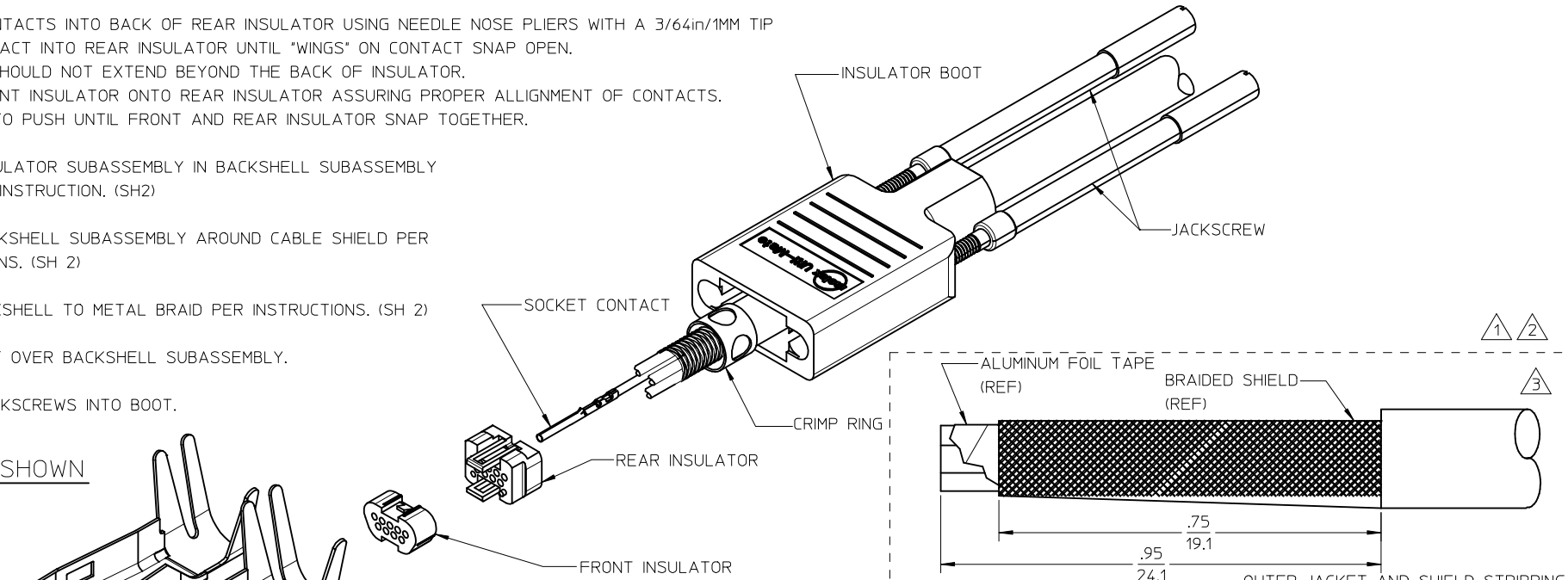


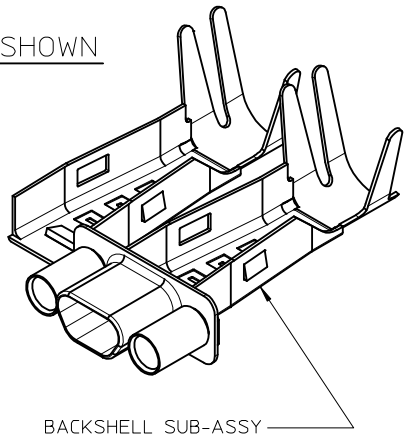
| | | | | | | | | | |
|-----------------|--------------------|---|---|---|---|---|---|---|---|
| 10 | 9 | 8 | 7 | 6 | 5 | 4 | 3 | 2 | 1 |
| MATERIAL NUMBER | ENGINEERING NUMBER | | | | | | | | |
| 834219101 | 83421-9101 | | | | | | | | |

CONNECTOR ASSEMBLY INSTRUCTIONS

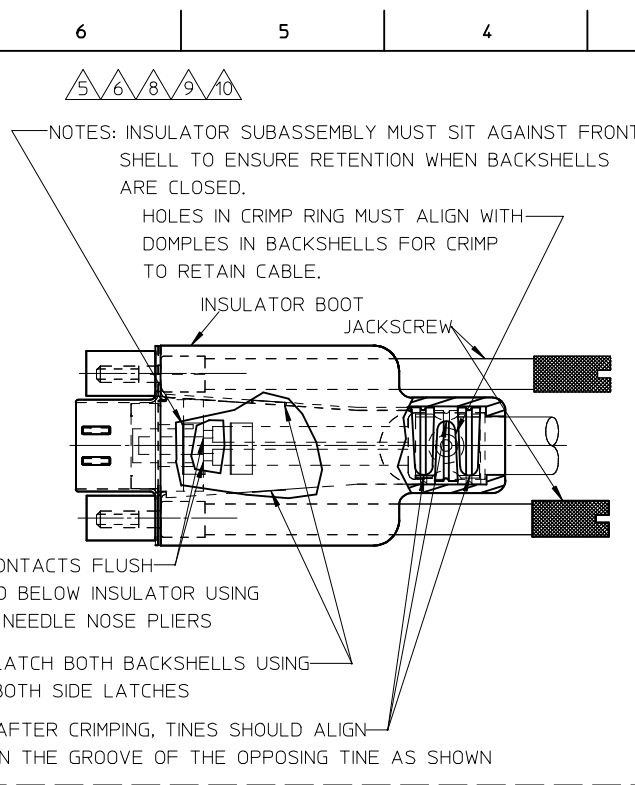
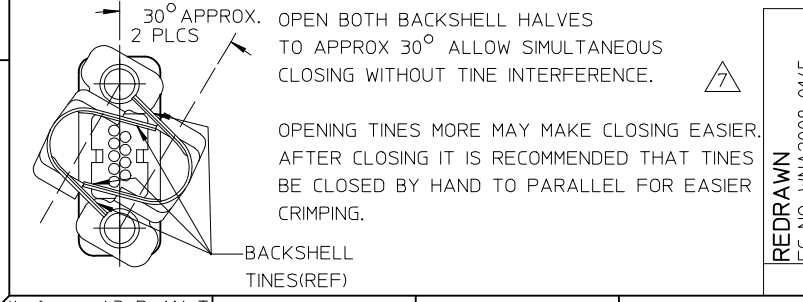
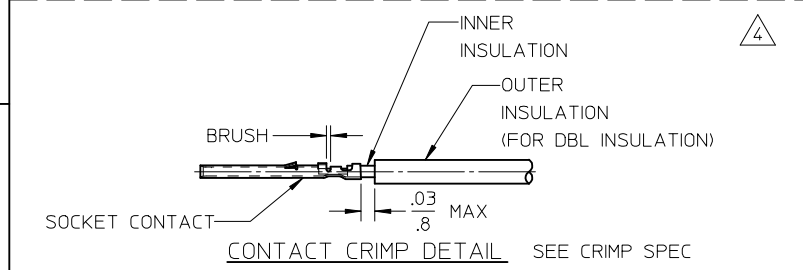
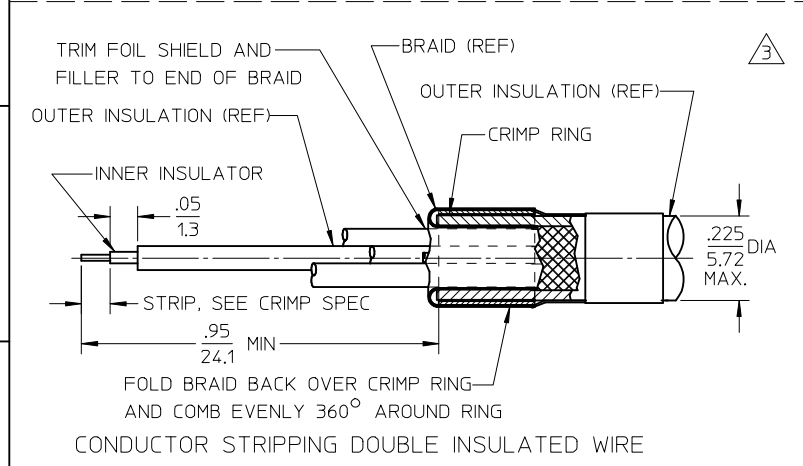
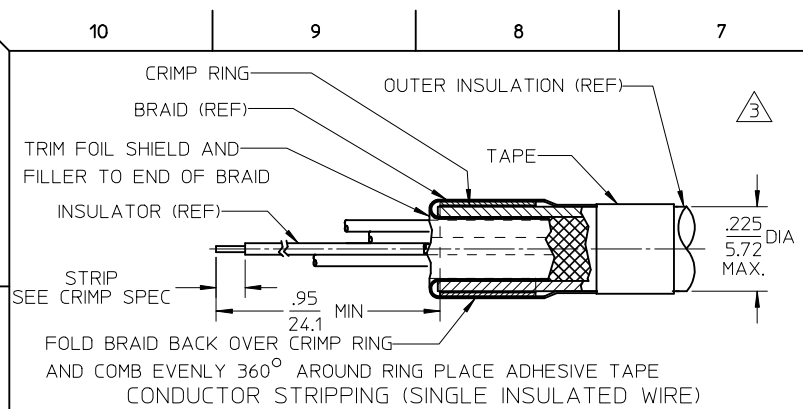
- 1 SLIDE BOOT OVER CABLE.
- 2 SLIDE CRIMP RING OVER CABLE. BRAIDED SHIELD FOLDS BACK OVER CRIMP RING.
- 3 STRIP CABLE PER STRIPPING INSTRUCTIONS. (SH 1&2)
- 4 CRIMP CONTACTS PER CRIMP INSTRUCTIONS. (SH2)
SEE CRIMP SPEC 638207800 FOR FINE ADJUST APPLICATOR.
SEE CRIMP SPEC 638111400 FOR HAND TOOL.
- 5 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. (SH2)
- 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.



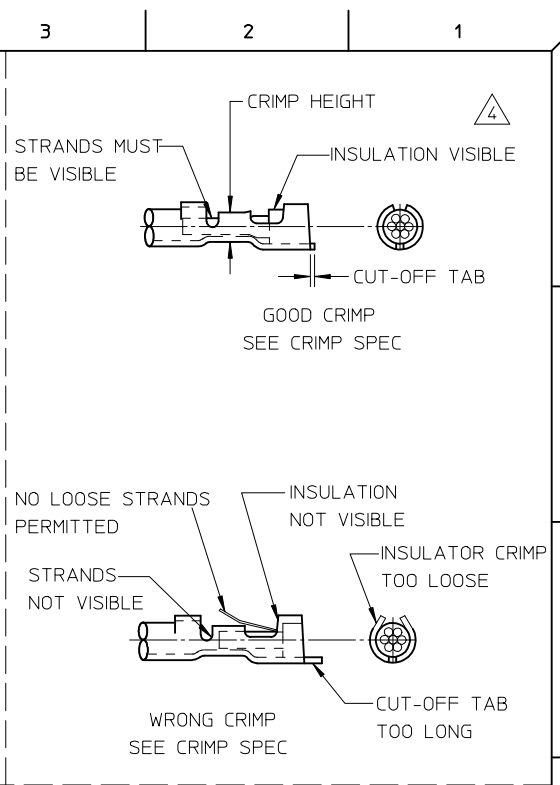
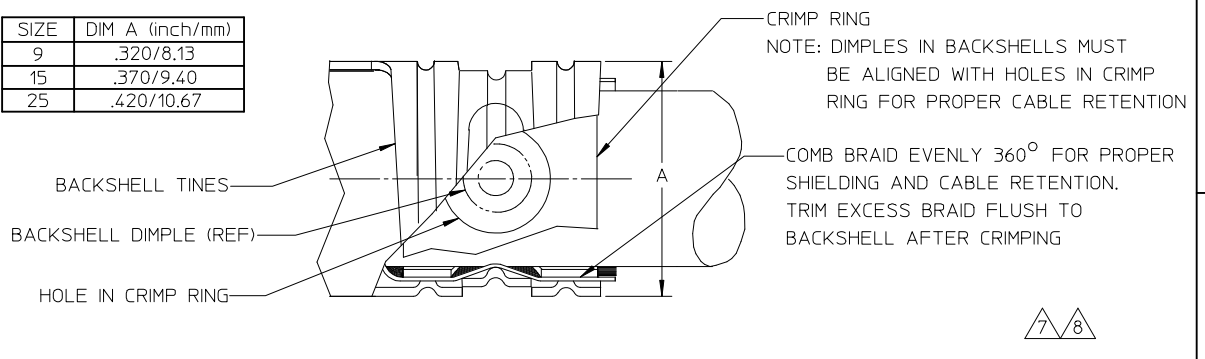
9-POSITION SHOWN



| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|-------------------------------|--|-----------|---------------------------------|------|---------------------|-----------------------------|------------------------|----------|-------|--------|----------|--------|-------|---------|--------|-------|---------------|--|--|---|----------|------|-------|----------|----------|---|------------|------|---------|----------|-------------|------|---------|----------|---------------------------|--------------|--|--------------|-----------|-----------|--|--------------|--------|---|
| REDRAWN EC NO: WNA2008-0145 DRWNR: RUPERT 2008/10/17 CHKD: APPR: J. MURPHY 2008/11/12 REV | QUALITY SYMBOLS ▽=0 ◻=0 | GENERAL TOLERANCES (UNLESS SPECIFIED) | | DIMENSION STYLE IN/MM | | SCALE 2:1 | DESIGN UNITS INCH | THIRD ANGLE PROJECTION | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | <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° | | | <table border="1"> <tr> <td>DRAWN BY</td> <td>DATE</td> <td>TITLE</td> </tr> <tr> <td>JLOMASTR</td> <td>05/01/26</td> <td rowspan="4"> ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR </td> </tr> <tr> <td>CHECKED BY</td> <td>DATE</td> </tr> <tr> <td>RDEROSS</td> <td>05/02/02</td> </tr> <tr> <td>APPROVED BY</td> <td>DATE</td> </tr> <tr> <td>REDORSS</td> <td>05/02/04</td> <td> MOLEX INCORPORATED </td> </tr> <tr> <td colspan="2">MATERIAL NO.</td> <td>DOCUMENT NO.</td> <td>SHEET NO.</td> </tr> <tr> <td colspan="2">SEE CHART</td> <td>SD-83421-006</td> <td>1 OF 2</td> </tr> </table> | DRAWN BY | DATE | TITLE | JLOMASTR | 05/01/26 | ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR | CHECKED BY | DATE | RDEROSS | 05/02/02 | APPROVED BY | DATE | REDORSS | 05/02/04 | MOLEX INCORPORATED | MATERIAL NO. | | DOCUMENT NO. | SHEET NO. | SEE CHART | | SD-83421-006 | 1 OF 2 | THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION |
| | mm | INCH | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 4 PLACES | ± --- | ± --- | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3 PLACES | ± --- | ± .005 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 2 PLACES | ± 0.13 | ± .01 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1 PLACE | ± 0.25 | ± --- | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| ANGULAR ±1/2° | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| DRAWN BY | DATE | TITLE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| JLOMASTR | 05/01/26 | ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| CHECKED BY | DATE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| RDEROSS | 05/02/02 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| APPROVED BY | DATE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| REDORSS | 05/02/04 | MOLEX INCORPORATED | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| MATERIAL NO. | | DOCUMENT NO. | SHEET NO. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SEE CHART | | SD-83421-006 | 1 OF 2 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |



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



REDRAWN
 IEC NO: WNA2008-0145
 DRWNR: RUPERT 2008/10/17
 CHKD: JFURPHY 2008/11/12
 APPR: JFURPHY

QUALITY SYMBOLS
 ▽=0
 ◻=0

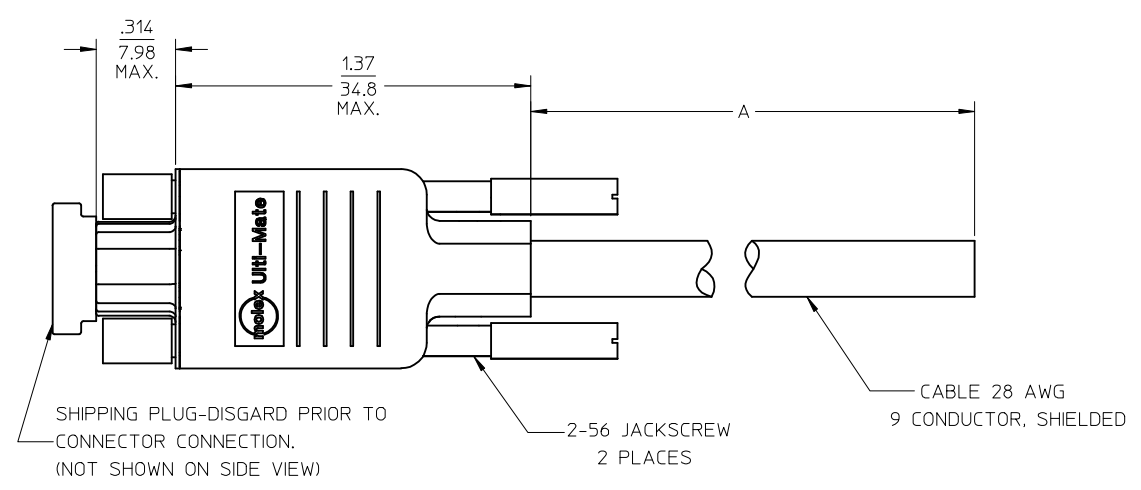
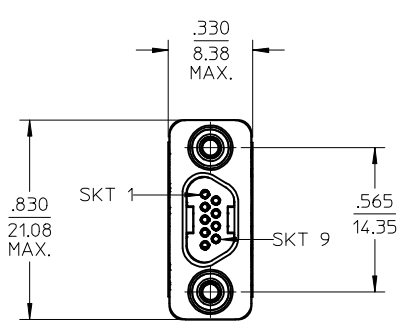
GENERAL TOLERANCES (UNLESS SPECIFIED)

| | mm | INCH |
|----------------|--------|--------|
| 4 PLACES | ± --- | ± --- |
| 3 PLACES | ± --- | ± .005 |
| 2 PLACES | ± 0.13 | ± .01 |
| 1 PLACE | ± 0.25 | ± --- |
| ANGULAR ± 1/2° | | |

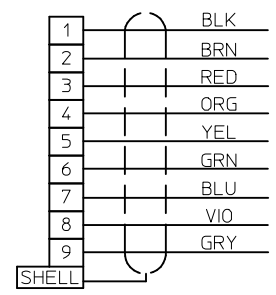
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS

DIMENSION STYLE IN/MM
 DRAWN BY JLOMASTR DATE 05/01/26
 CHECKED BY RDEROSS DATE 05/02/02
 APPROVED BY REDORSS DATE 05/02/04
 MATERIAL NO. SEE CHART

SCALE 2:1
 DESIGN UNITS INCH
 THIRD ANGLE PROJECTION
**ASSEMBLY INSTRUCTIONS
 COMMERCIAL MICRO D
 CONNECTOR**
MOLEX INCORPORATED
 DOCUMENT 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



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



1. MARKING: NONE.
 NOTES: UNLESS OTHERWISE SPECIFIED.

| | | | | | | | |
|--|-----------------|--|---|--|--------------|------------------------|--|
| REDRAWN EC NO: WNA2008-0145 DRWNR:RUPERT 2008/10/17 CHKD: APPR: JF MURPHY 2008/11/12 | QUALITY SYMBOLS | GENERAL TOLERANCES (UNLESS SPECIFIED) 4 PLACES ± --- ± --- 3 PLACES ± --- ± .005 2 PLACES ± --- ± .01 1 PLACE ± --- ± --- ANGULAR ± 2 ° | DIMENSION STYLE | SCALE | DESIGN UNITS | THIRD ANGLE PROJECTION | |
| | | | IN/MM | 2:1 | INCH | | |
| | | | mm INCH | DRAWN BY DATE D. URBACH 2AUG99 CHECKED BY DATE F. VAN WYK APPROVED BY DATE | | | |
| | | | | MATERIAL NO. 834219023 DOCUMENT NO. SD-83421-9023 SHEET NO. 1 OF 1 | | | |
| | | DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS | TITLE CONN ASSY, COMM-D 9 SKT, SPECIAL MOLEX INCORPORATED THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION | | | | |