

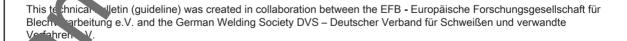
Technical B W tin



Technical Bulletin DVS 3/11-2 Self-pierce Riveting – Special Processes

Technical Comittee of the DVS

Working Group V10 "Mecha" at Joining" by the joint committee for DVS and EFB Subgroup V 10.1 / MF1 "Se f-pie ce riveting"



The pullication has been drawn up by a group of experienced specialists working in an honorary capacity and its consideration is recommended. The user should always check to what extent the contents are applicable to his particular case and whether the version on hand is still valid. No liability can be accepted by the DVS – Deutscher Verband für Schweißen und verwandte Verfahren e.V., the EFB - Europäische Forschungsgesellschaft für Blechverarbeitung e.V. and those participating in the drawing up of the document

July 2020 DVS/EFB 3410-2

Content:

1.	Purpose and scope of the guideline	
2.	Description of the special self-pierce riveting processes	3
2.1.	1.1. Semi-tubular self-pierce riveting with split dies	
2.2.	Solid self-pierce riveting with split dies	4
2.3.		4
2.4.	Pierce-compressing riveting	5
2.5.	Self-pierce riveting with closing element	
2.6.	Self-closing solid self-pierce riveting	6
2.7.	Self-pierce riveting with pre-assembled semi-tubular rivetsFlange self-pierce riveting	6
2.8.	Flange self-pierce riveting	7
2.9.	Clinch riveting	7
2.10.	Self-pierce riveting with overlaid motion	8
2.11.	Self-pierce riveting with overlaid motion	8
2.12.	Impulse self-pierce riveting with multiple impulse	9
2.13.	Self-pierce riveting with component heating	10
2.14.	Hydro self-pierce riveting	10
2.15.	Solid self-pierce riveting with double-locking discs	11
3.	References	12
3.1.	Standards and Guidelines	12
3.2.	Literature	