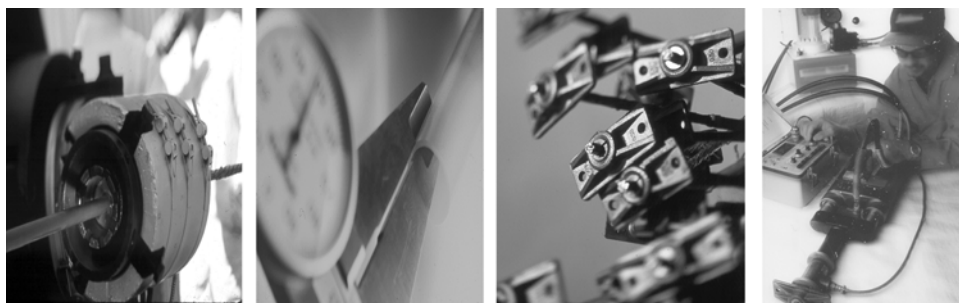


MANUAL FOR CERTIFICATION OF PLANTS PRODUCING UNBONDED SINGLE STRAND TENDONS

Fifth Edition



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INSTITUTE

CERTIFIED PLANT

MANUAL FOR CERTIFICATION OF PLANTS PRODUCING UNBONDED SINGLE STRAND TENDONS

Fifth Edition

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TABLE OF CONTENTS

1.0	INTRODUCTION	1
1.1	Scope and Purpose	1
1.2	Limitations	1
2.0	PTI CERTIFICATION PROGRAM CRITERIA	1
2.1	General	1
2.2	Prestressing Steel	2
2.2.1	Storage and Inspection of Strand	2
2.2.2	Acceptance Criteria	2
2.2.3	Records	2
2.3	Anchorage and Couplers	2
2.3.1	Test Reports	2
2.3.2	Water tightness	2
2.3.3	Records	3
2.4	Sheathing	3
2.4.1	Dimensional Requirements	3
2.4.2	Acceptance Requirements	3
2.4.3	Records	3
2.5	P-T Coating	3
2.5.1	Coating Material Quantity	3
2.5.2	Quality and Compatibility	3
2.5.3	Records	3
2.6	Fabricating Process	3
2.6.1	Sheathing	3
2.6.2	Fixed-End Anchorage	3
2.6.3	Gauges	4
2.6.4	Records	4
2.7	Storage and Shipping	4
2.7.1	Storage	4
2.7.2	Packaging	4
2.7.3	Marking	4
2.8	Record Keeping	4
2.8.1	File Organization	4
2.8.2	Records	4
2.9	Stressing Equipment	5
2.9.1	Gauges and Jacks	5
2.9.2	Facilities	5

2.9.3	Calibration Records	5
2.10	Quality Control Program	5
3.0	PTI CERTIFICATION PROGRAM ADMINISTRATION	5
3.1	Certifying Agencies	5
3.2	Inspections, Grading and Notification of Inspection Results	6
3.2.1	Certification	6
3.2.2	Re-Inspection	6
3.2.3	Inactive Status	7
3.3	Appeal Procedure	7
3.3.1	Appeal Board	7
3.3.2	Decision of Board	7
3.3.3	Cost of Appeal	7
3.4	Renewal of PTI Certification	7
3.5	Grievance Procedure	8
3.5.1	Procedure for Complaints	8
3.6	List of PTI Certified Plants	8
3.7	Fees	8
3.8	Changes to the <i>Manual for Certification of Plants Producing Unbonded Single Strand Tendons</i>	8
3.9	Application for PTI Certification	8
APPENDIX A – GUIDELINES FOR GRADING PLANTS PRODUCING UNBONDED SINGLE STRAND TENDONS		10
APPENDIX B – PLANT INSPECTION CHECKLIST		11
APPENDIX C - INFORMATION REQUIRED FOR PTI STATIC & DYNAMIC TESTS		17
APPENDIX D - RECOMMENDED PROCEDURE FOR WATER TIGHTNESS TEST		18
APPENDIX E – PTI PLANT CERTIFICATION CONTRACT DOCUMENTS		20
APPENDIX F – CONFIDENTIALITY AGREEMENT		23
APPENDIX G – APPLICATION FOR RENEWAL OF PTI PLANT CERTIFICATION		24

APPENDIX H – PTI ZONE MAP

26

APPENDIX I – SAMPLE GUIDE SPECIFICATION

27

MANUAL FOR CERTIFICATION OF PLANTS PRODUCING UNBONDED SINGLE STRAND TENDONS

1.0 INTRODUCTION

1.1 Scope and Purpose

The Post-Tensioning Institute (PTI) program for Certification of Plants Producing Unbonded Single Strand Tendons has been developed to provide independent certification of a plant's fabrication capability to produce unbonded single strand tendons. This certification program also includes evaluation of calibration practices for jacks and gauges used for stressing single strand tendons.

The program is applicable to Fixed and Mobile Fabricating Facilities. A Mobile Fabricating Facility is defined as a mobile facility that routinely cuts unbonded tendons to length and/or has the ability to apply a fixed end anchor. Mobile Fabricating Facilities shall not include those that fabricate materials pertaining to incidental field adjustments, replacement materials, and materials for repairs, supplied by a fixed PTI plant.

The certification of a plant under this program indicates the plant and personnel are capable of producing unbonded single strand tendons in conformance with the Post-Tensioning Institute *Specification for Unbonded Single Strand Tendons*, September, 2000, or as later amended, or as specified in contract document(s) for specific project(s).

1.2 Limitations

The certification program extends only to the fabrication procedures and materials within the examined plant, and is expressly not intended to cover procedures or events subsequent to shipment of tendons to the job site. Furthermore, while it is intended that the inspections reflect the quality of routine tendon production for a plant, the PTI certification program is expressly not intended for use in certifying the quality of particular tendons supplied by a plant or their suitability for use on any particular project. PTI does not approve, endorse, or guarantee any product or construction, or in any way make any warranty regarding products or construction design or methodology, including warranties of quality, workmanship or safety, express or implied, further including, but not limited to, implied warranties of merchantability and fitness for a particular purpose. THE POST-TENSIONING INSTITUTE SHALL NOT BE LIABLE FOR ANY DAMAGES, INCLUDING CONSEQUENTIAL DAMAGES. Acceptance of tendons as fabricated for specific projects remains the responsibility of the owner's designated representative.

The certification program is limited as stated herein and does not relate to a number of aspects of a post-tensioned project. For example, a post-tensioned project requires sound design and construction practices, the details of which may vary with the application.

Post-tensioning materials must also be installed, stressed, and finished properly (see Part 3 of the PTI *Specification for Unbonded Single Strand Tendons*). Any errors or omissions in design or construction utilizing unbonded tendons or its installation, stressing, or finishing are the responsibility of either the Engineer of Record or the General Contractor, and shall not in any way be considered to be delegated to, or made the responsibility of, PTI, the PTI certification Program, the Certifying Agencies, or any of their officers, agents or employees.

2.0 PTI CERTIFICATION PROGRAM CRITERIA

2.1 General

The PTI Certification Program is based on a review of materials, test data, and fabrication procedures during the two plant inspections by a Certifying Agency each year the plant is involved in the program. During the first year there will be one in-depth announced inspection and one unannounced inspection. During the second and following years, two unannounced inspections will be made of each plant. Certifying Agencies are selected from firms with in-depth experience in the post-tensioning industry.

Inspections by a Certifying Agency shall include detailed review of records, test data, fabrication procedures, materials, equipment and quality control program as outlined in Sections 2.2 through 2.10, inclusive.

The PTI Certification Program assigns responsibility for the quality of the final tendon assemblies to the PTI Certified Plant. This applies whether the Plant utilizes in-house or outside facilities to coat and sheath the strand.

Plants utilizing coated strand received from outside facilities are responsible for the final condition and quality of the coated strand and its components. Plants must provide documentation for all components of coated strand according to Sections 2.2, 2.4, 2.5, and 2.7 as follows:

(a) Strand coated by parent company owned facility: Certified Plant is required to maintain on-site traceable records of the strand producer, P-T coating supplier, and plastic (resin) manufacturer according to Sections 2.2, 2.4, 2.5, and 2.7. Technical certifications for individual components may be kept on file at the coating facility but should be kept readily available with the ability to provide the documentation in a timely manner.

(b) Strand coated by other third party source: Certified Plant is required to maintain on-site traceable records of the strand producer, P-T coating supplier, and plastic (resin) manufacturer according to Sections 2.2, 2.4, 2.5, and 2.7 as well as technical certifications for all components used.

2.2 Prestressing Steel

2.2.1 Storage and Inspection of Strand

- (a) Strand packs shall be stored in a manner to maintain the protection provided by the strand supplier. Strand in storage shall be inspected prior to extrusion. Records of the results of inspections are to be maintained. The presence of any corrosion shall be rated according to the guidelines in Section 2.2.3 and recorded in the extruder log.
- (b) Strand in storage shall be readily identifiable by size, grade, type, strength and manufacturer.

2.2.2 Acceptance Criteria

Corrosion present on the bare strand shall be rated according to the rating criteria listed below. Physically damaged strand shall be rejected on arrival, or have damaged sections removed prior to processing.

Strand used for tendon manufacture shall be of grade A, B, or C only. Strand graded D, E, or F does not meet the requirements of ASTM A416 and shall NOT be used.

Grade A:	No visible rust.
Grade B:	Light surface rust, which can be removed by vigorous rubbing with a cloth. No pitting noticeable to the naked eye, although the steel surface may be discolored in the affected area.
Grade C:	Surface rust, which when removed with a fine steel wool pad, leaves small pits on the steel surface of not more than 0.002 inch (50 micro-m) diameter or length.
Grade D:	Same as Grade C, except pits exceed 0.002 inch (50 micro-m) diameter or length (can be felt with the fingernail).
Grade E:	Large oxidized areas, with flakes developing in the corrosion affected zones, loss of steel section noticeable to the naked eye.
Grade F:	Heavy oxidation on most or all of the exposed surface areas, with strong flaking and pit formations.

2.2.3 Records

Records shall be available for strand in accordance with PTI *Specifications for Unbonded Single Strand Tendons*, (Section 1.5.1). Records for sheathed strands are to be maintained starting with the fabrication process to permit identification of strand supplier and coil (pack) number.

2.3 Anchorages and Couplers

2.3.1 Test Reports

Test reports with specific descriptive component information from an independent testing laboratory shall be made available to the Certifying Agency demonstrating that assembled tendons with production anchors and corresponding wedges incorporated in the test comply with the PTI *Specifications for Unbonded Single Strand Tendons*. Identifiable numbered, dated and revised drawings and specifications for components used in the tests shall be included in the test reports. Similar data shall be provided for couplers. Component parts from different manufacturers should never be mixed without similar test data. Attachment of loose, non-referenced documents will not be acceptable.

2.3.2 Water tightness

For tendons used in aggressive environments, test reports from an independent testing laboratory shall be made available to the Certifying Agency to demonstrate compliance with the water tightness requirement of PTI *Specification for Unbonded Single Strand Tendons* Section 2.2.6 (also see Appendix D). Identifiable numbered,

dated and revised drawings and specifications for waterproofing components used in the test shall be included in, or shall be referenced by, the test reports.

2.3.3 Records

Records shall be available for anchors, wedges and couplers, including each manufacturer's Certificate of Compliance with *PTI Specification for Unbonded Single Strand Tendons*, Section 2.2, providing the following information:

- (a) Source, lot numbers (date codes) and Certification of Materials for anchors.
- (b) Source, lot numbers and Certification of Materials (including heat treatment) for wedges.
- (c) Source, lot numbers and Certification of Materials for couplers.

2.4 Sheathing

2.4.1 Dimensional Requirements

Sheathing thickness and inside diameter is to comply with *PTI Specification for Unbonded Single Strand Tendons* (Section 2.3.2) or as specified in contract documents for specific project(s). When properly fabricated, the strand should be easily pushed by hand through the sheath in a 3-ft. long sample. No rifling is to be visible on the surface of the sheath.

2.4.2 Acceptance Requirements

Sheathing shall meet the minimum specified thickness of *PTI Specification for Unbonded Single Strand Tendons* (Section 2.3.2) or as specified in contract documents for specific project(s), and shall be free of pinholes or other defects which may adversely affect the water tightness of the sheathing.

2.4.3 Records

Records shall include source, lot material number and suppliers' certification of sheathing complying to *PTI Specification for Unbonded Single Strand Tendons*, Section 2.3.

2.5 P-T Coating

2.5.1 Coating Material Quantity

The coating shall extend over the entire tendon length. Visual inspection of a 3-ft. long piece of coated and sheathed strand shall demonstrate that the amount of P-T coating material used is sufficient to ensure complete filling of the annular space between the strand and the sheathing.

Records of coating material consumption shall be maintained to document compliance with *PTI's Specification for Unbonded Single Strand Tendons* (Section 2.4.3).

A written procedure for logical means of determining quantity of coating material applied to strand shall be provided.

2.5.2 Quality and Compatibility

The coating materials used by the plant shall comply with *PTI Specification for Unbonded Single Strand Tendons* (Section 2.4 and Table 1).

2.5.3 Records

Records shall include source, batch number (or equivalent identification) and Manufacturer's Certificate of Compliance for the corrosion inhibiting coating. See *PTI Specification for Unbonded Single Strand Tendons* (Section 1.5.4 and 2.4).

2.6 Fabricating Process

2.6.1 Sheathing

Tendons shall be fabricated without damage to the sheathing from either machine operation or handling process.

2.6.2 Fixed-End Anchorage

Fixed-end anchorage shall be attached to the tendons in accordance with *PTI Specification for Unbonded Single Strand Tendons* (Sections 3.2.4.1 & 3.2.4.2). Wedges shall be seated evenly at the correct force.

2.6.3 Gauges

Gauges and hydraulic cylinder(s) used in the fixed-end anchorage application process shall be calibrated at no more than six month intervals. Gauges shall have a dial face of no less than 3 ½ inches diameter and shall be visible to the operator. The maximum stressing pressure for intended use shall be printed on the face of the gauge or easily read digital readouts.

2.6.4 Records

Records following the tendon fabrication process shall permit identification of individual tendons or tendon groups as cut from coated and sheathed reels in accordance with Section 2.2.2 of this manual. Records shall also provide positive traceability of anchorage components.

2.7 Storage and Shipping

2.7.1 Storage

Bulk sheathed strand, anchorage components, and fabricated tendons shall not be stored in areas subject to water accumulation. For storage periods exceeding two weeks, materials shall be protected from the sun, weather or other corrosive effects. Sheathed strand, including bulk packs and fabricated tendons, shall be stored in a manner to prevent damage to the sheathing, p-t coating, and prestressing steel.

2.7.2 Packaging

Sheathed strand and tendon bundle packaging shall prevent damage to the material during loading, transport and unloading at the job site. Banding with steel bands is permissible as long as the tension in the bands does not damage the sheathing. Buffer material shall be placed between steel bands and strand coils. Fixed-end and intermediate anchorages shall be positioned in a manner to prevent sheathing damage in bundles of fabricated tendons.

Handling of material bundles, including loading and unloading, shall be done using loading bar, protected forks, or nylon slings. Steel cables (choker) or chains shall not be used.

Prior to transport, the tendons or tendon bundles shall be secured to avoid shifting or other movements in transit, which may damage the sheathing.

2.7.3 Marking

Tendons or tendon bundles shall be marked in a weatherproof and durable manner to permit easy identification of their intended location in the structure, as detailed on the post-tensioning installation drawings.

Each shipment of fabricated material shall display at least one PTI Certified Plant tag that describes the proper handling and storage of the material, and identifies the material as coming from a PTI Certified Plant. This requirement may be waived for local shipments of residential slab on ground projects.

Tags shall NOT be affixed to tendons not manufactured to minimum PTI Specification requirements.

2.8 Record Keeping

2.8.1 File Organization

Files shall be sufficiently well organized and maintained so the data normally reviewed during inspection can easily be retrieved. A formal file guide outlining the location of documents to be reviewed during inspections shall be maintained. It is the responsibility of the contact personnel at the participating plant to notify the Certifying Agency in advance when key plant personnel may be absent for extended periods of time, such as vacations, holidays, in-house training, etc.

2.8.2 Records

A system of record keeping shall be maintained at the fabricating plant, which will permit traceability of material used on a specific project. These records shall be kept for a minimum of three (3) years, unless a longer period is otherwise stated in the project specifications. These records shall include the following:

- (a) Traceability of prestressing steel, according to Section 2.2.3 of this manual.
- (b) Traceability of anchors, wedges and couplers, according to Section 2.3.3 of this manual
- (c) Traceability of sheathing material, according to Section 2.4.3 of this manual.
- (d) Traceability of P-T coating, according to Section 2.5.3 of this manual.

Permanent tendon system records shall be maintained at the fabricating plant, for a minimum period of three (3) years, unless a longer period is otherwise stated in the project specifications, which will include the following:

- (a) Tendon component part drawings showing dimensions, tolerances, material specifications and special fabrication processes where required.
- (b) Tendon test reports on production component specimens demonstrating compliance with PTI *Specification for Unbonded Single Strand Tendons* (Sections 2.2, 2.3, 2.4, and 2.5).

2.8.3 Mobile Plant Minimum Documentation Requirements

The minimum documentation required with the mobile fabricating facility is 1). Mill certificates, 2). Extrusion Documents, 3). PT Coating Certificates, 4). Plastic certificates, 5). Wedge and Anchor Certificates, 6). Fixed – End Applicator Certification and supporting documentation for the material present. -Note: The other PTI required documentation may be stored in another location. Logistically if all documentation could not be inspected within the normal inspection time period, then additional charges would apply.

2.9 Stressing Equipment

2.9.1 Gauges and Jacks

Gauges used in the post-tensioning stressing operation and on fixed-end applicators shall have a dial face of not less than 3 ½ inches diameter. The maximum stressing pressure for intended use shall be clearly identified on the face of the gauge or easily read digital readouts.

Gauges may be re-calibrated against a master gauge traceable to known standard, provided that the jack has also been calibrated against the same master gauge. Such calibration shall be over the full pressure range of the gauge being calibrated.

2.9.2 Facilities

Areas used for the storage, maintenance and calibration of stressing equipment shall be maintained in an organized functional manner. Calibrating or calibrated equipment shall be maintained and stored in designated areas.

2.9.3 Calibration Records

Records filed at the inspected plant, and available for review during the inspection shall demonstrate that jacks and gauges are calibrated against a testing machine, master gauge, or a load cell, traceable to known standards. The agency or laboratory supplying such calibration shall indicate the date of calibration of its testing equipment. Serial numbers of calibrating and calibrated equipment shall be noted on all calibration documents.

Calibration records shall show the following data:

- (a) Date of calibration.
- (b) Agency, laboratory or registered engineer supervising the calibration.
- (c) Method of calibration: e.g. proving ring, load cell, testing machine, etc., and its calibration reference.
- (d) The full range of calibration with gauge readings indicated against actual load. Full range means incremental readings must be taken at 1,000 lb. intervals of pressure up to the maximum range, which the gauge will be used.
- (e) Jacks and gauges, as a unit, shall be calibrated at not more than 6-month intervals (some specifications may require calibration at more frequent intervals).

2.10 Quality Control Program

Plant shall have a written Quality Control Program on file to ensure ongoing compliance to the PTI Certification Program. The Quality Control Program shall include an outline of procedures and assignment of responsibilities for each step of procedures.

3.0 PTI CERTIFICATION PROGRAM ADMINISTRATION

3.1 Certifying Agencies

The PTI Certification Committee may recommend Independent Certifying Agencies for appointment by the PTI Board of Directors. The Certifying Agencies shall be organizations staffed with personnel experienced and familiar

with unbonded post-tensioning materials, components, and production processes; as well as unbonded post-tension design and construction. Certifying Agencies shall be appointed for a minimum initial term of three (3) years to have jurisdiction over not less than one PTI zone (see Zone Map in Appendix H). A Certifying Agency's activities shall terminate at the close of the contract term unless renewed by mutual agreement.

Certifying Agencies shall be responsible for expeditiously conducting plant inspections, preparing an evaluation report, and sending copies of the evaluation report to the Post-Tensioning Institute and to the inspected plant's designated representative. Except as otherwise required by law, the test report and underlying data and any other information furnished by the inspected plant shall not be disclosed by the Certifying Agency or PTI to any personnel other than the inspected plant's authorized representative. Subject to this rule of confidentiality, each Certifying Agency shall submit an annual report to the PTI Board of Directors summarizing the agency's activities over the previous year.

The Certifying Agencies shall sign a confidentiality agreement (See Appendix F) with all participating plants under their jurisdiction to protect all confidential, proprietary or trade secret information of the participating plants.

3.2 Inspections, Grading and Notification of Inspection Results

The PTI Certification Program is based on the review of materials, test data and fabrication procedures during two plant inspections by a Certifying Agency each year the plant is involved in the program. During the first year there will be one in-depth announced inspection and one unannounced inspection. During the second and following years, two unannounced inspections will be made of each plant. Unless otherwise approved by PTI, a minimum of 15 weeks shall elapse between inspections during any calendar year. Plants applying for their initial certification after November 1st will receive one (1) in-depth announced inspection that calendar year and two (2) unannounced inspections in the second and following years.

When the Certifying Agency completes its study of the supporting data submitted with the application, the Certifying Agency will make arrangements with the applicant for the initial announced in-depth inspection.

The purpose of the inspection shall be to determine whether the procedures of the plant conform to the requirements of this program. The in-depth inspection and future unannounced inspections shall cover the items listed in Sections 2.2 through 2.10 of this manual.

Grading of each inspection criteria by the Certifying Agency shall be based on the grading guidelines and forms presented in Appendices B, C & D, and shall be based on the following three categories:

Pass	(comparable to a numerical grade equal to or greater than 80)
Marginal	(comparable to a numerical grade equal to or greater than 70 and less than 80)
Unacceptable	(comparable to a numerical grade less than 70)

An evaluation report will be issued by the Certifying Agency within 15 days following completion of each inspection. Copies of the report will be sent to the applicant and the Post-Tensioning Institute.

3.2.1 Certification

A plant will be certified if it receives "Pass" category grades in all nine inspection criteria, or in eight of the nine inspection criteria and a "Marginal" category grade in the ninth during its initial in-depth inspection. The inspected plant must meet the same minimum grades during future unannounced inspections to maintain its certification

PTI will issue a number to each mobile fabricating facility that would be affixed to the mobile fabricating facility in a permanent manner, and readily accessible for inspection.

For office display, each certified plant will be provided a mountable wall plaque.

Plants obtaining certification will also be issued a current certificate and will be included in the PTI listing of certified plants.

3.2.2 Re-Inspection

Plants which do not pass the initial in-depth inspection, or subsequent unannounced inspections, may request re-inspection. Such requests shall be made in writing to the Post-Tensioning Institute within 21 calendar days of receiving the PTI Certifying Agency's evaluation report. It shall include a statement that the deficiencies noted in

the previous inspection have been corrected, a detailed explanation of what was done to correct the deficiencies, and shall be accompanied by the re-inspection fee prevailing at that time.

Plants properly requesting re-inspection (such re-inspection by the Certifying Agency to be unannounced) will be maintained on the PTI List of Certified Plants until the re-inspection report is received by PTI. Copies of re-inspection reports will be issued to the plant and to PTI by the Certifying Agency within 15 days of the re-inspection.

3.2.3 Inactive Status

Plants, which become inactive, shall notify PTI in writing of this situation within 15 days. Certification shall remain in effect during this period of inactivity. Plant must immediately notify PTI of ANY production/fabrication being resumed. ANY production/fabrication activity removes the Plant from inactive status and scheduling of inspections will resume.

3.2.4 Mobile fabricating Facility Notification

The location of a mobile fabricating facility must be reported daily. It is the company operating the mobile plant's responsibility to communicate the location to PTI. Examples of such would include: GPS locators on all vehicles, web site reporting, or a PTI approved method of location monitoring.

3.3 Appeal Procedure

In the event a dispute arises between applicant and the Certifying Agency concerning the applicant's evaluation report, applicant may appeal the decision to the PTI Appeal Board within 21 days of receiving the PTI's Certifying agency's evaluation report. Applicant shall state in writing its position to the PTI Certification Director. The Certification Director shall refer the matter to the Appeal Board.

3.3.1 Appeal Board

The Appeal Board shall consist of five members. Three of the members shall be appointed by the PTI President, two of whom shall be professional members and the third shall be a company member who serves as chairman. One member shall be a representative designated by the applicant, and one member shall be the principal of the Certifying Agency. Applicant shall be afforded a full opportunity, in person and by counsel if desired, to be heard by and to present any relevant additional evidence to said Appeal Board.

In the case of a conflict of interest that arises due to the PTI President being a principal or employee of the Applicant requesting the appeal, the PTI Vice President shall assume the role of appointing the Appeal Board members listed above.

The PTI president shall not serve on the Appeal Board. No person who is an officer, employee, or is otherwise affiliated with the Applicant shall serve on the Appeal Board.

3.3.2 Decision of Board

The decision of the Appeal Board shall be submitted to the applicant and to the Certifying Agency. The Appeal Board's decision concerning the disposition of the evaluation report shall be final.

3.3.3 Cost of Appeal

The applicant shall bear the costs of conducting a review including the Appeal Board's meeting costs, if meetings are required.

3.4 Renewal of PTI Certification

The PTI Certification Program operates on a calendar year basis. During December of the year in which the initial Certificate of Certification was issued and each subsequent year, each certified plant shall submit a written request for renewal of certification to the Post-Tensioning Institute on the form provided by PTI for that purpose (see Appendix G). The application for renewal shall be accompanied by test data required by this manual for any component of the post-tensioning system that was modified since the original application. The fee for the two unannounced inspections during the year shall accompany the request. Plants requesting renewal of certification will be maintained on the PTI list of certified plants until such time that future inspection evaluation reports may necessitate a change. Plants not requesting renewal of certification during December will automatically be dropped from the list of PTI Certified Plants on December 31st.

3.5 Grievance Procedure

3.5.1 Procedure for Complaints

All participants in the PTI Certification Program shall be subject to inspection, grading and notification over and above that set forth in Section 3.2 based on written complaints from any person identifying him or herself, which come to the attention of PTI, and which pertain to the subject matter of the Certification Program criteria and which appear to have a reasonable basis. PTI shall deal with all such complaints within a reasonable time. All other procedures set forth in Sections 3.2 and 3.3 shall pertain to complaints instituted hereunder.

The costs of any additional inspection(s) resulting from the provisions of this section are to be paid by the Participant at the same rate as set forth for a re-inspection.

3.6 List of PTI Certified Plants

The Post-Tensioning Institute shall publish semi-annually a list of PTI Certified Plants. The list shall be based on evaluation reports received from the Certifying Agencies indicating which plants have met the criteria for a PTI Certified Plant.

3.7 Fees

Fees to be paid by the applicants for participation in the PTI Certification Program are set by the PTI Board of Directors to cover the costs of maintaining the program. The current fee schedule is available upon request from the PTI office.

All Plants applying for Certification must submit the entire annual certification fee with the initial application. Applicants applying after November 1st will receive one (1) announced inspection in that calendar year per Section 3.2. The Applicant will receive a credit of 50% of the fee submitted to be applied towards the next calendar year's certification fee. If Applicant elects not to continue in the Certification program in the following year it forfeits the credit to PTI.

3.8 Changes to the *Manual for Certification of Plants Producing Unbonded Single Strand Tendons*

The PTI Certification Committee shall periodically review the contents of the *Manual for Certification of Plants Producing Unbonded Single Strand Tendons* to determine if the procedures can be improved. If the committee deems that changes in the procedures should be made, the committee shall recommend to the PTI Board of Directors that specific changes be made. If the Board of Directors approves the changes, the changes shall be published in the PTI Newsletter or other form of notification distributed to PTI Company Members, and shall be put into effect 60 days after the approval date. Changes will not affect certification in effect prior to the effective date, but will be considered when subsequent inspections are made.

3.9 Application for PTI Certification

An application for participation in the PTI Certification Program shall be submitted on the appropriate form supplied by the Post-Tensioning Institute (see Appendix E for a sample "PTI Plant Certification Contract" form). Two copies of the contract and supporting data shall be submitted.

This agreement applies to all fixed plants and mobile fabricating facilities. Each mobile fabricating facility is a separate unit. If a company has 3 mobile plants, each would require a number and certification. A company may not certify one mobile plant and then operate others outside of the PTI program.

The application shall include the following information:

- Part 1. Applicant: The name and complete address of the company, business, organization, or individual applying for evaluation. The applicant need not be a member of PTI.
- Part 2. Description and trade name(s): The industry description of the system, including the trade name or names under which it is sold, if any.
- Part 3. Data submitted: To facilitate the plant inspection process, all test data required by Sections 2.2, 2.3, 2.4, and 2.5 of this manual, along with copies of jack and gauge calibration records as required by Section 2.9 must be submitted with the application for review prior to the plant inspection. The following information, if applicable to the materials, anchorages, and equipment involved shall be submitted.

1. Descriptions of the materials, anchorages, and equipment including drawings, engineering calculations, metallurgical data, and other pertinent data. A compact illustrative brochure should be submitted if available.
2. Test reports indicating the performance of the materials, anchorages, and equipment. The test reports must contain, or be accompanied by, the following:
 - (a) A statement of the laboratory's independence and its relationship to the applicant.
 - (b) Copies of test procedures used, unless tests are standard tests, in which case the complete designations of the test standards shall be given.
 - (c) Verification of the laboratory's capabilities and facilities to conduct such tests.
 - (d) A statement that the data presented are representative for the materials, anchorages, and equipment and that reports or knowledge of inferior behavior have not been withheld.
3. A detailed list of the applicant's stressing equipment. The list shall include size, capacity, manufacturer's name and model designation of each item. Copies of initial calibration reports and dates of subsequent calibrations shall be supplied for each jack.

Part 4. Coated Strand Facilities: If any coated strand is produced outside of the certified plant, the PTI Certifying Agency shall be required to inspect each strand coater's facilities if it is not a current PTI Certified Plant to verify compliance with the relevant section of the program. All additional costs for such inspection shall be paid by the plant requiring inspection.

Applicant must submit with the application all relevant test data required in Sections 2.2, 2.4, and 2.5 pertaining to any coated strand produced outside of the certified plant. This information must be provided for each strand coater used by the certified plant. In addition, for each strand coater who is not a PTI Certified Plant, the Applicant must submit a copy of the strand coater's Quality Control Manual which applies specifically to coating and sheathing of the strand as required in Section 2.10.

Part 5. Fee: Receipt of the appropriate annual fee for PTI Member or Non-Member Certification is required before the application is processed.

Part 6. Acknowledgement: The application must be signed by a proprietor, partner or authorized officer of the applying firm, and notarized. The name and title of the person to be contacted for additional information shall also be given if it is different from the individual signing the application.

Upon receipt of the application, supporting data and application fee noted above, the Post-Tensioning Institute will forward the application and supporting data to the appropriate Certifying Agency for review. Laboratory test reports are studied to verify conclusions. The performance is compared with the requirements of PTI's *Specification for Unbonded Single Strand Tendons*, or as specified in contract documents for specific project(s). If additional data are required, the applicant will be so notified and further processing will be withheld until the requested information is received.

APPENDIX A – Guidelines for Grading Plants Producing Unbonded Single Strand Tendons

The following guidelines are to be used in conjunction with the plant grading checklist during plant inspections.

- 2.2 Prestressing Steel
 - 2.2.1 Strand Storage, Storage area – A lower point value will be assessed for outside storage.
- 2.3 Anchorages and Couplers
 - 2.3.1 Test Data - Full identification, including general descriptive component information (part drawings, dimensions and tolerances) material specifications and special fabrication processes should be available. A lower point value will be assessed for incomplete documentation or less than full compliance.
 - 2.3.2 Water tightness, Principal moisture access points are at the outer and inner faces of the anchor, (at the anchor/sheathing connection, or cap and anchor connection) and the sheathing and transition component. High credit will be given for mechanical type connections, and lesser credit given for non-mechanical connections. Least credit will be given for tape connections, which require plant or field application.
- 2.4 Sheathing
 - 2.4.1 Dimensional Requirements, Wall thickness – Both average and minimum thickness is checked. A re-sampling shall be made of two samples at random locations, as to be determined by the inspection agency if the minimum thickness falls below standard. The two random samples shall meet or exceed the minimum standard grade or the grade shall be zero.
 - 2.4.2 Aggressive Environment Requirements, Pinholes or Defects – Ratings will be based on both the sheathed product and the fabricated product.
- 2.5 Corrosion Inhibiting Coating
 - 2.5.1 Coating Material Quantity, Comparison – Any plant that does not have an organized system established for recording and maintaining coating material-use-data, will be assessed a lower point value.
- 2.6 Fabricating Process
 - 2.6.2 Fixed-End Anchorages - Special attention will be given to encapsulated systems to ensure that all connections are watertight.
 - 2.6.3 Gauges - Maximum required stressing pressure not clearly visible would be assessed a lower point value.
- 2.7 Storage and Shipping
 - 2.7.1 Storage - Outside storage will be critically evaluated relative to the yearly climatic conditions prevailing at each plant location.
- 2.8 Record Keeping
 - 2.8.1 File Organization - This section is included to encourage all plants to maintain their records in an organized manner and is reflective of good quality control procedures.
 - 2.8.2 Records - Copies of component drawings and of traceable documentation must be maintained. Lower point values will be assessed for non-compliance.
- 2.9 Stressing Equipment
 - 2.9.2 Facilities - A lower point value will be assessed for disorganized and/or un-functional facilities.
- 2.10 Quality Control Program

APPENDIX B – Plant Inspection Checklist

Plant Control Number _____ Plant _____

Weather _____ Inspection Date _____ Time _____

Production Manager On Duty _____

Assistant _____

Activity _____

2.2 Prestressing Steel	Max Points	Eval. Points
2.2.1 Storage of Strand (Wt. = _____)		
Define Storage area:		
Type weather protection:		
Ventilation & condensation controls:		
Pack protection & VPI content:		
Stored on dunnage? _____ Type _____ Vert. Axis _____ Horiz. Axis _____		
Evidence of corrosion on wrapped or unwrapped packs:		
Additional comments		
Total	100	
2.2.2 Acceptance Criteria (Wt. = _____)		
Corrosion Noted: _____ Where and how frequently:		
Grades of corrosion noted:		
Total	100	
2.2.3 Records (Wt. = _____)		
3 Mo. inventory inspection records with dates & results:		
Each pack:		
Heat # _____ Coil # _____ Supplier _____		
Break Strength _____ Yield @ 1% _____ Elong. _____		
Diam & Net Area _____ Type _____ E _____		
1000 Hour Tests:		
Sheathed strand		
Sheathed strand referenced to supplier, heat #, pack #		
How:		
Total	100	

2.3 Anchorages & Couplers	Max Points	Eval. Points
2.3.1 Test Data (Wt. = _____)		
(Min. 3 ft. length and 2% elongation)		
Behavior at 95% MUTS (Static Test)		

500,000 Cycles at 60-66% MUTS		
50 Cycles at 40-80% MUTS (Dynamic Tests)		
Availability of documents		
Comments		
Total	100	
2.3.2 Water tightness (Wt. =)		
How achieved at anchors & couplers:		
Lab test made? _____ Lab:		
Results:		
Total	100	
2.3.3 Records (Wt. =)		
Anchor Type	Source	
Anchor Type	Source	
Lot Nos.	Material Cert.	
Lot Nos.	Material Cert.	
Wedge Type	Source	
Wedge Type	Source	
Lot Nos.	Mat'l Cert & H.T.	
Lot Nos.	Mat'l Cert & H.T.	
Coupler Type	Source	
Coupler Type	Source	
Lot Nos.	Mat'l Cert & H.T.	
Lot Nos.	Mat'l Cert & H.T.	
Records for 2.3.1 on file?		
Total	100	

2.4 Sheathing	Max Points	Eval. Points
2.4.1 Dimensional Requirements (Wt. =)		
Min. wall thickness		
Min. opening diameter (0.030" (0.76mm) greater than strand dia)		
Push through okay	Rifling on surface	
Total	100	
2.4.2 Aggressive Environment Requirements (Wt. =)		
Evidence of pinholes or defects		
Comments		
Total	100	
2.4.3 Records (Wt. =)		
Type Material	Source	Cert
Watertight	Stable	Non-Reactive
Total	100	

2.5 Corrosion Inhibiting Coating	Max Points	Eval. Points
2.5.1 Coating Material Quantity (Wt. =)		
Visual inspection result (3' (1 m) specimen)		
Record check for usage (Min. 2 mo. Period)		
Inventory on inspection date		
Total coating material use		
½ in. (12.7 mm) strand coated during period		

Min. 2.5 lbs per 100 ft (1.14 kg/30.5m)		
0.6 in. (15.25 mm) strand coated during period		
Min. 3.0 lbs per 100 ft. (1.36 kg/30.5m)		
Comparison minimum use vs. actual use		
Method to determine use		
Total	100	
2.5.2 Quality & Compatibility (Wt. = _____)		
Evidence of full compliance with Table 1, PTI Spec.		
Total	100	
2.5.3 Records (Wt. = _____)		
Type coating	Source	
Type coating	Source	
P.O.'s on file	Mfgrs. Cert. of Compliance	
Test date	Performed by	
Total	100	

2.6 Fabricating Process	Max Points	Eval. Points
2.6.1 Sheathing (Wt. = _____)		
Type sheathed packs (reeless)_____ (on reels)_____ Type _____		
Take up powered_____ Pay-off powered_____		
Does machine tend to damage sheathing?		
Tendon coils (vert axis)_____ (horiz axis)_____ (I.D.)_____ (O.D.)_____		
Lazy-susan_____ Powered_____ Width controlled_____		
Does machine tend to damage sheathing?		
Tendon tying, material, technique:		
Evidence of defects or damage on outer surface of sheathed tendons		
Total	100	
2.6.2 Fixed-End Anchorages		
Uniform wedge sheathing _____ Rough/Smooth _____		
Encapsulated System		
(a) is wedge properly protected w/ watertight cover		
(b) is anchor/sheathing connection watertight		
Method of attachment at 80% MUTS		
Total	100	
2.6.3 Gauges (Wt. = _____)		
Dial face size _____ Digital _____		
Maximum stressing pressure printed on face:		
Total	100	
2.6.4 Records (Wt. = _____)		
Are tendons _____ or tendon groups _____ traceable to material sources?		
Strand _____ Sheathing _____ Coating _____		
Stress-End Anchors, Standard _____ Encapsulated _____		
Fixed-End Anchors, Standard _____ Encapsulated _____		
Fixed-End Wedges _____ Stress-End Wedges _____		
Total	100	

2.7 Storage and Shipping	Max Points	Eval. Points
2.7.1 Storage (Wt. = _____)		
Storage area subject to water intrusion:		

Total	100	
Sample Calibration		
Jack ID	Gauge ID	
Readings		
Average		
2.9.2 Facilities (Wt. =)		
Are calibration facilities & equipment area organized, functional, & well defined		
Total	100	
2.9.3 Calibration Records (Wt. =)		
Jacks & Gauges calibrated together (test mach, mstr gauge, load cell, proving ring)		
Records show: Date/Agency/ Lab or Eng. supervising calibration		
Method of calibration, Charts with full range of readings		
Equipment	Last Calib Date	By
Equipment	Last Calib Date	By
Equipment	Last Calib Date	By
Calibration of lab equipment		
Last Calibration Date		By
Jacks with gauges calibrated within 6 months		
Description of calibration process		
Total	100	

2.10 Quality Control Program	Max Points	Eval. Points
2.10.1 Quality Control Program (Wt. =)		
Written quality control program on file:		
Total	100	

Weighted % for total plant grade	GRADING SUMMARY	Individual Line Item Grades	Weight of Individual Item Grades	Weighted Grade Per Category
10	2.2 Prestressing Steel			
	2.2.1 Storage of Strand			
	2.2.2 Acceptance Criteria			
	2.2.3 Records			
	Section Total			
15	2.3 Anchorages & Couplers			
	2.3.1 Test Data			
	2.3.2 Watertightness			
	2.3.3 Records			
10	2.4 Sheathing			
	2.4.1 Dimensional Requirements			
	2.4.2 Acceptance Requirements			
	2.4.3 Records			
	Section Total			
10	2.5 P-T Coating			
	2.5.1 Coating Material Quantity			
	2.5.2 Quality & Compatability			
	2.5.3 Records			
	Section Total			
20	2.6 Fabricating Process			
	2.6.1 Sheathing			
	2.6.2 Fixed-End Anchorages			
	2.6.3 Gauges			
	2.6.4 Records			
	Section Total			
10	2.7 Storage & Shipping			
	2.7.1 Storage			
	2.7.2 Packaging			
	2.7.3 Marking			
	Section Total			
10	2.8 Record Keeping			
	2.8.1 File Organization			
	2.8.3 Records			
	Section Total			
10	2.9 Stressing Equipment			
	2.9.1 Gauges & Jacks			
	2.9.2 Facilities			
	2.9.3 Records			
	Section Total			
05	2.10 Quality Control Program			
	Section Total			
	TOTAL SCORE			

APPENDIX C - Information Required for PTI Static & Dynamic Tests

Supplier provides for Testing

- (a) Test Objective.
- (b) Description of recommended test procedure.
- (c) Specimens of components to be included in test assemblies.
- (d) Certification, or test data, showing that specifications have been met for all specimens supplied.
- (e) Certification, or test data, showing that components are compatible with all materials with which they will, initially or ultimately, be in contact. (Compatibility with corrosion inhibiting coating material, sheathing material and repair materials will be considered sufficient.)

Testing Agency Provides for Supplier:

- (a) Description of Testing Procedure.
- (b) Description of Testing Equipment
- (c) Certification of Calibration of Testing Equipment.
- (d) Drawing of test set-up.
- (e) Drawing of tested assemblage, with component identification.
- (f) Acknowledgement that components met specification requirements.
- (g) Acknowledgement that compatibility requirements were met.
- (h) Results of Test.

APPENDIX D - Recommended Procedure for Water tightness Test

Supplier Provides for Testing:

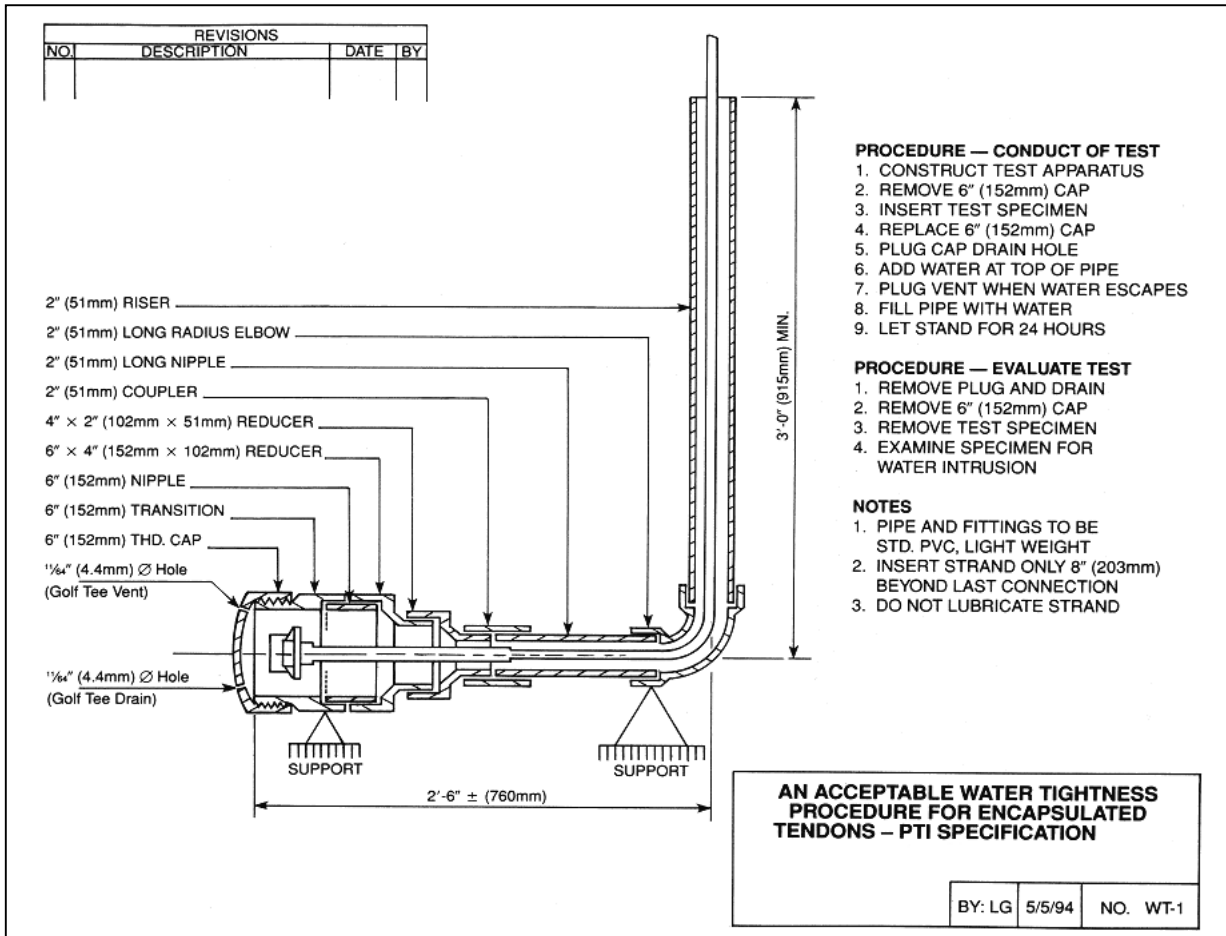
- (a) Test Objective.
- (b) Description of recommended test procedure.¹
- (c) Specimens of encapsulating components
- (d) Certification, or test data, showing that specifications have been met for all specimens supplied.
- (e) Certification, or test data, showing that components are compatible. With all materials with which they will, initially or ultimately, be in contact.²

Testing Agency Provides for Supplier:

- (a) Description of Testing Procedure.
- (b) Description of Testing Equipment.
- (c) Drawing of test set-up.
- (d) Drawing of tested assemblage, with component identification.
- (e) Acknowledgement that components met specification requirements.
- (f) Acknowledgement that compatibility requirements were met.
- (g) Results of Test.

Footnotes:

- 1. May be as suggested with this document, or any alternative test procedures producing similar results.
- 2. Compatibility of components with each other, if of different composition, and or components with water, concrete, corrosion inhibiting coating, clamps, adhesives, sealants and anchorage materials should be considered.



PTI PLANT CERTIFICATION APPLICATION

Date: _____

1. Applicant Name _____
Address _____
City, State, Zip Code _____
Name of Person to Contact _____
Phone Number _____
Applicant is _____ is not _____ a PTI member
2. Description and Trade Name(s) _____

3. Data Submitted (please indicate): Enclosed _____ Under Separate Cover _____
Please list data submitted _____

4. Coated Strand Facilities: In-House _____ Outside Facility _____
If outside facility is used, give location with address, phone number, and contact person:

5. Fee: Check or money order enclosed in the amount of _____

Application will not be processed until check or money order and all information required by PTI are received.

PTI PLANT CERTIFICATION CONTRACT

This agreement is entered into by and between Post-Tensioning Institute (PTI) and

_____ (participant)

with respect to plant(s) described in Exhibit A attached hereto.

WHEREAS:

- A. PTI has developed and published its Specification for Unbonded Single Strand Tendons (Specification); and
- B. PTI has adopted a program for Certification of Plants Producing Unbonded Single Strand Tendons; and
- C. PTI and Participant desire to review the Participant's compliance with specified provisions of the Standard through a series of voluntary inspections;

NOW THEREFORE, in consideration of the payment of fees by Participant to PTI, and in consideration of PTI's agreeing to administer the certification program, it is hereby agreed as follows:

1. This agreement applies to all of the Participant's plants.
2. Fees are charged to Participant on a per plant basis, as set by the PTI Board of Directors and are payable by Participant in advance.
3. Inspections, Grading, and Certification
 - (a) Inspections will be conducted by a Certifying Agency appointed by PTI. PTI retains sole authority in the appointment of the Certifying Agency.
 - (b) Inspections, grading, and certification shall be conducted as described in the PTI Manual for Certification of Plants Producing Unbonded Single Strand Tendons (Manual) which is incorporated herein by reference.
 - (c) Inspections will be conducted on dates scheduled by the Certifying Agency.
 - (d) Participant agrees to cooperate fully with the PTI appointed Certifying Agency and its employees.
 - (e) Immediately following inspections, the inspector will be available for consultation with plant management.
4. Confidentiality: Except as required by legal order or otherwise required by law, neither PTI nor the inspecting agency nor any of its employees shall reveal any data or grading with respect to any plant inspected at Participant's request, other than Participant's authorized representatives, except with Participant's written consent
5. Term: This contract shall become effective on the first day of the month following payment of inspection fees. Contracts are for a maximum of one year and expire on December 31 of each year. Renewal shall be in accord with Section 3.4 of the Manual.
6. Application: Application for certification shall be made in such form as PTI may from time to time prescribe.
7. Certification, Certificate, and Certification Mark
 - Upon certification,
 - (a) Participant shall receive a Certification Certificate.
 - (b) PTI will grant Participant the right to use, in conformance with this agreement, the appropriate Certification Mark for use on stationary and for advertising purposes.
 - (c) It is understood by Participant that in issuing a certificate and Certification Mark and authorizing its use, PTI does not approve, endorse, or guarantee any product, system, or construction, or in any way make any express or implied warranties in connection with any product, system, or construction.
 - (d) The Certificate and Certification Mark remain the property of PTI and must be surrendered by Participant immediately in the event of decertification or voluntary withdrawal from the

program and any use of literature, documents, or any other items bearing the Certification Mark must immediately cease.

(e) Participant agrees that certification is limited to fabrication procedures, materials and anchorages essentially identical to the specimens tested in support thereof.

- 8. Participant promises to abide by the terms of this agreement. Participant understands that PTI reserves the right to change the terms and conditions governing certification and use Certification Marks from time to time, and Participant shall abide by such changed provision upon receipt of notice thereof or otherwise completely withdraw from the certification program by surrendering its certificates and foregoing the right to use the Certification Mark. Violation of the Agreement, or any part thereof, including, without limitation, any misrepresentation by Participant or misuse of the Certification Mark, constitutes grounds for PTI to withdraw Participant's privilege to participate in the Certification Program. In the event Participant is notified in writing by PTI that such withdraw has occurred, Participant shall immediately surrender its certification and cease using the Certification Mark or facsimile thereof in any way.
- 9. Indemnification and Waiver of Claims: Participant agrees to indemnify, hold harmless and defend PTI from any and all liability, loss, expenses, or damage, including court costs and attorney's fees, PTI may suffer as a result of any matter arising from any action undertaken by PTI pursuant to this agreement, including, without limitation, any claims, demands, costs, or judgments against it arising from the testing or certification of Participant's systems by PTI, or from Participant's use of the Certification Mark, or from the use or operation of the certified systems or any certificate issued under this application whether the liability, loss, expense, or damage is caused by, or arises out of negligence by PTI or its officers, agents, employees, or otherwise.

Participant further agrees that it hereby waives any claim it may have against PTI arising from any action undertaken by PTI pursuant to this agreement, including, without limitation, the accidental or negligent release of data by PTI or from the negligent performance of tests by PTI.
- 10. Participant agrees to submit an affidavit that all statements in this application and its submitted materials are true.
- 11. Choice of Law: Any disputes arising under this agreement shall be governed by the law of the state of Illinois.

IN WITNESS THEREOF, the parties have executed this contract the day and year first above written.

Post-Tensioning Institute

Participant Company_____

By_____

By_____

Title_____

Title_____

Signed and Sworn to Before me
this _____ day of _____, 20_____.

Notary Public

EXHIBIT A – LIST OF PLANTS SEEKING CERTIFICATION

The following is a list of all of the applicants plant(s), including address, phone number, and contact person.

1. Plant: _____
Address: _____

Phone: _____ Contact: _____

2. Plant: _____
Address: _____

Phone: _____ Contact: _____

3. Plant: _____
Address: _____

Phone: _____ Contact: _____

4. Plant: _____
Address: _____

Phone: _____ Contact: _____

5. Plant: _____
Address: _____

Phone: _____ Contact: _____

6. Plant: _____
Address: _____

Phone: _____ Contact: _____

Check here to indicate additional plants and list them on a separate sheet _____

APPENDIX F – Confidentiality Agreement

CONFIDENTIALITY AGREEMENT

This agreement, dated as of this _____ day of _____, 20_____, by and between “Certifying Agency” 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 Certifying Agency reviews Participant’s compliance with specified provisions of the PTI *Specification for Unbonded Single Strand Tendons* (“Specification”);

Whereas, such review of compliance requires Certifying Agency 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 Certifying Agency shall not copy 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 Certifying Agency 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 Certifying Agency.
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.

Certifying Agency

Participant

APPENDIX G – Application for Renewal of PTI Plant Certification

PTI CERTIFICATION RENEWAL APPLICATION
FOR PLANTS PRODUCING UNBONDED SINGLE STRAND TENDONS

Date: _____

1. Applicant Name _____
Address _____
City, State, Zip Code _____
Name of Person to Contact _____
Phone Number _____
Applicant is _____ is not _____ a PTI member
2. Description and Trade Name(s) _____

3. Nature of modification(s) (if none, so state) _____

4. Data Submitted (please indicate): Enclosed _____ Under Separate Cover _____
Please list data submitted _____

5. Coated Strand Facilities: In-House _____ Outside Facility _____
If outside facility is used, give location with address, phone number, and contact person:

6. Renewal covers all of applicant's plants for the calendar year _____. (See Exhibit A)
6. Fee: Check or money order enclosed in the amount of _____
Application will not be processed until check or money order is received.

Firm Name

Signature of Proprietor, Partner, or Authorized
Officer and Title

EXHIBIT A – LIST OF PLANTS SEEKING RENEWAL OF CERTIFICATION

The following is a list of all of the applicants plant(s), including address, phone number, and contact person.

1. Plant: _____
Address: _____

Phone: _____ Contact: _____

2. Plant: _____
Address: _____

Phone: _____ Contact: _____

3. Plant: _____
Address: _____

Phone: _____ Contact: _____

4. Plant: _____
Address: _____

Phone: _____ Contact: _____

5. Plant: _____
Address: _____

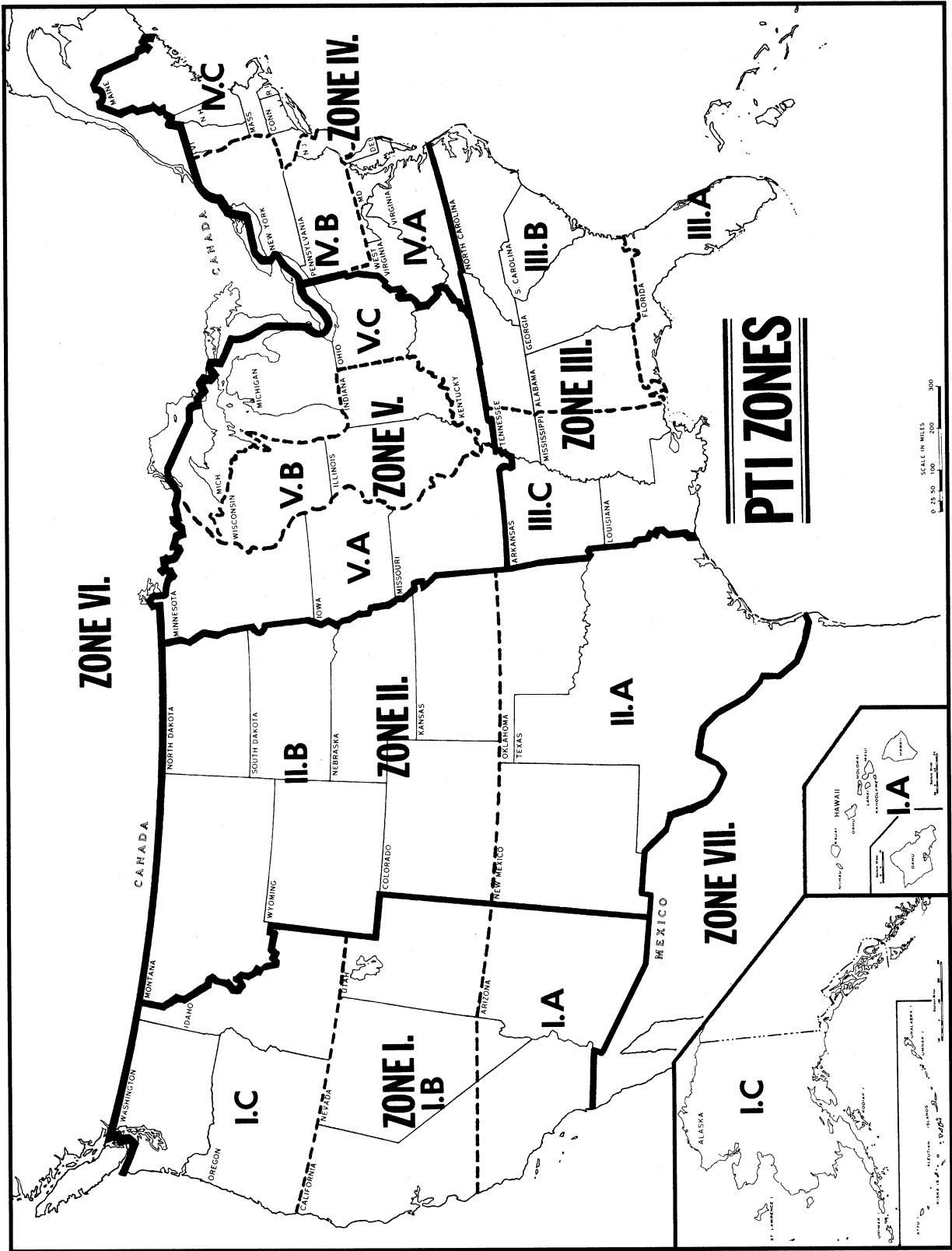
Phone: _____ Contact: _____

6. Plant: _____
Address: _____

Phone: _____ Contact: _____

Check here to indicate additional plants and list them on a separate sheet _____

APPENDIX H – PTI Zone Map



APPENDIX I – Sample Guide Specification

To obtain the full benefit of the PTI Plant Certification Program, use the following guide specifications for your projects,

Section 03365, Post-Tensioned Concrete

Material Quality Assurance

The fabricator of the post-tensioning unbonded tendons shall be a fully certified PTI plant at the time of bidding and throughout the duration of the contract, as defined by the Post-Tensioning Institute's (PTI) Program for Certification of Plants Producing Unbonded Single Strand Tendons.

Upon request, the fabricator shall provide a letter certifying that all products supplied to the job site meet the current PTI "Specifications for Unbonded Single Strand Tendons."



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