

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)

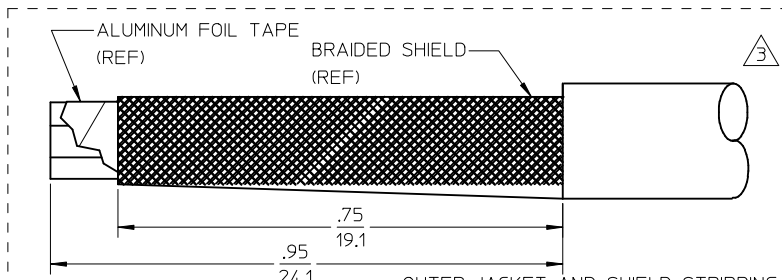
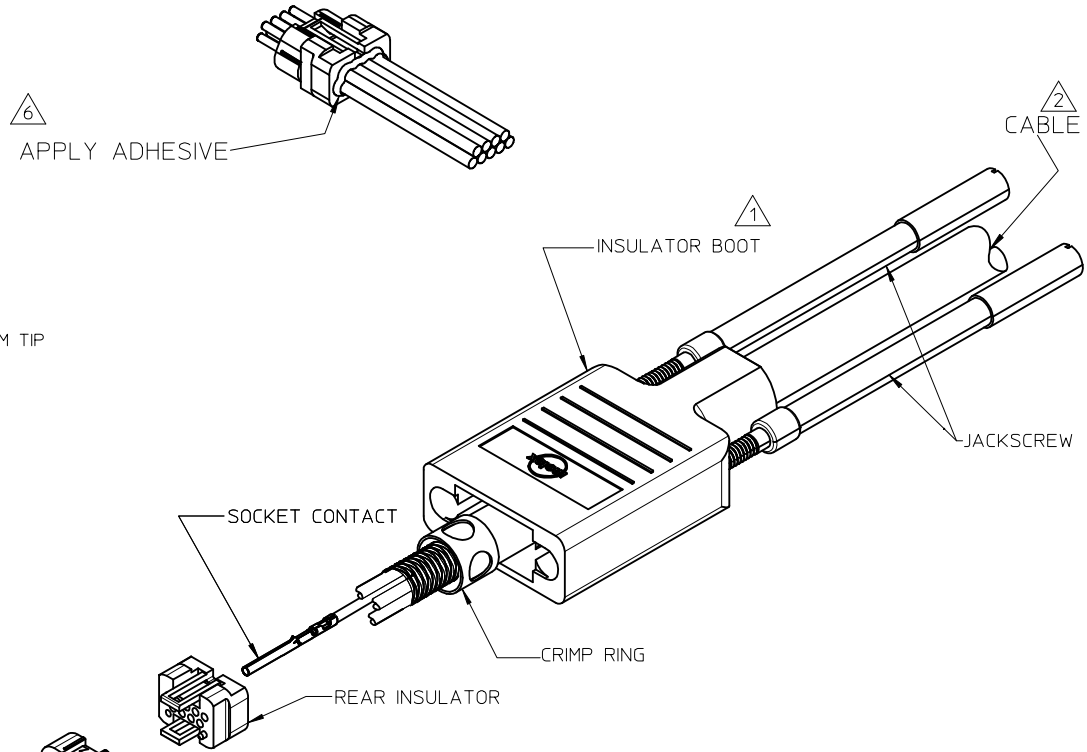
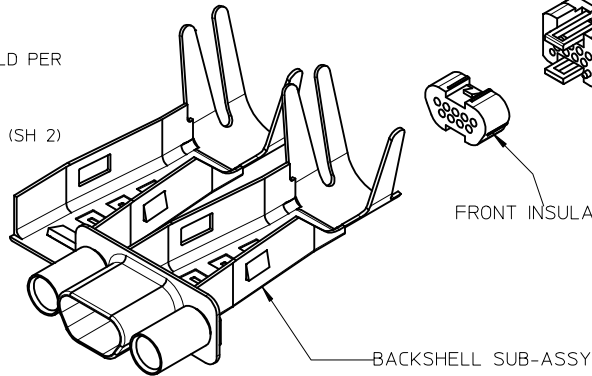
CRIMP BACKSHELL TO METAL BRAID PER INSTRUCTIONS. (SH 2)
SEE CRIMP SPEC.

	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



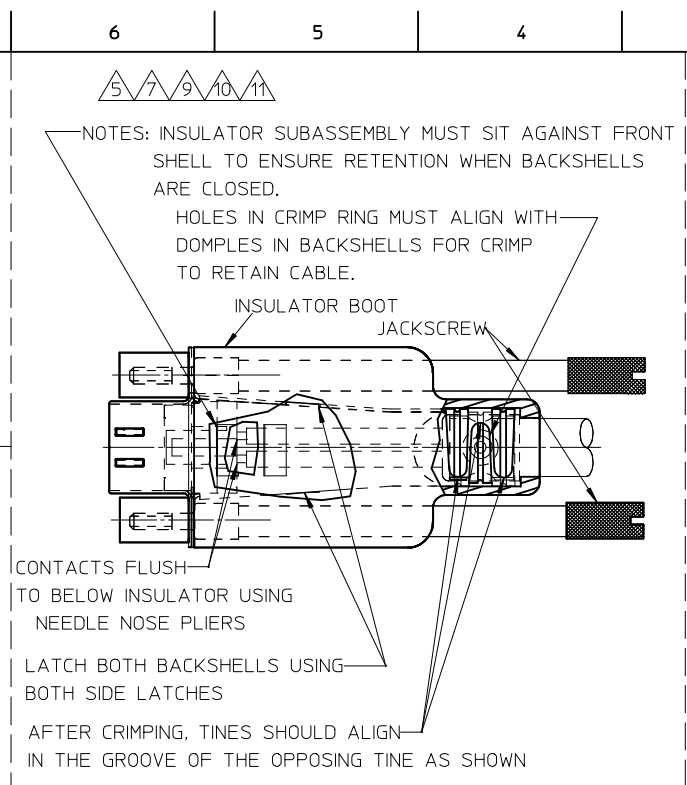
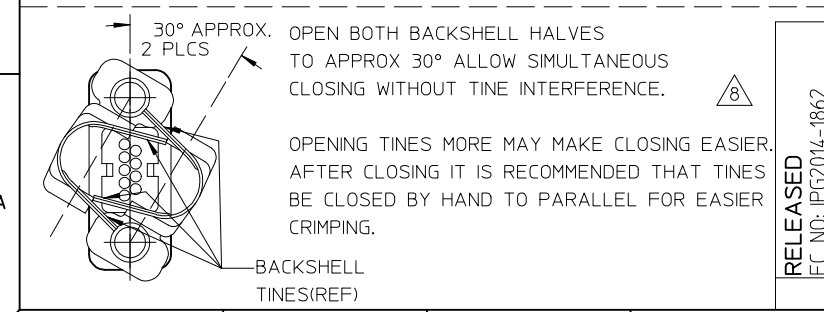
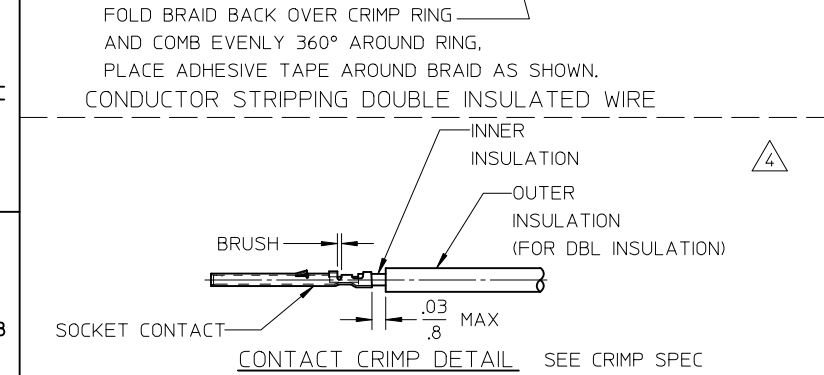
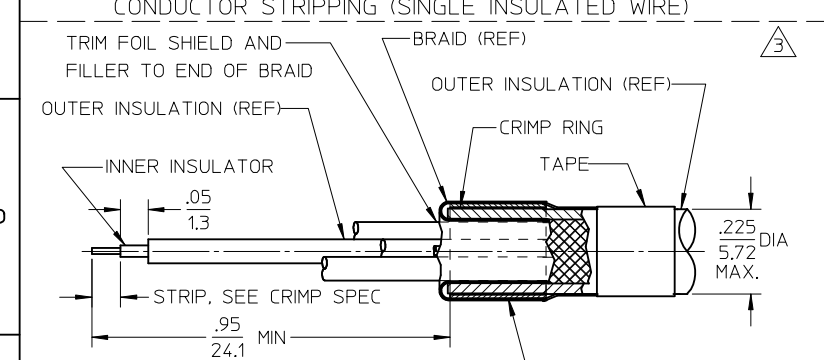
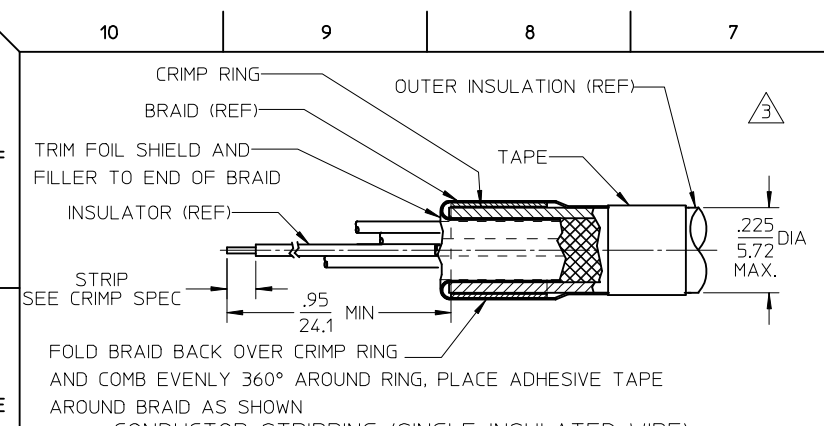
9 POSITION SHOWN

ADDED VIEW & NOTE EC NO: IPG2014-1862 DRAWN:GGUSTAFSON 2014/04/25 CHKD: APPR:BWODMAN 2014/05/09	QUALITY SYMBOLS	DESCRIPTION
	▽=0	
	◻=0	
	REV	

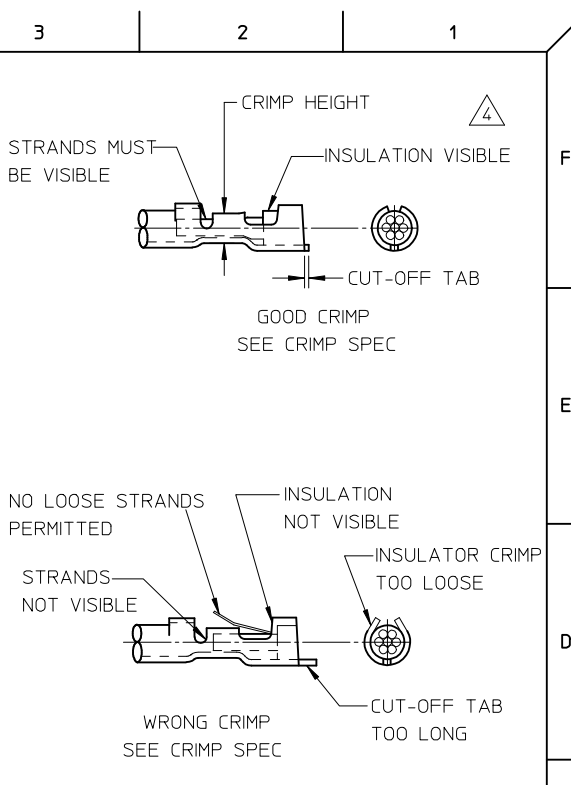
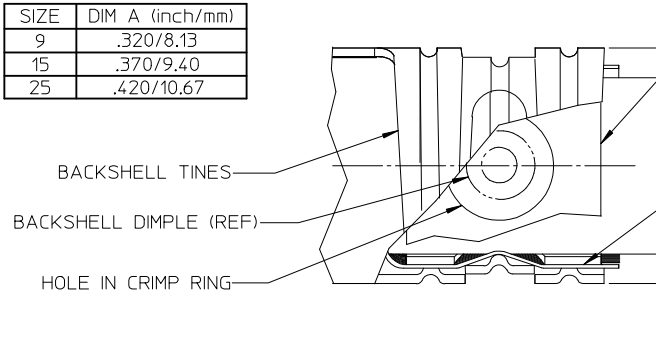
GENERAL TOLERANCES (UNLESS SPECIFIED) 4 PLACES ± --- ± --- 3 PLACES ± --- ± --- 2 PLACES ± --- ± --- 1 PLACE ± --- ± --- ANGULAR ± ---° DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	mm	INCH

DIMENSION STYLE		SCALE	DESIGN UNITS
IN/MM		2:1	INCH
DRAWN BY	DATE	TITLE	
GGUSTAFSON	2014/03/26	ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR	
CHECKED BY	DATE	MOLEX INCORPORATED	
APPROVED BY	DATE	DOCUMENT NO.	
BWOODMAN	2014/04/04	SD-83421-040	
MATERIAL NO.	SHEET NO.		
SEE CHART	1 OF 2		

OUTER JACKET AND SHIELD STRIPPING			
THIRD ANGLE PROJECTION			
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



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

QUALITY SYMBOLS
▽=0
◻=0

GENERAL TOLERANCES (UNLESS SPECIFIED)

	mm	INCH
4 PLACES	± ---	± ---
3 PLACES	± ---	± ---
2 PLACES	± ---	± ---
1 PLACE	± ---	± ---
ANGULAR ± ---°		

DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS

DIMENSION STYLE
IN/MM

SCALE
2:1

DESIGN UNITS
INCH

THIRD ANGLE PROJECTION

DRAWN BY
GGUSTAFSON

DATE
2014/03/26

CHECKED BY

DATE

APPROVED BY
BWODMAN

DATE
2014/04/04

MATERIAL NO.

SEE CHART

TITLE
ASSEMBLY INSTRUCTIONS
COMMERCIAL MICRO D
CONNECTOR

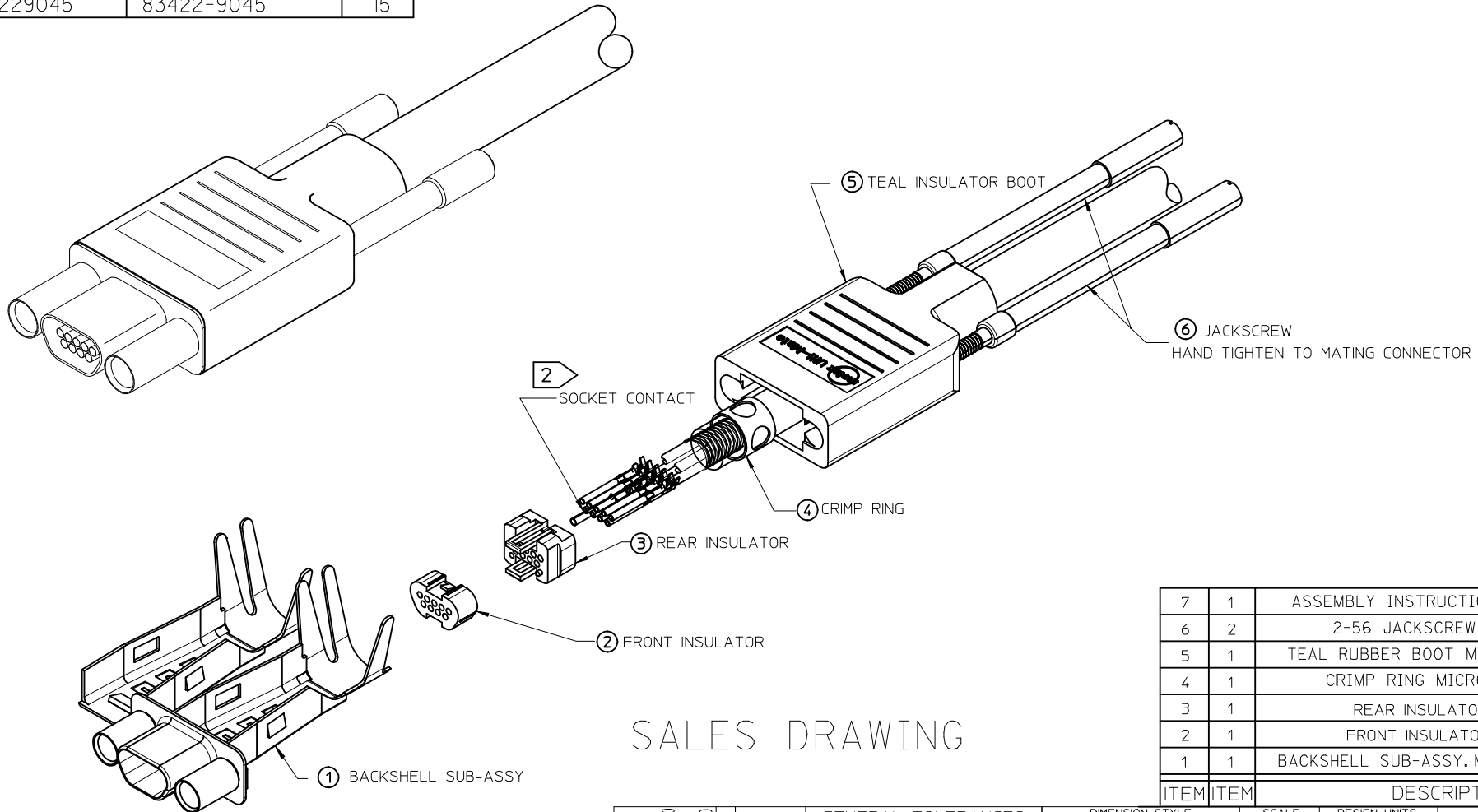
MOLEX INCORPORATED

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

10	9	8	7	6	5	4	3	2	1
MATERIAL NO.	ENGINEERING NO.	SIZE							
834229045	83422-9045	15							



SALES DRAWING

7	1	ASSEMBLY INSTRUCTIONS NOT SHOWN
6	2	2-56 JACKSCREW UNDIPPED
5	1	TEAL RUBBER BOOT MICRO-D SIZE 15
4	1	CRIMP RING MICRO-D SIZE 15
3	1	REAR INSULATOR
2	1	FRONT INSULATOR
1	1	BACKSHELL SUB-ASSY. MICRO-D SIZE 15
ITEM	ITEM	DESCRIPTION

NOTES:
 1. REFER TO PS-83421-9000 FOR PRODUCT SPECIFICATION
 2. CONTACTS SOLD SEPARATELY. ORDER BY:
 P/N 830009502 (2500 CONTACT REEL)
 P/N 830009503 (50000 CONTACT REEL)
 P/N 830009583 (LOOSE CONTACTS)
 3. ROHS COMPLIANT

UPDATE DWG EC NO: WNA2009-0427 DRWN:BRUPERT 2009/01/20 CHKD:B.RUPERT APPR:JF.MURPHY 2009/01/30	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>±----</td> </tr> <tr> <td>2 PLACES</td> <td>±----</td> <td>±----</td> </tr> <tr> <td>1 PLACE</td> <td>±----</td> <td>±----</td> </tr> </table>		mm	INCH	4 PLACES	±----	±----	3 PLACES	±----	±----	2 PLACES	±----	±----	1 PLACE	±----	±----	DIMENSION STYLE IN/MM DRAWN BY JLMASTRO DATE 05/09/19 CHECKED BY RDEROSS DATE 05/09/19 APPROVED BY RDEROSS DATE 05/09/19	SCALE DESIGN UNITS INCH THIRD ANGLE PROJECTION	TITLE CONNECTOR KIT RECEPTACLE 2-56 JACKSCREW SIZE 15 MOLEX INCORPORATED	MATERIAL NO. SEE CHART DOCUMENT NO. SD-83422-004 SHEET NO. 1 OF 1
		mm	INCH																		
	4 PLACES	±----	±----																		
	3 PLACES	±----	±----																		
2 PLACES	±----	±----																			
1 PLACE	±----	±----																			
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																			