

The Atlas Copco logo is positioned in the top right corner of the image. It consists of the company name "Atlas Copco" in a white, serif font, centered between two horizontal white bars. The logo is set against a dark blue rectangular background.A technical drawing of a die is overlaid on a blue triangular graphic in the bottom left corner. The drawing shows a cross-section of a die with various dimensions and labels, including "DZ11-150", "DZ11-175", "DZ11-200", and "DZ11-225".

Henrob die catalog

Breakdown of Henrob
part numbers for
self-pierce riveting dies

Henrob die catalog

Die part number build up

DXXXXXXXXXXXXXX is the standard part numbering format for dies

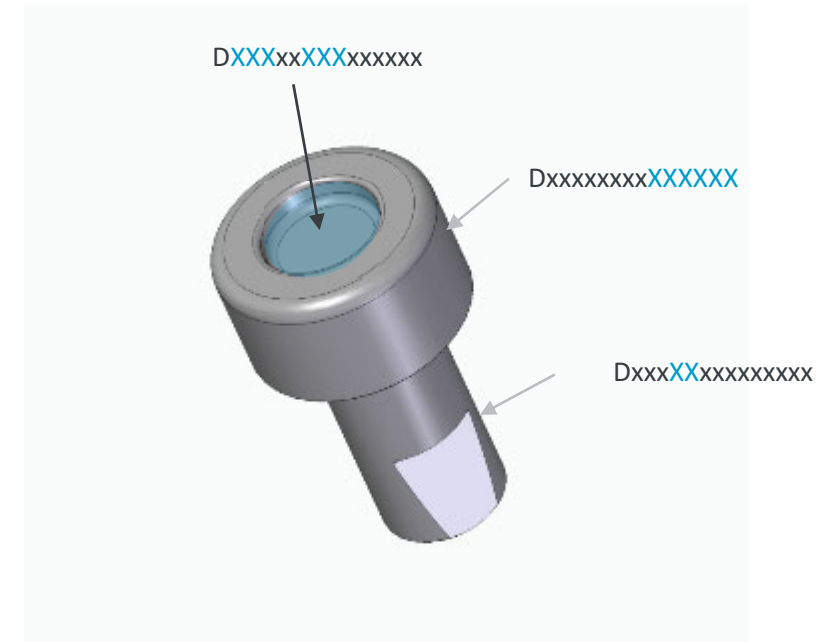
DXXXXXXXXXXXXXX – Die Cavity Profile Type (may be no letter here)

DxXXXXXXXXXXXXXX – Die Cavity Nominal Diameter

DxxxXXXXXXXXXXXX – Shank Diameter Length

DxxxxXXXXXXXXXX – Die Profile Depth

DxxxxxxxXXXXXXX – Die Head Geometry



*Note - Process Work reports may reference only the profile part of the die – DXXX-XXX,
(Profile Type & Diameter – Profile Depth)*

Henrob die catalog

Die part number build up – example (i)

DG0902200H1R1.5 is the part number for the die below

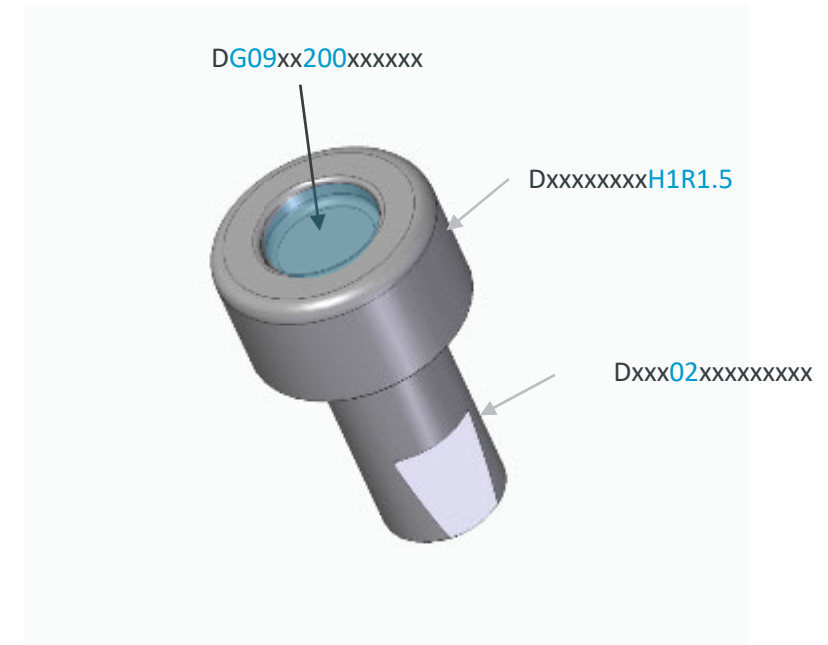
DG0902200H1R1.5 – Die Cavity Profile Type “G” – (flat die)

DG0902200H1R1.5 – Die Cavity Nominal Diameter is 9mm

DG0902200H1R1.5 – Shank Diameter is 10mm, Length is 20mm

DG0902200H1R1.5 – Die Profile Depth is 2mm

DG0902200H1R1.5 – 10mm tall die with 1.5mm radius around the edge



Note - Process work reports may reference only the profile part of this die as – DG09-200

Henrob die catalog

Die part number build up – example (ii)

DZ0764000 is the part number for the die below:

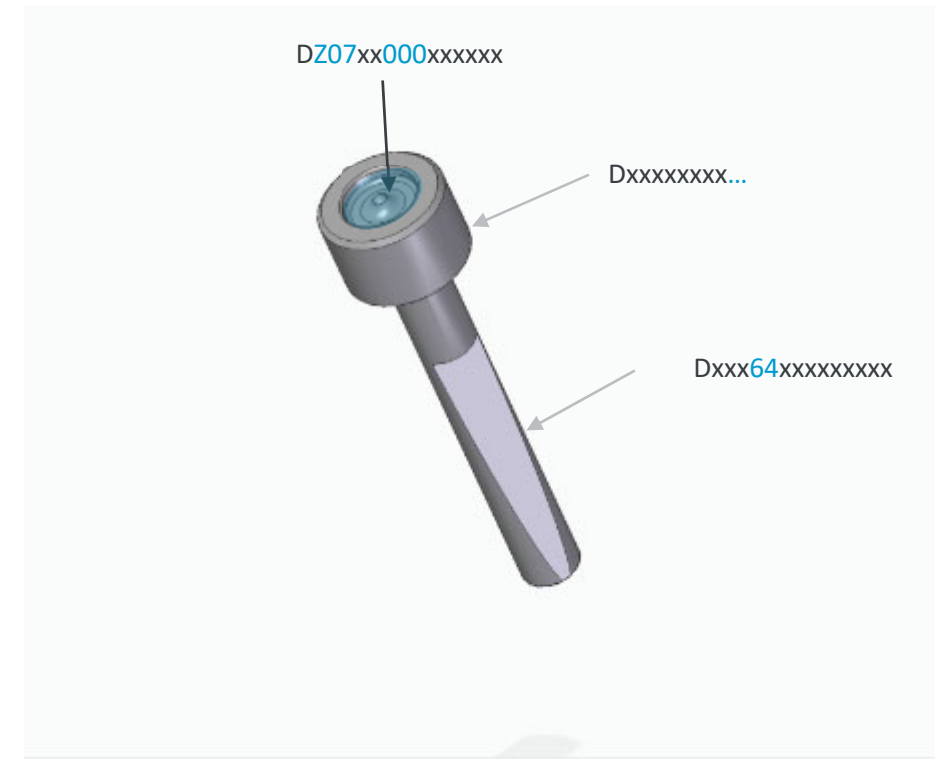
DZ0764000 – Die Cavity Profile Type “Z” – (pipped die)

DZ0764000 – Die Cavity Nominal Diameter is 7mm

DZ0764000 – Shank Diameter is 6mm, Length is 40mm

DZ0764000 – Die Pip Depth is flush to top surface

DZ0764000... – 8mm tall die with 0.5mm chamfer around the edge



Note - Process Work reports may reference only the profile part of this die as – DZ07-000

Henrob die catalog

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THIRD ANGLE PROJECTION														IF IN DOUBT, ASK				REV		CHANGE DETAIL		DATE		BY		CHK		APP																					
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PROFILES:																																																	
STANDARD SHANK GEOMETRY:																																																	
STANDARD HEAD GEOMETRY:																																																	
<p>THIS DRAWING IS THE PROPERTY OF HENROB LTD. IT IS TO BE KEPT IN CONFIDENCE AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF HENROB LTD.</p> <p>UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN MILLIMETERS.</p> <p>INCORPORATED CONFIDENTIAL</p> <p>APPROXIMATE DIMENSIONS IN MILLIMETERS</p> <p>ANGULAR DIMENSIONS TO NEAREST 5 MINUTES</p> <p>PERMIT CONSENT OF THE AUTHORISED OFFICE OF HENROB LTD.</p> <p>ASSOCIATED COMPANIES: GUNBROS</p> <p>DATE: 10/10/10</p> <p>BREAK ALL SHARP EDGES TO 10% OF SIZE</p> <p>ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED</p>																																																	
<p>HENROB Ltd SECOND AVENUE, ZONE 2 DESIDE INDUSTRIAL PARK FULFORD, CLACKMANNON, SCOTLAND TEL: 01344 837200 FAX: 01344 837222</p> <p>DRAWN TO: BS8898</p> <p>DRAWN BY: DPH DATE: 30 JAN 10</p> <p>CHECKED BY: DPH DATE: 14 FEB 10</p> <p>APPROVED BY: GSR DATE: 20 FEB 10</p> <p>DESCRIPTION: DIE MATRIX</p> <p>PART No.: 3805</p> <p>SIZE: A3</p> <p>DRG. FILE No.: 3005</p> <p>ORIGINAL SCALE: 1:1</p> <p>DO NOT SCALE IF IN DOUBT ASK</p> <p>SHEET 1 OF 1</p>																																																	

Henrob die catalog

Profiles (i)



- Non-automotive die
- Used with R and P rivets only
- Used when riveting lower-tensile steels
- DxxxxXXX refers to pip height below surface of die.
- Head diameter of this die is usually 16mm across the range



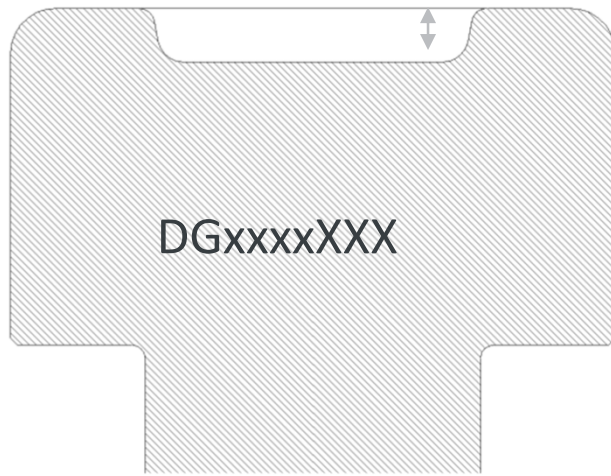
- Automotive die
- Used with shorter C rivets
- Used when riveting low-elongation castings
- DCxxxxXXX refers to cavity depth below surface of die
- Can produce high forces



- Automotive or general industry die
- Used with all rivet types
- Used when riveting all materials
- DFxxxxXXX refers to cavity depth below surface of die
- Deeper versions (>120) superseded by “DG” series.

Henrob die catalog

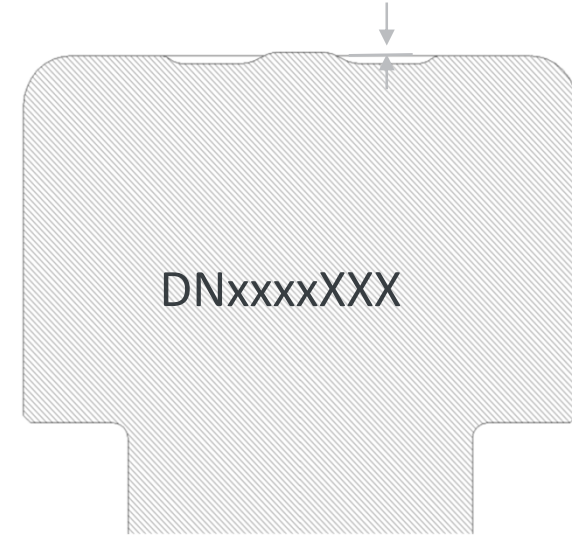
Profiles (ii)



- Automotive or general industry die
- Used with all rivet types – ONLY type to be used with T rivets
- Used when riveting all materials
- DGxxxxXXX refers to cavity depth below surface of die



- Automotive die
- Used with shorter C rivets
- Used when riveting low-elongation castings
- DKxxxxXXX refers to cavity depth below surface of die
- Can produce high forces



- Automotive die
- Used with very short 3mm C rivets
- Used in Aluminium only.
- Used when low-profile button is required
- DNxxxxXXX refers to cavity depth above surface of die
- Care to be applied – very small stackup/rivet length feasibility

Henrob die catalog

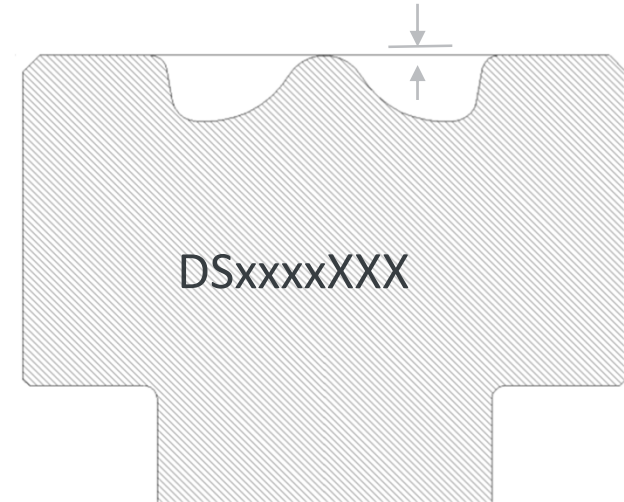
Profiles (iii)



- Automotive die
- Used with short or medium length C and K rivets
- Used in aluminum only, may be better suited for higher strength, lower ductility aluminium
- DPxxxxXXX refers to cavity depth below surface of die
- Can produce high forces



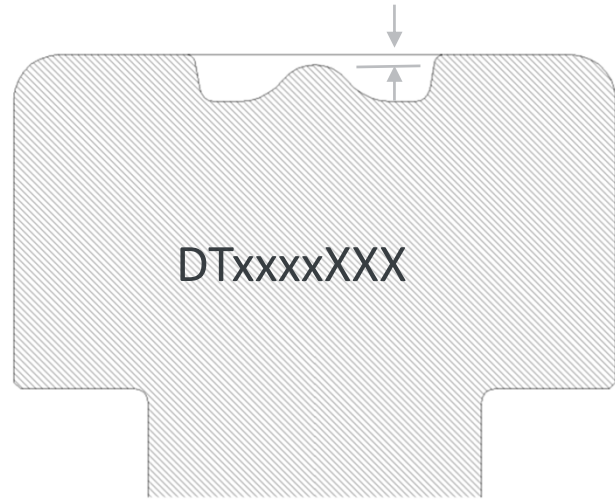
- Automotive or general industry die
- Used with all rivet types
- Used when riveting all materials
- DRxxxxXXX refers to cavity depth below surface of die, ('+50' = above)



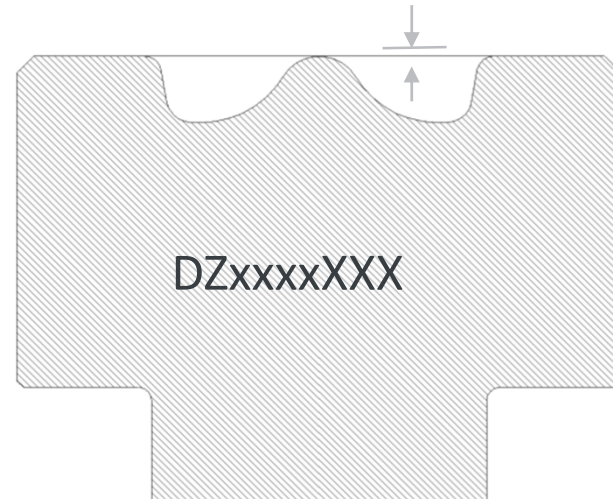
- Automotive die
- Used with short or medium length C and K rivets
- Used in aluminum only.
- DSxxxxXXX refers to pip depth above surface of die

Henrob die catalog

Profiles (iv)



- Automotive die
- Used with 3mm rivets only
- Used in aluminum only, may be better suited for higher strength, lower ductility aluminium.
- DTxxxxXXX refers to pip depth below surface of die

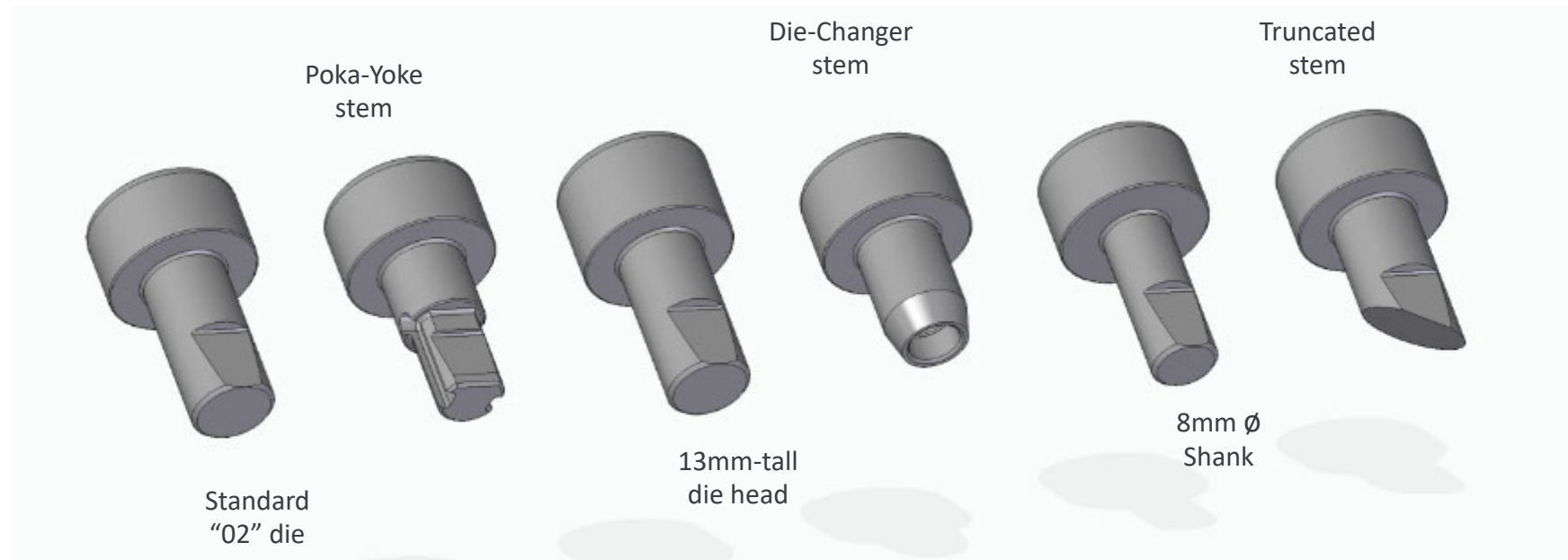


- Automotive die
- Used with short or medium length C and K rivets
- Used in aluminum only
- DZxxxxXXX refers to pip depth above surface of die

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Exceptions to standard die part numbers

- There are some exceptions to the standard external formats, usually down to individual setter requirements
- These must be requested specifically as they may not be available across profile ranges
- Example:



Atlas Copco

