



**Portland & Blended Cement (PBC)
Technical Committee
Meeting Minutes**

Working Session # 5

Tuesday, June 10th, 2025 10:00AM – 11:15AM

1) Call to Order and Introductions

Items :

- Michael M. Intro
 - Roll call – Committee, industry, Manufacturers – healthy attendance

2) Brief summary of the audit program

Items

- (History) Change from product evaluation to audit Program overview (audit particulars)



3) Update on audits performed this year (Scott)

Items

2024

- Audited 51 facilities , 17 states
- 38 CARs issued
 - 5 specifications
 - 31 QMS
 - (All minor CARs)

2025

- 106 Audits, 18 completed mills/terminals
44 In progress
 - 33 CARs
 - QC/testing/Inspection -2
 - Standard Specs – 5
 - Comment (SH) Facilities need to HAVE specs available at audit time
 - QMS reviews - 21 (mostly documentation errors)
- Facility Info/Walkthrough (no testing or equipment operation)– 1
Terminal/silo inspections

Goal for manufacturers - Update docs before audit



4) Proposed changes to the Work Plan

Items

Changes consist of a mix of editorials from states and auditor feedback

Definition of terminal vs mill, manufacturer vs supplier

Add missing AASHTO/ASTM standards to reference docs

Consistent use of abbreviations

Training and Competency- Facilities using non-employees (drivers to collect MTR samples, etc) . Do we need training for terminal personnel for non-record testing?

AASHTO samples – Do the sampling personnel need training?

Comments : Sampling important -Brenda W(PennDOT)

Build into the work plan “non conventional “ sampling personnel and techniques

Require sampling equipment as per C183

Sarc. - Difference from field operation

Swisher and Scott - Clarify sampling and personnel

Ashley – Differences to training and documentation : Texas expects training in line with c183 (sampling can be done in various ways)

Ed Hughes - C183 for MTR vs retain?



Verbiage proposed - sample collection needs to be in accordance with C183 for MTR generation. Sample comparison should be in accordance with c183 and training of ALL involved individuals

Jonathon C. - Testing samples from Mill should be in compliance with C183. Terminal pose a problem with non-traditional sampling techniques.

On site access to both AASHTO and ASTM standards – Document what the facility is referencing. Either OR both ASTM and AASHTO standards. Let the manufacturer decide what they want to certify. Either OR both ASTM/AASHTO.

Scott -cautions if a facility doesn't include AASHTO, they might be out compliance for a year if the required specs are not available.

Equipment measuring silo quantities – Is it necessary to audit to this level?

Terminal versus Mill sampling sizes – Include Ports of Entry (if state requested)

Sarc – Clarification of edit. Manufacturers need to designate whether they are a Port of Entry(POE). Both 10 lb samples or only for AASHTO sample. If designated POE -treat sample like a Mill.

Jonathon – Additional physical testing - how will it work out?

Adding timeframes/deadlines for lab testing Scott clarification

Shawn SGS – comments on their timeline operation 32 day timeframe was reasonable (range 32-35), Communication has improved, auditors good at communicating with the lab. Jonathon – suggests 30 chemical, 60 physical

Scott- triggers a status request Sarc.- 35 for manufacturer/supplier (date of



audit);

Auditor/lab meeting to be conducted

[Ashley Yunkin presentation](#)

Presentation on workplan changes (TxDOT perspective)

Kathy indicated this program is a national effort regardless of TxDOT concerns

Actions Items

- Silos - omit measurement devices in 2026.
- Look into whether submission has the ability to designate Port of Entry for vendor
- Kathy- Clarification in work plan followed by changes to DataMine for 2026

5) State adoptions

Items

- Adopted by Alabama, Illinois, North Carolina, South Carolina, Tennessee and Texas



****Session will end promptly at 11:15AM to allow for the next session to begin on time****

Portland & Blended Cement Technical Committee

Drew Waldrop, Chair
ALDOT

Brian Hunter, Vice-Chair
NCDOT

Agenda

- Summary of the technical committee
- Update on audits performed this year (Scott Hughes)
- Proposed changes to the Work Plan
- Update on State Adoption Status
- Industry concerns
- Open Discussion

Summary of Program

- Audit of cement mills & terminals
- Review of QC practices & documentation
- Does NOT include test methods (CCRL)
- Sample collected, tested by producer lab and 3rd-Party lab
- CARs issued require response to remain in compliance



Update on 2025 audits

- 106 facilities applied
- 18 completed mills/terminals
- 44 in progress
- 33 CARs written
 - QC Testing/Inspection Matrix (Section 4) – 2
 - Standard Specifications (Section 5) – 5
 - QMS Records Review (Section 6) – 21
 - Facility Information/Walkthrough (Section 7) – 1
 - Traceability Sample Records Review (Section 8) – 4
- All CARs were minor in nature.

Proposed Changes to Work Plan

- Mixture of editorial changes, and changes based on state member or auditor feedback
- Editorial:
 - Consistent use & definition of the terms “manufacturer” & “supplier” vs “mill” & “terminal” throughout document
 - Adding missing AASHTO/ASTM standards to Referenced Documents
 - Consistent use of defined abbreviations (PBC, MTR, etc.)

Proposed Changes to Work Plan

- ▲ 9.1.1 Training and Competency - Review will show that the quality control technicians, ~~and~~ inspection personnel and non-employees (i.e. truckdrivers, private consultants) if the non-employees are obtaining samples used to populate MTRs are trained and evaluated for competency. These evaluations shall be properly documented, provide details that the evaluated personnel can perform test procedures and product inspection correctly, and kept as a quality control record.

Proposed Changes to Work Plan

9.2

Quality Control Inspection Evaluation – Each Supplier will be asked to demonstrate the QC activities (inspection, sampling), ~~and, if lab is not CCRL inspected, testing~~ that are performed as stated in the QMS. While performing each inspection and testing, the most current AASHTO ~~or~~ ASTM test methods (This will fall upon the Manufacturer/Supplier to know whether the STATE DOT purchasing the material is requiring them to produce/supply material meeting the requirements of AASHTO or ASTM) will be referenced. The equipment used for each inspection and test will be examined and applicable records will be reviewed.

Proposed Changes to Work Plan

9.8 **Measuring devices for material quantities – Does this need to be removed from SP01 and taken out of the Audit Report?**

Proposed Changes to Work Plan

10.2 *Sampling:*

-For Mills/Terminals - Two (2) – 10 ~~lb.~~ (5 kg) test specimens from the same lot/batch/etc. at the Manufacturer/Supplier being audited. ~~for Mills, and~~

For Terminals – Two (2) – 2 lb. (1 kg) test specimens from the same lot/batch/etc. at the Supplier being audited.

For Port of Entry Terminals - Two (2) – 10 lb. (5 kg) test specimens from the same lot/batch/etc. at the Manufacturer/Supplier being audited.

Proposed Changes to Work Plan

- 10.4 The Manufacturer/Supplier shall complete all testing of their comparison specimen, enter the results on the Auditor-supplied spreadsheet and send them to the Auditor within the following time frames; Chemistry result's with 15 business days and Physical result's within 32 calendar days.60 business days of the completion of the audit. The AASHTO Designated Laboratory will be held to the same time frames, except that the time frames will start from the date the samples were received at the testing laboratory.

Proposed Changes to Work Plan

Additional comments/visuals from Ashley Yunkin (TXDOT)

Status of State Adoption

- Adopted by: Alabama, Illinois, North Carolina, South Carolina, Tennessee, Texas
- Any updates since last quarterly call?

Industry Concerns

Open Discussion

AASHTO Product Evaluation & Audit Solutions

**Portland Blended Cement (PBC)
2024 & 2025 Overview**

Mills/Terminals Audited In 2024 51 - Facilities Applied (17 States)

Mills/Terminals – 51 Complaint

Corrective Actions Written - 38 Total

Standard Specifications (Section 5) = 7

Quality Management System Records Review (Section 6) = 31

All the CARs were **minor** in nature.

Mills/Terminals To Be Audited In 2025

106 - Facilities Applied (40 States)

Mills/Terminals – 18 Completed
44 In Progress

Corrective Actions Written - 33 Total

QC Testing/Inspection Matix (Section 4) = 2

Standard Specifications (Section 5) = 5

Quality Management System Records Review (Section 6) = 21

Facility Information/Walkthrough (Section 7) = 1

Traceability Sample Records Review (Section 8) = 4

All the CARs were **minor** in nature.

Questions?

Working Session #5

Portland & Blended Cement (PBC)

Attendance

June 10, 2025

First Name	Last Name	Employer
Tammy	Jernigan	ARDOT
Craig	Joss	Applied Infrastructure, LLC
Andrew	Thaxton	WV DOH
Amber	Landrith	Nevada Dept of Transportation
Dennis	Warren	Michigan DOT
Carly	Mcgee	Kta
Brian	Hill	Illinois DOT
Alex	Lewis	FDOT
Cassady	Allen	FDOT
Brian	Hunter	NCDOT
Douglas	Miller	MS DOT
Ashley	Yunkun	Txdot
Jonathan	Culver	CEMEX
Ed	Hughes	Contractor
Todd	Bennett	MoDOT
Scott	Hughes	SEH
Christopher	Leibroek	Kansas DOT
Robert	Sarcinella	Sarc.engineering & Consulting Services
Leonard	Vader	MoDOT
Dan	Wadley	KDOT
Scott	Wutzke	NDDOT
Sarah	Smith	FL DOT
Kenny	Seward	OK DOT
Brenda	Waters	PennDOT
Ray	Rowden	RTR NSPECTION
Philip	Peloquin	Vermont Agency of Transportation
Doug	Dupler	Contractor
Brandon	Boyer	DelDOT
Robert	Conway	FHWA

Matt	Romero	ODOT
Shawn	McCormick	SGS TEC Services
Steven	Ingram	ALDOT
Jason	Krogman	Minnesota Department of Transportation
Temple K	Short	SCDOT
Brandi	Mitchell	KYTC
Jennifer	Harrell	ACPA
Michael	Huyett	W.R. Meadows
Dan	Brayack	WVDOH
Jim	Reilman	Indiana DOT
Sam	Frederick	NCDOT
Henri	Johnson	The Quikrete Companies
Matt	Mueller	MWMueller
David	Wingard	The Quikrete Companies
Barry	Paye	Wisconsin DOT
Kelly	Senger	Illinois DOT
Pravat	Karki	TxDOT
Micharl	Mellons	Tennessee DOT
Katharine	Dafoe	WSDOT
T	Sandoval-Gil	ADOT
kaelyn	goenner	minnesota department of transportation
Shane	Little	Arizona Department of Transportation
Laura	Fernwood	Vermont aot
David	Kuniega	AASHTO
Guohua	Lian	Gdot
Kelly	Montoya	NMDOT
Jim	Swisher	VA DOT
Danny	Lane	Tennessee dot
Troy	DeWitt	Auditor
Jeff	De Vries	Iowa DOT
Darin	Hodges	SDDOT
Earnest	Colvin	ALDOT
Danny	Lane	Tennessee dot
Ethan	Mathieu	NH DOT
Susan	Mendola	CTDOT
Awilda	Merced	AM Quality Improvement Solutions-AASHTO contractor
Philip	Owens	Euclid chemical
Sam	Frederick	Ncdot
Daniel	Miller	Ohio Department of Transportation

Tim	Stallard	Michigan DOT
Rosa	Bravo	NCDOT
Dawn	Bickford	MaineDOT
Jacob	Walker	GDOT
Dorian	Brawner	KYTC
Joe	Barreres	Nevada DOT
Domenico	Tedeschi	CTDOT
Thomas	Murphy	NDDOT
Matt	Needham	Montana DOT
Paul	Bushnell	MDT
Cynthia	Pearson	ARDOT
Margarita	Takou	Acpa
Eliana	Carlson	CTDOT
Jerry	McMahan	Vermont AOT
Eghe	Igiehon	ACPA
Jason	Robertson	MassDOT
Sue	Zheng	FDOT
Ian	Gow	Massdot
Trey	Summers	Illinois Department of Transportation
Ashley	Buss	Iowa DOT
Aamer	Syed	Sika
Oak	Metcalf	National Precast Concrete Association
Adam	Tecken	VDOT
Eric	Frempong	Maryland DOT State Highway Administration
Sean	Li	Virginia DOT
Drew	Waldrop	ALDOT
Eric	Frempong	Maryland DOT
