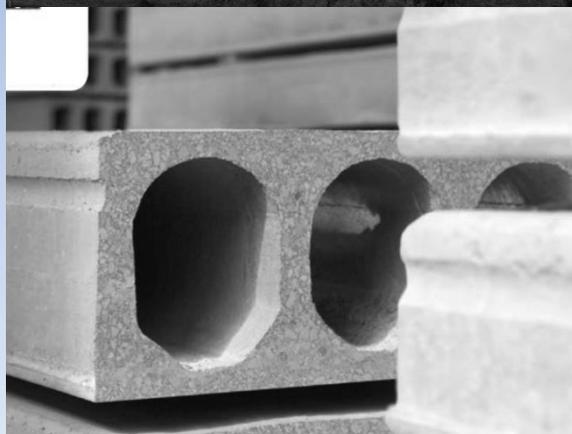


# IPHA PRODUCTION SEMINAR 2021

## PROGRAM



October 28-29, 2021  
**SAN SALVO - VASTO**  
Italy



INTERNATIONAL PRESTRESSED  
HOLLOWCORE ASSOCIATION

In cooperation with



**GENERALE  
PREFABBRICATI**

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**nordimpianti**

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Dear Colleagues,



I am delighted to see you at the **IPHA Production Seminar 2021** in **San Salvo - Vasto** in Italy. This is the second Production Seminar in IPHA's history, bringing an excellent opportunity for your staff responsible for hollowcore production to discuss important issues regarding a safe, timely and high quality production. By this Production Seminar, IPHA promotes a dynamic and enriching **exchange of information** between its international members, **encouraging dialogue** and **knowledge sharing** to ensure they are up-to-date on technical matters related to the production of hollowcore slabs.

Once again, we worked hard to organize what will be an event of paramount importance as well as an interesting experience that nobody involved in the hollowcore industry wants to miss. Participation in the course is free of charge for IPHA members and it is part of IPHA's endeavours to promote free exchange of information.

Yours sincerely,

**Seamus McKeague**  
President IPHA



The first recorded Production Seminar took place in Mollerussa/Lleida, Catalonia, in 2016 in cooperation with Prefabricats Pujol. Now, 5 years later, this second seminar in cooperation with Generale Prefabbricati focuses on **operations management**, discussing key points to make your operation more successful. Knowledge of technology, rational analyses, **leadership and people** are all essential to ensure operational **efficiency** in terms of optimal use of resources to create the optimal output, as well as **effectivity** in terms of meeting customer requirements in a competitive market.

IPHA Production Seminar's program includes presentations on safety and environment, team performance and efficiency in production, and quality assurance and quality control. In addition, a factory visit and site visit are part of the technical program. Moreover, sharing and discussing best practices with peer staff members is key in the social program.

Looking forward to physically meet you in San Salvo.

**Wim Jansze**  
President Technical Committee IPHA

## Generale Prefabbricati Spa, San Salvo

We are happy to host the 2021 Production seminar in our factory in San Salvo, Southern part of Italy where we'll offer a **warm welcome** to delegates in a safe and sure location.

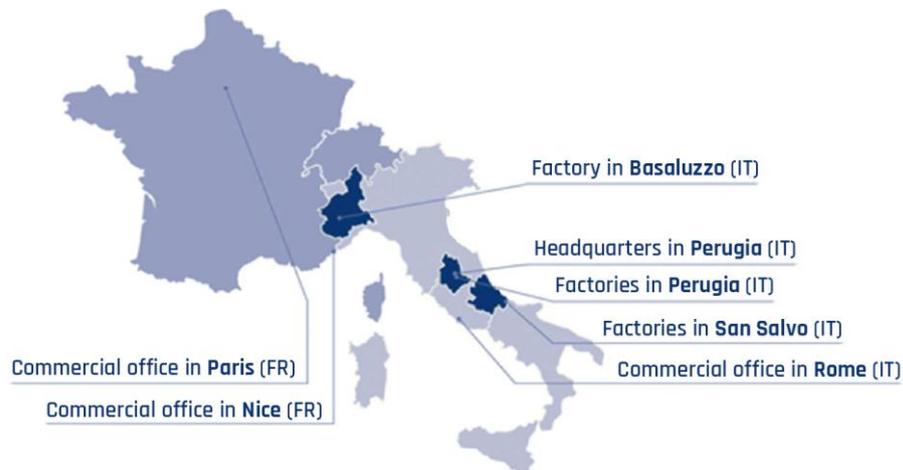
The production seminar represents a key moment of growth and training. In San Salvo delegates will be able to compare and learn from the best actors in the sector of hollowcore production. During these two days we can **deepen** our **knowledge** and **share** our **expertise**. Furthermore, we can spend pleasant days in this welcoming part of Abruzzo in front of the Adriatic sea.

I hereby invite you to visit our **multi-product precast factory** in San Salvo and visit the **site of the Amazon Logistic Centre** that is under execution.



### Marco Pecetti

Generale Prefabbricati / Board member IPHA



Generale Prefabbricati Spa is owned and managed by the Pecetti family. The company is active all over Italy and abroad, and is a leading manufacturer of prestressed hollowcore slabs. Generale Prefabbricati has four factories, San Salvo situated in the region of Abruzzo.

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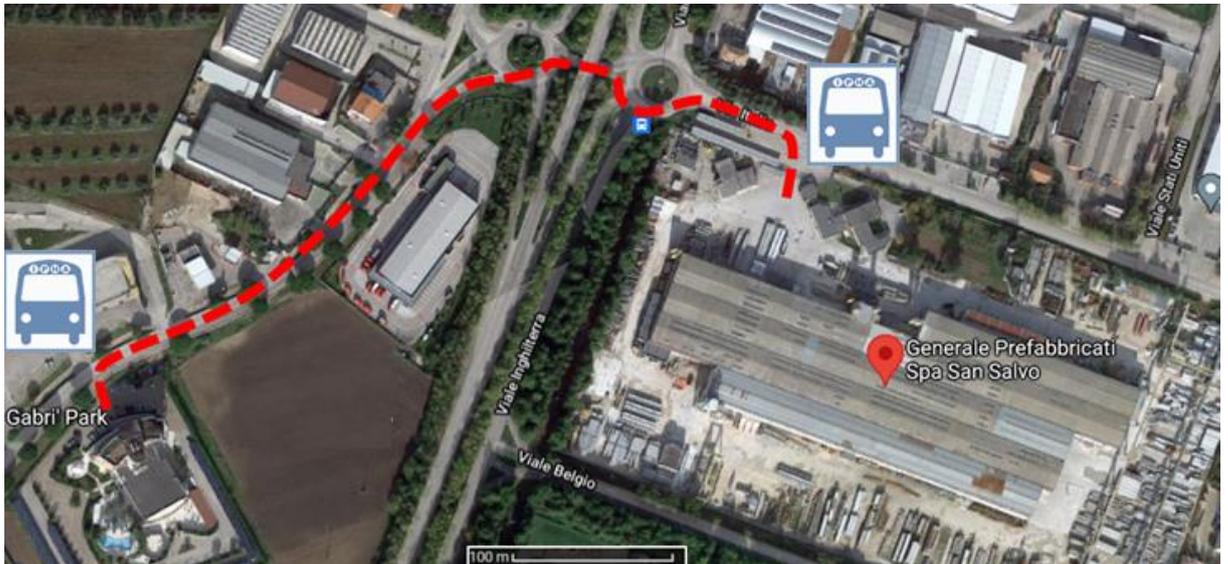


The 4-star **HOTEL EXCELSIOR** is situated in Vasto Marina. The hotel is 3 km from the center of Vasto Marina and 6.5 km from the center of Vasto village. Participants need to book the hotel through IPHA (€ 69,00 per night including breakfast plus € 2,50 local tax). IPHA will send the Hotel Reservation Form that needs to be returned to IPHA before 15.09.2021.



**Hotel Excelsior**  
 Strada Statale 16 Sud  
 266 KM 522.1 loc. Buonanotte  
 66054 Vasto (CH)  
<https://www.hotelexcelsiorvasto.com>

**Seminar** The two-day seminar is held at the premises of the factory of Generale Prefabbricati and in the conference room located at Gabri Park Hotel at 650 m distance. Note that due to safety due to heavy traffic in the surrounding industrial area the transport between 2 locations will be by IPHA bus.



**WEDNESDAY 27 OCTOBER 2021**

If registered, bus transport (4 hours) from Fiumicino Airport Rome (1<sup>st</sup> at 12:00 h, 2<sup>nd</sup> at 15:00 h). Please be not later than 10 minutes before the departure time at the Meeting Point in Terminal 3 (IPHA will place a IPHA pop-up stand. When arriving by common bus transport, or by individual travel, note that each guest have to sign in at arrival at the hotel and give copy of credit card and pay on departure.

**IPHA invites all delegates to a small dinner in Hotel Excelsior in Vasto on the night of arrival at 19:30.**

> NOTE: Please be aware that it is the responsibility of each of the participants to investigate which travel restrictions are in force on arrival to Italy from your departure location, such as but not necessarily limited to Corona Passport, Locater Card and use of head masks.<

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### Your safety comes first

IPHA and Generale Prefabbricati will bring a great experience to all delegates, and that includes taking care of every detail, especially when it comes to safety measures. Generale Prefabbricati will provide yellow reflecting safety jackets and hard hats for all delegates to ensure their safety while they are in the company facilities.

> You are kindly requested to bring your own safety shoes when visiting the factory, shear test on stockyard, and the building site. <

### Factory visit 28 October at 11:00 h

The San Salvo factory is located on a 25.000 m<sup>2</sup> area with 2 production halls. In one hall the hollowcores are produced on 130 m beds. Multi products such as beams and walls are produced in the other production hall.



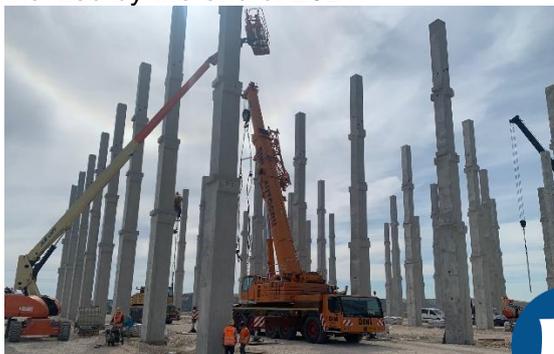
### Shear test 28 October at 14:00 h

Prestressed hollow core slabs rely on tensile strength and strand bond anchorage. The proper placing and compacting of concrete and the shear resistance of the finished product shall therefore be verified and confirmed by full scale testing under quality control.



### Site visit 29 October at 11:00 h

Close to the factory, Generale Prefabbricati is assembling the precast structure of an Amazon logistical centre. This warehouse has 120.000 m<sup>2</sup> of hollowcores and will be finalized by the end of 2021.



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## Thursday 28 OCTOBER 2021

- 07:45 Bus from hotel to conference location
- 08:00 Registration
- 08:30 Opening; Seamus McKeague, Marco Pecetti, Wim Jansze

**08:45 Session on HSE**  
 Safety | Tom Michiels  
 Reuse – Rework - Recycle | Martin Mclvor

**09:45 Factory visit introduction**  
 Introduction to San Salvo factory - Licia Costantini

10:00 Break + sponsors

**11:00 Factory visit**  
 Safety first. Visit in 4 groups by routing through precast multi-product factory

13:00 Lunch at factory mensa

**14:00 Shear test on hollowcore slab**

15:00 Break + sponsors

**15:30 Session on Performance and Efficiency in Production**  
 Leadership and Team Performance | Hilde Fløgstad  
 Production Cyclus, Cycle Times, OEE, Stockyard and Logistic Planning | Jon Morten Lund

16:30 Closure first day, bus to hotel

19:00 Departure from hotel to restaurant hosted by Generale Prefabbricati

00:00 Return at hotel

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**Safety****Tom MICHIELS | CRH Europe Materials | Belgium**

Moving towards proactive leading indicators which encourage and measure proactive safety management practices and behaviours is a key element in the ongoing development of the safety management system.



Tom Michiels (1976, Belgium) is HSE Manager at CRH Europe Materials. Tom studied Health and Safety at the Safety Institute in Antwerp Belgium. He started in 2013 as Safety Manager for VVM Cement, one of the Belgian CRH companies. In 2016 he joined the central safety team of CRH Europe to support the operating companies of the Materials Division in Western Europe. Prior of joining CRH in 2013 Tom worked for 15 years at Umicore Precious Metals Refining in various rolls and locations with the last 5 years at the UPMR internal safety department in Belgium.

**Reuse – Rework - Recycle****Martin McIVOR | Creagh Concrete | Northern Ireland**

Creagh is currently re-energizing a company-wide waste management initiative 'Reuse – Rework – Recycle'. They will share an overview of the lean and waste management initiatives company-wide with a focus on waste recycling of hardened concrete and strands from the prestressed hollow core manufacturing.

Martin Mc Ivor (1983, Northern Ireland) is Creagh's Senior Manager responsible for Procurement & Cost Reduction. Martin started to work for Creagh in 2007 in a Production Management/Procurement role, he quickly developed in the Procurement Manager role and leads a team of five buyers who have complete responsibility for Creagh's spend companywide from their Toomebridge HQ. Recently, Martin has had a new focus on the company's waste, aiming to install new systems and procedures to ensure Creagh have minimal waste throughout all the business from design through installation of their wide range of Products.

**Leadership and Team Performance****Hilde FLØGSTAD | CONTIGA AS | Norway**

The perfect hollowcore factory needs high-end technology and smooth processes, but key for outstanding performance and efficiency will always rely on the people running the processes. Atomization means less people to manage but the increased importance of precision makes the day-to-day management of people the key to success. Experiences are shared on how to lead these teams in the challenging environment where safety, quality, output and costs are the main drivers.



Hilde Fløgstad (1975, Norway) is the Production Director at Contiga Norway, supplier of prefabricated elements in steel and concrete. Hilde has been working in Contiga since 2013 and is responsible for the operation and development of six factories. This year she also took on the position as Technical Director of Nordic Precast Group. She has a Master in Logistics and Supply Chain Management from Cranfield University in England and an MBA from NHH. Hilde has 20 years of experience from various positions in the value chain.

**Production Cyclus, Cycle Times, OEE, Stockyard and Logistic Planning****Jon Morten LUND | SPENNCON AS | Norway**

In hollowcore operations key performance indicators are influenced by people and technology. In the factory these KPI's are highly influenced by the chosen production cyclus and the working time of the machinery. And how to manage the hollowcore elements on the stockyard, as part of the logistical puzzle for the delivery to the client and according to desired output.

Jon Morten Lund (1958, Norway) is Operations Director at Spenncon Norway. Jon Morten has 40 years of experience in precast manufacturing and have assessed over 50 precast factories in Europe. Jon Morten has been working in Spenncon since 1983 He has an education in management, and is also a Lean Six Sigma Black Belt. Jon Morten has among other things worked as Production Technical Director and Director for Lean/Operational excellence in Consolis, and as Operations Director in Consolis Baltics. He has also experience as Plant Manager for a number of precast plants in Norway and other countries.

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**Friday 29 OCTOBER 2021**

08:00 Bus to Conference location

**08:30 Session on Quality Assurance and Quality Control**

Quality Assurance | Paolo Fagioli

Quality Control by Shear Tests | Wim Jansze

**09:30 Site visit introduction**

Project Introduction and Production Aspects | Marco Pecetti

10:00 Break + sponsors

**11:00 Site visit to Amazon Logistic Centre**

Safety first. Visit in groups by routing over precast site

13:00 Lunch

14:00 Departure by IPHA bus

18:00 Arrival at Rome Fiumicino Airport

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## Quality Assurance

Paolo FAGIOLI | GENERALE PREFABBRICATI | Italy

Quality assurance is the part of quality management focused on providing confidence that a product will fulfill requirements for quality. The confidence provided by quality assurance is twofold - internally to management and externally to customers. Some insights will be given in the presentation.

Paolo Fagioli (1955, Italy) is Senior Design Engineer at Generale Prefabbricati S.p.a. Paolo studied at University of Rome, Technical Department. In 1989 he began working for Generale Prefabbricati as Junior Engineer for designing floors in hollowcore slabs. He progressed into the design of precast structures, and now he is Responsible for the Technical Office, and Technical Responsible of Production and Quality Assurance. From 2010 he has been active at University of Perugia, Technical Department, for managing seminars on Design of Prefab Structures.

## Quality Control by Shear Tests

Wim JANSZE | CONSOLIS | The Netherlands



Quality control is the part of quality management focused on fulfilling quality requirements and related inspection. Inspection is the process of measuring, examining, and testing one or more characteristics of a product and the comparison of these with specified requirements to determine conformity. Loading tests can be used at the beginning of production as acceptance tests (ITT) and during production as periodical and continuous quality control tests (CQC).

Wim Jansze (1966, The Netherlands) has been R&D Director at Consolis since 2008. Wim studied Civil Engineering at Delft University of Technology (MSc 1993; PhD 1997) and Strategy and Innovation at MSM/FHR (MBA 2006). In 1997 he started his career in precast tunneling and in 1999 he moved to Spanbeton. From 2003 up to 2007 he emigrated to Suriname and lectured at the Anton de Kom University and consulted on hollowcores and precast bridges. After returning to Europe in 2008 he rejoined Consolis. Wim has been in the IPHA Board since 2012 and is President of IPHA Technical Committee.

## Project Introduction and Production Aspects

Marco PECETTI | Generale Prefabbricati | Italy



Generale Prefabbricati is involved in the construction of Amazon's logistical centre close to San Salvo. For this project Generale Prefabbricati delivers columns, beams and hollowcores. Before the construction site will be visited, this introduction elaborates on the project design, and it will address the production aspects of the hollowcores as discussed in the presentations earlier.

Marco Pecetti (1974, Italy) is Sales Director and Board Member at Generale Prefabbricati S.p.a. Marco is graduated in Industrial Engineering at "POLITECNICO di Milano". He is specialized in the field of Construction Project Management, Costs Control for the Construction Industry and Fire Engineering (Fire Expert Engineer Registered at n. A2623 of the "Ordine Ingegneri della Provincia di Perugia"). From 2005 up to 2011 he had responsibility of construction projects for BNP Paribas Real Estate. In 2012 he started working for Generale Prefabbricati taking responsibility of R&D and Hollowcore Strategic Business Unit. Marco has been in the Confindustria Perugia (local section of the main Italian association representing manufacturing companies) Board since 2012 and in the IPHA Board since 2014.

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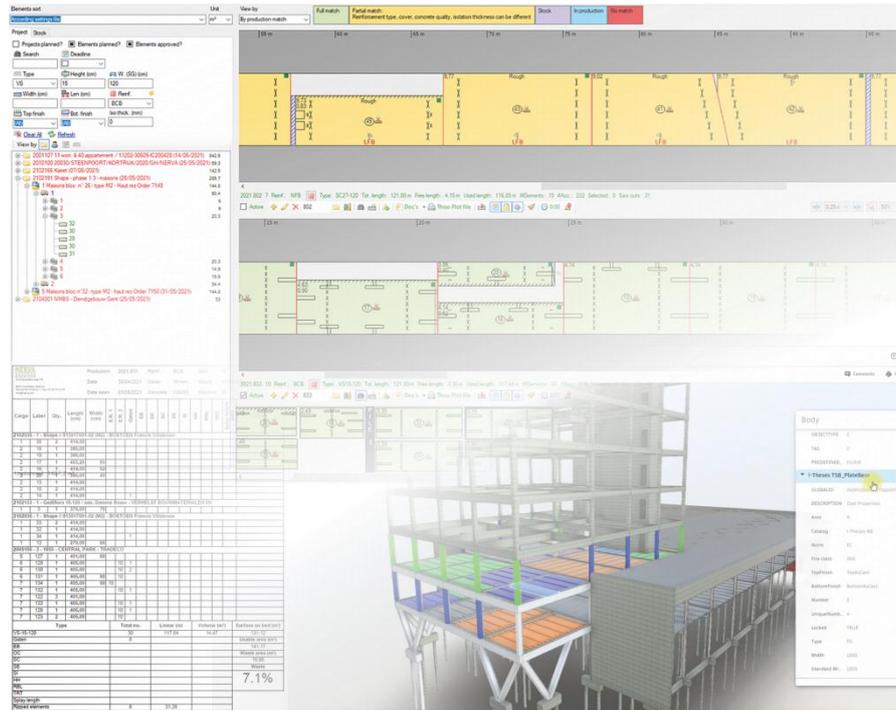
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PlanDesk Production Planner – Hollowcore - Graphical Bedplanning connected to BIM model

### Manage Every Phase of Your Precast Process, from Enquiry to Delivery

i-Theses develops software for the precast concrete industry. With PreCastOffice, you can manage the entire precast process, from initial customer contact right through to delivery. It gives you a permanent overview of project progress, with the information you need always at your fingertips.

iTs Project Manager is the perfect tool for customer and document management, design planning and monitoring your KPI's. Whether it's viewed graphically through a BIM model or through data and graphs, you can understand the bigger picture and the most important details.

It integrates seamlessly with i-Theses AutoPrecast design modules, such as AutoFloor, AutoBeCo and AutoStairs, but you can also import data from other design software. This can also be processed through iTs PlanDesk modules for accurate and optimised production planning.

With automatic checks as standard, you can reduce errors to a minimum, speed up delivery, increase your margins, and provide your customers with the information they need – when they need it.



Ecoratio is specialized in developing and supplying a unique range of environmentally friendly release agents, retarders, curing compounds, and additional products for all precast concrete factory needs. Our products are designed to prevent problems that almost all concrete producers face, such as pinholes, corrosion, dust, and discoloration. Our technical teams around Europe, APAC, and Asia provide technical support for our products and beyond.

All our products are developed to protect the planet, and therefore they are unlabeled and free of hazardous chemicals - without compromising results, since 1998.

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Since 1970, NORDIMPIANTI has been one of the world's leading suppliers of machinery, equipment, production lines and complete production plant for the manufacture of pre-stressed concrete elements. Based in Chieti, Central Italy in the region of Abruzzo, the company has, for the last four decades established an extensive customer base throughout the world. Currently, machines and plant from Nordimpianti are working in more than 40 countries, across the five continents.

Nordimpianti's success in overcoming many challenges is due to its highly skilled workforce and means that Nordimpianti has the expertise to give its customers the head-start they need in business. Nordimpianti's casting machines (Slipformer, Extruder and Wet Casting) can produce a wide range of products such as Hollow core slabs, Vineyard posts, Lintels, T Beams, Slabs with lattice ribs, Inverted double T Beams and Slabs, Double ribbed slabs, U-Panels, up to the large 1m hollow core slabs used for the most demanding construction applications. Besides the casting machines, Nordimpianti also designs and manufactures all the ancillary equipment such as casting beds, saw machines, stressing and lifting equipment etc.

Nordimpianti has a dedicated after sales service department available to support all its customers, all over the world.

Nordimpianti's strength is to listen to its clients and use its experience and flexible approach to develop customized solutions that help customers maximize their own business.



DELTABEAM® Green  
**EPD**



### Peikko Group Corporation

Peikko is a leading global supplier of slim floor structures, wind energy applications and connection technology for precast and cast-in-situ construction. Peikko has sales offices in over 30 countries in five continents with manufacturing operations in twelve countries.

Peikko's DELTABEAM® Slim Floor Structure is the hollow-core's "best friend": it enables the use of hollow-core slabs also in architecturally demanding projects.

DELTABEAM® Green is the new, environmental-friendly version of Peikko's DELTABEAM®. It offers the same benefits and in addition, it cuts CO2 emissions by up to 50% compared to standard steel, composite or concrete beams.

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1	Steven Coleman	Bahrain Precast Concrete	Bahrain
2	Tom Michiels	CRH	Belgium
3	Pieter van der Zee	CRH	Belgium
4	Kristof Hermans	Echo Precast Engineering	Belgium
5	Mallory Vervloet	Echo Precast Engineering	Belgium
6	Carsten Friberg	IPHA	Belgium
7	Lennie van de Keer	I-theses	Belgium
8	Rony Verlee	I-theses	Belgium
9	Kevin Gastmans	Prefabo (CRH)	Belgium
10	Kenny De Krem	Prefabo (CRH)	Belgium
11	Alexander Vogl	Contiga	Denmark
12	Kai Jess	Contiga	Denmark
13	Casper Harlev	Sensohive	Denmark
14	Ian Treanor	Treanor Pujol	England
15	Jani Eilola	Elematic	Finland
16	Curt Lindroth	Elematic	Finland
17	Kjell-Ole Gjestemoen	Peikko	Finland
18	Gregor Schabrun	Peikko	Finland
19	Clément Bonnaire	Strudal	France
20	Taoufik Cheriet	Strudal	France
21	Michael von Ahlen	CPI Worldwide	Germany
22	Holger Karutz	CPI Worldwide	Germany
23	Arne Völker	Max-truder	Germany
24	Paolo Fagioli	Generale Prefabbricati	Italy
25	Marco Pecetti	Generale Prefabbricati	Italy
26	Ergert Qukaj	Generale Prefabbricati	Italy
27	Fabio Spinazzola	Generale Prefabbricati	Italy
28	Gaetano Guarino	Master Builders Solutions	Italy
29	Andrey Borisenkov	Nordimpianti	Italy
30	Ernesto Biot Cortell	Nordimpianti	Italy
31	Gian Piero Gagliardi	Nordimpianti	Italy
32	Min Kyu Kim	Nordimpianti	Italy
33	Brendan Mc Closkey	Creagh Concrete	Northern Ireland
34	Martin Mclvor	Creagh Concrete	Northern Ireland
35	Seamus McKeague	Creagh Concrete	Northern Ireland
36	Hilde Fløgstad	Contiga	Norway
37	Ove Sandvin	Contiga	Norway
38	Jon Morten Lund	Spenncon	Norway
39	Kathrine Lyngstad	Spenncon	Norway
40	Nelson Hanna	Creagh Concrete	Northern Ireland
41	Michael Mc Keown	Creagh Concrete	Northern Ireland
42	Denis Milenovic	Put Inzenjering	Serbia
43	Dragan Zivkovic	Put Inzenjering	Serbia
44	Arturo Martin	CRH - Suberolita	Spain
45	Arturo Martin	CRH - Suberolita	Spain
46	Patrik Lindh	Consolis	Sweden
47	Stefan Rinaldo	Consolis	Sweden
48	Paul Tate	Strusoft	Sweden
49	Kristof Weyns	Sika	Switzerland
50	Wim Jansze	Consolis	The Netherlands
51	Martien van Peer	Dycore	The Netherlands
52	Michael Hollenbenders	Ecoratio	The Netherlands
53	Richard Siemes	Ecoratio	The Netherlands
54	Ronald Klein-Holte	VBI	The Netherlands
55	Johan Slinger	VBI	The Netherlands
56	Edward Birkhead	Spiroll/CCI	UK
57	Luke Kani Zihni	Spiroll/CCI	UK

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