

Abstract

A clinching tool (20) for producing a load-bearing, supporting or stable connection of a first metal workpiece (11) with a second metal workpiece (12). The clinching tool (20) comprises a die tool (20) and a counter-tool (30) which together form and join, by local plastic reshaping or deformation of the metal workpieces (11, 12), a clinch connection (13) which connects or permanently joins the first metal workpiece (11) and the second metal workpiece (12). The die tool (20) comprises a die having a flank (25) arranged concentrically with respect to the rotational axis (24). The flank (25) has a front end surface (23) perpendicular to the rotational axis (24). The flank (25) is conically shaped at least in the lower transition region (21) to the front end surface (23) and has a flank angle (W, W1, W2) smaller than or equal to 10 degrees, preferably smaller than or equal to 5 degrees.

(Fig. 1)