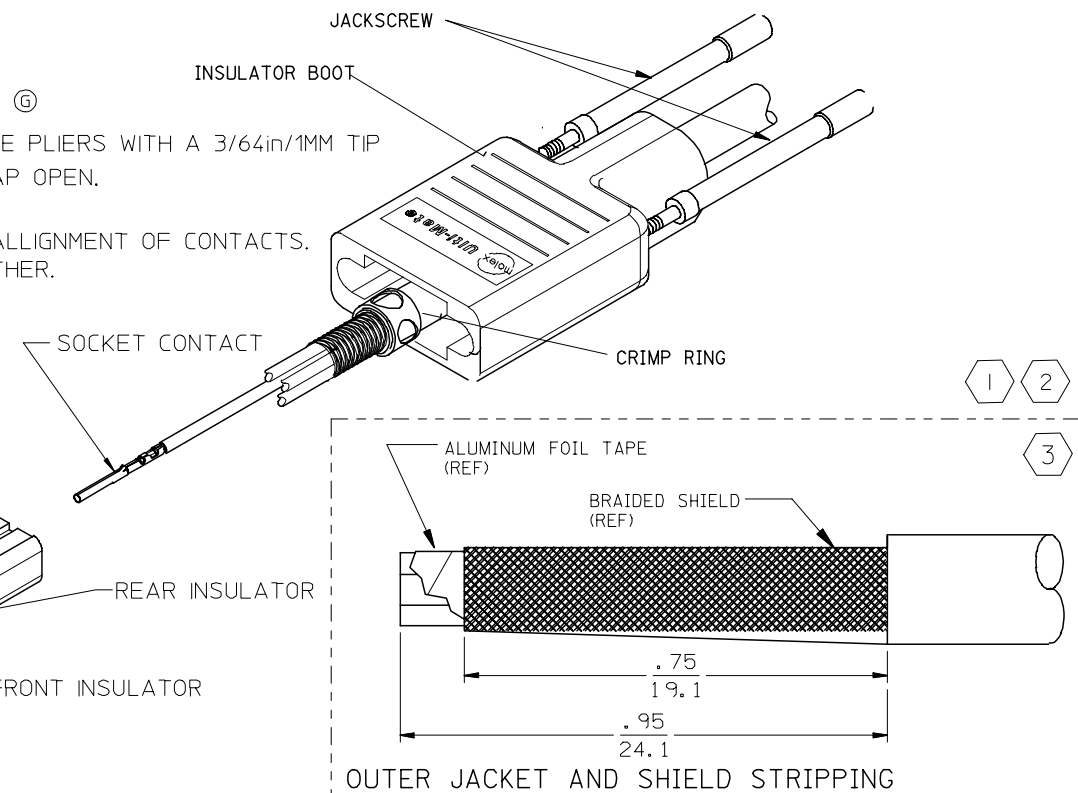


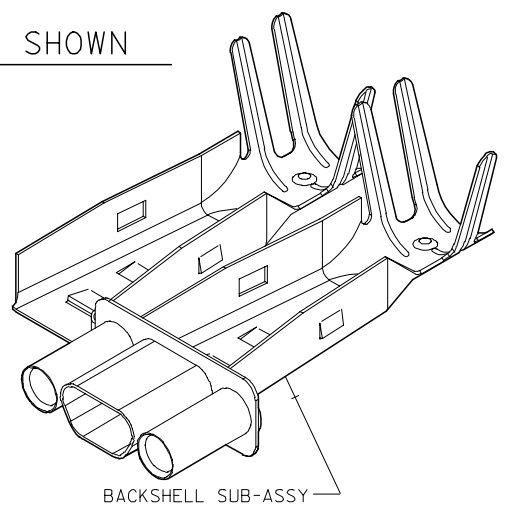
MATERIAL NUMBER	ENGINEERING NUMBER
834219101	83421-9101

CONNECTOR ASSEMBLY INSTRUCTIONS

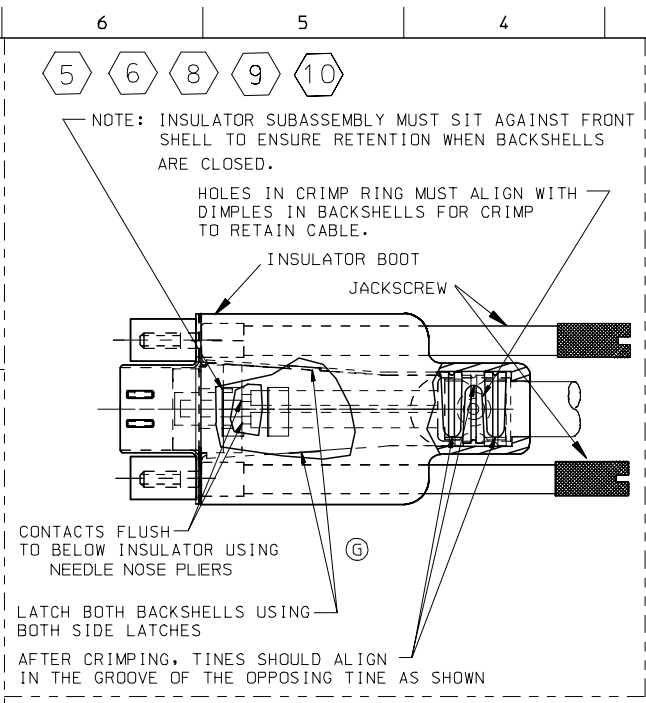
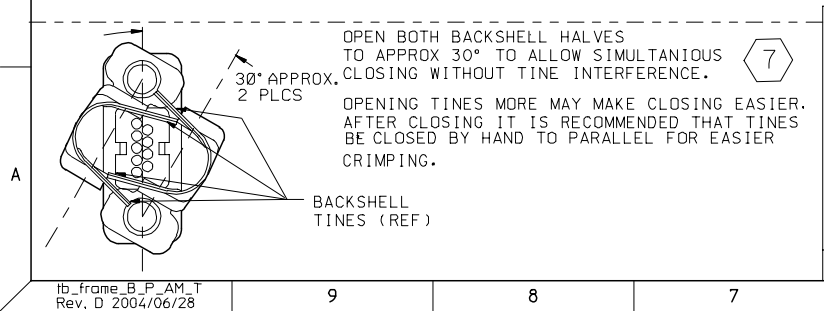
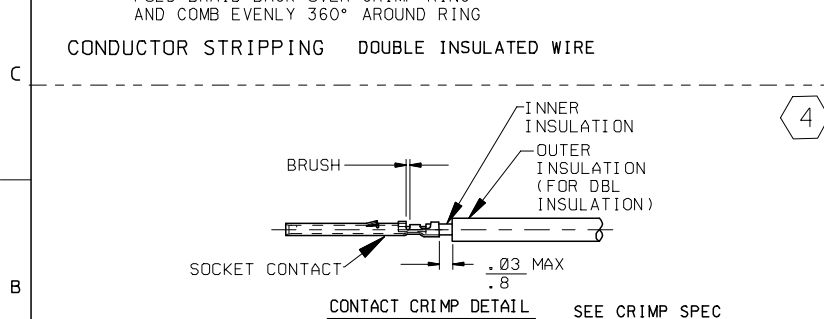
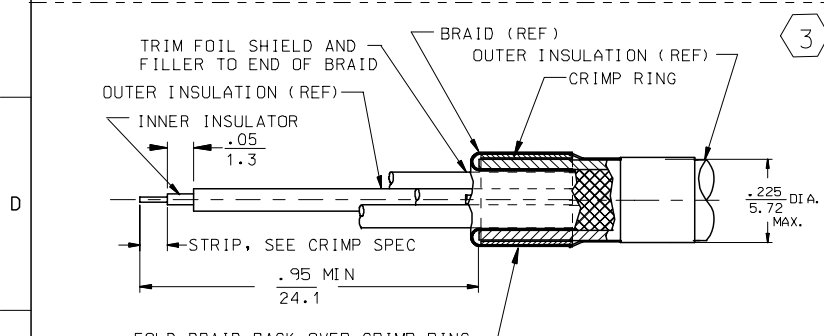
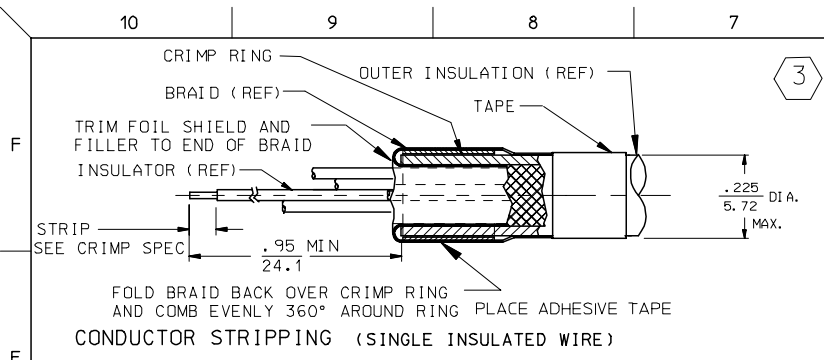
- ① SLIDE BOOT OVER CABLE.
- ② SLIDE CRIMP RING OVER CABLE.
BRAIDED SHIELD FOLDS BACK OVER CRIMP RING.
- ③ STRIP CABLE PER STRIPPING INSTRUCTIONS.(SH 1&2)
- ④ CRIMP CONTACTS PER CRIMP INSTRUCTIONS,(SH2).
SEE CRIMP SPEC 638207800 FOR FINE ADJUST APPLICATOR.
SEE CRIMP SPEC 638111400 FOR HAND TOOL.
- ⑤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



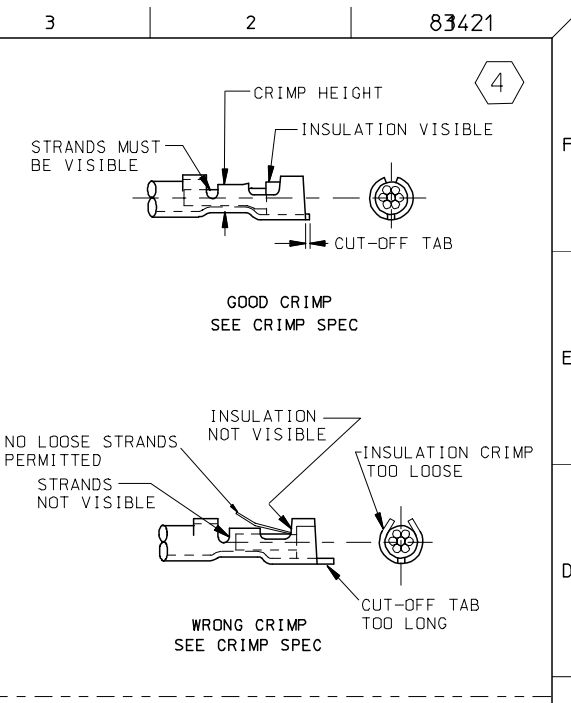
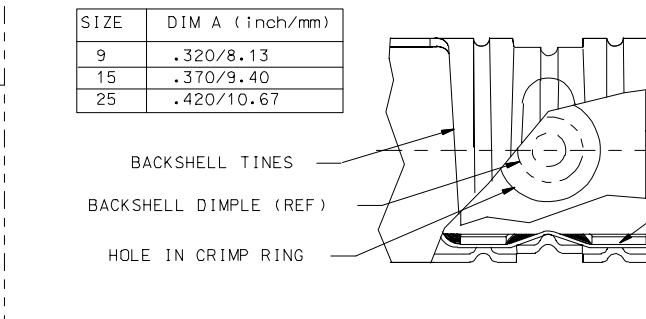
9-POSITION SHOWN



REVISED NOTES EC NO: ETC2005-0132 DRWN: JLOMASTRO 2005/02/02 CHKD: 2005/02/02 APPR: RDEROSS 2005/02/02	DESCRIPTION QUALITY SYMBOLS ▽=0 ▽=0	GENERAL TOLERANCES (UNLESS SPECIFIED)		DMENSION STYLE	SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION	
			mm	INCH	IN/MM	INCH	INCH	
		4 PLACES	± .---	± .---	DRAWN BY	DATE	TITLE	
		3 PLACES	± .---	± .005	CHECKED BY	DATE	ASSEMBLY INSTRUCTIONS	
2 PLACES	± 0.13	± .01	APPROVED BY	DATE	COMMERCIAL MICRO D			
1 PLACE	± 0.25	± .---	REDOSS	05/02/04	CONNECTOR			
		ANGULAR ± 1/2°	MATERIAL NO.	DOCUMENT NO.	MOLEX INCORPORATED			
			SEE CHART	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 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>± .01</td> <td>± .001</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	± .01	± .001	2 PLACES	± 0.13	± .01	1 PLACE	± 0.25	± .01	DIMENSION STYLE IN/MM	SCALE 1:1	DESIGN UNITS INCH	THIRD ANGLE PROJECTION
		mm	INCH																		
	4 PLACES	± .005	± .0005																		
	3 PLACES	± .01	± .001																		
2 PLACES	± 0.13	± .01																			
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																	

