

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

### CONNECTOR ASSEMBLY INSTRUCTIONS

- 1 SLIDE INSULATOR 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 638522000 & 638622000 FOR APPLICATOR, TERMINATOR DIE AND CRIMP SPEC..  
SEE 638114800 FOR HAND TOOL AND CRIMP SPEC.

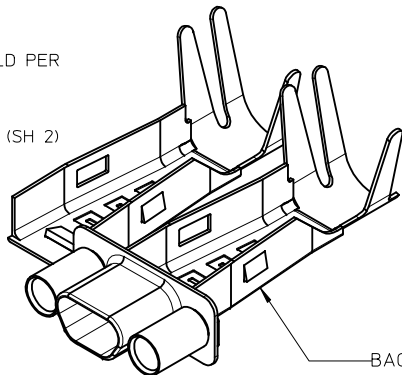
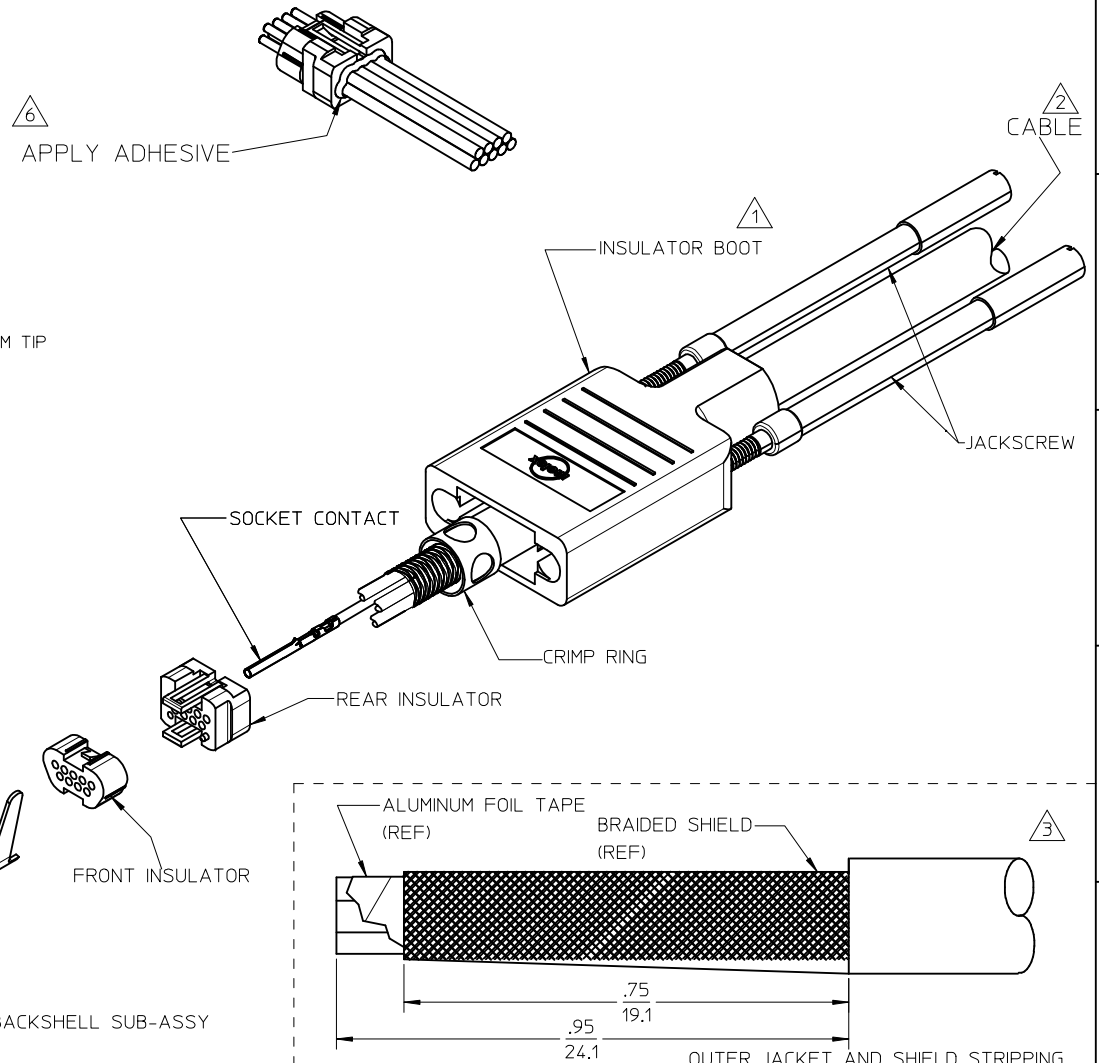
- 5 INSERT CONTACTS INTO BACK OF REAR INSULATOR USING NEEDLE NOSE PLIERS WITH A 3/64in/1MM TIP (SPECIAL CARE MUST BE TAKEN NOT TO DAMAGE LOCKING WINGS).  
PUSH CONTACT INTO REAR INSULATOR UNTIL "WINGS" ON CONTACT SNAP OPEN.  
CONTACT SHOULD NOT EXTEND BEYOND THE BACK OF INSULATOR.  
PLACE FRONT INSULATOR ONTO REAR INSULATOR ASSURING PROPER ALIGNMENT OF CONTACTS.  
CONTINUE TO PUSH UNTIL FRONT AND REAR INSULATOR SNAP TOGETHER.  
LIGHTLY PULL CRIMPED WIRE TO ENSURE TERMINAL HAS LOCKED INTO INSULATOR.  
-WARNING PULLING TO HARD CAN DAMAGE CONTACT-

- 6 APPLY ADHESIVE LOCITE 416 OR EQUIVANT AROUND EACH WIRE AS SHOWN, WHERE WIRE ENTERS INSULATOR
- 7 MOUNT INSULATOR SUBASSEMBLY IN BACKSHELL SUBASSEMBLY PER ASSY INSTRUCTION. (SH2)
- 8 CLOSE BACKSHELL SUBASSEMBLY AROUND CABLE SHIELD PER INSTRUCTIONS. (SH 2)

- 9 CRIMP BACKSHELL TO METAL BRAID PER INSTRUCTIONS. (SH 2)  
SEE CRIMP SPEC.

	9 POSITION	15 POSITION	25 POSITION
MOLEX PRESS	622008900	622019800	622020000
CRIMP KIT	622009000	622019900	622020100

- 10 SLIDE BOOT OVER BACKSHELL SUBASSEMBLY.
- 11 INSERT JACKSCREWS INTO BOOT.
- 12 USE WITH MOLEX TERMINALS 830009502, 830009503 OR 830000083

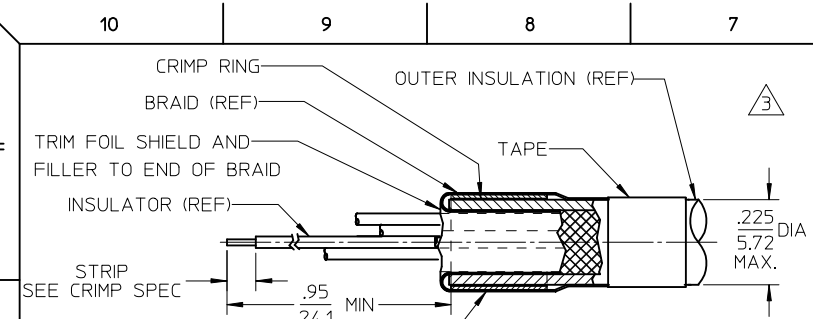


9 POSITION SHOWN

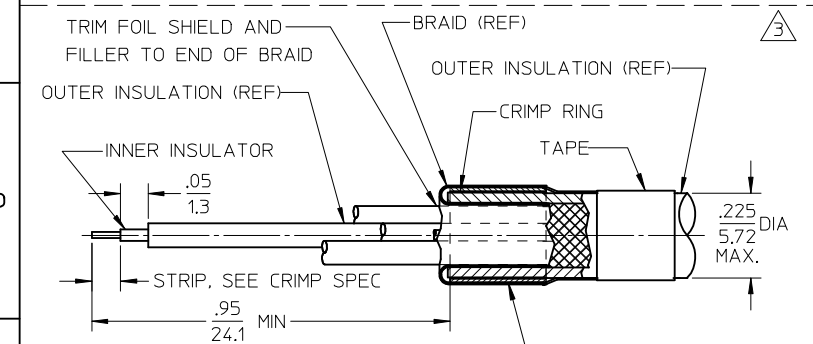
<b>ADDED VIEW &amp; NOTE</b> EC NO: IPG2014-1862 DRAWN:GGUSTAFSON 2014/04/25 CHKD: APPR:BWODMAN 2014/05/09 REV DESCRIPTION	QUALITY SYMBOLS	GENERAL TOLERANCES (UNLESS SPECIFIED)	DIMENSION STYLE	SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION
	▽=0	mm INCH	IN/MM	2:1	INCH	⊙ □
	∇=0	4 PLACES ± --- ± ---	DRAWN BY DATE	TITLE	ASSEMBLY INSTRUCTIONS	
		3 PLACES ± --- ± ---	GGUSTAFSON 2014/03/26	CHECKED BY DATE	COMMERCIAL MICRO D CONNECTOR	

2 PLACES ± --- ± ---	APPROVED BY DATE	MOLEX INCORPORATED DOCUMENT NO. SD-83421-040
1 PLACE ± --- ± ---	BWOODMAN 2014/04/04	
ANGULAR ± ---°	MATERIAL NO.	SHEET NO.
	SEE CHART	1 OF 2

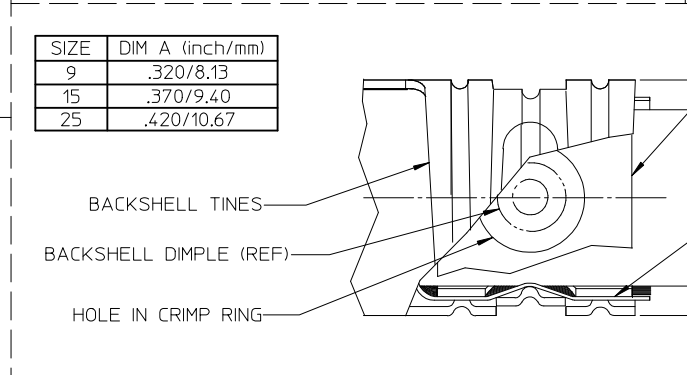
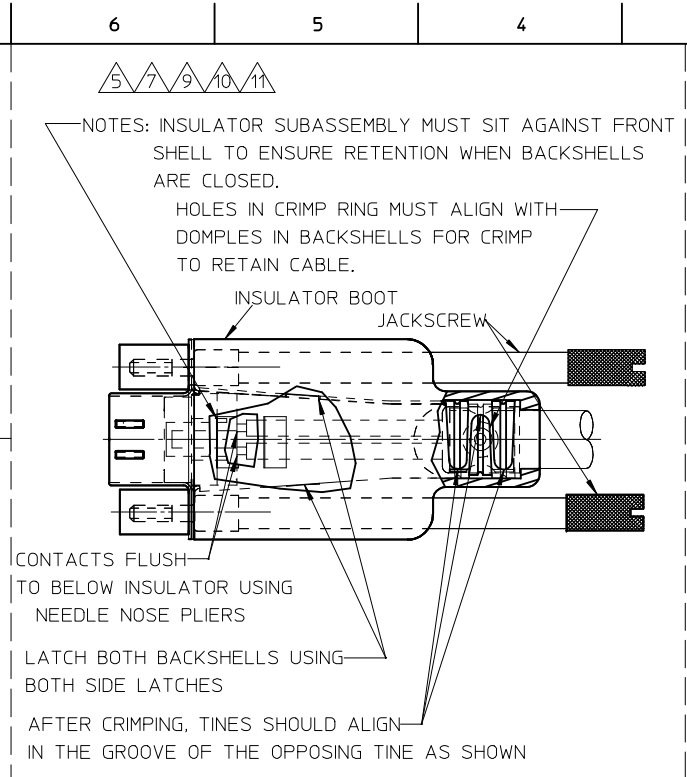
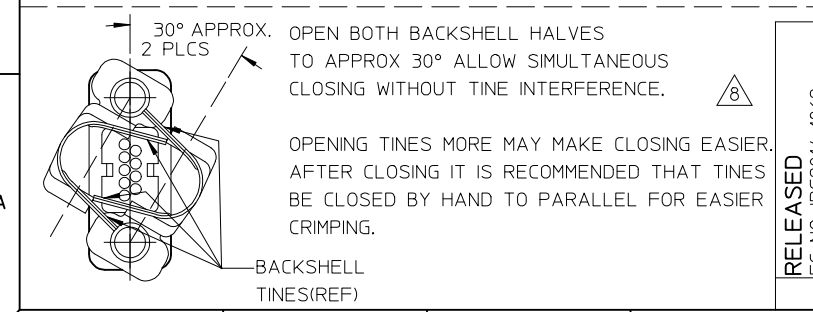
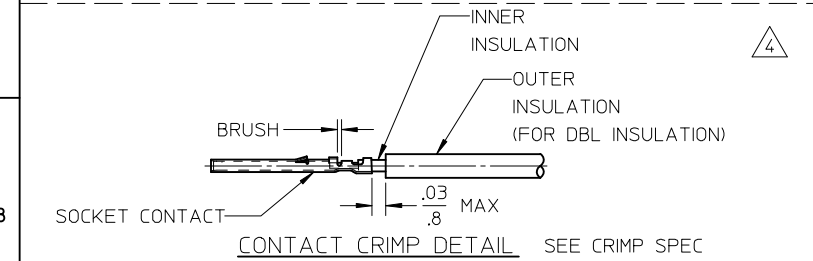
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	SIZE A3	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION	
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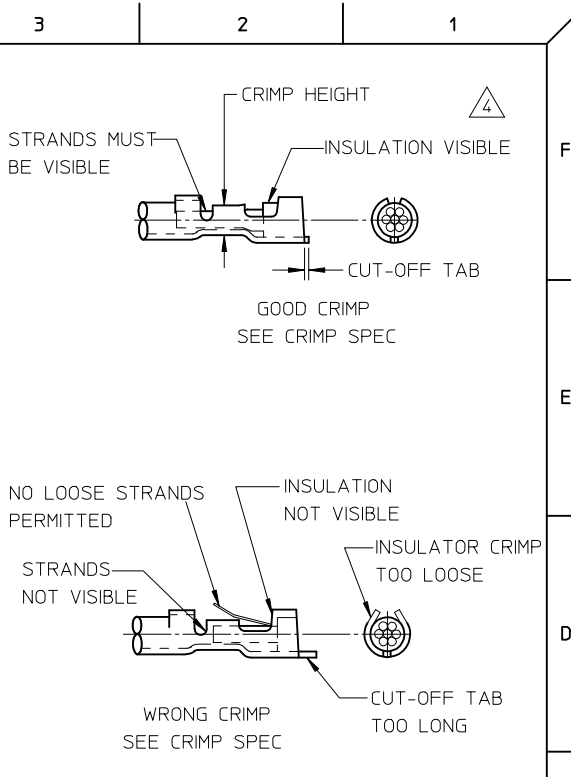
FOLD BRAID BACK OVER CRIMP RING AND COMB EVENLY 360° AROUND RING, PLACE ADHESIVE TAPE AROUND BRAID AS SHOWN  
**CONDUCTOR STRIPPING (SINGLE INSULATED WIRE)**



FOLD BRAID BACK OVER CRIMP RING AND COMB EVENLY 360° AROUND RING, PLACE ADHESIVE TAPE AROUND BRAID AS SHOWN.  
**CONDUCTOR STRIPPING DOUBLE INSULATED WIRE**



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



RELEASED EC NO: IPG2014-1862 2014/04/25  
 DRAWN:GGUSTAFSON 2014/03/26  
 CHKD: 2014/05/09  
 APPR:BWODMAN 2014/05/09  
 DESCRIPTION

QUALITY SYMBOLS  
 ▽=0  
 ▽=0  
 GENERAL TOLERANCES (UNLESS SPECIFIED)  
 4 PLACES ± --- ± ---  
 3 PLACES ± --- ± ---  
 2 PLACES ± --- ± ---  
 1 PLACE ± --- ± ---  
 ANGULAR ± ---°  
 DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS

DIMENSION STYLE IN/MM  
 DRAWN BY GGUSTAFSON 2014/03/26  
 CHECKED BY DATE  
 APPROVED BY BWODMAN 2014/04/04  
 MATERIAL NO. SEE CHART

SCALE 2:1  
 DESIGN UNITS INCH  
 THIRD ANGLE PROJECTION  
 TITLE ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR  
 MOLEX INCORPORATED  
 DOCUMENT NO. SD-83421-040 SHEET NO. 2 OF 2  
 THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION