moto g24 and moto g24 Power
Level 2 – Service and Repair Manual

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Revision History

Revision	Date	Notes
1	01/02/2024	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.

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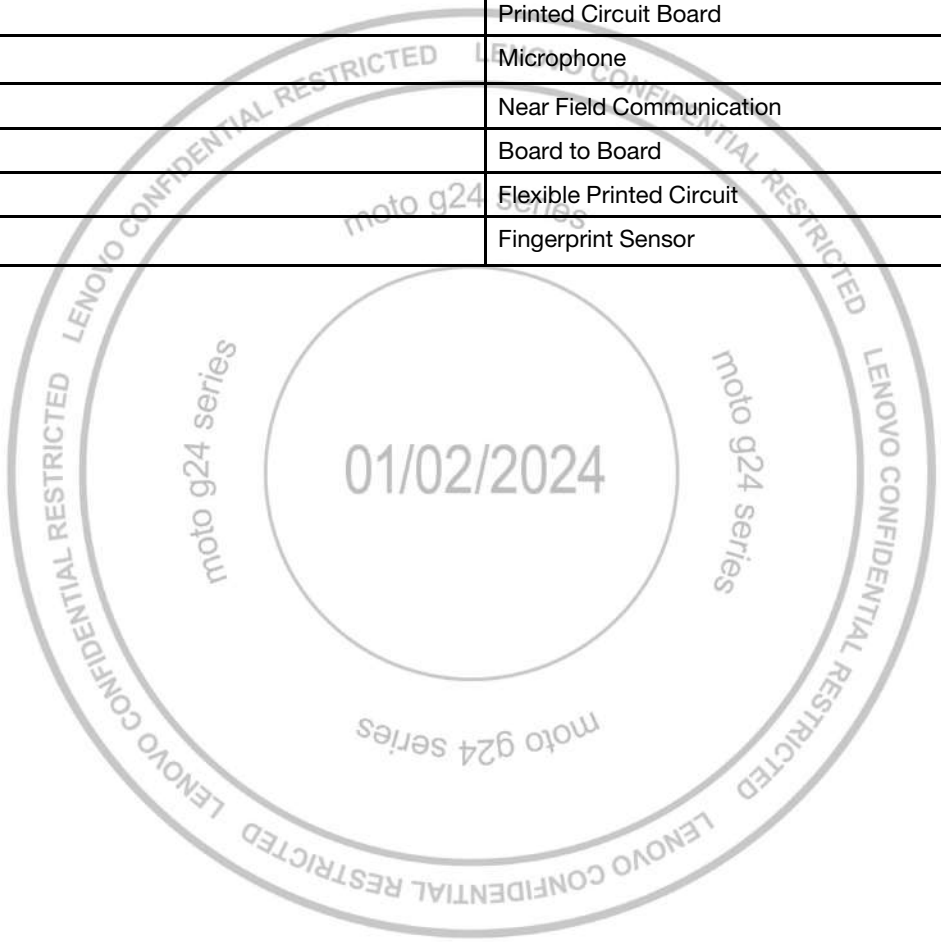
Chapter 2. Introduction

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



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External Views

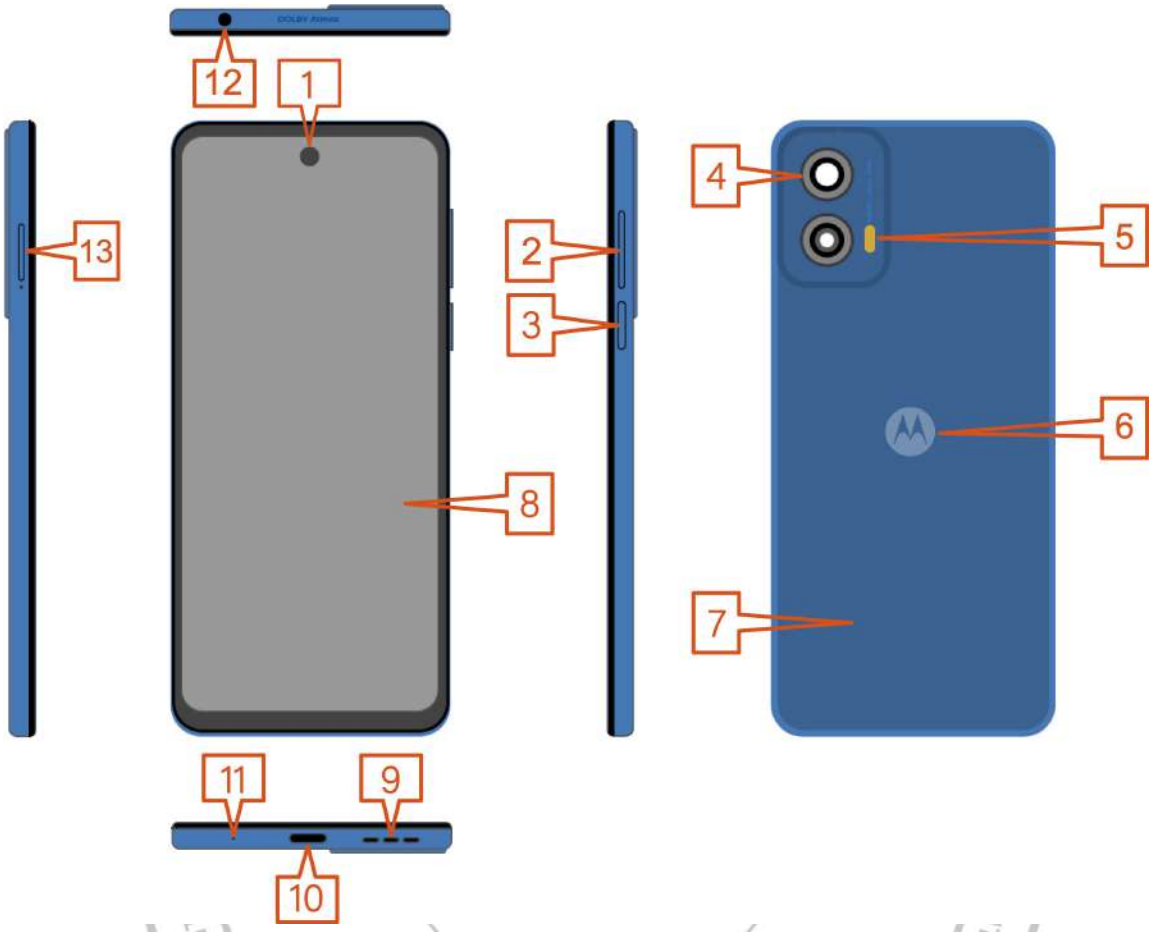

Figure 1. External Views

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	Primary MIC

Table 2. External Views Parts List (continued)

Reference #	Description
12	Secondary MIC
13	Sim Door

Main Exploded Views

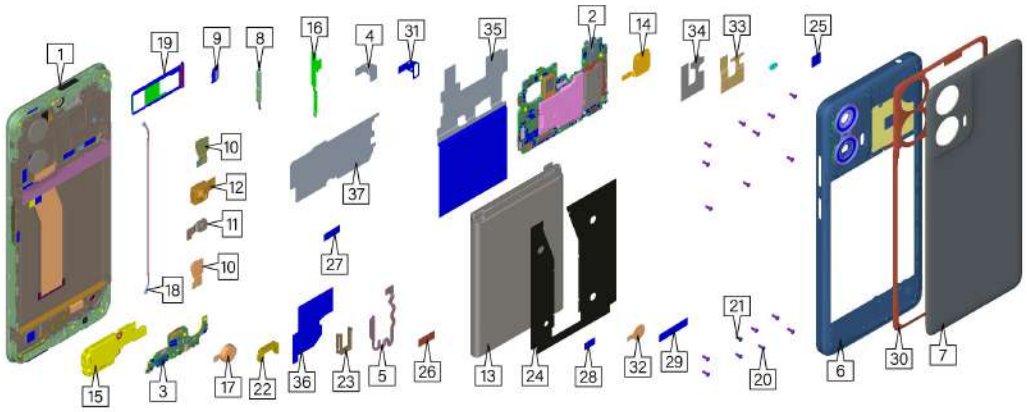

Figure 2. Assembly Exploded View

Table 3. Assembly Exploded View Parts List

Reference #	Description	Recovery Part
1	XT2423,TPLCM,S101-CKZ130-000	Yes
	XT2423-5,TPLCM,JP,S101-CKZ133-000	Yes
	XT2425,TPLCM,IN,S101-CK5131-000	Yes
2	XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001	Yes
	XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000	Yes
	XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003	Yes
	XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002	Yes
	XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005	Yes
	XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004	Yes
	XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006	Yes
	XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007	Yes
	XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008	Yes
	ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP	Yes
	XT2425-1,MB,8+128 SS,LA,F00CK53-000-001	Yes
	XT2425-1,MB,8+256 SS,LA,F00CK53-000-002	Yes
	XT2425-1,MB,8+256 DS,LA,F00CK53-000-003	Yes
	XT2425-1,MB,4+256 SS,LA,F00CK53-000-000	Yes
	ASSY,BD KIT,Fogo4G 6000 4+128 DS IN	Yes
	ASSY,BD KIT,Fogo4G 6000 8+128 DS IN	Yes
	XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004	Yes
	XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	Yes

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Table 3. Assembly Exploded View Parts List (continued)

Reference #	Description	Recovery Part
3	XT2423,SubBD,S102-CKZ000-000	Yes
	XT2423-5,SubBD,JP,S102-CKZ002-000	Yes
	ASSY,DTR BRD,Fogo4G 5000 BR PLT	Yes
	XT2425,SubBD,S102-CK5000-000	Yes
	ASSY,DTR BRD,Fogo4G 6000 IN PLT	Yes
4	XT2423,FLSH BD,S102-CKZ001-000	Yes
	ASSY,DTR BRD,Fogo4G 5000 BR IN FLB PLT	Yes
5	XT2423,FPS,GRY,S108-CKZ080-000	Yes
	XT2423,FPS,GRN,S108-CKZ030-000	Yes
	XT2423,FPS,PNK,S108-CKZ100-000	Yes
	XT2425,FPS,CB,S106-CK5020-000	Yes
	XT2425,FPS,SS,S106-CK5060-000	Yes
6	XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100	Yes
	XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100	Yes
	XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100	Yes
	XT2423,MIDFRM,GRY,S101-CKZ080-100	Yes
	XT2423,MIDFRM,GRN,S101-CKZ030-100	Yes
	XT2423,MIDFRM,PNK,S101-CKZ100-100	Yes
	XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100	Yes
	XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100	Yes
	XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100	Yes
	XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100	Yes
	XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100	Yes
	XT2425,MIDFRM,CB,8M,S101-CK5020-100	Yes
	XT2425,MIDFRM,SS,8M,S101-CK5060-100	Yes
	XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100	Yes
	XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100	Yes
	XT2425,MIDFRM,CB,16M,S101-CK5022-100	Yes
	XT2425,MIDFRM,SS,16M,S101-CK5062-100	Yes
	XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100	Yes
	XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100	Yes
	XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100	Yes
	XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100	Yes
	XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100	Yes

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Table 3. Assembly Exploded View Parts List (continued)

Reference #	Description	Recovery Part
	XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100	Yes
	XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100	Yes
	XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100	Yes
	XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100	Yes
	XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100	Yes
	XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100	Yes
	XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100	Yes
	XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100	Yes
	XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100	Yes
	XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100	Yes
	XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100	Yes
	XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100	Yes
	XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100	Yes
	XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100	Yes
	XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100	Yes
	XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100	Yes
	XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100	Yes
	XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	Yes
7	XT2423,Inlay,GRY,S101-CKZ082-200	Yes
	XT2423,Inlay,GRN,S101-CKZ032-200	Yes
	XT2423,Inlay,PNK,S101-CKZ102-200	Yes
	XT2423-5,Inlay,GRY,JP,S101-CKZ083-200	Yes
	XT2423-5,Inlay,GRN,JP,S101-CKZ033-200	Yes
	XT2425,Inlay,CB,deepBLU,S101-CK5023-200	Yes
	XT2425,Inlay,SS,lightBLU,S101-CK5063-200	Yes
8	TNM305-CKZ080-000+Volume Key Grey_EH	Yes
	TNM305-CKZ030-000+Volume GRN	Yes
	TNM305-CKZ100-000+Volume PNK	Yes
	TNM305-CKZ081-000+Vol Key GRY_HRD_JP	Yes
	TNM305-CKZ031-000+Vol Key GRN_EH_JP	Yes
	TNM305-CKZ020-000+Volume Key Blue_EH	Yes
	TNM305-CKZ060-000+Volume SaltW	Yes
9	TNM223-CKZ000-101+flash shield11.2x4.8	Yes
	TNM223-CK5000-101+flash cover_AB_HG	Yes

Table 3. Assembly Exploded View Parts List (continued)

Reference #	Description	Recovery Part
10	MDL,CAMR,8M,FRNT,SL08A1AB;Sunwin,FF:Fogo	Yes
	MDL,CAMR,16M,front,C3EF01;Q Tech,FF:Saba	Yes
11	MDL,CAMR,2M,rear;D1N206D;SUNNY,FF:Cancun	Yes
12	MDL,CAMR,50M,rear,C2PA30;Q Tech,AF:Cancu	Yes
13	ACCY,BAT,5000mAh,QF50,ATL436590,ATL	Yes
	ACCY,BAT,6000mAh,PC60,ATL536589,ATL,WW	Yes
14	TNN505-CKZ000-010+Receiver_HS	No
15	TNN501-CKZ000-010+Speaker_HS	Yes
16	TNN802-CKZ000-010+FPC_Sidekey_KOX	No
17	TNN901-CKZ000-000+Coin_Vibrator_HZF	Yes
18	TNEI06-818026-002+RF cabel_white_DL	Yes
19	TNEI30-CKZ081-000+SIM tray GRY SS_HRD	Yes
	TNEI30-CKZ031-000+SIM tray GRN SS_HRD	Yes
	TNEI30-CKZ101-010+SIM tray PNK SS_HRD	Yes
	TNEI30-CKZ080-000+SIM tray Grey_HRD	Yes
	TNEI30-CKZ030-000+SIM tray GRN DS_HRD	Yes
	TNEI30-CKZ100-000+SIM tray PNK DS_HRD	Yes
	TNEI30-CKZ082-000+SIM Tray GRY_HRD_JP	Yes
	TNEI30-CKZ032-000+SIM Tray GRN_HRD_JP	Yes
	TNEI30-CKZ021-000+SIM tray BLU SS_HRD	Yes
	TNEI30-CKZ061-000+SIM tray SaltW SS_HRD	Yes
	TNEI30-CKZ020-000+SIM tray Blue_HRD	Yes
	TNEI30-CKZ060-000+SIM tray SaltW DS_HRD	Yes
20	TNM501-211105-027+round head screw_LJT	No
21	TNM501-211103-059+round head screw1_LJT	No
22	TNM716-CKZ000-002+T-C silicone sleeve_EH	Yes
23	TNM716-CKZ000-001+EAR silicone sleeve_EH	Yes
24	TNM715-CKZ000-006+BAT Adhesive_KY	No
25	TNM715-CKZ001-004+Adhesive_XHT	No
26	XT2423,ADH,Inlay,Small,M715-CKZ000-002	No
27	XT2425,ADH,Inlay,top,M715-CK5000-000	No
28	XT2425,ADH,inlay,btm,M715-CK5000-001	No
29	XT2423,ADH,Inlay,btm,M715-CKZ000-008	No
30	XT2423,ADH,Inlay,M709-CKZ000-031	No

Table 3. Assembly Exploded View Parts List (continued)

Reference #	Description	Recovery Part
	XT2425,ADH,Inlay,M709-CK5000-000	No
31	XT2423,ADH,Flash,M715-CKZ000-003	No
32	XT2347 Motor Adhesive&M715-CJ8000-017	No
33	TNM719-CKZ000-001+CAM copper foil_KY	No
34	TNM721-CKZ001-006+C_R Radiator sheet_LS	No
35	TNM721-CKZ001-018bot Radiator sheet_LS	No
36	TNM721-CKZ001-007+SPK Radiator sheet_LS	No
37	TNM721-CK5000-000+TOP Radiator_XD	No
/	TNM501-211103-011+round head screw	No
/	TNM716-CKZ000-003+silicone sleeve_EH	Yes
/	TNM717-CKZ000-000+Conductive Fabric_KY	No
/	TNM719-CKZ000-000+CON copper foil_KY	No
/	TNP316-CBR000-000+label double layer_LHL	No
/	TNP316-CH1000-000+waterproof Label	No

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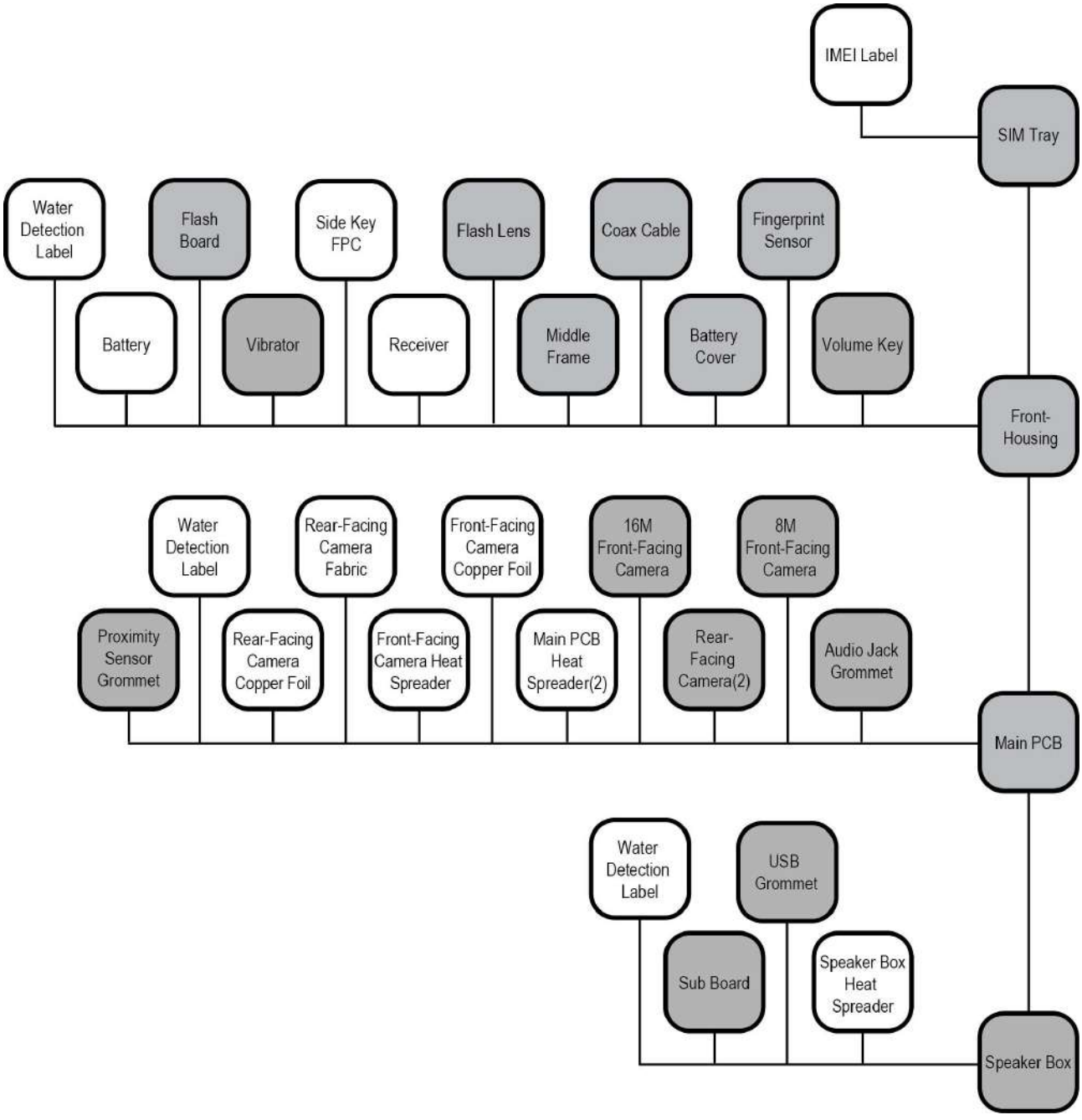
Chapter 3. Disassembly and Recovery

Disassembly and Recovery Map

*Shaded parts may be eligible for parts recovery.



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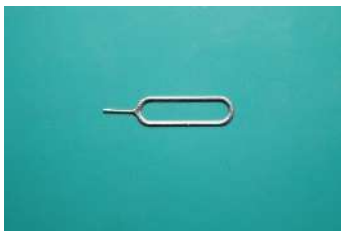
Tools Required for Disassembly

The following tools are required to disassemble the moto g24 and moto g24 Power phone.

WARNING
Improper tools may cause damage to components.

Description	Part #	Picture/Drawing
3 mm Allen Wrench	--	
Anti-static foam pad Pad thickness : ≥5mm Pad Material : silicone rubber, as reference Silicone Clean. Matt: (RG-400)	--	
Regen-i Removal Fixture https://www.regeni.com/	01/02/2024 RG271	
Hot Plate	--	
SIM/SD Tray Removal Tool	--	

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

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Description	Part #	Picture/Drawing
Sealed Bag	--	
Plastic Tweezers	--	
Oven	RG-202F	
Thin Plastic Spudger	0-00-00-40826	
ESD Mat	--	--
Wrist Strap	--	--
Gloves	--	--

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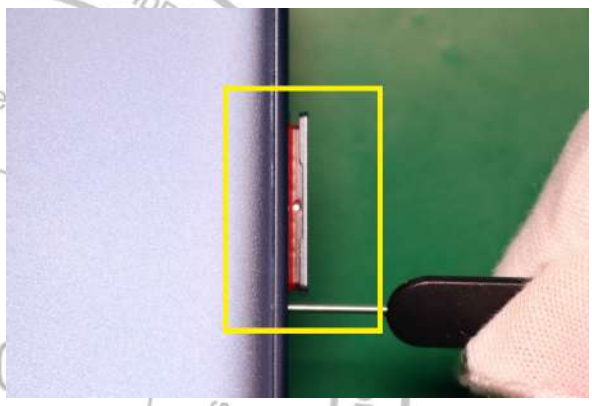
SIM Tray Removal

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.

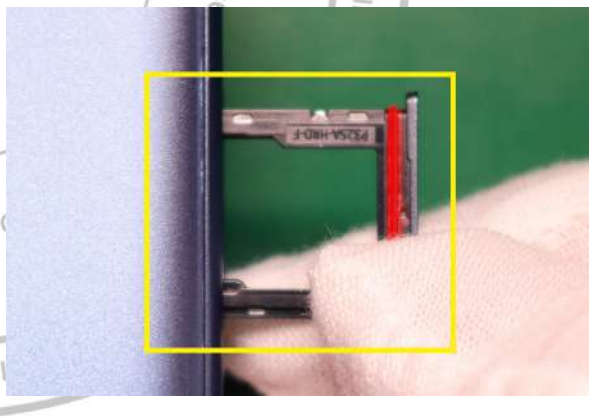
WARNING
Disassembling the device without turning it off may cause data loss.

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



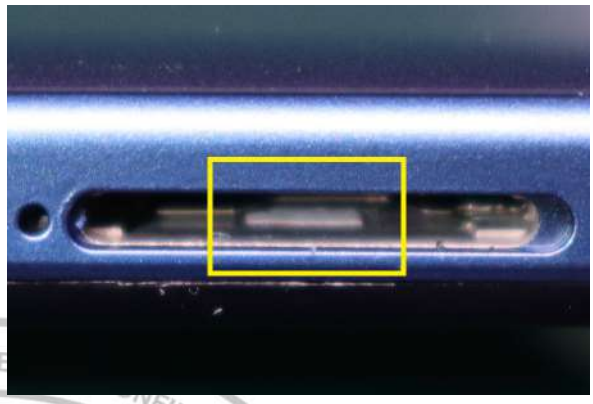
3. Use fingers to take out the SIM Tray.

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.

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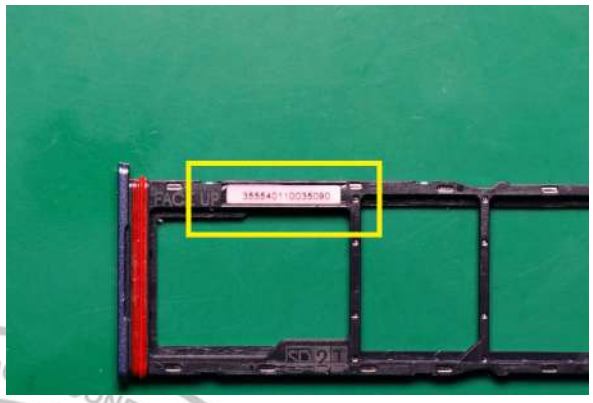
IMEI Label Removal

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.

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Battery Cover Removal

Preheating for Battery Cover Removal

NOTE
The Battery Cover can be recovered and reused after removal.

NOTE
Battery Cover Removal Methods A and B have the same preheating steps, as shown below.

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

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

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

WARNING
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 Method A

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

1. Use the Suction Cup Tool to create a gap between the Battery Cover and the Middle Frame.

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

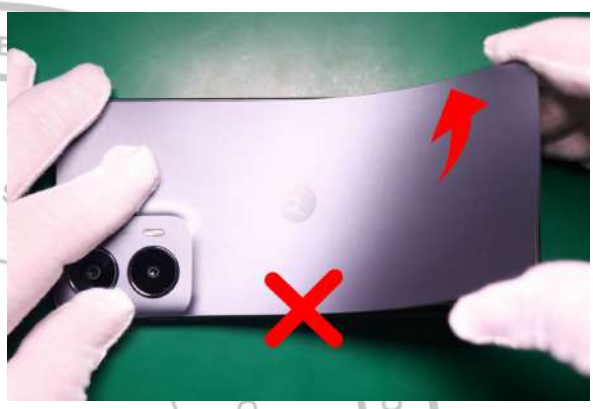
//CAUTION//
Do not insert the Thin Plastic Spudger more than 10 mm to prevent damaging internal components.

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

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

NOTE
Do not bend the Battery Cover over 25 degrees.

NOTE
Pieces of adhesive is applied to Rear-Facing camera, Speaker Box and NFC areas and need strong force to loosen.



NOTE
Do not 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 Middle Frame.

5. Split the Battery Cover from the phone.

Battery Cover Removal Method B

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

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

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

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

//CAUTION//
Make sure that suction cup avoids icon location.

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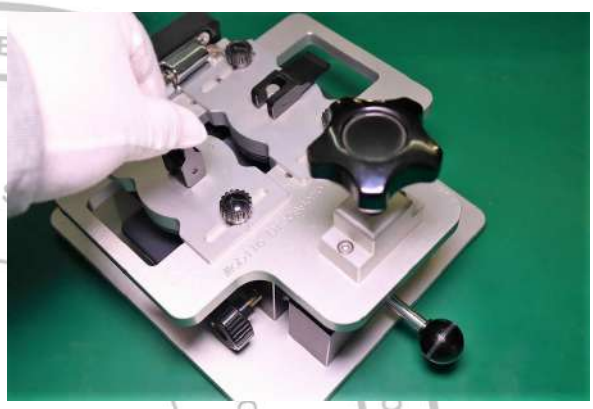
4. Use both hands to press the Top Holder of the fixture for 5 seconds.

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



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

NOTE
Please use one Suction Cup when disassemble Battery Cover and Front-Housing and make sure to attach the suction cup on the edges of the phone.

6. Rotate the Main Thread clockwise to disengage the Battery Cover from the Middle Frame.

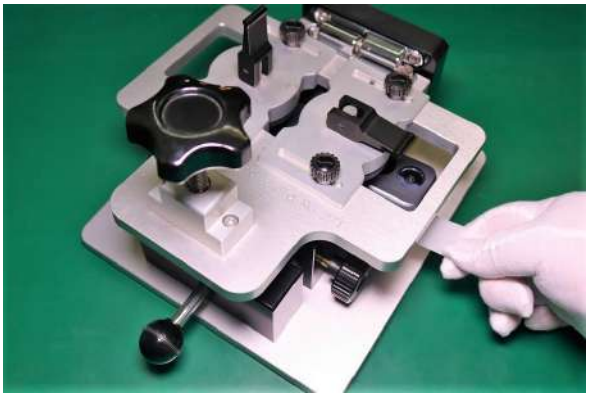
NOTE
Do not rotate the Main Thread to the end position to avoid damaging the Battery Cover.

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

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

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

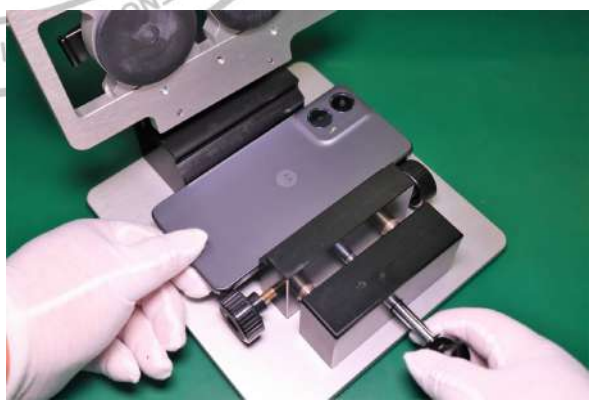
//CAUTION//
Do not insert the Thin Plastic Spudger more than 10 mm to prevent damaging internal components.



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

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

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



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

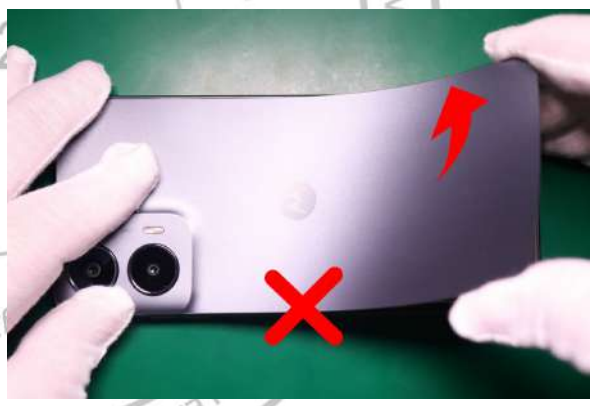
//CAUTION//
Do not insert the Thin Plastic Spudger more than 10 mm to prevent damaging internal components.

//CAUTION//
Slowly move the Thin Plastic Spudger to avoid scratching the Front Housing.

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

NOTE
Do not bend the Battery Cover over 25 degrees.

NOTE
Pieces of adhesive is applied to Rear-Facing camera, Speaker Box and NFC areas and need strong force to loosen.



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.

14. Split the Battery Cover from the phone.

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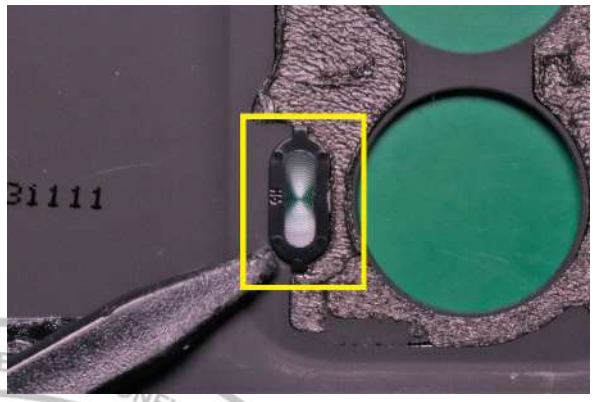
Flash Lens Removal (For 5000mAH Battery Version)

NOTE
The Flash Lens can be recovered and reused after removal.



Use the pointed end of the Black Stick to remove the Flash Lens from the Battery cover as shown.

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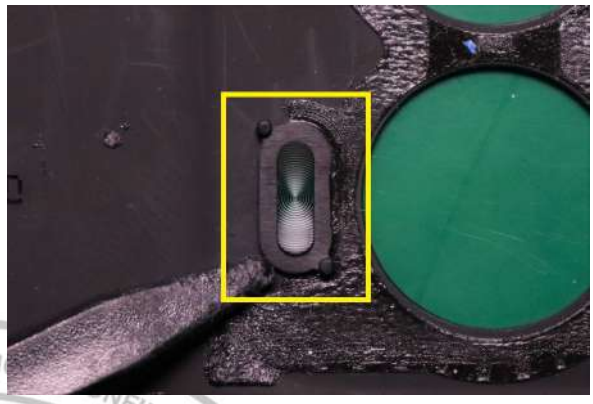
Flash Lens Removal (For 6000mAH Battery Version)

NOTE
The Flash Lens can be recovered and reused after removal.



Use the pointed end of the Black Stick to remove the Flash Lens from the Battery cover as shown.

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Middle Frame Removal (For 5000mAH Battery Version)

NOTE
The Middle Frame can be recovered and reused after removal.

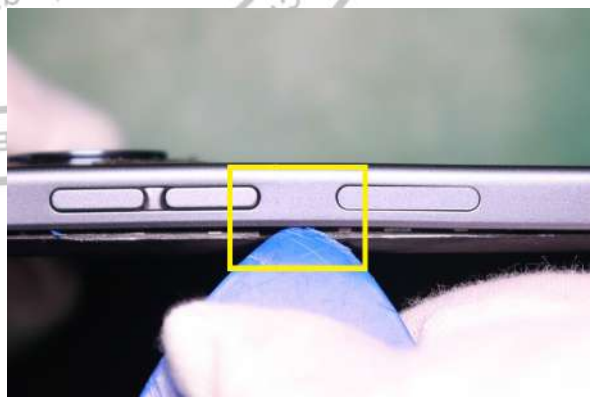
1. Use the Torque Driver with PH00 Bit to remove the 16 screws as shown.

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

NOTE
Please keep the screws properly.

WARNING
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.

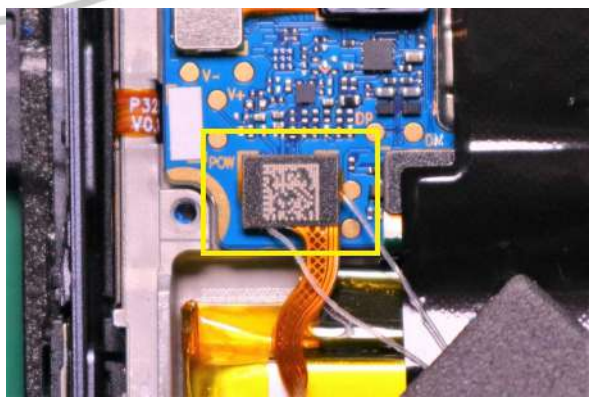


3. Move the Shim in the direction as shown to realease the buckles.

4. Split the Middle Frame from the phone.

4. Use the BtB tool to remove the FPS Flex connector from the location as shown.

NOTE
Be careful to avoid damaging the BtB connector.



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Middle Frame Removal (For 6000mAH Battery Version)

NOTE
The Middle Frame can be recovered and reused after removal.

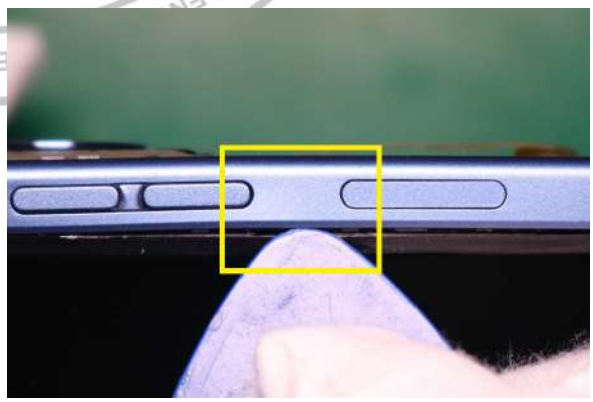
1. Use the Torque Driver with PH00 Bit to remove the 16 screws as shown.

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

NOTE
Please keep the screws properly.

WARNING
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.

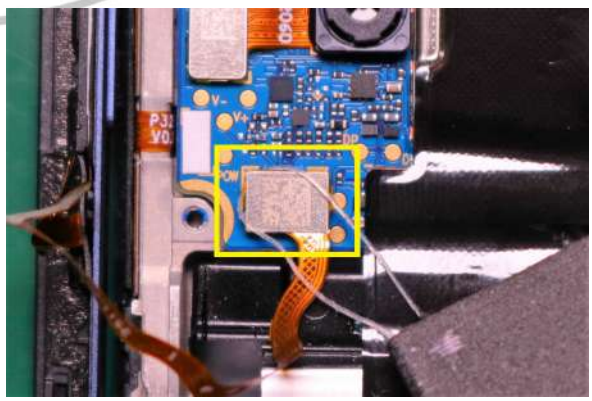


3. Move the Shim in the direction as shown to realease the buckles.

4. Split the Middle Frame from the phone.

4. Use the BtB tool to remove the FPS Flex connector from the location as shown.

NOTE
Be careful to avoid damaging the BtB connector.



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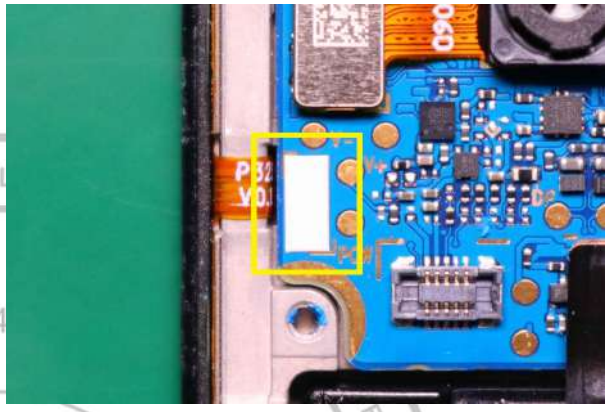
Water Detection Label Inspection

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.



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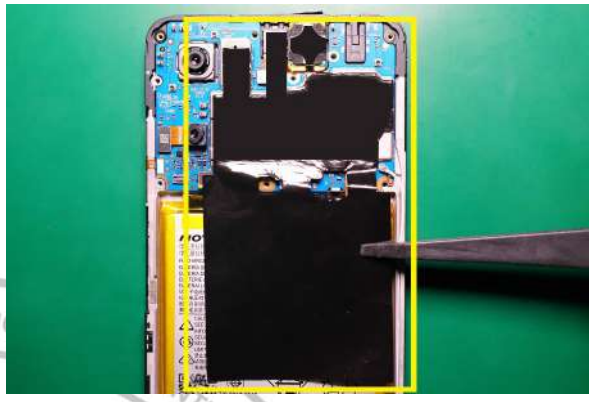
Main PCB Bottom Heat Spreader Removal (For 5000mAH Battery Version)



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

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

NOTE
Do not against metal components on Main PCB with the Plastic Tweezer when disassembling in case of damage.

NOTE
During assembly, please assemble the Front-Facing Camera Heat Spreader and Main PCB Bottom Heat Spreader (6000mAH version) for the 5000mAH version phone.

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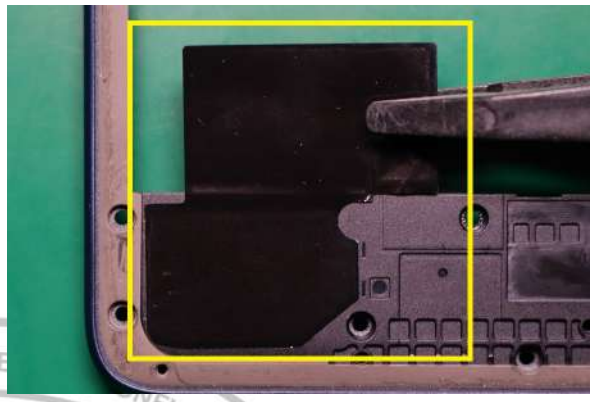
Speaker Box Heat Spreader Removal (For 6000mAH Battery Version)

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.

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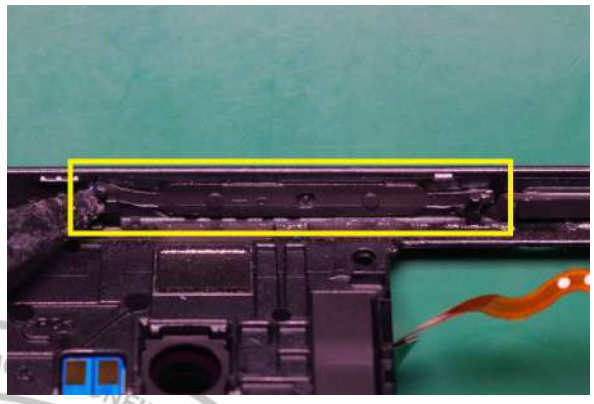
Volume Key Removal

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.

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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.

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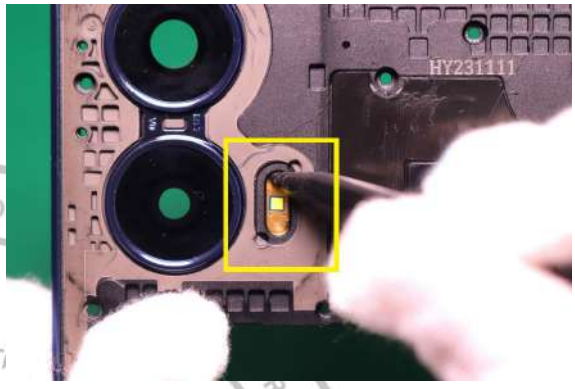
Flash Board Removal

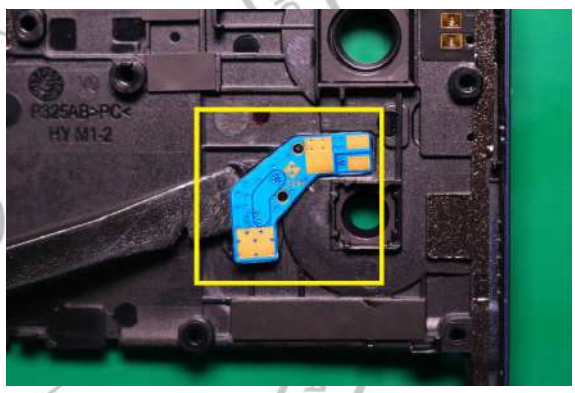
NOTE
The Flash Board can be recovered and reused after removal.

1. Use the pointed end of the Black Stick to push the Flash Board inwards as shown.



NOTE
Careful not to damage functional components of Flash Board.

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



NOTE
Careful not to damage functional components of Flash Board.

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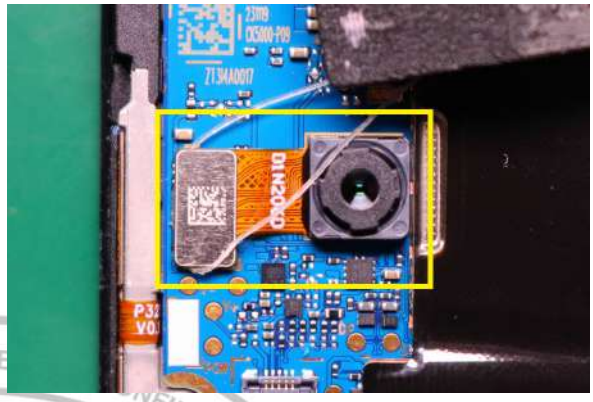
2M Macro Rear-Facing Camera Removal

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



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

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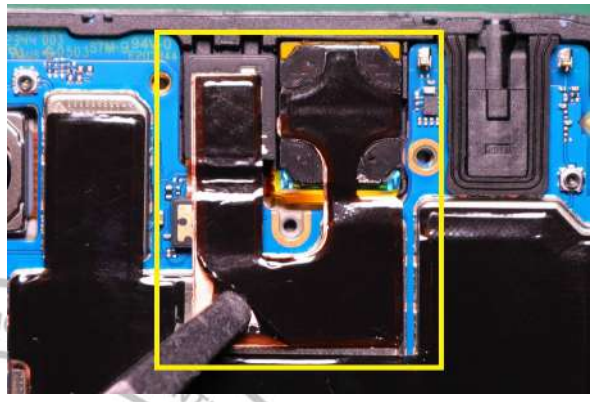
Front-Facing Camera Heat Spreader Removal (For 6000mAH Battery Version)

NOTE
After you remove the Front-Facing Camera Heat Spreader, you cannot reuse it.



Use the Plastic Tweezer to remove the Front-Facing Camera Heat Spreader from the location as shown.

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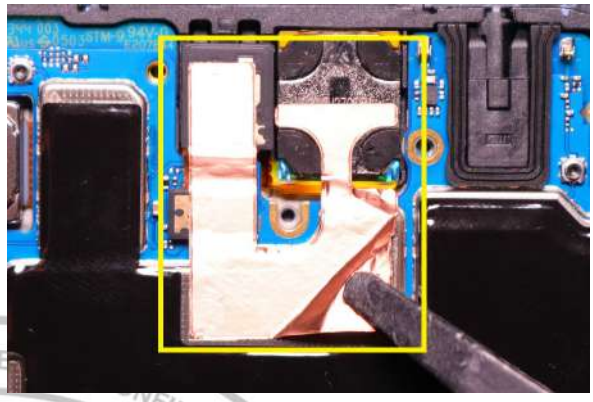
Front-Facing Camera Copper Foil Removal

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.

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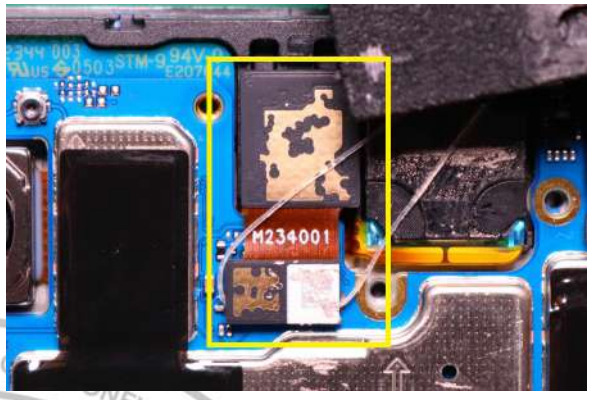
16M Front-Facing Camera Removal (For IN)

NOTE
The 16M Front-Facing Camera can be recovered and reused after removal.



Use the BtB Tool to remove the 16M Front-Facing Camera from the location as shown.

NOTE
The product offers two Front-Facing Camera specifications: 16M for India, and 8M for other regions.

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

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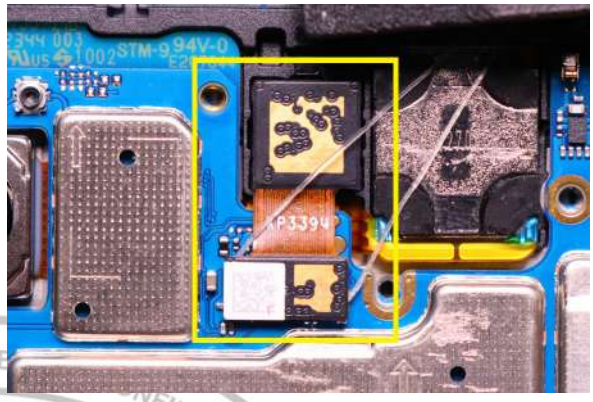
8M Front-Facing Camera Removal (For ROW)

NOTE
The 8M Front-Facing Camera can be recovered and reused after removal.



Use the BtB tool to disengage and remove the 8M Front-Facing Camera from the location as shown.

NOTE
The product offers two Front-Facing Camera specifications: 16M for India, and 8M for other regions.

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

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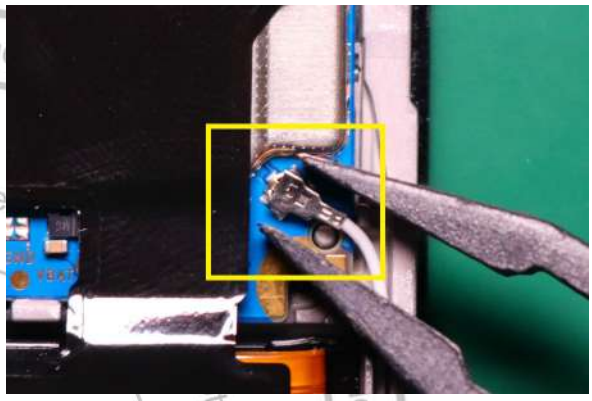
Main PCB Removal

NOTE
The Main PCB can be recovered and reused after removal.

WARNING
Before disassembling the Main PCB, double check to make sure the Sim Tray has been removed.

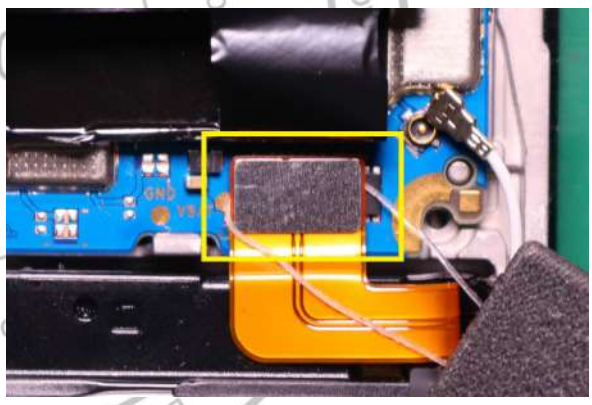
1. Use the Plastic Tweezer to disconnect the Coax Cable from the location as shown.

NOTE
Be careful to avoid damaging the BtB connector.

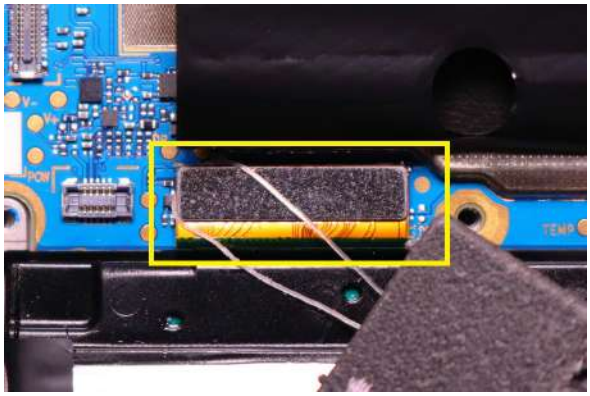


2. Use the BtB tool to disengage the Battery Flex BtB Connector from the Main PCB as shown.

NOTE
Be careful to avoid damaging the BtB connector.

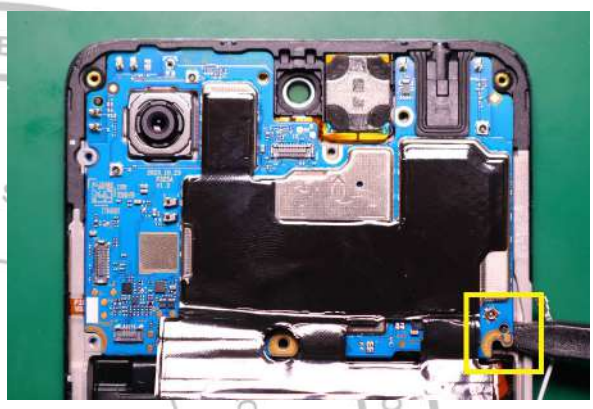


3. Use the BtB tool to disengage the LCD FPC BtB Connector from the Main PCB as shown.



WARNING
Be careful to avoid damaging the BtB connector.

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



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

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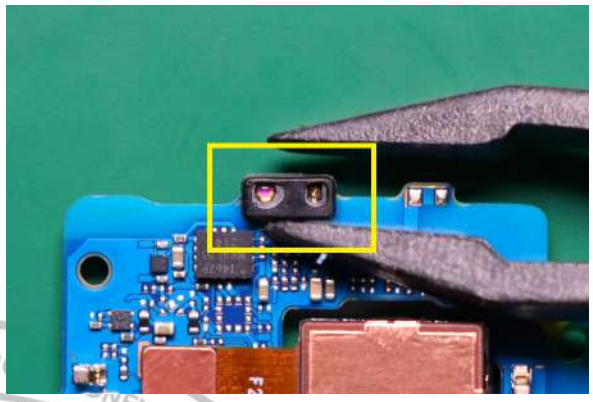
Proximity Sensor Grommet Removal

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.

WARNING
Do not against metal components on Main PCB with the Plastic Tweezer when disassembling in case of damage.

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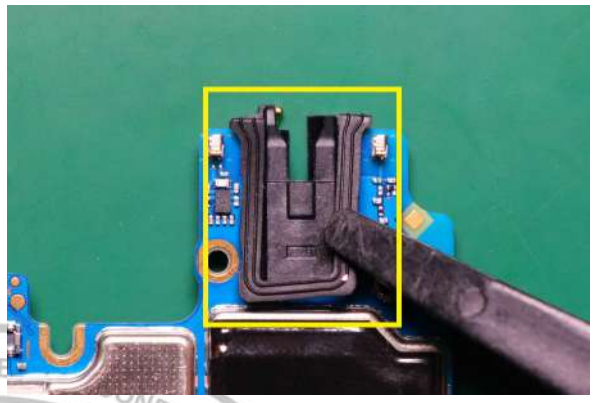
Audio Jack Grommet Removal

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

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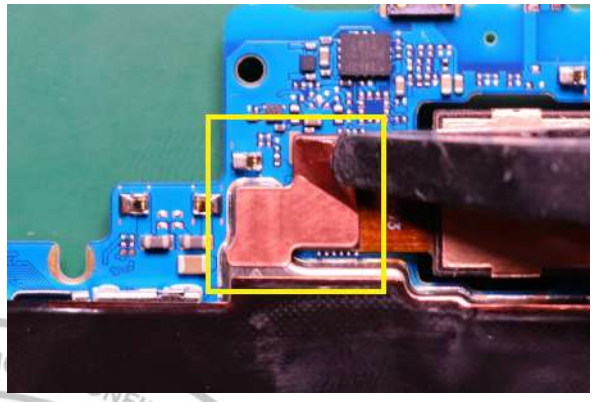
50M Rear-Facing Camera Copper Foil Removal

NOTE
After you remove the 50M Rear-Facing Camera Copper Foil, you cannot reuse it.



Use the Plastic Tweezer to remove the 50M Rear-Facing Camera Copper Foil from the location as shown.

NOTE
Do not against metal components on Main PCB with the Plastic Tweezer when disassembling in case of damage.

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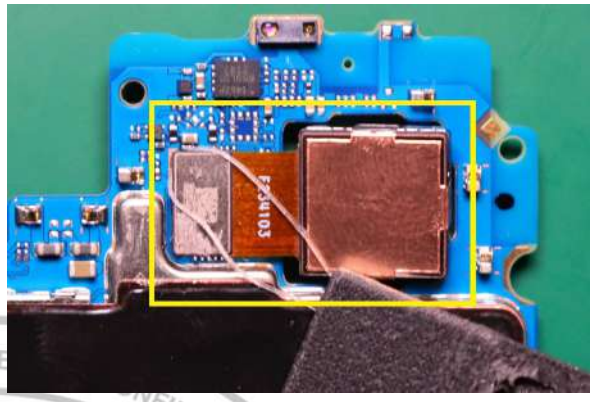
50M Rear-Facing Camera Removal

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 Rear-Facing Camera BtB connector.

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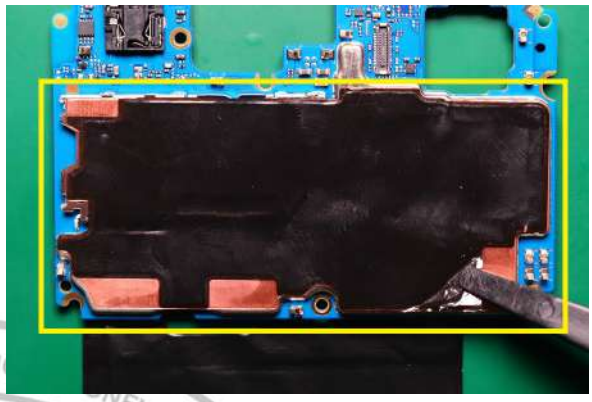
Main PCB Front Heat Spreader Removal (For IN & BR)



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

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

NOTE
Do not against metal components on Main PCB with the Plastic Tweezer when disassembling in case of damage.

NOTE
The Main PCB Front Heat Spreader is only for IN & BR.

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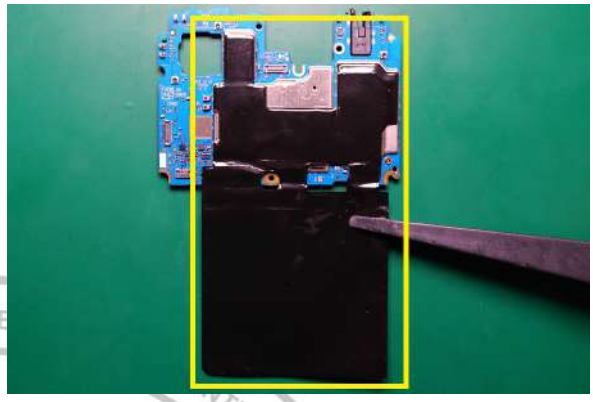
Main PCB Bottom Heat Spreader Removal (For 6000mAH Battery Version)



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

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

NOTE
Do not against metal components on Main PCB with the Plastic Tweezer when disassembling in case of damage.

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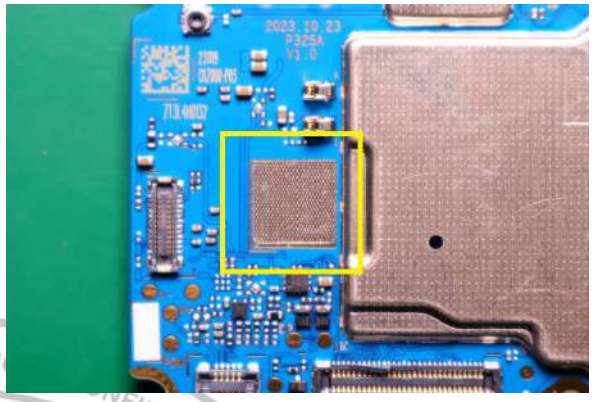
2M Macro Rear-Facing Camera Fabric Removal



NOTE
After you remove the 2M Macro Rear-Facing Camera Fabric, you cannot reuse it.

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

NOTE
Do not against metal components on Main PCB with the Plastic Tweezer when disassembling in case of damage.

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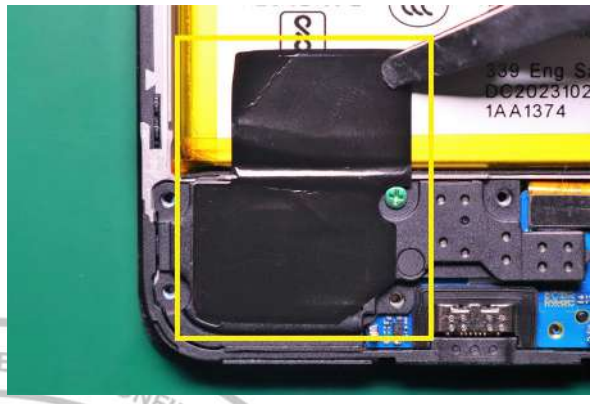
Speaker Box Heat Spreader Removal (For 5000mAH Battery Version)

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.

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Speaker Box Removal

NOTE
The Speaker Box can be recovered and reused after removal.

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

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

NOTE
Please keep the screw properly.

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

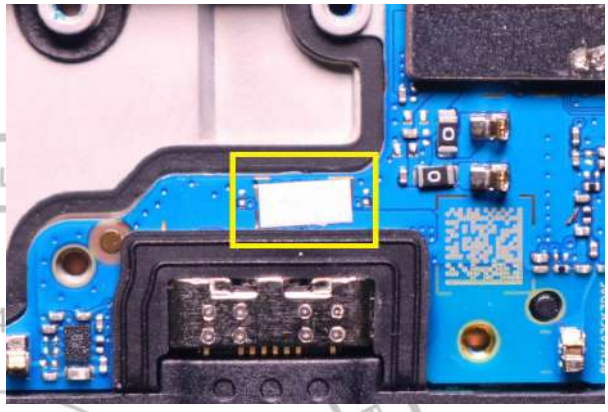
2. Use the pointed of the Black Stick to remove the Speaker Box from the location as shown.

NOTE
Be careful to avoid damaging the Speaker Box.

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 Sub Board for signs of activation.



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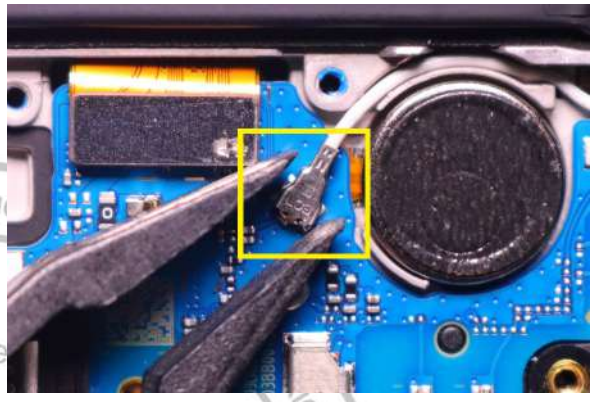
Sub Board Removal

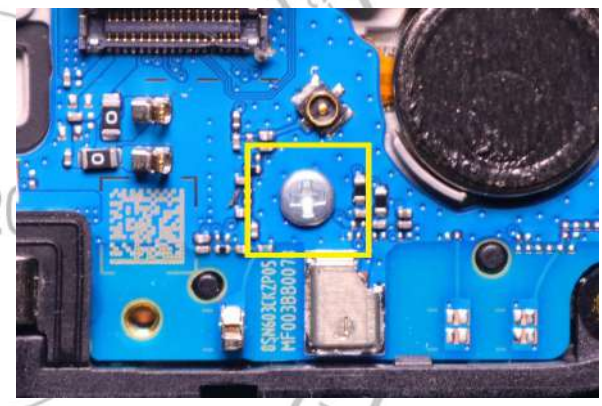
NOTE
The Sub Board can be recovered and reused after removal.

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



NOTE
Be careful to avoid damaging the Coax Cable.

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



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

NOTE
Please keep the screw properly.

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

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

NOTE
Be careful when disassembling to avoid damaging the Sub Board.

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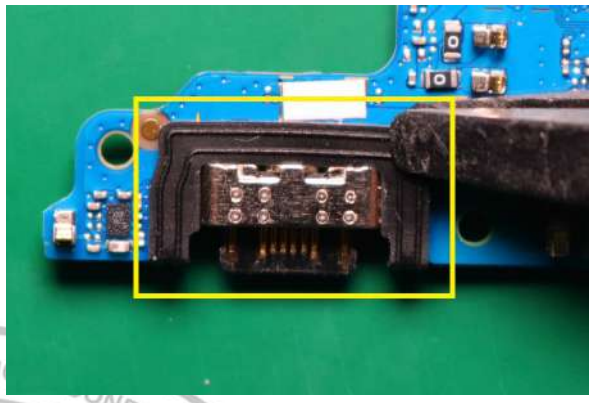
USB Grommet Removal

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.

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Coax Cable Removal

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

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

NOTE
Coax Cable cannot be reused in North America refurbish operation.

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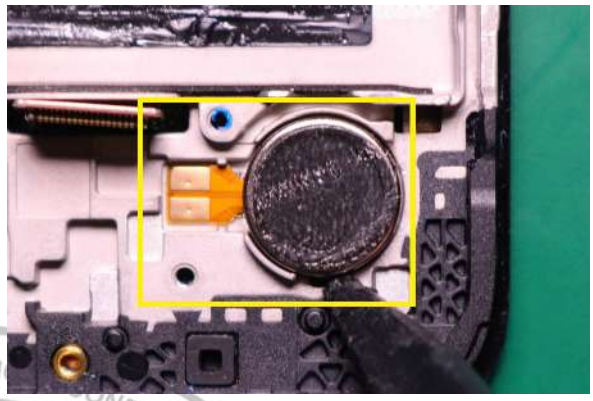
Vibrator Removal

NOTE
The Vibrator can be recovered and reused after removal.



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

NOTE
Be careful to avoiding damaging the Vibrator.

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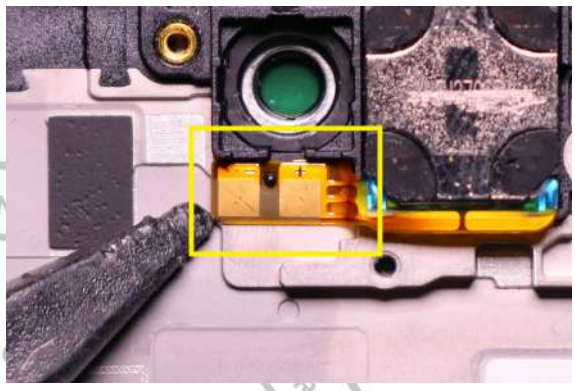
Receiver Removal

NOTE
After you remove the Receiver, you cannot reuse it.

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



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

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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.

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.

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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℃ 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.

4. Turn on the Freezing Separator.

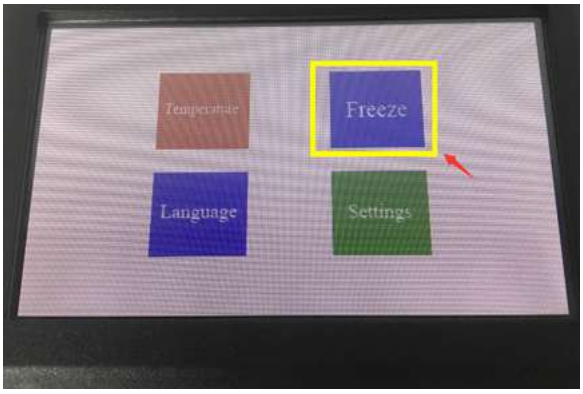
NOTE
The switch is on the back.

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

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

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

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

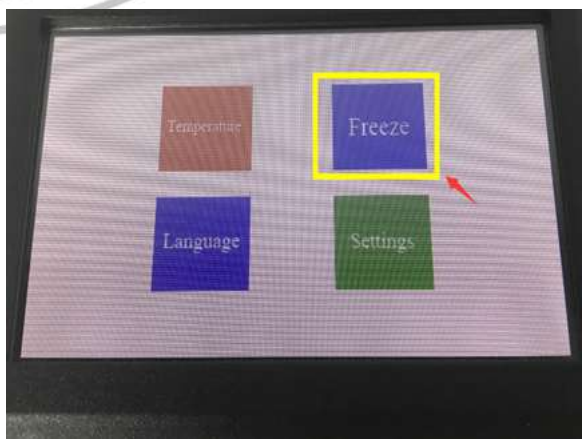


9. Verify the temperature reaches the setting value. When the temperature reaches -40 degrees, the compressor will stop, then open the door.

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

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

11. Click Freeze menu.



12. Click the start menu.

13. After clicking the Start menu, Start the countdown, and freeze it for 5 minutes. When the countdown time reaches, the device will alarm and ring three times.

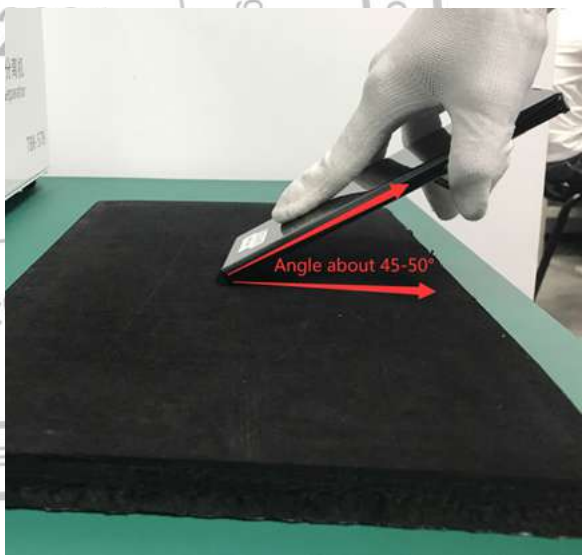
14. Open the door. Take out one Display at the time with wearing cotton gloves. Take out the Display in the order it was put in.

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

15. Remove the Battery.

16. Take out the frozen assembly from the bags.

17. Holding the Display place the Battery face down with the ESD sponge pad at an angle of about 45-50 degrees, and hit on the pad 3-4 times, the Battery will fall off automatically.

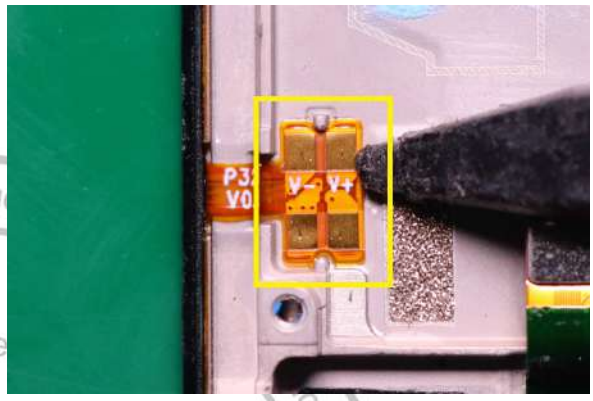


18. After the Battery removed. Immediately put the Batteries and Display into two different sealed bag and sealed into bags for temperature return.

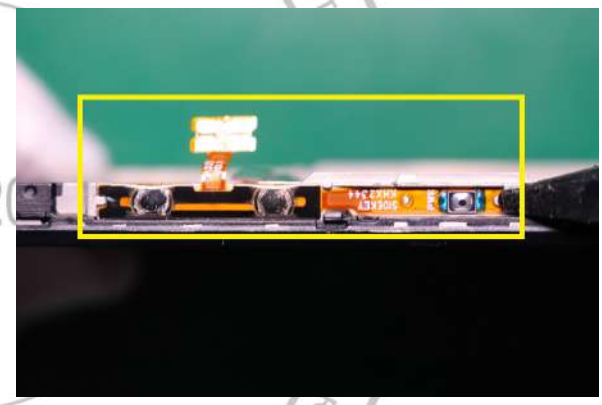
Side Key FPC Removal

NOTE
After you remove the Side Key FPC, you cannot reuse it.

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



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



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Chapter 4. Parts Refresh

Tools Required for Parts Refresh

The following tools are required for parts refresh of the moto g24 and moto g24 Power phone.

WARNING
Improper tools may cause damage to components.

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

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Battery Cover Cleaning (For 5000mAH Battery Version)

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.

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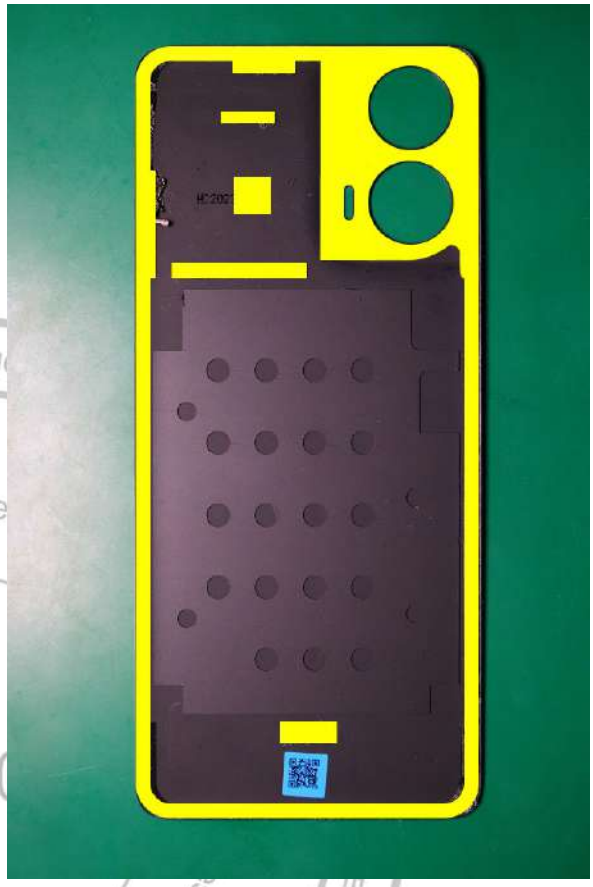
Battery Cover Cleaning (For 6000mAH Battery Version)

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.



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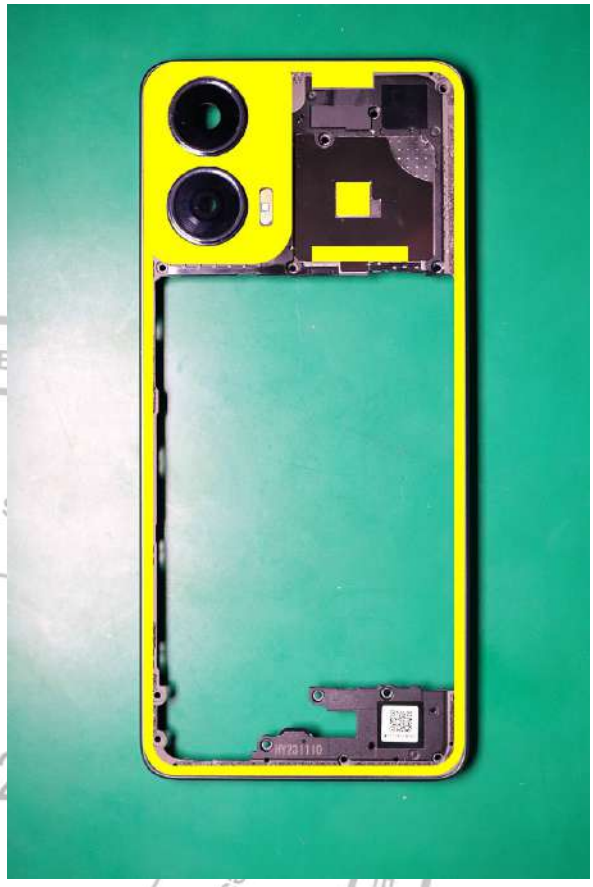
Middle Frame Cleaning (For 5000mAH Battery Version)

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



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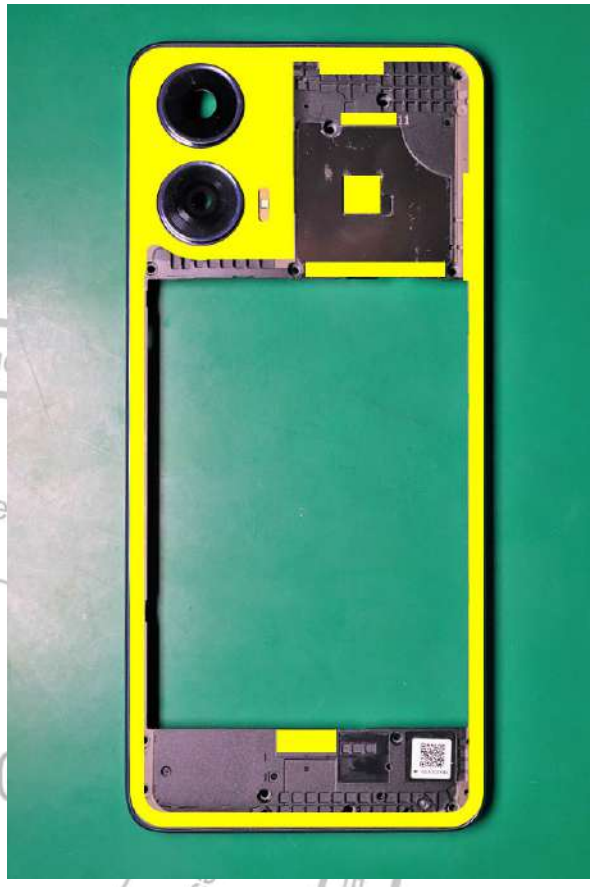
Middle Frame Cleaning (For 6000mAH Battery Version)

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



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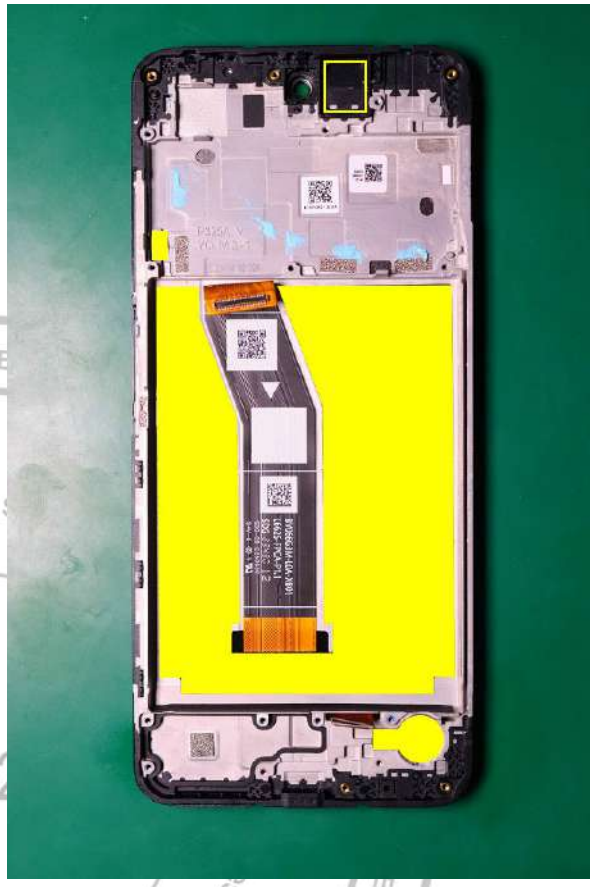
Front-Housing Cleaning

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



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Front-Housing Cleaning

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

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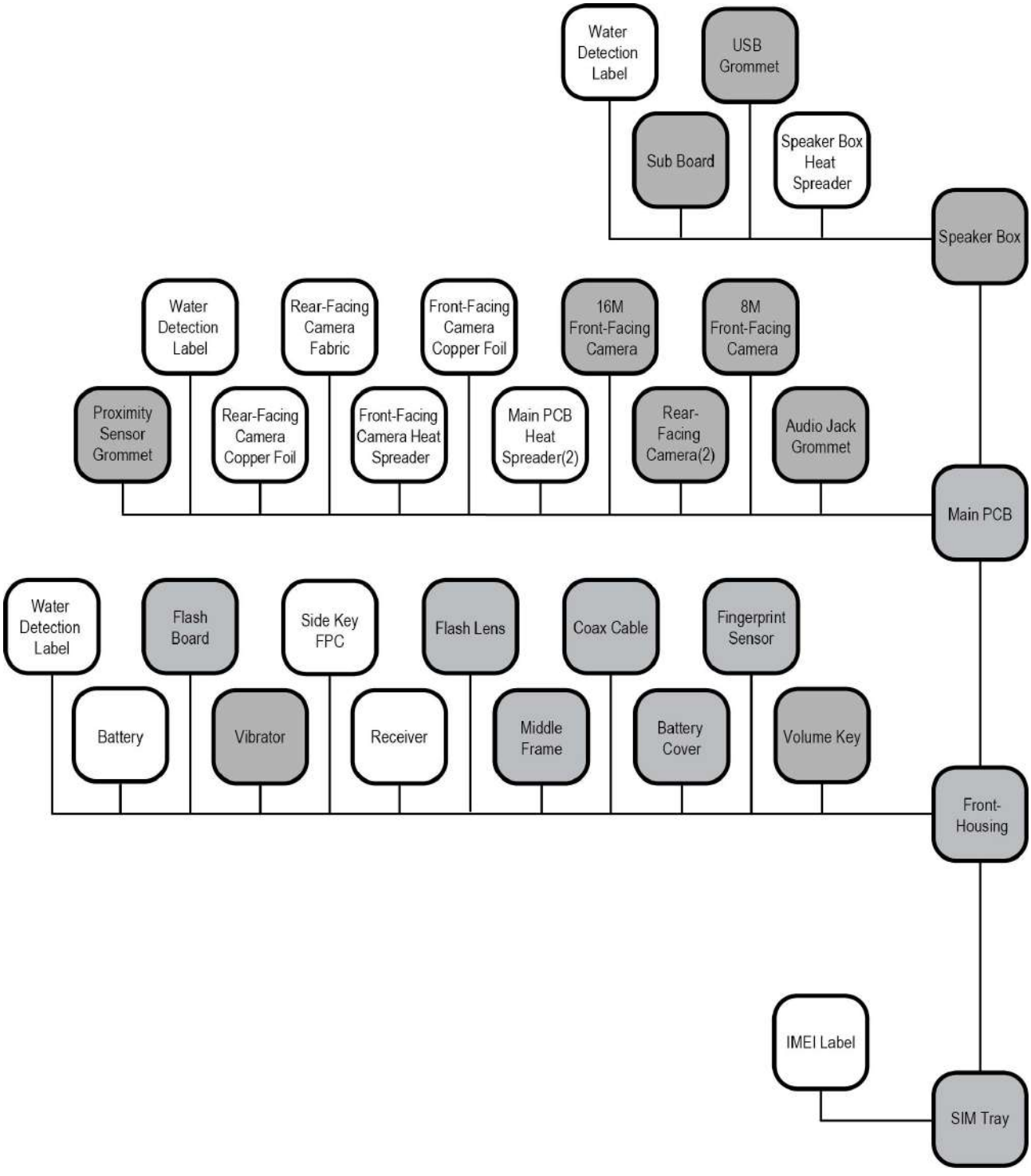
Chapter 5. Assembly

Assembly Map

*Shaded parts may be eligible for parts recovery



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Tools Required for Assembly

The following tools are required to assemble the moto g24 and moto g24 Power phone.

WARNING
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 (For 5000mAH Battery Version) Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-U9-10000	

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Description	Part #	Picture/Drawing
Inlay Adhesive Alignment (For 6000mAH Battery Version) Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-V2-10000	
Inlay Press - Holder with Pad Supplier: AMS Email: holger.grube@amsde.com https://amsde.com/en	1-00-V1-10000	
Manual Roller	--	
Plastic Tweezers	--	--
Tweezers	--	--
Gloves or Finger Collets	--	--

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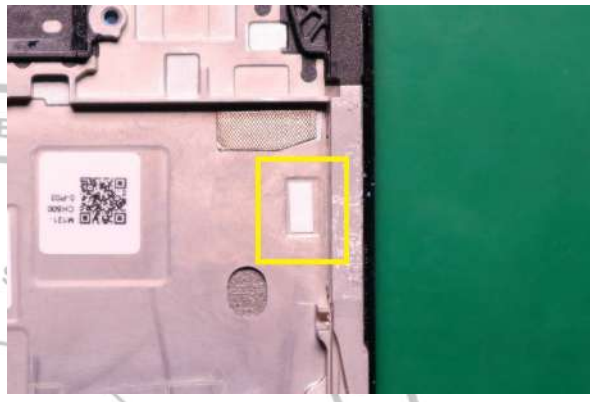
Water Detection Label Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
TNP316-CH1000-000+waterproof Label	-

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



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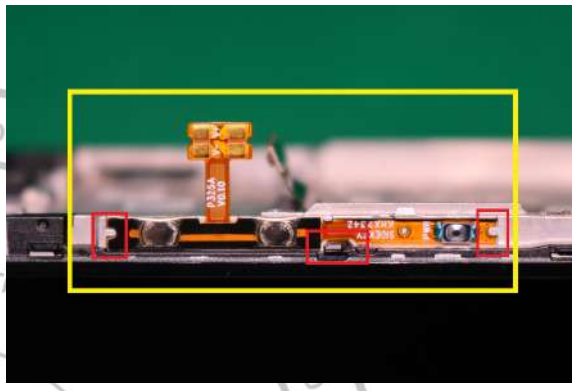
Side Key FPC Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
TNN802-CKZ000-010+FPC_Sidekey_KOX	16

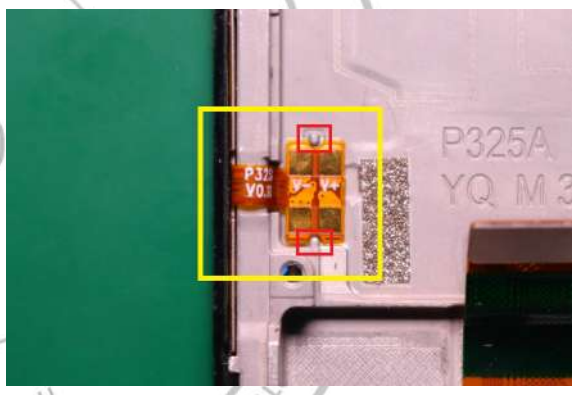
1. Use the Plastic Tweezer to place and secure the Side Key FPC on the location aligning with the pins as shown.



NOTE
The Side Key FPC should be pasted strictly in place. Improper installation will affect the volume key function.

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

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



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

Vibrator Adhesive Assembly

Description	Reference #
TNN901-CKZ000-000+Coin_Vibrator_HZF	17
XT2347 Motor Adhesive&M715-CJ8000-017	32

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

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

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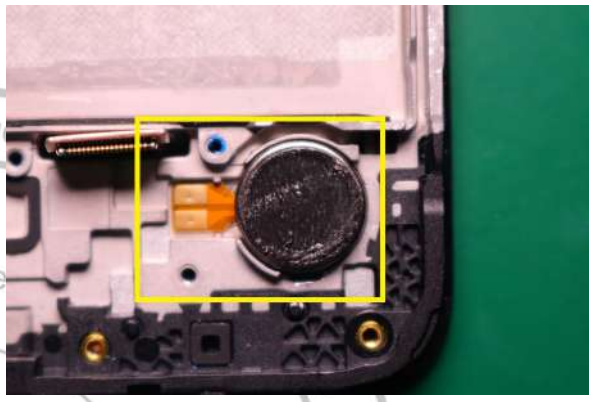
Vibrator Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
TNN901-CKZ000-000+Coin_Vibrator_HZF	17

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



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

WARNING
If the Vibrator, especially the FPC, is not well placed, the vibration performance of the phone will be impacted.

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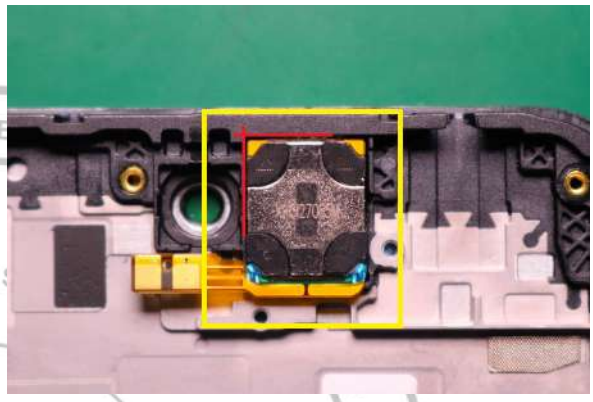
Receiver Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
TNN505-CKZ000-010+Receiver_HS	14

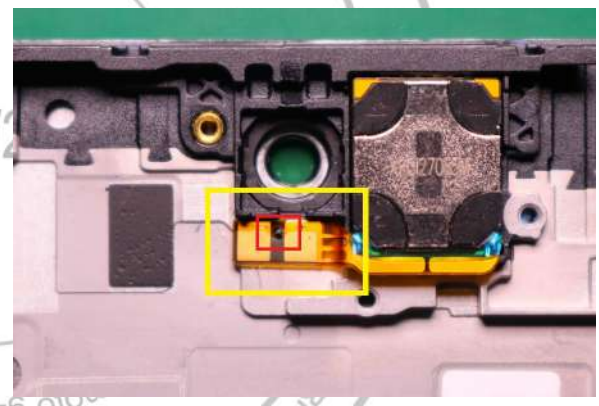
1. Use the Plastic Tweezer to place and secure the Receiver on the location as shown.



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

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

2. Use the Plastic Tweezer to place the Receive Flex on the location aligning with the pin as shown.



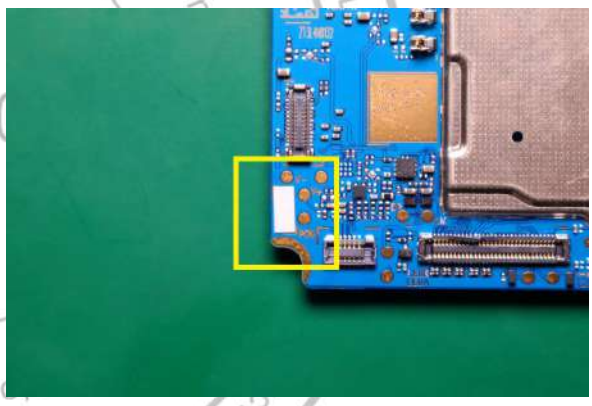
NOTE
Press firmly for seconds 3 times to activate the adhesive.

NOTE
Be careful to not damage the Receiver FPC.

Water Detection Label Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
TNP316-CH1000-000+waterproof Label	-

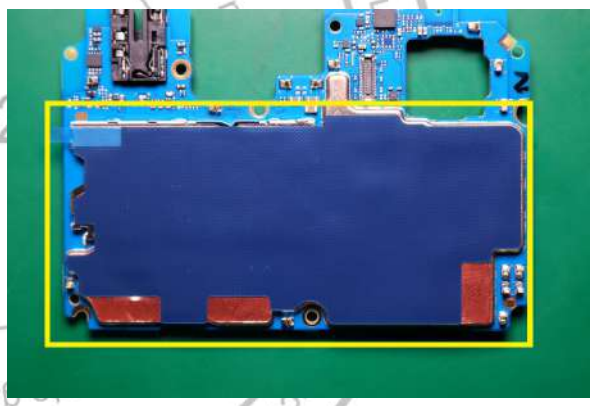
Use the Plastic Tweezer to place the Water Detection Label (WDL) on the Main PCB as shown.



Main PCB Top Heat Spreader Assembly (For IN & BR)

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
TNM721-CK5000-000+TOP Radiator_XDS	37

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



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

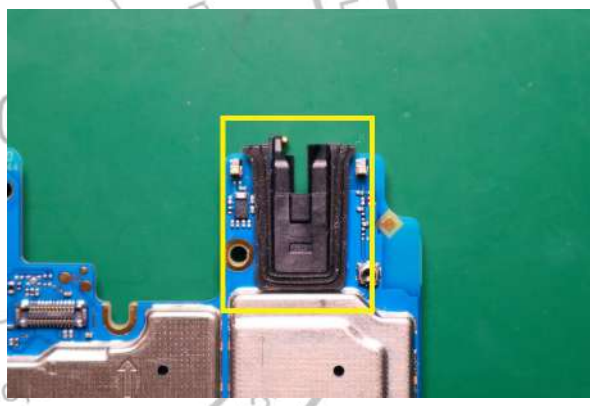
NOTE
Strictly follow the position shown in the figure for the assembly to ensure the best heat dissipation effect of the Main PCB area.

NOTE
The Main PCB Front Heat Spreader is only for IN & BR.

Audio Jack Grommet Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
TNM716-CKZ000-001+EAR silicone sleeve_EH	23

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

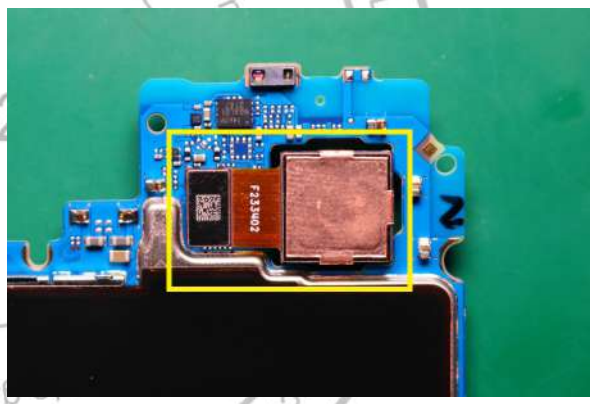


NOTE
Audio Jack Grommet cannot be installed backwards.

50M Rear-Facing Camera Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
MDL,CAMR,50M,rear,C2PA30;Q Tech,AF:Cancu	12

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



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

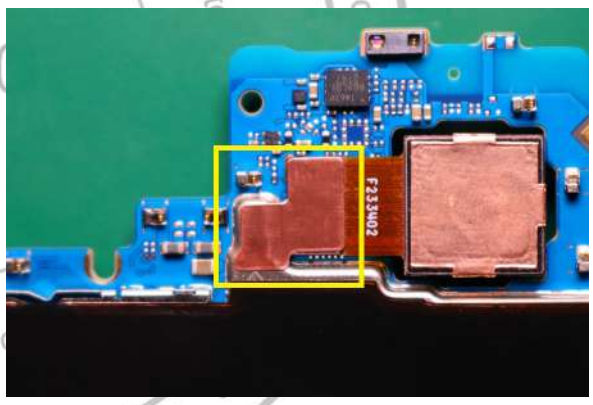
WARNING
If the camera is not assembled in place, the imaging function of phone may be affected.

50M Rear-Facing Camera Copper Foil Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
MDL,CAMR,50M,rear,C2PA30;Q Tech,AF:Cancu	12
TNM719-CKZ000-000+CON copper foil_KY	-

Use Plastic Tweezer to place and secure the 50M Rear-Facing Camera Copper Foil on the Main PCB as shown.

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

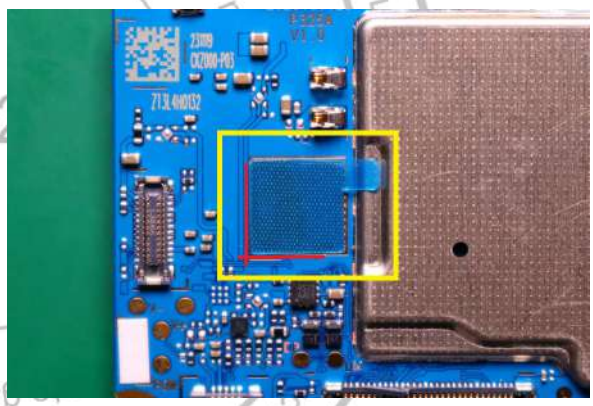


2M Macro Rear-Facing Camera Fabric Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
TNM717-CKZ000-000+Conductive Fabric_KY	-

Use Plastic Tweezer to place and secure the 2M Macro Rear-Facing Camera Fabric based on the golden area on the Main PCB as shown and peel off the liner.

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



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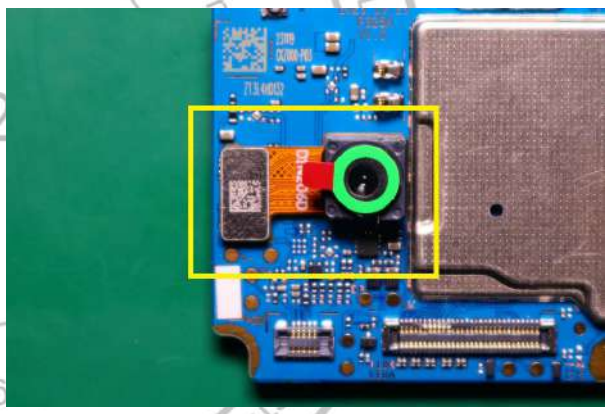
2M Macro Rear-Facing Camera Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
MDL,CAMR,2M,rear;D1N206D;SUNNY,FF:Cancun	11

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



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

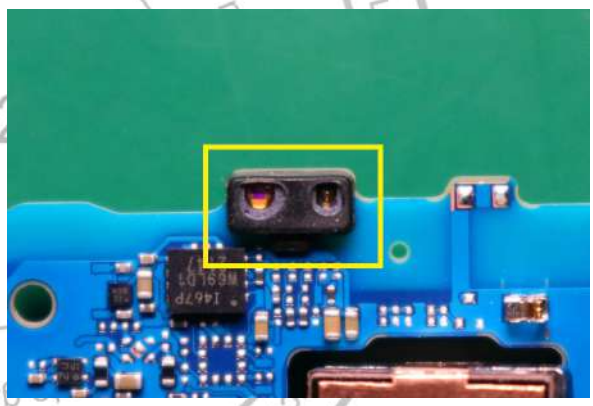
WARNING
If the camera is not assembled in place, the imaging function of phone may be affected.

Proximity Sensor Grommet Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
TNM716-CKZ000-003+silicone sleeve_EH	-

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

WARNING
If the Proximity Sensor Grommet is not assembled in place, the light sensing function of phone may be affected.



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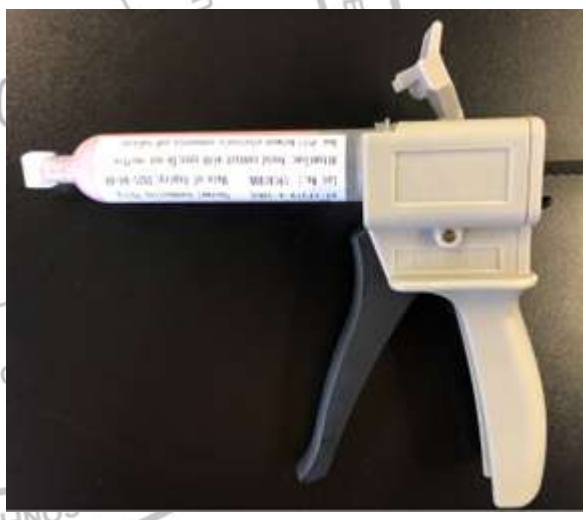
Thermal Gel Assembly

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

Thermal Gel Syringe size package and Needle Gauges description

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

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



3. Henkel LF350 30ml operate with dispensing tool.

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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

For 5000mAH Battery Version

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

NOTE
The assembly of thermal gel is crucial for the heat dissipation of the phone.

For 6000mAH Battery Version

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

NOTE
The assembly of thermal gel is crucial for the heat dissipation of the phone.

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Front-Housing Thermal Gel Assembly by Weight

For 5000mAH Battery Version

Add Thermal Conductive Gel (205±25mg) on the visual block as shown.
A : 100mg
B : 90mg
C : 15±5mg

WARNING
Excessive thermal gel may cause overflow, while too little may lead to a decrease in heat dissipation effect. Strictly follow the amount specified in the manual for assembly.

For 6000mAH Battery Version

Add Thermal Conductive Gel (235±25mg) on the visual block as shown.
A : 100±5mg
B : 90±5mg
C : 15±5mg
D: 10±5mg
E: 20±5mg

WARNING
Excessive thermal gel may cause overflow, while too little may lead to a decrease in heat dissipation effect. Strictly follow the amount specified in the manual for assembly.

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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

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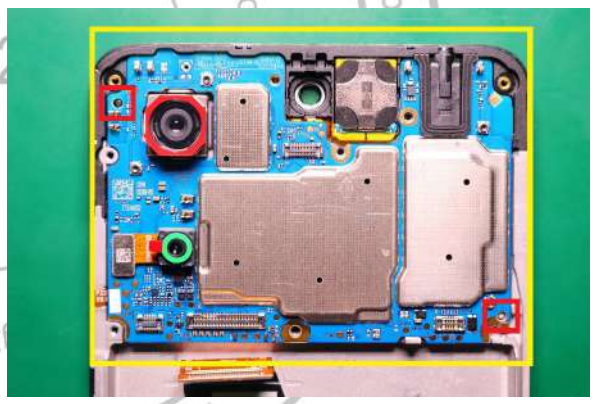
Main PCB Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2

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



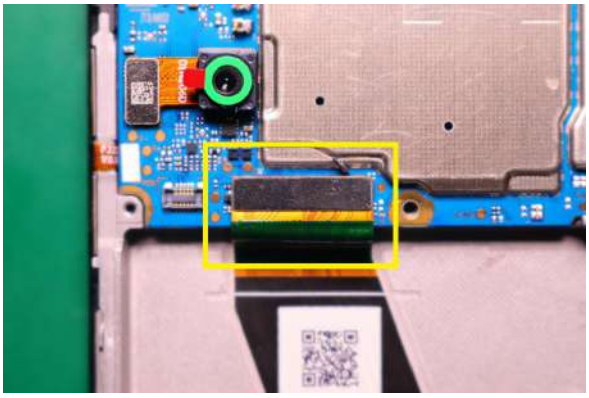
NOTE

Make sure that do not damage falling springs and other components on the Main PCB. Side Springs can not exceed the edge of the Front-Housing.

NOTE

Incline and insert the Main PCB into the Front-Housing.

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



WARNING
Please align the connector before securing to avoid damaging the contacts.

WARNING
If the Display Flex BtB connector is not secured in place, the usage of the display may be affected.

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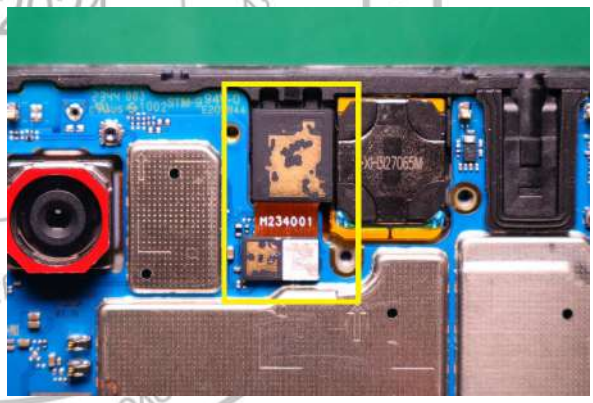
16M Front-Facing Camera Assembly (For IN)

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
MDL,CAMR,16M,front,C3EF01;Q Tech,FF:Saba	10

Use fingers to place and secure the 16M Front-Facing Camera on the location as shown.



NOTE

The product offers two Front-Facing Camera specifications: 16M for India, and 8M for other regions.

NOTE

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

WARNING

Align the connector before securing to avoid damaging the contacts.

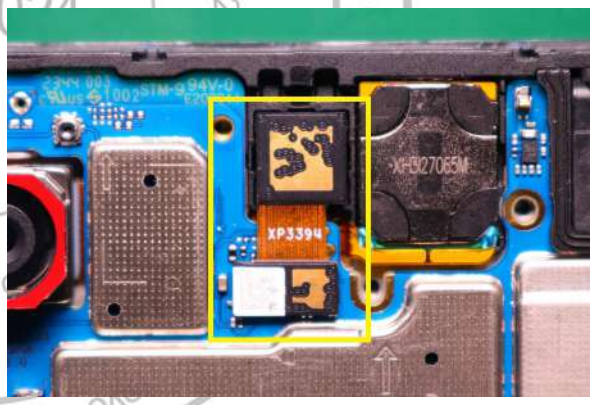
WARNING

If the Front-Facing Camera is not assembled in place, the imaging function of phone may be affected.

8M Front-Facing Camera Assembly (For ROW)

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
MDL,CAMR,8M,FRNT,SL08A1AB;Sunwin,FF:Fogo	10

Use fingers to place and secure the 8M Front-Facing Camera on the location as shown.



NOTE

The product offers two Front-Facing Camera specifications: 16M for India, and 8M for other regions.

NOTE

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

WARNING

Align the connector before securing to avoid damaging the contacts.

WARNING

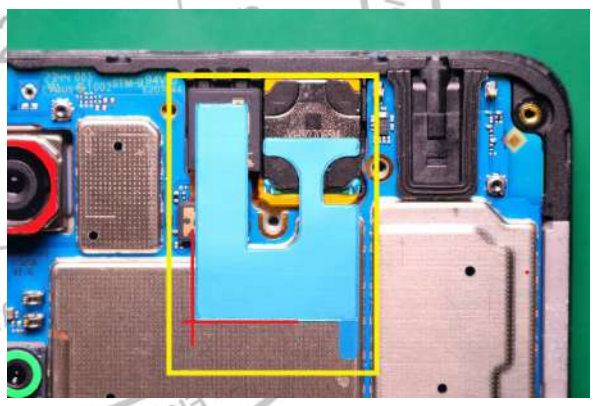
If the Front-Facing Camera is not assembled in place, the imaging function of phone may be affected.

Front-Facing Camera Copper Foil Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
MDL,CAMR,16M,front,C3EF01;Q Tech,FF:Saba MDL,CAMR,8M,FRNT,SL08A1AB;Sunwin,FF:Fogo	10
TNM719-CKZ000-001+CAM copper foil_KY	-

Use the Plastic Tweezer to place the Front-Facing Camera Copper Foil aligning with the positioning mark on the metal shield as shown and peel off the liner.

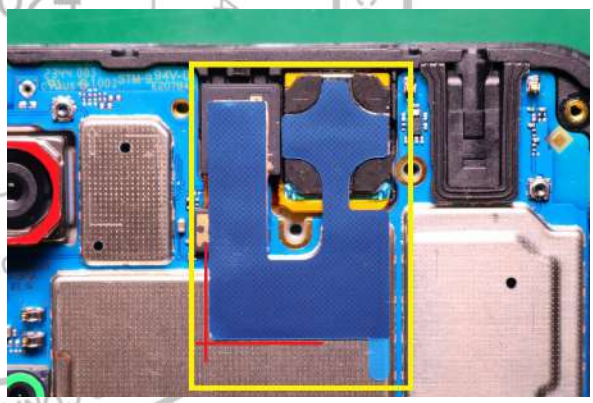
NOTE
Press firmly for seconds 3 times to activate the adhesive.



Front-Facing Camera Heat Spreader Assembly

Description	Reference #
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
MDL,CAMR,16M,front,C3EF01;Q Tech,FF:Saba MDL,CAMR,8M,FRNT,SL08A1AB;Sunwin,FF:Fogo	10
TNM721-CKZ001-006+C_R Radiator sheet_LS	34
TNM719-CKZ000-000+CON copper foil_KY	-

Use the Plastic Tweezer to place the Front-Facing Camera Heat Spreader based on the Copper Foil on the Main PCB as shown and peel off the liner.



NOTE
Strictly follow the position shown in the figure for the assembly to ensure the best heat dissipation effect of the Front-Facing Camera area.

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

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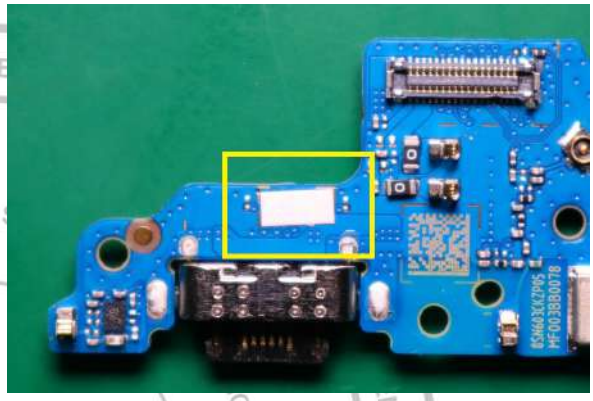
Water Detection Label Assembly

Description	Reference #
XT2423,SubBD,S102-CKZ000-000 XT2423-5,SubBD,JP,S102-CKZ002-000 ASSY,DTR BRD,Fogo4G 5000 BR PLT XT2425,SubBD,S102-CK5000-000 ASSY,DTR BRD,Fogo4G 6000 IN PLT	3
TNP316-CH1000-000+waterproof Label	-

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



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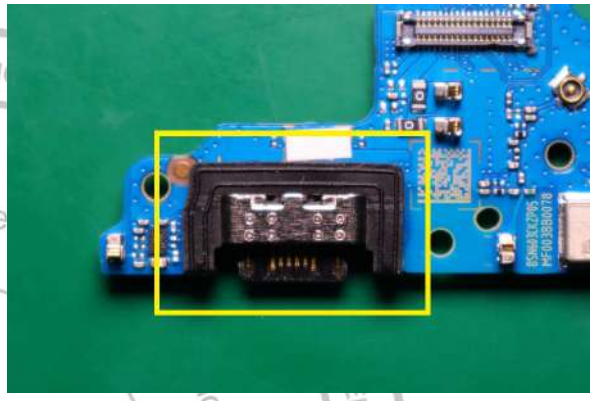
USB Grommet Assembly

Description	Reference #
XT2423,SubBD,S102-CKZ000-000 XT2423-5,SubBD,JP,S102-CKZ002-000 ASSY,DTR BRD,Fogo4G 5000 BR PLT XT2425,SubBD,S102-CK5000-000 ASSY,DTR BRD,Fogo4G 6000 IN PLT	3
TNM716-CKZ000-002+T-C silicone sleeve_EH	22

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



NOTE
USB Grommet cannot be installed backwards.

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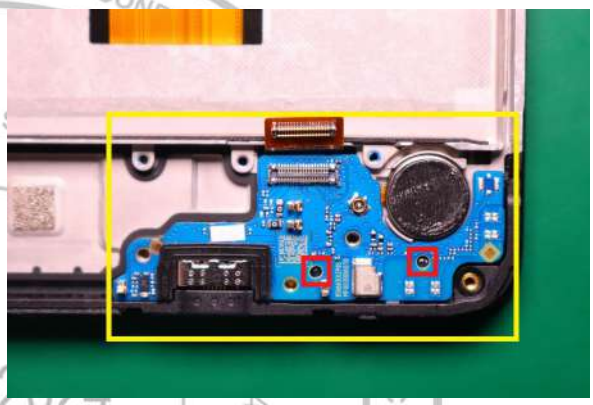
Sub Board Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423,SubBD,S102-CKZ000-000 XT2423-5,SubBD,JP,S102-CKZ002-000 ASSY,DTR BRD,Fogo4G 5000 BR PLT XT2425,SubBD,S102-CK5000-000 ASSY,DTR BRD,Fogo4G 6000 IN PLT	3
TNM501-211103-011+round head screw	-

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



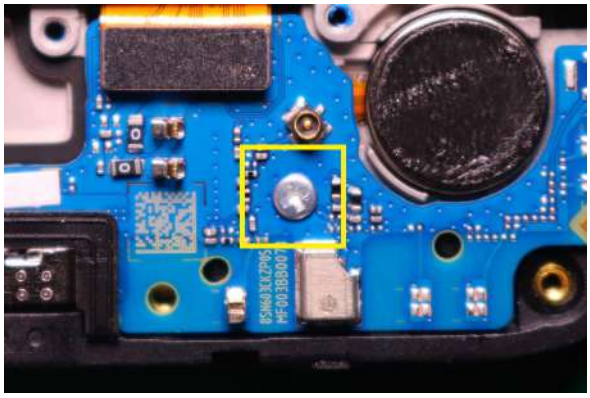
NOTE

Make sure that do not damage falling springs and other components on the Sub Board. Side Springs can not exceed the edge of the Front-Housing.

NOTE

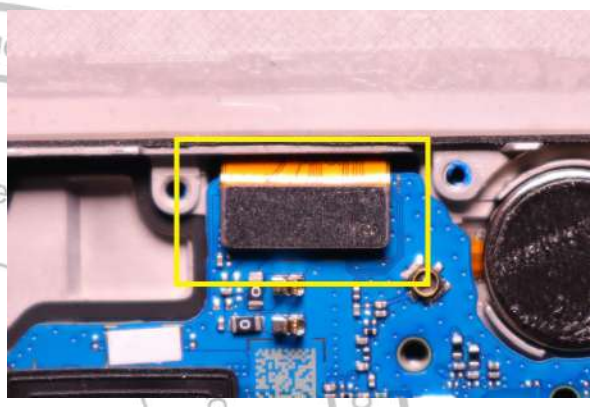
Incline and insert the Sub Board to the Front-Housing.

2. Use Torque Driver with PH00 Bit to tighten the screw as shown (0.7±0.1 kgf-cm).



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

3. Use fingers to place the LCD FPC BtB connector on the Sub Board as shown.



WARNING
Align the connector before securing to avoid damaging the contacts.

WARNING
If the Display Flex BtB connector is not secured in place, the usage of the display may be affected.

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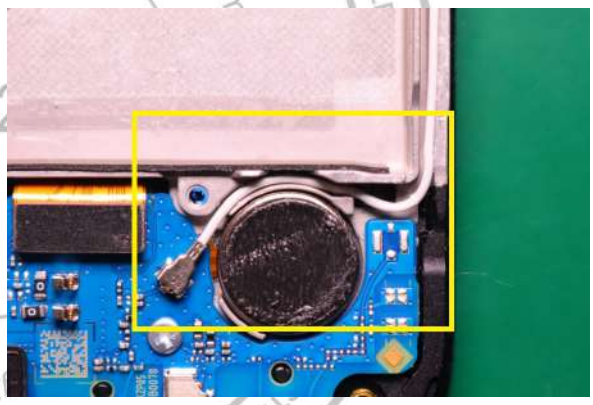
Coax Cable Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2413-2,MB,4+64 SS,RTL CS XT2413-2,MB,4+64 SSL,CC CS XT2413-2,MB,4+64 SSL,CMCT CS XT2413-2,MB,4+64 SSL,Spectrum CS XT2413-2,MB,4+64 SSL,DISH CS XT2413V,MB,4+64 SSL,VZW CS XT2413V,MB,4+64 SSL,TF CS XT2413-3,MB,4+64 SSL,ATT CS XT2413-1,MB,4+64 SSL,CKT CS	2
XT2423,SubBD,S102-CKZ000-000 XT2423-5,SubBD,JP,S102-CKZ002-000 ASSY,DTR BRD,Fogo4G 5000 BR PLT XT2425,SubBD,S102-CK5000-000 ASSY,DTR BRD,Fogo4G 6000 IN PLT	3
TNEI06-818026-002+RF cabel_white_DL	18

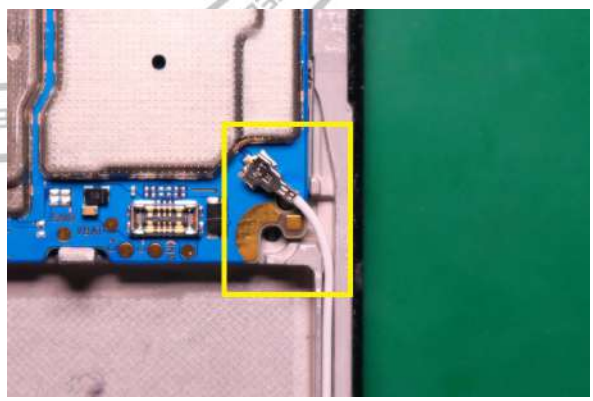
1. Use fingers to secure the Coax Cable on the Sub Board and arrange the cable aligning with the cable groove as shown.



NOTE
Make sure the cable is placed into the cable groove.

WARNING
The metal joint part is easily deformed, please align the connector before securing to avoid damaging the contacts.

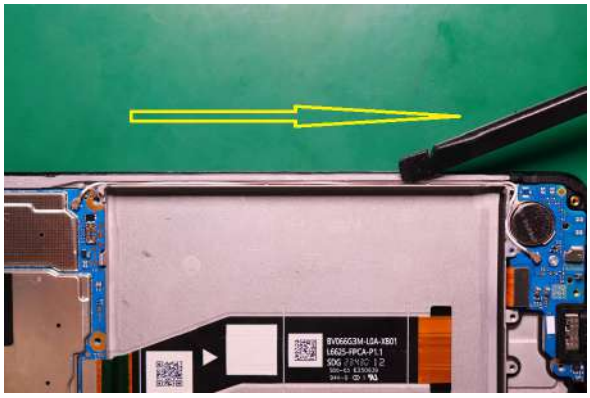
2. Use the fingers to place the Coax Cable on the Main PCB as shown.



NOTE
Make sure the metal ring is placed into the mounting slot.

WARNING
The metal joint part is easily deformed, please align the connector before securing to avoid damaging the contacts.

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



WARNING
If the Coax Cable is not assembled in place, the signal of phone may be affected.

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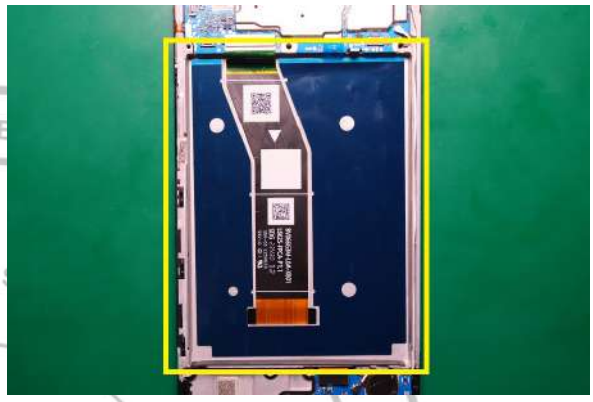
Battery Adhesive Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
TNM715-CKZ000-006+BAT Adhesive_KY	24

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



NOTE

Make sure no wrinkles form when applying the adhesive in the location.

NOTE

Press firmly for seconds 3 times to activate the adhesive.

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Battery Assembly (For 5000mHA Battery Version)

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
ACCY,BAT,5000mAh,QF50,ATL436590,ATL	13

/// 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.

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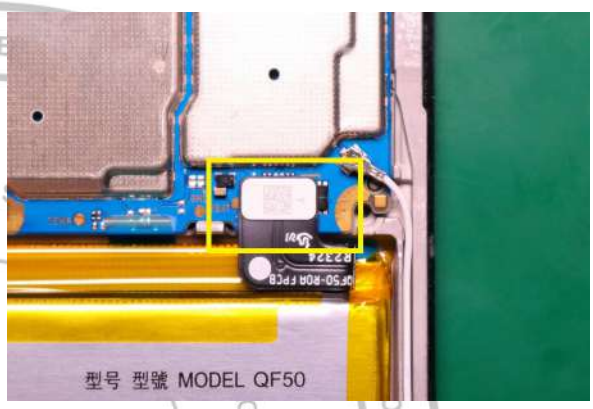
1. Use fingers to place and secure the Battery on the location as shown.

NOTE
5000mHA battery is used for XT2423-X.

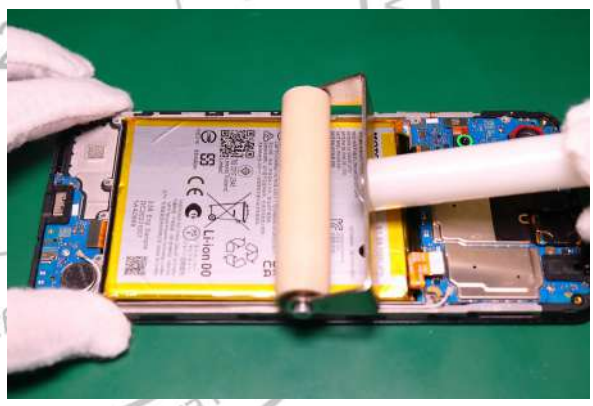
2. Use fingers to place and secure Battery BtB Connector on the location as shown.



WARNING
Align the connector before securing to avoid damaging the contacts.

WARNING
If the Battery connectors are not secured in place, the phone may not turn on properly.

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.

Battery Assembly (For 6000mHA Battery Version)

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
ACCY,BAT,6000mAh,PC60,ATL536589,ATL,WW	13

/// 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.

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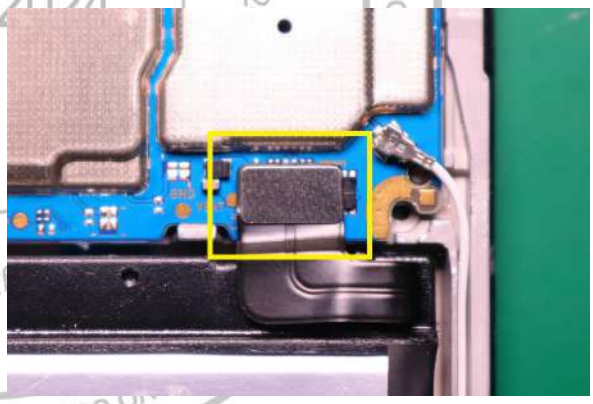
1. Pre-bend the 6000mAH Battery Flex as shown.

NOTE
6000mHA battery is used for XT2425-X.

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

NOTE
Make sure to locate the Battery using the bottom left corner of the Battery compartment as marked in red.

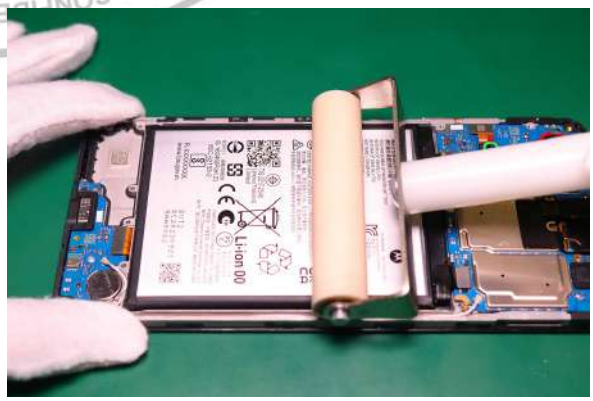
3. Use fingers to place and secure Battery BtB Connector on the location as shown.



WARNING
Align the connector before securing to avoid damaging the contacts.

WARNING
If the Battery connectors are not secured in place, the phone may not turn on properly.

4. 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 #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
TNN501-CKZ000-010+Speaker_HS	15
TNM501-211103-059+round head screw1_LJT	21

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

NOTE
Make sure to incline the Speaker Box while inserting onto the Front-Housing.

2. Use Torque Driver with PH00 Bit to tighten the green screw as shown (0.8±0.1 kgf-cm).

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

Main PCB Bottom Heat Spreader Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2
TNM721-CKZ001-018bot Radiator sheet_LS	35

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

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

NOTE
Strictly follow the position shown in the figure for the assembly to ensure the best heat dissipation effect of the Main PCB area.

Flash Board Adhesive Assembly

Description	Reference #
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
XT2423,ADH,Flash,M715-CKZ000-003	31

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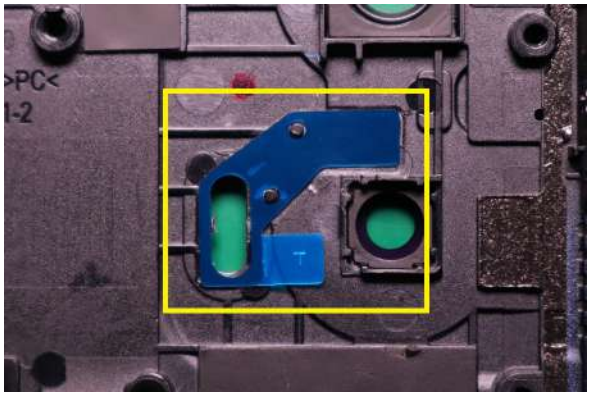
Use the Plastic Tweezer to place the Flash Board Adhesive on the Middle Frame as shown and peel off the liner.



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

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Flash Board Assembly

Description	Reference #
XT2423,FLSH BD,S102-CKZ001-000 ASSY,DTR BRD,Fogo4G 5000 BR IN FLB PLT	4
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6

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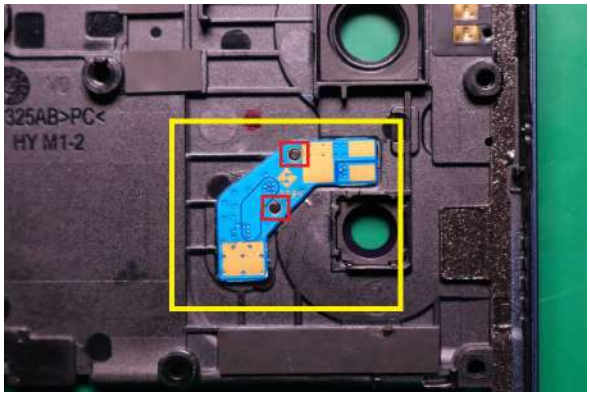
Use the Plastic Tweezer to place the Flash Board on the Middle Frame aligning with the pins as shown.



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

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Fingerprint Sensor Assembly

Description	Reference #
XT2423,FPS,GRY,S108-CKZ080-000 XT2423,FPS,GRN,S108-CKZ030-000 XT2423,FPS,PNK,S108-CKZ100-000 XT2425,FPS,CB,S106-CK5020-000 XT2425,FPS,SS,S106-CK5060-000	5
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6

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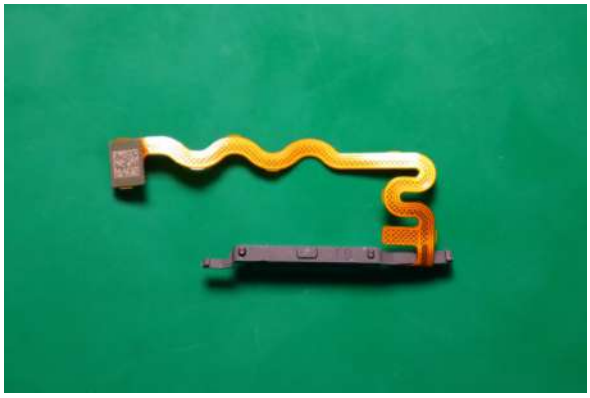
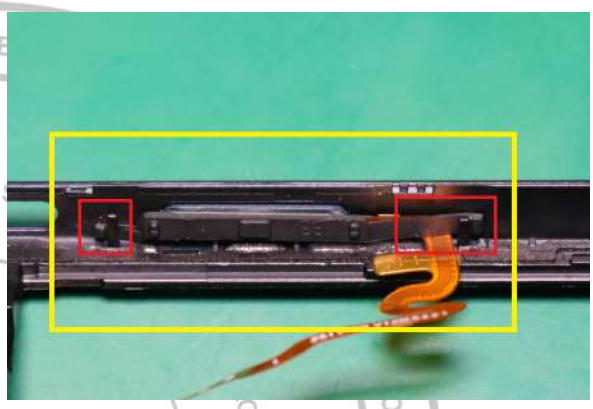
1. Use fingers to pre-bend the Fingerprint Sensor FPC as shown.



2. Use fingers to place the Fingerprint Sensor on the location as shown.



NOTE
The Fingerprint Sensor lugs cannot be exceeded the Middle Frame limit slot.

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

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Volume Key Assembly

Description	Reference #
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
TNM305-CKZ080-000+Volume Key Grey_EH TNM305-CKZ030-000+Volume GRN TNM305-CKZ100-000+Volume PNK TNM305-CKZ081-000+Vol Key GRY_HRD_JP TNM305-CKZ031-000+Vol Key GRN_EH_JP TNM305-CKZ020-000+Volume Key Blue_EH TNM305-CKZ060-000+Volume SaltW	8

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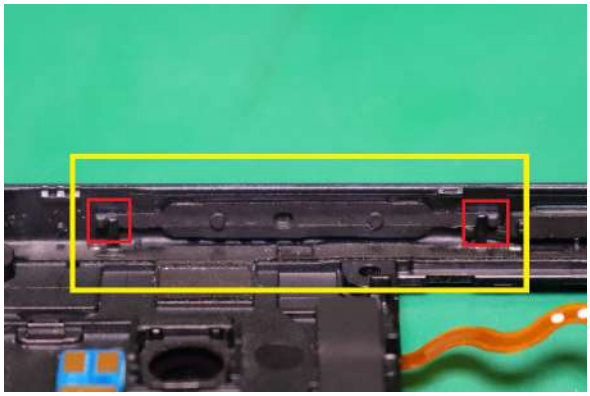
Use the Plastic Tweezer to place the Volume Key on the location as shown.



NOTE
The Volume Key lugs cannot be exceeded the Middle Frame limit slot.

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

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Middle Frame Assembly (For 5000mAH Battery Version)

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100	6
TNM501-211105-027+round head screw_LJT	20

1. Use fingers to secure the Fingerprint Sensor Flex BtB connector on the location and remove the Rear- Facing camera protective covers as shown.

2. Use fingers to place the Middle Frame on the location as shown.

NOTE
To secure the Middle Frame, proceed in the following order: start from the bottom, then the side key position, then the middle area and right side, and finally the top.

NOTE
Make sure all the buckles are snapped in place.

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3. Use Torque Driver with PH00 Bit to tighten the 16 screws as shown (0.8±0.1 kgf-cm).

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

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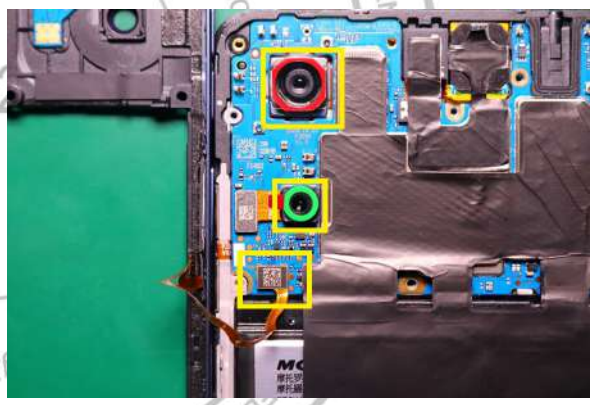
Middle Frame Assembly (For 6000mAH Battery Version)

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
TNM501-211105-027+round head screw_LJT	20

1. Use fingers to secure the Fingerprint Sensor Flex BtB connector on the location and remove the Rear- Facing camera protective cover as shown.



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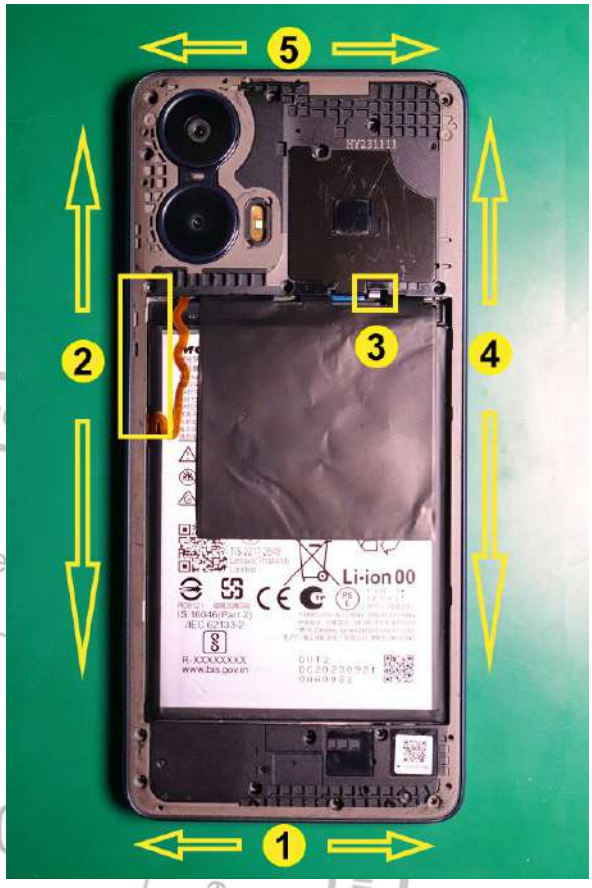
2. Use fingers to place the Middle Frame on the location as shown.



NOTE
To secure the Middle Frame, proceed in the following order: start from the bottom, then the side key position, then the middle area and right side, and finally the top.

NOTE
Make sure all the buckles are snapped in place.

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3. Use Torque Driver with PH00 Bit to tighten the 16 screws as shown (0.8±0.1 kgf-cm).

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

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Middle Frame-NFC Zone Adhesive Assembly

Description	Reference #
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
TNM715-CKZ001-004+Adhesive_XHT	25

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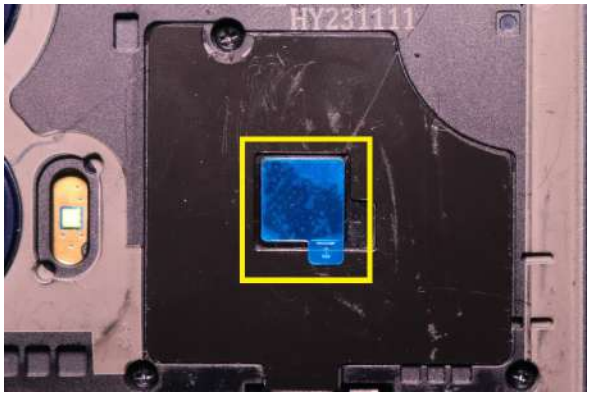
Use the Plastic Tweezer to place the Middle Frame-NFC Zone Adhesive on the Middle Frame as shown and peel off the liner.



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

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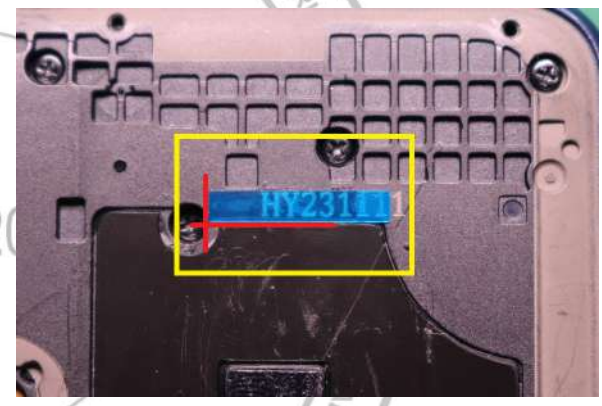
Inlay Anti-shock Top Adhesive Assembly (For 6000mAH Battery Version)

Description	Reference #
XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
XT2425,ADH,Inlay,top,M715-CK5000-000	27

Use the Plastic Tweezer to place the Inlay Anti-shock Top Adhesive based on the positioning mark on the Middle Frame as shown and peel off the liner.

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

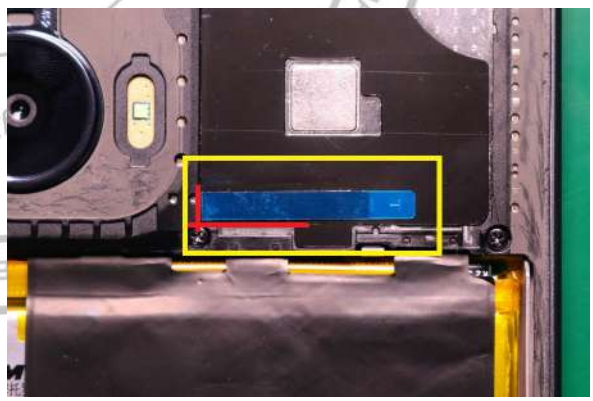


Inlay Anti-shock Bottom Adhesive Assembly (For 5000mAH Battery Version)

Description	Reference #
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100	6
XT2423,ADH,Inlay,btm,M715-CKZ000-008	29

Use the Plastic Tweezer to place the Inlay Anti-shock Bottom Adhesive based on the positioning mark on the Middle Frame as shown and peel off the liner.

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



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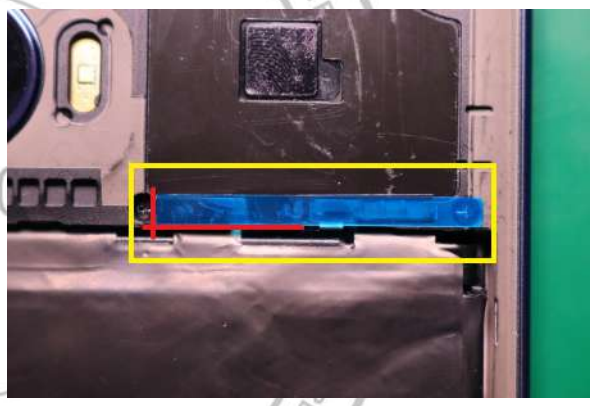
Inlay Anti-shock Bottom Adhesive Assembly (For 6000mAH Battery Version)

Description	Reference #
XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
XT2425,ADH,inlay,btm,M715-CK5000-001	28

Use the Plastic Tweezer to place the Inlay Anti-shock Bottom Adhesive based on the positioning mark on the Middle Frame as shown and peel off the liner.

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



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Inlay Small Adhesive Assembly (For 5000mAH Battery Version)

Description	Reference #
XT2423,MIDFM,GRY,ETCH,BR,S101-CKZ082-100 XT2423,MIDFM,GRN,ETCH,BR,S101-CKZ032-100 XT2423,MIDFM,PNK,ETCH,BR,S101-CKZ102-100 XT2423,MIDFRM,GRY,S101-CKZ080-100 XT2423,MIDFRM,GRN,S101-CKZ030-100 XT2423,MIDFRM,PNK,S101-CKZ100-100 XT2423,MIDFRM,NFC,GRY,S101-CKZ081-100 XT2423,MIDFRM,NFC,GRN,S101-CKZ031-100 XT2423,MIDFRM,NFC,PNK,S101-CKZ101-100 XT2423-5,MIDFRM,NFC,GRY,JP,S101-CKZ084-100 XT2423-5,MIDFRM,NFC,GRN,JP,S101-CKZ034-100 XT2423,MIDFM,GRY,ETCH,LA,S101-CKZ083-100 XT2423,MIDFM,GRN,ETCH,LA,S101-CKZ033-100 XT2423,MIDFM,PNK,ETCH,LA,S101-CKZ103-100 XT2423,MIDFM,GRY,ETCH,EU,S101-CKZ089-100 XT2423,MIDFM,GRN,ETCH,EU,S101-CKZ039-100 XT2423,MIDFM,PNK,ETCH,EU,S101-CKZ109-100 XT2423,MIDFM,GRY,ETCH,RS,S101-CKZ085-100 XT2423,MIDFM,GRN,ETCH,RS,S101-CKZ035-100 XT2423,MIDFM,PNK,ETCH,RS,S101-CKZ105-100 XT2423,MIDFM,GRY,ETCH,TN,S101-CKZ086-100 XT2423,MIDFM,GRN,ETCH,TN,S101-CKZ036-100 XT2423,MIDFM,PNK,ETCH,TN,S101-CKZ106-100 XT2423,MIDFM,GRY,ETCH,AU,S101-CKZ087-100 XT2423,MIDFM,GRN,ETCH,AU,S101-CKZ037-100 XT2423,MIDFM,PNK,ETCH,AU,S101-CKZ107-100	6
XT2423,ADH,Inlay,Small,M715-CKZ000-002	26

Use the Plastic Tweezer to place the Inlay Small Adhesive based on the positioning mark on the Middle Frame as shown and peel off the liner.

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

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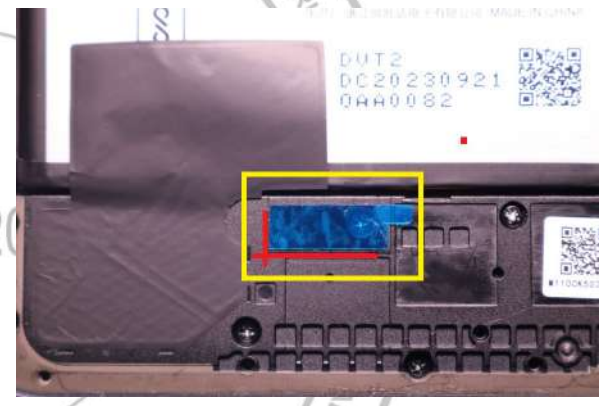
Inlay Small Adhesive Assembly (For 6000mAH Battery Version)

Description	Reference #
XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
XT2423,ADH,Inlay,Small,M715-CKZ000-002	26

Use the Plastic Tweezer to place the Inlay Small Adhesive based on the positioning mark on the Middle Frame as shown and peel off the liner.

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



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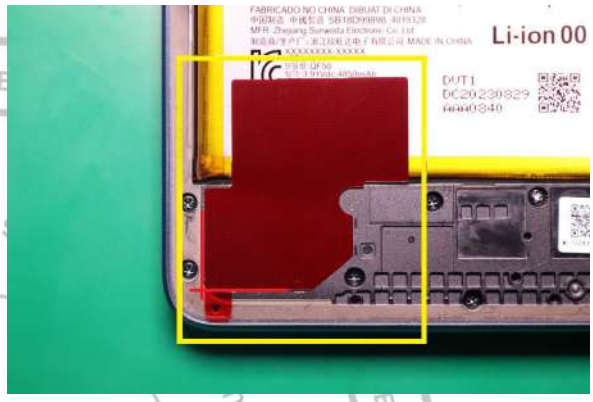
moto g24 series

Speaker Box Heat Spreader Assembly (For 5000mAH Battery Version)

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
TNN501-CKZ000-010+Speaker_HS	15
TNM721-CKZ001-007+SPK Radiator sheet_LS	36

Use the Plastic Tweezer to place the Speaker Box Heat Spreader aligning with the positioning mark and peel off the liner.



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

WARNING
Strictly follow the position shown in the figure for the assembly to ensure the best heat dissipation effect.

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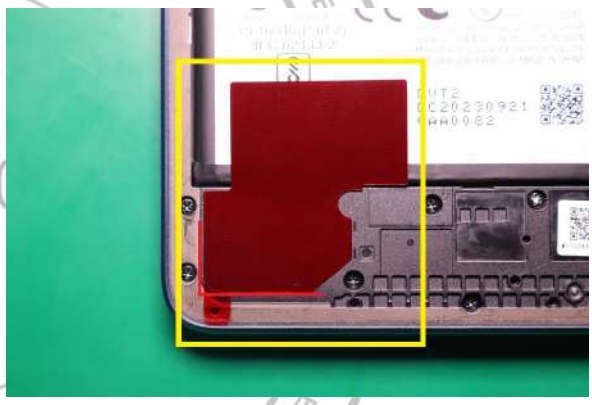
Speaker Box Heat Spreader Assembly (For 6000mAH Battery Version)

Description	Reference #
XT2425,MIDFRM,CB,8M,S101-CK5020-100 XT2425,MIDFRM,SS,8M,S101-CK5060-100 XT2425,MIDFRM,CB,8M,NFC,S101-CK5021-100 XT2425,MIDFRM,SS,8M,NFC,S101-CK5061-100 XT2425,MIDFRM,CB,16M,S101-CK5022-100 XT2425,MIDFRM,SS,16M,S101-CK5062-100 XT2425,MIDFM,CB,ETCH,LA,S101-CK5023-100 XT2425,MIDFM,SS,ETCH,LA,S101-CK5063-100 XT2425,MIDFM,CB,ETCH,EU,S101-CK5024-100 XT2425,MIDFM,SS,ETCH,EU,S101-CK5064-100 XT2425,MIDFM,CB,ETCH,RS,S101-CK5025-100 XT2425,MIDFM,SS,ETCH,RS,S101-CK5065-100 XT2425,MIDFM,CB,ETCH,TN,S101-CK5026-100 XT2425,MIDFM,SS,ETCH,TN,S101-CK5066-100	6
TNN501-CKZ000-010+Speaker_HS	15
TNM721-CKZ001-007+SPK Radiator sheet_LS	36

Use the Plastic Tweezer to place the Speaker Box Heat Spreader aligning with the positioning mark and peel off the liner.



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

WARNING
Strictly follow the position shown in the figure for the assembly to ensure the best heat dissipation effect.

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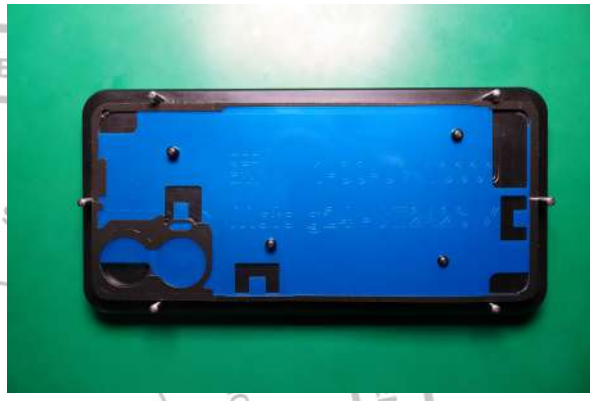
Battery Cover Adhesive Assembly (For 5000mAH Battery Version)

Description	Reference #
XT2423,Inlay,GRY,S101-CKZ082-200 XT2423,Inlay,GRN,S101-CKZ032-200 XT2423,Inlay,PNK,S101-CKZ102-200 XT2423-5,Inlay,GRY,JP,S101-CKZ083-200 XT2423-5,Inlay,GRN,JP,S101-CKZ033-200	7
XT2423,ADH,Inlay,M709-CKZ000-031	30

1. Peel off the colorless liner. 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.

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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.

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

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Battery Cover Adhesive Assembly (For 6000mAH Battery Version)

Description	Reference #
XT2425,Inlay,CB,deepBLU,S101-CK5023-200 XT2425,Inlay,SS,lightBLU,S101-CK5063-200	7
XT2425,ADH,Inlay,M709-CK5000-000	30

1. Peel off the colorless liner. 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.

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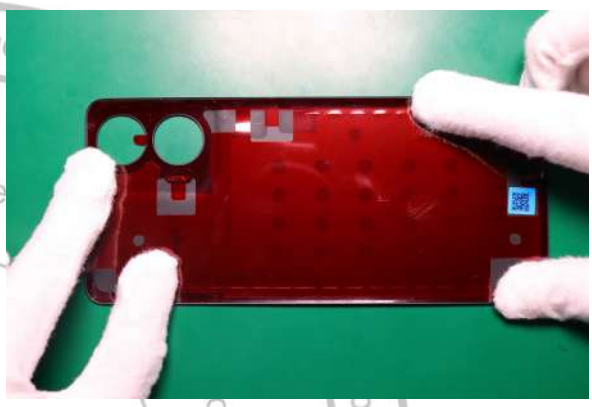
3. Use fingers to press down the Battery Cover with the Battery Cover Adhesive Alignment as shown.

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

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

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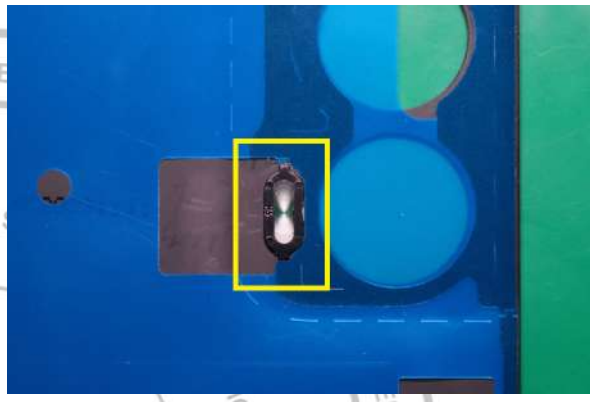
Flash Lens Assembly (For 5000mAH Battery Version)

Description	Reference #
XT2423,Inlay,GRY,S101-CKZ082-200 XT2423,Inlay,GRN,S101-CKZ032-200 XT2423,Inlay,PNK,S101-CKZ102-200 XT2423-5,Inlay,GRY,JP,S101-CKZ083-200 XT2423-5,Inlay,GRN,JP,S101-CKZ033-200	7
TNM223-CKZ000-101+flash shield11.2x4.8	9

Peel off the liner of the Flash Lens Adhesive. Use the Plastic Tweezer to place the Flash Lens on the Battery Cover as shown.



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

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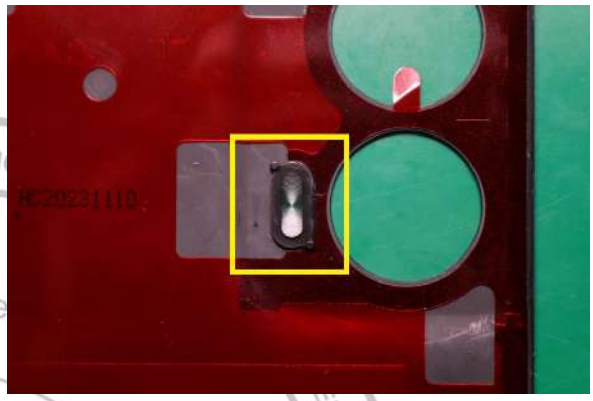
Flash Lens Assembly (For 6000mAH Battery Version)

Description	Reference #
XT2425,Inlay,CB,deepBLU,S101-CK5023-200 XT2425,Inlay,SS,lightBLU,S101-CK5063-200	7
TNM223-CKZ000-101+flash shield11.2x4.8	9

Peel off the liner of the Flash Lens Adhesive. Use the Plastic Tweezer to place the Flash Lens on the Battery Cover as shown.



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

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Battery Cover Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423,Inlay,GRY,S101-CKZ082-200 XT2423,Inlay,GRN,S101-CKZ032-200 XT2423,Inlay,PNK,S101-CKZ102-200 XT2423-5,Inlay,GRY,JP,S101-CKZ083-200 XT2423-5,Inlay,GRN,JP,S101-CKZ033-200 XT2425,Inlay,CB,deepBLU,S101-CK5023-200 XT2425,Inlay,SS,lightBLU,S101-CK5063-200	7

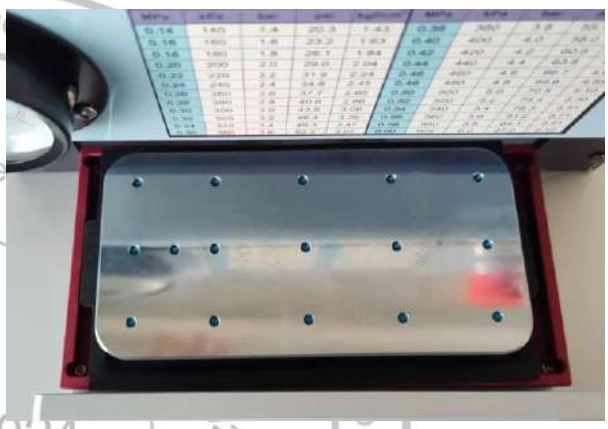
1. Peel off the liner of Battery Cover Adhesive and use fingers to place the Battery Cover on the Front-Housing as shown.

2. Power on pneumatic press system by press power switch to “ON” position.

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

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

4. Place the Inlay press fixture (1-00-V1-10000) on top of the phone as shown.



5. 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.

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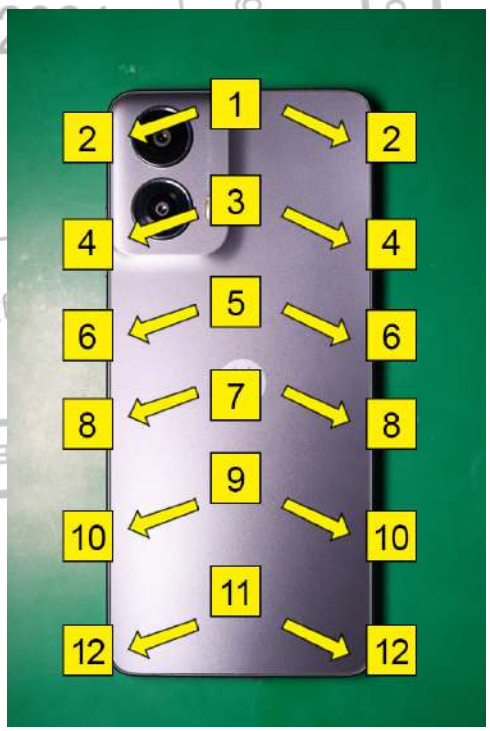
6. Press both of “Start” on the left and right side to initiate press process. Wait 30 seconds until process is finished.

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

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



15. 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.

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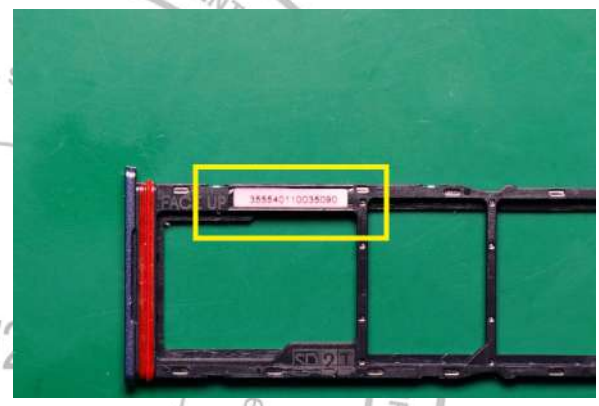
IMEI Label Assembly

Description	Reference #
TNEI30-CKZ081-000+SIM tray GRY SS_HRD TNEI30-CKZ031-000+SIM tray GRN SS_HRD TNEI30-CKZ101-010+SIM tray PNK SS_HRD TNEI30-CKZ080-000+SIM tray Grey_HRD TNEI30-CKZ030-000+SIM tray GRN DS_HRD TNEI30-CKZ100-000+SIM tray PNK DS_HRD TNEI30-CKZ082-000+SIM Tray GRY_HRD_JP TNEI30-CKZ032-000+SIM Tray GRN_HRD_JP TNEI30-CKZ021-000+SIM tray BLU SS_HRD TNEI30-CKZ061-000+SIM tray SaltW SS_HRD TNE	19
TNP316-CBR000-000+label double layer_LHL	-

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



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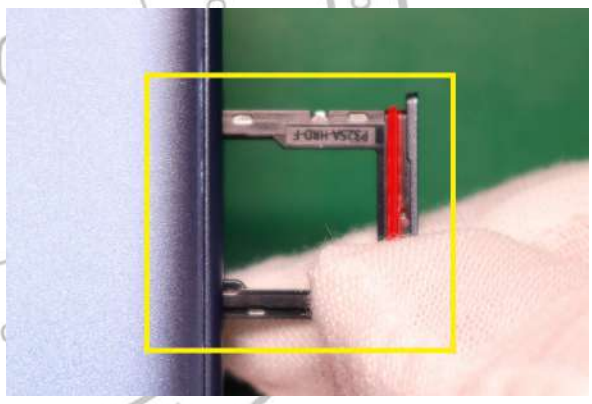
Sim Tray Assembly

Description	Reference #
XT2423,TPLCM,S101-CKZ130-000 XT2423-5,TPLCM,JP,S101-CKZ133-000 XT2425,TPLCM,IN,S101-CK5131-000	1
XT2423-1,MB,4+128 SS,LA,F00CKZ3-000-001 XT2423-1,MB,4+128 DS,LA,F00CKZ3-000-000 XT2423-1,MB,4+256 SS,LA,F00CKZ3-000-003 XT2423-1,MB,4+256 DS,LA,F00CKZ3-000-002 XT2423-2,MB,8+128 DS,MEA,F00CKZ3-000-005 XT2423-2,MB,4+128 DS,MEA,F00CKZ3-000-004 XT2423-3,MB,4+128 DS,EU,F00CKZ3-000-006 XT2423-3,MB,8+128 DS,EU,F00CKZ3-000-007 XT2423-5,MB,8+128 DS,JP,F00CKZ3-000-008 ASSY,BD KIT,Fogo4G 5000 BR 4+128 DS EMCP XT2425-1,MB,8+128 SS,LA,F00CK53-000-001 XT2425-1,MB,8+256 SS,LA,F00CK53-000-002 XT2425-1,MB,8+256 DS,LA,F00CK53-000-003 XT2425-1,MB,4+256 SS,LA,F00CK53-000-000 ASSY,BD KIT,Fogo4G 6000 4+128 DS IN ASSY,BD KIT,Fogo4G 6000 8+128 DS IN XT2425-3,MB,8+256 DS,MEA,F00CK53-000-004 XT2425-4,MB,8+256 DS,EU,F00CK53-000-005	2

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

WARNING
Please be careful not to install it upside down.



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

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Chapter 6. Assembly Quality check

Battery Quality Check

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

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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 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 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.

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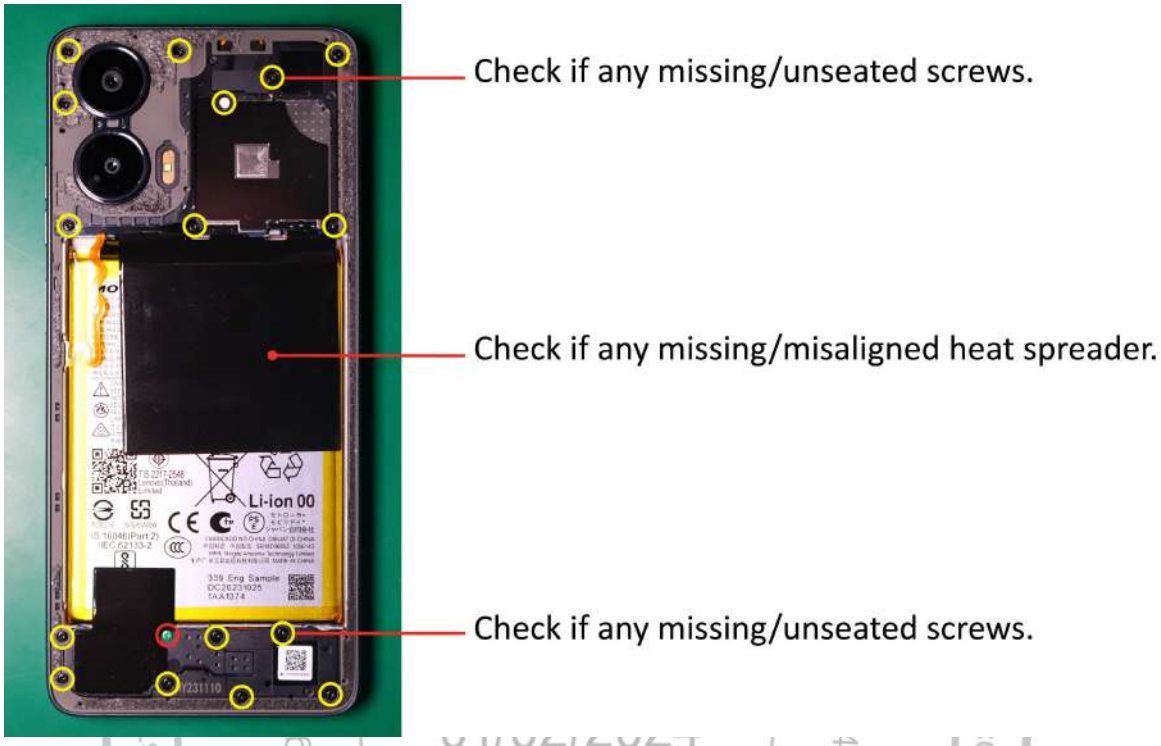
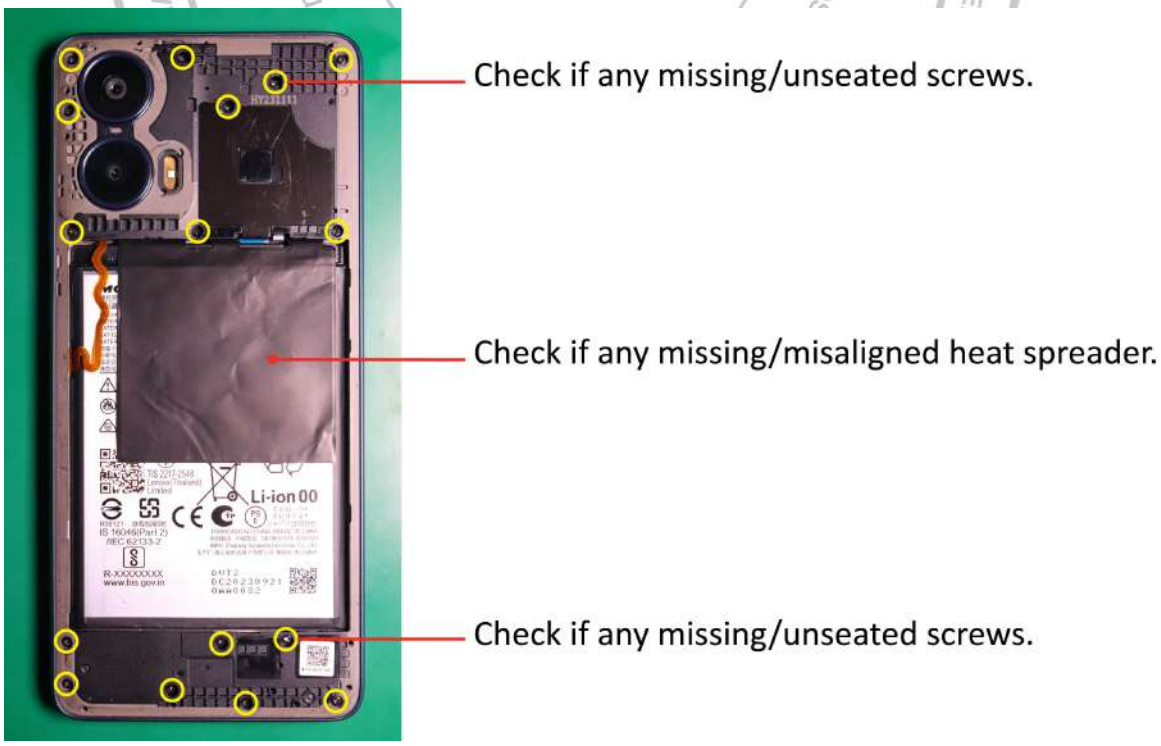
Screws Quality Check

For 5000mAH Battery Version



For 6000mAH Battery Version



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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.

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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:

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- 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 lose 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.

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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.

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