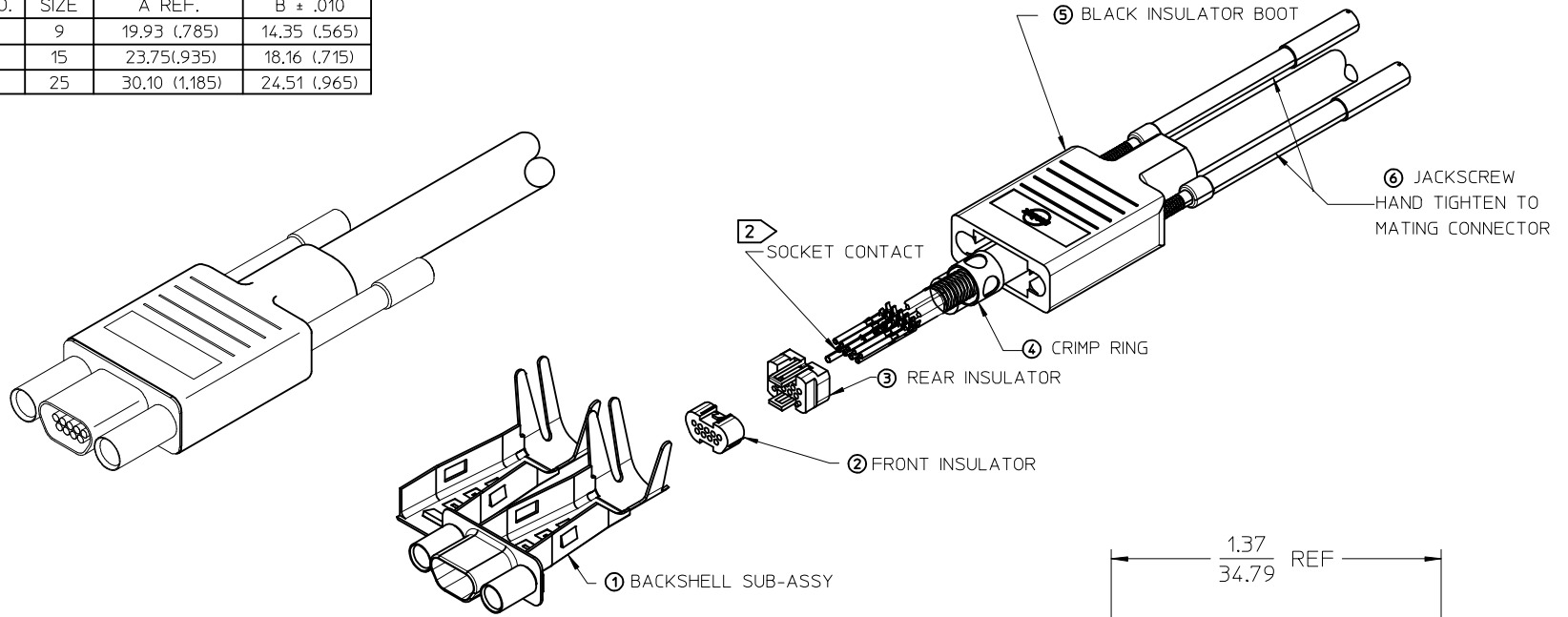
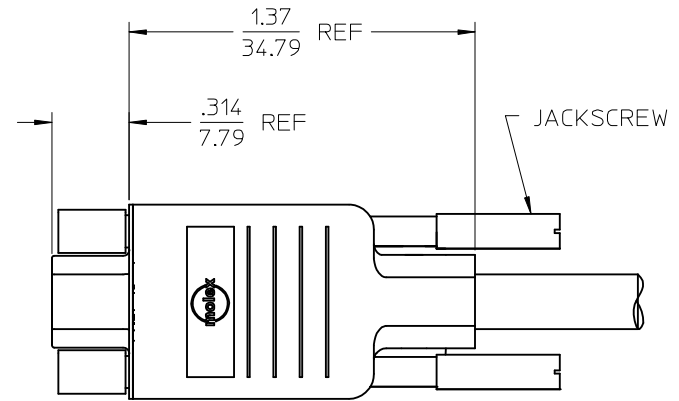
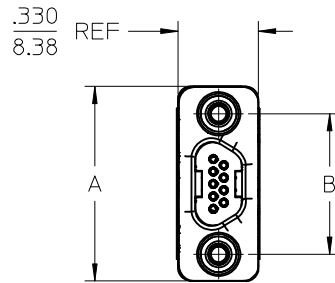


MATERIAL NO.	ENGINEERING NO.	SIZE	A REF.	B ± .010
834219014	83421-9014	9	19.93 (.785)	14.35 (.565)
834229014	83422-9014	15	23.75(.935)	18.16 (.715)
834249014	83424-9014	25	30.10 (1.185)	24.51 (.965)



ITEM	ITEM	DESCRIPTION
7	1	ASSEMBLY INSTRUCTIONS NOT SHOWN
6	2	2-56 JACKSCREW UNDIPPED
5	1	RUBBER BOOT MICRO-D
4	1	CRIMP RING MICRO-D
3	1	REAR INSULATOR
2	1	FRONT INSULATOR
1	1	BACKSHELL SUB-ASSY, MICRO-D SIZE I5



3. ROHS COMPLIANT

⚠ 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-83421-001 FOR PRODUCT SPECIFICATION

NOTES: UNLESS OTHERWISE SPECIFIED

ADDED LAYOUT VIEW EC NO: IPG2014-0111 DR:MINIBARDEN CHKD: APPR: BWOODMAN 2013/07/16 2013/07/25	QUALITY SYMBOLS	GENERAL TOLERANCES (UNLESS SPECIFIED)	DIMENSION STYLE	SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION	
	▽=0 ▽=0	mm INCH	IN/MM	2:1	INCH		
		4 PLACES ± --- ± --- 3 PLACES ± --- ± --- 2 PLACES ± --- ± --- 1 PLACE ± --- ± --- 0 PLACE ± --- ± ---	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, W/2-56 JACKSCREWS <b>molex</b> SD-83421-002		
		ANGULAR ±1/2° DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	MATERIAL NO. SEE CHART	DOCUMENT NO.			
			SIZE B	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 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.

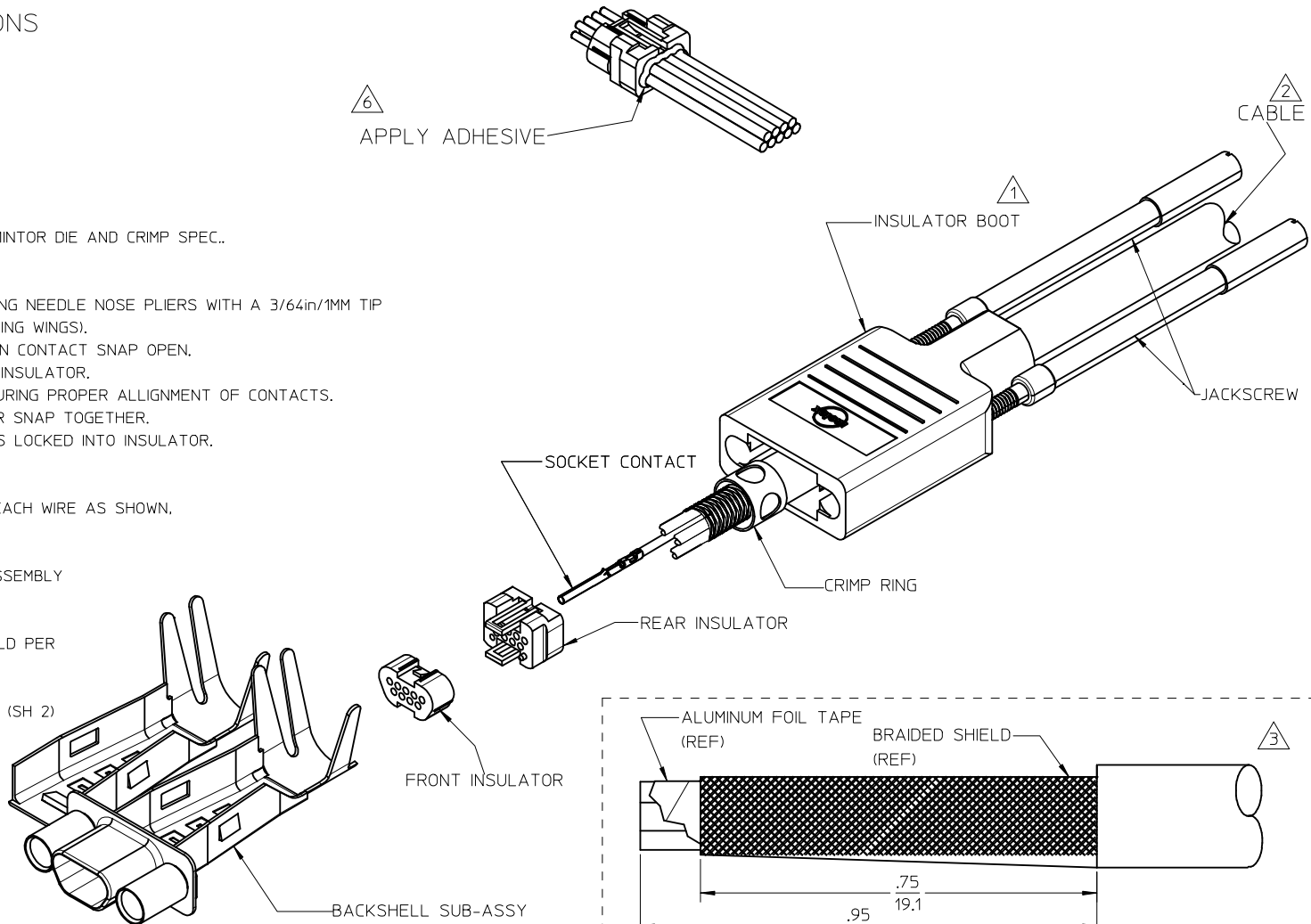
- 5 INSERT CONTACTS INTO BACK OF REAR INSULATOR USING NEEDLE NOSE PLIERS WITH A 3/64in/1MM TIP (SPECIAL CARE MUST BE TAKEN NOT TO DAMAGE LOCKING WINGS).  
PUSH CONTACT INTO REAR INSULATOR UNTIL "WINGS" ON CONTACT SNAP OPEN.  
CONTACT SHOULD NOT EXTEND BEYOND THE BACK OF INSULATOR.  
PLACE FRONT INSULATOR 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



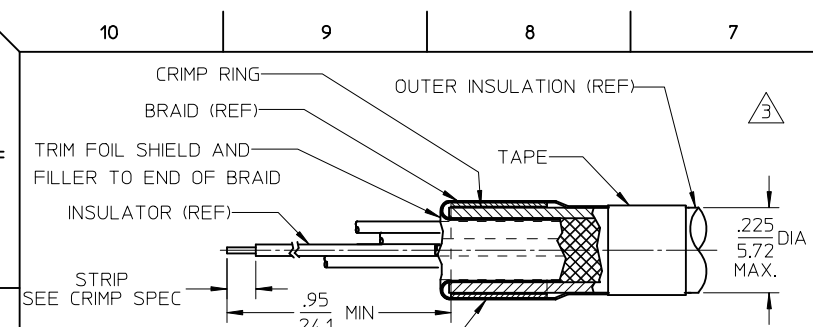
9 POSITION SHOWN

<b>ADDED VIEW &amp; NOTE</b> EC NO: IPG2014-1862 DRWN:GGUSTAFSON 2014/04/25 CHKD: APPR:BWODMAN 2014/05/09	QUALITY SYMBOLS	DESCRIPTION
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	◻=0	
	REV	

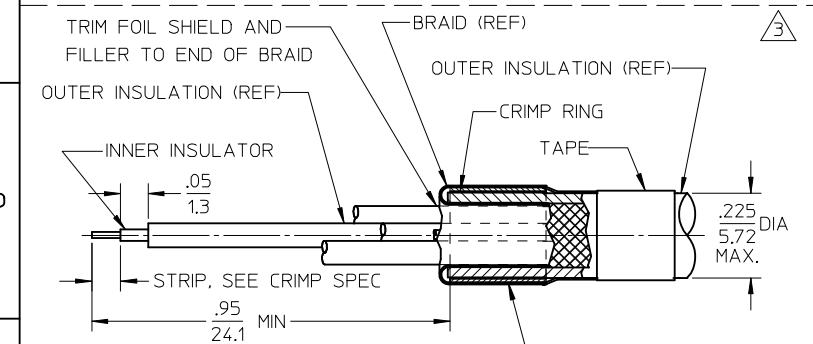
GENERAL TOLERANCES (UNLESS SPECIFIED)	DIMENSION STYLE	SCALE	DESIGN UNITS	THIRD ANGLE PROJECTION
	IN/MM	2:1	INCH	☉ □
4 PLACES ± ---	mm			
3 PLACES ± ---	INCH			
2 PLACES ± ---				
1 PLACE ± ---				
ANGULAR ± ---°				
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS	SIZE	THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION		
	A3			

DRAWN BY	DATE	TITLE
GGUSTAFSON	2014/03/26	ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR
CHECKED BY	DATE	
APPROVED BY	DATE	
BWOODMAN	2014/04/04	
MATERIAL NO.	DOCUMENT NO.	SHEET NO.
SEE CHART	SD-83421-040	1 OF 2

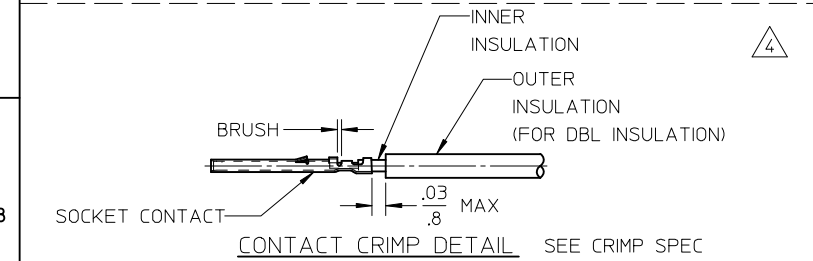
MOLEX INCORPORATED	
SD-83421-040	
1 OF 2	



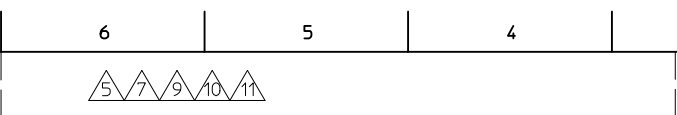
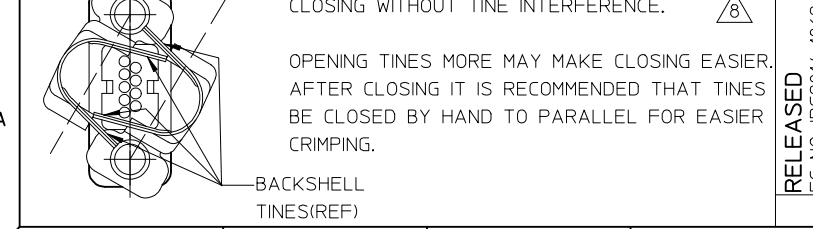
FOLD BRAID BACK OVER CRIMP RING AND COMB EVENLY 360° AROUND RING, PLACE ADHESIVE TAPE AROUND BRAID AS SHOWN  
**CONDUCTOR STRIPPING (SINGLE INSULATED WIRE)**



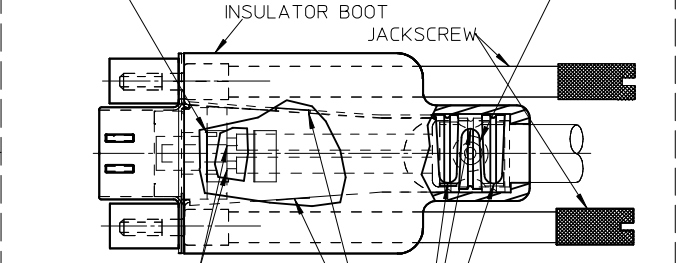
FOLD BRAID BACK OVER CRIMP RING AND COMB EVENLY 360° AROUND RING, PLACE ADHESIVE TAPE AROUND BRAID AS SHOWN.  
**CONDUCTOR STRIPPING DOUBLE INSULATED WIRE**



**CONTACT CRIMP DETAIL** SEE CRIMP SPEC

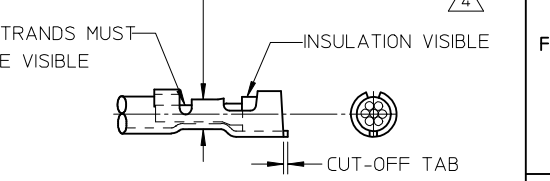
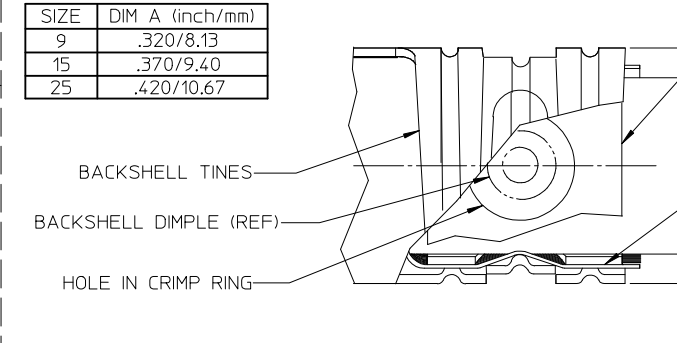


NOTES: INSULATOR SUBASSEMBLY MUST SIT AGAINST FRONT SHELL TO ENSURE RETENTION WHEN BACKSHELLS ARE CLOSED.  
 HOLES IN CRIMP RING MUST ALIGN WITH DOMPLES IN BACKSHELLS FOR CRIMP TO RETAIN CABLE.



CONTACTS FLUSH TO BELOW INSULATOR USING NEEDLE NOSE PLIERS  
 LATCH BOTH BACKSHELLS USING BOTH SIDE LATCHES  
 AFTER CRIMPING, TINES SHOULD ALIGN IN THE GROOVE OF THE OPPOSING TINE AS SHOWN

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



NO LOOSE STRANDS PERMITTED  
 STRANDS NOT VISIBLE  
 INSULATION NOT VISIBLE  
 INSULATOR CRIMP TOO LOOSE  
 CUT-OFF TAB TOO LONG  
 WRONG CRIMP SEE CRIMP SPEC

<b>RELEASED</b> EC NO: IPG2014-1862 DRWN:GGUSTAFSON 2014/04/25 CHKD: APPR:BWODMAN 2014/05/09 DESCRIPTION	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>± ---</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> <tr> <td colspan="3">ANGULAR ± ---°</td> </tr> </tbody> </table>		mm	INCH	4 PLACES	± ---	± ---	3 PLACES	± ---	± ---	2 PLACES	± ---	± ---	1 PLACE	± ---	± ---	ANGULAR ± ---°			DIMENSION STYLE <b>IN/MM</b> DRAWN BY: GGUSTAFSON DATE: 2014/03/26 CHECKED BY: _____ DATE: _____	SCALE: <b>2:1</b> DESIGN UNITS: <b>INCH</b> THIRD ANGLE PROJECTION	TITLE: <b>ASSEMBLY INSTRUCTIONS COMMERCIAL MICRO D CONNECTOR</b> APPROVED BY: BWODMAN DATE: 2014/04/04 MATERIAL NO.: <b>SEE CHART</b> DOCUMENT NO.: <b>SD-83421-040</b>	SHEET NO.: <b>2 OF 2</b>
		mm	INCH																					
4 PLACES	± ---	± ---																						
3 PLACES	± ---	± ---																						
2 PLACES	± ---	± ---																						
1 PLACE	± ---	± ---																						
ANGULAR ± ---°																								
DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS SIZE: <b>A3</b> THIS DRAWING CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX INCORPORATED AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION	<b>MOLEX INCORPORATED</b>																							