

Title (en)  
PROCESS AND DEVICE FOR THE MANUFACTURE OF SOLID SELF-PIERCING RIVETS

Title (de)  
VERFAHREN UND WERKZEUG ZUR HERSTELLUNG EINES VOLLSTANZNIIETES

Title (fr)  
PROCÉDÉ ET APPAREIL DE FABRICATION DE RIVETS SOLIDES AUTO-PERCEURS

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Abstract (en)  
[origin: WO2013023831A1] The invention relates to a method for producing a solid punch rivet, in which a trimmed wire piece (8) is deformed by means of a tool (1) comprising a punch (4) and a matrix (2), wherein the wire piece (8) is clamped between shaped parts (33) which are arranged in a jaw like manner and are radially engageable, and which form the peripheral rivet contour (321) and comprise at least one annular groove (322) forming an undercut, and subsequently an axial force is applied to the wire piece (7) at the two ends thereof via a respective pressure pin (24, 46), which results in the wire material fluently filling the peripheral rivet contour formed by the shaped pieces (33). The invention further relates to a tool for producing a solid punch rivet by said method.

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