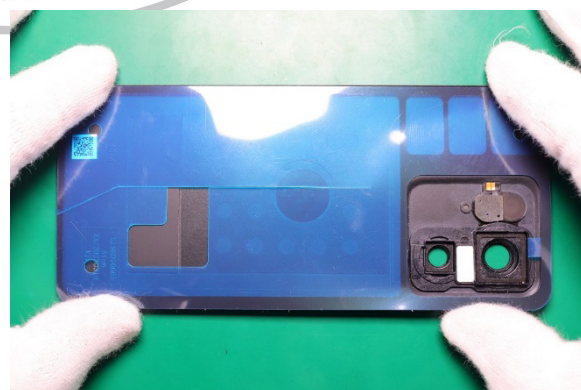
8. Use fingers to press down the Front-Housing with the Battery Cover Adhesive Alignment as shown.



NOTE

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

9. Use fingers to press the surrounding Battery Cover Adhesive 3 times to activate it as shown.



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.

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10. Use fingers to place the Battery Cover on the Front-Housing as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



11. Heat the phone in the Oven for 2 min in 55°C - 65°C (131°F-149°F).

NOTE

For the best of IP68 waterproof performance, please heat the phone before press inlay. And perform the Inlay press procedure before the phone starts to cool off.

// CAUTION //

Wear protective gloves when handling heated phones.



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

NOTE

Please read pneumatic press system user manual prior to operation.



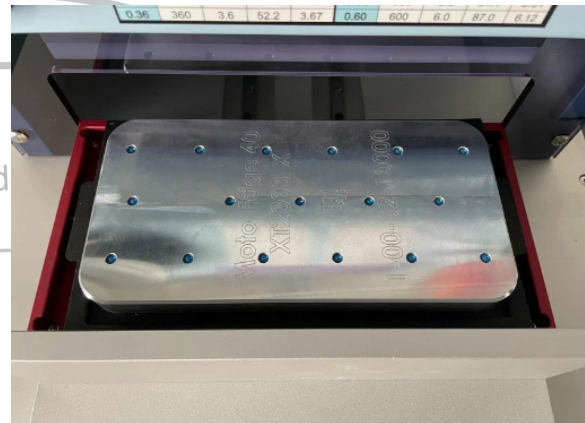
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13. Pull out press drawer from chamber and place the phone onto the base rubber pad in pneumatic press system as shown.



14. Place the Inlay press – 4 edges (1-00-S2-10000) fixture on top of the phone as shown.



15. Push the press system drawer into the chamber, and set program to No.9 by press "Program" button repeatedly, check the "Pressure" (Mpa) shows "0.40" and "Time" (sec) shows "60" as shown



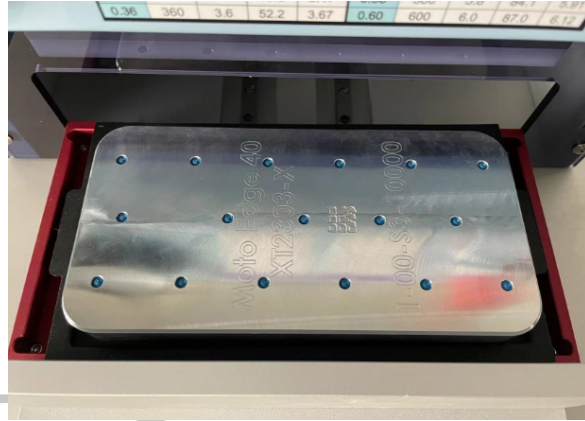
16. Press both of "Start" on the left and right side to initiate press process. Wait 60 seconds until process is finished.



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17. Pull out press drawer from chamber and Inlay press – 4 corners (1-00-S3-10000) fixture on top of the phone as shown.



18. Push the press system drawer into the chamber and set program to No.9 by press "Program" button repeatedly, check the "Pressure" (Mpa) shows "0.40" and "Time" (sec) shows "60" as shown.



19. Press both of "Start" on the left and right side to initiate press process. Wait 60 seconds until process is finished.



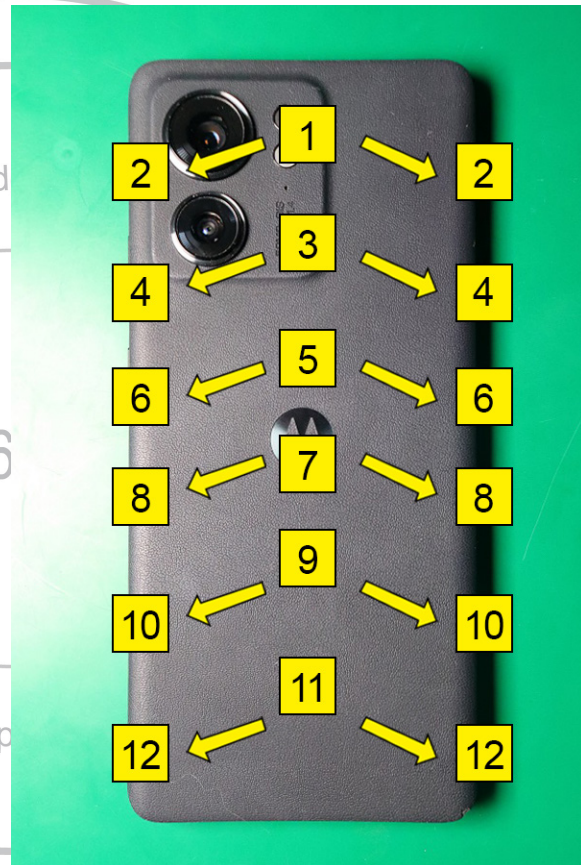
20. Pull out the drawer from the press chamber, remove the fixture, then take out the phone.

NOTE

For the best of IP68 waterproof performance, leave the phone for 1 hour for adhesive curing.



21. Apply manual pressure to the Battery Cover as follows:
22. Place both thumbs on point 1 (in middle of the Battery Cover) and slide them out to point 2.
23. Place both thumbs on point 3 and slide them out to point 4.
24. Place both thumbs on point 5 and slide them out to point 6.
25. Place both thumbs on point 7 and slide them out to point 8.
26. Place both thumbs on point 9 and slide them out to point 10.



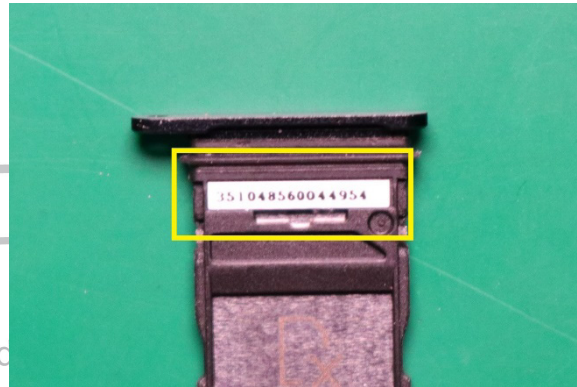
27. Place both thumbs on point 1 and slide them around the perimeter of the Battery Cover to point 2. Use fingers to press around the perimeter of the Camera bezel as shown.



IMEI Label Assembly

Description	Reference #
LYRIQ ASSY_SINGLE_SIM_TRAY_BLK	24
LBL,IMEI,9X1.3mm,Full Size 35.6x27.6mm	-

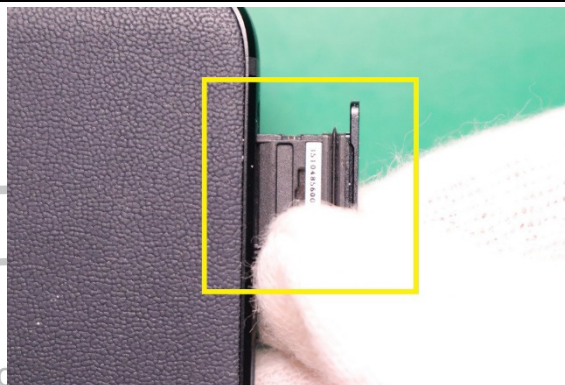
Use the Plastic Tweezer to place the IMEI Label on the SIM Tray as shown.



Sim Tray Assembly

Description	Reference #
XT2305,TPLCM,BLK CS	1
LYRIQ ASSY_SINGLE_SIM_TRAY_BLK	24

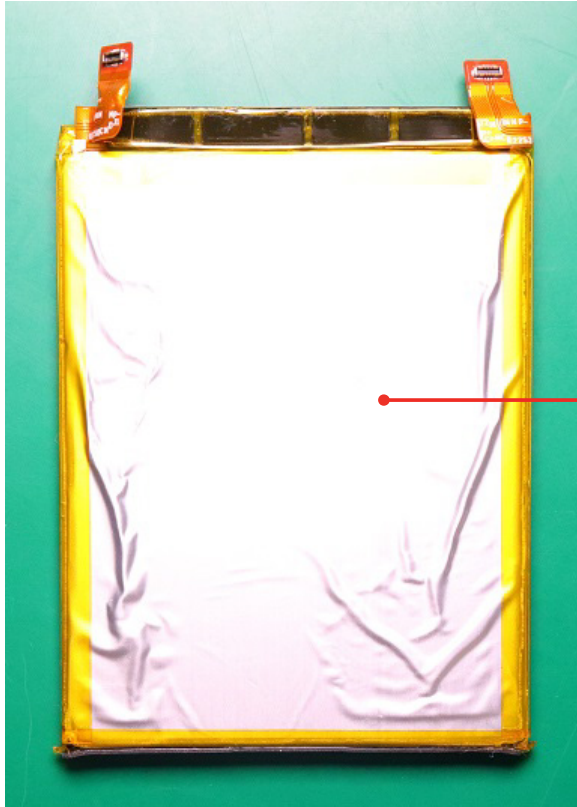
1. Insert the SIM Tray in the transceiver as shown.



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

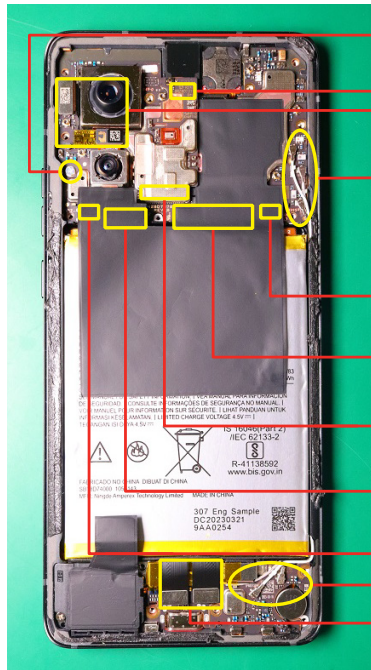
ASSEMBLY QUALITY CHECK

Battery Quality Check



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

Grommet and Connectors Quality Check



Check if any missing/unseated screws.

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 coax cable 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 stack board connector is well-seated and there's no sign of damage.

Check if the display flex 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.

Screws Graphite 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.

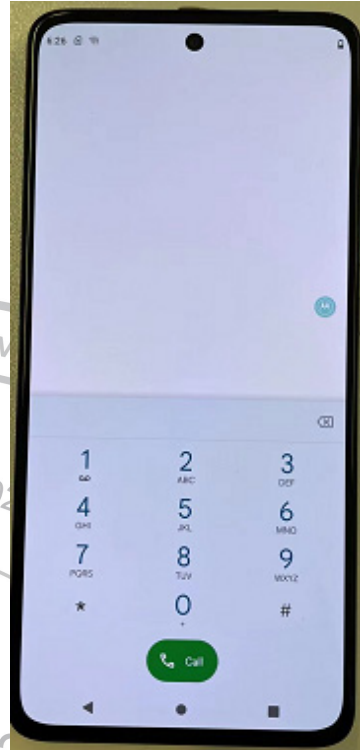
FOD CALIBRATION

NOTE

Use LMST (Motorola Software Test Tool) to perform the FOD calibration with the tool.

For the manual FOD calibration, follow below processes:

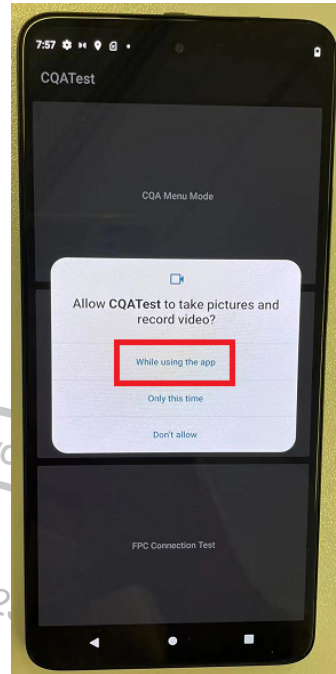
1. Open the phone Dial Screen.



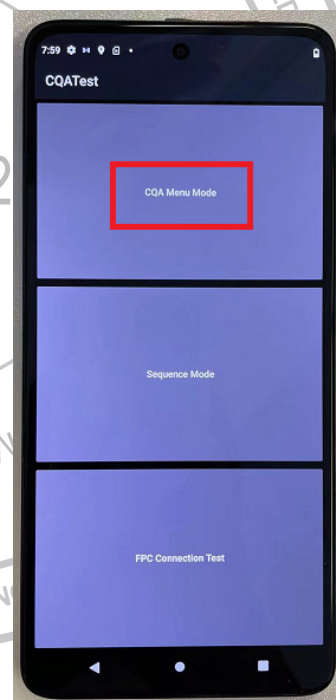
2. Enter *****#2486***** on the Dial Pad and press Call.



3. Select Allow to all pop-ups.



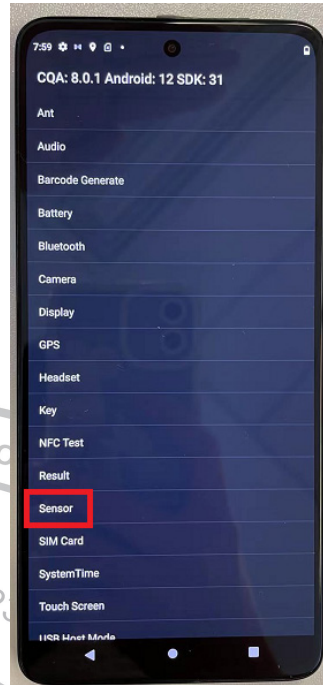
4. Select the CQA Menu Mode.



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5. Scroll down and select Sensor from the options.



6. Select Fingerprint Egls Fod SMTP from the options.



7. Press Start.



8. Press Next.



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- Put the large Peach Pad and select Next on the screen. Cavity face down.



- Notification should be as follows and then select Next.



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11. Place the Black Pad and select Next on the screen. Cavity face down.



12. Notification should be as follows and then select Next.



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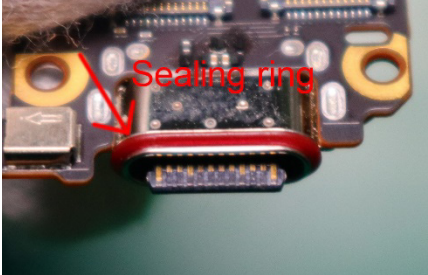
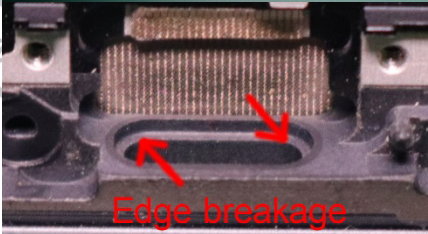
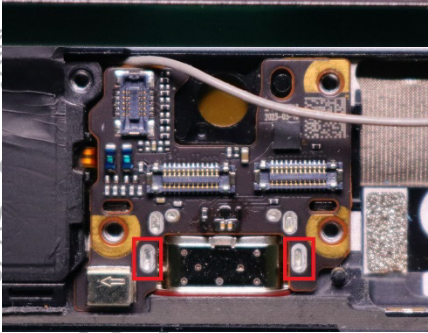
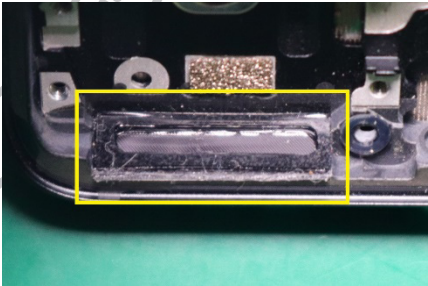

13. Place the small Peach Pad and select Next on the screen. Stripes face down and horizontal.

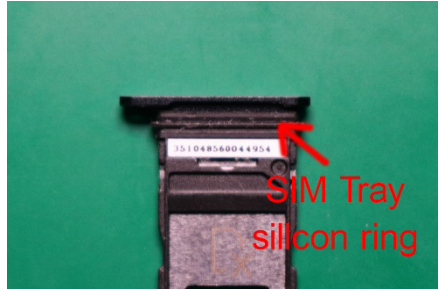
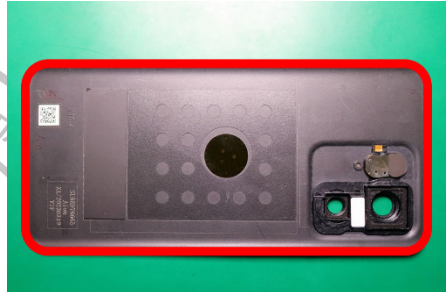


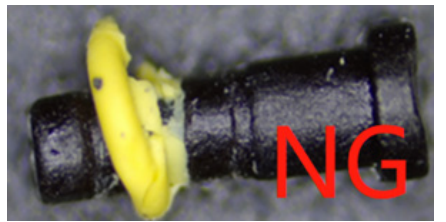


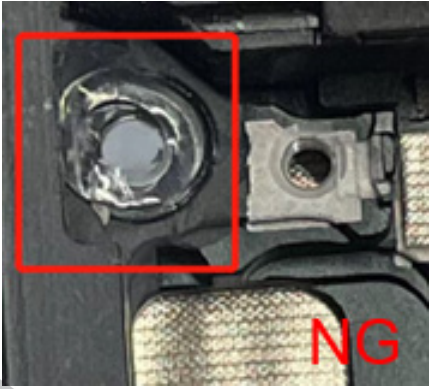
14. Calibration results should be as follows and then Exit.



DEFECTIVE AIR TIGHTNESS INSPECTION

Order	Check Content	Check Factors	Picture/Drawing
1	USB	<ol style="list-style-type: none"> Whether the USB sealing ring is damaged. Whether the edge of USB port hole on Front-Housing is damaged. Whether the USB port hole on Front-Housing is in place. 	  
2	Speaker Box	<ol style="list-style-type: none"> Whether the Speaker mesh is in place. Whether the Speaker Box leaks air (the probability is very low). 	
3	Sim Tray	<ol style="list-style-type: none"> Whether the Sim Tray is assembled in place. 	

Order	Check Content	Check Factors	Picture/Drawing
		2. Whether the Sim Tray silicon ring is damaged or dirty.	
4	Battery Cover	1. Whether the reused Battery Cover is clean. 2. Whether the Battery Cover adhesive has marks or dirt.	 
5	Middle Frame	1. Whether the residual adhesive is cleaned. 2. Whether the adhesive surface is damaged.	
6	Sim Pin	1. Whether the Sim Pin is assembled in place. 2. Whether the Sim Pin silicon is damaged.	

Order	Check Content	Check Factors	Picture/Drawing
7	Mic Mesh	<ol style="list-style-type: none">1. Whether the Mic Mesh is assembled in place.2. Whether the Mic Mesh is damaged or wrinkle.	



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.

12/06/2023

BROKEN GLASS HANDLING GUIDE

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.

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.

