

**भारतीय मानक**  
**Indian Standard**

**IS 18507 : 2024**

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## ड्राईवॉल स्क्रू — विशिष्टि

## Drywall Screws — Specification

ICS 21.060.10

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**February 2024**

**Price Group 6**

General Engineering and Fasteners Standards Sectional Committee, PGD 37

## FOREWORD

This Indian Standard was adopted by the Bureau of Indian Standards, after the draft finalized by the General Engineering and Fasteners Standards Sectional Committee had been approved by the Production and General Engineering Division Council.

This standard specifies the characteristics and performance of drywall screws intended to be used for the fixing of gypsum plasterboards, gypsum boards with fibrous reinforcements, for fastening application in furniture industry etc. One of the most significant benefits of drywall screws is their strength and durability. Unlike traditional nails, drywall screws have a higher tensile strength, which makes them less likely to break or snap. Additionally, they have a greater holding power, ensuring that your drywall stays firmly in place.

In the preparation of this standard, assistance has been taken from DIN 18182-2 : 2019 ‘Accessories for use with gypsum plasterboards — Part 2: Dry wall screws, staples and nails’.

The composition of the Committee responsible for the formulation of this standard is given in [Annex B](#).

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 ‘Rules for rounding off numerical values (*second revision*)’. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

## Indian Standard

# DRYWALL SCREWS — SPECIFICATION

### 1 SCOPE

This standard specifies the characteristics of cross recessed bugle head/trumpet head drywall screws for thread diameter from 3.5 mm to 5.5 mm.

### 2 REFERENCES

The standards listed in [Annex A](#) contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on the standard are encouraged to investigate the possibility of applying the most recent editions of these standards.

### 3 SYMBOLS

For the purpose of this standard, the symbols given in IS 8535 shall apply.

### 4 DIMENSIONS

The dimensions of drywall screws shall be as given in [Fig. 1](#), [Fig. 2](#), [Table 1](#) and [Table 2](#).

### 5 REQUIREMENTS

The various requirements of drywall screws shall be as given in [Table 3](#).

### 6 TORQUE TESTING

Drywall screws shall conform to the minimum breaking torque requirements as mentioned in [Table 4](#) when tested in accordance with IS 1367 (Part 20).

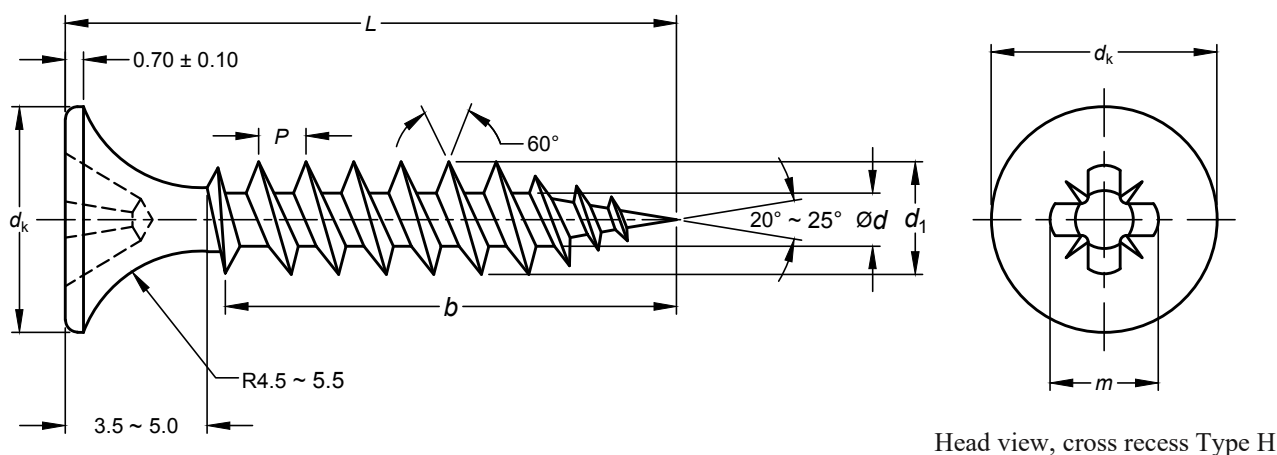


FIG.1 TRUMPET HEAD DRYWALL SCREW WITH POINTED END

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**Table 1 Dimensions**

(Clause 4)

All dimension in mm.

| SI No. | Type                                            | Thread Type<br>(see Fig. 2) | Diameter         |     |     |                   |      | Pitch |           | Head Diameter |      | Screw length   |       |       | Thread Length | Tip Length <sup>1)</sup> |  |  |  |
|--------|-------------------------------------------------|-----------------------------|------------------|-----|-----|-------------------|------|-------|-----------|---------------|------|----------------|-------|-------|---------------|--------------------------|--|--|--|
|        |                                                 |                             | Outside Diameter |     |     | Internal Diameter |      |       |           |               |      |                |       |       |               |                          |  |  |  |
|        |                                                 |                             | $d_1$            |     |     | $d$               |      | $P$   |           | $d_k$         |      | $l$            |       |       | $b$           |                          |  |  |  |
|        |                                                 |                             | Nominal          | Max | Min | Max               | Min  | Nom   | Tolerance | Max           | Min  | Nominal Length | Max   | Min   | Min           | Max                      |  |  |  |
| (1)    | (2)                                             | (3)                         | (4)              | (5) | (6) | (7)               | (8)  | (9)   | (10)      | (11)          | (12) | (13)           | (14)  | (15)  | (16)          | (17)                     |  |  |  |
| i)     | Trumpet Head with pointed screw<br>(see Fig. 1) | Single start/double start   | 3.5              | 3.7 | 3.4 | 2.45              | 2.25 | 2.80  | ± 0.28    | 8.5           | 7.9  | 13             | 13.5  | 12.2  | 8.70          | 9                        |  |  |  |
|        |                                                 |                             | 4.2              | 4.2 | 3.9 | 2.95              | 2.75 | 3.20  | ± 0.32    |               |      | 19             | 19.5  | 18.1  | 12.70         |                          |  |  |  |
|        |                                                 |                             | 4.8              | 4.8 | 4.5 | 3.25              | 3.05 | 3.20  | ± 0.32    |               |      | 25             | 26.1  | 24    | 16.70         |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 32             | 33.1  | 30.5  | 21.35         |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 38             | 39.3  | 36.5  | 25.35         |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 50             | 51.3  | 48.5  | 33.35         |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 60             | 62.5  | 58    | 40            |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 75             | 77    | 73    | 50            |                          |  |  |  |
|        |                                                 | Single start/double start   | 5.5              | 5.5 | 5.2 | 3.75              | 3.45 | 3.50  | ± 0.35    |               |      | 32             | 33.5  | 30.5  | 21.5          |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 38             | 39.5  | 36.5  | 25.5          |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 50             | 51.5  | 48    | 33.5          |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 70             | 71.5  | 68.5  | 45            |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 80             | 81.5  | 78.5  |               |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 90             | 91.8  | 88.5  |               |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 100            | 101   | 98.5  |               |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 110            | 111.8 | 108.3 |               |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 120            | 121.8 | 118.3 |               |                          |  |  |  |
|        |                                                 |                             |                  |     |     |                   |      |       |           |               |      | 130            | 132.8 | 128.0 |               |                          |  |  |  |

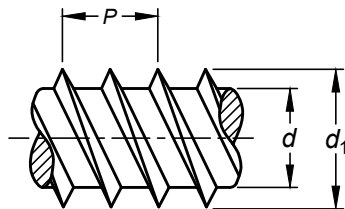
<sup>1)</sup>It is the distance from the threaded portion of the screw where the outside diameter/internal diameter of the screw starts reducing to the pointed tip of the screw.

**Table 2 Dimensions of Cross Recess**

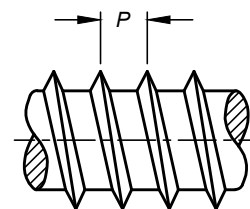
([Clause 4](#))

All dimensions in mm.

| Sl No. | Outside Diameter |        |                   | 3.5        | 4.2     | 4.8     | 5.5     |         |
|--------|------------------|--------|-------------------|------------|---------|---------|---------|---------|
| (1)    | (2)              |        |                   | (3)        | (4)     | (5)     | (6)     |         |
| i)     | Cross recess No. |        |                   | 2          | 2       | 2       | 2       |         |
| ii)    | Cross recess     | Type H | <i>m</i>          |            | 4.7 - 5 | 4.7 - 5 | 4.7 - 5 | 4.7 - 5 |
|        |                  |        | Penetration depth | <i>Min</i> | 2.59    | 2.59    | 2.59    | 2.59    |
|        |                  |        |                   | <i>Max</i> | 3.10    | 3.10    | 3.10    | 3.10    |



a) Thread type, double start



b) Thread type, single start

Key

$P$  Pitch  
 $d_1$  Outer diameter  
 $d$  Core diameter

FIG. 2 TYPES OF THREADS

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**Table 3 Requirements**

([Clause 5](#))

| Sl No. | Material                                    |               | Steel                                                                                                                                                                                                                                                                                        | Stainless Steel                                               | Non-ferrous Metal                                                                                  |
|--------|---------------------------------------------|---------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------|----------------------------------------------------------------------------------------------------|
| (1)    | (2)                                         |               | (3)                                                                                                                                                                                                                                                                                          | (4)                                                           | (5)                                                                                                |
| i)     | General Requirements                        |               | IS 1367 (Part 1)                                                                                                                                                                                                                                                                             |                                                               |                                                                                                    |
| ii)    | Cross recess                                |               | Type H in accordance with IS 7478                                                                                                                                                                                                                                                            |                                                               |                                                                                                    |
| iii)   | Material                                    |               | Grade 7M or 8M conforming to IS 7887                                                                                                                                                                                                                                                         | Grades A2, A3, A4 or A5 conforming to IS 1367 (Part 14/Sec 4) | Brass <sup>1)</sup>                                                                                |
| iv)    | Tolerances, shape and positional tolerances | Product grade | Confirming to IS 1367 (Part 2) <sup>2)</sup>                                                                                                                                                                                                                                                 |                                                               |                                                                                                    |
| v)     | Surface Coating                             |               | As processed (no coating)<br><br>Electroplating shall be done in accordance with IS 1367 (Part 11)<br><br>Phosphating shall be done in accordance with IS 1367 (Part 12)<br><br>Additional requirements or other finishes or coatings shall be agreed between the supplier and the purchaser | Clean and bright and/or passivated                            | As processed (no coating)<br><br>Electroplating shall be done in accordance with IS 1367 (Part 11) |
| vi)    | Surface condition                           |               | The limits of surface defects shall be in accordance with IS 1367 (Part 9/Sec 1)                                                                                                                                                                                                             |                                                               |                                                                                                    |
| vii)   | Acceptance test                             |               | Requirements of IS 1367 (Part 17) shall apply to the acceptance test                                                                                                                                                                                                                         |                                                               |                                                                                                    |

<sup>1)</sup>The specific grade of material shall be in agreement between the manufacturer and the purchaser.

<sup>2)</sup>IS 1367 (Part 2) currently only applies to screws with metric ISO threads and self-tapping screws. The permissible deviations and tolerances for shape and position for these screws are to be adopted for drywall screws unless they are specified in this standard.

**Table 4 Breaking Torque Requirements**

([Clause 6](#))

| Sl No. | Thread Size | Torque (N/m)<br><i>Min</i> |
|--------|-------------|----------------------------|
| (1)    | (2)         | (3)                        |
| i)     | 2           | 1.2                        |
| ii)    | 2.5         | 1.8                        |
| iii)   | 3           | 2.2                        |
| iv)    | 3.5         | 2.8                        |
| v)     | 4           | 3.2                        |
| vi)    | 4.5         | 4.3                        |
| vii)   | 5           | 5.8                        |
| viii)  | 5.5         | 7.8                        |

## 7 HARDNESS

**7.1** Drywall screws shall have surface hardness of 550 HV 0.3 to 800 HV 0.3 when tested in accordance with IS 1501 (Part 1). The total case depth for various diameter shall be as mentioned in the table below:

| Sl No. | Diameter          | Total Case Depth<br>mm |
|--------|-------------------|------------------------|
| (1)    | (2)               | (3)                    |
| i)     | $d \leq 3.5$      | 0.1 to 0.18            |
| ii)    | $3.5 < d \leq 5$  | 0.1 to 0.23            |
| iii)   | $5 \leq d \leq 6$ | 0.14 to 0.30           |

**7.2** Drywall screws shall have core hardness of 300 HV 0.1 to 450 HV 0.1 when tested in accordance with IS 1501 (Part 1).

## 8 DESIGNATION

The drywall screws shall be designated with the IS No. of this standard, the nominal outside thread diameter  $d_1$ , the nominal length  $L$  and the material (grade of steel/SS or brass).

*Example:*

Designation of a drywall screw with a nominal outside thread diameter of 4.2 mm, nominal length 60 mm and made up of stainless steel (Grade A4) shall be designated as:

Drywall screw: IS 18507 — 4.2 × 60 — SS(A4)

## 9 MARKING

**9.1** Each package shall be legibly marked with the following information:

- Designation and type of coating;
- Manufacturer's name, initials or trade-mark; and
- Month and year of manufacture or batch/lot number.

### 9.2 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder and the product(s) may be marked with the Standard Mark.

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## ANNEX A

### (Clause 2)

#### LIST OF REFERRED STANDARDS

| IS No.                                      | Title                                                                                                          | IS No.                                        | Title                                                                                                                                                                                                       |
|---------------------------------------------|----------------------------------------------------------------------------------------------------------------|-----------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| IS 1367                                     | Technical supply conditions for threaded steel fasteners:                                                      | (Part 17) : 2023/<br>ISO 3269 : 2019          | Inspections sampling and acceptance procedure ( <i>fifth revision</i> )                                                                                                                                     |
| (Part 1) : 2014/<br>ISO 8992 : 2005         | General requirements for bolts, screws, studs and nuts ( <i>fourth revision</i> )                              | (Part 20) : 1996/<br>ISO 898-7 : 1992         | Industrial fasteners — Threaded steel fasteners — Technical supply conditions — Mechanical properties: Part 20 Torsional test and minimum torques for bolts and screws with nominal diameters 1 mm to 10 mm |
| (Part 2) : 2002/<br>ISO 4759-1 : 2000       | Tolerances for fasteners — Bolts, screws, studs and nuts — Product grades A, B and C ( <i>third revision</i> ) | IS 1501 (Part 1) : 2020/<br>ISO 6507-1 : 2018 | Metallic materials — Vickers hardness test: Part 1 Test method ( <i>fifth revision</i> )                                                                                                                    |
| (Part 9/Sec 1) :<br>1993/ISO 6157-1 :1988   | Surface discontinuities, Section 1 Bolts, screws and studs for general applications ( <i>third revision</i> )  | IS 7478 : 2011/ISO 4757 : 1983                | Cross recesses for screws ( <i>second revision</i> )                                                                                                                                                        |
| (Part 11) : 2020/<br>ISO 4042 : 2018        | Electroplated coating systems ( <i>fourth revision</i> )                                                       | IS 7887 : 1992                                | Mild steel wire rod for general engineering purposes — Specification ( <i>first revision</i> )                                                                                                              |
| (Part 12) : 1981                            | Phosphate coatings on threaded fasteners ( <i>second revision</i> )                                            | IS 8535 : 2020/<br>ISO 1891 : 2009            | Fasteners — Terminology ( <i>second revision</i> )                                                                                                                                                          |
| (Part 14/Sec 4) :<br>2023/ISO 3506-4 : 2009 | Mechanical properties of corrosion-resistant stainless-steel fasteners, Section 4 Tapping screws               |                                               |                                                                                                                                                                                                             |

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## ANNEX B

### (Foreword)

## COMMITTEE COMPOSITION

General Engineering and Fasteners Standards Sectional Committee, PGD 37

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## Amendments Issued Since Publication

| Amend No. | Date of Issue | Text Affected |
|-----------|---------------|---------------|
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|           |               |               |
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