



Operating Manual

Blocking Tester (Order Code 32001)

1. Assembly

- 1 Basic Tool
- 2 Threaded Sleeve
- 3 Counternut for Threaded Sleeve
- 4 Integrated Switch Probe



2. Preparation

To adjust the instrument for the needed application, first of all the projection height and the nominal travel of the probe are to identify. Use the following formula to calculate the adjustment dimension:

projection height – nominal travel – switch travel = adjustment dimension

Example F733: adjustment dimension x = 10.5 mm – 4.0 mm – 0.5 mm = 6.0 mm



The threaded sleeve (2) is positioning the required adjustment dimension. It is fixed by the counternut (3).

The maximum adjustment dimension x is approx. 23.0 mm;
the minimum is approx. 4.5 mm



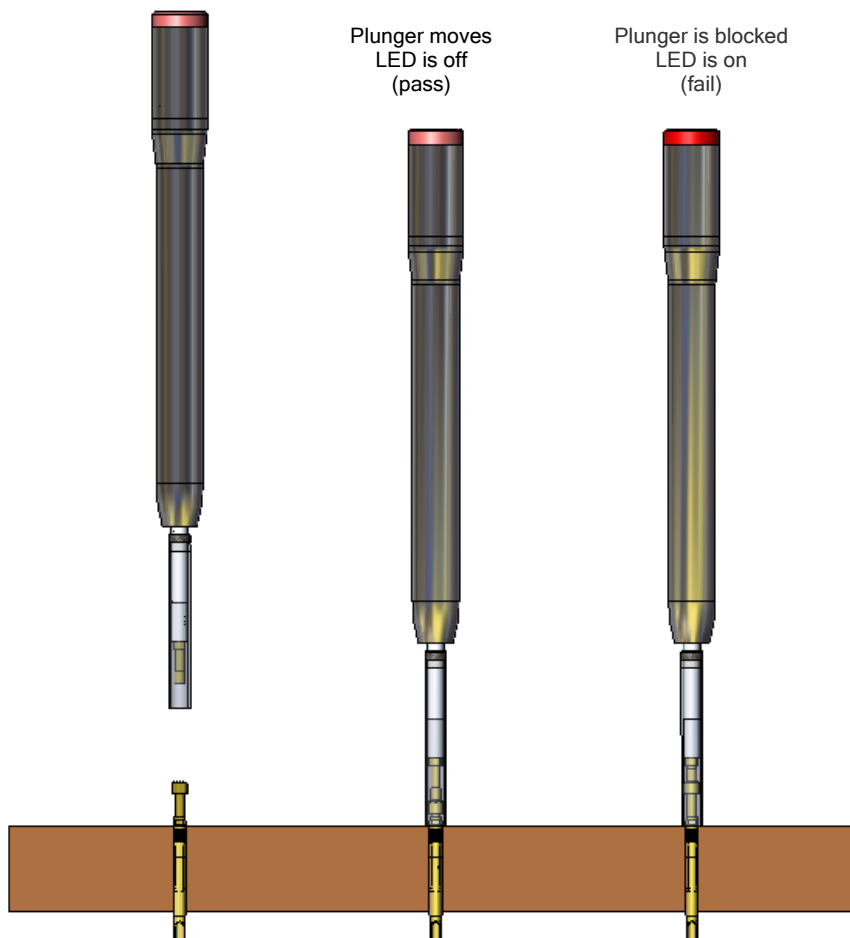
3. Test Procedure

Put the tool over the ready for testing spring contact probe and push down until body stop. During the procedure keep an eye on the LED at the end of the tool.

Case 1: LED is off → plunger moves (pass)

Case 2: LED is on → plunger is blocked or tight (fail)

In case 2 the spring contact probe is not working correctly. So the probe should be exchanged.





4. Adjustment dimensions of selected probes

Probe	Projection Height	Nominal Travel	Adjustment Dimension	Notice
F730	10,5	4,0	6,0	different for step probes
F175	10,1	5,0	4,6	
F731	12,8	3,5	8,8	different for step probes
F732	10,5	4,0	6,0	different for step probes
F723	7,3	2,8	4,0	
F733	10,5	4,0	6,0	different for step probes
F737	19,5	12,0	7,0	different for step probes
F873	10,4	4,0	5,9	
F875	10,2	4,0	5,7	
F875...L	16,7	4,0	12,2	
F375	15,0	8,0	6,5	
F880	10,2	4,0	5,7	
F880...L	16,7	4,0	12,2	
F881	10,2	4,0	5,7	
F883...SM	10,0	4,0	5,5	
F883...LM	16,5	4,0	12,0	
F884...SM	10,2	4,0	5,7	
F884...LM	16,7	4,0	12,2	
F885...SM	10,0	4,0	5,5	
F885...LM	16,5	4,0	12,0	
F886...SM	10,0	4,0	5,5	
F886...LM	16,5	4,0	12,0	
F385	17,0	9,0	7,5	
F887	9,2	4,0	4,7	
F752...S	15,2	4,0	10,7	
F752...L	18,2	4,0	13,7	
F756	10,4	4,0	5,9	
F757	10,5	2,0	8,0	
F760	10,5 to 26,7	4,0	6,0 bis 22,2	
F761	10,5	2,0	8,0	
F754...S	16,2	4,0	11,7	
F754...L	20,2	4,0	15,7	
F755...E13	13,3	5,0	7,8	different on other projection height
F310	10,6	2,4	7,7	
F320	13,6	3,2	9,9	
F330	18,8	5,6	12,7	
F340	22,5	6,4	15,6	
F735	10,8	4,4	5,9	



5. Change of the switch probe

There is a possibility to exchange the switch probe within the tool. For example if probes with very low spring forces are to be tested.

Included in basic device (order code 32001):

BG32001F1250 for spring forces up to 550 cN at nominal travel

Other switch probes:

BG32001F900 for spring forces up to 300 cN at nominal travel

BG32001F350 for spring forces up to 150 cN at nominal travel

BG32001F200 for spring forces up to 80 cN at nominal travel

How to change the probe:

Remove the threaded sleeve and the counternut.



Use an appropriate tool to remove the switch probe. Build in another switch probe type.



After replacing the switch probe screw the threaded sleeve and counternut to the tool again.

