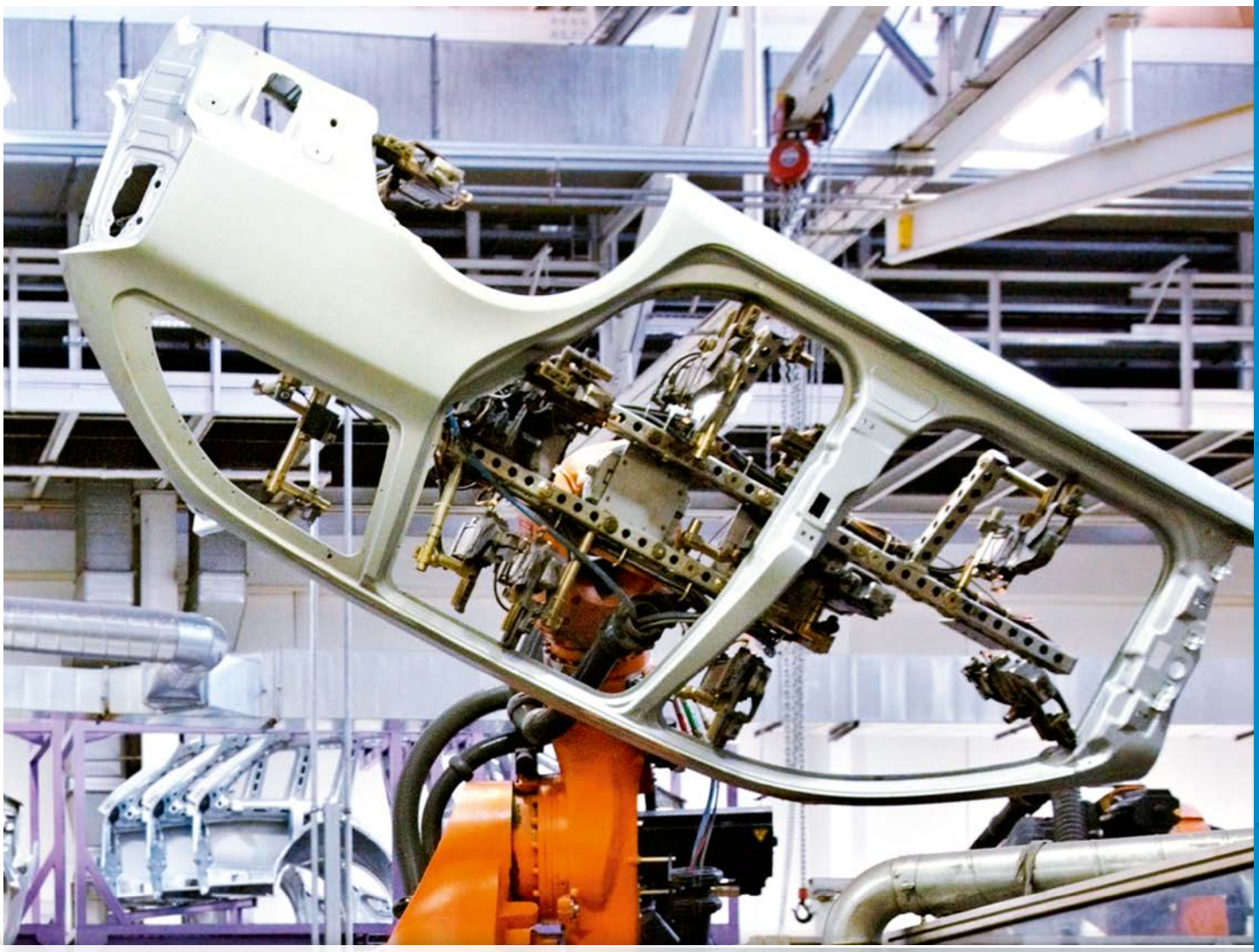
Version 03.2024
www.arnold-fastening.com

ARNOLD®
BlueFastening Systems



Focus on lightweight construction – innovative metal multi-material joining systems

- The market challenges
- Joining multi-material mix
- Integrating functional elements
- All-encompassing services
- www.arnold-fastening.com



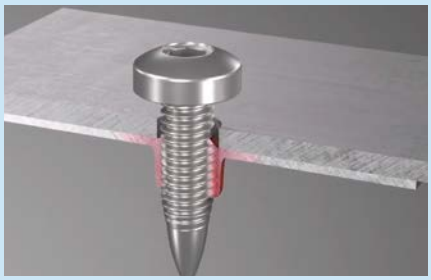
Focus on lightweight construction: The challenges of multi-material mix joining

Lightweight construction has been a hot topic within the automotive industry for quite a few years. Lightweight means that different materials often need to be joined together – the key words being “multi-material mix”. Conventional welding is generally not appropriate here. Instead innovative joining processes are used, such as flowhole forming, clinching or punching. These methods also reduce cycle times and produce a more secure fastening.



Innovative solutions for pioneering markets

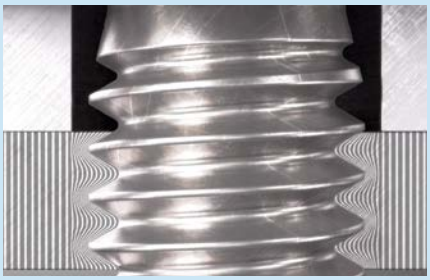
Flowhole-forming

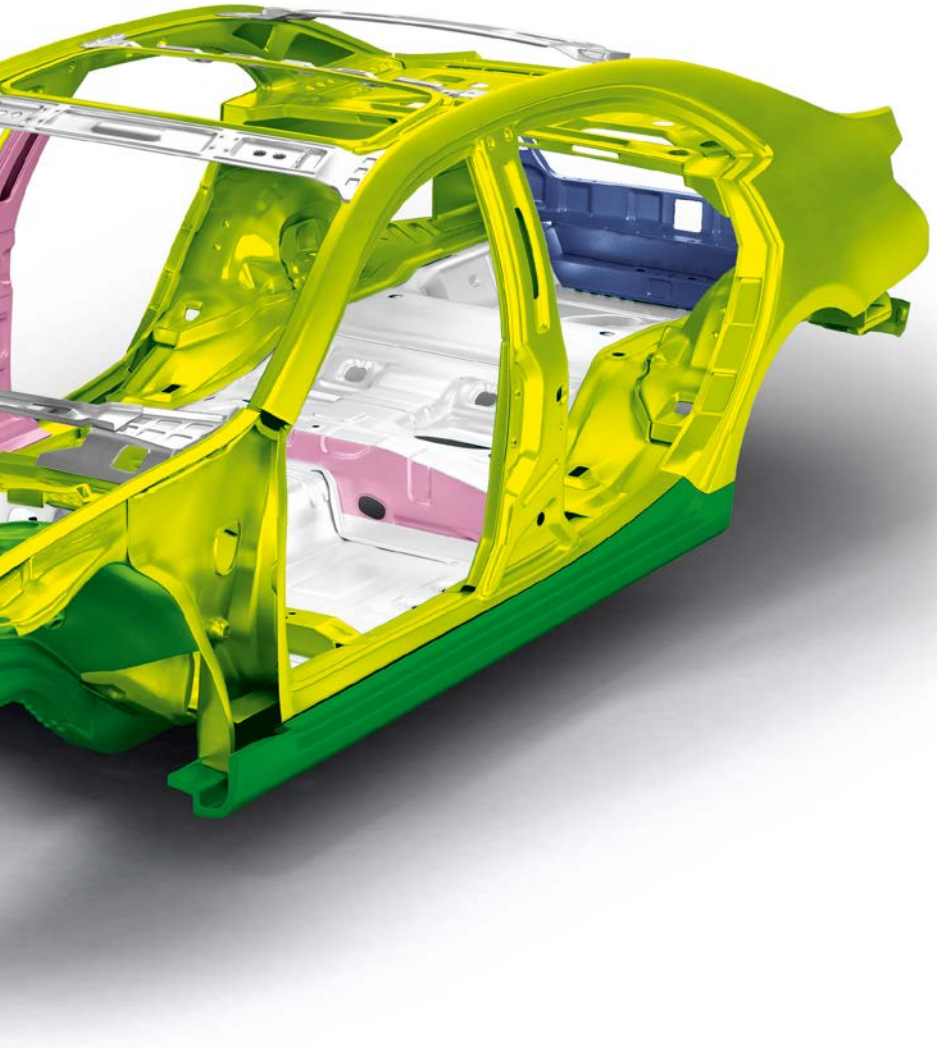


Resistance element welding



Direct screw fastening





- aluminum sheet
- aluminum extrusion
- cast aluminum
- mild steel < 350 MPa
- high-strength steel (HSS) 350–450 MPa
- advanced high-strength steel (AHSS) 450–1000 MPa
- ultra high-strength steel (UHSS) > 1000 MPa

Self pierce and clinching



Self clinching



Assembly



Procedure for joining different materials in lightweight body construction

Joining multi-material mix

Flowform®

Flowhole-forming screw for single-side joining applications and high strength joint properties



Flowform® Plus

The advanced screw that weighs less: 25% lighter. Joining without pre-drilling possible



Flexweld®

Resistance element welding for mixed material applications with ultra high-strength steel (UHSS) materials



Sheetite®

Direct screw fastening pre-drilled sheet metals



Integrating functional elements

RIVTEX® RXS

Self-clinching screw for thin plates.
Plate thickness: 0.75–2.0 mm



RIVTEX® RXM

Round pierce-clinch nut for thin plates.
Plate thickness : 0.75–2.0 mm



STRUX® SX

Self-clinching screw for thick plate.
Metal thickness: 2.0–5.0 mm



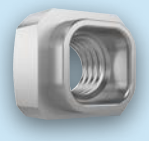
Rivorm® AX

Rivet: Our strongest fastener as far as rivets are concerned



RIVORM® HR

Square rivet nut for thin and thick plate. Sheet thickness: 0.4 – 3.5 mm (4.5 mm)



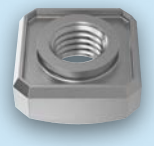
RIVORM® TR

Rivet suitable for any application



PIAS® KP

Square pierce-clinch nut for thin plate. Sheet thickness: 0.6–2.0 mm



PIAS® HN

Square self-clinching nut for thick plate. Sheet thickness: 2.0–4.0 mm

PIAS® HNR

Heavy duty pierce-clinch nut



- aluminum sheet
- aluminum extrusion
- cast aluminum
- mild steel < 350 MPa
- high-strength steel (HSS) 350–450 MPa
- advanced high-strength steel (AHSS) 450–1000 MPa
- ultra high-strength steel (UHSS) > 1000 MPa

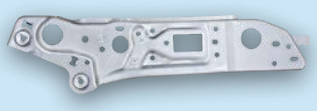
Assembly

Ready-to-assemble plate modules with integrated fastener

PIAS® KP 8H
Pierce-clinch nuts

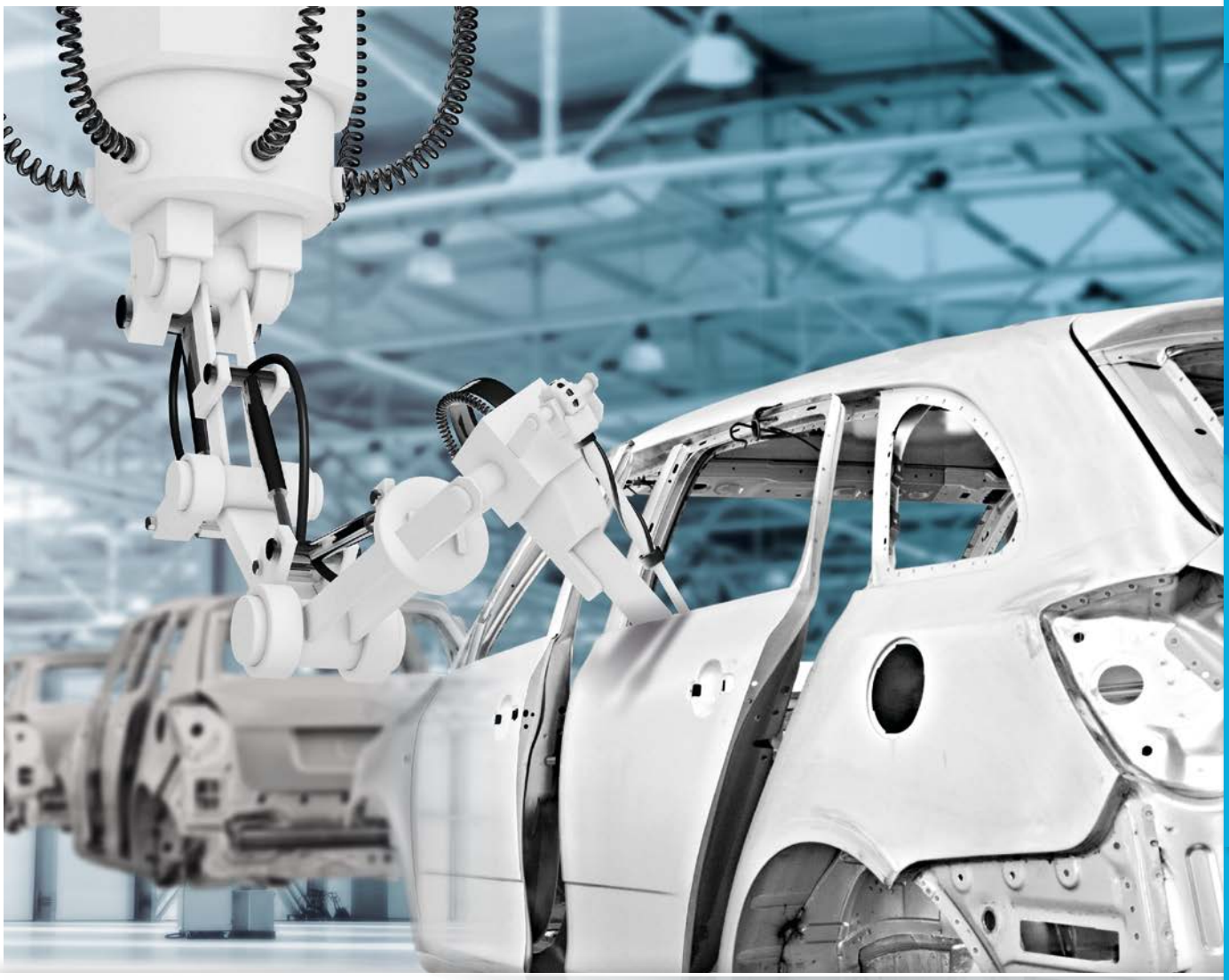


STRUX® SX M6
Selfclinching screws



PIAS® KP 8H
Pierce-clinch nuts





Joining multi-material mix

- Flowform® – flowhole-forming and thread-forming fastener
- Flowform® Plus – the advanced screw that weighs less
- Flexweld® – resistance element welding
- Sheetite® – direct screw fastening for sheet metals

- www.arnold-fastening.com

Flowform® – flowhole-forming and thread-forming fastener





Flowform® data

The values shown are by way of example parameters. Specific values must always be determined by carrying out trials on original production parts. Our applications laboratory is always happy to answer any further questions you may have.



New head geometry

- ⊕ External driving feature with chamfered edges
- ⊕ Better locating (bit drive)



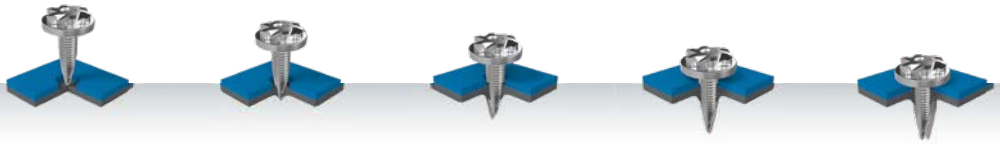
Round shaft cross-section

- ⊕ 60° flank profile
- ⊕ Over-proportioned diameter

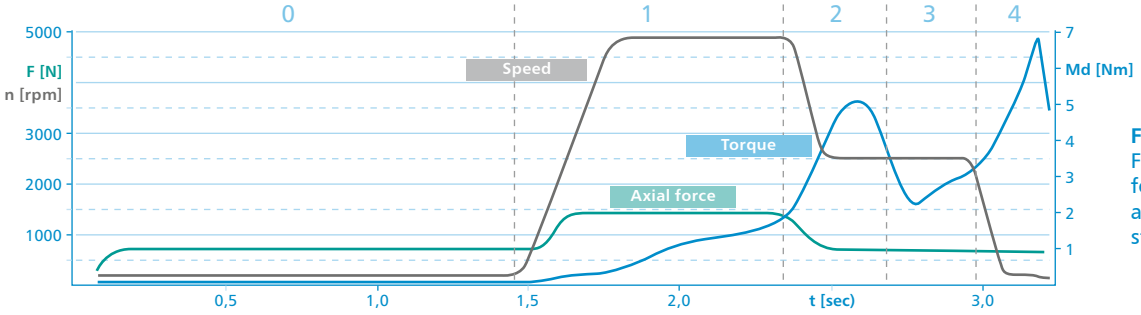


Polygonal shaft cross-section

- ⊕ Radius flank profile above the tapping zone
- ⊕ Increasing thread formation



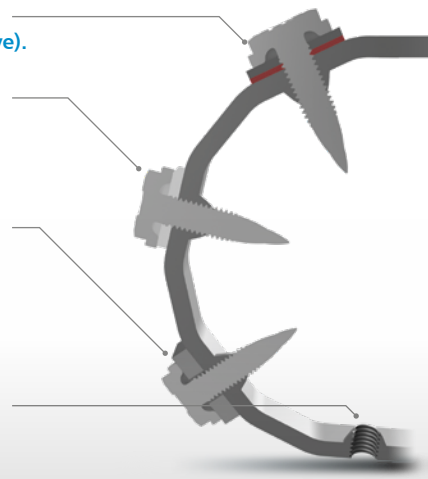
0 **Positioning** 1 **Flowhole forming** 2 **Thread forming** 3 **Screwing in** 4 **Final thightening**



Cycle time
3.5–5.0 sec.

Flowform®
Flowhole-forming screw for single-side joining applications and high strength joint properties

- ⊕ Single-side access joining technology **fastens** hybrid joins **(including with adhesive).**
- ⊕ Ideal for fastening aluminum to aluminum and aluminum to **high-strength steel.**
- ⊕ Generates a nut thread providing good **load capacity** for the fastening to meet strict **crash requirements.**
- ⊕ Thicker join combinations require a **pre-drilled hole** in the clamping part. Thinner join combinations do not need to be pre-drilled.
- ⊕ Can be undone



Flowform® Plus – it's the structure that makes the difference





Flowform® Plus data

The values shown are by way of example parameters. Specific values must always be determined by carrying out trials on original production parts. Our applications laboratory is always happy to answer any further questions you may have.



Application of load
- ⊕ Smaller in size
- ⊕ EP12 → EP10
- ⊕ Short location times



Underhead channelling
Recess to accept rising material as the join is made



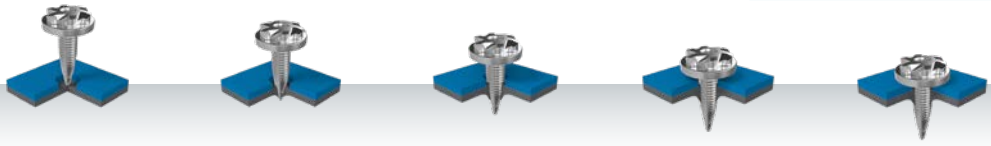
Round shaft cross-section
Bearing thread area with an excess to increase load-bearing capacity

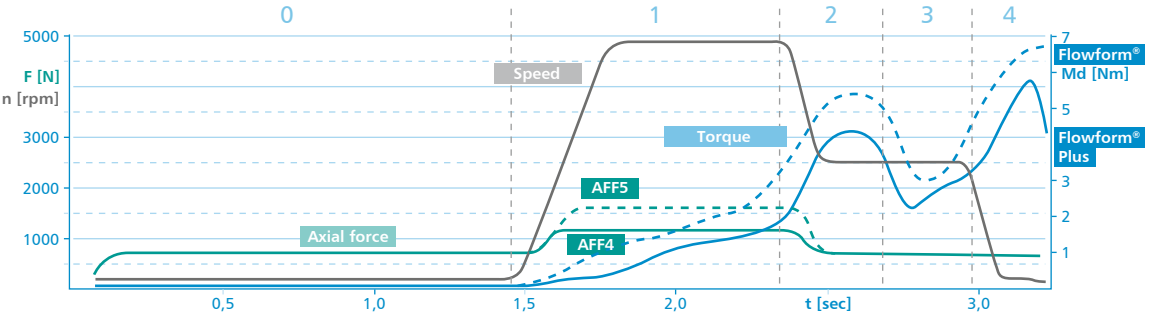


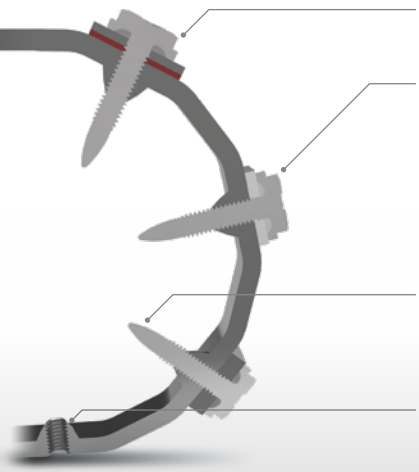
Polygonal shaft cross-section
Thread-forming area to form the counter-thread



Polygonal tip cross-section
Solid tip geometry makes it possible to drill into sheet metals







- ⊕ Joins up to **1,000 Mpa strength sheet steels** and around ≤ 1.0 mm thick, in combination with aluminum screw-in parts
- ⊕ Ideal for joining aluminum sheets **without pre-drilled holes,** while also reducing gap formation
- ⊕ Despite the smaller size, it has very good fastening properties due to the ductile and very **high strength screw material**
- ⊕ Can be used on existing series production equipment
- ⊕ **25% weight saving** by scaling down the size of the fastener
- ⊕ **Lower axial joining forces** required through slim tip shape
- ⊕ In thicker joint pairings, no pre-drilled hole is required in the clamping part
- ⊕ Can be undone

Flexweld® – resistance element welding

Resistance element welding for mixed material applications with ultra high-strength steel (UHSS) materials – with conventional resistance spot welding equipment.

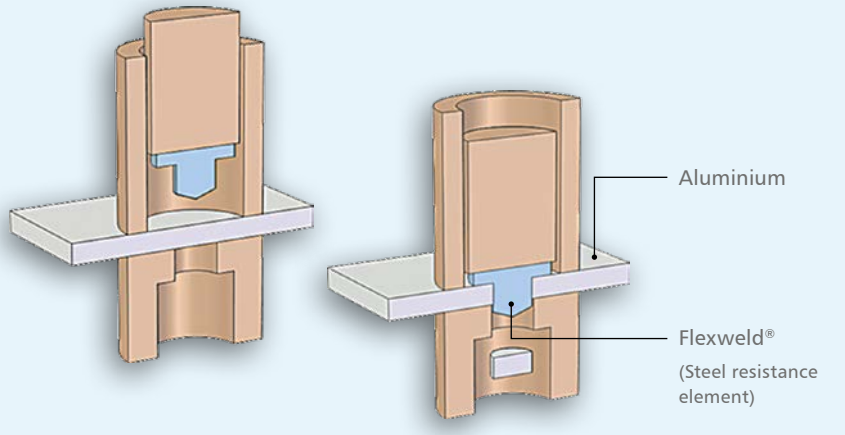
This is how Flexweld® works

Flexweld® elements are pre-assembled into the aluminum sheet where they are permanently fixed. This component is then welded to steel components, using conventional spot welding guns and body in white adhesive.

Pre-assembly production

Step 1

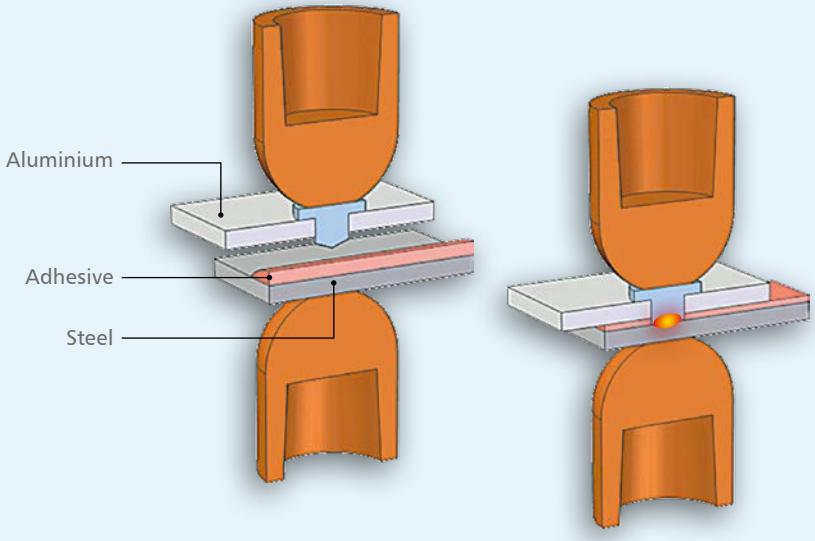
Preassembly piercing and riveting by c-frame or progressive die



Welding on main assembly line

Step 2

Adhesive bonding and resistance welding



Pictures: Volkswagen, Dr. Th. Franz Franz

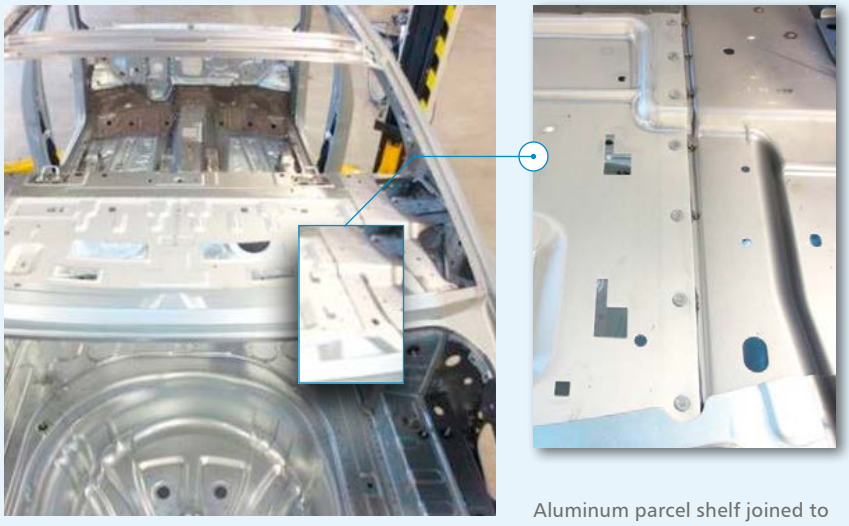
The Flexweld® element and an application example

Element and system technology from one hand



Element properties

- All available automotive relevant surfaces. Different Element length for aluminum thickness range from 0,7–3,1 [mm]

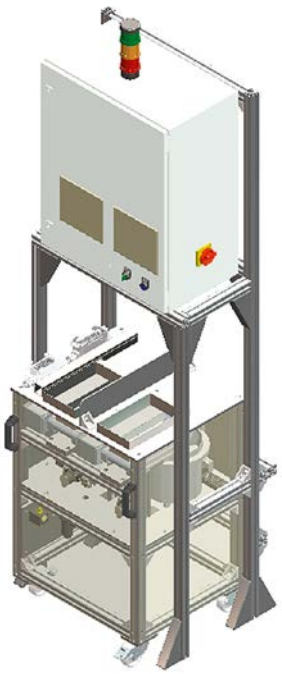


Aluminum parcel shelf joined to steel body in the VW Passat B8 using Flexweld®

Pictures: Volkswagen, Herr Dr. Th. Franz

Flexweld® application in mass volume production **reduces more than one kilogram** weight per car.

Flexweld® – Feedtec and Controltec

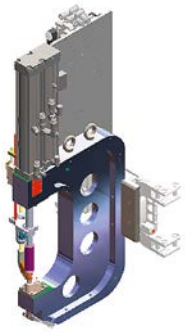


Flexweld® feeder and control device

Modular feeder device suitable for application of all Flexweld® element sizes without tool changing. The operating panel and the PIC 2000 process control system can be integrated into the control cabinet or available as a mobile panel.

Flexweld® – Tooltec

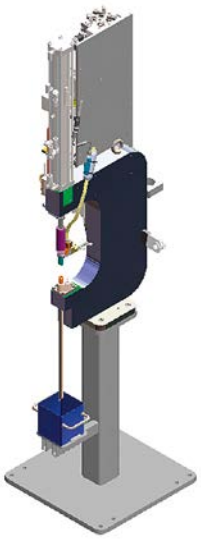
Example C-frame unit for robot.

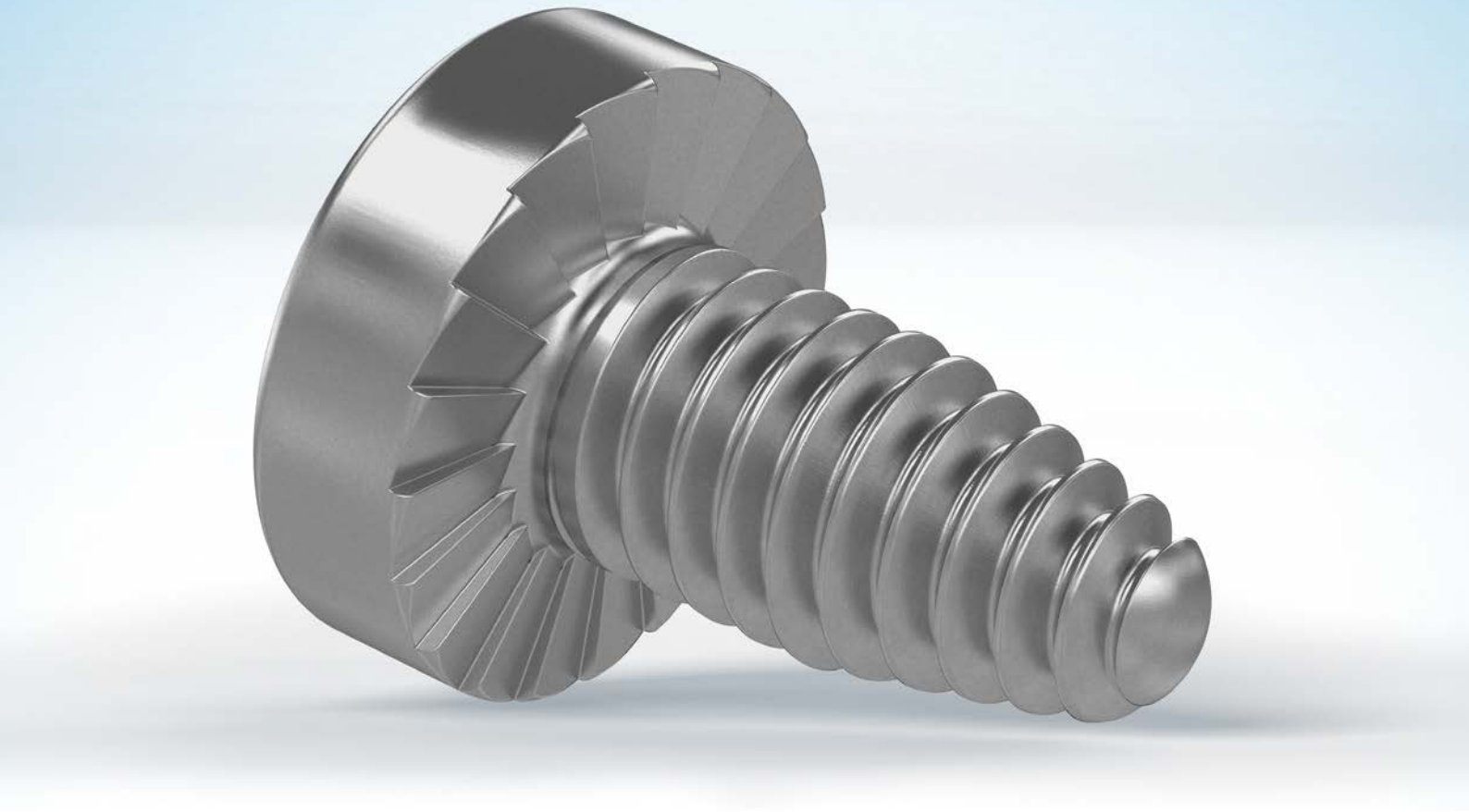


Flexweld® C-frame unit

The c-frame unit can be mounted on a robot or used in a stationary system. The system is independent of the punch direction and operates at any angle position.

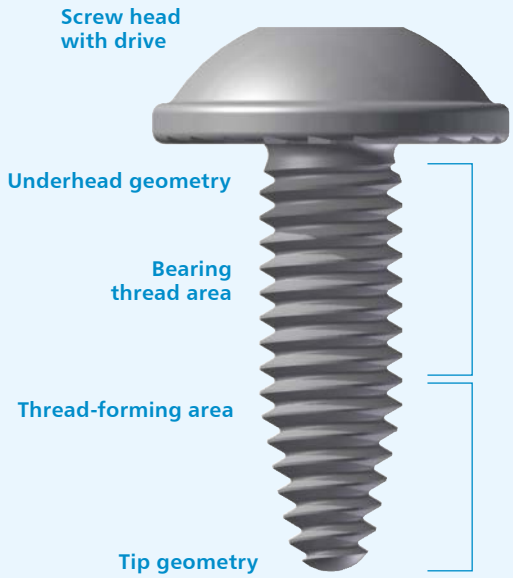
Example C-frame unit for stationary systems.

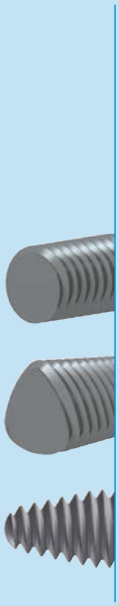




Sheetite® – direct screw fastening for sheet metals

Speed up your production and greatly lower your overall fastener costs.
With Sheetite ® you make use of the technological and economical advantages of fastening directly into sheet metals.





Potential characteristics
- ⊕ flat head, truss head
- ⊕ customer-specified solutions

Potential characteristics
- ⊕ locking toothing, milled toothing
- ⊕ customer-specified solutions

Round shaft cross-section
- ⊕ optimized load capacity
- ⊕ metric female thread

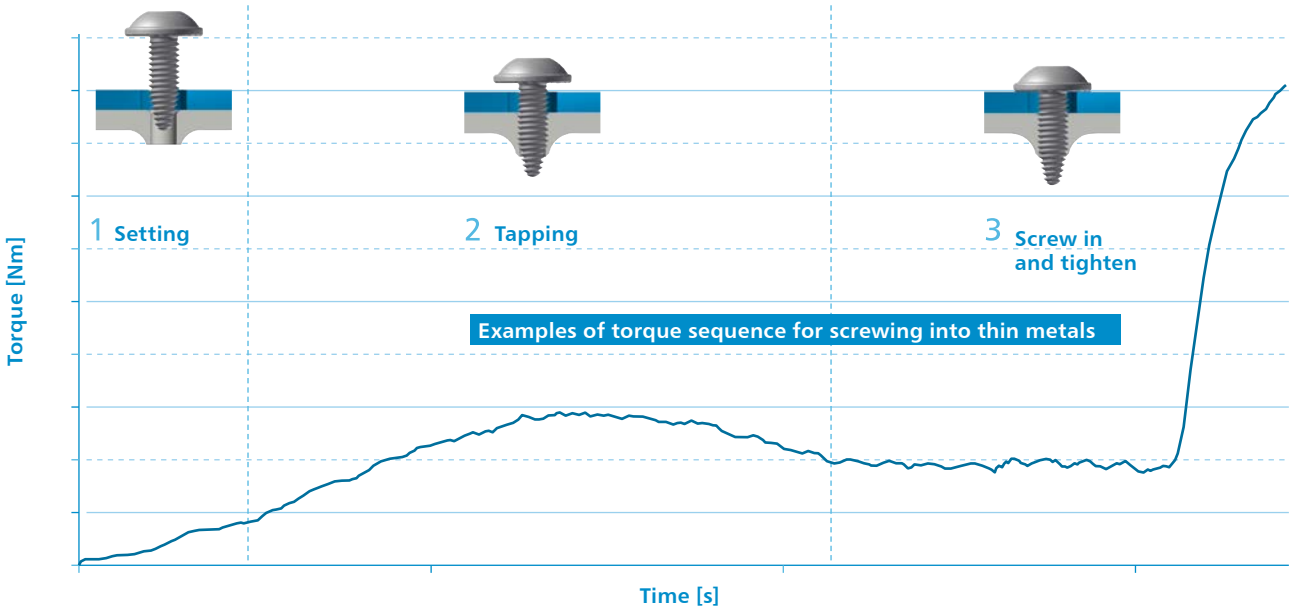
Polygonal shaft cross-section
- ⊕ low tapping torques
- ⊕ no chip formation during thread-forming

Rounded tip
- ⊕ improved hole location
- ⊕ reduces risk of injury
- ⊕ protects other components

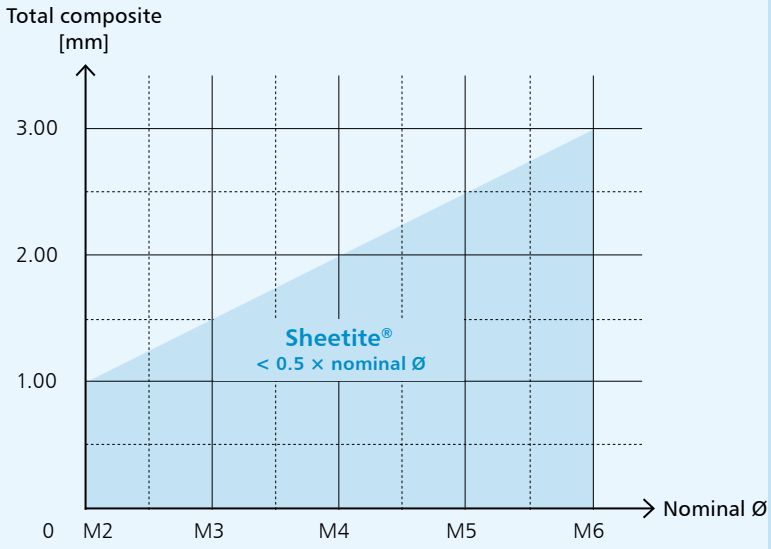
The screw-fastening operation for thin plate

Sheetite® screws are fastened into pre-drilled sheet metals (through-holes and extruded holes) using a simple screwing-in procedure, which helps to form a metric thread.

The Sheetite®'s special shape ensures a high delta between the screw-in and overturn torques.



Application notes



Sheetite® is designed to connect two or more plate-shaped components placed one on top of the other, with a total composite of 0.5 times the nominal diameter or less. This composite consists of a minimum of an upper clamping part with a through-hole and a lower pre-bored screwed part with or without a through-hole.

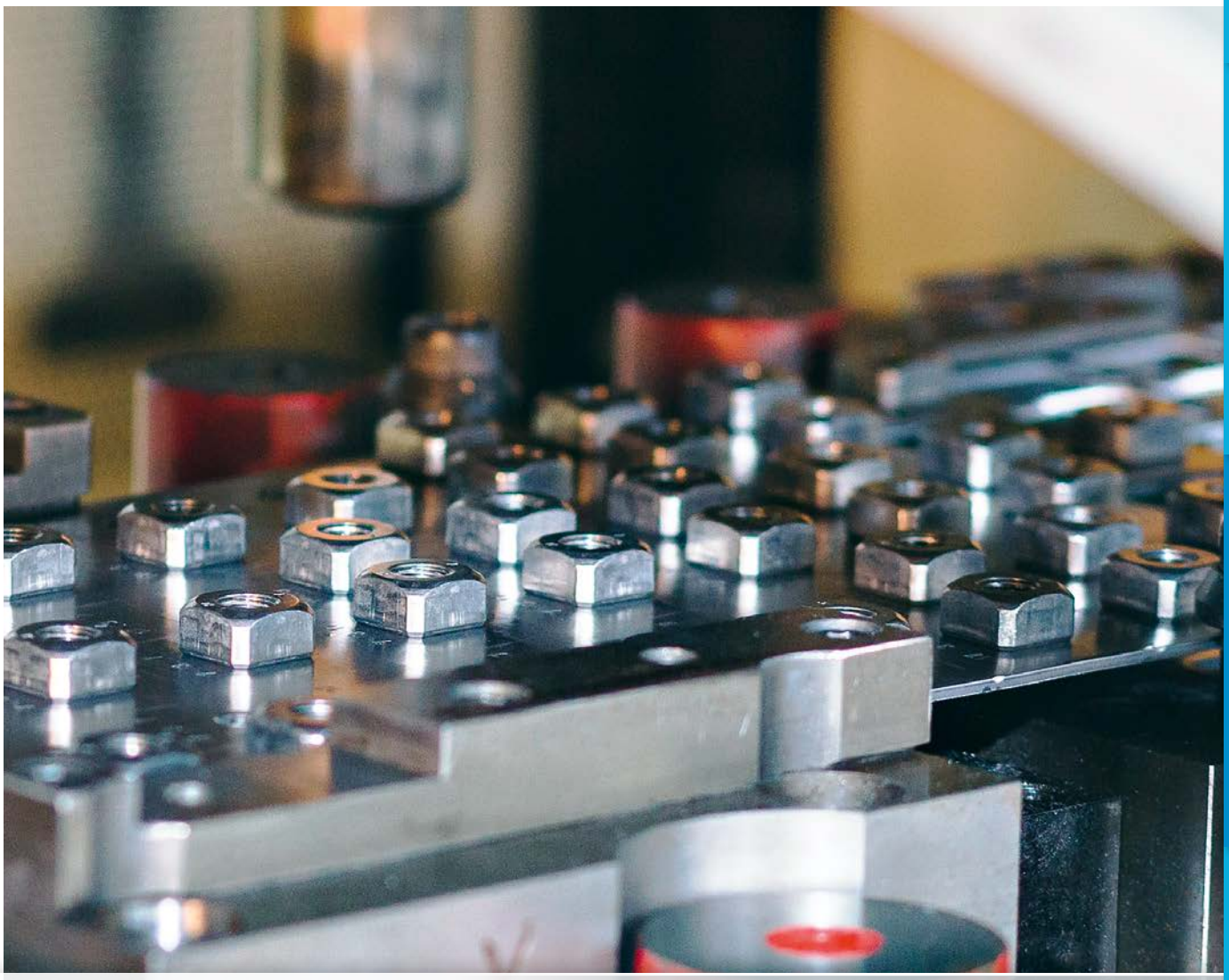
It can be used to join the following materials:

- steel
- aluminum

other metallic materials possible on request.

Note: The values shown are by way of example parameters. Specific values must always be determined by carrying out trials on original production parts. Our applications laboratory is always happy to answer any further questions you may have.

ARNOLD®
BlueFastening Systems



Integrating functional elements

- RIVTEX® | STRUX® self-clinching screws
- PIAS® | RIVTEX® pierce-clinch nuts
- Rivorm® rivets
- System technology – Feedtec / Tooltec / Controltec

→ www.arnold-fastening.com



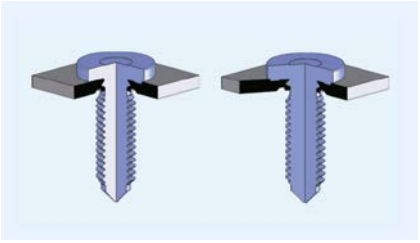
RIVTEX® RXS Self-clinching screw

The benefits of RIVTEX® RXS self-clinching screws

- ⊕ especially suitable for use in thin sheet-metals
- ⊕ can process several self-clinching screws in a single stroke
- ⊕ can be used in steel and aluminum
- ⊕ Sheet thickness: 0.75–2.0 mm
- ⊕ Strength class: 8.8 and 10.9

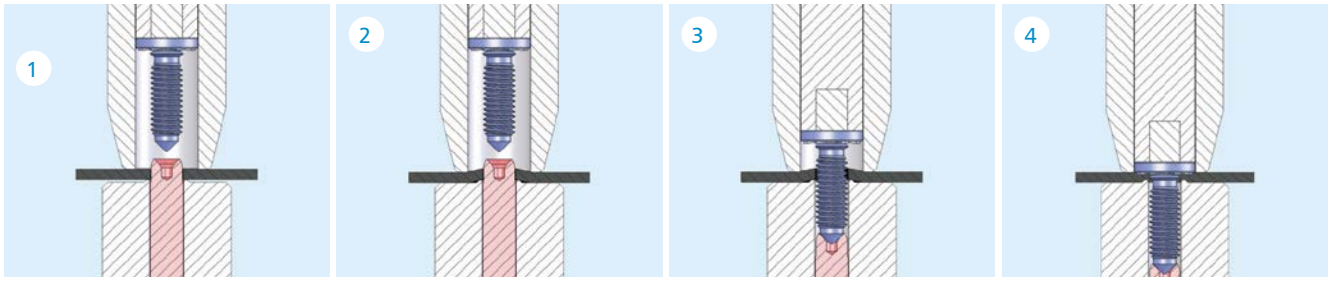
The advantages compared with welding

- ⊕ low inspection and control costs
- ⊕ avoids emissions and reduces energy costs
- ⊕ no thermal weakening at the fastening position

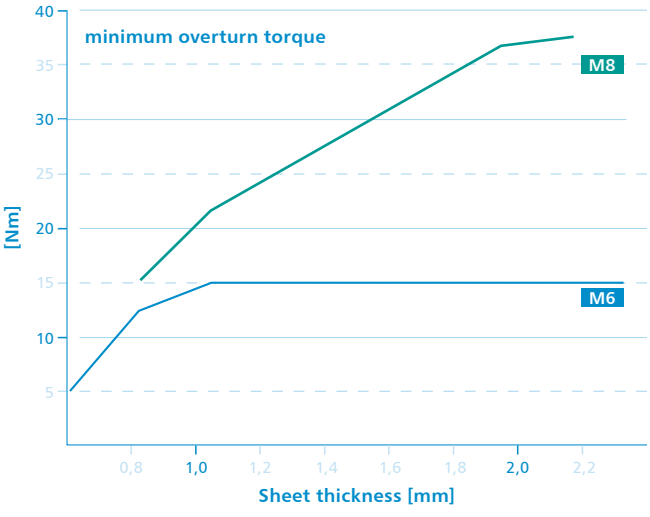


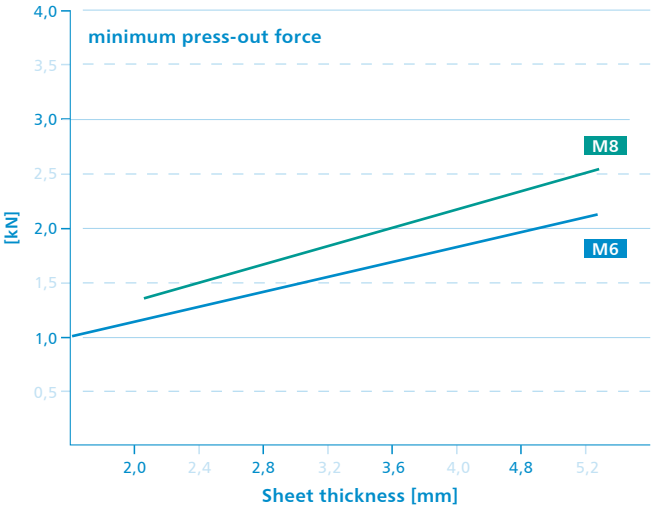
Technical data	
Sheet thickness	0.75–2.0 mm
Strength class	8.8 and 10.9

Function sequence



Press-out and torque values (material Rm 350 N/mm²)





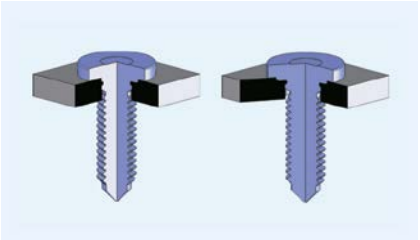
STRUX® SX Self-clinching screw

The benefits of STRUX® SX self-clinching screws

- especially suitable for heavy loads in thick sheet metals
- can process several self-clinching screws in a single stroke
- can be used in steel and aluminum
- Sheet thickness: 2.0–5.0 mm
- Strength class: 8.8 and 10.9

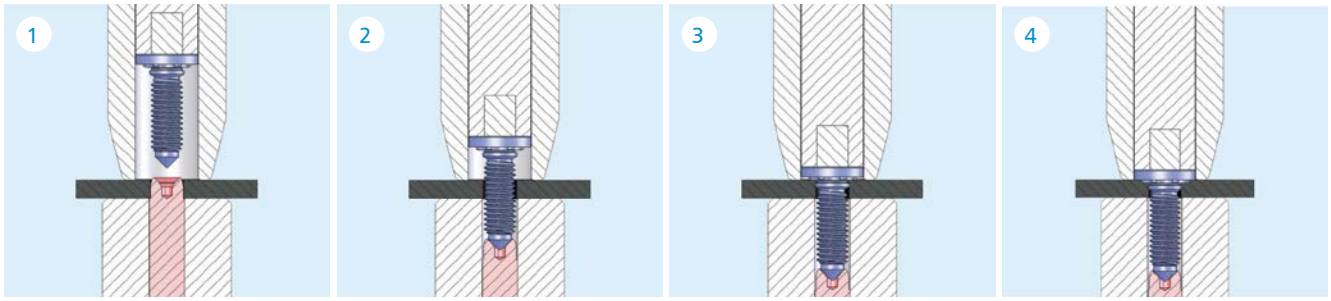
The advantages compared with welding

- low inspection and control costs
- avoids emissions and reduces energy costs
- no thermal weakening at the fastening position

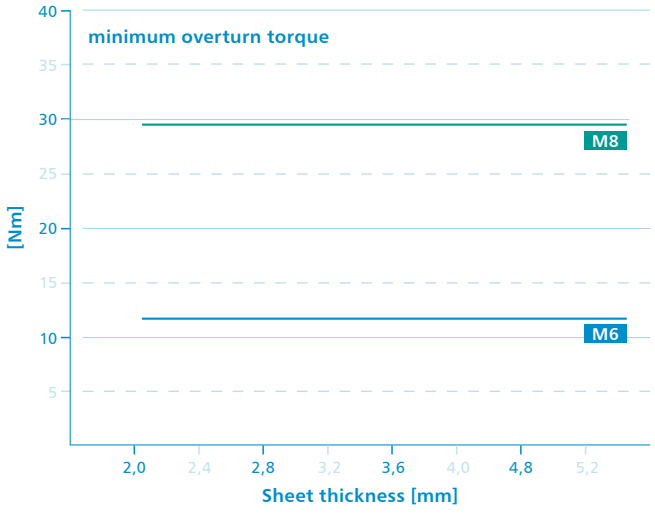


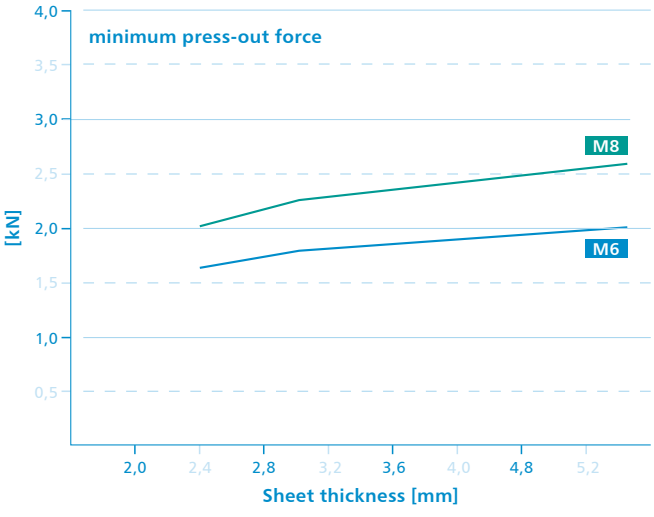
Technical data	
Sheet thickness	2.0–5.0 mm
Strength class	8.8 and 10.9

Function sequence



Press-out and torque values (material Rm 350 N/mm²)





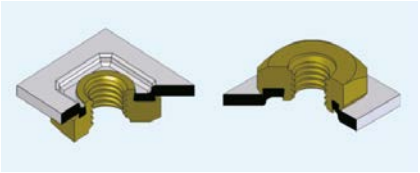
PIAS® KP – Pierce-clinch nuts

The benefits of PIAS®KP Pierce-clinch nuts

- self-piercing
- higher torque requirements
- high process reliability in fully-automated processing
- flush-mounted processing
- manual, semi / fully automated processing possible
- self-locking thread possible

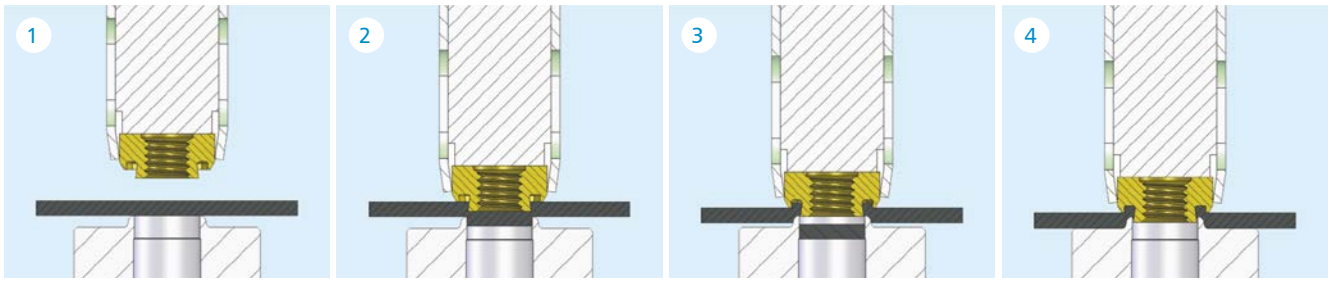
The advantages compared with welding

- corrosion resistant
- no weld spatter on the thread
- no thermal weakening at the fastening position

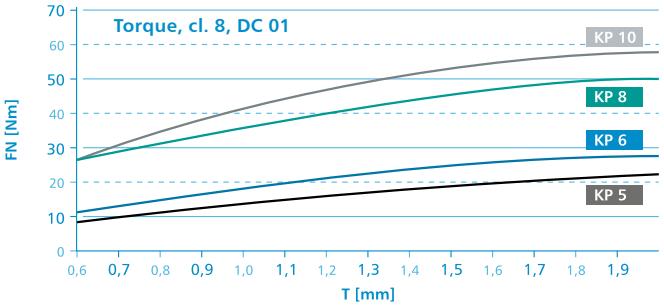


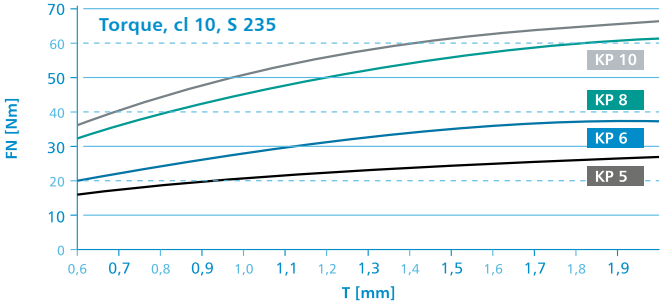
Technical data	
Sheet thickness	0.6 – 2.00 mm
Strength class	8 and 10

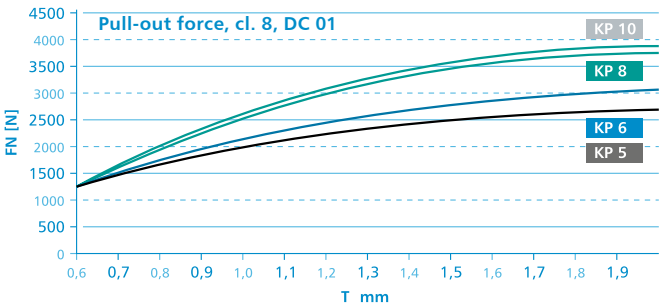
Function sequence

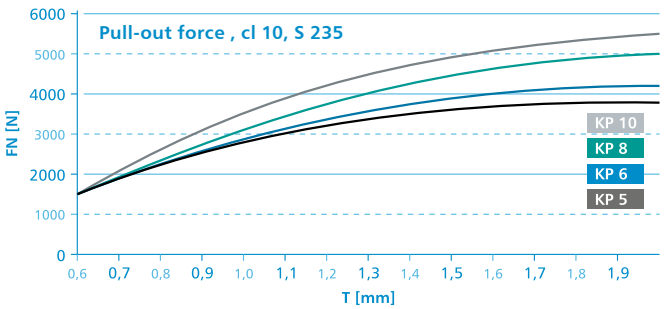


Pull-out and torque values





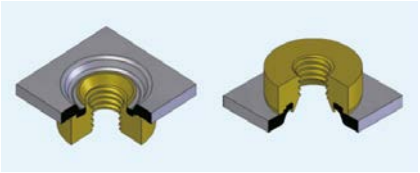




RIVTEX® RXM pierce-clinch nut

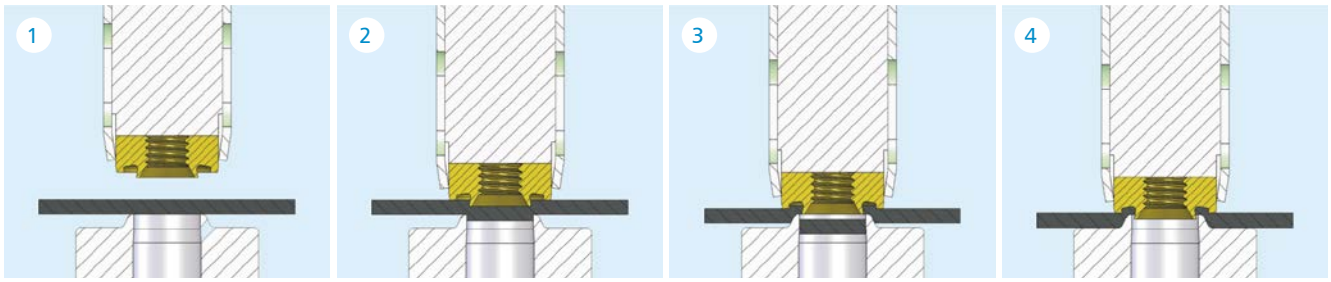
The benefits of RIVTEX® RXM pierce-clinch nuts

- self-piercing
- one nut for all sheet thicknesses from 0.75 mm to 2.0 mm
- flush-mounted processing
- very good press-out and torque values
- self-locking thread possible
- corrosion resistant
- no weld spatter on the thread
- no thermal weakening at the fastening position

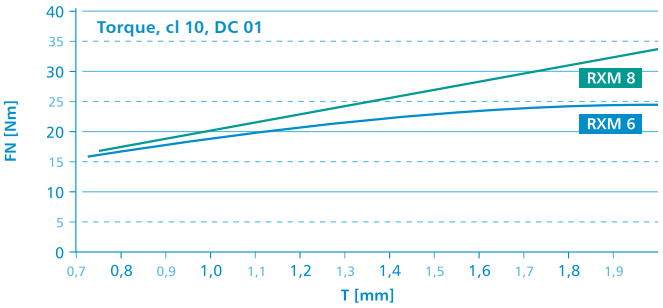


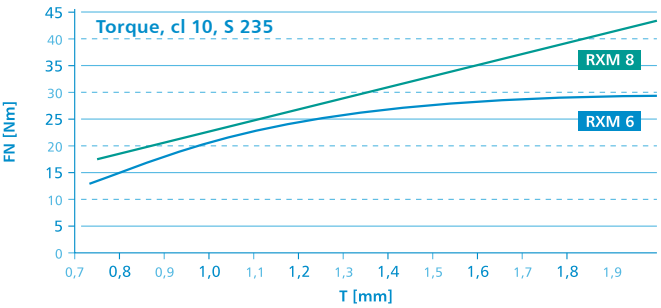
Technical data	
Sheet thickness	0.75 – 2.00 mm
Strength class	10

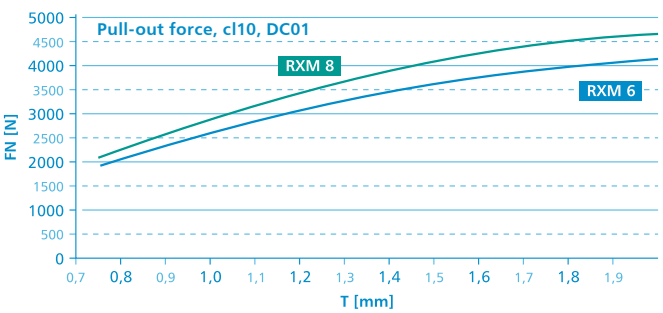
Function sequence

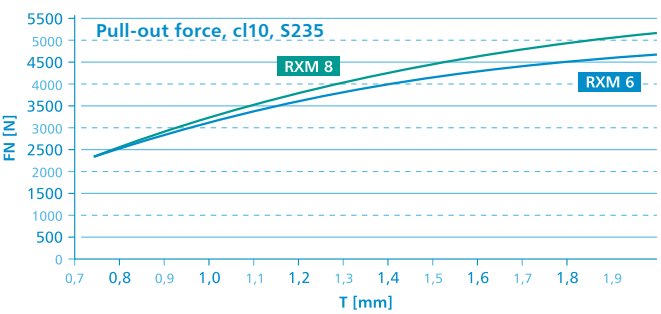


Pull-out and torque values





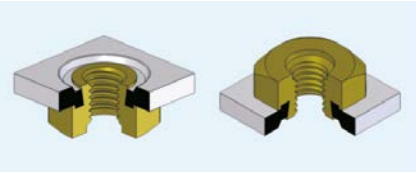




PIAS® HN – pierce-clinch nuts

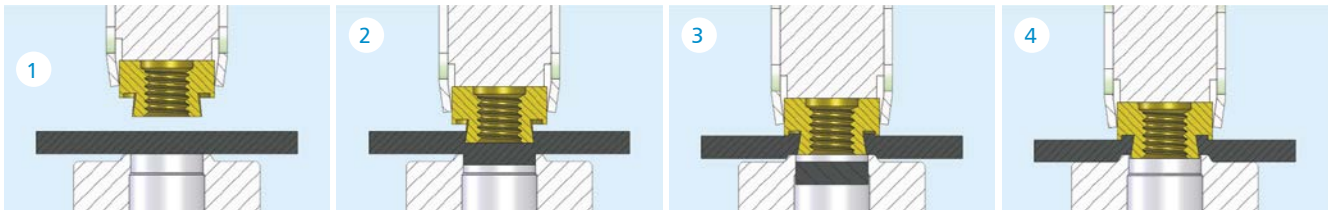
The benefits of PIAS®HN pierce-clinch nuts

- self-piercing up to 4.0 mm.
- high mechanical rigidity
- high torque
- high level of process reliability
- self-locking thread possible

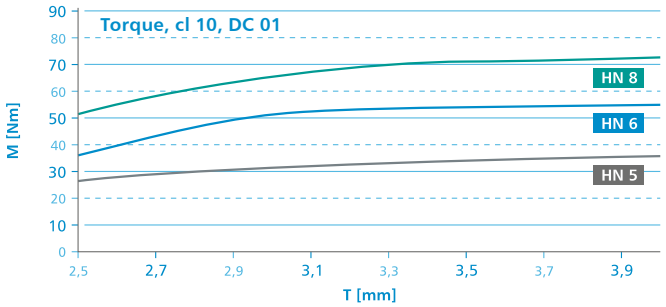


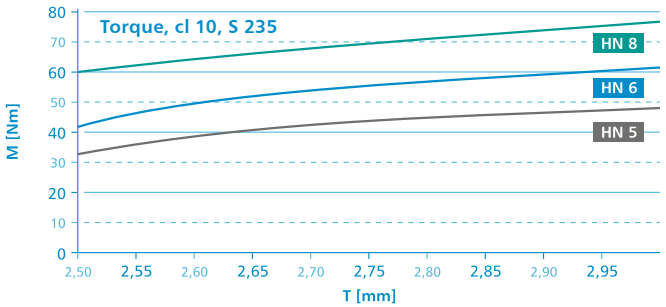
Technical data	
Sheet thickness	2.0 – 4.0 mm
Strength class	10

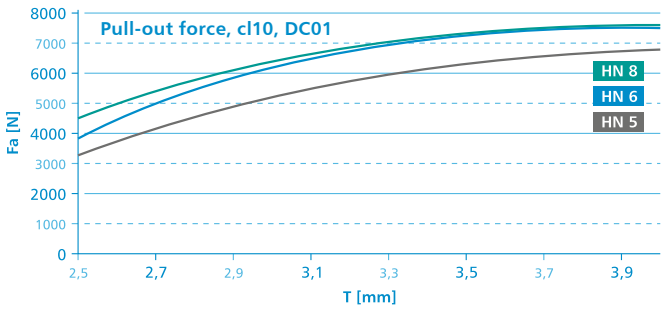
Function sequence

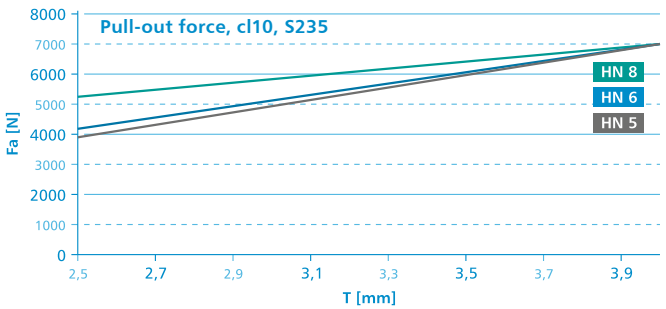


Pull-out and torque values





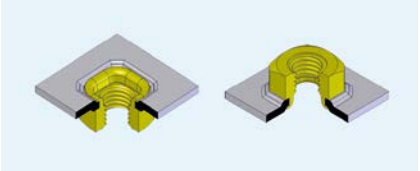




Rivorm® HR rivet nuts

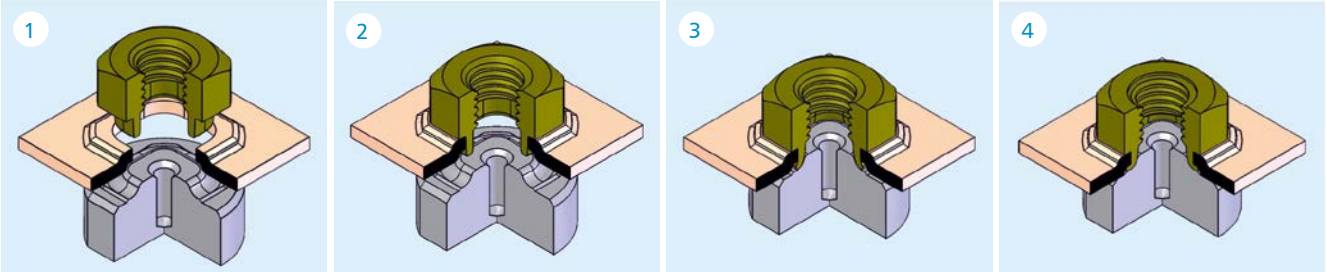
The benefits of the Rivorm® HR rivet nut

- one nut for any sheet thickness up to 4.5 mm
- Cost-saving because fewer variants
- high-strength, press-hardened and hot-stamped steels
- very good torsional strength regardless of metal strength
- high pull-out force
- ARNOLD processing technology for process-reliable and cost-optimized production
- existing ARNOLD processing technology for other nut types can be altered at little cost (and permanently) to convert to HR nuts.
- also available in stainless steel

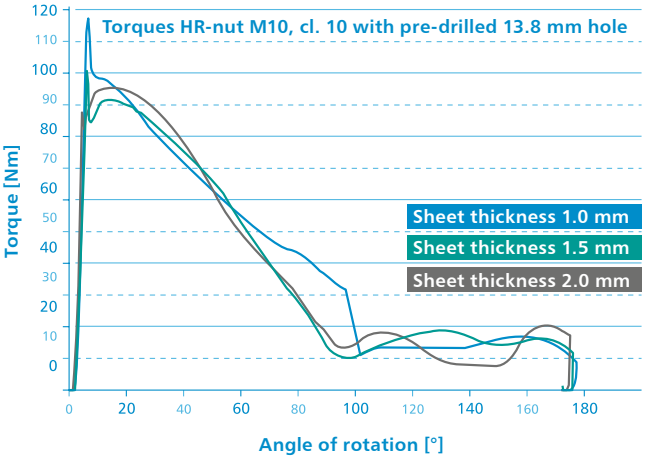


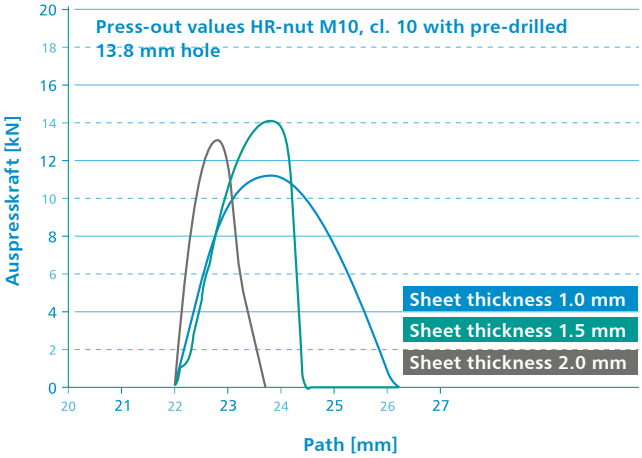
Technical data	
Sheet thickness	0.4 – 3.5 mm (4.5 mm)
Strength class	8 and 10
Surface	as required

Function sequence



Pull-out and torque values (material 22 MnB5, press-hardened 49HRC)

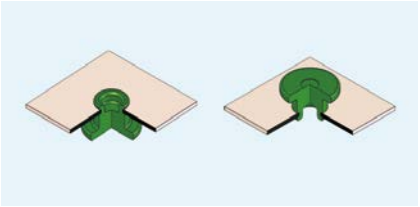




Rivorm® TR rivet

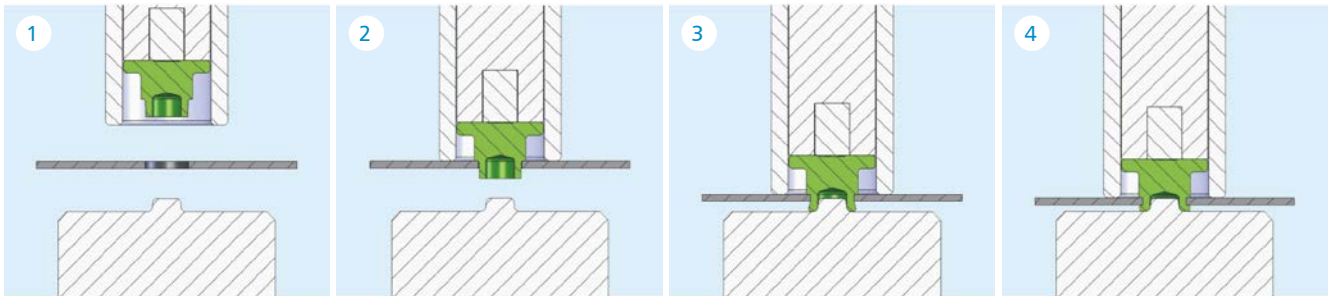
The benefits of the Rivorm® TR rivet

- for fitting ties and springs
- fully automated processing possible in the subsequent composite tool
- can be applied universally for different assembly jobs, such as fastening electrical control units, or other plastic parts, simply by clipping them in
- can be processed in all metal strengths
- Application as positioning and assembly aid

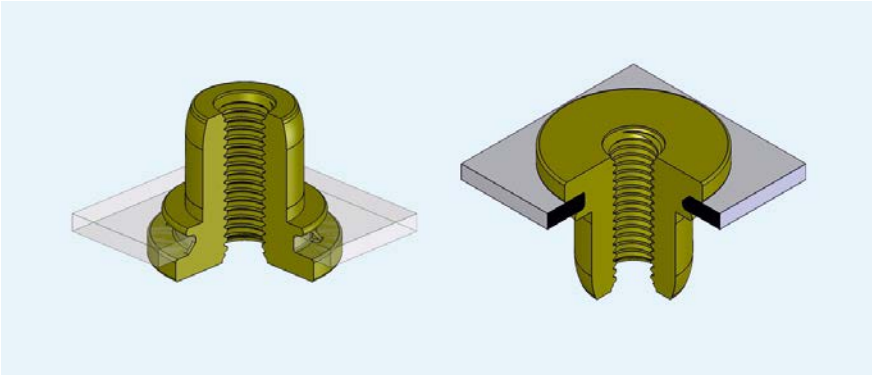


Technical data	
Dimensions	10 x 6 to 16 x 8
Strength class	8
Surface	as required

Function sequence



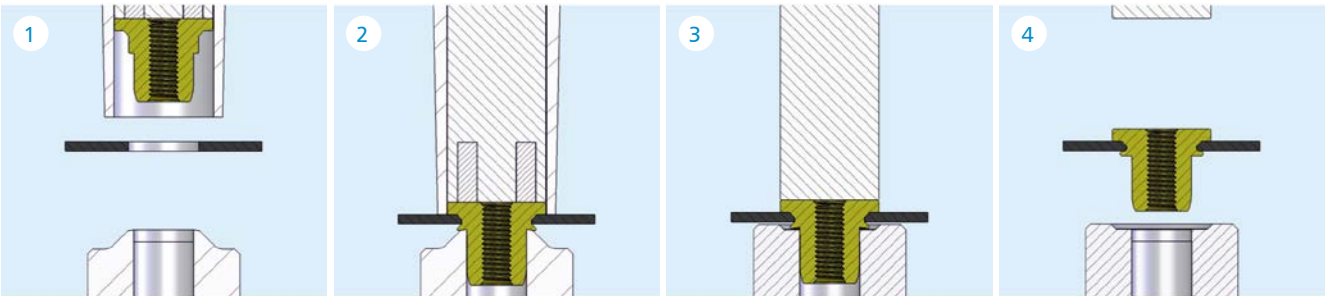
Rivorm® AX rivet



By patenting the innovative fastening method into metals, with the Rivorm® AX rivet, Arnold is providing a further customized fastening solution.

In applications with integral functionality, such as a bearing seating, assembly aid or spacer, the new product line from Dörzbach has already proved itself in several series applications. Depending on the geometrical design of the rivet, the Rivorm® AX rivet is setting new standards of strength between fastener and sheet metal. Moreover, it can be used to fasten a wide range of sheet thicknesses.

Function sequence



How the fastener functions

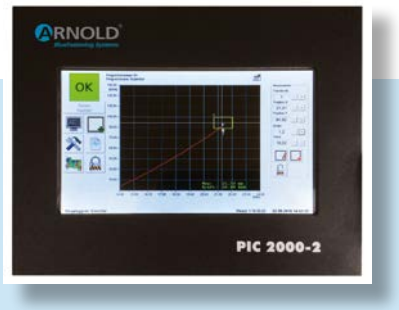
The material is peeled and a collar formed so that a flush and positive fit of the fastener is created with the sheet metal material. This can either transfer very high forces (e.g. AX 20x14) or with a version that is flush with the sheet, the fastener can be used to directly mount connected parts (e.g. AX 16x4). This principle can be applied to almost every material.

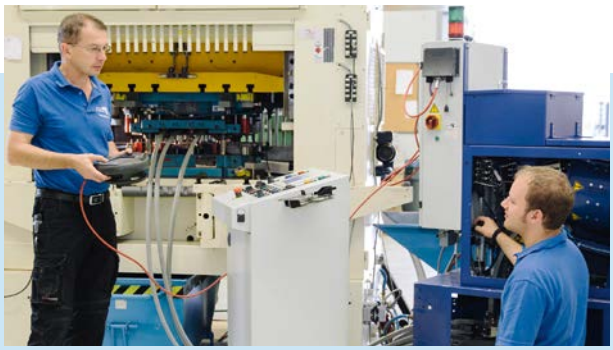
System technology

Our complete solutions for your production processes.

We have been producing complex system technology for more than 20 years. We design the feeder and tooling technology, along with the necessary control systems, custom-tailored to your application.

In the stamping and pressing sector you have standardized tool and feed technologies to make your selection. When integrated into your tools, this system technology provides maximum efficiency and a high level of process reliability. The aim must be, regardless of the pressing system used: ready-to-use components straight from the press.
ARNOLD produces complete system solutions, comprising Tooltec, Feedtec and Controltec, to feed fasteners into the assembly line or the shell body.



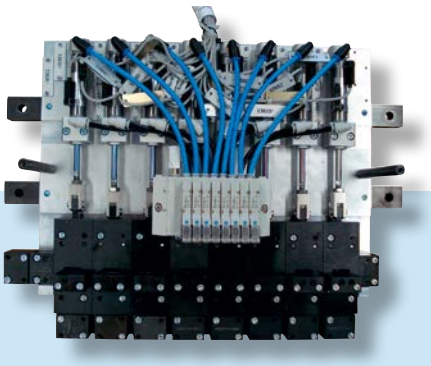


Controltec
Precise monitoring of individual pressing processes

A fastening must reliably maintain its specified properties. Car manufacturers ensure that it does so with high repeat accuracy by making use of self-clinching systems. The accompanying monitoring technology records and monitors the correctness of the required parameters.

Controltec PIC2000, the clinch monitoring system developed by ARNOLD, checks that the specified limiting values - such as insert depth and assembly pressure - are maintained, thus making a valuable contribution to process reliability.

The PIC2000 is distinctive for its ease of operation, flexible analysis and reliable monitoring of the clinching processes.





Tooltec
Optimum tool technology

With Tooltec, ARNOLD is supplying the optimum tool technology for assembling parts. The components we supply are distinctive for the following:

- a high level of process reliability
- low space requirement
- multi-distribution options

Moreover, the systems are low-maintenance, robust and available in modular form. We will be delighted to help you plan complex manufacturing systems, for example to feed pierce-clinch nuts as seen in the example below.





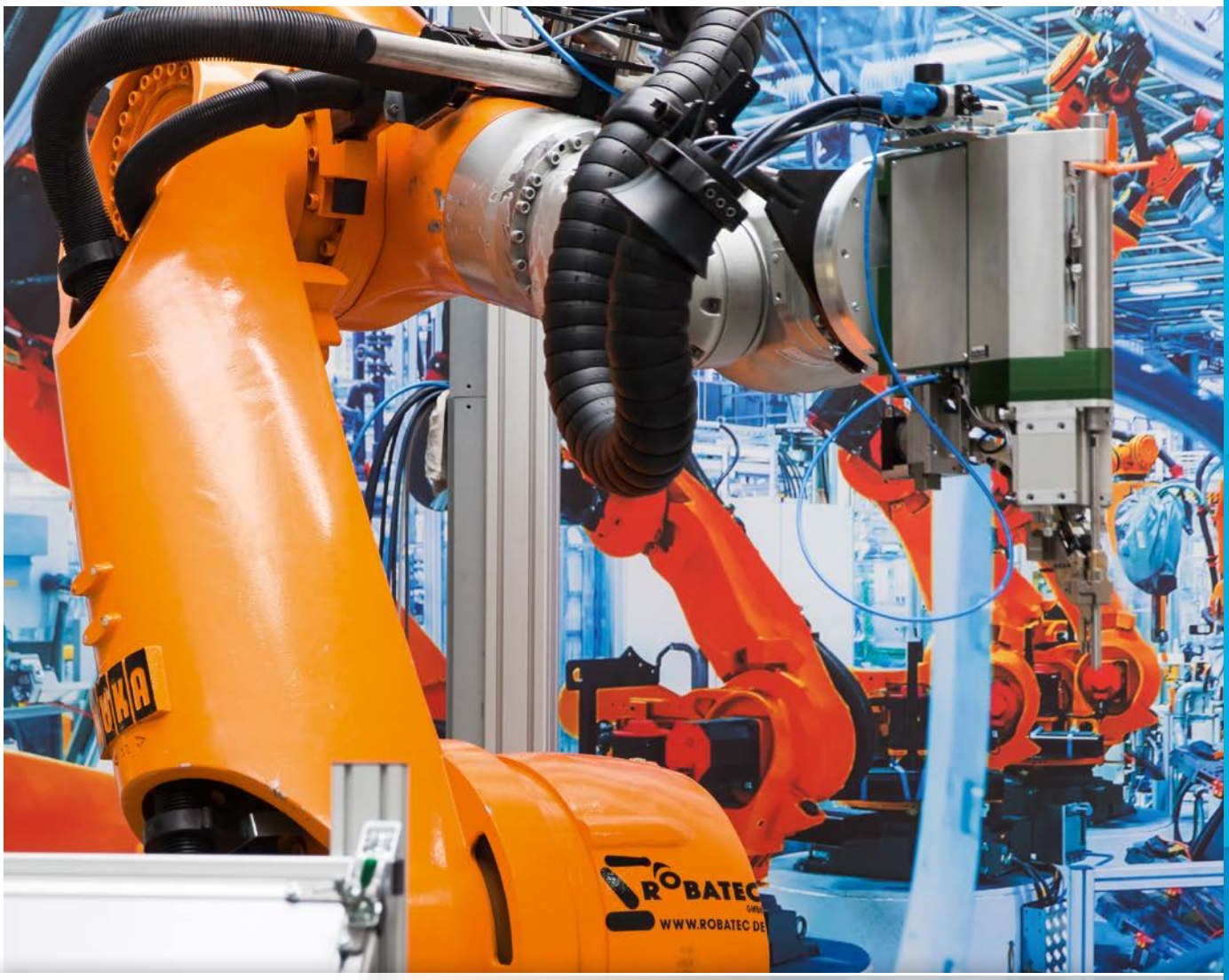
Feedtec
High quality feeder technology and systems

With Feedtec we supply the best possible feeder technology and systems for the machine-aided transportation of your parts to the point of manufacture. We can assist you to the best possible effect with magazine configuration, vibration feeders, drum and segment feeder devices.

Feedtec systems are distinctive for the following:

- their compact construction,
- low wear and
- their high level of process reliability

Moreover, the systems are low-maintenance, robust and available in modular form.



Engineering services

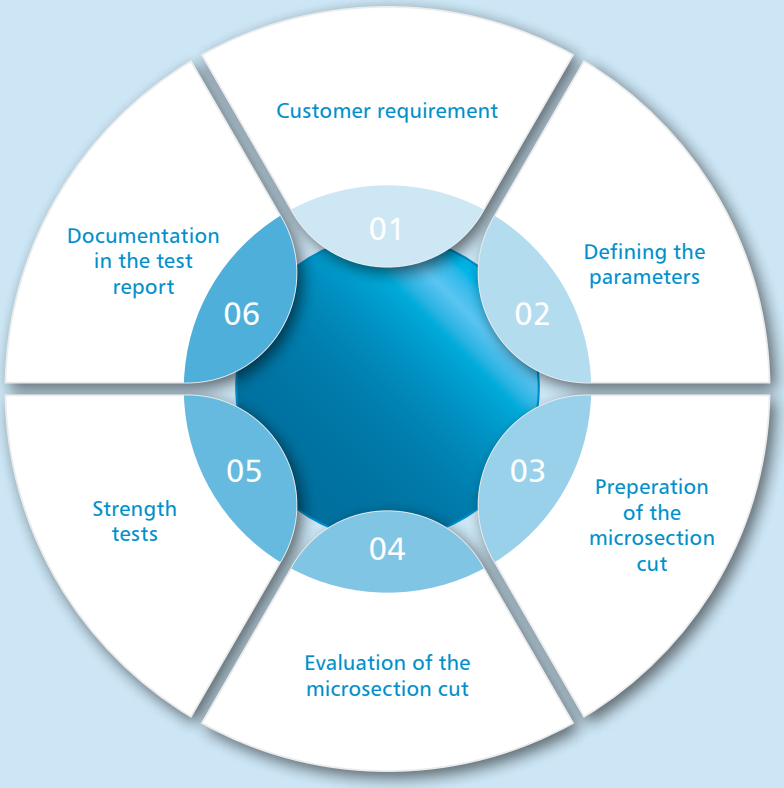
- Laboratory Sheet Metal Applications – joint investigations
- Robtec – automated joining using robot technology
- Assembly – ready-to-assemble plate modules with integrated fastener

- www.arnold-fastening.com



Laboratory Sheet Metal Applications – joint investigations

Several validation steps are required to ensure a reliable series process. This includes a laboratory joinability investigation as well as further joining validations using original components. Then the applications characteristics achieved with the Arnold fasteners are checked for functionality. The investigations illustrated here merely show the preliminary trials under laboratory conditions.



Standardized joint investigation in every ARNOLD Laboratory Sheet Metal Applications center



ARNOLD joint investigation laboratory equipment

Flowhole screwdriving systems for Flowform® and Flowpush® joint investigations

- Speeds: up to 8000 rpm
- Joining forces: up to 3.5 kN
- torques: up to 20 Nm



- Manufacturer: DEPRAG



- Manufacturer: KLINGEL



- Manufacturer: WEBER



High-speed camera

- Frame rate: up to 16,000 Bps
- Storage: 2.6 GB = 4.2 sec recording time
- Application: Recordings used to investigate the exact joining process



Hand-held adhesive gun

- operating temperature: 50 °C to 210°C
- Application: Attach a wide variety of adhesive materials in cartridges to produce hybrid (joined with adhesive) solidity samples or customers' components



Thermal imaging camera

- Temperature ranges: -20 °C to 100 °C / 0 °C to 250 ° / 150 °C to 900 °C
- Application: to record temperature variations at and around the join position during the joining process.



Laboratory drying cabinet

- Temperature range: 50 °C to 330°C
- Application: To harden hybrid (joined with adhesive) solidity samples or customers' components



3D printer

- Print volume:
  145 × 145 × 175 mm
- Application:
  Printing joining elements during the development phase, along with feasible functioning components to develop and enhance processing equipment.



Servo presses

- Max. force: 35 kN
- Application:
  To insert and compress function elements during joint investigations, and to record the process curve.



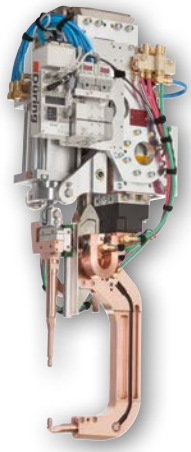
Tensile / compression test machine

- Max. force: 250 kN
- Application: To compress function elements and place tension on solidity samples in joint investigations, and to record the process curve.

Corrosion test chamber

- Corrosion tests to DIN EN ISO 9227:2012
- Application: Corrosion test on individual joining elements and joined samples during joint investigations.





Resistance spot welding gun

- Type: C-frame gun with servomotoric drive
- Electrode force: 6 kN



Wet cutting / grinding machine

- Application: Preperation of the microsection cut



Customer requirement

Collecting information from the checklist

General Information

- Description of project
- Contact details
- Scheduling
- Contact
- Project name

Application

- Clamping part
- Basic drawing
- Part for joining
- Corrosion protection
- Pre-drilling
- Initial application
- Material thickness
- Seal requirement
- Material
- Safety criticality

Fastener

- Dimensions
- Shape of under-head
- Shape of drive
- Quantity required
- Initial sample
- Tensile strength
- Corrosion protection require-ments

Documentation in the test report

Producing the test report

- Selecting the fastener print
- Assembly designation (clamping and joined part)
- Measured value, statistics and screw-in curves
- Micro-sections
- Predictions
- Notes



Documentation

The results of the laboratory test are gathered together into a final document, and then discussed with the user.

Robtec – automated joining using robot technology

Robtec makes it possible to use several different joining technologies and come a step closer to Industry 4.0 and the system concept. It is also helping to better illustrate the series process by producing realistic events, such as system flexibility.

A further application option is the endurance testing facility for development trials and problem analysis. We can feed and fasten several thousand joining elements per feed system fully automatically, with the aim of producing meaningful statistics and establishing possible sources of error.

Scope of services

- Original components can be used
- Can join complex customer-specific components
- Endurance testing
- Close-to-series customer application
- Several joining technologies can be represented
- Module manufacturing
- Test objectives for possible future enhancements

Robot: KUKA KR 360-2F

Working range 1: Door opening: 3.8 m
Working range 2: Door opening: 1.8 m

Flexible tool options, for example for:

- Resistance spot welding guns
- Adhesive applicators
- Flow-hole joining systems
- Semi-hollow punch rivet guns
- C-frame guns (pierce nuts, etc..)

KUKA

Assembly

Ready-to-assemble plate modules with integrated fastener



ARNOLD UMFORMTECHNIK's sheet metal module production with integrated fasteners is often the most economical way to manufacture small and mid-sized series where major investment in tools and processing technology is not feasible, or where, for other reasons, the process cannot be incorporated into the production process - or only in a limited way.

Variants of sheet metal module production



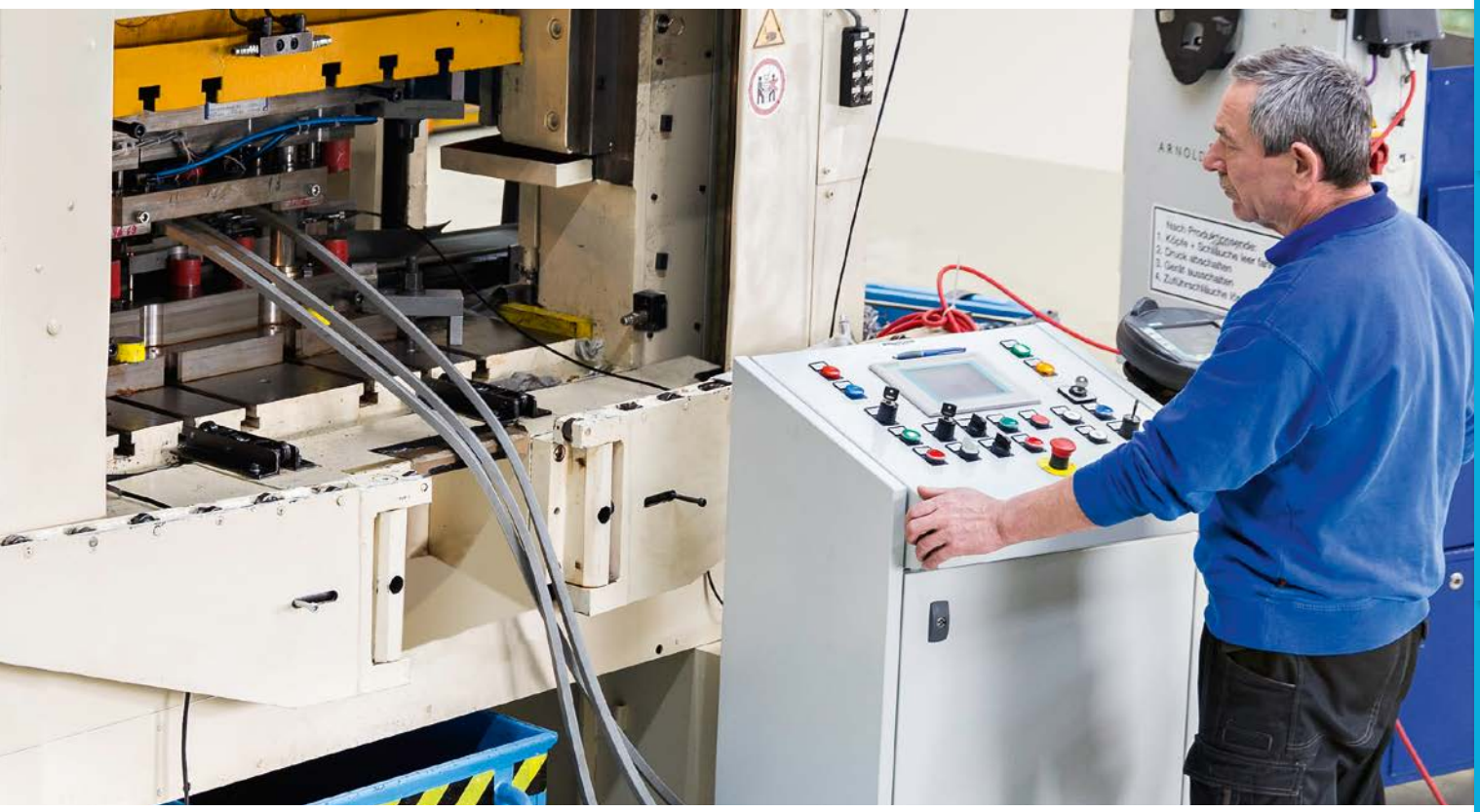
For mid-size and small production runs: processing within the shell

ARNOLD UMFORMTECHNIK has a number of different solutions for processing fasteners on the assembly line. The main component here is on the C-frame press with fully automated feed. Then there are semi-automated solutions or manually operated systems. All the system types are in use in a wide variety of applications.



For large quantities: deployed in the pressing tool

Deployed in a stamping and pressing plant the fastener/tool system can demonstrate its benefits to the full because the fastener insertion process is integrated into the sheet-metal manufacturing process. Processing the fasteners on the tool guarantees that the fastening components will maintain their location tolerances. The fastener is connected to the sheet metal in a single work step. The pressing and stamping process leaves a clean working area. Thus, rapid cycle times are assured, while at the same time the number of work steps can be reduced. A ready-to-assemble sheet-metal component with the required fasteners is the result of the process.



Optimum parts production already chosen by well-known companies

ARNOLD UMFORMTECHNIK's innovative service is distinctive for its high degree of automation and integral process monitoring systems, ensuring optimum and stable parts production. For many years, well-known companies in the automotive, electrical, domestic appliance and furniture industries have placed their confidence in ARNOLD UMFORMTECHNIK's manufacturing expertise.

Press	Pressing force	Equipment
C-frame press	80 kN	For manual insertion
Hydraulic press	200 kN	For manual insertion
Hydraulic press	400 kN	For manual insertion
Differential travel press	800 kN	With conveyor system
Eccentric press	1600 kN	With conveyor system



Sheet-metal part with PIAS® KP 8H pierce-clinch nuts



Sheet-metal part with STRUX® SX M6 self-clinching screws



Sheet-metal part with PIAS® KP 8H pierce-clinch nuts



The ARNOLD GROUP

- Efficient, sustainable and international
- BlueFastening Systems –
  our expertise for innovative markets

- www.arnold-fastening.com



The ARNOLD GROUP

ARNOLD – internationally the name stands for efficient and sustained technology at the highest level. With a foundation of many years of expertise in the production of intelligent fastening systems and very complex extruded parts, over a number of years the ARNOLD GROUP has developed into a comprehensive supplier and development partner for complex fastening systems. With our positioning of "BlueFastening Systems" this development will now continue under a unified and harmonized structure. Engineering, fastenings and functional parts, together with feeder processing systems, all from a single source – efficient, sustained and international.













1898
Established by Louis & Carl Arnold
Production of wooden screws

1945
Production of metal and cutting screws

1970
Licences for trilobular products and TORX screw systems

1994
Acquisition by the Würth Group
ARNOLD & SHINJO established

2002
ARNOLD TECHNIQUE FRANCE S.A. established

2007
ARNOLD FASTENERS SHENYANG established









ARNOLD BlueFastening Systems



2012
ARNOLD FASTENING SYSTEMS established in USA

2014
Fasteneering®: Systematic development of fastening solutions

2015
Systeneering®: Definition of the systematic development of fasteners

2017
Merger of ARNOLD UMFORMTECHNIK with ARNOLD & SHINJO

2021
Sustainability becomes fifth strategic direction

BlueFastening Systems
Our skills and expertise for innovative markets

Engineering
Reliable expertise
at every stage of development



Fasteneering®
Developing the ideal fastener



Systeneering®
Complete systems for perfect production processes

Production
Because engineering needs a strong base



Integrated processes such as toolmaking, heat treatments, and surface finishing, along with a sophisticated quality assurance system, all ensure reliability in all ARNOLD products and services.

System technology
For the entire processing section



Feedtec
Conveyor technology and systems



Tooltec
Tool technology



Controltec®
Control technology

Fasteners
Much more than "just" a screw



Joining metals
TAPTITE 2000®



Joining synthetic materials
REMFORM®



Joining plate metals
RIVTEX® | STRUX®
PIAS® | Rivorm®
Sheetite® | Flowform®
Flowform® Plus
Flexweld®



Lightweight construction
Alufast®
Eco-Sert®



Rapid fastening system
TriPress®



Security lock systems
LocTec® | MAThread®
TORX PLUS® | Threadloc®
ARNOLD® Seal

Functional parts
Complex cold extruded parts for multi-functional applications



Conform®
Precision parts



Conform®
Interlocking parts



Conform®
Hollow parts and nuts



Conform®
Bushes



Conform®
Component assemblies



Conform®
Multi-functional fasteners

Imprint

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The values shown in this brochure are by way of examples. Specific values must always be determined by carrying out trials on original production parts. Our applications laboratory is always happy to answer questions.

ARNOLD®
BlueFastening Systems

www.arnold-fastening.com

The ARNOLD GROUP

Wherever customers need us.

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UMFORMTECHNIK
Ernsbach
Germany



ARNOLD
UMFORMTECHNIK
Forchtenberg
Deutschland



ARNOLD
UMFORMTECHNIK
Dörzbach
Germany



ARNOLD
FASTENING SYSTEMS
Rochester Hills
USA



ARNOLD
FASTENERS SHENYANG
Shenyang
China

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