APPROVED

ICC EVALUATION SERVICE

Virtual/Remote Audit

ICC Evaluation Service, LLC
Western Regional Office
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Brea, CA 92821
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FOLLOW-UP INSPECTION REPORT

Form Q-24

Date of Inspection: 5/1/2020 (virtual audit)

ICC-ES Evaluation Report Number*: BOCA-93-36.02 ICC NTA Project # ICC-ES-PORT010120-803

*Please fill out a separate Q-24 for each master/follower report number as applicable.

Reissue Date of Evaluation Report*: 8/2003

*This date can be found on the upper right-hand corner of the first page of the evaluation report published on the ICC-ES website.

Revision or Correction Date of Evaluation Report*: 8/2003

*This date can be found on the upper right-hand corner or at the bottom of the first page of the evaluation report published on the ICC-ES website.

Name of Report Holder: Portland Stone Ware Co., Inc.

Name of Manufacturing Facility: Portland Stone Ware Co., Inc.

Manufacturer's Representative Name and Title: Kirsten Schuler - Product Specialist

Manufacturer's Representative E-Mail Address: kschuler@portlandstoneware.con Phone Number: 978-954-3062

Address of Inspected Facility: 10 McGrath Rd PO Box 670 Methuen Massachusetts United States 01844-1866

Street City State

Country and Province, if outside of the United States:

Names of Products Inspected*: The Portland Column

*Be sure to identify products using names provided in the evaluation report.

Signature of Manufacturer's Representative: Kirsten J Schuler Date: May 1, 2020

In lieu of a handwritten signature, you may type your name above.

Name of Agency Conducting Inspection: ICC NTA, LLC

Name of Inspector: Kyle Lacefield

Inspector's E-Mail Address: klacefield@ntainc.com Phone Number: 574-213-4994

Inspector's Time of Arrival: 10am (virtual audit) Inspector's Time of Departure: 11am (virtual audit)

Was product being produced at the time of inspection? Yes ☑ No ☐

Signature of Inspector: Kyle LaFP Date: 5/1/2020

In lieu of a handwritten signature, you may type your name above.

Name of ICC-ES Staff Person Reviewing This Report: APPROVED Date:
(For ICC-ES Internal Use) By Jay Lee at 2:43 pm, May 22, 2020

Instructions

Introduction: The purposes of the follow-up plant inspection are to verify that the product being produced is consistent with the product used in the qualifying tests and recognized in the ICC-ES evaluation report or listing; that the documented quality system continues to meet ICC-ES requirements; and that the quality system is effectively implemented.

The Plant Inspection: The inspector should verify that documents and processes (including the current quality documentation) observed at the listee or report holder's facility during the inspection are consistent with the information provided by ICC-ES. A simple check in the Yes/No boxes may not suffice; if needed, use the comments sections or use an attached document for your remarks or explanations. The inspector should, to the extent possible, inspect the product recognized in the ICC-ES evaluation report or listing to assess conformance to specifications as described in the ICC-ES evaluation report or listing and ICC-ES supporting documents. Additionally, the inspector must use the ICC-ES supporting documents, the manufacturer's current quality documentation and operating procedures, and the manufacturing process records, to evaluate the implementation and effectiveness of the facility's quality management system. **If there are questions regarding which documents to verify, please contact ICC-ES (inspections@icc-es.org).**

The Report: The inspector will complete this report during the inspection. If there is a nonconformity, the nonconformity will be detailed in the inspection report, and a Corrective Action Request (CAR) will be issued. CARs must clearly state what is required by the ICC-ES Acceptance Criteria for Quality Documentation (AC10) and by the manufacturer's documented quality system, and what the inspector actually found. This Follow-up Inspection Report must be signed by the manufacturer's representative and by the inspector. A copy of this report, and any CARs, must be given to the manufacturer's representative (and/or the report holder or listee, if the manufacturer and the report holder or listee are different) at the conclusion of the inspection, and a copy must be forwarded to ICC-ES.

Resolution of CARS: The manufacturer must respond to each CAR within 30 days of the inspection. CARs must be resolved by the manufacturer (or the report holder or listee, if the manufacturer and the report holder or listee are different) to the satisfaction of ICC-ES. ICC-ES reserves the right to require another follow-up inspection, to confirm corrective actions, when deemed necessary.

REVIEW OF NONCONFORMANCE(S) FROM PREVIOUS INSPECTION

Reviewed effectiveness of correction plan for nonconformance(s) issued during previous inspection?	**Yes** ☑	**No** ☐
Is the implementation of the resolution(s) satisfactory?	**Yes** ☑	**No** ☐
Is additional follow-up required? (please provide a comment if additional follow-up is required)	**Yes** ☐	**No** ☑
Comments: No previous CARs.		

PART A – PRODUCT VERIFICATION

1.	Are the manufacturer's quality manual and operating procedures consistent with the quality documentation submitted to ICC-ES? Note any discrepancies and provide applicable copies.	**Yes** ☑	**No** ☐	
Comments:				
2.	Are the manufacturer's documented procedures, for inspection or testing of incoming materials, being carried out? Are the procedures consistent with the quality documents submitted to ICC-ES?	**Yes** ☑ **Yes** ☑	**No** ☐ **No** ☐	
Comments: CoA's and Mill Certs are supplied by vendors.				
3.	Is this manufacturer conducting inspections and tests, as required in the quality documentation, for in-process quality control? Are these inspections and tests sufficient to ensure consistency of product quality? Are the procedures and tests consistent with what is described in the quality documents submitted to ICC-ES?	**Yes** ☑ **Yes** ☑ **Yes** ☑	**No** ☐ **No** ☐ **No** ☐	 **N/A** ☐
Comments: QM Sec. 2.3 - weight batcher automatically calculates weight/mix ratio, if something is out of spec it will stop.				
4.	Is the manufacturer conducting final inspections and tests, prior to final approval and labeling of the finished product? Do these inspections or tests ensure that the product receiving the label complies with the applicable specifications and design values?	**Yes** ☑ **Yes** ☑	**No** ☐ **No** ☐	
Comments: Visual inspection is completed at the end of the line to catch any production defects.				
5.	Using the identification that is applied to the finished product, conduct a traceability study by taking a finished product and tracing it back to the production and quality control records. Is the traceability adequate?	**Yes** ☑	**No** ☐	
Comments: Traceability was acceptable. QM Sec. 2.1.5				

6a.	Does this facility presently label product for private label listees? If yes, please complete Section 6b.	**Yes** ☐	**No** ☑
6b.	List the name of each private label listee for which there is labeling with the ICC-ES report number and/or mark. (A list of authorized listees appears below the report holder's name on the evaluation report)		
Comments: N/A			
6c.	Is the product labeling consistent with what is described in the quality documentation	**Yes** ☑	**No** ☐
	Is the product labeling consistent with what is described in the "Identification" section of the evaluation report or listing? (Verify that these guidelines apply to all products labeled with the ICC-ES report number or mark.)	**Yes** ☑	**No** ☐
Comments: Viewed label vs. report			

PART B – QUALITY SYSTEM VERIFICATION

AC10 Section	AC10 REQUIREMENTS	QUALITY SYSTEM IMPLEMENTED?	
2.1.2	Is the facility street address, telephone number and contact person, as noted in the documentation, correct?	**Yes** ☑	**No** ☐
Comments: QM Sec. 2.1.2			
2.1.3	Is the manufacturer reviewing the quality system documentation a minimum of once every two (2) years?	**Yes** ☑	**No** ☐
	Is there a revision log included in the quality documentation that is kept current and dated? (If the date of the quality documentation provided by ICC-ES for the follow-up inspection is different from the date of the quality documentation at the manufacturing plant, or if revisions have been made to the quality documentation, please provide to ICC-ES a copy of the revision record with an explanation of the changes that were made.)	**Yes** ☑	**No** ☐
Comments: QM Sec. 2.1.3			
2.1.6	Is the product flowchart or the description of production methods, as contained in the manufacturer's quality documentation, representative of the actual production flow and process?	**Yes** ☑	**No** ☐
Comments: QM Sec. 2.1.6 - compliant.			

2.1.7	ICC-ES must be notified of any significant product changes so that those changes may be evaluated and documented. Does the quality documentation have procedures to notify ICC-ES and other appropriate parties of any product changes? Has the product changed significantly since the last inspection? If yes, describe the change in the comments section below.	**Yes** ☑ **Yes** ☐	**No** ☐ **No** ☑
Comments: QM Sec. 2.1.7			
2.1.8	Is the organizational chart up-to-date, and are the duties and responsibilities of key positions in the quality program identified?	**Yes** ☑	**No** ☐
Comments: QM Sec. 2.1.8			
2.1.9	Are the products packaged and stored per the manufacturer's quality documentation and operating procedures?	**Yes** ☑	**No** ☐
Comments: QM Sec. 2.1.9			
2.1.10	Are records of all significant complaints about the product being kept? Is appropriate action being taken with respect to such complaints? Are the actions being documented?	**Yes** ☑ **Yes** ☑ **Yes** ☑	**No** ☐ **No** ☐ **No** ☐
Comments: QM Sec. 2.1.10			
2.5	Are nonconforming materials segregated from conforming materials as directed in this manufacturer's quality manual and operating procedures?	**Yes** ☑	**No** ☐
Comments: QM Sec. 2.5			
2.6.1	Does the manufacturer maintain a list that includes all the critical measuring and test equipment? Does the equipment identified on this list have current calibration records?	**Yes** ☑ **Yes** ☑	**No** ☐ **No** ☐
Comments: Calibration certs viewed - compliant			
2.7.1	Is the manufacturer actually using the forms, checklists and reports identified in the manufacturer's quality documentation to record manufacturing and quality process metrics?	**Yes** ☑	**No** ☐
Comments:			
2.7.2	Are the quality records as noted in item 2.7.1, above (forms, checklists and reports), approved by responsible personnel as required by the manufacturer's quality documentation?	**Yes** ☑	**No** ☐
Comments:			
2.7.3	Are all manufacturing and quality records maintained for a minimum of two years? (Examples are reports resulting from the manufacturer's own tests and inspections.)	**Yes** ☑	**No** ☐
Comments: Records are retained for 7 years.			

Summary of the Inspection

Inspector should note general observations on the manufacturer's quality system, facility and product manufacturing process. (Include details as appropriate.)

Conducted virtual audit with Kirsten Schuler and Donna Morgan of Portland Stoneware Co. on 5/1/2020. They were very helpful and knowledgeable of production and quality processes. No changes have been made since last inspection. No CARs were noted on the previous inspection. The quality system in place is adequate to ensure product quality. No CARs were written for today's inspection. Total time spent reviewing quality documentation plus virtual audit portion was 4 hours.

CORRECTIVE ACTION REQUESTS (CARs)

Findings should be entered in the blocks provided below, and defined as falling into one of four categories:

- **Major CAR** – A major nonconformity (e.g., change of key raw materials, significantly different manufacturing process, different final product specifications) that must be resolved to the satisfaction of the ICC-ES technical staff.
- **Minor CAR** – A relatively minor nonconformity (e.g., equipment out of calibration, changes to forms, inadequately trained personnel) that can be resolved to the satisfaction of the inspector, in most cases, without much difficulty.
- **Concern** – A weakness in the quality system that needs to be corrected to head off the possibility of future CARs.
- **Comment** – A suggestion for improvement.

CARs must be addressed within 30 days of the inspection. The manufacturer or report holder should respond with a written report on the corrective actions taken, and objective evidence of the action. Objective evidence could be in the form of revised documents, new documents, photographs, etc.

Findings (check the category, and describe the details of the finding. Use a separate sheet if necessary):

CAR NO.	Major CAR ☐	Minor CAR ☐	Concern ☐	Comment ☐
Comments:				
CAR NO.	**Major CAR ☐**	**Minor CAR ☐**	**Concern ☐**	**Comment ☐**
Comments:				
CAR NO.	**Major CAR ☐**	**Minor CAR ☐**	**Concern ☐**	**Comment ☐**
Comments:				
CAR NO.	**Major CAR ☐**	**Minor CAR ☐**	**Concern ☐**	**Comment ☐**
Comments:				
CAR NO.	**Major CAR ☐**	**Minor CAR ☐**	**Concern ☐**	**Comment ☐**
Comments:				

Report Date: 06/27/2019

WORCESTER SCALE CO., INC.

228 Brooks St., Higgins Industrial Park
Worcester, Mass. 01606
P: (508) 853-2886
F: (508) 853-2902
www.worcscale.com

Certificate of Calibration

Customer: Portland Stoneware
Address: 10 McGrath Rd
City, State, Zip: Dracut , MA 01826
Attention: Kirstin Shuler

Test Number: 49136
Test Date: 06/26/2019
Calibration Due: 06/2020
Measurement Uncertainty: mu= 0.17 lb

Equipment Tested : **Description :** Traveling Batcher

Manufacturer: Acromix Systems **Model:** Easy Touch Control **ID:** N/A
Capacity: 1000 lb **Division:** 1 lb **Calibration:** **On Site:** <
Condition as Found: Good **Temperature:** 75 ° F **Humidity:** 74 % **W.S. Shop:**
Keyboard Functions: Pass **Repeatability:** Pass **Decreasing Load:** Pass **Shift Test:** Pass

Test Results:

Test Load	Readings as Found	Readings as Left	+/- Tolerance per HB-44
0 lb	0 lb	0 lb	1 lb
250 lb	*257 lb	250 lb	1 lb
500 lb	*470 lb	500 lb	1 lb
750 lb	*8 pivots were out	749 lb	2 lb
1000 lb	of bearimg pockets	998 lb	2 lb

* Denotes out of tolerance

See standards report for traceability

Remarks: Tested, put pivots back in pockets, calibrated ,and certified to final readings. +/- 2 lb shift error

Standards Used: 61,63,65,69,70,71,72,73,74,76,77,79,81,82,83,87,91,96,98,99

Tested By: Mark Houseman *Technician (s)*

Approved By: *Service Manager*

This certificate attests that the above stated instrument has been calibrated with standards traceable to SI units though NISTor another NMI. Certificates of traceability are on file at Worcester Scale Company, Inc. Calibration procedure per WSC-009 and manufacturers' service manuals. The calibration was performed in compliance of all applicable requirements of ISO/IEC 17025. Computed uncertainties refer to WSC's Laboratory Accreditation Documents (reference Certificate AC-1266 for results). Test methods and tolerance requirements are found in the current edition of HB-44, section 2. Any deviation from these is noted in remarks section of this report. Due to numerous conditions that may affect calibration, this certificate attests only to the status of the tested equipment at the time of the test and/or calibration.Moving the scale from the current location may affect calibration. No sampling was performed during this calibration.Decision Rule: Measurement Uncertainty will not exceed 25% of acceptance tolerance without notification to customer and PFA will be reported.Measurement Uncertainty is expressed at a 95% confidence level with a coverage factor of k=2.

WSC-064H

DRAGON PRODUCTS COMPANY
P.O. Box 191, U.S. Route 1 • Thomaston, Maine 04861 • 207-594-5555

MILL TEST RESULTS
Laboratory at Thomaston, Maine
Report for production of Jan-20

Date: February 26, 2020
Cement Type: I/II
Silo Numbers: 20, 24, 25, 27 & 30

CHEMICAL DATA	Percent
Silicon Dioxide	20.1
Aluminum Dioxide	3.5
Ferric Oxide	3.0
Calcium Oxide	61.6
Magnesium Oxide	3.4
Sulphur Trioxide	3.5
Loss on Ignition	2.6
Insoluble Residue	0.9
Tricalcium Silicate	58
Dicalcium Silicate	12
Tricalcium Aluminate	4
Sum of C3S + 4.75*C3A	77
Sum of C4AF + 2*C3A	17
Sodium Oxide	0.1
Potassium Oxide	1.1
Equivalent Alkalies	0.83
Limestone Addition	3.5
$CaCO_3$ in Limestone	87.8

(Chemical Analysis all per ASTM C 114)

Heat of Hydration (cal/g) .. 83
(7 day result Per ASTM C186)

PHYSICAL DATA	
Specific Surface	388
Blaine (sq m /kg) *(Per ASTM C 204)*	
Percent Passing 325 Mesh. *(Per ASTM C 430)*	98.7
Compressive Strength (psi) *(Per ASTM C 109)*	
1 day	2050
3 day	3780
7 day	4790
28 day	
Vicat Setting Time *(Per ASTM C 191)*	
Initial (min.)	120
Final (min.)	205
Air Content (%) *(Per ASTM C 185)*	7.3
Autoclave Expansion (%) *(Per ASTM C 151)*	0.12
Expansion in water (%) *(Per ASTM C 1038)*	0.014
Sulfate Resistance (% exp) *(Per ASTM C 452)*	0.033

Certified by:

Jennifer Lynn Small
Quality Control & Distribution Manager

We hereby certify that this cement complies with current ASTM C 150, AASHTO M-85 and CSA A3001 Type GU, MS and HS specifications.

Testing was completed by Brian Secord, Richard Erickson and/or Amy Schnoor.
This mill test report is generated for silos produced in the calendar month prior to the date upon this report.

S.W.COLE ENGINEERING, INC.

Report of Concrete Compressive Strength

ASTM C-31 & C-39

Project Name: FREETOWN MA - 2019 CONCRETE LABORATORY TESTING SERVICES

Project Number: 19-0199

Report Date: 6/19/2019

Client: DRAGON PRODUCTS COMPANY, INC.

Client Contract Number:

General Contractor: Dragon Products Company, Inc.

Concrete Supplier:

PLACEMENT INFORMATION

Date Cast: 6/4/2019 **Time Cast:** **Date Received:** 6/5/2019

Placement Location:

Placement Method:

Placement Vol. (yd³):

Cylinders Made By:

Aggregate Size (in): 1/2

*** Test Cylinders Not Made By S. W. Cole Personnel**

INITIAL CURING CONDITIONS

Temperatures

Minimum (ºF) **Maximum (ºF)**

DELIVERY INFORMATION

Admixtures: AE

TEST RESULTS

Slump (in) (C-143): 5

Air Content (%) (C-231) 5.2

Air Temp (ºF):

Conc. Temp (ºF) (C-1064): 72

Load Number: **Batch**

Mixer Number:

Ticket Number **Arrive**

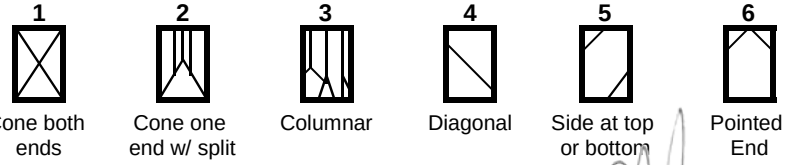
Cubic Yards:

Depart

Design (psi): **3000**

Cylinder Designation	Cylinder Weight (lbs)	Cylinder Diameter (in)	Cross Sectional Area(In)²	Date Of Test	Cure Type	**Age (days)**	Fracture Type	Load (kips)	**Strength (psi)**
188-3A	8.25	4.01	12.60	6/11/2019	Lab	**7**	3	38.3	**3040**
188-3B	8.25	4.00	12.57	6/18/2019	Lab	**14**	3	71.3	**5670**
188-3C	8.25			7/2/2019	Lab	**28**			
188-3D	8.25			7/2/2019	Lab	**28**			
188-3E	8.25			7/2/2019	Lab	**28**			
188-3F	8.20			7/30/2019	Lab	**56**			

Fracture Types



Remarks: T11-Cement 336 lbs, Slag Cement 144 lbs,

Reviewed By

The Portland Column

Assembled to comply with ICC Evaluation Service, Inc.

"See I.C.C. - ES Legacy Report"

No. 93-36.02

8' x 3 1/2" O.D. 16 ga Tube Load Capacity 19,300

Date Assembled: 04/15/2020

61453080350

Portland Stone Ware Co. Inc.
Dracut, MA 01826

Made in U.S.A
portlandstoneware.com