



Standard Specification for Steel Self-Piercing Tapping Screws for the Application of Gypsum Panel Products or Metal Plaster Bases to Wood Studs or Steel Studs¹

This standard is issued under the fixed designation C 1002; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope *

1.1 This specification covers steel self-piercing tapping screws for use in fastening gypsum panel products and metal plaster bases to cold-formed steel studs less than 0.033 in. (0.84 mm) in thickness and wood members and for fastening gypsum panel products to gypsum board.

1.2 This specification also covers test methods for determining performance requirements and physical properties.

1.3 The values stated in inch-pound units are to be regarded as the standard. The SI (metric) values given in parentheses are approximate and are for information only.

1.4 The following safety hazards caveat pertains only to the test methods described in this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- A 548 Specification for Steel Wire, Carbon, Cold-Heading Quality for Tapping or Sheet Metal Screws²
- C 11 Terminology Relating to Gypsum and Related Building Materials and Products³
- C 36 Specification for Gypsum Wallboard³
- C 645 Specification for Nonstructural Steel Framing Members³
- C 847 Specification for Metal Lath³

3. Terminology

3.1 *Definitions:* For definitions relating to gypsum and related building materials and systems, see Terminology C 11.

3.2 *Definitions of Terms Specific to This Standard:*

¹ This specification is under the jurisdiction of ASTM Committee C11 on Gypsum and Related Building Materials and Systems and is the direct responsibility of Subcommittee C11.02 on Specifications and Test Methods for Accessories and Related Products.

Current edition approved July 10, 2000. Published October 2000. Originally published as C 1002 – 83. Last previous edition C 1002 – 98.

² Discontinued; see 1990 Annual Book of ASTM Standards, Vol 01.03.

³ Annual Book of ASTM Standards, Vol 04.01.

3.2.1 *self-piercing, v*—the ability to penetrate without benefit of a pre-drilled hole with sharp-point angles of not more than 30°.

3.2.2 *spin-out, v*—for a screw, the continued rotation of a screw without further penetration into the substrate.

4. Classification

4.1 Steel screws covered by this specification are of four types of thread configurations:

4.1.1 *Type G*, course-pitch high-thread self-piercing screws for fastening gypsum board to gypsum board.

4.1.2 *Type S*, fine-thread screw for fastening gypsum board to cold formed steel members.

4.1.3 *Type W*, course-thread screw for fastening gypsum board to wood members.

4.1.4 *Type A*, course-pitch tapping screw thread for fastening metal plaster bases to wood or cold-formed steel.

5. Materials

5.1 *Steel Wire*, for manufacturing screws, Specification A 548, Grades 1013 to 1022.

6. Physical Properties

6.1 Hardness:

6.1.1 The surface of Type S, Type W, and Type A screws shall be case hardened to a depth of not less than 0.002 in. (0.05 mm) with case hardness not less than 45 HRC.

6.1.2 The surface of Type G screws is not required to be case hardened.

6.2 *Ductility*—The screws shall have sufficient ductility to be able to withstand a 15° bend without visible signs of fracture when tested as specified in 12.6.6.

7. Performance Requirements

7.1 Type G Screws:

7.1.1 Screws shall be able to self-pierce and drive into gypsum panel products.

7.1.2 Screw threads shall be adequate to pull the head of the screw below the surface of the gypsum panel product when tested as specified in 12.6.2.

7.2 Type S Screws:

7.2.1 *General*—Screws shall be able to self-pierce and drive

*A Summary of Changes section appears at the end of this standard.

into cold-formed steel members in less than 2 s, when tested as specified in 12.6.3.1.

7.2.2 *Screws for Fastening Gypsum Panel Products*—Screw threads shall be adequate to pull the head of the screw below the surface of the gypsum panel product, without spin-out, when tested as specified in 12.6.3.1.

7.3 *Type W Screws:*

7.3.1 *General*—Screw threads shall be able to self-pierce and drive into wood members.

7.3.2 *Screws for Fastening Gypsum Panel Products*—Screw threads shall be adequate to pull the head of the screw below the surface of the gypsum panel product, without spin-out when tested as specified in 12.6.4.1.

7.4 *Type A Screws:*

7.4.1 *General*—Screw shall be able to pierce and drive into wood or cold-formed steel members.

7.4.2 *Screws for Fastening Metal Plaster Bases*—Screw threads shall be adequate to pull a metal plaster base tightly enough against the face of a wood or steel stud, without spin-out, so that when subjected to a steady pull, the plaster base will tear before slipping out from under the screw head, when tested in accordance with 12.6.5.1 or 12.6.5.2.

8. Dimensions and Permissible Variations

8.1 *Head Diameter:*

8.1.1 *General*—Heads shall be permitted to be out of round not more than 0.02 in. (0.51 mm).

8.1.2 *Screws for Fastening Gypsum Board*—Not less than 0.315 in. (8 mm).

8.1.3 *Screws for Fastening Metal Plaster Bases*—Not less than 0.437 in. (11.1 mm).

8.2 *Head Contour:*

8.2.1 *Screws for Fastening Gypsum Panel Products*—The top of the head shall be flat. The outer flange thickness shall be 0.025 ± 0.005 in. (0.64 ± 0.13 mm). The contour beneath the flange head shall be such that the screw head shall be able to be driven so that the head of the screw rests immediately below the surface of the gypsum panel product.

8.2.2 *Screws for Fastening Metal Plaster Bases*—The top of the screw shall be either flat or contoured. The underside of the head shall be flat or near flat. The threads shall extend to the underside of the head.

8.3 *Driving Recess:*

8.3.1 *Screws for Fastening Gypsum Board*—No. 2 “Phillips” design, depth of recess, not less than 0.104 in. (2.64 mm).

8.3.2 *Screws for Fastening Metal Plaster Bases*—No. 2 “Phillips” design, depth of recess, not less than 0.077 in. (1.95 mm).

8.3.3 Determine depth of recess with a Phillips penetration depth gage.

8.3.4 Other types of screw-driving recesses having performance values equal to those of the recesses specified are acceptable.

8.4 *Shank Diameter*—Not less than No. 6, with major diameter not less than 0.136 in. (3.45 mm).

8.5 *Length:*

8.5.1 *Nominal Length*—The nominal length shall be the minimum length.

8.5.2 Type W and Type A screws shall be long enough to

penetrate wood members not less than $\frac{5}{8}$ in. (15.9 mm).

8.6 *Threads*—Either single or multiple thread design.

8.7 *Points*—Self-piercing design.

9. Finish and Appearance

9.1 *Form*—The form shall be straight and neatly formed.

9.2 *Threads*—The threads shall be clean and smooth.

9.3 *Finish*—Screws shall have a corrosion-resistant treatment. The treatment shall not inhibit adhesion to finishing compounds nor bleed through field-applied decoration.

10. Sampling

10.1 Obtain not less than one specimen of each type of screw to be tested from each of five containers, with not less than five screws per 16 000 screws, to constitute a lot for testing.

11. Number of Tests and Retests

11.1 If any of the first lot fails the test, test 25 more screws.

11.2 If two or more screws of the second lot fail the second test, then the represented lot fails to meet the specified requirements.

12. Test Methods

12.1 The following test methods set forth procedures used to determine the ability of the screws to self-pierce through gypsum panel and metal plaster base and into the backup material without spin-out.

12.1.1 The test methods can also be used to determine whether or not alternate screw driving recesses will have performance values equal to those of the “Phillips” recess specified.

12.2 *Significance and Use*—The test methods provide procedures for evaluating the physical properties and performance requirements of steel self-piercing screws. The degree of correlation between these tests and service performance has not been determined.

12.3 *Apparatus:*

12.3.1 *Screw Gun*—Standard manufacture electric screw gun, turning at a minimum of 2500 r/min having a bit suitable for the driving recess of the screw being tested.

12.3.2 *Timing Device*—Standard stopwatch, calibrated in $\frac{1}{10}$ s.

12.3.3 *Vice*—Standard machinists vice, not less than 3 in. (76 mm).

12.3.4 *Clamp*—Locking pliers (“Vice-Grip”), 6 in. (152 mm).

12.4 *Materials:*

12.4.1 *Gypsum Wallboard*—Specification C 36, Type X, $\frac{5}{8}$ in. (16 mm) thick.

12.4.2 *Metal Lath*—As in Specification C 847, diamond mesh, weight 2.5 lb/yd² (1.4 kg/m²).

12.4.3 *Steel Stud*—As in Specification C 645, 0.0179 in. (0.455 mm) thick, hardness not less than 52 HRB, size 3 $\frac{5}{8}$ in. (92.1 mm).

12.4.4 *Wood Stud*—Douglas fir, construction grade, 2 by 4 or 2 by 6, nominal, containing not less than 16 % nor more than 19 % free moisture as determined by a suitable moisture meter.

12.4.5 *Kraft Paper*—0.01 in. (0.25 mm) thick, 2 in. (51 mm) square.