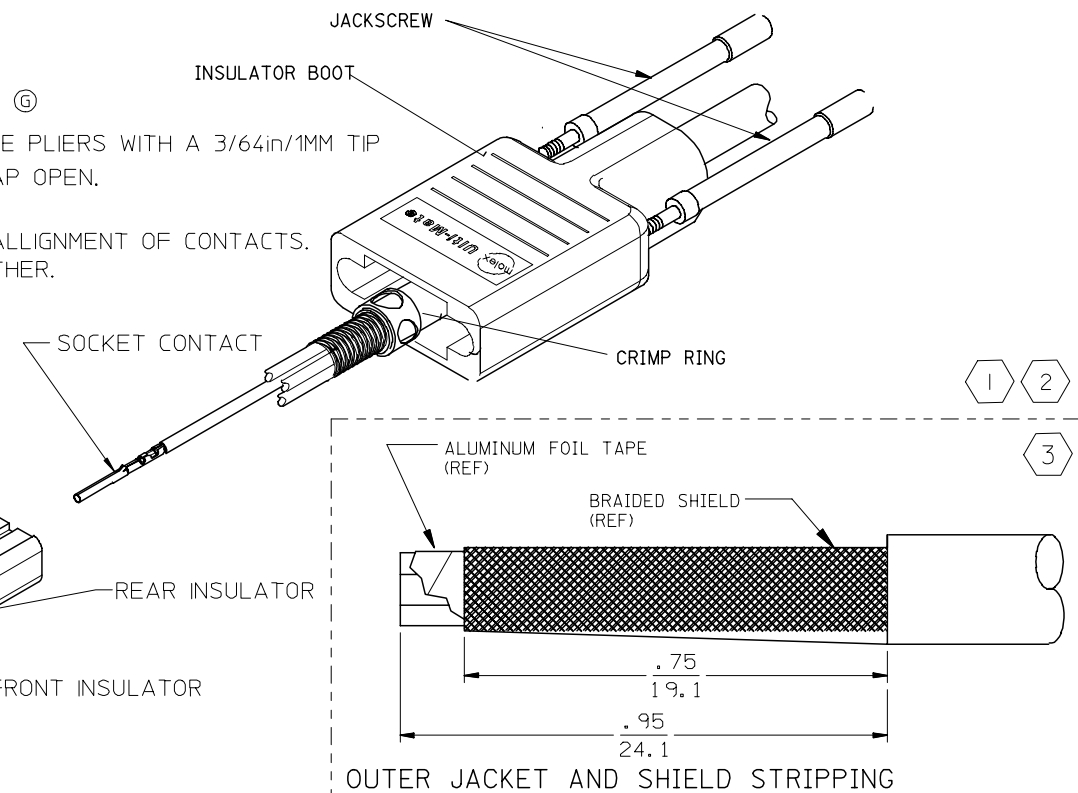


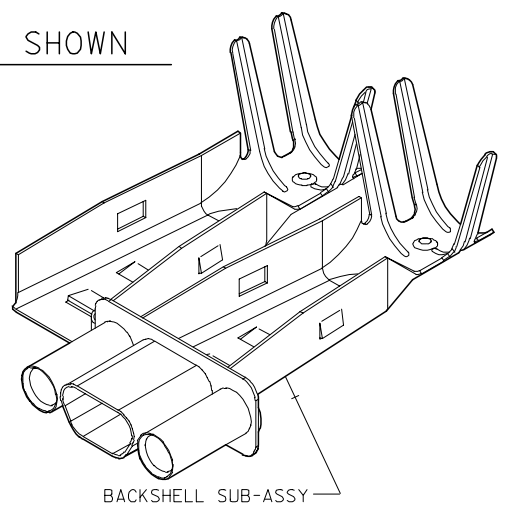
MATERIAL NUMBER	ENGINEERING NUMBER
834219101	83421-9101

### CONNECTOR ASSEMBLY INSTRUCTIONS

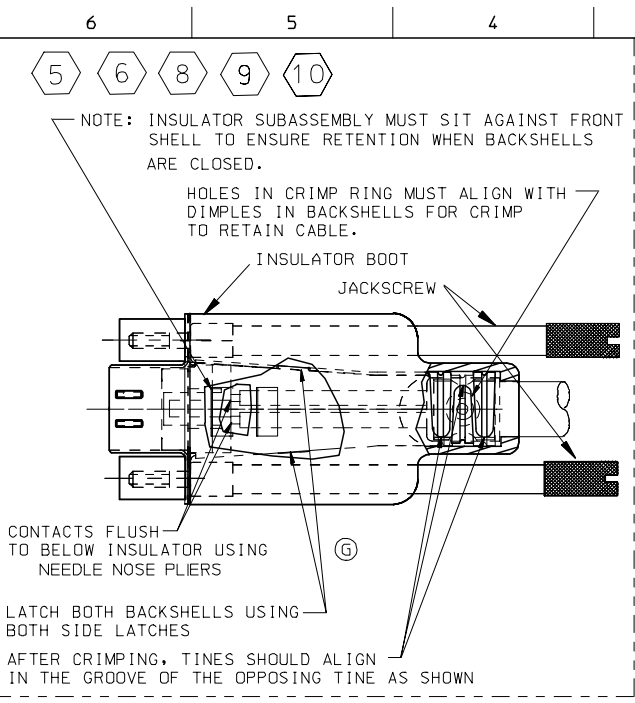
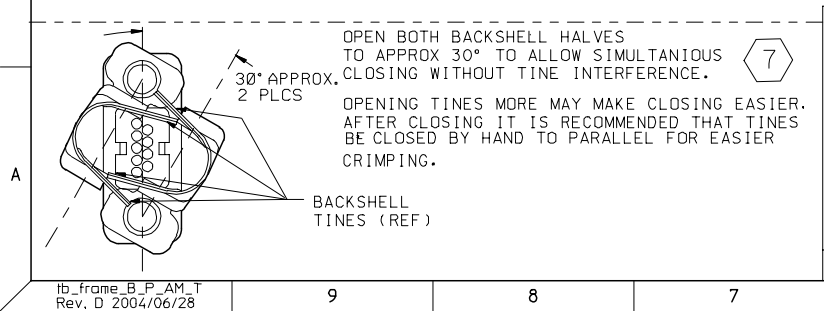
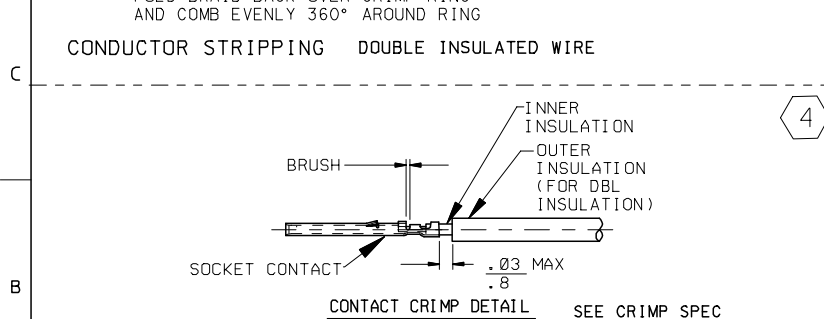
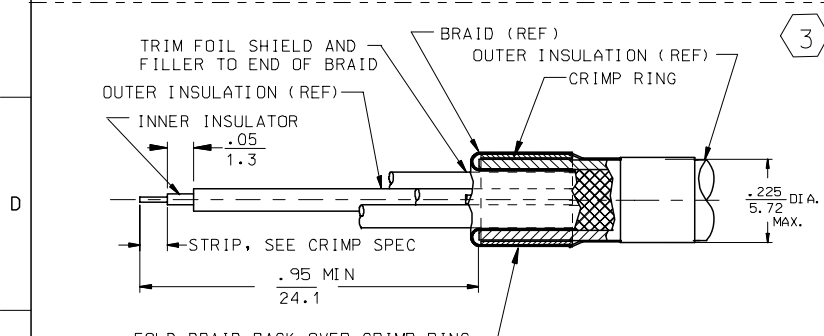
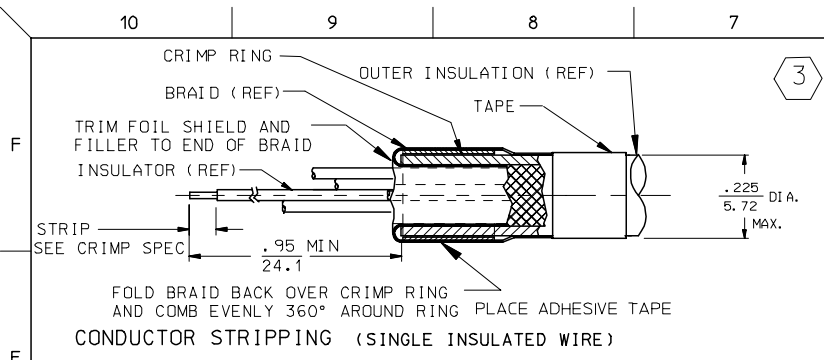
- ① SLIDE BOOT OVER CABLE.
- ② SLIDE CRIMP RING OVER CABLE.  
BRAIDED SHIELD FOLDS BACK OVER CRIMP RING.
- ③ STRIP CABLE PER STRIPPING INSTRUCTIONS.(SH 1&2)
- ④ CRIMP CONTACTS PER CRIMP INSTRUCTIONS,(SH2).  
SEE CRIMP SPEC 638207800 FOR FINE ADJUST APPLICATOR.  
SEE CRIMP SPEC 638111400 FOR HAND TOOL.
- ⑤ INSERT CONTACTS INTO BACK OF REAR INSULATOR USING NEEDLE NOSE PLIERS WITH A 3/64in/1MM TIP  
PUSH CONTACT INTO REAR INSULATOR UNTIL "WINGS" ON CONTACT SNAP OPEN.  
CONTACT SHOULD NOT EXTEND BEYOND THE BACK OF INSULATOR  
PLACE FRONT INSULATOR ONTO REAR INSULATOR ASSURING PROPER ALLIGNMENT OF CONTACTS.  
CONTINUE TO PUSH UNTIL FRONT AND REAR INSULATOR SNAP TOGETHER.
- ⑥ MOUNT INSULATOR SUBASSEMBLY IN BACKSHELL SUBASSEMBLY  
PER ASSY INSTRUCTION.(SH 2)
- ⑦ CLOSE BACKSHELL SUBASSEMBLY AROUND CABLE SHIELD PER  
INSTRUCTIONS.(SH 2)
- ⑧ CRIMP BACKSHELL TO METAL BRAID PER INSTRUCTIONS.(SH 2)
- ⑨ SLIDE BOOT OVER BACKSHELL SUBASSEMBLY
- ⑩ INSERT JACKSCREWS INTO BOOT



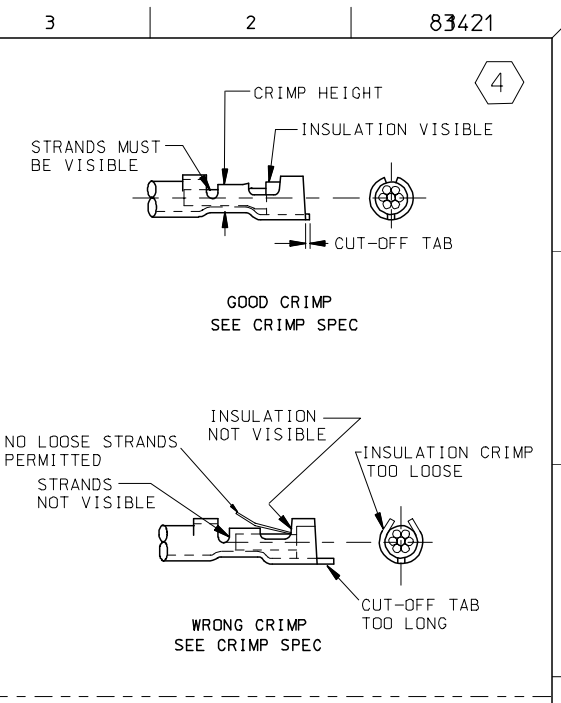
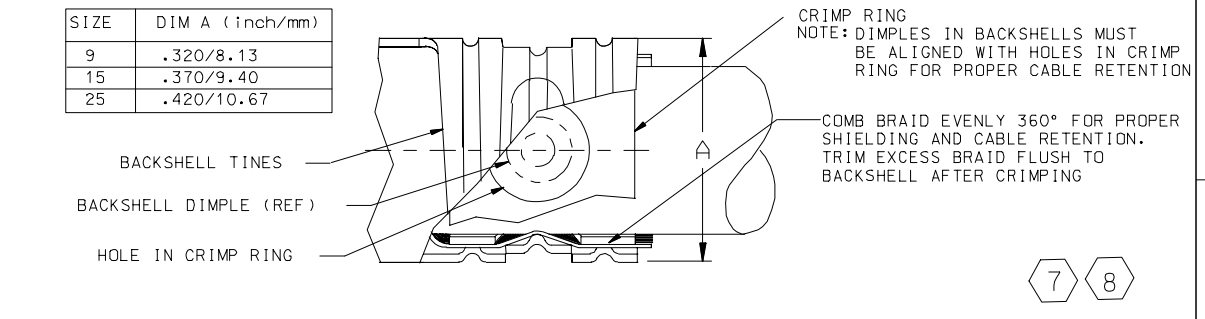
9-POSITION SHOWN



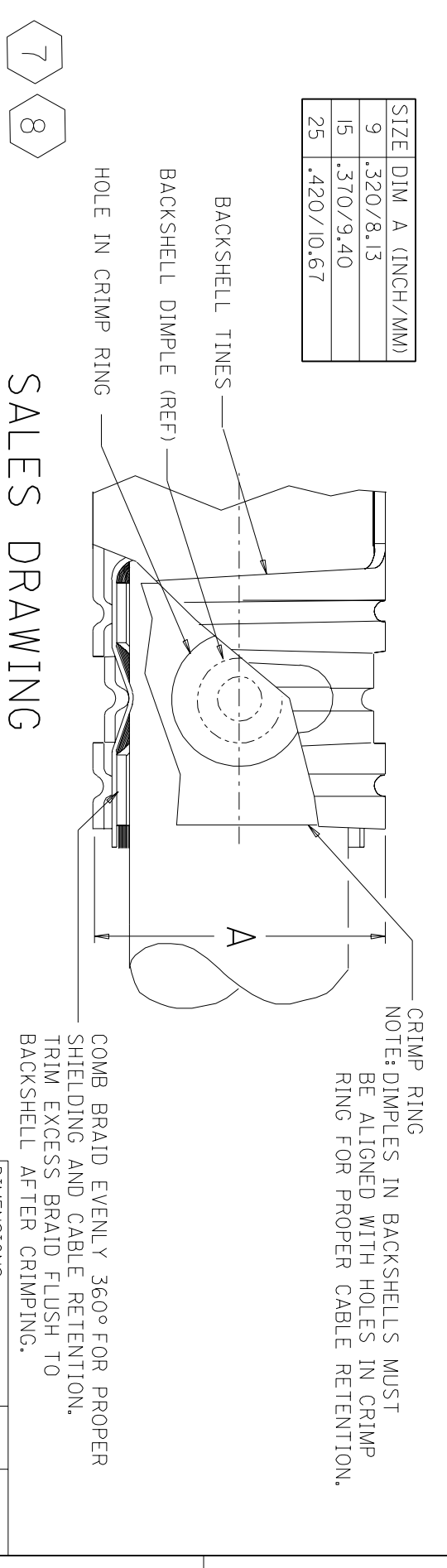
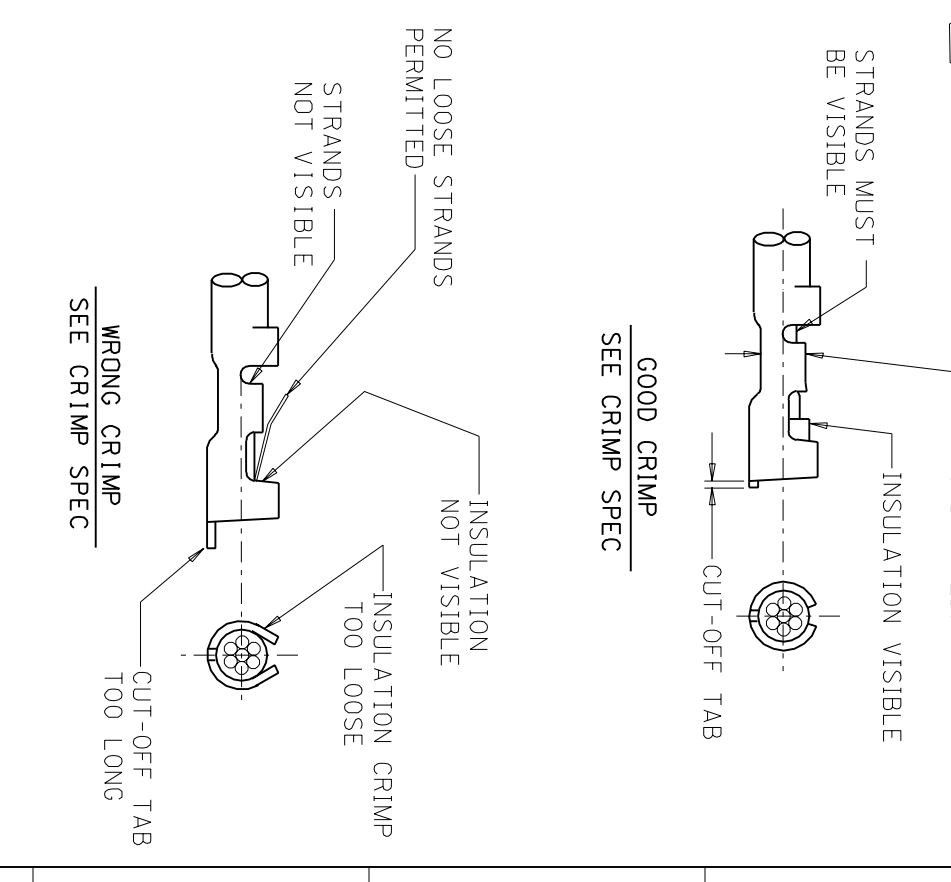
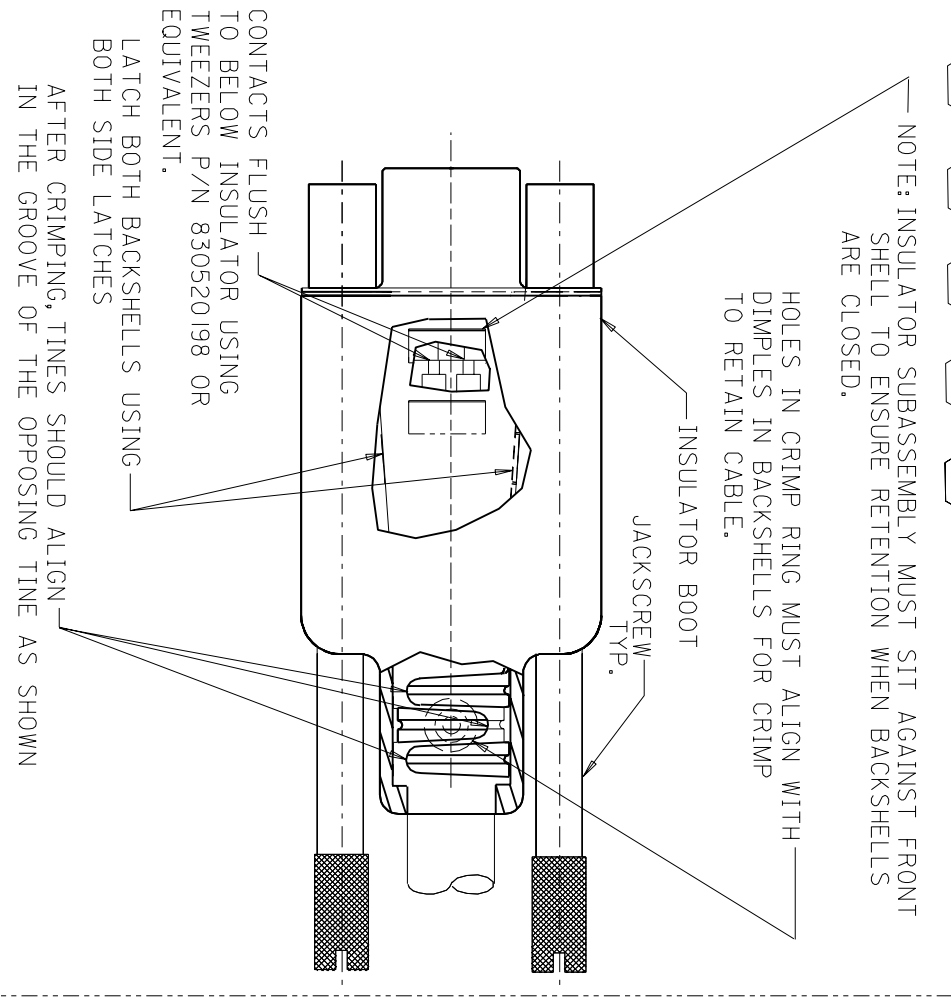
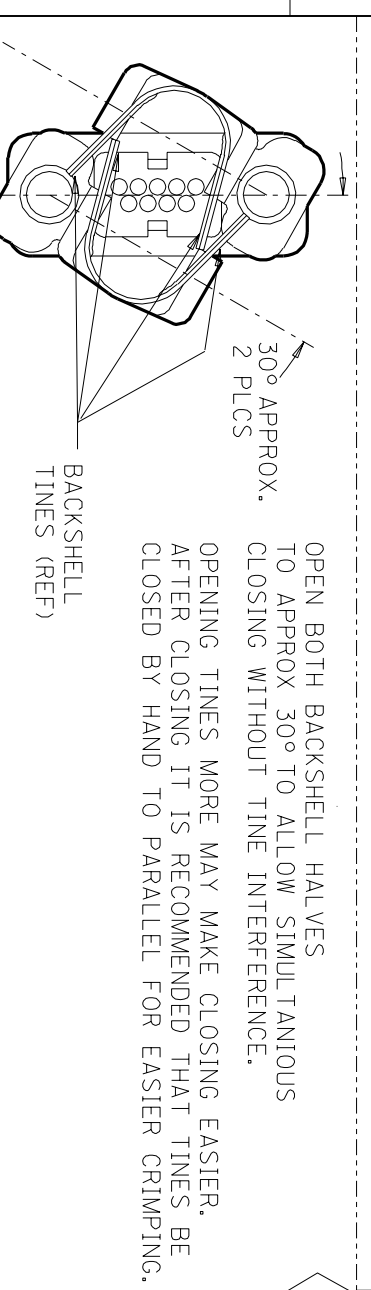
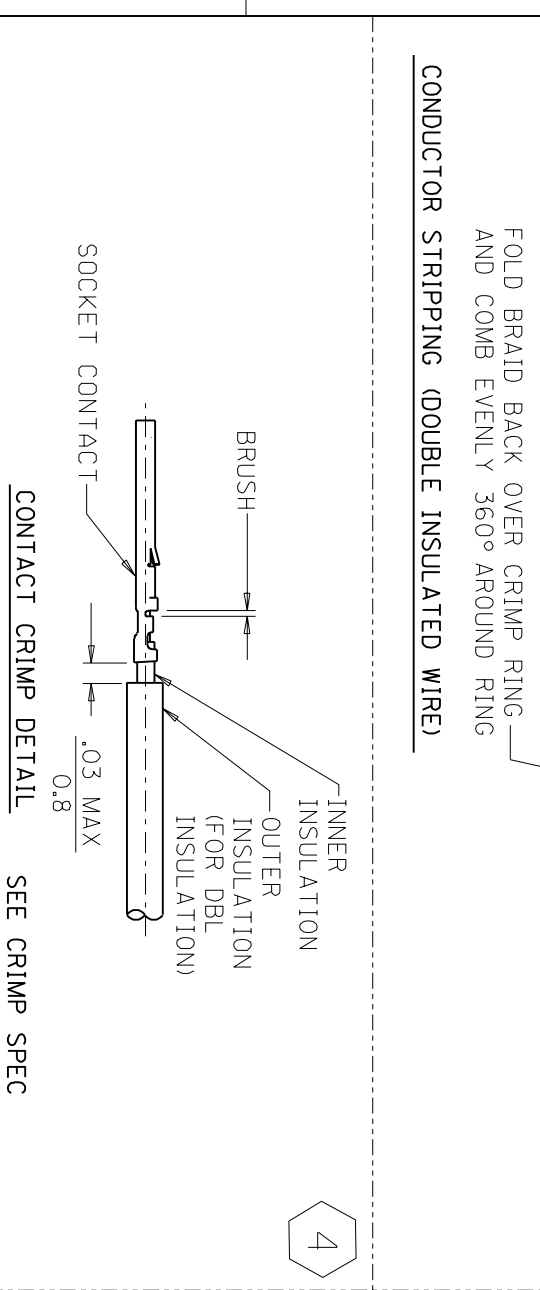
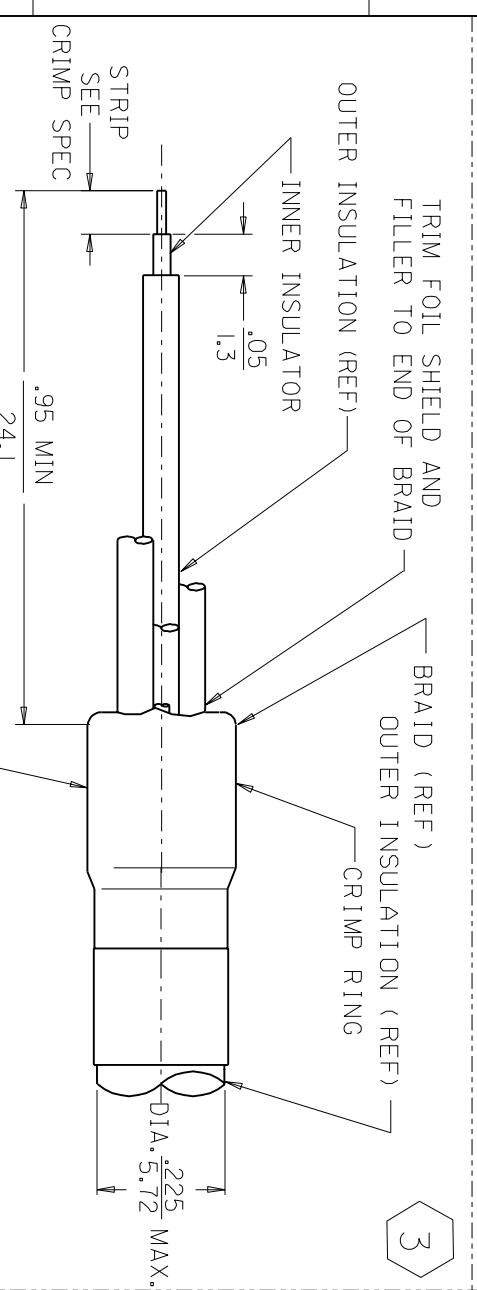
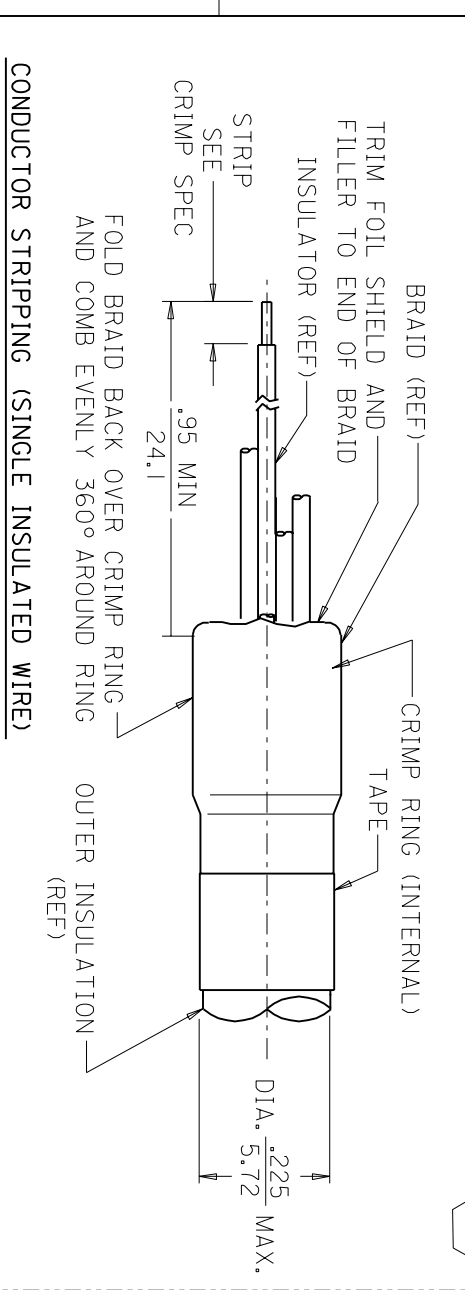
<b>REVISED NOTES</b> EC NO: ETC2005-0132 DRWN: JLOMASTRO 2005/02/02 CHKD: 2005/02/02 APPR: RDEROSS 2005/02/02	QUALITY SYMBOLS ▽=0 ▽=0	GENERAL TOLERANCES (UNLESS SPECIFIED) <table border="1"> <tr> <td></td> <td>mm</td> <td>INCH</td> </tr> <tr> <td>4 PLACES</td> <td>± .---</td> <td>± .---</td> </tr> <tr> <td>3 PLACES</td> <td>± .---</td> <td>± .005</td> </tr> <tr> <td>2 PLACES</td> <td>± 0.13</td> <td>± .01</td> </tr> <tr> <td>1 PLACE</td> <td>± 0.25</td> <td>± .---</td> </tr> <tr> <td colspan="3">ANGULAR ±1/2°</td> </tr> </table>		mm	INCH	4 PLACES	± .---	± .---	3 PLACES	± .---	± .005	2 PLACES	± 0.13	± .01	1 PLACE	± 0.25	± .---	ANGULAR ±1/2°			DIMENSION STYLE IN/MM	SCALE INCH	DESIGN UNITS INCH	THIRD ANGLE PROJECTION
		mm	INCH																					
	4 PLACES	± .---	± .---																					
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DRAWN BY JLOMASTR DATE 05/01/26	CHECKED BY RDEROSS DATE 05/02/02	APPROVED BY RDEROSS DATE 05/02/04	TITLE ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR																					
MATERIAL NO. SEE CHART			DOCUMENT NO. SD-83421-006		SHEET NO. 1 OF 2																			
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS																								



SIZE	DIM A (inch/mm)
9	.320/8.13
15	.370/9.40
25	.420/10.67



<b>REVISED NOTES</b> EC NO: ETC2005-0132 DRWN: JLOMASTRO 2005/02/02 CHKD: 2005/02/02 APPR: RDEROSS 2005/02/02	QUALITY SYMBOLS ▽=0 ▽=0	GENERAL TOLERANCES (UNLESS SPECIFIED) <table border="1"> <thead> <tr> <th></th> <th>mm</th> <th>INCH</th> </tr> </thead> <tbody> <tr> <td>4 PLACES</td> <td>± .005</td> <td>± .0005</td> </tr> <tr> <td>3 PLACES</td> <td>± .005</td> <td>± .0005</td> </tr> <tr> <td>2 PLACES</td> <td>± 0.13</td> <td>± .01</td> </tr> <tr> <td>1 PLACE</td> <td>± 0.25</td> <td>± .01</td> </tr> </tbody> </table> ANGULAR ±1/2°		mm	INCH	4 PLACES	± .005	± .0005	3 PLACES	± .005	± .0005	2 PLACES	± 0.13	± .01	1 PLACE	± 0.25	± .01	DIMENSION STYLE IN/MM	SCALE 1:1	DESIGN UNITS INCH	THIRD ANGLE PROJECTION
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1 PLACE	± 0.25	± .01																			
DRAWN BY JLOMASTRO	DATE 05/01/26	TITLE ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR																			
CHECKED BY RDEROSS	DATE 05/02/02	MOLEX INCORPORATED																			
APPROVED BY REDORSS	DATE 05/02/04	MATERIAL NO. SEE CHART	DOCUMENT NO. SD-83421-006	SHEET NO. 2 OF 2																	
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS																					
THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION																					

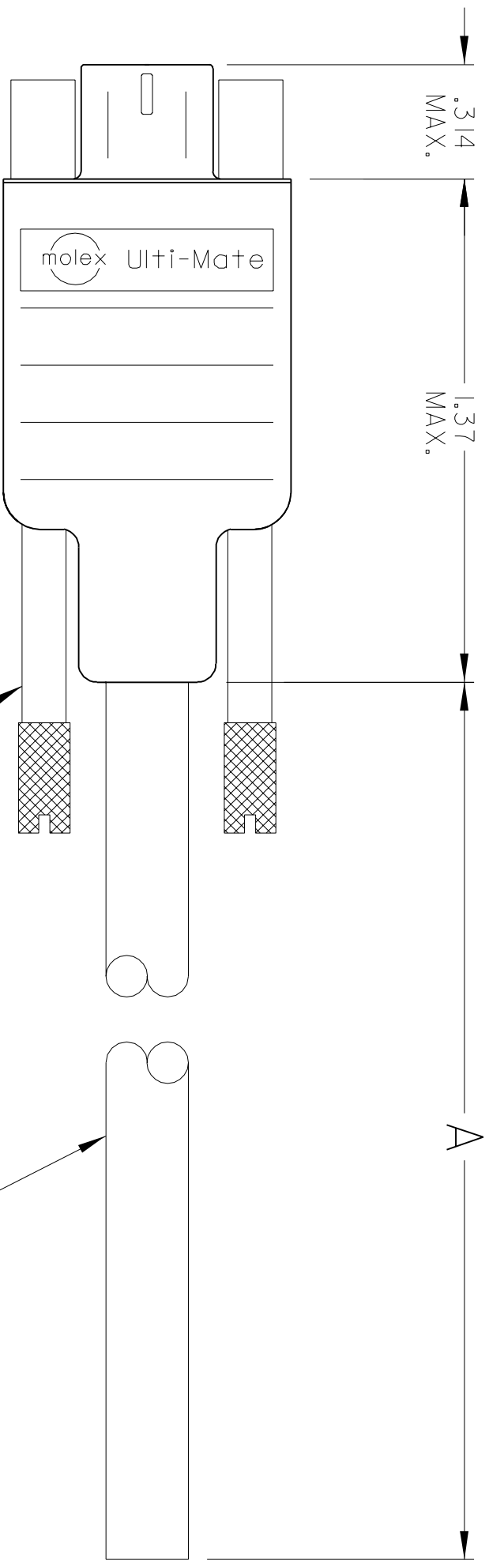
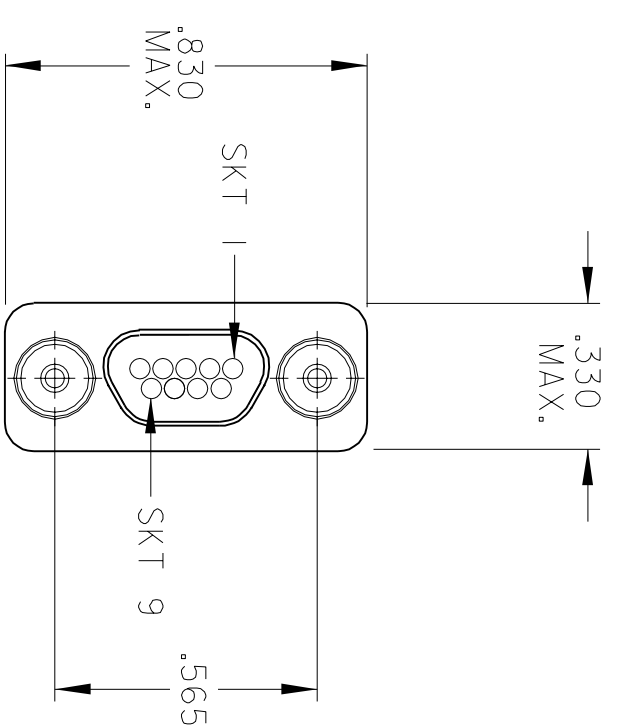


REL. TO W. MANAGER  
 EC NO. ETCN002-0300  
 DRWN: DLM 02/05/03  
 CHK: J 02/05/03  
 APPR: RWD 02/05/03

REV	DESCRIPTION	QUALITY SYMBOLS	GENERAL TOLERANCES: (UNLESS SPECIFIED)	SCALE	DESIGN UNITS	TITLE	DIMENSIONS:	SHT	REV
A		MAJOR = ∅ CRITICAL = ∅	mm INCH 1 PLACES ±0.25 2 PLACES ±0.13 3 PLACES ±0.10 4 PLACES ±0.05 ANGULAR: ±1/2°	NTS	mm INCH <input checked="" type="checkbox"/> mm <input type="checkbox"/> INCH	ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO-D CONNECTOR	mm INCH mm ONLY <input checked="" type="checkbox"/> mm <input type="checkbox"/> INCH <input type="checkbox"/> mm ONLY		

CAD FILENAME: SD83421006.S02 (SEE CHART)  
 MATERIAL NO. MOLEX INCORPORATED  
 DRAWING NO. SD-83421-006  
 SHEET NO. 2 OF 2  
 THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.

REV	DATE	ECN NO.	APPVD BY	REL BY
A	25JAN99	UM9-0280	FVW	CH
B	27JULY00	UM2001-0017	FVW	CH
C	13JAN01	UM2001-0200		



PART NUMBER	A ±.5
834219023	4.5
834219042	18.5
834219043	36.5
834219044	72.5

1	2	3	4	5	6	7	8	9
BLK	BRN	RED	ORG	YEL	GRN	BLU	VIO	GRY

SHELL

<b>QUALITY SYMBOLS</b> MAJOR = CRITICAL = SPC =	<b>UNLESS SPECIFIED:</b> ALL DIMENSIONS IN INCHES GENERAL TOLERANCES: 3 PLACE ±.005 2 PLACE ±.01 ANGULAR ±2°	SCALE	DWG SIZE	<b>THIRD ANGLE PROJECTION</b>	REVISE ON CAD ONLY
		NONE	B		
<b>TITLE:</b> CONNECTOR ASSEMBLY, COMMERCIAL MICRO-D, 9 SKT., SPECIAL		DRAWN BY & DATE D.URBACH 2AUG99		PART NO. 834219023 DRAWING NO. SD-83421-9023	
CHECKED BY & DATE F. VAN WYK		APPROVED BY & DATE		MOLEX INCORPORATED Orange, CA 92868	
UNLESS SPECIFIED: ALL DIMENSIONS IN INCHES GENERAL TOLERANCES: 3 PLACE ±.005 2 PLACE ±.01 ANGULAR ±2°		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.		SHEET NO. 1 OF 1 REV C	

I. MARKING: NONE.

NOTES: UNLESS OTHERWISE SPECIFIED.