



Moto G 5G(2024)

Level 2 – Service and Repair Manual





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Revision History

Revision	Date	Notes
1	02/05/2024	Initial Release.





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Chapter 1. Safety Information

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.

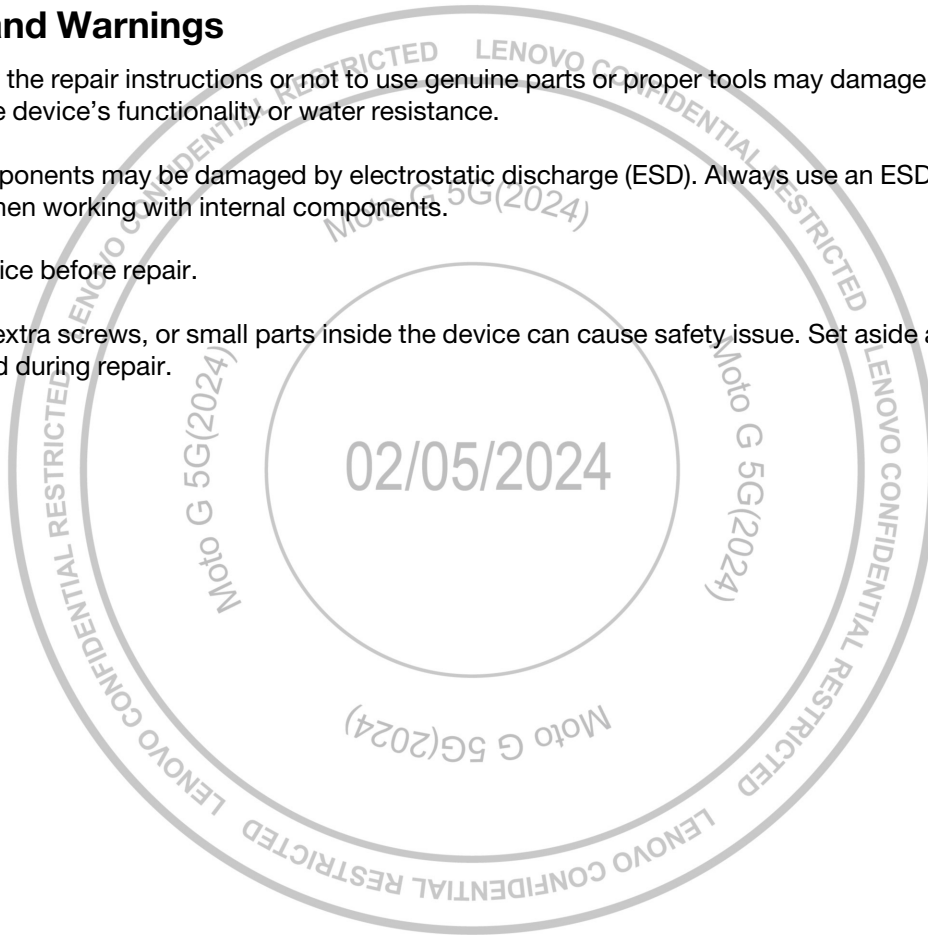
Cautions and Warnings

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.

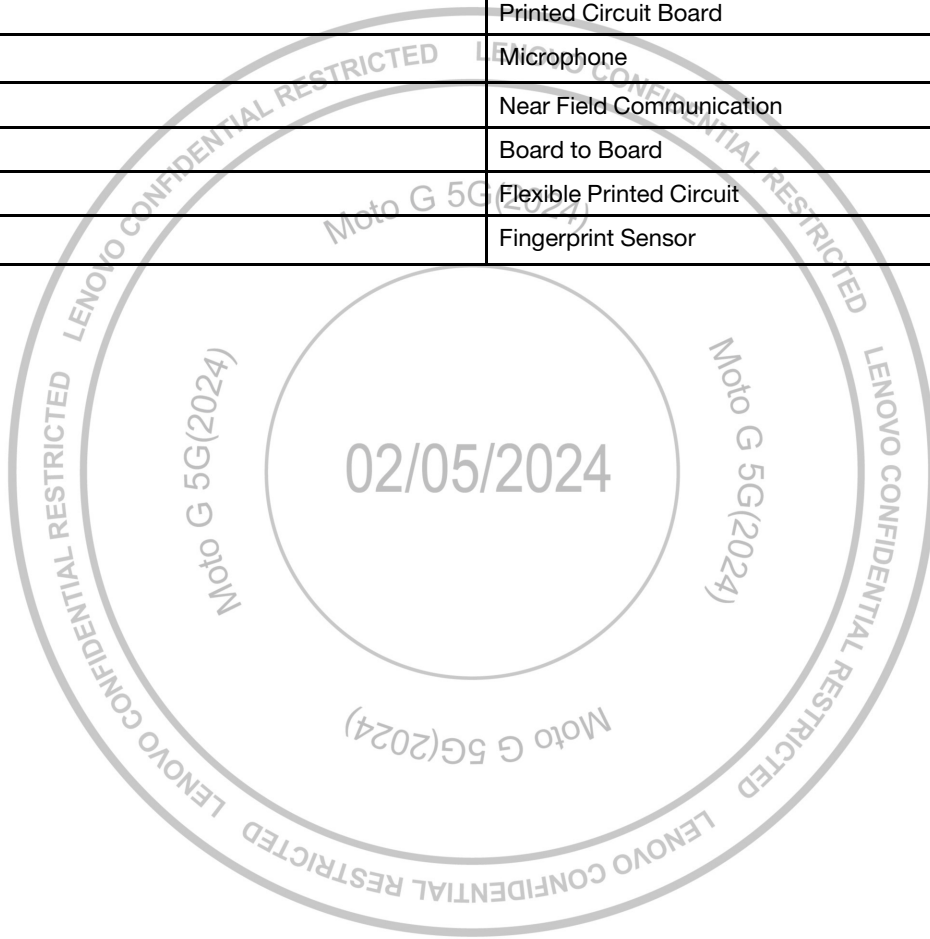


Chapter 2. Introduction

Acronyms and Abbreviations

Table 1. Acronyms and Abbreviations

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



External Views

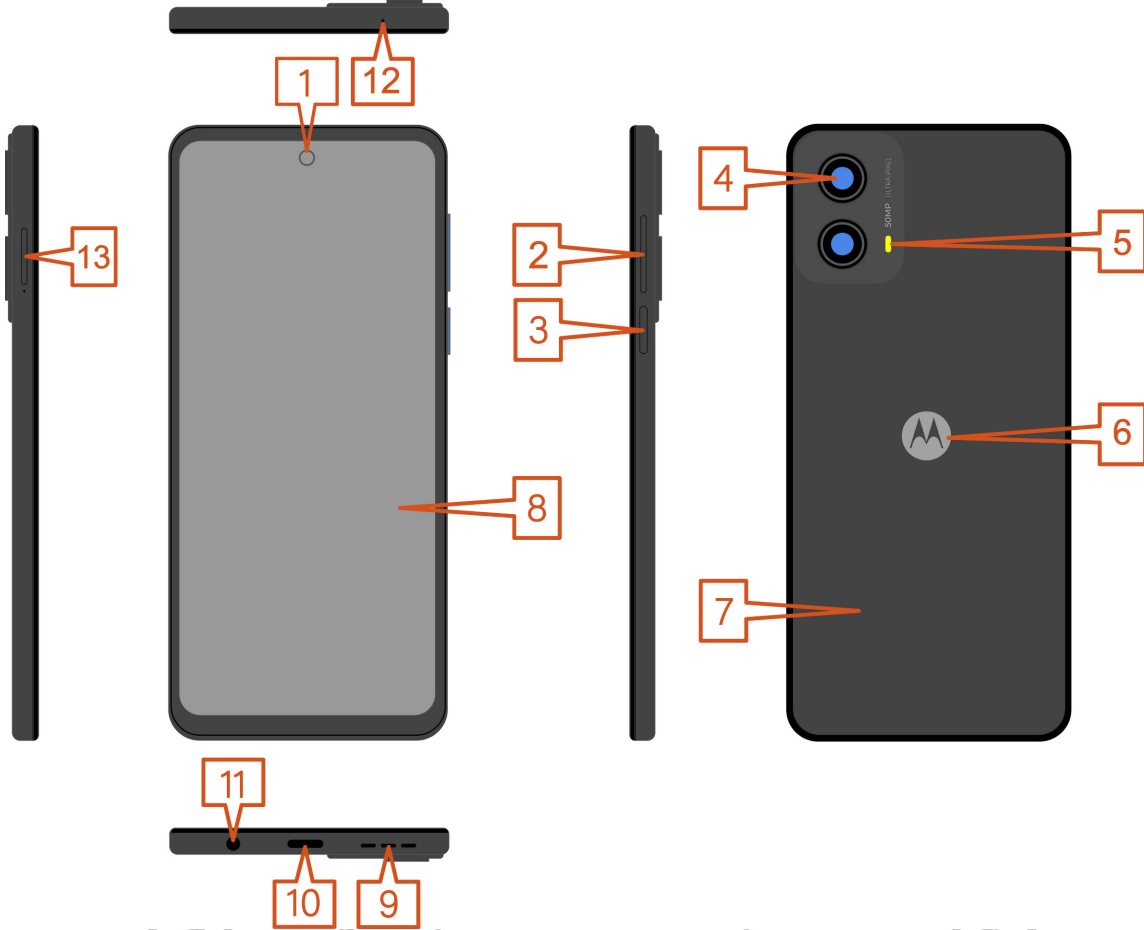


Figure 1. External Views

Table 2. External Views Parts List

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

Table 2. External Views Parts List (continued)

Reference #	Description
12	Microphone
13	Sim Door



Main Exploded Views

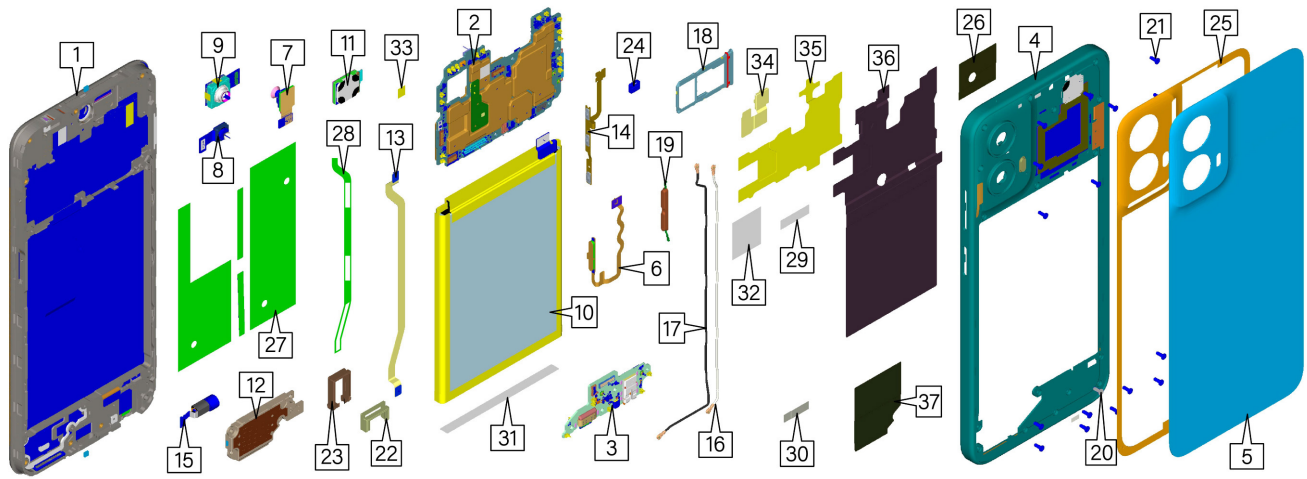


Figure 2. Assembly Exploded View

Table 3. Assembly Exploded View Parts List

Reference #	Description	Recovery Part
1	XT2417,TPLCM,CS	Yes
2	XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	Yes
3	XT2417,USB Board CS	Yes
4	XT2417,MID FRM,GRY CS	Yes
5	XT2417,Inlay,GRY CS	Yes
6	XT2417,FPS,GRY CS	Yes
7	MDL,CAMR,8M,FRNT,D1N801D;SUNNY:Fogo NA	Yes
8	MDL,CAMR,2M,rear;D1N206D;SUNNY,FF:Cancun	Yes
9	MDL,CAMR,50M,rear,C2PA30;Q Tech,AF:Cancu	Yes
10	ACCY,BAT,5000mAh,QF50,ATL436590,ATL	No
11	HQ705030000E0+Receiver_1210x2.8mm_HS	No
12	HQ705010004U0+BOX component_HS	Yes
13	HQ251010008U0+softboard assembly LinkFPC	Yes
14	HQ251010008W0+softboardAssembly SideKey	Yes
15	HQ704020000Q0+nonlinear motor_FPC_AH	Yes

Table 3. Assembly Exploded View Parts List (continued)

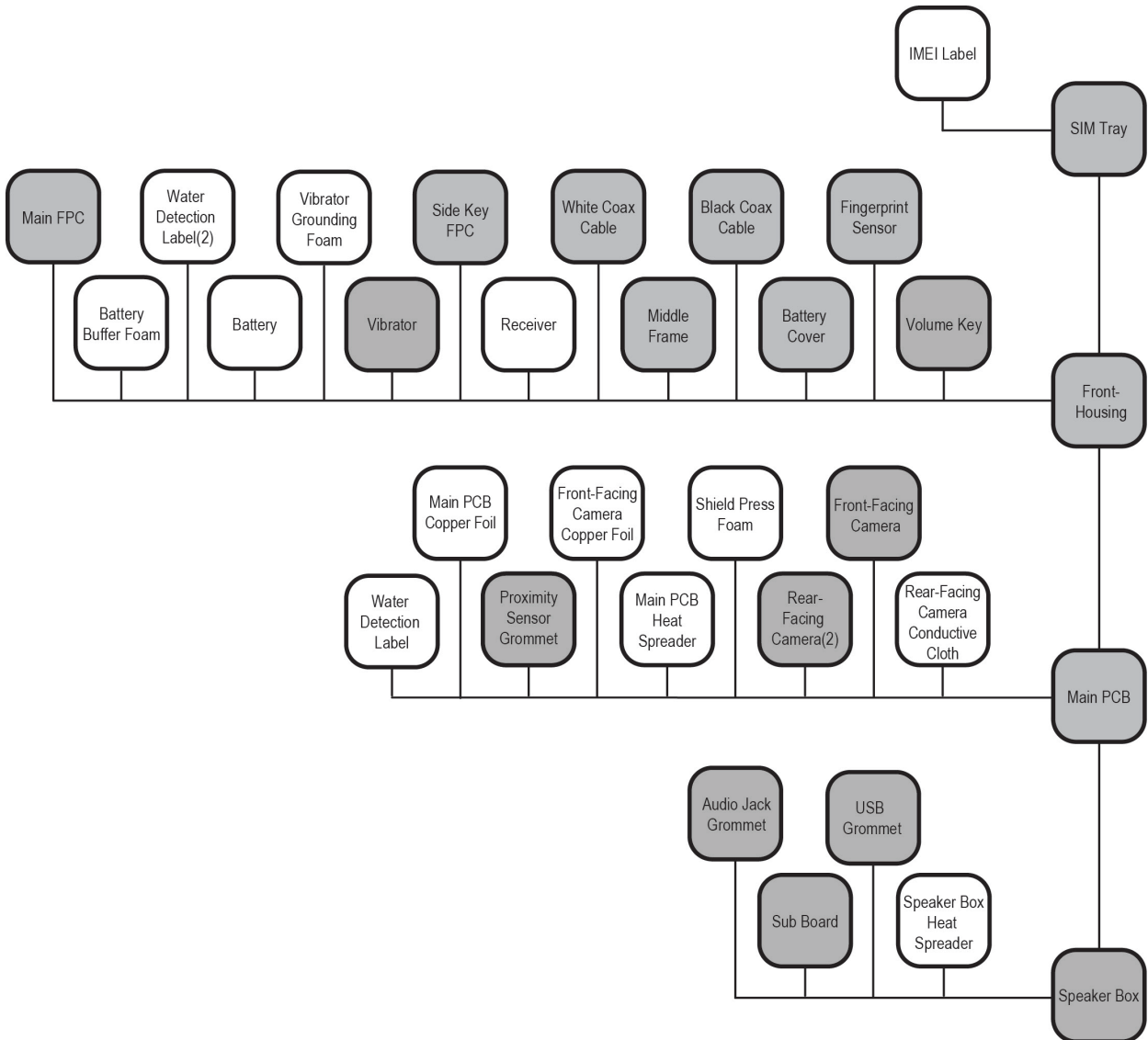
Reference #	Description	Recovery Part
16	HQ27001000430+coaxial cable0.64x142.9_DL	Yes
17	HQ27001000460+coaxial cable0.81x117.6_DL	Yes
18	HQ256010004L0+plastic Cato_Sedona Sage_J	Yes
19	HQ25401000340+Volume key_Sedona Sage_Spr	Yes
20	HQ269040006F0+Screw_round head_cross_PG	No
21	HQ22111669000+Screw_M1.4xL3.5xD2.5_LJT	No
22	HQ271040002L0+USB rubber sleeve_Black_GM	Yes
23	HQ271040002N0+Earphone rubber sleeve_GMM	Yes
24	HQ271040002Q0+rubber sleeve_P-Sensor_GMM	Yes
25	HQ253050000Y0+Inlay Adhesive CS	No
26	HQ253050001D0+Inlay-NFC Adhesive CS	No
27	HQ25203001C60+Battery Adhesive CS	No
28	HQ25203001C70+MainFPC Adhesive CS	No
29	HQ25804001A80+Middle frame foam Adhesive	No
30	HQ25804001A60+SPK_Shell vibrator adhesiv	No
31	HQ258010006Y0+Compressed foam_Battery_HJ	No
32	HQ25801000700+Shell_shielding foam_HJ	No
33	HQ25803001AY0+Camera conductive cloth_HJ	No
34	HQ25803001B60+Camera_copper foil_HJ	No
35	HQ25803001B40+Bot_copper foil mylar_HJ	No
36	HQ258100002G0+Shielding graphite_HLD	No
37	HQ258100001N0+graphite_SPK copperFoil_HL	No
/	HQ251040000G0+Sidekey FPC Adhesive CS	No
/	HQ70402000100+motorFPC Adhesive CS	No
/	HQ25803001B00+Conductive foam_Motor_HJ	No
/	HQ60460004000+waterproof label	No
/	HQ60420501000+Lisbon IMEI Label_DL	No
/	HQ62304000200+Cling_DL	No
/	HQ623020003D0+Cling_80g art paper_4C_DL	No



Chapter 3. Disassembly and Recovery

Disassembly and Recovery Map

*Shaded parts may be eligible for parts recovery.





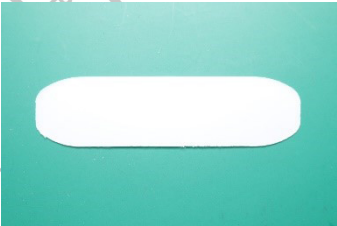

Tools Required for Disassembly

The following tools are required to disassemble the Moto G 5G(2024) phone.

NOTE
Improper tools may cause damage to components.

Description	Part #	Picture/Drawing
3 mm Allen Wrench	--	
Anti-static foam pad Pad thickness : ≥5mm Pad Material : silicone rubber, as reference Silicone Clean Matt (RG-400)	--	
Hot Plate	--	
SIM/SD Tray Removal Tool	--	
Black Stick	--	

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

Description	Part #	Picture/Drawing
Plastic Tweezers	--	
Oven	RG-202F	
Thin Plastic Spudger	Moto G 5G(2024) 0-00-00-40826	
PU Inlay Disassembly Tool	02/05/2024 30007085	
ESD Mat	--	--
Wrist Strap	--	--
Gloves	--	--

SIM Tray Removal

NOTE

The SIM Tray can be recovered and reused after removal.

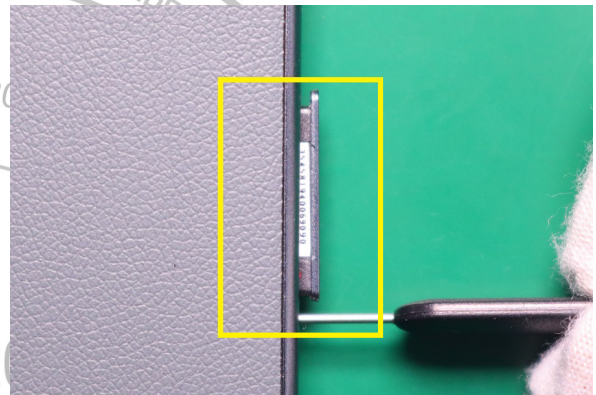


1. Power off the device before beginning with the procedure. Use the SIM Tray Removal pin to push into the SIM Tray hole.

WARNING

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

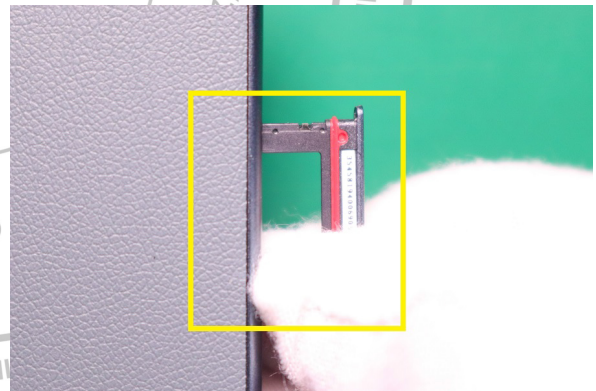
2. Press the SIM Tray removal tool to make it pop-out as shown.



3. Use fingers to take out the SIM Tray.

NOTE

Remove the SIM Tray vertically outwards to avoid deformation.

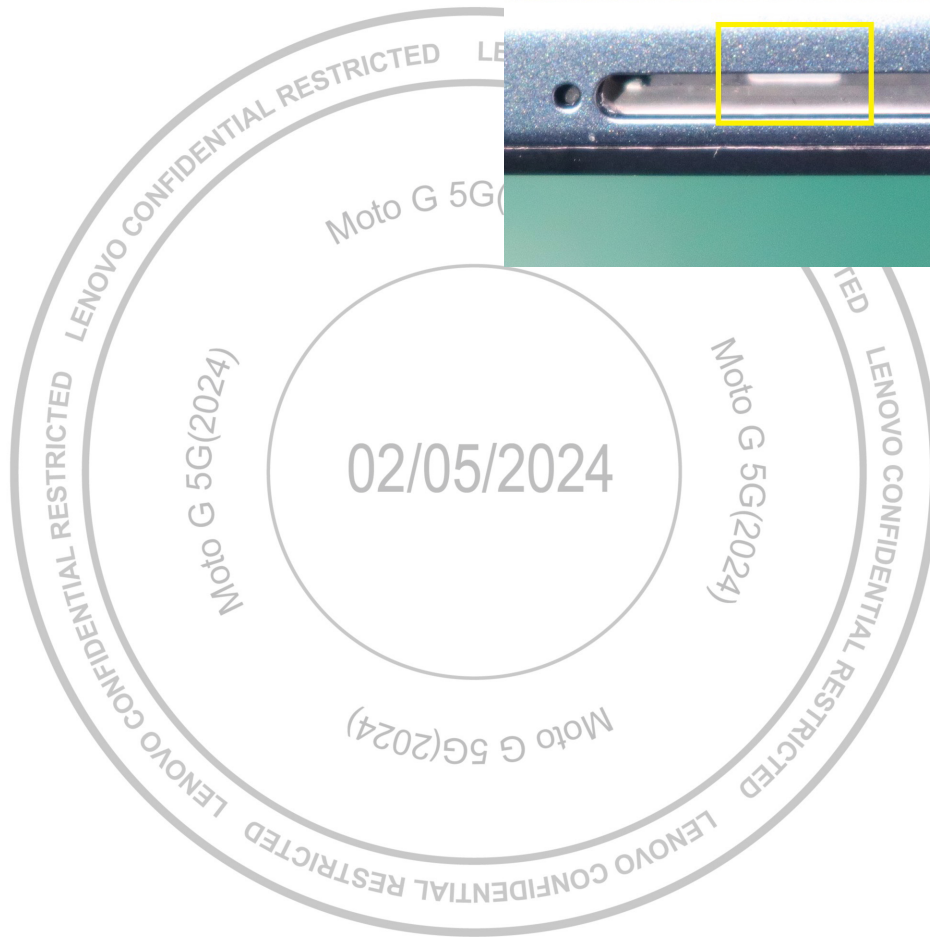
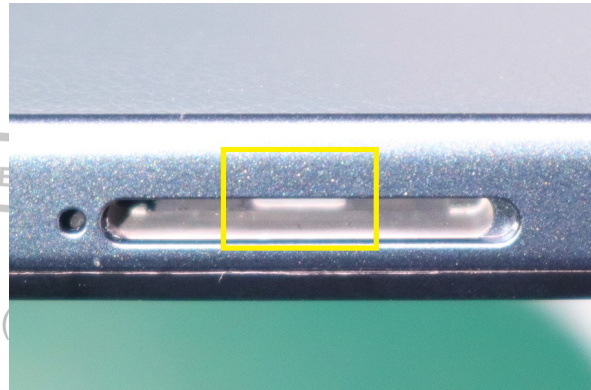


Water Detection Label Inspection

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.



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.



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.

NOTE

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

3. Remove the phone from the oven.

// CAUTION //

Wear protective gloves when handling heated phones.

NOTE

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

Battery Cover Removal

NOTE

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



1. Use the 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//

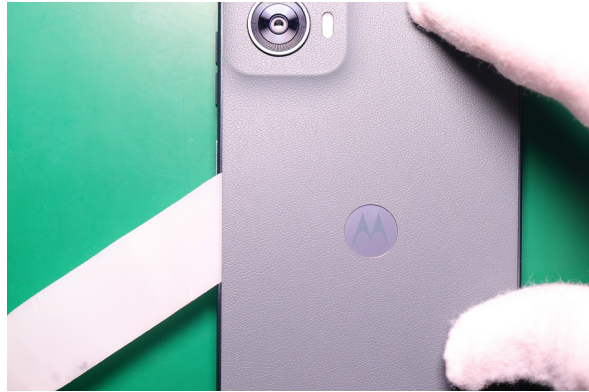
Do not insert the Thin Plastic Spudger more than 10 mm to prevent damaging internal components.



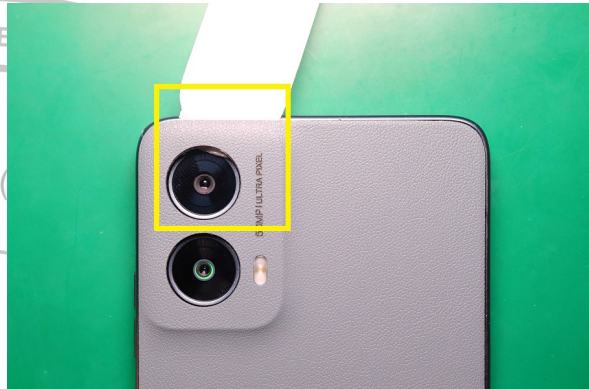
3. Use the Thin Plastic Spudger to disengage the Battery Cover from all the sides of the phone.



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



5. Use the Thin Plastic Spudger to disengage the adhesive from the Camera Decoration area as shown.



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



7. Pull the Battery Cover up toward bottom and upper side.



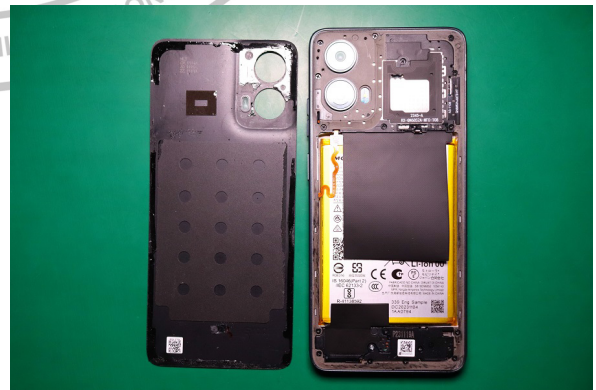
NOTE
Make sure not to rotate the Battery Cover too much, it will cause Battery Cover crack.



NOTE
Make sure to pry Battery Cover up slowly and keep Battery Cover be flat when separate Battery Cover with Front-Housing.



8. Split the Battery Cover from the phone.



Middle Frame Removal

NOTE

The Middle Frame can be recovered and reused after removal.



1. Use the Torque Driver with PH00 Bit to remove the 18 screws as shown.

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

NOTE

Keep the screws properly.

WARNING

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



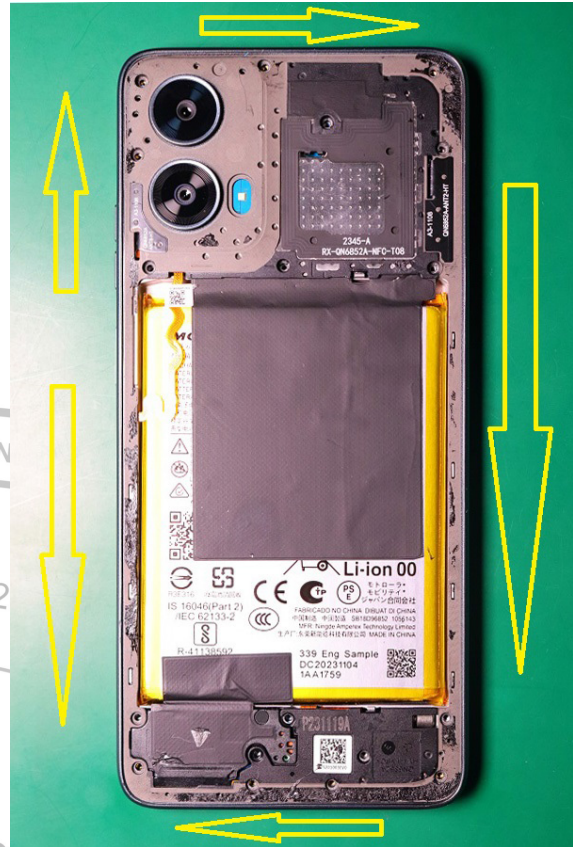
2. Use the Shim to create a gap between Front-Housing and Middle Frame from the Side Key position as shown.

WARNING

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



- Use the Shim in the direction as shown.



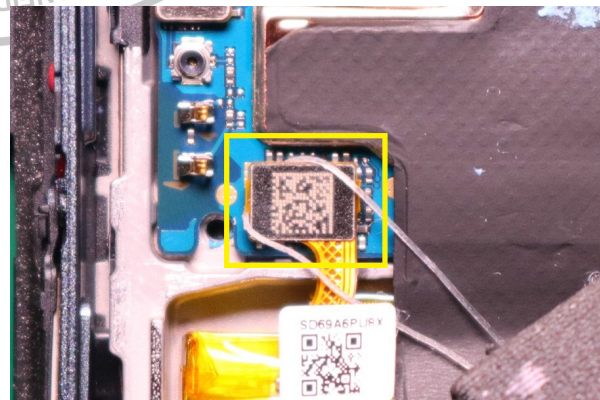
- Split the Middle Frame from the phone.

WARNING
Be careful to avoid damaging the Fingerprint Sensor FPC.



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

WARNING
Be careful to avoid damaging the BtB connector.



Fingerprint Sensor Removal

NOTE

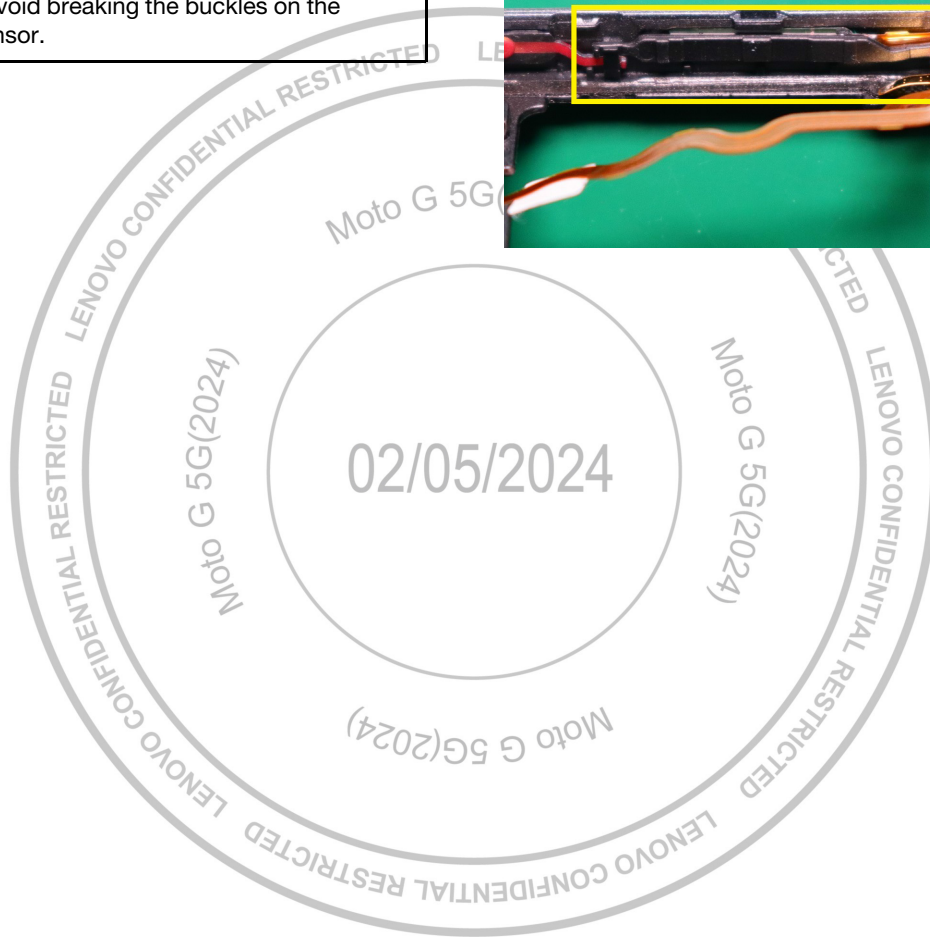
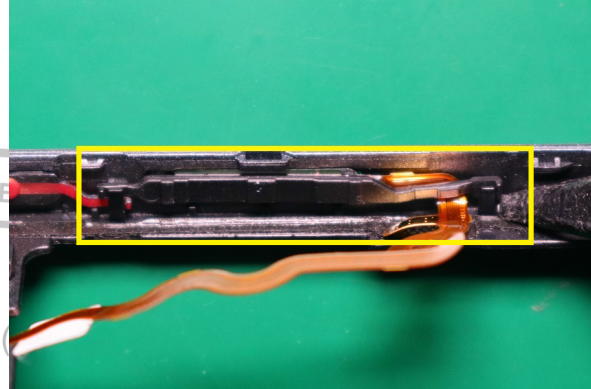
The Fingerprint Sensor can be recovered and reused after removal.



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

NOTE

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



Volume Key Removal

NOTE

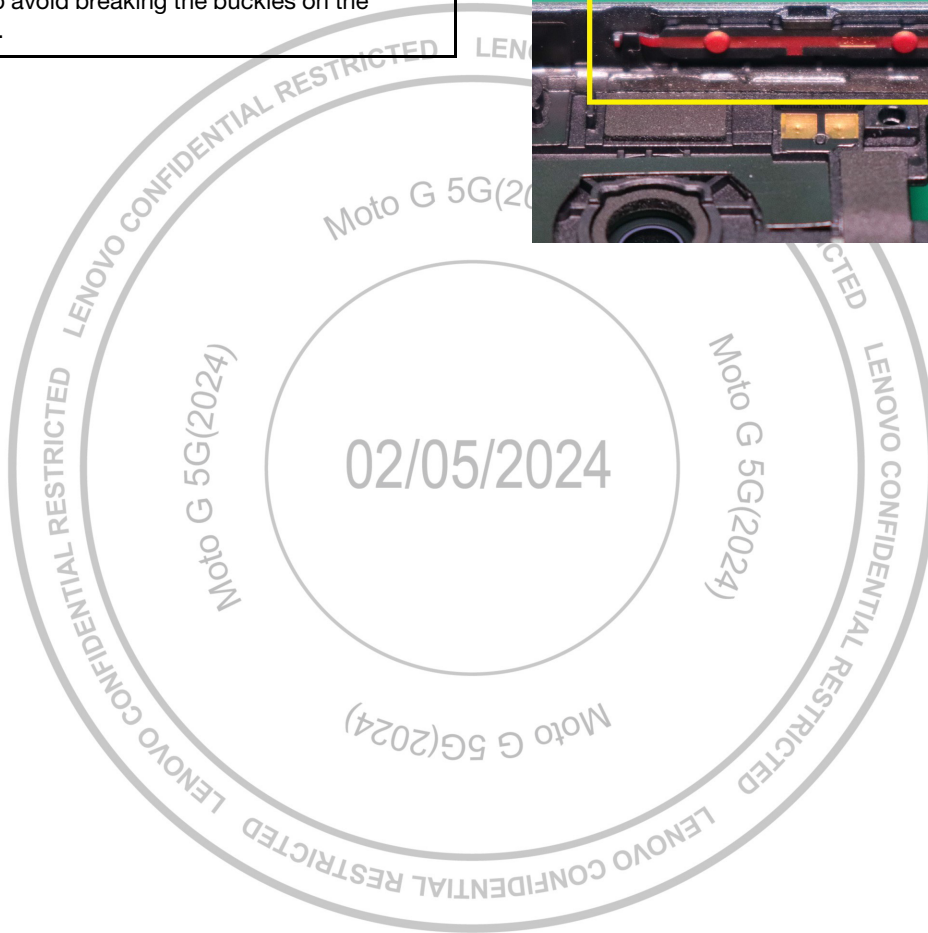
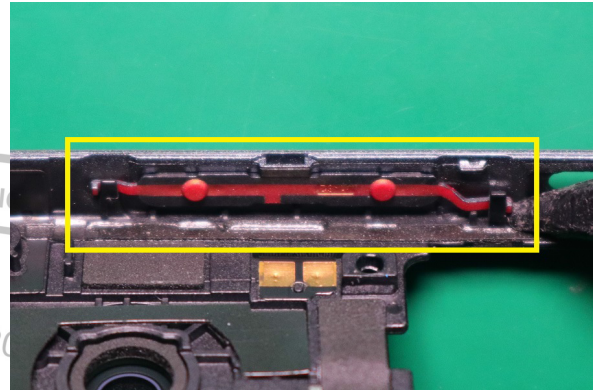
The Volume Key can be recovered and reused after removal.



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

NOTE

Be careful to avoid breaking the buckles on the Volume Key.

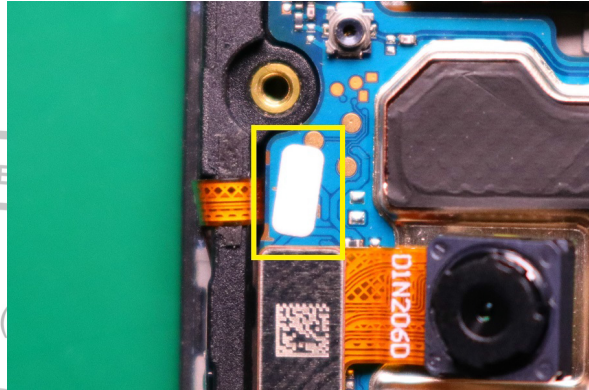


Water Detection Label Inspection

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.



2M Rear-Facing Camera Removal

NOTE

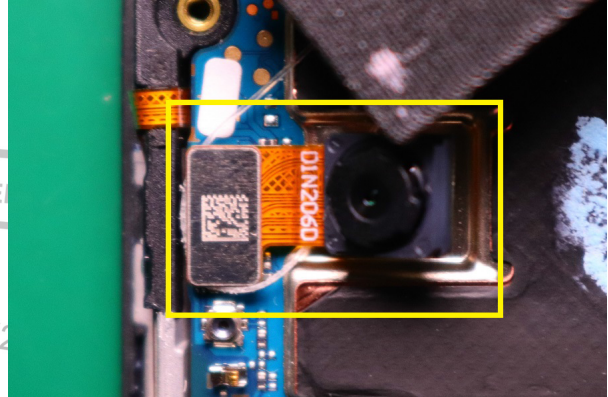
The 2M Rear-Facing Camera can be recovered and reused after removal.



Use the BtB tool to disengage and remove the 2M Rear-Facing Camera from the Main PCB as shown.

NOTE

Be careful to avoid damaging the 2M Rear-Facing Camera BtB connector.



2M Rear-Facing Camera Conductive Cloth Removal

NOTE

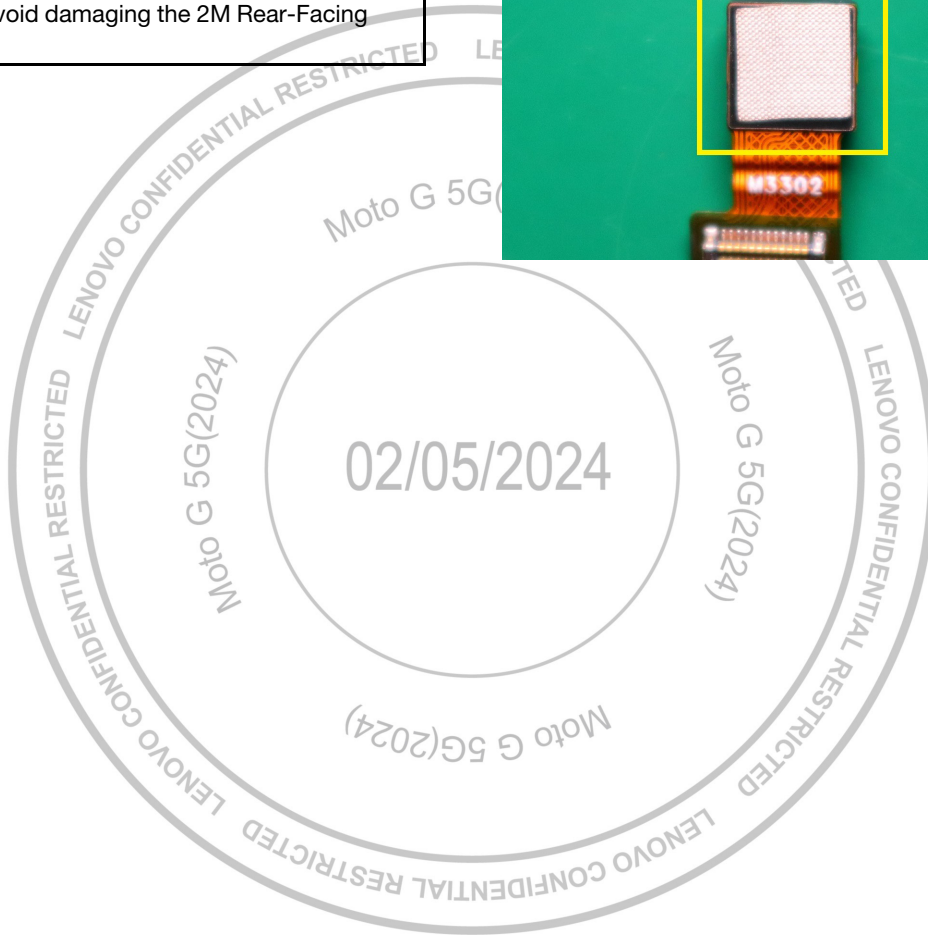
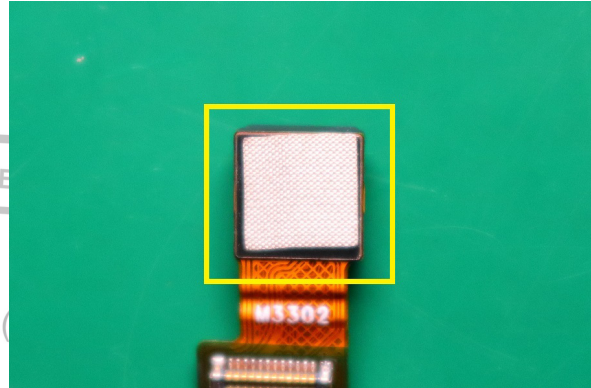
After you remove the 2M Rear-Facing Camera Conductive Cloth, you cannot reuse it.



Use the Plastic Tweezer to remove the 2M Rear-Facing Camera Conductive Cloth from the location as shown.

NOTE

Be careful to avoid damaging the 2M Rear-Facing Camera.



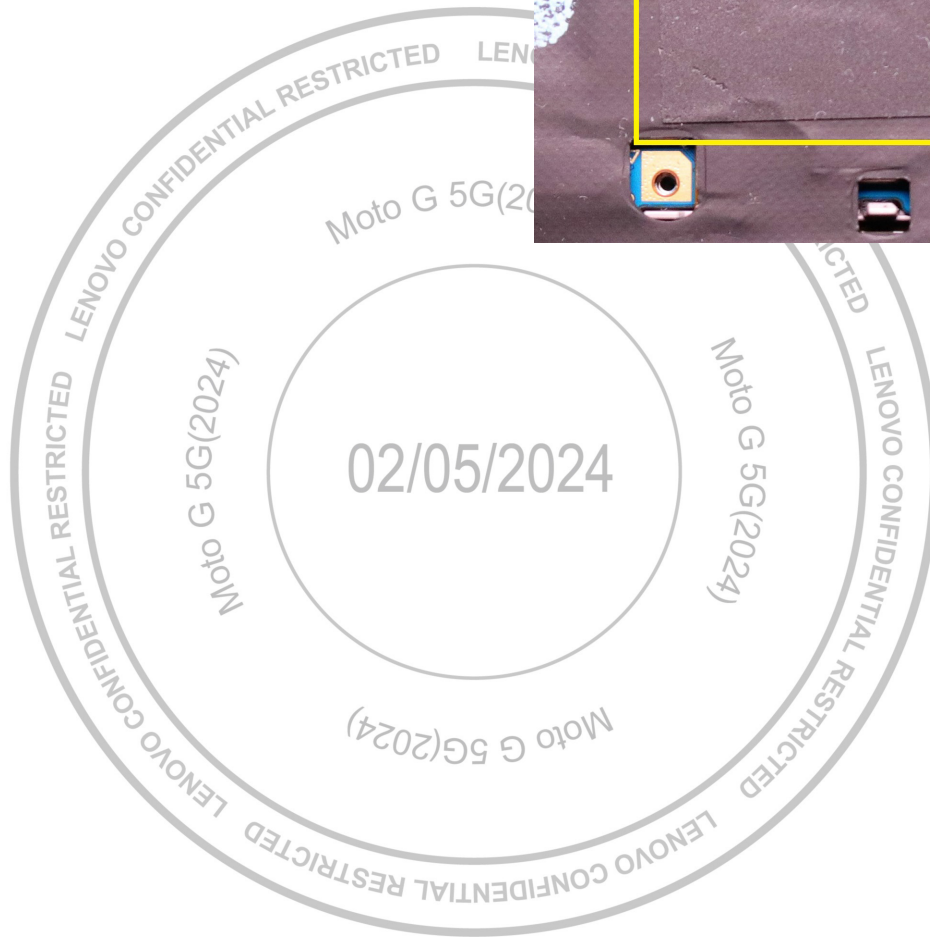
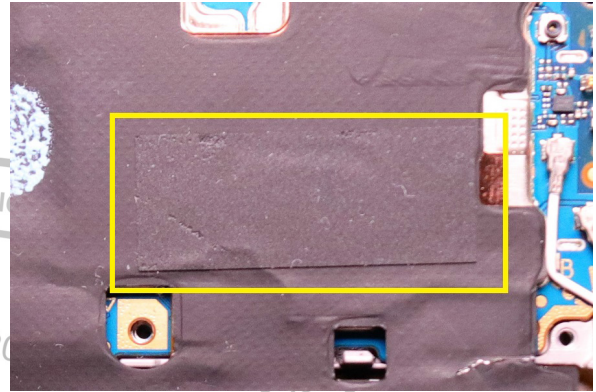
Shield Press Foam Removal

NOTE

After you remove the Shield Press Foam, you cannot reuse it.



Use the Plastic Tweezer to remove the Shield Press Foam from the location as shown.



Main PCB Heat Spreader Removal

NOTE

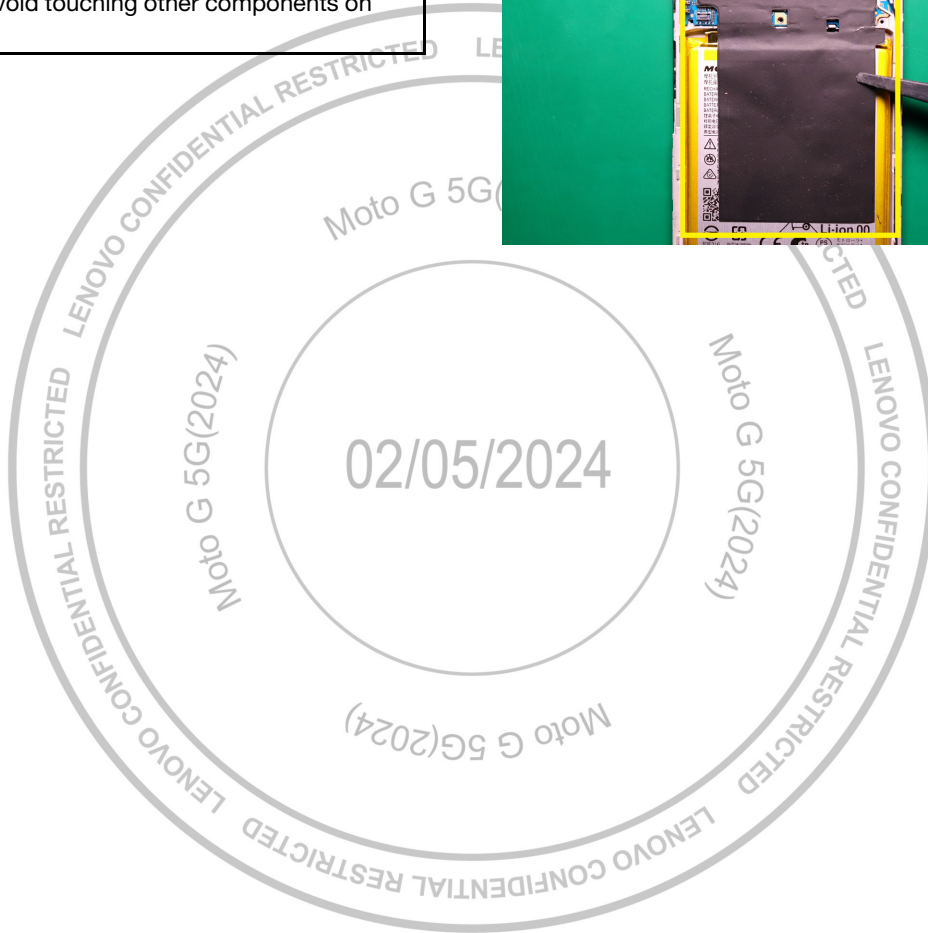
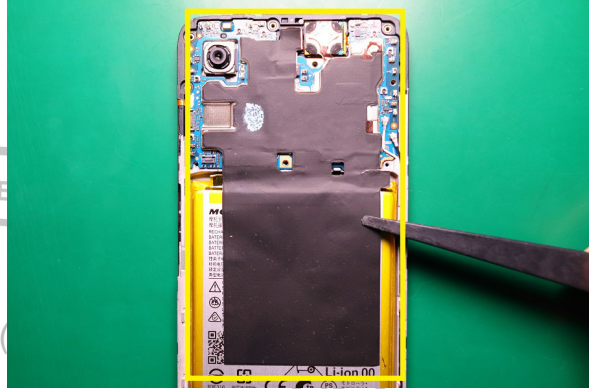
After you remove the Main PCB Heat Spreader, you cannot reuse it.



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

NOTE

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



Front-Facing Camera Copper Foil Removal

NOTE

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



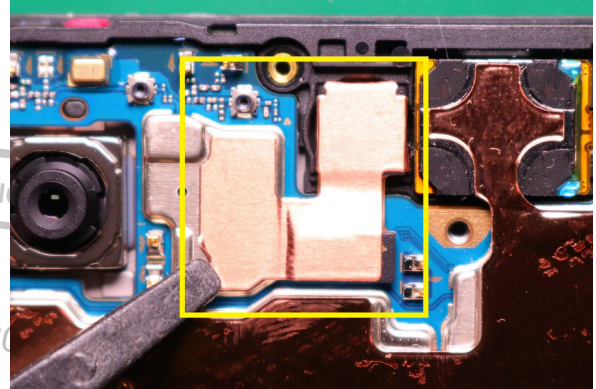
Use the Plastic Tweezer to remove the Front-Facing Camera Copper Foil from the location as shown.

NOTE

The Front-Facing Camera Copper Foil covers the top, left, and right sides of the Front-Facing Camera. Remove them all.

NOTE

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



02/05/2024

Front-Facing Camera Removal

NOTE

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



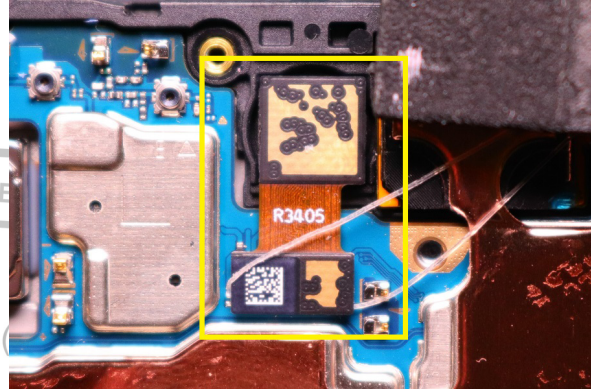
Use the BtB tool to disengage and remove Front-Facing Camera from the location as shown.

NOTE

Check the sides of the Front-Facing Camera for any residual copper foil, if found, clear it away.

NOTE

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



02/05/2024

Main PCB Copper Foil Removal

NOTE

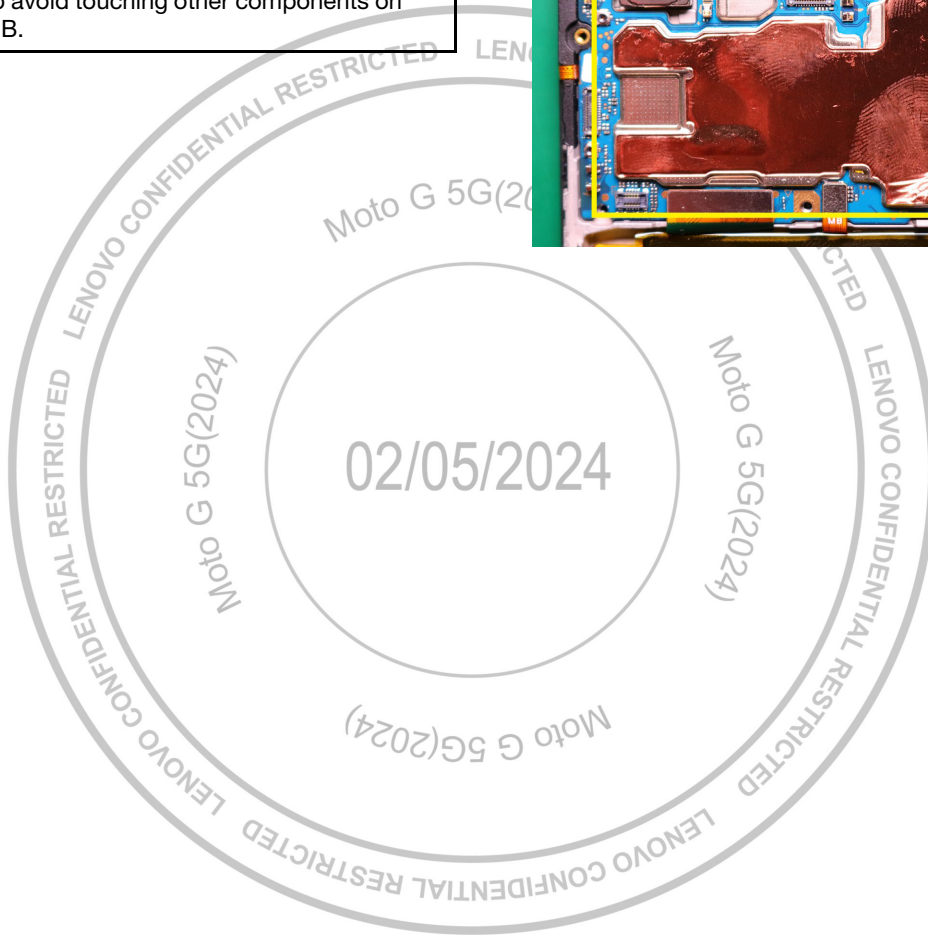
After you remove the Main PCB Copper Foil, you cannot reuse it.



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

NOTE

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



Main PCB Removal

NOTE

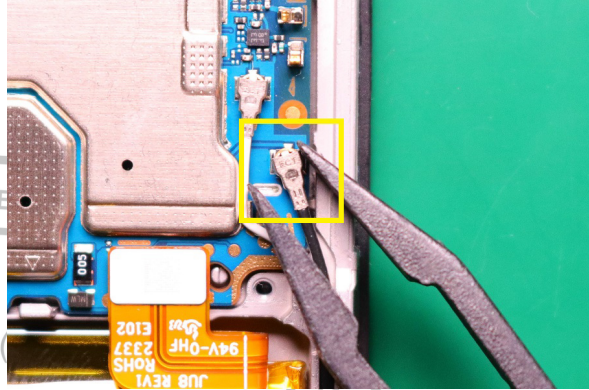
The Main PCB can be recovered and reused after removal.



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

NOTE

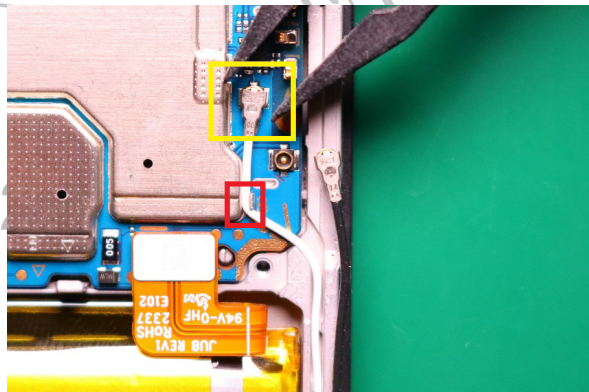
Be careful to avoid damaging the metal ring of the Black Coax Cable.



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

NOTE

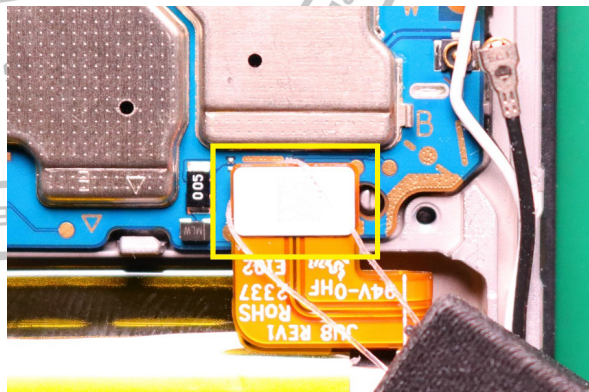
Be careful to avoid damaging the metal ring of the White Coax Cable.



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

NOTE

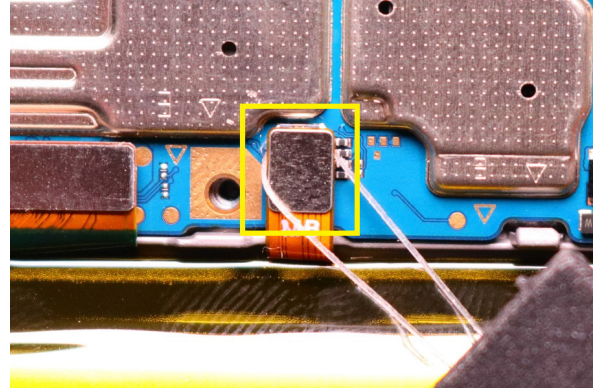
Be careful to avoid damaging the BtB connector.



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

NOTE

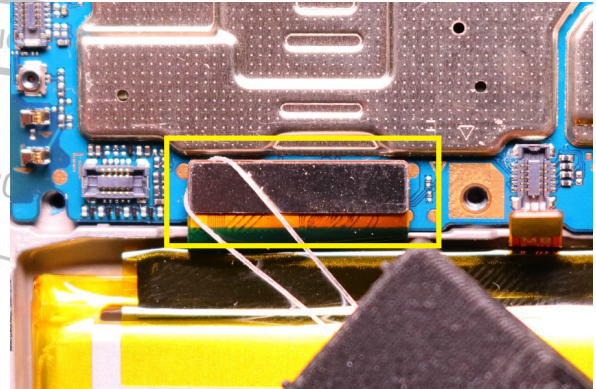
Be careful to avoid damaging the BtB connector.



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

NOTE

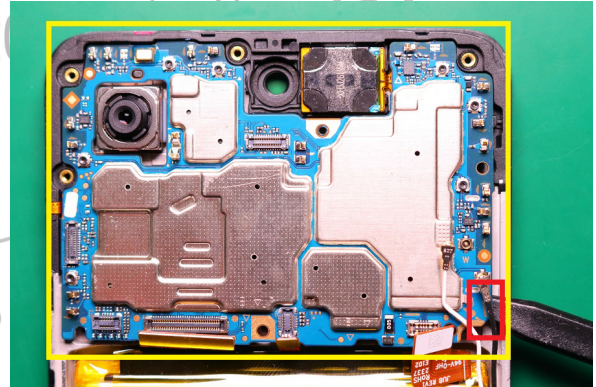
Be careful to avoid damaging the BtB connector.



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

NOTE

Do not lift too hard to damage the Main PCB.



50M Rear-Facing Camera Removal

NOTE

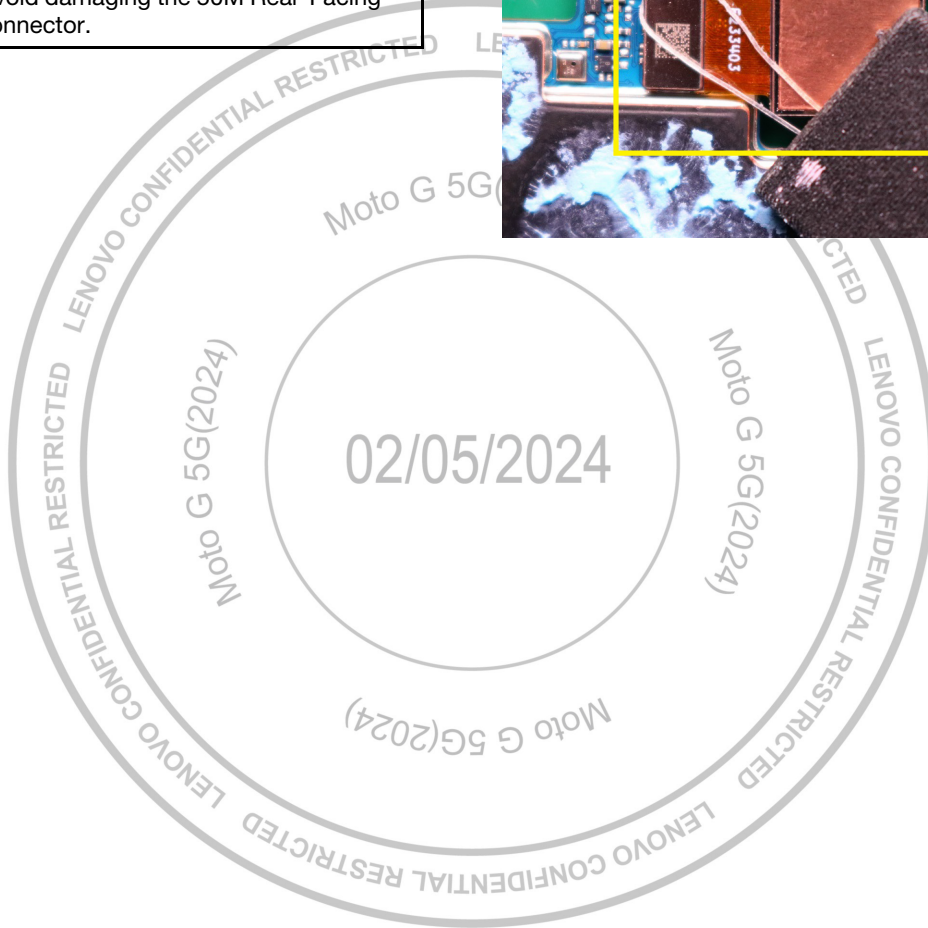
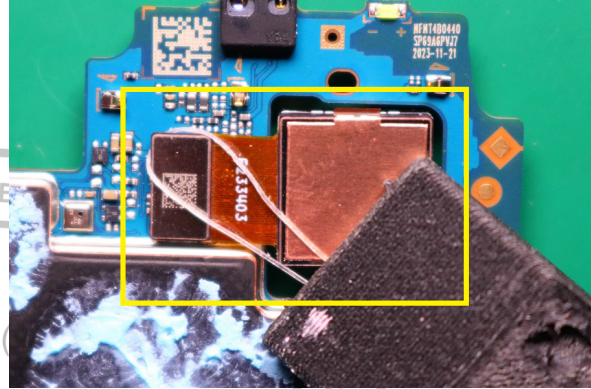
The 50M Rear-Facing Camera can be recovered and reused after removal.



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

NOTE

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



Proximity Sensor Grommet Removal

NOTE

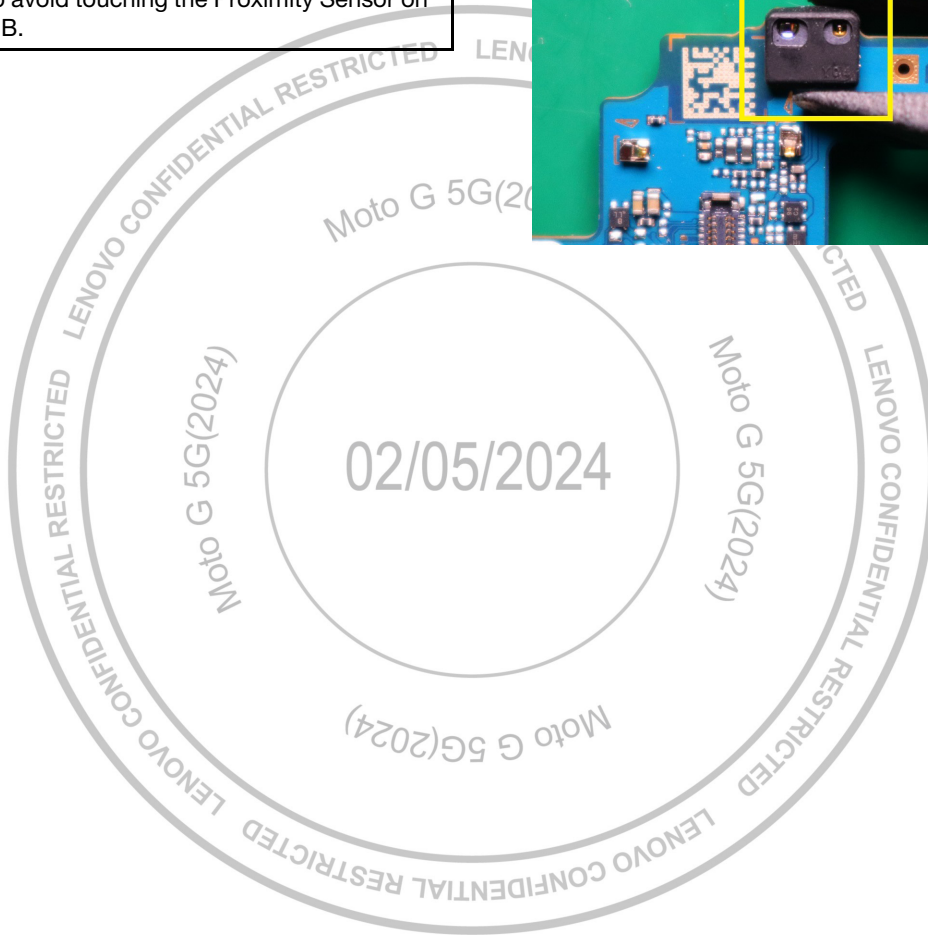
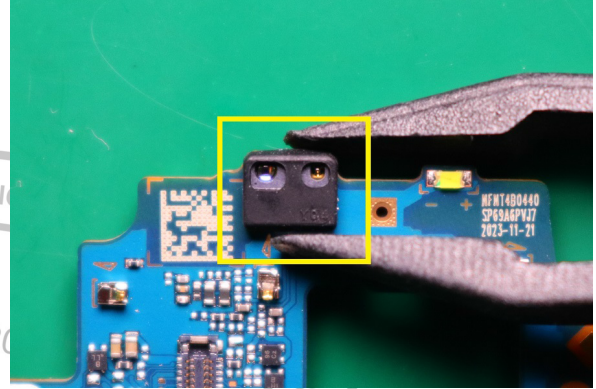
The Proximity Sensor Grommet can be recovered and reused after removal.



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

NOTE

Be careful to avoid touching the Proximity Sensor on the Main PCB.



Speaker Box Removal

NOTE

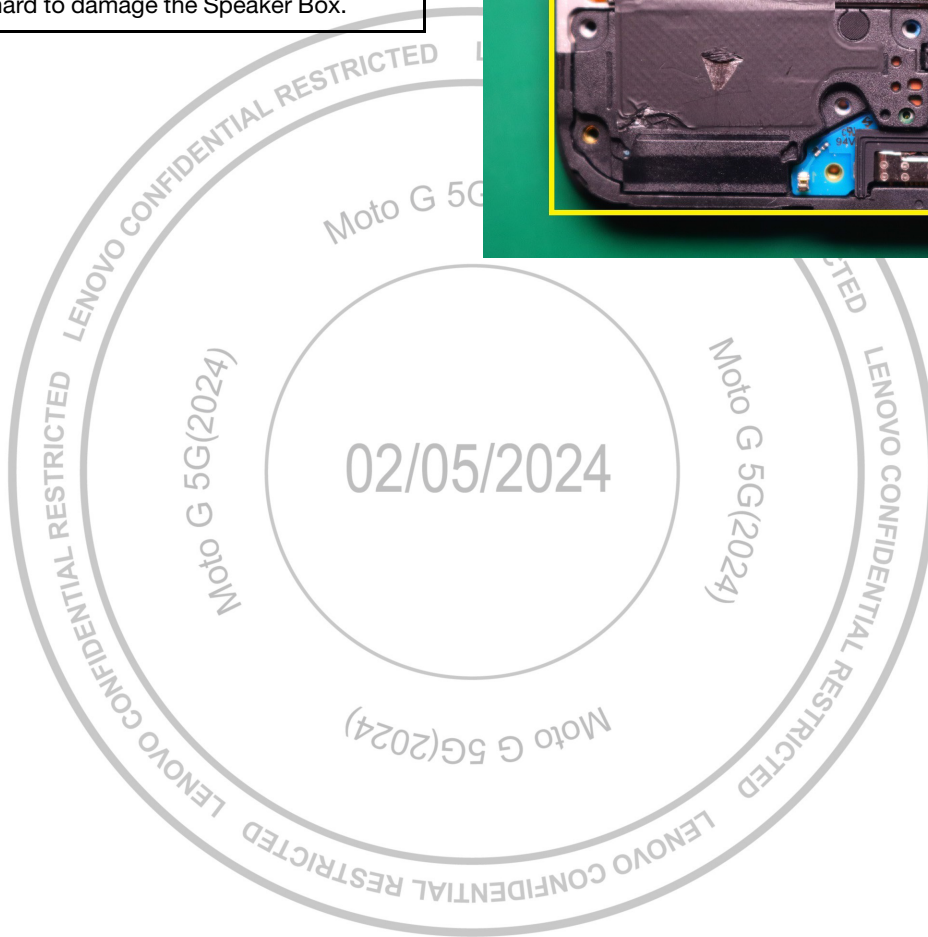
The Speaker Box can be recovered and reused after removal.



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

NOTE

Do not lift too hard to damage the Speaker Box.



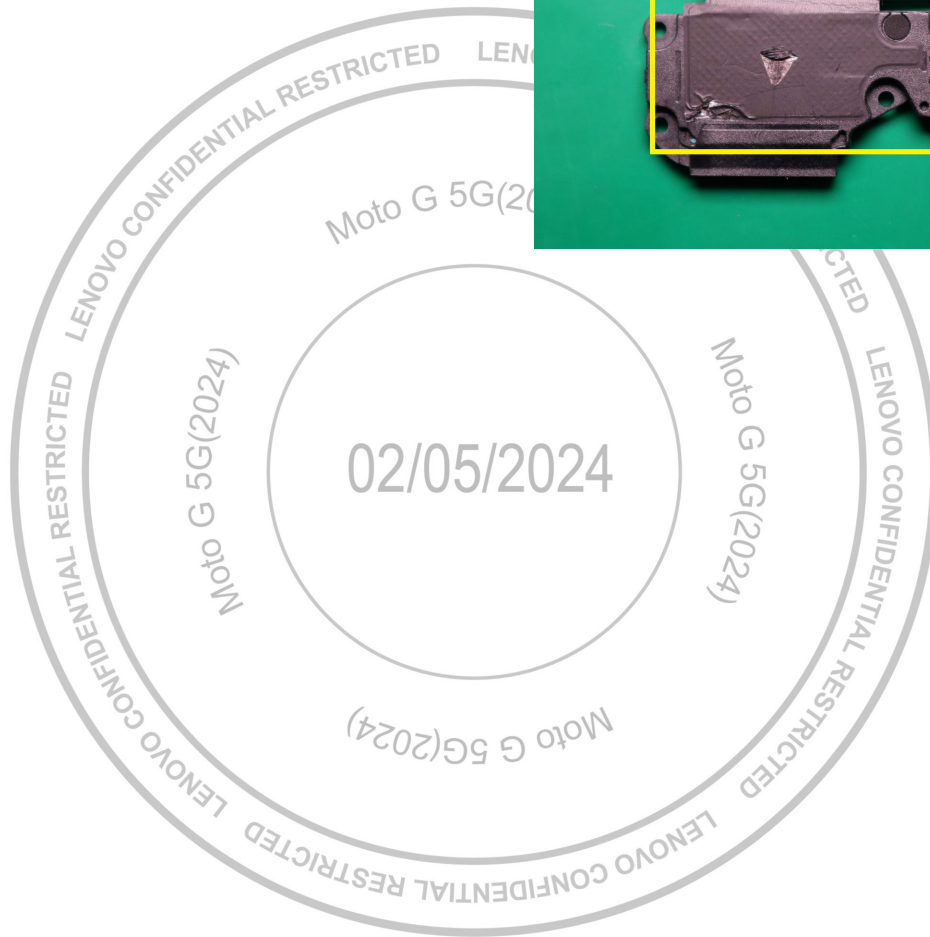
Speaker Box Heat Spreader Removal

NOTE

After you remove the Speaker Box Heat Spreader, you cannot reuse it.



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



Sub Board Removal

NOTE

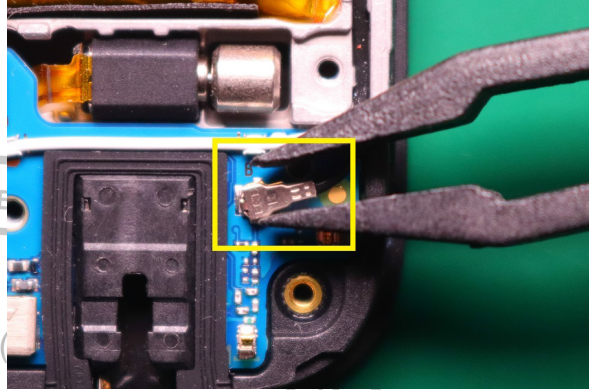
The Sub Board can be recovered and reused after removal.



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

NOTE

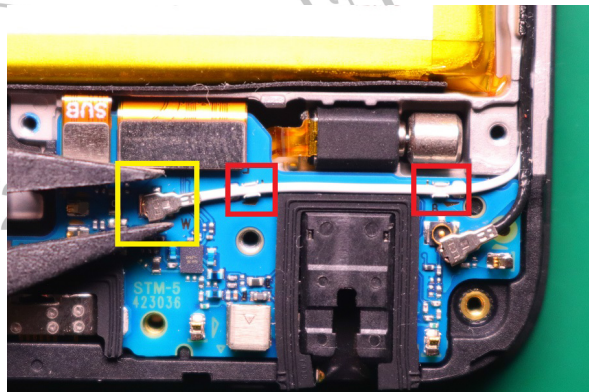
Be careful to avoid damaging the metal ring of the Black Coax Cable.



2. Use the Plastic Tweezer to disconnect the White Coax Cable from the location and remove the White Coax Cable from the cable guide as shown.

NOTE

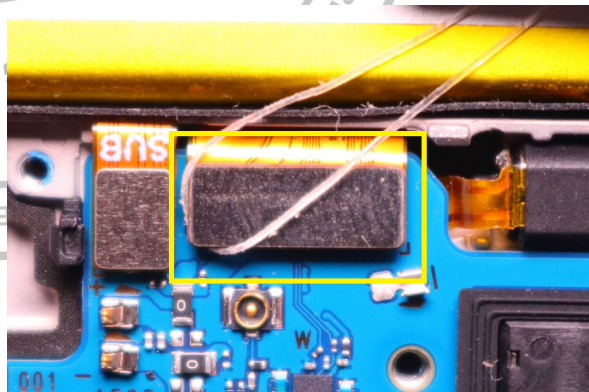
Be careful to avoid damaging the metal ring of the White Coax Cable.



3. Use the BtB tool to disengage the TP FPC BtB Connector from the location as shown.

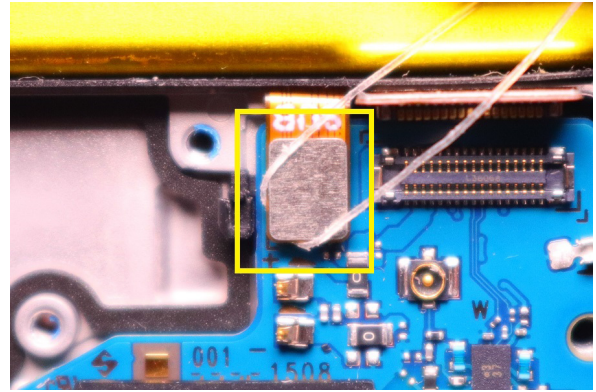
NOTE

Be careful to avoid damaging the BtB connector.



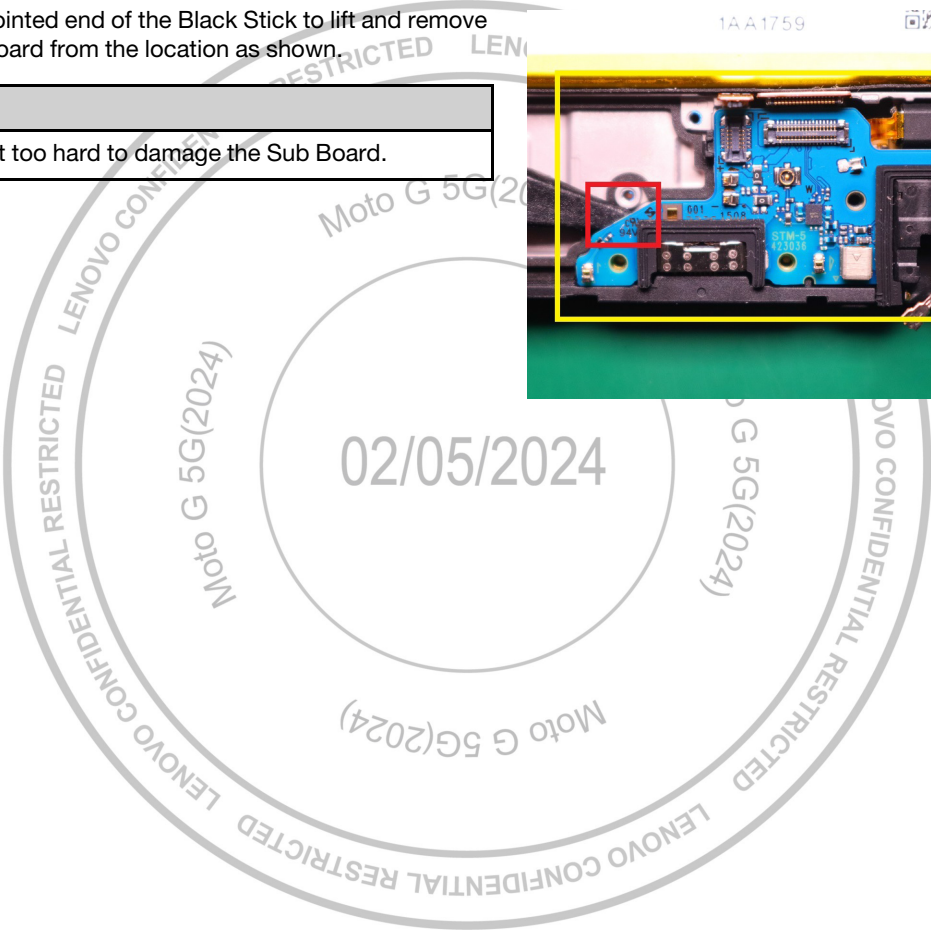
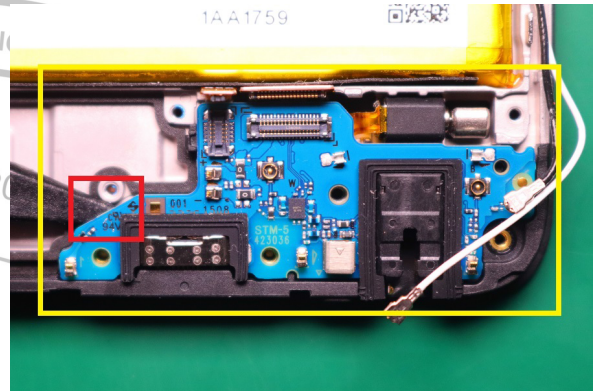
4. Use the BtB tool to disengage the Main FPC BtB Connector from the location as shown.

NOTE
Be careful to avoid damaging the BtB connector.



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

NOTE
Do not lift too hard to damage the Sub Board.

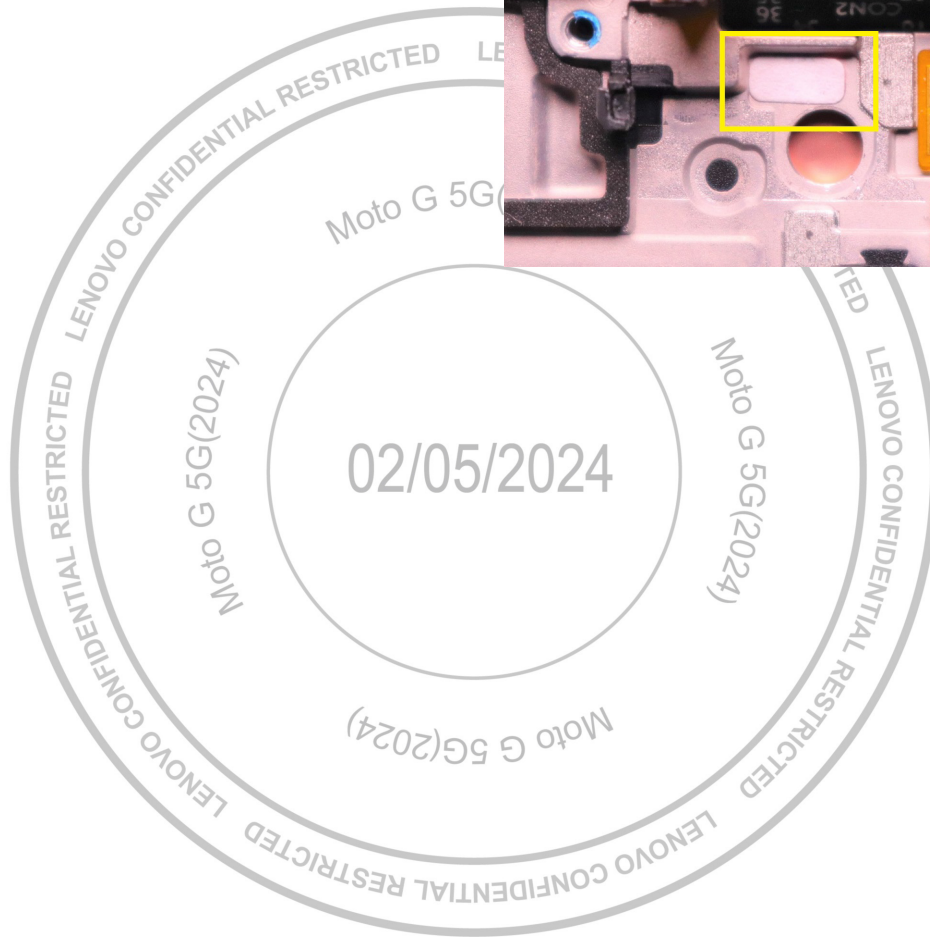
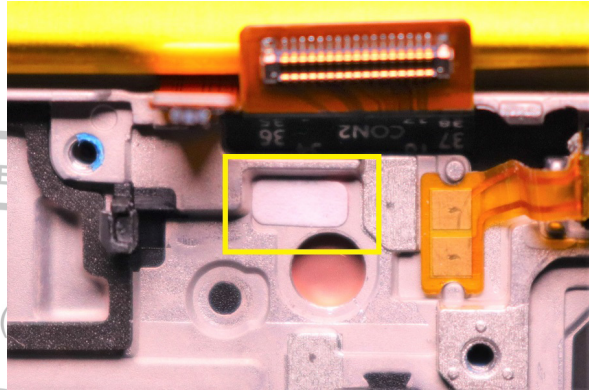


Water Detection Label Inspection

NOTE

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

Inspect the WDL on the Front-Housing for signs of activation.



Audio Jack Grommet Removal

NOTE

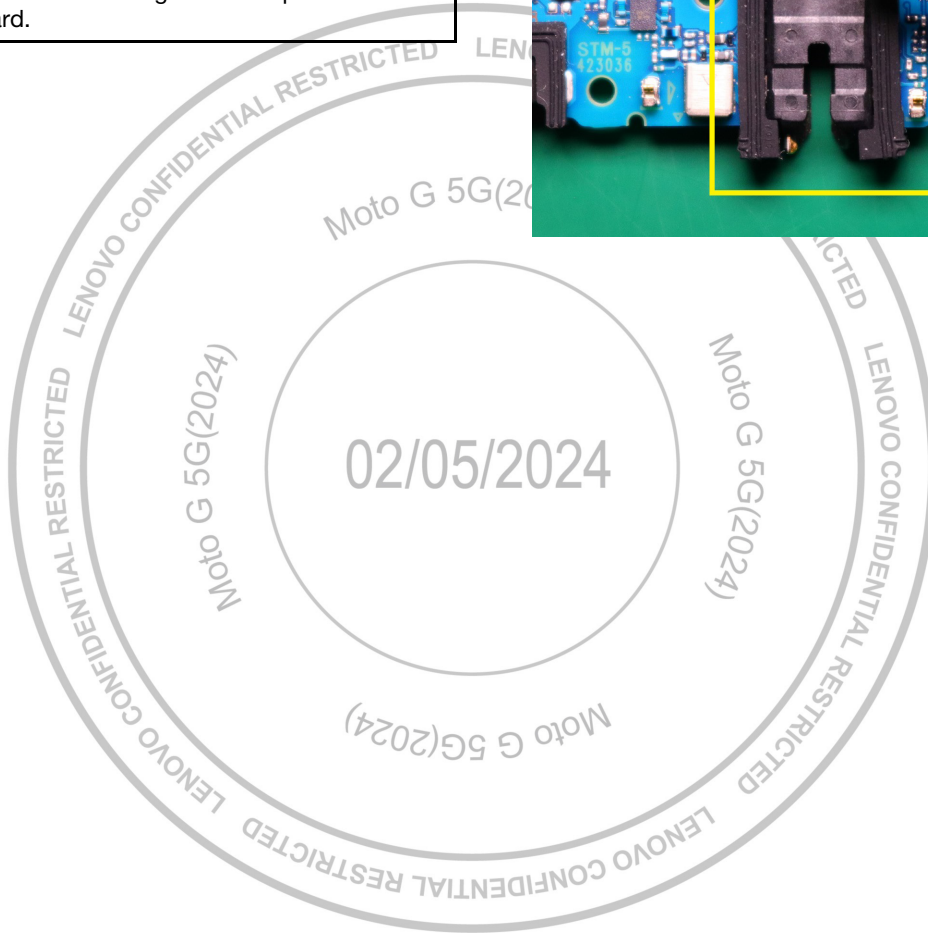
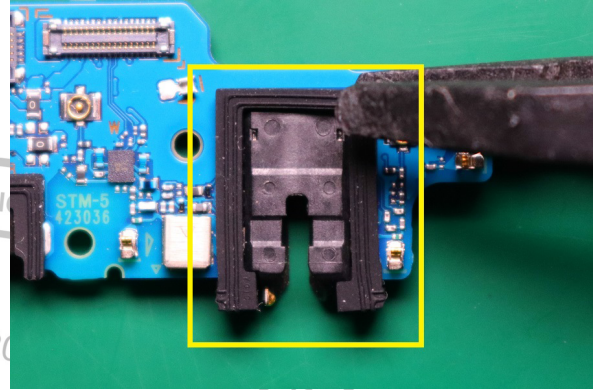
The Audio Jack Grommet can be recovered and reused after removal.



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

NOTE

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



USB Grommet Removal

NOTE

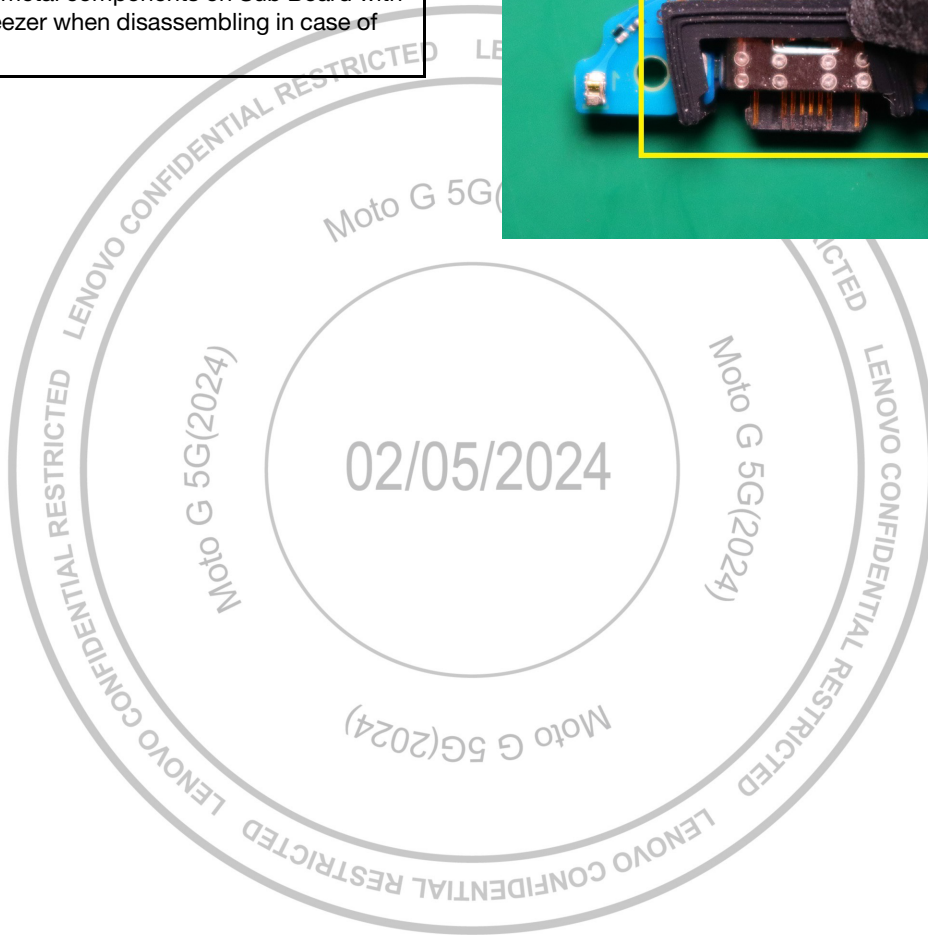
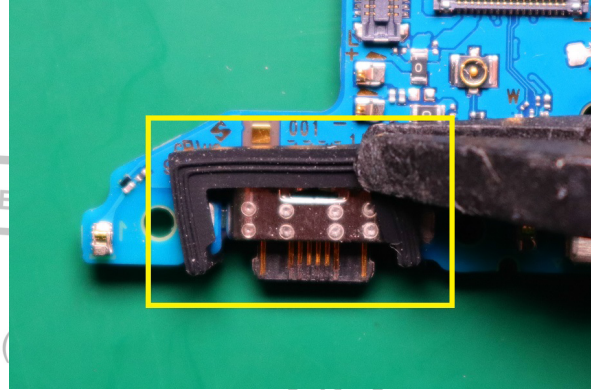
The USB Grommet can be recovered and reused after removal.



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

NOTE

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



Black Coax Cable Removal

NOTE

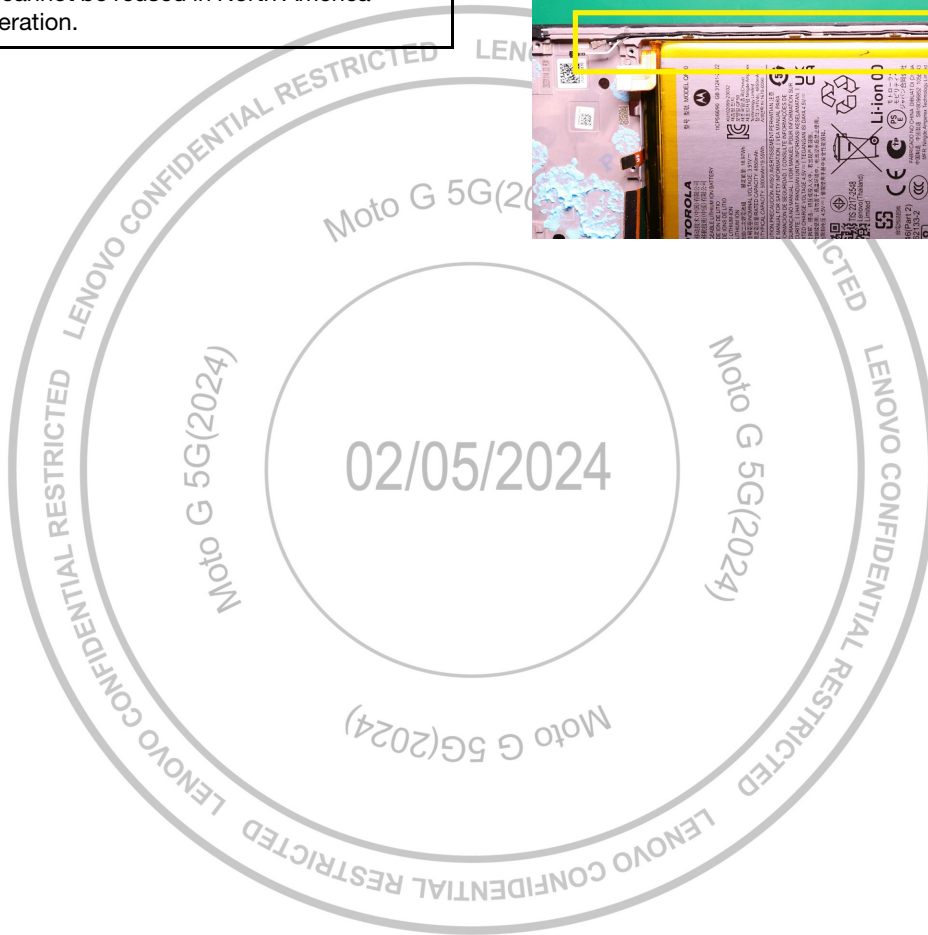
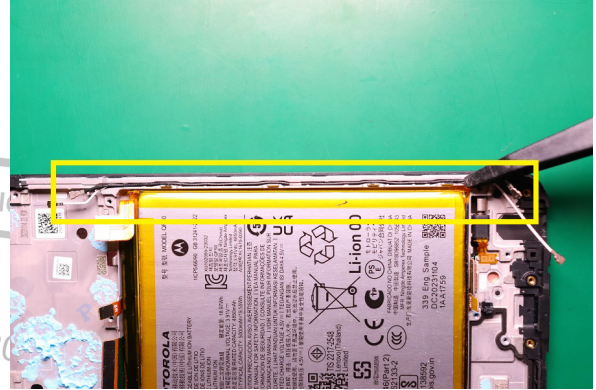
The Black Coax Cable can be recovered and reused after removal.



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.



White Coax Cable Removal

NOTE

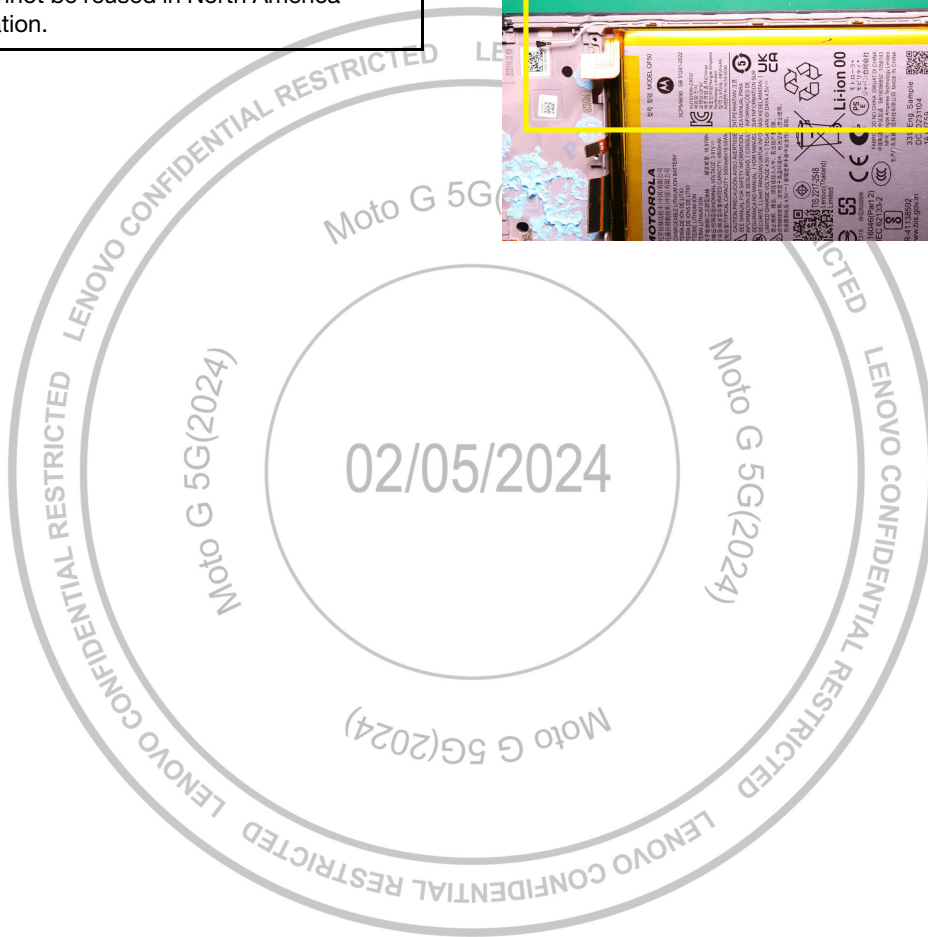
The White Coax Cable can be recovered and reused after removal.



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.



Battery Removal

Battery Removal Method A

/// WARNING ///

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

NOTE

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



// CAUTION //

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

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

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

Ensure screws and screwdrivers do not contact the Battery.

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

// CAUTION //

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

NOTE

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

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



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

NOTE

Heat the phone sufficiently to avoid damaging the part.

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



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



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



7. Use fingers to carefully lift the Battery.



Battery Removal Method B

/// WARNING ///

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

NOTE

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

NOTE

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

// CAUTION //

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

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

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

Ensure screws and screwdrivers do not contact the Battery.

1. The power supply line is more than 2.5 meters away.
2. Allow enough space for heat dissipation, more than 1 meter is recommended.



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



- Turn on the Freezing Separator.

NOTE
The switch is on the back.



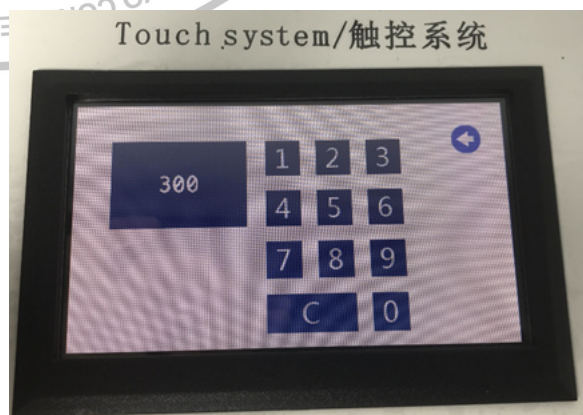
- Select the Language menu and set the desired language.



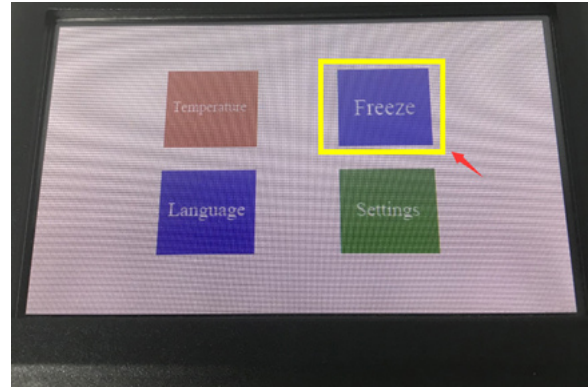
- Select the settings menu, set the temperature and Freezing times.
Set the temperature to -40 °C: Click the temperature menu, enter 40 on the screen number. Then press the arrow in the upper right corner to return.



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



- Click Freeze menu, then click the start menu.



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



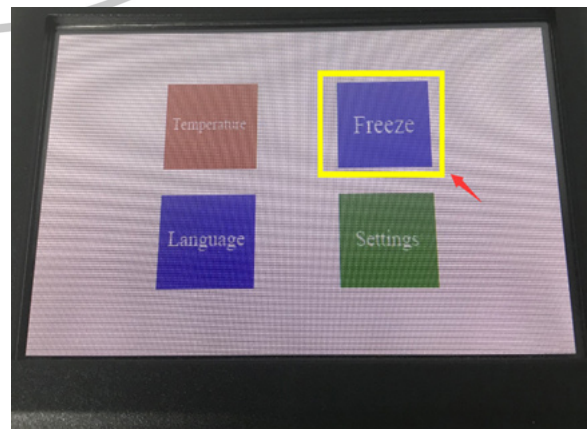
- Put display into sealing bag and seal then put 1~2 Display into cold plate and close the door.

NOTE

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



- Click Freeze menu.



- Click the start menu.

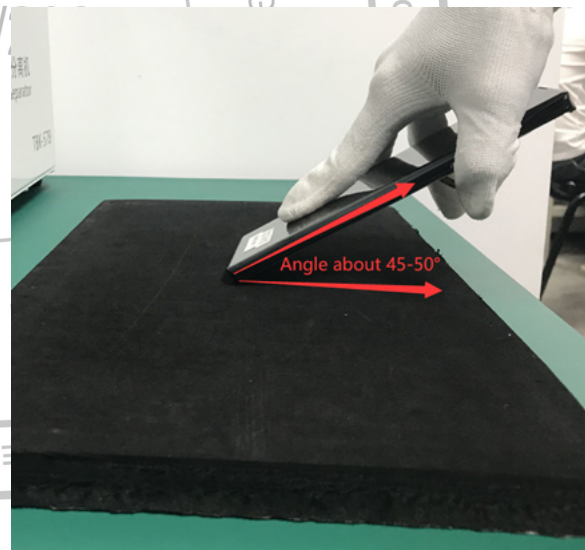


- After clicking the Start menu, Start the countdown, and freeze it for 5 minutes. When the countdown time reaches, the device will alarm and ring three times.
- Open the door. Take out one Display at the time with wearing cotton gloves. Take out the Display in the order it was put in.

NOTE

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

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



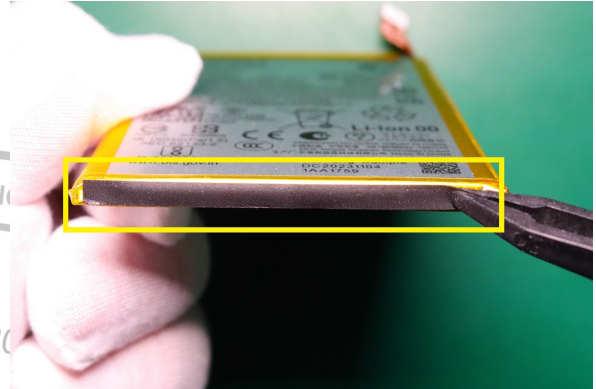
Battery Buffer Foam Removal

NOTE

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



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



Main FPC Removal

NOTE

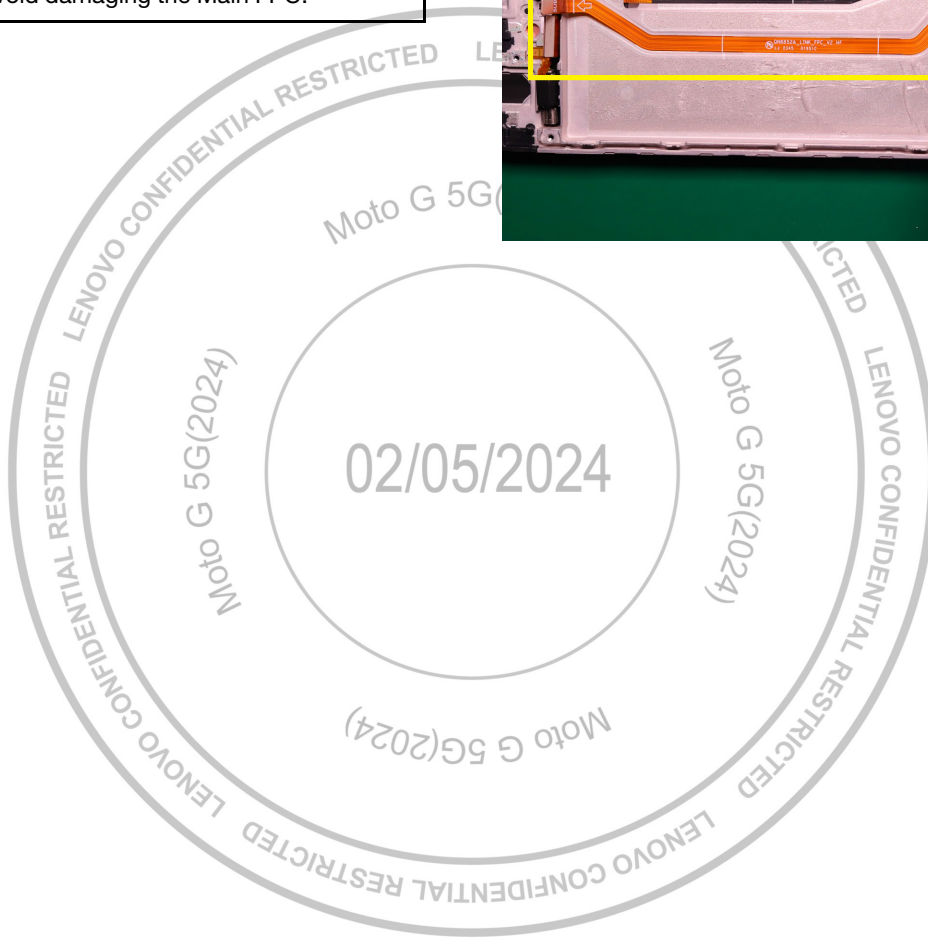
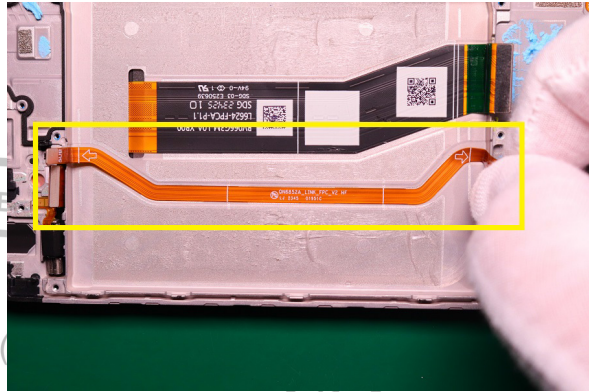
The Main FPC can be recovered and reused after removal.



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

NOTE

Be careful to avoid damaging the Main FPC.



Vibrator Removal

NOTE

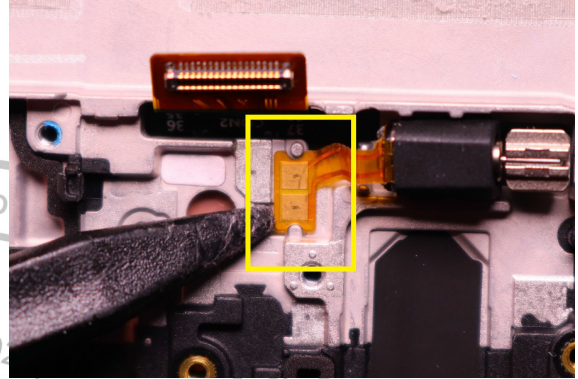
The Vibrator can be recovered and reused after removal.



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

NOTE

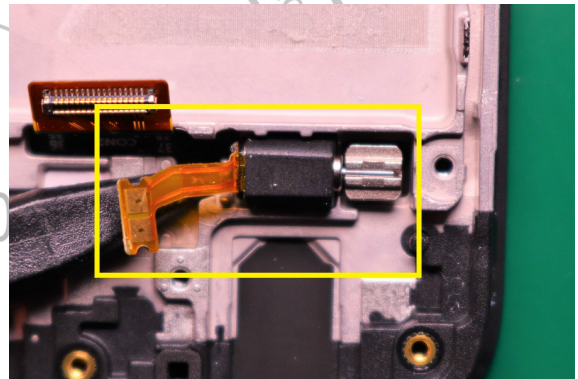
Be careful to avoid damaging the Vibrator FPC.



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

NOTE

Be careful to avoid damaging the Vibrator.



Vibrator Grounding Foam Removal

NOTE

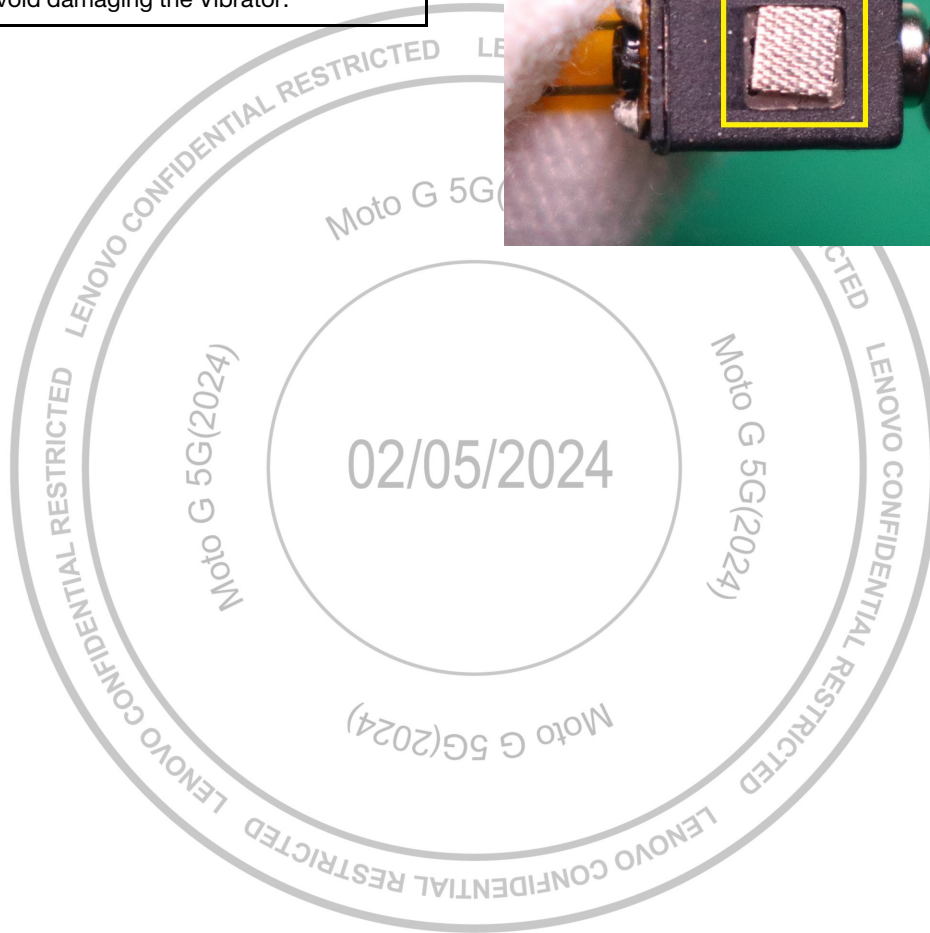
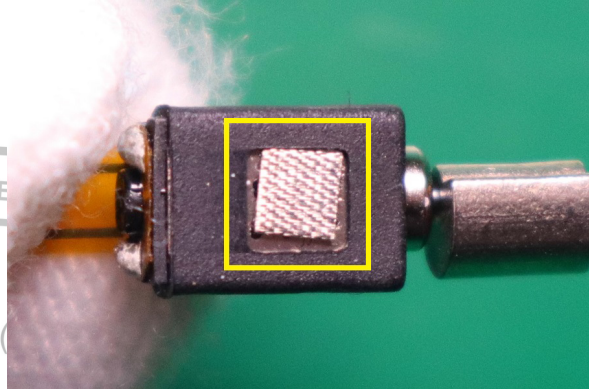
After you remove the Vibrator Grounding Foam, you cannot reuse it.



Use the Plastic Tweezer to remove the Vibrator Grounding Foam from the location as shown.

NOTE

Be careful to avoid damaging the Vibrator.



Receiver Removal

NOTE

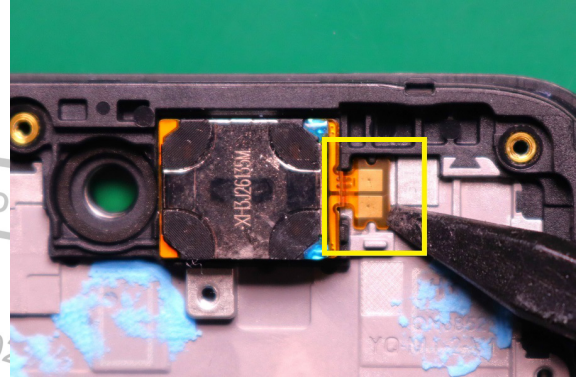
After you remove the Receiver, you cannot reuse it.



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

NOTE

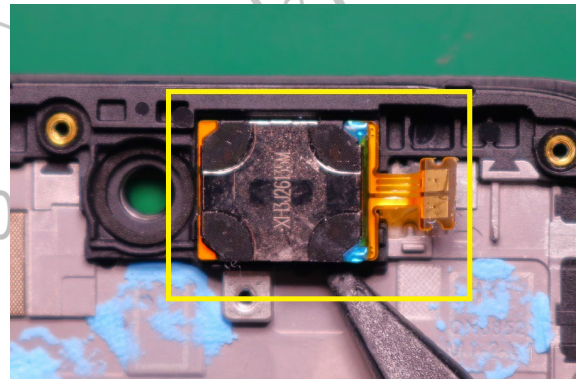
Be careful to avoid damaging the Front-Housing.



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

NOTE

Be careful to avoid damaging the Front-Housing.



Side Key FPC Removal

NOTE

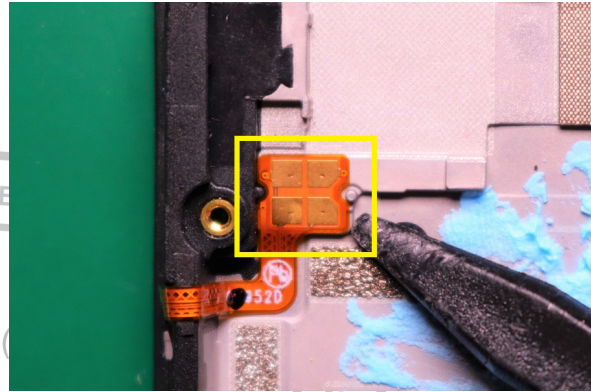
The Side Key FPC can be recovered and reused after removal.



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

NOTE

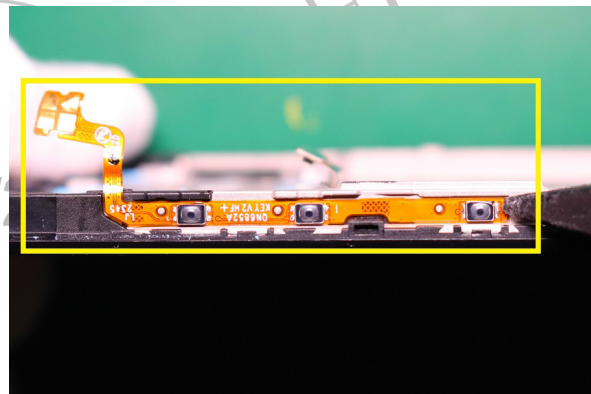
Be careful to avoid damaging the Side Key FPC.



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

NOTE


Be careful to avoid damaging the Side Key FPC.



Chapter 4. Parts Refresh

Tools Required for Parts Refresh

The following tools are required for parts refresh of the Moto G 5G(2024) phone.

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

Battery Cover Cleaning

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

/// CAUTION ///

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

/// CAUTION ///

Inadequate cleaning will result in degraded assembly quality.



Front-Housing Cleaning

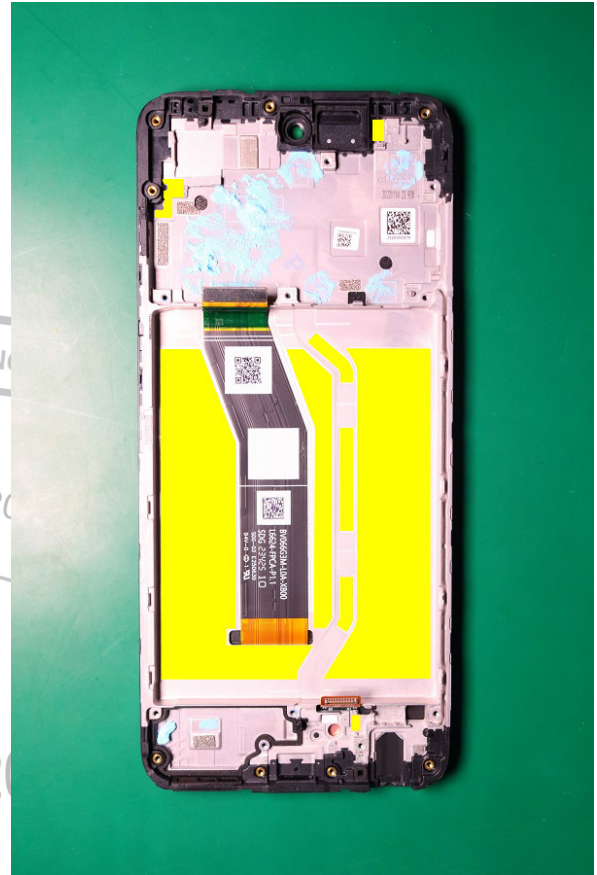
Use the Cotton Swabs with ISP Alcohol to remove all the adhesives from the location as shown.

/// CAUTION ///

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

/// CAUTION ///

Inadequate cleaning will result in degraded assembly quality.



Middle Frame Cleaning

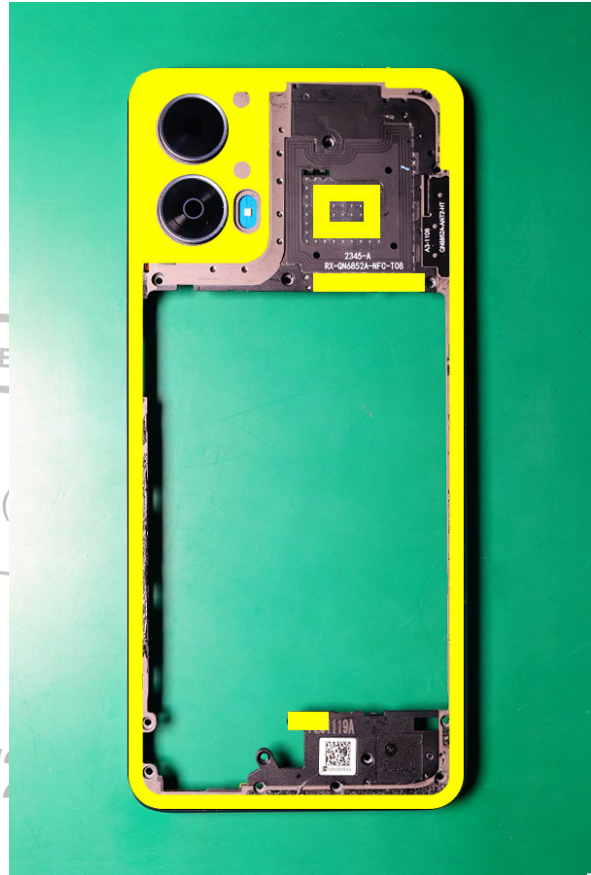
Use the Cotton Swabs with ISP Alcohol to remove all the adhesives from the location as shown.

/// CAUTION ///

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

/// CAUTION ///

Inadequate cleaning will result in degraded assembly quality.



Thermal putty Cleaning

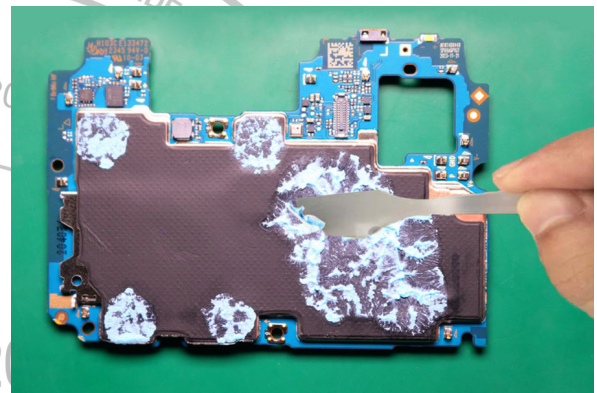
Use Plastic Scraper to remove the most part of Thermal putty from the Front-Housing, Main PCB, and Speaker Box.

/// CAUTION ///

Remove the Thermal putty carefully to avoid damage to the Front-Housing, Main PCB, and Speaker Box.

/// CAUTION ///

Inadequate cleaning will result in degraded assembly quality.



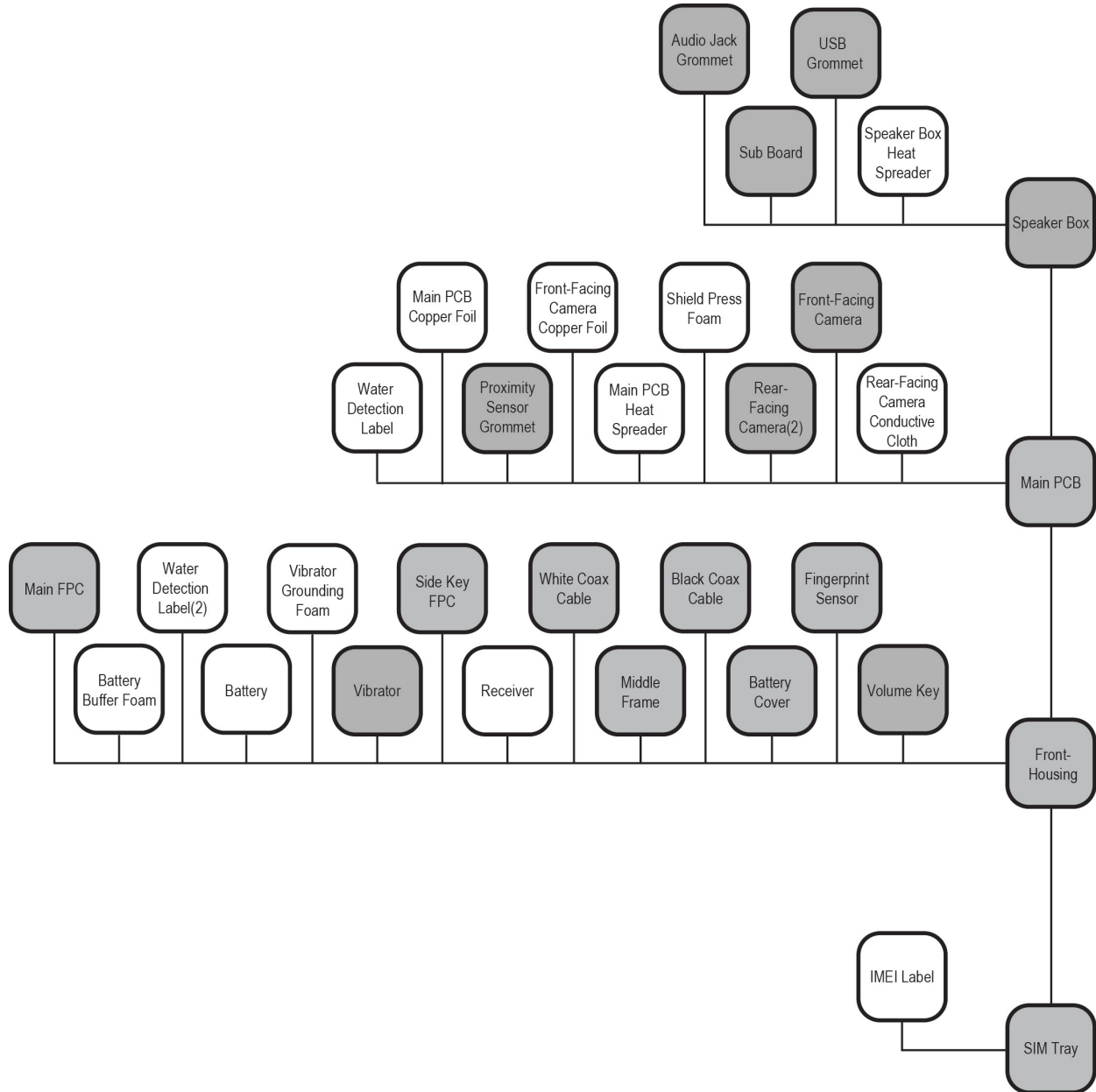
LENOVO CONFIDENTIAL RESTRICTED
Moto G 5G(2024)
02/05/2024
Moto G 5G(2024)
LENOVO CONFIDENTIAL RESTRICTED



Chapter 5. Assembly

Assembly Map

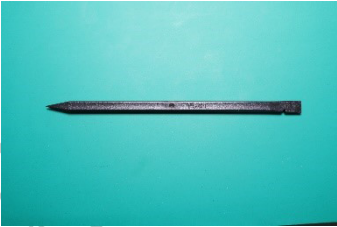




*Shaded parts may be eligible for parts recovery





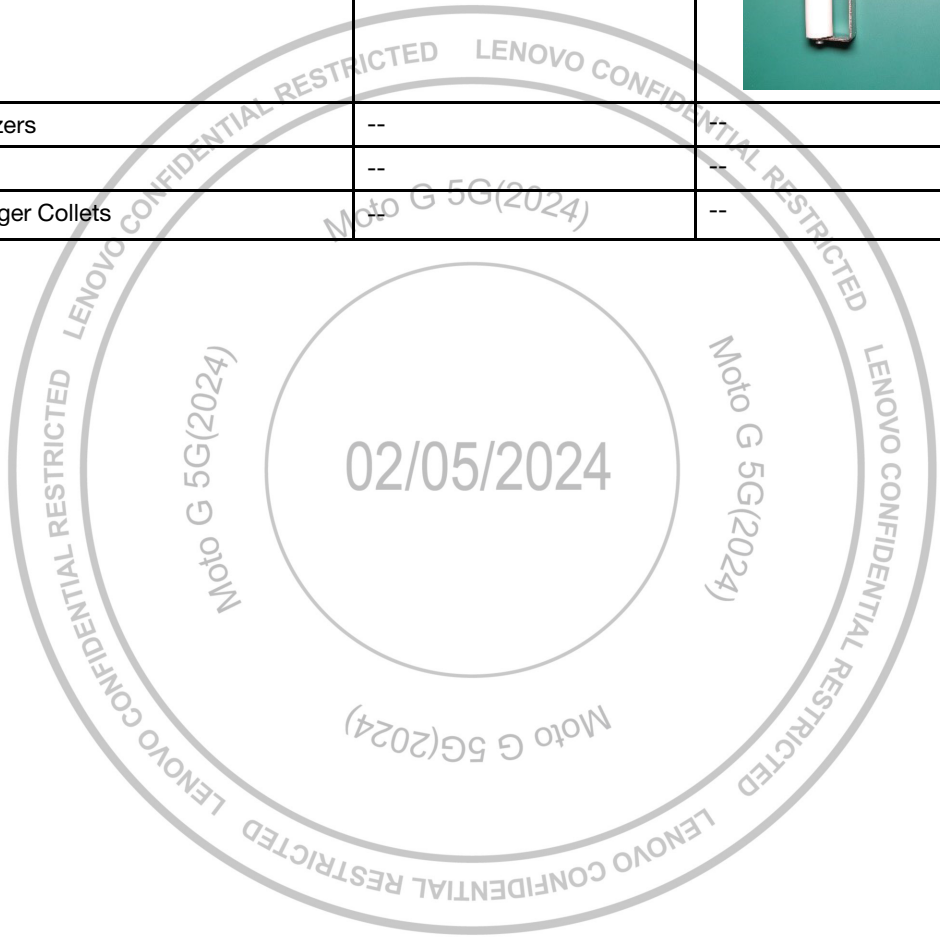
Tools Required for Assembly

The following tools are required to assemble the Moto G 5G(2024) phone.

NOTE
Improper tools may cause damage to components.

Description	Part #	Picture/Drawing
Black Stick	--	
Torque Driver	--	
PH00 Bit	--	
Regen-I Pneumatic Press System https://www.regeni.com/	RG262	
Inlay Adhesive Alignment Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-V5-10000	

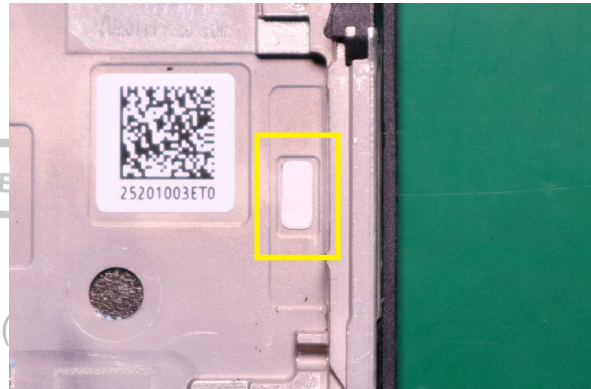
Description	Part #	Picture/Drawing
Inlay Press - Holder with Pad Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-V6-10000	
Manual Roller	--	
Plastic Tweezers	--	--
Tweezers	--	--
Gloves or Finger Collets	--	--



Water Detection Label Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ60460004000+waterproof label	-

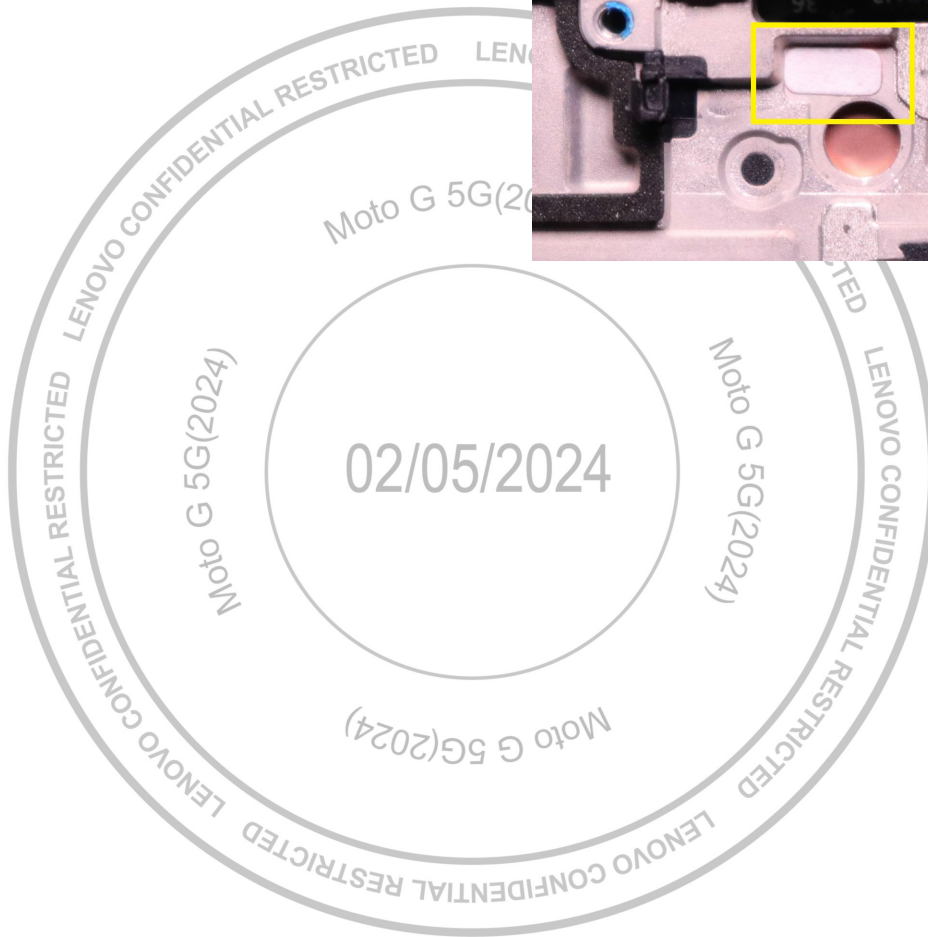
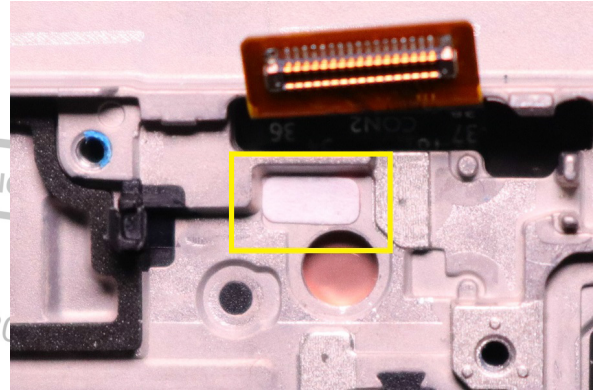
Use the Plastic Tweezer to place the Water Detection Label (WDL) on the Front-Housing as shown.



Water Detection Label Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ60460004000+waterproof label	-

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



Side Key FPC Adhesive Assembly

Description	Reference #
HQ251010008W0+softboardAssembly SideKey	14
HQ251040000G0+Sidekey FPC Adhesive CS	-

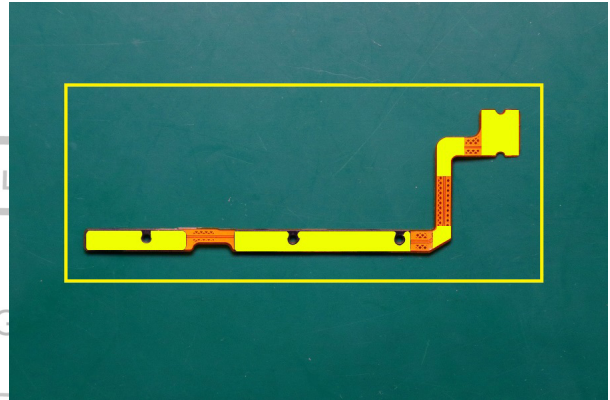
Use the Plastic Tweezer to place the Side Key FPC Adhesive on the location as shown and peel off the liners.

NOTE

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

NOTE

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



02/05/2024

Side Key FPC Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ251010008W0+softboardAssembly SideKey	14

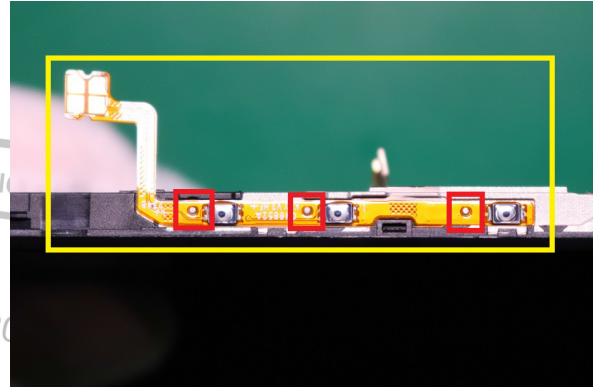
1. Use the Plastic Tweezer to place and secure the Side Key FPC on the location aligning with the pins as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The Side Key FPC should be pasted strictly in place.



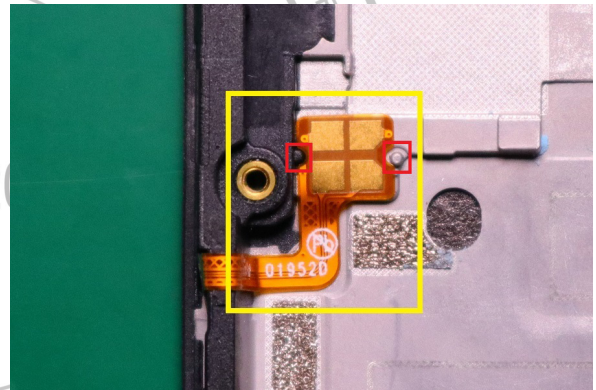
2. Use the Plastic Tweezer to place and secure the Side Key FPC on the location aligning with the pins as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

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



Receiver Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ705030000E0+Receiver_1210x2.8mm_HS	11

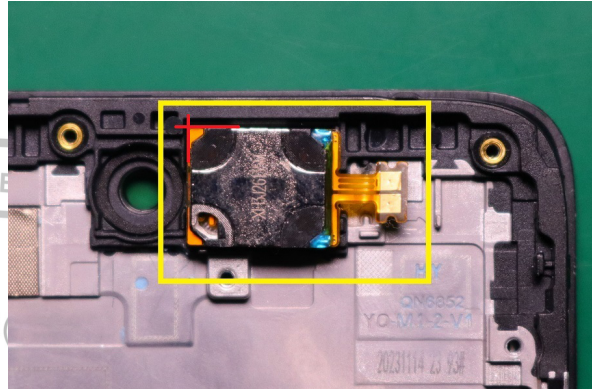
1. Peel off the liners of the Receiver and use the Plastic Tweezer to place and secure the Receiver on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

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



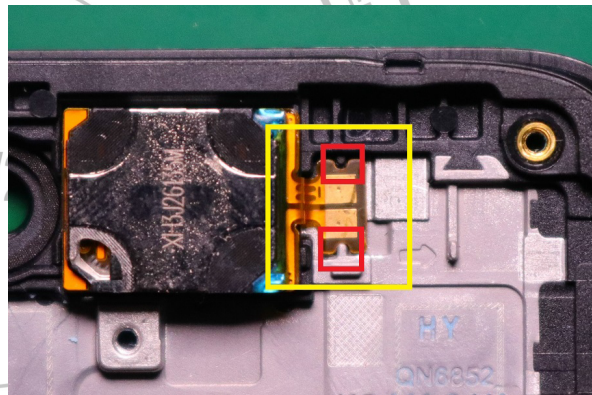
2. Use the Plastic Tweezer to place and secure the Receiver FPC on the location aligning with the pins as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

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



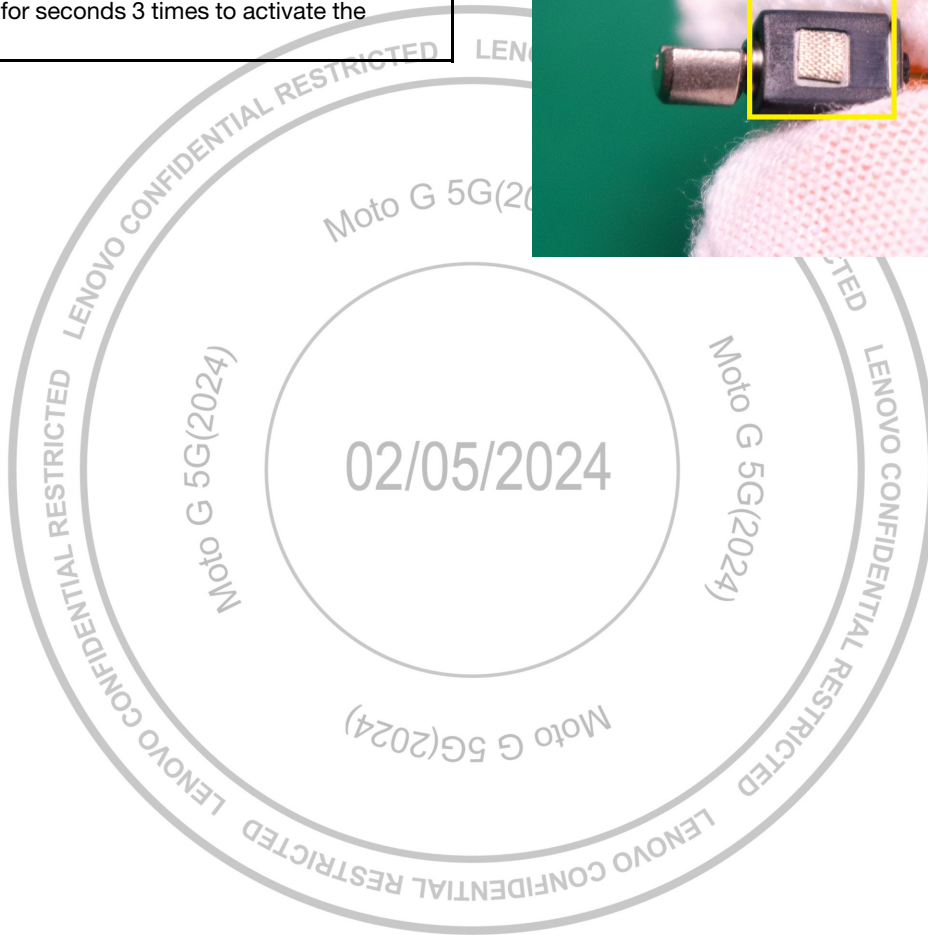
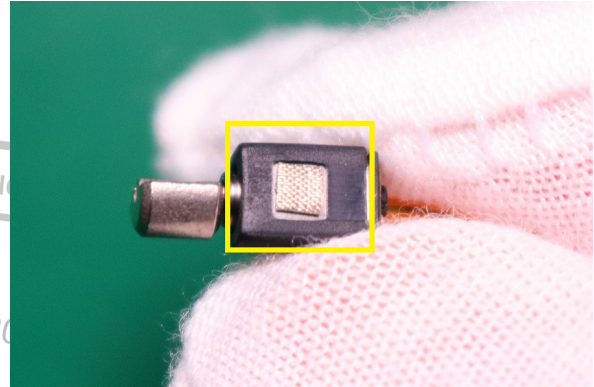
Vibrator Grounding Foam Assembly

Description	Reference #
HQ704020000Q0+nonlinear motor_FPC_AH	15
HQ25803001B00+Conductive foam_Motor_HJ	-

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

NOTE

Press firmly for seconds 3 times to activate the adhesive.



Vibrator FPC Adhesive Assembly

Description	Reference #
HQ70402000Q0+nonlinear motor_FPC_AH	15
HQ70402000100+motorFPC Adhesive CS	-

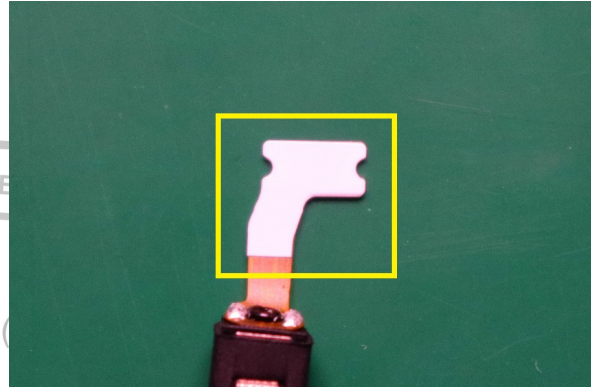
Use the Plastic Tweezer to place the Vibrator FPC Adhesive on the location as shown and peel off the liner.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The Vibrator FPC Adhesive should be pasted strictly in place.



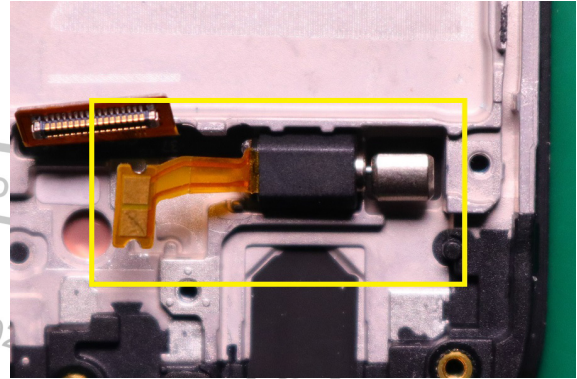
Vibrator Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ704020000Q0+nonlinear motor_FPC_AH	15

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

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

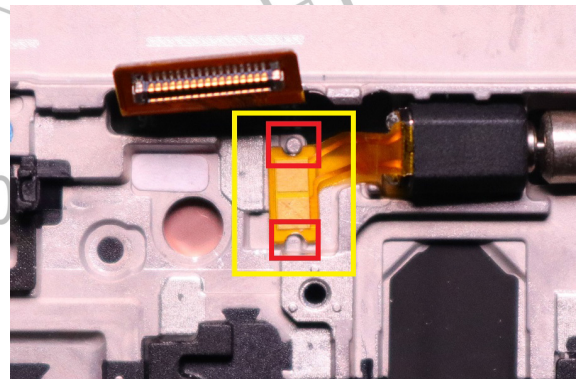
NOTE
The Vibrator should be assembled strictly in place. Improper installation will affect the vibration function of the phone.



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

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

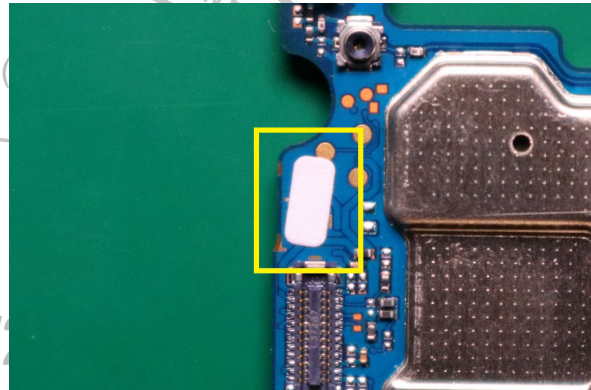
NOTE
The Vibrator should be assembled strictly in place. Improper installation will affect the vibration function of the phone.



Water Detection Label Assembly

Description	Reference #
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
HQ60460004000+waterproof label	-

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



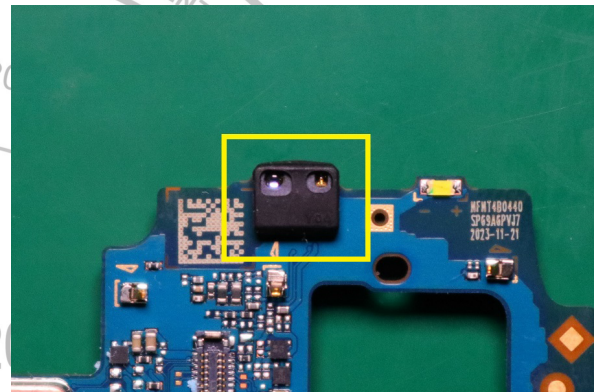
Proximity Sensor Grommet Assembly

Description	Reference #
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
HQ271040002Q0+rubber sleeve_P-Sensor_GMM	24

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

NOTE

The Proximity Sensor Grommet cannot be installed backwards.



50M Rear-Facing Camera Assembly

Description	Reference #
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
MDL,CAMR,50M,rear,C2PA30;Q Tech,AF:Canca	9

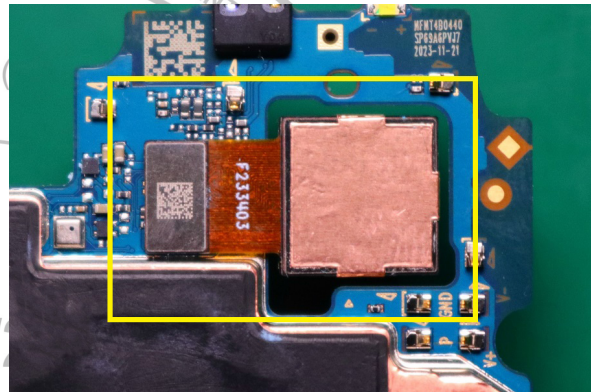
Peel off the protective cover of 50M Rear-Facing Camera and use fingers to place and secure the 50M Rear-Facing Camera on the Main PCB as shown.

NOTE

Align the interface before securing to avoid damaging the contacts.

NOTE

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



Thermal Gel Assembly

NOTE

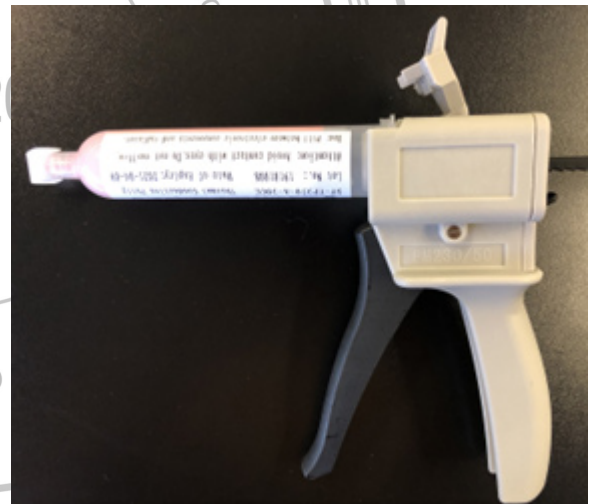
This procedure is only required when replacing the Main PCB or Front Housing.

Thermal Gel Syringe size package and Needle Gauges description

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



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



3. Henkel LF350 30ml operate with dispensing tool.



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



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

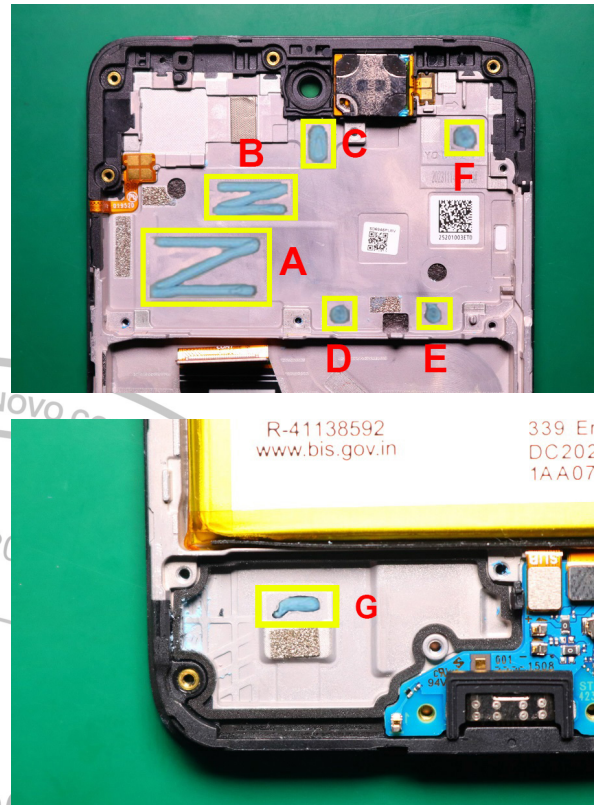


- 6. When use SY-TP350 or Henkel LF350 30ml package suggest using 14- or 15-gauge needle.



Front-Housing Thermal Gel Location Assembly

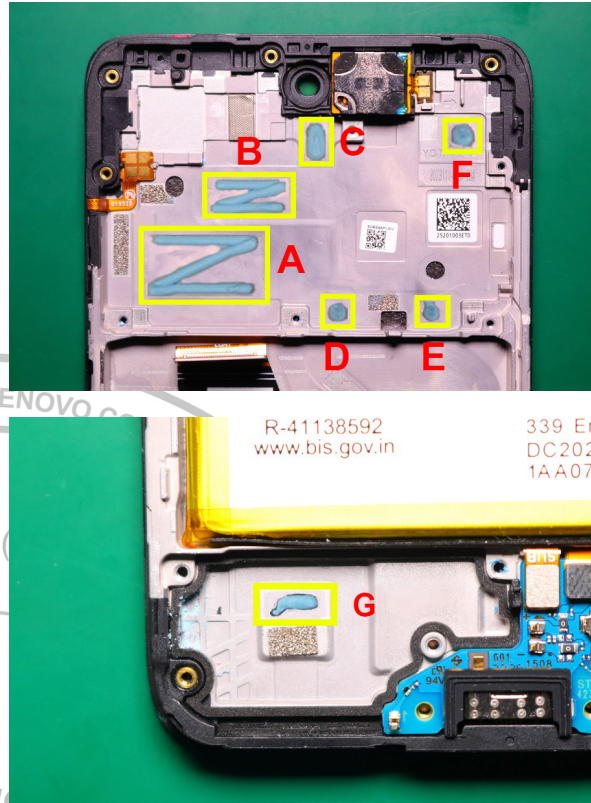
Noticing on the Front-Housing and refer to Thermal Gel shape as shown.



Front-Housing Thermal Gel Assembly by Weight

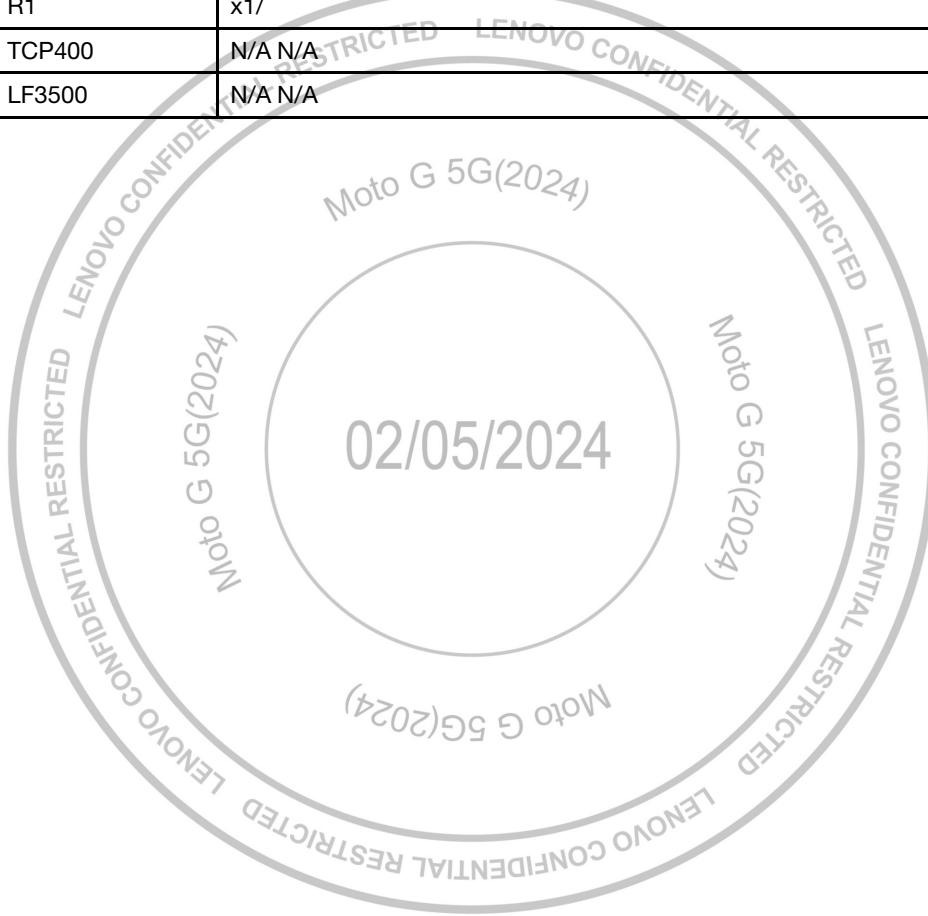
Add Thermal Conductive Gel (550±55 mg) on the visual block as shown.

- A: 280±20 mg
- B: 140±10 mg
- C: 300±5 mg
- D: 20±5 mg
- E: 20±5 mg
- F: 20±5 mg
- G: 40±5 mg



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 N/A
Henkel	LF3500	N/A N/A



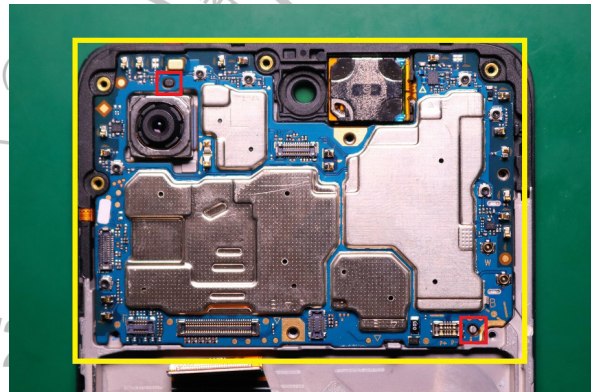
Main PCB Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2

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

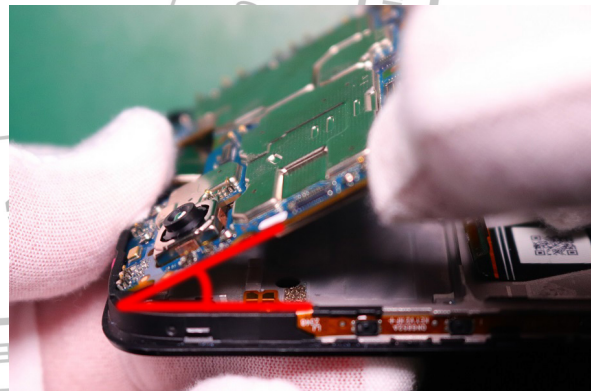
NOTE

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



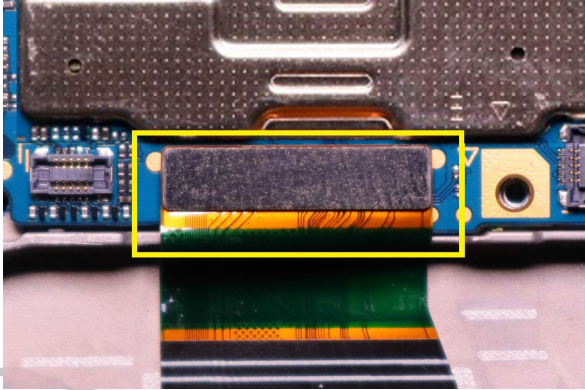
NOTE

Incline the Main PCB, insert the Proximity Sensor first, and then insert the Main PCB into the Front-Housing at about 10–45 degrees.



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

NOTE
Align the interface before securing to avoid damaging the contacts.



Main PCB Copper Foil Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
HQ705030000E0+Receiver_1210x2.8mm_HS	11
HQ25803001B40+Bot_copper foil mylar_HJ	35

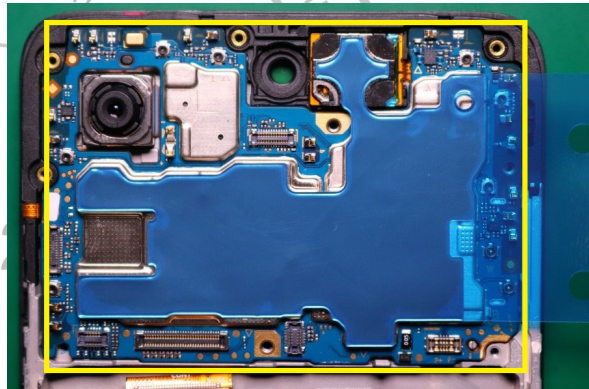
Use the Plastic Tweezer to place the Main PCB Copper Foil on the location as shown and peel off the liner.

NOTE

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

NOTE

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



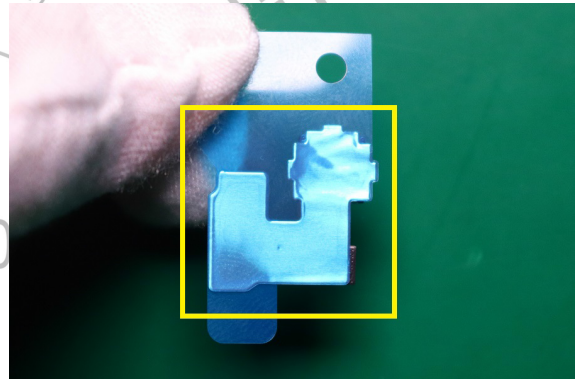
Front-Facing Camera and Copper Foil Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
MDL,CAMR,8M,FRNT,D1N801D;SUNNY:Fogo NA	7
HQ25803001B60+Camera_copper foil_HJ	34

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

NOTE

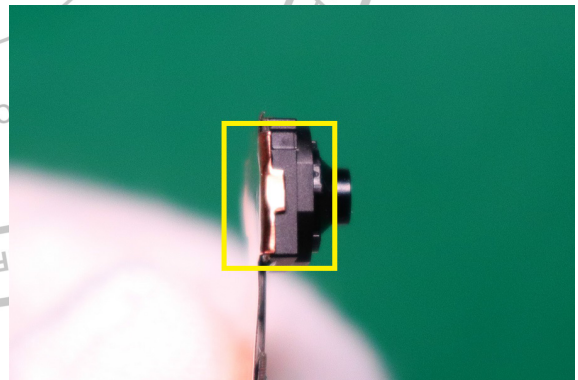
Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



2. Use fingers to smooth the top, left, and right ends of the Front-Facing Camera Copper Foil to the sides of the Camera as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



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

NOTE

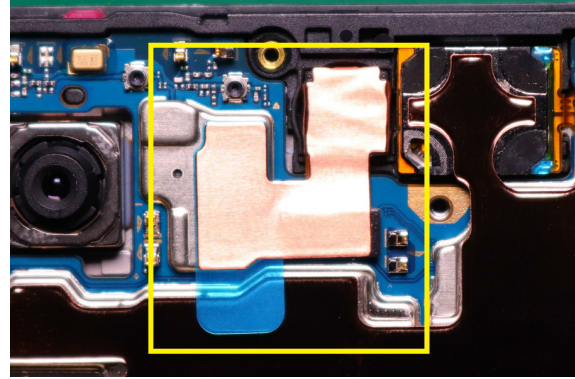
Align the interface before securing to avoid damaging the contacts.

NOTE

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

NOTE

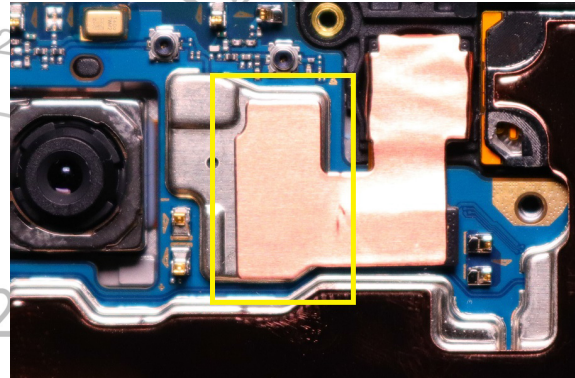
The Front-Facing Camera should be assembled strictly in place. Improper installation will affect the photograph function of the phone.



- Use fingers to peel off the left liner, and paste the left side of the Copper Foil on the Main PCB.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



2M Rear-Facing Camera Conductive Cloth Assembly

Description	Reference #
MDL,CAMR,2M,rear;D1N206D;SUNNY,FF:Cancun	8
HQ25803001AY0+Camera conductive cloth_HJ	33

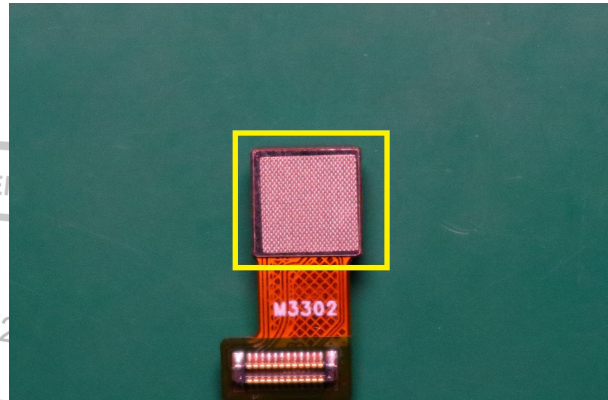
Use plastic tweezers to place and secure the 2M Rear-Facing Camera Conductive Cloth on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

NOTE

The 2M Rear-Facing Camera Conductive Cloth should be assembled strictly in place.

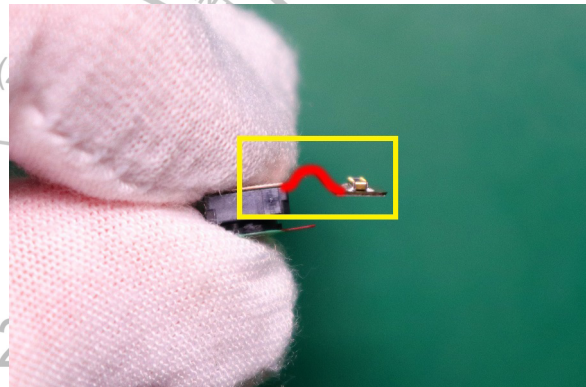


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2M Rear-Facing Camera Assembly

Description	Reference #
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
MDL,CAMR,2M,rear;D1N206D;SUNNY,FF:Cancun	8

1. Pre-bend the 2M Rear-Facing Camera Flex FPC before assembling 2M Rear-Facing Camera as shown.



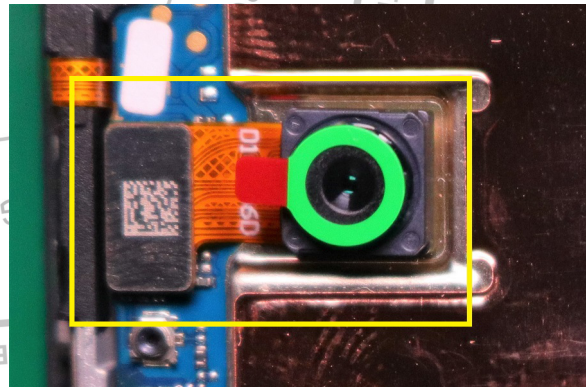
2. Use fingers to place and secure the 2M Rear-Facing Camera on the Main PCB as shown.

NOTE

Align the interface before securing to avoid damaging the contacts.

NOTE

The 2M Rear-Facing Camera should be assembled strictly in place. Improper installation will affect the photograph function of the phone.



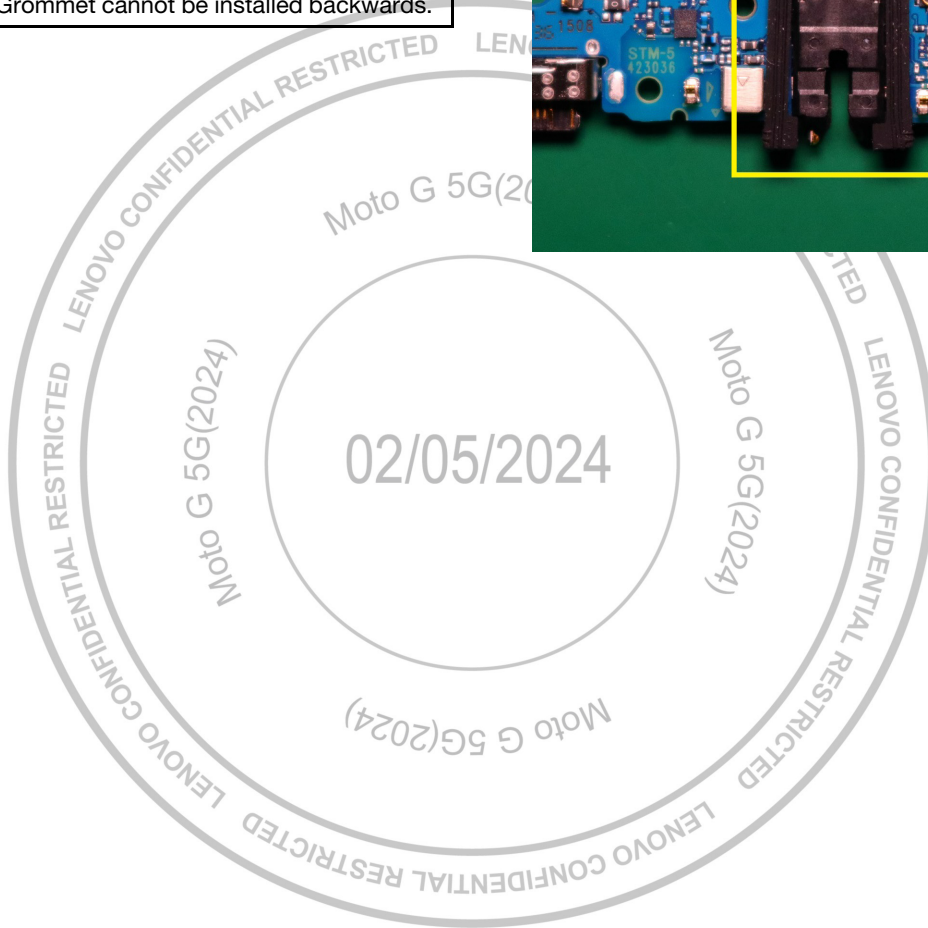
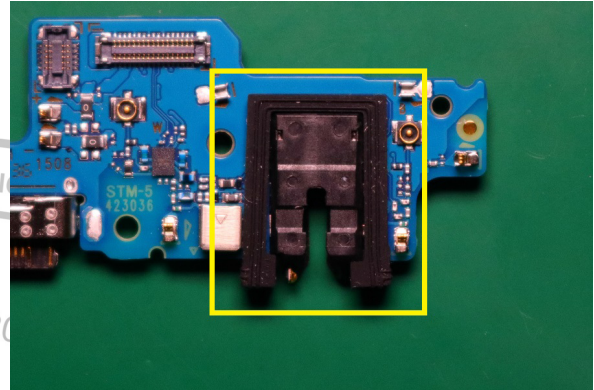
Audio Jack Grommet Assembly

Description	Reference #
XT2417,USB Board CS	3
HQ271040002N0+Earphone rubber sleeve_GMM	23

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

NOTE

Audio Jack Grommet cannot be installed backwards.



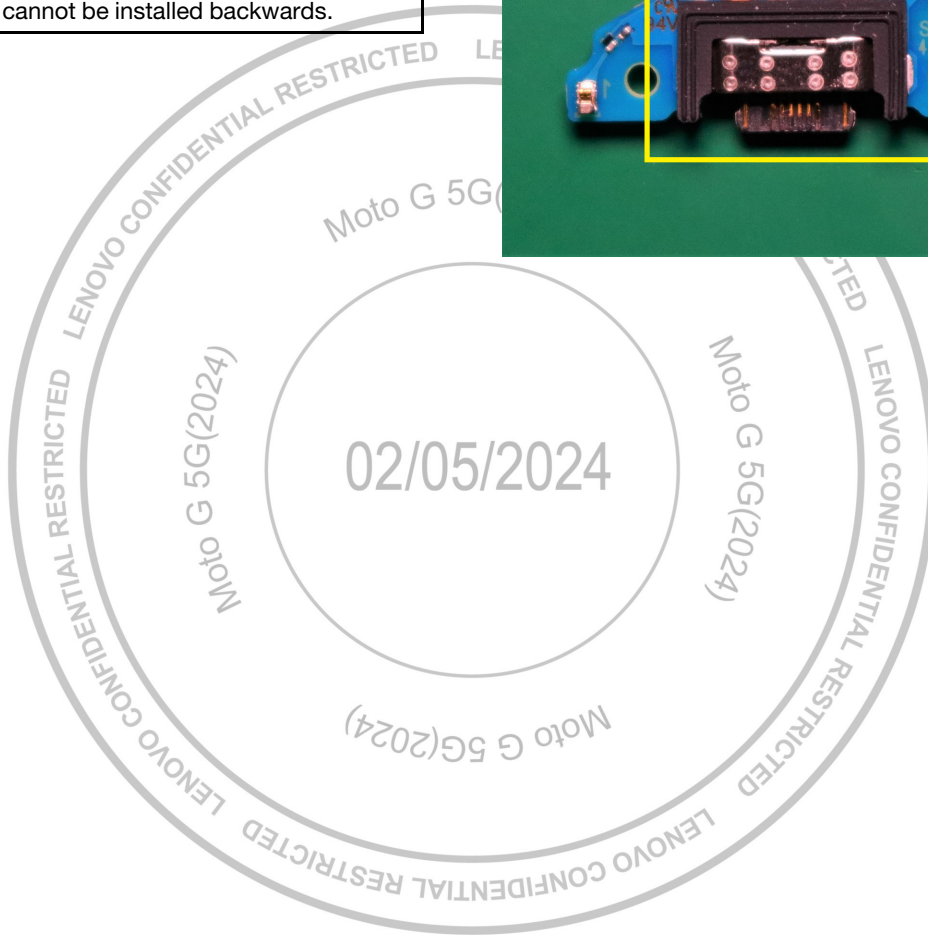
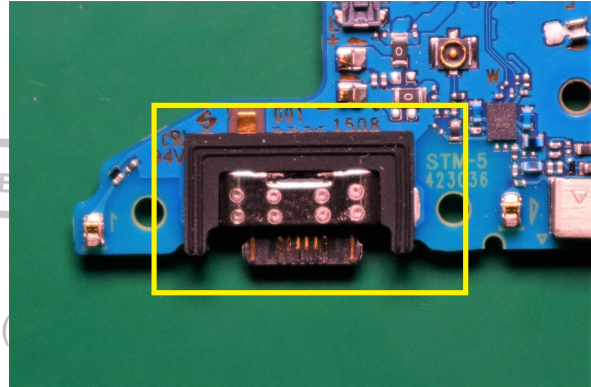
USB Grommet Assembly

Description	Reference #
XT2417,USB Board CS	3
HQ271040002L0+USB rubber sleeve_Black_GM	22

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

NOTE

USB Grommet cannot be installed backwards.



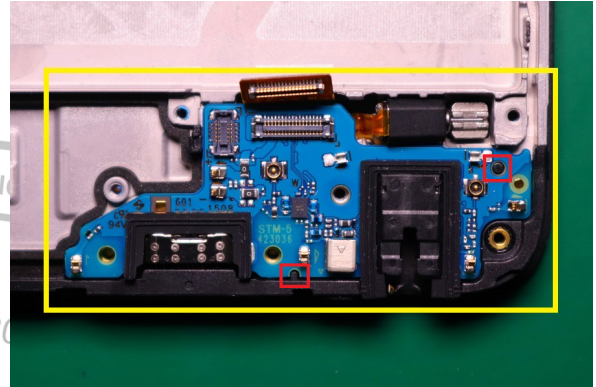
Sub Board Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417,USB Board CS	3

1. Use fingers to place the Sub Board on the location aligning with the pins as shown.

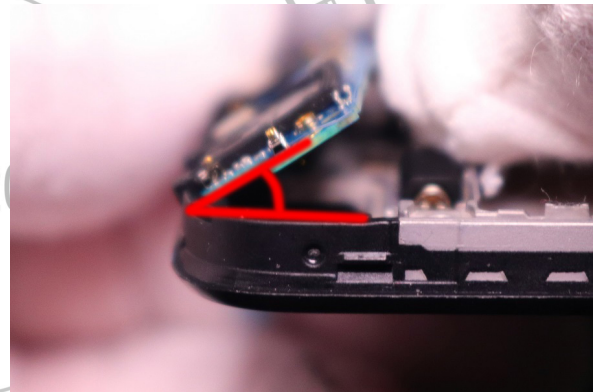
NOTE

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



NOTE

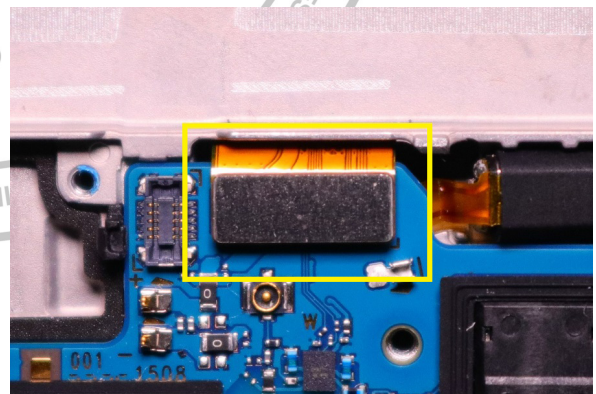
Make sure to insert the Sub Board at some degrees as shown.



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

NOTE

Align the interface before securing to avoid damaging the contacts.



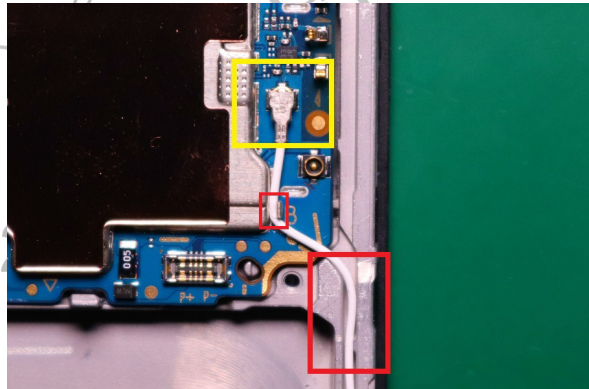
White Coax Cable Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
XT2417,USB Board CS	3
HQ27001000430+coaxial cable0.64x142.9_DL	16

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

NOTE

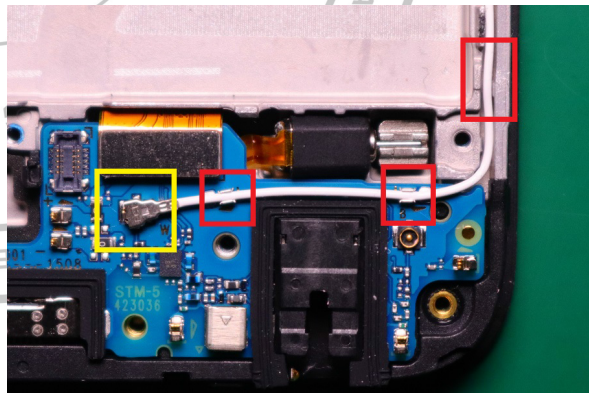
Align the interface before securing to avoid damaging the contacts.



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

NOTE

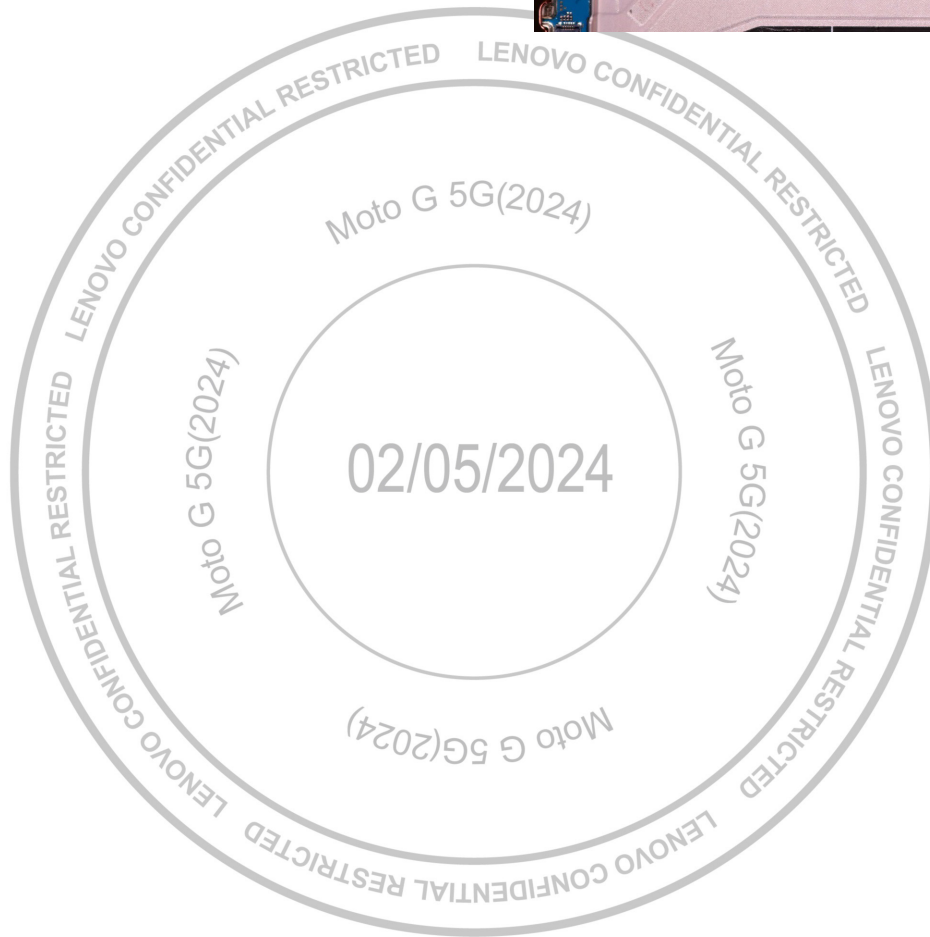
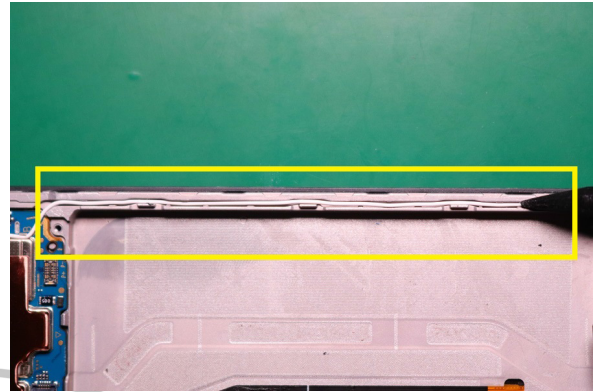
Align the interface before securing to avoid damaging the contacts.



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

NOTE

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



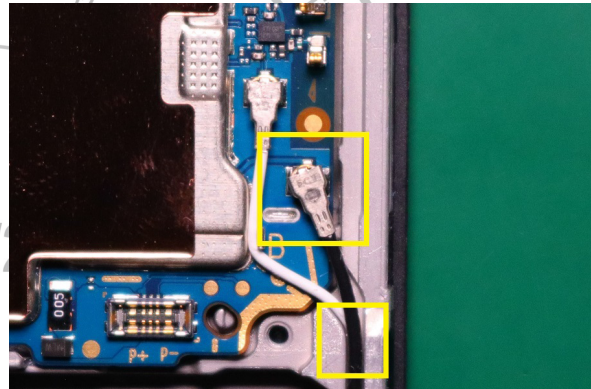
Black Coax Cable Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
XT2417,USB Board CS	3
HQ27001000460+coaxial cable0.81x117.6_DL	17

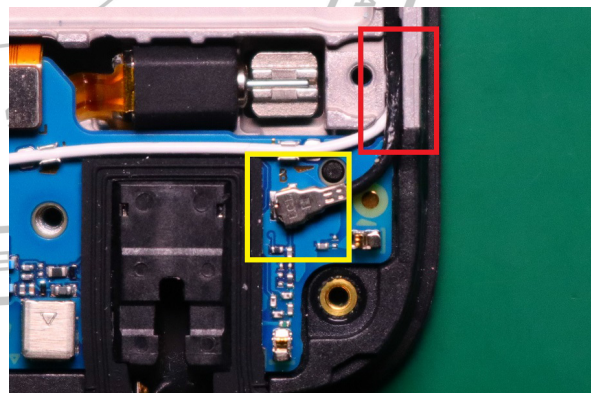
1. Use the Plastic Tweezer to place and secure the Black Coax Cable on the Main PCB as shown.

NOTE

Align the interface before securing to avoid damaging the contacts.

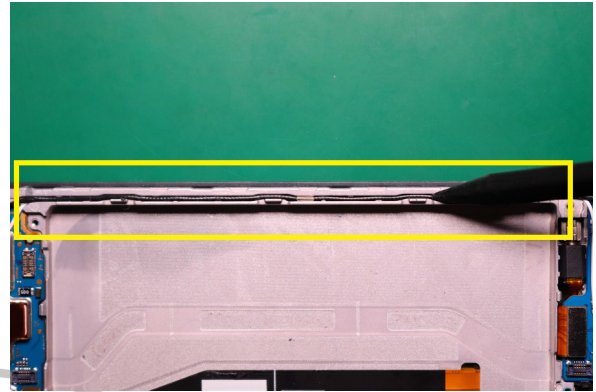


2. Use the Plastic Tweezer to place and secure the Black Coax Cable on the Sub Board as shown.



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

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



Main FPC Adhesive Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ25203001C70+MainFPC Adhesive CS	28

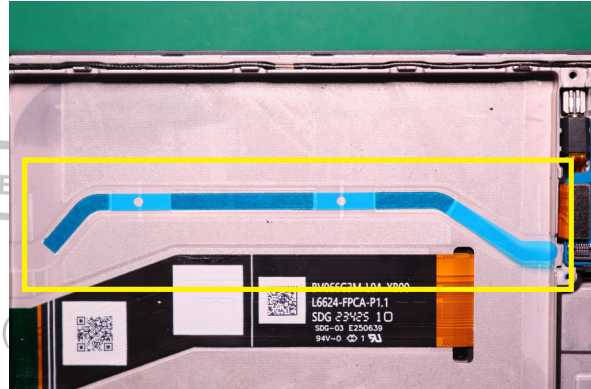
Use the Plastic Tweezer to place the Main FPC Adhesive on the location as shown and peel off the liner.

NOTE

The Main FPC Adhesive should be pasted strictly in place.

NOTE

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



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Main FPC Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
XT2417,USB Board CS	3
HQ251010008U0+softboard assembly LinkFPC	13

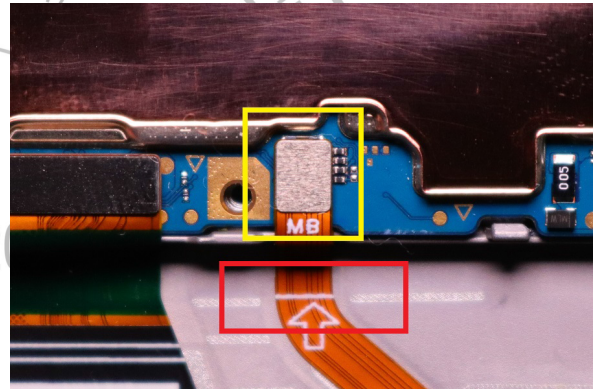
1. Use fingers to place and secure the Main FPC on the Main PCB as shown.

NOTE

Align the interface before securing to avoid damaging the contacts.

NOTE

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



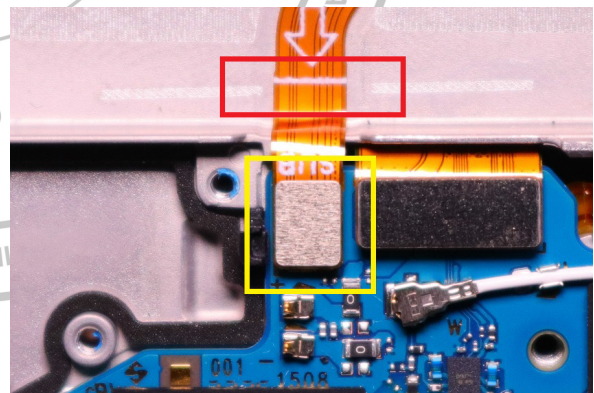
2. Use fingers to place and secure the Main FPC on the Sub Board as shown.

NOTE

Align the interface before securing to avoid damaging the contacts.

NOTE

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



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

NOTE

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

NOTE

Press firmly for seconds 3 times to activate the adhesive.



Battery Buffer Foam Assembly

Description	Reference #
ACCY,BAT,5000mAh,QF50,ATL436590,ATL	10
HQ258010006Y0+Compressed foam_Battery_HJ	31

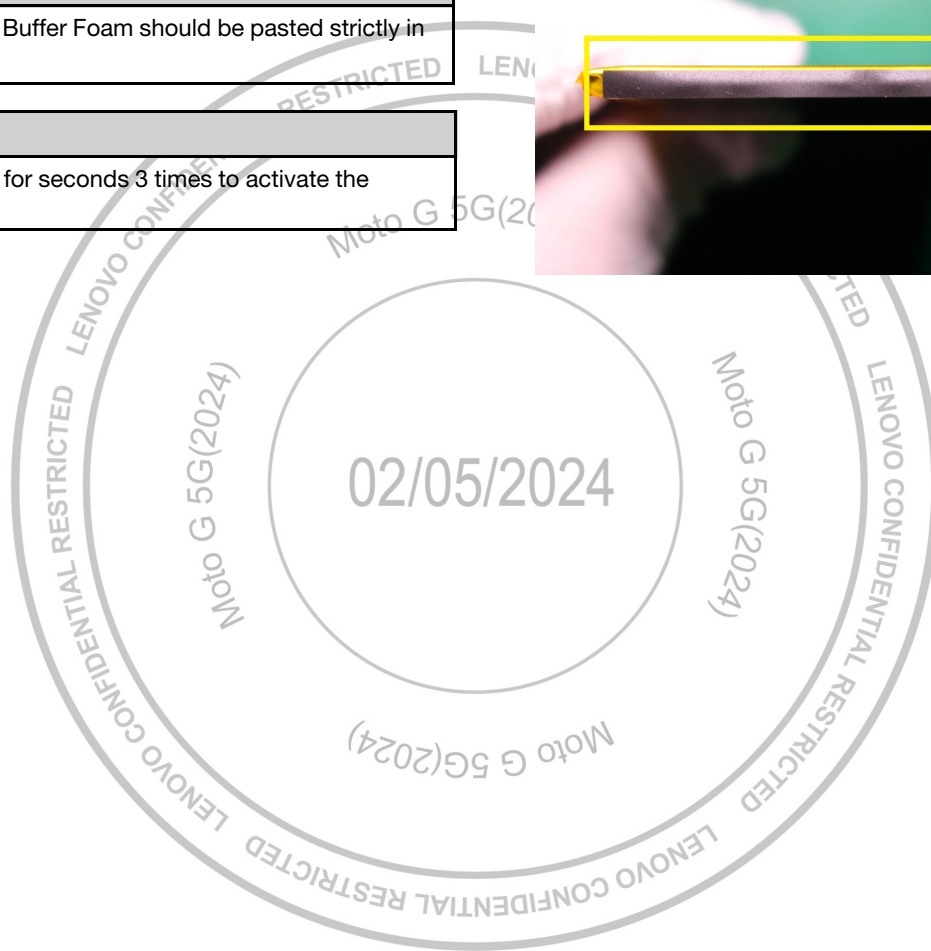
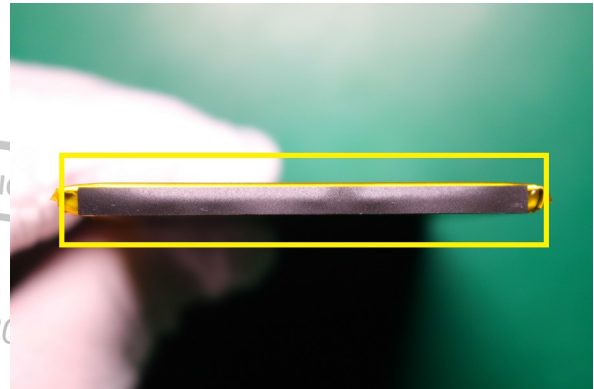
Use the Plastic Tweezer to place the Battery Buffer Foam on the location as shown.

NOTE

The Battery Buffer Foam should be pasted strictly in place.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



Battery Adhesive Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ25203001C60+Battery Adhesive CS	27

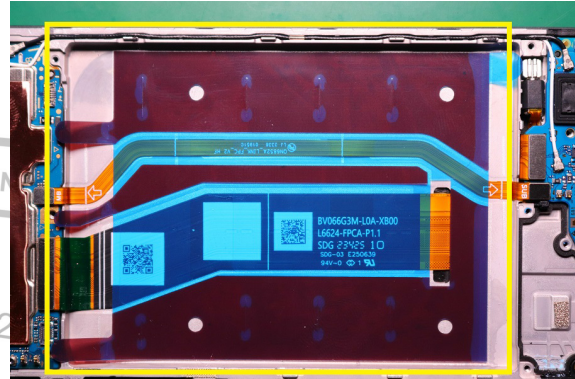
1. Use the Plastic Tweezer to place the Battery Adhesive on the Front-Housing as shown and peel off the blue liner.

NOTE

The Battery Adhesive should be pasted strictly in place.

NOTE

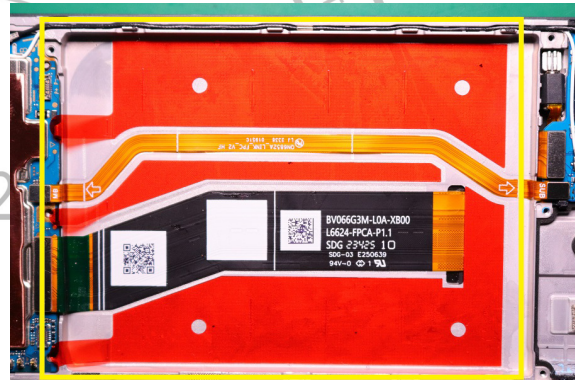
Press firmly for seconds 3 times to activate the adhesive before peeling off the liner.



2. Use the Plastic Tweezer to peel off the red liners on the location as shown.

NOTE

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



Battery Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
ACCY,BAT,5000mAh,QF50,ATL436590,ATL	10

/// WARNING ///

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

// CAUTION //

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

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

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

Ensure screws and screwdrivers do not contact the Battery.

1. Use fingers to place and secure the Battery on the location as shown.

NOTE

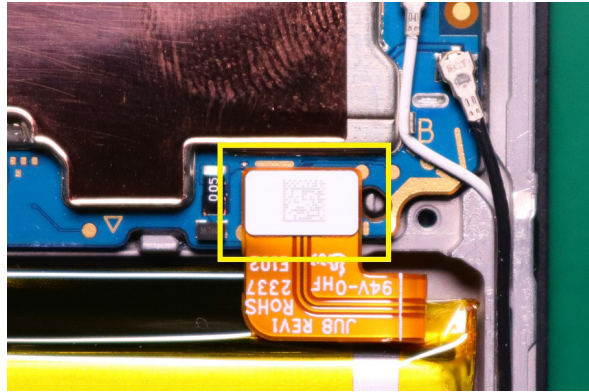
Make sure to assembly the Battery using the bottom of the Battery compartment as marked in red.



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

NOTE

Align the interface before securing to avoid damaging the contacts.



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

NOTE

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

NOTE

Each cycle should last for 3 seconds.



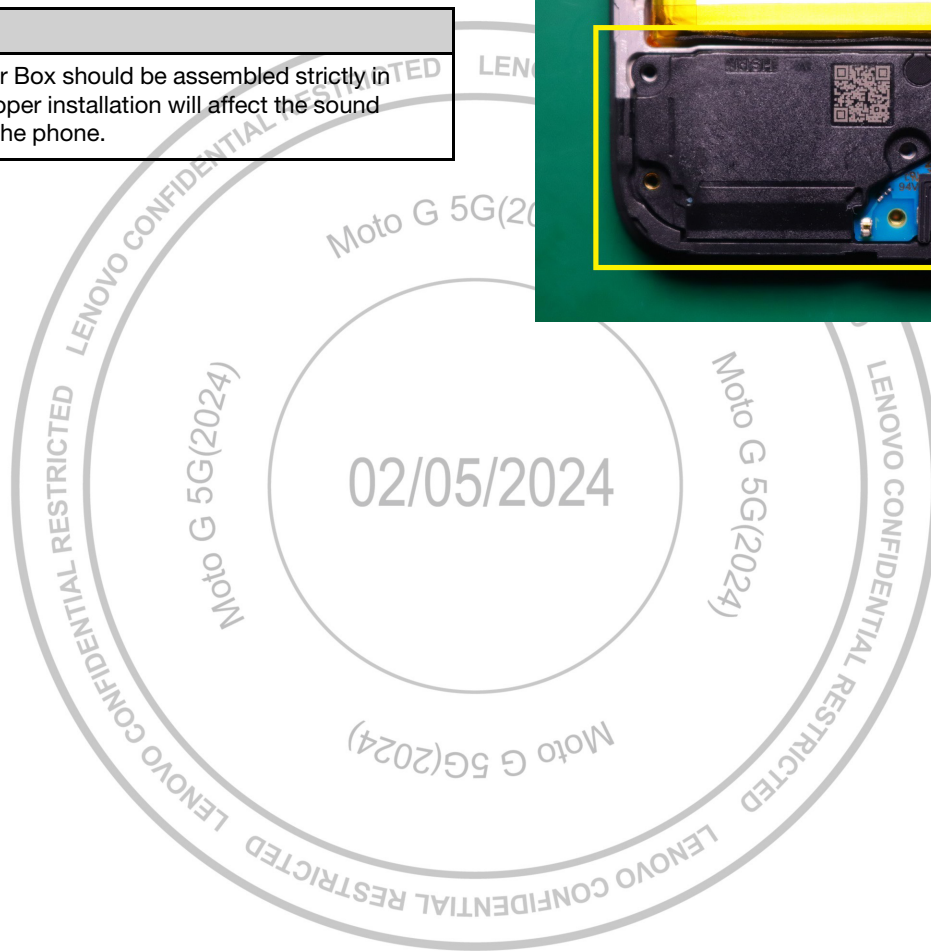
Speaker Box Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417,USB Board CS	3
HQ705010004U0+BOX component_HS	12

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

NOTE

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



Speaker Box Heat Spreader Assembly

Description	Reference #
ACCY,BAT,5000mAh,QF50,ATL436590,ATL	10
HQ705010004U0+BOX component_HS	12
HQ258100001N0+graphite_SPK copperFoil_HL	37

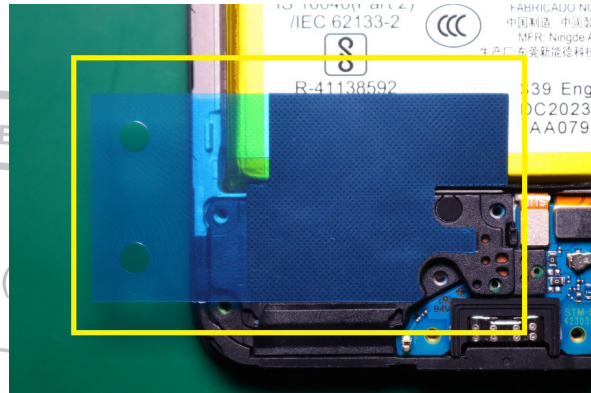
Use the Plastic Tweezer to place the Speaker Box Heat Spreader on the location as shown and peel off the liner.

NOTE

Improper installation will affect the heat dissipation of the phone.

NOTE

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



Main PCB Heat Spreader Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
HQ258100002G0+Shielding graphite_HLD	36

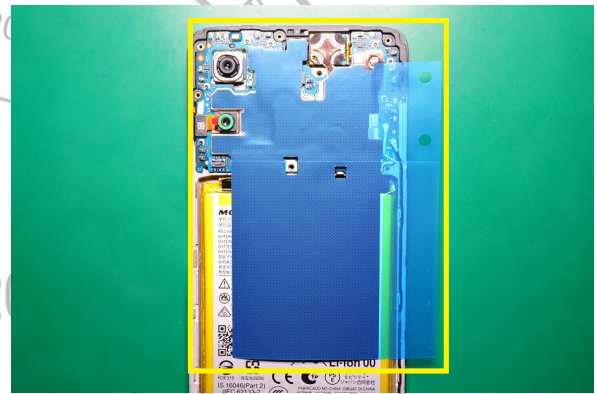
Use the Plastic Tweezer to place the Main PCB Heat Spreader on the location as shown and peel off the liner.

NOTE

Improper installation will affect the heat dissipation of the phone.

NOTE

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



Main PCB Heat Spreader Thermal Gel Assembly

NOTE

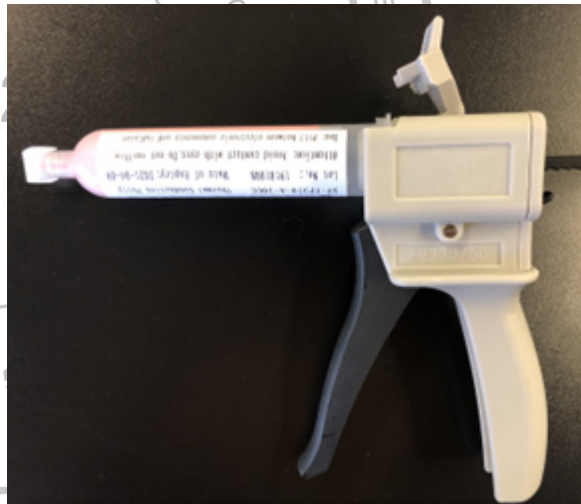
This procedure is only required when replacing the Main PCB Heat Spreader.

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.



- Cooler Master and Artic Thermal Gel syringe package.



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

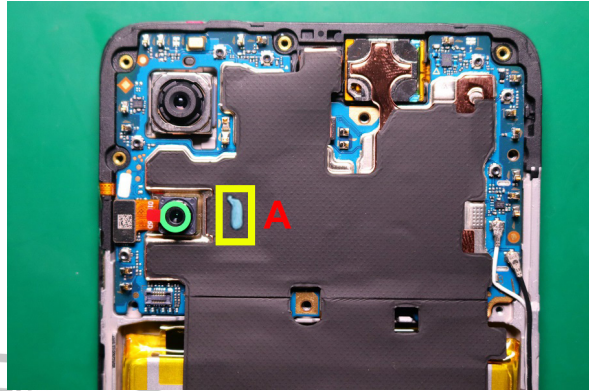


- When use SY-TP350 or Henkel LF350 30ml package suggest using 14- or 15-gauge needle.



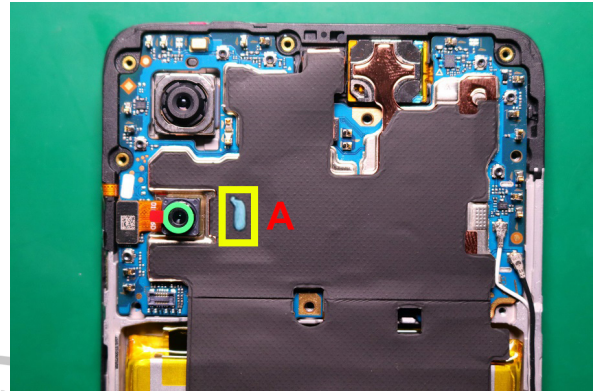
Main PCB Heat Spreader Thermal Gel Location Assembly

Noticing on the Main PCB Heat Spreader and refer to Thermal Gel shape as shown.



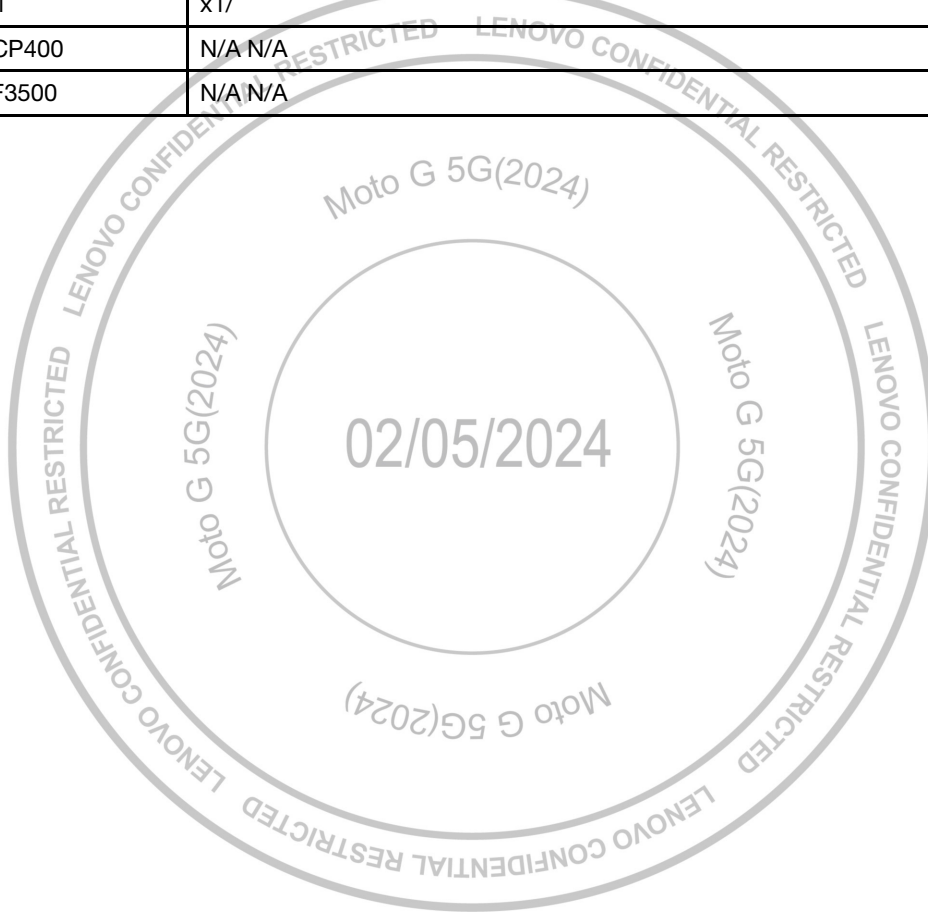
Main PCB Heat Spreader Thermal Gel Assembly by Weight

Add Thermal Conductive Gel (25±5 mg) on the visual block as shown.



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 N/A
Henkel	LF3500	N/A N/A



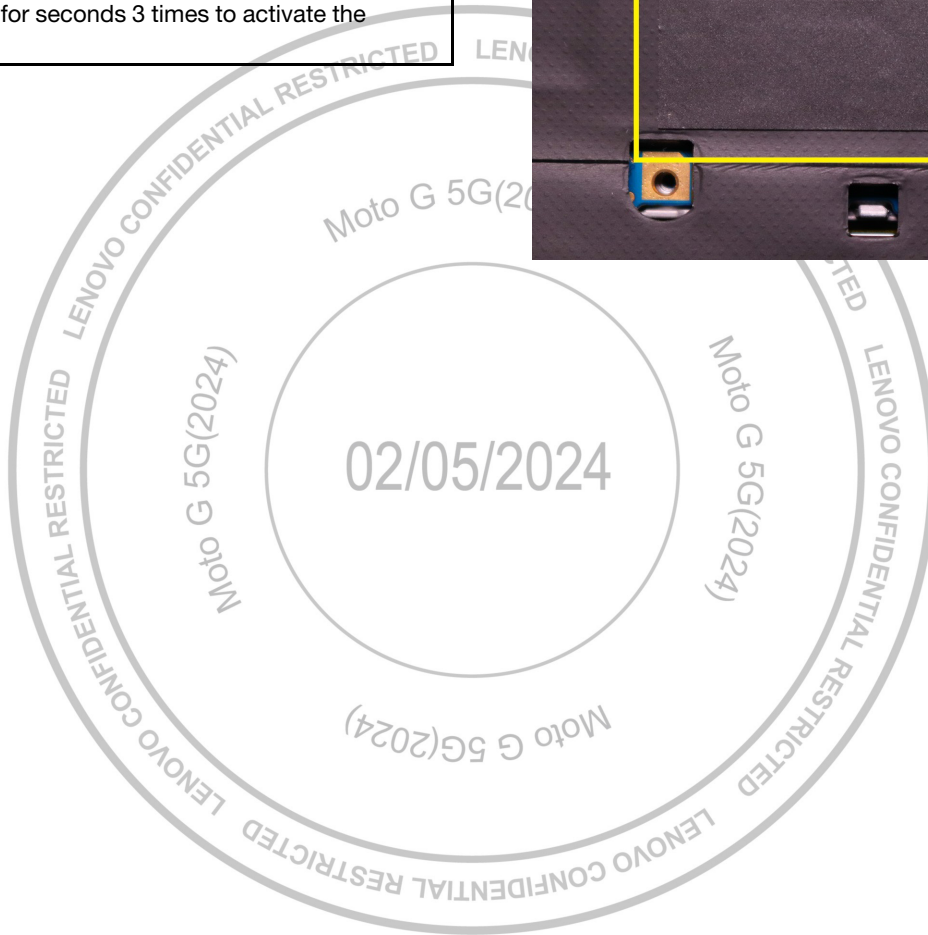
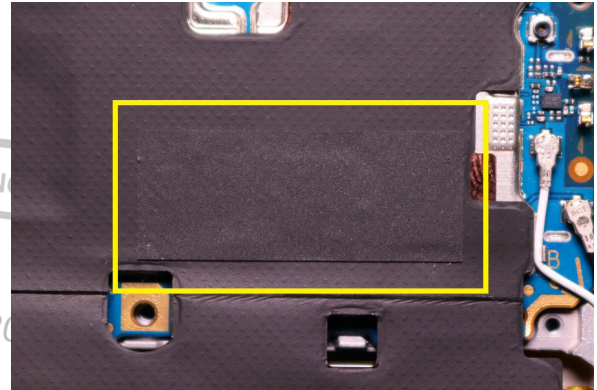
Shield Press Foam Assembly

Description	Reference #
HQ25801000700+Shell_shielding foam_HJ	32
HQ258100002G0+Shielding graphite_HLD	36

Use the Plastic Tweezer to place the Shield Press Foam on the location as shown.

NOTE

Press firmly for seconds 3 times to activate the adhesive.



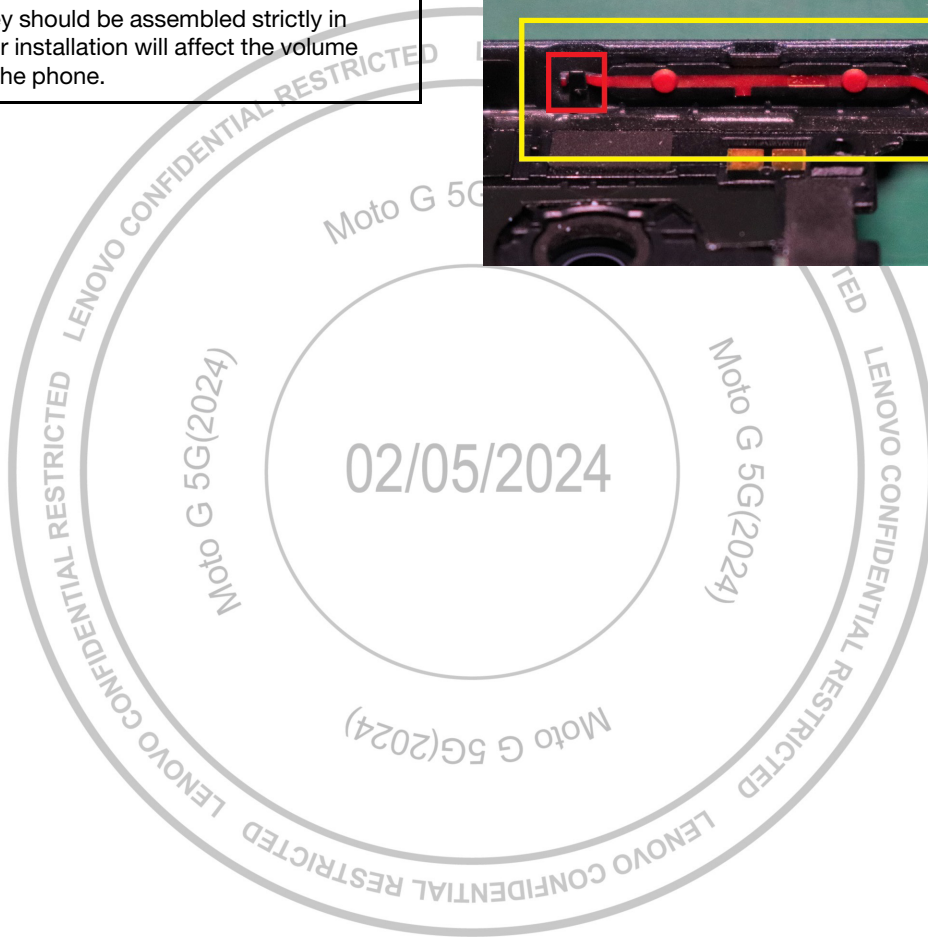
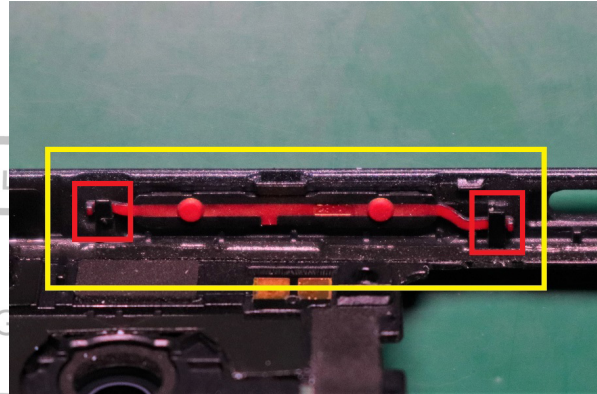
Volume Key Assembly

Description	Reference #
XT2417,MID FRM,GRY CS	4
HQ25401000340+Volume key_Sedona Sage_Spr	19

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

NOTE

The Volume Key should be assembled strictly in place. Improper installation will affect the volume adjustment of the phone.

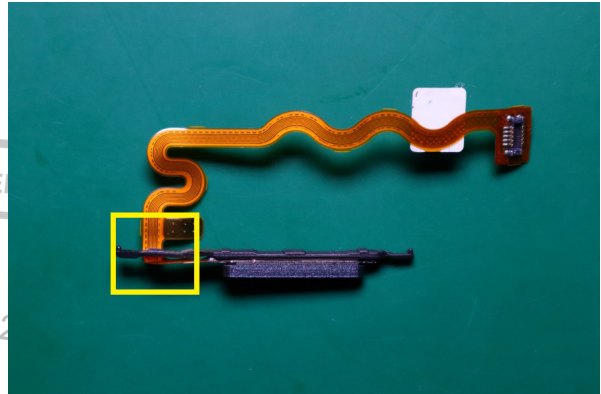


Fingerprint Sensor Assembly

Description	Reference #
XT2417,MID FRM,GRY CS	4
XT2417,FPS,GRY CS	6

NOTE

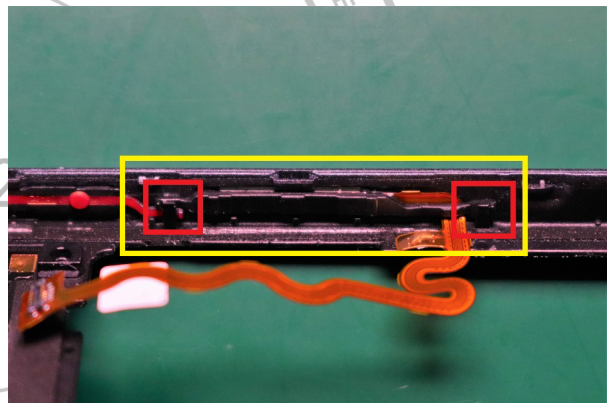
Pre-bend the Fingerprint Sensor to about 90° as shown before assembly.



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

NOTE

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



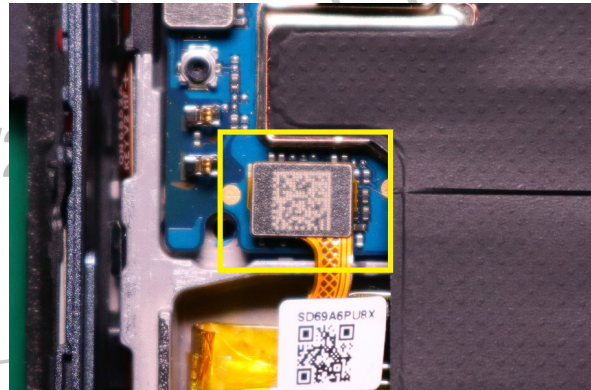
Middle Frame Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417-1,MB,4+128 DS,RTL CS XT2417-1,MB,4+128 DSL,CC CS XT2417-1,MB,4+128 DSL,CMCT CS XT2417-1,MB,4+128 DSL,SPEC CS XT2417-1,MB,4+128 DSL,TMO CS XT2417-1,MB,4+128 DSL,DISH CS XT2417-2,MB,4+128 DSL,CKT CS XT2417-4,MB,4+128 DSL,ATT CS XT2417D,MB,4+128 DSL,VZW CS XT2417D,MB,4+128 DSL,TF CS	2
XT2417,MID FRM,GRY CS	4
XT2417,FPS,GRY CS	6
HQ269040006F0+Screw_round head_cross_PG	20
HQ22111669000+Screw_M1.4xL3.5xD2.5_LJT	21

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

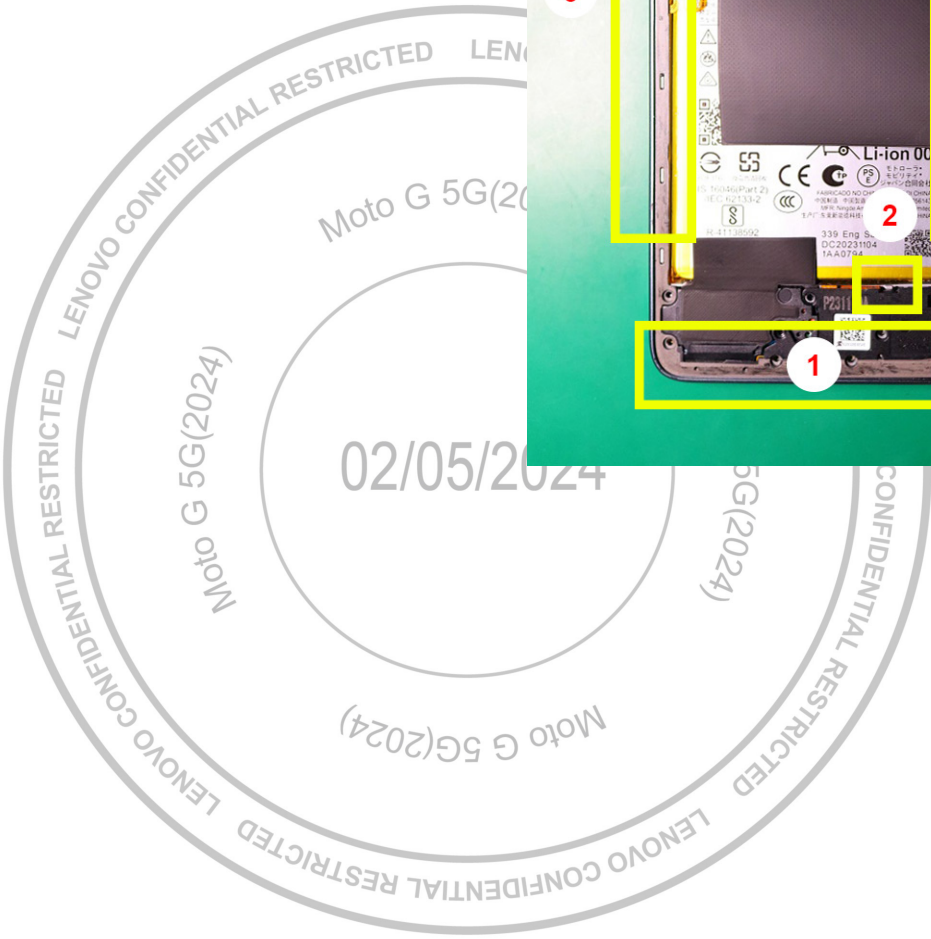
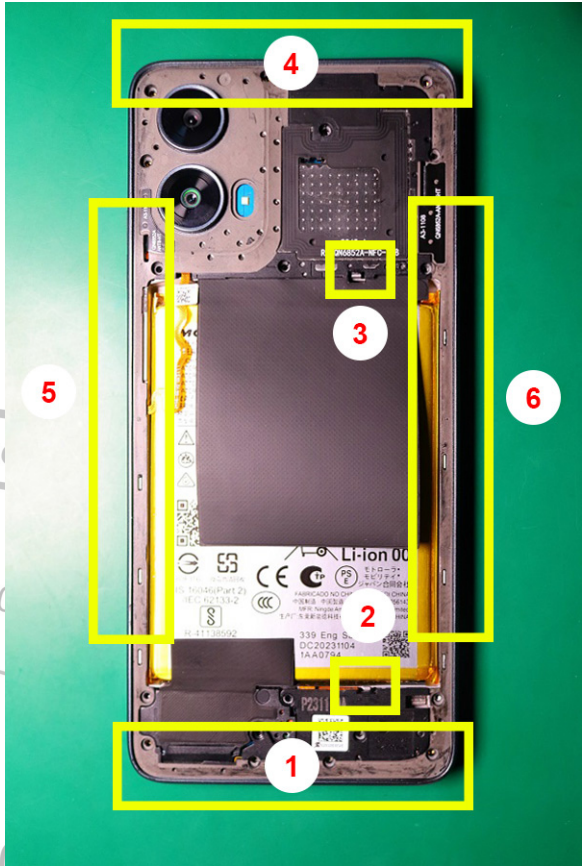
NOTE

Align the interface before securing to avoid damaging the contacts.



2. Peel off the protective cover of 2M Rear-Facing Camera and use fingers to place and secure the Middle Frame on the location in order as shown.

NOTE
Make sure all the buckles are snapped in place.



- Use Torque Driver with PH00 Bit to tighten the 18 screws as shown (0.85 ± 0.08 kgf-cm).

NOTE

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



Top Anti-Shock Adhesive Assembly

Description	Reference #
XT2417,MID FRM,GRY CS	4
HQ25804001A80+Middle frame foam Adhesive	29

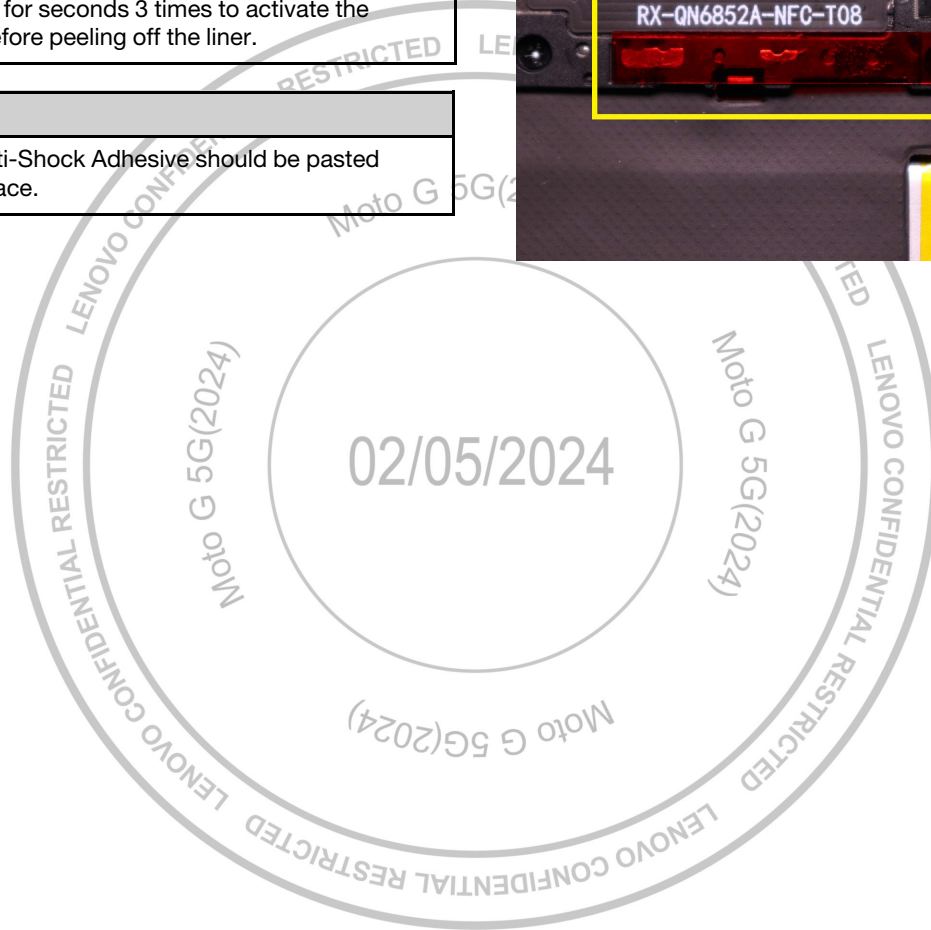
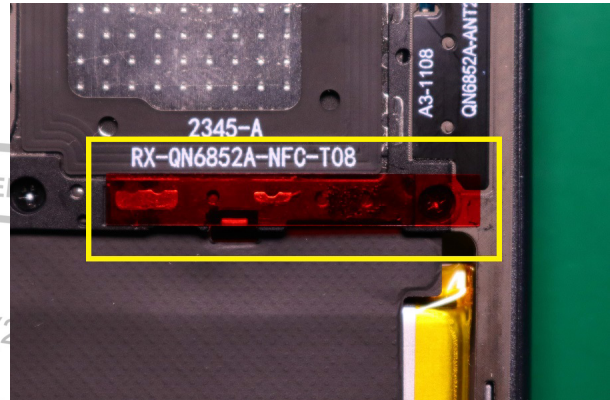
Use the Plastic Tweezer to place the Top Anti-Shock Adhesive on the location as shown and peel off the liner.

NOTE

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

NOTE

The Top Anti-Shock Adhesive should be pasted strictly in place.



Bottom Anti-Shock Adhesive Assembly

Description	Reference #
XT2417,MID FRM,GRY CS	4
HQ25804001A60+SPK_Shell vibrator adhesiv	30

Use the Plastic Tweezer to place the Bottom Anti-Shock Adhesive on the location as shown and peel off the liner.

NOTE

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

NOTE

The Bottom Anti-Shock Adhesive should be pasted strictly in place.



NFC Adhesive Assembly

Description	Reference #
XT2417,MID FRM,GRY CS	4
HQ253050001D0+Inlay-NFC Adhesive CS	26

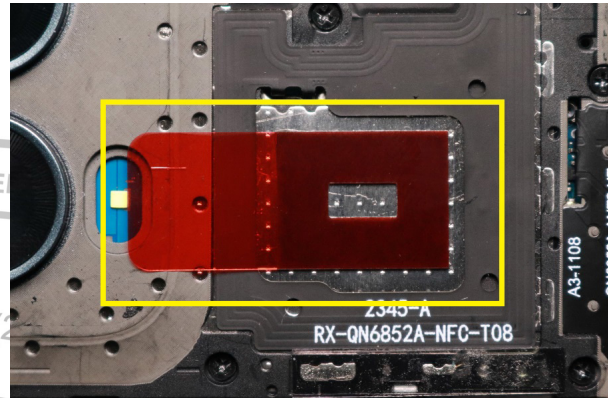
Use the Plastic Tweezer to place the NFC Adhesive on the location as shown and peel off the liner.

NOTE

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

NOTE

The NFC Adhesive should be pasted strictly in place.

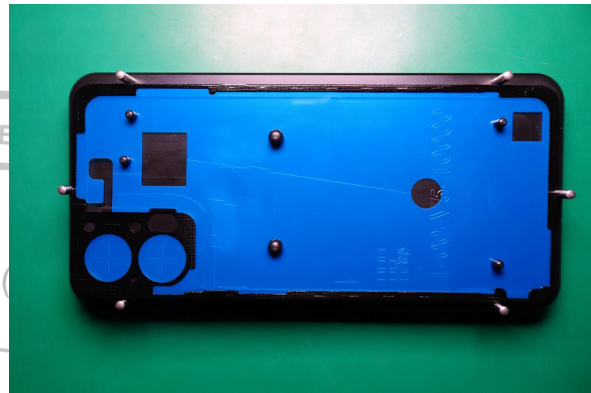


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Battery Cover Assembly

Description	Reference #
XT2417,TPLCM CS	1
XT2417,Inlay,GRY CS	5
HQ253050000Y0+Inlay Adhesive CS	25

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



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



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

NOTE

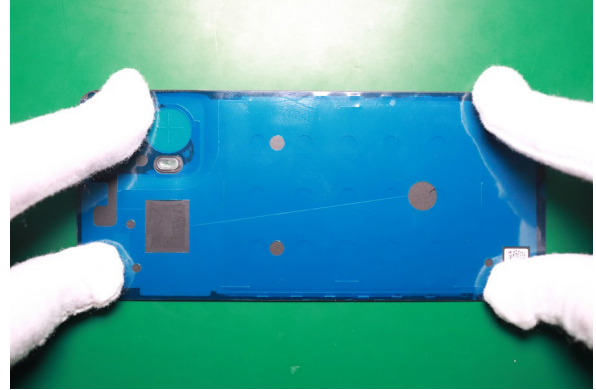
Make sure to press the Battery Cover and the alignment at the same time.



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

NOTE

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



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



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

NOTE

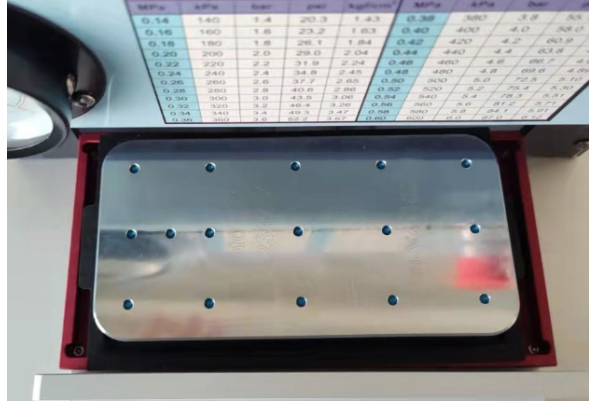
Please read pneumatic press system user manual prior to operation.



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



- Place the Inlay press fixture (1-00-V6-10000) on top of the phone as shown.



- Push the press system drawer into the chamber, and set program to No.8 by press “Program” button repeatedly, check the “Pressure” (Mpa) shows “0.36” and “Time” (sec) shows “30” as shown.



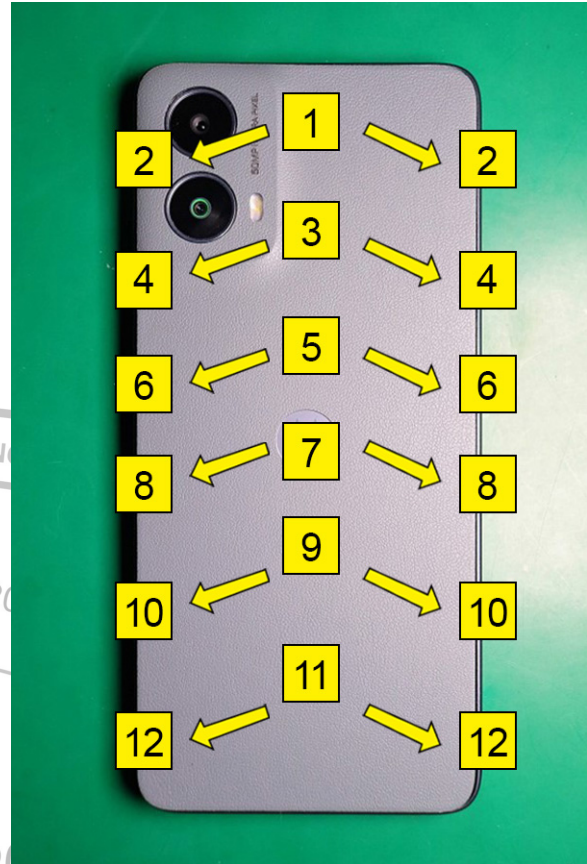
- Press both of “Start” on the left and right side to initiate press process. Wait 30 seconds until process is finished.



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



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



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



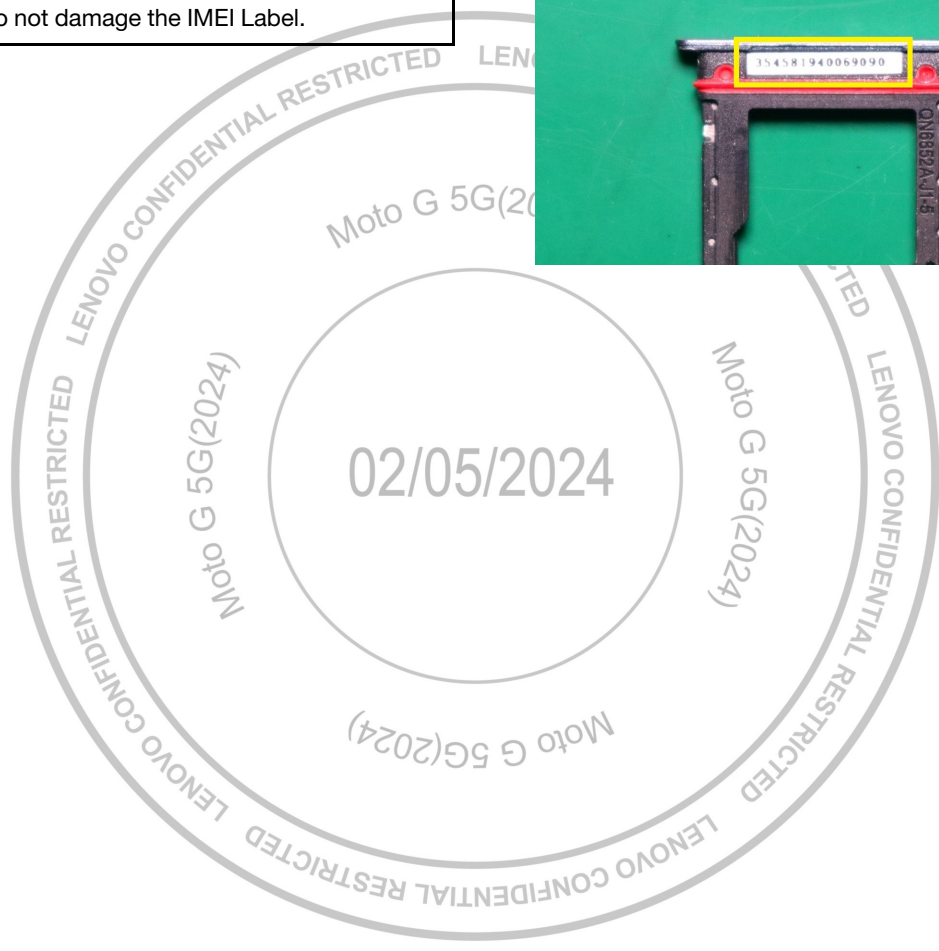
IMEI Label Assembly

Description	Reference #
HQ256010004L0+plastic Cato_Sedona Sage_J	18
HQ60420501000+Lisbon IMEI Label_DL	-

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

NOTE

Be careful to not damage the IMEI Label.



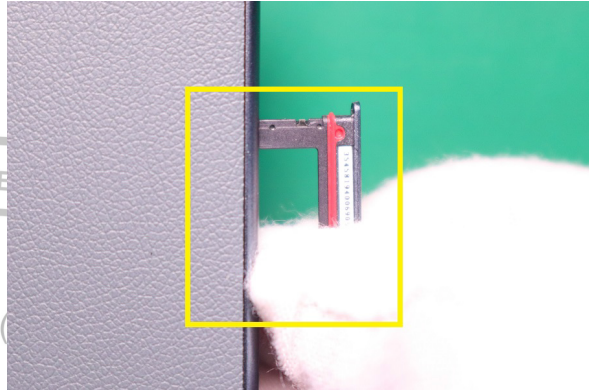
SIM Tray Assembly

Description	Reference #
XT2417,TPLCM CS	1
HQ256010004L0+plastic Cato_Sedona Sage_J	18

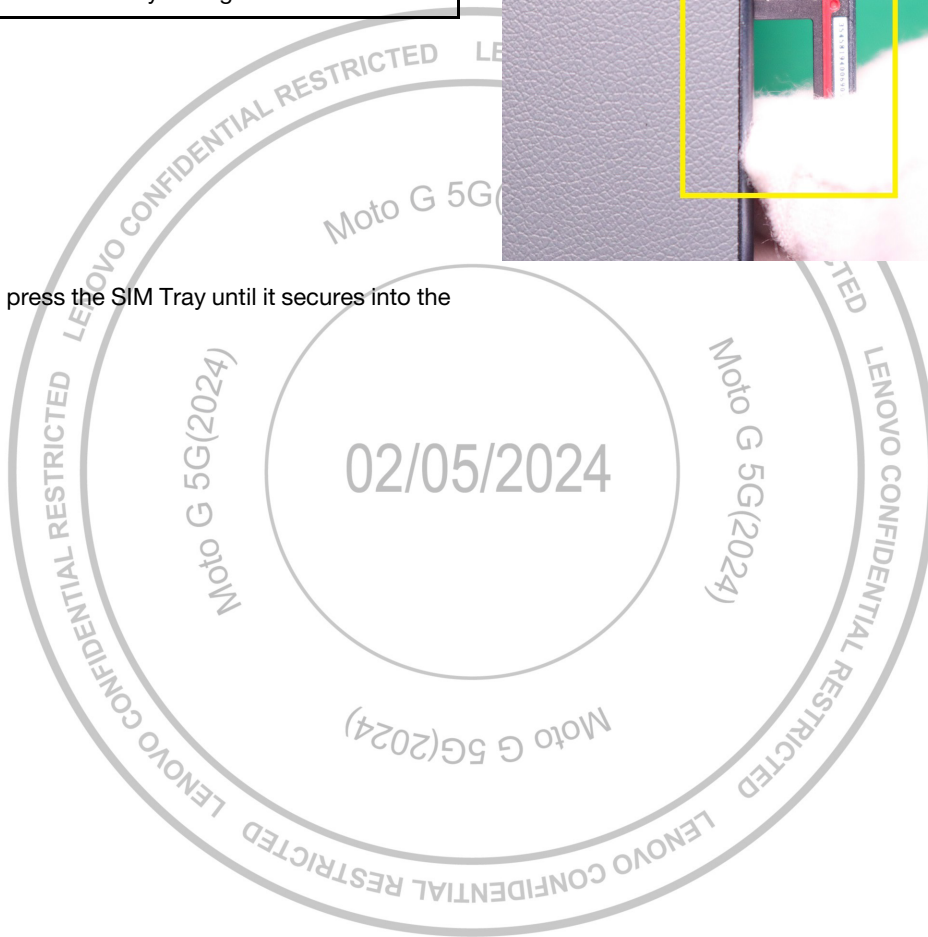
1. Insert the SIM Tray in the transceiver as shown.

NOTE

Do not shake the SIM Tray during the insertion.



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



Chapter 6. Assembly Quality check

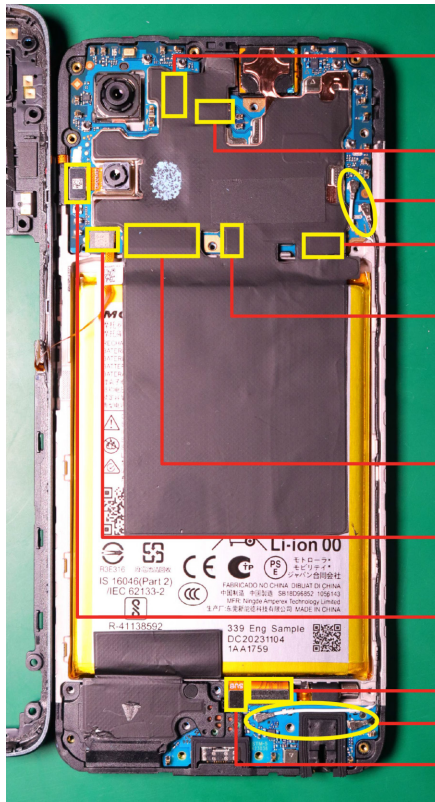
Battery Quality Check



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



Connector Quality Check



Check if the rear facing camera connector is well-seated and there's no sign of damage.

Check if the front facing camera connector is well-seated and there's no sign of damage.

Check if the 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 coax cable connector is well-seated and there's no sign of damage.

Check if the LCD connector is well-seated and there's no sign of damage.

Check if the FPS 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 LCD connector is well-seated and there's no sign of damage.

Check if the main flex connector is well-seated and there's no sign of damage.



Screws Quality Check



Check if any missing/unseated screws.

Check if any missing/misaligned heat spreader.

Check if any missing/unseated screws.





Chapter 7. Battery Safety Guidelines

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

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

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

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

Ensure screws or screwdrivers or any sharp tools do not contact the Battery.

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

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

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

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

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

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



Chapter 8. Guidance for Handling Lithium Ion Batteries

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

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

Background

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

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

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

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

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

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

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

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

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

Battery Service: Required Equipment

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

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

Battery Service: Precautions, Training and Handling Guidelines

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

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

Battery Safety Training

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

Battery Handling

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

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

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

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

New Battery Installation

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

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

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

Storage Guidelines

Technicians shall follow these Li-Ion battery storage guidelines:

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

Battery Recycling and Shipment

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

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

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

Employee Emergency Action Plan

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

First Aid Procedures

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





Chapter 9. Broken Glass Handling Guide

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.

