



PTI-CRT20 G1-1120: MANUAL FOR CERTIFICATION OF PLANTS PRODUCING UNBONDED SINGLE STRAND TENDONS

Renewal of Emergency Addendum #2 December-2020: Valid until recalled by

CRT-20 This Addendum supersedes Addendum #1 March-2020

Introduction

In response to continued COVID-19 safety concerns, the UTPC program is moving to temporary Virtual Inspections until travel restrictions are safely lifted. PTI's Unbonded Tendon Plant Certification inspections will be conducted virtually via GoToMeeting.

It is essential that plants notify PTI in case they are closed or not producing.

Confidentiality

Confidentiality will be maintained by the inspection staff as outlined in the revised Confidentiality Agreement (attached).

Personnel and Internet Requirements

The inspector must be able to review the documentation and the physical plant on the GoToMeeting. As the plant sees appropriate, one or more individuals may facilitate the inspection (for example, the office manager provides all access to paper and / or electronic documentation from the plant office or from home and the plant manager provides access through a phone camera to plant information such as the coil tags and other items stored in the plant).

Plants to provide a contact for a management-level person who could be contacted in addition to the primary plant contact.

PTI will provide instruction on how to prepare devices for the GoToMeeting and how to log in.

Documentation Inspection

- Computer with internet connection for inspection of program documentation via GoToMeeting (free app will need to be downloaded in advance of inspection).

Plant Inspection

- Mobile device (cell phone, or tablet) with internet connection and web cam for plant inspection via GoToMeeting (free app will need to be downloaded in advance of inspection).



PTI-CRT20 G1-1119: MANUAL FOR CERTIFICATION OF PLANTS PRODUCING UNBONDED SINGLE STRAND TENDONS

Emergency Addendum #2 April-2020: Valid until recalled by CRT-20

This Addendum supersedes Addendum #1 March-2020

Inspection timing

Virtual inspections will be scheduled one day in advance. The day before the inspection, with a 24-hour notice, the inspector will send an email with the new Confidentiality Agreement and call the primary plant contact to announce the inspection for the following day. If the plant contact does not answer, a voicemail message will also be sent.

If there is no response from the plant acknowledging the Virtual Inspection within 24 hours of the initial contact, the management-level person will be contacted.

If there is no response within a second 24 hours from the plant or the management-level person, the plant certification will fail the inspection according to Section 5.2.3.

Inspection Items Excluded

Due to restraints of the virtual inspection, the following grading items in Sections 2.3.2 and 2.4.3 will not be evaluated during a virtual inspection. These grading items will be automatically given a score of 100%. All other requirements, including the internal plant logs for these two items are still required.

2.3.2 PT Coating Material Quantity

Inspection Verification of PT Coating Quantities

The Inspection Agency shall perform a dimensional check of samples of coated strand at the production site for compliance with the applicable PTI specification; PTI M10.2-17, Section 2.2.3 or PTI M10.6-15, Section 2.4.3.

The inside diameter of the sheathing shall comply with the applicable PTI specification; PTI M10.2-17, Section 2.3.3 or PTI M10.6-15, Section 2.3.2.2.

If tendons are fabricated using strand coated with less than the required quantities of PT coating according to M10.2-17, Section 2.2.3 or M10.6-15, Section 2.4.3, the plant will fail the inspection.

Label and segregate coated strand exhibiting insufficient PT Coating application and deemed unacceptable until final disposition is determined.

Questions	Weight (out of 1000 pts)	IA	IB	IC	IIA	IIB	IIC	III
Is the measured sheathing inside diameter a minimum .030" greater than strand diameter?	3.46	✓	✓	✓	✓	✓	✓	✓
Compare calculated capacity of sample to reported application, Comply?	3.46	✓	✓	✓	✓	✓	✓	✓
Is the volumetric capacity of PT Coating of either of the two initial samples less than 95% of required quantity of PT coating? (a) If no, the grade score is 100. (b) If either of the volumes on the two initial samples falls below 95% of the requirement, the grade score is 80 (c) If both of the volumes on the two initial samples fall below 95% of the requirement, then two additional random samples are taken. If both additional samples have volumes 95% or higher than the requirement, the grade score is 70. (d) If either of the additional samples have volumes less than 95% of the requirement, the grade score is 0.	65.63	✓	✓	✓	✓	✓	✓	✓

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Inspection Items Excluded (cont.)

2.4.3 Sheathing Material Thickness Quality

Maintain calibration records for a minimum of three years.

b) Sheathing Thickness Measurement

Provide minimum thickness sheathing complying with the applicable PTI specification; PTI M10.2-17, Section 2.3.2 or PTI M10.6-15, Section 2.3.2.1.

Sheathing thickness measurements of two samples from each type of strand extrusion (strand diameter and sheathing thickness) are to be taken as follows:

- (a) Measure a sheathing sample of sufficient length length-wise to allow caliper to fully engage the thin edge of the caliper jaws.
- (b) Apply sufficient pressure to the caliper to insure a true reading.
- (c) Locate thinnest point, mark and take measurement.
- (d) Take measurements at four equidistant locations around the circumference of the sheathing sample.
- (e) Take measurements by holding the caliper perpendicular to the sheathing sample.
- (f) Calculate the average thickness for each sample and compare with the specified sheathing thickness.

Due to the fabrication process, slight variations in sheathing thickness may occur around the circumference of the sheathing sample. Local reductions in sheathing thickness of up to 10% are acceptable provided an average of four equidistant readings along the circumference equals or exceeds the required thickness.

If the average thickness of each initial sample for each type of strand extrusion sampled falls below standard, check two additional samples taken at random

locations a minimum of 100 ft away from the initial sample location following item (d) above.

If either additional random sample fails the average thickness requirement, the plant will fail the inspection.

If any of the thickness measurements in the two initial samples or the two additional random samples (if required) fall below the 10% allowed variation, the plant fails the inspection

Questions	Weight (out of 1000 pts)	IA	IB	IC	IIA	IIB	IIC	III
b) Sheathing Thickness Measurement								
Does the strand move easily through a three-foot sheathing sample without having to spiral through the sheathing?	3.46	✓	✓	✓		✓	✓	✓
Does the minimum thickness meet or exceed the thickness listed on the coil tag?								
Is any individual thickness measurement below specified (including tolerances)?								
(a) If all individual thickness measurements on the two initial samples meet minimum thickness requirements, the grade score is 100.								
(b) If either of the average thickness measurements on the two initial samples falls below specified thickness, the grade score is 80.								
(c) If both initial samples fail the average thickness requirements then two additional random samples are taken and if both additional random samples meet average requirements, the grade score is 70.	65.63	✓	✓	✓	✓	✓	✓	✓
(d) If either additional random sample fails the average thickness requirement, the grade score is 0.								
(e) If any of the individual thickness measurements in the two initial samples or the two additional random samples (if required) fall below the 10% allowed variation, the grade score is 0.								

Confidentiality Agreement

CONFIDENTIALITY AGREEMENT for PTI Inspectors and Auditors

This agreement, dated as of this _____ day of _____, 20_____, by and between “Inspection Agency or Auditor” and _____ (“Participant”).

Whereas, during the course of the Post-Tensioning Institute’s (“PTI”) inspection program for Certification of Plants Producing Unbonded Single Strand Tendons (“Certification Inspection”) the Inspection Agency , and in some instances, PTI’s or ANSI auditors review Participant’s compliance with the PTI program for Certification of Plants Producing Unbonded Single Strand Tendons;

Whereas, such review of compliance requires Inspection Agency/Auditors to examine and review files, data, documents and other materials of Participant which are, in Participant’s sole judgment, confidential and proprietary or trade secret information (“Information”);

Whereas, the certification program requires execution of an agreement between PTI and Participant which prohibits revelation of any data or grading with respect to any plant visited during a Certification Inspection; and

Whereas, the parties desire to clarify their rights and obligations respecting Information;

Now therefore, in consideration of the mutual promises set forth below and other good and valuable consideration, the receipt and sufficiency of which are hereby acknowledged, the parties agree as follows:

1. The Inspection Agency/Auditors shall not copy, electronically capture screen or photo images, record video, or remove from Participant’s premises any Information examined or otherwise revealed to it during a Certification Inspection without the express written permission of Participant.
2. The Inspection Agency/Auditors agrees not to reveal for any purpose, or use, for purposes other than the Certification Inspection, at any time, any and all Information examined or otherwise revealed to it during a Certification Inspection without the express written permission of Participant.
3. The term “Information” shall not include general knowledge of materials, processes, data, or information which comes into the public domain not due to the fault of the Inspection Agency/Auditors.
4. Any amendment or waiver of the terms of this Agreement shall be made only in writing executed by the parties. Any waiver of the terms of this Agreement shall not act as a subsequent waiver of the same or similar terms. Any disputes arising under this Agreement shall be governed by the laws of the State of _____.

In witness whereof, the parties have executed this agreement as of the date set forth above.

Inspection Agency/Auditors

Participant