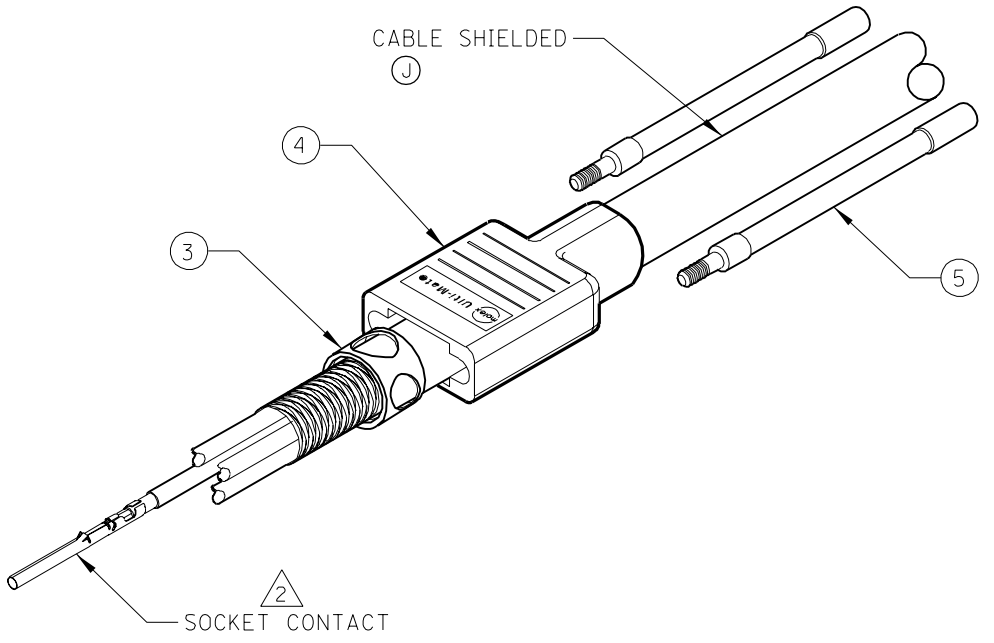
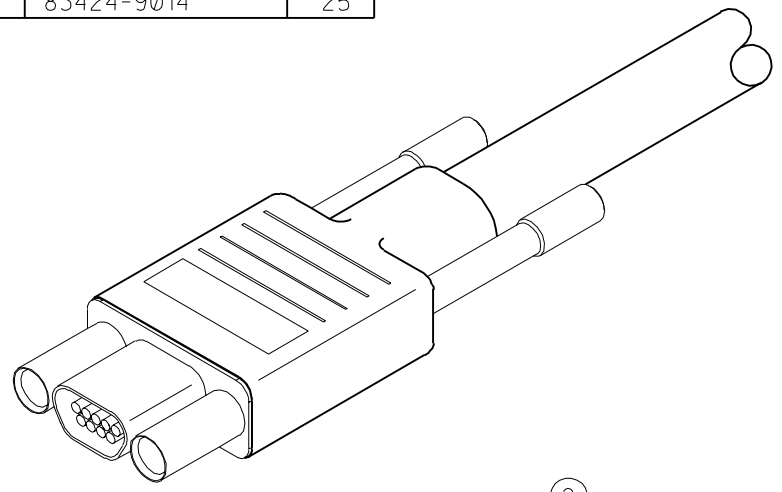
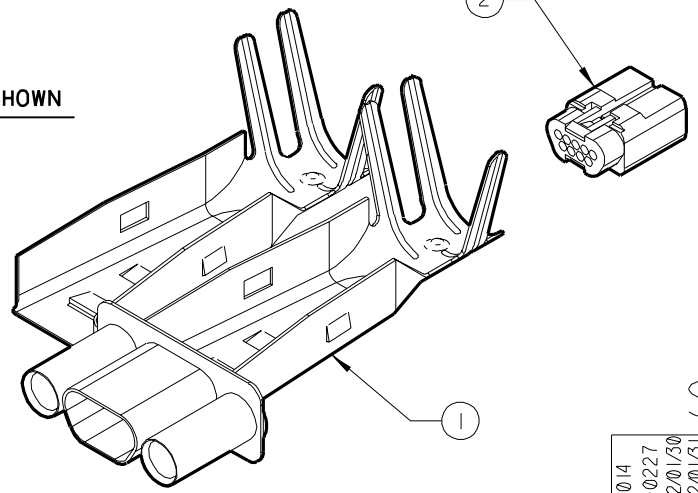


MATERIAL NO.	ENGINEERING NO.	SIZE
834219014	83421-9014	9
834229014	83422-9014	15
834249014	83424-9014	25

SD-83421-002



SIZE 9 SHOWN



ITEM	QTY	DESCRIPTION
6	1	ASSEMBLY INSTRUCTIONS
5	2	2-56 JACKSCREW
4	1	RUBBER BOOT MICRO-D
3	1	CRIMP RING MICRO-D
2	1	INSULATOR SUB-ASSY. MICRO-D
1	1	BACKSHELL SUB-ASSY. MICRO-D

SALES DRAWING

CONTACTS SOLD SEPARATELY. ORDER BY:
 P/N 830009502 (2500 CONTACT REEL)
 P/N 830009503 (50000 CONTACT REEL)
 P/N 830000083 (LOOSE CONTACTS)

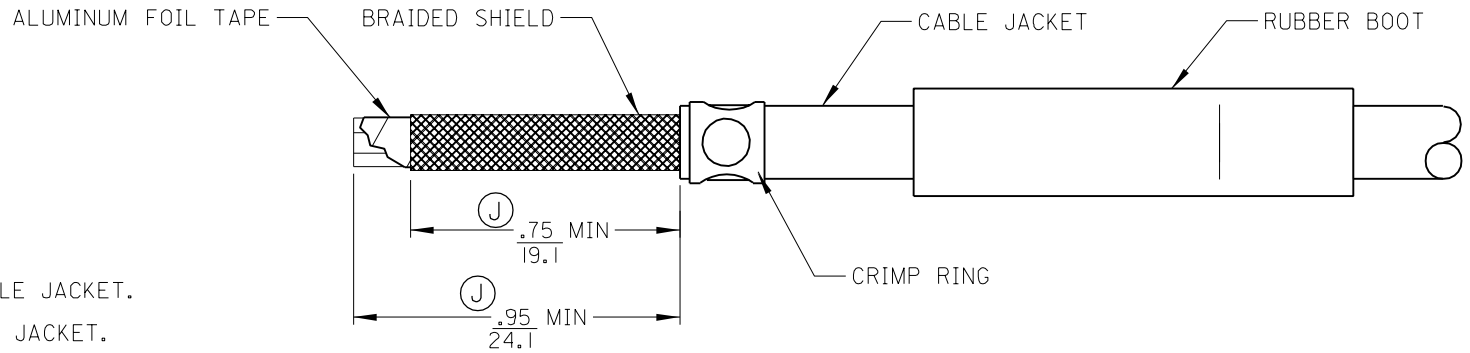
1. REFER TO PS-83421-9000 FOR PRODUCT SPECIFICATION.

NOTES: UNLESS OTHERWISE SPECIFIED

WAS SD-83421-9014 EC No. ETC2002-0227 DRWN:EMF 02/01/30 CHK:HEB 02/01/31 APPR:RWD 02/01/31	QUALITY SYMBOLS MAJOR $\nabla = 0$ CRITICAL $\nabla C = 0$	GENERAL TOLERANCES: (UNLESS SPECIFIED) <table border="1"> <tr> <td></td> <td>mm</td> <td>INCH</td> </tr> <tr> <td>4 PLACES</td> <td>$\pm 0.$</td> <td>$\pm .$</td> </tr> <tr> <td>3 PLACES</td> <td>$\pm 0.$</td> <td>$\pm .005$</td> </tr> <tr> <td>2 PLACES</td> <td>± 0.13</td> <td>± 0.10</td> </tr> <tr> <td>1 PLACE</td> <td>± 0.3</td> <td>$\pm .$</td> </tr> </table>			mm	INCH	4 PLACES	$\pm 0.$	$\pm .$	3 PLACES	$\pm 0.$	$\pm .005$	2 PLACES	± 0.13	± 0.10	1 PLACE	± 0.3	$\pm .$	SCALE: NO:NE <input type="checkbox"/> mm <input checked="" type="checkbox"/> INCH	DESIGN UNITS <input type="checkbox"/> mm <input checked="" type="checkbox"/> INCH	DIMENSIONS: <input type="checkbox"/> mm <input checked="" type="checkbox"/> INCH <input type="checkbox"/> mm ONLY	SHT REV REVISE ON CAD ONLY
			mm	INCH																		
4 PLACES	$\pm 0.$	$\pm .$																				
3 PLACES	$\pm 0.$	$\pm .005$																				
2 PLACES	± 0.13	± 0.10																				
1 PLACE	± 0.3	$\pm .$																				
DESCRIPTION REV	DRAWN BY & DATE URBACH 99/09/03 CHECKED BY & DATE HEB 02/01/31 APPROVED BY & DATE RWD 02/01/31	TITLE: CONNECTOR KIT RECEPTACLE SIZES 9, 15 & 25 W/ 2-56 JACKSCREWS		MOLEX INCORPORATED		MATERIAL NO. SEE CHART	DRAWING NO. SD-83421-002	SHEET NO. 1 OF 2														
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		ANGULAR: $\pm 1/2^\circ$		CAD FILENAME SD83421002.S01		THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.		SIZE B														

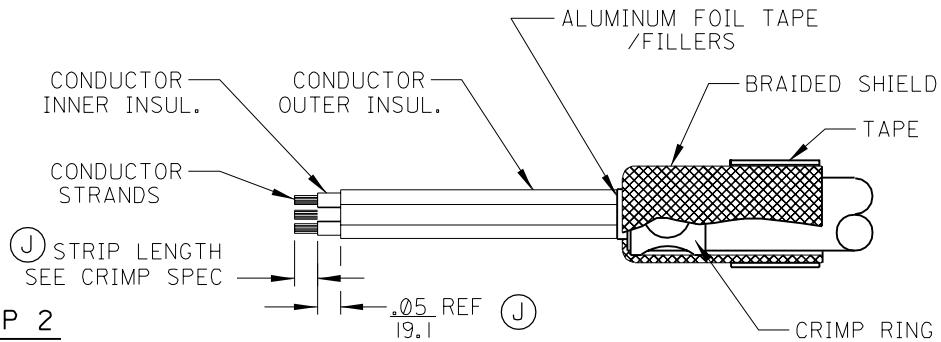
CABLE PREPARATION

DOUBLE SHIELDED CABLE



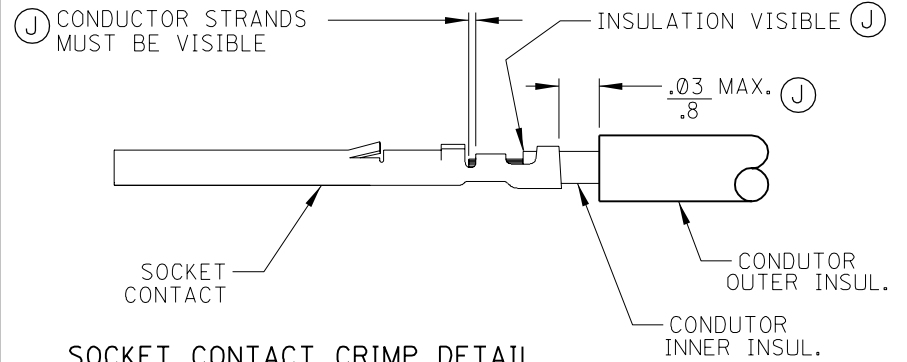
STEP 1

- 1) SLIDE RUBBER BOOT OVER CABLE JACKET.
- 2) SLIDE CRIMP RING OVER CABLE JACKET.
- 3) TRIM CABLE JACKET AND BRAIDED SHIELD TO DIMENSIONS SHOWN.



STEP 2

- 1) SLIDE CRIMP RING UP TO END OF CABLE JACKET.
 - 2) FOLD BRAID BACK OVER CRIMP RING, DISTRIBUTE EVENLY AND TAPE.
 - 3) TRIM ALUMINUM FOIL AND FILLERS BACK TO BRAIDED SHIELD, (END OF CABLE JACKET).
 - 4) STRIP LENGTH SEE CRIMP SPEC
 - 5) CRIMP CONTACTS AS SHOWN AND LOAD IN INSULATOR.
 - 6) LOAD INSULATOR INTO BACKSHELL SUB-ASSEMBLY AND CRIMP.
- NOTE: BE SURE TO ORIENTATE HOLE OF CRIMP RING TO MATE WITH DIMPLE IN BACKSHELL.



SOCKET CONTACT CRIMP DETAIL

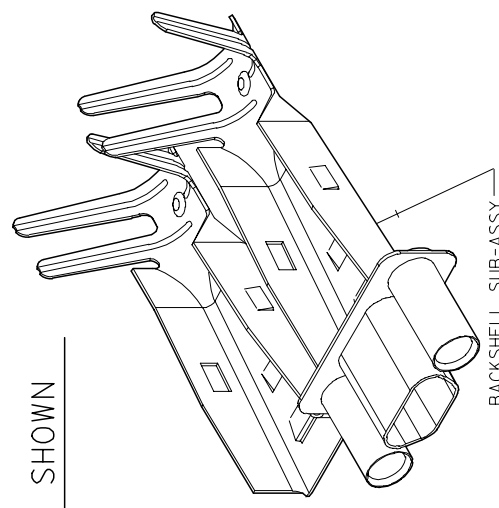
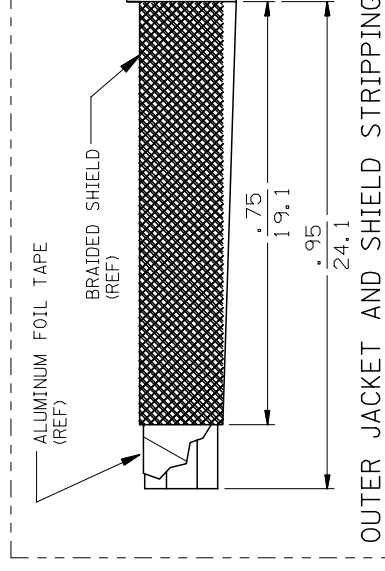
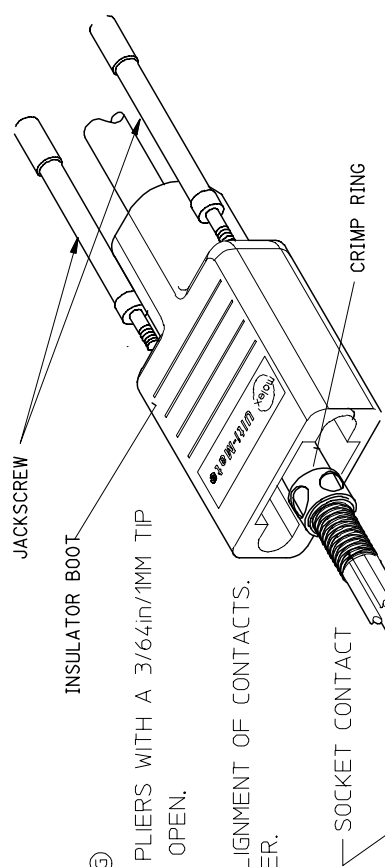
SALES DRAWING

WAS SD-83421-90/14 EC No. ETC2002-0227 DRWN:EMF 02/01/30 CHK:HEB 02/01/31 APPR:RWD 02/01/31	QUALITY SYMBOLS MAJOR $\nabla = 0$ CRITICAL $\nabla C = 0$	GENERAL TOLERANCES: (UNLESS SPECIFIED)		SCALE NO: NE	DESIGN UNITS <input type="checkbox"/> mm <input checked="" type="checkbox"/> INCH	DIMENSIONS: <input type="checkbox"/> mm <input checked="" type="checkbox"/> INCH <input type="checkbox"/> mm ONLY	SHT REV
		4 PLACES $\pm 0.$ $\pm .$ 3 PLACES $\pm 0.$ $\pm .005$ 2 PLACES ± 0.13 ± 0.10 1 PLACE ± 0.3 $\pm .$	DRAWN BY & DATE URBACH 99/09/03 CHECKED BY & DATE HEB 02/01/31 APPROVED BY & DATE RWD 02/01/31	TITLE: CONNECTOR KIT RECEPTACLE SIZES 9, 15 & 25 W/ 2-56 JACKSCREWS		THIRD ANGLE PROJECTION <input type="checkbox"/> mm <input checked="" type="checkbox"/> INCH <input type="checkbox"/> mm ONLY	REVISE ON CAD ONLY
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	CAD FILENAME SD83421002.S02	MATERIAL NO. SEE SHT 1	DRAWING NO. SD-83421-002	SHEET NO. 2 OF 2	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION.	SIZE B	

MATERIAL NUMBER	ENGINEERING NUMBER
834219101	83421-9101

CONNECTOR ASSEMBLY INSTRUCTIONS

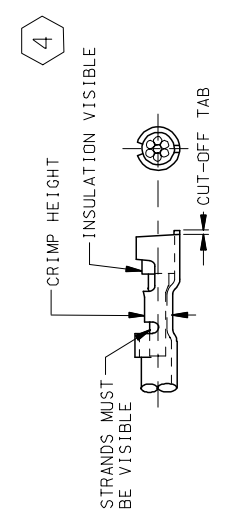
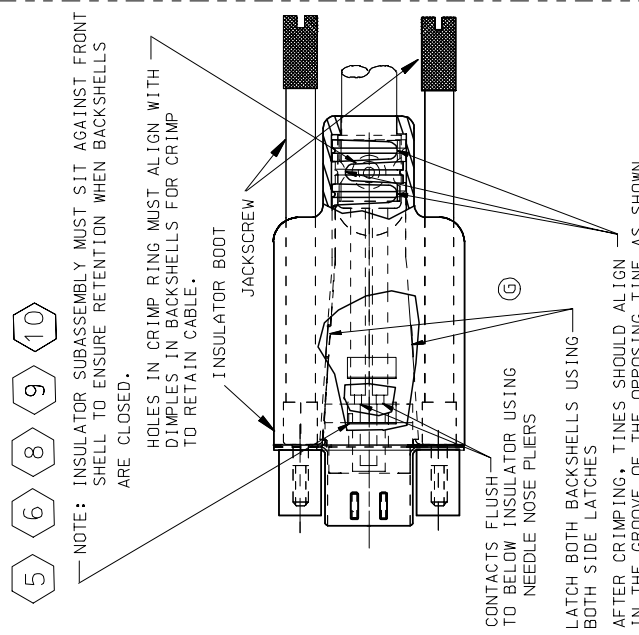
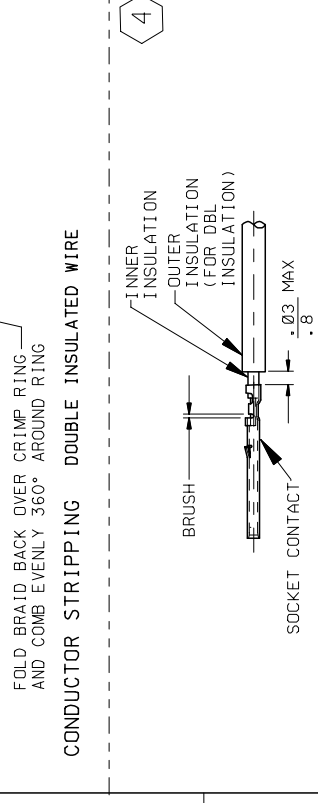
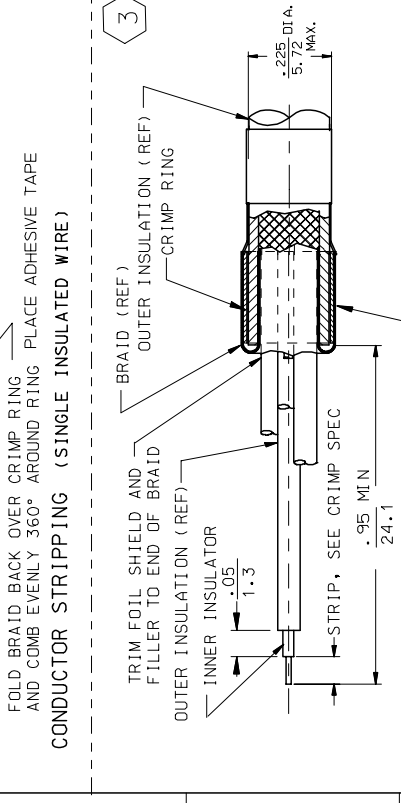
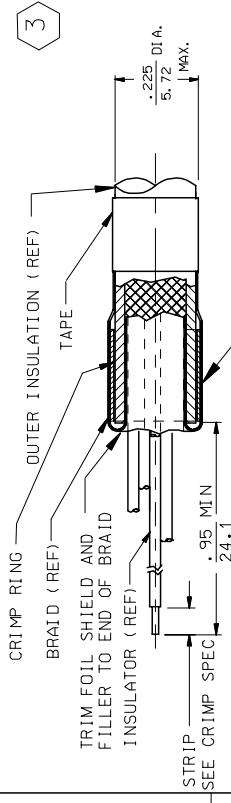
- ① SLIDE BOOT OVER CABLE.
- ② SLIDE CRIMP RING OVER CABLE.
BRAIDED SHIELD FOLDS BACK OVER CRIMP RING.
- ③ STRIP CABLE PER STRIPPING INSTRUCTIONS. (SH 1&2)
- ④ CRIMP CONTACTS PER CRIMP INSTRUCTIONS,(SH2).
SEE CRIMP SPEC 638207800 FOR FINE ADJUST APPLICATOR.
SEE CRIMP SPEC 638111400 FOR HAND TOOL.
- ⑤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



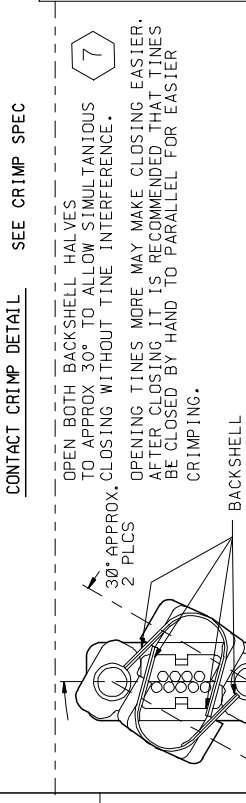
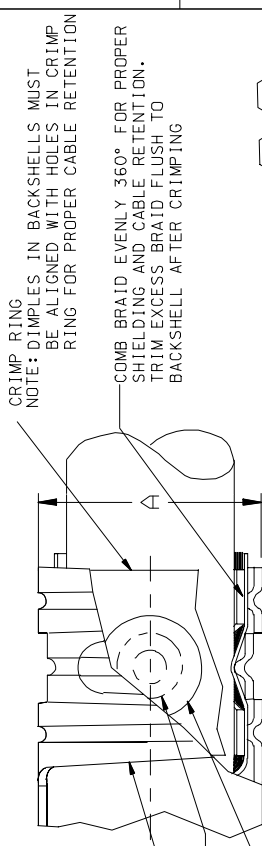
9-POSITION SHOWN

OUTER JACKET AND SHIELD STRIPPING

QUALITY SYMBOLS	▷=0	▽=0	DESCRIPTION	REV
	DRW: JLOWASTRO 2005/02/02 CHD: 2005/02/02 APPR: RDEROSS 2005/02/02			B
GENERAL TOLERANCES (UNLESS SPECIFIED)		DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS		
4 PLACES	± .005	± .005	DATE	05/01/26
3 PLACES	± .01	± .01	CHECKED BY	RDEROSS
2 PLACES	± .025	± .025	DATE	05/02/02
1 PLACE	± .025	± .025	APPROVED BY	RDEROSS
ANGULAR		± 1/2°		
DIMENSION STYLE		INCH		
SCALE		ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR		
DESIGN UNITS		THIRD ANGLE PROJECTION		
TITLE		ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR		
DRAWN BY		DATE		
JLOWASTRO		05/01/26		
CHECKED BY		DATE		
RDEROSS		05/02/02		
APPROVED BY		DATE		
RDEROSS		05/02/04		
MATERIAL NO.		DOCUMENT NO.		
MOLEX		MOLEX INCORPORATED		
SHEET NO.		1 OF 2		
SEE CHART		SD-83421-006		
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



QUALITY SYMBOLS	GENERAL TOLERANCES (UNLESS SPECIFIED)	DIMENSION STYLE	SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION										
▶=0	4 PLACES ± .005	IN/MM	1:1	INCH											
◀=0	3 PLACES ± .01														
	2 PLACES ± 0.13														
	1 PLACE ± 0.25														
	ANGULAR ±1/2°														
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS															
REVISIONS: <table border="1"> <tr> <th>REV</th> <th>DESCRIPTION</th> </tr> <tr> <td>B</td> <td>DRWN: JLOWASTRO</td> </tr> <tr> <td></td> <td>CHKD: 2005/02/02</td> </tr> <tr> <td></td> <td>APP: RDEROSS</td> </tr> <tr> <td></td> <td>2005/02/02</td> </tr> </table>						REV	DESCRIPTION	B	DRWN: JLOWASTRO		CHKD: 2005/02/02		APP: RDEROSS		2005/02/02
REV	DESCRIPTION														
B	DRWN: JLOWASTRO														
	CHKD: 2005/02/02														
	APP: RDEROSS														
	2005/02/02														
REVISIONS: <table border="1"> <tr> <th>REV</th> <th>DESCRIPTION</th> </tr> <tr> <td>B</td> <td>ETC NO: ETC2005-012</td> </tr> <tr> <td></td> <td>2005/02/02</td> </tr> </table>						REV	DESCRIPTION	B	ETC NO: ETC2005-012		2005/02/02				
REV	DESCRIPTION														
B	ETC NO: ETC2005-012														
	2005/02/02														