

# DISASSEMBLY/ASSEMBLY

## Precautions Before Disassembling Parts

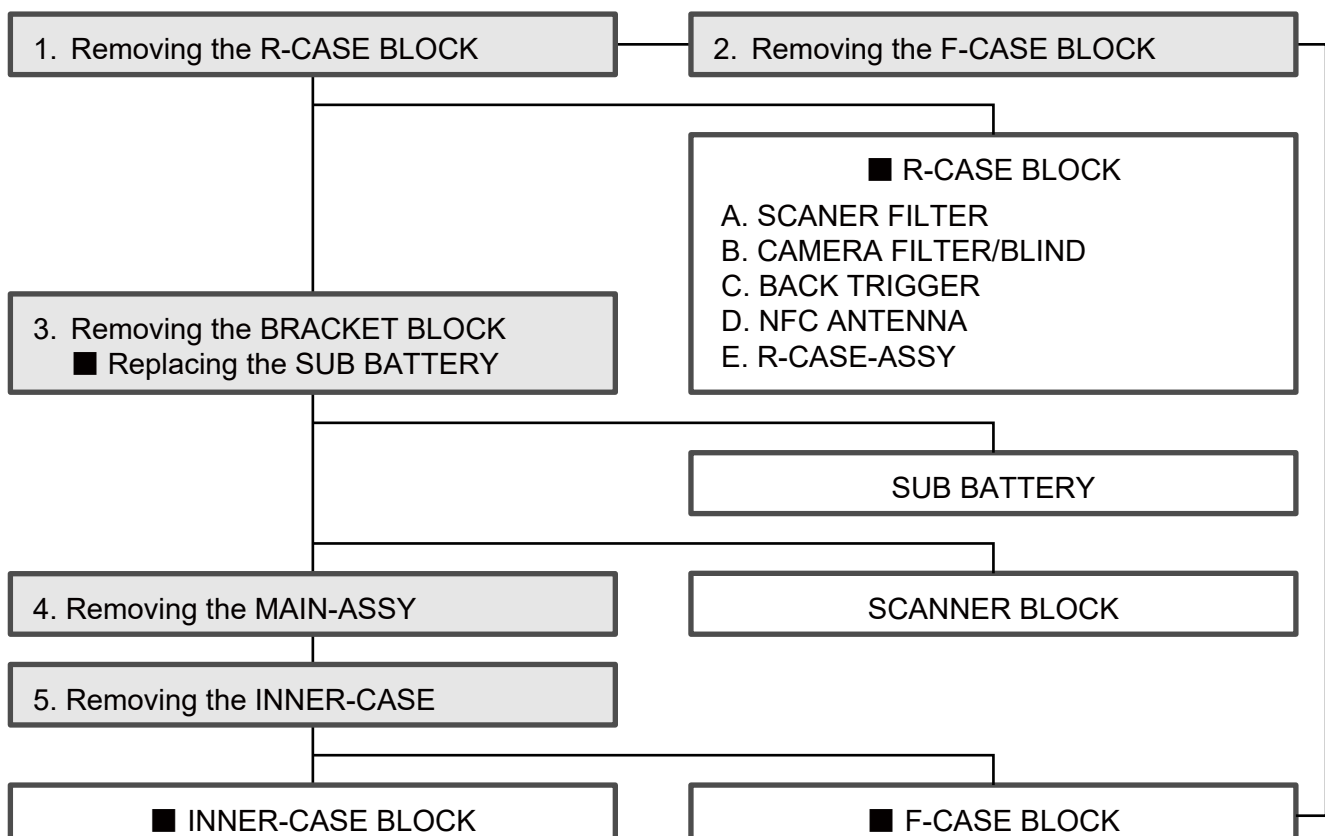
- When reassembling the parts, reverse the disassembly procedures.  
If [ **Note on reassembling** ] is stated, be sure to follow it.
- Use the right screwdriver according to the screw diameter.
- If a torque value is indicated on a screw, use a torque driver to tighten the screw at the indicated value.
- When disassembling or reassembling parts, do not pinch or damage wires.
- When reassembling FPC (cable), be sure that its orientation is correct. The contacts of the FPC are on one side only.
- Adhesive tape is not reusable. Use the new one.

## Tool list

The following tools are necessary when replacing maintenance parts.

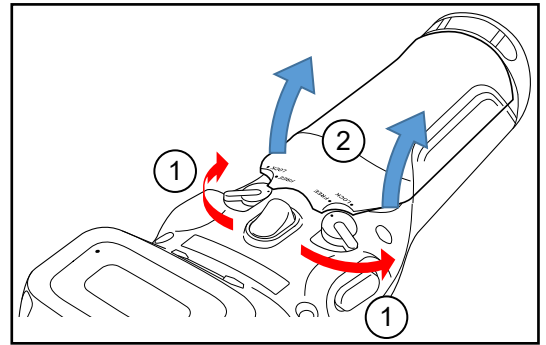
No.	Item
1	#0 precision screwdriver (Phillips head)
2	#1 precision screwdriver (Phillips head)
3	Tweezers
4	Special screwdriver (Torx T8 head)

## Flow

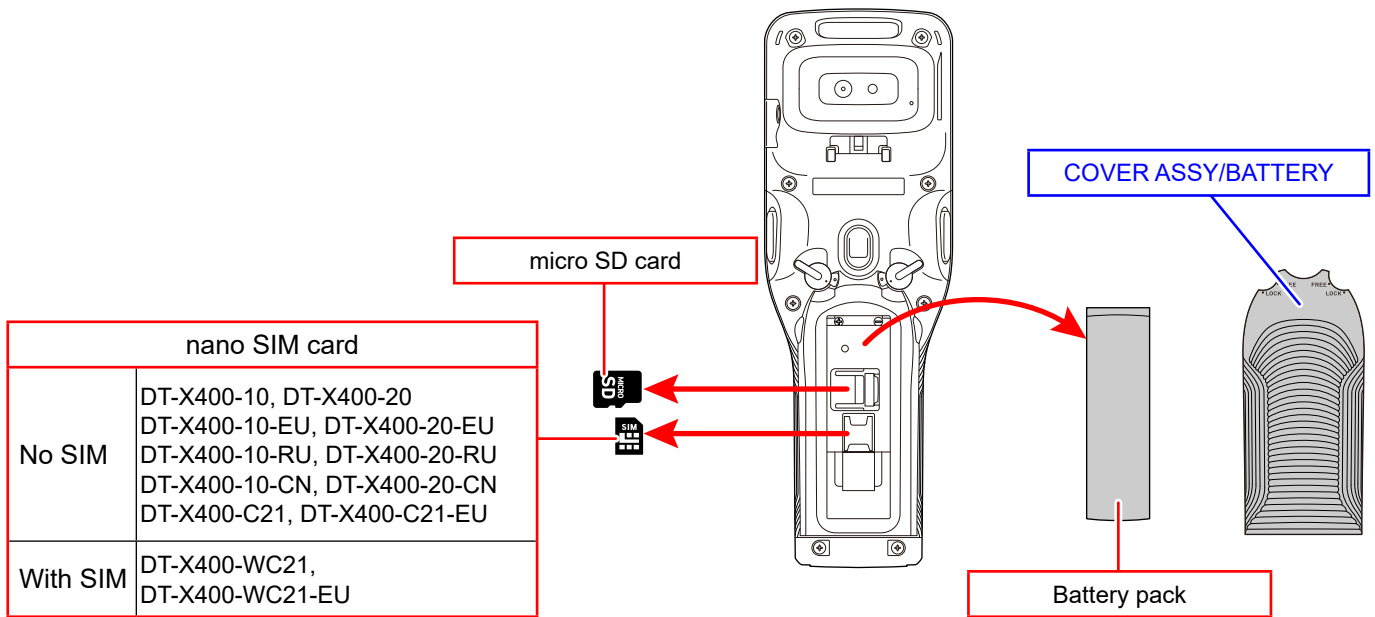


# 1. Removing the R-CASE BLOCK

- (1) Turn the terminal over, turn the left and right battery pack cover lock switches to the "FREE" position (①) and remove the battery pack cover (②).



- (2) Remove the battery pack, microSD card and nano SIM card.



- (3) Undo eight screws.

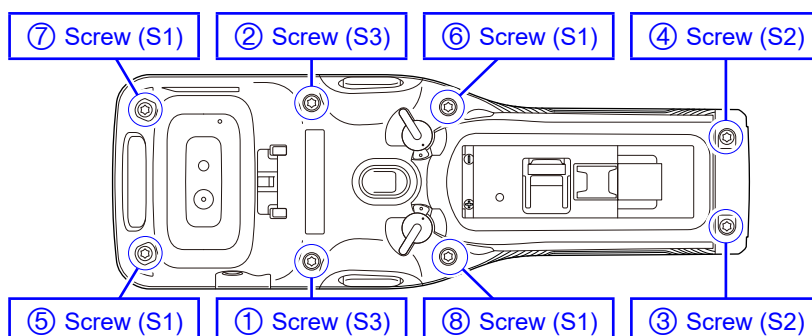
**NOTE:** There are 3 types of screws.

**NOTE:** The S1 ~ S3 screws are torx head type.

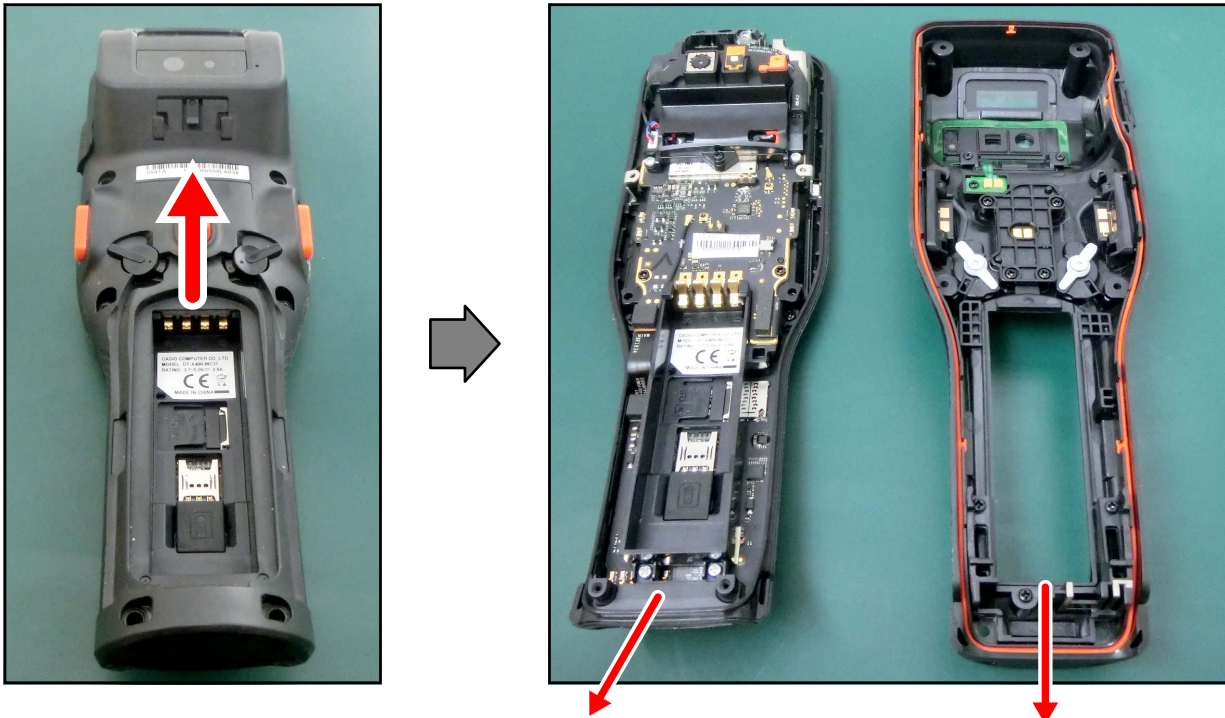


**NOTE:** Tighten the screws in the order of the round number with the following torque value.

Torque	Screw (S1)	3.5 ± 0.5 kgf•cm
	Screw (S2)	
	Screw (S3)	1.0 ± 0.3 kgf•cm



(4) Remove the R-CASE BLOCK.

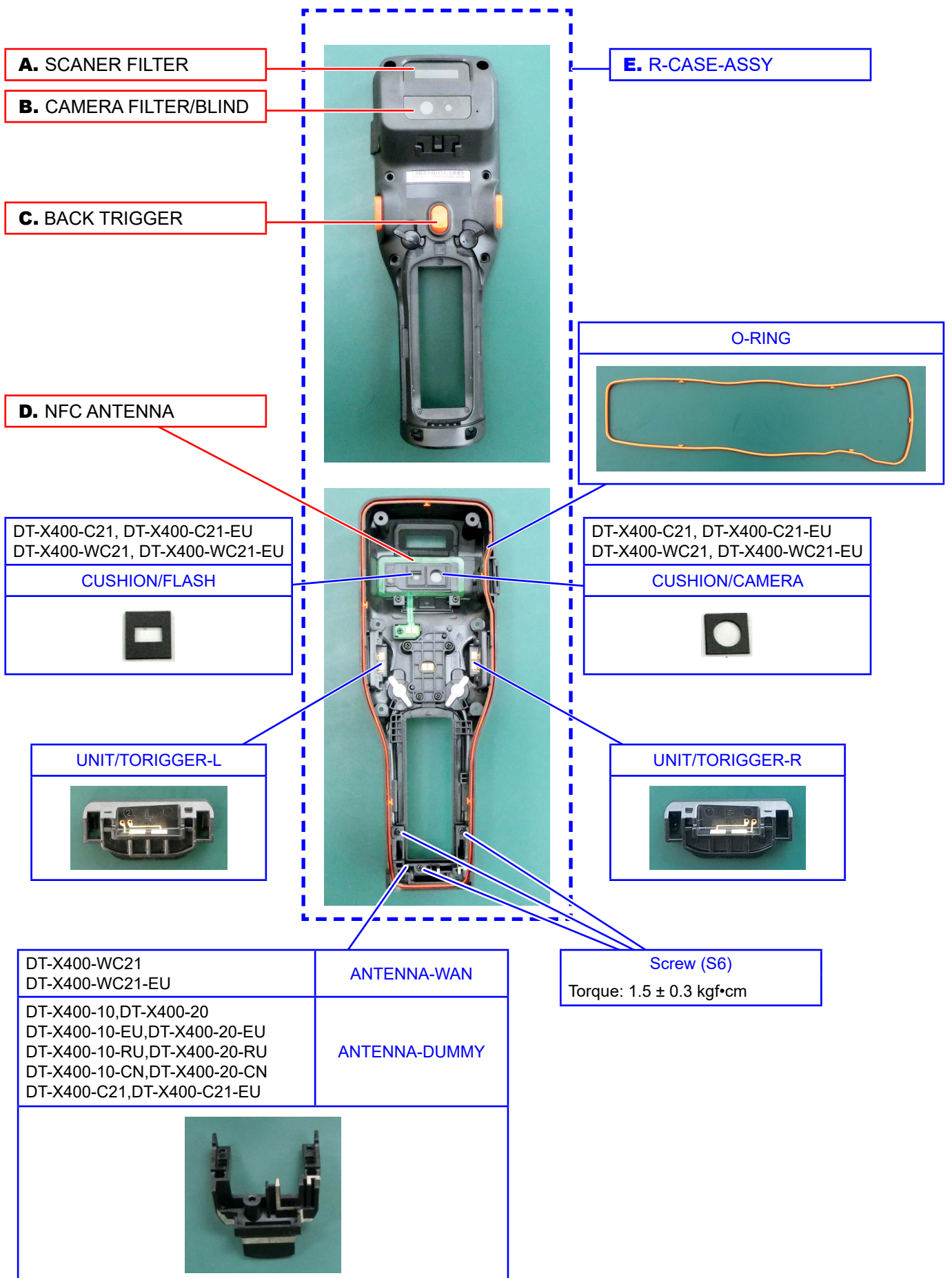


**2. Removing the F-CASE BLOCK**

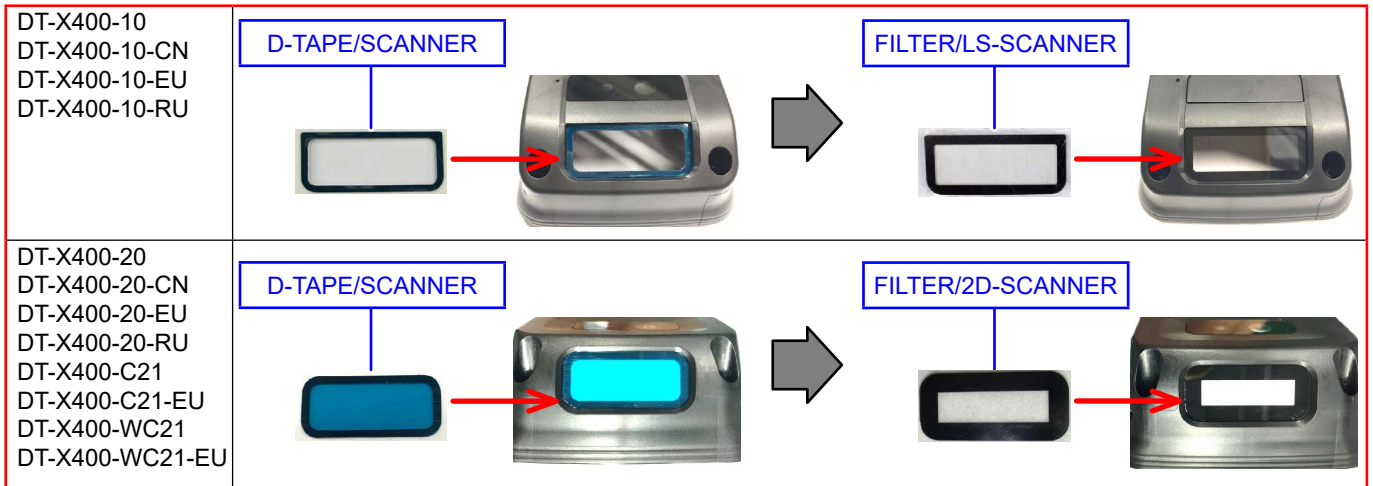
**■ R-CASE BLOCK**

**3. Removing the BRACKET BLOCK**

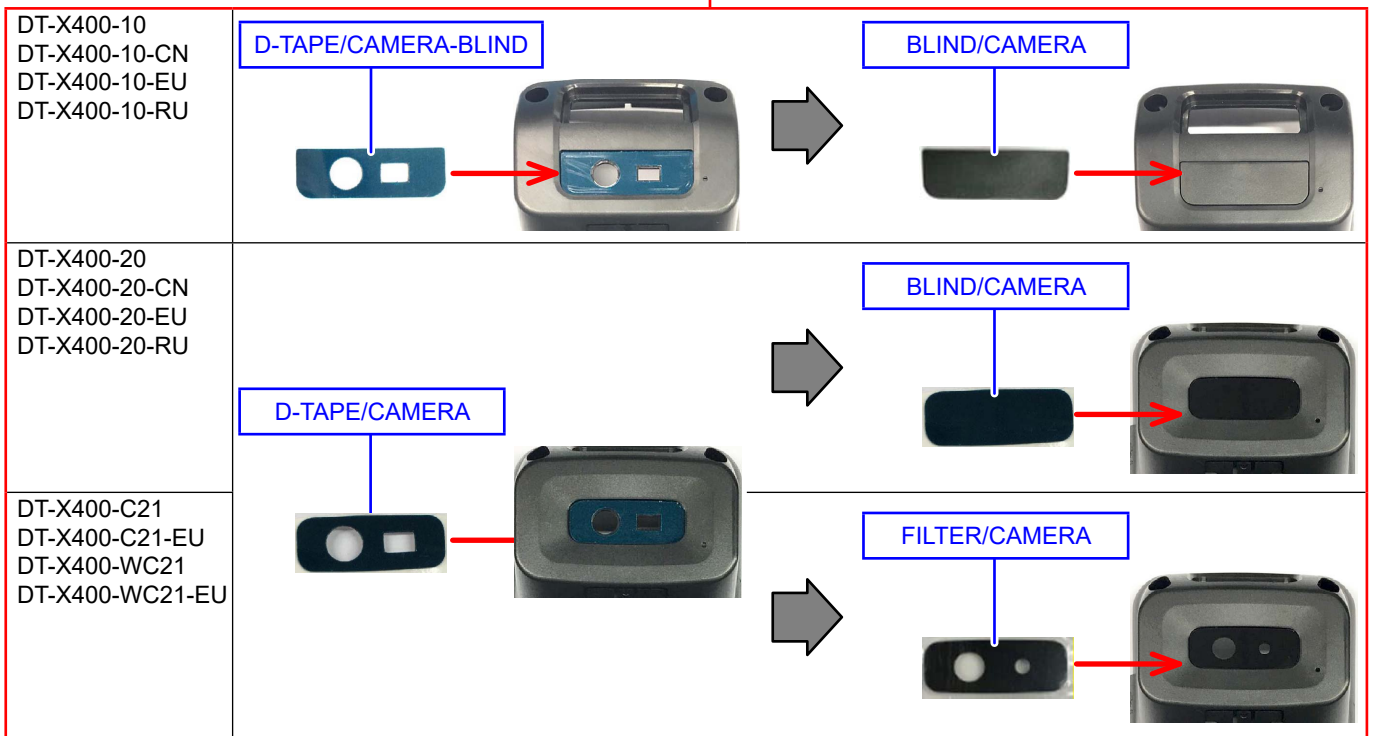
■ R-CASE BLOCK



**A. SCANNER FILTER**



**B. CAMERA FILTER/BLIND**






**C. BACK TRIGGER**

KEY/BACK-TRIGGER

RUBBER/B-TRIGGER

[ Note on reassembling ] Be sure that the rubber is not floating.

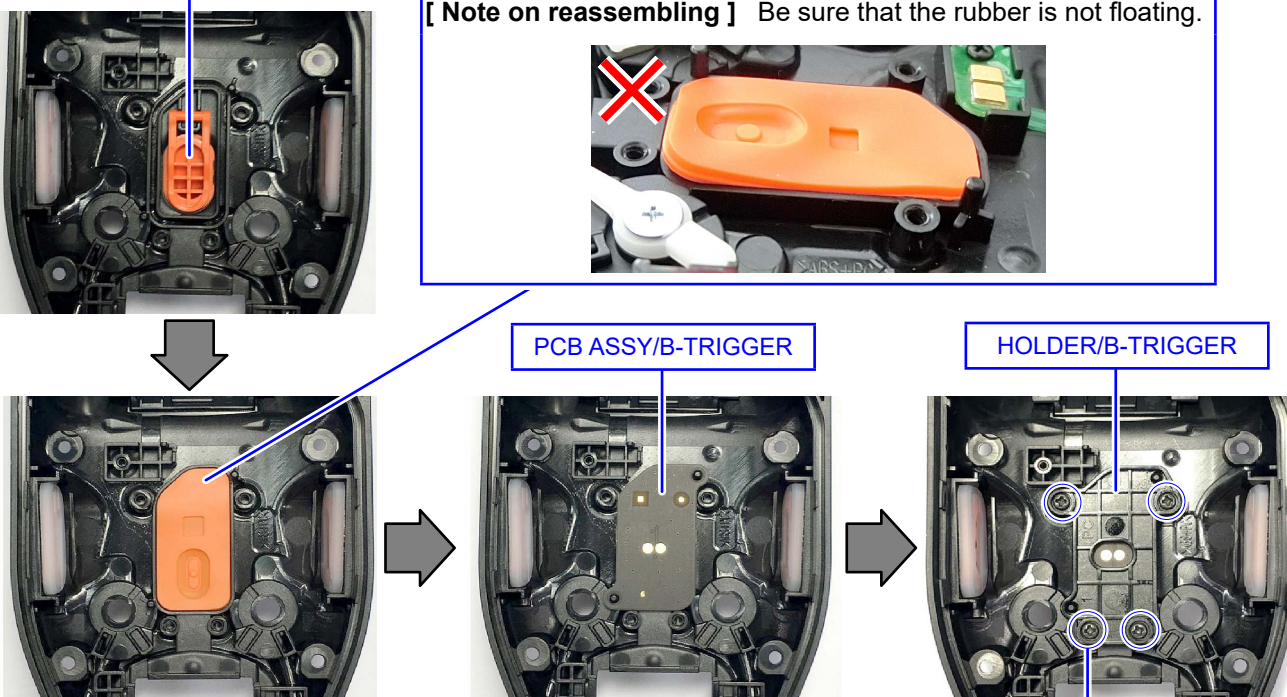
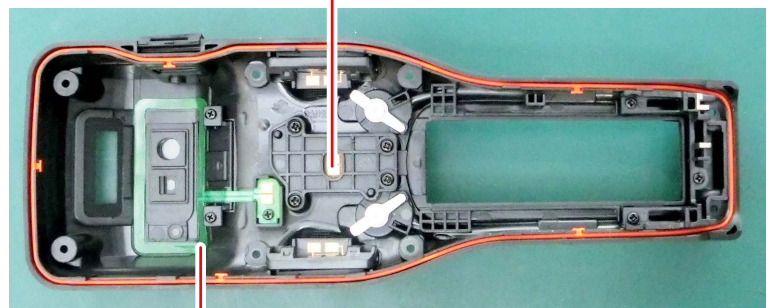


PCB ASSY/B-TRIGGER

HOLDER/B-TRIGGER

Screw (S7)

Torque:  $1.5 \pm 0.3$  kgf·cm

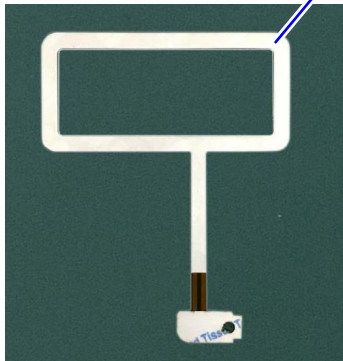
**D. NFC ANTENNA**

DT-X400-C21, DT-X400-C21-EU  
DT-X400-WC21, DT-X400-WC21-EU

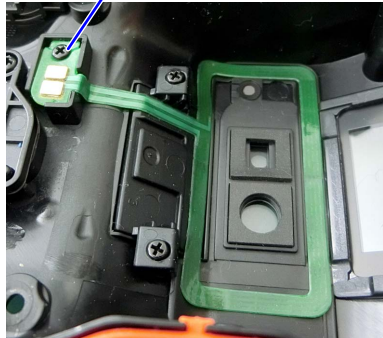
PCB ASSY/NFC-ANT

Screw (S8)

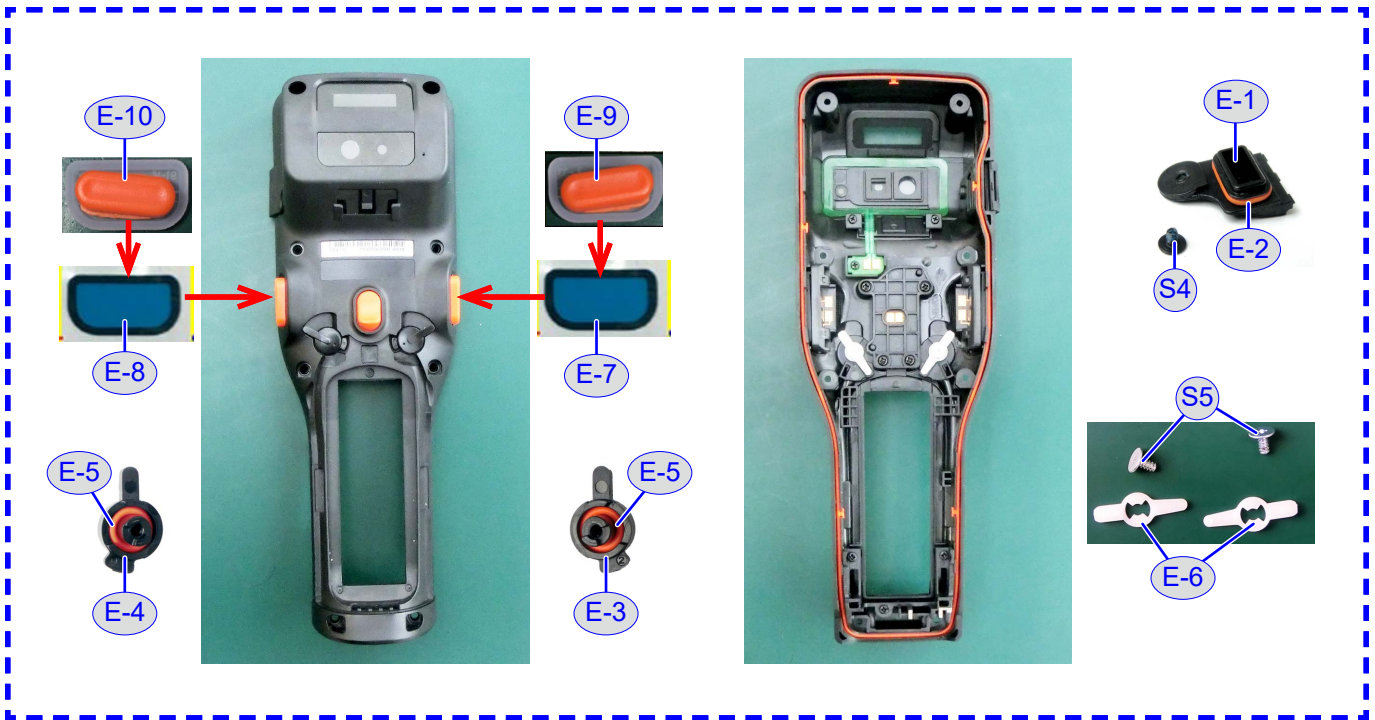
Torque:  $1.5 \pm 0.3$  kgf·cm




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**E. R-CASE-ASSY**

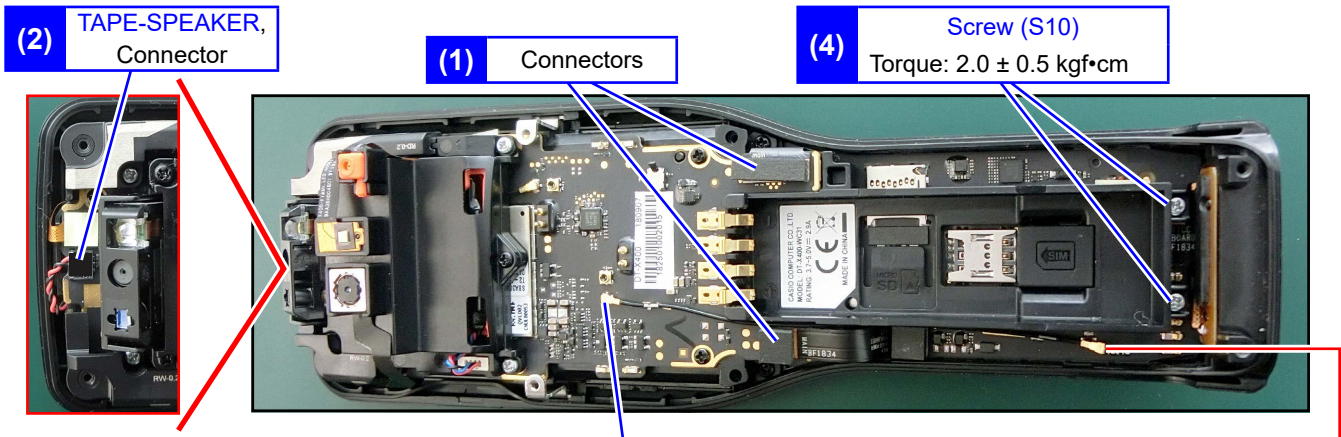


R-CASE-ASSY		
E-1	CAP/USB	<b>NOTE:</b> When replacing with a new one, do not forget to attach the packing (E-2)
E-2	O-RING/USB	
S4	SCREW	Torque: 1.5 ± 0.3 kgf•cm
E-3	HOOK-L/BATTERY	<b>NOTE:</b> When replacing with a new one, do not forget to attach the packing (E-5)
E-4	HOOK-R/BATTERY	
E-5	O-RING/BAT-HOOK	
E-6	LOCK/BATTERY-HOOK	<b>NOTE:</b> 
S5	SCREW	Torque: 1.5 ± 0.3 kgf•cm
E-7	D-TAPE/TRIGGER-L	
E-8	D-TAPE/TRIGGER-R	
E-9	KEY/SIDE-TRIGGER-L	
E-10	KEY/SIDE-TRIGGER-R	



## 2. Removing the F-CASE BLOCK

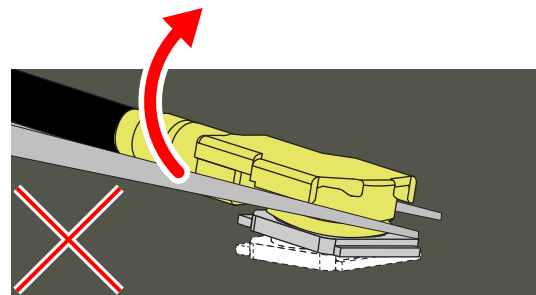
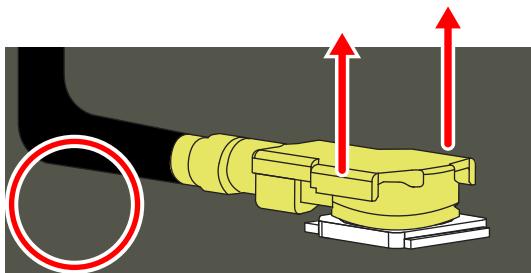
- (1) Release two connectors.
- (2) Remove tape and release the connector.
- (3) Remove the CABLE/ANNTENA.
- (4) Undo two screws.



(3) CABLE/ANNTENA DT-X400-WC21, DT-X400-WC21-EU

**NOTE:** When disconnecting/connecting the connector, use a special jig and disconnect/connect it vertically.

When force is applied to one side of the connector using tweezers.



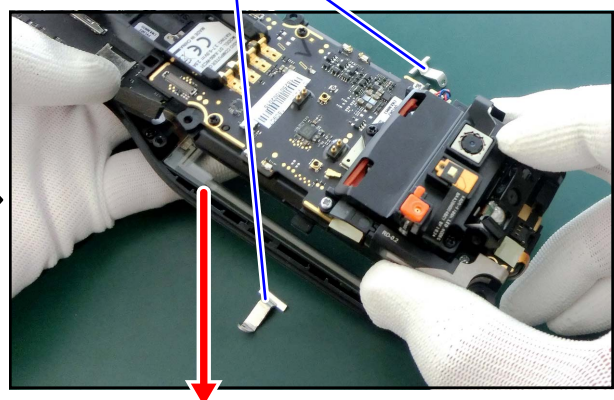
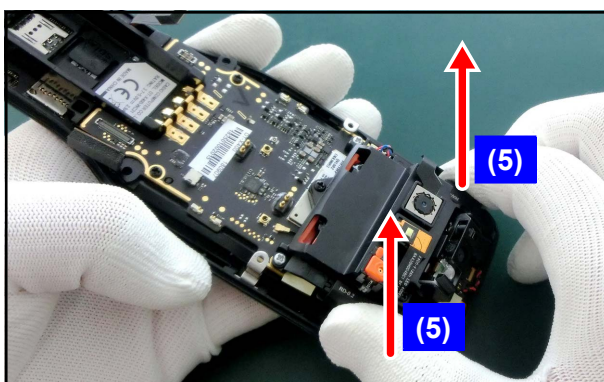
**NOTE:** When the connector of the F-CASE side is to be disconnected/connected, do it after removing the INNER-CASE.

- (5) Remove the INNER-CASE.

### SCREW-PLATE

When the INNER-CASE is lifted, the SCREW-PLATEs come off.

**[ Note on reassembling ]** After attaching the INNER-CASE, set the SCREW-PLATEs in place.



■ F-CASE



### 3. Removing the BRACKET BLOCK

- (1) Remove the SPACER/CN.
- (2) Disconnect the connector.
- (3) Remove the HOLDER/MIC.
- (4) Undo one screw and remove the ANTENNA.

(3) Except: DT-X400-10-CN,DT-X400-20-CN **HOLDER/MIC**

(4) Screw (S9)  
Torque: 2.0 ± 0.5 kgf·cm

(2) Connector

(1) SPACER/CN

DT-X400-WC21 DT-X400-WC21-EU	ANTENNA-DIVERSITY
(4) DT-X400-10,DT-X400-20 DT-X400-10-EU,DT-X400-20-EU DT-X400-10-RU,DT-X400-20-RU DT-X400-10-CN,DT-X400-20-CN DT-X400-C21,DT-X400-C21-EU	ANTENNA-DUMMY

- (5) Remove the SHEET/FLASH.
- (6) Disconnect the following FPCs.

**NOTE:** FPCs are attached with double faced tape.

DT-X400-10, DT-X400-10-EU, DT-X400-10-RU, DT-X400-10-CN DT-X400-20, DT-X400-20-EU, DT-X400-20-RU, DT-X400-20-CN	DT-X400-C21, DT-X400-C21-EU DT-X400-WC21, DT-X400-WC21-EU
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When the SUB BATTERY is to be replaced.

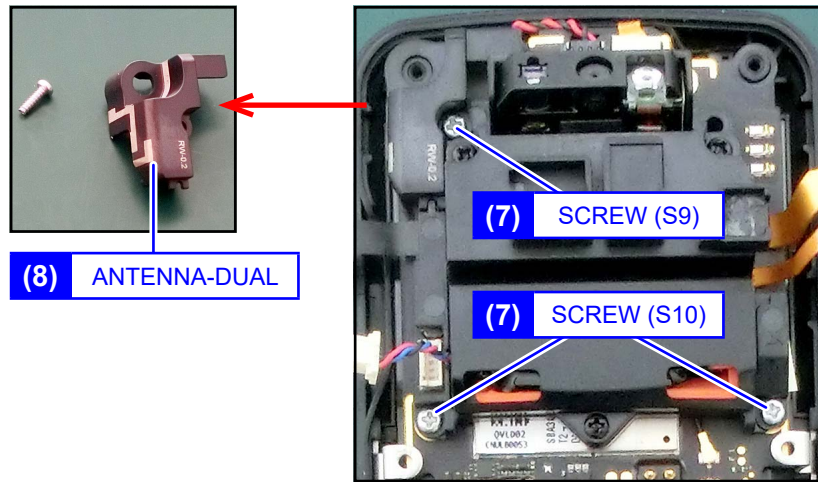
**■ SUB BATTERY**

(7) Undo three screws.

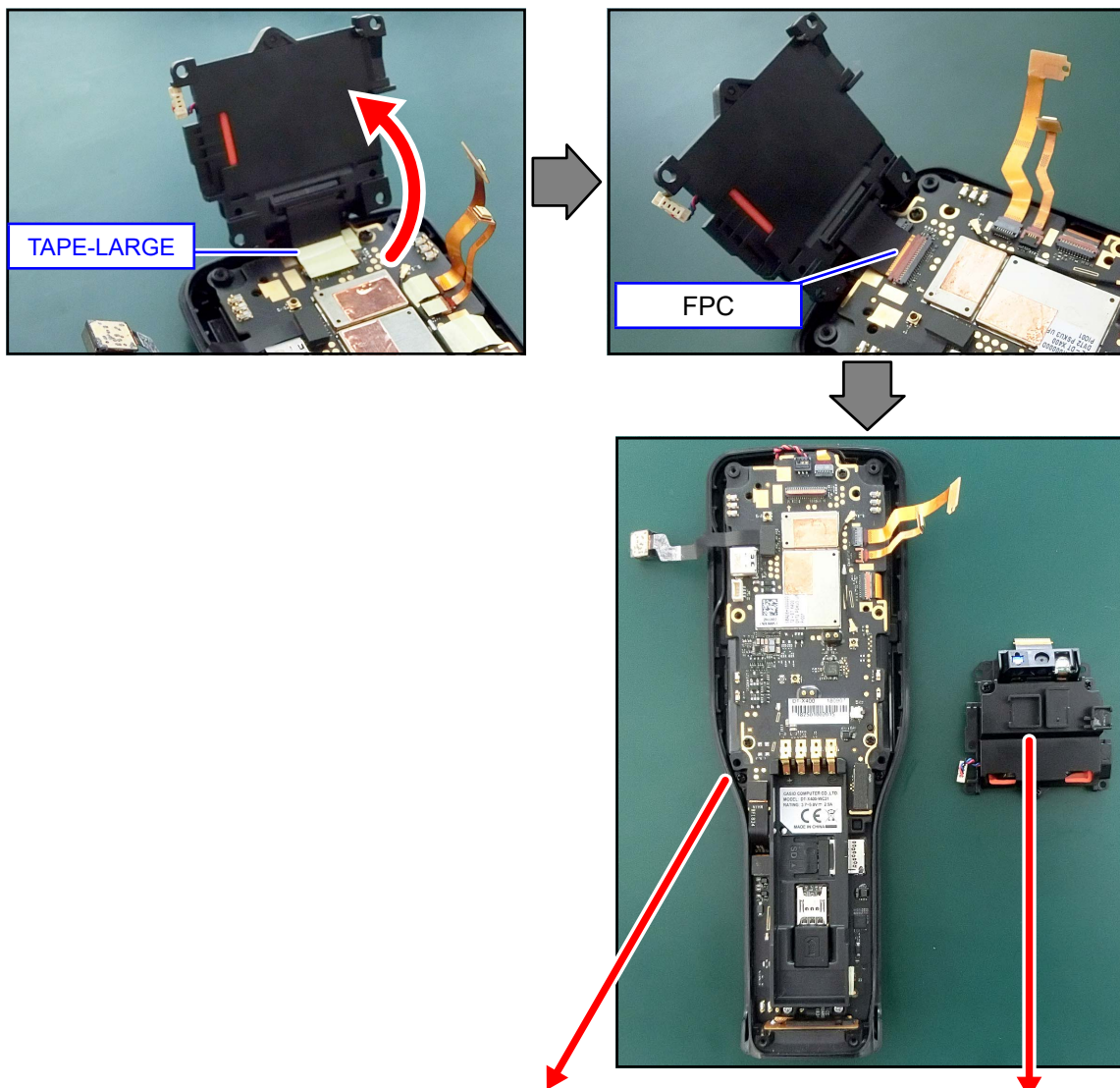
**NOTE:** Tighten the screw with the torque value shown below.

Torque	Screw (S9)	2.0 ± 0.5 kgf•cm
	Screw (S10)	

(8) Remove the ANTENNA/DUAL.



(9) Release the connector locks and disconnect the FPC, then remove the bracket.



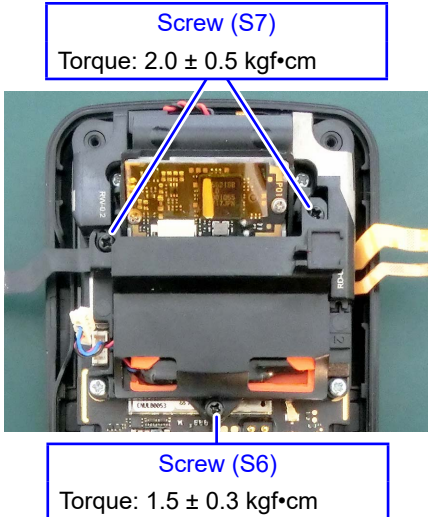
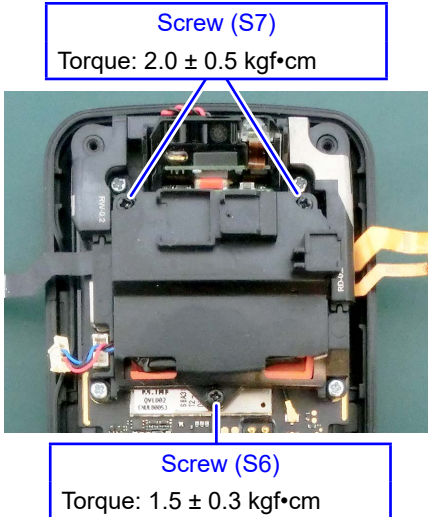
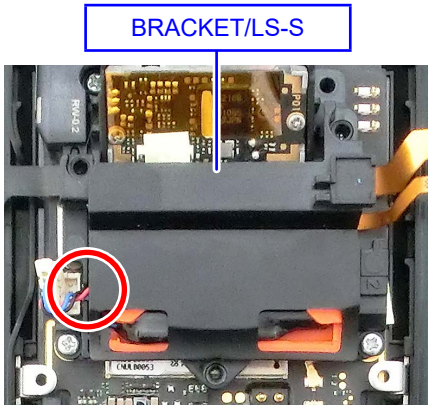
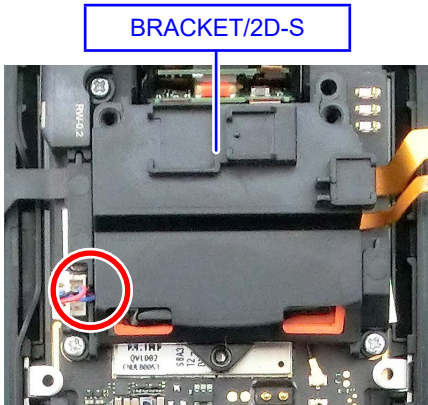

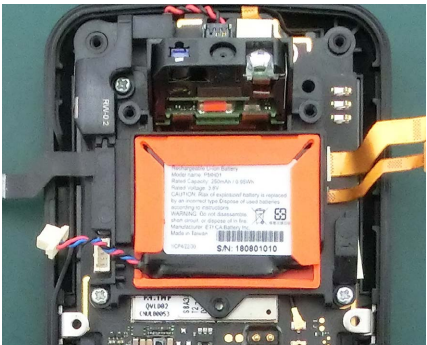
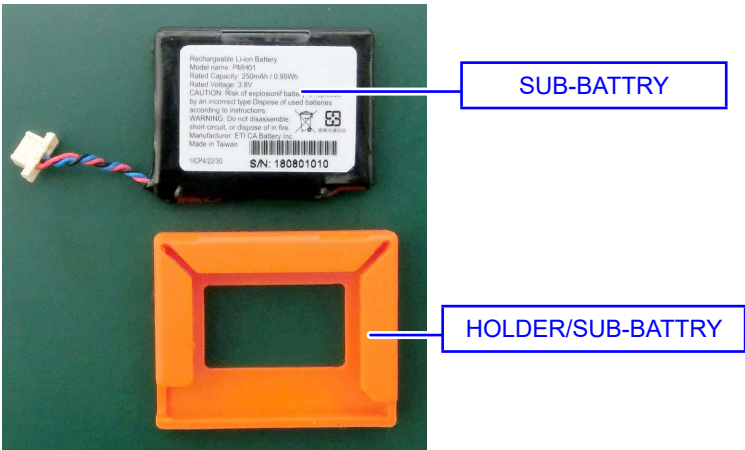
**4. MRemoving the MAIN-ASSY**

**■ SCANNER BLOCK**

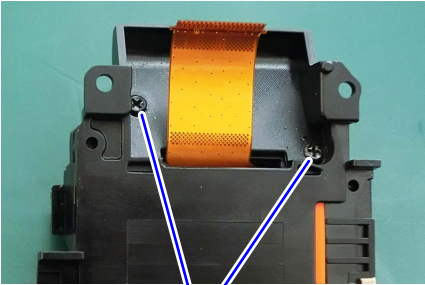
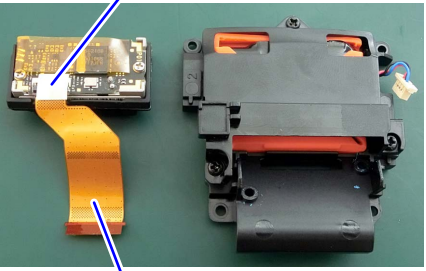
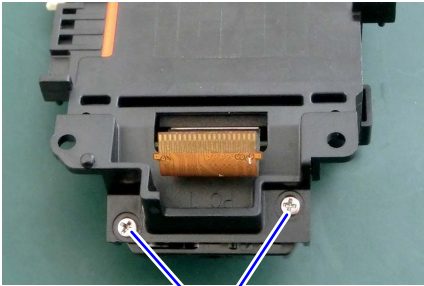
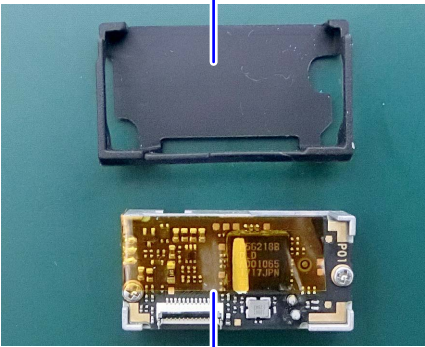
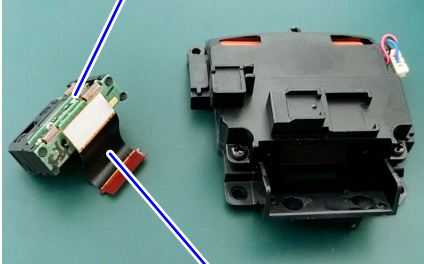


■ SUB BATTERY

Remove the SUB BATTERY in the following order.

<p>DT-X400-10 DT-X400-10-CN DT-X400-10-EU DT-X400-10-RU</p>	<p>DT-X400-20 DT-X400-20-CN DT-X400-20-EU DT-X400-20-RU</p>	<p>DT-X400-C21 DT-X400-C21-EU DT-X400-WC21 DT-X400-WC21-EU</p>
 <p>Screw (S7) Torque: 2.0 ± 0.5 kgf·cm</p> <p>Screw (S6) Torque: 1.5 ± 0.3 kgf·cm</p>	 <p>Screw (S7) Torque: 2.0 ± 0.5 kgf·cm</p> <p>Screw (S6) Torque: 1.5 ± 0.3 kgf·cm</p>	
 <p>BRACKET/LS-S</p>	 <p>BRACKET/2D-S</p>	
<p>[ Note on reassembling ] Pay attention not to pinch the battery cable.</p>		
		
	 <p>SUB-BATTERY</p> <p>HOLDER/SUB-BATTERY</p>	

■ SCANNER BLOCK

DT-X400-10 DT-X400-10-CN DT-X400-10-EU DT-X400-10-RU	DT-X400-20 DT-X400-20-CN DT-X400-20-EU DT-X400-20-RU	DT-X400-C21 DT-X400-C21-EU DT-X400-WC21 DT-X400-WC21-EU
 <p data-bbox="292 678 635 757">Screw (S11) Torque: <math>2.5 \pm 0.5</math> kgf•cm</p>	 <p data-bbox="1050 383 1313 427">PAD/2D-SCAN</p>	
 <p data-bbox="272 801 539 846">TAPE-MIDDLE</p> <p data-bbox="252 1126 560 1171">FPC/LASER-MODULE</p>	 <p data-bbox="946 1093 1289 1171">Screw (S12) Torque: <math>1.0 \pm 0.2</math> kgf•cm</p>	
 <p data-bbox="341 1227 608 1272">HOLDER/LASER</p> <p data-bbox="341 1641 608 1686">LASER-MODULE</p>	 <p data-bbox="906 1272 1173 1317">2D-MODULE</p> <p data-bbox="1018 1597 1284 1641">FPC/2D-MODULE</p>	

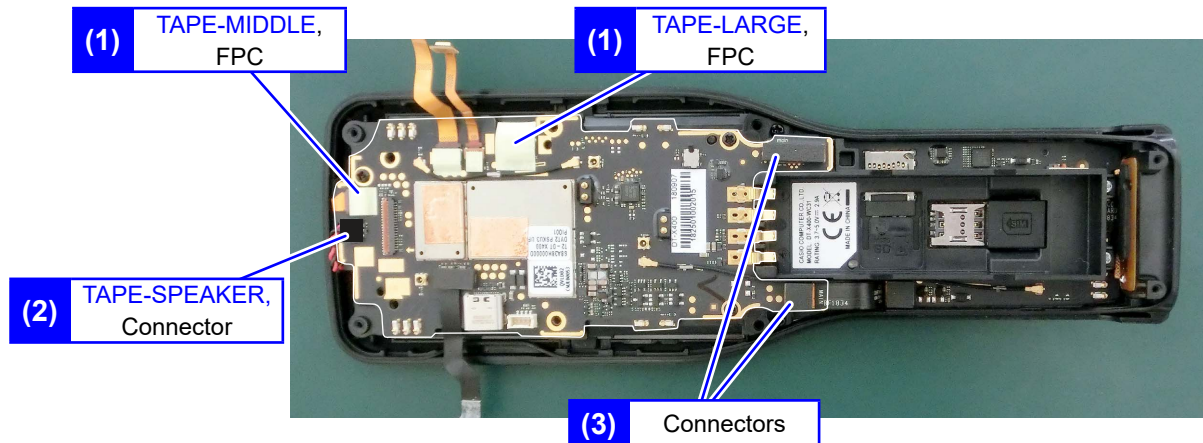


## 4. Removing the MAIN-ASSY

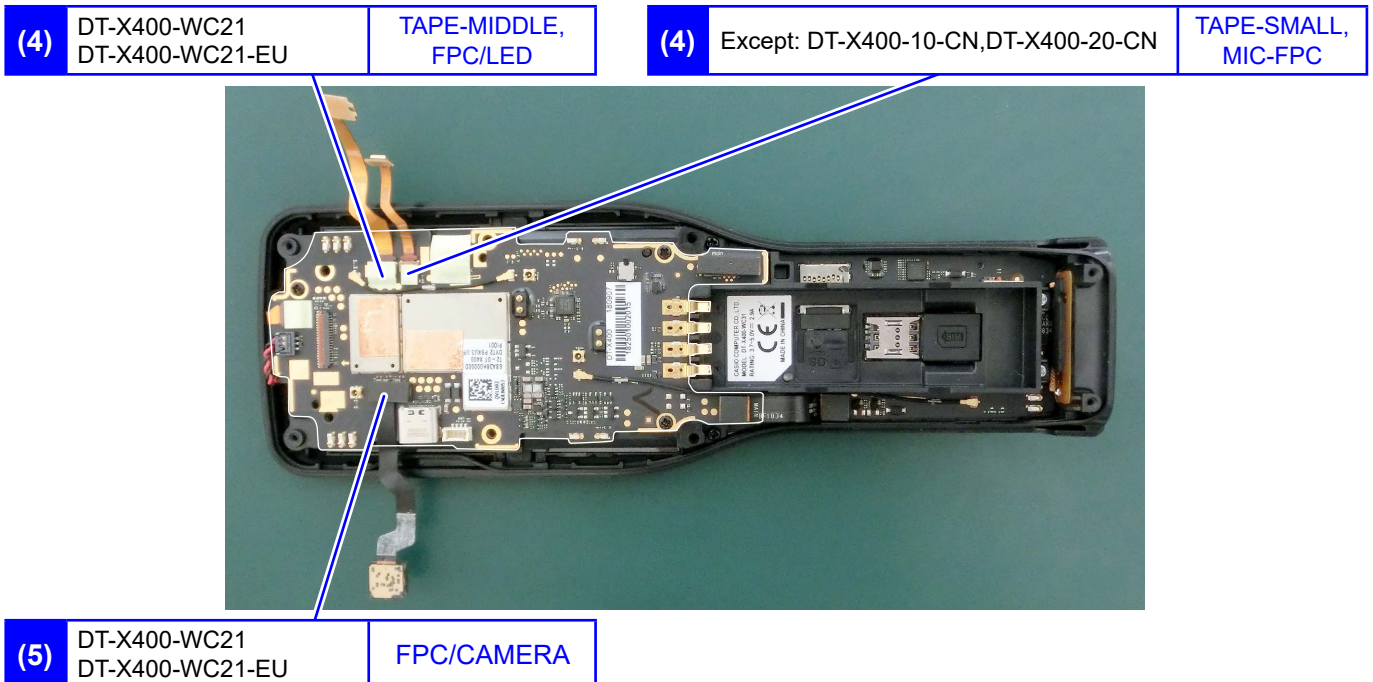
**NOTE:** There are four kinds of tapes, P-TAPE-A (large), P-TAPE-B (middle), P-TAPE-C (small) and PORON TAPE.

- (1) Remove tape and disconnect two FPCs.
- (2) Remove tape and release the connector.
- (3) Release two connectors.

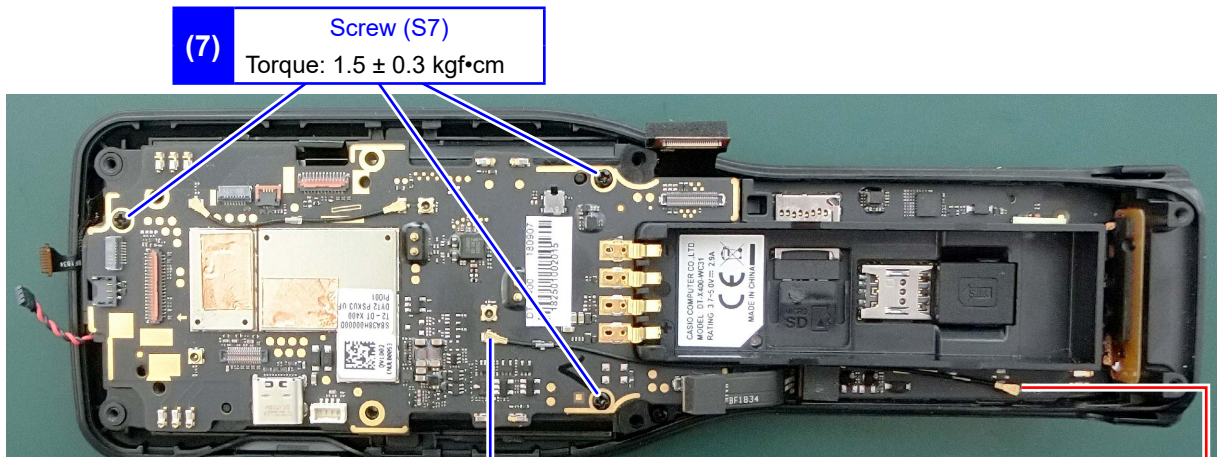
When you do not replace the MAIN-ASSY, go to (6).



- (4) Remove tape and disconnect two FPCs.
- (5) Remove the FPC/CAMERA.



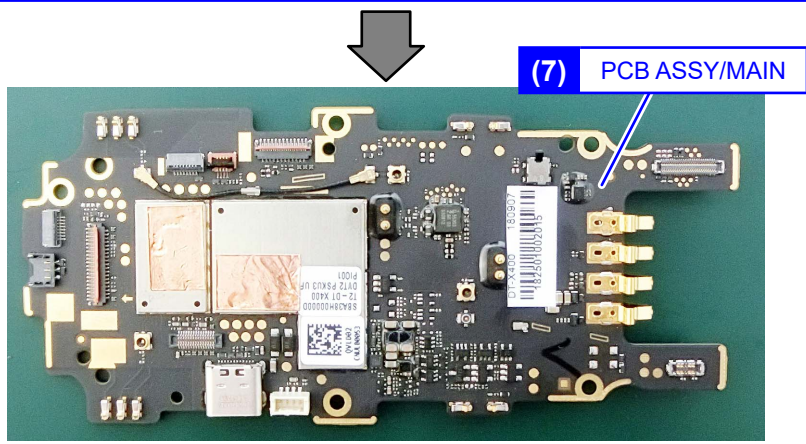
- (6) Remove the CABLE/ANNTENA.
- (7) Undo three screws and then remove the PCB ASSY/MAIN.



<b>(6)</b>	CABLE/ANNTENA	DT-X400-WC21, DT-X400-WC21-EU
<p><b>NOTE:</b> When disconnecting/connecting the connector, use a special jig and disconnect/connect it vertically.</p>		
	<p>When force is applied to one side of the connector using tweezers.</p>	

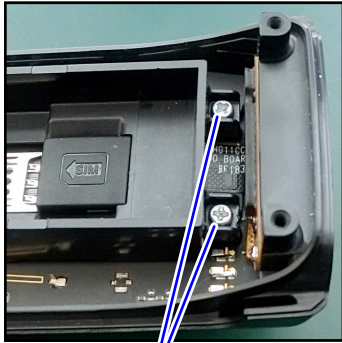
**NOTE:** When the connector of the F-CASE side is to be disconnected/connected, do it after removing the INNER-CASE.

→
**■ F-CASE**



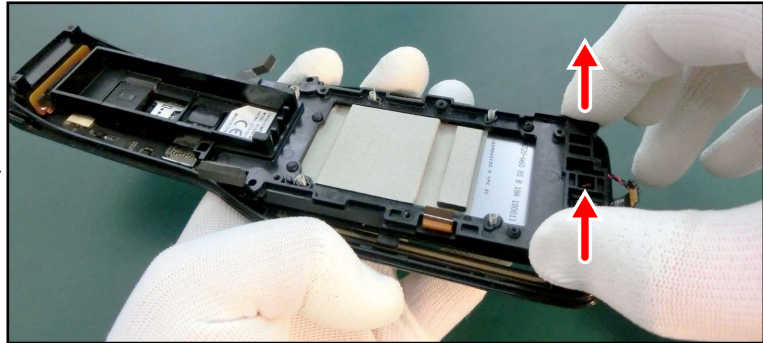
## 5. Removing the INNER-CASE

- (1) Undo two screws and then remove the INNER-CASE.
- (2) Remove the INNER-CASE.

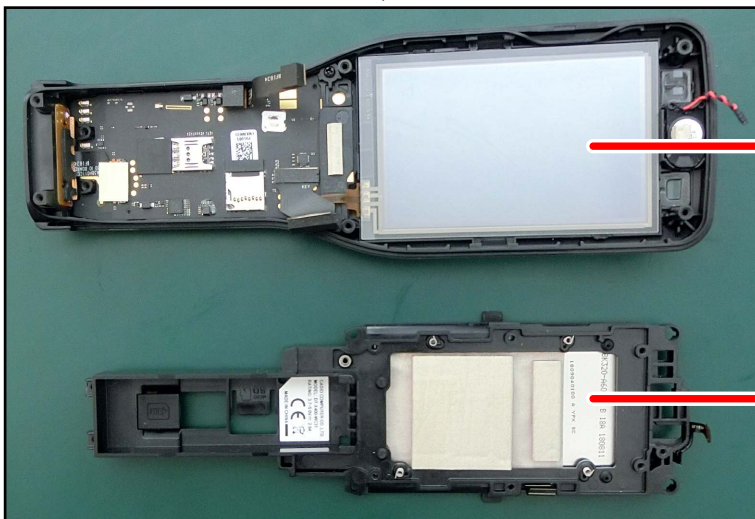


Screw (S10)

Torque:  $2.0 \pm 0.5$  kgf·cm



[ Note on reassembling ] Make sure that no dirt or dust is on the LCD surface.

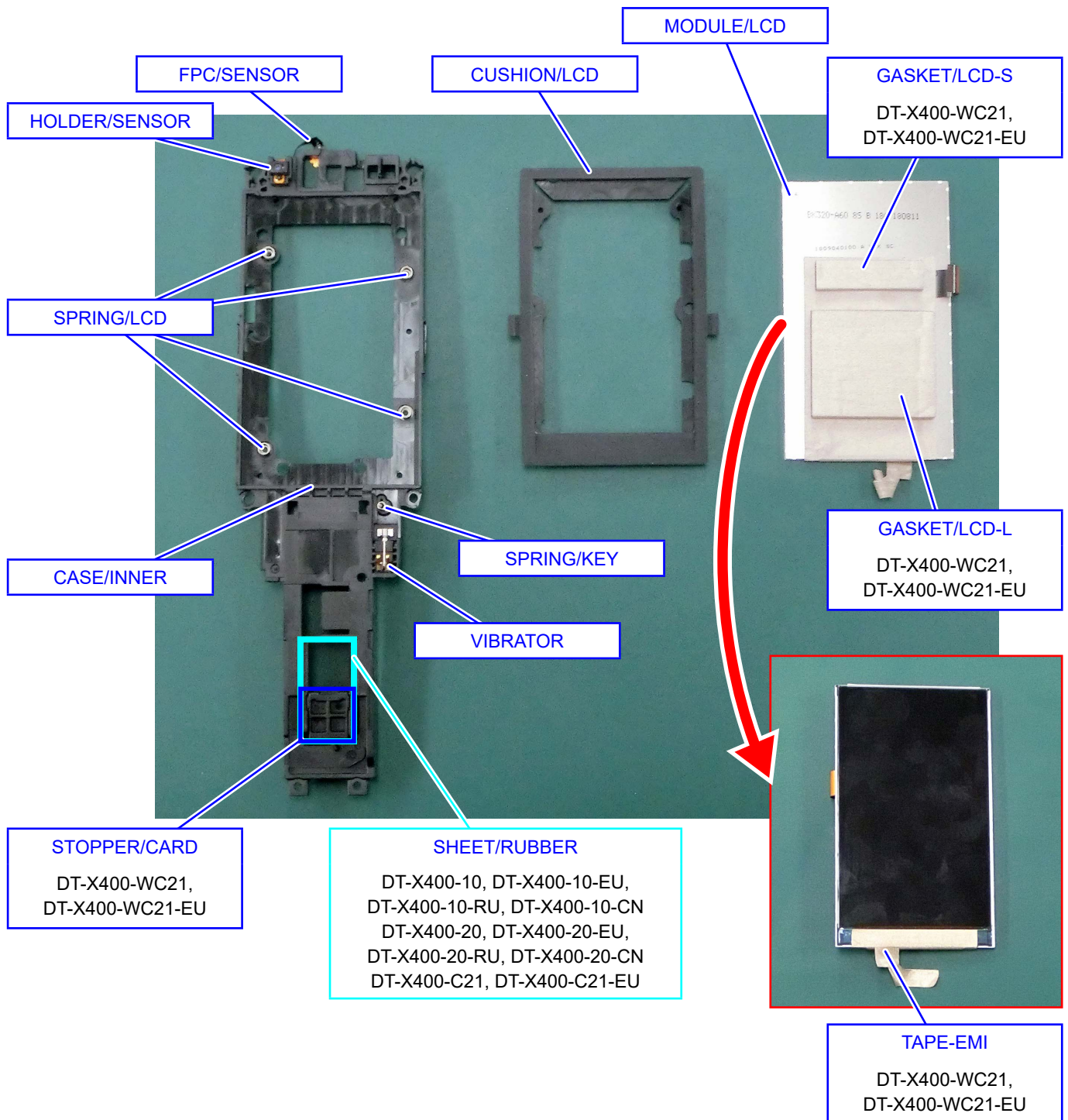


■ F-CASE

■ INNER-CASE



■ INNER-CASE





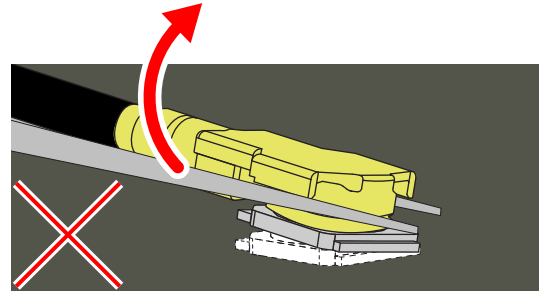
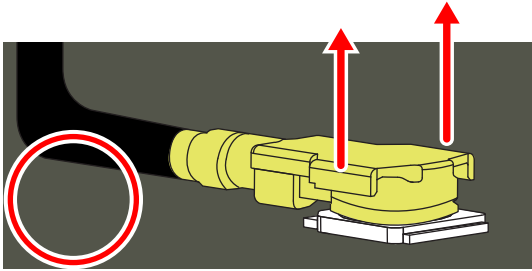
■ F-CASE-ASSY

ANT-CABLE

DT-X400-WC21、DT-X400-WC21-EU

**NOTE:** When disconnecting/connecting the connector, use a special jig and disconnect/connect it vertically.

When force is applied to one side of the connector using tweezers.



**A. F-CASE-ASSY**

HOLDER/MIC

Except: DT-X400-10-CN,DT-X400-20-CN

Screw (S7)  
Torque:  $1.3 \pm 0.3$  kgf·cm

TAPE-SMALL

HOLDER/KEY

GASKET/KEY  
DT-X400-WC21,  
DT-X400-WC21-EU

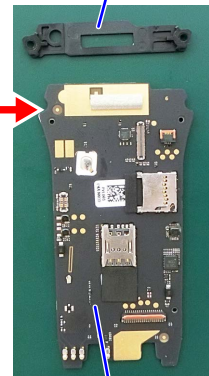
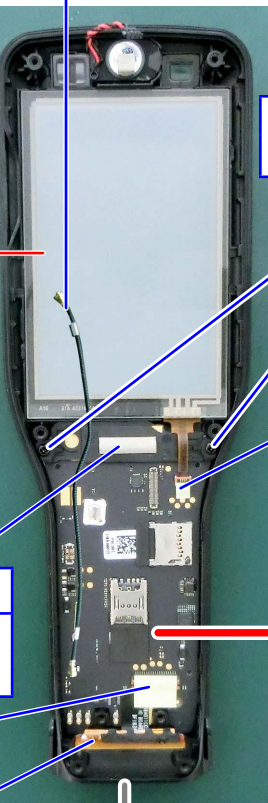
TAPE-LARGE

ASSY/IO



Screw (S8)  
Torque:  $1.0 \pm 0.3$  kgf·cm

PCB ASSY/KEY



**A. F-CASE-ASSY**

