

Doro L20

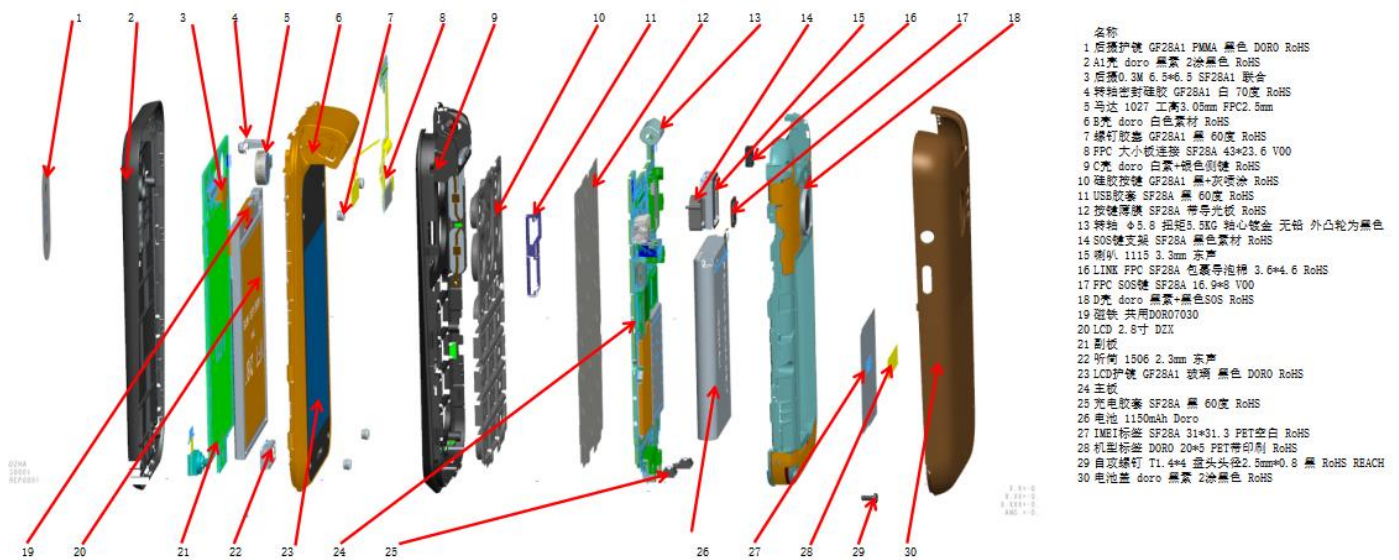
Disassembly and Assembly procedure

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1 Introduction

The purpose of this document is to explain how to disassemble and assemble DORO L20 product. Detailed steps are mentioned with warnings as below.



2 Tooling definition

Forceps



Screwdriver



Plastic Card



Hot Gun



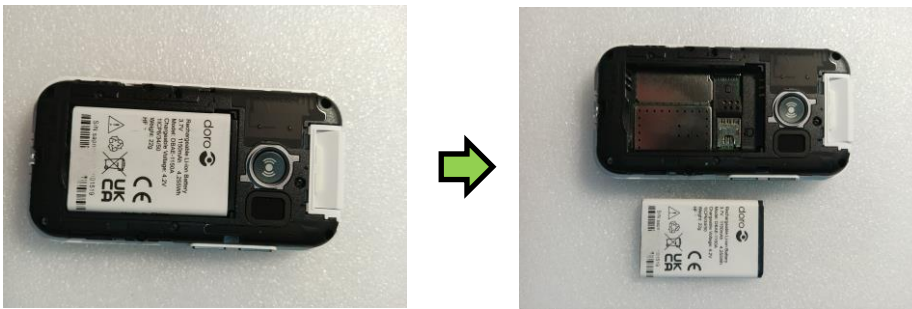
3 Disassembling procedure

3.1 Remove the battery cover



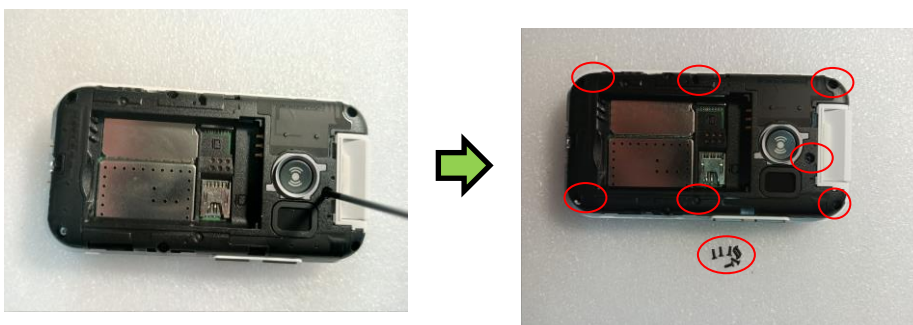
Remove the battery cover by opening the special slot.

3.2 Remove the battery



Remove the battery by opening the special slot.

3.3 Remove the screws



Remove the screws (qty=7) by using the screwdriver carefully.

3.4 Remove the lower housing assembly



Remove the lower housing from the upper housing assembly by plastic card and please start from the bottom of the product and then along the sides to open the lower housing assembly carefully.

3.5 Remove the PCBA



Disconnect LINK FPC from the PCBA and remove the FPC by forceps.

3.6 Disassemble the PCBA module



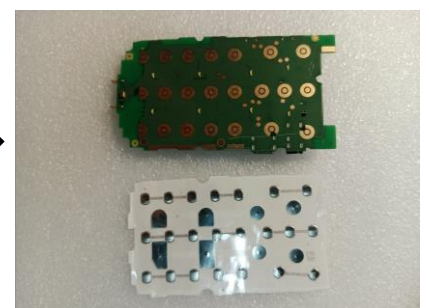
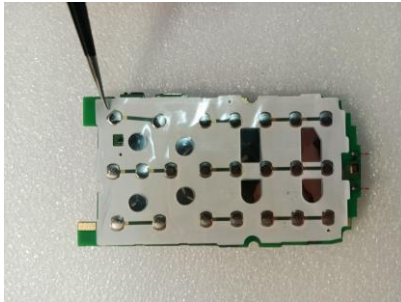
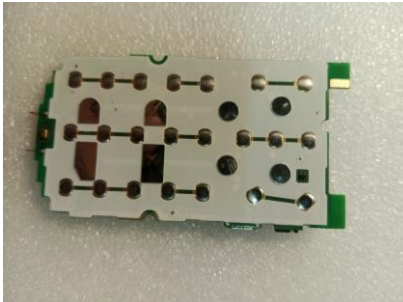
Remove SOS FPC and SOS holder from PCBA by forceps.



Remove USB Rubber and MIC Rubber from PCBA by forceps.



Remove Charger spring clip cover from PCBA by forceps.



Remove the metal dome from PCBA by forceps.

3.7 Disassemble the Flap B



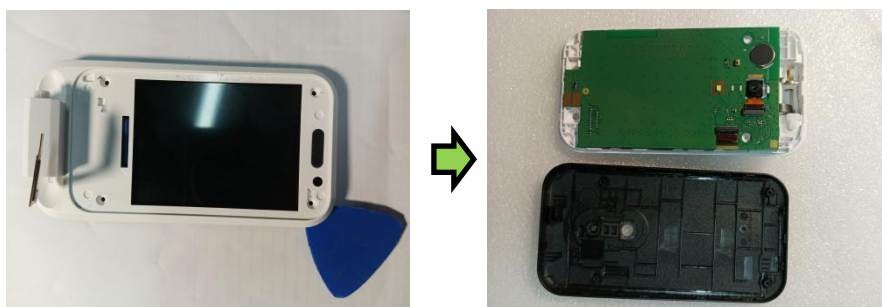
Remove the Flap B from upper housing by using forceps to push in FLAP Hinge Unit carefully.



Not necessary unless the LCD Window needs to be replaced. Preheat (85°C) for about five minutes (hot air gun/heating table) and carefully remove the LCD Window with a hard plastic plectrum/card.



Remove screws (qty=4) on the Flap B by screwdriver.



Carefully separate the Flap B along the edge with a hard plastic plate.

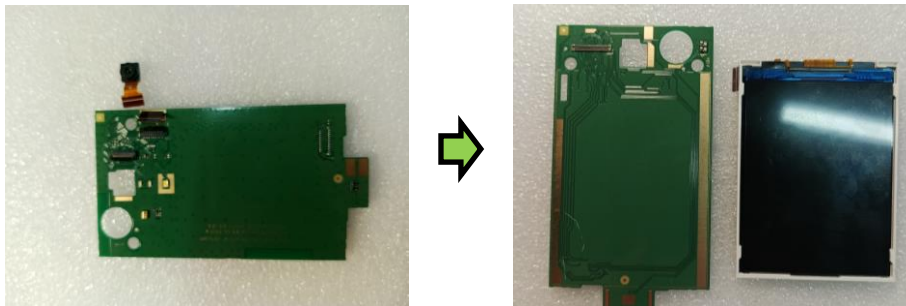


Disconnect LINK FPC. Remove ref Sub PCB from the Flap B by forceps.



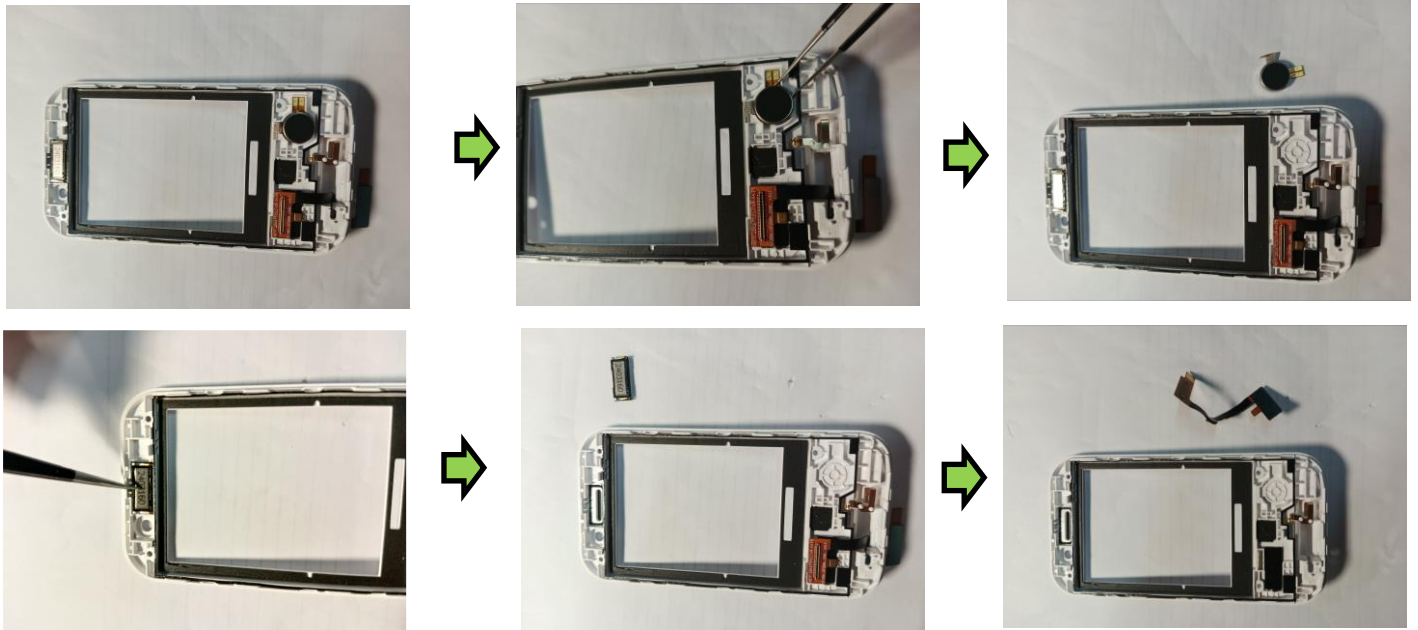
Remove the back Camera from Flap B by using the forceps.

3.8 Remove the 2.8 LCD



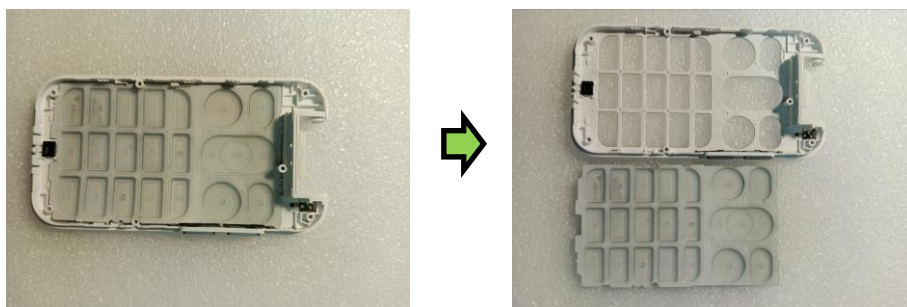
Remove 2.8 LCD from Sub PCB by using the forceps.

3.9 Remove the receiver and motor

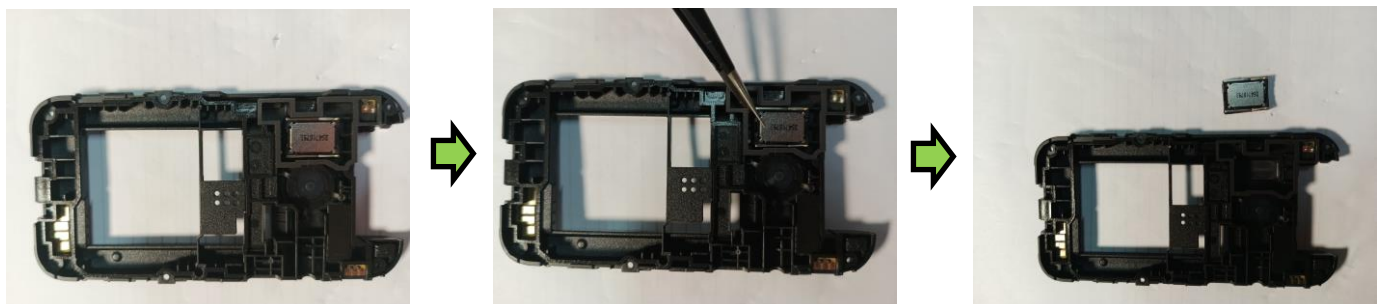


Remove the motor and receive from the front housing by using the forceps. Remove the LINK FPC from the front housing.

3.10 Remove the keypad and speaker



Remove Keypad from the front housing.



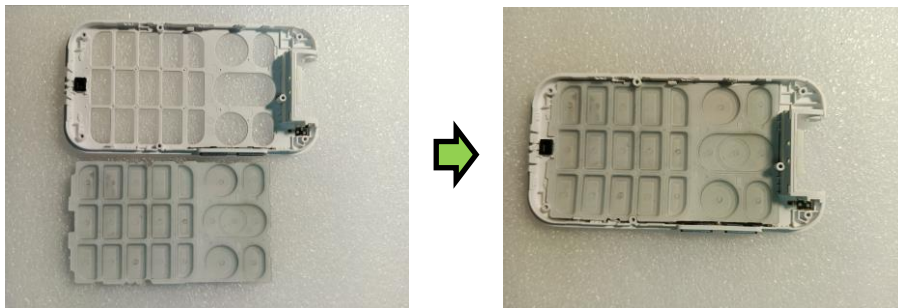
Remove Speaker from ref lower housing by forceps.

4 Assembling procedure

4.1 Assemble the keypad and speaker

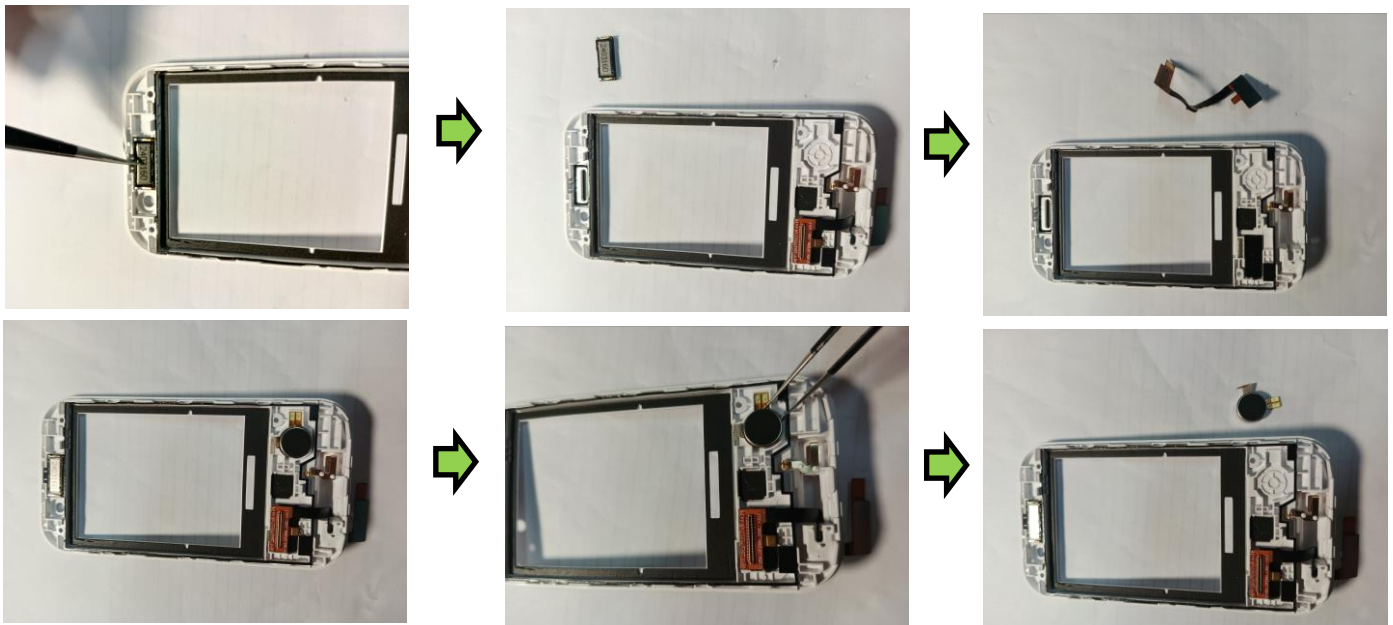


Assemble the Speaker to the corresponding position in lower housing.



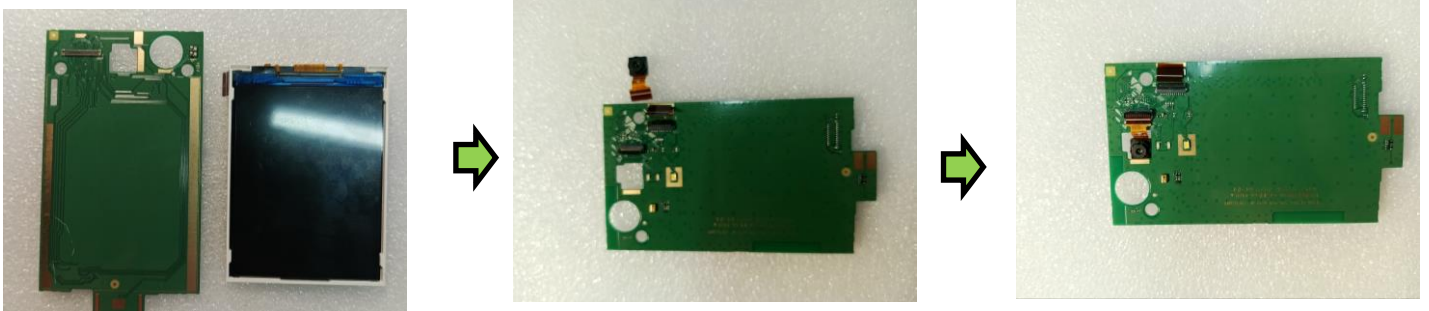
Assemble the keypad to the corresponding position in front housing.

4.2 Assemble the receiver and motor



Assemble the motor and receive from the front housing by using the forceps. Remove the LINK FPC in the front housing.

4.3 Assemble the LCD and back camera



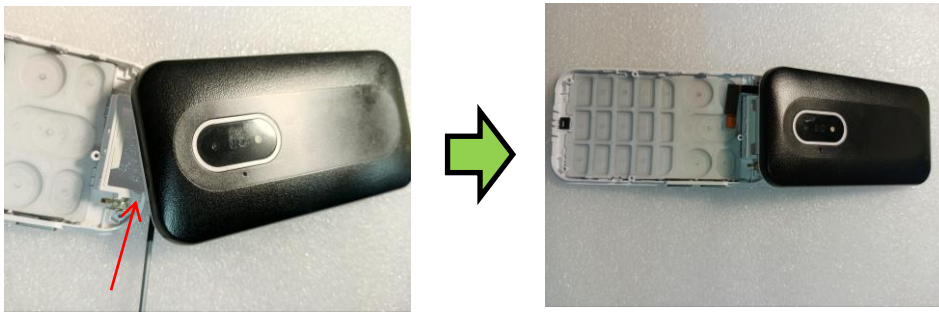
Assemble 2.8 LCD in Sub PCB by using the forceps. Assemble the back camera in the SUB PCB by using the forceps.

4.4 Assemble the Flap B



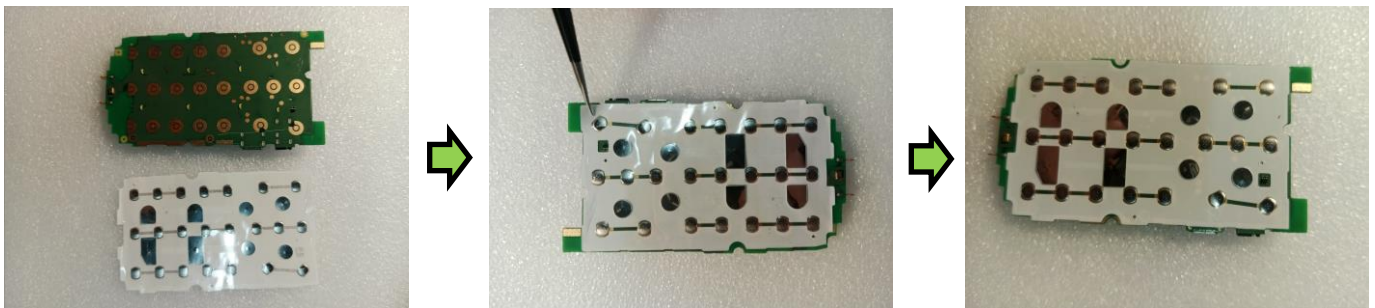
Assemble the SUB PCB to the front housing. Assemble the screws to the Flap B by screwdriver. Assemble the screen to the front housing.

4.5 Assemble components on the upper housing



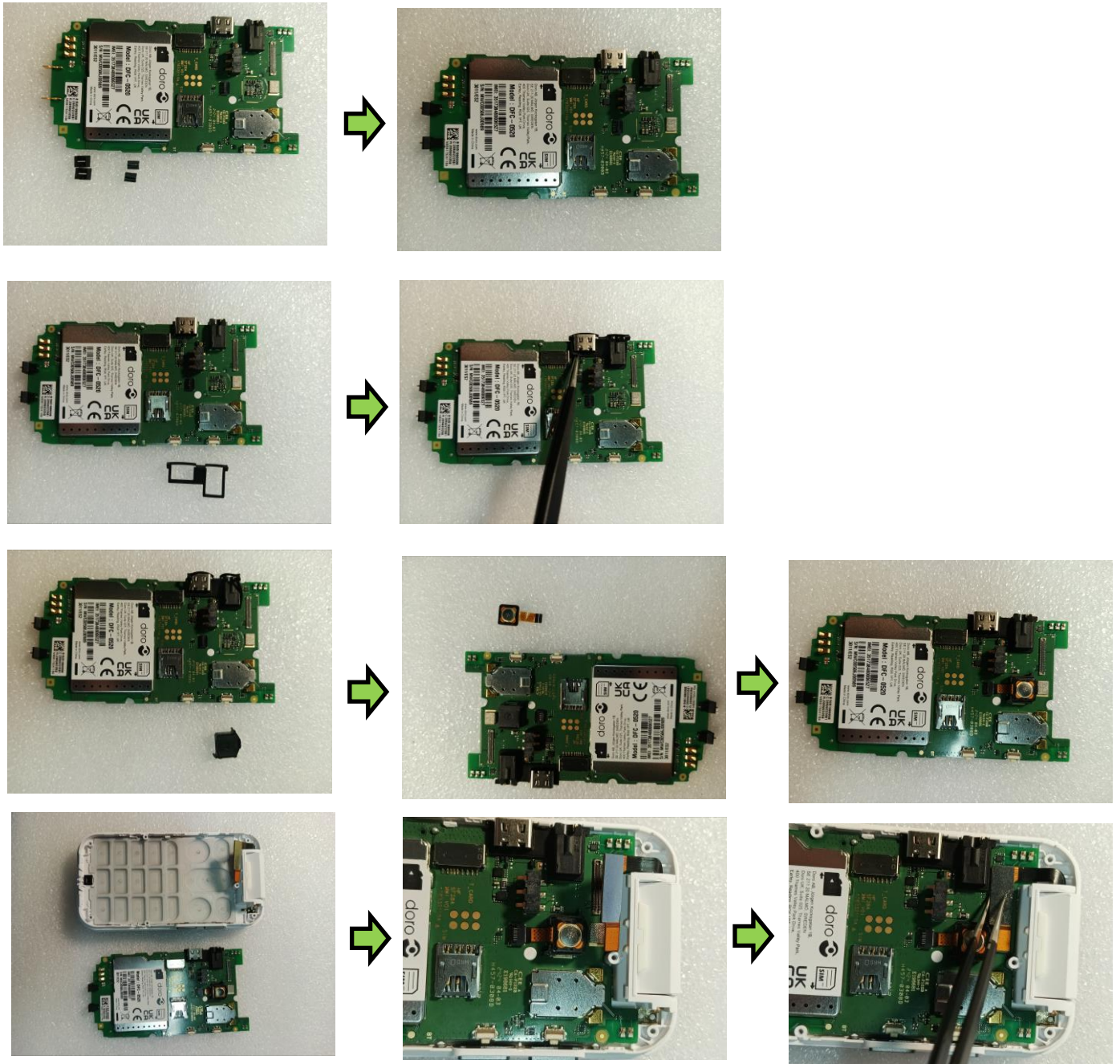
Assemble the Flap B from upper housing by using forceps to push in the special slot carefully.

4.6 Assemble the metal dome on PCBA



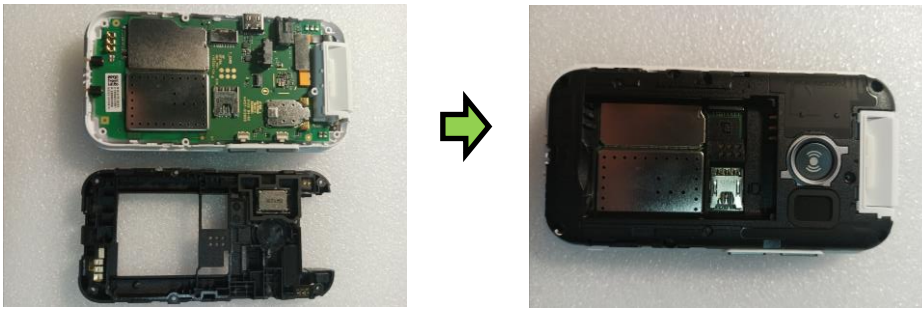
Assemble the metal dome to the corresponding position in PCBA.

4.7 Assemble the PCBA



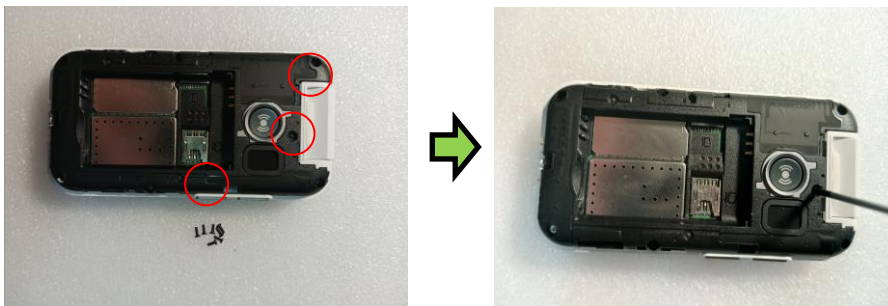
Assemble the charger spring clip cover, USB Rubber, MIC Rubber and SOS assembly from PCBA by forceps. Assemble the PCBA to the lower housing by using the forceps.

4.8 Assemble the lower housing assembly



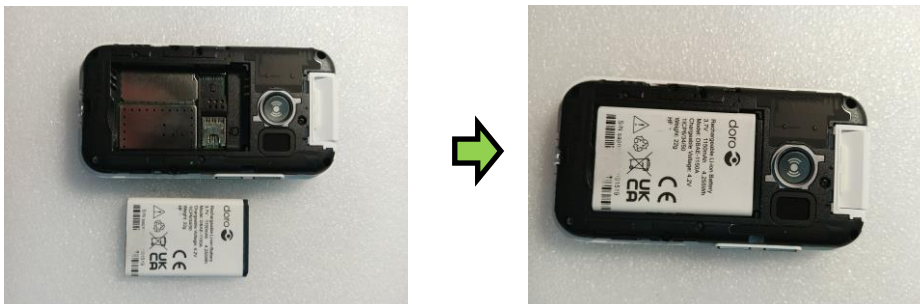
Assemble the lower housing to the corresponding position in upper housing.

4.9 Assemble the screw



Assemble the screws (qty=7) to the corresponding position by screwdriver carefully.

4.10 Assemble the Battery



Assemble the Battery to the corresponding position.

4.11 Assemble the Battery cover



Assemble the Battery cover to the corresponding position.