

1050302 CONTRACTOR QUALITY CONTROL GENERAL REQUIREMENTS –
COMPLIANCE WITH THE MATERIALS MANUAL – SECTION 6.1-60112.
COMMENTS FROM INTERNAL/INDUSTRY REVIEW

Bert Woerner
386-943-5351
bert.woerner@dot.state.fl.us

Comments: (1-8-13)

District 5 has reviewed the subject industry review and would like to submit the following comments:

1. The titles of the office and the position (District Materials Office and District Materials and Research Engineer) should be consistent.

Response: Agree.
Changes made.

2. 6.1.6.2 seems to refer to an onsite Quality Control Manager, but in section 6.1.7.2 it states that the QC manager can serve in more than one facility, thereby making the manager off site in any other facilities, while onsite in one. Suggest that the QC manager in 6.1.6.2 be removed to a separate sentence to help indicate that they may not be always on site.

Response: QC manager can designate technician to perform QC function. SMO will call meeting with districts to identify if this needs to be clarified.
No changes made.

3. 6.1.7.2 (14) calls for hydrostatic testing on a periodic basis, but the period is not defined. Also pipe joints covered in 943 are corrugated steel, does this method effectively translate to PVC, HDPE, PP, and aluminum pipe; and does it waive the requirement of 7.3 and 7.4 for the plastic pipes for which ASTM D 3212 was written?

Response: Periodic performance of hydrostatic test has proven to be ineffective if pipe profile design remains unchanged. In addition, hydrostatic tests are expensive so periodic testing is opposed by industry. Test does apply to all flexible pipe. D3212 is for plastic pipe and there is no language anywhere that waives any section. Language will be reviewed and all possible ambiguities removed.
No changes made.

4. 6.1.9.1: are these companies supposed to be Bureau of Weights and Measures certified like the scale companies in Materials Manual 9.2 Volume II 9.2.6.5.1?

Response: Not necessarily. Company's calibration devices or equipment must be NIST traceable if such program is available for the specific variable in question. If no such program exists, then the Department can accept other means acceptable.

5. 6.1.9.2: Random checks in addition to the quality control plan defined checks will be hard to enforce. A manufacture could argue a random check is done once a year while the periodic checks per the quality control plan and 20% measurements of final product are done in accordance with the plan. Suggest removing random check recording requirements.

Response: Agree. Text related to random checks will be deleted.
Changes made.

6. Can the production rate requirement in 6.1.10.3 be added to the quality control plan checklist in Materials Manual 5.6?

Response: Yes.

7. 6.1.11.6 dimensional checks of corrugations are not done on all types of pipe covered by this chapter, this second sentence makes it difficult to understand this is not a requirement of all the pipe types, where as length and diameter are. Suggest moving corrugation to another sentence further in the paragraph where discussion of different requirements for different pipe are made.

Response: SMO will call meeting with districts to discuss best way to address this comment.
No changes made at this time.

8. 6.1.11.7 is an awkward set of references. First we go to ASTM 3212 which is over ridden in parts by a suggestion of 5 psi, with performance requirements in 449 which send us to either to Materials Manual 6.2 or ASTM C 443. This leave the pressure used somewhere in the range of 5, 10.8, or 13 psi with test lengths of 10 minutes to 24 hours. And again from 6.1.7.1, 14 the test itself has been modified by Specification 943. A definitive pressure and applicable methods would be better suited to ease of understanding and fulfillment of intent possibly in a Florida Method or unaltered ASTM.

Response: Agreed. Multiple possibilities for confusion exist and all will be addressed soon.
Drainage office is working on defining water tight to be 10.8 psi. This item needs to be addressed when the requirement is changed.
No change made at this time.

9. 6.1.12: the measurement and recording of 20% of a finished lot can be a huge number of pipes, even a single size run over a week could produce 500-600 pipes and 20% of that is 120 pipes. Broken down to 20% a day, per shift would be approximately 8 pipes (in a plant running 6 days in 3 shifts) but it would no longer be randomly selected. There has also been arguments made that all the pipe in a production run (defined as a LOT by FDOT) is built to stock specifications and may not be used for FDOT projects. Suggest 5% of a LOT for recorded inspection.

Response: Agree. Will change 20% to 5%.
Change made.

10. 6.1.14: There is a spelling error in General Manager. "Manger"

Response: Spelling error will be corrected.
Change made.

11. 6.1.17.1 thru 6.1.17.4: There are currently no approved training courses for flexible pipe, not have there been any listed in several years. The requirements of these sections are next to

impossible to enforce as they are written. Other than approving or developing a training course, no suggestion.

Response: These sections refer to training produced by the manufacturer since there are no agencies offering such training like there is for concrete pipe. This is not training offered by FDOT. FDOT reviews and approves training submitted by pipe manufacturer.
No changes made.
