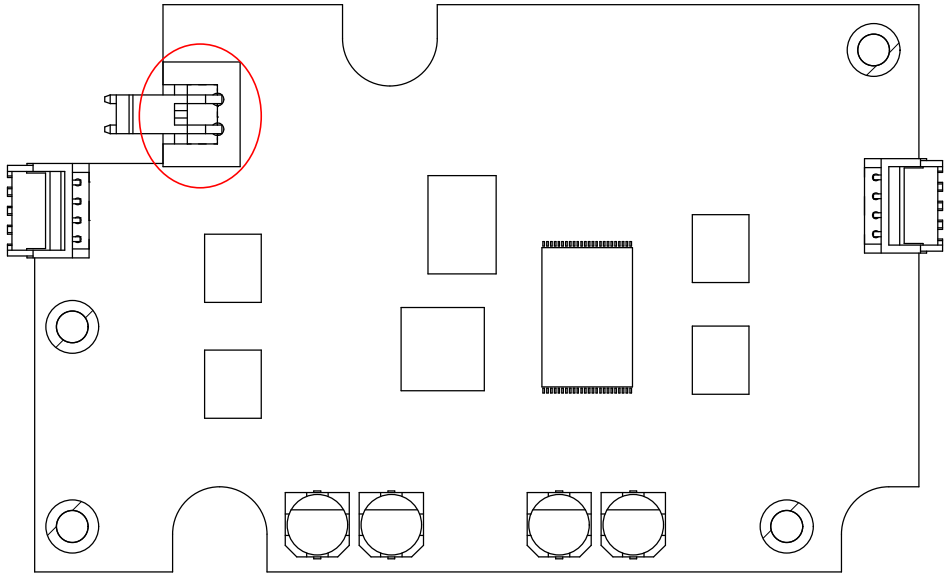
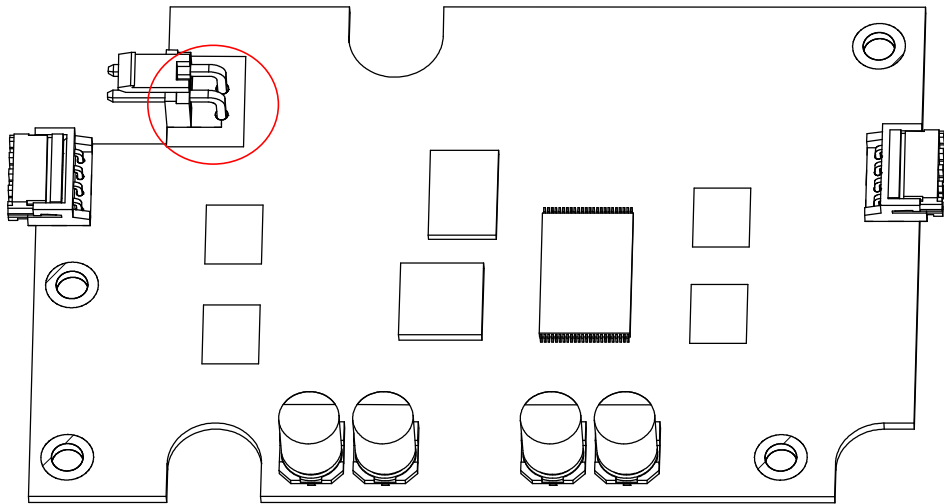
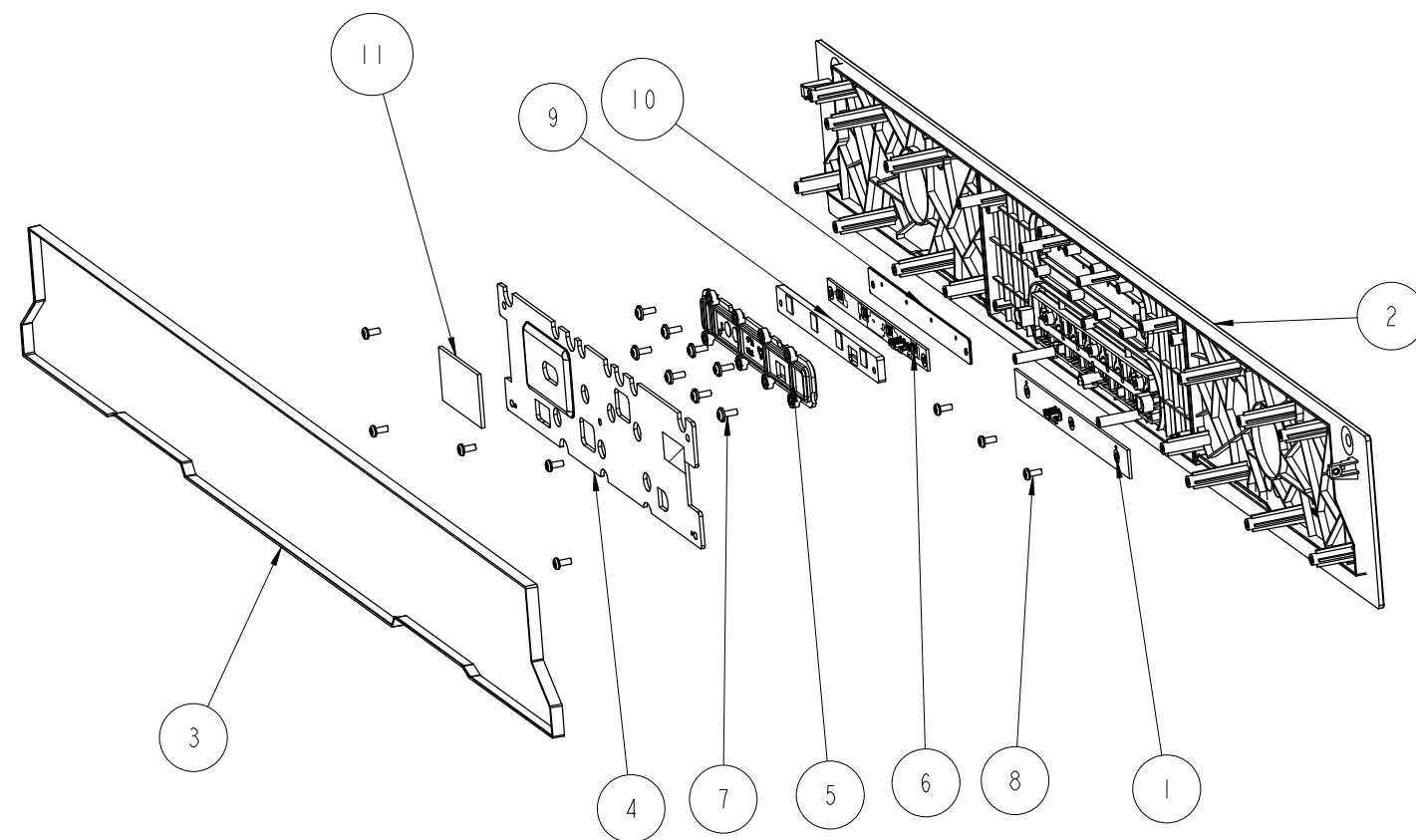


Note:
Fix the capacitor with glue.



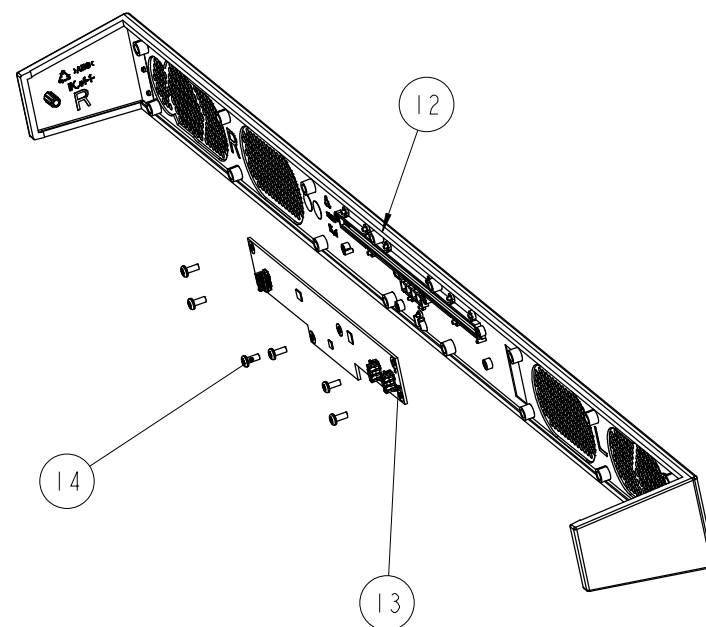
Applying Area: 3 +/- 1mm (Components around)

Top cover Assembly



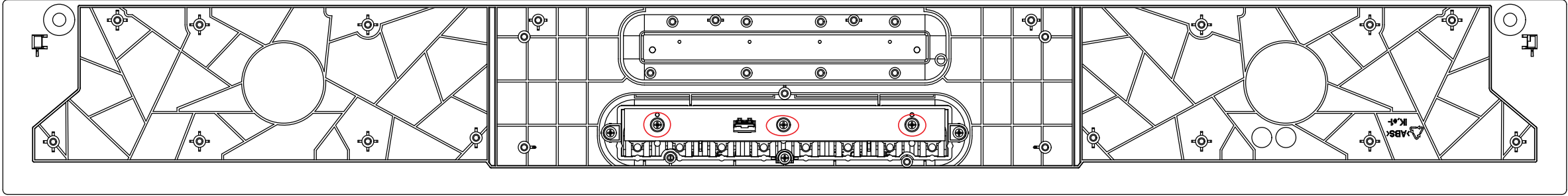
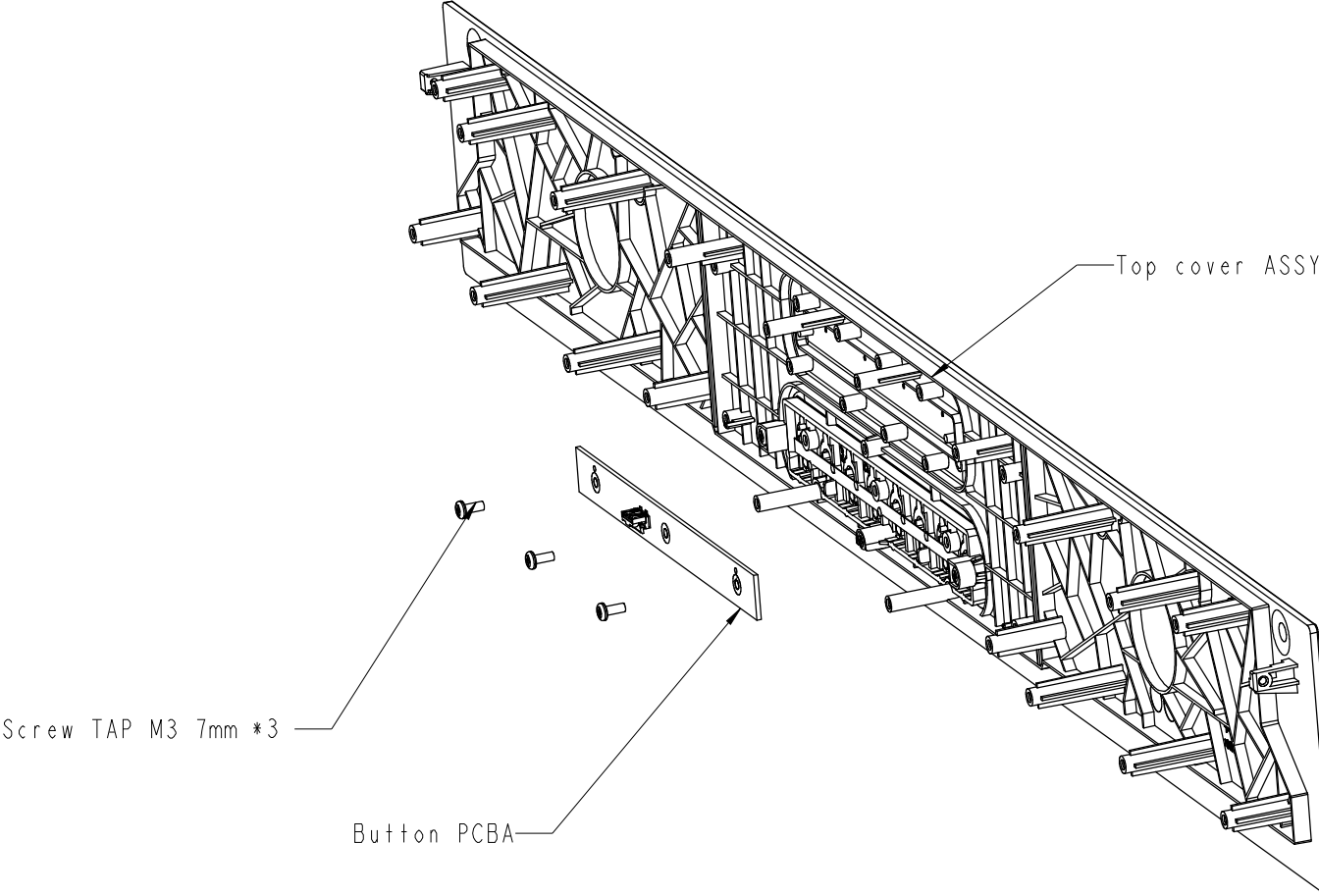
11	THERMAL_PAD_AMP_IC_2	1	
10	SPONGE_MIC_SILICON_ASSY	1	
9	SILICON_MIC_RUBBER	1	
8	SCREW_TTS_3_7	8	
7	SCREW_M3X8	8	
6	MIC_PCB_LINEAR_ASSY	1	
5	HOLDER_BRACKET_MIC_UA300_0330	1	
4	HEATSPREADER_AMP_BOTTOM_ASSY_	1	
3	GASKET_CASE_TOP	6	
2	CASE_TOP_ASM	1	
1	BUTTON_PCB_ASSY_	1	
ITEM	PART NAME	QTY	REMARK

Front cover Assembly

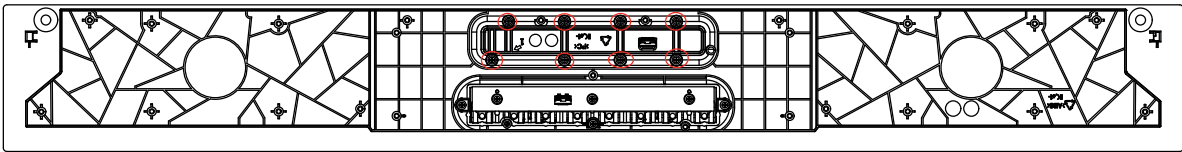
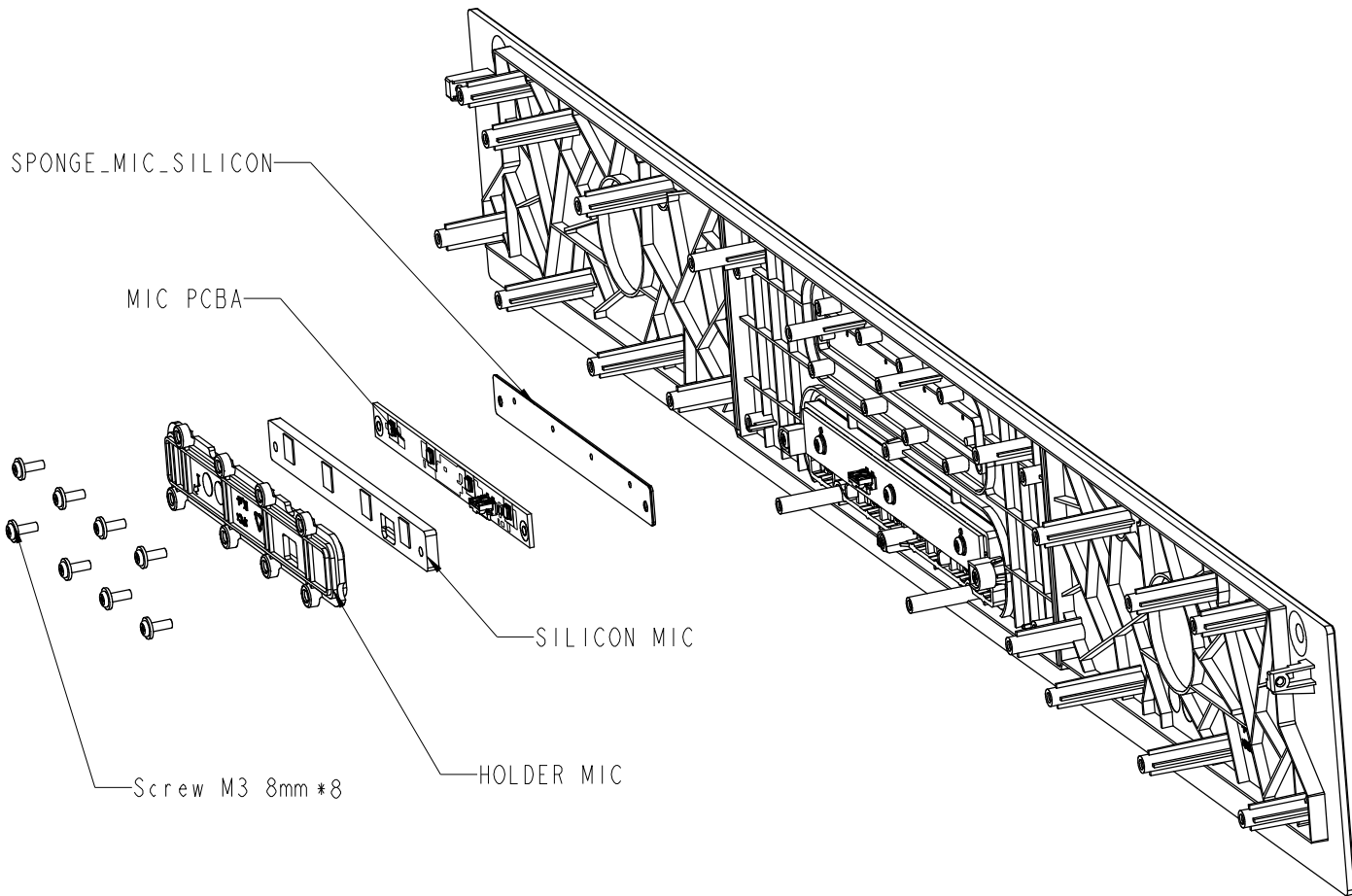


14	SCREW_TTS_3_7	6	
13	LED_PCB_ASSY	1	
12	RRILL_FABRIC_ASSY	1	
ITEM	PART NAME	QTY	REMARK

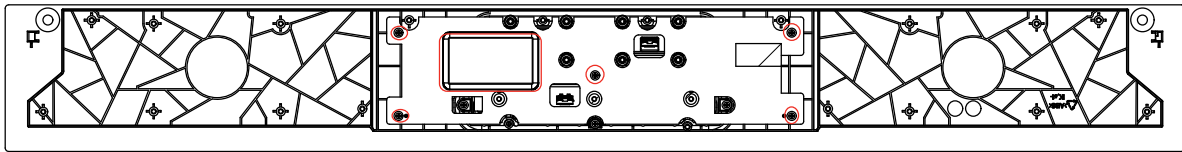
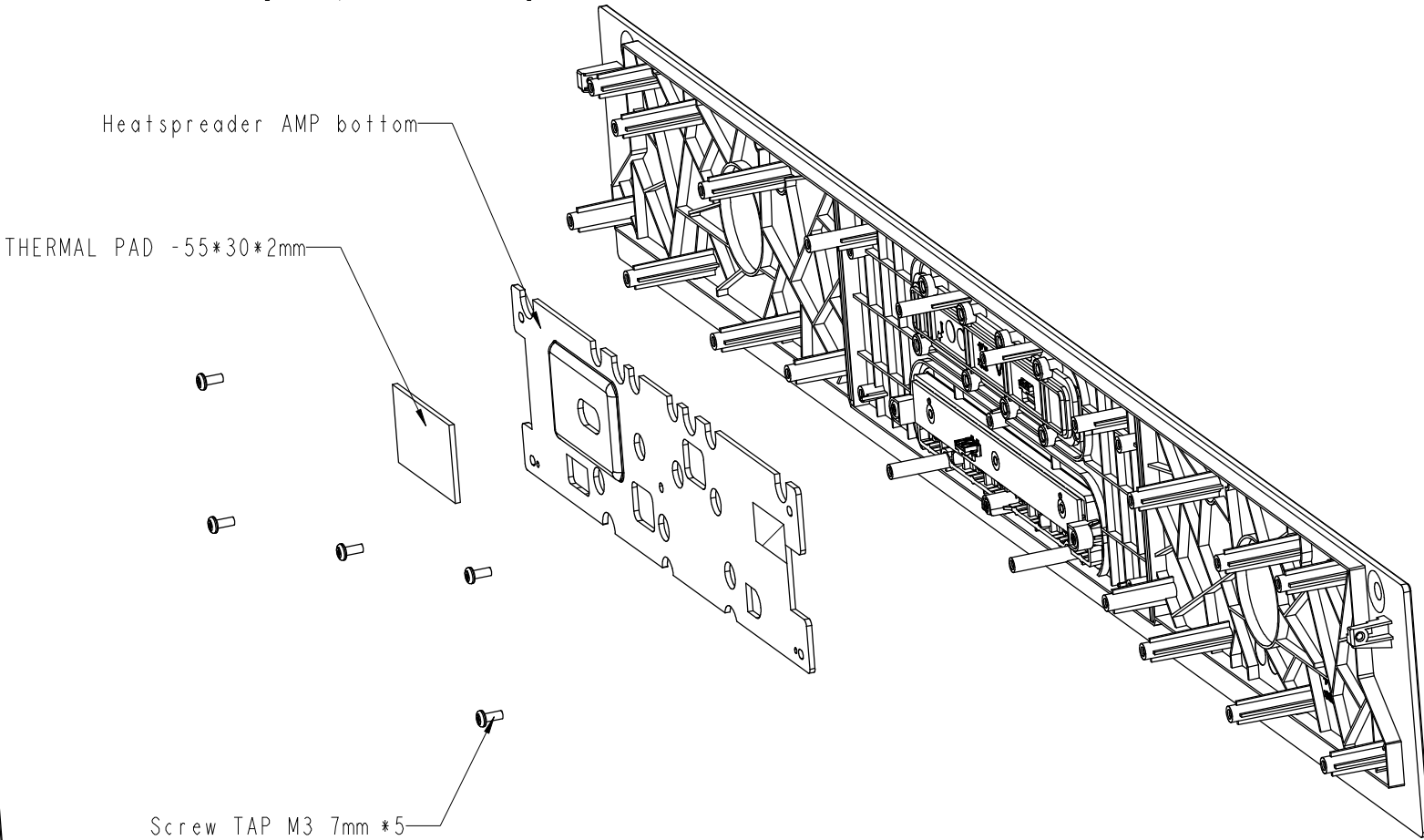
Step 1: Fix the Button PCBA to Button function with 3 screws.
Locking torque: 3.5±0.5 kgf*cm



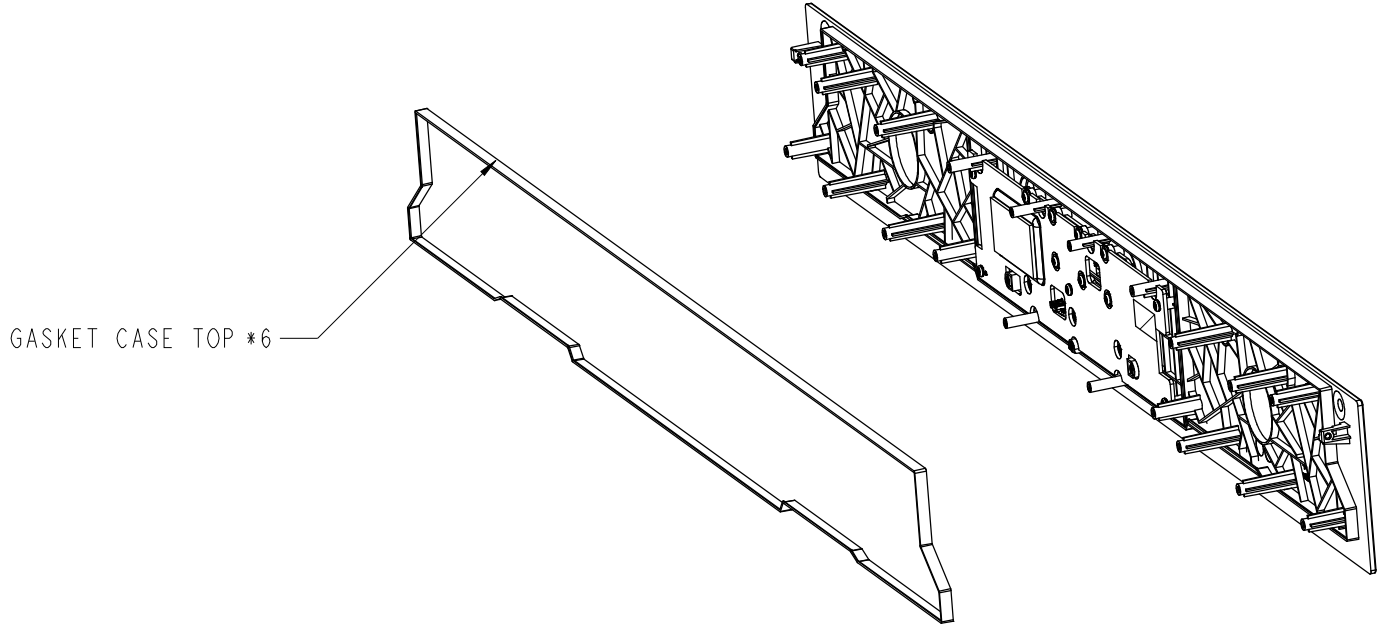
Step 2: Assemble rubber·MIC PCBA·holder on Top cover as shown below,
and fix the holder to Top function with 8 screws.
Locking torque: 3.5±0.5 kgf*cm



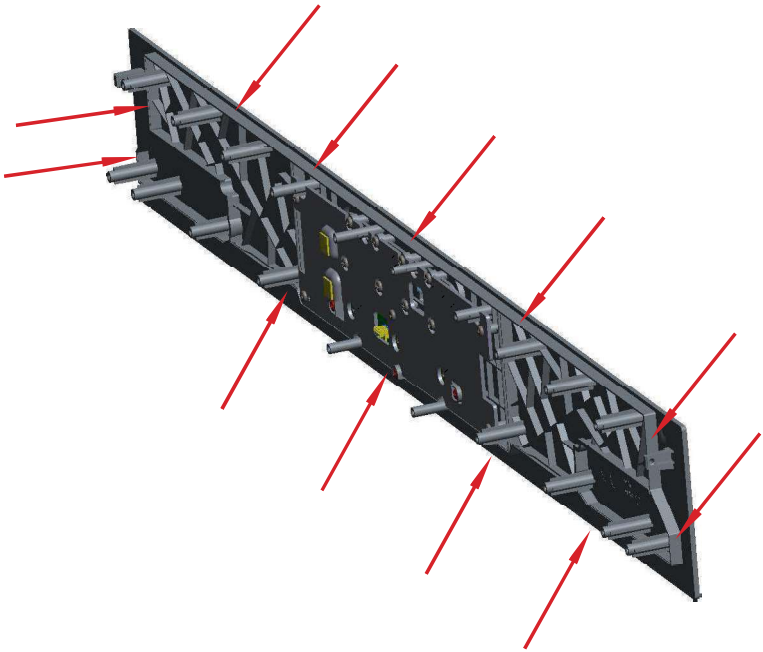
Step 3: Fix the Heatspreader AMP Bottom to Top cover with 5 screws and
assemble the thermal pad to heatspreader.
Locking torque: 3.5±0.5 kgf*cm



Step 4: Stick the Gaske to Top cover .



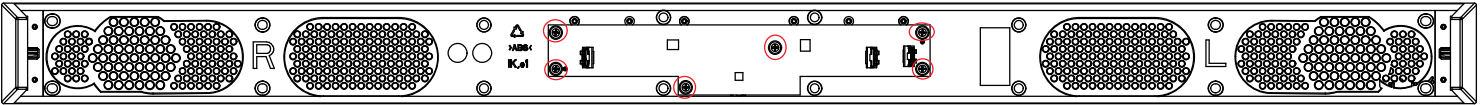
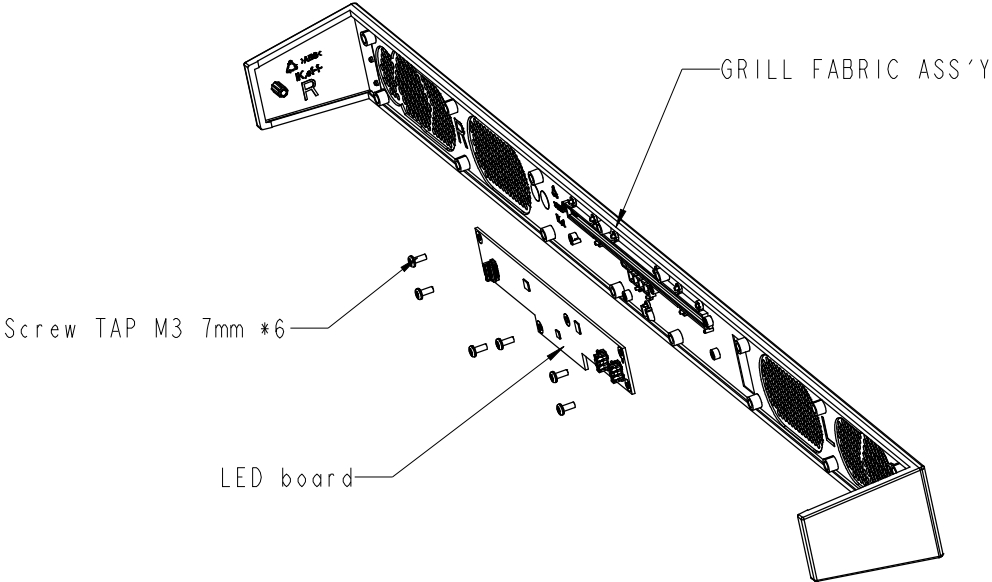
Gasket position



MIC hole should be clear

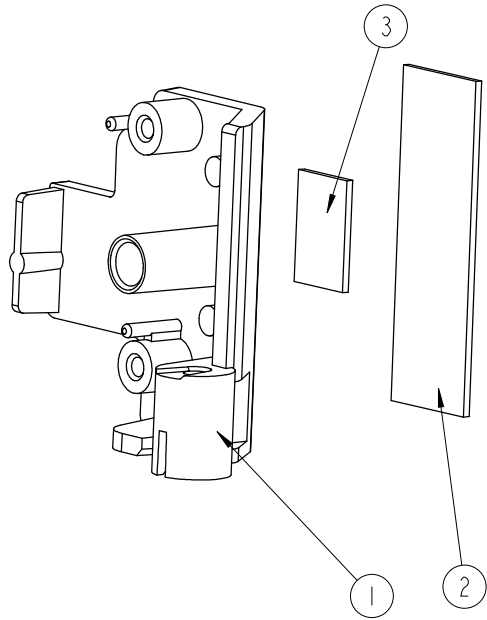


Step 5: Fix the LED Board to Grill Fabric ASS'Y with 6 screws.
Locking torque: 3.5±0.5 kgf*cm



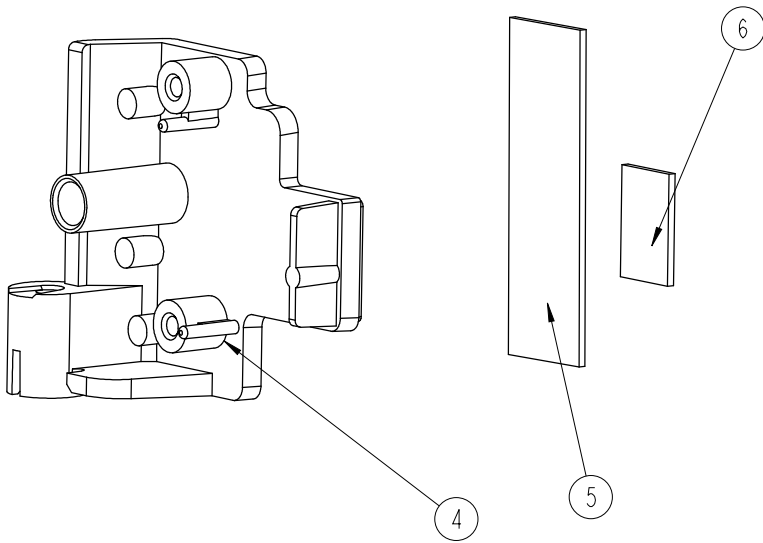
Side LED board Assembly

SIDE LED LEFT



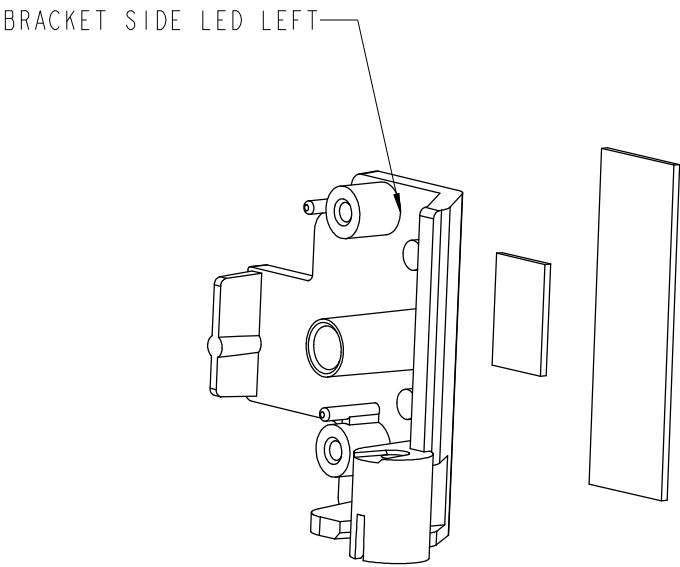
3	GASKET_B	1	
2	GASKET_A	1	
1	BRACKET_RIGHT_SIDE_LED_0319	1	
ITEM	PART NAME	QTY	REMARK

SIDE LED RIGHT

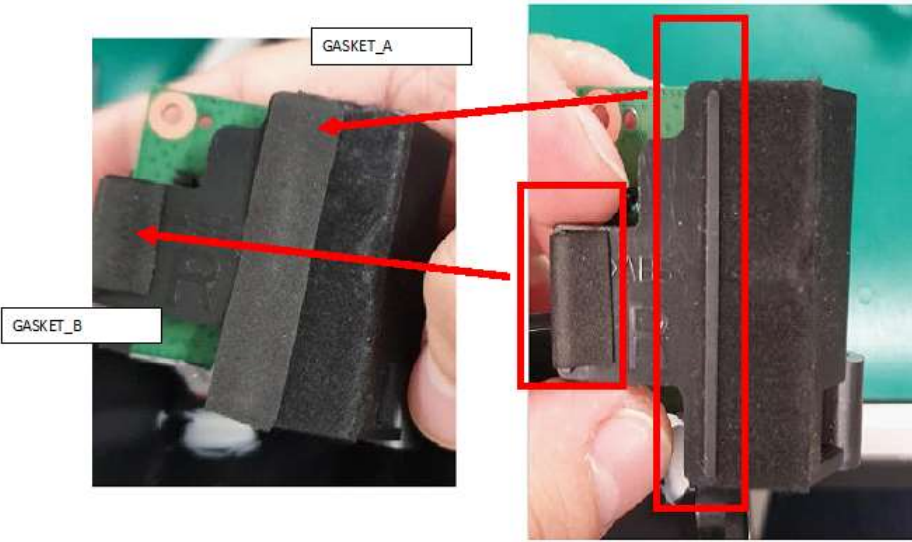
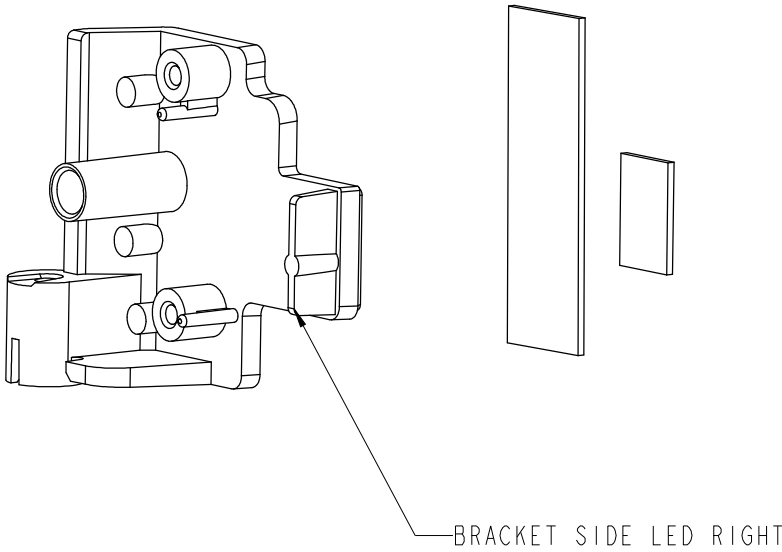


6	GASKET_B	1	
5	GASKET_A	1	
4	BRACKET_LEFT_SIDE_LED_0330	1	
ITEM	PART NAME	QTY	REMARK

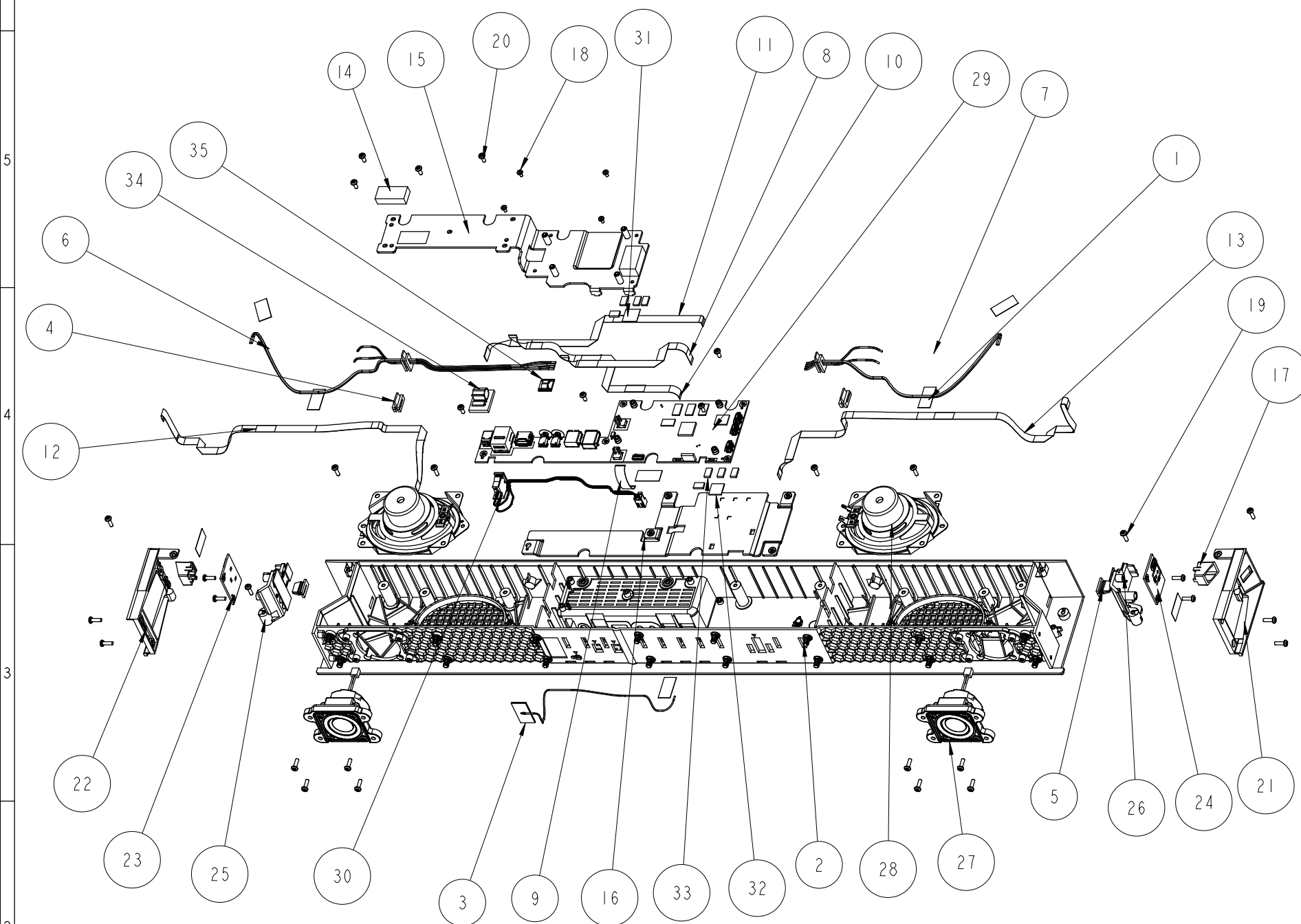
Step 6: Snap the Gasket A and Gasket B to BRACKET.



Step 7: Snap the Gasket A and Gasket B to BRACKET.

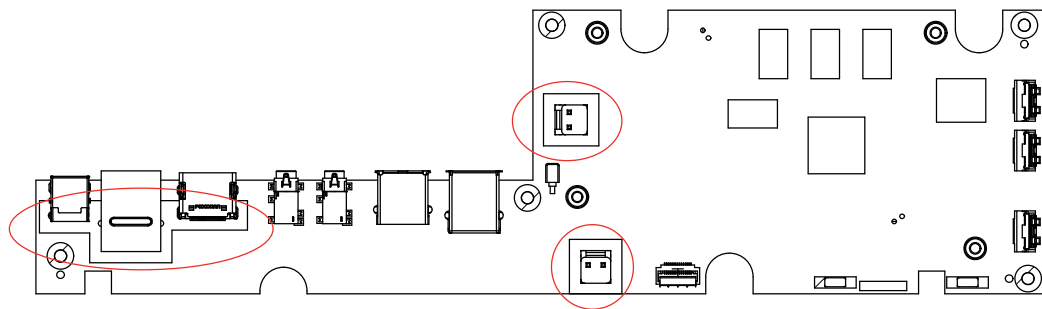
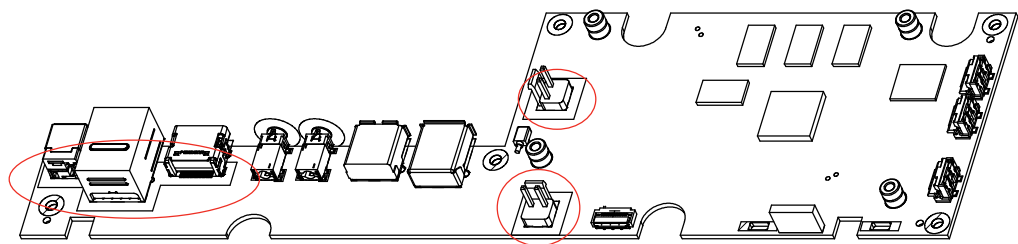


Bottom cover Assembly



35	WIRE_SADDLE-1	1	
34	WIRE_MOUNT	1	
33	THERMAL_PAD_03	8	
32	THERMAL_PAD_02_BOTTOM_CPU_35	1	
31	THERMAL-PAD-01	1	
30	SWITCH_CABLE_INT	1	
29	SWAN_PCB_ASSEMBLY	1	
28	SPEAKER_UNIT_MIDRAGNE_	2	
27	SPEAKE_UNIT_TWEETER_	2	
26	SIDE_PCBA_BRACKET_RIGHT_ASSY	1	
25	SIDE_PCBA_BRACKET_LEFT_ASSY	1	
24	SIDE_LED_PCB_RIGHT_ASM	1	
23	SIDE_LED_PCB_LEFT_ASM	1	
22	SIDE_DECO_LEFT_ASSY	1	
21	SIDE_DECO_ASSY_RIGHT	1	
20	SCREW_TTS_3_7	9	
19	SCREW_TTS_3_10	24	
18	SCREW-M2_5-5MM	4	
17	LIGHT_PIPE_SIDE_LED	2	
16	HEATSPREADER_BOTTOM_SOC_ASSY_AS	1	
15	HEAT_SPREADER_TOP_SOC_ASSY	1	
14	GASKET-ELECTIC	1	
13	FPC_SIDE_PCB_RIGHT	1	
12	FPC_SIDE_PCB_LEFT	1	
11	FPC_LED_BOARD	1	
10	FPC_CABLE_MIC	1	
9	FPC_CABLE_AMP_SOC	1	
8	FPC_BUTTON_PCB	1	
7	CABLE_SPEAKER_RIGHT	1	
6	CABLE_SPEAKER_LEFT	1	
5	BUSING_CABLE_OUT_SIDE	2	
4	BUSING_CABLE_INNER_SIDE	2	
3	BT_ANT_DUAL	1	
2	BOTTOM_COVER_ASY	1	
1	ACETIC_TAPE_25X12_5	8	
ITEM	PART NAME	QTY	REMARK

Note:
a. Fix the capacitor with glue.
b. Fix the cable-SOC-AMP\switch with glue.

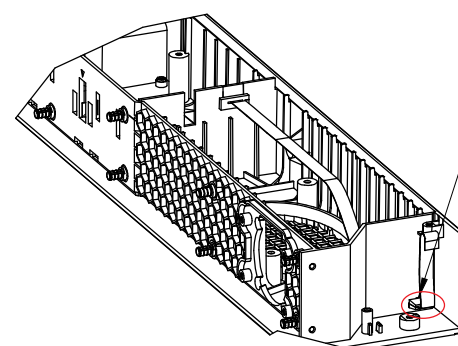
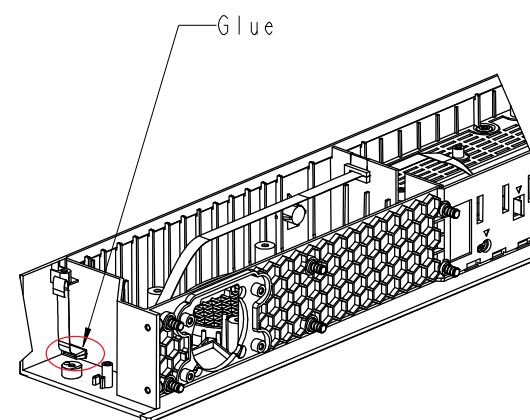
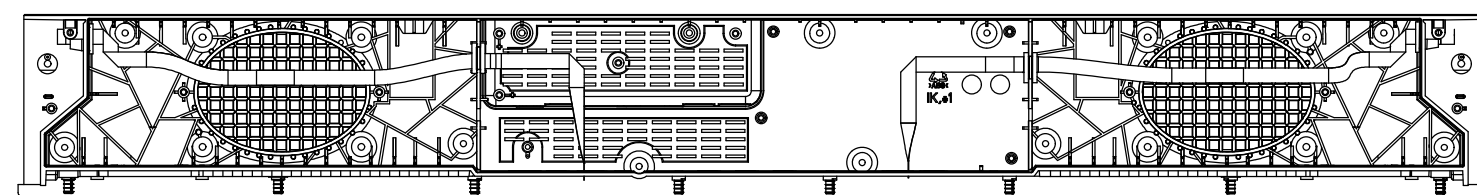
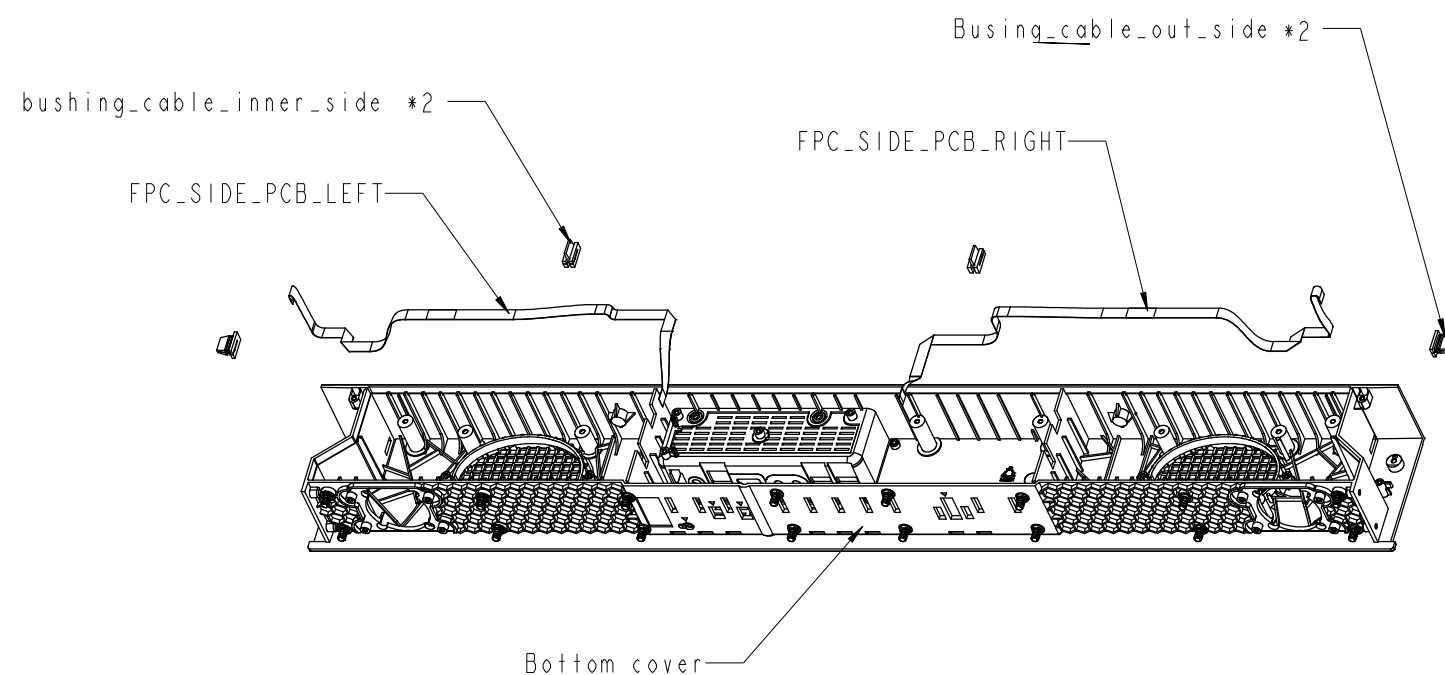


Applying Area: 3 +/- 1mm (Components around)



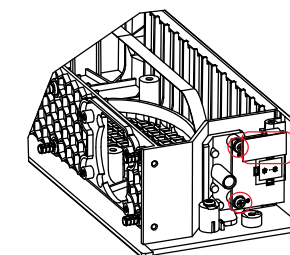
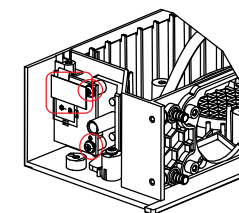
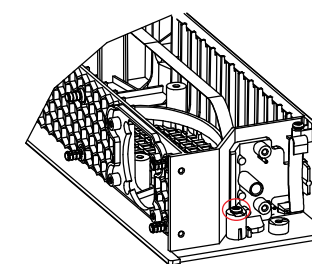
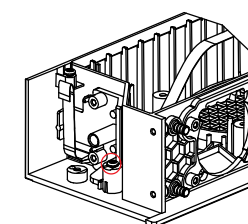
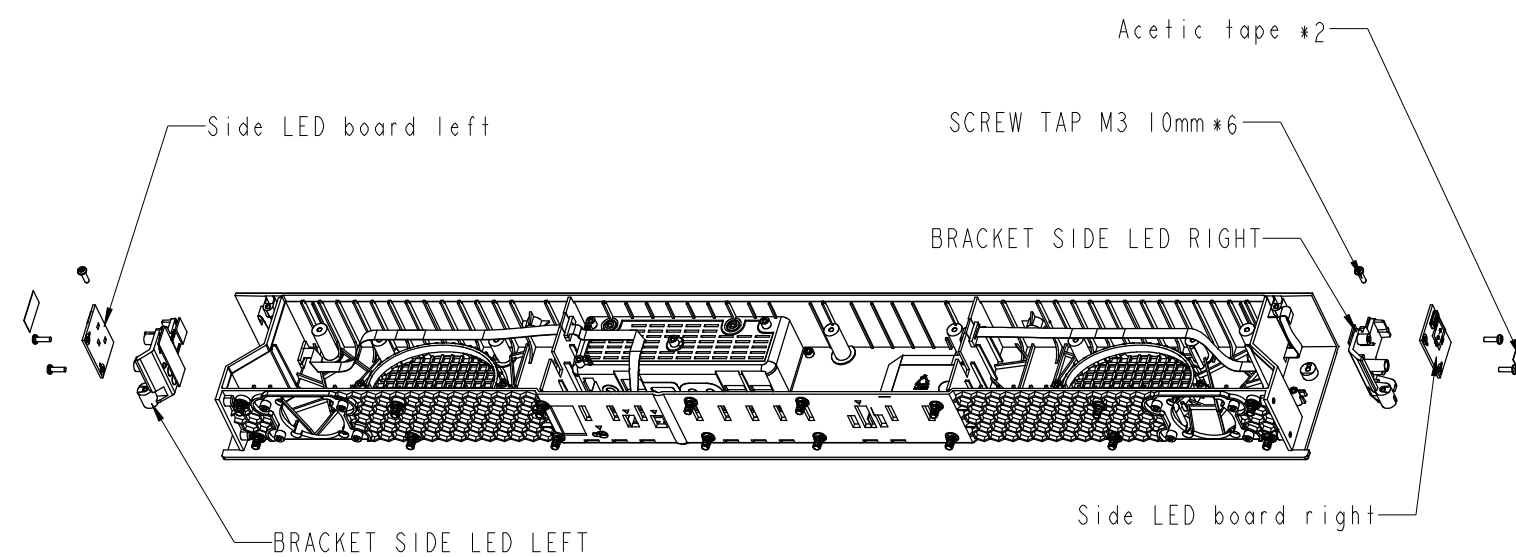
Step 8:

- Make the FPC_SIDE_PCB pass through the bottom cover and assemble the Busing to FFC cable as indicated.
- Assemble the Busing to bottom cover as indicated.
- Seal the Busing with glue.

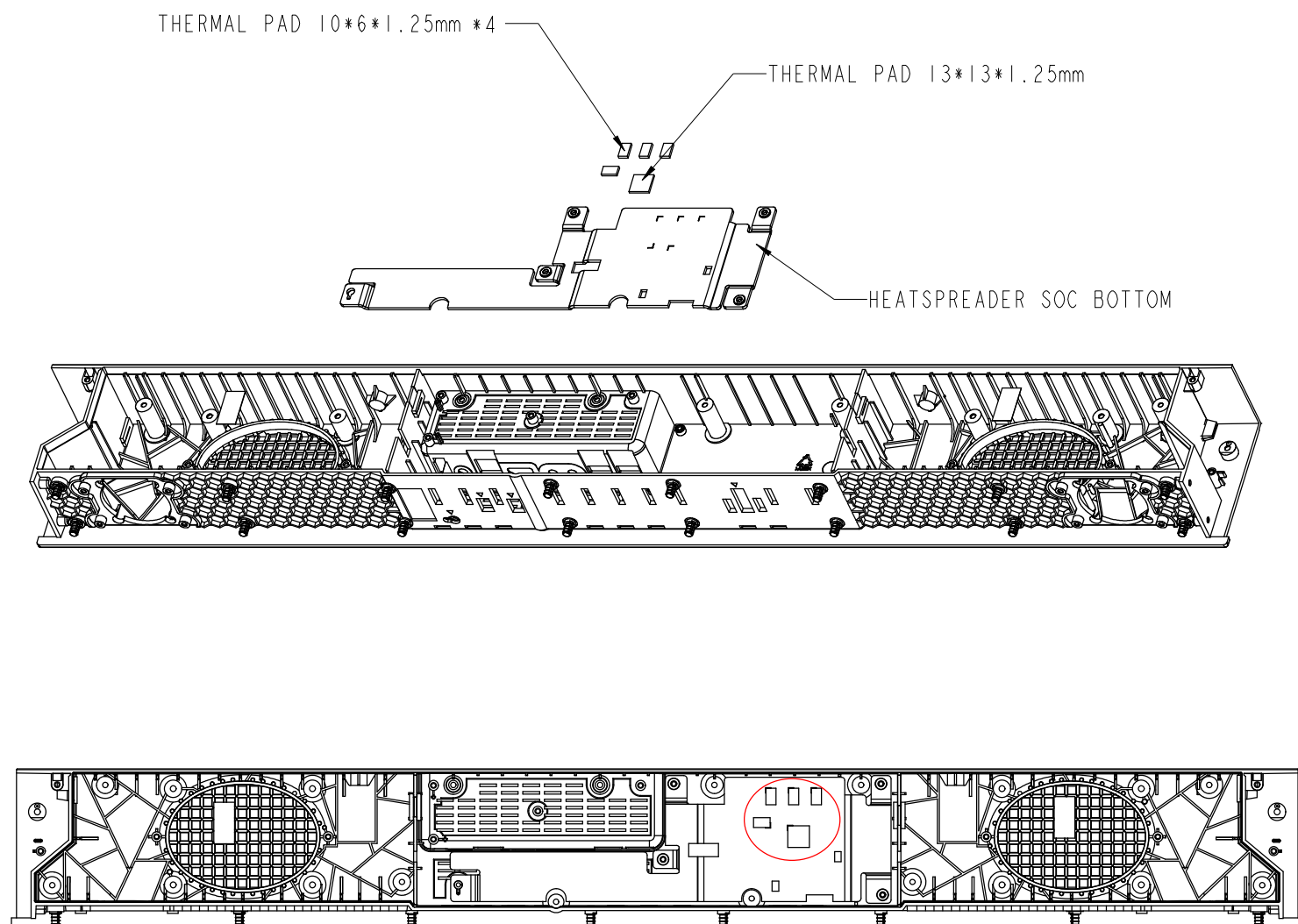


Step 9:

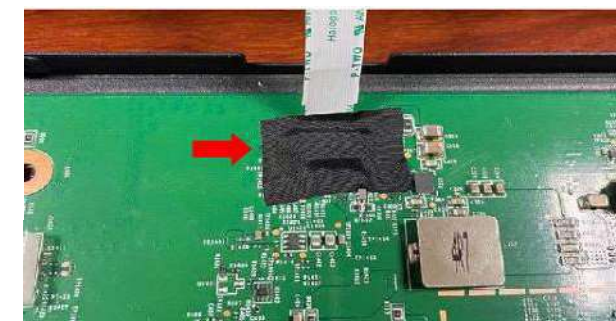
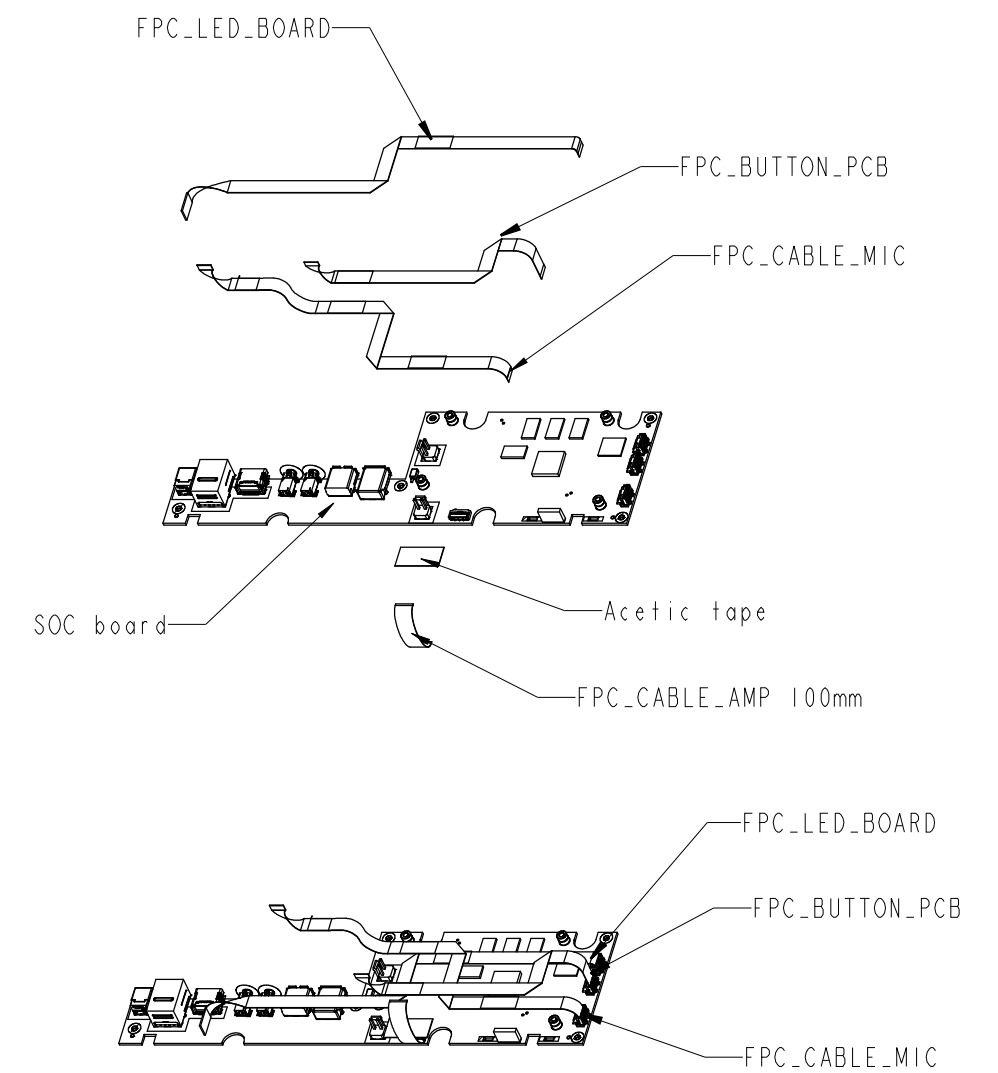
- Fix the BRACKET_SIDE_LED to Bottom cover with 1 screw.
Locking torque: 3.5 ± 0.5 kgf*cm.
- Assemble the FFC cable to SIDE_LED_BOARD with Acetic tape as indicated.
- Fix the Side LED board to BRACKET_SIDE_LED with 2 screws.
Locking torque: 3.5 ± 0.5 kgf*cm



Step 10:
Assemble the heatspreader to bottom cover, and stick the thermal pad to heatspreader.

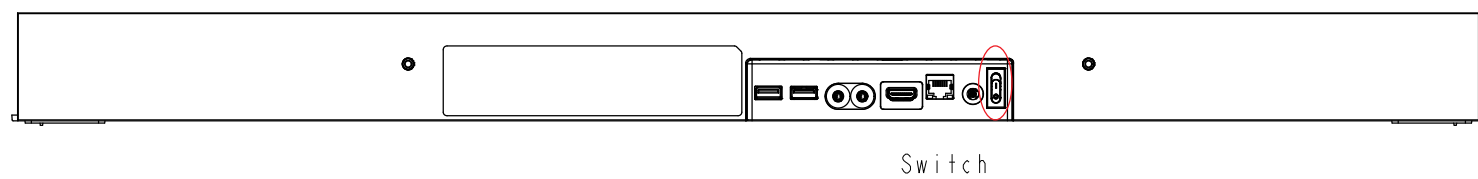
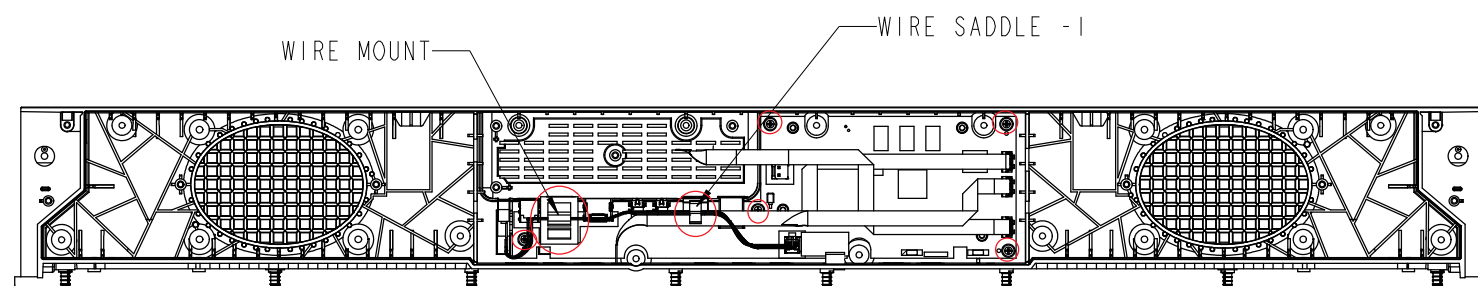
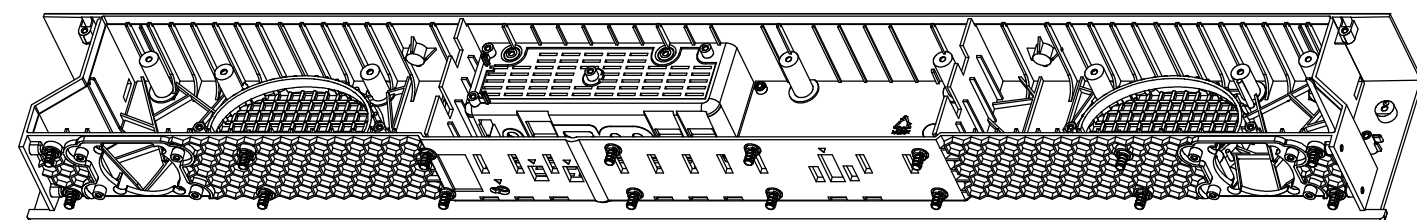
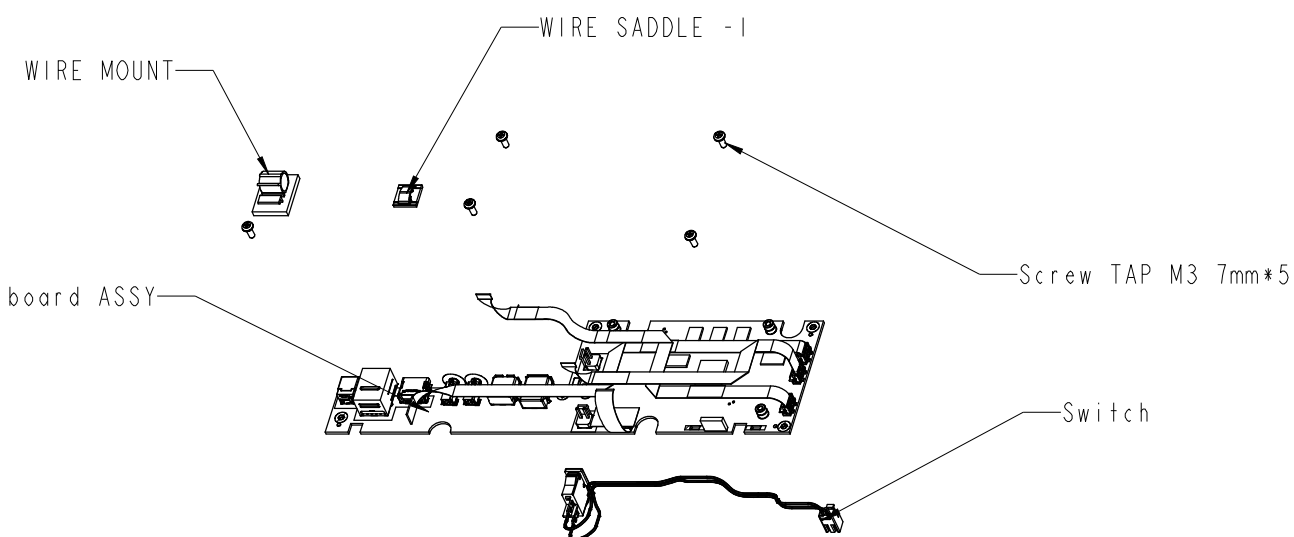


Step 11:
a. Assemble the FFC cable to SoC board as indicated.
b. Fix the FFC cable_AMP to SoC board with Acetic tape.



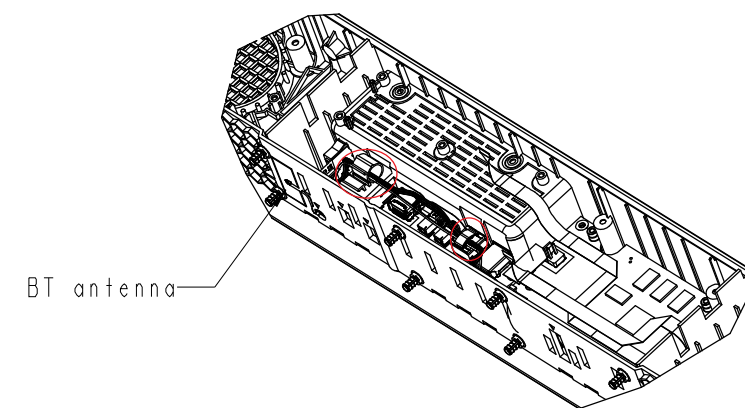
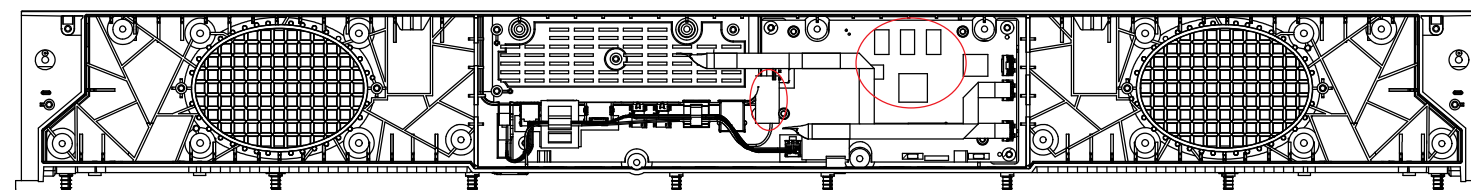
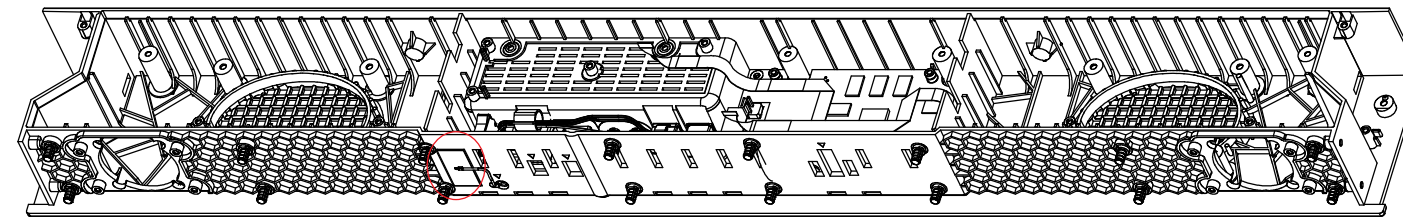
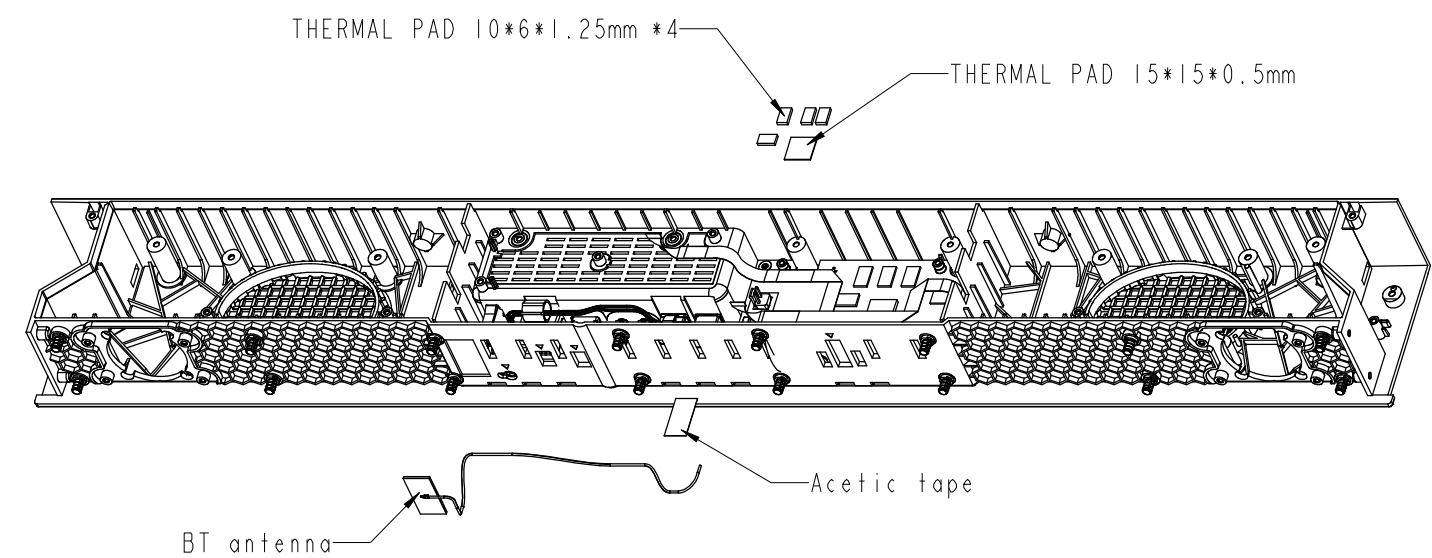
Step 12:

- Assemble the Switch to bottom cover.
 - Fix the SoC board to bottomcover with 5 screws.
- Locking torque: $3.5 \pm 0.5 \text{ kgf} \cdot \text{cm}$
- Stick the WIRE MOUNT and WIRE SADDLE-1 to SoC board.
 - Snap the switch cable to SoC board as indicated.



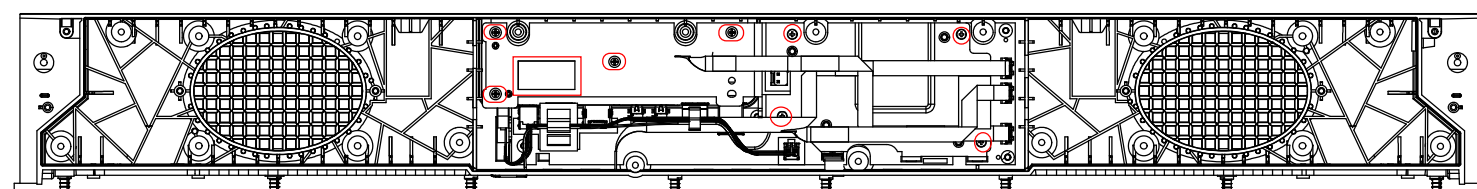
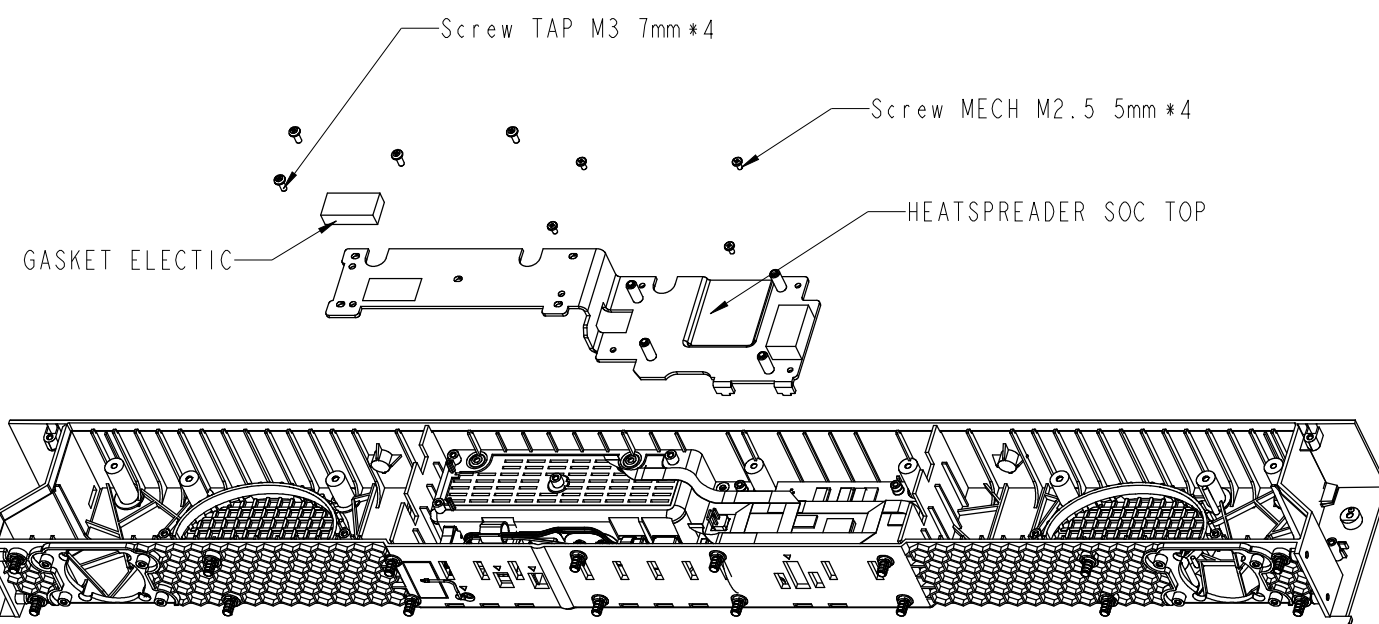
Step 13:

- Stick the BT antenna to Bottom cover.
- Make the BT antenna pass through the bottom cover, and snap the BT antenna to SoC board as indicated
- Fix the BT antenna to SoC board with and Acetic tapes.
- Make the switch cable and BT antennapass through the WIRE MOUNT and WIRE SADDLE-1.



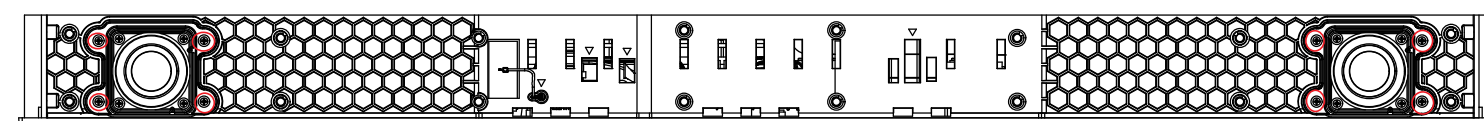
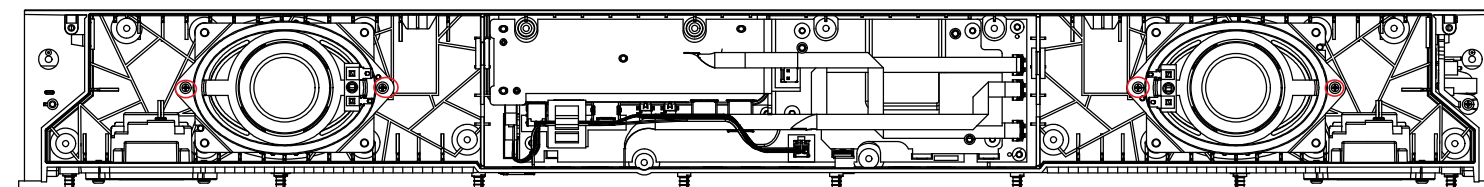
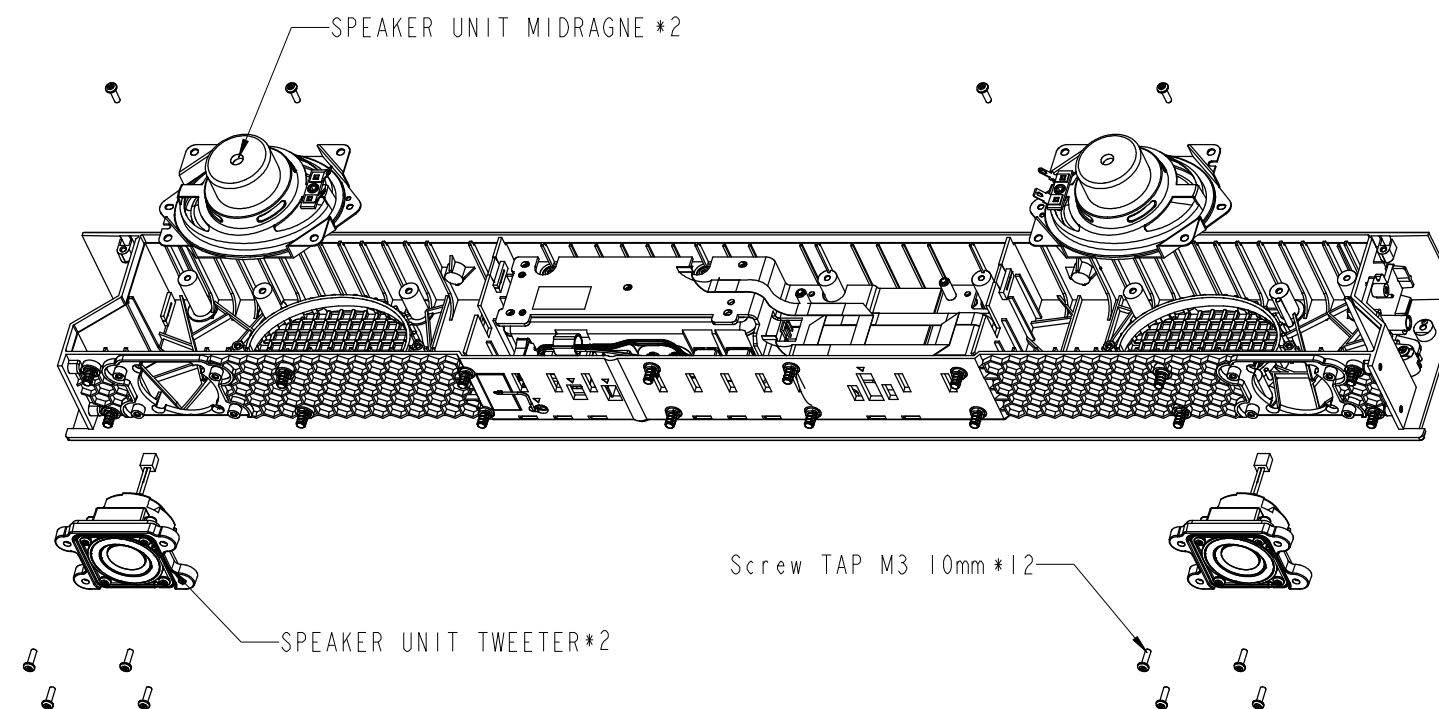
Step 14:

- Fix the HEATSPREADER ScC top to ScC board with 4 screws.
Locking torque: 3.5 ± 0.5 kgf*cm
- Fix the HEATSPREADER ScC top to bottom cover with 4 screws.
Locking torque: 3.5 ± 0.5 kgf*cm
- Stick the GASKET ELECTIC to heatspreader.

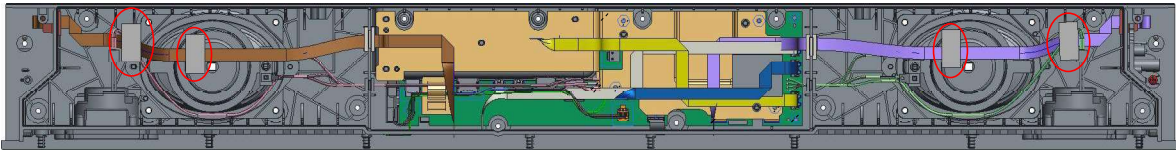
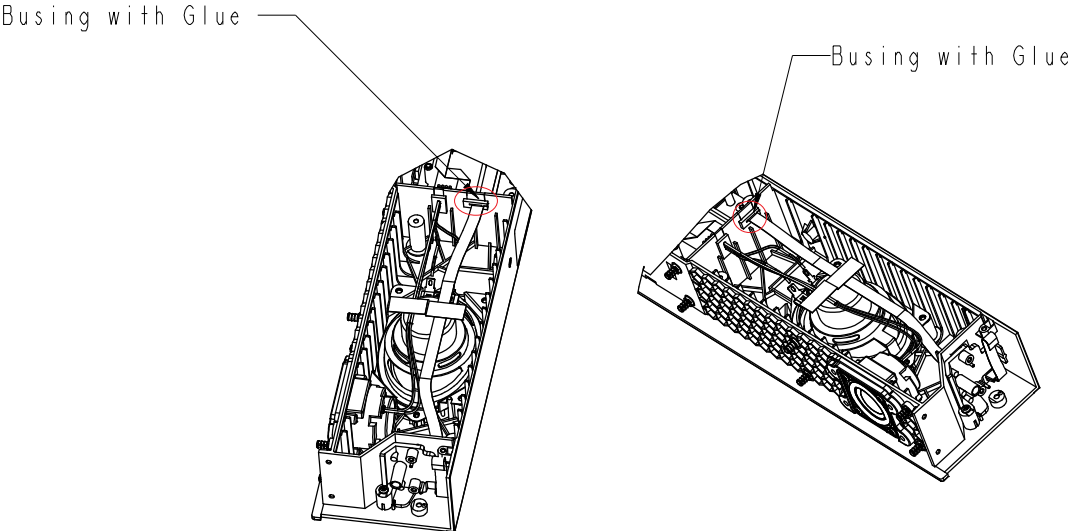
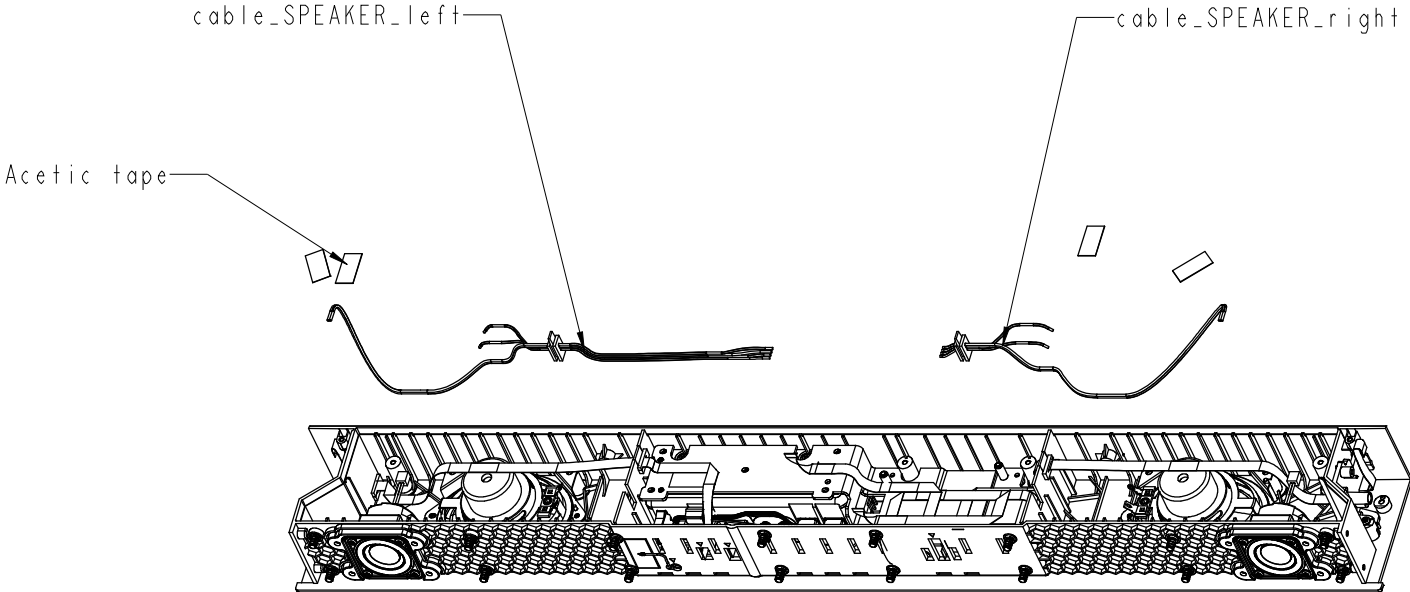


Step 15:

- Fix the Spreaker to Bottom cover with 12 screws as indicated..
Locking torque: 3.5 ± 0.5 kgf*cm

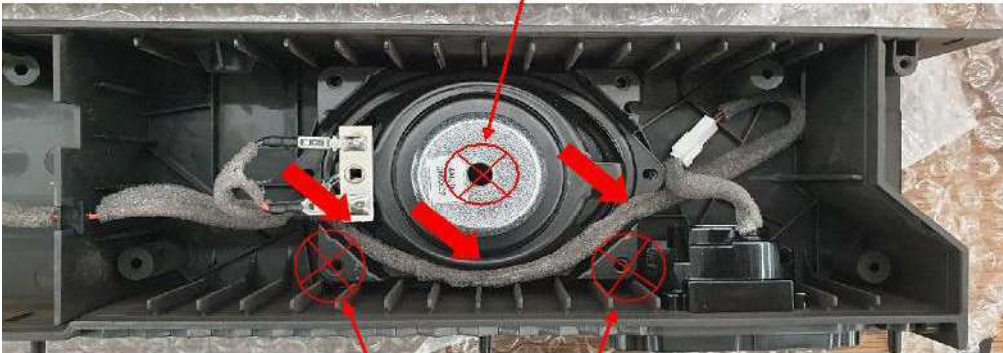


- Step 16:
- a. Assemble the speaker cable to speaker.
 - b. Fix the FFC cable and speaker cable to speaker with 4 Acetic tape as indicated.
 - c. Assemble the Busing to bottom cover as indicated.
 - d. Seal the Busing with glue.



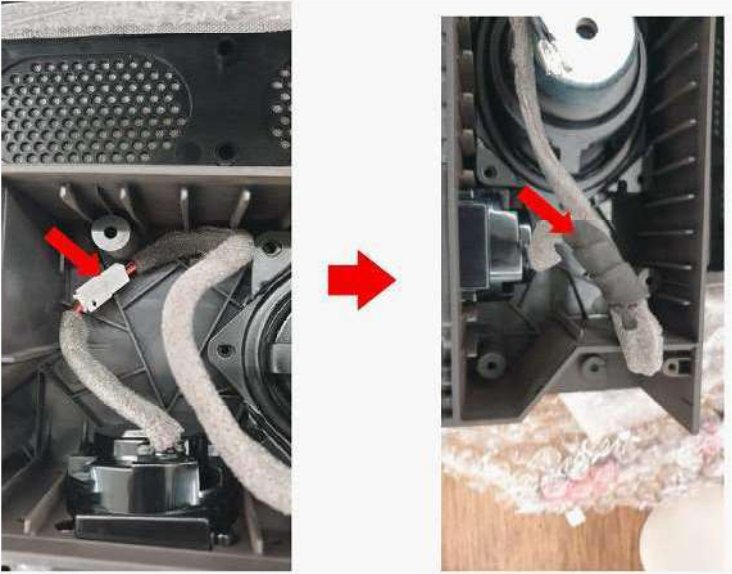
Recommend this way to route full range speaker cable

Do not overlap woofer magnet center hole



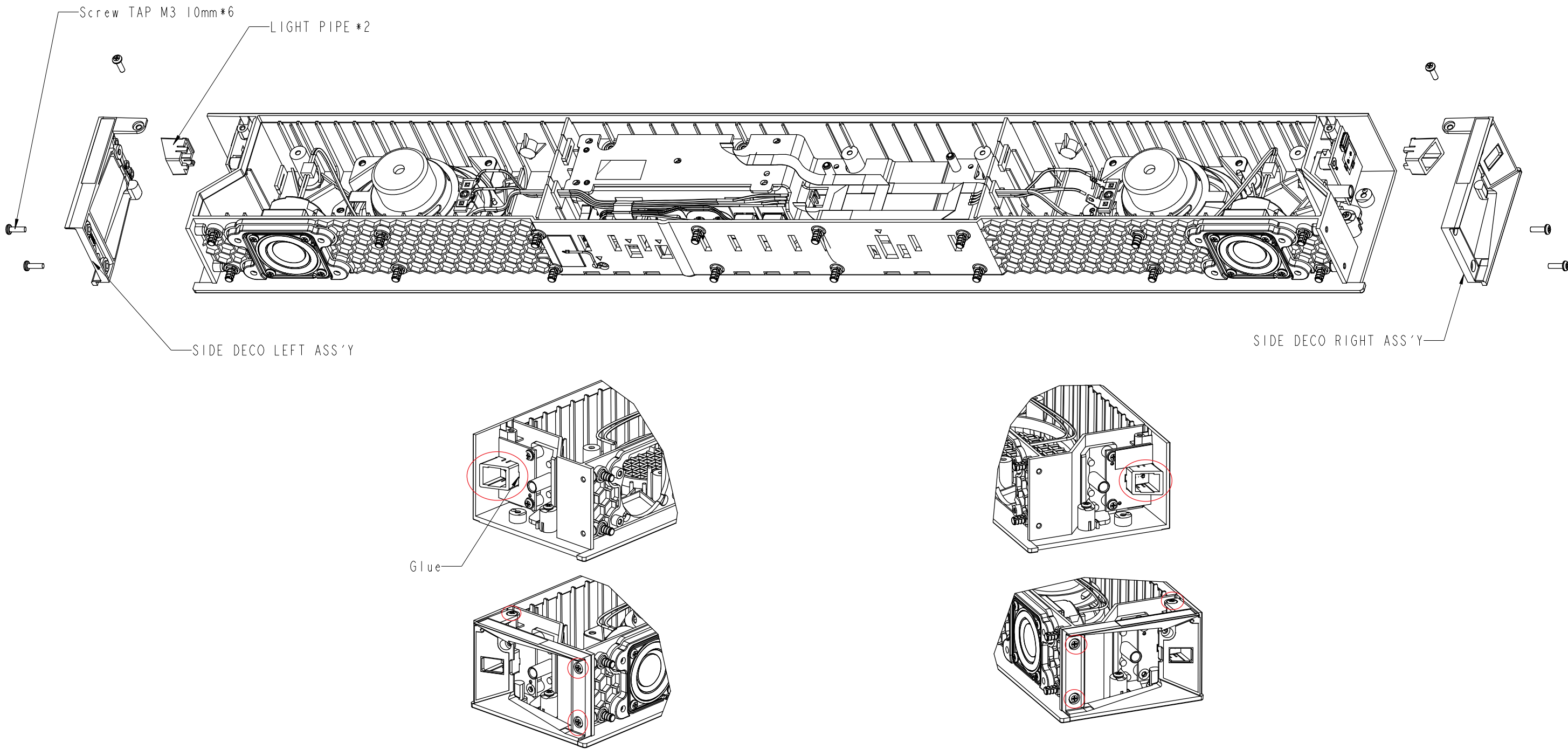
Do not overlap speaker cable for screw hole

Full range speaker connector should be rapped after assembly
Use Sponge tape or Gasket
ALT recommended to use the remaining top gasket.(484.00422.005)

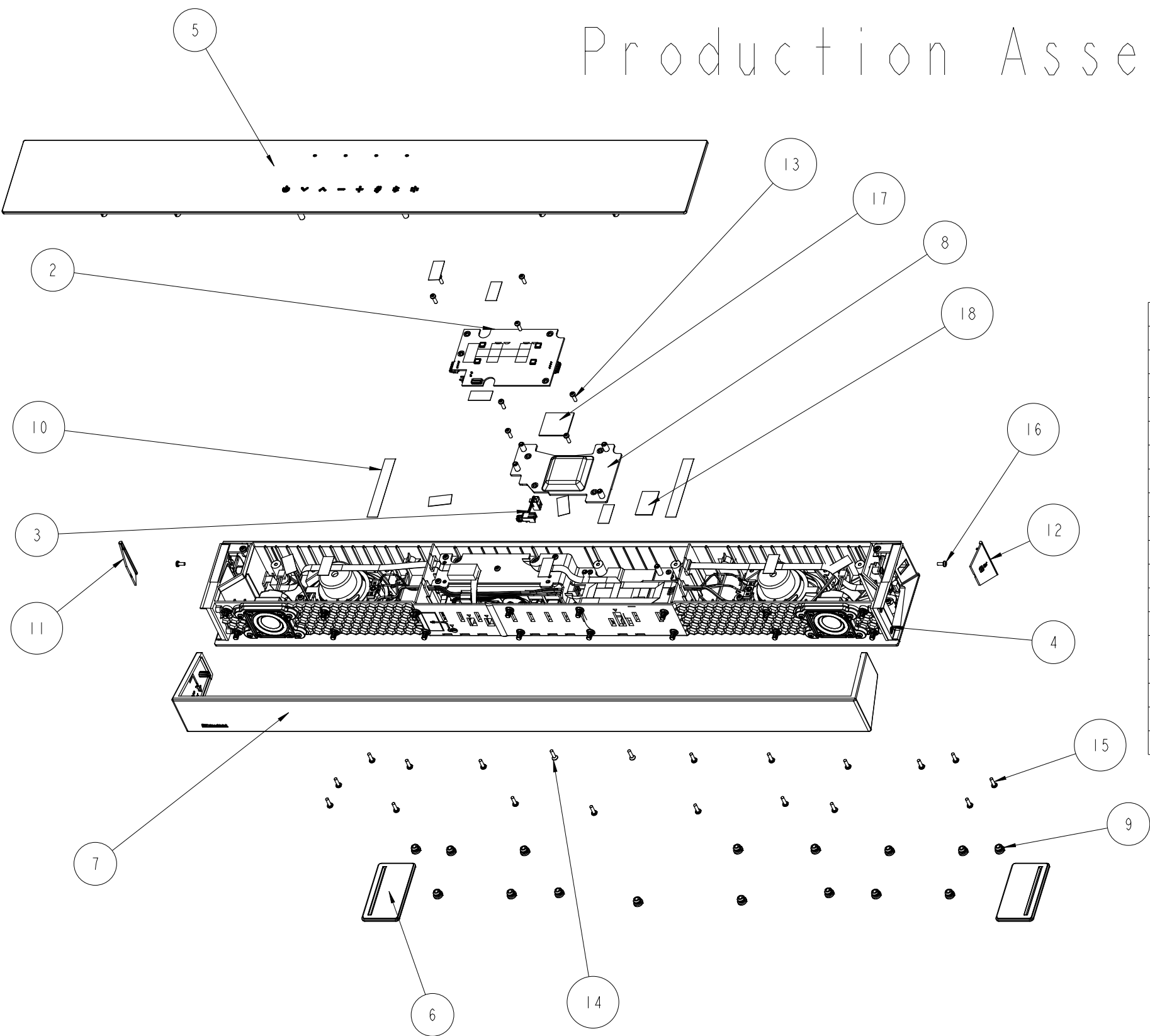


REV.	MARK	ECR/ECN NO.	DATE	UPDATE DESCRIPTION	SIGNATURE
00			19-Dec-20	First offical release	Jim Chen

Step 17:
a. Assemble the light pipe to the Side LED board as indicated.
b. Seal the light pipe with glue.
c. Fix the SIDE DECO ASS'Y to Bottom cover with 6 screws as indicated.
Locking torque: 3.5±0.5 kgf*cm.



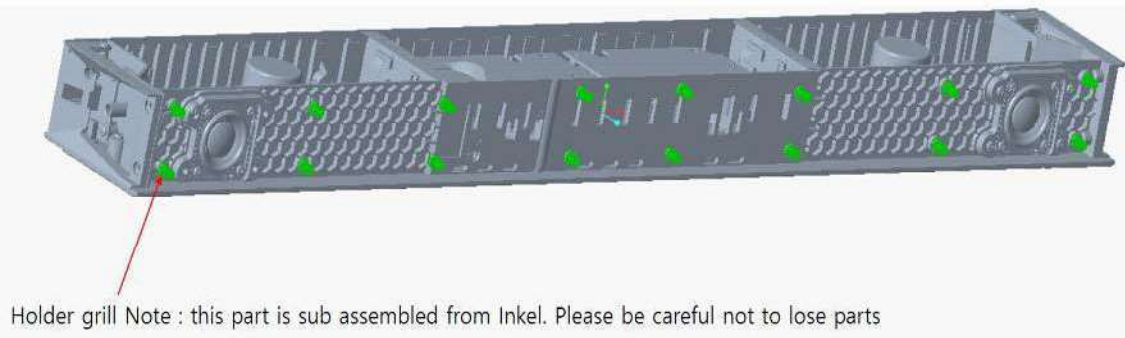
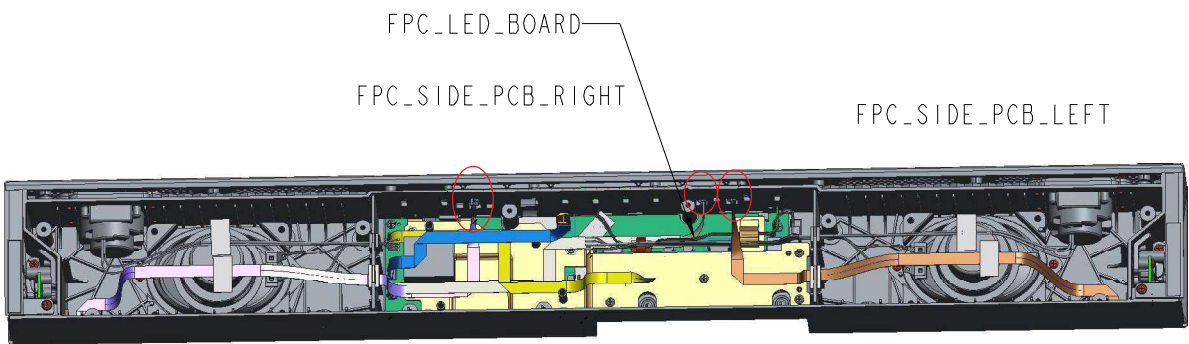
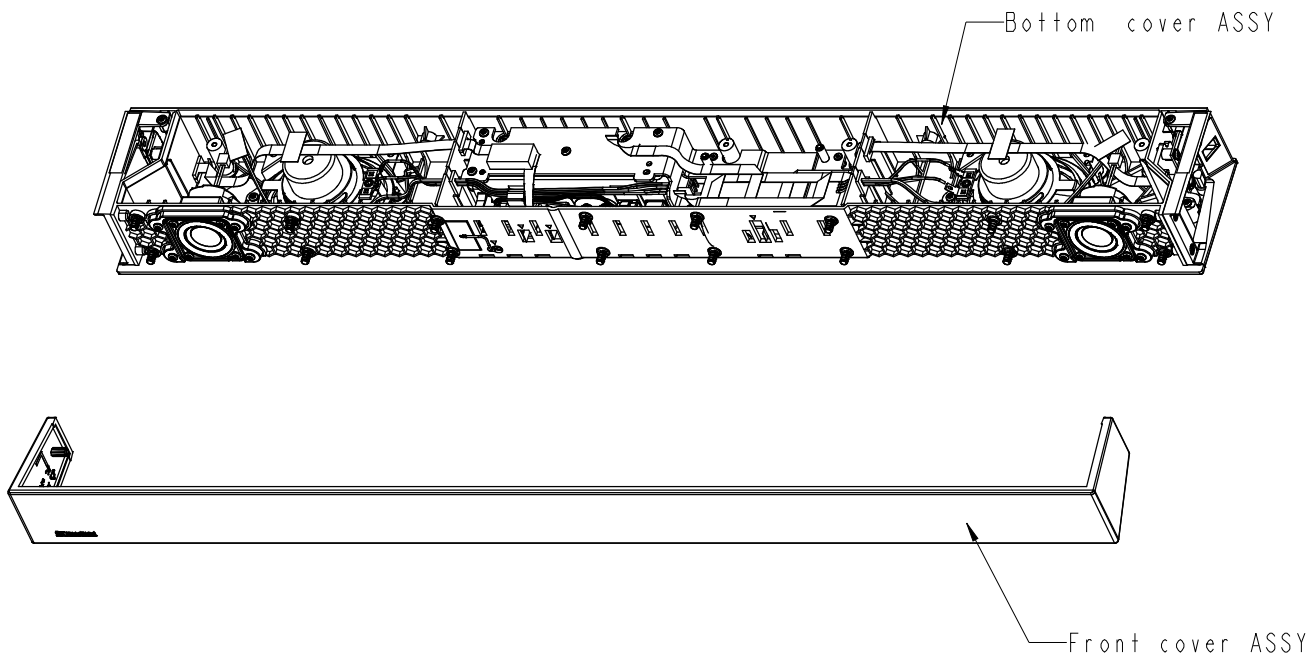
Production Assembly



18	THERMAL_PAD_AL_1	1	
17	THERMAL_PAD-4_AMP_IC	1	
16	SCREW_TTS_3_7	2	
15	SCREW_TTS_3_10	20	
14	SCREW_M3X12	2	
13	SCREW_M3-6	8	
12	PLATE_LOGO_RIGHT_BTVM_UA300_42_1	1	
11	PLATE_LOGO_BTVMIRROR_LEFT_UA30	1	
10	NONWOVEN_TAPE_CASE_INNER_0330	2	
9	ME_COVER_SCREW_UA300_0330	16	
8	HEAT_SPREADER_AMP_TOP_ASSY	1	
7	GRILL_ASSY_UA300_ASM	1	
6	FOOT_ASSY_UA300_ASM_CURRENT	2	
5	CASE_TOP_ASSY	1	
4	CASE_BOTTOM_ASSY	1	
3	CABLE-SOC-AMP	1	
2	AMP_BOARD_SWAN_ASSY	1	
1	ACETIC_TAPE_25X12_5	8	
ITEM	PART NAME	QTY	REMARK

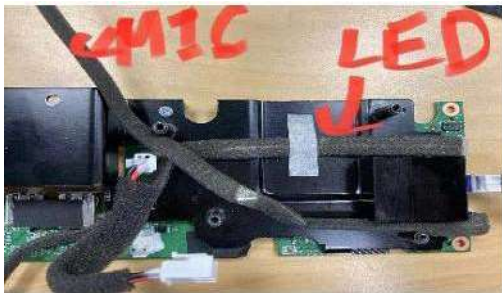
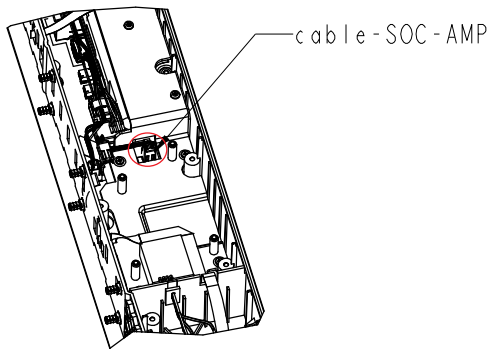
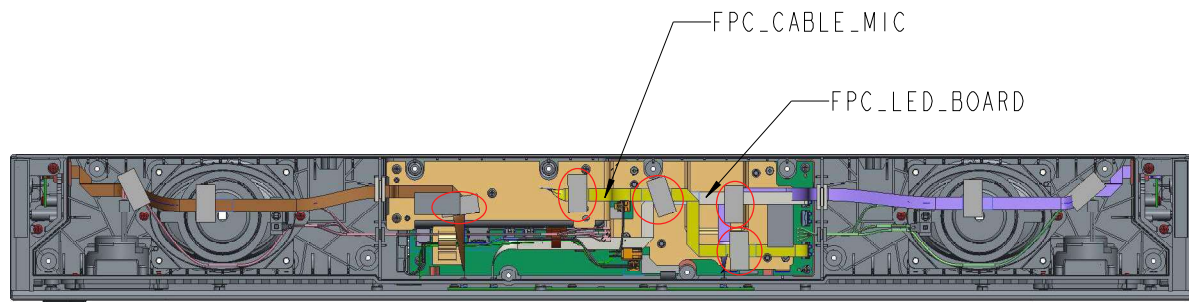
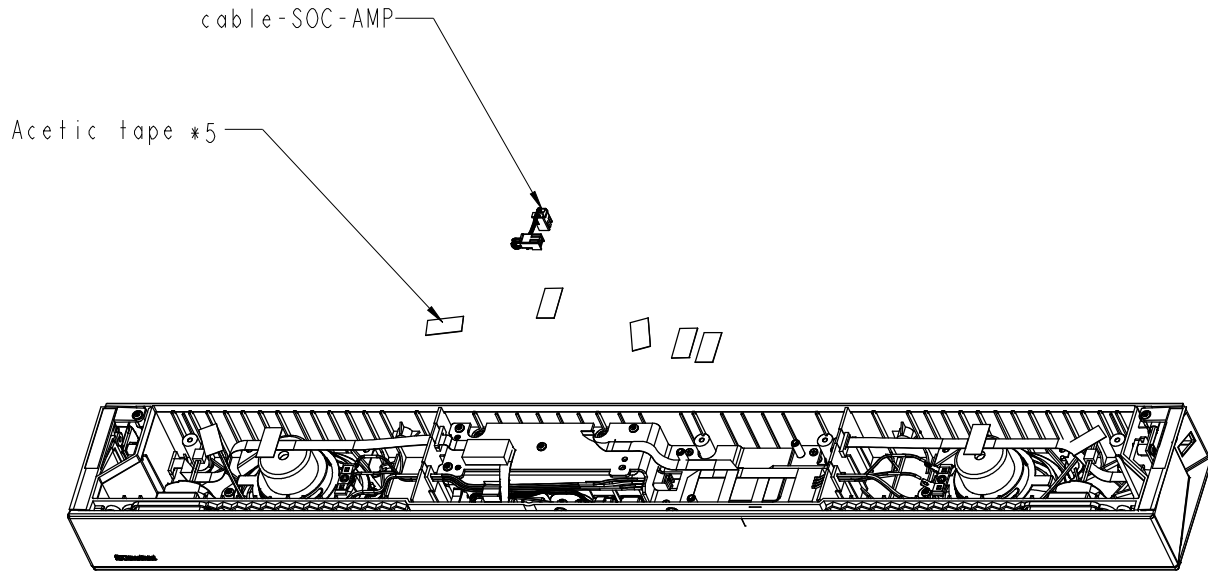
Step 18:

- a. Snap the FPC_SIDE_PCB_RIGHT, FPC_LED_BOARD, FPC_SIDE_PCB_LEFT to LED board respectively as indicated
- b. Assemble the front cover to bottom cover.



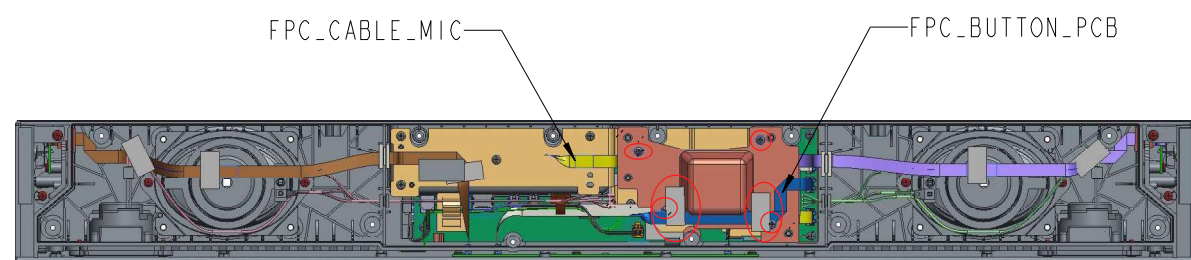
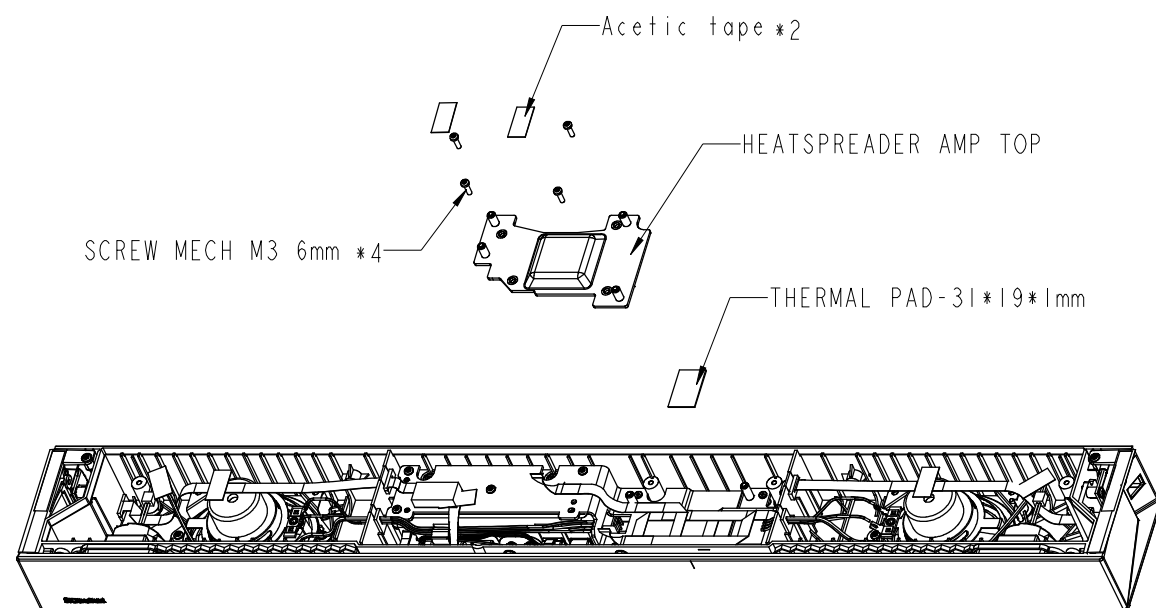
Step 19:

- a. Fix the FFC cable to heatspreader with 5 Acetic tapes.
- b. Snap the cable-SOC-AMP to SoC board as indicated



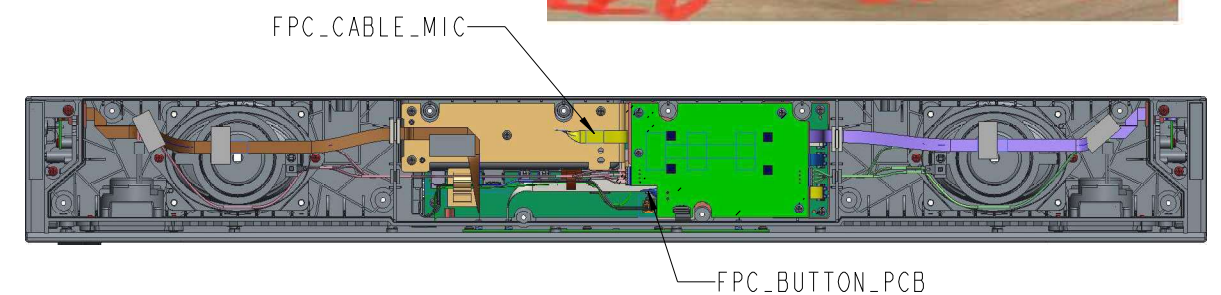
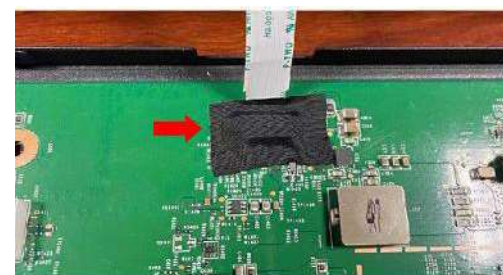
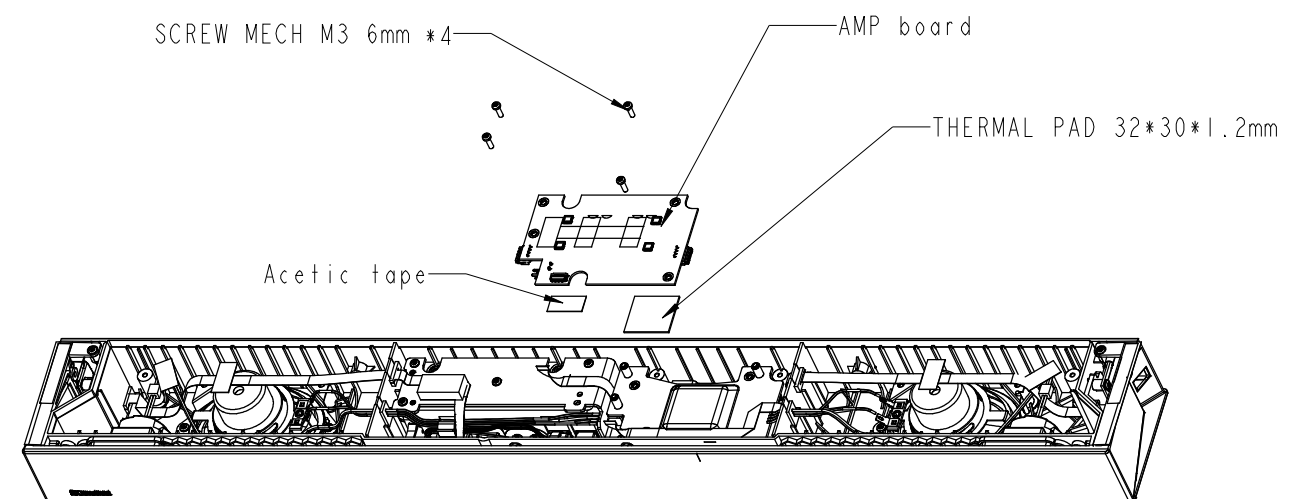
Step 20:

- Assemble the thermal pad to heatspreader.
- Fix the HEATSPREADER AMP TOP to HEATSPREADER SOC TOP with 4 screws as indicated. Locking torque: 3.5 ± 0.5 kgf*cm.
- Fix the button FFC cable to HEATSPREADER with Acetic tape as indicated.

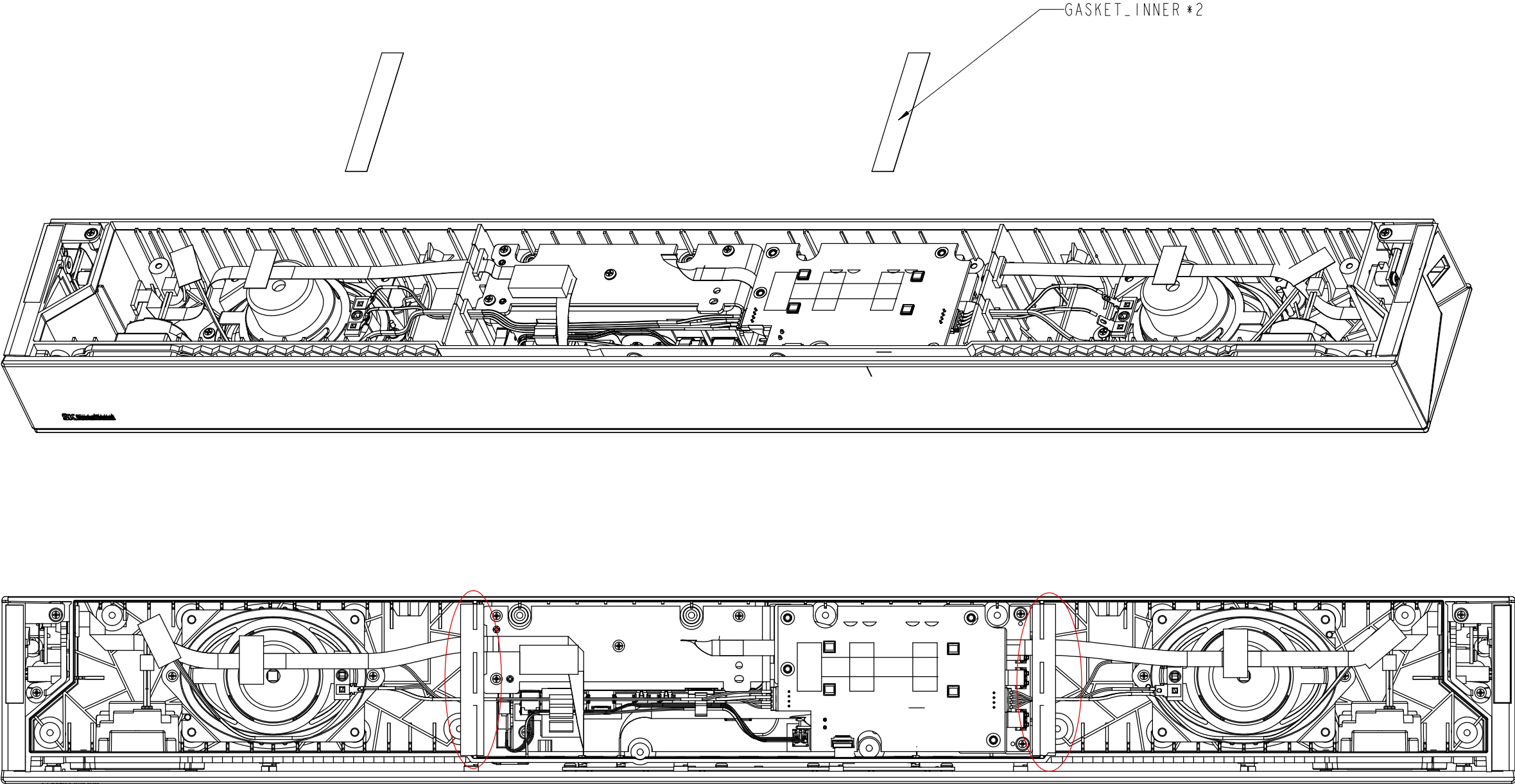


Step 21:

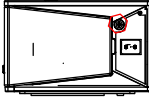
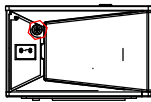
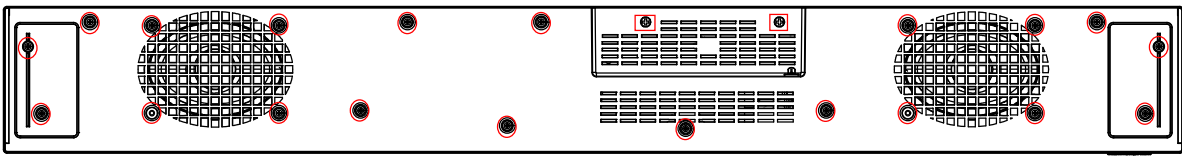
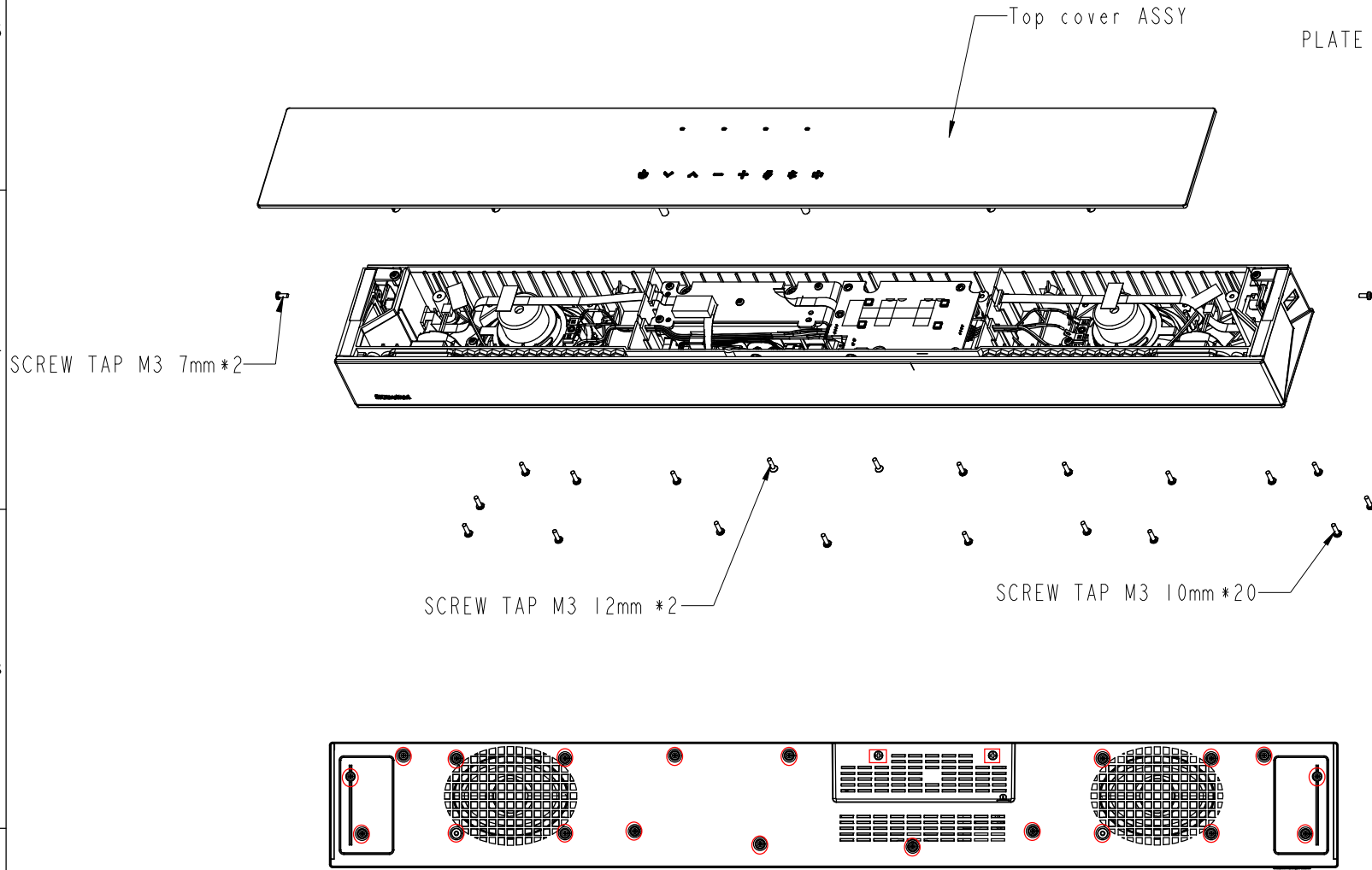
- Fix the FFC cable to AMP board with Acetic tape and assemble the thermal pad to AMP board.
- Fix the AMP board to HEATSPREADER AMP TOP with 4 screws as indicated. Locking torque: 3.5 ± 0.5 kgf*cm.
- Stick the sponge to AMP board.



Step 22: Stick the GASKET INNER to Bottom cover.



Step 23: Fix the top cover to bottom cover with 22 screws as indicated.
Locking torque: 3.5±0.5 kgf*cm.



- Aline top and bottom housing
- Press gently from the center to each side



Step 24:
a. Assemble the RUBBER FOOT, RUBBER COVER to bottom cover respectively as indicated.
b. Assemble the PLATE BTV LOGO to bottom cover after all test pass.

