

1050511 Industry Review Comments and Responses

Jennifer Taylor

COMMENTS:

The only comment I have is more of a question and is as follows. In the case of Durastress, QC inspectors all have. PCI- 1 & 2 and the 450 spec cert. Plus ACI level 1 & CTQP Concrete Field Inspector Level 1. They will be doing all of the inspection for the pole bed department (Incidental Precast). Will these Certs serve for doing inspection for the pole department?

RESPONSE: Yes, the proposed Subarticle 105-5.11.2.1 requires CTQP Concrete Field Testing Technician Level I, which in the above example Durastress Inspectors are considered to be qualified to do Incidental Precast Concrete.

ACTION: No change is needed.

Mike Bergin

COMMENTS:

1. 105-5.11, the word "Pipe" should be after Fiber Reinforced Concrete

RESPONSE: We will modify the proposed specification as suggested.

2. 105-5.11.1.4.1, The ACI, Strength Testing Technician should be adequate to perform compressive strength testing on cylinders. The Lab Level I would be needed if the technician planned to go on to be a certified Lab Level II technician.

RESPONSE: We will modify the proposed specification as suggested.

Doug Holdener
Rinker Materials

COMMENTS:

105-5.11.1 Apparent Interchangeable Use of Terms “Personnel” and “Inspector”

The title of this paragraph refers to “personnel.” However, the sub-paragraphs within this section refer to “inspectors.” According to Section 1 (Definitions and Terms), “Inspectors” are agents of the “Engineer,” which in turn is defined as “State Construction Engineer.” It is our understanding that these QC training requirements apply to plant personnel, and FDOT inspectors are also expected to participate in the training at the State’s expense. Please verify the intended audience of the proposed specification.

RESPONSE: The proposed Subarticle 105-5.11.1 is for quality control inspectors, which are plant personnel. The inspectors can be classified as quality control and quality assurance inspectors. The Department accepts the results of the quality control testing and inspections, when their results are verified with the results of the testing and inspections of quality assurance inspectors. Therefore, the words “quality control inspectors” meet the aforementioned definition.

The requirements for the Department Quality Assurance Inspectors are depicted in the proposed Volume I (sections 6.2 and 6.3) of the Materials Manual, which are currently under the review and approval process.

ACTION: No change is needed.

105-5.11.1.1 Training Requirements for Flexible Pipe Quality Control Inspectors

COMMENTS:

Why is the requirement for flexible pipe QC inspectors only 8 hours, while the requirement for rigid pipe (concrete) inspectors is longer (12 hours)? That the concrete industry requirement exceeds the flexible industry by 50 percent seems inequitable.

We are concerned that greater depth of QC and inspection will be imposed on rigid pipe, while many important aspects of flexible pipe manufacturing and testing will get less attention than necessary. By requiring the lower training requirement, is the Department implying that (a) their inspectors do not need as much knowledge about flexible pipe production, (b) not as much QC is needed for flexible pipe, and (c) there are fewer variables in the manufacturing that affect the quality of the final product?

RESPONSE: The durations of the courses for concrete pipe are similar to the currently available training programs of national certification agencies, such as National Precast Concrete Association. The manufacture of flexible pipe begins with the use of pre-processed, certified materials, as opposed to concrete pipe where the manufacturing process requires blending of raw materials. Using pre-processed materials eliminates the need for numerous production and quality control steps, hence the shorter course duration. If experience dictates, course duration requirements will be adjusted.

ACTION: No change is needed.

105-5.11.1.4.1 Additional Requirements for Testing Personnel and Batch Plant Operator

COMMENTS:

Why does the Department find it necessary to have requirements for testing staff and oversight of batching operations at concrete product facilities *yet have no parallel requirement for plastics or other flexible product facilities?*

RESPONSE: It is necessary that the concrete batch plant operators know the basics of the mix adjustments and proportioning. During the batching of the other products, similar types of adjustment are not needed. The manufacture of flexible pipe begins with the use of pre-processed, certified materials, as opposed to concrete pipe where the manufacturing process requires blending of raw materials. Oversight at flexible pipe plants is comparable to that at concrete pipe plants. The requirements of Materials Manual Chaps. 6.1 and 6.2 for flexible pipe and concrete pipe, respectively, parallel one another in breadth and scope.

ACTION: No change is needed.

COMMENT:

The batching of concrete for concrete pipe production is akin to the blending of HDPE resins and other additives for extrusion and molding operations at an HDPE facility. Is it the Department's position that there are no variables in these HDPE production processes that affect finished product quality?

RESPONSE: Yes, there are variables. But, the variables are not similar to those of concrete materials ingredients. Blending of HDPE resins is a simple process that is controlled volumetrically by the manufacturing equipment.

ACTION: No change is needed.

If flexible pipe "batch operator" QC training is not required, then what level of quality control is there for such operations as material distribution, extrusion rates, temperature and cooling rates, pressure, and other processes?

RESPONSE: The QC training requirements cover these topics for flexible pipe. All aspects of manufacturing and quality control are included in the training requirements.

ACTION: No change is needed.

Closing

We appreciate the opportunity to participate in this industry review. Please feel free to contact us if you have any questions or comments.

RESPONSE: Thanks for the comments..

ACTION: No change is needed.