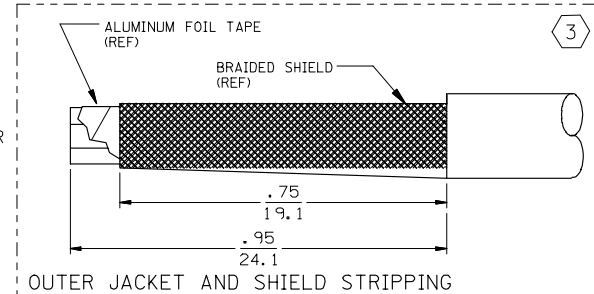
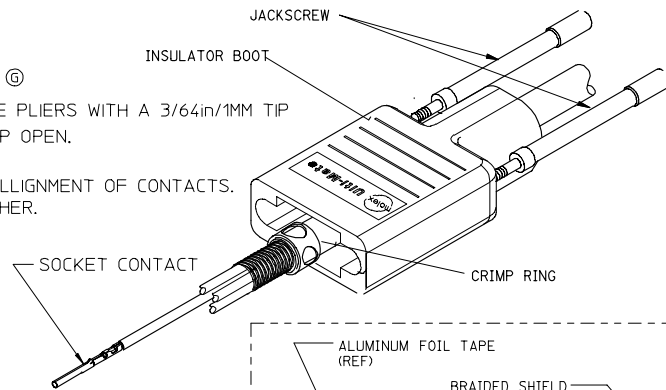


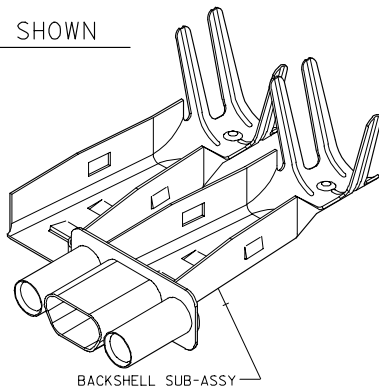
MATERIAL NUMBER	ENGINEERING NUMBER
834219101	83421-9101

CONNECTOR ASSEMBLY INSTRUCTIONS

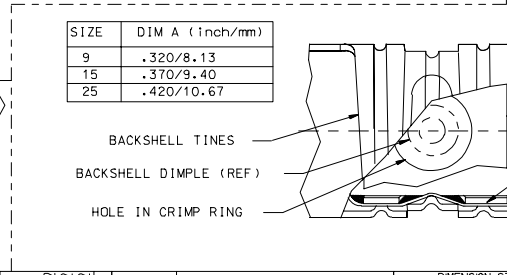
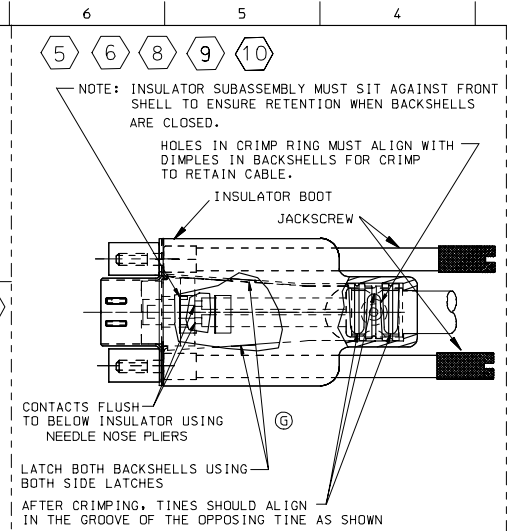
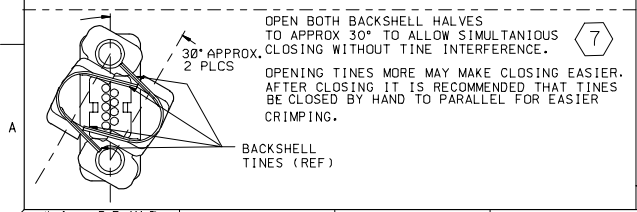
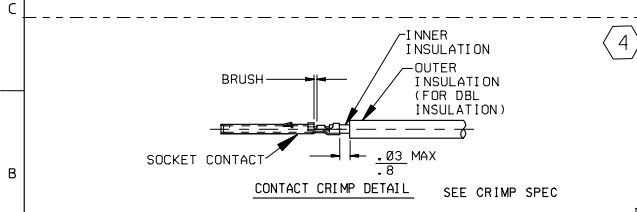
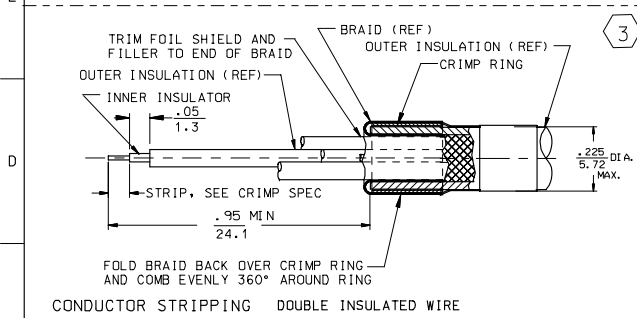
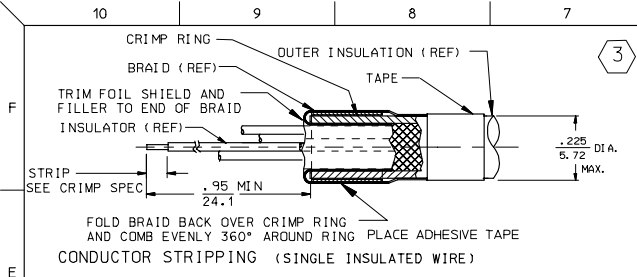
- ① SLIDE BOOT OVER CABLE.
- ② SLIDE CRIMP RING OVER CABLE.
BRAIDED SHIELD FOLDS BACK OVER CRIMP RING.
- ③ STRIP CABLE PER STRIPPING INSTRUCTIONS. (SH 1&2)
- ④ CRIMP CONTACTS PER CRIMP INSTRUCTIONS.(SH2).
SEE CRIMP SPEC 638207800 FOR FINE ADJUST APPLICATOR.
SEE CRIMP SPEC 638111400 FOR HAND TOOL.
- ⑤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



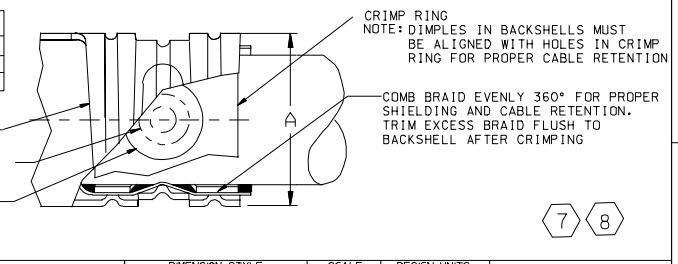
9-POSITION SHOWN



REVISED NOTES EC NO: ETC2005-0132 DRAWN: JLOMASTRO CHYCD: APPROVED: RDEROSS	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> </table> ANGULAR ±1/2°		mm	INCH	4 PLACES	± .---	± .---	3 PLACES	± .---	± .005	2 PLACES	± 0.13	± .01	1 PLACE	± 0.25	± .---	DIMENSION STYLE IN/MM	SCALE INCH	DESIGN UNITS INCH	THIRD ANGLE PROJECTION
		mm	INCH																		
	4 PLACES	± .---	± .---																		
	3 PLACES	± .---	± .005																		
2 PLACES	± 0.13	± .01																			
1 PLACE	± 0.25	± .---																			
DRAWN BY JLOMASTR DATE 05/01/26	CHECKED BY RDEROSS DATE 05/02/02	APPROVED BY REDORSS DATE 05/02/04	TITLE ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR	MOLEX INCORPORATED	DOCUMENT NO. SD-83421-006	SHEET NO. 1 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																					



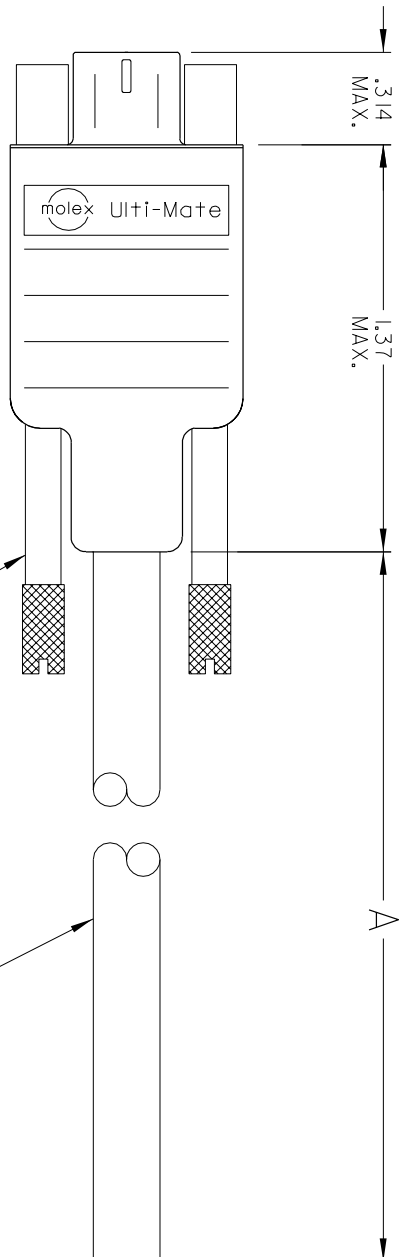
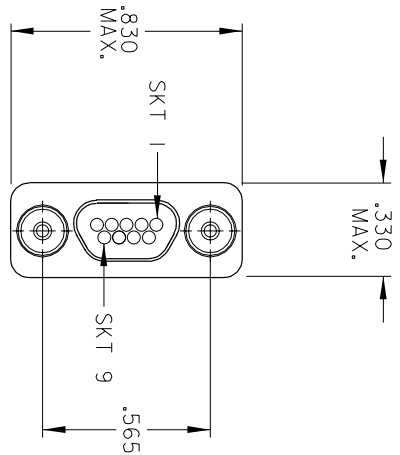
SIZE	DIM A (inch/mm)
9	.320/8.13
15	.370/9.40
25	.420/10.67



REVISED NOTES	QUALITY SYMBOLS	GENERAL TOLERANCES (UNLESS SPECIFIED)		DIMENSION STYLE		SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION
		mm	INCH	IN/MM	IN/MM			
EC NO: ETC2005-0132 DRAWN: JLOMASTR CHECKED: RDEROSS APPROVED: REDORSS DATE: 2005/02/02 DATE: 2005/02/02 DATE: 2005/02/02	▽=0 ▽=0	4 PLACES	± .005	± .005	DRAWN BY	JLOMASTR	DATE	05/01/26
		3 PLACES	± .01	± .01	CHECKED BY	RDEROSS	DATE	05/02/02
		2 PLACES	± 0.13	± .01	APPROVED BY	REDORSS	DATE	05/02/04
		1 PLACE	± 0.25	± .01	MATERIAL NO.	SEE CHART	DOCUMENT NO.	SD-83421-006
		ANGULAR ±1/2°		DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		MATERIAL NO.		SEE CHART
				MATERIAL NO.		SEE CHART	DOCUMENT NO.	SHEET NO.
				MATERIAL NO.		SEE CHART	DOCUMENT NO.	2 OF 2

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

SD-83421-9023



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

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

<p>QUALITY SYMBOLS</p> <p>MAJOR =</p> <p>CRITICAL =</p> <p>SPEC =</p>	<p>UNLESS SPECIFIED: ALL DIMENSIONS IN INCHES</p> <p>GENERAL TOLERANCES:</p> <p>3 PLACE ±.005</p> <p>2 PLACE ±.01</p> <p>ANGULAR ±2°</p>	<p>SCALE: NONE</p> <p>DWG SIZE: B</p>	<p>THIRD ANGLE PROJECTION</p>	<p>REVISE ON CAD ONLY</p>
<p>DRAWN BY & DATE: DJURBACH ZAUG99</p> <p>CHECKED BY & DATE: F. VAN WYK</p> <p>APPROVED BY & DATE:</p>	<p>TITLE: CONNECTOR ASSEMBLY, COMMERCIAL MICRO-D, 9 SKT., SPECIAL</p>	<p>PART NO.: 834219023</p> <p>DRAWING NO.: SD-83421-9023</p>	<p>MOLEX INCORPORATED</p> <p>92868</p>	<p>SHEET NO.: 1 OF 1</p> <p>REV: C</p>
<p>Uti-Mate CAGE CODE: 58967</p>	<p>THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.</p>			

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