

**SL FLAT FLEX CABLE  
TERMINATOR KIT FOR TM42 PRESS  
Instruction Manual  
Order No. 62201-8700  
For 70430 and 70431 Series Connectors**

- Description
- Operation
- Maintenance

## WARNING

- NEVER** USE THIS MACHINE WITHOUT THE GUARDS OR SAFETY DEVICES THAT ARE INTENDED TO PREVENT HANDS FROM REMAINING IN THE NEST AREA. RUNNING THIS MACHINE WITHOUT GUARDS, UNDER ANY CIRCUMSTANCES, CAN CAUSE SERIOUS INJURY.
- NEVER** LIFT THIS PRESS WITHOUT THE AID OF MECHANICAL LIFTING DEVICES. SEVERE BACK OR OTHER INJURIES CAN RESULT.
- NEVER** OPERATE, SERVICE, OR ADJUST THIS MACHINE OR INSTALL APPLICATOR DIES WITHOUT PROPER INSTRUCTION AND WITHOUT FIRST READING AND UNDERSTANDING THE INSTRUCTIONS IN THIS MANUAL.
- NEVER** SERVICE THIS MACHINE WHILE IT IS CONNECTED TO ANY ELECTRICAL POWER SOURCE. DISCONNECT POWER BY UNPLUGGING THE PRESS FROM ITS POWER SOURCE.
- CAUTION** MOLEX CRIMP SPECIFICATIONS ARE VALID ONLY WHEN USED WITH MOLEX TERMINALS AND TOOLING.

**WORK SAFELY AT ALL TIMES**

**For Service, Contact Your  
Local Molex Sales Office**

**Molex Application Tooling Group**  
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Lisle, Illinois 60532  
Tel: 630-969-4550  
Fax: 630-505-0049

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- 1 General Description
- 2 Installation
- 3 Maintenance and Troubleshooting
- 4 Parts List, Assembly Drawings
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## Section 1

### General Description

- 1.1. Description
- 1.2. Features
- 1.3. Technical Specifications
- 1.4. Delivery Check
- 1.5. Tools

## General Description

Unpacked weight 9.07kg (20 Lbs)

### 1.1 Description

The 62201-8700 SL Flat Flex Cable Terminator Kit is designed to be installed in the TM42 Press Order No. 69002- 5001. It is designed to terminate the Flat Flex Cable Connector 70430 or 70431 series to Flat Flex Cable. The tooling will accommodate from 2 to 20 circuits. The operator loads a connector into the nest, sets the cable stop, positions, and clamps the cable. The nest is slid into the termination area and the press is activated. When termination is complete the operator slides the nest out and removes the harness. It is then loaded into the insertion station where the terminals are manually inserted and the carrier strip is broken off. This terminator is ideally suited for medium volume production.

### Electrical

110/220V AC, 5.8/2.9A, 60 Hz, Single Phase.

### Production Rate

240 terminations per hour maximum, depending on operator skill.

### 1.4 Delivery Check

When carefully remove the TM42 Assembly from its shipping container and check to determine if the following items are included in this package.

<u>Description:</u>	<u>Quantity</u>
SL FFC Terminator	62201-8700 1
TM42 Press Manual	ATS-690025099 1
Terminator Kit Manual	ATS-622018700 1

### 1.2 Features

- Terminator Kit is quickly installed into the Molex TM42 Press 69002-5001.
- Bench Mounted operated.
- All electrical, no shop air required.
- Simple modification of press allows this terminator kit to be easily interchanged with other TM42 terminator kits.

### 1.3 Technical Specifications

Dimensions	Press with tooling
Height	50.8mm (2.0")
Width	152.4mm (6.0")
Depth	254.0mm (10.0")

### 1.5 Tools

The following tools are recommended for setup and adjustments to the this tool.

- ✓ Metric hex wrench set
- ✓ Small standard screwdriver
- ✓ Adjustable wrench
- ✓ Needle nose pliers
- ✓ Crimp micrometer
- ✓ Eye loupe (10x)
- ✓ Wire stripper/cutter
- ✓ English hex wrench set for some non-metric tools.

## Section 2

### Installation

- 2.1. Installation
- 2.2. Set-Up
- 2.3. Operation

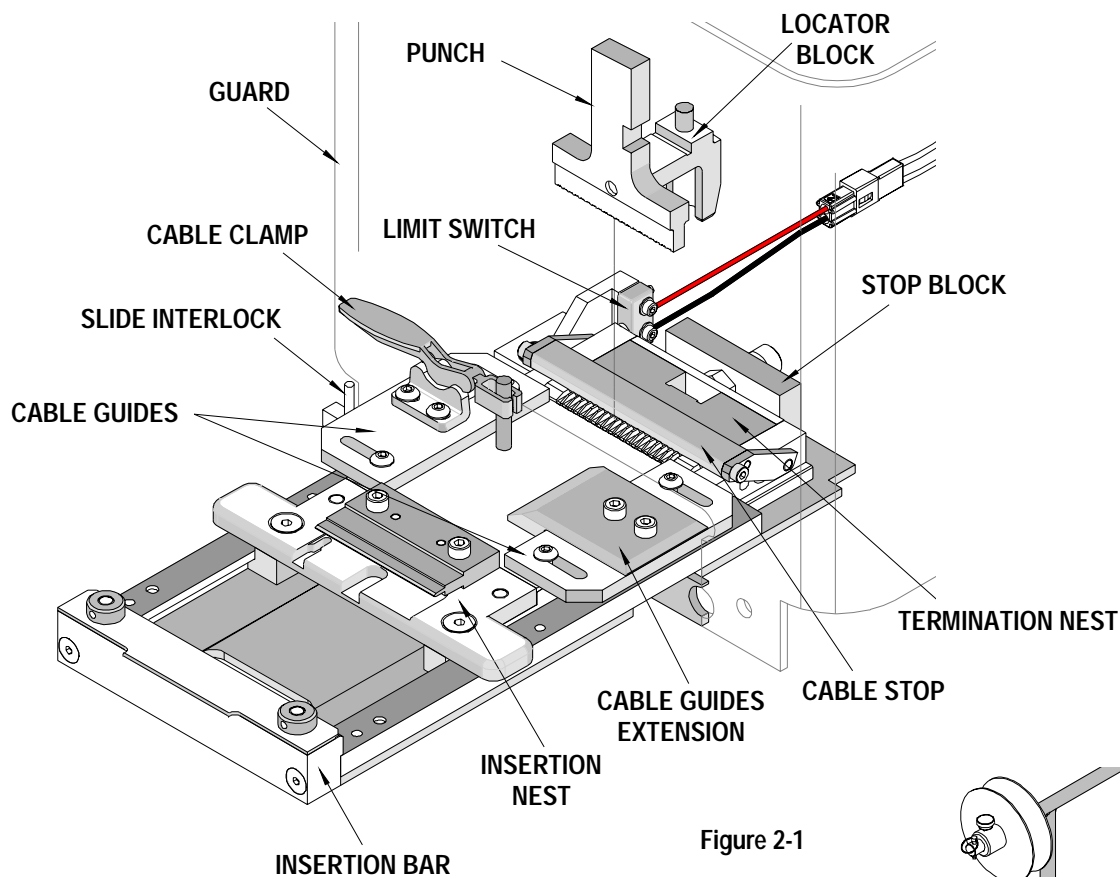


Figure 2-1

## 2.1 Installation

1. To install the Terminator Kit 62201-8700 into the TM42 Press 69002-5001 it will be necessary to remove the following parts:

- Locating Plate 11-40-0218
  - Bolster Plate Shim 63800-4205
  - Feed Finger 69001-0105
  - Feed Finger 69001-0106
  - And all Feed Arm assembly parts
  - Guard Block 69002-5507
  - Die Guard 69002-5533
  - Hand Rest 69002-5547
  - Reel Support assembly parts
- See Figure 2-2.

2. Install the locator block 62200-6017 into the TM42 ram on press.
3. Install the termination punch 62201-8715 into the locator block on the ram. See Figure 2-3.

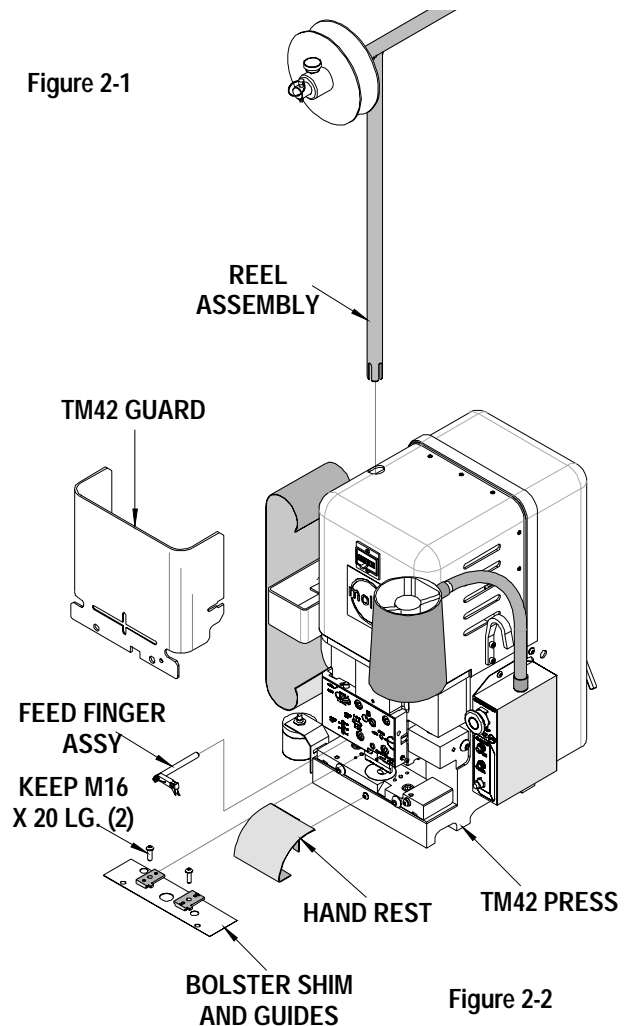


Figure 2-2

4. Next place the terminator assembly unit with the micro switch assembly towards the back of the press onto the bolster plate. The terminator assembly should be located over the two dowel pins in which the guide blocks were removed. Use the two M16 x 20 BHCS from the guide plates to secure the assembly but do not tighten.

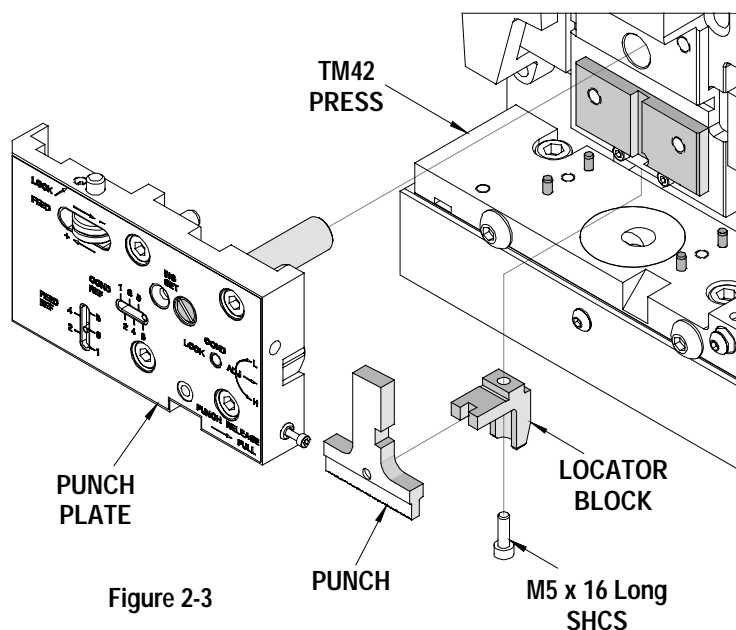


Figure 2-3

### To Install Cable Assembly to TM42 Press

The first time the terminator kit is installed into the TM42 Press, the Cable Assembly 62200-7721 attached to the limit switch will need to be connected to the inside of the press. Follow the steps below.

1. Remove the back cover from the press.
2. Bring the end of the cable assembly with the male and female quick disconnect terminals up to the solenoid. See Figure 2-4.
3. Carefully remove one of the female quick disconnect terminals from the solenoid and push it on to the male quick disconnect terminals from the limit switch cable.
4. Push the female quick disconnect terminal from the limit switch cable onto the vacated solenoid terminal.
5. Secure the cable down into the area of the limit switch and replace the rear cover.
6. Plug the limit switch of the cable assembly into the connector hanging outside the press cover.
7. Slide nest into the press.

8. Manually lower the press's ram to align the upper and lower tooling.
9. Tighten the two M16 x 20 BHCS in the nest assembly.
10. Check the termination height and micro switch adjustment. See Section 2.2, Setup.
11. Make sure all the tooling is aligned.
12. Replace rear cover and install the 62201-4219 guard of the 62201-8700 Terminator Kit assembly.

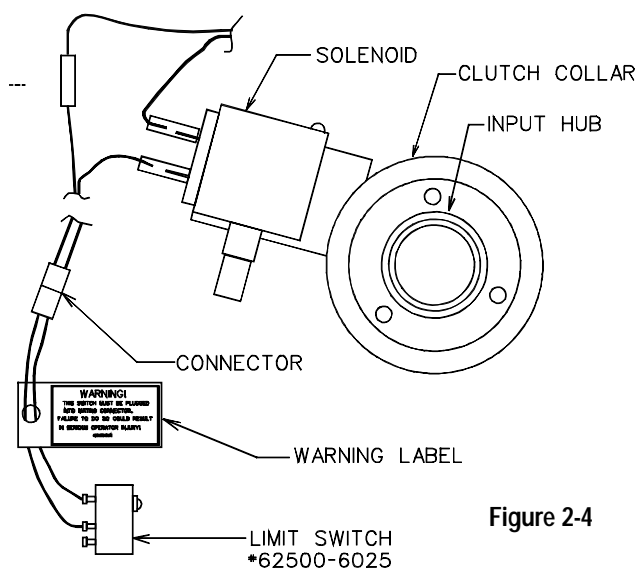


Figure 2-4

**WARNING:** The TM42 Press weighs over 100kg (200lbs); it should not attempt to be lifted by one individual. Mechanical lifting devices should be used. A person lifting the press can sustain severe back or other injuries.

## 2.2 Set Up

### Termination Height

See also Section 3.9 Conductor Crimp Punch (Crimp Height) Adjustment in the TM42 Instruction Manual.

1. To adjust the termination height, load a connector into the nest with the terminals in the guides.
2. Position and clamp a cable in the nest.
3. Move the nest under the press and terminate the cable and connector. See Section 2.3 Operation for additional instructions on terminating.
4. Check the quality of the termination and measure the height in accordance with sheet 5 of drawing



PS-70430 of Product Specification. (.038" ± .002" Ref)

**CAUTION:** Always disconnect power supply before installing or removing tooling.

5. Always power down the press by pressing the emergency stop button located on the front of the control panel. Remove the press guard by unscrewing the four M10 button head screws. Two are located on the front bolster plate and one is located on each side.
6. Loosen the M6 conductor adjustment lock screw located on the front of the punch plate. See Figure 2-5.

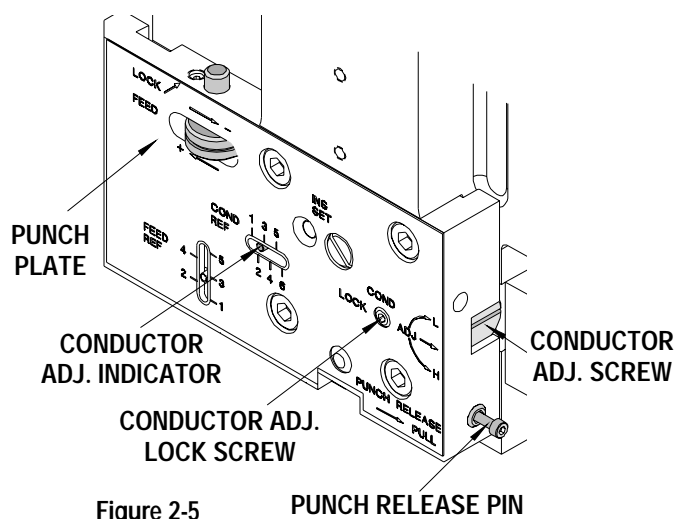


Figure 2-5 PUNCH RELEASE PIN

7. With a screwdriver, turn the conductor adjusting screw, located on the right side of the punch plate. Rotating the adjusting screw clockwise one full turn will lower the crimp height approximately 0.03mm (.001"). Each increment on the Conductor Adjustment Indicator represents approximately 0.13mm (.005") for a total of 0.65mm (.026"). The "1" setting indicates the highest crimp height and the "6" setting is the tightest.
8. Tighten the conductor adjusting locking screw.
9. Reinstall the machine guard and repeat the above steps until the desired crimp height is obtained.

### Nest-in-Position Indicator Switch Adjustment

**CAUTION:** Always disconnect power supply before installing or removing tooling.

There is a miniature limit switch 62500-0518 in the Cable Assembly-62200-7721 on the back of the lower tooling. This switch signals the nest in position for termination. See Figure 2-6. If this switch should work loose or has to be replaced, it may be necessary to adjust its position. To do this, follow these instructions:

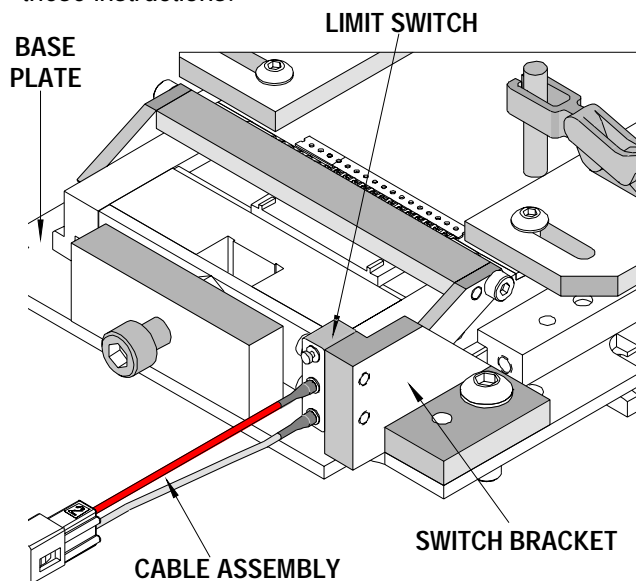


Figure 2-6

1. Unplug the power cord.
2. Remove the back cover from the TM42 press.
3. Push the slide assembly into the press.
4. Manually lower the TM42 ram using the wrench supplied with the press. See TM42 press manual for additional instructions. Lower the ram until the locator in the ram mates with the slide assembly in the lower tooling.
5. Adjust switch toward the slide assembly until the switch is fully actuated but not totally bottomed out.
6. Replace back cover on press.
7. Plug cord into power source.

### 2.3 Operation

**CAUTION:** Molex recommends that the operator and observers wear eye protection when the press is in operation or being serviced.

**CAUTION:** *DO NOT* use the TM42 press without guards.

1. Lift the cable stop and load a (70430 and/or 70431 series) connectors into the nest making

sure the terminals are lined up in the terminal guides. See Figure.2-7.

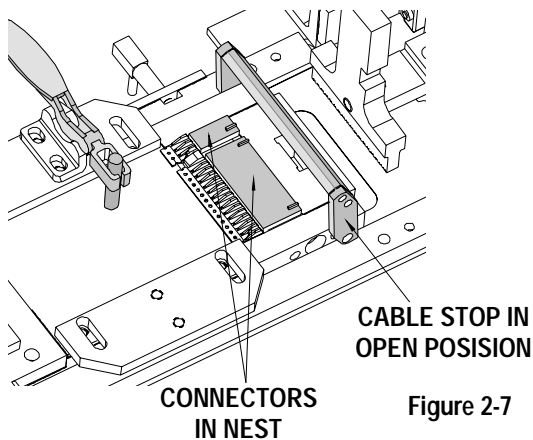


Figure 2-7

2. Lower the cable stop onto the connector(s).
3. Place a cable between the guides and adjust the guides, if necessary, to center the cable over the connector but not so tight as to restrict cable handling. Then slide the cable up to the cable stop.

**Note:** It is important to press the front edge of the cable against the cable stop. This will achieve the proper location for the cable being pressed onto the connector.

4. Close the cable clamp located on the left side of the slide.
5. Slide the nest into the press until the interlock clicks in. The nest position switch will not let the press fire unless the nest is in the proper position.

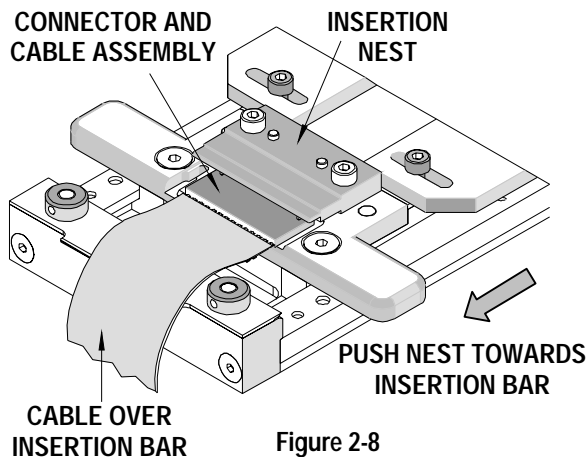


Figure 2-8

6. Push the foot pedal to trigger the press and terminate the connector(s) onto the cable.

7. On the left side of the slide is the slide interlock. Pull this out and hold while sliding the nest out of the press.
8. Remove the connector and cable assembly from the termination nest and load it into the insertion nest on the front of the slide with the cable draped over the insertion bar. See Figure 2-8.
9. Place the second and third fingers of each hand around the handles on the insertion nest. Put the thumbs on the front of the insertion bar. While applying a light pressure with the index fingers on the cable over the carrier strip, squeeze the insertion nest toward the insertion bar. The carrier strip should drop into the slot in the insertion bar.

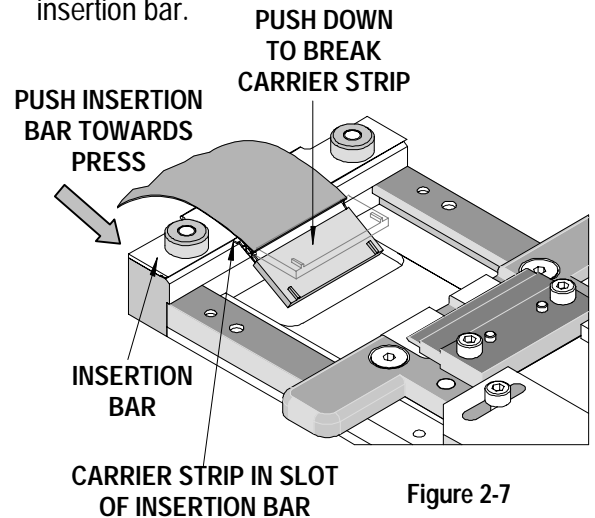


Figure 2-7

10. Continue to squeeze the insertion nest toward the insertion bar until the terminals are fully seated in the housing.
11. While holding the cable and connector back against the insertion bar, slide the nest and slide assembly away.
12. Push down on the connector to break the carrier strip off. The cable will spring the connector back up. See Figure 2-9.
13. Remove the completed harness.
14. Remove the carriers from the insertion bar by pushing the upper insertion bar forward. This will expel the carrier strip from the tool.

## Section 3

### Maintenance

- 3.1. Cleaning
- 3.2. Lubrication
- 3.3. Perishable Parts
- 3.4. Spare Parts
- 3.5. Troubleshooting

### 3.1 Cleaning

For efficient operation, the SL Flat Flex Cable Terminator should be cleaned daily. Use a soft bristle brush to remove debris from critical areas such as the crimp tooling. For best results, remove the crimp forms from the press. Brush and then use a clean cloth to wipe off the upper and lower tooling mounting areas. Before reinstalling tooling, wipe all sides of the forms with a clean cloth.

**CAUTION:** Using compressed air to clean the Terminator is not recommended as debris could become jammed in the tooling and/or fly out at the operator.

See Chart 3.1 for recommended Preventive Maintenance Schedule.

### 3.2. Lubrication

The SL Flat Flex Termination Kit does not need lubrication. However, the press does need regular lubrication on a monthly basis. Please consult the TM42 Press Instruction Manual (Order No. 69002-5099) for proper procedures.

An example of a maintenance chart is shown below. Copy and use this chart to track the maintenance of your Press or use this as a template to create you own schedule or use your company’s standard chart, if applicable.

#### Preventive Maintenance Chart

**Daily:** Clean. See Section 3.1.

**As Required:** Lubricate. See Section 3.2.

CHECK SHEET    MONTH \_\_\_\_\_ YEAR \_\_\_\_\_

Week	Daily Clean	Days of the Week							Solution
		MON	TUE	WED	THU	FRI	SAT	SUN	
1									
2									
3									
4									
Cleaning	Yes								Soft Brush
Inspect all tooling for wear	Yes								Replace if signs of wear.

Schedule should be adjusted up or down depending on usage. Molex recommends that a log of preventive maintenance be kept with the press.

### 3.3. Perishable Parts

Customers are responsible for maintaining the SL Flat Flex Cable Terminator Kit. Perishable parts are those parts that come in contact with the product and will wear out over time. Molex recommends that all customers keep at least one set of the perishable tool kit in stock at all times. This will reduce the amount of production down time.

### 3.4. Spare Parts

Customers are responsible for maintaining the SL Flat Flex Cable Terminator Kit. Spare parts are available. Moving and functioning parts can be damaged or wear out over time and will require replacement. Molex recommends that the customer keep some or all of them in stock to reduce production down time. These parts are identified in the Parts List. See Section 4.

### 3.5. Troubleshooting

Symptom	▪ Cause	Solution
When foot pedal is pressed, counter counts but press does not fire.	▪ Limit switch is out of position	Adjust limit switch position. See Section 2.2
	▪ Nest is not all the way in	Make sure the nest is completely under The termination upper tooling and latch has "clicked" in.
	▪ Limit switch is damaged or not connected properly	Test Switch with continuity tester. Replace, if necessary. If switch is functional, check and repair the switch wiring. See Section 2.2.
Termination height is not right.	▪ Termination punch height not set correctly	Readjust the crimp height. See Section 2.2
Terminals will not Insert into housing after crimping.	▪ Cable crimped too far forward on terminals	Cable must be located against the front edge of the cable stop for proper location.

## Section 4

- 4.1 Parts List
- 4.2 Assembly Drawings

## 4.1 Parts List

SL Flat Flex Cable Terminator Kit 62202-0800				
Item	Order No.	Engineering No.	Description	Quantity
<b>Perishable Tooling</b>				
1	62201-4218	62201-4218	Carrier Bar	1
2	62201-8705	62201-8705	Anvil	1
3	62201-8709	62201-8709	Terminal Locator	1
4	62201-8715	62201-8715	Punch	1
<b>Other Components</b>				
5	62200-6002	62200-6002	Left Gib	1
6	62200-6003	62200-6003	Gib	1
7	62200-6007	62200-6007	Slide Bar	1
8	62200-6008	62200-6008	Left Slide Bar	1
9	62200-6017	62200-6017	Locator Block	1
10	62200-6021	62200-6021	Spacer	1
11	62200-6022	62200-6022	Spring RSP	1
12	62200-6026	62200-6026	Cable Stop Arm	2
13	62200-6027	62200-6027	Plunger Mount	1
14	62200-6028	62200-6028	Spring Support	1
15	62200-7721	62200-7721	Cable Assembly With Limit Switch	1
16	62200-7729	62200-7729	Stop Block	1
17	62201-4201	62201-4201	Base Plate	1
18	62201-4206	62201-4206	Nest Locator Bar	1
19	62201-4210	62201-4210	Terminal Locator Pin	1
20	62201-4211	62201-4211	Plate	1
21	62201-4214	62201-4214	Back Bar	1
22	62201-4219	62201-4219	Guard	1
23	62201-4220	62201-4220	Guard Spacer	1
24	62201-4224	62201-4224	Switch Bracket	1
25	62201-8704	62201-8704	Connector Nest	1
26	62201-8712	62201-8712	Insert Nest	
27	62201-8713	62201-8713	Insert Nest Cover	1
28	62201-8716	62201-8716	Cable Guide	2
29	62201-8725	62201-8725	Cable Stop	1
30	62201-8730	62201-8730	Cable Guide Extension	1
31	63600-0575	63600-0575	5mm I.D. Collar Set Screw	2
32	63600-0576	63600-0576	Toggle Clamp	1
33	63600-0621	63600-0621	Plunger	1
<b>Hardware</b>				
34	N/A	N/A	M2.5 by 10 Long SHCS	2**
35	N/A	N/A	M2.5 Flat Washer	2**
36	N/A	N/A	M3 by 8 Long SHCS	2**
37	N/A	N/A	M4 by 6 Long BHCS	2**
38	N/A	N/A	M4 by 8 Long FHCS	8**
39	N/A	N/A	M4 by 8 Long SHCS	2**

SL Flat Flex Cable Terminator Kit 62202-0800				
40	N/A	N/A	M4 by 10 Long BHCS	2**
41	N/A	N/A	M4 by 10 Long SHCS	4**
42	N/A	N/A	M4 by 12 Long BHCS	4**
43	N/A	N/A	M4 by 12 Long SHCS	6**
44	N/A	N/A	M4 by 20 Long FHCS	2**
45	N/A	N/A	M5 by 10 Long FHCS	2**
46	N/A	N/A	M5 by 16 Long SHCS	1**
47	N/A	N/A	M6 by 10 Long SHCS	1**
48	N/A	N/A	M6 by 20 Long BHCS	1**
49	N/A	N/A	M6 by 20 Long SHCS	1**
50	N/A	N/A	M6 by 10 Hex Nut	2**
51	N/A	N/A	3mm by 8 Long Dowel Pin	4**
52	N/A	N/A	4mm by 10 Long Dowel Pin	4**
53	N/A	N/A	4mm by 16 Long Dowel Pin	2**
54	N/A	N/A	4mm by 20 Long Dowel Pin	2**
55	N/A	N/A	5mm by 12 Long Dowel Pin	4**
** Available from an industrial supply company such as MSC (1-800-645-7270).				



### 4.2 Assembly

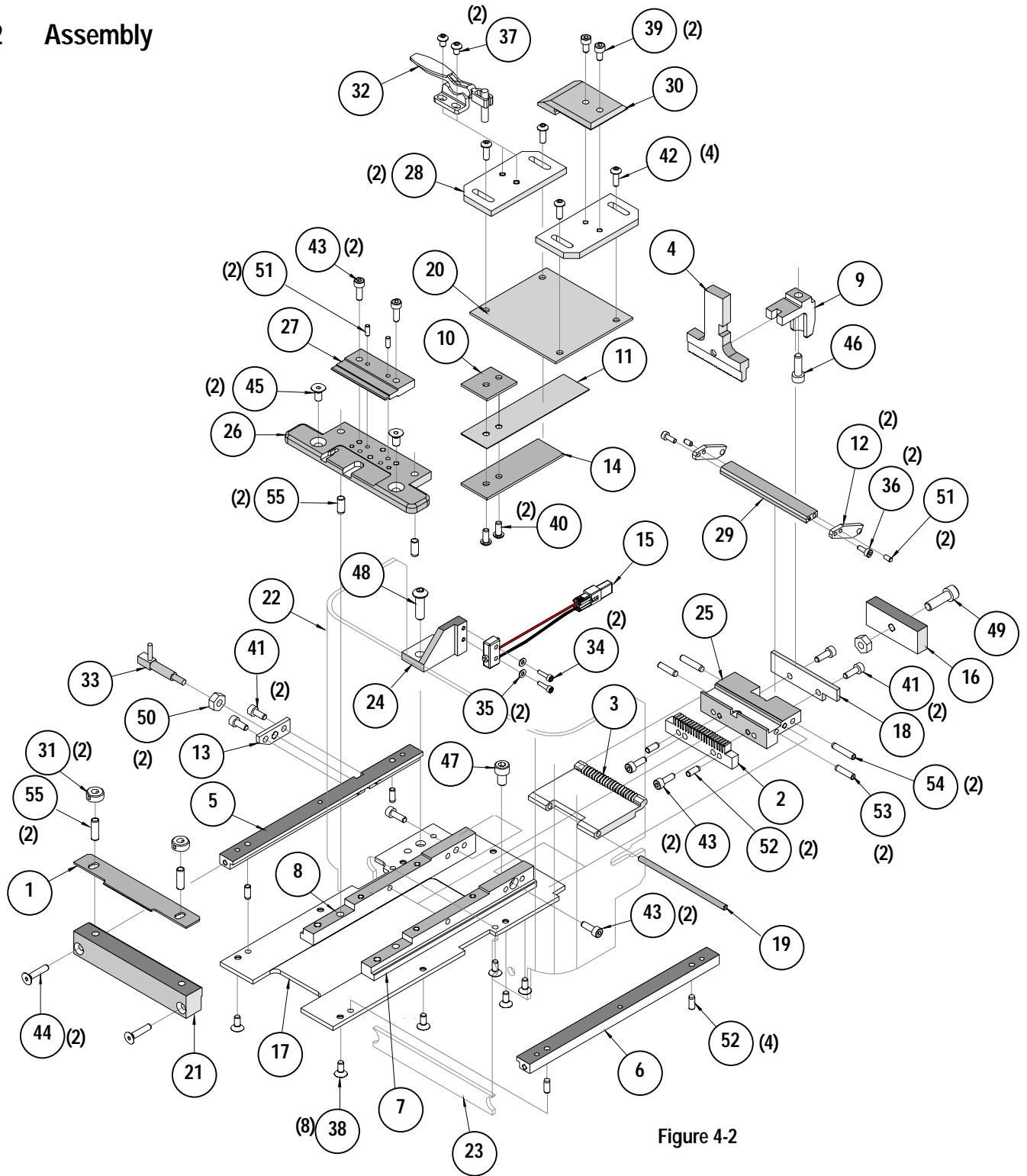


Figure 4-2

## Section 5

### 5.1 Connector Series Chart

### 5.1 Connector Series Chart

Terminal Series No.	Terminal Order No.							
70430	15-38-8020	15-38-8027	15-38-8028	15-38-8029	15-38-8030	15-38-8037	15-38-8038	15-38-8039
	15-38-8040	15-38-8047	15-38-8048	15-38-8049	15-38-8050	15-38-8057	15-38-8058	15-38-8059
	15-38-8060	15-38-8067	15-38-8068	15-38-8069	15-38-8070	15-38-8077	15-38-8078	15-38-8079
	15-38-8080	15-38-8087	15-38-8088	15-38-8089	15-38-8090	15-38-8097	15-38-8098	15-38-8099
	15-38-8100	15-38-8107	15-38-8108	15-38-8109	15-38-8110	15-38-8117	15-38-8118	15-38-8119
	15-38-8120	15-38-8127	15-38-8128	15-38-8129	15-38-8130	15-38-8137	15-38-8138	15-38-8139
	15-38-8140	15-38-8147	15-38-8148	15-38-8149	15-38-8150	15-38-8157	15-38-8158	15-38-8159
	15-38-8160	15-38-8167	15-38-8168	15-38-8169	15-38-8170	15-38-8177	15-38-8178	15-38-8179
	15-38-8180	15-38-8187	15-38-8188	15-38-8189	15-38-8190	15-38-8197	15-38-8198	15-38-8199
	15-38-8200	15-38-8207	15-38-8208	15-38-8209				
	15-47-4020	15-47-4021	15-47-4022	15-47-4023	15-47-4024	15-47-4025	15-47-4026	15-47-4027
	15-47-4030	15-47-4031	15-47-4032	15-47-4033	15-47-4034	15-47-4035	15-47-4036	15-47-4037
	15-47-4040	15-47-4041	15-47-4042	15-47-4043	15-47-4044	15-47-4045	15-47-4046	15-47-4047
	15-47-4050	15-47-4051	15-47-4052	15-47-4053	15-47-4054	15-47-4055	15-47-4056	15-47-4057
	15-47-4060	15-47-4061	15-47-4062	15-47-4063	15-47-4064	15-47-4065	15-47-4066	15-47-4067
	15-47-4070	15-47-4071	15-47-4072	15-47-4073	15-47-4074	15-47-4075	15-47-4076	15-47-4077
	15-47-4080	15-47-4081	15-47-4082	15-47-4083	15-47-4084	15-47-4085	15-47-4086	15-47-4087
	15-47-4090	15-47-4091	15-47-4092	15-47-4093	15-47-4094	15-47-4095	15-47-4096	15-47-4097
	15-47-4110	15-47-4111	15-47-4112	15-47-4113	15-47-4114	15-47-4115	15-47-4116	15-47-4117
	15-47-4120	15-47-4121	15-47-4122	15-47-4123	15-47-4124	15-47-4125	15-47-4126	15-47-4127
	15-47-4130	15-47-4131	15-47-4132	15-47-4133	15-47-4134	15-47-4135	15-47-4136	15-47-4137
	15-47-4140	15-47-4141	15-47-4142	15-47-4143	15-47-4144	15-47-4145	15-47-4146	15-47-4147
	15-47-4150	15-47-4151	15-47-4152	15-47-4153	15-47-4154	15-47-4155	15-47-4156	15-47-4157
	15-47-4160	15-47-4161	15-47-4162	15-47-4163	15-47-4164	15-47-4165	15-47-4166	15-47-4167
	15-47-4170	15-47-4171	15-47-4172	15-47-4173	15-47-4174	15-47-4175	15-47-4176	15-47-4177
	15-47-4180	15-47-4181	15-47-4182	15-47-4183	15-47-4184	15-47-4185	15-47-4186	15-47-4187
	15-47-4190	15-47-4191	15-47-4192	15-47-4193	15-47-4194	15-47-4195	15-47-4196	15-47-4197
	15-47-4220	15-47-4221	15-47-4222	15-47-4223	15-47-4224	15-47-4225	15-47-4226	15-47-4227
	15-47-4230	15-47-4231	15-47-4232	15-47-4233	15-47-4234	15-47-4235	15-47-4236	15-47-4237
	15-47-4242	15-47-4241	15-47-4242	15-47-4243	15-47-4244	15-47-4245	15-47-4246	15-47-4247
	15-47-4250	15-47-4251	15-47-4252	15-47-4253	15-47-4254	15-47-4255	15-47-4256	15-47-4257
	70430-0352	70430-0353	70430-1005	70430-1050	70430-4043	70430-4053		
	70430-4102	70430-4103	70430-4107	70430-4202	70430-4253			
	70430-5000	70430-5001	70430-5002	70430-5003	70430-5004	70430-5005	70430-5006	70430-5007
	70430-5008	70430-5009	70430-5010	70430-5011	70430-5012	70430-5013	70430-5014	70430-5015
	70430-5016	70430-5017	70430-5018					

Terminal Series No.	Terminal Order No.							
	70431	15-38-9020	15-38-9022	15-38-9030	15-38-9032	15-38-9040	15-38-9042	15-38-9050
15-38-9060		15-38-9062	15-38-9070	15-38-9072	15-38-9080	15-38-9082	15-38-9090	15-38-9092
15-38-9100		15-38-9102	15-38-9103	15-38-9110	15-38-9112			
15-38-9120		15-38-9122	15-38-9130	15-38-9132	15-38-9140	15-38-9142	15-38-9150	15-38-9152
15-38-9160		15-38-9162	15-38-9170	15-38-9172	15-38-9180	15-38-9182	15-38-9190	15-38-9192
15-38-9220		15-38-9222	15-38-9230	15-38-9232	15-38-9240	15-38-9242	15-38-9250	15-38-9252
15-47-4028		15-47-4038	15-47-4048	15-47-4058	15-47-4068	15-47-4078	15-47-4088	15-47-4098
15-47-4108		15-47-4118	15-47-4128	15-47-4138	15-47-4148	15-47-4158	15-47-4168	15-47-4178
15-47-4188		15-47-4198	15-47-4208	15-47-4218	15-47-4228	15-47-4238	15-47-4248	15-47-4258
15-47-5020		15-47-5022	15-47-5024	15-47-5030	15-47-5032	15-47-5034	15-47-5040	15-47-5042
15-47-5044		15-47-5050	15-47-5052	15-47-5054	15-47-5060	15-47-5062	15-47-5064	15-47-5070
15-47-5072		15-47-5074	15-47-5080	15-47-5082	15-47-5084	15-47-5090	15-47-5092	15-47-5094
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15-47-5124		15-47-5130	15-47-5132	15-47-5134	15-47-5140	15-47-5142	15-47-5144	15-47-5150
15-47-5152		15-47-5154	15-47-5160	15-47-5162	15-47-5164	15-47-5170	15-47-5172	15-47-5174
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704315050		704315080	704315100	704315110	704315200			

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