

# **Carolina Inspection Services, Inc.**

**April 14, 2004**

## **QUALITY CONTROL PROCEDURES FOR LUMBER MANUFACTURERS PARTICIPATING IN THE HEAT TREATMENT (HT) OR KILN DRIED (KD/HT) HEAT TREATMENT PROGRAM**

**PURPOSE: TO CREATE A COMPREHENSIVE PROCESS FOR ENFORCING CIS'S  
HEAT TREATED PROGRAM AT PRIMARY, SECONDARY, AND  
REMANUFACTURE LUMBER PRODUCERS.**

A manufacturer producing HT or KD/HT product by constructing HT and/or KD/HT lumber or components produced by an ALSC qualified primary lumber manufacturer, secondary manufacturer, or remanufacture facility.

### ***DEFINITIONS:***

- Kiln Dried (KD) – lumber seasoned in a closed chamber by means of artificial heat to a maximum moisture content of 19% or less.
- Heat Treatment (HT) – lumber which has been placed in a closed chamber and artificial heat added until the lumber or packing achieved a minimum core temperature of 56° C or 133° F for a minimum of 30 minutes.

### **PROCEDURE**

#### ***CIS Representative Shall:***

1. Be familiar and execute the provisions of CIS's Quality Control procedures for HT and/or KD/HT Program.
2. Audit each HT or KD/HT producer a minimum of 12 times per year (Generally once per month).
3. Address any circumstance or conditions that results in a non-conforming HT or KD/HT product.
4. Issue a report upon each HT, KD/HT audit.
5. CIS shall approve written procedures for facilities under the HT and/or KD/HT quality control program.
6. Verify that the HT or KD/HT producer has created and is maintaining an accurate and orderly file of all HT and/or KD/HT lumber produced for one year.
7. If applicable CIS will review kiln records or appropriate reports at this operator.
8. Verify that HT, KD/HT marks are used in a legible manner. When product is available, a reasonable sample shall be taken to ensure conformance.

9. Verify that the HT or KD/HT mark is placed on the products properly. This mark should be placed in a visible location on each product.
10. Verify that HT, KD/HT products are separated in inventory from non-HT, non-KD/HT marked product. HT, KD/HT marked product may not be mixed with non-marked product in the same pack.
11. Monitor the moisture contents on product that is marked KD/HT.
12. Remove or cause to be removed any HT, KD/HT marks placed on non-conforming products.
13. Qualify at least one person at each HT or KD/HT producing plant to act as the HT; KD/HT Supervisor.

***Licensee's Role:***

1. Meet all requirements of the ALSC and CIS standards.
2. Manufacturer shall maintain an orderly filing system for HT and KD/HT products. The file shall be maintained for one year. The file shall document kiln chart or closed chamber chart for each run produced by manufacturer. This chart shall include:
  - Document time product started and time product finished.
  - Temperature reached and maintained.
  - Size of lumber (thickness and, width – 2x4, 2x6, etc.)
  - Board footage per shipment.
3. Create a monthly summary of quantity of HT and KD/HT materials product shipped. All quantities are to be reported in board feet.
4. Allow CIS Representative access to HT, KD/HT files during routine audits.
5. Allow CIS to review HT, KD/HT material to verify legibility and conformance for HT, KD/HT markings.
6. Allow CIS access to Licensee's HT, KD/HT records and facility a minimum of once per month.
7. Allow CIS Representative to assist in training and selecting at HT Supervisor from producer's staff.
8. Facilitate and give access to inventory for regular audits at mill or at destination.

***HT Supervisor's Shall:***

1. Be familiar and willing to execute the provisions of CIS's Quality Control Procedures for HT and KD/HT.
2. Address any circumstances that may lead to non-conforming HT or KD/HT products.
3. Create and maintain HT and/or KD/HT quality control procedures and daily work sheets.
4. Create and maintain HT files.
5. Keep HT and/or KD/HT product separate from non-HT product.
6. Monitor moisture content on KD/HT material.
7. Monitor legibility of HT and KD/HT products.
8. Assist CIS Representative during routine audits.