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)

DxXXxxxxxxxxxxx – Die Cavity Nominal Diameter

DxxxXXxxxxxxxxx – Shank Diameter Length

DxxxxxXXXxxxxxx – Die Profile Depth

DxxxxxxxXXXXXX – Die Head Geometry

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

| DIE NO | SIZE | DIAMETER | TAPER | PROFILE | SHANK GEOMETRY | HEAD GEOMETRY | DCERIEN | DCERIEN
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Table with dimensions and specifications for Henrob dies.
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120) superseded by “DG” series.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)**

- **DGxxxxXXX**
  - 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

- **DKxxxxXXX**
  - 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

- **DNxxxxXXX**
  - 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
  - Can produce high forces
  - Care to be applied – very small stackup/rivet length feasibility
Henrob die catalog

Profiles (iii)

- DPxxxxXXX
  - 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 aluminum
  - DPxxxxXXX refers to cavity depth below surface of die
  - Can produce high forces

- DRxxxxXXX
  - 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)

- DSxxxxXXX
  - 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)

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

- DZxxxxXXX
  - 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
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: