Custom Cable Assemblies for Medical Applications and more.

National Cable Molding is one of the United States’ premier suppliers of custom molded electrical assemblies for medical applications.

Our capability for very high quality, complex assemblies, short to medium runs and fast prototyping provides a perfect fit for a wide range of products in the electronics industry.

We also offer a highly experienced engineering staff who can assist you in the development of your product.

National Cable Molding
Custom Cable Assemblies
a Division of National Wire and Cable
National Wire and Cable and National Cable Molding Headquarters
Los Angeles California
National Cable Molding specializes in custom cable assemblies with integral-molded connectors. Our products are designed mainly for the medical environment where quality and reliability are critical. Over the last 35 years our cables have proven themselves time and time again under the most adverse conditions.

National Cable Molding shares the same manufacturing facility as the parent corporation, National Wire & Cable. This allows for very tight control over the cable products that we use and eliminates the problems normally associated with buy-out components. Vertical Integration of the manufacturing process is what enables us to deliver superior quality products.

National Cable Molding can build to your exact specifications, or our engineering staff can assist you with designing the right assembly for your application.

Options include molding on an industry standard connector for superior mechanical properties, or integral molding a custom connector to fit your specific application.
What is the Integral Molding Concept?
1. Bulk cable ends are stripped, individual electrical contacts are attached to wires.
2. Cable end with contacts attached is placed inside proprietary mold tooling system.
3. Hot plastic is injected into tool by unique high-speed molding equipment.
4. Finished connector comes out of tool ready to use. Created directly around cable, contacts and shell.
5. A conventional connector is not used or attached to cable. Instead we form the connector body around the cable and pins by unique molding processes.

Why Integral Molding is Better:
1. Professional custom-made appearance.
3. Highly reliable molded construction.
4. Cable assemblies are supplied ready to use.
5. Permits a wide choice of custom connector shapes.
6. Permits a large cost savings due to high-production techniques.

Unique Advantages:

To Purchasing
1. No connectors to buy and stock.
2. No bulk cable to buy and stock.
3. In-house assembly and soldering people not required. Training is unnecessary.
4. Cable assemblies arrive complete - ready to use.
5. Shipments scheduled to meet your needs, minimizing your inventory.
6. You deal direct with the original manufacturer of both cable and connectors.
7. No odd hardware and connector accessories to buy and stock.
8. Very low cost compared to conventional construction.

To Engineering
1. Highly reliable due to embedded construction in connector and wires.
2. No failures due to shorts. Molded insulation is excellent dielectric material.
3. Molded insulation provides a distributed strain-relief to all wires and the cable jackets, minimizing failure due to axial strain on the cable.
4. Consistent low capacitance between circuits.
5. Connector body outer surfaces are resilient, crack-proof, dent-resistant
6. Connector Pins cannot “pull back” or move due to cable tensions.

To Designers
1. Permits unlimited choice of custom connector shapes for special applications.
2. Molding allows certain shapes which cannot be obtained in metal connectors.
3. Permits wide choice of colors for connector and cable.
4. Molding allows use of plastic or metal inserts, clips, threaded nuts and other embedded materials not available in standard connectors.

To Marketing
1. Molded connectors have a custom professional appearance.
2. Molded connectors and cable can be color-matched to the equipment.
3. Molded connectors cannot tarnish. They’re always glossy, neat in appearance.
4. Your company name, trademarks or part number may be a permanent part of your connector surface.
5. Pricing advantages due to low cost of molded cables.

To Production Managers
1. In-house assembly and soldering personnel not required.
2. Inventory of cable & connectors not required.
3. Assembly personnel training not required.
4. Plant floor-space for assembly operation is free for other uses.
5. No investment in high-production cable-terminating equipment.
6. A single source is responsible for delivery of cable, connectors and effort to provide the finished item, permitting a unified control to meet our schedules.

For Quality Control
1. A single source is responsible for connectors, bulk cable, assembly and molding.
2. Separate inspections of connectors, cable, soldering are avoided.
3. Cable assembly arrives as a single unit; ready for acceptance.
4. Inspection labor time is a minimum.
The Overall Picture:

Integrally-molded connectors on cable assemblies are being used in increasingly wider applications by manufacturers whose product uses cord or cable assemblies.

The custom professional appearance, reliability and economy of connectors molded on the cable makes this type of assembly a logical choice over conventional methods.

The fact that a molded connector may be custom-shaped for economy, often permits a better product plus added economy, compared to conventional methods.

Although integrally-molded connectors lend themselves to high-volume production, short runs (100 pieces) are still practical due to our proprietary molding and tooling technology plus our selection of standard adjustable tooling.

We provide complete design and engineering services to assist in specifying molded cable and connectors.

As the manufacturer of all components involved in a molded cable assembly, we are able to exercise unified control of design, engineering and manufacture of all wire, cable, contacts, hardware, molding and tolling to produce truly professionals, quality molded-connector cables economically and promptly.

These quality ready-to-use cable assemblies, made to your specifications, delivered promptly, ease the load on your purchasing, supervision and production.

The Cable

National has a complete wire and cable mill for manufacturing all types of control cable and special-purpose electronic wire. We specialize in custom cable manufacture. These facilities allow us to furnish exactly the cable needed for your particular product, tailored to your own specifications.

Features: Special colors of outer plastic jacket; name or part number permanently embossed in surface of cable jacket; ultra flexible cable constructions; ultra low capacitance cables; special shielding techniques for low noise cable; engineering and design service for your special requirements.

Many standard cable constructions are carried in our warehouse where we stock over 300 different control cable types, in addition to our 100 million foot inventory of electronic hook up wires. These stocks, plus normal 2-shift factory operation, allow rapid supply of cable for molded cable assemblies.

The Connector

National’s proprietary molding and tooling techniques allow us to create the connector directly on the cable by embedding cable, contacts and hardware in hot-injected plastic. Thus a conventional purchased connector is not used with consequent savings.

A connector may be only one pin molded to a leadwire or may have dozens of contacts molded onto large cable with embedded hardware. We mold on a wide selection of connectors using our standard contacts and hardware. Some common types are:

- Male and female plugs on cable
- Male and female contacts on leadwires
- Medical electrodes
- Short plugs
- Molded leg breakouts on cables
- Molded yokes on cables
- Y and Y molded splices
- Test probes and leads

Technical Notes

Connectors with round shells may have several clocking angles and keyway positions, allowing simple polarization of similar plugs. Right-angles cable exit direction may also be controlled by position of keyway. Integrally-molded plastic strain-relief tube may be included on any connector.

Raised markings may be included on connector. Bold Gothic type is normally used. Trademarks may also be molded-in. Permanent indent-marking is available on cable sheath.

Threaded molded-in inserts for screws, external fittings are available, also alligator flat-jaw clamps and chain loops. Consult our engineering department for details of accessories and mounting.

Special-purpose exterior surface shapes are available, such as flats, inset or raised areas, slots, grooves, keys, through or blind holes, finger grips, knurled or patterned areas. Consult our design service for suggestions and innovations.

The Tools

We invite your inquiries on our standard or special connector styles. Our engineering staff will be pleased to discuss your particular requirements.

The tools for high-speed injection molding are precision machines in themselves, having high-accuracy fits on internal and external portions.

By proprietary molding and tool-making techniques on our special machinery, we are able to tool cable-connector designs at greatly reduced cost compared to conventional methods.

These great savings are passed on to the customer in the form of lower unit prices.

A wide variety of standard cable-connector tools are available for producing your assembly with no tooling costs. Often our mold specialists can adjust our non-standard tools for your special needs with only a minor engineering change.

Due to their proprietary nature, tools are generally retained by us when they may be used on other work by adjustments. Where the customer must have privacy of use, there is a nominal engineering change.

How to get the Ball Rolling

1. Specify the type of cable
   a. number of conductors and wire gauge
   b. voltage ratings, shielding

   We carry many standard cables, or will make cable to your exact needs.

2. Specify connector your assembly must mate
   a. number of contacts
   b. shell style or type – manufacturer’s part number desirable

3. Specify quantity, cable length and delivery rate you’ll need

4. Specify colored or special marking you prefer
   a. your name or part number on cable sheath
   b. your name or part number on connectors
   c. cable or connector color
<table>
<thead>
<tr>
<th>FIGURE NO.</th>
<th>MOLD NO.</th>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>1a</td>
<td>T-151</td>
<td>MS CONNECTOR, WITH STRAIN RELIEF</td>
</tr>
<tr>
<td>1</td>
<td>T-188</td>
<td>SAFETY YOKE ASSEMBLY</td>
</tr>
<tr>
<td>2a</td>
<td>T-115</td>
<td>MS CONNECTOR, STANDARD VERSION</td>
</tr>
<tr>
<td>2</td>
<td>T-214</td>
<td>SAFETY CHOKE YOKE ASSEMBLY</td>
</tr>
<tr>
<td>3a</td>
<td>T-102</td>
<td>RIGHT ANGLE MS CONNECTOR - STANDARD</td>
</tr>
<tr>
<td>3a</td>
<td>T-216</td>
<td>RIGHT ANGLE MS CONNECTOR - LOW PROFILE</td>
</tr>
<tr>
<td>3</td>
<td>B-01-090</td>
<td>RIGHT ANGLE MS CONNECTOR - STRAIN RELIEF</td>
</tr>
<tr>
<td>4a</td>
<td>T-180</td>
<td>DIN CONNECTOR, STRAIN RELIEF VERSION</td>
</tr>
<tr>
<td>4</td>
<td>T-148</td>
<td>YOKE BREAKOUT ASSEMBLY, MINIATURE VERSION</td>
</tr>
<tr>
<td>5a</td>
<td>T-109</td>
<td>DIN CONNECTOR, STANDARD VERSION</td>
</tr>
<tr>
<td>5</td>
<td>T-103</td>
<td>STANDARD YOKE BREAKOUT ASSEMBLY</td>
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<tr>
<td>6a</td>
<td>B-01-155</td>
<td>ACCESSORY CONNECTOR</td>
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<td>B-01-155</td>
<td>MINI-DIN CONNECTOR</td>
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<td>6</td>
<td>T-131</td>
<td>RESISTOR YOKE BREAKOUT ASSEMBLY</td>
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<td>7a</td>
<td>B-01-131</td>
<td>H.P. INSTRUMENT CONNECTOR</td>
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<tr>
<td>7</td>
<td>T-136</td>
<td>YOKE BREAKOUT ASSEMBLY, STRAIN RELIEF VERSION</td>
</tr>
</tbody>
</table>

**PHONE PLUGS**

| 8a         | T-108    | .250” DIA. TWO CONNECTOR PHONE PLUG (Style A) |
| 8a         | T-108    | .250” DIA. THREE CONNECTOR PHONE PLUG (Style B) |
| 8a         | T-108    | .250” DIA. FOUR CONNECTOR PHONE PLUG (Style C) |
| 8a         | T-108    | .173” DIA. THREE CONNECTOR PHONE PLUG (Style D) |
| 8a         | T-108    | TWO CONDUCTOR POWER JACK (Style E) |

**YOKE BREAKOUT LEAD TERMINATIONS**

| 8          | T-144    | STANDARD MEDICAL-GRADE SNAP |
| 8          | T-133    | PINCH CLIP |
| 8          | T-140    | .125” PIN PLUG |
| 8          | T-116B   | BANANA PLUG |

**ADDITIONAL PHONE PLUG CONNECTORS**

| 9          | T-116B   | TWO COND. 2.5 mm or 3.5 mm PHONE PLUG (Style A) |
| 9          | T-116B   | THREE COND. 2.5mm or 3.5mm PHONE PLUG (Style B) |
| 9          | B-01-006 | .250 TWO OR THREE COND. 90DEG PHONE PLUG (Style C) |
| 9          | B-01-026 | TWO COND. 2.5mm or 3.5mm PHONE PLUG (Style D) |
| 9          | B-01-026 | THREE COND. 2.5mm or 3.5mm PHONE PLUG (Style D) |
| 9          | B-01-205 | .281 FIVE COND. PHONE PLUG (Style F) |
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<th>MOLD NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
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<tr>
<td>10</td>
<td>T-188</td>
<td>HARNESS ASSEMBLY</td>
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## SUBMINIATURE CONNECTORS

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<tr>
<td>11</td>
<td>T-236-1</td>
<td>9 POS MALE/ FEMALE W/PAN HEAD SCREWS</td>
</tr>
<tr>
<td>11</td>
<td>T-236</td>
<td>9 POS MALE/ FEMALE W/THUMBSCREWS</td>
</tr>
<tr>
<td>11</td>
<td>T-238</td>
<td>25 POS MALE/ FEMALE with Pan Head Screws or Thumbscrews</td>
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## CABLE AND LEAD RETAINERS

<table>
<thead>
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<th>FIGURE NO.</th>
<th>MOLD NO.</th>
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## MOLDED LEADWIRE ASSEMBLIES

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<th>MOLD NO.</th>
<th>DESCRIPTION</th>
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<td>13</td>
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<td>SAFETY LEADWIRE ASSEMBLY FOR T-188 AND T214 SAFETY YOKES WITH STRAIN RELIEF SNAP</td>
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<tr>
<td>14</td>
<td></td>
<td>SAFETY LEADWIRE ASSEMBLY FOR T-188 AND T-214 SAFETY YOKES</td>
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## ADDITIONAL LEADWIRE TERMINATIONS

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<th>FIGURE NO.</th>
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<th>DESCRIPTION</th>
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<tr>
<td>15a</td>
<td>T-140</td>
<td>2.5mm PHONE PLUG</td>
</tr>
<tr>
<td>15a</td>
<td>T-179-B3</td>
<td>2.5mm or 3.5mm PHONE PLUG</td>
</tr>
<tr>
<td>15a</td>
<td>T-100</td>
<td>.125 PIN CONNECTOR</td>
</tr>
<tr>
<td>15a</td>
<td>T-179-B3</td>
<td>STANDARD BANANA PLUG</td>
</tr>
<tr>
<td>15a</td>
<td>T-184</td>
<td>STANDARD BANANA PLUG</td>
</tr>
<tr>
<td>15a</td>
<td>T-176</td>
<td>STANDARD BANANA PLUG</td>
</tr>
<tr>
<td>15a</td>
<td>T-116B</td>
<td>STANDARD BANANA PLUG</td>
</tr>
<tr>
<td>15</td>
<td>T-162</td>
<td>1/4” MALE SNAP WITH 1/4 WATT RESISTOR</td>
</tr>
<tr>
<td>15</td>
<td>T-164-F</td>
<td>STD. MEDICAL SNAP WITH 1/4 WATT RESISTOR</td>
</tr>
<tr>
<td>15</td>
<td>T-129</td>
<td>STANDARD MALE SNAP</td>
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<tr>
<td>15</td>
<td>T-164-M</td>
<td>STANDARD MALE SNAP WITH 1/4 WATT RESISTOR</td>
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<tr>
<td>15</td>
<td>CB-02-008</td>
<td>ALLIGATOR CLIP</td>
</tr>
<tr>
<td>15</td>
<td>T-169</td>
<td>1.5mm SAFETY SOCKET</td>
</tr>
<tr>
<td>15</td>
<td>T-138</td>
<td>3mm or 4mm BANANA JACKET</td>
</tr>
</tbody>
</table>
Military Style Connector
Strain Relief Version
(with molded-in resistor capability)
Mold No. T-151

Strain Relief Yoke Assembly
Available in 3, 4 and 5 position
(5 position shown)
Mold No. T-188

ORDER DESK 323-225-5611
www.nationalwire.com

ORDER DESK 323-225-5611
www.nationalwire.com
Military Style Connector
Standard Version
Mold No. T-115

Safety Choke Yoke Assembly
Available in 3, 4 and 5 position
(5 position shown)
Mold No. T-214

1. Assembly may be ETO gas sterilized.
2. Yoke capable of molded -in 1 Watt resistors and
   RF chokes in each position.
3. Optional colors for cable and yoke assembly are:
   Medium gray, light gray and black.
   (Color matching available).
4. Mates with leadwire assemblies as shown
   on sheets 14 and 15.
5. Bedsheet clip cable strap available (see sheet 13).
Right Angle Military Style Connector
Standard Version
Mold No. T-102

Strain Relief Version
Mold No. B-01-090

Low Profile Version
(with molded-in resistor capability)
Mold No. T-215

FIGURE 3a
Order Desk 323-225-5611
www.nationalwire.com
**DIN Connector**
Strain Relief Version

**Mold No. T-180**

**Miniature Yoke Breakout Assembly**
Available in 3, 4 and 5 position
(3 Lead with Pinch Clip shown)

**Mold No. T-148**

1. Assembly may be ETO gas sterilized.
2. Optional colors for cable and yoke assembly are:
   Medium gray, light gray and black.
   (Color matching available).
3. See sheet 8 for additional yoke breakout lead terminations.
DIN Connector
Standard Version
Mold No. T-109

Standard Yoke Breakout Assembly
Available in 3, 4 and 5 position
(5 lead version with 125 pin shown)
Mold No. T-103

1. Assembly may be ETO gas sterilized.
2. Optional colors for cable breakout assembly and leads are: medium gray, light gray and black. (Color matching available). Colored leads available.
3. See sheet 8 for additional yoke breakout lead terminations.
4. Lead retainer with bedsheet clip available (see sheet 13).
**Mini DIN Connector**
Available in 3 through 14 position-male
*Mold No. B-01-155*

**Resistor Yoke Breakout Assembly**
Available in 3, 4 and 5 lead
*(5 lead version with banana plug shown)*
*Mold No. T-131*

---

**CUSTOMER SPECIFIED CONNECTOR CAN BE INSTALLED ON REQUEST**

---

1. Assembly may be ETO gas sterilized.
2. Yoke capable of molded-in series resistors (1 Watt or smaller for each position).
3. Optional colors for cable and breakout assembly are: Medium gray, light gray and black.
   (Color matching available). Colored leads available.
4. See sheet 8 for additional yoke breakout leads terminations.
Instrument Connector
(Compatible with HP monitors)
Mold No. B-01-131

Strain Relief Yoke Breakout Assembly
Available in 3 and 5 position
(3 position shown with female snap)
Mold No. T-136

1. Breakout assembly is fully shielded.
2. Assembly may be ETO gas sterilized.
3. Optional colors for cable and breakout assembly are:
   Medium gray, light gray and black.
   (Color matching available). Colored leads available.
4. See sheet B for additional yoke breakout lead terminations.
Phone Plugs
Mold No. T-108

FIGURE 8a
Order Desk 323-225-5611
www.nationalwire.com

Yoke Breakout Lead Terminations

FIGURE 8
Order Desk 323-225-5611
www.nationalwire.com
Additional Phone Plug Connectors

**MOLD NO. T-116B**
- Style A
- Ø.46
- 1.95
- Ø.15
- 2.5 mm OR 3.5 mm
- 2 CONDUCTOR

**MOLD NO. B-01-006**
- Style C
- .64
- .65
- .42
- Ø.19
- 2 OR 3 CONDUCTOR
- RIGHT ANGLE

**MOLD NO. B-01-026**
- Style D
- Ø.49
- .95
- Ø.19
- 2.5 mm OR 3.5 mm
- 2 CONDUCTOR

**MOLD NO. B-01-205**
- Style E
- Ø.28
- 2.00
- Ø.63
- 2.5 mm OR 3.5 mm
- 3 CONDUCTOR

Order Desk 323-225-5611
www.nationalwire.com
Harness Assemblies
Subminiature D Connectors

25 POSITION

9 POSITION

Order Desk 323-225-5611
www.nationalwire.com

FIGURE 11
Cable and Lead Retainers

**RETAINER LEAD ASSEMBLY**
APPLICABLE TO T-103, 3 OR 5 LEAD YOKE ASSEMBLIES

**BEDSHEET CLIP WITH STRAP**
APPLICABLE TO T-103, T-131, T-136

Order Desk 323-225-5611
www.nationalwire.com
1. Molded assembly may be ETO gas sterilized.
2. Molded parts to be same color (Table 1.)
3. Lead wire assy. mates with T-188 and T-214 safety yokes.
4. Optional lead wire colors are: Blk, Wht, Red, Brn, Grn, Lt Gry
   And medium gray (color matching available).
5. Insulated wire is 22 AWG consisting of 41 strands of 38 AWG tinned copper for high flexibility.

---

**TABLE 1**

<table>
<thead>
<tr>
<th>DASH NO.</th>
<th>COLOR</th>
</tr>
</thead>
<tbody>
<tr>
<td>-1</td>
<td>BLACK</td>
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<tr>
<td>-2</td>
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<td>RED</td>
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<td>-4</td>
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<td>-5</td>
<td>GREEN</td>
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**TABLE 2**

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<td>-24</td>
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</tr>
<tr>
<td>-36</td>
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</table>

1.5mm interface complies with applicable ANSI/AAMI EC-53 Standard and FDA 21 CFR Part 896.
Molded Leadwire Assemblies

1. Molded assembly may be ETO gas sterilized.
2. Molded parts to be same color (Table 1).
3. Lead wire assy. mates with T-188 and T-214 safety yokes.
4. Optional lead wire colors are: Blk, Wht, Red, Brn, Grn, Lt. Gry
   And medium gray (color matching available).
5. Insulated wire is 22 AWG consisting of 41 strands
   of 38 AWG tinned copper for high flexibility.

**TABLE 1**

<table>
<thead>
<tr>
<th>DASH NO.</th>
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<tbody>
<tr>
<td>-1</td>
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</tr>
<tr>
<td>-36</td>
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</table>

Order Desk 323-225-5611
www.nationalwire.com
Additional Molded Leadwire Terminations

MOLD NO. T-140
2.5mm PHONE PLUG
INTEGRAL 1/8 WATT RESISTOR CAPABILITY
MOLDED-IN LIMIT MARKINGS ARE AVAILABLE ON REQUEST

MOLD NO. T-179-B3
STANDARD BANANA PLUG

MOLD NO. T-184
STANDARD BANANA PLUG

MOLD NO. T-179-B3
2.5mm OR 3.5mm PHONE PLUG
INTEGRAL 1/8 WATT RESISTOR CAPABILITY
MOLDED-IN LIMIT MARKINGS ARE AVAILABLE ON REQUEST

MOLD NO. T-176
STANDARD BANANA PLUG

MOLD NO. T-100
.125 DIAMETER MALE PIN
MOLDED-IN LIMIT MARKINGS ARE AVAILABLE ON REQUEST

MOLD NO. T-116B
STANDARD BANANA PLUG

FIGURE 15  Order Desk 323-225-5611
www.nationalwire.com

FIGURE 15a