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

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This standard has been approved for use by agencies of the U.S. 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 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:*²

[A548 Specification for Steel Wire, Carbon, Cold-Heading Quality, for Tapping or Sheet Metal Screws \(Withdrawn 1989\)](#)³

[A568/A568M Specification for Steel, Sheet, Carbon, Structural, and High-Strength, Low-Alloy, Hot-Rolled and Cold-Rolled, General Requirements for](#)

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.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

[C11 Terminology Relating to Gypsum and Related Building Materials and Systems](#)

[C645 Specification for Nonstructural Steel Framing Members](#)

[C847 Specification for Metal Lath](#)

[C1396/C1396M Specification for Gypsum Board](#)

3. Terminology

3.1 *Definitions:* For definitions relating to gypsum and related building materials and systems, see Terminology C11.

3.2 *Definitions of Terms Specific to This Standard:*

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°.

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 A548, Grades 1013 to 1022 for Type G and Type W screws.

5.2 *Steel Wire*, for manufacturing screws, Specification A568/A568M, Grades 1018 to 1022 for Type S and Type A screws.

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.

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

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 10° bend without visible signs of fracture when tested as specified in 12.6.7.

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 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.

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 12.6.6.

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 12.6.4 or 12.6.5.

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 gauge.

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 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 90 screws from not less than five containers.

11. Number of Tests and Retests

11.1 Test a minimum of five screws for each test. If any of the first lot fails, test 25 more screws.

11.2 If two or more 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 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 Shall Satisfy the Following:*