



First scope

Good-housing

1. Dissemble
2. LCD [IQC]
3. Cleaning
4. Lamination
5. Frame attach
6. Kitting

Back-housing

Good-housing

1. Dissemble

Separation del housing y el LCD

1. Heating pad
 - a. Programable?
2. Succion Screw
 - a. Pedal?
3. Tape Face ID Cam (frontal cam & true depth)
 - a. No particles in the air?

2. LCD [IQC]

1. Test with S300
2. Take out shield plate
3. Apply tape to the screen if broken
4. Remove Frame

3. Cleaning

XR 11 8 8+

1. OCA Removing (its the glue that hold LCD and Crystal)
 - a. They use jigs for holding the LCD acrylic, rubber and antistatic rug
 - i. **!** They do need it taller and the rubber
 - b. Test with S300 & Phones
 - i. **!** They using phones because theres not enough S300

4. Lamination

1. Place the LCD in the jig
 - a. its a sandwich
 - i. Metal with the laminate
 - ii. LCD on acrylic jig with tape
 1. **!** They spend too much tape to hold horizontally the LCD because sometimes the LCD
 - a. Solution: Maybe use suction cups or magnets
 - iii. 'goma' que viene con fixture

- iv. Rest of the fixture
 - 1. Metal holding the 'goma'
 - 2. Bottom plastic
- 2. Place the whole jig in the Lamination machine
 - a. Place it and they hold the door close until vacuum is ready
 - b. After vacuum is reached the press comes down
 - i. Vacuum: -100kPa
 - ii. Pressure:
- 3. Test with S300
- 4. If iPhone 8 & 8+
 - a. Home key test not using jig
 - i. ! This gotta be a jig

5. Frame attach

- 1. First clean up the fixture from dry glue
- 2. Clean again the back of LCD from the remaining OCA
 - a. they use alcohol and/or thinner
- 3. The place the new frame in the fixture and remove tapes
- 4. Add the glue into the frame
 - a. ! USED TO BE A MACHINE; not using because lack of technician
 - b. They do it in a circular motion
 - i. ! This could be in a turn table and pedal
- 5. Place lcd & grip temporarily
 - a. ! this is madness, personnel told me it was because she doesn't have pulse
- 6. Grip again and hold for 1 hr
 - a. No timer, just take the last one and start the timer there
- 7. Remove excess glue

6. Kitting

- 1. Clean the back of the cameras with alcohol:
 - a. ! CLEANING: The person with the most experience use q-tip for this but when taught the personnel it was supposed to be using the black plastic spatula
- 2. Apply the tapes
 - a. ! TAPING: they use the fingers to press down the tapes
- 3. Align the glue
 - a. ! HOLDING GUIDE: they use a particular model of tweezers for this part, some of them make them more prone to fail at the alignment process

Back-housing

Enclosure Flow Chart